

HM-Wechselklingen

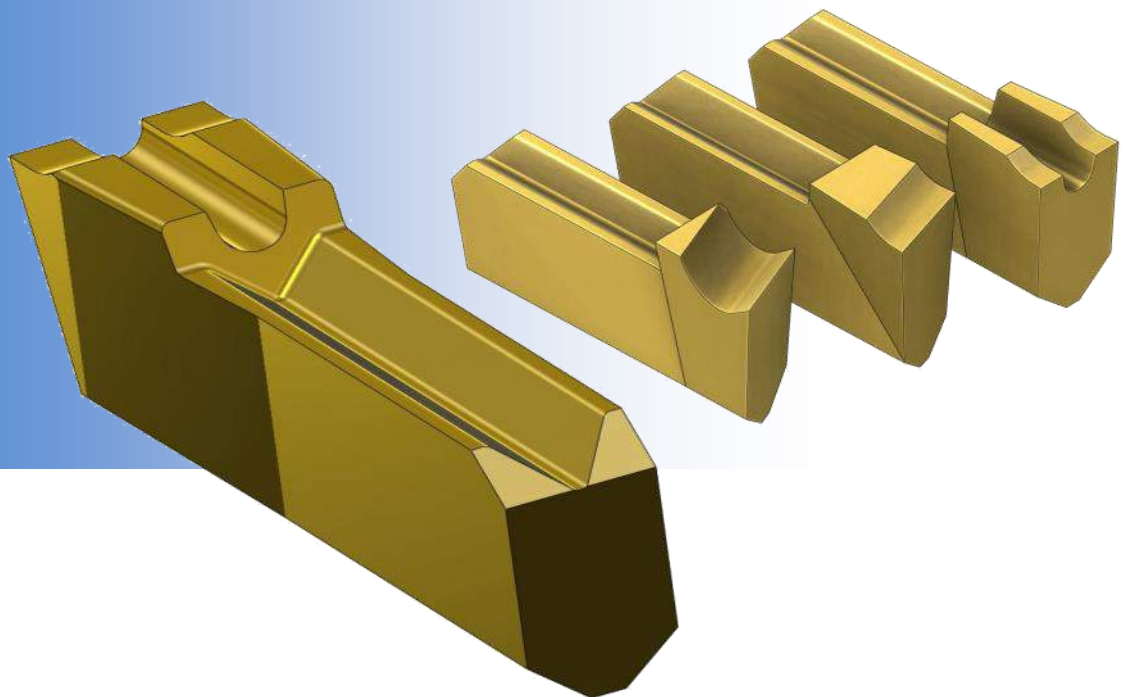
Carbide interchangeable blades

Lames interchangeables en carbure

HM-Wechselklingentypen

Types of interchangeable carbide inserts

Types de lames interchangeables

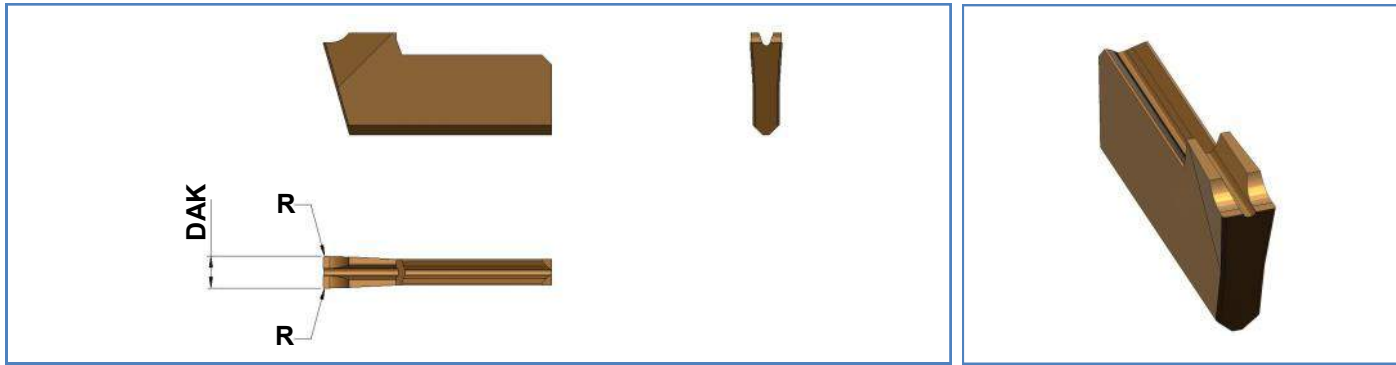


HM-Wechselklingen

Carbide interchangeable blades
Lames interchangeables en carbure

DAK-16-0-NF...

Standard type, universell einsetzbar
The standard type, universally applicable
La géométrie standard à usage universel



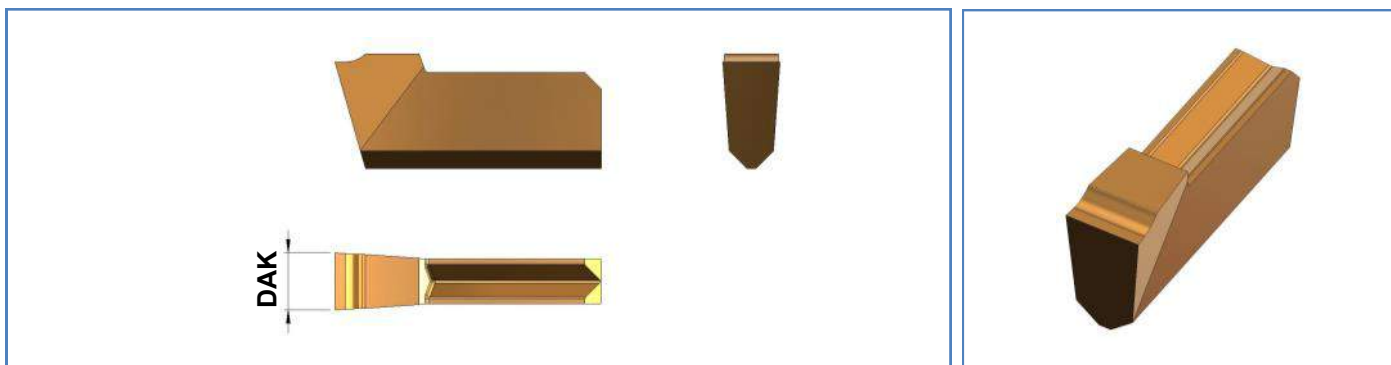
Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
107486	DAK-16-0-NF-UFK-2	1.6	-	UFK-2 (K15/K20)	-
107487	DAK-16-0-NF-UFK-4	1.6	-	UFK-4 (K40)	-
107409	DAK-16-0-NF-UFK2-BD1	1.6	-	UFK-2 (K15/K20)	BD1 (TiN)
107988	DAK-16-0-NF-UFK4-BD2	1.6	-	UFK-4 (K40)	BD2 (TiCN)
144231	DAK-16-0-R0.1-NF-UFK4-BD2	1.6	0,1	UFK-4 (K40)	BD2 (TiCN)

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DAK-16-0-E-...

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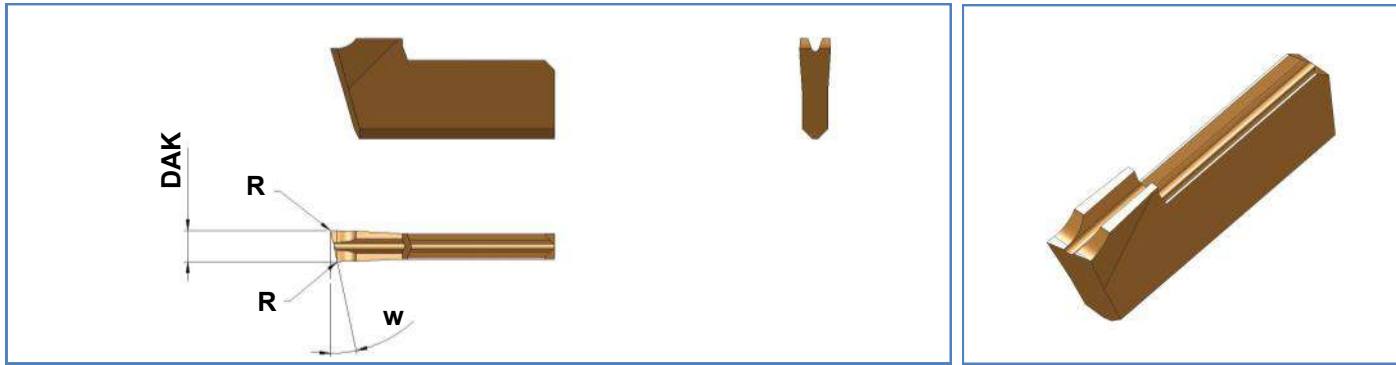
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	158727	DAK-16-0-E-UFK-4	1.6	-	UFK-2 (K15/K20)	-

