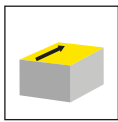


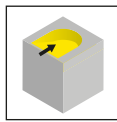


新牌号DAH8
高进给量铣削系统
扩展应用

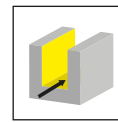
NEW GRADE FOR THE DAH8
HIGH-FEED MILLING SYSTEM
FOR EXTENDED APPLICATIONS



面铣
Face milling



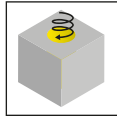
坡走铣
Ramping



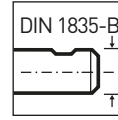
铣槽
Groove milling



内冷
Internal cooling



螺旋插补铣
Circular plunge milling



刀杆 DIN 1835-B
Shank form DIN 1835-B

无特殊说明外，所有尺寸单位为mm

All dimensions are in mm, unless otherwise stated.

交期

- ▲ 库存
- △ 4周

适用切削材质

- 推荐
- 可选
- 不适合

Delivery times:

- ▲ on stock
- △ 4 weeks

Use for material groups:

- recommended
- alternative recommendation
- not suitable

Die HORN-Trennstellencodierung - wofür wird sie benötigt?

Die Trennstellencodierung stellt sicher, dass Sie immer die zueinander passenden Werkzeuge finden und wird bei Werkzeughaltern und bei Schneidplatten ausgewiesen. Wenn die Codes übereinstimmen, kann die Schneidplatte im entsprechenden Werkzeughalter verwendet werden.

Das gilt auch für unser modulares Haltersystem, hier gibt die Trennstellencodierung die Schnittstelle zwischen Grundhalter und Kassette an.

HORN连接接口代码-需要它做什么?

连接接口代码确保您将始终找到适合刀具，并显示在刀杆和刀片上。如果代码匹配，则可以刀片装在对应刀杆上。这也适用于我们的模块化刀具系统，其中连接代码表示刀杆和刀夹之间的接口

HORN连接接口代码及可能的组合:

HORN connection interface codes and possible combinations:

HIS = 刀片座 / Insert seat

HWS = 工件侧接口 / Interface workpiece side

HIS	↔	HWS
HMS	↔	HWS

HMS = 机床侧接口 / Interface machine side

刀片示例

Example insert

产品型号 Part number	a_p	a	h	r_x	HIS	IG6B	SA4B	SC6A
DAH.82.030.S.08	1	6,8	4,5	0,8	DAH82	▲	▲	▲

刀杆示例

Example toolholder

产品型号 Part number	Z	Ds	a_p	h_2	h	d_s	d_k	l_2	b	C	d_2	HWS
DAH.82.040.A1635.05	5	40	1	33,5	35	16	33	22	8,4	5,6	16	DAH82

不同之处 更多可能

THE DIFFERENCE: MORE POSSIBILITIES

- **刀片牌号的延伸**

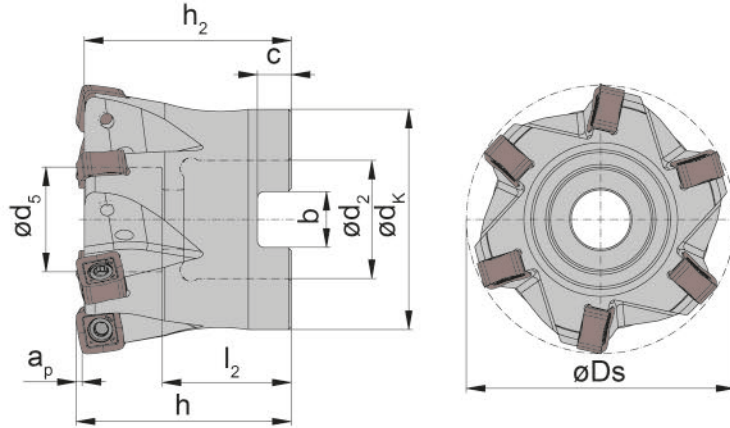
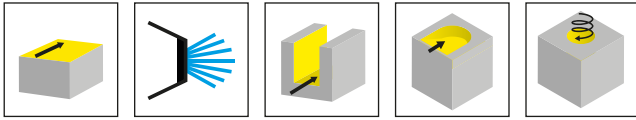
An extended range of grades

