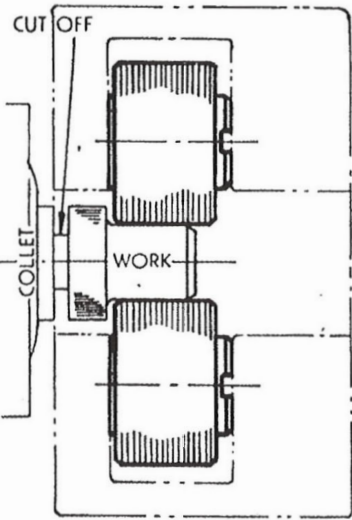


# Reed

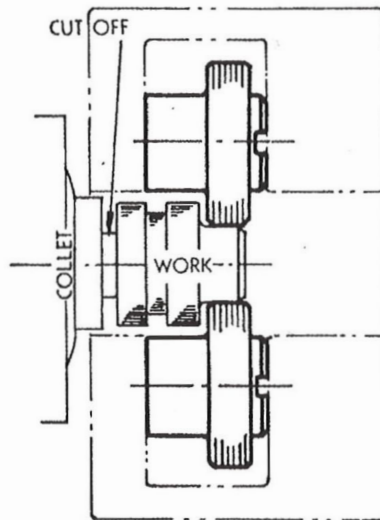
**ATTACHMENT THREAD ROLLS  
SINGLE BUMP ROLLS  
END ROLLING HEAD THREAD ROLLS**





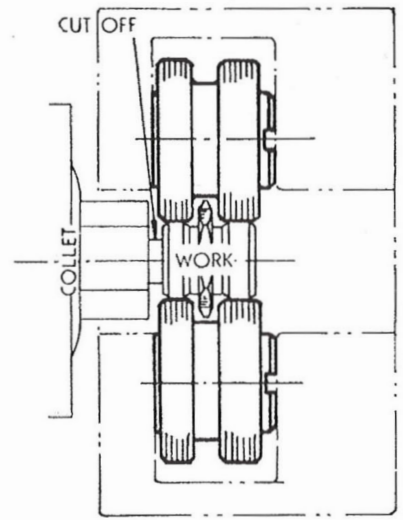
### Type C-1 Roll

These rolls, with standard hubs, are generally used for rolling on the outboard end of the work as shown, or where the standard working face of the roll is satisfactory for the length of thread to be rolled, and the position of the attachment relative to the collet face is unimportant. All other types of rolls are modifications of this design.



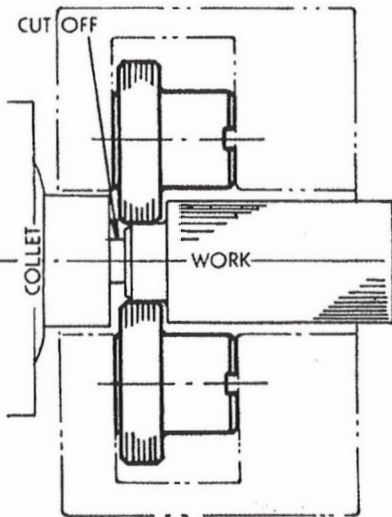
### Type C-3 Roll

These are rolls used when the threaded section on the work is away from the cut-off end and where it is desirable to position the attachment on the cross slide close to the spindle carriage. The roll design includes a narrow working face, retaining the standard drive hub for ease of assembly in the head.



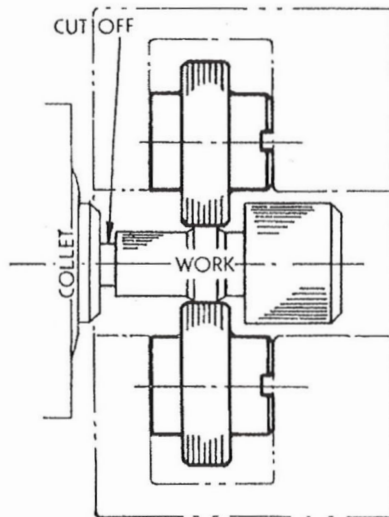
### Type C-5 Roll

Two sections with threads of the same diameter and pitch can be rolled with rolls of this design. The rolls are relieved to provide clearance for the shoulders on the work. The combined length of the threaded and center sections is within the standard total working face of a roll with a standard drive hub.



