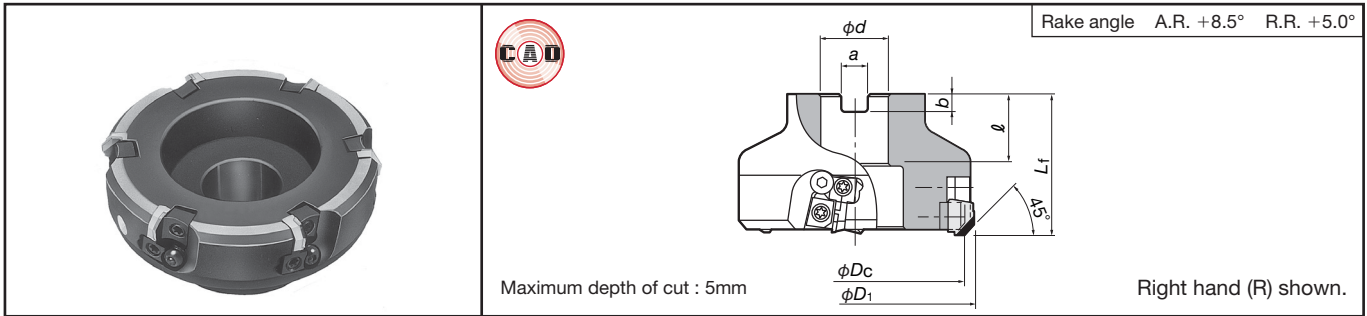


# DAD15

Diameter  $\phi 80\sim 315\text{mm}$  

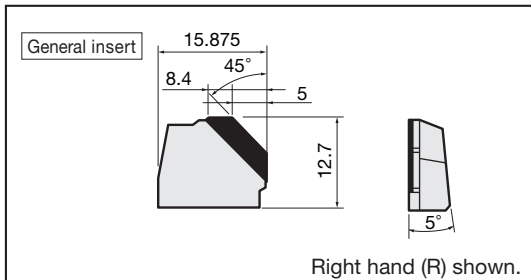


For high speed milling of aluminum alloys and non-ferrous metals

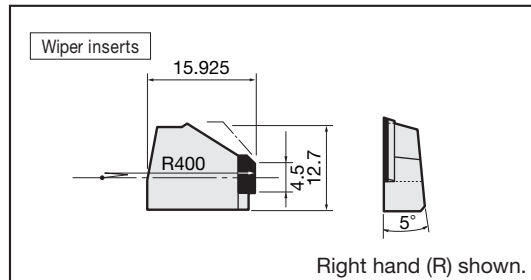


Cat. No.	Stock		No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details	
	R	L		$\phi D_c$	$\phi D_1$	$\phi d$	$l$	$L_f$	$b$			$a$
DAD15080R/L			4	80	90	25.4	26	63	6	9.5	1.4	9-144(B)
DAD15100R/L			4	100	110	31.75	32		8	12.7	2.4	
DAD15125R/L			6	125	135	38.1	38		10	15.9	3.6	
DAD15160R/L			6	160	170	50.8			11	19	5.5	
DAD15200R/L			8	200	210	47.625	38	14	25.4	8.9	9-144(C)	
DAD15250R/L			10	250	260					14.6		
DAD15315R/L			12	315	325					24.0		9-144(D)

## Inserts



Cat. No.	Grades	Stock
	T-DIA	
YDEN1505ADFR-D	DX140	●
YDEN1505ADFL-D		



Cat. No.	Grades	Stock
	T-DIA	
YDEN1505ADFR-WD	DX140	●
YDEN1505ADFL-WD		

"DX140": 1-insert packing

## Replacement parts

No.	Part	Part Cat. No.
①	Insert locking wedge	FW304R/L-D
②	Locator adjusting wedge	FW325R/L-D
③	Screw for preventing wedge from flying out	BHM615-GT
④	Wedge fixing screw ( $\phi D=80$ )	FDS-8ST-18
	Wedge fixing screw (for $\phi D>80$ )	FDS-8ST
⑤	Adjusting wedge fixing screw	FDS-8ST-18
—	Wrench	T-27T

## Cautionary Points in Use

- To avoid a danger of unbalanced revolution, the TAC mill should not be used in a state of reduced number of inserts.
- Use the cutter within the maximum revolutions written on the cutter body.
- When using the cutter at a cutting speed more than 1500 m/min, the balance quality of the arbor and toolholder should be prepared within class G16.
- When installing the inserts, recommended clamping torque for the wedge fixing screw is 9.8 N·m.

## Standard cutting conditions

Work materials	Insert grades	Cutter dia. $\phi D_c$	80	100	125	160	200	250	315
Aluminum alloys (Si : <12%)	DX140 (T-DIA)	Maximum cutting speed $V_{cmax}$ (m/min)	4000						
		Maximum revolution $n_{max}$ (min <sup>-1</sup> )	16000	12700	10200	8000	6400	5100	4000
		Depth of cut $a_p$ (mm)	~5mm						
		Feed $f_z$ (mm/tooth)	0.05~0.28						
Aluminum alloys (Si : >13%)		Cutting speed $v_c$ (m/min)	200~500						

- No. of revolutions (min<sup>-1</sup>) = Cutting speed × 1000 ÷ 3.14 ÷ Cutter diameter
- Table feed (mm/min) = No. of revolutions × Feed per tooth × No. of inserts

● : Stocked in Japan.