- **可转位的硬质合金牌号刀片，特别与应用相匹配，包括涂层**

Indexable insert with carbide grade specially matched to the application, including coating

- **精密压铸8切削刃刀片**

Precision sintered insert with 8 usable cutting edges



图示=右手型

Picture = right hand cutting version

产品型号 Part number	Z	Ds	ap	h ₂	h	d ₅	d _k	l ₂	b	C	d ₂	n _{max}	HWS
DAH82.040.A1635.05	5	40	1	33,5	35	16	33	22	8,4	5,6	16	14500	DAH82
DAH82.042.A1635.05	5	42	1	33,5	35	16	33	22	8,4	5,6	16	14000	DAH82
DAH82.050.A2240.06	6	50	1	38,5	40	19,5	41	24	10,4	6,3	22	13000	DAH82
DAH82.052.A2240.06	6	52	1	38,5	40	19,5	41	24	10,4	6,3	22	13000	DAH82
DAH82.063.A2240.07	7	63	1	38,5	40	19,5	49	24	10,4	6,3	22	13000	DAH82

配合标准DIN 830-A

Coupling system as per DIN 8030-A

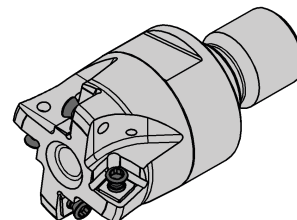
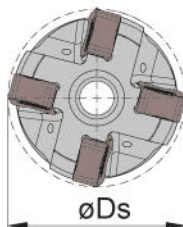
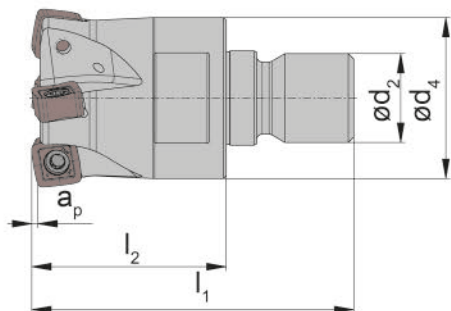
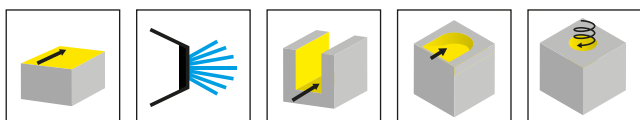
螺钉扭矩030.3070.T10P=3.0Nm

Torque specification of the screw 030.3070.T10P = 3,0 Nm.

备件

Spare Parts

芯轴式铣刀 Arbor Mounted Cutter	扳手 Allen Wrench	锁紧螺钉 Clamping Screw	TORX PLUS®-梅花扳手 TORX PLUS® Wrench	垫片 Washer	圆柱螺钉 Cylindrical screw
DAH82.04...	SW6,0 DIN911	030.3070.T10P	T10PL	8.4.433	8.25.912
DAH82.05.../06...	SW8,0 DIN 911	030.3070.T10P	T10PL	10.5.433	10.25.912



图示：右手型

Picture = right hand cutting version

产品型号 Part number	Z	Ds	l ₁	l ₂	d ₄	a _p	d ₂	SW	n _{max}	HWS	HMS
DAH82.020.M104.02	2	20	45	25	18	1	M10	15	21000	DAH82	10001
DAH82.025.M125.03	3	25	52	30	21	1	M12	17	18500	DAH82	12001
DAH82.032.M166.04	4	32	58	35	29	1	M16	24	16500	DAH82	16001
DAH82.035.M166.04	4	35	58	35	29	1	M16	24	15500	DAH82	16001
DAH82.040.M166.05	5	40	58	35	29	1	M16	24	14500	DAH82	16001