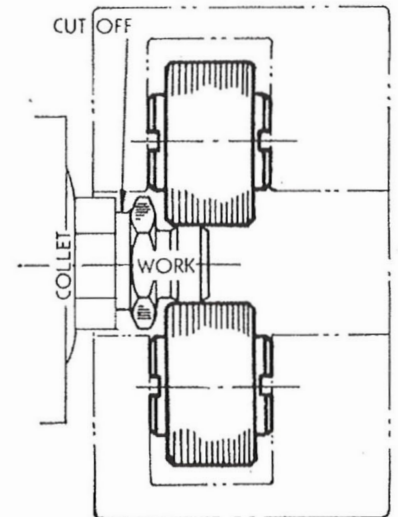
### Type C-2 Roll

These rolls, with a narrow working face, are generally used for rolling the thread at the cut-off end behind a shoulder. With the working face at the plain hub end, it permits positioning the cut-off end of work close to the collet face.



### Type C-4 Roll

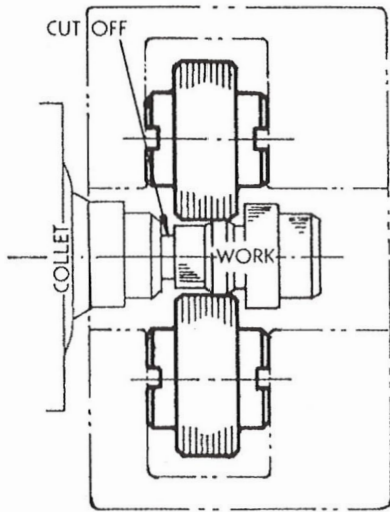
These rolls, with a narrow working face, are normally centered, but can be positioned off center. They are used when attachment positioning on the cross slide is important as well as the position of the cut-off end of the work in relation to the collet face. On the application shown, the narrow working face on the roll is required to prevent contact of the roll with the finished diameter between the threaded section on the roll and cut-off end.



### Type CR-1 Roll

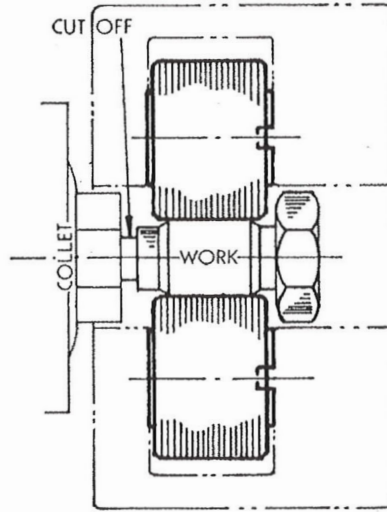
When the thread length permits, reversible rolls of this design can be used and provide for two settings of the roll. The design includes two standard drive hubs for ease of assembly in the head. The rolls can be reversed without repositioning the attachment or other cross-slide tooling.

# SLIDE ATTACHMENT THREAD ROLL



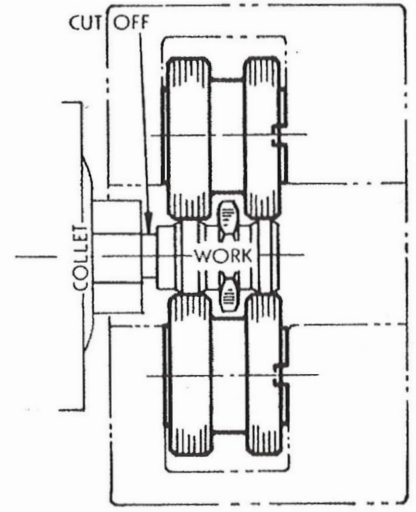
## Type CR-4 Roll

These reversible rolls are designed with a centralized narrow working face providing two settings of the roll on work having a short length of thread. Limitations of space between a shoulder and the cut-off tool and exact positioning of the work from the collet face, require rolls of this design. The rolls can be reversed without repositioning the attachment or other cross-slide tooling.



