

**NEW**

## 高进给铣刀系列 DAH82 和 DAH84

高金属去除率的高进给铣刀

HIGH FEED MILLING SYSTEM

DAH82 AND DAH84

High feed cutting for high metal remove rate



# 不同之处： 更多可能

## THE DIFFERENCE: MORE POSSIBILITIES

- **轻快切削刃的精磨转位刀片**  
Precision ground indexable insert  
with eight usable cutting edges
- **轻快切削的正前角槽型**  
A soft cut through positive geometry
- **高切削参数的高金属去除率**  
High metal removal rate due to  
high cutting values

# 高进给铣削

## High Feed Milling



### 铣刀杆

#### Milling shank

## DAH82



切削刃Ø	Cutting edge Ø	20-40 mm
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刀杆材料：钢  
Material of shank: Steel

配合可转位刀片  
for Indexable insert

型号 DAH82  
Type



图示=右手型  
Picture = right hand cutting version

产品型号 Part number	Z	Ds	d	l <sub>1</sub>	l <sub>3</sub>	a <sub>p</sub>
<b>DAH82.020.D204.02B</b>	2	20	20	87	50	1
<b>DAH82.025.D255.03B</b>	3	25	25	101	56	1
<b>DAH82.032.D326.04B</b>	4	32	32	111	60	1
<b>DAH82.035.D326.04B</b>	4	35	32	111	60	1
<b>DAH82.040.D326.05B</b>	5	40	32	111	60	1

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specification of the screw, please see Technical Instructions.

### 配件

#### Spare Parts

铣刀杆 Milling shank	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
DAH82...	<b>030.3070.T10P</b>	<b>T10PL</b>

### 螺纹锁紧铣刀

#### Screw-in cutter

## DAH82

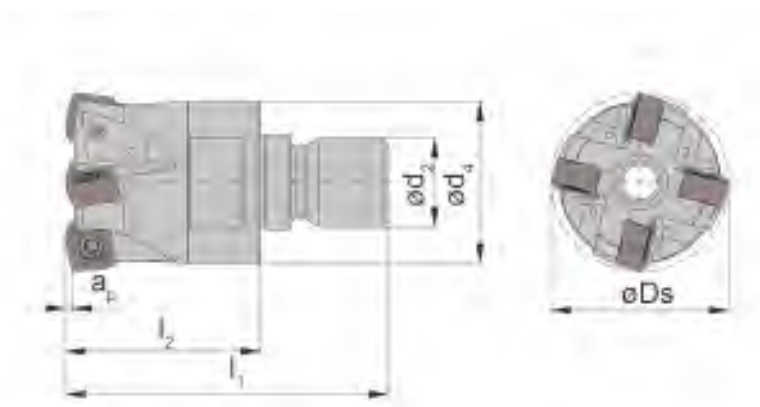


切削刃Ø	Cutting edge Ø	20-40 mm
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刀杆材料：钢  
Material of shank: Steel

配合可转位刀片  
for Indexable insert

型号 DAH82  
Type



图示=右手型  
Picture = right hand cutting version

适用于MD系列刀柄  
suitable for Shank Type MD

产品型号 Part number	Z	Ds	l <sub>1</sub>	l <sub>2</sub>	d <sub>4</sub>	a <sub>p</sub>	d <sub>2</sub>	SW
DAH82.020.M104.02	2	20	45	25	18	1	M10	15
DAH82.025.M125.03	3	25	52	30	21	1	M12	17
DAH82.032.M166.04	4	32	58	35	29	1	M16	24
DAH82.035.M166.04	4	35	58	35	29	1	M16	24
DAH82.040.M166.05	5	40	58	35	29	1	M16	24

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。

For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm  
Dimensions in mm

### 配件

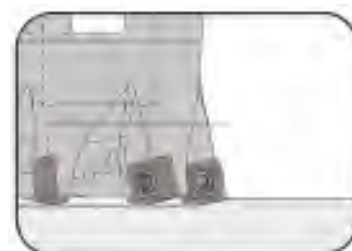
#### Spare Parts

螺纹锁紧铣刀 Screw-in cutter	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
DAH82...	030.3070.T10P	T10PL

### 芯轴刀柄式铣刀

#### Arbor Mounted Cutter

## DAH82

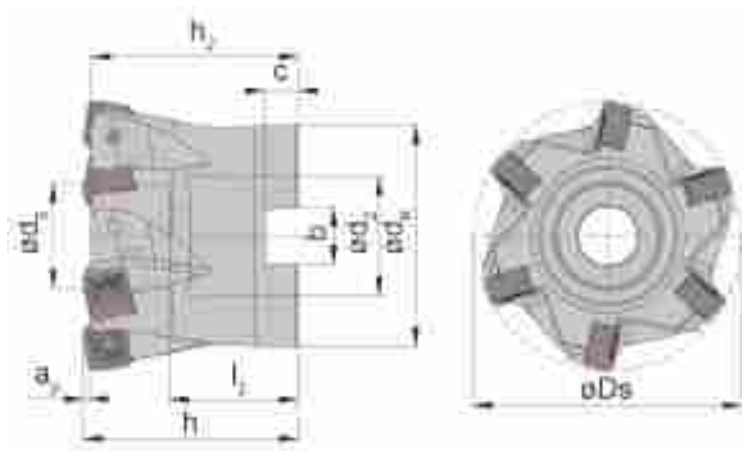


切削刃Ø	Cutting edge Ø	40-50 mm
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与DIN 8030-A 标准连接  
Coupling system as per DIN 8030-A

