

# RD-DA

Die Attachment (Designed Specially for Solid Round Dies)

## Specification

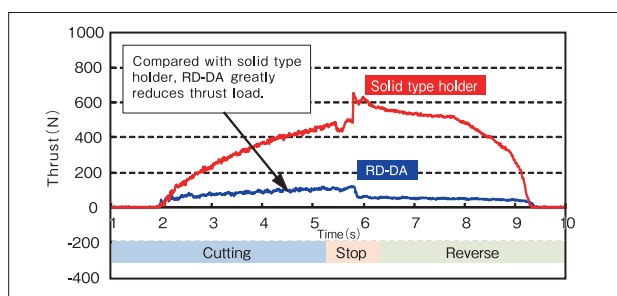


Shank dia.	Holder dia.	Recess dia.	Overall length	Shank length	Depth of die mounting	Cutting depth	Outside dia of Die	Thickness of Die
DS	D <sub>1</sub>	D <sub>2</sub>	L	ℓ <sub>s</sub>	ℓ	ℓ <sub>1</sub>	D	T



- Tooling designed specially for solid dies, with the mechanism to compensate for feed error and to absorb misalignment.
- Combined with CNC toolings, this attachment enables the cutting of external threads on complex workpieces with ease.

- Due to the mechanism to compensate for feed error, the thrust in the axial direction decreases and the tool life becomes longer.

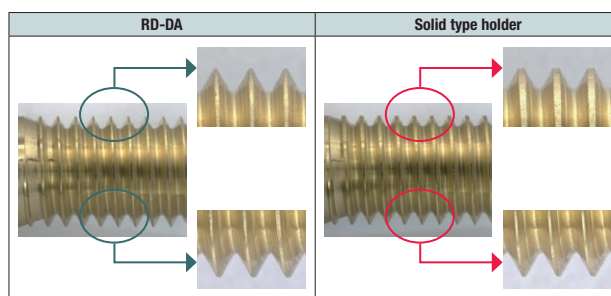


## Cutting data

Cutting condition (Rigid feed)

Tool Size	M10×1.5	Cutting Length	15mm
Work Material	Brass	Machine	Vertical MC
Cutting Speed	5m/min	Cutting Fluid	Tapping spray

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

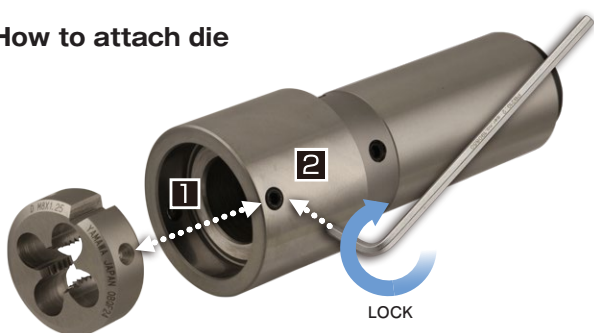


## Cutting data

Cutting condition (Rigid feed)

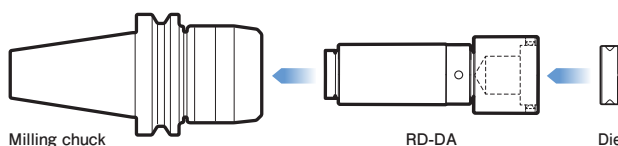
Tool Size	M8×1.25	Cutting Length	12mm
Work Material	Brass	Machine	Vertical MC
Cutting Speed	5m/min	Cutting Fluid	Water soluble cutting fluid

## How to attach die



- ① Align push-hole or V groove of the die with the side lock screw on RD-DA and attach die.
- ② Turn the side lock screw by hex wrench and fasten die tightly.
- ③ Make sure the die is fastened tightly and use RD-DA with NC toolings.

## Example of use



Combined with NC toolings, RD-DA can be used with MC.



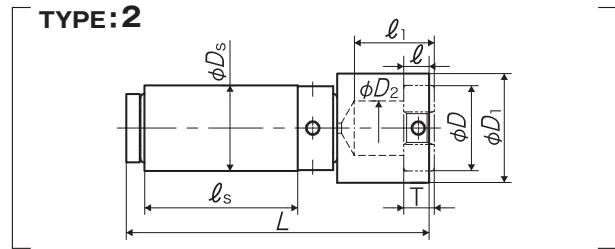
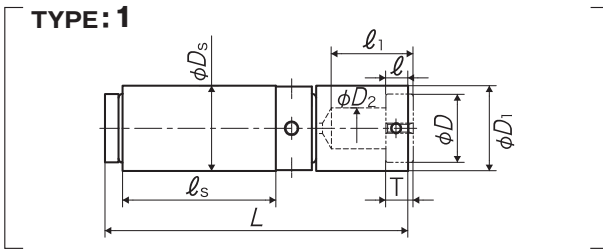
Click here for the RD-DA instruction manual



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 <sub>1</sub>	D <sub>2</sub>	L	ℓ <sub>s</sub>	ℓ	ℓ <sub>1</sub>	D	T

10

JIS



Segment : 3A

Code	Ds (mm)	D <sub>1</sub> (mm)	D <sub>2</sub> (mm)	L (mm)	ℓ <sub>s</sub> (mm)	ℓ (mm)	ℓ <sub>1</sub> (mm)	D (mm)	T (mm)	TYPE	MSRP
DA10-20	20	20	6	71	40	3	11	10	3	1	¥ 30,500 □ ▲
DA16-20	20	20	10	76	40	4.5	16	16	5	1	¥ 30,500 □ ▲
DA20-25	25	25	12	89	45	6.5	22.5	20	7	1	¥ 34,900 □ ▲
DA25-25	25	32	16	89	45	7.5	22	25	9	2	¥ 36,800 □ ▲
DA38-32	32	50	26	122	60	11	36	38	13	2	¥ 46,100 □ ▲

Remarks: Products marked with ▲ in the MSRP column are while supplies last.

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

⑪

Precision Machinery/  
Medical Surgical Instruments

⑫

JIS

⑩-60