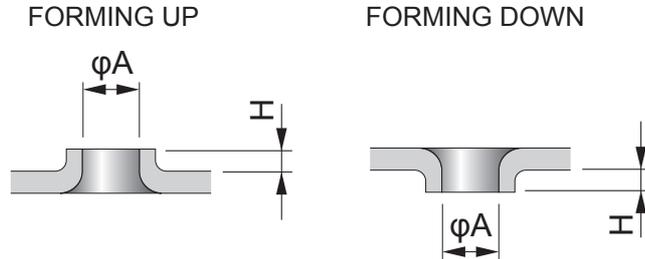


OUTLINE OF FORMING



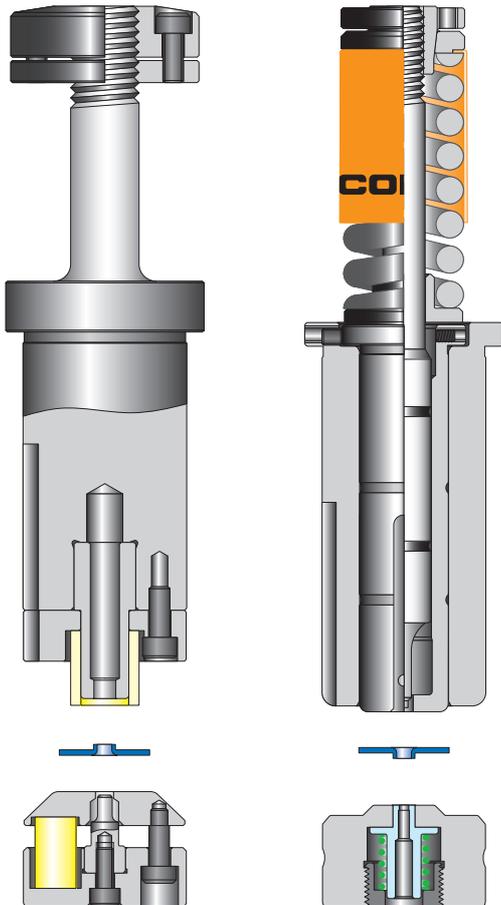
Forming process for making tubes of threading for screw.
 Threading for screws and increased bearing area for tubes.

NOTE

TOOLING STRUCTURE (NC 1-1/4)

FORMING UP
 (Forming after pre-piercing)

FORMING DOWN
 (Pre-piercing and forming)



- 1) Height(H) is almost same as material thickness.
- 2) There are two types of tooling.
 - One is forming together with pre-piercing at the same time.
 - And the other is forming after pre-piercing.
- 3) Please indicate the screw size or diameter (A), when you order.
 Our standard size is shown in the table below.

Screw size	Diameter(A)	Pre-hole	Material thickness					
			0.8	1.0	1.2	1.6	2.0	2.3
M2.5	φ2.1	φ1.2	○	○	○	○	△	△
M3	φ2.6	φ1.5	○	○	○	○	△	△
M4	φ3.4	φ2.0	△	○	○	○	○	○
M5	φ4.3	φ2.4	△	○	○	○	○	○
M6	φ5.1	φ2.8	△	△	○	○	○	○

- 4) Upward pin of the standard dimensions has "TiN coating process" for better durability.

For More information,
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