

■ Thread rolling dies list

For Metric Coarse Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M3	0.5	40	15tons	
M3.5	0.6	40	15tons	2 sets
M6	1.0	40	15tons	2 sets
M8	1.25	40	15tons	
M8	1.25	60	15tons	Left-hand thread
M8	1.25	120	15tons	
M8	1.25	60	15tons	
M10	1.5	40	15tons	
M10	1.5	60	15tons	2 sets
M10	1.5	100	15tons	Left-hand thread
M12	1.75	60	15tons	3 sets
M12	1.75	80	15tons	
M14	2.0	60	15tons	
M16	2.0	100	15tons	2sets
M16	2.0	60	15tons	
M18	2.5	60	15tons	
M20	2.5	100	15tons	
M20	2.5	150	15tons	
M24	3.0	100	15tons	
M24	3.0	150	25tons	
M24	3.0	60	15tons	
M27	3.0	100	25tons	
M27	3.0	150	60tons	For through feed
M30	3.5	150	25tons	
M30	3.5	150	25tons	Effective width:125
M30	3.5	150	60tons	For through feed
M33	3.5	100	15tons	
M36	4.0	150	25tons	
M36	4.0	150	60tons	Effective diameter:140
M36	4.0	200	60tons	
M36	4.0	200	100tons	For stinless steel
M42	4.5	100	60tons	For through feed
M42	4.5	150	25tons	
M42	4.5	200	60tons	
M45	4.5	150	60tons	
M48	5.0	150	25tons	
M48	5.0	200	60tons	
M48	5.0	220	100tons	For stinless steel
M52	5.0	150	60tons	
M56	5.5	200	60tons	

■ Thread rolling dies list

For Metric Coarse Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M56	5.5	150	60tons	For through feed
M56	5.5	200	100tons	
M64	6.0	200	60tons	
M64	6.0	200	100tons	

For Metric Fine Pitch Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M4	0.75	105	15tons	
M8	1.0	60	15tons	
M8	1.0	40	15tons	
M8	1.0	80	15tons	
M10	1.0	40	15tons	
M10	1.0	60	15tons	Left-hand thread
M10	1.25	40	15tons	3 sets
M10	1.25	60	15tons	3 sets
M10	1.25	60	15tons	Left-hand thread
M12	1.0	40	15tons	
M12	1.25	40	15tons	2 sets
M12	1.25	50	15tons	2sets
M12	1.25	60	15tons	Left-hand thread
M14	1.5	40	15tons	
M15	1.5	60	15tons	Left-hand thread
M16	1.5	100	15tons	
M18	1.5	60	15tons	
M20	1.5	100	15tons	
M20	1.5	40	15tons	
M20	1.5	60	15tons	3 sets
M24	1.0	200	25tons	Left-hand thread
M24	1.5	150	15tons	
M24	1.5	180	25tons	Left-hand thread
M24	1.5	60	15tons	Effective width:50
M24	1.5	40	15tons	2 sets
M24	2.0	100	15tons	Effective width:90
M24	2.0	80	15tons	Effective width:75
M30	1.5	60	15tons	
M30	2.0	60	15tons	
M30	2.0	150	15tons	
M30	3.0	100	15tons	
M30	3.0	150	60tons	For through feed

■ Thread rolling dies list

For Metric Fine Pitch Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M33	2.0	60	15tons	
M33	3.0	150	60tons	For through feed
M35	1.5	150	25tons	For through feed
M35	1.5	150	25tons	
M36	2.0	100	15tons	
M36	3.0	100	25tons	Taper ratio:3/1000
M36	3.0	150	25tons	Effective width:145 2 sets
M36	3.0	150	60tons	For through feed
M39	3.0	150	60tons	For through feed
M42	2.0	100	25tons	
M42	3.0	100	25tons	
M42	3.0	100	25tons	Taper ratio:3/1000
M42	3.0	100	60tons	
M42	3.0	100	60tons	Taper ratio:3/1000
M48	2.0	150	25tons	
M48	3.0	100	60tons	3 sets
M48	3.0	100	60tons	Taper ratio:3/1000
M48	3.0	150	25tons	Effective width:140
M52	3.0	100	60tons	Effective width:90
M52	3.0	150	60tons	For through feed
M52	3.0	150	100tons	
M56	3.0	150	60tons	
M56	3.0	150	60tons	Taper ratio:3/1000
M60	3.0	200	60tons	
M60	4.0	150	60tons	
M64	3.0	150	60tons	Taper ratio:3/1000
M64	3.0	150	100tons	
M64	3.0	150	100tons	For through feed
M64	3.0	150	60tons	
M64	3.0	150	60tons	
M64	3.0	250	60tons	
M64	4.0	200	100tons	
M68	3.0	150	60tons	
M72	3.0	200	100tons	
M72	6.0	200	100tons	
M76	3.0	150	100tons	Taper ratio:3/1000
M76	4.0	150	100tons	
M80	3.0	150	100tons	Effective width:145
M80	3.0	150	100tons	For through feed
M80	3.0	150	100tons	