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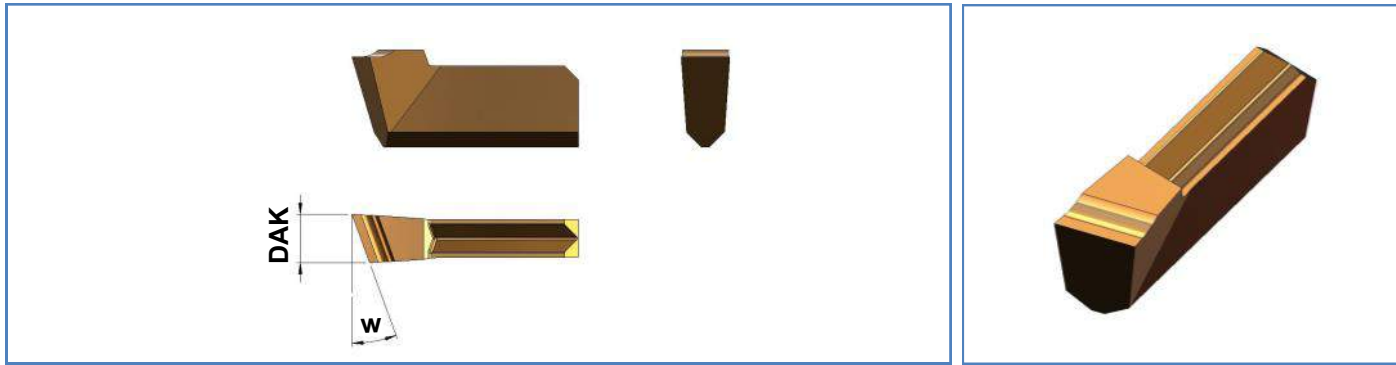
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107494	DAK-16-4-RF-UFK-2	1.6	-	4°	UFK-2 (K15/K20)	-
	107495	DAK-16-4-RF-UFK-4	1.6	-	4°	UFK-4 (K40)	-
	107410	DAK-16-4-RF-UFK2-BD1	1.6	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	136608	DAK-16-4-RF-UFK2-BD2	1.6	-	4°	UFK-2 (K15/K20)	BD2 (TiCN)
	107992	DAK-16-4-RF-UFK4-BD2	1.6	-	4°	UFK-4 (K40)	BD2 (TiCN)
	108322	DAK-16-4-RF-UFK4-BD3	1.6	-	4°	UFK-4 (K40)	BD3 (TiAlN)
	118040	DAK-16-4-RF-UFK4-BD7	1.6	-	4°	UFK-4 (K40)	BD7 (AlCrN)
	107490	DAK-16-12-RF-UFK-2	1.6	-	12°	UFK-2 (K15/K20)	-
	107491	DAK-16-12-RF-UFK-4	1.6	-	12°	UFK-4 (K40)	-
	107412	DAK-16-12-RF-UFK2-BD1	1.6	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	107990	DAK-16-12-RF-UFK4-BD2	1.6	-	12°	UFK-4 (K40)	BD2 (TiCN)
	108171	DAK-16-18-RF-UFK4-BD2	1.6	-	18°	UFK-4 (K40)	BD2 (TiCN)

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DAK-16-...-E-R...

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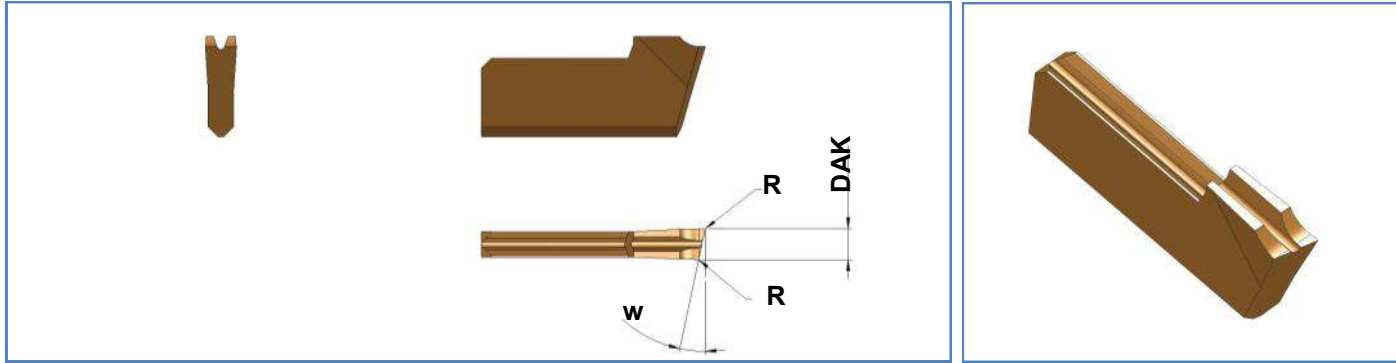
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	158729	DAK-16-4-E-R-UFK-4	1.6	4°	UFK-4 (K40)	-
	158731	DAK-16-6-E-R-UFK-4	1.6	6°	UFK-4 (K40)	-
	158733	DAK-16-12-E-R-UFK-4	1.6	12°	UFK-4 (K40)	-
	158736	DAK-16-20-E-R-UFK-4	1.6	20°	UFK-4 (K40)	-

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DAK-16-...-LF...

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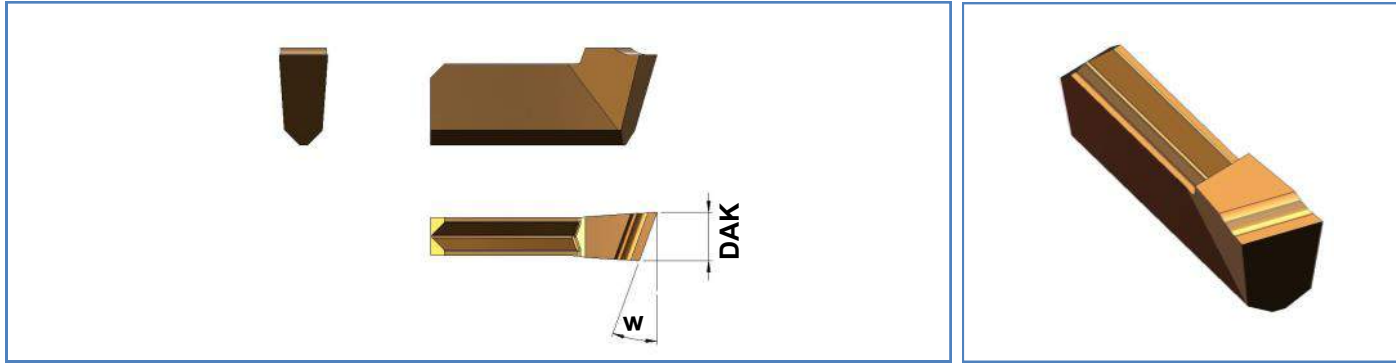
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107492	DAK-16-4-LF-UFK-2	1.6	-	4°	UFK-2 (K15/K20)	-
	107493	DAK-16-4-LF-UFK-4	1.6	-	4°	UFK-4 (K40)	-
	107411	DAK-16-4-LF-UFK2-BD1	1.6	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	107991	DAK-16-4-LF-UFK4-BD2	1.6	-	4°	UFK-4 (K40)	BD2 (TiCN)
	107488	DAK-16-12-LF-UFK-2	1.6	-	12°	UFK-2 (K15/K20)	-
	107489	DAK-16-12-LF-UFK-4	1.6	-	12°	UFK-4 (K40)	-
	107413	DAK-16-12-LF-UFK2-BD1	1.6	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	107989	DAK-16-12-LF-UFK4-BD2	1.6	-	12°	UFK-4 (K40)	BD2 (TiCN)

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DAK-16-...-E-L...

