

Compensating holder
DAH™ 50 HS



Dihart® DAH™ 50 HS compensating holders – for maximum precision and concentricity

The new Dihart DAH 50 HS compensating holders ensure that the tool runs concentrically. They allow precision adjustment of the tool in the micron (μm) range at the cutter eliminating any machine spindle error. Maximum concentricity guarantees reliable production within extremely close tolerances. The quality of the bore, including surface quality, circularity, roundness and parallelism and above all the dimensional accuracy are improved considerably. This significantly increases the process reliability with Dihart multiple blade reamers.



Proven hydro-expansion clamping with new highlight

- Maximum concentricity and repetition accuracy < 0.00004" (1 μm) for uniform blade contact
- Extremely simple concentricity adjustment
- Compact design
- Optimum vibration damping for excellent surface quality
- Flexible clamping range with reduction sleeves
- Speeds up to 25,000 rpm
- For minimum quantity lubrication (MQL)

Flexible clamping range with adapter sleeves

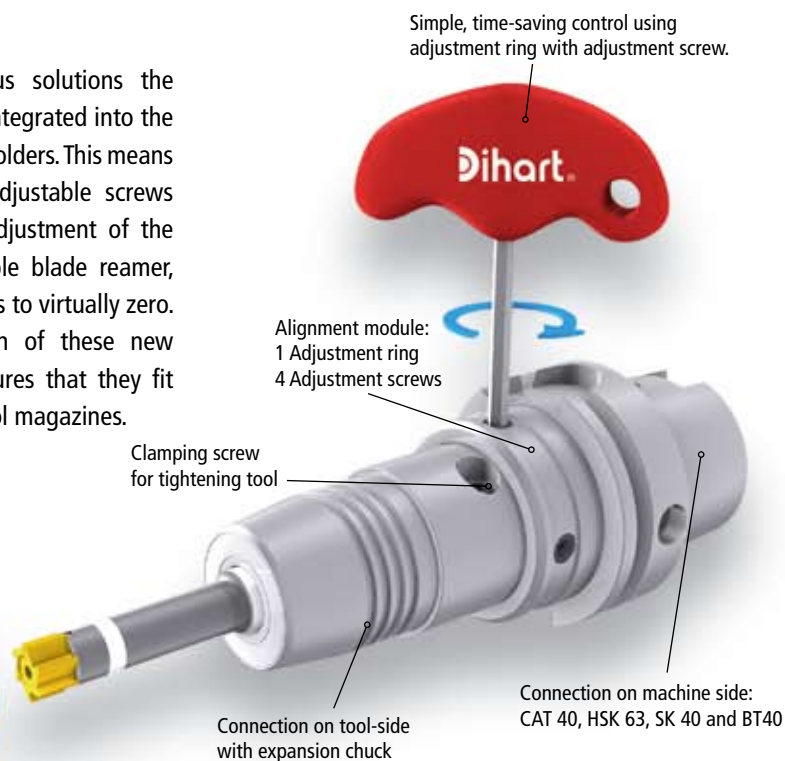
Adapter sleeves allow one Dihart hydro-expansion compensating holder to be used for different shank diameters.



Simple handling – reduced machine idle times

In comparison to previous solutions the hydro-expansion chuck is integrated into the new Dihart compensating holders. This means one less interface. Four adjustable screws allow rapid and precise adjustment of the concentricity of the multiple blade reamer, reducing concentricity errors to virtually zero. The extremely slim design of these new compensating holders ensures that they fit easily into practically all tool magazines.

Adjustment of concentricity on cutter to absolute "zero" micron (μm)

