

A-A-410
October 17, 1979

COMMERCIAL ITEM DESCRIPTION

DIE, THREAD CUTTING
(ROUND, SPLIT, INCH SERIES)

The General Services Administration has authorized the use of this commercial item description in lieu of Federal Specification GGG-D-296.

This commercial item description covers adjustable, round split dies with American National or Unified National threads.

Salient characteristics:

Design. Dies shall be cylindrical in shape with a split (slot) from the threads to the periphery. One side of the slot shall be tapped and furnished with an adjustment setscrew. Two dimples in the periphery, 180° apart and 90° to the slot, and midway between the die's faces, shall be provided for retaining the die in the diestock. Threads shall be right-hand unless otherwise specified.

Material. Carbon tool steel or high speed steel.

Hardness. Rockwell C57 to 63 for carbon tool steel, Rockwell C61 to 65 for high speed steel. The cutting lands of the die threads shall show no evidence of partial or total decarbonization.

Sizes. Dies shall be furnished in the following sizes:

National Stock Number (NSN)	Thread size, pitch, and series	Nominal dimensions (inches)	
		Diameter	Thickness
5136-00-186-6052	9/16-18 NF	1-1/2	1/2
5136-00-186-6070	11/16-11 NS	2	5/8
5136-00-187-7150	1/2-20 NF LH	2	5/8
5136-00-189-3189	3/4-16 NF LH	2-1/2	3/4
5136-00-189-3194	1/4-28 NF	1-1/2	1/2
5136-00-189-3195	5/16-24 NF	1-1/2	1/2
5136-00-189-3196	3/8-24 NF	1-1/2	1/2
5136-00-189-3197	7/16-20 NF	1-1/2	1/2
5136-00-189-3198	1/2-20 NF	1-1/2	1/2
5136-00-189-3199	9/16-18 NF	2-1/2	3/4
5136-00-189-3200	5/8-18 NF	2-1/2	3/4
5136-00-189-3201	3/4-16 NF	2-1/2	3/4
5136-00-189-3204	5/16-18 NC LH	1-1/2	1/2
5136-00-189-3205	3/8-16 NC LH	1-1/2	1/2
5136-00-189-3206	7/16-14 NC LH	1-1/2	1/2
5136-00-189-3207	1/2-13 NC LH	1-1/2	1/2
5136-00-189-3210	3/4-10-NC LH	2-1/2	3/4
5136-00-189-3216	5/8-18 NC	1-1/2	1/2
5136-00-189-3217	3/8-16 NC	1-1/2	1/2
5136-00-189-3218	7/16-14 NC	1-1/2	1/2
5136-00-189-3219	1/2-13 NC	1-1/2	1/2
5136-00-189-3220	9/16-12 NC	2-1/2	3/4
5136-00-189-3221	5/8-11 NC	2-1/2	3/4
5136-00-189-3222	3/4-10 NC	2-1/2	3/4
5136-00-189-3223	7/8-9 NC	2-1/2	3/4
5136-00-189-3224	1-8 NC	2-1/2	3/4
5136-00-189-3238	7/8-14 NF	2-1/2	3/4
5136-00-189-3239	1-14 NS	2-1/2	3/4
5136-00-189-3241	1-1/4-12 NF	3	1
5136-00-197-9296	1/4-28 NF	2	5/8
5136-00-197-9298	5/16-18 NC	2	5/8
5136-00-197-9299	5/16-24 NF	2	5/8
5136-00-197-9302	3/8-24 NF	2	5/8

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National Stock Number (NSN)	Thread size, pitch, and series	Nominal dimensions (inches)	
		Diameter	Thickness
5136-00-197-9305	7/16-20 NF	2	5/8
5136-00-197-9307	1/2-13 NC	2	5/8
5136-00-197-9308	1/2-20 NF	2	5/8
5136-00-197-9309	1/2-28 NEF	2	5/8
5136-00-197-9534	1-1/8-7 NC	3	1
5136-00-197-9535	1-1/4-7 NC	3	1
5136-00-222-2226	6-32 NC	5/8	1/4
5136-00-224-1449	1/4-20 NC	2	5/8
5136-00-224-1461	1/4-20 NC	1-1/2	1/2
5136-00-224-1486	10-32 NF	5/8	1/4
5136-00-227-5401	8-32 NC	5/8	1/4
5136-00-227-5402	10-24 NC	5/8	1/4
5136-00-227-5407	4-40 NC	5/8	1/4
5136-00-227-5409	2-56 NC	5/8	1/4
5136-00-237-8263	3-56 NF	13/16	1/4
5136-00-237-8264	4-36 NS	13/16	1/4
5136-00-239-2761	10-32 NF LH	13/16	1/4
5136-00-239-2762	0-80 NF	13/16	1/4
5136-00-239-2763	1-72 NF	13/16	1/4
5136-00-239-2764	2-64 NF	13/16	1/4
5136-00-239-2765	4-48 NF	13/16	1/4
5136-00-239-2766	5-44 NF	13/16	1/4
5136-00-239-2767	6-40 NF	13/16	1/4
5136-00-239-2768	8-36 NF	13/16	1/4
5136-00-239-2769	10-32 NF	13/16	1/4
5136-00-239-2770	12-28 NF	13/16	1/4
5136-00-239-2772	1-64 NC	13/16	1/4
5136-00-239-2773	2-56 NC	13/16	1/4
5136-00-239-2774	3-48 NC	13/16	1/4
5136-00-239-2775	4-40 NC	13/16	1/4
5136-00-239-2776	5-40 NC	13/16	1/4
5136-00-239-2777	6-32 NC	13/16	1/4
5136-00-239-2778	8-32 NC	13/16	1/4
5136-00-239-2779	10-24 NC	13/16	1/4
5136-00-239-2780	12-24 NC	13/16	1/4
5136-00-240-6161	12-24 NC	5/8	1/4
5136-00-820-8090	1-12 NF	2-1/2	3/4
5136-00-889-6605	3/8-16 NC	2	5/8
5136-00-889-6985	1-8 NC	3	1

Threads. Thread form shall be American National or Unified National. Threads on the front face shall be chamfered approximately 2 to 3 threads and 1 to 1-1/2 threads on the back face.

Marking. The dies shall be marked on the front face in a legible and permanent manner with the manufacturer's name or trademark, the thread size, and "HS," "HSS," or "High Speed" to indicate high speed steel, if applicable.

Workmanship. All dies shall be free from imperfections which may affect their appearance, serviceability, or durability.

Certification. The contractor shall certify that the product offered meets the salient characteristics of this description and that the product conforms to the producer's own drawings, specifications, standards, and quality assurance practices and is the same product offered for sale in the commercial marketplace. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

Recovered materials. The manufacturer shall utilize recovered materials to the maximum extent practicable.

Preservation, packaging, packing, and marking. The dies shall be preserved and packaged in accordance with normal commercial practice and packed to assure acceptance by common carrier and provide product protection against loss and damage during multiple shipments, handling, and storage. The shipping container shall be in compliance with National Motor Freight Classification and Uniform Freight Classification. Marking shall be in accordance with the contract or order.