

## Roll holder table RA10 for axial rolling systems type RS10 and RAR10-2

### Roll holder table RA10 for axial rolling systems type RS10-FL and RAR10-FL

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads											
				Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads						
Item number		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm						UNC	UNF	UNEF	UN	UNS	NPT	
RA10-0-4.0 73942000	R20/9,8	1.5–4.0	KD+0,85	M2.2					No. 2-56	No. 2-64					
	R20/10,5	1.7–4.0	KD+1.05	M2.5					No. 3-48	No. 3-56					
	R20	1.8–4.0	KD+1.2	M3–M3.5	M2.5 × 0.35				No. 4-40	No. 4-48					
RA10-1-5.0 75740000	R21/14	2.2–3.4 8.8	KD+3.4	M3 M3.5		1/8"			No. 5-40 No. 6-32	No. 5-44 No. 6-40					
RA10-1-5.0 75740000	R21	2.8–4.0 5.8	KD+6.4	M4 M4.5		1/32"	3/16"-32 7/32"-28		No. 8-32 No. 10-24 No. 12-24	No. 8-36 No. 10-32			No. 10-28		
RA10-1-3.0 75740200	R21/14	2.2–3.4 8.8	KD+3.4	M3 M3.5	M3 × 0.35 M3.5 × 0.35										
RA10-1-3.0 75740200	R21	2.8–4.0 5.8	KD+6.4		M4–5 × 0.35 M4–5 × 0.5										
RA10-2-4.0 75740400	R23	3.8–8.6 10.3	KD+7.4	M5–M10	M5.5–6.5 × 0.75 M10 × 1.25	1/4" 5/16" 3/8"	1/4"-26 5/16"-22 3/8"-20		1/4-20 5/16-18 3/8-16–20	No. 12-28 1/4-28 5/16-24	No. 12-32 1/4-32	5/16-20	No. 10-36–40 No. 12-36–40 1/4-24–36 5/16-27 3/8-18		
RA10-2-2.5 75740600	R23	3.8–8.6 10.3	KD+7.4		M5.5–6 × 0.5 M7–9.5 × 0.75 M7.5–10 × 1			G1/8"		3/8-24	5/16-32 3/8-32	5/16-28 3/8-28	No. 10-48–56 No. 12-48–56 1/4-40–48 5/16-36–40 0.390-27 3/8-27–36	1/16-27 1/8-27	
RA10-2-1.5 75742400	R23	3.8–8.6 10.3	KD+7.4		M5.5–9 × 0.35 M6.5–9 × 0.5								1/4-56 5/16-48 3/8-40		

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
R20/9.8 = 9.8/6 × 8 R20/10.5 = 10.5/6 × 8 R20 = 11/6 × 8	–	–	6 × 18.2	72000500	–	–
R21/14 = 14/9 × 8 R21 = 17/9 × 8	45–1.5 × 7.8	03462053	6 × 18.2	72000500	9/6 × 7.9	03463106
R23 = 20/11 × 10	57–1.5 × 9.8	03462054	8 × 18.2	72000400	11/8 × 9.9	03463101

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

## Roll holder table for grooving rolling systems RAR10-2-S

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Roll bolt		Bearing needles		Carbide bushings	
Item number	Dimensions D/d × W in mm	Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm	D × L in mm	Item number	Pieces, Needles D × L in mm	Item number	D/d × L in mm	Item number
<b>RA10-0-0.0</b> 74344100	<b>R20-10</b> 10.2/6 × 10	1.5–4.0 6.0	KD + 1.0	6 × 18.2	72000500	–	–	–	–
<b>RA10-1-0.0</b> 73047500	<b>R21/14</b> 14/9 × 8 <b>R21</b> 17/9 × 8	2.2–7.6 8.8 2.8–4.6 5.8	KD + 3.4 KD + 6.4	6 × 18.2	72000500	45–1.5 × 7.8	03462053	9/6 × 7.9	03463106
<b>RA10-2-0.0</b> 72405700	<b>R23</b> 20/11 × 10	3.8–8.6 10.3	KD + 7.4	8 × 18.2	72000400	57–1.5 × 9.8	03462054	11/8 × 9.9	03463101

## Roll holder table RA16 for axial rolling systems type RS16 und RAR16-2

Roll holder Designation	Roll Designation	Rolling range	max. collar Ø on the workpiece	Types of threads											
				Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads						
Item number		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm						UNC	UNF	UNEF	UN	UNS	NPT	
<b>RA16-0-3.6</b> 75740800	<b>R21/14</b>	2.2–6.0	KD + 3.4	M3											
	<b>R21</b>	3.0–9.3 10.3	KD + 6.4	M4 M4.5	M4–4.5 × 0.35 M4.5 × 0.5		3/16"-32 7/32"-28		No. 8-32 No. 10-24 No. 12-24	No. 8-36 No. 10-32 No. 12-28			No. 10-28–40		
<b>RA16-1-3.2</b> 75741000	<b>R25</b>	4.0–10.2 11.2	KD + 9.4	M5* M6–M10	M5.5–7 × 0.75 M7.5–9 × 1.0 M10 × 1.25		1/4"-26 5/16"-22 3/8"-20 7/16"-8		1/4-20 5/16-18 3/8-16 7/16-14	1/4-28 5/16-24 7/16-20	No. 12-32 1/4-32	5/16-20–28 3/8-20–24 7/16-16	No. 12-36–40 1/4-24–36 5/16-27 3/8-18 7/16-18–24		
<b>RA16-1-2.0</b> 75741200	<b>R25</b>	4.0–10.2 11.2	KD + 9.4		M5–6.5 × 0.35 M5–9 × 0.5 M7–11.5 × 0.75 M9.5–10.5 × 1				G1/8" R1/8"		3/8-24 7/16-20	5/16-32 3/8-32 7/16-28	3/8-28 7/16-32	No. 10-48–56 No. 12-48–56 1/4-40–56 5/16-36–48 3/8-27–40 0,390-27 7/16-27	1/16-27 1/8-27
<b>RA16-1-1.0</b> 75741400	<b>R25</b>	4.0–10.2 11.2	KD + 9.4		M7–11.5 × 0.35 M9.5–10.5 × 0.5										
<b>RA16-2-3.5</b> 75741600	<b>R25</b>	9.0–15.5 16.2	KD + 9.4	M12–M16	M12 × 1.5	1/2–5/8"	1/2"-16 9/16"-16 5/8"-14		1/2-13 9/16-12 5/8-11			1/2-16 5/8-16 11/16-12–16	7/16-18 1/2-12–18 9/16-16 5/8-14		
<b>RA16-2-2.0</b> 75741800	<b>R25</b>	9.0–15.5 16.2	KD + 9.4		M11–13 × 0.75 M10.5–16 × 1 M12–17 × 1.5 M12–18 × 1.25				G1/4" R1/4"		1/2-20 7/16-20 9/16-18 5/8-18	7/16-28 1/2-28 9/16-24 5/8-24	1/2-32 9/16-20–28 5/8-12–20 11/16-20	7/16-24–27 1/2-24–27 9/16-27 5/8-27	1/4-18 3/8-18
<b>RA16-2-1.0</b> 75742000	<b>R25</b>	9.0–15.5 16.2	KD + 9.4		M10–16 × 0.5 M10.5–16 × 0.75								9/16-32 5/8-28–32		
<b>RA16-3-1.5</b> 75742200	<b>R24</b>	15.0–22.0 23.0	KD + 9.4		M16–22 × 0.5 M17–23 × 0.75 M17–23 × 1 M17–23 × 1.5				G1/2" G3/8"		3/4-16 7/8-14	11/16-24 3/4-20 13/16-20 7/8-20	11/16-28–32 3/4-28–32 13/16-16–32 7/8-16–32	3/4-14–27 7/8-18–27	
<b>RA16-3-1.5</b> 75742200	<b>R23</b>	17.0–24.0 25.0	KD + 7.4		M22.5–24.5 × 0.5 M24–25 × 0.75 M24–25 × 1 M24–25 × 1.5						15/16-20 1-10	15/16-16–32 1-16–32	1-18–27		

