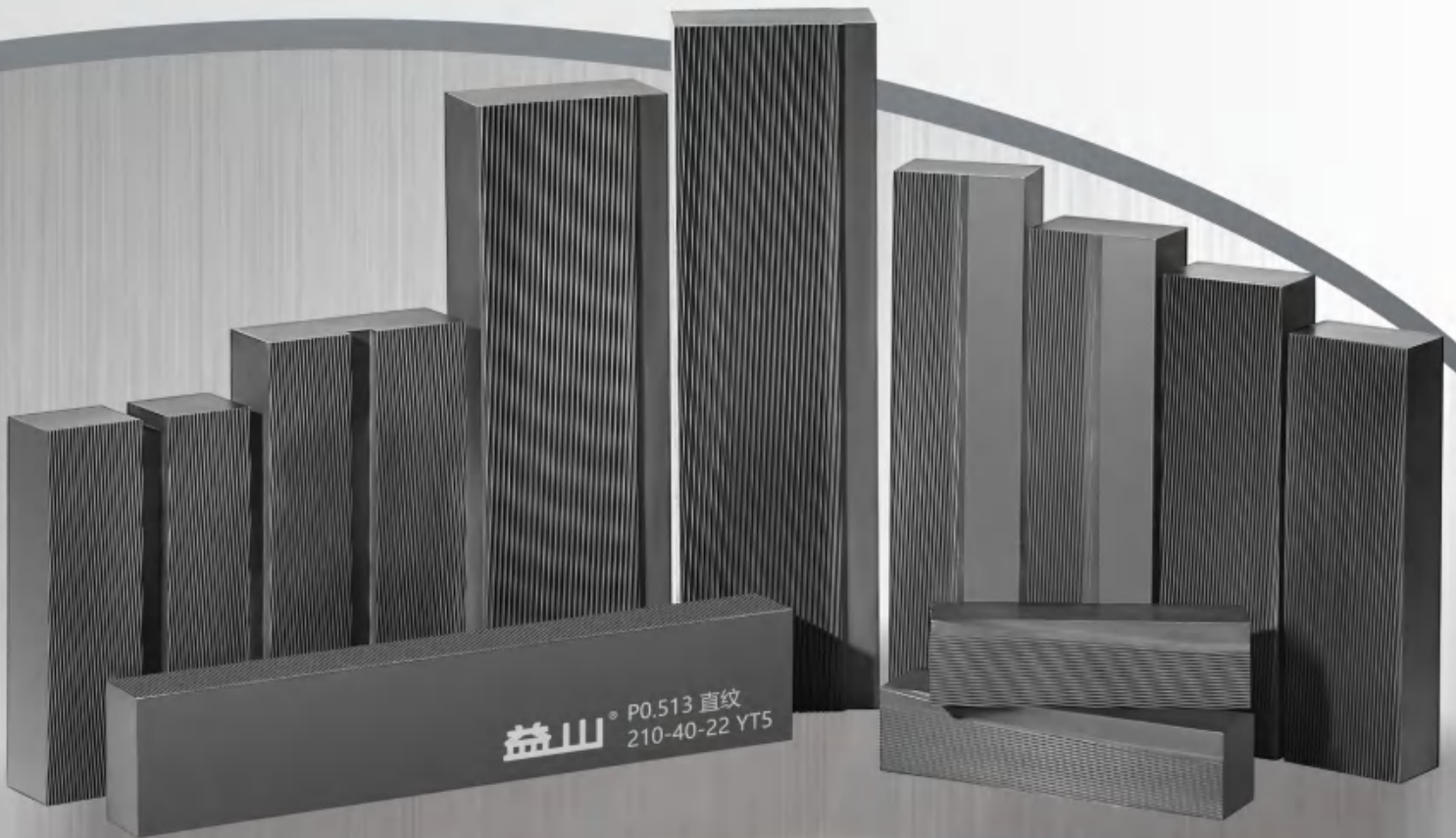


益山[®]
DURATUFF[®]

