



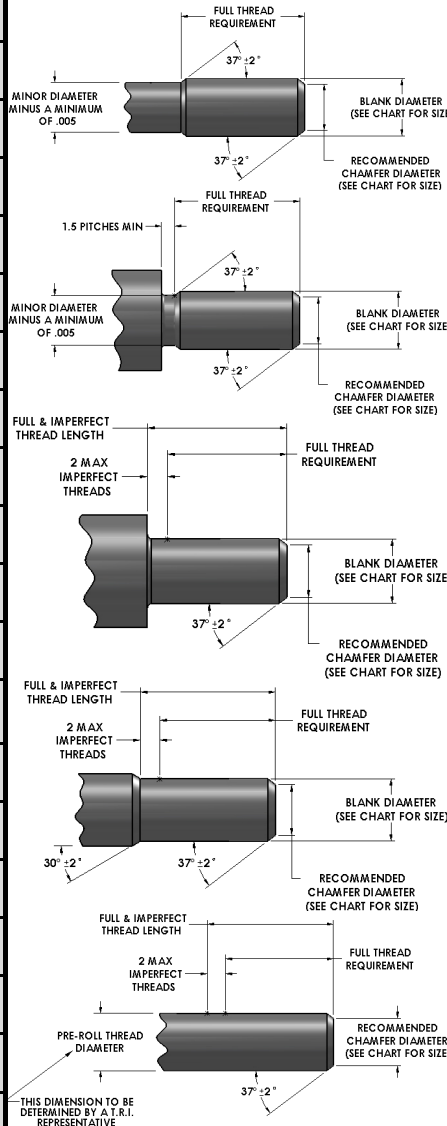
## Roll Thread Blank Reference Chart

TRI helps design our customers' blanks to accommodate rolled threads. Please consult this chart for general guidelines. For specific requirements or sizes not shown, contact TRI for a pre-roll thread drawing.

Fine Thread		
Thread Size	Blank Diameter (± .001)	Recommended Chamfer Diameter (± .010 (U.O.S.))
0 (.060)-80	.056	.038±.005
1 (.073)-72	.068	.050±.005
2 (.086)-64	.080	.058±.005
3 (.099)-56	.092	.068±.005
4 (.112)-48	.103	.077±.005
5 (.125)-44	.114	.087±.005
6 (.138)-40	.126	.095±.005
8 (.164)-36	.150	.122±.007
10 (.190)-32	.174	.140±.007
12 (.216)-28	.197	.160
.2500-28	.231	.190
.3125-24	.290	.245
.3750-24	.352	.310
.4375-20	.409	.355
.5000-20	.472	.420
.5625-18	.531	.470
.6250-18	.594	.530
.7500-16	.714	.650
.8750-14	.833	.755
1.000-14	.958	.880
1.000-12	.950	.865

### Blank

Final pre-roll thread diameter will be developed and centerless ground to the final close tolerance dimension. 37° angle will be approximately 45° after rolling. If the 45° is critical and a compound angle is not feasible, the chamfer may require machining after roll threading. Unless otherwise specified, thread lengths given will be assumed to be minimum required full threads.



PREPARATION FOR ROLL THREAD ONLY

Coarse Thread		
Thread Size	Blank Diameter (± .001)	Recommended Chamfer Diameter (± .010 (U.O.S.))
1 (.073)-64	.067	.045±.005
2 (.086)-56	.079	.057±.005
3 (.099)-48	.090	.065±.005
4 (.112)-40	.100	.072±.005
5 (.125)-40	.113	.085±.005
6 (.138)-32	.122	.087±.007
8 (.164)-32	.148	.112±.007
10 (.190)-24	.167	.125±.007
12 (.216)-24	.193	.150±.007
.2500-20	.222	.170
.3125-18	.281	.220
.3750-16	.339	.275
.4375-14	.395	.328
.5000-13	.454	.375
.5625-12	.513	.425
.6250-11	.570	.470
.7500-10	.689	.585
.8750-9	.807	.685
1.000-8	.924	.815

For use with standard thread series including: UNC, UNF, UNR, UNJ, UNS

