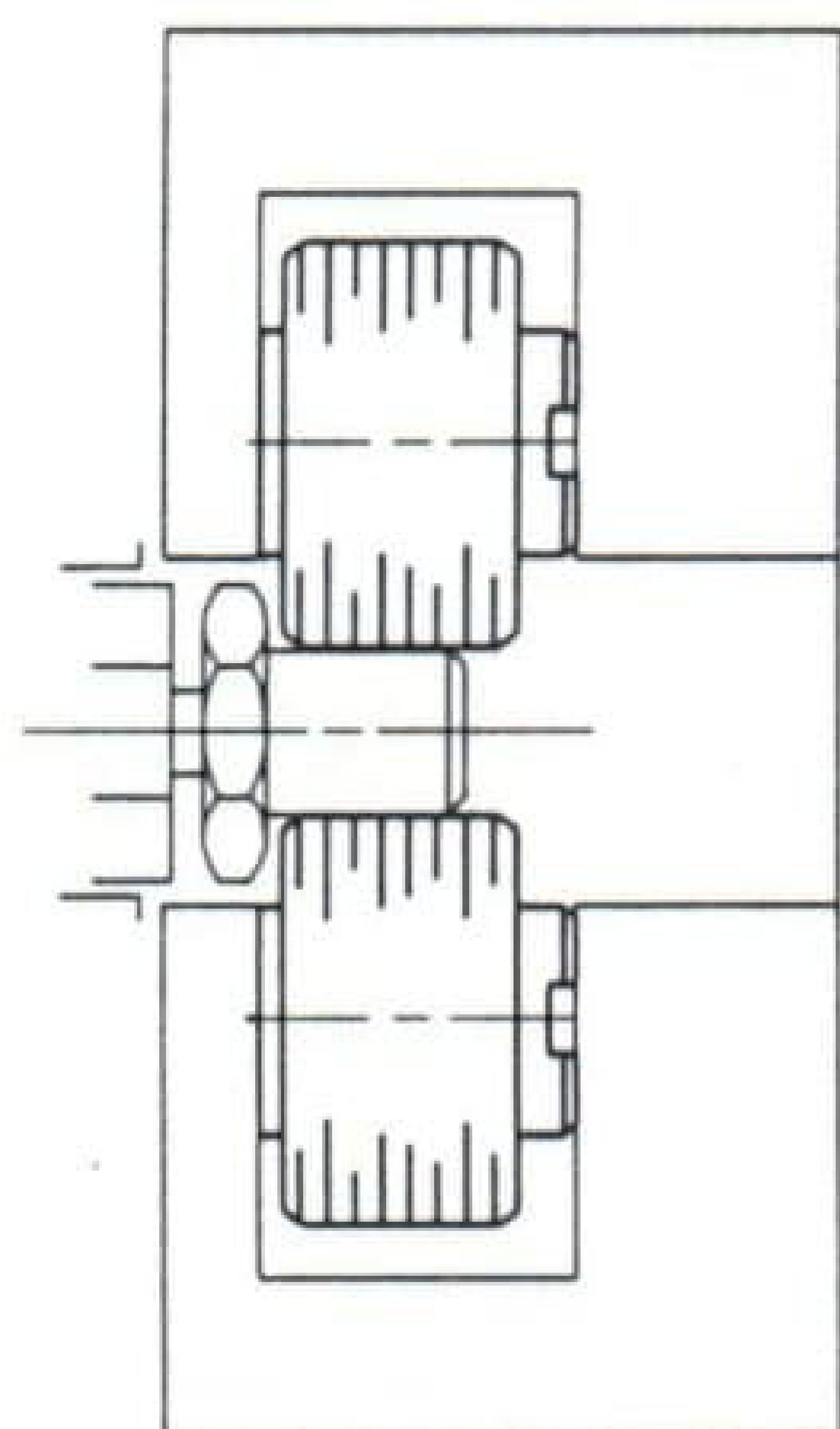


# THREAD ROLL STYLES

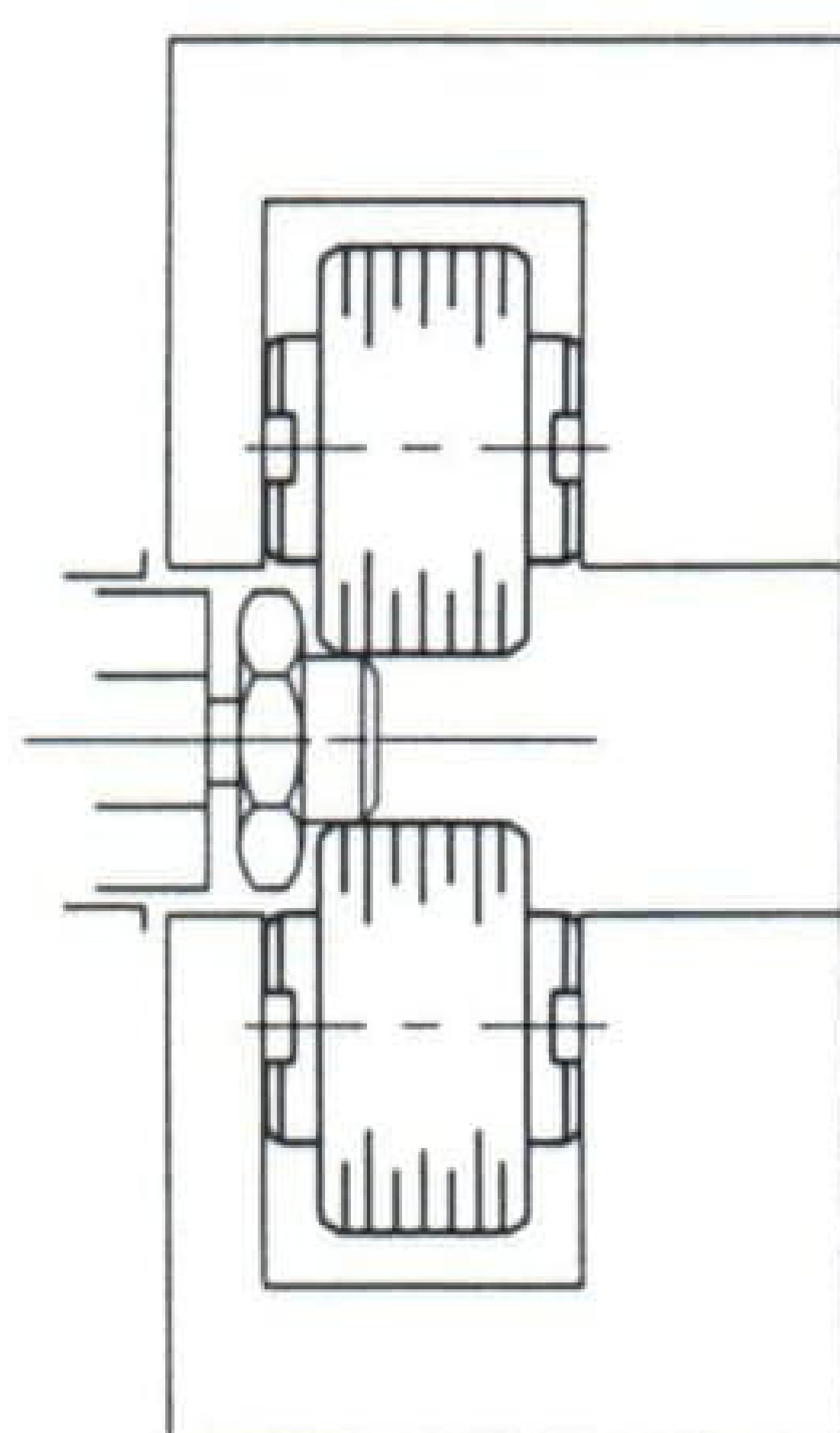
## STANDARD WORKING FACES for THREAD ROLL STYLE TYPES 1

