

THREAD ROLLS

For Alco & Fette thread rolling heads



Our stocked thread rolls are manufactured from M2 High speed steel hardened to HRC 62-64. We also stock some thread rolls in M42. These are only for UNJF threads that are normally used on tough aircraft materials.

Except for the 2 roll A0 head most rolls are in sets of three.

Each roll in a set of three is marked on one side with 1, 2, 3, the thread or thread range covered, and the lead of the rolls, usually 1K or 2K for stocked rolls. The other side will be marked A, B, C.

Just like the chamfer on a tap, the form at the beginning of each thread roll is progressive to spread the load as the rolls contact the workpiece. This 'lead' is present at each end of the rolls. Standard short lead for work close to a shoulder is 1K, which equates to 2.3 x thread pitch. Standard long lead is 2K, which is 3.3 x thread pitch. 0.6K can be supplied for very close threading but remember that a shorter lead can mean a shorter roll life. 3K is also available. 0.6K and 3K leads are not stocked and are priced on application.

Thread rolls are fitted into the head with either 1, 2, 3 or A, B, C facing the front. When the rolls have had some use there will be wear on the lead. The rolls can then be turned around to present the lead on the other side to the workpiece. When the lead on both ends has worn, as long as there is no damage i.e, breaking up, the rolls can then be reground. Most sets can be reground at least once and maybe more. When the rolls are reground the existing form is completely removed and a new form ground on. Obviously the bigger the rolls can be to start with, the more regrinds can be done. Effectively the saving is on the material cost as you are supplying the 'blank'.

Most thread rolls are manufactured to cover a range e.g M14-16x2. If you have a regular requirement for, say, M14x2 you can request the the rolls are made just for that thread, at their biggest allowable diameter for the head being used. In this way you will get the maximum thread regrinds possible.

The thread form on the rolls is annular, not helical. The angle required to form a spiral thread is built into the front and back plates of the thread rolling head. It is important therefore that the correct head is selected for the thread to be produced. Heads are available for coarse or fine threads.

A set of thread rolls can be used to produce either a right or left hand thread. To produce a left hand thread a left hand thread rolling head is required. These can be recognised by the suffix 'L' or 'IZQ' on the head identification e.g A4 is for right hand threads, A4 IZQ is for left hand threads.

For other thread rolling heads, special fixtures, and thread rolling machines



We can supply thread rolls, and a regrinding service for most other types of thread rolling equipment

If enquiring please give us full details including machine or head type and size, and as much other information (dimensions etc) that you may have.