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
<b>R21</b> = 17/9 × 8 <b>R21/14</b> = 14/9 × 8	45–1.5 × 7.8	03462053	6 × 25	71980900	9/6 × 7.9	03463106
<b>R23</b> = 20/11 × 10 <b>R24</b> = 22/11 × 10	57–1.5 × 9.8	03462054	8 × 25	71981000	11/8 × 9.9	03463101
<b>R25</b> = 25/15 × 13	45–2.5 × 12.8	03462061	10 × 25	71981100	15/10 × 12.9	03463102

\* R25 with major diameter 24.5 mm

Max. thread length including run-out:

> Ø 16 mm to Ø 22 mm = 27 mm

For thread: > Ø 22 mm to Ø 25 mm = 19 mm

D = Major diameter

W = Width of Roll

d = Bore diameter

L = Length

## Roll holder table RA16-FI for axial rolling systems Typ RS16-FI and RAR16-2-FI

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Types of threads										
				Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads					
Item number		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm						UNC	UNF	UNEF	UN	UNS	NPT
<b>RA16-0-3.6</b> 75740800	<b>R21</b>	3.0–6.5 8.7	KD + 6.4	M4–M7	M4–4.5 × 0.35 M4–M7 × 0.5				10-24 12-24	8-36 10-32 12-28	12-32	5/16-20	10-28 10-32 10-40	
<b>RA16-0.5-3.2</b> 74784900	<b>R25</b>	3.8–7.5 9.4	KD + 9.4	M5–M9	M5–M7 × 0.5 M8 × 1	1/4 × 1/20 5/16 × 1/18	1/4"-22 5/16"-22		5/16-18	1/4-28 5/16-24	12-32 1/4-32	5/16-20 5/16-28	12-36 1/4-24 1/4-27	
<b>RA16-1-3.2</b> 75741000	<b>R25</b>	6.5–10 12.4	KD + 9.4	M9–M12	M10 × 1.25 M12 × 1.5	3/8 × 1/16 7/16 × 1/14 1/2 × 1/12	3/8"-20 7/16"-18		3/8-16 7/16-14	3/8-24 7/16-20		5/16-28 3/8-20 7/16-16	5/16-27 3/8-18 7/16-18	
<b>RA16-1-2.0</b> 75741200	<b>R25</b>	6.5–10 12.4	KD + 9.4		M8–M9 × 0.5 M8–M10 × 1			G1/8" R1/8"		3/8-24 7/16-20	5/16-32 3/8-32 7/16-28	3/8-28	5/16-36, 5/16-40 3/8-27, 3/8-36 7/16-24, 7/16-27	1/16-27 1/8-27
<b>RA16-1-1.0</b> 75741400	<b>R25</b>	6.5–10 12.4	KD + 9.4		M8–M10 × 0.35 M8–M10 × 0.5	5/8 × 1/11							5/16-48 3/8-40	
<b>RA16-2-3.5</b> 75741600	<b>R25</b>	10.0–15.4 16.2	KD + 9.4	M14–M16			1/2"-16		9/16-12 5/8-11			1/2-16 5/8-12	1/2-12, 1/2-14 1/2-18 9/16-14	
<b>RA16-2-2.0</b> 75741800	<b>R25</b>	10.0–15.4 16.2	KD + 9.4		M12–M16 × 1 M12–M16 × 1.25 M13–M16 × 1.5		9/16"-16 5/8"-14	G1/4" R1/4" G3/8"		1/2-20 9/16-18 5/8-18	1/2-28 9/16-24 5/8-24	1/2-32 9/16-20–32 5/8-16–28	1/2-24, 1/2-27 9/16-27	1/4-18
<b>RA16-2-1.0</b> 75742000	<b>R25</b>	10.0–15.4 16.2	KD + 9.4		M12–M16 × 0.75							9/16-32 5/8-28–32		
<b>RA16-3-1.5</b> 75742200	<b>R24</b>	16.0–20.0 23.3	KD + 9.4		M18–M23 × 0.75 M18–M23 × 1 M19–M23 × 1.5			G1/2"		3/4-16		3/4-28–32	3/4-14, 3/4-18 3/4-24, 3/4-27	
<b>RA16-3-1.5</b> 75742200	<b>R23</b>	18.0–22.0 25.3	KD + 7.4		M20–M23 × 0.75 M20–M23 × 1 M21–M24 × .5					7/8-14	7/8-20	7/8-26–32	7/8-18 7/8-18 7/8-27	

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
<b>R21</b> = 17/9 × 8	45–1.5 × 7.8	03462053	6 × 25	71980900	9/6 × 7.9	03463106
<b>R23</b> = 20/11 × 10 <b>R24</b> = 22/11 × 10	57–1.5 × 9.8	03462054	8 × 25	71981000	11/8 × 9.9	03463101
<b>R25</b> = 25/15 × 13	45–2.5 × 12.8	03462061	10 × 25	71981100	15/10 × 12.9	03463102

Max. thread length including run-out:  
> Ø 16 mm bis Ø 22 mm = 27 mm

For threads:  
> Ø 22 mm bis Ø 25 mm = 19 mm

D = Major diameter      W = Width of roll  
d = Bore diameter      L = Length

## Roll holder table for grooving rolling systems RAR16-2-S

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Roll bolt		Bearing needles		Carbide bushings	
Item number	Dimensions D/d × W in mm	Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm	D × L in mm	Item number	Pieces, Needles D × L in mm	Item number	D/d × L in mm	Item number
<b>RA16-1-0.0</b> 73523500	<b>R25</b> 25/15 × 13	4.0–10.2 11.2	KD + 9.4	10 × 25	71981100	45–2.5 × 12.8	3462061	15/10 × 12.9	3463102
<b>RA16-2-0.0</b> 73021900	<b>R25</b> 25/15 × 13	9.0–15.5 16.2	KD + 9.4	10 × 25	71981100	45–2.5 × 12.8	3462061	15/10 × 12.9	3463102
<b>RA16-3-0.0</b> 73022100	<b>R25</b> 25/15 × 13	9.0–15.5 16.2	KD + 9.4	10 × 25	71981100	45–2.5 × 12.8	3462061	15/10 × 12.9	3463102

