

LANDIS CNC THREAD ROLLING TOOLS

Create stronger threads faster with better finishes using Landis CNC Thread Rolling Tools. Compact in size, with a small working envelope, they're ideal for large and small lot production on automatics and CNC machines.

Landis CNC Thread Rolling Tools are designed for thread sizes from #0 to 3/8" and material hardness to 24 Rockwell C.

Advantages of Rolled vs. Cut Threads

- **IMPROVED FINISH** – Rolled surface finishes of 32μ in. or less vs. a minimum of 63 for cut threads
- **INCREASED STRENGTH** – Rolled threads are as much as 20% stronger than cut threads
- **FASTER THREADING SPEEDS** – Rolled SFM's are 3-times faster than cutting
- **MATERIAL SAVINGS** – Rolling stock is smaller in diameter than full size cutting stock
- **CHIPLESS OPERATION** – No chip disposal required with thread rolling



Landis CNC Thread Rolling Tools

#1-1/2 CNC THREAD ROLLS AND DIE BODIES FOR #0 THRU #12 THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
#1 - 64 UNC	LOC065380	LOB063645	AA - 4 DEG 25 MIN	0.156
#2 - 56 UNC	LOC063315	LOB063312	B - 4 DEG 25 MIN	0.203
#3 - 48 UNC	LOC063317	LOB063312	B - 4 DEG 25 MIN	0.203
#4 - 40 UNC	LOC059613	LOB059611	C - 4 DEG 45 MIN	0.266
#5 - 40 UNC	LOC063320	LOB059611	C - 4 DEG 45 MIN	0.266
#6 - 32 UNC	LOC059612	LOB059611	C - 4 DEG 45 MIN	0.266
#8 - 32 UNC	LOC063323	LOB059624	D - 4 DEG 45 MIN	0.312
#10 - 24 UNC	LOC063324	LOB059624	D - 4 DEG 45 MIN	0.312
#12 - 24 UNC	LOC063332	LOB059624	D - 4 DEG 45 MIN	0.312
#0 - 80 UNF	LOC063633	LOB063650	A - 4 DEG 35 MIN	0.125
#1 - 72 UNF	LOC063644	LOB063645	AA - 4 DEG 25 MIN	0.156
#2 - 64 UNF	LOC063314	LOB118675	BF - 3 DEG 45 MIN	0.203
#3 - 56 UNF	LOC063316	LOB118675	BF - 3 DEG 45 MIN	0.203
#4 - 48 UNF	LOC063318	LOB118676	CF - 4 DEG	0.266
#5 - 44 UNF	LOC063319	LOB118676	CF - 4 DEG	0.266
#6 - 40 UNF	LOC063321	LOB118676	CF - 4 DEG	0.266
#8 - 36 UNF	LOC063322	LOB109833	DF - 3 DEG 30 MIN	0.312
#10 - 32 UNF	LOC062473	LOB109833	DF - 3 DEG 30 MIN	0.312
#12 - 28 UNF	LOC063348	LOB109833	DF - 3 DEG 30 MIN	0.312

#1-1/2 CNC THREAD ROLLS AND DIE BODIES FOR M1.6 THRU M5 THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
M1.6 x .35	LOC141599	LOB063650	A - 4 DEG 35 MIN	0.125
M1.8 x .35	LOC141600	LOB063645	AA - 4 DEG 25 MIN	0.156
M2 x .4	LOC065218	LOB063312	B - 4 DEG 25 MIN	0.203
M2.2 x .45	LOC141608	LOB063312	B - 4 DEG 25 MIN	0.203
M2.5 x .45	LOC121521	LOB118675	BF - 3 DEG 45 MIN	0.203
M3 x .5	LOC063998	LOB106668	CX - 3 DEG 30 MIN	0.266
M3.5 x .6	LOC065953	LOB106668	CX - 3 DEG 30 MIN	0.266
M4 x .7	LOC064998	LOB106668	CX - 3 DEG 30 MIN	0.266
M4.5 x .75	LOC115099	LOB109833	DF - 3 DEG 30 MIN	0.312
M5 x .8	LOC065200	LOB109833	DF - 3 DEG 30 MIN	0.312

