

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

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① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Tools

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

⑩-55

DA SS

Die Attachment for Machining Center

Specification



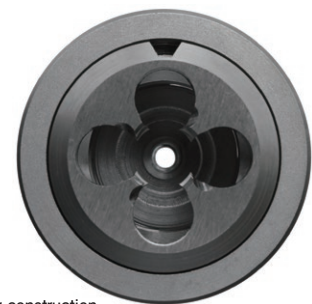
Product Features

- The exclusive tooling for YAMAWA solid dies, with functions to compensate feed error and misalignment of centering.
- In combination with NC tooling, external threads can be easily made in complicated workpieces.
- Stable and consecutive threading is achieved by removing remaining chips through the provided chip outlet.
- The coolant through hole is standardized to support the internal coolant supply.

Machining Data



Chip outlet



No remaining chips

◎ Cutting condition (Rigid feed)

Tool size	M8×1.25	Cutting length	16mm
Work Material	Brass	Machine	Vertical-type machining center
Cutting Speed	5m/min	Cutting Oil	Water-soluble cutting oil

Stable and consecutive threading is achieved by removing remaining chips through the chip outlet! It can also be used with external lubrication equipment.

Coolant Through Hole Specifications

Coolant Through Hole

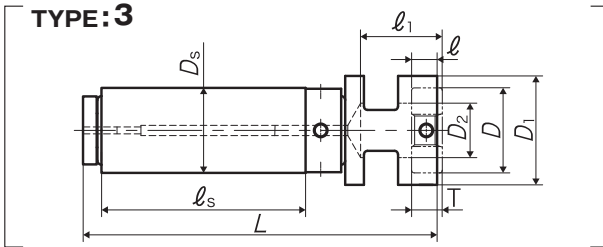
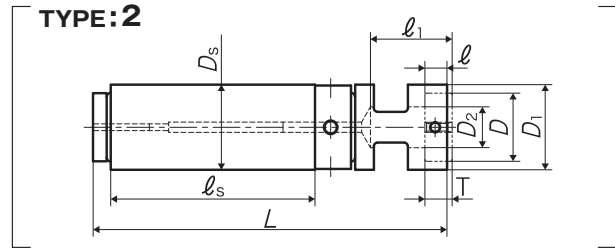
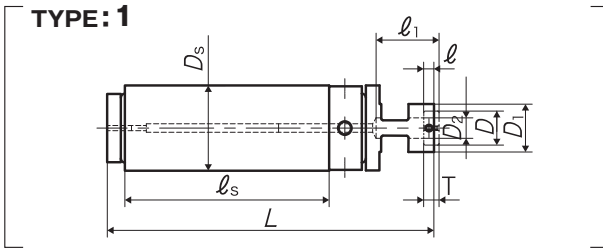


Cutting oil passes through the coolant through hole provided in the center of the die attachment to accelerate chip ejection, lubrication, and cooling.

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Segment : 3A

Code	Ds (mm)	D ₁ (mm)	D ₂ (mm)	L (mm)	ℓs (mm)	ℓ (mm)	ℓ ₁ (mm)	D (mm)	T (mm)	TYPE	MSRP
DASS201060	20	14	6	96	60	3	16	10	3	1	¥ 44,200 □
DASS201660	20	20	10	96	60	4.5	16	16	5	2	¥ 44,200 □
DASS202060	20	25	12	103	60	6.5	22.5	20	7	3	¥ 50,100 □
DASS252060	25	25	12	104	60	6.5	22.5	20	7	2	¥ 52,200 □
DASS252560	25	32	16	104	60	7.5	22	25	9	3	¥ 52,200 □
DASS323870	32	50	26	132	70	11	36	38	13	3	¥ 64,600 □

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Thread Mills
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⑨

Dies

⑩

Center Drills
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⑪

Precision Machinery/
Medical Surgical Instruments

⑫

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□=In stock at manufacturer.

 Think threads with
YAMAWA