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Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
158728	DAK-16-4-E-L-UFK-4	1.6	4°	UFK-4 (K40)	-
158730	DAK-16-6-E-L-UFK-4	1.6	6°	UFK-4 (K40)	-
158732	DAK-16-12-E-L-UFK-4	1.6	12°	UFK-4 (K40)	-
158734	DAK-16-20-E-L-UFK-4	1.6	20°	UFK-4 (K40)	-

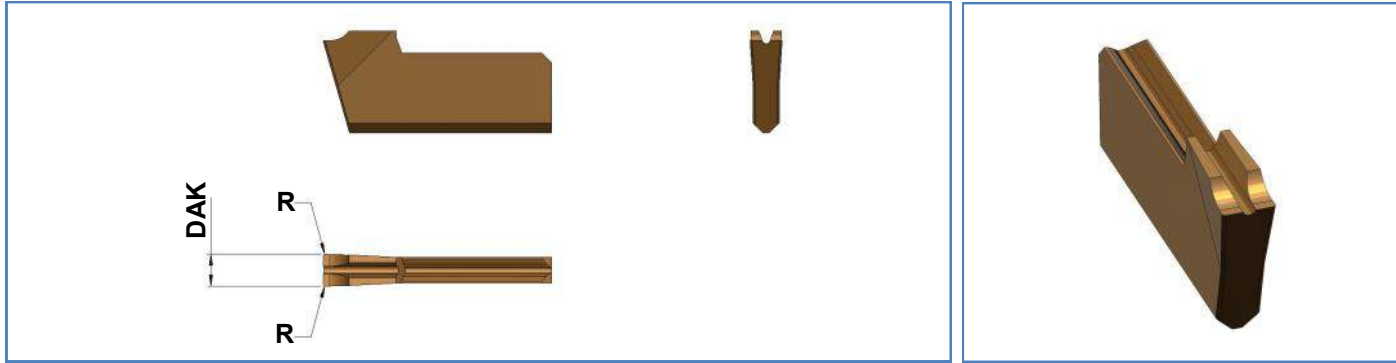
DAK-24-...-NF...

Standardtype, universell einsetzbar / The standard type, universally applicable / La géométrie standard à usage universel

DAK-24-...R-NF...

Spezialgeometrie für rostfreie Stähle und weichen Stahl, für höheren Vorschub, bessere Oberfläche, längere Standzeiten

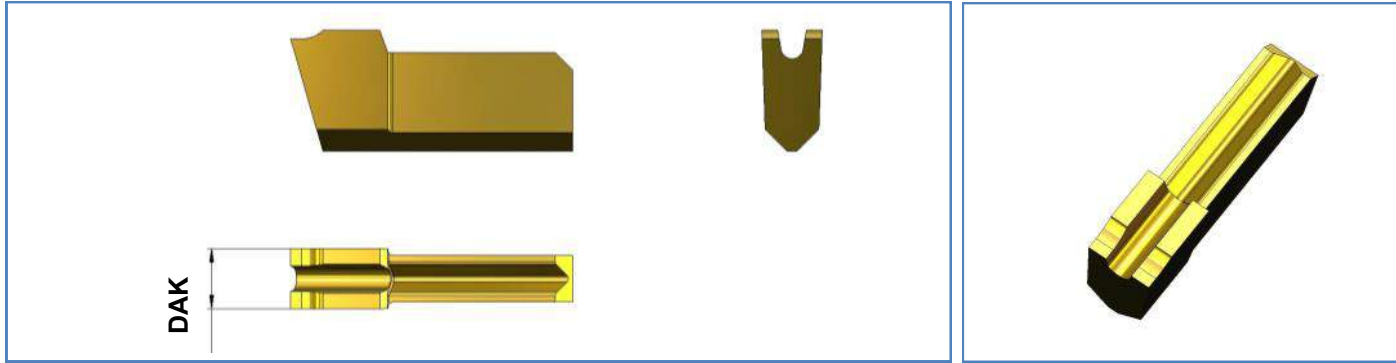
Special geometry for stainless steel and soft steel, for higher feed, better surface quality and longer tool life
Géométrie spéciale pour des aciers inoxydables ou doux, pour l'avance élevé, une surface supérieure et une durée de vie longue.



Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
107496	DAK-24-0-NF-UFK-2	2.4	-	UFK-2 (K15/K20)	-
107497	DAK-24-0-NF-UFK-4	2.4	-	UFK-4 (K40)	-
107414	DAK-24-0-NF-UFK2-BD1	2.4	-	UFK-2 (K15/K20)	BD1 (TiN)
107993	DAK-24-0-NF-UFK4-BD2	2.4	-	UFK-4 (K40)	BD2 (TiCN)
112672	DAK-24-0-R-NF-UFK-2	2.4	0,15	UFK-2 (K15/K20)	-
109239	DAK-24-0-R-NF-UFK-4	2.4	0,15	UFK-4 (K40)	-
110795	DAK-24-0-R-NF-UFK2-BD1	2.4	0,15	UFK-2 (K15/K20)	BD1 (TiN)
109238	DAK-24-0-R-NF-UFK4-BD2	2.4	0,15	UFK-4 (K40)	BD2 (TiCN)
111201	DAK-24-0-R-NF-UFK4-BD3	2.4	0,15	UFK-4 (K40)	BD3 (TiAlN)

DAK-24-...P-NF...

Parallel geschliffen, für optimale Oberfläche
 Parallely ground, for optimized surface quality
 Rectifié parallèlement, pour une surface optimale



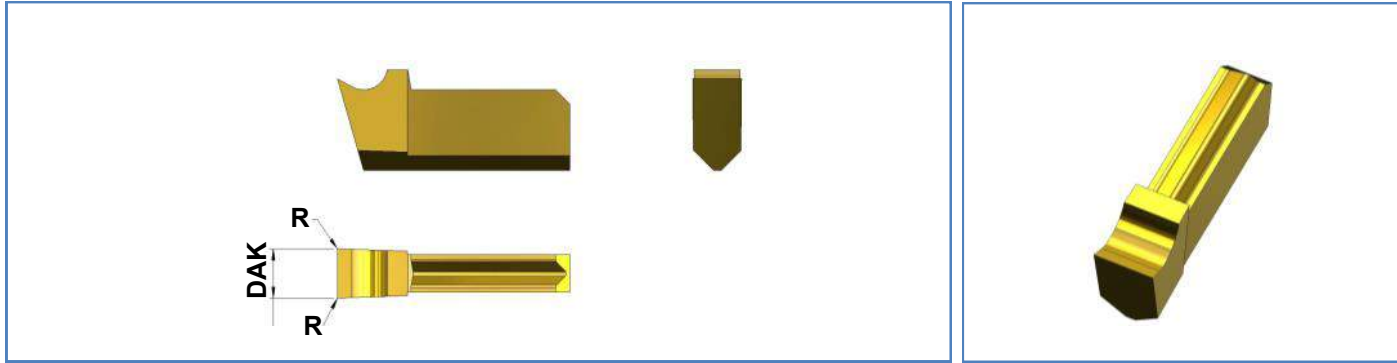
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107498	DAK-24-0-P-NF-UFK-2	2.4	-	UFK-2 (K15/K20)	-
	107499	DAK-24-0-P-NF-UFK-4	2.4	-	UFK-4 (K40)	-
	107419	DAK-24-0-P-NF-UFK2-BD1	2.4	-	UFK-2 (K15/K20)	BD1 (TiN)
	107994	DAK-24-0-P-NF-UFK4-BD2	2.4	-	UFK-4 (K40)	BD2 (TiCN)

DAK-24-0-AL-N...

für Drehen von Aluminium, NE-legierten Werkstoffen und Kunststoffen

For turning aluminium, non-ferrous materials and plastics

Pour tournage d'aluminium, de matériels non-ferreux et de plastiques



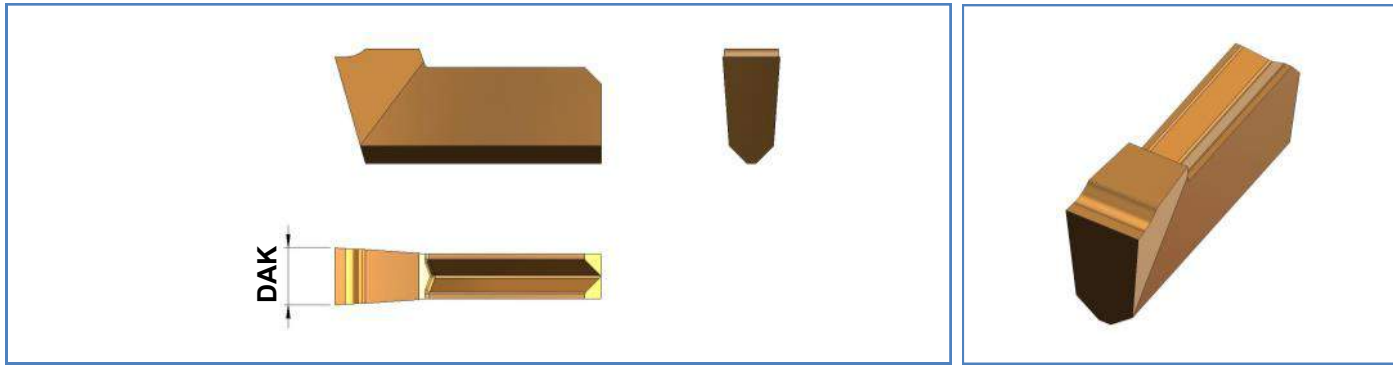
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	125198	DAK-24-0-AL-N-UFK-2	2.4	-	UFK-2 (K15/K20)	-
	127662	DAK-24-0-AL-N-UFK2-BD3	2.4	-	UFK-2 (K15/K20)	BD3 (TiAlN)
	125199	DAK-24-0-AL-N-UFK2-BD8	2.4	-	UFK-2 (K15/K20)	BD8 (TiB2)
	125787	DAK-24-0-R01-AL-N-UFK-2	2.4	0,1	UFK-2 (K15/K20)	-
	127663	DAK-24-0-R01-AL-N-UFK2-BD3	2.4	0,1	UFK-2 (K15/K20)	BD3 (TiAlN)
	126292	DAK-24-0-R01-AL-N-UFK2-BD8	2.4	0,1	UFK-2 (K15/K20)	BD8 (TiB2)

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Carbide interchangeable blades
Lames interchangeable en carbure

DAK-24-0-E-...

