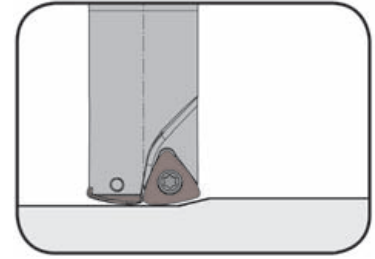


MILLING HEAD Type

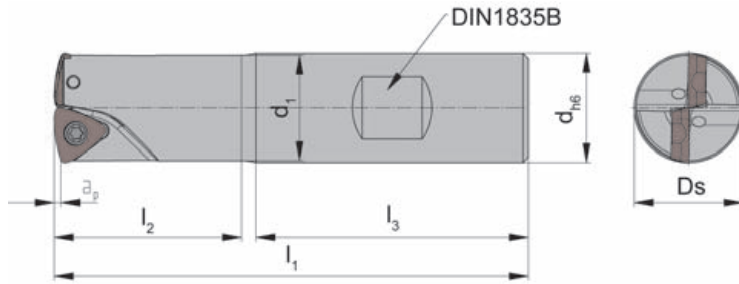
DAHM



Cutting edge Ø

40/32/25/20 mm

Material of shank: Steel



for use with Indexable insert

Type DAH37

Part number	Z	Ds	a_p	l_1	l_2	l_3	d_1	d
DAHM.37.020.D204.02B	2	20	1.2	87	34	50	19	20
DAHM.37.025.D255.03B	3	25	1.2	101	41	56	24	25
DAHM.37.032.D326.04B	4	32	1.2	111	47	60	31	32
DAHM.37.040.D326.05B	5	40	1.2	111	47	60	39	32

Dimensions in mm

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

N

Spare parts

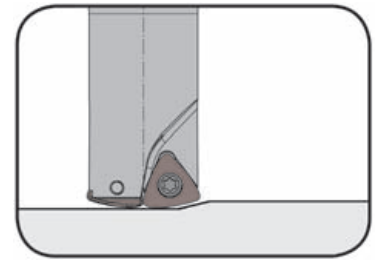
Milling head	Screw	TORX PLUS® Wrench
DAHM.37.0...	030.3070.T10P	T10PL

N20

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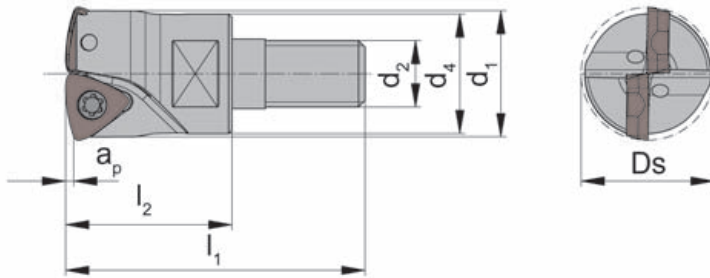
SCREW-IN CUTTER Type

DAHM



Cutting edge \varnothing 40/32/25/20 mm

Material of shank: Steel



for use with Indexable insert

Type DAH37

suitable for
Shank Type MD

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

Dimensions in mm

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

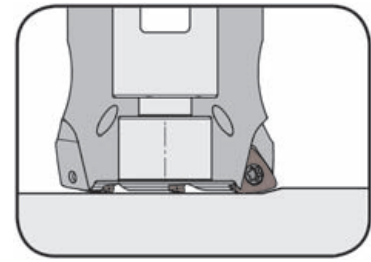
Spare parts

Screw-in cutter	Screw	TORX PLUS® Wrench
DAHM.37.0...	030.3070.T10P	T10PL



MILLING CUTTER Type

DAHM



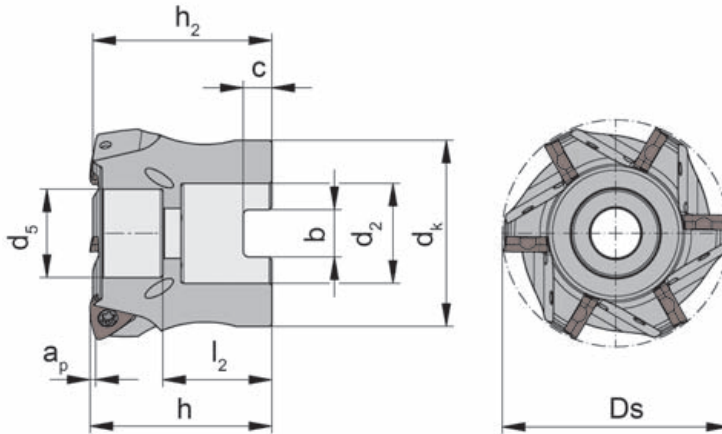
Cutting edge \varnothing

40/50/63/80 mm

Arbor mounted cutter as per DIN 8030-A

for use with Indexable insert

Type DAHM37



Picture = right hand cutting version

Type arbor mounted

Part number	Z	Ds	a_p	h	h_2	d_k	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.A2740.07	7	63	1.2	45	44.4	49	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