世界一流的搓丝板

The World-class Thread Rolling Dies



MAThread
The World's Best Fastener



DURATUFF®

公司简介 Company Profile

宁波益山五金有限公司是行业内领先的搓丝板制造厂商，在2012年通过了ISO9001认证。

在过去的16年里，我司凭借技术和能力为客户开发了数百种专用的搓丝板，给客户创造了不可估量的价值。我们很自豪成为了搓丝板制造行业的标杆企业。益山搓丝板整条生产线各个生产加工步骤均在宁波生产车间完成，流程工艺包括锯料、粗铣、精铣、平面磨、热处理、精磨、螺纹磨、倒角、喷砂、表面处理等。

益山搓丝板持续前进的动力来源于客户长期的信赖和认可，专业针对热处理后搓丝是益山搓丝板的优势和特色。

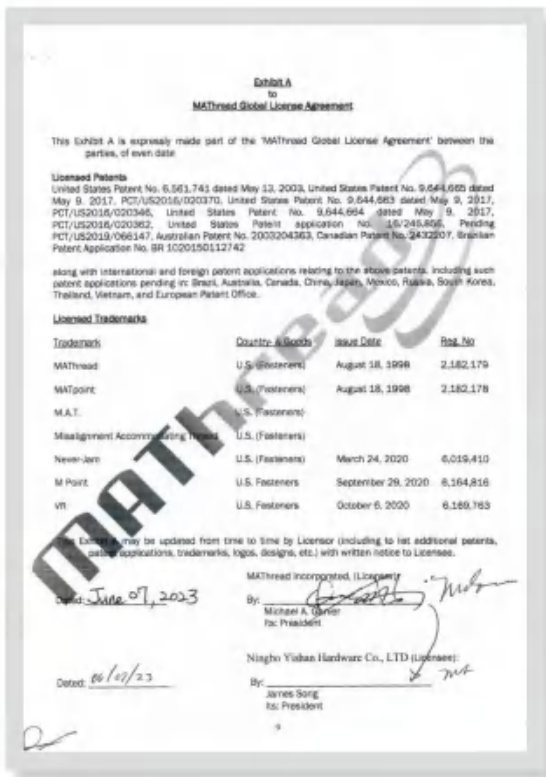
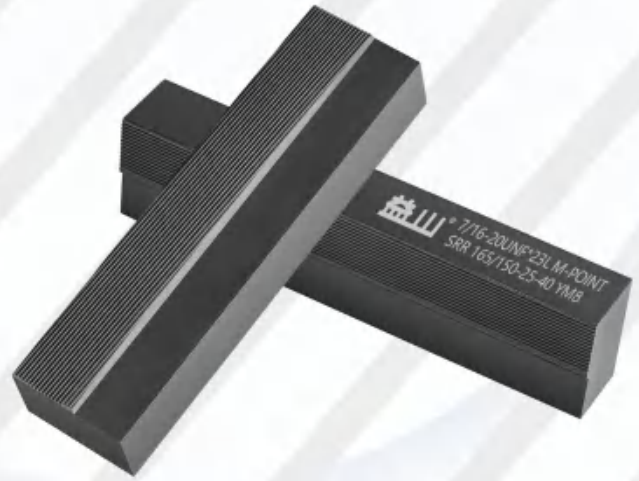
Ningbo Yishan is the industry-leading flat thread roll dies factory. We are ISO certified roll dies factory.

We have the technical capabilities to developed hundreds special thread profile roll dies for our valued customers past 16 years. We take pride in being the leading flat thread roll dies industry. Ningbo Yishan roll dies are made in our own factory in house at Ningbo China, material cutting, precision milling, Grinding, heat treatments, precision grinding, thread grinding and surface treatments.

One of the most unique aspects about Ningbo Yishan is customers trust Ningbo Yishan roll dies to be the after heat treatment screw roll dies expert factory.



