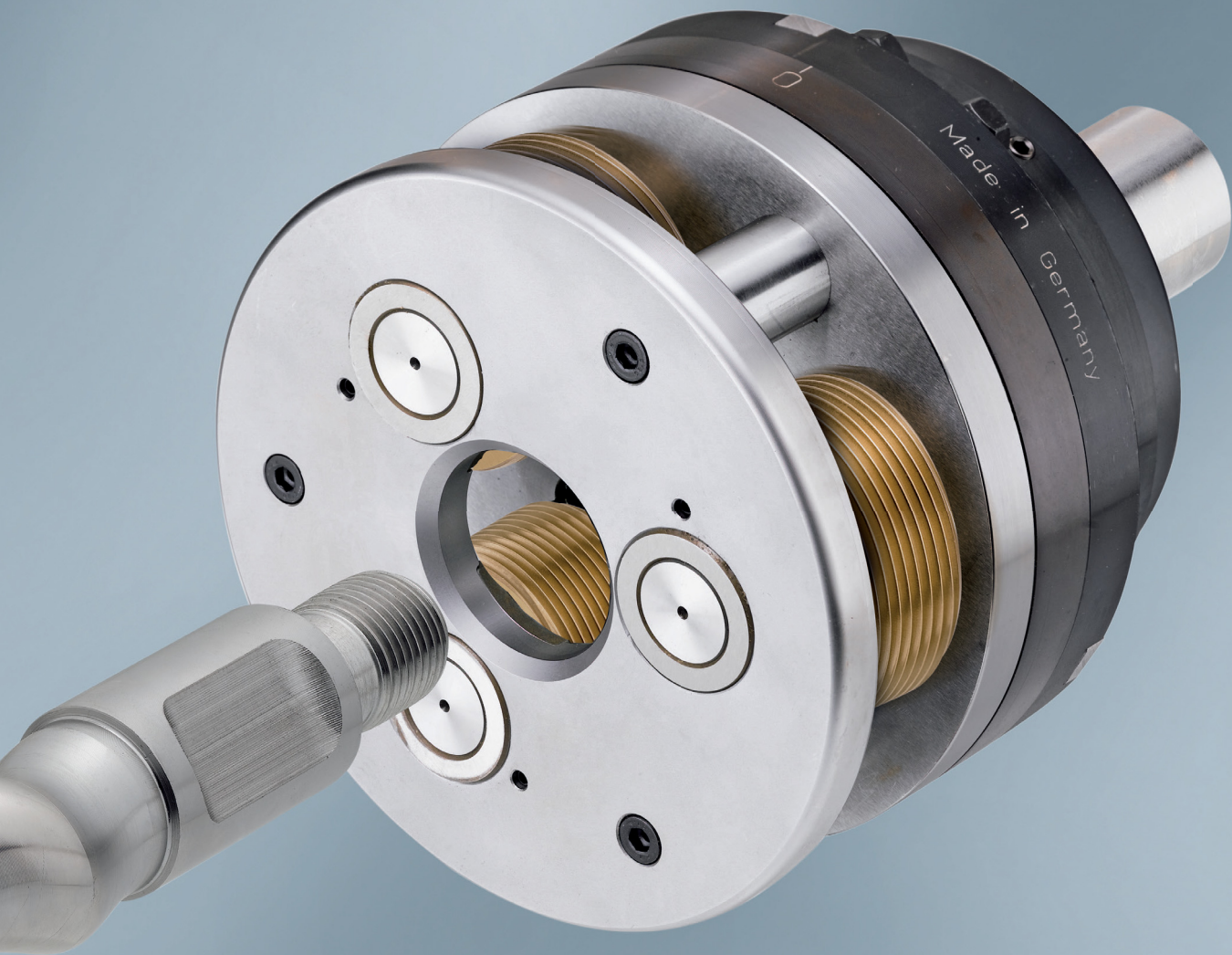


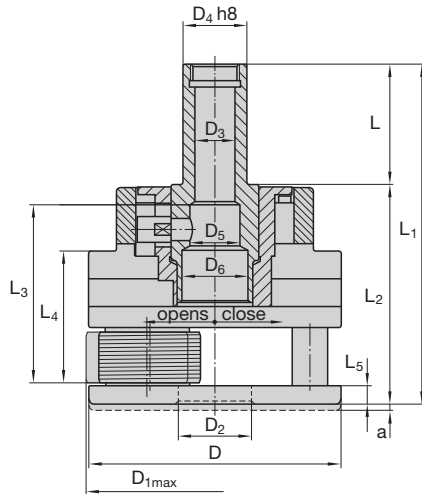
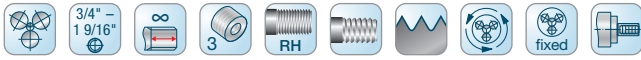


