

DA SS

The optimal choice for high quality external-threading applications.
Helps correct feed errors and misalignment during threading.

Die attachments for
dedicated solid die
tooling machining centers

DA SS

JIS

- **New design for improved chip evacuation.**
- **"Chip evacuation hole", "Internal lubrication coolant hole"**
- **Optimal shank design for NC tooling.**



Product features

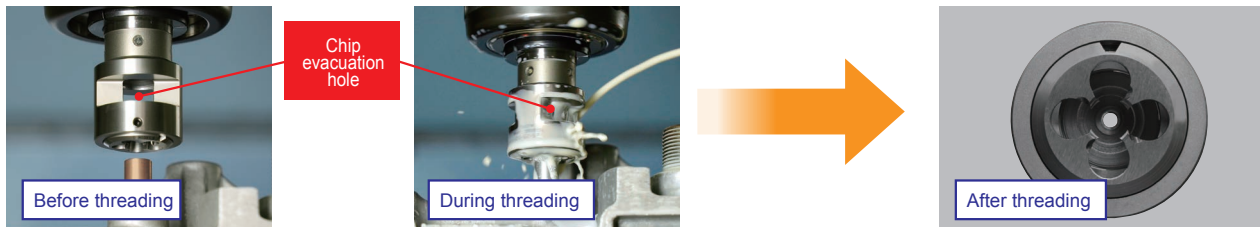
Die attachments for machining centers **DASS**



- Special tooling for solid dies with functions to correct feed errors and absorb misalignment.
- When used with NC tooling , you can easily thread complex workpieces.
- The chip discharge hole eliminates chip residue and ensures stable, continuous machining.
- Standardized coolant hole supports internal lubrication while threading.



•The chip evacuation hole eliminates chip residue and ensures stable and continuous machining. It can also be used with external lubrication equipment.



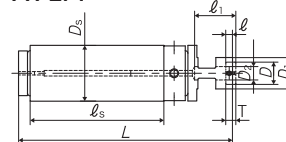
○Machining conditions(synchronous feed)

Size	M8×1.25	Machining speed	5m/min	Machine used	Vertical machining center
Workpiece material	Free cutting brass	Threading length	16mm	Cutting fluid	Water soluble cutting fluid

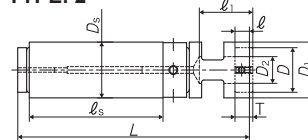
Shape and dimensions

Product code	D _s (mm)	D ₁ (mm)	D ₂ (mm)	L (mm)	ℓ _s (mm)	ℓ (mm)	ℓ ₁ (mm)	D (mm)	T (mm)	TYPE	MSRP (JPY)
DASS201060	20	14	6	96	60	3	16	10	3	1	40,100 □
DASS201660		20	10	96		4.5	16	16	5	2	40,100 □
DASS202060		25	12	103		6.5	22.5	20	7	3	45,500 □
DASS252060	25	25	12	104	70	6.5	22.5	20	7	2	47,400 □
DASS252560		32	16	104		7.5	22	25	9	3	47,400 □
DASS323870	32	50	26	132	70	11	36	38	13	3	58,700 □

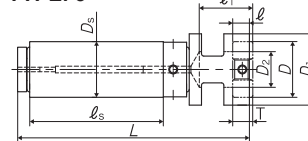
TYPE: 1



TYPE: 2



TYPE: 3



Coolant hole



The cutting fluid passes through a coolant hole in the center of the die attachment to promote chip evacuation, lubrication, and cooling.

○Dies application table

□=Manufacturer inventory

Product code	D (mm)	Metric	Unified
DASS201060	10	M1~M2.6	—
DASS201660	16	M1~M4	№0~№3
DASS202060	20	M1~M9	№0~U 1/4
DASS252060	20	M1~M9	U 1/4~U 3/8
DASS252560	25	M2~M10	U 1/4~U 3/8
DASS323870	38	M4~M16	U 5/16~U 5/8

*The above table is for reference only. For detailed sizes, please check the various die dimensions in the catalog.

Warning

- ◆Tools may shatter during use. Wear safety eye cover or eye glasses to avoid injury during tapping.
- ◆Use tools under the proper tapping condition.
- ◆Never wear gloves during turning operations as the gloves may get caught in the tools.
- ◆Wear safety shoes to avoid foot injury by the falling tools.
- ◆When attaching tools to the machine, fasten firmly to avoid chatter and run-out.
- ◆Fasten the workpiece firmly so it never moves during the tapping operation. Never use worn tools or damaged tools.
- ◆Take a special care to prevent fire during machining. High temperature during tapping can cause a fire.

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