■ Thread rolling dies list

For Metric Fine Pitch Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M80	6.0	230	100tons	
M85	4.0	150	100tons	
M90	3.0	150	100tons	2 sets
M90	3.0	150	100tons	Taper ratio:3/1000
M90	6.0	150	100tons	2 sets
M100	3.0	150	100tons	
M100	3.0	150	120tons	For through feed
M100	3.0	165	100tons	
M100	3.0	120	120tons	
M100	3.0	120	120tons	
M100	3.0	220	120tons	For through feed
M100	6.0	200	100tons	Effective width:180
M110	3.0	150	100tons	For through feed
M110	3.0	200	100tons	2 sets
M110	6.0	200	100tons	2 sets
M120	6.0	150	120tons	
M120	6.0	200	100tons	3 sets
M125	4.0	150	100tons	For through feed 2 sets
M125	4.0	200	100tons	
M125	6.0	150	100tons	
M125	6.0	200	100tons	

For ORT Thread Rolling Machines

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M100	3.0	120	120tons	
M100	3.0	150	120tons	
M100	3.0	220	120tons	For through feed
M110	6.0	220	120tons	
M110	3.0	80	120tons	Leadless; 2 sets
M120	6.0	150	120tons	
M120	6.0	220	120tons	2組
M125	4.0	130	120tons	Leadless
M140	6.0	220	120tons	
2" UN	16山	150	120tons	
2" 3/16 UNJS	16山	120	120tons	
2" 3/4 UN	16山	200	120tons	
M72~M185	6.0	145	120tons	Leadless

■ Thread rolling dies list

For Other Metric Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
M5	0.9	40	15tons	2 sets
M5	0.9	60	15tons	

For Unified Coarse Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
3/8 UNC	16	60	15tons	
7/16 UNC	14	60	15tons	
5/8 UNC	11	60	15tons	
1" 1/4 UNC	7	20	15tons	
1" 3/8 UNC	6	150	60tons	
1" 1/2 UNC	6	150	60tons	
1" 3/4 UNC	5	150	60tons	
1" 3/4 UNC	8	150	60tons	Taper ratio:3/1000
3" 1/2 UNC	8	275	100tons	

For Unified Fine Pitch Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
1/4 UNF	28	40	15tons	2 sets
5/16 UNF	24	40	15tons	
5/16 UNF	24	60	15tons	
3/8 UNF	24	40	15tons	3 sets
7/16 UNF	20	40	15tons	
7/16 UNF	20	60	15tons	
1/2 UNF	20	60	15tons	2 sets

For Unified Thread Screws (Constant Pitch)

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
1" 5/8 UN	8	150	25tons	Taper ratio:3/1000
2" UN	8	150	60tons	For through feed 2 sets
2" 1/2 UN	8	150	60tons	
2" 1/2 UN	8	150	100tons	
3" 3/4 UN	8	150	100tons	
3" UN	8	250	100tons	
4" UN	8	220	120tons	
4" 1/2 UN	8	150	120tons	

■ Thread rolling dies list

For Unified Thread Screws (Others)

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
3"1/4UNS	8	150	100tons	

For Witworth Thread Screws

Nominal diameter	Pitch	Die width	Applicable machine	Remarks
W 3/8	16	40	15tons	
W 2	8	100	25tons	
W 1 5/8	8	100	25tons	Taper ratio:3/1000