01 | DURATUFF®



美国专利 MAThread 授权益山公司



益山公司 ISO9001 证书

DURATUFF®

生产车间 Workshop



检验设备 Inspection Equipment



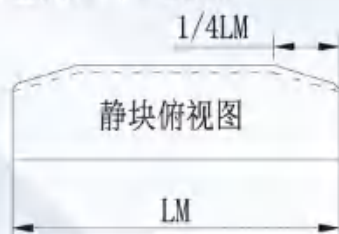
搓丝板常用规格尺寸

Popular Specification and Size of Flat Thread Rolling Dies

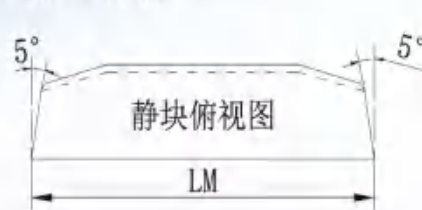
国产机型	动块(Lm)	静块(Ls)	厚度(D)	高度(F)	规格
201	55	45	20	20/25/40	M2/M3/M4
202	65	55	20	25/40/50	M2/M3/M4
203	80	70	24	40/50/55	M2/M3/M4/M5
204	100	85	25	40/50/55/60/65	M4/M5/M6
205	115	100	25	40/50/55/60/65	M4/M5/M6
302	125	110	25	40/50/55/60/65/80	M5/M6/M8
206	145	125	30	40/50/55/60/65/80	M6/M8/M10
207	170	150	30	40/50/55/60/65/80/105/130	M8/M10/M12
208	210	190	40	40/50/55/60/65/80/105/130	M8/M10/M12/M14
209	250	230	45	40/50/55/60/65/80/105/130	M10/M12/M14/M16
210	250	230	50	40/50/55/60/65/80/105/130	M10/M12/M14/M16
213	310	285	50	40/50/55/60/65/80/105/130	M12/M14/M16/M18
234	145	125	40	40/50/55/60/65/80/105/130	M6/M8/M10
236	170	150	40	40/50/55/60/65/80/105/130	M8/M10/M12

台湾机型	动块(Lm)	静块(Ls)	厚度(D)	高度(F)	规格
003	55	45	15	20/25/40	M2/M3/M4
0#	64	51	19	25/40/50/55	M2/M3/M4
4R	70	60	20	25/40/50/55	M2/M3/M4/M5
5R	75	65	20	25/40/50/55	M2/M3/M4/M5
004	80	65	20	25/40/50/55	M3/M4/M5/M6
3/16	89	76	25	25/40/50/55/60/65/80	M4/M5/M6
6R	105	90	25	25/40/50/55/60/65/80	M4/M5/M6
1/4	115	100	25	25/40/50/55/60/65/80/105	M4/M5/M6
8R	127	108	25	25/40/50/55/60/65/80/105/130	M5/M6/M8
5/16	140	127	25	40/50/55/60/65/80/105/130	M6/M8/M10
3/8	165	150	25	40/50/55/60/65/80/105/130	M8/M10/M12
1/2	215	190	35	40/50/55/60/65/80/105/130	M8/M10/M12
3/4	265	230	38	40/50/55/60/65/80/105/130	M10/M12/M14/M16
	230	200	38	40/50/55/60/65/80/105/130	M10/M12/M14
	200	180	35	40/50/55/60/65/80/105/130	M8/M10/M12