Standard type, universell einsetzbar
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Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
158737	DAK-24-0-E-UFK-4	2.4	-	UFK-2 (K15/K20)	-

Otto Dieterle Spezialwerkzeuge GmbH,
 Predigerstr. 56, 78628 Rottweil, Germany Tel.: +49(0) 741 94205-0 Fax: +49(0) 741 94205-50 info@dieterle-tools.com
 www.dieterle-tools.com

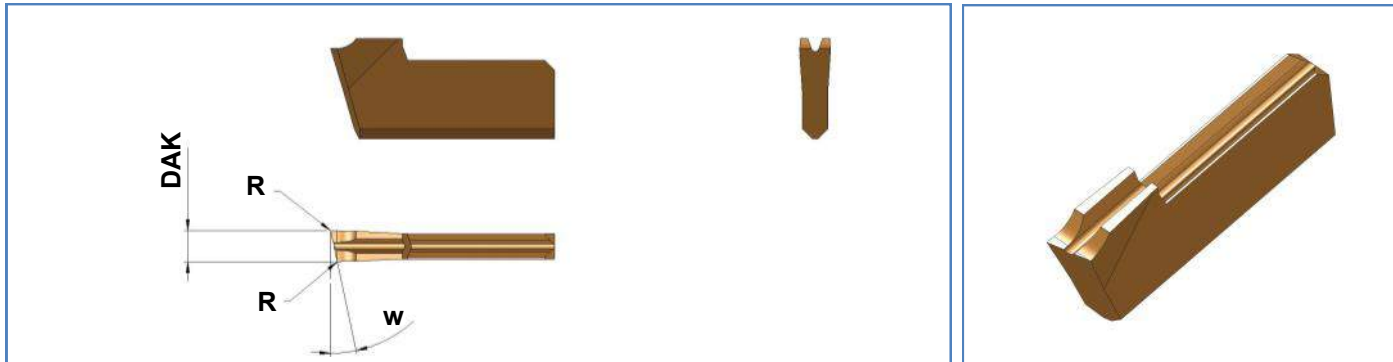
DAK-24-...-RF...

Standard type, universell einsetzbar / Standard type, universally applicable / Géométrie standard à usage universel

DAK-24-...R-RF...

Spezialgeometrie für rostfreie Stähle und weichen Stahl, für höheren Vorschub, bessere Oberfläche, längere Standzeiten

Special geometry for stainless steel and soft steel, for higher feed, better surface quality and longer tool life
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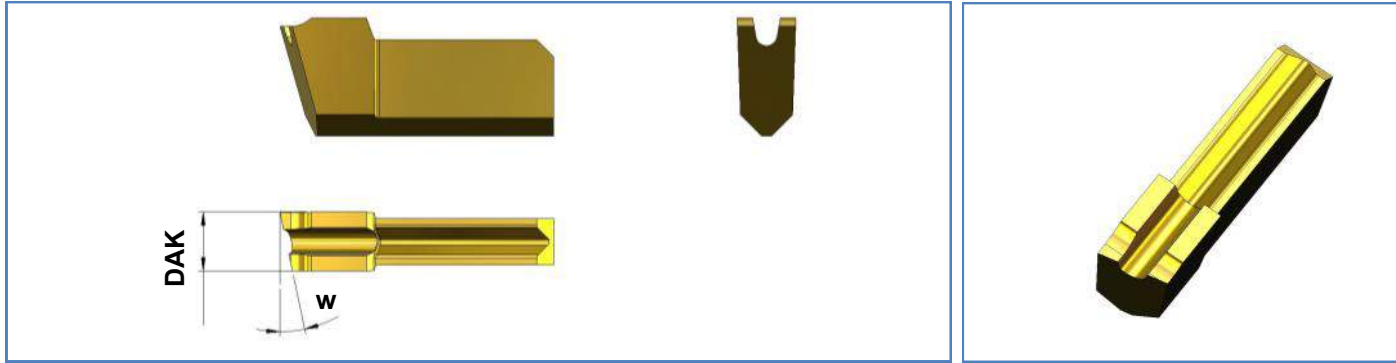


Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
107514	DAK-24-4-RF-UFK-2	2.4	-	4°	UFK-2 (K15/K20)	-
107515	DAK-24-4-RF-UFK-4	2.4	-	4°	UFK-4 (K40)	-
107415	DAK-24-4-RF-UFK2-BD1	2.4	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
108001	DAK-24-4-RF-UFK4-BD2	2.4	-	4°	UFK-4 (K40)	BD2 (TiCN)
118041	DAK-24-4-RF-UFK4-BD7	2.4	-	4°	UFK-4 (K40)	BD7 (AlCrN)
107506	DAK-24-12-RF-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
107507	DAK-24-12-RF-UFK-4	2.4	-	12°	UFK-4 (K40)	-
107417	DAK-24-12-RF-UFK2-BD1	2.4	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
109081	DAK-24-12-RF-UFK2-BD2	2.4	-	12°	UFK-2 (K15/K20)	BD2 (TiCN)
107997	DAK-24-12-RF-UFK4-BD2	2.4	-	12°	UFK-4 (K40)	BD2 (TiCN)
111890	DAK-24-15-RF-UFK4-BD2	2.4	-	15°	UFK-4 (K40)	BD2 (TiCN)
108426	DAK-24-18-RF-UFK2-BD1	2.4	-	18°	UFK-2 (K15/K20)	BD1 (TiN)
145954	DAK-24-18-RF-UFK4-BD2	2.4	-	18°	UFK-4 (K40)	BD2 (TiCN)
108638	DAK-24-25-RF-UFK2-BD1	2.4	-	25°	UFK-2 (K15/K20)	BD1 (TiN)

122268	DAK-24-5-R-RF-UFK-2	2.4	0,15	5°	UFK-2 (K15/K20)	-
109240	DAK-24-5-R-RF-UFK-4	2.4	0,15	5°	UFK-4 (K40)	-
122290	DAK-24-5-R-RF-UFK2-BD1	2.4	0,15	5°	UFK-2 (K15/K20)	BD1 (TiN)
109237	DAK-24-5-R-RF-UFK4-BD2	2.4	0,15	5°	UFK-4 (K40)	BD2 (TiCN)

DAK-24-...P-RF...

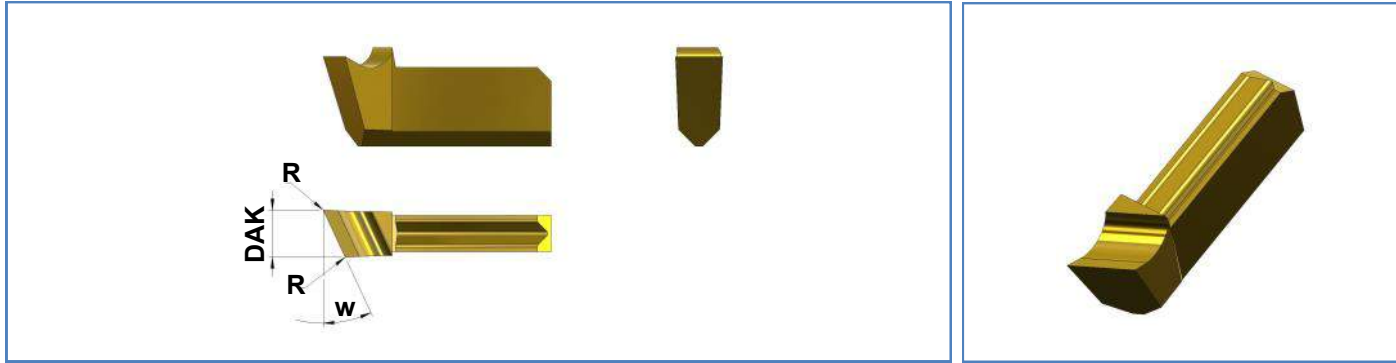
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	107512	DAK-24-4-P-RF-UFK-2	2.4	-	4°	UFK-2 (K15/K20)	-
	107513	DAK-24-4-P-RF-UFK-4	2.4	-	4°	UFK-4 (K40)	-
	128694	DAK-24-4-P-RF-UFK-4-BD3	2.4	-	4°	UFK-4 (K40)	BD3 (TiAlN)
	107420	DAK-24-4-P-RF-UFK2-BD1	2.4	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	108002	DAK-24-4-P-RF-UFK4-BD2	2.4	-	4°	UFK-4 (K40)	BD2 (TiCN)
	107504	DAK-24-12-P-RF-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
	107505	DAK-24-12-P-RF-UFK-4	2.4	-	12°	UFK-4 (K40)	-
	107422	DAK-24-12-P-RF-UFK2-BD1	2.4	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	107998	DAK-24-12-P-RF-UFK4-BD2	2.4	-	12°	UFK-4 (K40)	BD2 (TiCN)

DAK-24-...-AL-R...

