



XIAMEN CHANGCHUN

<http://www.xmchangchun.com>



Xiamen Changchun Import & Export CO., Ltd.
<http://www.xmchangchun.com>



The background of the slide is a dense, repeating pattern of various types of screws and bolts, rendered in a light gray color. The screws are scattered across the entire page, creating a textured, industrial aesthetic.

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Company Introduction

Xiamen Changchun Import & Export Co., Ltd, is located in guankou Town, Jimei District, Xiamen City, which is one of the world's leading fastener production and export bases in China. Our company specializes in producing all kinds of high-strength fasteners, with monthly production capacity of 1, 000 tons, with annual sales of more than 80 million yuan.

We mainly provide construction fasteners which includes high quality bolt, nut, screw and non-standard fastener in accordance with GB, DIN, ISO, ANSI / ASTM / SAE / IFI, AS, BS, UNI, JIS. Which are mainly applied to architectural steel structures, bridges, oil pipeline, machinery equipment, furniture, vessel, railway, and exported to Europe, Australia, North America, Middle East, Africa and Southeast Asia etc.

Now the company has been certificated by ISO9001(Moody International), ISO9001(CQC). The company operates each link form raw materials procession to the production process in strict accordance with the procedures and boasts good quality inspectors and perfect testing equipment. Which take effective control on the production process to ensure product quality.



Company Culture

- 1)Enterprise mission: the development of fastener industry, build independent fastener brand.
- 2)Corporate purposes: sound management, and create value.
- 3)Corporate vision: the "Changchun fasteners" developed into an internationally renowned enterprises.
- 4)The spirit of enterprise: diligent and pragmatic, honest and trustworthy, unity and cooperation, development together.
- 5)Corporate values: to provide customers with products to solve customer problems, create value for customers. For the staff to achieve growth value for the community to create wealth.
- 6)Corporate philosophy:
 - ①business philosophy: rolling development, efficiency first
 - ②the development of ideas: grasp the opportunity to challenge the future.
 - ③brand concept: to guide consumption, create demand.
 - ④the work of philosophy: loyalty, beyond ourselves.
 - ⑤the concept of talent: ability to determine the post, the contribution of the decision value.



Equipment and workshop



Product Introduction

- Screws are divided into three types: mechanical screws, wood screws, self-tapping screws, are from the connection and fixed role. Mechanical screws are mainly used in machinery, wood screws are mainly used in wood and expansion screws, self-tapping screws used to do aluminum alloy products, such as aluminum doors and windows. Upper mechanical screws mainly with wrenches, wood screws mainly with Kai Zi.
- In order to better distinguish the various screw functions, the company further subdivided into: non-standard custom, mechanical screws, triangular teeth screws, self-tapping screws, combination screws, lead screws, hexagonal



Non-standard screws

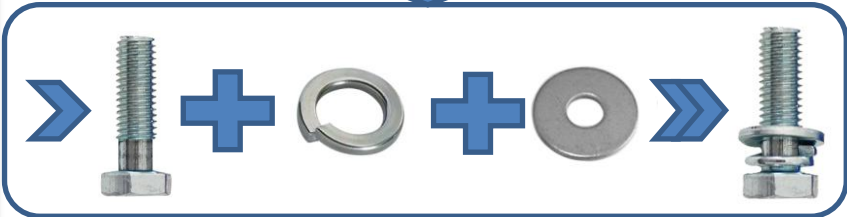


Combination screws

Product Introduction

Non-standard screw features, drilling tapping, locking is completed, the other binding force is strong, but also save construction time, improve work efficiency. Non-standard screws are mainly used in: stainless steel plate, metal plate, galvanized steel, engineering installation, metal curtain wall metal compartment and other indoor and outdoor installation, general angle, channel, iron and other metal materials combined installation, Container boxes, shipbuilding, refrigeration equipment and other assembly works. Customized products according to different specifications.

The combination screws are used for connection between thin metal plates and act as a connection. Surface plating with color zinc, blue zinc, white zinc white nickel and so on. It consists of the following components:





Mechanical screws



Self-tapping screws

Mechanical tooth screw is a kind of standardized, universal and serialized type of screw, which is widely used. It has the advantages of strong interchangeability, strong tension resistance, high machining accuracy, strong adaptability, easy to be prefabricated, easy to save time, improve production power, complete parts, and meet the requirements of various functional parts.

Self-tapping screw materials are heat treated to ensure that the required mechanical properties and performance are achieved. Surface plating treatment, phosphate treatment (phosphating), high surface hardness, good toughness. Advantages: do not need bottoming, tapping and metal gasket, directly into the thin steel plate and resin and other materials, can reduce the workload, easy to use, commonly used in home appliances and other products. Disadvantages: the same hole can not be reused.



The pin is one of the fasteners commonly used in modern machinery and equipment. The diameter of the cylinder is an important data to distinguish its specifications. The role of the pin is to prevent the relative displacement of the two parts, usually by the cylindrical wood, metal or other materials to do the parts, especially for a few separate objects together or as an object hanging in another The support on the object.

Pins



Sealed seals are made of ordinary seals, electronic seals, seals, etc., are loaded into the container and the box is properly closed, and a device similar to a lock is applied by a particular person. Once the seal is properly locked, unless the violent damage (ie, cut) can not be opened, the damaged seal can not be reused. Penetration screw Application: railway, aviation, oil, customs, ports, postal and other logistics industry. Mining, roads, finance, chemicals, petroleum, container, pharmaceutical and other industries. And apply to gas meters, meters, table boxes and so on.

Lead screws



Triangle screw



Connect the screws

The triangular screw thread is an ordinary thread with an arc triangular cross section, and the threaded surface also has a high hardness. The internal thread is tapped in the bottom hole of the connected member to form a connection, which is characterized by a low screw-in torque and high locking performance. Mechanical teeth are generally 60 degrees, there are 55 degrees teeth, Wei teeth. Advantages: 1, can be relatively hard hardness of the product, such as iron plate. 2, do not need matching nuts, cost savings.

Product Introduction

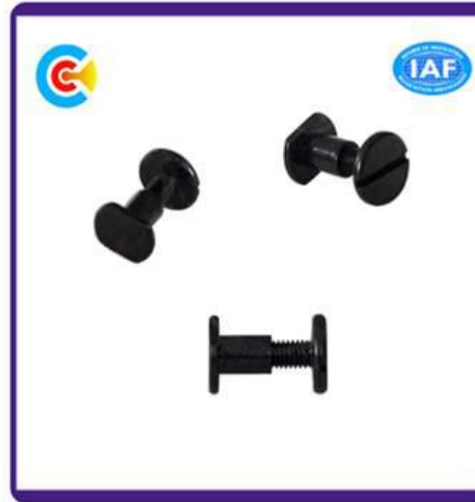
Copper nut is made of copper material (usually lead brass, such as H59, H62) made of nuts, copper nuts are not easy to rust, corrosion, easy to heat and conductivity and other advantages, generally used for rust, high temperature, conductive, Thermal conductivity and other use of the environment, such as taps, valves, electrical switches and so on. Another major use is injection molding, after heating into the plastic parts inside or direct mold injection.

Sub-screw application:

