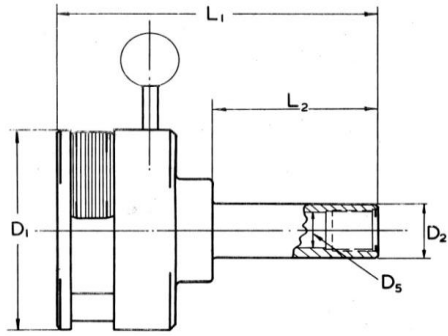


ALCO F TYPE HEADS DIMENSIONS & CAPACITIES



DIMENSIONS

ROLLING HEAD	A0	A1	A12	A2	A23	A233400	A3	A34
D1 HEAD DIAMETER	50.04mm 1.97"	63.50mm 2.50"	63.50mm 2.50"	88.11mm 3.47"	88.11mm 3.47"	96.10mm 3.78"	117.5mm 4.63"	117.5mm 4.63"
D2 SHANK DIAMETER	19.05mm 0.75"	19.05mm 0.75"	19.05mm 0.75"	25.40mm 1"	25.40mm 1"	25.40mm 1"	31.75mm 1.25"	31.75mm 1.25"
L1 OVERALL LENGTH	100.9mm 3.97"	110.4mm 4.34"	110.7mm 4.36"	143.3mm 5.64"	143.3mm 5.64"	142.0mm 5.59"	172.2mm 6.78"	173.4mm 6.83"
L2 SHANK LENGTH	59.92mm 2.36"	59.92mm 2.36"	59.92mm 2.36"	76.20mm 3"	76.20mm 3"	59.50mm 2.34"	90.09mm 3.55"	90.09mm 3.55"
FRONT PLATE BORE	11.51mm 0.45"	15.06mm 0.56"	15.06mm 0.56"	22.23mm 0.88"	22.23mm 0.88"	39.00mm 1.54"	34.93mm 1.38"	34.93mm 1.38"
FRONT PLATE THICKNESS	4.76mm 0.19"	5.94mm 0.23"	5.94mm 0.23"	7.54mm 0.28"	7.54mm 0.28"	8.00mm 0.31"	7.94mm 0.31"	7.94mm 0.31"
D5 BORE OF SHANK	6.35mm 0.25"	11.11mm 0.438"	11.11mm 0.438"	17.06mm 0.67"	17.06mm 0.67"	17.06mm 0.67"	22.23mm 0.88"	22.23mm 0.88"
WEIGHT WITHOUT ROLLS	0.45Kg	0.68Kg	0.68Kg	1.82Kg	1.93Kg	2.50Kg	3.75Kg	3.75Kg
AVERAGE WEIGHT OF ROLLS	0.09Kg	0.175Kg	0.175Kg	0.4Kg	0.4Kg	0.4Kg	1.1Kg	0.75 Kg
NUMBER OF ROLLS PER SET	2	3	3	3	3	3	3	3

CAPACITIES

Metric threads. Thread rolls are made to cover the following ranges.

see note							
A0	A1	A12	A2	A23	A233400	A3	A34
1-2x0.25	6-8x0.75	6-7x0.5	8-12x1	8-10x0.5	16-18x1.5	12-16x1.5	12-14x1
1.4x0.3	6-8x1	6-7x0.75	8-12x1.25	8-10x0.75	18-20x1.5	12-16x1.75	14-16x1
1.6-1.8x0.35	6-8x1.25	7-8x0.5	8-12x1.5	10-12x0.75	20-22x1.5	12-16x2	16-18x1
2-2.3x0.4	9-10x1	8-9x0.75	12x1.75	10-12x1	22-24x1.5	12-16x2.5	16-18x1.5
2.2-2.6x0.45	9-10x1.25	8-9x1	12-16x1.5	12-14x1	22-24x2	14-16x2	18-20x1
3x0.5	10x1.5	9-10x0.75	14-16x2	14-16x1	24-26x1.5	16-20x1.5	18-20x1.5
3-3.5x0.6		9-10x1		14-16x1.25	24-26x2	16-20x2	20-22*x1.5
4x0.7		10-11*x0.75		16-18*x1	26-28x1.5	16-20x2.5	22*-24x1.5
4-4.5x0.75		10-11*x1		16-18*x1.5	26-28x2	20-22*x2	24*-27*x1.5
5x0.8		10-11*x1.25		18*-20*x1	28-30x1.5	20-22*x2.5	27*-30*x1.5
5-5.5x0.9		11*-12*x0.75		18*-20*x1.5	28-30x2		
		11*-12*x1		20*22*x1.5	30-32x1.5		
		11*-12*x1.25			30-32x2		
		12*x1.5			32-34x1.5		
					32-34x2		
					34-36x1.5		
					34-36x2		

