

# 硬质合金车槽刀具

## CARBIDE GROOVING TOOLS





尊敬的客户：

我们的宗旨是用我们的产品为您提供低成本而高效率的解决方案。

HORN最新的“硬质合金车槽刀具”样本提供全球最全面的车槽刀具。在您进行加工任务、面临挑战和完成项目的时候，我们的刀具解决方案、专业知识和技术服务将使我们成为您最佳的合作伙伴。

无论标准产品还是非标产品都可实现短周期生产。

期望将来能与您成功合作。

如有任何需要请联系我们。

谨上

Lothar Horn, CEO

Dear Customer,

Our goal is to offer you the most cost-effective service and solutions possible with the range of products shown in this catalogue.

The new HORN-Catalogue **CARBIDE GROOVING TOOLS** presents the most comprehensive range of grooving and turning tools available worldwide. Our tooling solutions, expertise and technical advice make us your perfect partner when it comes to performing tasks, facing challenges and completing projects.

Standard and Special Tools are available on very short lead times.

We look forward to a successful mutual cooperation for the future.

Please don't hesitate to contact us in case of any further queries.

Yours sincerely

Lothar Horn, CEO



[phorn.de](http://phorn.de)



[phorn.com](http://phorn.com)



[youtube.com](http://youtube.com)



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**A****B****C****D****E****F****G****H****J****K****L****M****N****O**

# 质量和环境的承诺 QUALITY AND ENVIRONMENT COMMITMENT

## 质量=客户满意

Paul Horn公司作为一家硬质合金刀具生产厂商，有着其特殊的责任。  
为了成为一家成功的公司，我们必须满足客户对产品和服务的要求，同时也必须实现自我的要求。  
为了实现这些目标，Paul Horn公司通过了DIN EN ISO9001质量体系认证。

## Quality = Satisfied customers

Paul Horn GmbH, as a manufacturer of carbide cutting tools, has a very special responsibility.  
To exist as a successful company, we must meet the demands for both products and services that are set by the customer as well as those that we set ourselves.  
To achieve these goals, Paul Horn GmbH has introduced a modern Quality management System according to DIN EN ISO 9001.



## 环境=我们的未来

一个公司良好的发展不仅决定于它的营业额和利润，也需要得到公众和社会的认可。  
在Paul Horn公司，环境保护是重要的企业目标，也是公司政策中无可争议的一部分。  
在1999年，公司根据ISO14001的要求调整了公司的管理系统，早在1997年我们就通过了EG-ÖG-Audit-VO 1836/93的认证，最终在2000年7月通过了ISO14001认证。

## The environment - our future!

To ensure the future being a company, it depends not only on turnover and profit but the acceptance of the company by both the public and the society.  
For the Paul Horn GmbH the environment protection is an important corporate target and indisputable part of the corporate policy.  
In 1999 we have adjusted our Management System according to the requirements of the ISO 14001. Already in 1997 we have got the validity according to the EG-ÖG-Audit-VO 1836/93. The Management System is certified since July 2000.



# 摘要 / SUMMARY

**P** 切断  
PARTING OFF

**Q** 技术说明  
TECHNICAL INSTRUCTIONS

**R** 插削  
BROACHING

**S** 抛光车削  
POLISH TURNING

**T** CVD ISO 刀片  
CVD ISO Inserts

**U** 附加设备/加工示例  
ADDITIONAL EQUIPMENT / EXAMPLES FOR MACHINING

**INDEX**

**P**

**Q**

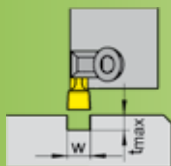
**R**

**S**

**T**

**U**



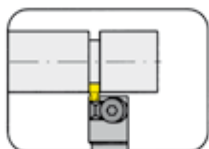


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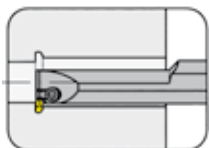


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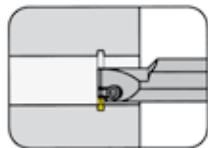
切槽  
- 外圆 -  
Grooving  
- external -