D = Major diameter  
d = Bore diameter

W = Width of roll  
L = Length

## Roll holder table RA16-VB for axial rolling systems type RS16-VB and RAR16-VB

Roll holder Designation	Roll Designation	Working range	Types of threads									
			Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads				
Item number	Minor-Ø in mm largest outer Ø	UNC						UNF	UNEF	UN	UNS	
<b>RA16-VB-1-3.2</b> 73257300	<b>R25-10VB</b>	4.0–10.2 11.2	M5* M6–M10	M5.5–M7 × 0.75 M7.5–M9 × 1.0	7/32" 1/4–3/8"	1/4"-26 5/16"-22 3/8"-20 7/16"-18		1/4-20 5/16-18 3/8-16	1/4-28 5/16-24 7/16-20	No. 12-32 1/4-32	5/16-20–28 3/8-20–24 7/16-16	No. 12-36–40 1/4-24–36 5/16-27 3/8-18 7/16-18–24
<b>RA16-VB-1-2.0</b> 73270700	<b>R25-10VB</b>	4.0–10.2 11.2		M5–M6.5 × 0.35 M5–M9 × 0.5 M7–M11.5 × 0.75 M9.5–M11.5 × 1			G1/8"		7/16-20	3/4-24 5/16-32 3/8-32 7/16-28	3/8-28 7/16-32	No. 10-48–56 No. 12-48–56 1/4-40–56 5/16-36–48 3/8-27–40 0,390-27 7/16-27
<b>RA16-VB-2-2.0</b> 73257500	<b>R25-10VB</b>	9.0–15.5 16.2		M11–M13 × 0.75 M10.5–M16 × 1 M12–M16 × 1.5			G1/4"		1/2-20 7/16-20 9/16-18 5/8-18	7/16-28 1/2-28 9/16-24 5/8-24	1/2-32 9/16-20–28 5/8-16–20 11/16-20	7/1-24–27 1/2-24–27 9/16-27 5/8-27
<b>RA16-VB-3-1.5</b> 73257700	<b>R25-10VB</b>	15.0–22.0 23		M16–M22 × 0.5 M17–M23 × 0.75 M17–M23 × 1 M17–M23 × 1.5					3/4-16	11/16-24 3/4-20 13/16-20 7/8-20	11/16-28–32 3/4-28–32 13/16-16–32 7/8-16–32	3/4-14–27 7/8-18–27

\*R25-10VB with major diameter 24.5 mm

Rolls = D / d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Max. thread length including run-out: > Ø 16 mm bis Ø 22 mm = 33 mm		
<b>R25-10VB</b> = 25/15 × 10	–	–	17/11 × 25	78046200	For threads: > Ø 22 mm bis Ø 23 mm = 26 mm	D = Major diameter d = Bore diameter	W = Width of roll L = Length

## Roll holder table RA22 for axial rolling systems type Typ RS22-2 und RR22-2

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads										
				Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads					
Item number		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm						UNC	UNF	UNEF	UN	UNS	NPT
<b>RA22-0-3.8</b> 75744200	<b>R25</b>	3.8–12.4 15.0	KD + 8.4	M5* M6 M7	M4,5–6.5 × 0.5 M5.5–6.5 × 0.75	1/4" 5/16–1/2"	1/4"-26 5/16"-22		No. 12-24 1/4-20 5/16-18 3/8-16 7/16-14 1/2-13	No. 12-28 1/4-28	No. 12-32 1/4-32	5/16-20	No. 10-36–48 No. 12-36–48 1/4-24–48 1/2-12	
<b>RA22-1-3.0</b> 75744400	<b>R27</b>	6.0–15.0 18.0	KD + 16.4	M8–18	M7,5–M9,5 × 1 M10–12 × 1.25 M12–14 × 1.5 M18 × 2	3/8–1/2"	3/8"-20 7/16"-18 1/2–9/16"-16 5/8–11/16"-14		9/16-12 5/8-11	5/16-24 3/8-24 7/16-20 1/2-20		5/16-28 3/8-20 7/16–9/16-16 5/8-12	5/16-27 3/8–7/16-18 1/2-14–18 9/16–5/8-14	1/16-27
<b>RA22-1-2.0</b> 75744600	<b>R27</b>	6.0–15.0 18.0	KD + 16.4		M7–9 × 0,5 M7–15 × 0,75 M9,5–16 × 1 M15–17 × 1,5			G1/8–3/8"		1/2-20 9/16-18 5/8-18	5/16–3/8-32 7/16–1/2-28 9/16–5/8-24	3/8-28 1/2-32 9/16-20–32 5/8-16–20	5/16-36–48 3/8-27–40 0,390-27 7/16-24–27 1/2-24–27 9/16–5/8-27	1/8-27 1/4-18 3/8-18
<b>RA22-1-1.0</b> 75744800	<b>R27</b>	6.0–15.0 18.0	KD + 16.4		M9–15,5 × 0.5 M12–16 × 0.75 M16 × 1							5/8-28 5/8-32		
<b>RA22-2-3.2</b> 75745000	<b>R27</b>	14.0–23.0 26.0	KD + 16.4	M18–22	M24 × 2.5		3/4–13/16"-12 7/8–15/16"-11 1"-10		3/4-10			11/16-12 3/4-12 13/16-12	7/8-10 1-10–14	
<b>RA22-2-2.0</b> 75745200	<b>R27</b>	14.0–23.0 26.0	KD + 16.4		M18–25 × 1.5 M20–25 × 2			G1/2"		3/4-16 7/8-14 1-12	5/8-24 11/16-24 3/4-20 13/16-20 7/8-20	7/8-12 11/16–16–20 13/16-16 7/8-16 15/16-12–16	3/4-14–24 7/8-18 1-10–14	1/2-14 3/4-14

\*R25 with major diameter 24.5 mm

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## Roll holder table RA22 for axial rolling systems Typ RS22-2 and RR22-2 (cont.)