### THREAD ROLL STYLE

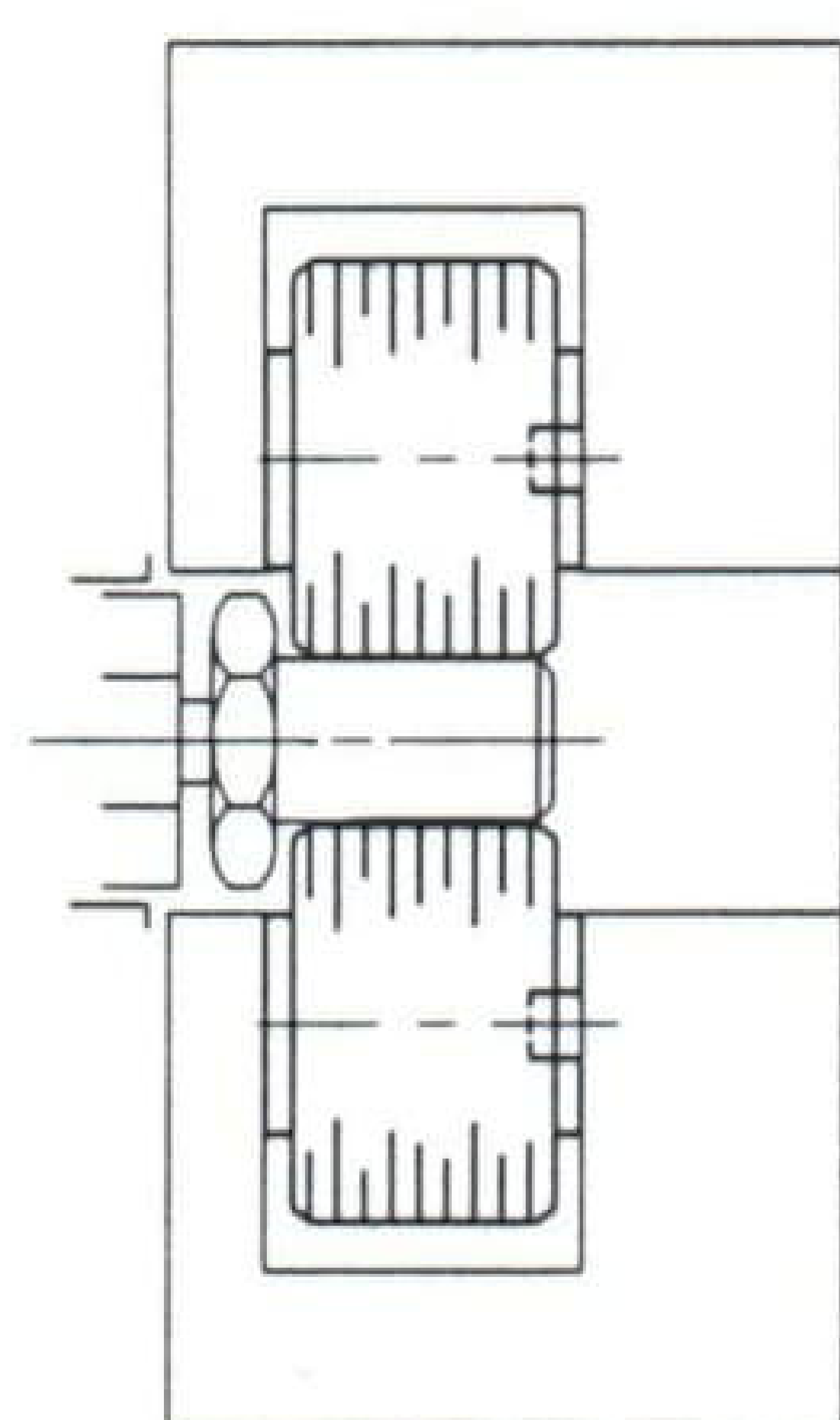
	TC-1	TCR-1	ID-1	TDR-1
<b>DAVENPORT</b>				
1421SA	0.625	0.500	0.750	0.750
1431SA	0.625	0.500	0.750	0.750
1448SA	0.625	0.500	0.750	0.750
<b>DETROIT</b>				
76000 (0-375)	0.530	0.468	0.593	0.593
76100 (6-625)	0.625	0.500	0.750	0.750
76200 (10-750)	0.812	0.688	0.938	0.938
76300 (30-1000)	0.812	0.688	0.938	0.938
76400 (25-1125)	1.062	0.938	1.188	1.188
<b>LANDIS</b>				
14GA	0.625	0.500	-	-
18GA	0.844	0.750	-	-
20GA	1.000	0.813	-	-
22GA	1.375	1.000	-	-
24GA	1.500	1.250	-	-
<b>REED</b>				
B-5	0.500	-	-	-
B-8	0.500	0.437	0.560	0.560
B-10 (500-G2A)	0.625	0.500	0.750	0.750
B-13 (750-G2A)	0.875	0.750	1.000	1.000
B-18 (1000-G2A)	1.125	1.000	1.250	1.250
B-36	1.125	1.000	1.250	1.250
<b>SALVO</b>				
CBL	0.812	0.688	0.937	0.937
BBL	1.062	0.937	1.187	1.187
DBL	1.312	1.187	1.437	1.437
SOB	1.062	0.937	1.187	1.187
<b>WINTER</b>				
125-SA	0.550	0.487	0.636	0.636
134-SA	0.625	0.500	0.750	0.750
141-SA	0.875	0.750	1.000	1.000
151-SA	0.875	0.750	1.000	1.000
160-SA	1.530	1.417	1.656	1.656
162-SA/163-SA	1.265	1.135	1.390	1.390
170-SA	1.530	1.417	1.656	1.656
172-SA/173-SA	1.265	1.135	1.390	1.390