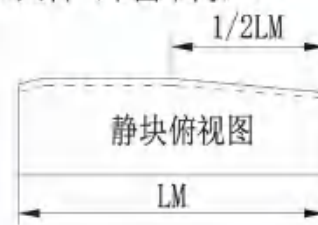
1/4出入料（单面）：



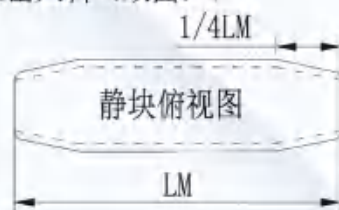
单斜5°（单面）：



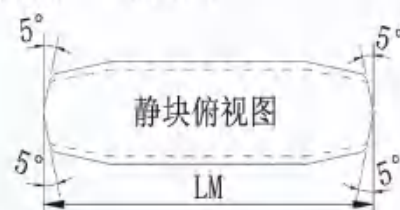
1/2入料（单面单向）：



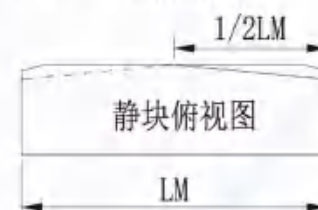
1/4出入料（双面）：



双斜5°（双面）：



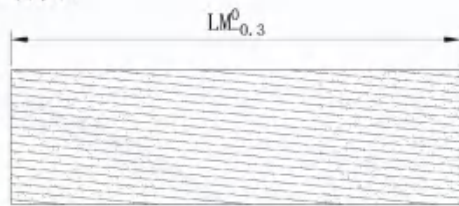
1/2入料（单面双向）：



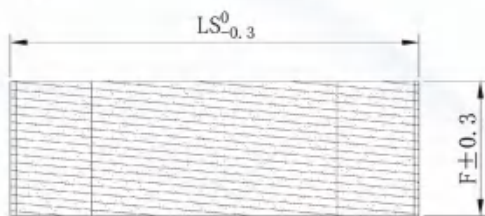
搓丝板标准工程图

Standard Drawing of Thread Rolling Dies

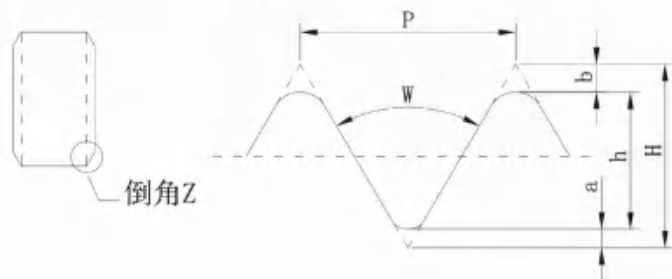
动块:



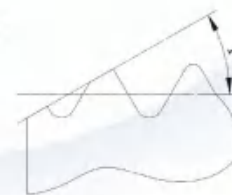
静块:



牙纹图:



倒角Z:



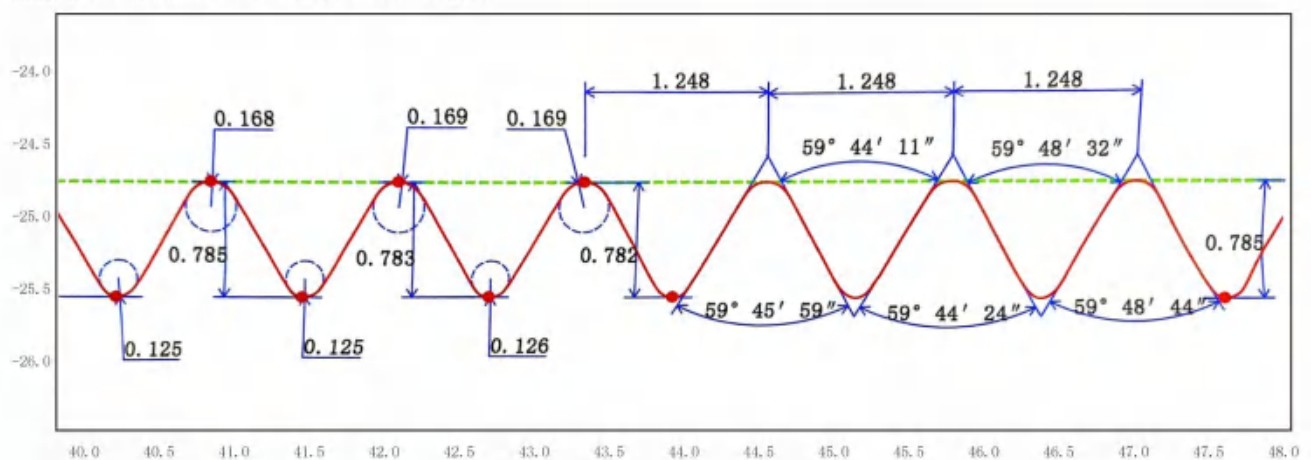
标注

W	60度	h	0.6143P
H	0.866P	b	H/6
Y	30度	a	H/8

宁波益山五金有限公司表面轮廓测量报告

Surface Profile of Thread Rolling Dies

测量图形 X倍率: x30.763 Z倍率: x32.974<轮廓>



机械牙螺丝螺纹规格参数表

Machine Screw Thread Forming data

公制粗牙 M/C Machine Screw 6g (60°) (mm)									
规格 Spec	螺距 Pitch	外径 Major Dia			中径 Pitch Dia			材料径 Blank Dia	
		基准 Basic	最大 Max	最小 Min	基准 Basic	最大 Max	最小 Min	最大 Max	最小 Min
M2	0.4	2	1.981	1.886	1.740	1.721	1.654	1.701	1.668
M2.3	0.4	2.3	2.281	2.186	2.040	2.021	1.954	2.000	1.966
M2.5	0.45	2.5	2.480	2.380	2.208	2.188	2.117	2.167	2.131
M2.6	0.45	2.6	2.580	2.480	2.308	2.288	2.217	2.266	2.231
M3	0.5	3	2.980	2.874	2.675	2.655	2.580	2.633	2.595
M3.5	0.6	3.5	3.479	3.354	3.110	3.089	3.004	3.065	3.022
M4	0.7	4	3.978	3.838	3.545	3.523	3.433	3.500	3.455
M4.5	0.75	4.5	4.478	4.338	4.013	3.991	3.901	3.969	3.924
M5	0.8	5	4.976	4.826	4.480	4.456	4.361	4.432	4.385
M6	1	6	5.974	5.794	5.351	5.324	5.212	5.298	5.242
M7	1	7	6.974	6.794	6.351	6.324	6.212	6.295	6.239
M8	1.25	8	7.972	7.760	7.188	7.160	7.042	7.137	7.078
M9	1.25	9	8.972	8.760	8.188	8.160	8.042	8.135	8.076
M10	1.5	10	9.968	9.732	9.026	8.994	8.862	8.970	8.904
M11	1.5	11	10.968	10.732	10.026	9.994	9.862	9.968	9.902
M12	1.75	12	11.966	11.701	10.863	10.829	10.679	10.803	10.728
M14	2	14	13.962	13.682	12.701	12.663	12.503	12.638	12.558
M16	2	16	15.962	15.682	14.701	14.663	14.503	14.634	14.554
M18	2.5	18	17.958	17.623	16.376	16.334	16.164	16.316	16.231
M20	2.5	20	19.958	19.623	18.376	18.334	18.164	18.313	18.228
M22	2.5	22	21.958	21.623	20.376	20.334	20.164	20.309	20.224
M24	3	24	23.952	23.577	22.052	22.003	21.803	21.979	21.879
M27	3	27	26.952	26.577	25.052	25.003	24.803	24.975	24.875

美制粗牙 UNC Machine Screw 2A (60°) (mm)									
规格 Spec	牙数 TPI	外径 Major Dia			中径 Pitch Dia			材料径 Blank Dia	
		基准 Basic	最大 Max	最小 Min	基准 Basic	最大 Max	最小 Min	最大 Max	最小 Min
1	64	1.854	1.839	1.742	1.598	1.582	1.532	1.571	1.546
2	56	2.184	2.169	2.065	1.890	1.875	1.821	1.864	1.837
3	48	2.515	2.497	2.383	2.172	2.154	2.096	2.144	2.114
4	40	2.845	2.824	2.695	2.433	2.413	2.350	2.405	2.373
5	40	3.175	3.155	3.025	2.764	2.743	2.677	2.732	2.699
6	32	3.505	3.485	3.332	2.990	2.969	2.898	2.964	2.928
8	32	4.166	4.143	3.990	3.650	3.627	3.553	3.617	3.580
10	24	4.826	4.801	4.618	4.138	4.112	4.028	4.109	4.067
12	24	5.486	5.461	5.278	4.798	4.773	4.686	4.765	4.722
1/4	20	6.350	6.322	6.116	5.525	5.497	5.403	5.493	5.446
5/16	18	7.938	7.907	7.686	7.021	6.990	6.888	6.984	6.933
3/8	16	9.525	9.492	9.253	8.494	8.461	8.349	8.453	8.397
7/16	14	11.113	11.077	10.815	9.934	9.898	9.779	9.893	9.833
1/2	13	12.700	12.662	12.385	11.430	11.392	11.265	11.385	11.321
9/16	12	14.288	14.247	13.957	12.913	12.873	12.741	12.866	12.800
5/8	11	15.875	15.834	15.527	14.376	14.336	14.196	14.330	14.260
3/4	10	19.050	19.004	18.677	17.399	17.353	17.203	17.345	17.270
7/8	9	22.225	22.177	21.824	20.391	20.343	20.183	20.335	20.255