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads											
				Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228, DIN EN 10226	American threads						
Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	UNC						UNF	UNEF	UN	UNS	NPT		
<b>RA22-2-1.0</b> 75745400	<b>R27</b>	14.0–23.0 26.0	KD + 16.4		M15–23.5 × 0.5 M16–24 × 0.75 M16–24 × 1 M23–25 × 1.5								5/16-20 11/16-28–32 3/4-28–32 13/16-28–32 7/8-28–32 15/16-28–32	3/4-27 7/8-24 7/8-27	
<b>RA22-2-3.6</b> 75745600	<b>R27/22</b>	14.0–23.0 26.0	KD + 16.4	M24		3/4–1"				7/8-9 1-8					
<b>RA22-3-2.0</b> 75745800	<b>R27</b>	21.0–31.2 34.0	KD + 16.4		M26–34 × 2			G3/4–1"		1-12 1 1/8-12 1 1/4-12		15/16-12–16 1-16 1 1/16-12–16 1 1/8-16 1 3/16-12–16 1 5/16-12–16 1 1/4-16	1-18 1 1/8-10–14 1 1/4-10–14		
<b>RA22-3-1.0</b> 75746000	<b>R27</b>	21.0–31.2 34.0	KD + 16.4		M23–32 × 0.75 M23–32 × 1 M24–33 × 1.5 M30–34 × 2						15/16-20 1-20 1 1/16–1 5/16-18	15/16-28–32 1-28–32 1 1/16–1 5/16 -20–28	1-24–27 1 1/8-24 1 1/4-24		
<b>RA22-3-1.0</b> 75746000	<b>R26</b>	24.0–34.2 37.0	KD + 13.4		M33–35 × 0.75 M33–35 × 1 M34–36 × 1.5 M35–36 × 2					1 3/8-12	1 5/16-18 1 3/8-18	1 5/16-20–28 1 3/8-14–28 1 7/16-12	1 3/8-10–24		

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
<b>R25</b> = 25/15x13	45–2.5 × 12.8	03462061	10 × 33	74545300	15/10 × 12.9	03463102
<b>R26</b> = 32/17x17 <b>R27</b> = 35/17x17	54–2.5 × 16.8	03462065	12 × 33	70239200	17/12 × 16.8	03463103
<b>R27/22</b> = 35/17x22	54–2.5 × 21.8	03462067	12 × 35	72411300	-	-

Max. thread length including run-out:  
> Ø 27 mm bis Ø 32 mm = 50 mm

For threads:  
> Ø 32 mm bis Ø 36 mm = 26 mm

D = Major diameter      W = Width of roll  
d = Bore diameter      L = Length



## Roll holder table for grooving rolling systems RR22-2

Roll holder Designation	Cam ring	Roll Designation	Working range	max. collar Ø on the workpiece	Roll bolt		Bearing needles		Carbide bushings	
Item number		Dimensions D/d × W in mm	Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm	D × L in mm	Item number	Pieces, Needles D × L in mm	Item number	D/d × L in mm	Item number
<b>RA22-00-0.0</b> 74021000	H34	<b>R29</b> 18/11 × 13	2.8–10.0 14.0	KD + 4	11 × 33	74021200	–	–	–	–
<b>RA22-0-0.0</b> 74158100	H34	<b>R25</b> 25/15 × 13	4.0–13.0 15.0	KD + 8.4	10 × 33	74545300	45–2.5 × 12.8	3462061	15/10 × 12.9	3463102
<b>RA22-0.5-0.0-22</b> 72405700	H36	<b>R27/29-22</b> 29/17 × 22	4.5–14.0 20.5	KD + 10	12 × 35	72411300	54–2.5 × 21.8	3462067	17/12 × 21.8	73818000
<b>RA22-0.5-0.0-28</b> 74774200	H40	<b>R27-28</b> 33/17 × 28	5.6–15.0 19.0	KD + 16.4	12 × 39.8	74729500	108–2.5 × 12.8	78042800	–	–
<b>RA22-1-0.0</b> 74774200	H34	<b>R27</b> 35/17 × 17	6.0–15.0 18.0	KD + 16.4	12 × 33	70239200	54–2.5 × 16.8	3462065	17/12 × 16.8	03463103
<b>RA22-1-0.0-22</b> 74290200	H36	<b>R27-22</b> 35/17 × 22	6.0–15.0 18.0	KD + 16.4	12 × 35	72411300	54–2.5 × 21.8	3462067	17/12 × 21.8	73818000
<b>RA22-1-0.0-28</b> 73098500	H40	<b>R27-28</b> 33/17 × 28	6.0–15.0 18.0	KD + 16.4	12 × 39.8	74729500	108–2.5 × 12.8	78042800	–	–
<b>RA22-1.1-0.0</b> 74278000	H34	<b>R27</b> 35/17 × 17	8.5–17.5 21.5	KD + 16.4	12 × 33	70239200	54–2.5 × 16.8	3462065	17/12 × 16.8	03463103
<b>RA22-2-0.0-22</b> 73047200	H36	<b>R27-22</b> 35/17 × 22	14.0–23.0 27.0	KD + 16.4	12x35	72411300	54–2.5 × 21.8	3462067	17/12 × 21.8	73818000
<b>RA22-2-0.0-28</b> 73804700	H40	<b>R27-28</b> 35/17 × 28	14.0–23.0 27.0	KD + 16.4	12 × 39.8	74729500	108–2.5 × 12.8	78042800	–	–
<b>RA22-3-0.0-28</b> 73804700	H40	<b>R27-28</b> 35/17 × 28	22.0–31.0 34.0	KD + 16.4	12 × 39.8	74729500	108–2.5 × 12.8	78042800	–	–

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

## Roll holder table RA27/56 for axial rolling systems Typ RS27/56 and RR27/56 (cont.)

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads								
				Metric fine thread DIN 13	Whitworth pipe thread DIN 259	Whitworth pipe thread DIN EN ISO 228 DIN EN 10226	American threads					
Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	UNC				UNF	UNEF	UN	UNS	NPT	
<b>RA27/56-0-3.8</b> 74446000	<b>R25</b> with roll bolt 74446200	3.8–7 12.0	KD + 8.4	M5**–M8  M4.5–6.5 × 0.5 M5.5–6.5 × 0.75			No. 12-24 1/4-20 5/16-18 3/8-16 7/16-14 1/2-13		No. 12-32 1/4-32	5/16-20	No. 10-36–48 No. 12-36–48 1/4-24–48 1/2-12	
<b>RA27/56-1-3.0</b> 73733000	<b>R27</b> with roll bolt 73734400	6.6–12.6 16.0	KD + 16.4	M8–14 M12 × 1.5			3/8–7/16-14–16 1/2-13 9/16-12 5/8-11	5/16-24	7/16-28	3/8-20 1/2-16 5/8-12	3/8–7/16-18–27 1/2-12–18 9/16–5/8-14	
<b>RA27/56-1-2.0</b> 73733200	<b>R27</b> with roll bolt 73734400	6.6–12.6 16.0	KD + 16.4	M9–14 × 1 M12–16 × 1.5	G1/8" G1/4"	R1/8" R1/4"		5/16 & 3/8-24 1/2-20 9/16-18	9/16-24	9/16-16–20	1/2-24–27 9/16-27	1/8-27 1/4-18
<b>RA27/56-2-3.0</b> 73733400	<b>R27</b> with roll bolt 70239200	12.6–18.6 22.0	KD + 16.4	M16–22			3/4-10 7/8-9					
<b>RA27/56-2-2.0</b> 73733600	<b>R27</b> with roll bolt 70239200	12.6–18.6 22.0	KD + 16.4	M15–20 × 1 M16–20 × 1.5 M18–21 × 2	G3/8" G1/2"	R3/8" R1/2"		3/4-16 5/8-18	5/8–11/16-24 3/4-20	5/8-16–20 11/16-12–20 13/16-12–16	5/8-14–27 3/4-14–27	3/8-18 1/2-14
<b>RA27/56-3-2,8-22</b> 73733800	<b>R27/22</b> with roll bolt 72411300	18.6–24.6 28.0	KD + 16.4	M24–27			1-8					3/4-14