1. Car key bag
2. Bookkeeping account
3. Album and so on.



Copper nuts



Male and female screws

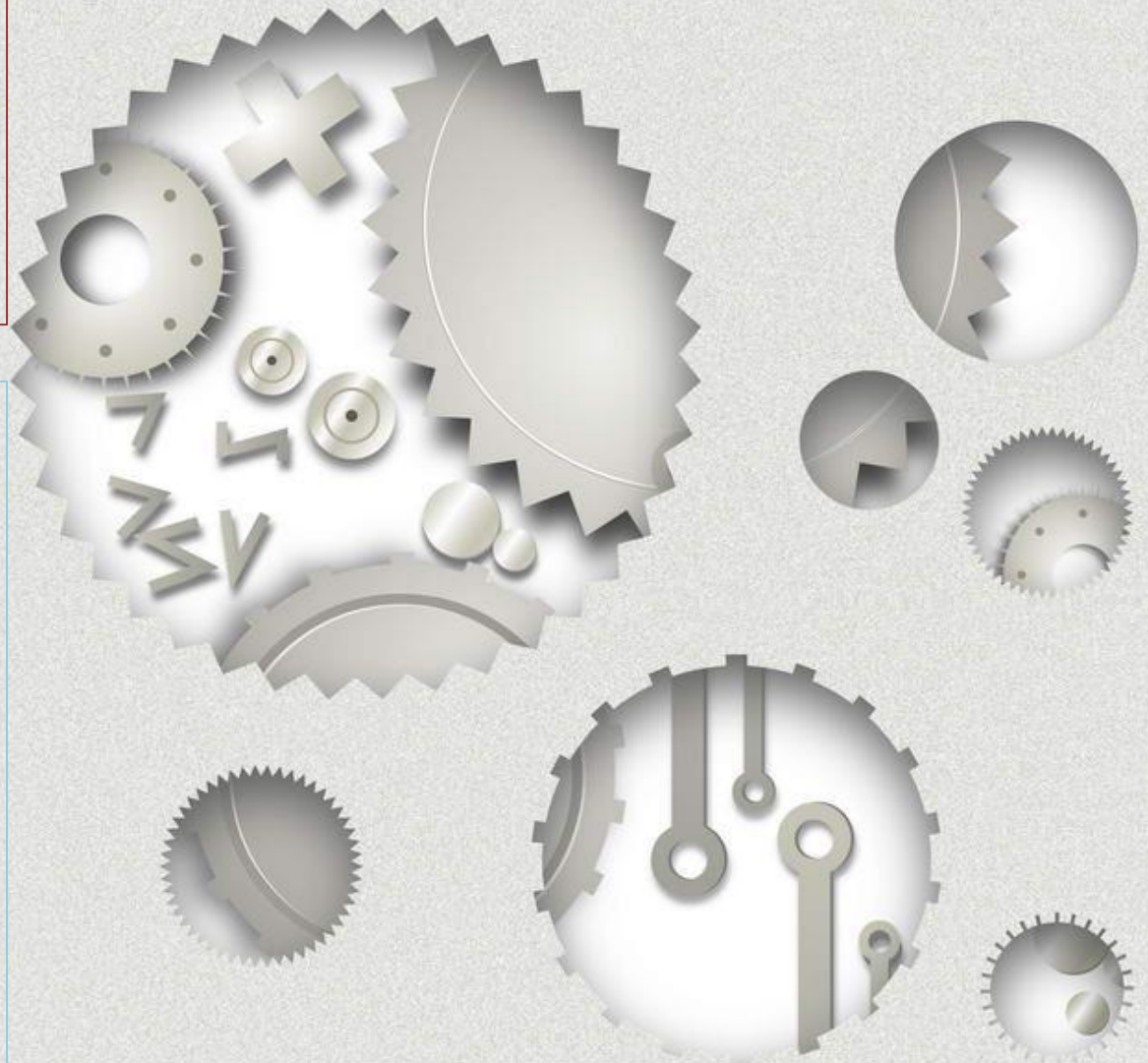


Hexagonal copper sleeve pin

Screw production process -- plating

Basically all the screws have to be plated, mainly for corrosion-resistant rust; such as plating blue and white zinc, galvanized zinc, black zinc plated, nickel-plated, etc. is not plated to black treatment.

Galvanized screw is not possible to completely replace the stainless steel screws, corrosion resistance in terms of end is nothing more than stainless steel screws. So still according to the use of occasions to choose the right material. Durable: In the suburbs, the standard hot-dip galvanized rust-proof thickness can be maintained for more than 50 years without repair; in the urban or offshore area, the standard hot-dip galvanized rust-proof layer can be maintained for 20 years without repair.



Screw production process -- Heat Treatment

Heat treatment mainly by changing the internal structure of the material to make the various fasteners to obtain the required performance and quality, the process usually does not change the shape of the material or fasteners. Enhance the surface of the carbon content of the screw to improve the surface strength of the screw, anti-wear resistance, anti-torque, tensile and other properties, popular talk is to improve the life of the screw.



Screw production process -- phosphating

Black phosphating process for steel parts (steel parts):
Degreasing→water washing→pickling washing→neutralization→water washing→surface conditioning→phosphorization, washing→dehydration→immersion

Process	Technological process	process conditions	Quality Index	Notes
1	Surface Pretreatment	Heavy oil, heavy rust for artificial self-care	Remove severe oil, burrs, heavy rust	
2	Hang up			According to the workpiece structure, pay attention to the process hole exhaust gas should be good.
3	Degreasing	POH-1 degreasing agent: 30 ~ 50Kg / m3 PH value: 11 ~ 13 Temperature: 60-75 °C Time: 10-15min	Remove the surface of animals and plants, mineral oil, etc., with reference to GB / T13312-91 standard	
4	water washing	Industrial tap water PH value: 7 ~ 8 Temperature: RT (room temperature) Time: 1-2min	Remove the out of the oil, the workpiece surface to form a continuous water film	Keep overflow in production and should always replace the bath
5	pickling washing	Industrial hydrochloric acid: 300-500Kg / m3 POR-2 additive: 10Kg / m3 Temperature: RT Time: 10-30min	Visual metal surface was wet with water, no oil and no rust was metallic silver white, with reference to JB / T6978-93 standard	Pay attention to control the bath concentration, regular clear the end.
6	water washing	Industrial water overflow PH: 6 to 7 Temperature: RT (room temperature) Time: 1-2min		Keep overflow and should be changed frequently.

Process	Technological process	process conditions	Quality Index	Notes
7	neutralize	Soda ash Na ₂ CO ₃ : 3-5Kg / m3 PH value: 10 ~ 12 Temperature: RT (room temperature) Time: 1-2min		
8	water washing	Industrial water overflow PH value: 6 ~ 7 Temperature: RT (room temperature) Time: 1-2min		Keep overflow and should be changed frequently.
9	surface conditioning	PTi-2M table swap: 2-3Kg / m3 PH value: 8.5 ~ 10 Temperature: RT Time: 1-2min		
10	Phosphate	PZn-8M Phosphating agent: 140Kg / m3 Total acidity (TA): 50Pt Free acid (FA): 5-6 Temperature: 95-98 ° C Time: 3-12min	The surface of the workpiece to form a dense continuous phosphate film, with reference to GB11376-89 standard	Always clean up the residue to control the process parameters
11	Water washing	Industrial self water overflow PH value: 6 ~ 7 Temperature: RT (room temperature) Time: 0.5 ~ 1min	Wash out the phosphating solution	Keep overflow and should be changed frequently
12	Dehydrated	PDO-2 dehydrated anti-rust oil Temperature: RT (room temperature) Time: 20-30min		
13	Soaked in oil	PSO-2 ultra-thin layer of anti-rust oil Temperature: RT (room temperature) Time: 20-30min		
14	Check	GB11376-89 metal phosphate conversion film		

Screw test ---- salt spray: environmental simulation test, according to the actual use of the product environment, under laboratory conditions by controlling the temperature, humidity, gas concentration, medium concentration and other parameters to simulate, in order to quickly understand the material or product Use performance or service life.



1 Salt spray test

Environmental testing of corrosion resistance of metallic materials. The test solution temperature was controlled according to the standard configuration of the salt solution.

Category: Neutral, Acetic Acid, Copper Salt Accelerated Acetate Fog

Equipment: SST-9NL salt spray test chamber, Q-FOG salt spray test chamber and so on

The main reference standard:

GB / T 10125-1997, GB / T 20854-2007, ISO 14993-2001 and so on.

Screw test--Salt spray



2 High and low temperature test; high and low temperature alternating test; hot and humid alternating test

Temperature range: $-70\text{ }^{\circ}\text{C} \sim 150\text{ }^{\circ}\text{C}$ Humidity range: 30% ~ 98% R.H.

Equipment: GDJS-010B high and low temperature alternating test chamber, LHL-212T, SHO10 constant temperature and humidity box, NTH225-40A4 fast temperature and humidity test chamber

The main reference standard:

GB2423.1-2001, GB2423.2-2001, GB2423.3-93 and so on.

3 Resistance to mold test

Evaluate the degree of long mold in the climate conditions favorable to mold growth and the effects of surface changes and properties due to mildew.

The main reference standard:

GB2423.16, GJB150.10-86, GJB4.10-83

4 Gas corrosion test

Temperature range: $10 \sim 50\text{ }^{\circ}\text{C}$

Humidity range: 60% to 95%

Gas types: sulfur dioxide, nitrogen dioxide, chlorine, hydrogen sulfide

Classification: Single gas corrosion test, mixed gas corrosion test

Equipment: LSO2-300 single gas corrosion test chamber, HQ-600B mixed gas corrosion test chamber

The main reference standard:

GB / T 2423.51-2000, GBT 2423.33-2005, DIN 50018, GB 9789-88



5 Resistance to liquid media test

The liquid medium aging test method is the aging test method of immersing the sample in a liquid medium. The liquid medium of the test is based on the purpose of the test and the environmental choice of the material (the medium may be water, acid, alkali, oil, organic solvent, etc.)

