DIN 22568 Round Split Dies and Die Stocks Specification

DIN 22568 specifies the dimensions and tolerances for round split dies and die stocks. The full dimensional table is reproduced below, followed by the DIN, ISO and ASME parts that match or supersede it.

Standard

DIN 22568

Product

Round Split Dies and Die Stocks

Governing standards

DIN 22568 / DIN EN 22568 (round split dies)

Equivalence between national standards is dimensional, not always metallurgical. Check the property class separately when substituting.



For round split dies and die stocks, DIN 22568 is the governing document for the dimensions listed below. Mechanical and performance requirements for this part family are set by its own standards, not by the bolt and screw property-class documents.

DIN 22568 — Scope

The table below lists the dimensions catalogued for round split dies and die stocks under DIN 22568. The scope of DIN 22568 itself is not summarised here — where a figure matters, confirm it against the published document.

Tolerance & Product Grades

Product grade is a concept from dimensional fastener standards and does not apply to DIN 22568. Tolerances for this part are the limits shown against each dimension in the table.

Dimensions Specified by DIN 22568

Die outside diameter	Thread range typically held	Adjustment	Held in
16 mm	M1 – M2.5	split, three-screw adjustment	16 mm die
20 mm	M3 – M5	split, three-screw adjustment	20 mm die
25 mm	M6 – M8	split, three-screw adjustment	25 mm die
30 mm	M9 – M12	split, three-screw adjustment	30 mm die
38 mm	M14 – M20	split, three-screw adjustment	38 mm die
45 mm	M22 – M24	split, three-screw adjustment	45 mm die

Equivalent Standards

Where direct equivalents exist (ISO ↔ DIN, ISO ↔ ASME), they are listed on the parent Round Split Dies and Die Stocks page.

> *Always confirm against the dimensions on this page, since some "equivalent" standards differ in tolerances and head geometry.*

When to Specify DIN 22568

DIN 22568 is still widely used in European mechanical engineering and as a cross-reference on legacy drawings; its ISO equivalent is preferred for new designs.

Custom manufacturing · Made to drawing

Need a fastener tool to this standard in a non-standard size?

Parts built to DIN 22568 are already in the catalog, so a special is usually a variation on existing tooling rather than a new design — which is what keeps the cost down.

Minimum order from 2,000 pieces; samples within 7 days of drawing approval.

Custom fastener tool manufacturing (https://engineeringhardware.com/custom/tools/)

Send a drawing (https://engineeringhardware.com/custom/tools/#rfq)

Technical Drawing

Customize the parameters below — every spec field is editable, and the drawing redraws to match the values you choose. Changing the size will snap the other fields to that size's standard values; you can then override any individual value.

Dimensioned line drawing of 16 mm Round Split Dies and Die Stocks to DIN 22568 / DIN EN 22568 (round split dies). Side view and top view, drawn to the dimensions in the table below and redrawn for any size selected.

Sends the selected values to the quote form below.

Request a Quote

The form below follows the current technical drawing configuration. Change the drawing values above and the request details update automatically.

Dimensions & Specifications (DIN 22568 / DIN EN 22568 (round split dies))

Die outside diameter	Thread range typically held	Adjustment	Held in
16 mm	M1 – M2.5	split, three-screw adjustment	16 mm die
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38 mm	M14 – M20	split, three-screw adjustment	38 mm die
45 mm	M22 – M24	split, three-screw adjustment	45 mm die

Product catalog

Related Taps & Dies products



(https://engineeringhardware.com/product/1m-2m-3m-factory-price-stainless-steel-high-precision-threaded-end-stud-bolts/)

Double-End & Tap-End Studs

1m 2m 3m Factory Price Stainless Steel High Precision Threaded End Stud Bolts (https://engineeringhardware.com/product/1m-2m-3m-factory-price-stainless-steel-high-precision-threaded-end-stud-bolts/)

Stud Bolt · DIN, ANSI, GB

US$1.06 – 1.79 MOQ 1,000 pieces



(https://engineeringhardware.com/product/hot-sale-grade-10-9-actrosss-truck-rear-wheel-hub-stud-bolts/)

Double-End & Tap-End Studs

Hot Sale Grade 10.9 Actrosss Truck Rear Wheel/Hub/Stud Bolts

(https://engineeringhardware.com/product/hot-sale-grade-10-9-actrosss-truck-rear-

wheel-hub-stud-bolts/)

