# GRORST ENGINEERING <br> 141 Prestige Park Rd. East Hartford, CT 06108 860.289.8209 www.threadrolling.com 

## Roll Thread Blank Reference Chart

We help design our customers' blanks to accommodate rolled threads. Please consult this chart for general guidelines. For specific requirements or sizes not shown, contact us for a drawing.

| Fine Thread |  |  | Final pre-roll thread diameter will be developed and centerless ground to the final close tolerance dimension. $37^{\circ}$ angle will be approximately $45^{\circ}$ after rolling. If the $45^{\circ}$ 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 | Coarse Thread |  |  |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| Thread Size | Blank Diameter ( $\pm .001$ ) | Recommended Chamfer Diameter ( $\pm .010$ [U.O.S.]) |  | Thread Size | Blank <br> Diameter $\text { ( } \pm .001 \text { ) }$ | Recommended Chamfer Diameter ( $\pm .010$ [U.O.S.]) |
| 0 (.060)-80 | . 056 | . $038 \pm .005$ |  | 1 (.073)-64 | . 067 | . $045 \pm .005$ |
| 1 (.073)-72 | . 068 | $.050 \pm .005$ |  | 2 (.086)-56 | . 079 | .057さ. 005 |
| 2 (.086)-64 | . 080 | . $058 \pm .005$ |  | 3 (.099)-48 | . 090 | . $065 \pm .005$ |
| $3(.099)-56$ | . 092 | . $068 \pm .005$ |  |  |  |  |
| 4 (112)-48 | . 103 | .077+. 0 | Hes min - | $4(.112)-4$ | . 100 | . $07 \pm .005$ |
|  |  |  |  | 5 (.125)-40 | . 113 | . $085 \pm .005$ |
| 5 (.125)-44 | . 114 | . $087 \pm .005$ |  |  |  |  |
| 6 (.138)-40 | . 126 | . $095 \pm .005$ |  | 6 (.138)-32 | . 122 | . $087 \pm .007$ |
| 8 (.164)-36 | . 150 | $.122 \pm .007$ |  | $8(.164)-32$ | . 148 | .112土. 007 |
| 10 (.190)-32 | . 174 | . $140 \pm .007$ |  | 10 (.190)-24 | . 167 | . $125 \pm .007$ |
| 12 (.216)-28 | . 197 | . 160 |  | 12 (.216)-24 | . 193 | . $150 \pm .007$ |
| .2500-28 | . 231 | . 190 |  | .2500-20 | . 222 | . 170 |
| . $3125-24$ | . 290 | . 245 |  | . $3125-18$ | . 281 | . 220 |
| .3750-24 | . 352 | . 310 |  | . $3750-16$ | . 339 | . 275 |
| .4375-20 | . 409 | . 355 |  | .4375-14 | . 395 | . 328 |
| .5000-20 | . 472 | . 420 |  | 5000-13 | 454 | 375 |
| .5625-18 | . 531 | . 470 |  |  |  |  |
| .6250-18 | . 594 | . 530 | Commended | .5625-12 | . 513 | . 425 |
| .7500-16 | . 714 | . 650 |  | .6250-11 | . 570 | . 470 |
| .8750-14 | . 833 | . 755 |  | .7500-10 | . 689 | . 585 |
| 1.000-14 | . 958 | . 880 |  | .8750-9 | . 807 | . 685 |
| 1.000-12 | . 950 | . 865 | DETERMINED BY AT.R.I. REPRESENTATIVE | 1.000-8 | . 924 | . 815 |

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