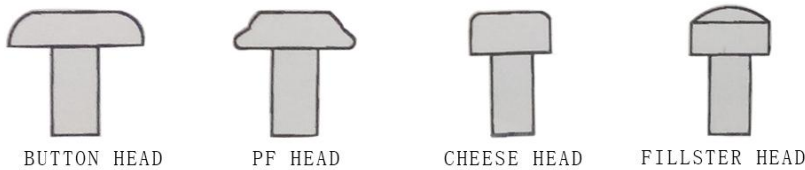
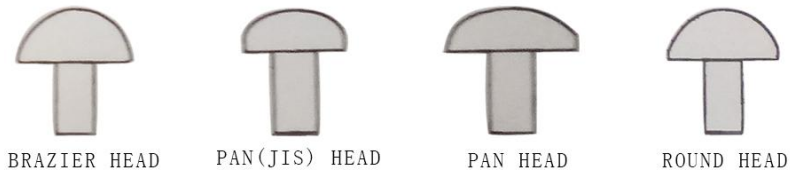
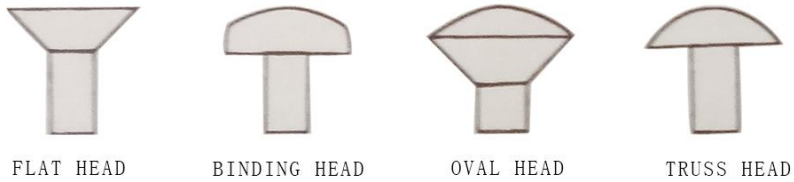
Equipment: high temperature aging box

The main reference standard: GB / T 1690 and so on.

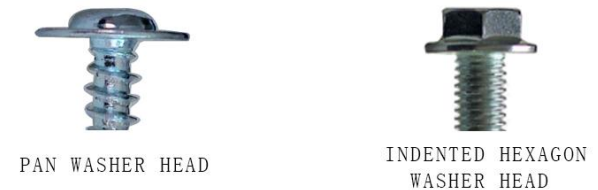
SCREW HEAD STYLES

Note: According to different needs to customize the different head type

Screw plan



Physical comparison chart



SCREW DRIVERS



PHILLIPS/CROSS



SLOTTED



PHILLIPS/SLOT



SIX-LOBE



SIX-LOBE
TAMPER



SLX-LOBE
/SLOT



SIX-LOBE
PLUS



POZIDRIV



POZIDRIV
/ROUND HOLE



SQUARE



SQUARE
/SLOT



PHILLIPS
/SQUARE



TRIANGLE



DOUBLE V



Y-TYPE



TRI-WING



H-TYPE



HEXAGON



5-POINT



S-TYPE



8-POINT



SPLINE



SPANNER



CLUTCH

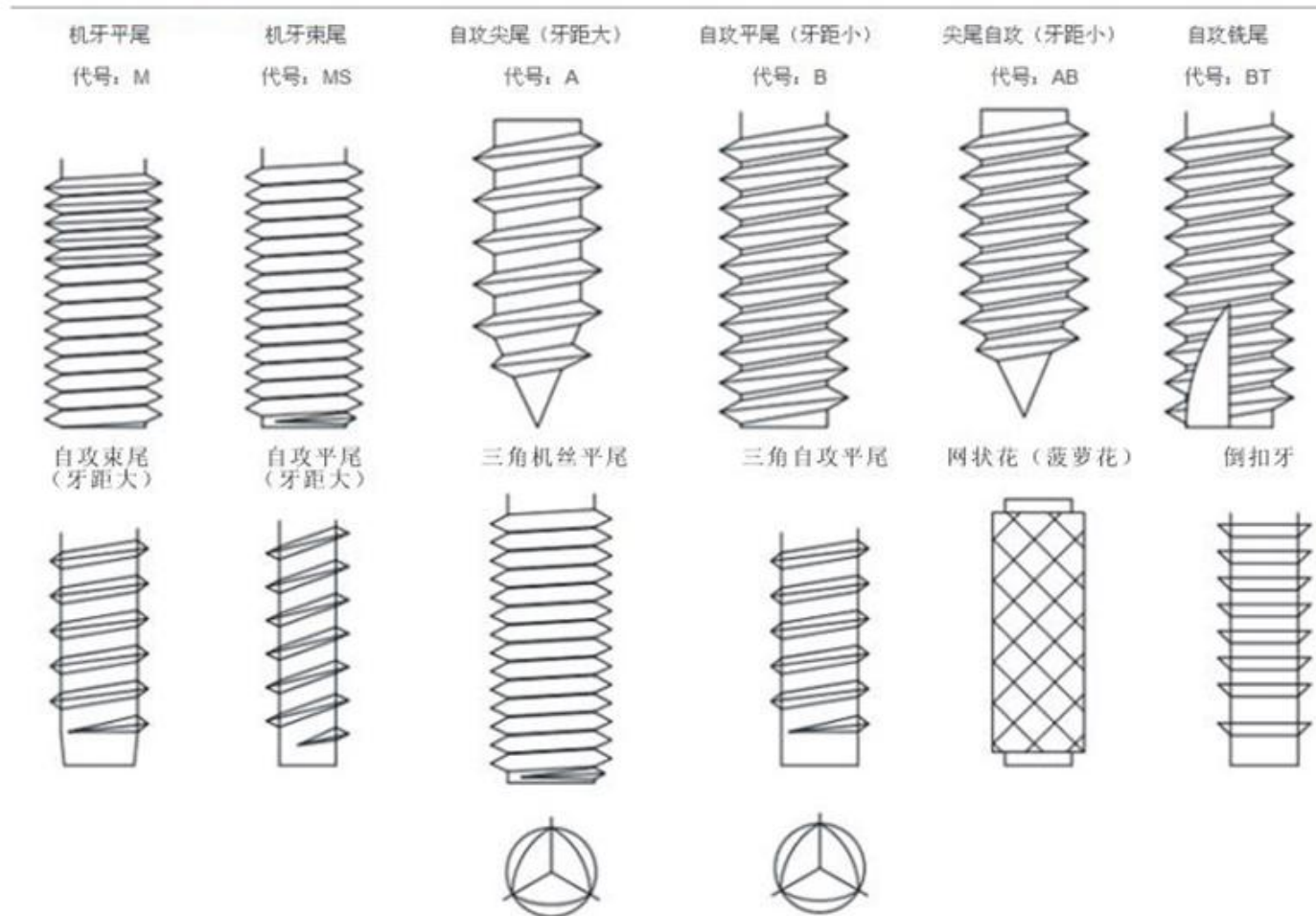


PHILLIPS
/SLOT. IND



SLOT. IND

Conventional screw type

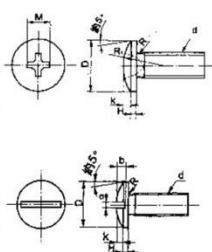




》 JIS SCREW HEADER SIZE 日标螺丝头型尺寸

JMB (JIS BINDING HEAD MACHINE & TAPPING SCREW)

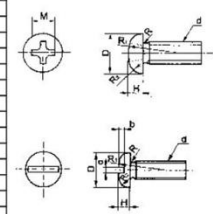
规格 (d)	D		H		K		H+K		a		b		R		M		Q		打字			
	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差				
M2	4.3	0.85	0.35	1.2	0.6	0.65	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	JMB M2.0			
M2.2	4.7	0.9	0.4	1.3	0.6	0.7	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	JMB M2.2			
M2.3	4.9	1	0.4	1.4	0.6	0.7	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	JMB M2.3			
M2.5	5.3	1	0.5	1.5	0.8	0.8	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	JMB M2.5			
M2.6	5.5	1.1	0.5	1.6	0.8	0.85	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	JMB M2.6			
M3	6.3	1.3	0.6	1.9	0.8	1	0.1	3.6	1.53	1.01	0.1	3.6	1.53	1.01	0.1	3.6	1.53	1.01	JMB M3.0			
M3.5	7.3	1.5	0.7	2.2	1	1.15	0.1	3.9	1.83	1.30	0.1	3.9	1.83	1.30	0.1	3.9	1.83	1.30	JMB M3.5			
M4	8.3	1.7	0.8	2.5	1	1.3	0.2	4.2	2.13	1.60	0.2	4.2	2.13	1.60	0.2	4.2	2.13	1.60	JMB M4.0			
M4.5	9.3	1.9	0.9	2.8	±0.2	1.5	0.2	4.6	2.53	1.99	0.2	4.6	2.53	1.99	0.2	4.6	2.53	1.99	JMB M4.5			
M5	10.3	2.1	1	3.1	1.2	1.7	0.25	4.9	2.83	2.29	0.25	4.9	2.83	2.29	0.25	4.9	2.83	2.29	JMB M5.0			
M6	12.4	2.4	1.3	3.7	1.2	2	±0.3	5.2	3.26	2.61	0.3	5.2	3.26	2.61	0.3	5.2	3.26	2.61	JMB M6.0			
M8	16.4	3.1	1.7	4.8	±0.3	1.6	2.8	±0.5	4.7	4.36	3.78	2.8	±0.5	4.7	4.36	3.78	2.8	±0.5	4.7	4.36	3.78	JMB M8.0