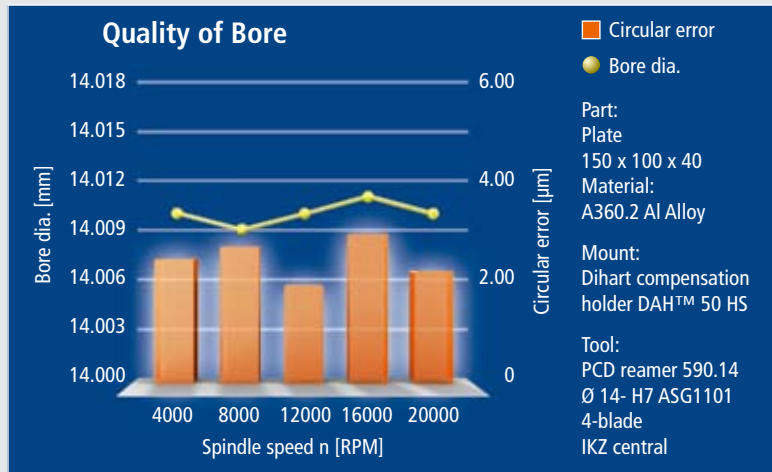


High speed machining – with maximum quality

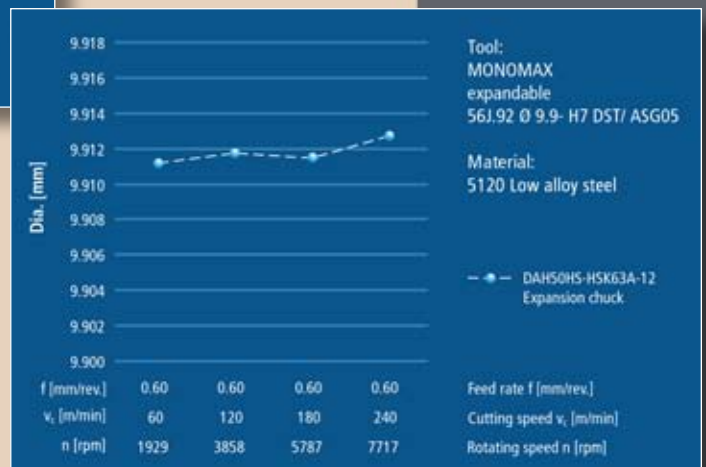
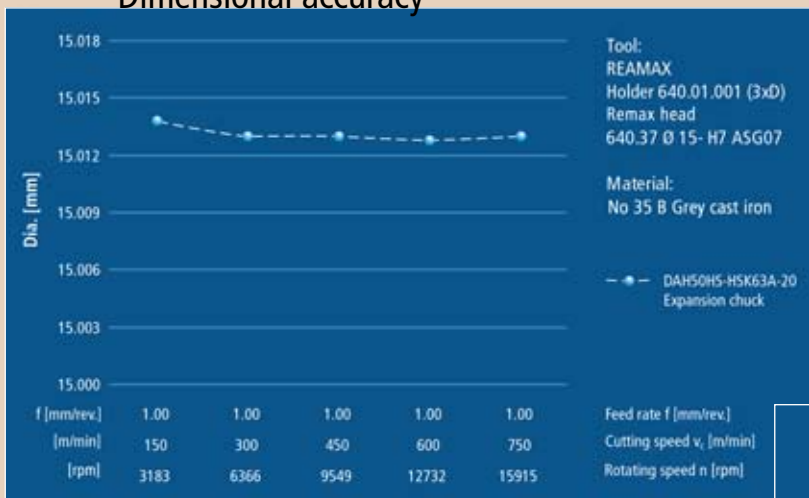
With the new Dihart DAH 50 HS compensating holders you can easily perform high speed machining at speeds up to 25,000 RPM. Extremely high speeds are possible even with small diameter PCD tools.

Applications for Dihart tools

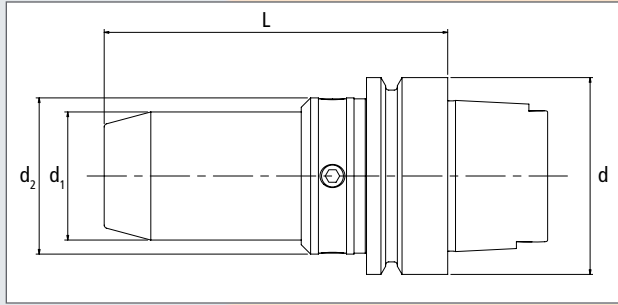
- REAMAX
- MONOMAX
- PCD standard line
- Solid carbide reamers
- Dihart special tools