#1-1/2 CNC COMPONENTS FOR #0 THRU #12 & M1.6 THRU M5 THREADS

PART NUMBER	DESCRIPTION
LOB066961	DIE HOLDER with standard hollow shank - .750" OD x 2" Long x .218" ID
LOE069852	THREAD ROLL SHAFT - for #0 thru #3 & M1.6 thru M2.5 threads
LOE059614	THREAD ROLL SHAFT - for #4 thru #12 & M3 thru M5 threads
LOE062986	ADJUSTING SCREW
L17SX#6X12	RETAINING SCREW
LGD000300	1/16" SOCKET SCREW WRENCH

#3 CNC THREAD ROLLS AND DIE BODIES FOR 1/4", 5/16" & 3/8" THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
1/4" - 20 UNC	LOB063326	LOB062984	F - 4 DEG 45 MIN	0.468
5/16" - 18 UNC	LOB063328	LOB062988	G - 3 DEG 45 MIN	0.547
3/8" - 16 UNC	LOB063330	LOB062988	G - 3 DEG 45 MIN	0.547
1/4" - 28 UNF	LOB063325	LOB068825	FF - 3 DEG	0.468
5/16" - 24 UNF	LOB063327	LOB109834	GF - 2 DEG 45 MIN	0.547
3/8" - 24 UNF	LOB063329	LOB109834	GF - 2 DEG 45 MIN	0.547

#3 CNC THREAD ROLLS AND DIE BODIES FOR M6 THRU M10 THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
M6 x 1	LOB064254	LOB129458	FX - 3 DEG 30 MIN	0.468
M7 x 1	LOB064965	LOB068825	FF - 3 DEG	0.468
M8 x 1	LOB059144	LOB109834	GF - 2 DEG 45 MIN	0.547
M8 x 1.25	LOB064966	LOB141511	GX - 3 DEG 15 MIN	0.547
M10 x 1.25	LOB059145	LOB109834	GF - 2 DEG 45 MIN	0.547
M10 x 1.5	LOB064270	LOB141511	GX - 3 DEG 15 MIN	0.547

#3 CNC COMPONENTS FOR 1/4", 5/16", 3/8" & M6 THRU M10 THREADS

PART NUMBER	DESCRIPTION
LOC066960	DIE HOLDER with standard hollow shank - 1" OD x 2.500" Long x .406" ID
LOE062987	THREAD ROLL SHAFT - for all threads
L17SFX#10X25	ADJUSTING & RETAINING SCREWS
LGD000302	3/32" SOCKET SCREW WRENCH

NOTE: Die Bodies Include Roll Shafts.
Die Holders Include Adjusting Screw, Retaining Screws and Wrench.

#5 CNC THREAD ROLLS AND DIE BODIES FOR 5/16" THRU 5/8" THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
5/16" - 18 UNC	LOB118891	LOB141738	H - 3 DEG 20 MIN	0.891
3/8" - 16 UNC	LOB118892	LOB141738	H - 3 DEG 20 MIN	0.891
7/16" - 14 UNC	LOB118893	LOB141738	H - 3 DEG 20 MIN	0.891
1/2" - 13 UNC	LOB118894	LOB141739	I - 2 DEG 45 MIN	0.891
9/16" - 12 UNC	LOB118895	LOB141739	I - 2 DEG 45 MIN	0.891
5/8" - 11 UNC	LOB141745	LOB141739	I - 2 DEG 45 MIN	0.891
5/16" - 24 UNF	LOB118897	LOB141740	HF - 2 DEG 30 MIN	0.891
3/8" - 24 UNF	LOB118898	LOB141740	HF - 2 DEG 30 MIN	0.891
7/16" - 20 UNF	LOB118584	LOB141740	HF - 2 DEG 30 MIN	0.891
1/2" - 20 UNF	LOB118577	LOB141741	IF - 1 DEG 50 MIN	0.891
9/16" - 18 UNF	LOB118899	LOB141741	IF - 1 DEG 50 MIN	0.891
5/8" - 18 UNF	LOB118585	LOB141741	IF - 1 DEG 50 MIN	0.891