》 JIS SCREW HEADER SIZE 日标螺丝头型尺寸

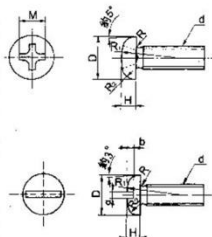
JMR (JIS ROUND HEAD MACHINE & TAPPING SCREW)

规格 (d)	D		H		R1		R2		a		b		R		M		Q		打字	
	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差		
M1	2	0	0.8	1.2	0.7	0.32	0.45	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	JMR M1.0
M1.2	2.3	-0.3	0.8	1.4	0.8	0.32	0.5	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	JMR M1.2
M1.4	2.6	1	1	1.6	0.9	0.32	0.6	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	JMR M1.4
M1.6	3	1.1	1	1.8	1	0.4	0.65	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	JMR M1.6
M1.7	3.2	1.2	1.1	1.9	1.1	0.4	0.7	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	JMR M1.7
M2	3.5	1.3	1.1	2.1	1.2	0.6	0.8	0.1	2.7	1.53	1.15	0.1	2.7	1.53	1.15	0.1	2.7	1.53	1.15	JMR M2.0
M2.2	4	-0.4	1.5	2.4	1.3	0.6	0.9	0.1	2.8	1.64	1.26	0.1	2.8	1.64	1.26	0.1	2.8	1.64	1.26	JMR M2.2
M2.3	4	1.5	1.5	2.4	1.3	0.6	0.9	0.1	2.9	1.75	1.37	0.1	2.9	1.75	1.37	0.1	2.9	1.75	1.37	JMR M2.3
M2.5	4.5	1.7	1.7	2.7	1.5	0.8	1	0.1	2.9	1.86	1.49	0.1	2.9	1.86	1.49	0.1	2.9	1.86	1.49	JMR M2.5
M2.6	4.5	1.7	1.7	2.7	1.5	0.8	1	0.1	3.0	1.97	1.62	0.1	3.0	1.97	1.62	0.1	3.0	1.97	1.62	JMR M2.6
M3	5.5	2	2	3.3	1.8	0.8	1.2	0.2	3.1	2.08	1.76	0.2	3.1	2.08	1.76	0.2	3.1	2.08	1.76	JMR M3.0
M3.5	6	-0.5	2.3	4.2	2.3	1	1.4	0.2	3.1	2.19	1.89	0.2	3.1	2.19	1.89	0.2	3.1	2.19	1.89	JMR M3.5
M4	7	2.6	±0.15	4.2	2.3	1	1.6	±0.25	3.2	2.3	2.01	0.25	3.2	2.3	2.01	0.25	3.2	2.3	2.01	JMR M4.0
M4.5	8	3	3	4.8	2.7	1	1.9	0.2	3.2	2.41	2.12	0.2	3.2	2.41	2.12	0.2	3.2	2.41	2.12	JMR M4.5
M5	9	-0.6	3.4	5.4	3	1.2	2.1	0.3	3.2	2.51	2.23	0.3	3.2	2.51	2.23	0.3	3.2	2.51	2.23	JMR M5.0
M6	10.5	4	±0.2	6.3	3.5	1.2	2.5	±0.4	3.2	2.61	2.34	0.4	3.2	2.61	2.34	0.4	3.2	2.61	2.34	JMR M6.0
M8	14	5.4	±0.2	8.4	4.6	1.6	3.3	±0.5	3.2	2.71	2.46	0.5	3.2	2.71	2.46	0.5	3.2	2.71	2.46	JMR M8.0



JMP (JIS PAN HEAD MACHINE & TAPPING SCREW)

规格 (d)	D		H		R1		R2		a		b		R		M		Q		打字	
	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差		
M1	2	0.65	3	0.3	0.32	0.3	0.3	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	JMP M1.0
M1.2	2.3	0.8	3.5	0.4	0.32	0.4	0.4	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	JMP M1.2
M1.4	2.6	0.9	3.7	0.5	0.32	0.5	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	JMP M1.4	
M1.6	3	1	4	0.5	0.4	0.55	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	JMP M1.6	
M1.7	3.2	1.1	4.2	0.6	0.4	0.6	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	JMP M1.7	
M2	3.5	1.3	4.5	0.7	0.6	0.7	0.1	2.7	1.53	1.15	0.1	2.7	1.53	1.15	0.1	2.7	1.53	1.15	JMP M2.0	
M2.2	4	1.5	5	0.8	0.6	0.8	0.1	2.8	1.64	1.26	0.1	2.8	1.64	1.26	0.1	2.8	1.64	1.26	JMP M2.2	
M2.3	4	1.5	5	0.8	0.6	0.8	0.1	2.9	1.75	1.37	0.1	2.9	1.75	1.37	0.1	2.9	1.75	1.37	JMP M2.3	
M2.5	4.5	1.7	6	0.9	0.8	0.9	0.1	2.9	1.86	1.49	0.1	2.9	1.86	1.49	0.1	2.9	1.86	1.49	JMP M2.5	
M2.6	4.5	1.7	6	0.9	0.8	0.9	0.1	3.0	1.97	1.62	0.1	3.0	1.97	1.62	0.1	3.0	1.97	1.62	JMP M2.6	
M3	5.5	2	7	1.1	0.8	1.1	0.1	3.5	2.13	1.60	0.1	3.5	2.13	1.60	0.1	3.5	2.13	1.60	JMP M3.0	
M3.5	6	-0.6	2.3	8	1.3	1	1.25	0.2	3.5	2.24	1.71	0.2	3.5	2.24	1.71	0.2	3.5	2.24	1.71	JMP M3.5
M4	7	2.6	±0.15	9	1.5	1	1.4	0.2	4.1	2.03	1.45	0.2	4.1	2.03	1.45	0.2	4.1	2.03	1.45	JMP M4.0
M4.5	8	2.9	11	1.7	1	1.6	±0.25	4.2	2.13	1.60	0.25	4.2	2.13	1.60	0.25	4.2	2.13	1.60	JMP M4.5	
M5	9	-0.7	3.3	12	1.9	1.2	1.8	±0.3	4.2	2.23	1.60	0.3	4.2	2.23	1.60	0.3	4.2	2.23	1.60	JMP M5.0
M6	10.5	3.9	±0.2	14	2.3	1.2	2.1	±0.3	4.2	2.33	1.60	0.25	4.2	2.33	1.60	0.25	4.2	2.33	1.60	JMP M6.0
M8	14	5.2	±0.2	18	3	1.6	2.8	±0.5	4.2	2.43	1.60	0.4	4.2	2.43	1.60	0.4	4.2	2.43	1.60	JMP M8.0



JMT (JIS TRUSS HEAD MACHINE & TAPPING SCREW)

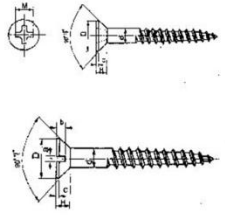
规格 (d)	D		H		R1		a		b		R		M		Q		打字			
	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差	公差				
M2	4.5	1.2	3	0.6	0.6	0.6	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	0.1	2.2	1.01	0.65	JMT M2.0	
M2.2	5	1.3	3.2	0.6	0.7	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	0.1	2.3	1.11	0.75	JMT M2.2		
M2.3	5.2	1.4	3.4	0.6	0.75	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	0.1	2.4	1.21	0.85	JMT M2.3		
M2.5	5.7	1.5	3.7	0.8	0.8	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	0.1	2.5	1.32	0.95	JMT M2.5		
M2.6	5.9	1.6	3.9	0.8	0.85	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	0.1	2.6	1.42	1.05	JMT M2.6		
M3	6.9	1.9	4.6	0.8	0.95	0.1	2.9	1.72	1.34	1.34	0.1	2.9	1.72	1.34	1.34	0.1	2.9	1.72	1.34	JMT M3.0 (PH#1)
M3.5	8.1	-0.5	2.2	5.4	1	1.1	0.1	3.9	1.83	1.30	0.1	3.9	1.83	1.30	0.1	3.9	1.83	1.30	JMT M3.5	
M4	9.4	2.5	6.1	1	1.25	0.2	4.2	2.13	1.60	0.2	4.2	2.13	1.60	0.2	4.2	2.13	1.60	JMT M4.0		
M4.5																				