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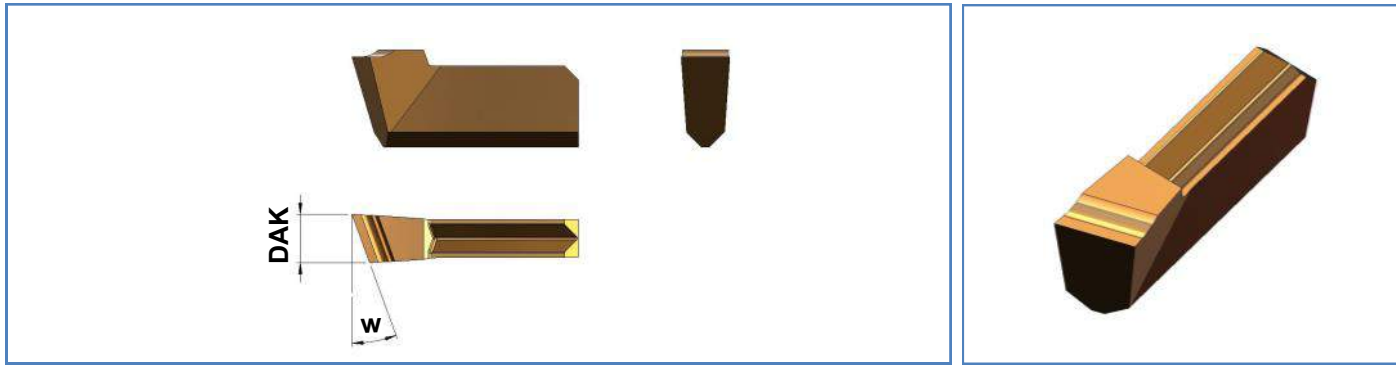
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	125783	DAK-24-12-AL-R-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
	127661	DAK-24-12-AL-R-UFK2-BD3	2.4	-	12°	UFK-2 (K15/K20)	BD3 (TiAlN)
	126450	DAK-24-12-AL-R-UFK2-BD8	2.4	-	12°	UFK-2 (K15/K20)	BD8 (TiB2)
	125785	DAK-24-12-R01-AL-R-UFK-2	2.4	0,1	12°	UFK-2 (K15/K20)	-
	127664	DAK-24-12-R01-AL-R-UFK2-BD3	2.4	0,1	12°	UFK-2 (K15/K20)	BD3 (TiAlN)
	126495	DAK-24-12-R01-AL-R-UFK2-BD8	2.4	0,1	12°	UFK-2 (K15/K20)	BD8 (TiB2)
	149776	DAK-24-25-AL-R-UFK-2	2.4	-	25°	UFK-2 (K15/K20)	-

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158739	DAK-24-4-E-R-UFK-4	2.4	4°	UFK-4 (K40)	-
158741	DAK-24-6-E-R-UFK-4	2.4	6°	UFK-4 (K40)	-
158743	DAK-24-12-E-R-UFK-4	2.4	12°	UFK-4 (K40)	-
158745	DAK-24-20-E-R-UFK-4	2.4	20°	UFK-4 (K40)	-

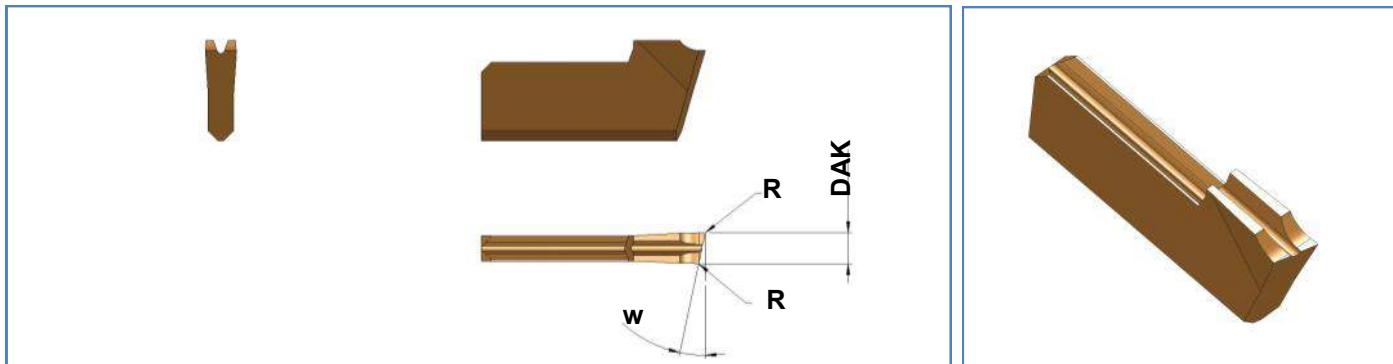
DAK-24-...-LF...

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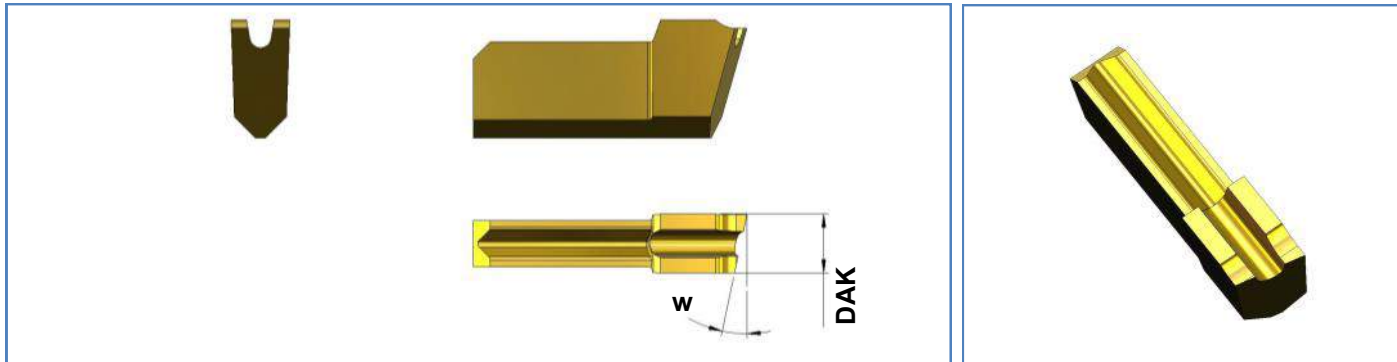
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107508	DAK-24-4-LF-UFK-2	2.4	-	4°	UFK-2 (K15/K20)	-
107509	DAK-24-4-LF-UFK-4	2.4	-	4°	UFK-4 (K40)	-
107416	DAK-24-4-LF-UFK2-BD1	2.4	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
107999	DAK-24-4-LF-UFK4-BD2	2.4	-	4°	UFK-4 (K40)	BD2 (TiCN)
108580	DAK-24-4-LF-UFK4-BD3	2.4	-	4°	UFK-4 (K40)	BD3 (TiAlN)
107500	DAK-24-12-LF-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
107501	DAK-24-12-LF-UFK-4	2.4	-	12°	UFK-4 (K40)	-
107418	DAK-24-12-LF-UFK2-BD1	2.4	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
107995	DAK-24-12-LF-UFK4-BD2	2.4	-	12°	UFK-4 (K40)	BD2 (TiCN)
108574	DAK-24-12-LF-UFK4-BD3	2.4	-	12°	UFK-4 (K40)	BD3 (TiAlN)
108427	DAK-24-18-LF-UFK2-BD1	2.4	-	18°	UFK-2 (K15/K20)	BD1 (TiN)
145953	DAK-24-18-LF-UFK4-BD2	2.4	-	18°	UFK-4 (K40)	BD2 (TiCN)
149488	DAK-24-25-LF-UFK-2	2.4	-	25°	UFK-2 (K15/K20)	-
123934	DAK-24-25-LF-UFK4-BD2	2.4	-	25°	UFK-4 (K40)	BD2 (TiCN)
110658	DAK-24-5-R-LF-UFK4-BD2	2.4	0,15	5°	UFK-4 (K40)	BD2 (TiCN)

DAK-24-...P-LF...