机械牙螺丝螺纹规格参数表

Machine Screw Thread Forming data

公制细牙 M/F Machine Screw 6g (60°) (mm)									
规格 Spec	螺距 Pitch	外径 Major Dia			中径 Pitch Dia			材料径 Blank Dia	
		基准 Basic	最大 Max	最小 Min	基准 Basic	最大 Max	最小 Min	最大 Max	最小 Min
M4	0.5	4	3.980	3.874	3.675	3.655	3.580	3.630	3.593
M4.5	0.5	5	4.480	4.374	4.175	4.155	4.080	4.129	4.092
M5	0.5	5	4.980	4.874	4.675	4.655	4.580	4.629	4.591
M6	0.75	6	5.978	5.838	5.513	5.491	5.391	5.460	5.410
M7	0.75	7	6.978	6.838	6.513	6.491	6.391	6.459	6.409
M8	1	8	7.974	7.794	7.351	7.324	7.212	7.293	7.237
M9	1	9	8.974	8.794	8.351	8.324	8.212	8.292	8.236
M10	1.25	10	9.972	9.760	9.188	9.160	9.042	9.133	9.074
M10	1	10	9.974	9.794	9.351	9.324	9.212	9.291	9.235
M12	1.25	12	11.972	11.760	11.188	11.160	11.028	11.123	11.057
M12	1.5	12	11.968	11.732	11.026	10.994	10.854	10.962	10.892
M14	1.25	14	13.972	13.760	13.188	13.160	13.028	13.121	13.055
M14	1.5	14	13.968	13.732	13.026	12.994	12.854	12.959	12.889
M16	1.5	16	15.968	15.732	15.026	14.994	14.854	14.957	14.887
M18	2	18	17.962	17.682	16.701	16.663	16.503	16.631	16.551
M18	1.5	18	17.968	17.732	17.026	16.994	16.854	16.955	16.885
M20	2	20	19.962	19.682	18.701	18.663	18.503	18.628	18.548
M20	1.5	20	19.968	19.732	19.026	18.994	18.854	18.954	18.884
M22	1.5	22	21.968	21.732	21.026	20.994	20.854	20.953	20.883
M24	1.5	24	23.968	23.732	23.026	22.994	22.844	22.947	22.872
M26	1.5	26	25.968	25.732	25.026	24.994	24.844	24.946	24.871
M27	1.5	27	26.968	26.732	26.026	25.994	25.844	25.946	25.871
M28	1.5	28	27.968	27.732	27.026	26.994	26.844	26.946	26.871

美制细牙 UNF Machine Screw 2A (60°) (mm)									
规格 Spec	牙数 TPI	外径 Major Dia			中径 Pitch Dia			材料径 Blank Dia	
		基准 Basic	最大 Max	最小 Min	基准 Basic	最大 Max	最小 Min	最大 Max	最小 Min
2	64	2.184	2.169	2.073	1.928	1.913	1.862	1.900	1.875
3	56	2.515	2.497	2.393	2.220	2.202	2.146	2.189	2.161
4	48	2.845	2.827	2.713	2.502	2.484	2.423	2.471	2.440
5	44	3.175	3.157	3.035	2.799	2.781	2.718	2.768	2.736
6	40	3.505	3.485	3.355	3.094	3.073	3.007	3.061	3.028
8	36	4.166	4.145	4.006	3.708	3.688	3.617	3.674	3.639
10	32	4.826	4.803	4.651	4.310	4.288	4.211	4.273	4.235
12	28	5.486	5.461	5.296	4.897	4.872	4.790	4.858	4.818
1/4	28	6.350	6.325	6.160	5.761	5.735	5.652	5.718	5.676
5/16	24	7.938	7.910	7.727	7.249	7.221	7.127	7.202	7.155
3/8	24	9.525	9.497	9.314	8.837	8.809	8.712	8.786	8.737
7/16	20	11.100	11.067	10.861	10.287	10.254	10.147	10.231	10.178
1/2	20	12.700	12.667	12.461	11.875	11.841	11.732	11.816	11.761
9/16	18	14.288	14.252	14.031	13.371	13.335	13.221	13.310	13.252
5/8	18	15.875	15.839	15.618	14.958	14.923	14.803	14.893	14.833
3/4	16	19.050	19.012	18.773	18.019	17.981	17.854	17.950	17.887
7/8	14	22.225	22.184	21.923	21.046	21.006	20.869	20.975	20.906
1	12	25.400	25.354	25.065	24.026	23.980	23.830	23.949	23.874