# Thread Rolling on API Thread Rods

For challenging oil & gas  
applications

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**Dimensions in mm | inch**

| Type      | D      | D <sub>1max</sub> <sup>1)</sup> | D <sub>2</sub> | D <sub>3</sub> | D <sub>4</sub> | D <sub>5</sub> | D <sub>6</sub> | L      | L <sub>1</sub> | L <sub>2</sub> | L <sub>3</sub> | L <sub>4</sub> | L <sub>5</sub> | a      | α   | γ      |
|-----------|--------|---------------------------------|----------------|----------------|----------------|----------------|----------------|--------|----------------|----------------|----------------|----------------|----------------|--------|-----|--------|
| F4-API-SR | 165    | 165                             | 52             | 32             | 50,8           | –              | 36             | 79     | 219            | 140            | –              | 77             | 10             | 4      | 30° | 1° 45' |
| 7055578   | 6.496" | 6.496"                          | 2.047"         | 1.260"         | 2.000"         | –              | 1.417"         | 3.110" | 8.622"         | 5.512"         | –              | 3.031"         | 0.394"         | 0.157" |     |        |
| F5-API-SR | 200    | 204                             | 58,5           | 32             | 50,8           | 40             | 53             | 95     | 268,3          | 173,3          | 139,9          | 103,9          | 15             | 5      | 30° | 1° 40' |
| 7068202   | 7.874" | 8.031"                          | 2.303"         | 1.260"         | 2.000"         | 1.575"         | 2.087"         | 3.740" | 10.563"        | 6.823"         | 5.508"         | 4.091"         | 0.591"         | 0.197" |     |        |

F4-API-SR and F5-API-SR used stationary or rotating

a = Pull off for opening

α = Closing angle

γ = Inclined position of rolls

<sup>1)</sup> Largest outside diameter of rolling head when rolls in open position.

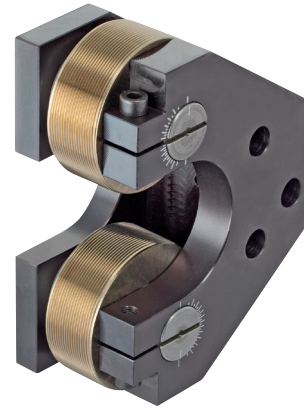
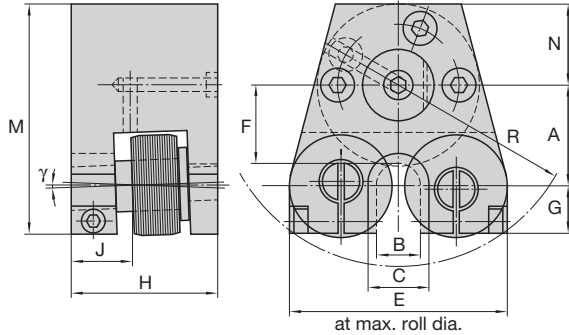
Further dimensions upon request

|  | API                         |                 |              |      |                         |
|-------------------------------------------------------------------------------------|-----------------------------|-----------------|--------------|------|-------------------------|
|                                                                                     | Rod<br>Nominal dia.<br>Zoll | Rod             |              | Lead | Ident No.               |
|                                                                                     |                             | Thread          | Design       |      |                         |
|                                                                                     | 1/2                         | API 3/4 – 10    | Sucker Rod   | 3k   | – <sup>1)</sup>         |
|                                                                                     | 5/8                         | API 15/16 – 10  | Sucker Rod   | 3k   | 7055635 7072643         |
|                                                                                     | 3/4                         | API 1 1/16 – 10 | Polished Rod | 3k   | 7118002 – <sup>1)</sup> |
|                                                                                     |                             |                 | Sucker Rod   | 3k   | 7055636 7072644         |
|                                                                                     | 7/8                         | API 1 3/16 – 10 | Polished Rod | 3k   | – <sup>1)</sup>         |
|                                                                                     |                             |                 | Sucker Rod   | 3k   | 7055637 7072645         |
|                                                                                     | 1                           | API 1 3/8 – 10  | Polished Rod | 3k   | – <sup>1)</sup>         |
|                                                                                     |                             |                 | Sucker Rod   | 3k   | 7055638 7072646         |
|                                                                                     | 1 1/8                       | API 1 9/16 – 10 | Polished Rod | 3k   | – <sup>1)</sup>         |
|                                                                                     |                             |                 | Sucker Rod   | 3k   | – 7072647               |
|                                                                                     |                             |                 |              |      | – 7118010               |