配合可转位刀片  
for Indexable insert

型号 DAH82  
Type



图示=右手型  
Picture = right hand cutting version

产品型号 Part number	Z	Ds	a <sub>p</sub>	h <sub>2</sub>	h	d <sub>5</sub>	d <sub>k</sub>	l <sub>2</sub>	b	C	d <sub>2</sub>
<b>DAH82.040.A1635.05</b>	5	40	1	33.5	35	16.0	33	22	8.4	5.6	16
<b>DAH82.042.A1635.05</b>	5	42	1	33.5	35	16.0	33	22	8.4	5.6	16
<b>DAH82.050.A2240.06</b>	6	50	1	38.5	40	19.5	41	24	10.4	6.3	22

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specification of the screw, please see Technical Instructions.

### 配件

#### Spare Parts

芯轴刀柄式铣刀 Arbor Mounted Cutter	扳手 Allen Wrench	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	垫圈 Washer	圆柱螺钉 Cylindrical screw
DAH82.0...	<b>SW6,0 DIN911</b>	<b>030.3070.T10P</b>	<b>T10PL</b>	<b>8.4.433</b>	<b>8.25.912</b>
DAH82.050.A2240.06	<b>SW8,0 DIN 911</b>	<b>030.3070.T10P</b>	<b>T10PL</b>	<b>10.5.433</b>	<b>10.25.912</b>

# 高进给铣削 High Feed Milling



## 可转位刀片 Indexable insert

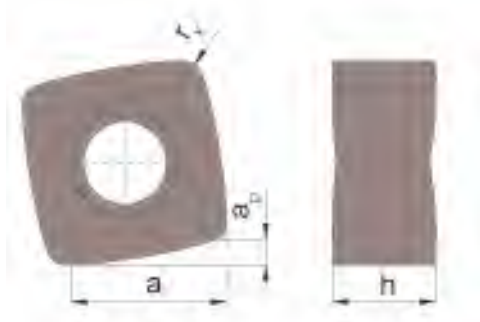
# DAH82



切深可达	Depth of cut up to	1 mm
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配合铣削刀杆  
for Milling tool

型号 DAHM82  
Type



正前角槽型  
positive geometry,  
8 usable cutting edges

产品型号 Part number	$a_p$	a	h	$r_x$	SA4B
<b>DAH.82.030.S.08</b>	1	6.8	4.5	0.8	▲
▲ 库存 / on stock	△ 4周 / 4 weeks	x 根据要求 / upon request			P ●
● 推荐 / recommended					M ●
○ 次推荐 / alternative recommendation					K ●
- 不合适 / not suitable					N ●
■ 非涂层 / uncoated grades					S -
■ 涂层 / coated grades					H -
■ 钎焊/金属陶瓷 / brazed/Cermet					

尺寸单位：mm  
Dimensions in mm

硬质合金牌号  
Carbide grades



# 切削参数 系列 DAH82

## Cutting Data System DAH82



ISO	材料 Material	硬度 HB Hardness HB	进给/齿 $f_z$ (mm) Feed/tooth $f_z$ (mm)	切削速度 Cutting speed $v_c$ (m/min)
<b>P</b>	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
<b>M</b>	不锈钢 马氏体 Stainless steel martensitic	240	0.8 - 2.0	140 - 220
	不锈钢 奥氏体 Stainless steel austenitic	180	0.6 - 1.6	120 - 200
<b>K</b>	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
<b>N</b>	铝合金 Al-alloys	90	1.0 - 3.0	1000 - 1500

### 编程半径和偏差

Programming radius and difference



理论圆角半径  $r_{th}$   
=编程半径  
theoretical corner radius  $r_{th}$   
= programming radius

最大偏差  
max. difference

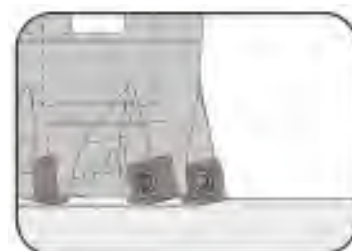
$r_{th}$ (mm)	最大偏差 (mm) max. difference (mm)
2	0.72