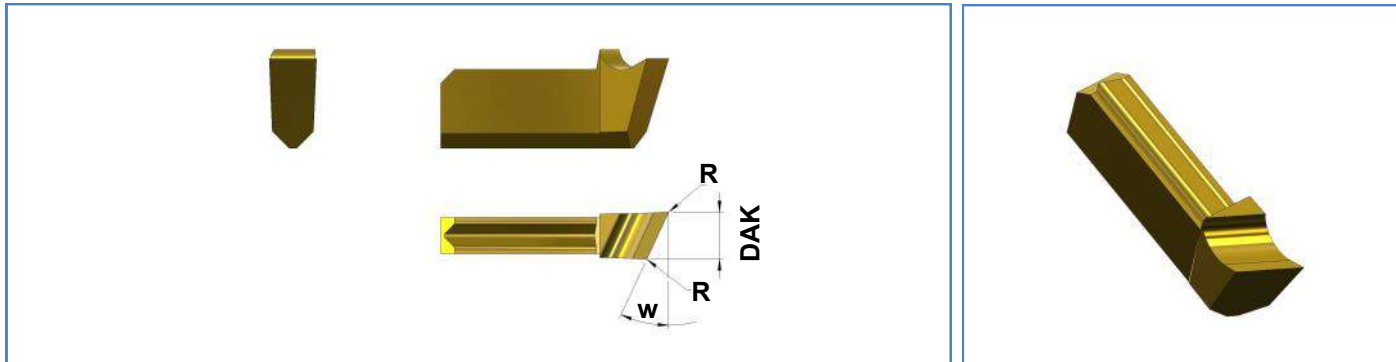
Parallel geschliffen, für optimale Oberfläche
 Parallely ground, for optimized surface quality
 Rectifié parallèlement, pour une surface optimale



	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107510	DAK-24-4-P-LF-UFK-2	2.4	-	4°	UFK-2 (K15/K20)	-
	107511	DAK-24-4-P-LF-UFK-4	2.4	-	4°	UFK-4 (K40)	-
	107421	DAK-24-4-P-LF-UFK2-BD1	2.4	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	108000	DAK-24-4-P-LF-UFK4-BD2	2.4	-	4°	UFK-4 (K40)	BD2 (TiCN)
	107502	DAK-24-12-P-LF-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
	107503	DAK-24-12-P-LF-UFK-4	2.4	-	12°	UFK-4 (K40)	-
	107423	DAK-24-12-P-LF-UFK2-BD1	2.4	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	107996	DAK-24-12-P-LF-UFK4-BD2	2.4	-	12°	UFK-4 (K40)	BD2 (TiCN)

DAK-24-...-AL-L...

für Drehen von Aluminium, NE-legierten Werkstoffen und Kunststoffen
 for turning aluminium, non-ferrous materials and plastics
 pour tournage d'aluminium, de matériel non-ferreux et de plastiques



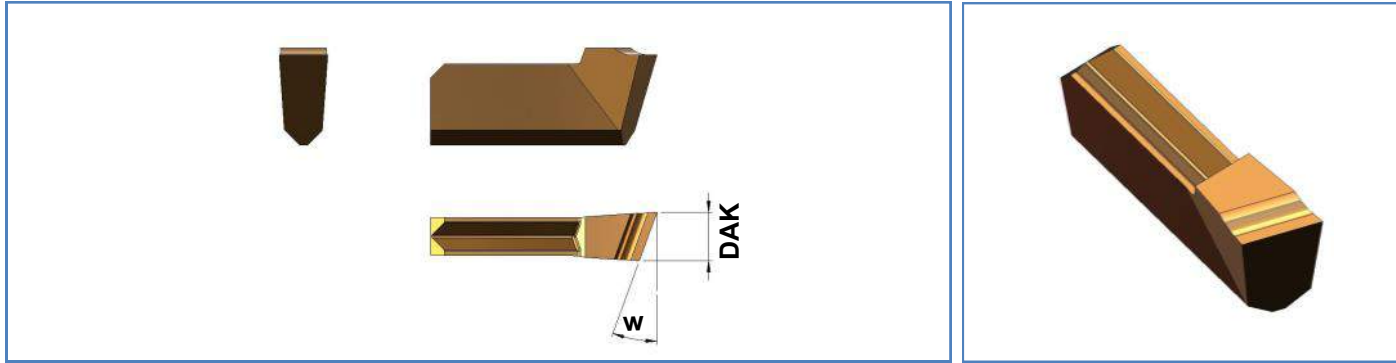
	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	149541	DAK-16-12-AL-L-UFK-2	1.6	-	12°	UFK-2 (K15/K20)	-
	125784	DAK-24-12-AL-L-UFK-2	2.4	-	12°	UFK-2 (K15/K20)	-
	127660	DAK-24-12-AL-L-UFK2-BD3	2.4	-	12°	UFK-2 (K15/K20)	BD3 (TiAlN)
	126496	DAK-24-12-AL-L-UFK2-BD8	2.4	0,1	12°	UFK-2 (K15/K20)	BD8 (TiB2)
	125786	DAK-24-12-R01-AL-L-UFK-2	2.4	0,1	12°	UFK-2 (K15/K20)	-
	126453	DAK-24-12-R01AL-L-UFK2BD8	2.4	0,1	12°	UFK-2 (K15/K20)	BD8 (TiB2)
	149777	DAK-24-25-AL-L-UFK-2	2,4	-	25°	UFK-2 (K15/K20)	-

HM-Wechselklingen

Carbide interchangeable blades
Lames interchangeable en carbure

DAK-24-...-E-L...

Standard type, universell einsetzbar
Standard type, universally applicable
Géométrie standard à usage universel



Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
158738	DAK-24-4-E-L-UFK-4	2.4	4°	UFK-4 (K40)	-
158740	DAK-24-6-E-L-UFK-4	2.4	6°	UFK-4 (K40)	-
158742	DAK-24-12-E-L-UFK-4	2.4	12°	UFK-4 (K40)	-
158744	DAK-24-20-E-L-UFK-4	2.4	20°	UFK-4 (K40)	-

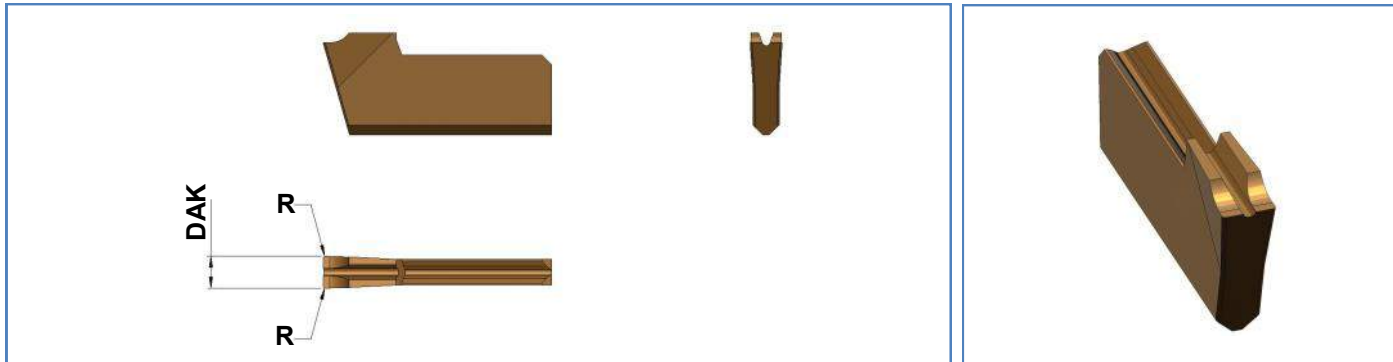
DAK-32-...-NF...

Standard type, universell einsetzbar / Standard type, universally applicable / Géométrie standard à usage universel

DAK-32-...R-NF...