Dimensions in mm

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

N

Spare parts

Milling cutter	Screw	TORX PLUS® Wrench
DAHM.37.0...	030.3070.T10P	T10PL

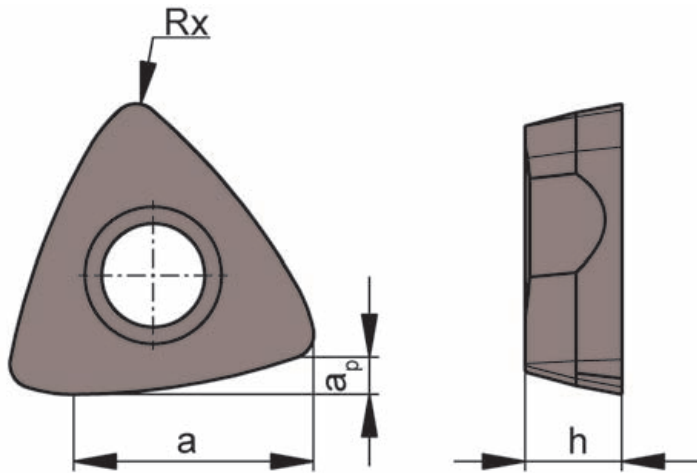
INDEXABLE INSERT Type

DAH37

Depth of cut up to .047"

for use with Milling head

Type DAHM37



Part number	a_p	a	h	r_x	SA4B
DAH.37.022.N.08	.047	.311	.125	.031	▲
▲ on stock Δ 4 weeks					P ●
● main recommendation					M ●
○ alternative recommendation					K ●
■ uncoated grades					N ●
■ coated grades					S ●
■ brazed/Cermet					H ●

Dimensions in inch Carbide grades

N

Z = Number of teeth

d_{eff} = effective cutting edge \emptyset

n = Revolutions
$$n = \frac{v_c \cdot 1000}{d \cdot \pi} \text{ (1/min) (RPM)}$$

v_c = Cutting speed
$$v_c = \frac{d \cdot \pi \cdot n}{1000} \text{ (m/min)} / .3048 = \text{sfm}$$

f_z = Feed/tooth
$$f_z = \frac{V_f}{Z \cdot n} \text{ (mm)} / 25.4 = \text{inch}$$

v_f = Feed rate
$$V_f = f_z \cdot Z \cdot n \text{ (mm/min)} / 25.4 = \text{inch/min}$$

Q = Material removal rate
$$Q = \frac{a_e \cdot a_p \cdot V_f}{1000} \text{ (cm}^3\text{/min)} \cdot .06102376 = \text{inch}^3\text{/min}$$

The effective cutting diameter d_{eff} must be calculated to obtain the correct RPM and the cutting feed.

The effective cutting diameter is calculated using the following values and formula.

a_p = depth of cut

D_s = cutter diameter

K_D = from Correction value chart

$$d_{\text{eff}} = K_D + (D_s - 20)$$

Correction value

a_p [mm]	K_D [mm]
0.1	9.71
0.2	11.47
0.3	12.81
0.4	13.93
0.5	14.92
0.6	15.82
0.7	16.63
0.8	17.39
0.9	18.10
1.0	18.77
1.1	19.40
1.2	20.00

N

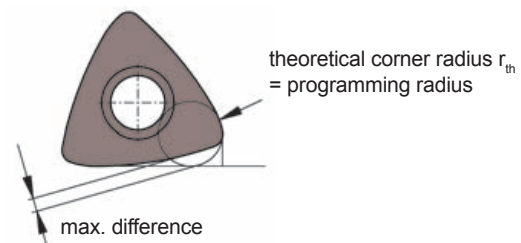
ISO	Material	Hardness HB	feed / tooth		Cutting speed	
			f _z (inch)	f _z (mm)	v _c (ft/min)	v _c (m/min)
P	unalloyed steel	125	.032-.087	0.8 - 2.2	655-985	200 - 300
	unalloyed steel	190	.032-.087	0.8 - 2.2	655-985	200 - 300
	low alloyed steel	200	.032-.079	0.8 - 2.0	590-985	180 - 300
	low alloyed steel	300	.032-.079	0.8 - 2.0	525-920	160 - 280
	high alloyed steel	200	.024-.063	0.6 - 1.6	490-820	150 - 250
M	Stainless steel martenistic	240	.032-.079	0.8 - 2.0	460-720	140 - 220
	Stainless steel austenitic	180	.024-.063	0.6 - 1.6	395-655	120 - 200
K	Malleable cast iron ferritic	130	.032-.087	0.8 - 2.2	525-920	160 - 280
	Malleable cast iron perlitic	230	.028-.071	0.7 - 1.8	490-820	150 - 250
	Spheroidal graphite cast iron ferritic/perlitic	180	.028-.071	0.7 - 1.8	490-820	150 - 250
	Spheroidal graphite cast iron perlitic	260	.028-.071	0.7 - 1.8	460-785	140 - 240
	Grey cast iron	160	.032-.098	0.8 - 2.5	590-1050	180 - 320
N	Al-alloys	90	.039-.118	1.0 - 3.0	3280-4921	1000 - 1500

Diving angle

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

Programming radius and difference

r _{th} (inch)	max. difference (inch)
.079" (2.0 mm)	.033" (0.83 mm)


N