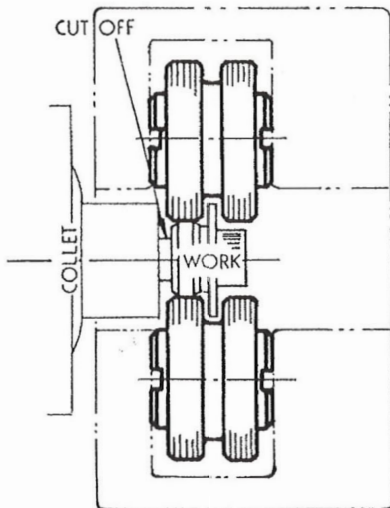
## Type D-1 Roll

When the working face of rolls with standard hubs is not sufficient for the required thread length on the work, additional thread length capacity can be provided with rolls of this design. It includes an extended working face, two standard plain hubs and a recessed drive slot.



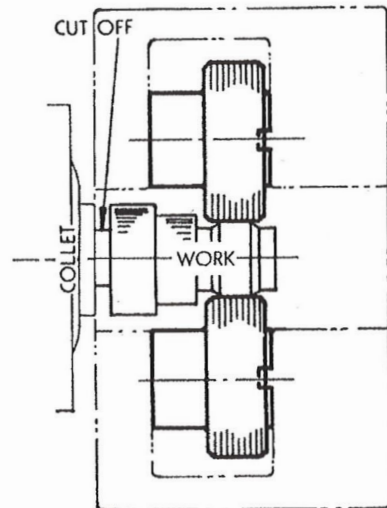
## Type D-5 Roll

These rolls are a further modification of a type C-5 roll, providing additional thread length capacity. This is necessary when the combined lengths of the threaded and center sections of the work exceed the total working face available on rolls having a standard drive hub.



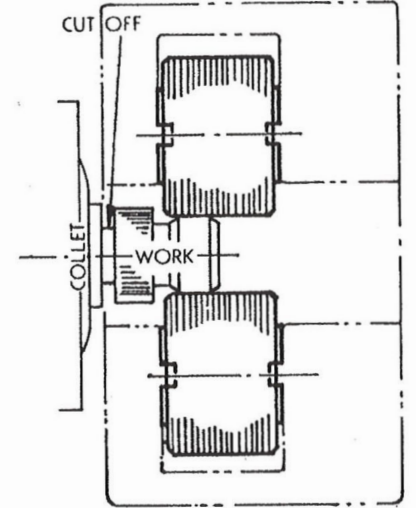
## Type CR-5 Roll

Reversible rolls of this design are used to provide two settings of the roll on work having a short thread length adjacent to a shoulder. The combined lengths of the threaded and center sections must be within the total working face of a roll with two standard drive hubs. The rolls can be reversed without repositioning the attachment or other cross-slide tooling.



## Type D-3 Roll

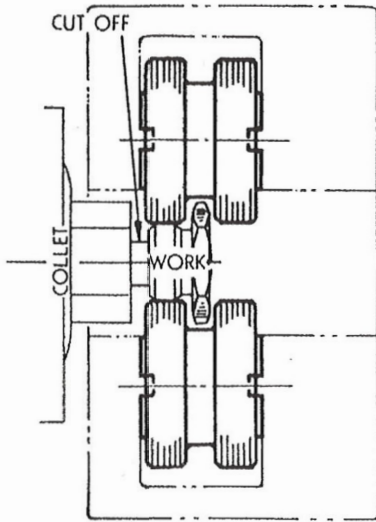
This design of roll is a further modification of a type C-3 roll and is used when cross-slide design makes it necessary for the attachment to be positioned as close to the spindle carriage as possible. The positioning of the attachment, close to the spindle carriage, is also desirable in some cases to eliminate possible interference of the end working tools, tool holders or tool slide with the attachment.



