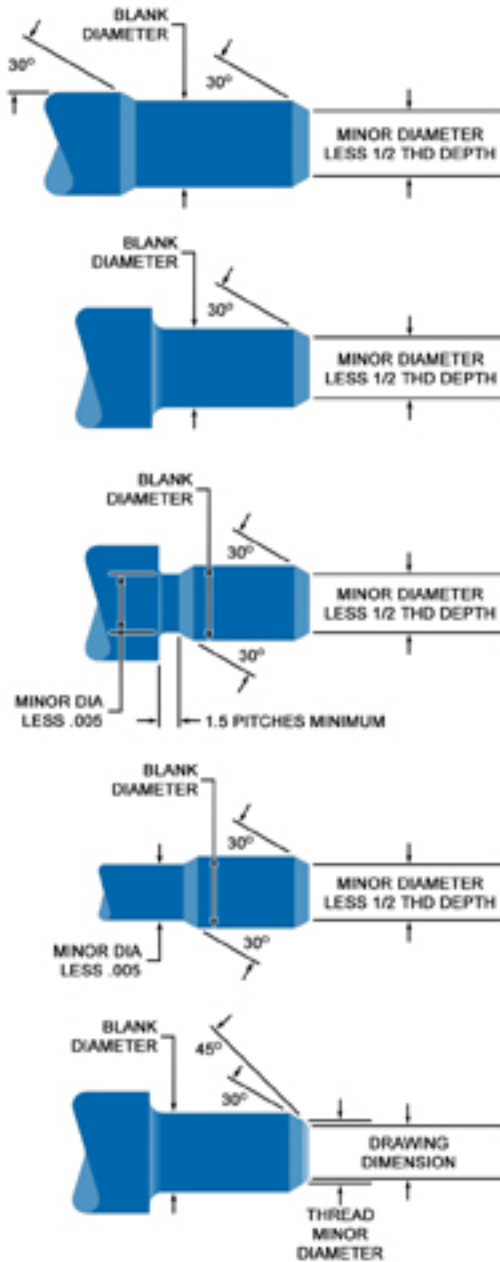




Thread Roll Blank Preparation Chart

For Use When Machining Diameters in Preparation for Thread Rolling

BLANK



30° ANGLES ARE NEEDED TO ACCOMMODATE THE THREAD ROLL PROCESS ONLY AND DOES NOT GUARANTEE 45° FINISH ANGLES.

IF THE DRAWING REQUIRES 45° FINISH ANGLES AFTER THREAD ROLL, A COMPOUND CHAMFER ANGLE IS NEEDED.

FINE THREAD

Thread Size	Min. Blank Diameter	Chamfer Diameter
2-64	.080	.055
3-56	.091	.065
4-48	.103	.075
5-44	.115	.085
6-40	.126	.090
8-36	.150	.120
10-32	.173	.140
1/4-28	.231	.187
5/16-24	.290	.240
3/8-24	.352	.305
7/16-20	.410	.350
1/2-20	.472	.415
9/16-18	.531	.470
5/8-18	.593	.530
3/4-16	.713	.645
7/8-14	.831	.755
1-12	.950	.870
1-14	.958	.880
1 1/16-12	1.013	.930
1 1/8-12	1.075	.990
1 1/4-12	1.200	1.115
1 3/8-12	1.325	1.240
1 1/2-12	1.450	1.365
1 3/4-12	1.700	1.620
1 7/8-12	1.825	1.740

COARSE THREAD

Thread Size	Min. Blank Diameter	Chamfer Diameter
2-56	.080	.055
3-48	.090	.062
4-40	.100	.072
5-40	.113	.082
6-32	.122	.085
8-32	.148	.112
10-24	.168	.125
1/4-20	.222	.168
5/16-18	.281	.220
3/8-16	.339	.272
7/16-14	.395	.325
1/2-13	.455	.375
9/16-12	.513	.435
5/8-11	.570	.480
3/4-10	.690	.595
7/8-9	.806	.700
1-8	.923	.810
1 1/8-7	1.037	.910
1 1/4-7	1.161	1.032
1 3/8-6	1.272	1.125
1 1/2-6	1.396	1.245
1 3/4-5	1.625	1.450
2-4 1/2	1.862	1.660

Please Note:
Machine Tolerances = +.005 / -.000
All Dimensions are in Inches



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