Square Head · DIN, ANSI, GB

US$1.08 – 1.56MOQ 1,000 pieces



(https://engineeringhardware.com/product/din-975-din-976-stainless-all-thread-rod-continuous-threaded-stud-bolt/)

Double-End & Tap-End Studs

DIN 975 DIN 976 Stainless All Thread Rod Continuous Threaded Stud Bolt (https://engineeringhardware.com/product/din-975-din-976-stainless-all-thread-rod-continuous-threaded-stud-bolt/)(https://engineeringhardware.com/product/din-975-din-976-stainless-all-thread-rod-continuous-threaded-stud-bolt/)

Stainless Steel · A2 A4

US$0.024 – 0.60 MOQ 100 pieces



(https://engineeringhardware.com/product/special-material-monel-stainless-steel-ss304-316-b400-b446-32760-din975-din976-stud/)

(https://engineeringhardware.com/product/special-material-monel-stainless-steel-ss304-316-b400-b446-32760-din975-din976-stud/)

Double-End & Tap-End Studs

Special Material Monel Stainless Steel SS304 316 B400/B446/32760 DIN975 DIN976 Stud Bolt Thread Rod
(https://engineeringhardware.com/product/special-material-monel-stainless-steel-ss304-316-b400-b446-32760-din975-din976-stud/)
(https://engineeringhardware.com/product/special-material-monel-stainless-steel-ss304-316-b400-b446-32760-din975-din976-stud/)

Stainless Steel · B

US$0.14 – 0.18 MOQ 1,000 pieces



(https://engineeringhardware.com/product/1-4-m6-wc-seat-cover-toilet-accessories-nylon-nut-fitting-toilet-seat-fixing-screw/)

Double-End & Tap-End Studs

1/4 M6 Wc Seat Cover Toilet Accessories Nylon Nut Fitting Toilet Seat Fixing Screw Bolt (https://engineeringhardware.com/product/1-4-m6-wc-seat-cover-toilet-accessories-nylon-nut-fitting-toilet-seat-fixing-screw/)

Double End Stud · DIN

US$0.24 – 0.96MOQ 2,000 sets



(https://engineeringhardware.com/product/oem-precision-nuts-and-bolts-lathe-bolt-stainless-steel-stud-bolt-and-nut-with/)

Double-End & Tap-End Studs

OEM Precision Nuts and Bolts Lathe Bolt Stainless Steel Stud Bolt and Nut with Tensile Strength (https://engineeringhardware.com/product/oem-

precision-nuts-and-bolts-lathe-bolt-stainless-steel-stud-bolt-and-nut-with/)

Round Head · DIN, ANSI, GB, JIS

US$0.60 – 12.00 MOQ 1,000 pieces

View all Double-End & Tap-End Studs → (https://engineeringhardware.com/fastener-products/threaded-rods-studs/double-end-tap-end-studs/)

Full product catalog (https://engineeringhardware.com/products/)

Materials & Grades

Select a material class to see the grades we supply it in. Each designation is listed with its ISO/EN, AISI/SAE, JIS and GB equivalents.