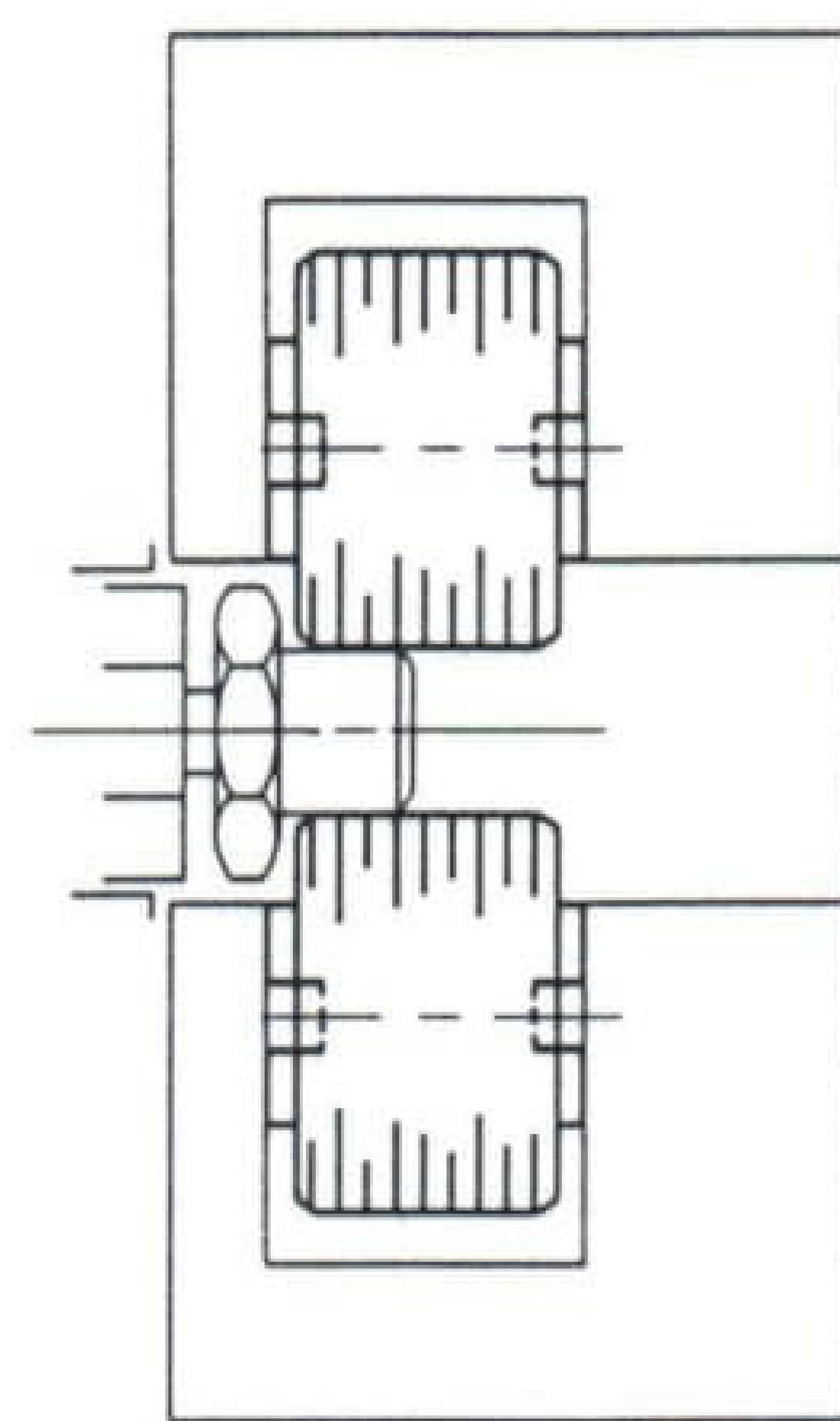
TC - 1



TCR - 1



TD - 1

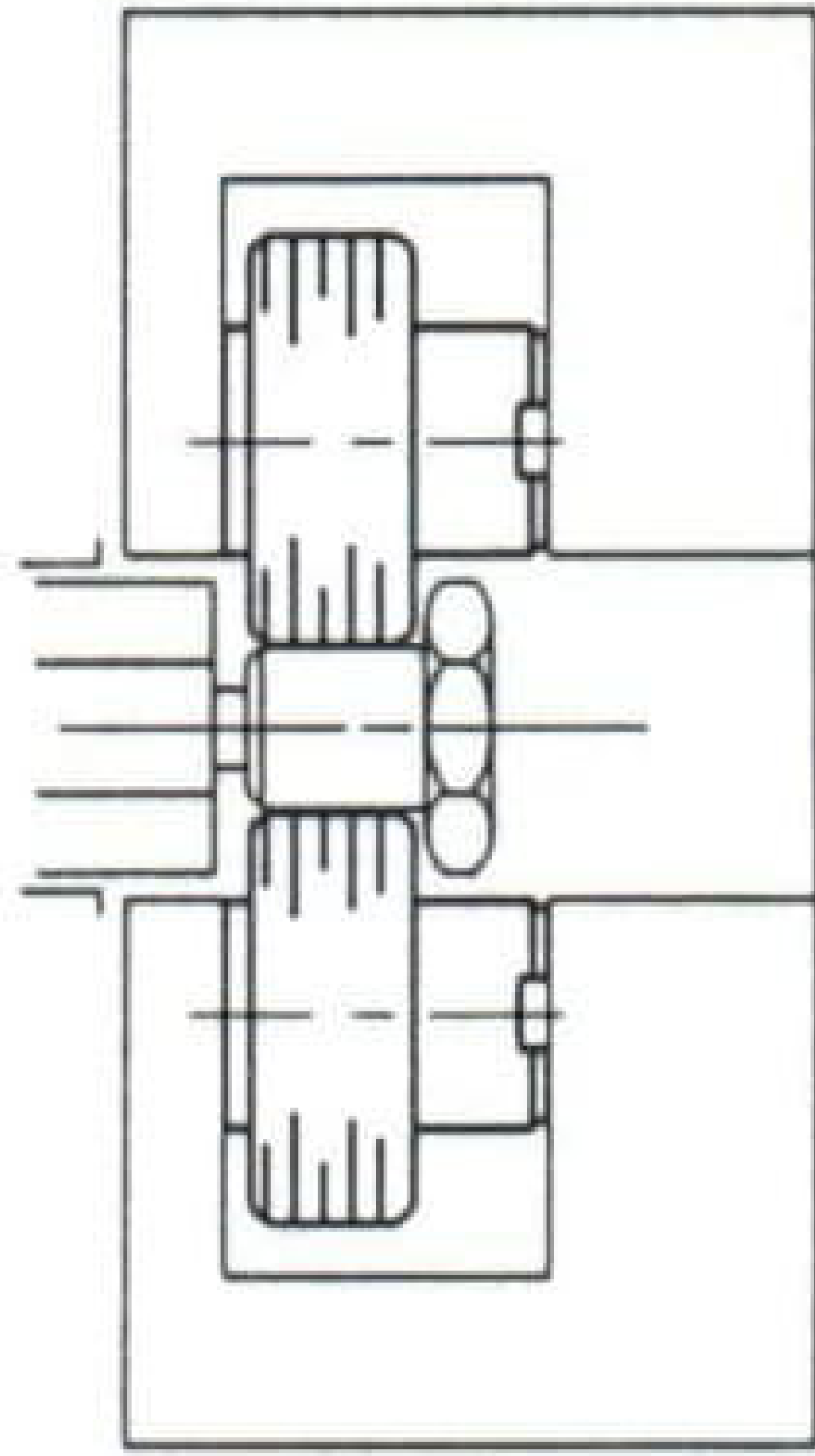


TDR - 1

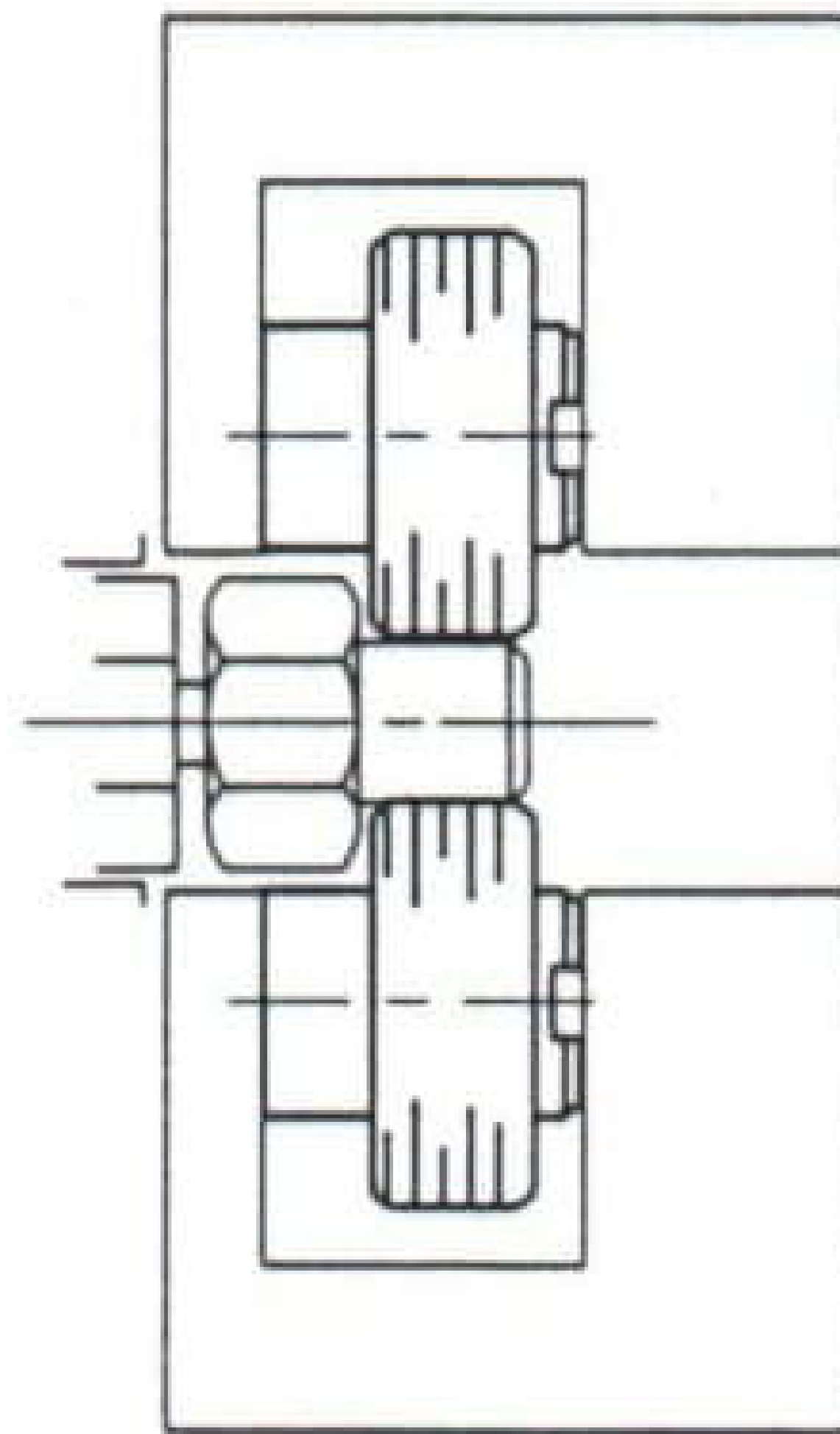
## THREAD ROLL STYLES (cont'd)