\*\*R25 with major diameter 24.5mm

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## Roll holder table RA27/56 for axial rolling systems Type RS27/56 and RR27/56 (cont.)

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads								
				Metric fine thread DIN 13	Whitworth pipe thread DIN 259	Whitworth pipe thread DIN EN ISO 228 DIN EN 10226	American threads					
Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	UNC				UNF	UNEF	UN	UNS	NPT	
<b>RA27/56-3-2.0</b> 73734000	<b>R27</b> with roll bolt 70239200	18.6–24.6 28.0	KD + 16.4	M21–26 × 1 M21–26 × 1.5 M22–27 × 2	G5/8" G3/4"	R3/4"		7/8-14 1-12	3/4-20 7/8-20 1-20 15/16-20	7/8–15/16-12–16 1-16 1 1/8-12	7/8-18–27 1-14–27	
<b>RA27/56-4-1.5</b> 73734200	<b>R27</b> with roll bolt 70239200	24.6–30.6 34.0	KD + 16.4	M27–32 × 1 M27–32 × 1.5 M28–33 × 2	G7/8" G1"		1 1/4-12	1 1/8–1 1/4-18 1 1/8-18	1 1/8–1 1/4-16–20 1 3/8-12–20 1 5/8-12	1 1/8-14–24 1 1/4-14–24		
<b>RA27/56-5-1.2</b> 73734600	<b>R27</b> with roll bolt 70239200	30.6–36.6 40.0	KD + 16.4	M33–38 × 1 M34–39 × 1.5 M35–40 × 2	G1 1/8"		1 3/8-12 1 1/2-12	1 5/8-18 1 3/8-18 1 1/2-18 1 7/8-18	1 5/8–1 3/8-16–20 1 7/8-12–20 1 1/2-16–20	1 3/8-14–24 1 1/2-14–24		
<b>RA27/56-6-1.0</b> 73735000	<b>R27</b> with roll bolt 70239200	36.6–42.6 46.0	KD + 16.4	M39–44 × 1 M40–45 × 1.5 M41–45 × 2	G1 1/4" G1 3/8"			1 5/8-18 1 1/4-18	1 5/8–1 3/4-10–20 1 3/8-12	1 5/8-10–24 1 3/4-14–18		
<b>RA27/56-7-1.0</b> 73735200	<b>R27</b> with roll bolt 70239200	42.6–48.6 52.0	KD + 16.4	M45–50 × 1 M46–50 × 1.5 M46–52 × 2	G1 1/2" G1 5/8"				1 13/16–1 15/16-16–20 2-12–16	1 7/8-14–18 2-14–18		
<b>RA27/56-8-0.8*</b> 73735400	<b>R27</b> with roll bolt 70239200	48.6–54.6 58.0	KD + 16.4	M51–56 × 1 M52–56 × 1.5 M53–56 × 2	G1 3/4"				2-20 2 1/8-12–20 2 1/4-12	2 1/8-16 2 3/8-16 2 1/4-14		

\*max. thread length including run-out for threads larger than diameter 52 = 31mm long

Rolls = D / d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
<b>R25</b> = 25/15 × 13	45–2.5 × 12.8	03462061	10 × 25	71981100	15/10 × 12.9	03463102
<b>R27</b> = 35/17 × 17	54–2.5 × 16.8	03462065	12 × 33	70239200	17/12 × 16.8	03463103
<b>R27/22</b> = 35/17 × 22	54–2.5 × 21.8	03462067	12 × 35	72411300	17/12 × 21.9	73818000

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

threads not listed with pitches 3.0 mm or 8, 9 and 10 threads/inch as well as trapezoidal threads on request.

BSF threads can be rolled with holders from the UN series.

## Roll holder table RA42 for axial rolling systems Type RS42 und RR42

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads												
				Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 229 DIN EN 10226	American threads				
UNC	UNF	UNEF	UN									UNS	NPT			
<b>RA42-00-3.5</b> 73352300	<b>R25</b>	4.0–10.2 15.0	KD + 9.4	M5–M7												
<b>RA42-0-3.0</b> 73121000	<b>R27</b>	6.0–10.0 20.0	KD + 22	M8–M12	M7.5–M8.5 × 1	3/8"	5/16"-22		5/16-18 3/8-16	5/16-24		5/16-20	5/16-27	1/16-27		
<b>RA42-1-3.0</b> 73121200	<b>R32</b>	7.5–18.0 22.0	KD + 22	M10–M20	M10 × 1.25 M12 × 1.5	7/16" 1/2" 5/8" 3/4" 7/8"	3/8"-20 7/16"-18 1/2"-16 5/8"-14		7/16-14 1/2-13 9/16-12	7/16-20		3/8-20 9/16-16 5/8-3/4-12	3/8-7/16-18 1/2-12-18 9/16-14-27 5/8-14			
<b>RA42-1-2.0</b> 73121400	<b>R32</b>	7.5–18.0 22.0	KD + 22		M9–M15 × 1 M12 × 1.25 M13–M20 × 1.5 M18–M20 × 2		9/16"-16 11/16"-14 3/4"-12 13/16"-12	G1/8–3/8" R1/8–1/2"		3/8-24 1/2-20 9/16-18 3/4-16	1/2-28 9/16–5/8-24	3/8-24–28 9/16-20–28 5/8–11/16-16–20 13/16-12	3/8–0.390-27 7/16–9/16-24–27 3/4-14–18	1/8-27 1/4-18 3/8-18 1/2-14		
<b>RA42-1-1.0</b> 73121600	<b>R32</b>	7.5–18.0 22.0	KD + 22		M16–M19 × 1						11/16-24 3/4-20	5/8–3/4-28	5/8-27 3/4-24–27			
<b>RA42-2-3.0</b> 73121800	<b>R32</b>	18.0–28.5 32.5	KD + 22	M22–M33		1" 1 1/8" 1 1/4"			7/8-9 1-8 1 1/8-7 1 1/4-7			1 1/16–1 3/16-8	7/8-10			
<b>RA42-2-2.0</b> 73122000	<b>R32</b>	18.0–28.5 32.5	KD + 22		M21–M30 × 2 M30–M32 × 3		7/8"-11 15/16"-11 1"-10 1 1/8"-9 1 1/4"-9	G1/2"		7/8-14 1-1 1/8-12		1 3/16-16 7/8-12–16 1 1/16-12 1 1/8-8 1 3/16-12 1 1/4-8	7/8-18 1-10–14 1 1/8–1 1/4-10			

Max. thread length—no restriction due to tool and holder

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## Roll holder table RA42 for axial rolling systems Type RS42 und RR42 (cont.)