Stainless Steel

Carbon Steel 66

Alloy Steel 41

Bearing Steel 5

Spring Steel 25

Aluminum and Aluminum Alloys 21

Brass 17

Bronze 11

Copper 8

Titanium and Titanium Alloys 18

Nickel and Nickel Alloys 22

Iron-Nickel and High-Temperature Alloys 10

Tool Steel and Specialty Hardened Steel 9

Structural and Construction Steel 9

Stainless Steel

Austenitic Stainless Steel

A1
AISI 303 · SAE 303 · SUS303 · EN 1.4305 · X8CrNiS18-9

A2
AISI 304 · SAE 304 · SUS304 · EN 1.4301 · X5CrNi18-10 · 06Cr19Ni10

304L
AISI 304L · SUS304L · EN 1.4307 · X2CrNi18-9 · 022Cr19Ni10

302
AISI 302 · SUS302 · EN 1.4310

305
AISI 305 · SUS305 · EN 1.4303

A4
AISI 316 · SAE 316 · SUS316 · EN 1.4401 · X5CrNiMo17-12-2 · 06Cr17Ni12Mo2

316L
AISI 316L · SUS316L · EN 1.4404 · X2CrNiMo17-12-2 · 022Cr17Ni12Mo2

321
AISI 321 · SUS321 · EN 1.4541 · X6CrNiTi18-10

310 / 310S
AISI 310 · AISI 310S · SUS310S · EN 1.4845

302HQ
AISI 302HQ

A3

A5

347
AISI 347 · SUS347 · EN 1.4550 · X6CrNiNb18-10

309 / 309S
AISI 309 · AISI 309S · SUS309S

Martensitic Stainless Steel

AISI 410
SUS410 · EN 1.4006 · X12Cr13 · 12Cr13

AISI 420
SUS420J1 · SUS420J2 · EN 1.4021 · EN 1.4028 · 20Cr13 · 30Cr13

AISI 431
SUS431 · EN 1.4057 · X17CrNi16-2

C1

C3

C4

AISI 440A

AISI 440B

AISI 440C
SUS440C · EN 1.4125

Ferritic Stainless Steel

AISI 430
SUS430 · EN 1.4016 · X6Cr17 · 10Cr17

F1

AISI 434

AISI 444

Precipitation-Hardening Stainless Steel

17-4 PH
AISI 630 · UNS S17400 · SUS630 · EN 1.4542 · X5CrNiCuNb16-4

15-5 PH
UNS S15500

17-7 PH
UNS S17700

Duplex and Super Duplex Stainless Steel

Duplex 2205
UNS S31803 · UNS S32205 · EN 1.4462

Super Duplex 2507
UNS S32750 · EN 1.4410

D2

D4

D6

D8

Lean Duplex 2101
UNS S32101

Super Duplex S32760
UNS S32760 · EN 1.4501

Carbon Steel

Low-Carbon Steel

- SAE 1006
- SAE 1008
- SAE 1010
- SAE 1018
- SAE 1020
- Q195
- Q235
- SAE 1012
- SAE 1015
- Q215
- ML08
- ML08Al
- ML10
- ML15
- ML20
- SWRCH6A
- SWRCH8A
- SWRCH10A
- SWRCH12A
- SWRCH15A
- SWRCH18A

Medium-Carbon Steel

- SAE 1035

SAE 1045
S45C
C45
SAE 1030
SAE 1040
SAE 1050
30
35
40
45
50
S35C
S40C
S50C
C35
C40

High-Carbon Steel

SAE 1060
SAE 1070
65Mn
SAE 1065
SAE 1075
SAE 1080
SAE 1085
SAE 1090
SAE 1095
60

65
70
75
80
85

Cold-Heading Steel

SWRCH22A
10B21
SWRCH22K
SWRCH25K
SWRCH30K
SWRCH35K
SWRCH40K
ML20Mn
ML25
ML30
ML35
ML40
15B25

Alloy Steel

Chromium Steel

40Cr
45Cr
AISI 5140

SAE 5140
AISI 5120
SAE 5120
SCr420
SCr440

Chromium-Molybdenum Steel

35CrMo
42CrMo
AISI 4140
SCM435
SCM440
42CrMo4
30CrMo
AISI 4130
SAE 4130
SAE 4140
AISI 4142
AISI 4145
SCM415
SCM420
SCM445
EN 1.7220
EN 1.7225
25CrMo4
34CrMo4

Nickel-Chromium-Molybdenum Steel

- **AISI 4340**
- **SAE 4340**
- **40CrNiMo**
- **SNCM439**
- **EN 1.6511**
- **36CrNiMo4**

Boron Alloy Steel

- **10B22**
- **10B21**
- **15B21**
- **15B25**
- **20MnTiB**
- **20Mn2B**
- **35VB**
- **40MnB**