刀杆材质：钢

Material of shank: Steel

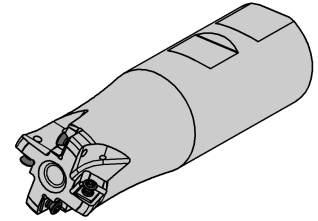
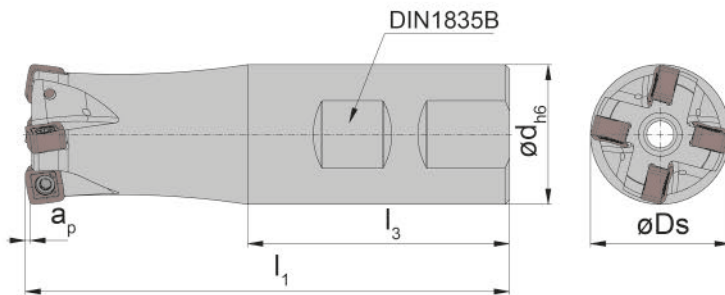
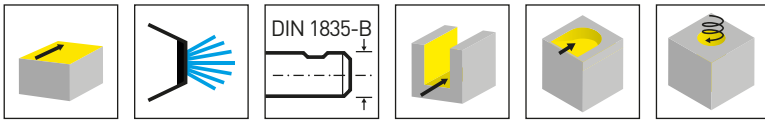
螺钉扭矩030.3070.T10P=3.0Nm

Torque specification of the screw 030.3070.T10P = 3,0 Nm.

备件

Spare Parts

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



图示：右刀型

Picture = right hand cutting version

产品型号 Part number	Z	Ds	d	l_1	l_3	a_p	n_{max}	HWS
DAH82.020.D204.02B	2	20	20	87	50	1	21000	DAH82
DAH82.025.D255.03B	3	25	25	101	56	1	18500	DAH82
DAH82.032.D326.04B	4	32	32	111	60	1	16500	DAH82
DAH82.035.D326.04B	4	35	32	111	60	1	15500	DAH82
DAH82.040.D326.05B	5	40	32	111	60	1	14500	DAH82

刀杆材质：钢

Material of shank: Steel

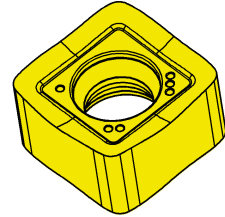
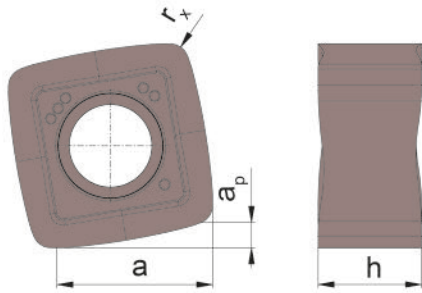
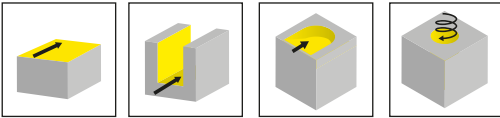
螺钉扭矩030.3070.T10P=3.0Nm

Torque specification of the screw 030.3070.T10P = 3,0 Nm.