》JIS SCREW HEADER SIZE 目标螺丝头型尺寸

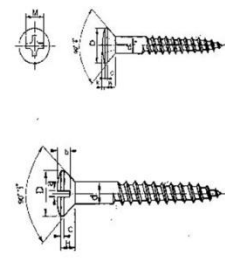
JWF (JIS FLAT HEAD WOOD SCREW)

规格 (d)	d	D	H	C	a	b	M	Q	打字			
										公差	公差	公差
1.6	1.6	3.2	0.95	0.15	0.4	0.4						
1.8	1.8	3.6	1.05	0.15	0.6	0.5						
2.1	2.1	4.2	0	0.2	0.6	0.5	±0.1	2.5	1.32	0.95	JWF M2.1	
2.4	2.4	4.8	0	0.2	0.7	0.6		2.7	1.52	1.14	JWF M2.4	
2.7	2.7	5.4	1.55	0.2	0.8	0.7	±0.14	2.9	1.72	1.34	JWF M2.7	
3.1	3.1	6.2	1.8	0.25	0.9	0.8		3.8	1.73	1.20	JWF M3.1	
3.5	3.5	7	0	0.25	1	0.9		4.2	2.13	1.60	JWF M3.5	
3.8	3.8	7.6	0	0.25	1	0.9	±0.2	4.5	2.43	1.89	JWF M3.8	
4.1	4.1	8.2	2.35	0	0.3	1.2	±0.2	4.8	2.73	2.19	JWF M4.1	
4.5	4.5	9	2.55	0	0.3	1.2	±0.2	5.2	3.13	2.59	JWF M4.5	
4.8	4.8	9.6	0	0.3	1.3	1.2		5.4	3.33	2.77	JWF M4.8	
5.1	5.1	10.2	2.85	0.3	1.4	1.2		6.4	3.06	2.50	JWF M5.1	
5.5	5.5	11	3.05	0.3	1.4	1.3	±0.25	6.7	3.36	2.80	JWF M5.5	
5.8	5.8	11.6	3.2	0.3	1.6	1.4		7.0	3.66	3.09	JWF M5.8	
6.2	6.2	12.4	0	0.3	1.6	1.5	±0.3	7.3	3.96	3.39	JWF M6.2	
6.6	6.6	13.6	0.7	0.3	1.8	1.6		7.8	4.40	3.87	JWF M6.6	
7.5	7.5	15	0	0.4	1.8	1.8	±0.35	9.0	4.65	4.11	JWF M7.5	
8	8	16	0	0.4	1.8	1.9		9.3	4.95	4.41	JWF M8.0	
9.5	9.5	19	-0.8	0.4	2	2.2	±0.4	10.3	5.95	5.39	JWF M9.5	



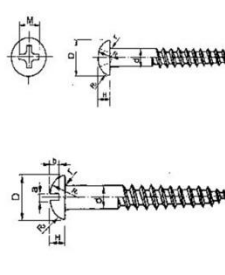
JWO (JIS OVAL HEAD WOOD SCREW)

规格 (d)	d	D	H	R1	R2	a	b	M	Q	打字				
											公差	公差	公差	公差
1.6	1.6	3.2	0.95	0.15	0.4	1.35	0.4	0.4	0.7	±0.1				
1.8	1.8	3.6	1.05	0.15	0.4	1.45	-0.3	0.6	0.9	±0.1				
2.1	2.1	4.2	0	0.2	0.5	1.75	0.8	0.8	0.9		2.7	1.52	1.14	JWO M2.1
2.4	2.4	4.8	1.4	1.4	0.6	2	0.7	1	1.1	±0.15	2.9	1.72	1.34	JWO M2.4
2.7	2.7	5.4	1.55	1.55	0.7	2.25	-0.4	0.8	1.1		3.1	1.62	1.54	JWO M2.7
3.1	3.1	6.2	1.8	1.8	0.8	2.6	0.9	1.3	1.3	±0.2	3.9	1.83	1.30	JWO M3.1
3.5	3.5	7	0	2	0.8	2.8	1	1.4	1.4		4.3	2.23	1.69	JWO M3.5
3.8	3.8	7.6	2.15	2.15	0.9	3.05	1	1.4	1.5	±0.25	4.6	2.53	1.99	JWO M3.8
4.1	4.1	8.2	2.35	2.35	1	3.35	1.2	1.5	1.7		4.9	2.83	2.28	JWO M4.1
4.5	4.5	9	2.55	2.55	1.1	3.65	-0.5	1.2	1.8		5.3	3.23	2.68	JWO M4.5
4.8	4.8	9.6	0	2.7	1.1	3.8	1.3	1.9	1.9	±0.3	5.5	3.43	2.87	JWO M4.8
5.1	5.1	10.2	2.85	2.85	1.2	4.05	1.4	2	2		6.5	3.16	2.60	JWO M5.1
5.5	5.5	11	3.05	3.05	1.3	4.35	1.4	2.2	2.2		6.8	3.46	2.90	JWO M5.5
5.8	5.8	11.6	3.2	3.2	1.4	4.6	1.6	2.3	2.3	±0.4	7.1	3.76	3.19	JWO M5.8
6.2	6.2	12.4	0	3.5	1.4	4.9	1.6	2.5	2.5		7.4	4.06	3.48	JWO M6.2
6.6	6.6	13.6	0.7	3.8	0	5.4	1.6	2.7	2.7	±0.45	7.9	4.56	3.97	JWO M6.6
7.5	7.5	15	0	4.15	1.8	5.95	-0.6	1.8	3	±0.5	9.2	4.85	4.31	JWO M7.5
8	8	16	0	4.4	1.8	6.2	1.8	3.1	3.1		9.5	5.15	4.60	JWO M8.0
9.5	9.5	19	-0.8	5.15	2.3	7.45	2	3.7	3.7	±0.5	10.5	6.15	5.58	JWO M9.5



JWR (JIS ROUND HEAD WOOD SCREW)

规格 (d)	d	D	H	R1	R2	a	b	M	Q	打字				
											公差	公差	公差	公差
1.6	1.6	3	1.3	1.6	1.1	0.4	0.4	0.8	0.8					
1.8	1.8	3.3	1.4	1.8	1.2	0.6	-0.15	0.6	0.9	±0.1				
2.1	2.1	3.9	1.6	2.3	1.4	0.8	0	0.6	0	±0.15	2.5	1.32	0.90	JWR M2.1
2.4	2.4	4.4	1.8	2.6	1.5	0.7	0.7	1.1	1.1		2.7	1.52	1.10	JWR M2.4
2.7	2.7	5	2	3	1.7	0.8	0.8	1.2	1.2	±0.2	2.9	1.72	1.29	JWR M2.7
3.1	3.1	5.7	2.3	3.4	1.9	0.9	0.9	1.4	1.4		3.7	1.63	1.05	JWR M3.1
3.5	3.5	6.5	2.5	4	2.1	1	1	1.6	1.6		3.9	1.83	1.25	JWR M3.5
3.8	3.8	7	2.7	4.4	2.3	1	1	1.7	1.7	±0.25	4.1	2.03	1.45	JWR M3.8
4.1	4.1	7.6	2.9	4.8	2.4	1.2	1.2	1.9	1.9		4.3	2.23	1.64	JWR M4.1
4.5	4.5	8.5	3.1	5.2	2.6	1.2	1.2	2.1	2.1	±0.3	4.5	2.43	1.84	JWR M4.5
4.8	4.8	8.9	3.3	5.7	2.63	1.3	1.3	2	2		4.7	2.63	2.04	JWR M4.8
5.1	5.1	9.4	3.5	6	2.9	1.4	1.4	2.2	2.2		5.9	2.56	1.96	JWR M5.1
5.5	5.5	10.2	3.8	6.5	3.2	1.4	1.4	2.4	2.4	±0.4	6.1	2.76	2.16	JWR M5.5
5.8	5.8	10.7	4	6.9	3.3	1.6	1.6	2.5	2.5		6.3	2.96	2.36	JWR M5.8
6.2	6.2	11.5	0.36	7.4	3.5	1.6	1.6	2.6	2.6		6.5	3.16	2.56	JWR M6.2
6.6	6.6	12.6	4.6	8.2	3.8	1.8	-0.25	1.8	2.8	±0.45	6.9	3.56	2.93	JWR M6.6
7.5	7.5	13.9	5	9.1	4.2	1.8	1.8	3.1	3.1		8.4	4.05	3.48	JWR M7.5
8	8	14.8	0.4	9.7	4.4	1.8	1.8	3.3	3.3	±0.5	8.7	4.35	3.77	JWR M8.0
9.5	9.5	17.6	6.3	11.6	5.2	2	2	3.9	3.9		9.7	5.35	4.75	JWR M9.5