Dimensional accuracy

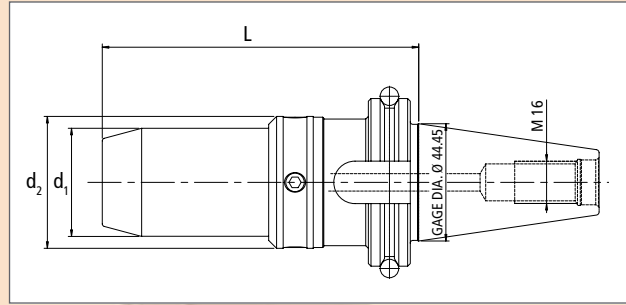


Compensating holder DAH™ 50 HS DIN 69883 - HSK



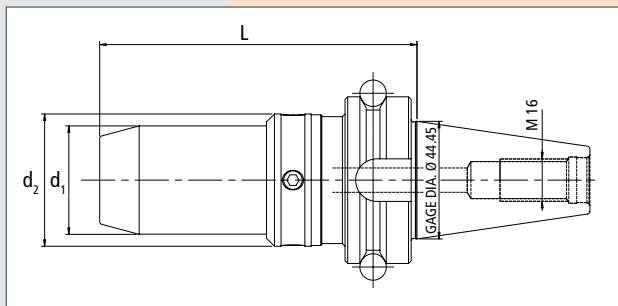
Part No.	Clamping range	Description	d mm	d ₁ mm	d ₂ mm	L mm
54B.10.00030	3 - 20mm	HSK-A63	63	41	50	110

Compensating holder DAH™ 50 HS DIN 69871AD - SK



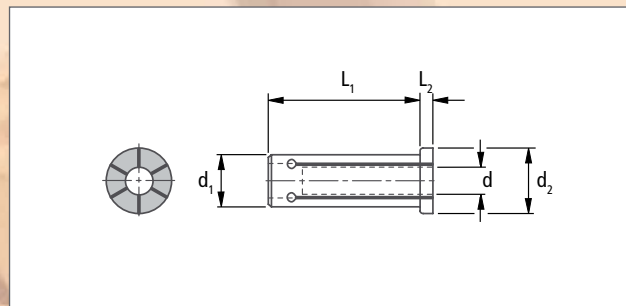
Part No.	Clamping range	Description	d ₁ mm	d ₂ mm	L mm
54B.90.00030	3 - 20mm	SK40	41	50	110

Compensating holder DAH™ 50 HS 403 AD - BT MAS



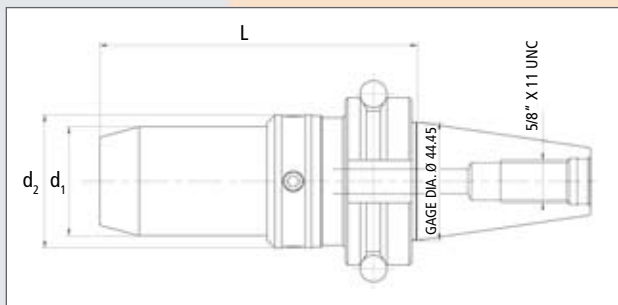
Part No.	Clamping range	Description	d ₁ mm	d ₂ mm	L mm
54B.91.00030	3 - 20mm	BT40	41	50	115

Reducer bushing for hydro-expansion chuck



Part No.	Clamping range mm	d mm	d ₁ mm	d ₂ mm	L ₁ mm	L ₂ mm
L01 14260	20/3	3	20	29	50.5	2
L01 14270	20/4	4	20	29	50.5	2
L01 14280	20/5	5	20	29	50.5	2
L01 14200	20/6	6	20	29	50.5	2
L01 14210	20/8	8	20	29	50.5	2
L01 14220	20/10	10	20	29	50.5	2
L01 14230	20/12	12	20	29	50.5	2
L01 14240	20/14	14	20	29	50.5	2
L01 14250	20/16	16	20	29	50.5	2

Compensating holder DAH™ 50 HS - CAT



Part No.	Clamping range	Description	d ₁ mm (in)	d ₂ mm (in)	L mm (in)
54B.93.00030	1/4" - 3/4"	CAT40	41 (1.614)	50 (1.969)	121 (4.764)
54B.93.00035	3 - 20mm	CAT40	41 (1.614)	50 (1.969)	121 (4.764)

Part No.	Clamping range inch	d inch	d ₁ inch	d ₂ inch	L ₁ inch	L ₂ inch
L01 13400	0.750/0.250	0.250	0.750	0.980	2.00	0.78
L01 13410	0.750/0.312	0.312	0.750	0.980	2.00	0.78
L01 13420	0.750/0.375	0.375	0.750	0.980	2.00	0.78
L01 13430	0.750/0.437	0.437	0.750	0.980	2.00	0.78
L01 13440	0.750/0.500	0.500	0.750	0.980	2.00	0.78
L01 13450	0.750/0.625	0.625	0.750	0.980	2.00	0.78



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