航空螺丝螺纹成型规格表

J Profile Thread Forming Data

航空公制粗牙 MJ Coarse 6g (mm)							
规格 Spec	螺距 Pitch	外径 Major Dia		中径 Pitch Dia		小径 Minor Dia	
		最大 Max	最小 Min	最大 Max	最小 Min	最大 Max	最小 Min
MJ1.6	0.35	1.581	1.496	1.354	1.291	1.177	1.093
MJ2	0.4	1.981	1.886	1.721	1.654	1.519	1.428
MJ2.5	0.45	2.480	2.380	2.188	2.117	1.960	1.862
MJ3	0.5	2.980	2.874	2.655	2.580	2.403	2.297
MJ3.5	0.6	3.479	3.354	3.089	3.004	2.786	2.665
MJ4	0.7	3.978	3.838	3.523	3.433	3.170	3.037
MJ5	0.8	4.976	4.826	4.456	4.361	4.052	3.909
MJ6	1	5.974	5.794	5.324	5.212	4.819	4.647
MJ8	1.25	7.972	7.760	7.160	7.042	6.529	6.335
MJ10	1.5	9.968	9.732	8.994	8.862	8.236	8.013
MJ12	1.75	11.966	11.701	10.829	10.679	9.945	9.689
MJ14	2	13.962	13.682	12.663	12.503	11.653	11.371
MJ15	1	14.974	14.794	14.324	14.206	13.819	13.641
MJ16	2	15.962	15.682	14.663	14.503	13.653	13.371
MJ17	1	16.974	16.794	16.324	16.206	15.819	15.641
MJ18	1.5	17.968	17.732	16.994	16.854	16.236	16.005
MJ20	2.5	19.958	19.623	18.334	18.164	17.071	16.750
MJ22	2.5	21.958	21.623	20.334	20.164	19.071	18.750
MJ24	3	23.952	23.577	22.003	21.803	20.488	20.106

航空美制粗牙 UNJC - 2A (inch)							
规格 Spec	牙数 TPI	外径 Major Dia		中径 Pitch Dia		小径 Minor Dia	
		最大 Max	最小 Min	最大 Max	最小 Min	最大 Max	最小 Min
0.0730	64	0.0724	0.0686	0.0623	0.0603	0.0544	0.0515
0.0860	56	0.0854	0.0813	0.0738	0.0717	0.0648	0.0616
0.0990	48	0.0983	0.0938	0.0848	0.0825	0.0743	0.0707
0.1120	40	0.1112	0.1061	0.0950	0.0925	0.0824	0.0784
0.1250	40	0.1242	0.1191	0.1080	0.1054	0.0954	0.0913
0.1380	32	0.1372	0.1312	0.1169	0.1141	0.1011	0.0964
0.1640	32	0.1631	0.1571	0.1428	0.1399	0.1270	0.1222
0.1900	24	0.1890	0.1818	0.1619	0.1586	0.1409	0.1350
0.2160	24	0.2150	0.2078	0.1879	0.1845	0.1669	0.1609
0.2500	20	0.2489	0.2408	0.2164	0.2127	0.1911	0.1844
0.3125	18	0.3113	0.3026	0.2752	0.2712	0.2471	0.2398
0.3750	16	0.3737	0.3643	0.3331	0.3287	0.3015	0.2933
0.4375	14	0.4361	0.4258	0.3897	0.3850	0.3536	0.3446
0.5000	13	0.4985	0.4876	0.4485	0.4435	0.4096	0.4000
0.5626	12	0.5609	0.5495	0.5068	0.5016	0.4647	0.4545
0.6250	11	0.6233	0.6112	0.5643	0.5588	0.5184	0.5074
0.7500	10	0.7482	0.7353	0.6832	0.6773	0.6324	0.6207
0.8750	9	0.8735	0.8641	0.8329	0.8280	0.8013	0.7926
1.0000	8	0.9980	0.9830	0.9168	0.9100	0.8537	0.8393