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads												
				Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 229 DIN EN 10226	American threads				
UNC	UNF	UNEF	UN									UNS	NPT			
<b>RA42-2-1.0</b> 73121800	<b>R32</b>	18.0–28.5 32.5	KD + 22		M20–M30 × 1 M21–M30 × 1.5					G3/4"			3/4–1.20 1 1/16–1 3/16-18	13/16–7/8-28 15/16-12–28 1–1 1/8-16–28 1 3/16-16–20 1 1/4-16	7/8-24–27 1-18–27 1 1/8-14–24	3/4-14
<b>RA42-3-2.5-30</b> 73122400	<b>R34</b> <b>R32*</b> 42/18 x 8-724114	28.5–39.0 44.0	KD + 22	M36–M39	M42 × 4	1 3/8"	1 3/8"-8 1 1/2"				1 3/8-6 1 1/2-6			1 5/16–1 1/2-8* 1 9/16–1 3/4-6	1 5/8-6 1 7/16-6	
<b>RA42-3-1.5</b> 73122600	<b>R32</b>	28.5–39.0 44.0	KD + 22		M32–M42 × 2 M33–M42 × 3			1 5/8"-8	G1–1 1/4"			1/4–1 1/2-12	1/4–1 9/16-18	1 1/4-16–20 1 5/16-12–20 1 3/8-16–20 1 7/16-12–16 1 1/2-16 1 5/8-8–12	1 1/4-14–24 1 3/8–1 1/2-10–14 1 9/16-8–16 1 5/8-10–14	1-11,5 1 1/4-11,5
<b>RA42-3-0.5</b> 73122800	<b>R32</b>	28.5–39.0 44.0	KD + 22		M31–M40 × 1 M31–M40 × 1.5	PG29								1 3/16–1 3/8-28 1 7/16-20–28 1 1/2-20–28	1 3/8–1 1/2-24 1 1/16-20	

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.	Needle bearing 2-row piece/ needles + ring D x L in mm	complete Item no.
<b>R25</b> = 25/15 × 13	45–2.5 × 12.8	03462061	10 × 49	73352500	15/10 × 12.9	03463102		
<b>R27</b> = 35/17 × 17	54–2.5 × 16.8	03462065	12 × 49	73120700	17/12 × 16.8	03463103		
<b>R30</b> = 45/25 × 22 <b>R32</b> = 48/25 × 22	57–3.5 × 21.8	03462071	18 × 49	71992400	25/18 × 21.8	03463104		
<b>R34</b> = 48/26 × 30	51–4.0 × 29.8	03462078	18 × 49	71992400	26/18 × 29.8	03463107	102-4.0 × 13.8 3-25.9/18.1 × 2.2	78042900

\*With spacer ring

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

The RA42 and RA42/75 roll holder series are designed for easily formable materials.

For materials with tensile strengths  $\delta_b > 1000 \text{ N/mm}^2$  and / or pitches  $P \geq 4 \text{ mm}$ , the S series is preferable.

## Roll holder table RA42 for axial rolling systems Type RS42 and RR42

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Types of threads	
Artikelnummer		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	Trapezoidal thread DIN 103	Cylindrical thread DIN 405
<b>RA42-1-3.0</b> 73121200	<b>R33</b>	7.5–18.0 22.0	KD + 22	Tr10 × 1.5 Tr12–18 × 2 Tr20–22 × 3	Rd20 × 1/8
<b>RA42-1-2.0</b> 73121400	<b>R33</b>	7.5–18.0 22.0	KD + 22	Tr20 × 2	
<b>RA42-1-6.0-30</b> 73127600	<b>R34</b> <b>R33</b> with ring*	7.5–18.0 22.0	KD + 22	Tr12 × 3* Tr14–16 × 4 Tr20 × 5	
<b>RA42-1-5.0-30</b> 73127800	<b>R34</b> <b>R33</b> with ring*	7.5–18.0 22.0	KD + 22	Tr14v15 × 3* Tr18 × 4 Tr22 × 5	Rd 11 × 1/10 Rd 12 × 1/10 Rd14–16 × 1/8*
<b>RA42-1-4.0-30</b> 73128000	<b>R34</b> <b>R33</b> with ring*	7.5–18.0 22.0	KD + 22	Tr14 × 2.5* Tr16–22 × 3* Tr20–22 × 4	Rd20 × 1/8*
<b>RA42-2-3.0</b> 73121800	<b>R33</b>	18.0–28.5 32.5	KD + 22	Tr22–30 × 3	
<b>RA42-2-2.0</b> 74265800	<b>R33</b>	18.0–28.5 32.5	KD + 22	Tr22–32 × 2 Tr30–32 × 3	
<b>RA42-2-5.0-30</b> 73128200	<b>R34</b> <b>R33</b> with ring*	18.0–28.5 32.5	KD + 22	Tr24–26 × 5 Tr25–28 × 6	
<b>RA42-2-4.0-30</b> 73128400	<b>R34</b> <b>R33</b> with ring*	18.0–28.5 32.5	KD + 22	Tr24 × 4 Tr28–30x5 Tr30–32 × 6	
<b>RA42-3-2.0</b> 73128600	<b>R33</b>	28.5–39.0 44.0	KD + 22	Tr34–42 × 3	
<b>RA42-3-4.0-30</b> 73122800	<b>R34</b>	28.5–39.0 44.0	KD + 22	Tr35–36 × 6	
<b>RA42-3-3.0-30</b> 73129000	<b>R34</b>	28.5–39.0 44.0	KD + 22	Tr35–36 × 5	

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.
<b>R32</b> = 48/25 × 22	57–3.5 × 21.8	03462071	18 × 49	71992400
<b>R33</b> = 48/26 × 22	51–4.0 × 21.8	03462075	18 × 49	71992400
<b>R34</b> = 48/26 × 30	51–4.0 × 29.8	03462078	18 × 49	71992400

Carbide bushings D/d × W in mm	Item no.	Needle bearing 2-row piece/ needles + ring D × L in mm	Complete Item no.
15/10 × 12.9	03463102		
17/12 × 16.8	03463103		
26/18 × 29.6	03463107	102-4,0 × 13,8 3-25.9/18.1 × 2.2	3462027 731009 78042900

The rollholder series RA42 and RA42/75 are designed for materials with good formability. For materials with tensile strengths  $\delta_g > 1000 \text{ N/mm}^2$  and/or pitches  $P \geq 4 \text{ mm}$ , the S series is preferable.