螺丝辗造径

铁板自攻螺丝规格表

TAPPING SCREW M/MTYPE A 米厘规格铁板螺丝					TAPPING SCREW M/MTYPE AB(B) 米厘规格铁板螺丝						
规格 SIZE	牙距 P(T)	外径		辗造径		规格 SIZE	牙距 P(T)	外径		辗造径	
		最大	最小	最大	最小			最大	最小	最大	最小
M1	60	1.05	1	0.87	0.82	M1	64	1	0.95	0.88	0.83
M1.2	56	1.25	1.2	1.05	1	M1.2	64	1.2	1.15	1.05	1
M1.4	48	1.5	1.4	1.2	1.15	M1.4	56	1.4	1.35	1.2	1.15
M1.7	40	1.8	1.7	1.45	1.4	M1.7	48	1.7	1.62	1.45	1.4
M2	32	2.1	2	1.75	1.7	M2	40	2	1.9	1.7	1.65
M2.3	32	2.4	2.4	2	1.95	M2.3	32	2.3	2.2	1.9	1.85
M2.6	28	2.7	2.6	2.2	2.15	M2.6	28	2.6	2.5	2.15	2.1
M3	24	3.1	3	2.45	2.4	M3	24	3	2.9	2.45	2.4
M3.5	18	3.65	3.5	2.85	2.8	M3.5	20	3.5	3.4	2.85	2.8
M4	16	4.15	4	3.3	3.25	M4	18	4	3.85	3.3	3.25
M4.5	14	4.65	4.5	3.6	3.55	M4.5	16	4.5	4.35	3.6	3.55
M5	12	5.2	5	3.95	3.9	M5	16	5	4.85	4.1	4.05
M6	10	6.2	6	4.8	4.75	M6	14	6	5.85	5.05	5
M8	9	8.2	8	6.45	6.4	M8	12	8	7.85	6.8	6.78

日式机械粗牙螺丝螺纹 (60°)					日式机械细牙螺丝螺纹 (60°)						
规格 SIZE	牙距 P(T)	外径		辗造径		规格 SIZE	牙距 P(T)	外径		辗造径	
		最大	最小	最大	最小			最大	最小	最大	最小
M1.2	0.25	1.8	1.14	1.04	1.01	M4.0	0.5	3.97	3.86	3.62	3.58
M1.4	0.3	1.38	1.35	1.20	1.16	M4.5	0.5	4.47	4.36	4.12	4.08
M1.7	0.35	1.68	1.61	1.46	1.42	M5.0	0.5	4.97	4.86	4.62	4.58
M2.0	0.4	1.98	1.89	1.72	1.69	M6.0	0.75	5.97	5.85	5.45	5.41
M2.3	0.4	2.28	2.19	2.02	1.99	M7.0	0.75	6.97	6.85	6.45	6.41
M2.6	0.45	2.58	2.48	2.28	2.25	M8.0	1.0	7.97	7.83	7.29	7.24
M3.0	0.5	2.98	2.88	2.64	2.61	M9.0	1.0	8.97	8.83	8.29	8.24
M3.5	0.6	3.47	3.36	3.06	3.03	M10	1.25	9.96	9.81	9.12	9.07
M4.0	0.7	3.98	3.84	3.49	3.45	M10	1.0	9.97	9.82	9.28	9.23
M4.5	0.75	4.47	4.34	3.96	3.92	M12	1.25	11.97	11.76	11.12	11.07
M5.0	0.8	4.98	4.83	4.43	4.38	M12	1.5	11.96	11.79	10.95	10.89
M6.0	1.0	5.97	5.82	5.30	5.25	M14	1.5	13.96	13.79	12.95	12.89
M7.0	1.0	6.97	6.82	6.30	6.25	M16	1.5	15.96	15.79	14.95	14.89
M8.0	1.25	7.96	7.79	7.12	7.07	M18	2.0	17.95	17.65	16.62	16.54
M9.0	1.25	8.96	8.79	8.12	8.07	M18	1.5	17.95	17.78	16.93	16.86
M10	1.5	9.96	9.77	8.97	8.91	M20	2.0	19.95	19.65	18.62	18.54
M11	1.5	10.97	10.73	9.97	9.91	M20	1.5	19.95	19.78	18.92	18.85
M12	1.75	11.95	11.76	10.79	10.73	M22	2.5	21.95	21.78	20.92	20.85
M14	2.0	13.95	13.74	12.63	12.56	M24	1.5	23.95	23.78	22.92	22.85
M16	2.0	15.95	15.74	14.63	14.56	M26	1.5	25.95	25.78	24.93	24.85



美制自攻螺丝规格表

WOOD SCREW ASA TYPE 美国木螺丝规格						WOOD SCREW ASA TYPE 美国木螺丝规格					
规格 SIZE	牙距 P(T)	外径		辗造径		规格 SIZE	牙距 P(T)	外径		辗造径	
		最大	最小	最大	最小			最大	最小		
NO 0	40	1.52	1.44	1.2	1.15	NO 0	48	1.52	1.44	1.25	1.2
NO 1	32	1.9	1.82	1.5	1.45	NO 1	42	1.9	1.82	1.6	1.55
NO 2	32	2.23	2.13	1.8	1.75	NO 2	32	2.23	2.13	1.8	1.75
NO 3	28	2.56	2.46	2.1	2.05	NO 3	28	2.56	2.46	2.05	2
NO 4	24	2.89	2.79	2.3	2.25	NO 4	24	2.89	2.79	2.3	2.25
NO 5	20	3.3	3.2	2.65	2.6	NO 5	20	3.3	3.2	2.6	2.55
NO 6	18	3.58	3.45	2.8	2.75	NO 6	20	3.53	3.43	2.85	2.8
NO 7	16	4.01	3.86	3.15	3.1	NO 7	19	3.91	3.78	3.15	3.1
NO 8	15	4.26	4.11	3.35	3.3	NO 8	18	4.21	4.09	3.4	3.35
NO 9	14	4.55	4.4	3.5	3.45	NO 10	16	4.8	4.65	3.9	3.85
NO 10	12	4.92	4.77	3.75	3.7	NO 12	14	5.46	5.31	4.4	4.35
NO 12	11	5.6	5.46	4.4	4.35	1/4	14	6.25	6.1	5.2	5.15
NO 14	10	6.45	6.29	5.1	5.05	5/16	12	8	7.82	6.75	6.7
NO 16	10	7.11	6.96	5.7	5.65						
NO 18	9	7.77	7.62	6.1	6.05						

TAPPING SCREW W. T. TYPE A 韦氏铁板螺丝					
规格 SIZE	牙距 P(T)	外径		辗造径	
		最大	最小	最大	最小
3/32	32	2.48	2.38	1.85	1.8
1/8	24	3.27	3.17	2.6	2.55
5/32	16	4.07	3.97	3.2	3.15
3/16	12	4.86	4.76	3.75	3.7
1/4	10	6.45	6.35	5.2	5.15
5/16	9	8.0	7.9	6.35	6.3
3/8	7	9.63	9.53	7.65	7.6
1/2	6	12.8	12.7	10.45	10.4

DIN TAPPING DIN TYPE 7970铁螺丝					
规格 SIZE	牙距 P(T)	外径		辗造径	
		最大	最小	最大	最小
2.2	0.79	2.24	2.13	1.8	1.75
2.9	1.06	2.9	2.79	2.3	2.25
3.5	1.27	3.53	3.43	2.8	2.75
3.9	1.34	3.91	3.78	3.15	3.1
4.2	1.41	4.22	4.08	3.4	3.35
4.8	1.59	4.8	4.65	3.85	3.8
5.5	1.81	5.46	5.31	4.4	4.35
6.3	1.81	6.25	6.1	5.15	5.1
8	2.12	8	7.82	6.75	6.7