Bearing Steel

Bearing Steel

- **GCr15**
- **AISI 52100**
  SAE 52100 · UNS G52986
- **SUJ2**
- **100Cr6**
  EN 1.3505
- **GCr15SiMn**

Spring Steel

Carbon Spring Steel

- SAE 1065
- SAE 1070
- SAE 1075
- SAE 1080
- SAE 1095
- 65
- 70
- 75
- 80
- 65Mn

Silicon-Manganese Spring Steel

- 60Si2Mn
- 60Si2MnA
- SUP6
- SUP7

Chromium-Vanadium Spring Steel

- 50CrVA
- SAE 6150
- AISI 6150
- SUP10

Stainless Spring Steel

- AISI 301

SUS301
EN 1.4310
AISI 302
AISI 304
AISI 316
17-7 PH

Aluminum and Aluminum Alloys

Commercially Pure Aluminum

1050
1060
1070
1100

2xxx Series Aluminum

2024
2011
2014
2017

5xxx Series Aluminum

5052
5083
5754

6xxx Series Aluminum

6061

6061-T6
6063
6082
6082-T6

7xxx Series Aluminum

7075
7075-T6
7005
7050
7075-T73

Brass

Free-Cutting Brass

C36000
H62
HPb59-1
C3601
C3602
C3604
CuZn36Pb3
CuZn39Pb3
EN CW614N
EN CW617N
H65

Lead-Free Brass

- **C69300**
- **C27450**
- **CW510L**
- **CW511L**

Naval Brass

- **C46400**
- **CuZn39Sn1**

Bronze

Silicon Bronze

- **C65500**
- **C65100**
- **C65600**

Phosphor Bronze

- **C51000**
- **C52100**
- **CuSn6**
- **CuSn8**

Aluminum Bronze

- **C95400**
- **C95500**
- **C63000**

CuAl10Ni5Fe4

Copper

Copper

C11000
T2
C10100
C10200
C12200
T1
TU1
TU2

Titanium and Titanium Alloys

Commercially Pure Titanium

Grade 2
Grade 1
Grade 3
Grade 4
TA1
TA2
TA3

Alpha-Beta Titanium Alloys

Grade 5

Ti-6Al-4V

TC4

UNS R56400

Low-Interstitial Grade

Grade 23

Ti-6Al-4V ELI

UNS R56407

Other Titanium Fastener Alloys

Ti-6Al-6V-2Sn

Ti-6Al-2Sn-4Zr-2Mo

Beta-C titanium

Ti-10V-2Fe-3Al

Nickel and Nickel Alloys

Commercially Pure Nickel

Nickel 200

UNS N02200

Nickel 201

UNS N02201

Inconel Alloys

Inconel 625
UNS N06625

Inconel 718
UNS N07718

Inconel 600
UNS N06600

Inconel 601
UNS N06601

Inconel 686
UNS N06686

Inconel X-750
UNS N07750

Monel Alloys

Monel 400
UNS N04400

Monel K-500
UNS N05500

Hastelloy Alloys

Hastelloy C-276
UNS N10276

Hastelloy C-22
UNS N06022

Hastelloy B-2
UNS N10665

Hastelloy B-3
UNS N10675

Hastelloy X
UNS N06002

Other Nickel Alloys

Alloy 20
UNS N08020

Alloy 625

Alloy 718

Alloy 825
UNS N08825

Alloy 925
UNS N09925

Iron-Nickel and High-Temperature Alloys

A286

A-286

UNS S66286

EN 1.4980

Invar

Invar 36

Alloy 36

UNS K93600

FeNi36

Alloy 42

Alloy 42

UNS K94100

FeNi42

Tool Steel and Specialty Hardened Steel

Tool Steel and Specialty Hardened Steel

AISI D2

AISI H13

SKD11
Cr12MoV
AISI O1
AISI A2
AISI S7
SKD61
9CrSi

Structural and Construction Steel

Structural and Construction Steel
ASTM A36
Q235B
Q355B
S355JR
Q235C
Q355C
S235JR
S275JR
S355J2

Applications & Industries

The sectors that buy Round Split Dies and Die Stocks to DIN 22568 / DIN EN 22568 (round split dies), and the duty each one buys them for. Stocked from 16 mm to 45 mm (nominal size).

Industries that specify Round Split Dies and Die Stocks

Fabrication **Threading rod on site.**

Toolroom **Short-run external threads.**

Vehicle restoration **Obsolete thread sizes.**

Maintenance **Cleaning up a damaged thread.**

Assembly & maintenance **Installing and servicing the fasteners in this catalog.**