备件

Spare Parts

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



▲ 库存

on stock

HIS

硬质合金牌号

Carbide grades

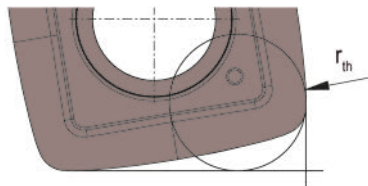
▲ 4周

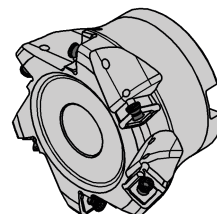
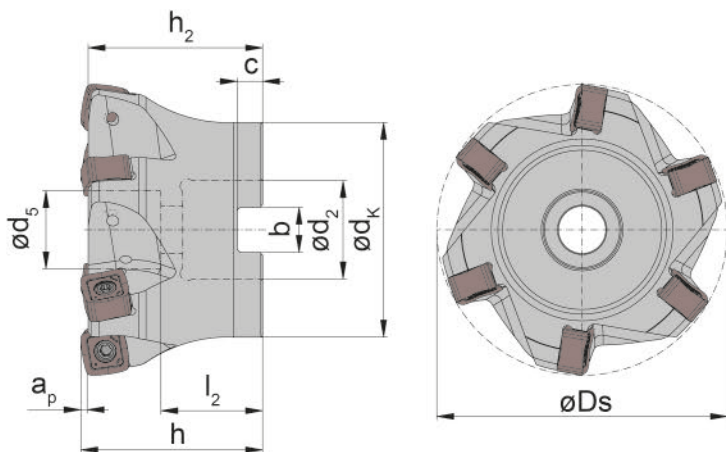
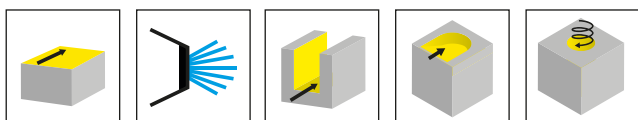
4 weeks

产品型号 Part number	a_p	a	h	r_x		IG6B	SA4B	SC6A
DAH.82.030.S.08	1	6,8	4,5	0,8	DAH82	▲	▲	▲
正几何型体 positive geometry						P ●	●	●
						M o	●	●
						K o	●	●
						N o	●	●
						S o	-	-
						H -	-	-

理论刀尖角 r_{th} =编程半径
根据要求提供实际外型

theoretical corner radius r_{th} = programming radius
actual outline upon request!





图示=右手型

Picture = right hand cutting version

产品型号 Part number	Z	Ds	ap	h ₂	h	d ₅	d _k	l ₂	b	C	d ₂	n _{max}	HWS
DAH84.050.A2240.04	4	50	1,5	38	40	16,5	41	25	10,4	6,3	22	8000	DAH84
DAH84.052.A2240.04	4	52	1,5	38	40	16,5	41	25	10,4	6,3	22	7500	DAH84
DAH84.063.A2240.05	5	63	1,5	38	40	19,5	49	25	10,4	6,3	22	6500	DAH84
DAH84.066.A2240.05	5	66	1,5	38	40	19,5	49	25	10,4	6,3	22	6500	DAH84
DAH84.080.A2750.06	6	80	1,5	48	50	21,5	59	28	12,4	7	27	5500	DAH84
DAH84.085.A2750.06	6	85	1,5	48	50	21,5	59	28	12,4	7	27	5500	DAH84
DAH84.100.A3250.07	7	100	1,5	48	50	30	80	33	14,4	8	32	5000	DAH84
DAH84.125.A4063.08	8	125	1,5	61	63	56	89	35	16,4	9	40	4000	DAH84

配合标准DIN830-A

Coupling system as per DIN 8030-A

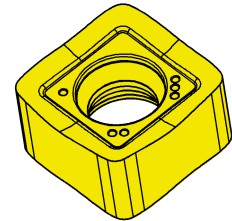
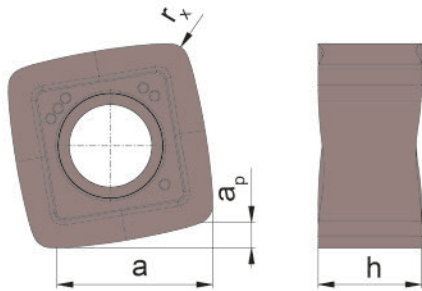
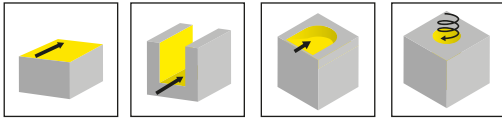
螺钉扭矩030.0412.T15P=5.0Nm

Torque specification of the screw 030.0412.T15P = 5,0 Nm.

