

18. Bar diameter of external threads (for thread rolling dies)

○NRS-D recommendation for bar diameter for metric external threads

Unit : mm

size	recommended bar diameter	
	Max.	Min.
M3×0.5	2.64	2.62
M4×0.7	3.54	3.52
M5×0.8	4.40	4.38
M6×1	5.30	5.28
M8×1.25	7.10	7.07

○RS-D recommendation for bar diameter for metric external threads

Unit : mm

size	recommended bar diameter	
	Max.	Min.
M1×0.25	0.808	0.785
M1.1×0.25	0.918	0.891
M1.2×0.25	1.007	0.984
M1.4×0.3	1.168	1.142
M1.6×0.35	1.332	1.300
M1.7×0.35	1.432	1.401
M1.8×0.35	1.530	1.498
M2×0.4	1.699	1.669
M2×0.25	1.796	1.771
M2.2×0.45	1.863	1.827

size	recommended bar diameter	
	Max.	Min.
M2.3×0.4	1.998	1.968
M2.3×0.25	2.096	2.071
M2.5×0.45	2.162	2.126
M2.5×0.35	2.228	2.196
M2.6×0.45	2.262	2.226
M2.6×0.35	2.318	2.278
M3×0.5	2.627	2.589
M3×0.35	2.718	2.677
M4×0.5	3.607	3.561
M5×0.5	4.606	4.560

○MS-RS-D recommendation for bar diameter for miniature external threads

Unit : mm

size	recommended bar diameter	
	Max.	Min.
S0.5×0.125	0.410	0.396
S0.6×0.15	0.494	0.479
S0.7×0.175	0.575	0.559
S0.8×0.2	0.658	0.640
S0.9×0.225	0.741	0.720