\*With spacer ring

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

## Roll holder table RA42/75 for axial rolling systems Type RS42 and RR42 with cam ring RA42/75

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads						
				Metric thread DIN 13 + Tr	Metric fine thread DIN 13	BSF thread	Whitworth pipe thread DIN EN ISO 228	American threads		
Item number		Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm					UNEF	UN	UNS
<b>RA42/75-4-2.2-3.0</b> 73123000	<b>R34</b> <b>R33</b> mit Ring 42/18 × 8-72411400	38.5–49.0 56.0	KD + 22	M45–M52  Tr45 × 5	M45–M52 × 4	1¾"-7 1⅞"-7 2"-7			1⅞-2 ⅞-6 1⅞-1⅞-8	1⅞-6–8
<b>RA42/75-4-1.2</b> 73123200	<b>R32</b>	38.5–49.0 56.0	KD + 22		M42–M48 × 2 M45–M52 × 3		G1½"		1⅞-16 1⅞-12–16 1¾-1⅞-12–16 1⅞-2-12	1⅞-1¾-14 1⅞-12–16 1⅞-10–14 2-14
<b>RA42/75-4-0.6</b> 73123400	<b>R32</b>	38.5–49.0 56.0	KD + 22		M42–M50 × 1 M42–M50 × 1.5 M50–M52 × 2			1⅞-18 1⅞-18	1⅞-1⅞-20 1⅞-16–20 2-16–20	1⅞-24 1¾-18–20 1⅞-2-20
<b>RA42/75-5-1.5-30</b> 73123600	<b>R34</b> <b>R32</b> with ring 42/18 × 8-72411400	49.0–59.5 66.0	KD + 22		M55–M62 × 3 M56–M64 × 4	2¼"-6 2½"-6			2⅞-2¼-6 2⅞-2½-8 2⅞-2½-6–8	
<b>RA42/75-5-0.8</b> 73123800	<b>R32</b>	49.0–59.5 66.0	KD + 22		M52–M60 × 1 M52–M60 × 1.5 M52–M62 × 2.0		G2"		2¼-12–20 2⅞-12–20	2⅞-2⅞-16 2¼-10–18
<b>RA42/75-6-1.2</b> 73124000	<b>R30</b> <b>(R34/45)</b>	59.5–69.5 76.0	KD + 22		M64–M74 × 3 M65–M75 × 4	2¾"-6			2⅞-2⅞-6–8 2¾-10	2½-10
<b>RA42/75-6-0.6</b> 73124200	<b>R30</b> <b>(R34/45)</b>	59.5–69.5 76.0	KD + 19		M62–M70 × 1 M62–M70 × 1.5 M64–M72 × 2		G2½"		2½-2⅞-12–20	2¼-2¾-14–10

Max. thread length: no restriction due to tool and holder

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.	Needle bearing 2-row pieces/ needles + ring D × L in mm	complete Item no.
<b>R30</b> = 45/25 × 22 <b>R32</b> = 48/25 × 22	57–3.5 × 21.8	03462071	18 × 57	71992600	25/18 × 21.8	3463104		
<b>R34</b> = 48/26 × 30	51–4.0 × 29.8	03462078	18 × 49	71992400	26/18 × 29.8	3463107	102–4,0 × 13,8 3–25.9/18,1 × 2.2	03462027 73100900

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

## Roll holder table for grooving rolling systems RR42

Designation Roll holder	Designation Rolls		Working range	max. collar Ø on the workpiece
Item number	D/d × W in mm		Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm
<b>RA42-1-0.0-30</b> 73379500	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	7.5–18.0 22.0	KD + 22
<b>RA42-2-0.0-30</b> 74316700	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	18.0–28.5 32.5	KD + 22
<b>RA42-3-0.0-30</b> 73812000	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	28.5–44.0 20.5	KD + 22

## with cam ring RR42/75

Designation Roll holder	Designation Rolls		Working range	max. collar Ø on the workpiece
Item number	D/d × W in mm		Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm
<b>RA42-4-0.0-30</b> 73812200	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	38.5–44.0 56.0	KD + 18
<b>RA42-5-0.0-30</b> 73812400	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	49.0–59.5 66.0	KD + 18
<b>RA42-6-0.0-30</b> 73812600	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	59.5–69.5 76.0	KD + 22

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item number	Roll bolt D × L in mm	Item number	Carbide bushings D/d × W in mm	Item number	Needle bearing 2-row pieces/needles+ring D × L in mm	Item number complete
<b>R32</b> = 48/25 × 22	57–3.5 × 21.8	03462071	18 × 57	71992600	25/18 × 21.8	3463104		
<b>R34</b> = 48/26 × 30	51–4.0 × 29.8	03462078	18 × 49	71992400	26/18 × 29.8	3463107	102–4.0 × 13.8 3–25.9/18.1 × 2.2	03462027 73100900 78042900

The roll holder series RA42 and RA42/75 are designed for materials with good formability. For large forming forces, the SF series is preferable.  
When installing the R32 rolls, the 72411400 spacer rings are required.

D = Major diameter  
d = Bore diameter

W = Width of roll  
L = Length



## Roll holder table RA42/S for grooving rolling systems RR42-SF

Roll holder Designation (max. collar-Ø)	Roll Designation	Working range	Roll bolt	Spacer washer	Bearing needles		Carbide bushes	
					Quantity D × L in mm	Item number	D/d × L in mm	Item number
Item number	Dimension D/d × B in mm	Minor-Ø in mm from... to... largest outer Ø	Item number	Item number				
<b>RA42 / S-0-0,0-30*</b> (Minor-Ø + 12 mm) 74317000	<b>R32</b> 48/25 × 22	16.5–27 (32)	70754800	72411400	57–3.5 × 21.8	03462071	25/18 × 21.8	03463104
<b>RA42 / S-0-0,0-30*</b> (Minor-Ø + 12 mm) 74317000	<b>R34</b> 48/26 × 30	16.5–27 (32)	70754800	–	51–4.0 × 29.8	03462078	25/18 × 29.8	03463107
<b>RA42 / S-0,1-0,0-30</b> (Minor-Ø + 12 mm) 74228000	<b>R32</b> 48/25 × 22	24.5–35 (40)	70754800	72411400	57–3.5 × 21.8	03462071	25/18 × 21.8	03463104
<b>RA42 / S-0,1-0,0-30</b> (Minor-Ø + 12 mm) 74228000	<b>R34</b> 48/26 × 30	24.5–35 (40)	70754800	–	51–4.0 × 29.8	03462078	25/18 × 29.8	03463107
<b>RA42 / S-0,2-0,0-22</b> (Minor-Ø + 12 mm) 74190300	<b>R32</b> 48/25 × 22	24.5–34 (40)	70754800	–	57–3.5 × 21.8	03462071	25/18 × 21.8	03463104
<b>RA42 / S-1,1-0,0-22*</b> (Minor-Ø + 12 mm) 74486000	<b>R32</b> 48/25 × 22	30.5–41 (46)	70754800	–	57–3.5 × 21.8	03462071	25/18 × 21.8	03463104
<b>RA42 / S-1,1-0,0-30*</b> (Minor-Ø + 12 mm) 74228200	<b>R32</b> 48/25 × 22	30.5–41 (46)	70754800	72411400	57–3.5 × 21.8	03462071	25/18 × 21.8	03463104
<b>RA42 / S-1,1-0,0-30*</b> (Minor-Ø + 12 mm) 74228200	<b>R34</b> 48/26 × 30	30.5–41 (46)	70754800	–	57–4.0 × 29.8	03462078	25/18 × 29.8	03463107