* Maximum thread length including runout. *14mm *19mm *24mm *24mm

The A233400 is a fine threading head for large diameters. Thread diameters up to 26mm are restricted to 67mm thread length including runout. Thread diameters over 26mm are restricted to 24mm thread length including runout.

Note:- Runout refers to the lead on the rolls. See Thread rolls technical information.

CAPACITIES

UNC threads. Thread rolls are made to cover the following ranges.

A0	A1	A12	A2	A23	A233400	A3	A34
1x64	1/4x20		5/16x18			7/16x14	
2x56	5/16x18		3/8x16			1/2x13	
3x48	3/8x16		7/16x14			9/16x12	
4-5x40			1/2x13			5/8x11	
6-6x32			9/16x12			3/4x10	
10-12x24			5/8x11			7/8*x9	

* Maximum thread length including runout. *24mm

CAPACITIES

UNF / UNEF threads. Thread rolls are made to cover the following ranges.

see note

A0	A1	A12	A2	A23	A233400	A3	A34
0x80	1/4x28	5/16-3/8x32	5/16-3/8x24	5/16-3/8x32	5/8x24	7/16-1/2x20	9/16-5/8x24
1x72	5/16-3/8x24	7/16*-1/2*x20		7/16-1/2x28	11/16x24	9/16-5/8x18	3/4x20
2x64		7/16*-1/2*x28		9/16-5/8x24	3/4x20		7/8x20
3x56					7/8x20		1"x20
4x48					1"x20		5/8x18
5x44					5/8x18		3/4x16
6x40					3/4x16		1"x12*
8x36					1"x12		1.1/8"x12
10x32					1.1/8x12		
12x28					1.1/4x12		
					1.3/8x12		
					1.7/16x12		

* Maximum thread length including runout. *14mm *24mm

The A233400 is a fine threading head for large diameters. Thread diameters up to 26mm are restricted to 67mm thread length including runout. Thread diameters over 26mm are restricted to 24mm thread length including runout.

BSP threads. Thread rolls are made to cover the following ranges.

see note

A0	A1	A12	A2	A23	A233400	A3	A34
	1/8x28	1/8x28	1/8x28	1/8x28	3/8x19	1/4-3/8x19	3/8x19
		1/4x19	1/4x19	1/4x19	1/2x14	1/2x14	1/2-5/8x14
				3/8*x19	5/8x14		3/4x14
				1/2*x14	3/4x14		7/8x14
					7/8x14		
					1"x11		

* Maximum thread length including runout. *19mm

The A233400 is a fine threading head for large diameters. Thread diameters up to 26mm are restricted to 67mm thread length including runout. Thread diameters over 26mm are restricted to 24mm thread length including runout.

Roll sets are also available for BSF and BSW threads, generally equivalent to the UNF and UNC threads listed.

As these threads are obsolescent they are not normally stocked but can be produced in around 7 working days, please enquire.

Similarly BA, BSCY, UNJ etc. threads can be produced and the rolls supplied.

If you want to produce any thread not listed in the tables above please call us to check that you have the required head.

Most Alco heads can be used for knurling. Again, please enquire.