\* WORKING FACE MUST BE SPECIFIED for STYLE TYPES 2, 3, and 4

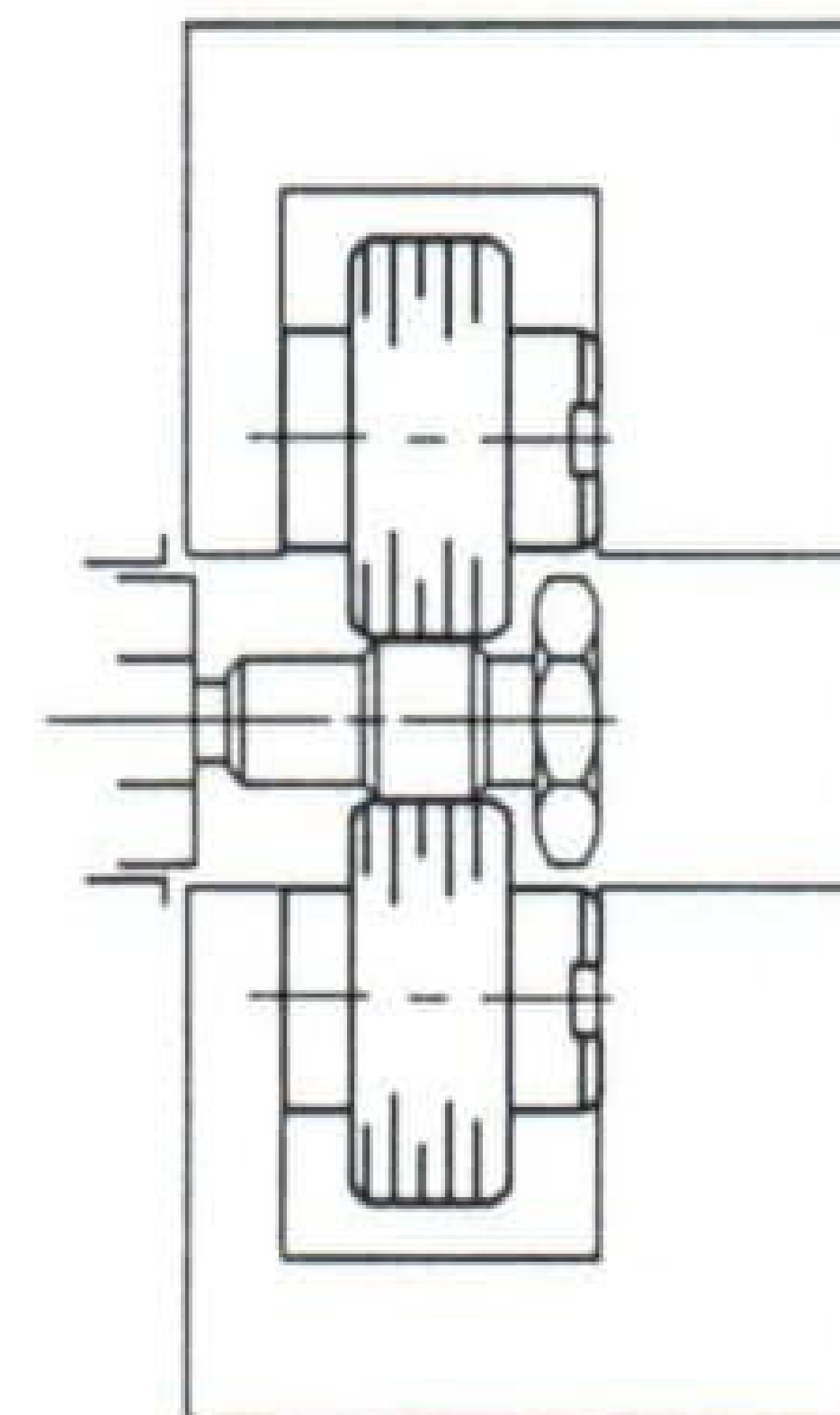
\*\* WORKING FACES & SHOULDER (OR GROOVE) DIAMETER MUST BE SPECIFIED for  
STYLE TYPES 5