Typical applications

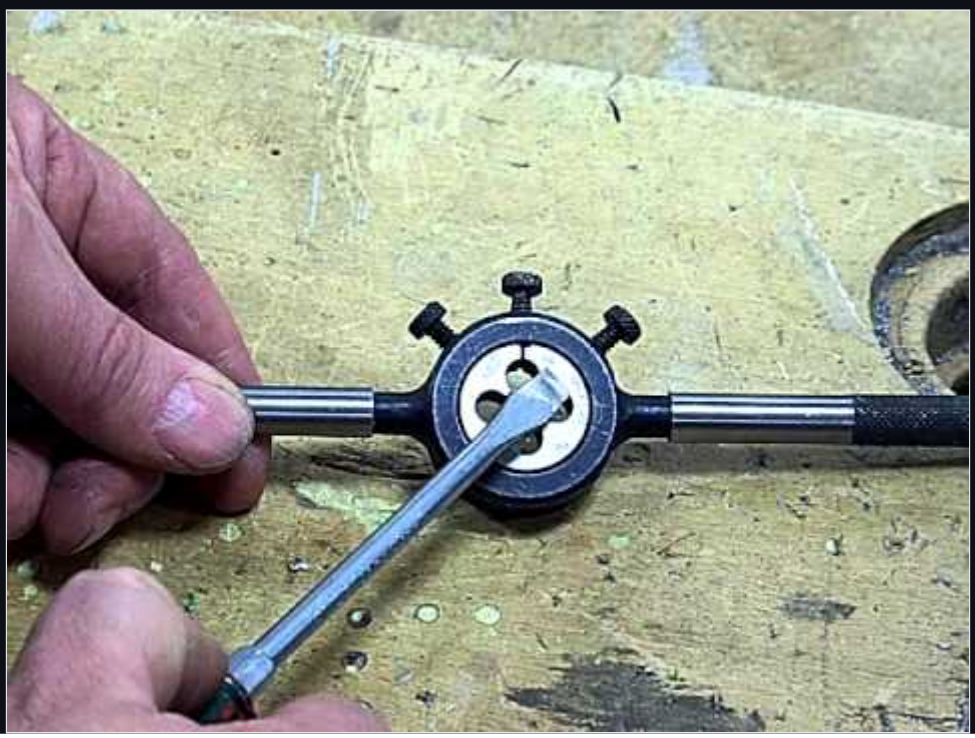
- **chamfering the rod end before starting**
- **checking the result with a ring gauge or the mating nut**
- **using cutting fluid throughout**
- **opening the die for a first pass and closing it to finish**
- **driving and releasing fasteners on the bench and in the field**

Where to use something else

- **Do not cut a full-depth thread in one pass with the die closed; it loads the die hard and produces a torn thread surface.**

Full application guide: where Round Split Dies and Die Stocks are used, how to specify them, and the cases they are wrong for (https://engineeringhardware.com/applications/round-split-dies/)

Video: DIN 22568 Round Split Dies and Die Stocks Specification



(https://www.youtube.com/watch?v=mknpJ9OLFyk)

► Watch video: https://www.youtube.com/watch?v=mknpJ9OLFyk (https://www.youtube.com/watch?v=mknpJ9OLFyk)

4 Split die and die holder (https://www.youtube.com/watch?v=mknpJ9OLFyk)

Third-party video, selected automatically for this topic. It is not produced by Engineering Hardware and is not a specification source — use the tables on this page for dimensional data.

Inside the plant

Manufactured in our own plant

This part is cold-formed, threaded, heat-treated and finished in-house. The stages below are where its class and finish are actually decided.



01

Cold heading

Wire rod is drawn to size and cold-formed into blanks. Forming rather than cutting keeps the grain flow continuous around the head, which is where a bolt is most likely to fail.

Head dimensions and under-head radius checked at set-up and per shift.



02

Thread rolling

Threads are rolled between hardened dies rather than cut. Rolled threads are stronger in fatigue than cut threads and hold pitch and flank angle far more consistently across a batch.

Go / no-go ring gauges to ISO 965 tolerance class 6g.



03

Heat treatment

Quench-and-temper brings carbon and alloy steel to the property class ordered — 8.8, 10.9 or 12.9 — with the furnace charge tracked so a finished lot can be traced back to it.

Core hardness and tensile tested per lot to ISO 898-1.



04

Surface treatment

Zinc, zinc-nickel, hot-dip galvanizing, black oxide, phosphate and Dacromet, selected against the service environment rather than against the price list.

Coating thickness and neutral salt spray hours to ISO 9227.

Frequently Asked Questions

Can I substitute DIN 22568 for the corresponding DIN standard on a drawing?

On modern drawings the ISO standard is the master reference; the older DIN equivalent is a cross-reference. For most dimensional purposes the parts are interchangeable, but check tolerance grades and the head height — these are the most common points of divergence.

Which edition of DIN 22568 does this table follow?

The table reproduces the dimensions we supply round split dies and die stocks to. We do not publish an edition year against it, so where the edition is contractually significant, cite the edition you require on the enquiry and we will confirm it against the table before quoting.

How do I request a quotation?

Use the technical drawing on this page to pick the exact configuration, then submit it with the quote form. We respond within one business day.

Related Pages

View the full Round Split Dies and Die Stocks page (https://engineeringhardware.com/fastener/round-split-dies/)

More Round Split Dies and Die Stocks Guides

- **EN 22568 Round Split Dies and Die Stocks (https://engineeringhardware.com/guide/standard/en-22568-round-split-dies/)**