

Shank dia.	Holder dia.	Recess dia.	Overall length	Depth of die mounting	Cutting depth	Outside dia of Die	Thickness of Die
Ds	D <sub>1</sub>	D <sub>2</sub>	L	ℓ	ℓ <sub>1</sub>	D	T

# DA SL

Die Attachment (Designed Specifically for Lathes)



## Specification

**Alloy steel**

## Product Features

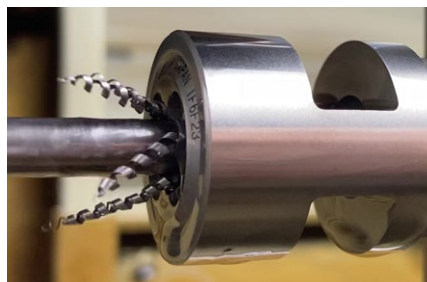
- Tooling that enables use of not only solid dies but also rolling dies commonly used with lathes.
- Stable and consecutive threading is achieved by removing remaining chips through the provided chip outlet.
- The flat cut on the shank is suitable for mounting the attachment on the turret of a lathe!
- The tension spring is equipped for stable threading. The feed rate should be set to 90 to 95% of the pitch length.

## Machining Data

- Use of a Spiral Pointed Solid Die DPO improves chip removal and achieves stable and consecutive threading!



DPO



Passed thread ring gauge inspection



## ◎ Cutting conditions [Asynchronous feed: 90% of the thread pitch]

Dise Size	M6×1	Machining Speed	2m/min, workpiece rotating	Machine	Automatic horizontal lathe
Workpiece Material	S45C	Threading Length	10mm	Cutting Fluid	Non soluble cutting oil

- High quality external threading using RS-D rolling dies



Passed thread ring gauge inspection



## ◎ Cutting conditions [Asynchronous feed: 90% of the die pitch]

Dise Size	M3×0.5	Machining Speed	3m/min, workpiece rotating	Machine	Automatic horizontal lathe
Workpiece Material	SUS303	Threading Length	10mm	Cutting Fluid	Non soluble cutting oil

Shank dia.	Holder dia.	Recess dia.	Overall length	Depth of die mounting	Cutting depth	Outside dia of Die	Thickness of Die
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Spiral Fluted Taps  
(for blind hole)

①

Spiral Fluted Taps  
(for through hole)

②

Spiral Pointed Taps  
(for through hole)

③

Hand Taps

④

Cemented  
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps  
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills  
Premium Thread Mills

⑨

Dies

⑩

Center Drills  
Centering Tools

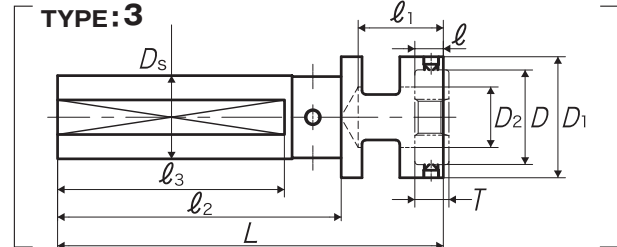
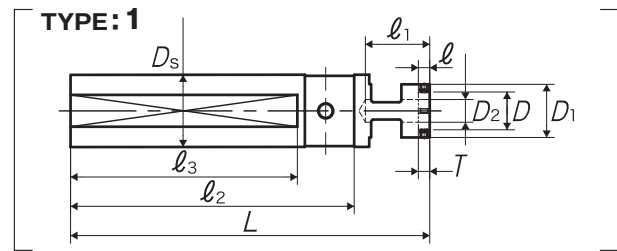
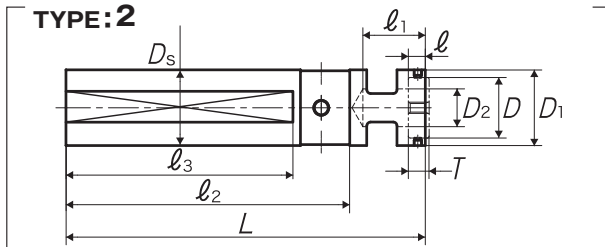
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Precision Machinery/  
Medical Surgical Instruments

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Segment : 3A

Code	Ds (mm)	D <sub>1</sub> (mm)	D <sub>2</sub> (mm)	L (mm)	ℓ (mm)	ℓ <sub>1</sub> (mm)	ℓ <sub>2</sub> (mm)	ℓ <sub>3</sub> (mm)	D (mm)	T (mm)	TYPE	MSRP
DASL191075	19.05	14	6	95	3	16	75	60	10	3	1	¥ 44,200 □
DASL191675	19.05	20	10	95	4.5	16	75	60	16	5	2	¥ 44,200 □
DASL192075	19.05	25	12	102	6.5	22.5	75	60	20	7	3	¥ 50,100 □
DASL201075	20	14	6	95	3	16	75	60	10	3	1	¥ 44,200 □
DASL201675	20	20	10	95	4.5	16	75	60	16	5	2	¥ 44,200 □
DASL202075	20	25	12	102	6.5	22.5	75	60	20	7	3	¥ 50,100 □
DASL221075	22	14	6	95	3	16	75	60	10	3	1	¥ 44,200 □
DASL221675	22	22	10	95	4.5	16	75	60	16	5	2	¥ 44,200 □
DASL222075	22	25	12	102	6.5	22.5	75	60	20	7	3	¥ 52,200 □
DASL222575	22	32	16	102	7.5	22	75	60	25	9	3	¥ 52,200 □
DASL252075	25	25	12	102	6.5	22.5	75	60	20	7	2	¥ 52,200 □
DASL252075A	25.4	25	12	102	6.5	22.5	75	60	20	7	2	¥ 54,600 □
DASL252575	25	32	16	102	7.5	22	75	60	25	9	3	¥ 52,200 □
DASL252575A	25.4	32	16	102	7.5	22	75	60	25	9	3	¥ 54,600 □
DASL3238105	32	50	26	147	11	36	105	88	38	13	3	¥ 64,600 □

□=In stock at manufacturer.



Think threads with

YAMAWA