\*Special Rolls up to Ø 52 mm possible

## Roll holder table for grooving rolling systems RR42-SF

Roll holder Designation	Rolls Designation		Working range	max. collar Ø on the workpiece
Item number	D/d × B in mm		Minor-Ø in mm Largest outer Ø	Minor-Ø (KD) + X in mm
<b>RA42/S-0-0-0-30</b> 74317000	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	16.5–27.0 32.0	KD + 12
<b>RA42/S-0-1-0-0-30</b> 74228000	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	24.5–35.0 32.5	KD + 12
<b>RA42/S-0-2-0-0-22</b> 74190300	<b>R32</b> 48/25 × 22		24.0–34.0 20.5	KD + 12
<b>RA42/S-1-1-0-0-22</b> 74486000	<b>R32</b> 48/25 × 22		30.5–41.0 46.0	KD + 12
<b>RA42/S-1-1-0-0-30</b> 74228000	<b>R32</b> 48/25 × 22	<b>R34</b> 48/26 × 30	30.5–41.0 46.0	KD + 12

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item number	Roll bolt D × L in mm	Item number	Carbide bushings D/d × W in mm	Item number	Needle bearing 2-row pieces / needles + ring D × L in mm	Item number complete
<b>R32</b> = 48/25 × 22	57–3.5 × 21.8	03462071	18 × 59	70754800	25/18 × 21.8	3463104		
<b>R34</b> = 48/26 × 30	51–4.0 × 29.8	03462078	18 × 59	70754800	26/18 × 29.8	3463107	102–4.0 × 13.8 3–25.9/18.1 × 2.2	03462027 73100900 78042900

When installing the R32 rolls in the holders ...-30, the spacer rings 72411400 are required.

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length

## Roll holder table RA45 for axial rolling systems Type RS45 und RR45

Roll holder Designation	Roll Designation	Working range	max. collar Ø on the workpiece	Type of threads						
				Item number	Minor-Ø in mm largest outer Ø	Minor-Ø (KD) + X in mm	Metric thread DIN 13 + Tr	Metric fine thread DIN 13	Whitworth thread DIN EN ISO 228	Whitworth pipe thread DIN EN ISO 228
UNC	UN	UNF								
<b>RA45-1-2.5</b> 74842700	<b>R48</b>	9.5–22	KD + 27	M12–M24	M12 × 1.5–M18 × 1.5 M12 × 1.75–M20 × 1.75 M18 × 2–M24 × 2	G1/4" G3/8" G1/2" G5/8"	R1/4" R3/8" R1/2"	1/2-13 9/16-12 5/8-11 3/4-10 7/8-9 1-8	1/2-16 9/16-16 5/8-12 3/4-12 7/8-12	5/8-18 3/4-16
<b>RA45-2-2.0</b> 74842500	<b>R48</b>	21.5–34	KD + 25	M27–M39	M25 × 2–M33 × 2 M30 × 3–M38 × 3	G3/4" G7/8" G1"	R3/4" R1"	1 1/8-7 1 1/4-7 1 3/8-6 1 1/2-6	1-16 1 1/4-8 1 1/2-8	1-12 1 1/8-12 1 1/4-12 1 3/8-12
<b>RA45-3-2.0</b> 74839900	<b>R48</b>	33.5–46	KD + 21	M42–M45	M38 × 3–M48 × 3 M40 × 4–M48 × 4	G1 1/8" G1 1/4" G1 3/8" G1 1/2"	R1 1/4" R1 1/2"		1 7/8-8	
<b>RA45-3-2.0</b> 74839900	<b>R48/56</b>	38–50	KD + 17		M50 × 3–M54 × 3 50 × 4–M54 × 4				2-8 2 1/8-8	

Rolls = D/d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D/d × W in mm	Item no.
<b>R48</b> = 60/29.2 × 35	69–3.5 × 34.8	03462084	22.2 × 59	74158000	29.2/22.2 × 34.8	03463114
<b>R48/56</b> = 56/29.2 × 35	69–3.5 × 34.8	03462084	22.2 × 59	74158000	29.2/22.2 × 34.8	03463114

### RS45

up to Ø 48 mm no restrictions  
Ø 49-54 mm max. 119 mm incl. thread run out

### RR45

up to Ø 48 mm no restrictions  
Ø 49-54 mm must be checked

D = Major diameter      W = Width of roll  
d = Bore diameter      L = Length

## Roll holder table RA60 for axial rolling systems Typ RS60

Roll holder Designation	Roll Designation	Working range	Type of threads	
Item number		Minor-Ø in mm largest outer Ø	Pipe thread DIN EN ISO 228	Metric fine thread DIN 13
<b>RA60-0-1.5</b> 74265800	<b>R30 / 42</b>	29.4–37.4	G1" G1½"	M32–M38 × 1 M32–M38 × 1.5 M33–M38 × 2 M34–M40 × 3
<b>RA60-1-1.2</b> 74266100	<b>R30 / 42</b>	37.0–45.0	G1¼" G1¾" G1½"	M39–M45 × 1 M40–M46 × 1.5 M39–M46 × 2 M42–M48 × 3
<b>RA60-2-1.0</b> 74414000	<b>R30 / 42</b>	44.0–52.0	G1¾"	M46–M52 × 1 M48–M52 × 1.5 M48–M52 × 2 M50–M55 × 3
<b>RA60-3-0.8</b> 74266300	<b>R30 / 42</b>	51.0–59.0	G2"	M55–M60 × 1 M55–M60 × 1.5 M55–M60 × 2 M56–M60 × 3

Rolls = D / d × W in mm	Pieces, Needles D × L in mm	Item no.	Roll bolt D × L in mm	Item no.	Carbide bushings D / d × W in mm	Item no.
<b>R30 / 42 = 42 / 25 × 22</b>	57–3.5 × 21.8	03462071	18 × 40	74114700	25 / 18 × 21.8	03463104

D = Major diameter  
d = Bore diameter  
W = Width of roll  
L = Length