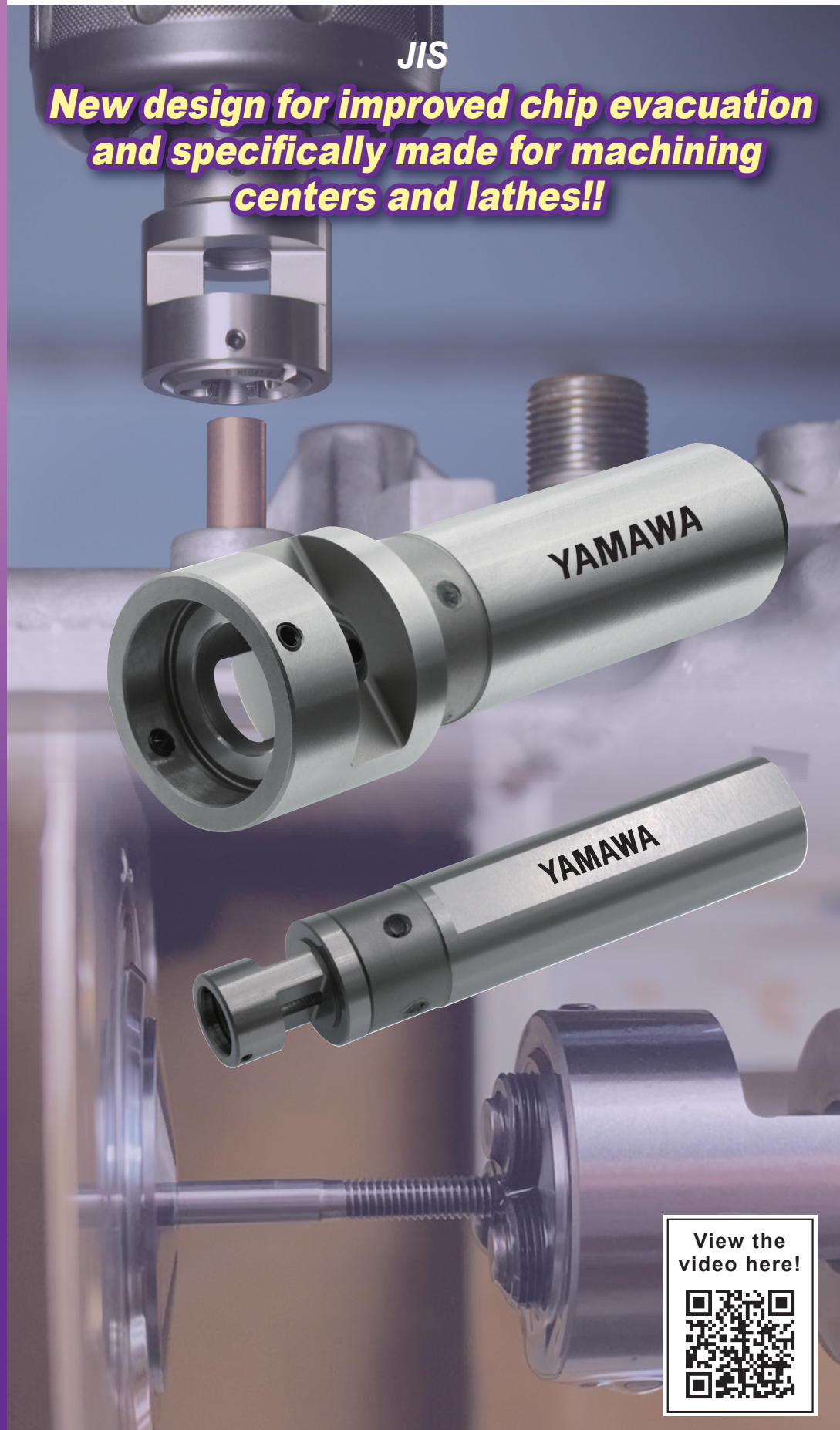


DA SS / DA SL

Die attachment for
machining centers
Die attachment for
lathes

The best die holder for machining high quality external screw threads!!

DA SS / DA SL



***New design for improved chip evacuation
and specifically made for machining
centers and lathes!!***

View the
video here!



Product features

Die attachment for machining centers

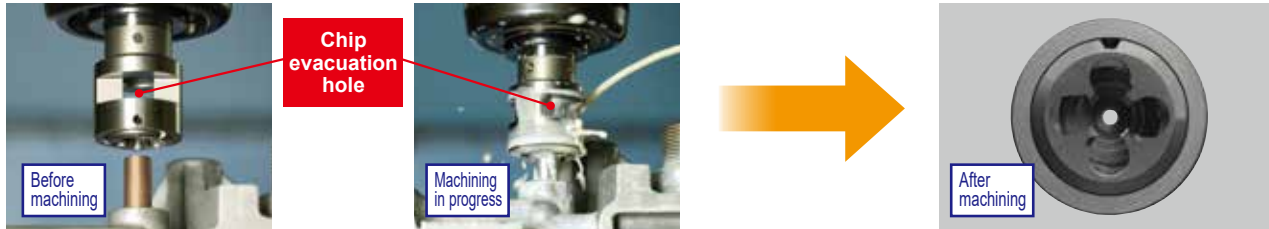
DA SS

Alloy steel



- Equipped with a mechanism to compensate feed error and absorb center misalignment.
- When used with NC tooling, you can easily create threads on complex workpieces.
- The chip evacuation hole eliminates any remaining chips and allows for stable continuous machining.
- Standard coolant through body.