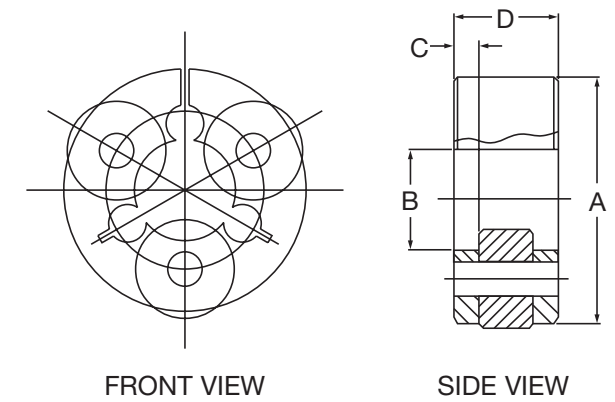
#5 CNC THREAD ROLLS AND DIE BODIES FOR M8 THRU M16 THREADS

THREAD	THREAD ROLL PART NUMBER	DIE BODY PART NUMBER	DIE BODY SIZE	B - DIMENSION (inch)
M8 x 1.25	LOB141605	LOB141738	H - 3 DEG 20 MIN	0.891
M10 x 1.5	LOB120613	LOB141738	H - 3 DEG 20 MIN	0.891
M12 x 1.75	LOB125521	LOB141739	I - 2 DEG 45 MIN	0.891
M14 x 2.0	LOB120614	LOB141739	I - 2 DEG 45 MIN	0.891
M16 x 2.0	LOB139490	LOB141739	I - 2 DEG 45 MIN	0.891

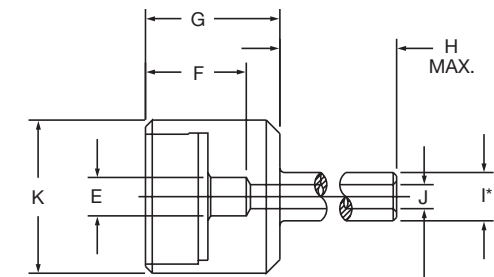
#5 CNC COMPONENTS FOR 5/16" THRU 5/8" & M8 THRU M16 THREADS

PART NUMBER	QUANTITY	DESCRIPTION
LOB141677	1	DIE HOLDER with standard hollow shank - 1" DIA. x 2-1/2" Long x .688" ID
LOD141679	3	THREAD ROLL SHAFT
LOD116819	3	ROLL SHAFT BUSHING - SOLID BRONZE
L104SX37X50	1	SET SCREW - FOR SIZING
L11SX25X50	1	SOCKET HEAD CAP SCREW - FOR SIZING
LFA000665	3	OVAL POINT SET SCREW - FOR RETAINING
LGD000305	1	WRENCH

DIE BODY



DIE HOLDER



#1-1/2 Tooling Dimensions

Dim.	Inches	mm
A	.8115	20.61
B	variable to thread size	
C	.093	2.38
D	.406	10.32
E	.250	6.35
F	.656	16.67
G	.875	22.23
H	2.00	50.8
I*	.750	19.05
J	.218	5.56
K	.997	25.3

*Standard shank diameter; nonstandard available—minimum .250".

#3 Tooling Dimensions

Dim.	Inches	mm
A	1.311	33.3
B	variable to thread size	
C	.125	3.17
D	.562	14.28
E	.531	13.49
F	.937	23.81
G	1.125	28.58
H	2.500	63.5
I*	1.00	25.4
J	.406	10.32
K	1.622	41.2

*Standard shank diameter; nonstandard available—minimum .500".

#5 Tooling Dimensions

Dim.	Inches	mm
A	3.375	85.73
B	0.891	22.62
C	0.188	4.76
D	1.125	28.58
E	0.688	17.46
F	THRU BORE	
G	1.375	34.92
H	2.500	63.50
I*	1.000	25.40
J	0.688	17.46
K	3.875	98.42

*Standard shank diameter; nonstandard available—minimum 1.000".