备件

Spare Parts

芯轴式铣刀 Arbor Mounted Cutter	扳手 Allen Wrench	锁紧螺钉 Clamping Screw	TORX PLUS®- 梅花扳手 TORX PLUS® Wrench	圆柱螺钉 Cylindrical screw	垫片 Washer	锁紧螺栓 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	
DAH84.100.A3250.07	SW14,0 DIN 911	030.0412.T15P	T15PQ	16.35.7984	17.0.433	
DAH84.125.A4063.08		030.0412.T15P	T15PQ			20.30.6367



硬质合金牌号

Carbide grades

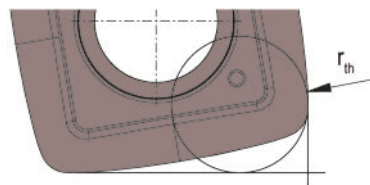
▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	a_p	a	h	r_x	HIS		IG6B	SA4B	SC6A
DAH.84.030.S.12	1,5	9,8	7	1,2	DAH84	▲	▲	▲	▲
正几何型体 positive geometry						P	●	●	●
						M	○	○	○
						K	○	○	○
						N	○	○	○
						S	○	-	-
						H	-	-	-

理论刀尖角 r_{th} =编程半径
根据要求提供实际外型

theoretical corner radius r_{th} = programming radius
actual outline upon request!



材料 Material		材料组 Material group	硬度 Hardness	抗拉强度 R _m [N/mm ²] Tensile Strength	示例 Example Material	
P	碳钢 Carbon steel	~ 0,2 % C	P1.1	125	430	CK15
		~ 0,4% C 退火 annealed	P1.2	190	610	19Mn6
		~ 0,4% C 调质 quenched	P1.3	210	640	36Mn5
		~ 0,6% C 退火 annealed	P1.4	190	610	C55
		~ 0,6% C 调质 quenched	P1.5	300	1000	CK60
		易切钢 Free cutting steel	P1.6	220	750	9SMn28
	合金钢 Stahl (<5%) Alloyed steel	退火 annealed	P2.1	180	590	100Cr6
		调质 quenched	P2.2	280	960	14NiCr10
		调质 quenched	P2.3	350	1250	34CrMo4
		调质 quenched	P2.4	430	1450	55Cr3
	高合金钢 Stahl (>5%) high alloyed steel	退火 annealed	P3.1	200	680	X10CrAl18
		硬化 hardened	P3.2	350	1200	X210Cr2
	铸钢 Cast steel	非合金 unalloyed	P4.1	180	590	GE200
		合金 alloyed	P4.2	220	750	GX40CrSi28
	烧结钢 Sintered steel	软 soft	P5.1	220	570	Sint-D39
	M	不锈钢 Stainless steel	马氏体铁素体 martensitic ferritic	M1.1	200	680
奥氏体铁素体 austenitic ferritic			M1.2	300	1000	X6CrNiMo- Ti17-12-2
铁素体奥氏体 ferritisch austenitic			M1.3	230	780	X2CrNi- Mo-N17-13-3
H	硬化钢 Hardened steels	50-55 HRC	H1.1	-	-	
		55-60 HRC	H1.2	-	-	
		60-63 HRC	H1.3	-	-	
		> 63HRC	H1.4	-	-	

材料 Material		材料组 Material group	硬度 Hardness	抗拉强度 R _m [N/mm ²] Tensile Strength	示例 Example Material	
K	灰铸铁 Grey cast iron	低抗拉强度 low tensile strength	K1.1	180	250	GG-25
		高抗拉强度 high tensile strength	K1.2	250	350	GG-40
	球墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	K2.1	160	400	GGG-40
		珠光体 perlitic	K2.1	260	700	GGG-60
	可锻铸铁 Malleable cast iron	铁素体 ferritic	K3.1	200	400	GTW-45
		珠光体 perlitic	K3.2	260	700	GTS-55-04
	奥氏体球墨铸铁/ ADI Ausferritic spheroidal cast iron / ADI	调质 quenched	K4.1	260	800	
		调质 quenched	K4.2	350	1050	
		调质 quenched	K4.3	450	1400	
	N	Al-铝合金 Al-alloys	热前 not heat	N1.1	30	
热后 heat treatable			N1.2	100	340	AlMgSi1
Al-铸铝 Al-cast-alloy		< 6% Si	N2.1	80	300	AlMgSi6
		6-10% Si	N2.2	100	320	AlSi7Mg
		10-15 % Si	N2.3	130	450	AlSi12
铜合金 Copper-alloys		纯铜 Pure copper	N3.1	100	340	Cu
		青铜 Bronze Brass	N3.2	90	310	CuZn40Pb
		无铅黄铜 Lead-free brass	N3.3	110	430	CuZn40
		高强度 high strength	N3.4	300	1000	CuZ- n25Al5-Mn4Fe3
石墨 Graphite			N4.1			
S	耐热合金 Heat resistant alloy	退火 annealed	S1.1	200	670	
		硬化 hardened	S1.2	275	930	
	(Ni,Co) 耐热合金 (Ni, Co) Heat resistant alloy	退火 annealed	S2.1	250	840	Inconel 600
		硬化 hardened	S2.2	350	1200	Inconel 713