## Type DR-1 Roll

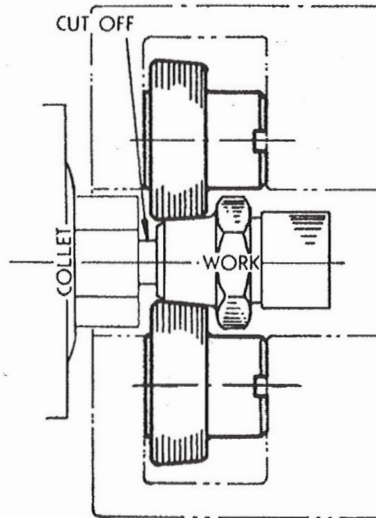
These are reversible rolls designed with an extended working face and recessed drive slots at both ends for two-roll settings. They are a modification of a type CR-1 roll, providing additional thread length capacity. The rolls can be reversed without repositioning the attachment or other cross-slide tooling.

# APPLICATIONS



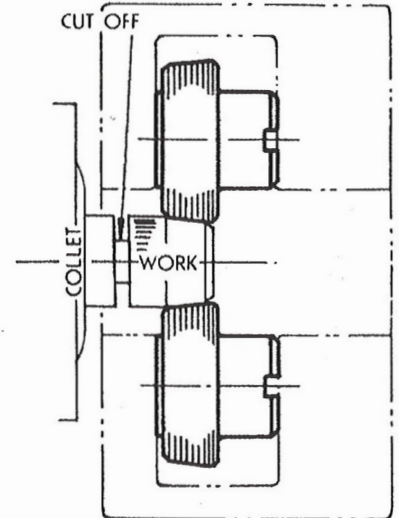
### Type DR-5 Roll

This design of roll includes an extended total working face with recessed drive slots, providing two settings of the roll on work having a short thread length adjacent to a shoulder. It is a modification of a type CR-5 roll, with additional thread length capacity. The rolls can be reversed without repositioning the attachment or other cross-slide tooling.



### Type K-2 Roll

These rolls are designed for rolling taper pipe threads when the small end of the taper on the work is towards the collet. The length of working face is determined by the requirements of the work.



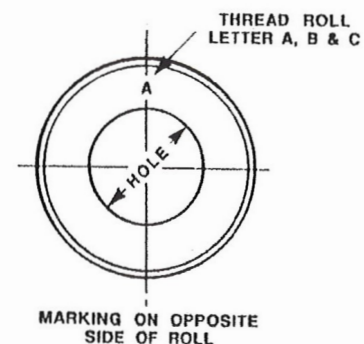
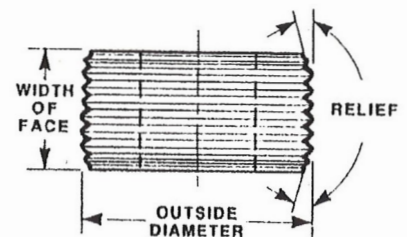
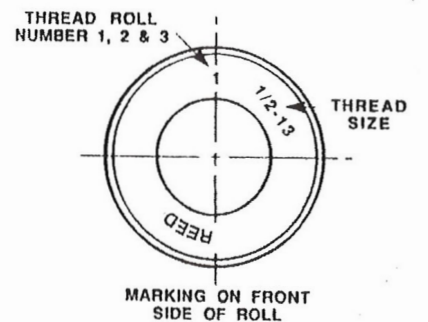
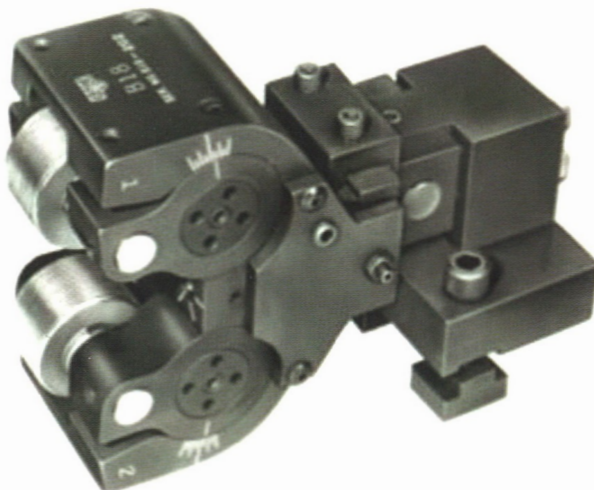
### Type Q-2 Roll