• The chip evacuation hole eliminates any remaining chips and allows for stable continuous machining. It can also be used with external lubrication.

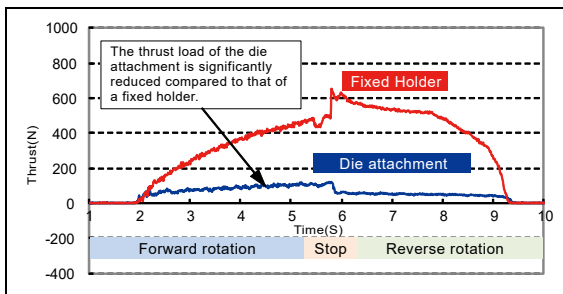


No chips left

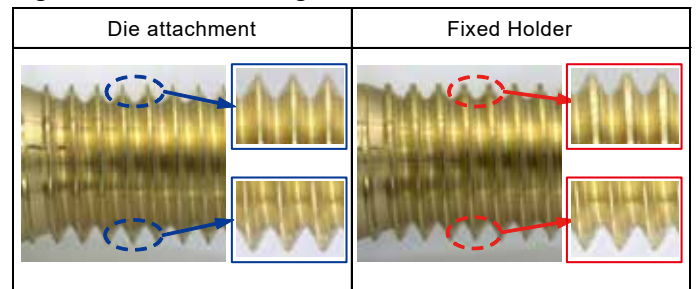
◎ Machining conditions [Synchronous feed]

Size	M8×1.25	Machining Speed	5m/min	Machine	Vertical Machining Center
Workpiece Material	Free-cutting brass (Brass)	Threading Length	16mm	Machining Oil	Water-soluble cutting fluid

• Feed error correction function reduces axial thrust load and improves tool life.



• Automatic alignment absorbs radial misalignment and allows for highly accurate external thread machining with good flank surface roughness.



◎ Machining conditions [Synchronous feed]

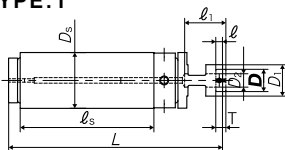
Size	M10×1.5	Threading Length	15mm
Workpiece Material	Free-cutting brass (Brass)	Machine	Vertical Machining Center
Machining Speed	5m/min	Machining Oil	Tapping spray

◎ Machining conditions [Synchronous feed]

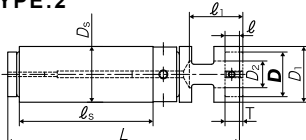
Size	M8×1.25	Threading Length	12mm
Workpiece Material	Free-cutting brass (Brass)	Machine	Vertical Machining Center
Machining Speed	5m/min	Machining Oil	Water-soluble cutting fluid

Dimensions and Sizes

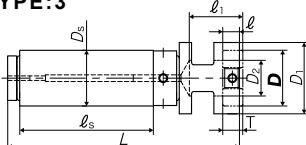
TYPE:1



TYPE:2



TYPE:3



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	11	36	38	13	3

□=Manufacturer Stock

◎ Dies application table

Code	D (mm)	Metric Threads	Unified Threads
DASS201060	10	M1~M2.6	-
DASS201660	16	M1~M4	№0~№2
DASS202060	20	M1~M9	№0~U1/4
DASS252060	20	M1~M9	№0~U1/4
DASS252560	25	M2~M10	U1/4~U3/8
DASS323870	38	M4~M16	U5/16~U5/8

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

Product features

Die attachment for lathes

DA SL Alloy steel

- Allows for the use of not only Solid Round Dies, but also Rolling Dies which are often used in lathe machining.
- The chip evacuation hole eliminates any remaining chips and allows for stable continuous machining.
- One-sided notch design for easy setup.
- Equipped with a tension spring for stable machining. Set the feed at 90 to 95% of the pitch.



- Spiral Pointed HSS Round Dies DPO's improved chip evacuation allows for stable continuous machining!



