

车 槽

切 断

铣 槽

插 削

仿 形 铣 削

铰 削



新 产 品

NEW

高进给铣削 DAH37

High feed milling DAH37

新增配有新型正前角几何槽型刀片

new insert with positive geometry

HORN-卓越于技术

HORN - EXCELLENCE IN TECHNOLOGY

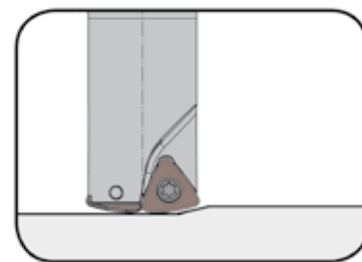


GROOVING PARTING OFF GROOVE MILLING BROACHING PROFILE MILLING REAMING

铣刀头 型号

MILLING HEAD Type

DAH37



切削刃Ø

Cutting edge Ø

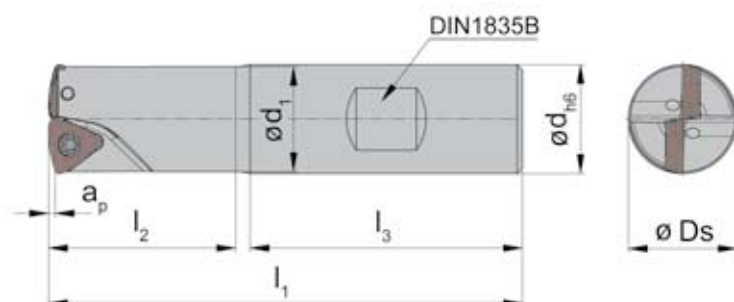
20/25/32/40 mm

刀杆材料：钢

Material of shank: Steel

配合 可转位刀片
for use with Indexable insert

型号 DAH37
Type



产品型号 Part number	Z	Ds	a _p	l ₁	l ₂	l ₃	d	d ₁
DAH37.020.D204.02B	2	20	1.2	87	34	50	20	19
DAH37.025.D255.03B	3	25	1.2	101	41	56	25	24
DAH37.032.D326.04B	4	32	1.2	111	47	60	32	31
DAH37.040.D326.05B	5	40	1.2	111	47	60	32	39

尺寸单位：mm
Dimensions in mm

螺钉030.3070.T10P的扭矩规格=3.4Nm。

Torque specification of the screw 030.3070.T10P = 3,4 Nm.

附件

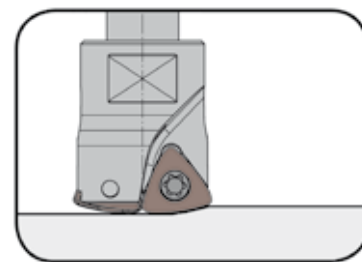
Spare parts

铣刀头 Milling head	螺钉 Clamping screw	TORX PLUS® 扳手 TORX PLUS® Wrench
DAH37.0...	030.3070.T10P	T10PL

螺纹锁紧铣刀 型号

SCREW-IN CUTTER Type

DAHM



切削刃Ø

Cutting edge Ø

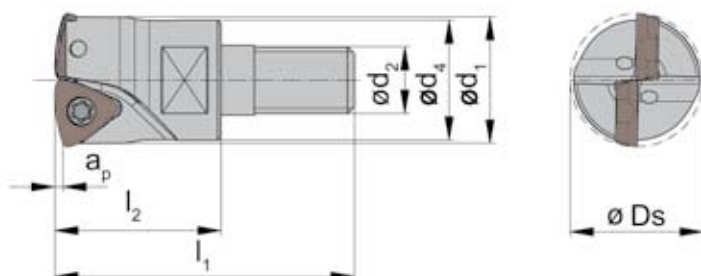
20/25/32/40 mm

刀杆材料：钢

Material of shank: Steel

配合 可转位刀片
for use with Indexable insert

型号 DAH37
Type



适用于MD系列刀柄
suitable for Shank Type MD

产品型号 Part number	Z	Ds	a _p	l ₁	l ₂	d ₁	d ₂	d ₄	SW
DAHM.37.020.M104.02	2	20	1.2	45	25	19	M10	18	15
DAHM.37.025.M125.03	3	25	1.2	52	30	24	M12	21	17
DAHM.37.032.M166.04	4	32	1.2	58	35	31	M16	29	24
DAHM.37.040.M166.05	5	40	1.2	58	35	39	M16	29	24

