**September 2025 | EMO Hannover**

**DA65 milling system**

Horn is expanding its DA milling system for corner, face and plunge milling. With the DA65 type, the system offers a larger insert than the existing DA62. This enables greater axial cutting depths during the process. Horn uses a six-edged indexable insert. The insert can be used on both sides and has three axial and radial cutting edges on each side. A large core cross-section with maximum insert length is the impressive feature of the precision-sintered triangular insert. Despite the negative insert angle, the insert design results in a positive cutting geometry, which leads to easy cutting. The six inserts per indexable insert result in a good cost-per-cutting-edge ratio.

The DA65 system can be used as a roughing and finishing system. In tests, the milling system achieved surfaces during finishing that meet market requirements. The choice of axial and radial angles has been proven to result in lower torsional moment and lower transverse load on the spindle compared to previous systems. This allows the system to be used on less powerful machines with unstable operating conditions. Another advantage of the selected axial angle is the good chip removal, especially in helical plunge operations.

The cutting edge geometry generates a precise 90° corner angle with a maximum cutting depth of 7 mm (0.276"). The patented indexable inserts are available with corner radii of 0.8 mm (0.031") and 1.2 mm (0.047"). The proven SA4B carbide substrate is suitable as an all-rounder for milling steel, stainless steel, cast iron and aluminium. The inserts are also available in the carbide grades SC6A and IG6B for machining other material groups.

The tools are available as end mills in diameters of 32 mm (1.260") and 40 mm (1.575"). In these types, they are equipped with two or three inserts. The tools are available as shell milling cutters with cutting diameters of 50 mm (1.969"), 63 mm (2.480"), 80 mm (3.150") and 100 mm (3.937"). Depending on the diameter, there are four, five, seven, nine or eleven teeth. All tools have targeted internal cooling to the cutting zone.

The DA65 milling system guarantees process reliability across a wide range of applications, high expertise and economic benefits for the user.

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**photo caption:** The six inserts per indexable insert result in a good cost-per-cutting-edge ratio.

Source: Horn/Sauermann



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Source: Horn/Sauermann

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