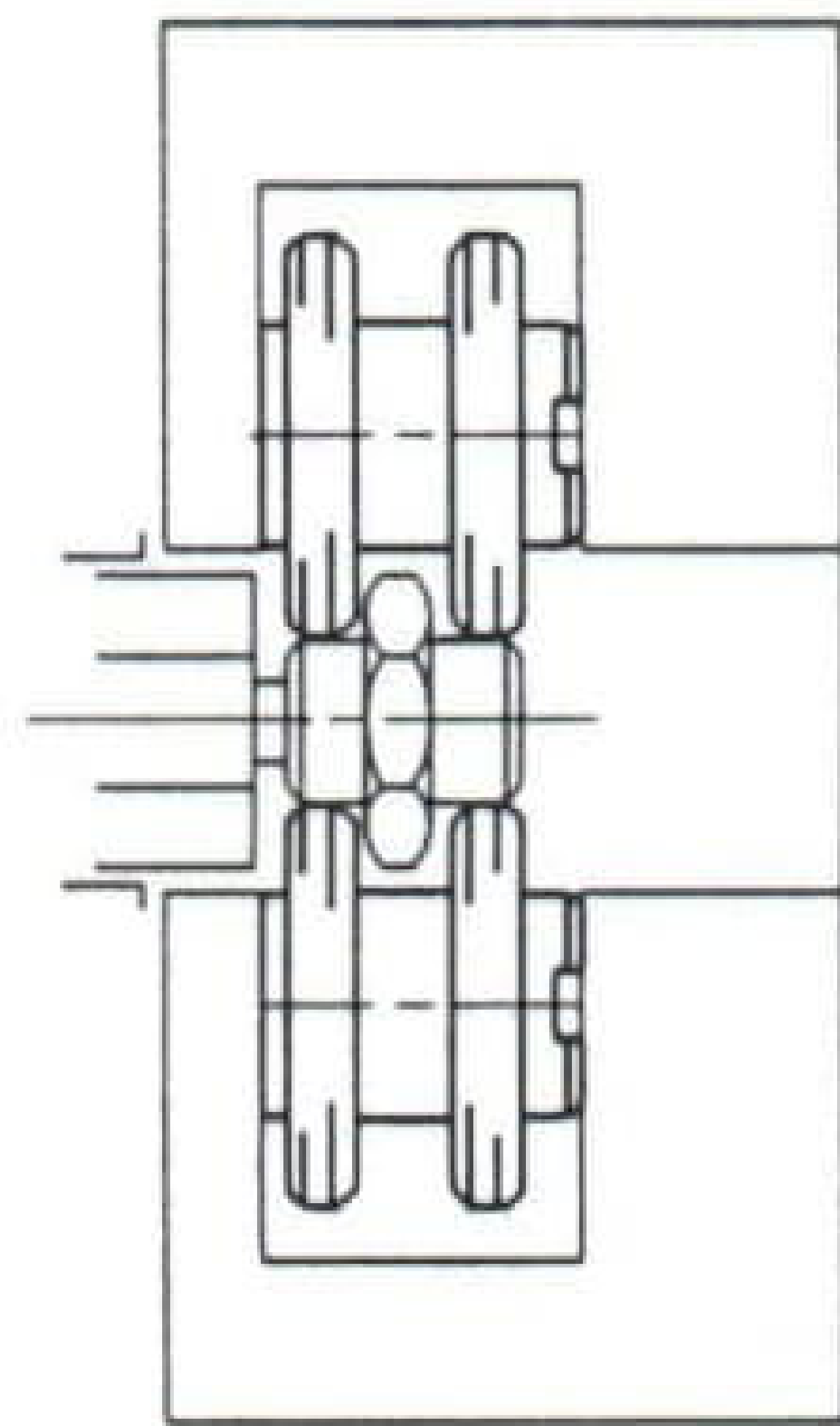
TC-2\*



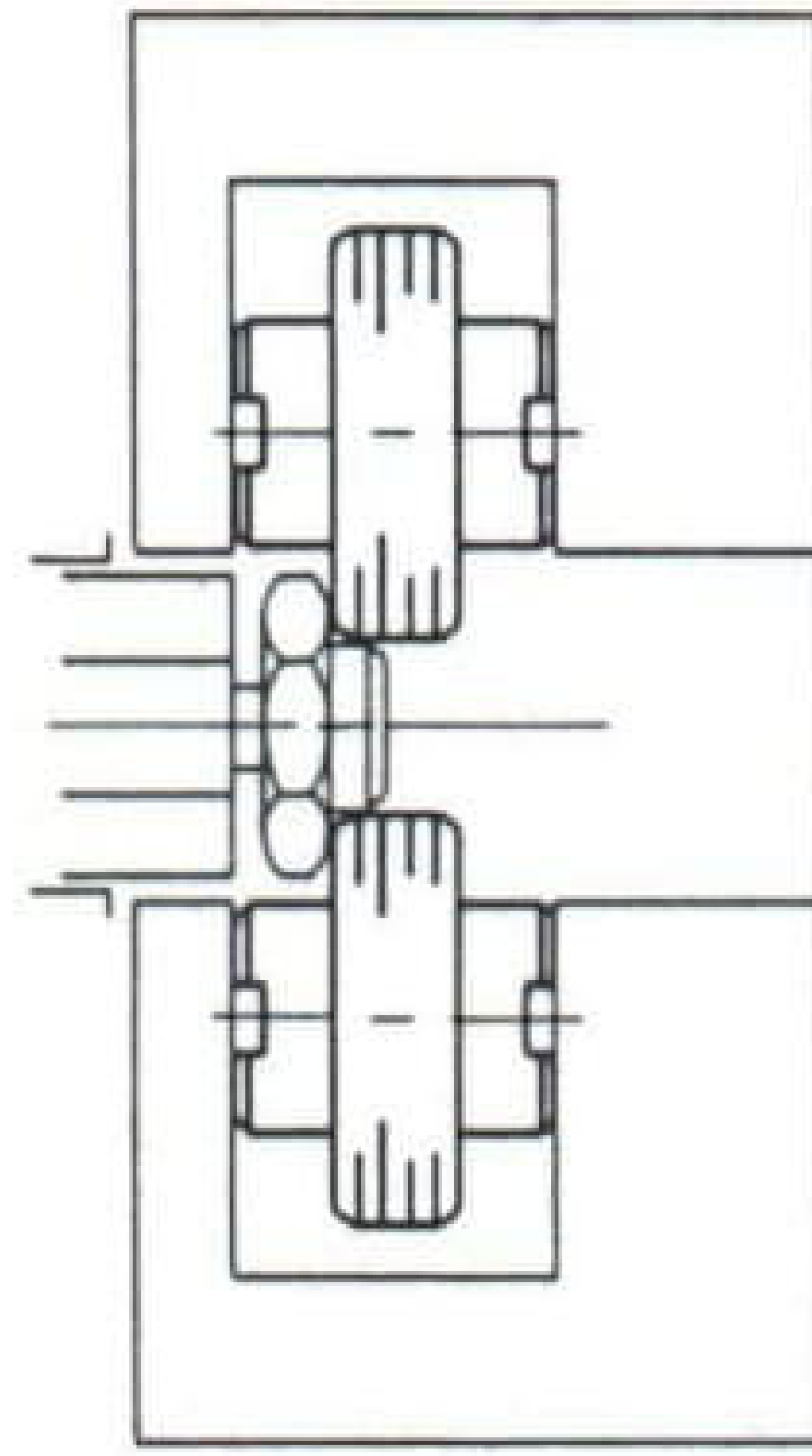
TC-3\*



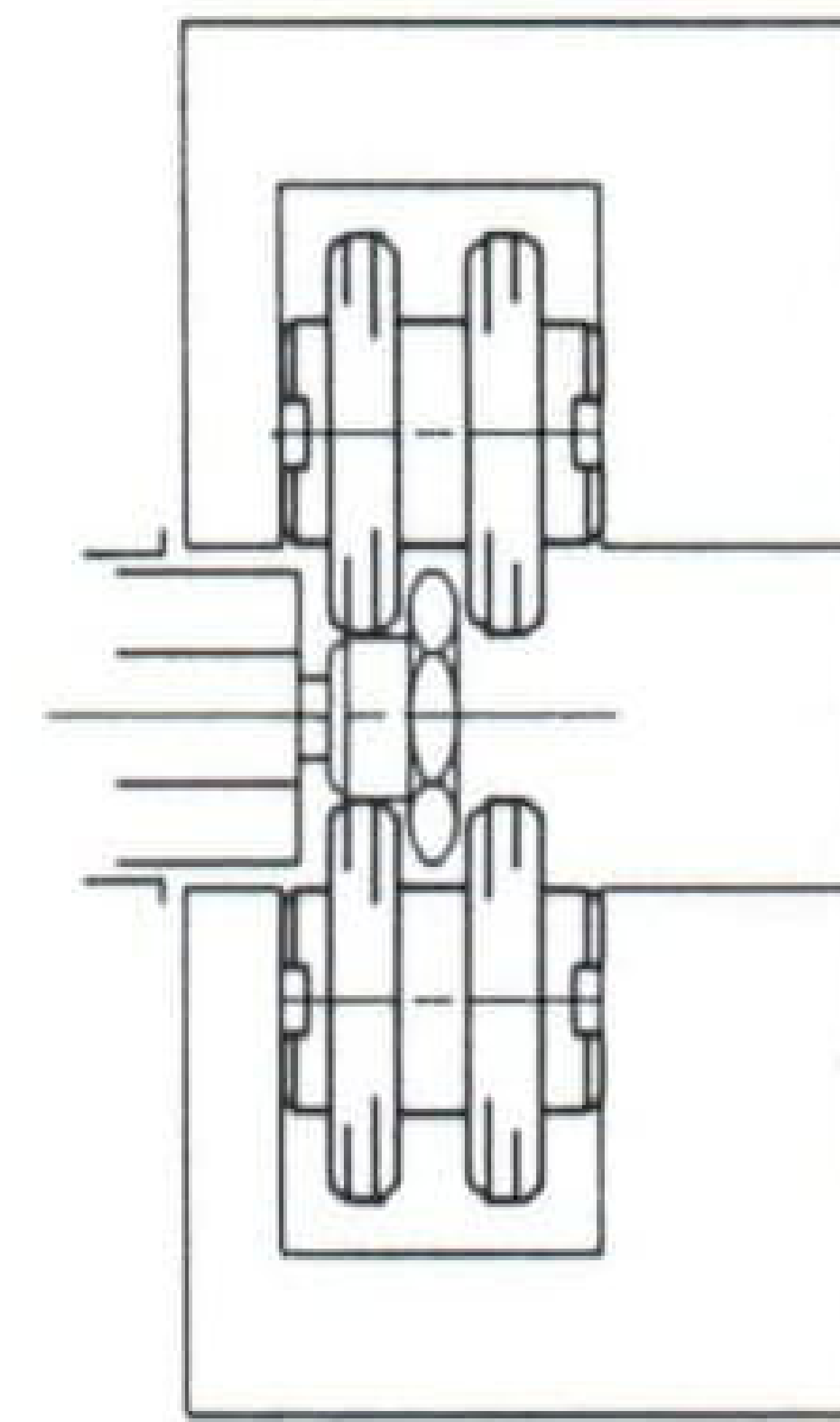
TC-4\*



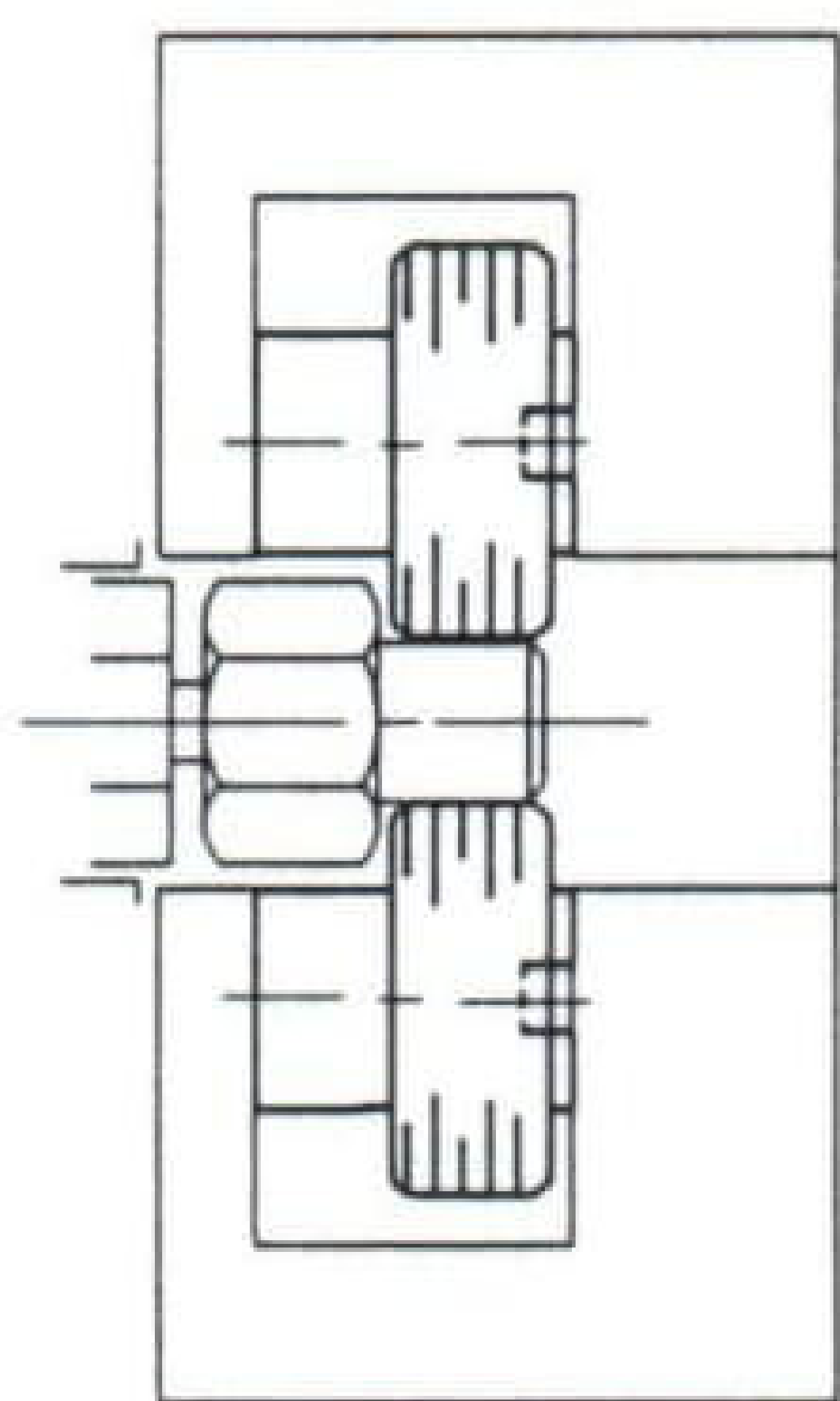
TC-5\*\*



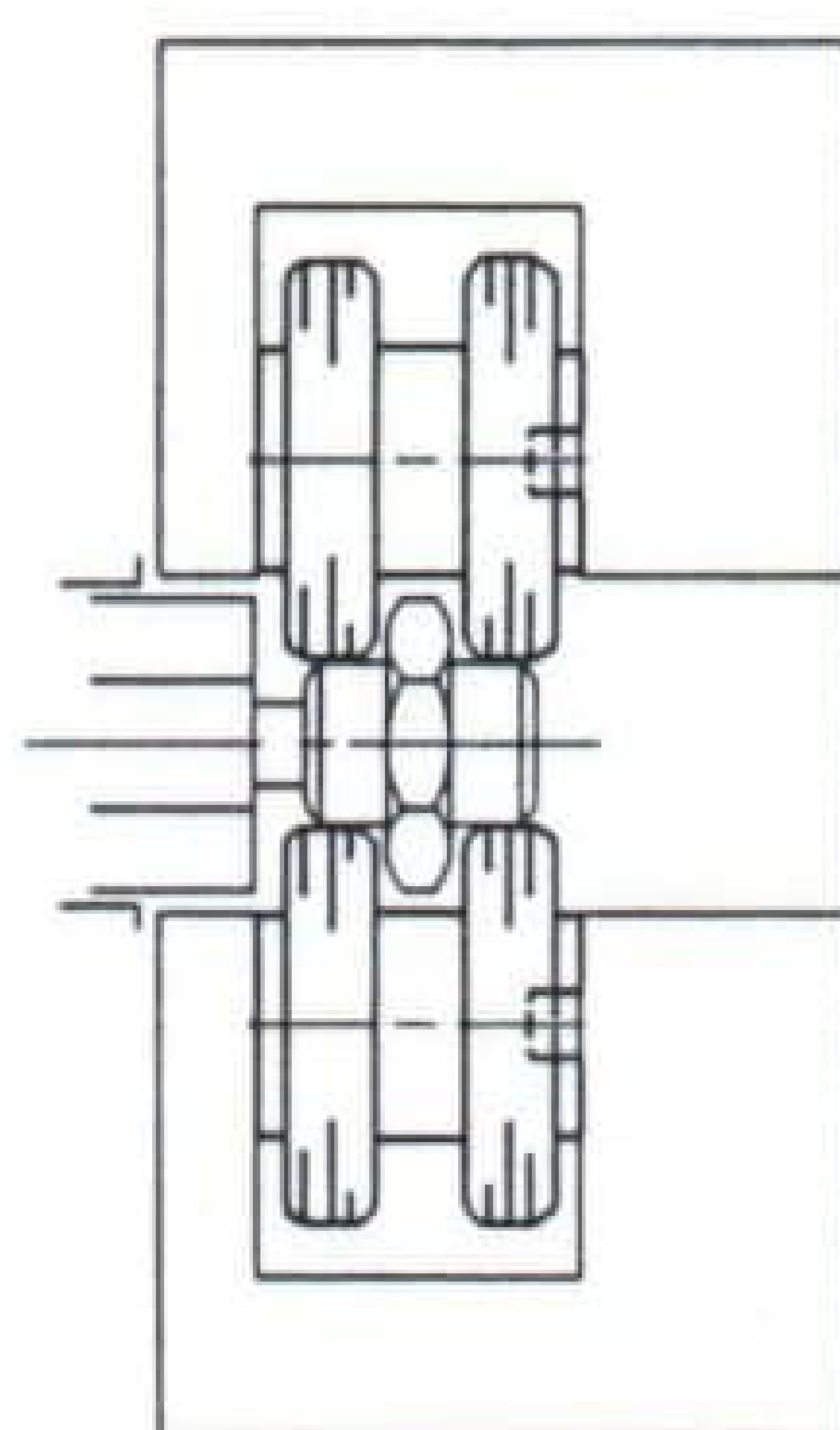
TCR-4\*



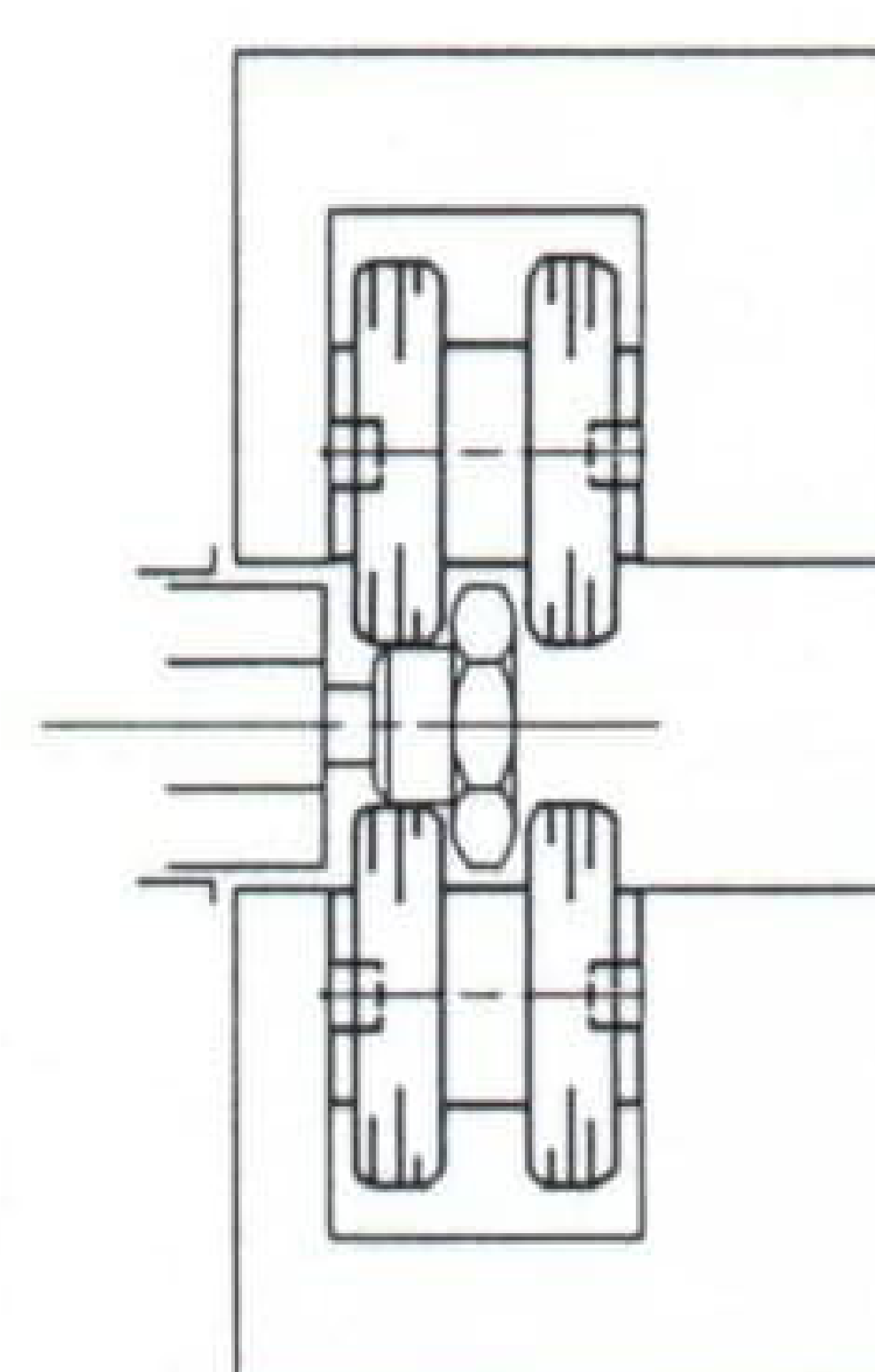
TCR-5\*\*



TD-3\*



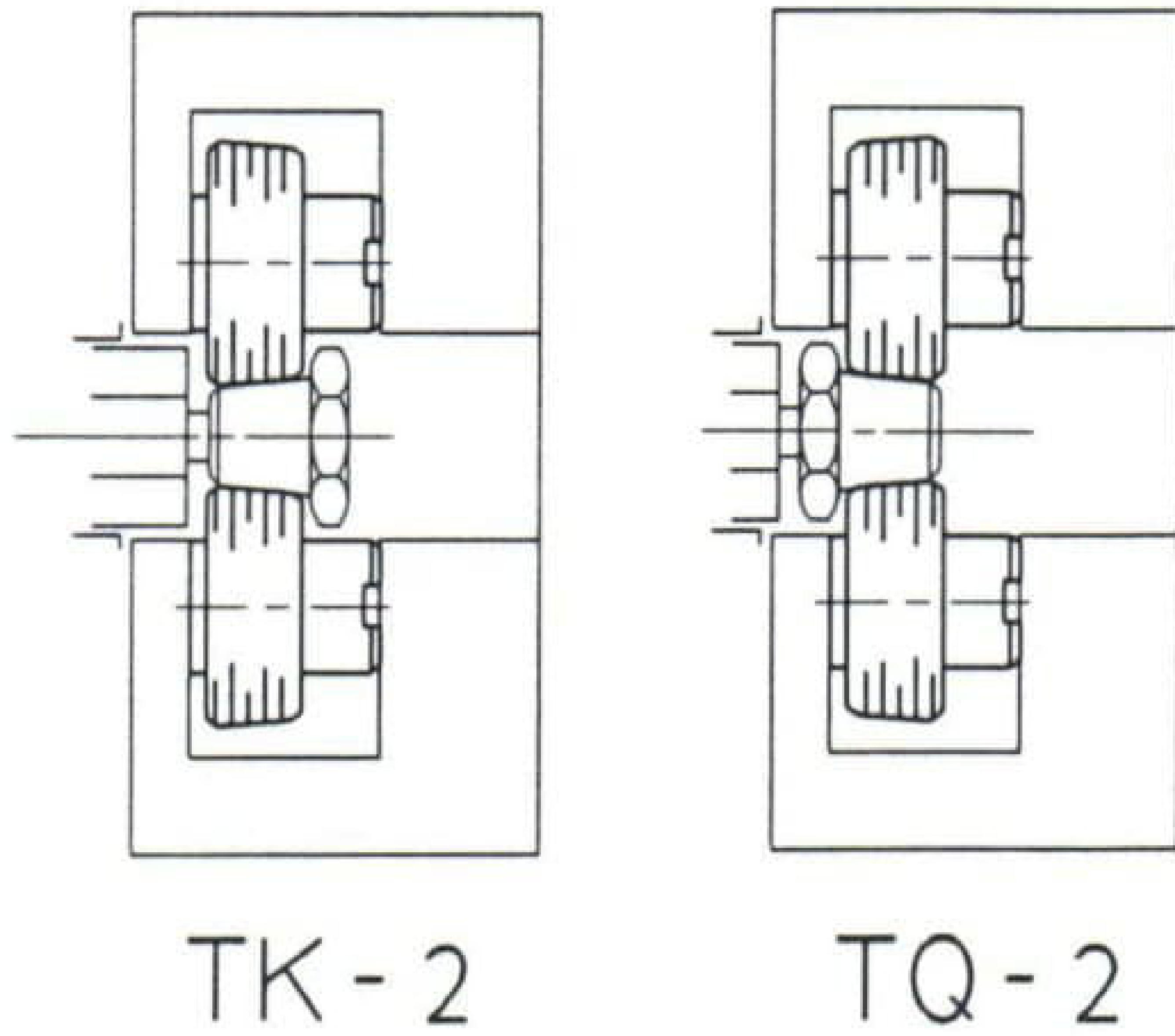