尺寸单位：mm
Dimensions in mm

螺钉030.3070.T10P的扭矩规格=3.4Nm。
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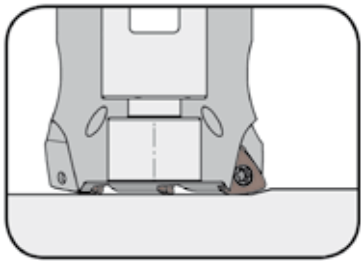
附件

Spare parts

螺纹锁紧铣刀 Screw-in cutter	螺钉 Clamping screw	TORX PLUS® 扳手 TORX PLUS® Wrench
DAHM.37.0...	030.3070.T10P	T10PL

铣刀 型号
MILLING CUTTER Type

DAHM

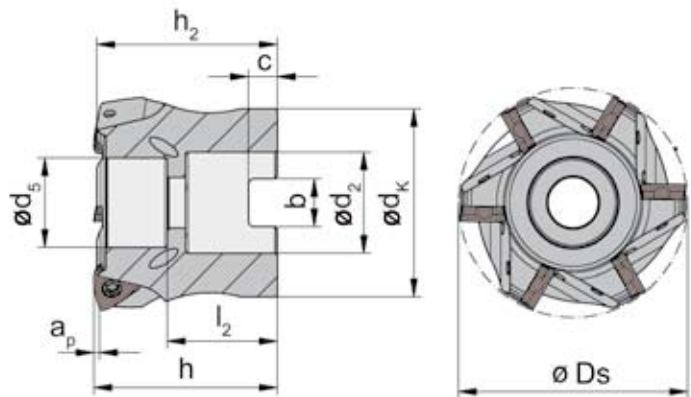


切削刃Ø Cutting edge Ø 40/50/63/80 mm

配合刀柄式铣刀，符合DIN8030-标准
Arbor mounted cutter as per DIN 8030-A

配合可转位刀片
for use with Indexable insert

型号 DAH37
Type



图示=右手型
Picture = right hand cutting version

配合刀柄
Type arbor mounted

产品型号 Part number	Z	Ds	ap	h	h ₂	dk	d ₂	d ₅	b	c	l ₂
DAHM.37.040.A1635.05	5	40	1.2	35	34.4	33	16	16.0	8.4	5.6	22
DAHM.37.050.A2235.06	6	50	1.2	40	39.4	41	22	19.5	10.4	6.3	24
DAHM.37.063.A2240.07	7	63	1.2	40	39.4	49	22	19.5	10.4	6.3	24
DAHM.37.063.A2740.07				45	44.4		27	21.5	12.4	7.0	27
DAHM.37.080.A3245.08	8	80	1.2	55	54.4	59	32	29.5	14.4	8.0	33

尺寸单位：mm
Dimensions in mm

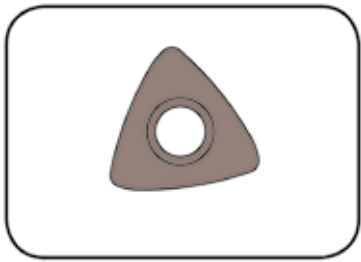
螺钉030.3070.T10P的扭矩规格=3.4Nm。
Torque specification of the screw 030.3070.T10P = 3,4 Nm.

附件
Spare parts

铣刀 Milling cutter	螺钉 Clamping screw	TORX PLUS® 扳手 TORX PLUS® Wrench
DAHM.37.0...	030.3070.T10P	T10PL