机械螺丝规格表

SWB MACHINE SCREW 2A Q(55°) 韦氏牙规格							BWB MACHINE SCREW 2A Q(55°) 韦氏牙规格						
规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数	规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数
		最大	最小	最大	最小				最大	最小			
1/16	60	1.56	1.47	1.29	1.27	0.235	7/16	14	11.082	10.892	9.88	9.84	1.127
3/32	48	2.361	2.155	2.01	1.99	0.258	1/2	12	12.67	12.46	11.27	11.22	1.319
1/8	40	3.155	3.045	2.72	2.7	0.39	9/16	12	14.258	14.047	12.86	12.81	1.319
5/32	32	3.945	3.795	3.4	3.38	0.48	5/8	11	15.848	15.605	14.33	14.27	1.426
3/16	24	4.742	4.592	4.03	4	0.652	3/4	10	19.02	18.78	17.34	17.28	1.59
1/4	20	6.33	6.16	5.48	5.45	0.78	7/8	9	22.195	21.935	20.32	20.28	1.765
5/16	18	7.91	7.72	6.97	6.94	0.86	1	8	25.37	25.11	23.27	23.23	1.99
3/8	16	9.5	9.31	8.44	8.4	0.985							

机械螺丝规格表

M/M MACHINE SCRE 2A Q(60°) 米厘牙(M)规格(粗牙)							M/M MACHINE SCRE 2A Q(60°) 米厘牙(M)规格(粗牙)						
规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数	规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数
		最大	最小	最大	最小				最大	最小			
1.2	0.25	1.18	1.14	1.04	1.01	0.156	9	1.25	8.96	8.79	8.12	8.07	0.782
1.4	0.3	1.38	1.34	1.2	1.16	0.188	10	1.5	9.96	9.77	8.97	8.91	0.94
1.7	0.35	1.68	1.61	1.46	1.42	0.219	11	1.5	10.968	10.732	9.97	9.91	0.94
2	0.4	1.98	1.89	1.7	1.67	0.25	12	1.75	11.95	11.76	10.79	10.73	1.094
2.3	0.4	2.28	2.19	2	1.97	0.25	14	2	13.95	13.74	12.63	12.56	1.264
2.6	0.45	2.58	2.48	2.26	2.23	0.281	16	2	15.95	15.74	14.63	14.56	1.264
3	0.5	2.98	2.87	2.63	2.6	0.313	18	2.5	17.95	17.71	16.31	16.23	1.56
3.5	0.6	3.47	3.36	3.06	3.03	0.375	20	2.5	19.95	19.71	18.31	18.23	1.56
4	0.7	3.978	3.838	3.49	3.45	0.438	22	2.5	21.95	21.71	20.31	20.23	1.56
4.5	0.75	4.47	4.34	3.96	3.92	0.468	24	3	23.94	23.68	21.98	21.9	1.87
5	0.8	4.976	4.826	4.43	4.38	0.5	27	3	26.94	26.68	24.98	24.89	1.87
6	1	5.97	5.82	5.3	5.25	0.625	30	3.5	29.94	29.66	27.66	27.56	2.19
7	1	6.97	6.82	6.3	6.25	0.625	33	3.5	32.94	32.66	30.65	30.56	2.19
8	1.25	7.96	7.79	7.12	7.07	0.782	36	4	35.93	35.63	33.33	33.23	2.5

M/M MACHINE SCRE 2A Q(60°) 米厘牙(M)规格(细牙)						
规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数
		最大	最小	最大	最小	
4	0.5	3.98	3.874	3.61	3.57	0.313
4.5	0.5	4.48	4.378	4.374	4.14	0.407
5	0.5	4.98	4.874	4.61	4.57	0.313
6	0.75	5.978	5.838	5.45	5.41	0.468
7	0.75	6.978	6.838	6.45	6.41	0.468
8	1	7.974	7.794	7.29	7.24	0.625
9	1	8.974	8.794	8.29	8.24	0.625
10	1	9.974	9.784	9.28	9.23	0.625
10	1.25	9.972	9.76	9.12	9.07	0.782
12	1.25	11.972	11.76	11.12	11.07	0.782
12	1.5	11.968	11.732	10.95	10.89	0.94
14	1.5	13.968	13.732	12.95	12.89	0.94
16	1.5	15.968	15.732	14.95	14.89	0.94

M/M MACHINE SCRE 2A Q(60°) 米厘牙(M)规格(细牙)						
规格 SIZE	牙距 P	外径		辗造径		(B)牙山 海涨数
		最大	最小	最大	最小	
18	1.5	17.968	17.732	16.93	16.86	0.94
18	2	17.962	17.682	16.62	16.54	1.264
20	1.5	19.968	19.732	18.92	18.85	0.94
20	2	19.962	19.682	18.62	18.54	1.264
22	1.5	21.968	21.732	20.92	20.85	0.94
24	1.5	23.968	23.732	22.92	22.85	0.94
26	1.5	25.967	25.732	21.93	21.85	0.94
27	1.5	26.968	26.732	25.93	25.85	0.94
28	1.5	27.968	27.732	26.93	26.85	0.94
30	1.5	29.968	29.732	28.93	28.85	0.94
32	1.5	31.968	31.732	30.93	30.85	0.94
33	1.5	32.968	32.732	31.93	31.85	0.94



美制机械螺丝规格表

UNC MACHINE SCREW 2A Q(60°) 美制牙规格(粗牙)						UNC MACHINE SCREW 2A Q(60°) 美制牙规格(粗牙)							
规格 SIZE	牙 距 P	外径		辗造径		(B) 牙山 澎涨 数	规格 SIZE	牙 距 P	外径		辗造径		(B) 牙山 澎涨 数
		最大	最小	最大	最小				最大	最小	最大	最小	
No1	64	1.838	1.743	1.57	1.54	0.235	3/8	16	9.491	9.254	8.45	8.40	0.947
No2	56	2.169	2.066	1.86	1.84	0.268	7/16	14	11.076	10.816	9.89	9.83	1.086
No3	48	2.96	2.838	2.14	2.44	0.31	1/2	13	12.661	12.386	11.39	11.32	1.168
No4	40	2.824	2.695	2.4	2.36	0.38	9/16	12	14.246	13.958	12.87	12.8	1.29
No5	40	3.154	3.026	2.72	2.69	0.38	5/8	11	15.836	15.528	14.33	14.26	1.386
No6	32	3.484	3.333	2.95	2.91	0.478	3/4	10	19.004	18.677	17.34	17.27	1.535
No8	32	4.142	3.991	3.6	3.57	0.478	7/8	9	22.176	21.824	20.34	20.26	1.65
No10	24	4.8	4.618	4.09	4.05	0.64	1	8	25.349	24.969	23.28	23.2	1.919
No12	24	5.461	5.279	4.75	4.7	0.64	1 1/8	7	28.519	28.103	26.16	26.07	2.196
1/4	20	6.322	6.117	5.5	5.45	0.76	1 1/4	7	31.694	31.278	29.33	29.24	2.21
5/16	18	7.907	7.687	6.98	6.93	0.849	1 3/8	7	34.864	34.002	32.12	32.02	2.563

UNC MACHINE SCREW 2A Q(60) 美制牙规格(细牙)						UNC MACHINE SCREW 2A Q(60) 美制牙规格(细牙)							
规格 SIZE	牙 距 P	外径		辗造径		(B) 牙山 澎涨 数	规格 SIZE	牙 距 P	外径		辗造径		(B) 牙山 澎涨 数
		最大	最小	最大	最小				最大	最小	最大	最小	
No2	64	2.169	2.073	1.9	1.87	0.235	7/16	20	11.079	10.874	10.23	10.18	0.76
No3	56	2.496	2.393	2.19	2.16	0.268	1/2	20	12.666	12.462	11.82	11.76	1.76
No4	48	2.827	2.713	2.46	2.43	0.31	9/16	18	14.251	14.031	13.31	13.25	1.849
No5	44	3.157	3.036	2.76	2.73	0.351	5/8	18	15.839	15.619	14.89	14.83	0.849
No6	40	3.484	3.356	2.05	3.02	0.38	3/4	16	19.011	18.774	17.95	17.89	0.947
No8	36	4.145	4.006	3.65	3.63	0.43	7/8	14	22.184	21.923	20.98	20.91	1.086
No10	32	4.803	4.651	4.26	4.22	0.478	1	12	25.254	25.065	23.95	23.87	1.29
No12	28	5.461	5.296	4.84	4.8	0.55	1 1/8	12	28.529	28.24	27.12	27.05	1.29
1/4	28	6.324	6.16	5.72	5.68	0.55	1 1/4	12	31.704	31.415	30.29	30.21	1.29
5/16	24	7.909	7.727	7.2	7.16	0.64	1 3/8	12	34.876	34.588	33.46	33.38	1.29
3/8	24	9.497	9.315	8.76	8.74	0.64	1 1/2	12	38.051	37.763	36.63	36.55	1.29