### 芯轴刀柄式铣刀

#### Arbor Mounted Cutter

## DAH84

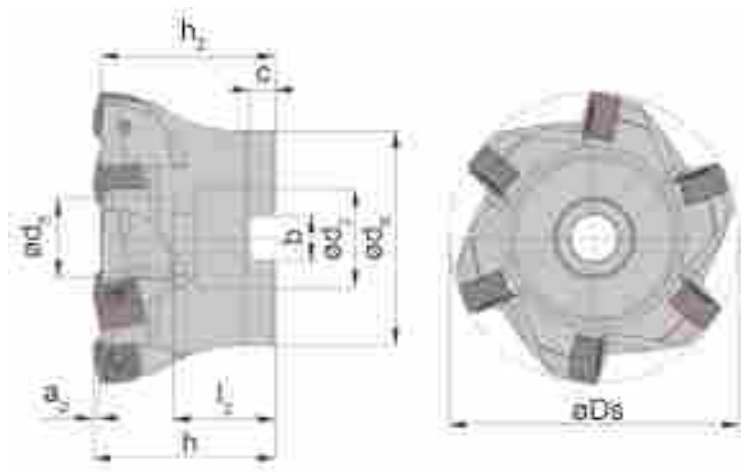


切削刃Ø                      Cutting edge Ø                      50-125 mm

与DIN 8030-A 标准连接  
Coupling system as per DIN 8030-A

配合可转位刀片  
for Indexable insert

型号    DAH84  
Type



图示=右手型  
Picture = right hand cutting version

产品型号 Part number	Z	Ds	a <sub>p</sub>	h <sub>2</sub>	h	d <sub>5</sub>	d <sub>k</sub>	l <sub>2</sub>	b	C	d <sub>2</sub>
DAH84.84.050.A2240.04	4	50	1.5	38	40	16.5	41	25	10.4	6.3	22
DAH84.84.052.A2240.04	4	52	1.5	38	40	16.5	41	25	10.4	6.3	22
DAH84.84.063.A2240.05	5	63	1.5	38	40	19.5	49	25	10.4	6.3	22
DAH84.84.066.A2240.05	5	66	1.5	38	40	19.5	49	25	10.4	6.3	22
DAH84.84.080.A2750.06	6	80	1.5	48	50	21.5	59	28	12.4	7.0	27
DAH84.84.085.A2750.06	6	85	1.5	48	50	21.5	59	28	12.4	7.0	27
DAH84.84.100.A3250.07	7	100	1.5	48	50	30.0	80	33	14.4	8.0	32
DAH84.84.125.A4063.08	8	125	1.5	61	63	56.0	89	35	16.4	9.0	40

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specification of the screw, please see Technical Instructions.

### 配件

#### Spare Parts

芯轴刀柄式铣刀 Arbor Mounted Cutter	扳手 Allen Wrench	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	圆柱螺钉 Cylindrical screw	垫圈 Washer	锁紧栓 Tightening Bolt
DAH84...04	SW8,0 DIN 911	030.0412.T15P	T15PQ	10.25.912		
DAH84...05	SW8,0 DIN 911	030.0412.T15P	T15PQ	10.25.912	10.5.433	
DAH84...06	SW10,0 DIN 911	030.0412.T15P	T15PQ	12.30.912	13.0.433	
DAH84.84.100.A3250.07	SW14,0 DIN 911	030.0412.T15P	T15PQ	16.35.7984	17.0.433	
DAH84.84.125.A4063.08		030.0412.T15P	T15PQ			20.30.6367

# 高进给铣削 High Feed Milling



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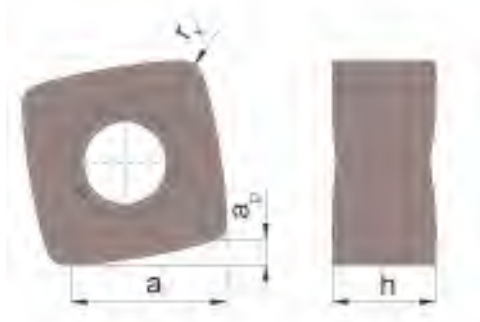
# DAH84



切深可达	Depth of cut up to	1.5 mm
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配合铣削刀杆  
for Milling tool

型号 DAHM82  
Type



正前角槽型  
positive geometry,  
8 usable cutting edges

产品型号 Part number	$a_p$	a	h	$r_x$	SA4B
<b>DAH.84.030.S.12</b>	1.5	9.8	7	1.2	▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
- 推荐 / recommended
- 次推荐 / alternative recommendation
- 不合适 / not suitable
- 非涂层 / uncoated grades
- 涂层 / 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



# 切削参数 系列 DAH84

## Cutting Data System DAH84



ISO	材料 Material	硬度 HB Hardness HB	进给/齿 $f_z$ (mm) Feed/tooth $f_z$ (mm)	切削速度 Cutting speed $v_c$ (m/min)
<b>P</b>	非合金钢 unalloyed steel	125	1.0 - 2.2	200 - 300
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	高合金钢 high alloyed steel	200	0.8 - 1.6	150 - 250
<b>M</b>	不锈钢 马氏体 Stainless steel martensitic	240	0.8 - 2.0	140 - 220
	不锈钢 奥氏体 Stainless steel austenitic	180	0.6 - 1.6	120 - 200
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<b>N</b>	铝合金 Al-alloys	90	1.5 - 3.0	1000 - 1500

### 编程半径和偏差

Programming radius and difference



理论圆角半径  $r_{th}$   
=编程半径  
theoretical corner radius  $r_{th}$   
= programming radius

最大偏差  
max. difference

$r_{th}$ (mm)	最大偏差 (mm) max. difference (mm)
3.25	0.96