◎ Example of machining conditions [Asynchronous feed: 90% of thread pitch]

Size	M6×1	Machining Speed	2m/min Work rotation	Machine	Automatic Horizontal Lathe
Workpiece Material	S45C	Threading Length	10mm	Machining Oil	Non water-soluble cutting oil

- High quality threads machined using Rolling Dies RS-D

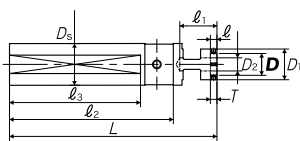


◎ Example of machining conditions [Asynchronous feed: 90% of thread pitch]

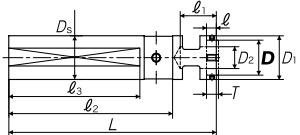
Size	M3×0.5	Machining Speed	3m/min Work rotation	Machine	Automatic Horizontal Lathe
Workpiece Material	SUS303	Threading Length	10mm	Machining Oil	Non water-soluble cutting oil

Dimensions and Sizes

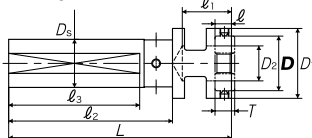
TYPE:1



TYPE:2





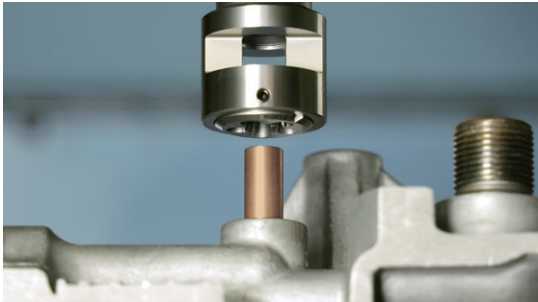
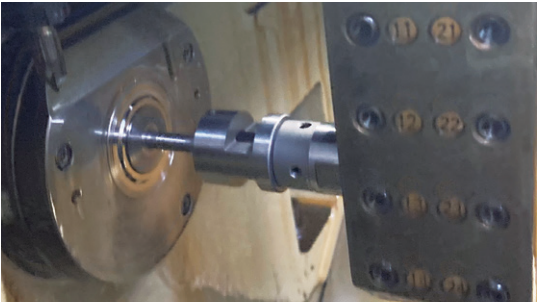






TYPE:3



Code	D_s (mm)	D_1 (mm)	D_2 (mm)	L (mm)	l (mm)	l_1 (mm)	l_2 (mm)	l_3 (mm)	D (mm)	T (mm)	TYPE	MSRP (JPY)
DASL191075	19.05	14	6	95	3	16	75	60	10	3	1	40,100 □
DASL191675		20	10	95	4.5	16			16	5	2	40,100 □
DASL192075		25	12	102	6.5	22.5			20	7	3	45,500 □
DASL201075	20	14	6	95	3	16			10	3	1	40,100 □
DASL201675		20	10	95	4.5	16			16	5	2	40,100 □
DASL202075		25	12	102	6.5	22.5			20	7	3	45,500 □
DASL221075	22	14	6	95	3	16			10	3	1	40,100 □
DASL221675		22	10	95	4.5	16			16	5	2	40,100 □
DASL222075		25	12	102	6.5	22.5			20	7	3	47,400 □
DASL222575		32	16	102	7.5	22			25	9	3	47,400 □
DASL252075	25	25	12	102	6.5	22.5			20	7	2	47,400 □
DASL252575		32	16	102	7.5	22			25	9	3	47,400 □
DASL3238105	32	50	26	147	11	36	105	88	38	13	3	58,700 □

□=Manufacturer Stock

Primary usage

Product name	DA SS Die attachment for machining centers	DA SL Die attachment for lathes
Product		
Features	<ul style="list-style-type: none"> •Mechanism to compensate feed error and absorb center misalignment. •Coolant hole •Chip evacuation hole 	<ul style="list-style-type: none"> •Tension spring •One-sided notch for side lock •Chip evacuation hole •TYPE1 and TYPE2 have a slim head design and can be installed from the front or back side of the sleeve.
Shank	<p>Compatible with NC tooling</p> 	<p>Compatible with lathe turret sleeve</p> 
Feed rate	Synchronous machining	Set the feed at 90 to 95% of the pitch
Usage advice	This special die holder compensates for feed errors and absorbs misalignment. Please be sure to use it with synchronous feed.	It is designed with a tension spring for stable machining, so set the feed to 90-95% of the thread pitch, and factor in the tension spring when setting the machining length.
Recommended Solid Round Dies	 D  DPO	 SP-D  HS-D
Recommended Rolling Dies	—	 N-RSD  MS-RS-D/RS-D

Warning

- ◆Tools may shatter. Wear cover or eye glasses to avoid injury during tapping.
- ◆Tools may shatter. Use tools under the proper tapping condition.
- ◆Never wear gloves during turning operations as the gloves may get caught with the tools.
- ◆Wear safety shoes to avoid injuring yourself by the falling tools.
- ◆On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ◆Fasten the work pieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆Take a special care to fire trouble. High temperature during machining may cause fire.

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YAMAWA group for Overseas

YAMAWA International Co., Ltd.



ISO 9001
JQA-QMA14664



ISO 14001
JQA-EM3465



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