三角牙螺丝

一、三角牙螺纹之优点

- 1、减少另外攻牙制程及其相关成本。
- 2、三角牙设计提防松滑司及粘剂之需求。
- 3、由于攻入时对母件之刚应力而产生较强之牙间紧密度。
- 4、容许较大的母件孔径变异。
- 5、可用于多种材质及各式冲、钻、铸、挤成型等之孔。
- 6、运用高周波局部渗碳热处理后，可对较厚之深孔钢质母件并保有调质热处理之强韧度。
- 7、可照样对有漆胶或焊渣之母件进行攻牙。
- 8、不会造成牙干涉。
- 9、预置扭矩总是等于或超过自锁螺丝标准。

二、三角自攻螺丝有四种类型：

- 1、S TYPE：一般机械牙、三角螺丝退出后，可符合其规格之小螺丝互换。
- 2、C TYPE：于小螺丝及C TYPE之铁板牙相同，并且可配合螺帽。
- 3、B TYPE：于B TYPE之铁板牙相同，适合使用在薄铁板及塑胶类。
- 4、P TYPE 使用在可塑性塑胶类。

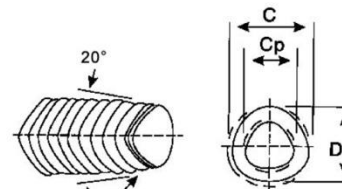
三、一般螺丝与三角螺丝使用比较：

- 1、攻牙兼锁入后牙峰膨胀至螺丝牙底密着接触不易松，并且钻孔不必钻深。
- 2、割尾之B型铁板螺丝切削兼锁入，其密着性不比(1)高，并且钻孔要深有切渣。
- 3、先攻牙后小螺丝再锁入其密着性没有，需附带弹簧垫子及螺帽。
- 4、S型三角螺丝，攻牙兼锁入牙峰，牙底密着不易松，不必配合垫子及螺帽。

四、三角螺丝用途：在电气制品、交通机具、家庭用品、精密机器、玩具塑料类及压铸零件等范围很广。

三角牙螺丝美式S型 (STYPE)

规格	牙 数	C 外切圆直径		D		Cp	辗造 径 d
		最大	最小	最大	最小		
#2	56	2.22	2.12	2.13	2.03	1.77	1.84
#3	48	2.56	2.46	2.46	2.36	2.05	2.12
#4	40	2.9	2.8	2.78	2.68	2.28	2.37
#5	40	3.23	3.13	3.11	3	2.61	2.7
#6	32	3.58	3.43	3.43	3.27	2.82	2.92
#8	32	4.24	4.09	4.09	3.93	3.47	3.58
#10	24	4.92	4.77	4.7	4.54	3.88	4.02
1/4	20	6.47	6.32	6.24	6.09	5.23	5.45

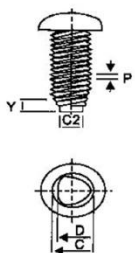


长度在2~3 1/2牙之范围



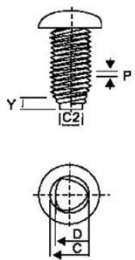
三角牙螺丝S型 (STYPE)

规格	螺距牙 / 英寸	螺丝径				先端部 (螺杆)		尾部长度		辗造径	
		Cmm		Dmm		C2mm		最大	最小	C1	D1
		最大	最小	最大	最小	最大	最小				
2	0.4	2.04	1.96	1.96	1.88	1.58	1.44	1.8	1.4	1.75	1.67
2.3	0.4	2.34	2.26	2.26	2.18	1.82	1.68	1.8	1.4	2.04	1.96
2.5	0.45	2.55	2.47	2.46	2.38	1.96	1.79	2.1	1.5	2.22	2.13
2.6	0.45	2.57	2.65	2.56	2.48	2.05	1.88	2.1	1.5	2.32	2.24
3	0.5	3.05	2.97	2.95	2.87	2.44	2.24	2.3	1.7	2.69	2.59
3.5	0.6	3.56	3.48	3.44	3.36	2.83	2.63	2.7	2.1	3.13	3.01
4	0.7	4.07	3.99	3.93	3.85	3.27	3.07	3.2	2.4	3.56	3.42
5	0.8	5.08	5	4.92	4.84	4.17	3.87	3.6	2.8	4.52	4.36

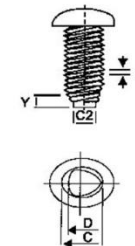


三角牙螺丝 C型 (STYPE)

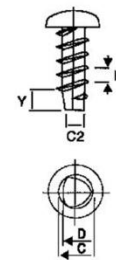
规格	螺距牙 / 英寸	螺丝径				先端部 (螺杆)		尾部长度		辗造径	
		C mm		D mm		C2 mm		最大	最小	C1	D1
		最大	最小	最大	最小	最大	最小				
2	0.4	1.98	1.89	1.9	1.81	1.52	1.38	1.8	1.4	1.68	1.6
2.3	0.4	2.28	2.19	2.2	2.11	1.76	1.62	1.8	1.4	1.98	1.9
2.5	0.45	2.48	2.38	2.39	2.29	1.88	1.71	2.1	1.5	2.14	2.05
2.6	0.45	2.58	2.48	2.49	2.39	1.98	1.81	2.1	1.5	2.24	2.15
3	0.5	2.98	2.87	2.88	2.77	2.37	2.17	2.3	1.7	2.61	2.51
3.5	0.6	3.47	3.36	3.35	3.24	2.76	2.56	2.7	2.1	3.03	2.93
4	0.7	3.97	3.84	3.83	3.7	3.17	2.91	3.2	2.4	3.46	3.32
5	0.8	4.97	4.84	4.81	4.68	4.06	3.76	3.6	2.8	4.38	4.22



规格	螺距牙 / 英寸	螺丝径				先端部 (螺杆)		尾部长度		辗造径	
		C mm		D mm		C2 mm		最大	最小	C1	D1
		最大	最小	最大	最小	最大	最小				
2	40	2.04	1.96	1.96	1.88	1.46	1.26	1.6	1.2	1.67	1.59
2.3	32	2.34	2.26	2.26	2.18	1.76	1.56	2	1.5	1.89	1.81
2.6	28	2.64	2.56	2.55	2.47	1.94	1.74	2.3	1.8	2.16	2.07
3	24	3.05	2.95	2.95	2.85	2.25	2.05	2.7	2.1	2.47	2.37
3.5	20	3.55	3.45	3.46	3.34	2.65	2.45	3.2	2.5	2.9	2.78
4	18	4.05	3.95	3.91	3.81	3	2.8	3.6	2.8	3.28	3.14
5	16	5.06	4.94	4.9	4.79	3.74	3.44	4	3.1	4.16	4



规格	螺距牙 / 英寸	螺丝径				先端部 (螺杆)		尾部长度		辗造径	
		C mm		D mm		C2 mm		最大	最小	C1	D1
		最大	最小	最大	最小	最大	最小				
2	32	2.12	2.02	2.04	1.94	1.54	1.34	2	1.6	1.67	1.52
2.3	28	2.43	2.33	2.35	2.25	1.84	1.64	2.3	1.8	1.87	1.79
2.5	24	2.63	2.53	2.54	2.44	1.94	1.74	2.5	2	1.99	1.9
2.6	24	2.73	2.63	2.64	2.54	2.04	1.84	2.5	2	2.12	2.04
3	20	3.15	3.03	3.05	2.93	2.35	2.15	3.3	2.6	2.43	2.33
3.5	18	3.66	3.54	3.57	3.45	2.7	2.5	3.5	2.8	2.87	2.75
4	16	4.16	4.04	4.02	3.9	3.1	2.9	4	3.2	3.23	3.1
5	14	5.19	5.05	5.03	4.59	3.76	3.46	4.5	3.6	4.03	3.87



防松螺丝

Enterprise culture

Looking forward to furture

Each ending is a new beginning.

The ideal in front, we walk quickly