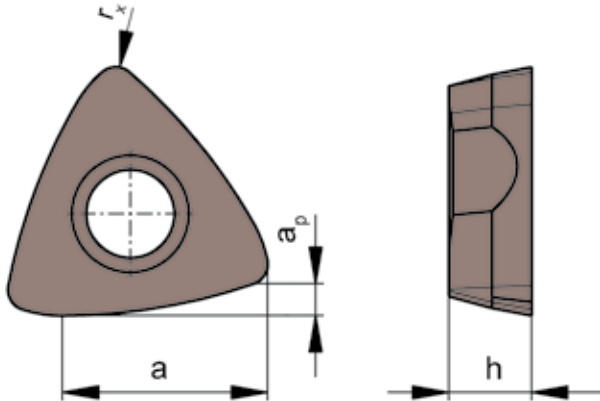
可转位刀片 型号
INDEXABLE INSERT Type

DAH37



切深可达 Depth of cut up to 1.2 mm

配合铣削刀杆
for use with Milling tool

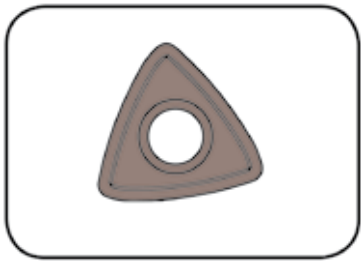


平头几何结构
neutral geometry

产品型号 Part number	a_p	a	h	r_x	r_{theo}		
DAH.37.022.N.08	1.2	7.9	3.18	0.8	0.83	SA4B	SC6A
▲ 库存 / on stock Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet 尺寸单位 : mm Dimensions in mm						▲	▲
						P	•
						M	•
						K	•
						N	•
						S	•
						H	•
						硬质合金牌号 Carbide grades	

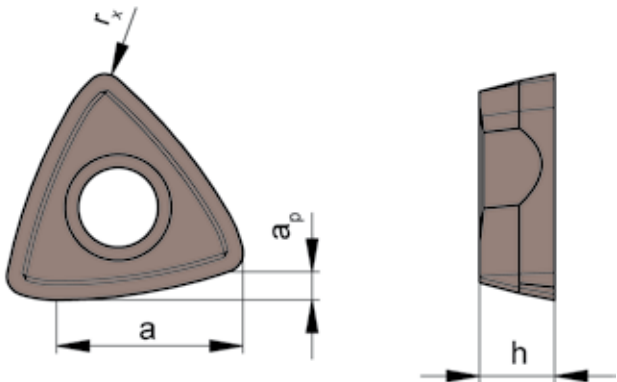
可转位刀片 型号
INDEXABLE INSERT Type

DAH37



切深可达 Depth of cut up to 1.2 mm

配合铣削刀杆
for use with Milling tool



正前角几何结构
positiv geometry

产品型号 Part number	a_p	a	h	r_x	r_{theo}	SA4B	
DAH.37.022.S.08	1.2	7.9	3.18	0.8	0.83	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet 尺寸单位 : mm Dimensions in mm						P	●
						M	●
						K	●
						N	●
						S	●
						H	●

硬质合金牌号
Carbide grades

ISO	材料 Material	硬度 HB Hardness HB	进给/齿 f_z (mm) Feed/tooth f_z (mm)	切削速度 v_c (m/min) Cutting speed v_c (m/min)
P	非合金钢 unalloyed steel	125	0.8 - 2.2	200 - 300
	非合金钢 unalloyed steel	190	0.8 - 2.2	200 - 300
	低合金钢 low alloyed steel	200	0.8 - 2.0	180 - 300
	低合金钢 low alloyed steel	300	0.8 - 2.0	160 - 280
	高合金钢 high alloyed steel	200	0.6 - 1.6	150 - 250
M	不锈钢 马氏体 Stainless steel martenistic	240	0.8 - 2.0	140 - 220
	不锈钢 奥氏体 Stainless steel austenitic	180	0.6 - 1.6	120 - 200
K	可锻铸铁 铁素体 Malleable cast iron ferritic	130	0.8 - 2.2	160 - 280
	可锻铸铁 珠光体 Malleable cast iron perlitic	230	0.7 - 1.8	150 - 250
	球墨铸铁 铁素体/珠光体 Spheroidal graphite cast iron ferritic/perlitic	180	0.7 - 1.8	150 - 250
	球墨铸铁 珠光体 Spheroidal graphite cast iron perlitic	260	0.7 - 1.8	140 - 240
	灰铸铁 Grey cast iron	160	0.8 - 2.5	180 - 320
N	铝合金 Al-alloys	90	1.0 - 3.0	1000 - 1500

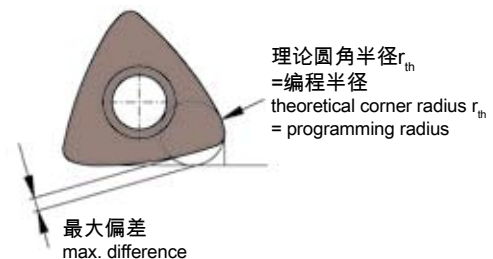
切入角

Diving angle

Ø (mm)	切入角 (°) Diving angle (°)
20	5.0
25	4.0
32	1.0
40	0.5
50	0.5
63	0.4
80	0.4

编程半径和偏差

Programming radius and difference



r_{th} (mm)	最大偏差 (mm) max. difference (mm)
2	0.83

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