These rolls are designed for rolling taper pipe threads when the large end of the taper on the work is towards the collet. The length of working face is determined by the requirements of the work.

In addition to our

## *Signature Reed Series B Thread Rolls*

We manufacture standard and custom designed Reed Thread Roll Dies for **All brands** of Thread Roll Attachments/End Rolling Heads in Axial, Radial and Tangential configurations.

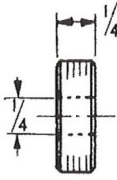
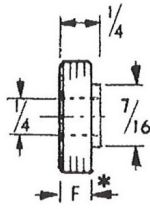
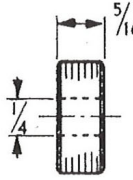
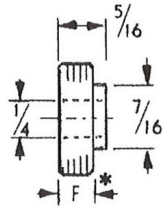


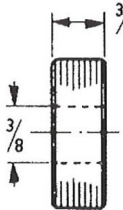
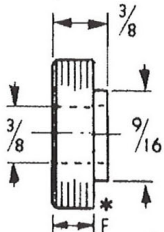
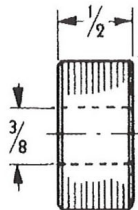
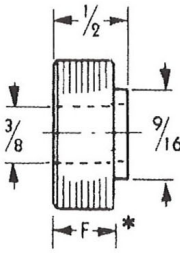
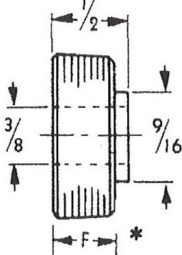
# Reed F1, F2, and Y2 Style Single Bump Rolls

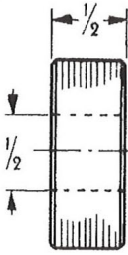
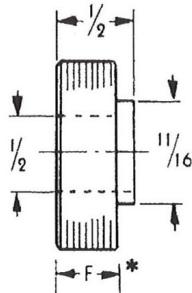
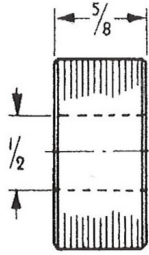
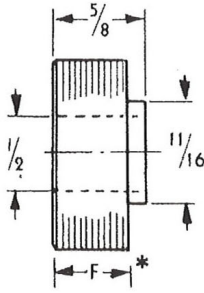
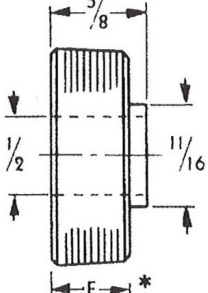
F1, F2 rolls for straight threads

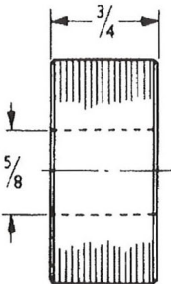
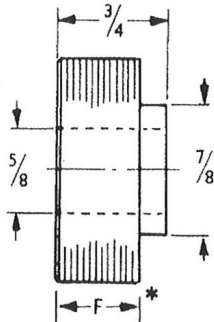
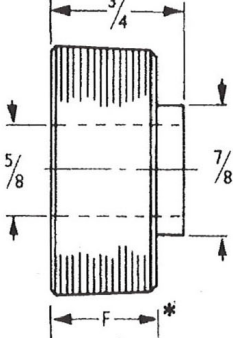