<sup>1)</sup> upon request

**Customer benefits:**

- Chip-less thread-forming process for increased fatigue strength of API-thread rods
- Our premium solutions on rolling heads and respective thread rolls
- High productive rolling process



**Dimensions in mm | inch**

| Type<br>Ident No.           | A            | B            | C            | E             | F              | G            | H            | J            | M             | N            | R               | γ      |
|-----------------------------|--------------|--------------|--------------|---------------|----------------|--------------|--------------|--------------|---------------|--------------|-----------------|--------|
| AC5-API-SR-5/8<br>7410950   | 55<br>2.165" | 53<br>2.087" | 69<br>2.716" | 189<br>7.441" | 28,5<br>1.122" | 33<br>1.299" | 89<br>3.504" | 29<br>1.142" | 128<br>5.039" | 40<br>1.575" | 118<br>4.646"   | 2°     |
| AC5-API-SR-3/4<br>7221791   | 55<br>2.165" | 56<br>2.205" | 72<br>2.835" | 193<br>7.598" | 27<br>1.063"   | 33<br>1.299" | 89<br>3.504" | 29<br>1.142" | 128<br>5.039" | 40<br>1.575" | 119<br>4.685"   | 1° 50' |
| AC5-API-SR-7/8<br>7221792   | 55<br>2.165" | 59<br>2.323" | 75<br>2.953" | 196<br>7.716" | 25,5<br>1.004" | 33<br>1.299" | 89<br>3.504" | 29<br>1.142" | 128<br>5.039" | 40<br>1.575" | 120,5<br>4.744" | 1° 40' |
| AC5-API-SR-1<br>7221793     | 55<br>2.165" | 64<br>2.520" | 80<br>3.150" | 203<br>7.992" | 23<br>0.905"   | 33<br>1.299" | 89<br>3.504" | 29<br>1.142" | 128<br>5.039" | 40<br>1.575" | 122<br>4.803"   | 1° 25' |
| AC5-API-SR-1 1/8<br>7221794 | 55<br>2.165" | 69<br>2.716" | 85<br>3.346" | 205<br>8.071" | 20,5<br>0.807" | 33<br>1.299" | 89<br>3.504" | 29<br>1.142" | 128<br>5.039" | 40<br>1.575" | 124<br>4.881"   | 1° 15' |

AC5 for right-hand threads

γ = Inclined position of rolls



**API**

| Rod<br>Nominal dia.<br>Zoll | Rod             |              | Lead | AC5-Rolls<br>Ident No. |
|-----------------------------|-----------------|--------------|------|------------------------|
|                             | Thread          | Design       |      |                        |
| 5/8                         | API 1 5/16 – 10 | Sucker Rod   | 2K   | 7128698                |
|                             |                 | Polished Rod | 3K   | 7209797                |
| 3/4                         | API 1 1/16 – 10 | Sucker Rod   | 2K   | 7128698                |
|                             |                 | Polished Rod | 3K   | 7209797                |
| 7/8                         | API 1 3/16 – 10 | Sucker Rod   | 2K   | 7128698                |
|                             |                 | Polished Rod | 3K   | 7209797                |
| 1                           | API 1 3/8 – 10  | Sucker Rod   | 2K   | 7128698                |
|                             |                 | Polished Rod | 3K   | 7209797                |
| 1 1/8                       | API 1 9/16 – 10 | Sucker Rod   | 2K   | 7128698                |
|                             |                 | Polished Rod | 3K   | 7209797                |

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