TD-5\*\*



TDR-5\*\*



## THREAD ROLL STYLES (cont'd)



### STANDARD WORKING FACES for TAPERED PIPE THREAD ROLL *STYLES TK-2 & TQ-2*

THREAD SIZE	STANDARD WORKING FACE
1/16-27	0.375
1/8-27	0.375
1/4-18	0.562
3/8-18	0.562
1/2-14	0.712
3/4-14	0.724
1"-11 1/2	0.900
1 1/4-11 1/2	0.924
1 1/2-11 1/2	0.941

## BUMP TYPE THREAD ROLLS

<p><b>B &amp; S:</b> 83-200 <b>DETROIT:</b> 309-5 <b>REED:</b> A00-54 <b>SALVO:</b> SA-00</p>	<p><b>B &amp; S:</b> 83-120/84-100 <b>DETROIT:</b> 309-4 <b>REED:</b> A00-86/A0-86 <b>SALVO:</b> SA-0/SB-00</p>	<p><b>B &amp; S:</b> 83-122/84-120 <b>DETROIT:</b> 309-6 <b>REED:</b> A0-108/A2-108 <b>SALVO:</b> SA-2/SB-0</p>	<p><b>B &amp; S:</b> 84-122  <b>REED:</b> A2-1210 <b>SALVO:</b> SB-2</p>
<p>TF-1-44    TF-1-54</p>	<p>TF-1-66    TF-1-86</p>	<p>TF-1-88    TF-1-108</p>	<p>TF-1-1210</p>
<p>TF-2-44    TF-2-54</p>	<p>TF-2-66    TF-2-86</p>	<p>TF-2-88    TF-2-108</p>	<p>TF-2-1210</p>
<p><b><u>STANDARD WORKING FACES FOR TAPERED PIPE BUMP ROLLS ARE THE SAME AS THOSE LISTED ABOVE FOR STYLES TK-2 &amp; TQ-2</u></b></p>	<p>TY-2-86</p>	<p>TY-2-108</p>	<p>TY-2-1210</p>