Spezialgeometrie für rostfreie Stähle und weichen Stahl, für höheren Vorschub, bessere Oberfläche, längere Standzeiten

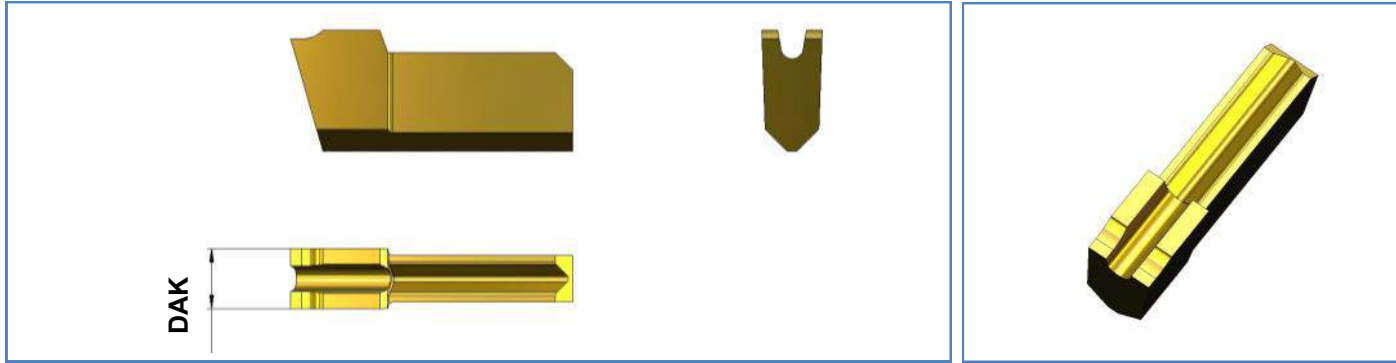
Special geometry for stainless steel and soft steel, for higher feed, better surface quality and longer tool life
Géométrie spéciale pour des aciers inoxydables ou doux, pour l'avance élevé, une surface supérieure et une durée de vie longue.



Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
107516	DAK-32-0-NF-UFK-2	3.2	-	UFK-2 (K15/K20)	-
107517	DAK-32-0-NF-UFK-4	3.2	-	UFK-4 (K40)	-
107404	DAK-32-0-NF-UFK2-BD1	3.2	-	UFK-2 (K15/K20)	BD1 (TiN)
108003	DAK-32-0-NF-UFK4-BD2	3.2	-	UFK-4 (K40)	BD2 (TiCN)
108575	DAK-32-0-NF-UFK4-BD3	3.2	-	UFK-4 (K40)	BD3 (TiAlN)
108647	DAK-32-0-R-NF-UFK-2	3.2	0,2	UFK-2 (K15/K20)	-
108648	DAK-32-0-R-NF-UFK-4	3.2	0,2	UFK-4 (K40)	-
110806	DAK-32-0-R-NF-UFK2-BD1	3.2	0,2	UFK-2 (K15/K20)	BD1 (TiN)
117413	DAK-32-0-R-NF-UFK4-BD2	3.2	0,2	UFK-4 (K40)	BD2 (TiCN)

DAK-32-...P-NF...

Parallel geschliffen, für optimale Oberfläche
 Parallely ground, for optimized surface quality
 Rectifié parallèlement, pour une surface optimale



	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107518	DAK-32-0-P-NF-UFK-2	3.2	-	UFK-2 (K15/K20)	-
	107519	DAK-32-0-P-NF-UFK-4	3.2	-	UFK-4 (K40)	-
	107399	DAK-32-0-P-NF-UFK2-BD1	3.2	-	UFK-2 (K15/K20)	BD1 (TiN)
	108004	DAK-32-0-P-NF-UFK4-BD2	3.2	-	UFK-4 (K40)	BD2 (TiCN)

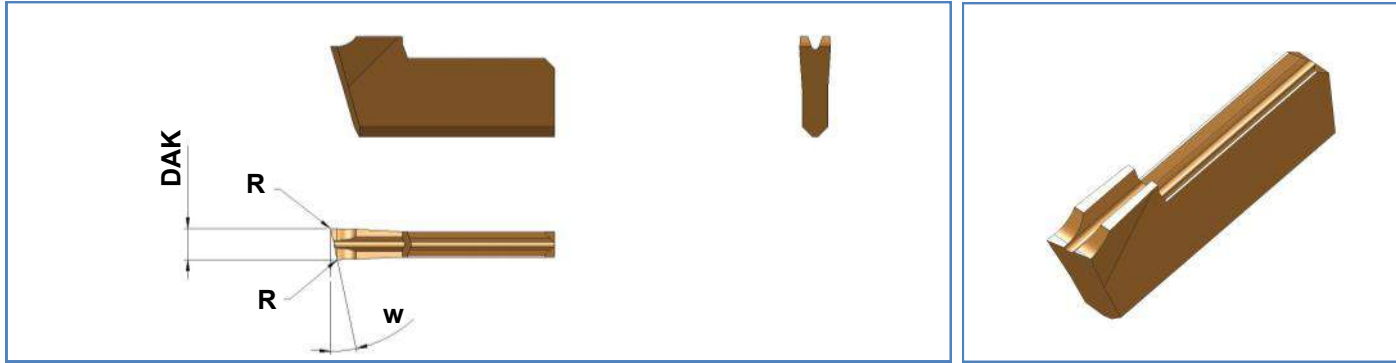
DAK-32-...-RF...

Standardtype, universell einsetzbar / Standard type, universally applicable / Géométrie standard à usage universel

DAK-32-...R-RF...

Spezialgeometrie für rostfreie Stähle und weichen Stahl, für höheren Vorschub, bessere Oberfläche, längere Standzeiten

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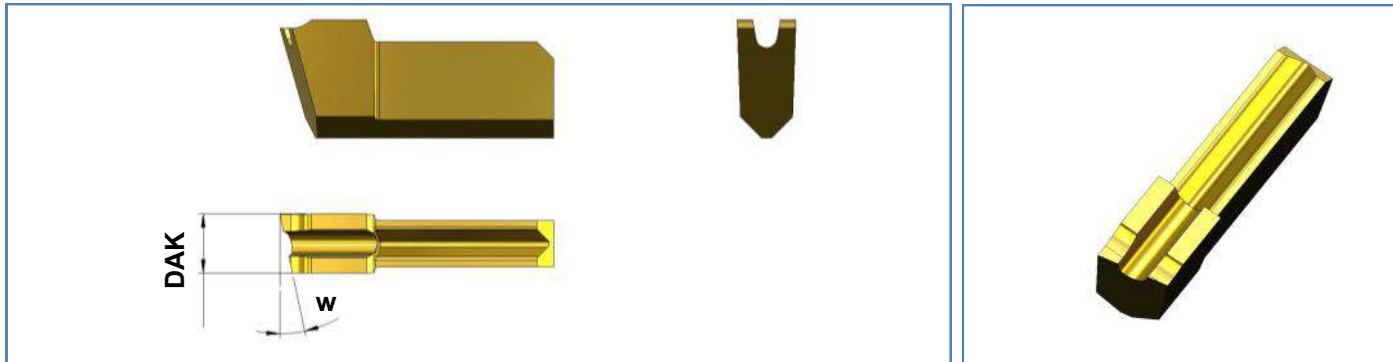


	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107535	DAK-32-4-RF-UFK-2	3.2	-	4°	UFK-2 (K15/K20)	-
	107536	DAK-32-4-RF-UFK-4	3.2	-	4°	UFK-4 (K40)	-
	107405	DAK-32-4-RF-UFK2-BD1	3.2	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	108011	DAK-32-4-RF-UFK4-BD2	3.2	-	4°	UFK-4 (K40)	BD2 (TiCN)
	108583	DAK-32-4-RF-UFK4-BD3	3.2	-	4°	UFK-4 (K40)	BD3 (TiAlN)
	107527	DAK-32-12-RF-UFK-2	3.2	-	12°	UFK-2 (K15/K20)	-
	107528	DAK-32-12-RF-UFK-4	3.2	-	12°	UFK-4 (K40)	-
	107407	DAK-32-12-RF-UFK2-BD1	3.2	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	108007	DAK-32-12-RF-UFK4-BD2	3.2	-	12°	UFK-4 (K40)	BD2 (TiCN)
	108581	DAK-32-12-RF-UFK4-BD3	3.2	-	12°	UFK-4 (K40)	BD3 (TiAlN)
	108428	DAK-32-18-RF-UFK2-BD1	3.2	-	18°	UFK-2 (K15/K20)	BD1 (TiN)
	145956	DAK-32-18-RF-UFK4-BD2	3.2	-	18°	UFK-4 (K40)	BD2 (TiCN)

	108649	DAK-32-5-R-RF-UFK-2	3.2	0,2	5°	UFK-2 (K15/K20)	-
	108651	DAK-32-5-R-RF-UFK-4	3.2	0,2	5°	UFK-4 (K40)	-
	117869	DAK-32-5-R-RF-UFK4-BD2	3.2	0,2	5°	UFK-4 (K40)	BD2 (TiCN)

DAK-32-...P-RF...