切削速度Vc(m/min)/初始值 Cutting speed vc (m/min) / Start values										
	K10	TA4_	AS4_	SA4_	SD6_	SC6_	IG3_ IG6_	NE2_	HD05	PD75
		160-140	300-220	180-140	300-220	300-220	200-160			
		160-140	260-220	160-140	260-220	260-220	180-160			
		160-140	260-220	160-140	260-220	260-220	180-160			
		160-140	260-220	160-140	260-220	260-220	180-160			
		1200-500	1000-350	1200-500					3000-500	3000-500
		1200-500	1000-350	1200-500					3000-500	3000-500
	600-350	1200-500	1000-350	1200-500				3000-500	3000-500	3000-500
	600-350	1200-500		1200-500				2000-500	3000-500	3000-500
		1200-500		1200-500				1500-350	3000-500	3000-500
	230-180	1200-500		1200-500				300-220	3000-500	3000-500
	230-180	1200-500		1200-500				230-180	3000-500	3000-500
	230-180	1200-500		1200-500				240-180	3000-500	3000-500
	230-180	1200-500		1000-500				250-160	3000-500	3000-500
		30-25		70-30		80-30	80-30			
		30-25		70-30		80-30	80-30			
		30-25		70-30		80-30	80-30			
		30-25		70-30		80-30	80-30			

材料 Material		材料组 Material group	硬度 Hardness	抗拉强度 R _m [N/mm ²] Tensile Strength	示例 Example Material
S 钛合金 Titan	α 钛合金 Titanium alloy α	S3.1	120	240	
	α-β 钛合金 Titanium alloy α-β	S3.2	360	1200	
	β 钛合金 Titanium alloy β	S3.3	410	1400	
O	热塑性塑料 Thermoplastics				
	硬塑料 Duro plaste				
	玻璃纤维增强塑料 Plastics glass fibre reinforced	GFK	01.3		
	碳纤维增强塑料 Plastics carbon fibre reinforced	CKF	01.4		

	切削速度Vc(m/min)/初始值 Cutting speed vc (m/min) / Start values									
	K10	TA4_	AS4_	SA4_	SD6_	SC6_	IG3_ IG6_	NE2_	HD05	PD75
		30-25		70-30		80-30	80-30			
		30-25		70-30		80-30	80-30			
		30-25		70-30		80-30	80-30			
	1500-500							500-1500		
	1500-500							500-1500		



**FINDEN SIE JETZT IHRE
PASSENDE WERKZEUGLÖSUNG.**

FIND YOUR RIGHT
TOOLING SOLUTION NOW.

horn-group.com

DEUTSCHLAND, STAMMSITZ

GERMANY, HEADQUARTERS

—

Hartmetall Werkzeugfabrik
Paul Horn GmbH
Horn-Straße 1
D-72072 Tübingen

Tel +49 7071 / 70040

Fax +49 7071 / 72893

info@de.horn-group.com

horn-group.com

CHINA

—

HORN (Shanghai) Trading Co. Ltd.
Room 905, No. 518 Anyuan Road,
P.R. of China Putuo District,
Shanghai 200060 上海市安远路518
号905室 邮编: 200060

Tel +86 21 52833505 ; 52833205

Fax +86 21 52832562

info@phorn.cn

www.phorn.cn