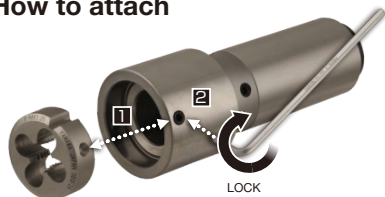


[Operating Instructions]

RD-DA, a Die Attachment that compensates for both feeding and centering error with Solid Die. Refer to these operating instructions before use for safety and proper use. Retain these operating instructions for reference when necessary.

1 How to attach

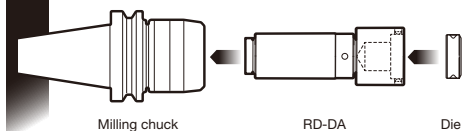


1 Align the side hole of the Die with the lock screw thread on RD-DA.

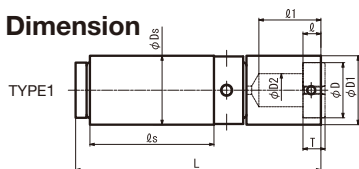
2 Tighten the lock screw on the RD-DA to hold Die.

3 Make sure the Die is tightened firmly when using a milling chuck.

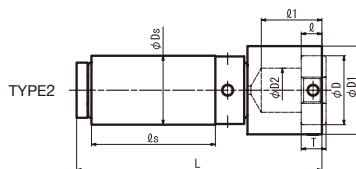
2 Example of use



3 Dimension



UNIT:mm									
Code	TYPE	φDs	φD1	φD2	L	ls	l	l1	φD T
DA10-20	1	20	φD1	6	71	40	3	11	φD 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

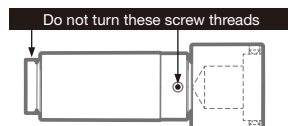


UNIT:mm									
Code	TYPE	φDs	φD1	φD2	L	ls	l	l1	φD T
DA25-25	2	25	32	16	89	45	7.5	22	φD 9
DA38-32		32	50	26	122	60	11	36	φD 13
DA25-1		25.4	32	16	89	45	7.5	22	φD 9
DA38-125		31.75	50	26	122	60	11	36	φD 13

φD(O.D. of Die) T(Thickness of Die)

4 Important operating functions.

- Do not use on machines without synchronized feed system. This will prevent breakage of Die or RD-DA and defects of external screw threads.
- Only use by clamping on the shank portion of the Die Attachment.
- Only use with Yamawa Solid Die.
- Do not loosen the screw thread of RD-DA unless removing the Solid Die.



5 Warning

- Tools may shatter. Wear safety or eye glass for eye protection and to avoid injury during tapping.
- Tools may be shatter. Use tools under the proper tapping condition.
- Never wear gloves during tapping 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 doesn't move during tapping operation. Never use worn tools or damaged and chip tools.
- Take special care to avoid fire. High temperature during machining may cause fire.

Please note that specification may change without advance notice.



YAMAWA MFG.Co., Ltd.

Website : www.yamawa.com/en/

YAMAWA group for Overseas

YAMAWA International Co., Ltd.

TEL+81(3)3561-2717

E-mail : e-support@yamawa.com