

RD-DA

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High precision thread cutting of external threads becomes possible with ease!!



Features

Die attachment (Designed for Solid Dies)

RD-DA

Alloy steel

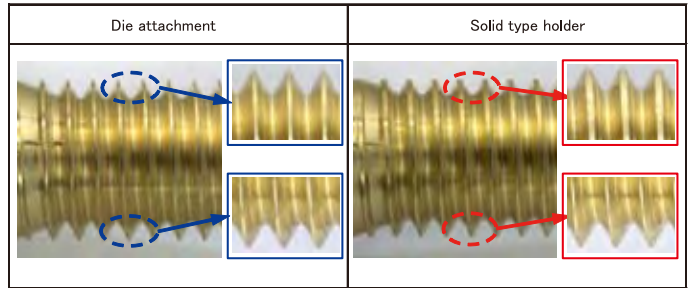
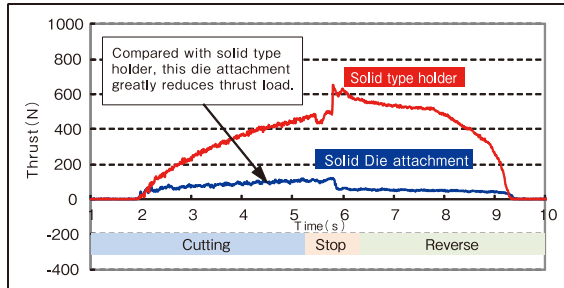
Synchro nized



- Tooling designed for Solid Dies, with a mechanism to compensate for feed error and to absorb misalignment.
- Combined with CNC tooling, this attachment enables the cutting of external thread on complex workpieces with ease.

● With a mechanism to compensate for feed error, the thrust in the axial direction decreases and results in longer tool life

● By automatic centering, RD-DA absorbs misalignment in radial the direction and realizes the high precision thread cutting of external threads.



◎Cutting condition (Rigid feed)

Tool size	M10×1.5	Thread length	15mm
Material	Brass	Machine	Vertical MC
Cutting speed	5m/min	Cutting fluid	Tapping spray

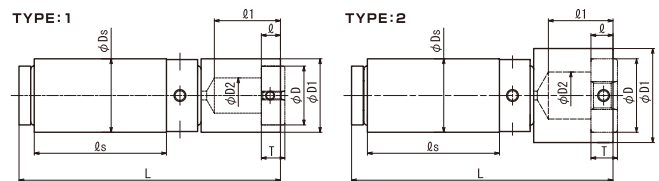
◎Cutting condition (Rigid feed)

Tool size	M8×1.25	Thread length	12mm
Material	Brass	Machine	Vertical MC
Cutting speed	5m/min	Cutting fluid	Water soluble

Dimension

Code	TYPE	φDs	φD1	φD2	L	ℓs	ℓ	ℓ1	φD	T
DA10-20	1	20	20	6	71	40	3	11	10	3.5
DA16-20		20	20	10	76	40	4.5	16	16	5
DA20-25		25	25	12	89	45	6.5	22.5	20	7
DA10-75		19.05	20	6	71	40	3	11	10	3.5
DA16-75		19.05	20	10	76	40	4.5	16	16	5
DA20-1		25.4	25	12	89	45	6.5	22.5	20	7
DA25-25	2	25	32	16	89	45	7.5	22	25	9
DA38-32		32	50	26	122	60	11	36	38	13
DA25-1		25.4	32	16	89	45	7.5	22	25	9
DA38-1.25		31.75	50	26	122	60	11	36	38	13

φD (Die OD) T (Die Thickness)



◎Application table of solid dies

φD	Metric	Unified
10	M1~M2.6	—
16	M1~M4	No.0~No.4
20	M1~M9	No.0~U1/4
25	M2~M12	U1/4~U3/8
38	M4~M16	U3/8~U5/8

The table is only for your reference. For detailed sizes, please refer to the dimensions of each die stated in the catalogue.

Remarks on usage

- ① Please use RD-DA with MC and CNC lathes that are full rigid-feed type. If used with non-rigid type machines, it may cause problems like poor external threads, damage of dies or damage on the die attachment.
- ② Please use YAMAWA solid dies D with RD-DA.

Warning

- ◆ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆ Tools may be shattered. 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 workpieces 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.

Please note that specification may change without advance notice.

YAMAWA Mfg. Co., Ltd.

Head office

Nakajima Gold bldg.13-10 Kyobashi
3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website: <http://www.yamawa.com/en>

YAMAWA group for Overseas

YAMAWA International Co., Ltd.



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JQA-EM3465