

# RD-DA

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High precision external threads can be easily achieved!



# Features

## Die attachment (Designed for Solid Dies)

# RD-DA

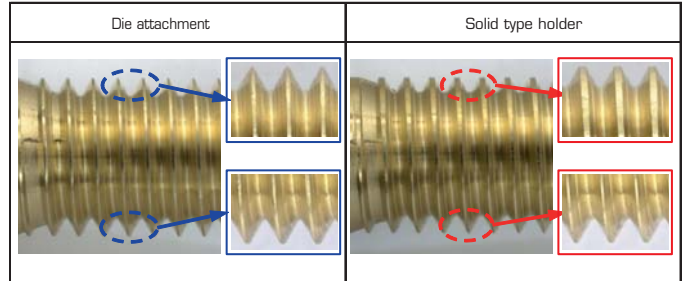
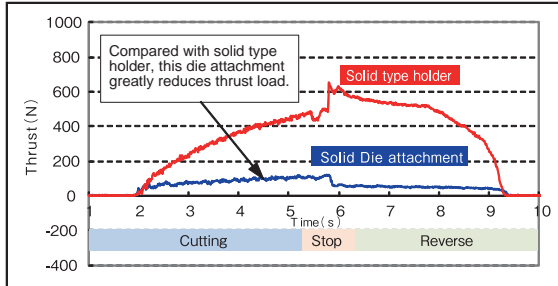
Alloy steel



- Tooling designed for Solid Dies, with a mechanism to compensate for feed error and to absorb misalignment.
- Combined with CNC tooling, this attachment enables the cutting of external thread on complex workpieces with ease.

● With a mechanism to compensate for feed error, the thrust in the axial direction decreases and results in longer tool life

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



◎Cutting condition (Rigid feed)

|               |         |               |               |
|---------------|---------|---------------|---------------|
| Tool size     | M10×1.5 | Thread length | 15mm          |
| Material      | Brass   | Machine       | Vertical MC   |
| Cutting speed | 5m/min  | Cutting fluid | Tapping spray |

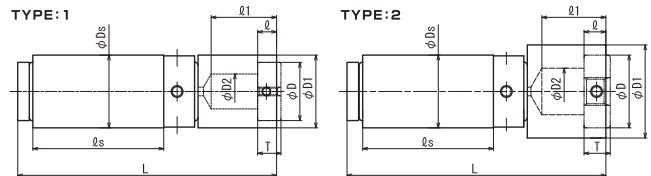
◎Cutting condition (Rigid feed)

|               |         |               |               |
|---------------|---------|---------------|---------------|
| Tool size     | M8×1.25 | Thread length | 12mm          |
| Material      | Brass   | Machine       | Vertical MC   |
| Cutting speed | 5m/min  | Cutting fluid | Water soluble |

# Dimensions

| Code      | TYPE | φDs   | φD1 | φD2 | L   | ℓs | ℓ   | ℓ1   | φD | T   |
|-----------|------|-------|-----|-----|-----|----|-----|------|----|-----|
| DA10-20   | 1    | 20    | 20  | 6   | 71  | 40 | 3   | 11   | 10 | 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   |
| DA25-25   | 2    | 25    | 32  | 16  | 89  | 45 | 7.5 | 22   | 25 | 9   |
| DA38-32   |      | 32    | 50  | 26  | 122 | 60 | 11  | 36   | 38 | 13  |
| DA25-1    |      | 25.4  | 32  | 16  | 89  | 45 | 7.5 | 22   | 25 | 9   |
| DA38-1.25 |      | 31.75 | 50  | 26  | 122 | 60 | 11  | 36   | 38 | 13  |

φD (Die OD) T (Die Thickness)



◎Application table of solid dies

| φD | Metric  | Unified   |
|----|---------|-----------|
| 10 | M1~M2.6 | —         |
| 16 | M1~M4   | No.0~No.4 |
| 20 | M1~M9   | No.0~U1/4 |
| 25 | M2~M12  | U1/4~U3/8 |
| 38 | M4~M16  | U3/8~U5/8 |

The table is only for your reference. For detailed sizes, please refer to the dimensions of each die stated in the catalogue.

# Remarks on usage

- ① Please use RD-DA with MC and CNC lathes that are full rigid-feed type. If used with non-rigid type machines, it may cause problems like poor external threads, damage of dies or damage on the die attachment.
- ② Please use YAMAWA solid dies D with RD-DA.

## Warning

- ◆ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆ Tools may be shatter. Use tools under the proper tapping condition.
- ◆ Never wear gloves during turning 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 that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆ Take a special care to fire trouble. High temperature during machining may cause fire.

Please note that specification may change without advance notice.

