

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

JIS

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 Taps

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 10-53



DA SS

Die Attachment for Machining Center



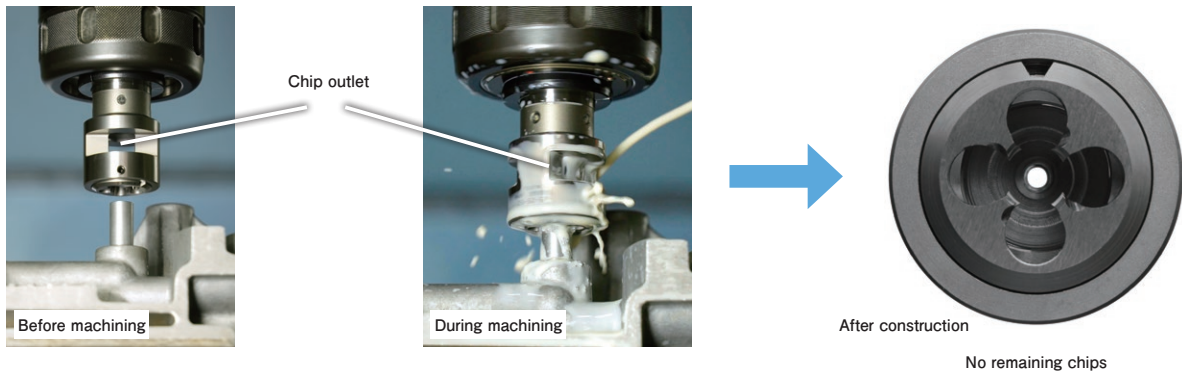
Specification



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

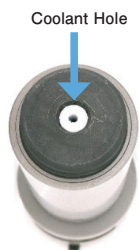


◎ Cutting condition (Rigid feed)

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

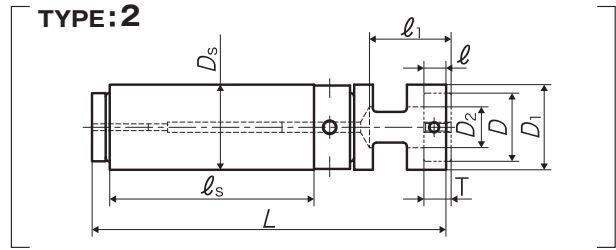
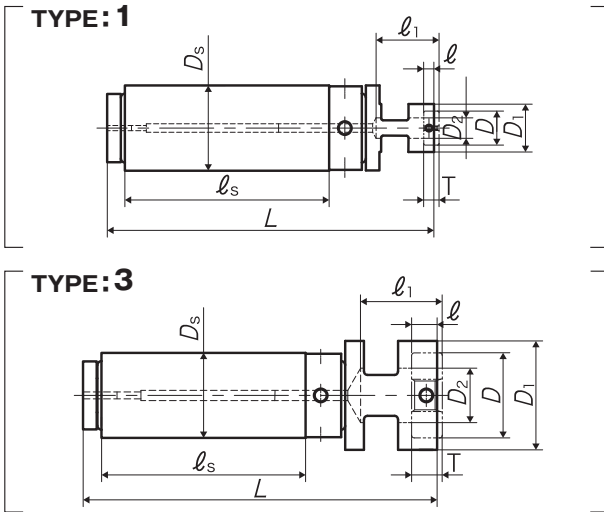
Stable and consecutive threading is achieved by removing remaining chips through the chip outlet! It can also be used with external lubrication equipment.

Coolant Through Hole Specifications



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

Shank dia.	Holder dia.	Recess dia.	Overall length	Shank length	Depth of die mounting	Cutting depth	Outside dia of Die	Thickness of Die
Ds	D1	D2	L	ls	l	l1	D	T



Segment : 3A

Code	Ds (mm)	D1 (mm)	D2 (mm)	L (mm)	ls (mm)	l (mm)	l1 (mm)	D (mm)	T (mm)	TYPE	MSRP
DASS201060	20	14	6	96	60	3	16	10	3	1	¥ 40,100 □
DASS201660	20	20	10	96	60	4.5	16	16	5	2	¥ 40,100 □
DASS202060	20	25	12	103	60	6.5	22.5	20	7	3	¥ 45,500 □
DASS252060	25	25	12	104	60	6.5	22.5	20	7	2	¥ 47,400 □
DASS252560	25	32	16	104	60	7.5	22	25	9	3	¥ 47,400 □
DASS323870	32	50	26	132	70	11	36	38	13	3	¥ 58,700 □

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- 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/Metal Surgical Instruments