Parallel geschliffen, für optimale Oberfläche
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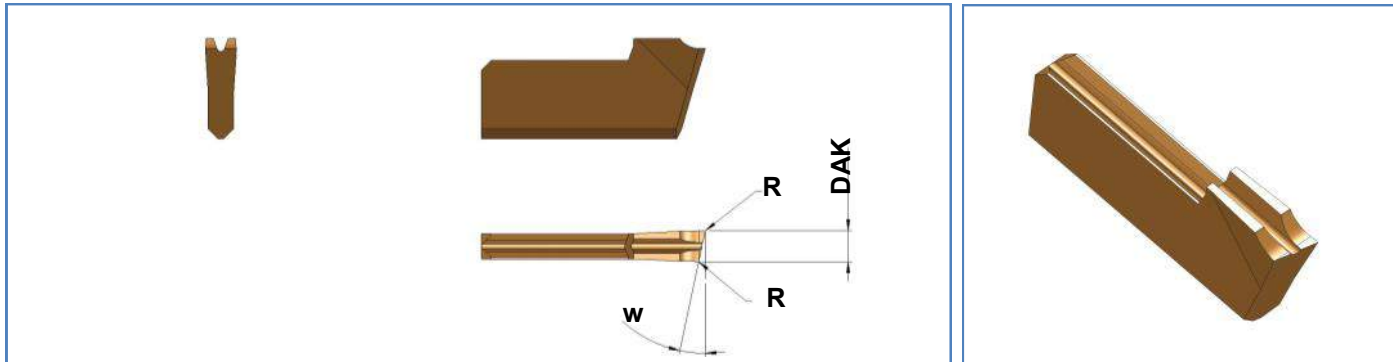


	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107533	DAK-32-4-P-RF-UFK-2	3.2	-	4°	UFK-2 (K15/K20)	-
	107534	DAK-32-4-P-RF-UFK-4	3.2	-	4°	UFK-4 (K40)	-
	107400	DAK-32-4-P-RF-UFK2-BD1	3.2	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	108012	DAK-32-4-P-RF-UFK4-BD2	3.2	-	4°	UFK-4 (K40)	BD2 (TiCN)
	107524	DAK-32-12-P-RF-UFK-2	3.2	-	12°	UFK-2 (K15/K20)	-
	107525	DAK-32-12-P-RF-UFK-4	3.2	-	12°	UFK-4 (K40)	-
	107402	DAK-32-12-P-RF-UFK2-BD1	3.2	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	108008	DAK-32-12-P-RF-UFK4-BD2	3.2	-	12°	UFK-4 (K40)	BD2 (TiCN)

DAK-32-...-LF... Standardtype, universell einsetzbar / Standard type, universally ground / Géométrie standard à usage universel

DAK-32-...R-LF... Spezialgeometrie für rostfreie Stähle und weichen Stahl, für höheren Vorschub, bessere Oberfläche, längere Standzeiten

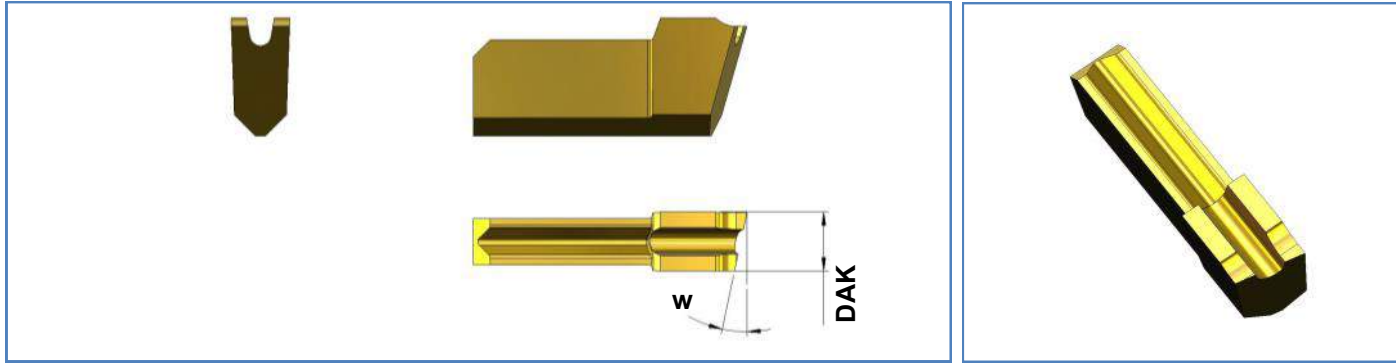
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	Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
	107529	DAK-32-4-LF-UFK-2	3.2	-	4°	UFK-2 (K15/K20)	-
	107530	DAK-32-4-LF-UFK-4	3.2	-	4°	UFK-4 (K40)	-
	107406	DAK-32-4-LF-UFK2-BD1	3.2	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
	108009	DAK-32-4-LF-UFK4-BD2	3.2	-	4°	UFK-4 (K40)	BD2 (TiCN)
	108582	DAK-32-4-LF-UFK4-BD3	3.2	-	4°	UFK-4 (K40)	BD3 (TiAlN)
	107520	DAK-32-12-LF-UFK-2	3.2	-	12°	UFK-2 (K15/K20)	-
	107521	DAK-32-12-LF-UFK-4	3.2	-	12°	UFK-4 (K40)	-
	107408	DAK-32-12-LF-UFK2-BD1	3.2	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
	108005	DAK-32-12-LF-UFK4-BD2	3.2	-	12°	UFK-4 (K40)	BD2 (TiCN)
	108429	DAK-32-18-LF-UFK2-BD1	3.2	-	18°	UFK-2 (K15/K20)	BD1 (TiN)
	145955	DAK-32-18-LF-UFK4-BD2	3.2	-	18°	UFK-4 (K40)	BD2 (TiCN)
	108650	DAK-32-5-R-LF-UFK-2	3.2	0,2	5°	UFK-2 (K15/K20)	-
	108652	DAK-32-5-R-LF-UFK-4	3.2	0,2	5°	UFK-4 (K40)	-
	121330	DAK-32-5-R-LF-UFK4-BD2	3.2	0,2	5°	UFK-4 (K40)	BD2 (TiCN)

DAK-32-...P-LF...

Parallel geschliffen, für optimale Oberfläche
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Art. Nr. Item no. No. d'art.	Best. Nr. Ref. no. Réf.	DAK	R	w	Hartmetall solid carbide carbure	Beschichtung coating revêtement
107531	DAK-32-4-P-LF-UFK-2	3.2	-	4°	UFK-2 (K15/K20)	-
107532	DAK-32-4-P-LF-UFK-4	3.2	-	4°	UFK-4 (K40)	-
107401	DAK-32-4-P-LF-UFK2-BD1	3.2	-	4°	UFK-2 (K15/K20)	BD1 (TiN)
108010	DAK-32-4-P-LF-UFK4-BD2	3.2	-	4°	UFK-4 (K40)	BD2 (TiCN)
107522	DAK-32-12-P-LF-UFK-2	3.2	-	12°	UFK-2 (K15/K20)	-
107523	DAK-32-12-P-LF-UFK-4	3.2	-	12°	UFK-4 (K40)	-
107403	DAK-32-12-P-LF-UFK2-BD1	3.2	-	12°	UFK-2 (K15/K20)	BD1 (TiN)
108006	DAK-32-12-P-LF-UFK4-BD2	3.2	-	12°	UFK-4 (K40)	BD2 (TiCN)

Technische Angaben / Technical details / Données techniques

Schnittdaten

Cutting Data / Données de coupe

Werkstoff Material Matériel	Schnittgeschwindigkeit (m/min) Cutting speed (m/min) Vitesse de coupe (m/min)	Vorschub f (mm/U) Feed f (mm/rev) Avance f (mm/t)
Automatenstahl Free cutting steel Acier de décolletage	80-160	0,05-0,10
Niro Stahl Stainless steel Acier inoxydable	30-90	0,04-0,08
Hochlegierter Stahl High-alloy tool steel Acier fortement alliés	30-110	0,03-0,08
Kupfer Copper Cuivre	120-250	0,05-0,15
Alu Aluminium	120-250	0,05-0,15
Titan Titanium	30-45	0,02-0,05

Richtwerte für die Anzugsmomente von TORX Schrauben bei unseren Wendepplatten

Recommended torque settings for inserts / Couples des serrage recommandés par vis de plaquettes

M1,6	T5	0,4 Nm	M3	T8	2,2 Nm
M1,8	T5	0,5 Nm	M3	T9	2,2 Nm
M1,8	T6	0,5 Nm	M3	T10	2,5 Nm
M2	T6	0,5 Nm	M3,5	T15	3,4 Nm
M2	T7	0,6 Nm	M4	T15	5,1 Nm
M2,2	T7	0,8 Nm	M5	T20	6,2 Nm
M2,5	T6	1,0 Nm	M5	T25	6,7 Nm
M2,5	T7	1,1 Nm	M6	T20	7,3 Nm
M2,5	T8	1,3 Nm	M6	T25	8,1 Nm