航空螺丝螺纹成型规格表

J Profile Thread Forming Data

航空公制细牙 MJ Fine 6g (mm)							
规格 Spec	螺距 Pitch	外径 Major Dia		中径 Pitch Dia		小径 Minor Dia	
		最大 Max	最小 Min	最大 Max	最小 Min	最大 Max	最小 Min
MJ8	1	7.974	7.794	7.324	7.212	6.819	6.647
MJ10	1.25	9.972	9.760	9.160	9.042	8.529	8.335
MJ10	1	9.974	9.794	9.324	9.212	8.819	8.647
MJ10	0.75	9.978	9.838	9.491	9.391	9.112	8.967
MJ12	1.5	11.968	11.732	10.994	10.854	10.236	10.005
MJ12	1.25	11.972	11.760	11.160	11.028	10.529	10.321
MJ12	1	11.974	11.794	11.324	11.206	10.819	10.641
MJ14	1.5	13.968	13.732	12.994	12.854	12.236	12.005
MJ16	1.5	15.968	15.732	14.994	14.854	14.236	14.005
MJ20	1.5	19.968	19.732	18.994	18.854	18.236	18.005
MJ20	1	19.974	19.794	19.324	19.206	18.819	18.641
MJ22	1.5	21.968	21.732	20.994	20.854	20.236	20.005
MJ24	2	23.962	23.682	22.663	22.493	21.653	21.361
MJ30	2	29.962	29.682	28.663	28.493	27.653	27.361
MJ30	1.5	29.968	29.732	28.994	28.844	28.236	27.995

航空美制细牙 UNJF -2A (inch)							
规格 Spec	牙数 TPI	外径 Major Dia		中径 Pitch Dia		小径 Minor Dia	
		最大 Max	最小 Min	最大 Max	最小 Min	最大 Max	最小 Min
0.0600	80	0.0595	0.0563	0.0514	0.0496	0.0451	0.0425
0.0730	72	0.0724	0.0689	0.0634	0.0615	0.0564	0.0536
0.0860	64	0.0854	0.0816	0.0753	0.0733	0.0674	0.0645
0.0990	56	0.0983	0.0942	0.0867	0.0845	0.0777	0.0744
0.1120	48	0.1113	0.1068	0.0978	0.0954	0.0873	0.0836
0.1250	44	0.1243	0.1195	0.1095	0.1070	0.0980	0.0941
0.1380	40	0.1372	0.1321	0.1210	0.1184	0.1084	0.1043
0.1640	36	0.1632	0.1577	0.1452	0.1424	0.1312	0.1267
0.1900	32	0.1891	0.1831	0.1688	0.1658	0.1530	0.1481
0.2160	28	0.2150	0.2085	0.1918	0.1886	0.1738	0.1684
0.2500	28	0.2490	0.2425	0.2258	0.2225	0.2078	0.2023
0.3125	24	0.3114	0.3042	0.2843	0.2806	0.2632	0.2570
0.3750	24	0.3739	0.3667	0.3468	0.3430	0.3258	0.3194
0.4375	20	0.4362	0.4281	0.4037	0.3995	0.3784	0.3712
0.5000	20	0.4987	0.4906	0.4662	0.4619	0.4409	0.4336
0.5625	18	0.5611	0.5524	0.5250	0.5205	0.4969	0.4891
0.6250	18	0.6236	0.6149	0.5875	0.5828	0.5594	0.5514
0.7500	16	0.7485	0.7391	0.7079	0.7029	0.6763	0.6675
0.8750	14	0.8734	0.8631	0.8270	0.8216	0.7909	0.7812
1.0000	12	0.9982	0.9868	0.9441	0.9382	0.9020	0.8910



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