Y2 rolls for tapered threads

\*(F) Working Face

 <p>F1-44</p>	 <p>F2-44</p>	 <p>F1-54</p>	 <p>F2-54</p>	<p>Reed manufactures rolls for all brands of thread roll attachments /end rolling heads. Rolls for special holders can be made to your drawing specifications.</p>
<p>Used in holders: Reed A00-54; Brown &amp; Shape 83-200; Detroit 309-5; Salvo SA-00</p>				

 <p>F1-66</p>	 <p>F2-66</p>	 <p>F1-86</p>	 <p>F2-86</p>	 <p>Y2-86</p>
<p>Used in holders: Reed A00-86, A0-86; Brown &amp; Shape 84-100, 83-120; Detroit 309-4; Salvo SA-0, SB-00</p>				

 <p>F1-88</p>	 <p>F2-88</p>	 <p>F1-108</p>	 <p>F2-108</p>	 <p>Y2-108</p>
<p>Used in holders: Reed A0-108, A2-108; Brown &amp; Shape 84-120, 83-122; Detroit 309-6; Salvo SA-2, SB-0</p>				

 <p>F1-1210</p>	 <p>F2-1210</p>	 <p>Y2-1210</p>	
<p>Used in holders: Reed A2-1210; Brown &amp; Shape 84-122; Salvo SB-2</p>			



PTG offers market-leading brands which are globally recognized and respected. REED, Hi-Life Tools, and Howell Penncraft are long established product lines that continue to offer

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## How to Order

When ordering or requesting a quotation for Single Bump or End Rolling Head thread rolls, please furnish the following information:

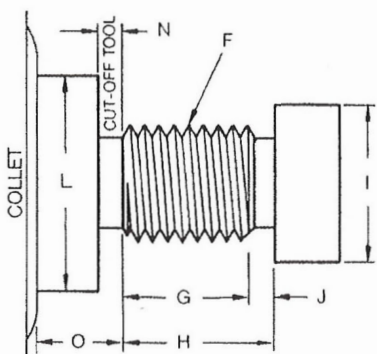


Figure 1

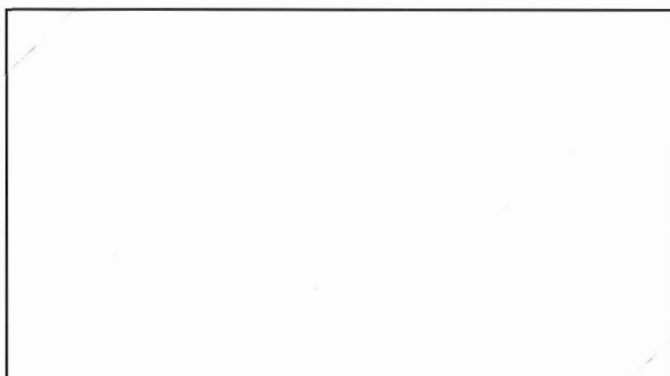
### SINGLE-BUMP THREAD ROLLS

1. Head/Holder Model or Size
2. Roll Type or Style
3. Work Specification (reference Figure 1)
  - F. Thread size
  - G. Thread length
  - H. Position of shoulder on work
  - I. Size of shoulder on work
  - J. Distance to first full thread
  - K. Material
4. Setup and Application Requirements
  - L. Stock size
  - M. Cut-off end work
  - N. Width of cut-off tool
  - O. Position of threaded section in relation to collet face
  - K. Spindle speed
5. Wall Thickness

### END ROLLING HEAD THREAD ROLLS

1. Head: make, size, model
2. Thread Size
3. Thread Length
4. Die Relief
  - a. Long
  - b. Short
  - c. Standard
5. Material
6. Spindle Speed
7. Stock Size
8. Wall Thickness

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