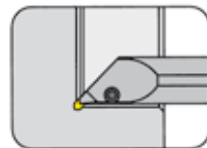
切槽  
- 内圆 -  
Grooving  
- internal -



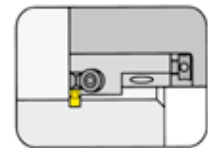
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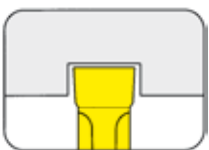


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A15-A16

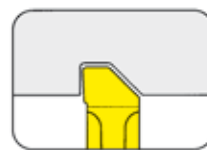
可转位刀片  
型号  
Indexable inserts type  
217



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A10



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A11



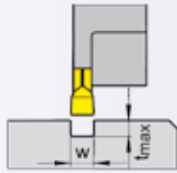
页 / Page  
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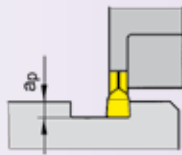
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A13



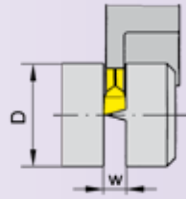
页 / Page  
A14



$w = 1.5 - 3 \text{ mm}$   
 $t_{\text{max}} = 16 \text{ mm}$



$w = 1.5 \text{ mm}$   
 $a_p = 2.25 \text{ mm}$

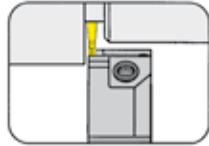


$w = 1.5 - 3 \text{ mm}$   
 $D = 20 - 32 \text{ mm}$

刀杆

螺钉锁紧

Toolholder  
with screwed clamping



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B2-B4



刀杆

自夹紧

Toolholder  
with self clamping

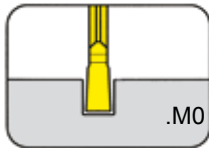


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B5

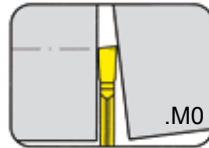


可转位刀片  
型号

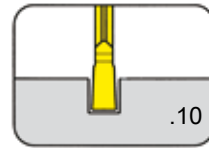
Indexable inserts type  
S264 / 264



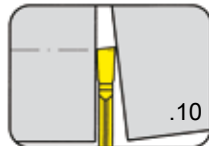
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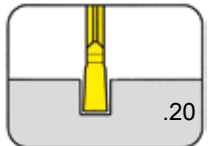
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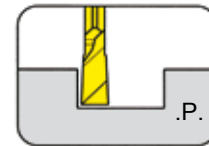
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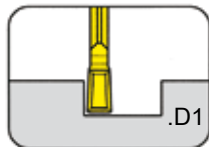
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B9



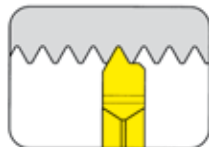
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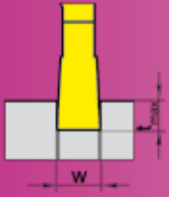
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B11



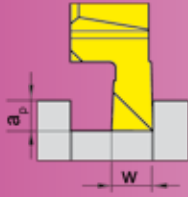
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B12



页 / Page  
B13



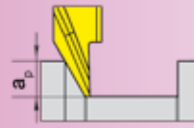
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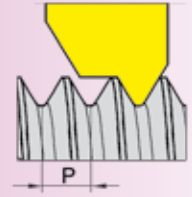
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 $a_p = 6.0 \text{ mm}$



$w = 0.8 - 2.0 \text{ mm}$

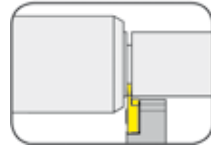


$a_p = 6.0 \text{ mm}$



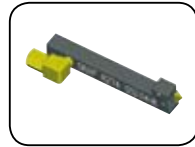
非全牙型/Partial profile  
 $P = 0.24 - 0.4 \text{ mm}$   
全牙型/Full profile  
 $P = 0.5 - 1.5 \text{ mm}$

刀杆  
Toolholder



页/Page  
C3-C4, C26

刀杆  
- 专用机 -  
Toolholder  
- machine-specific -



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C5



页/Page  
C6



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C7

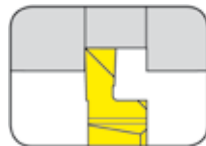


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C8

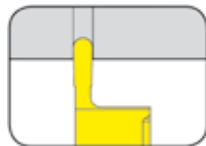


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C9

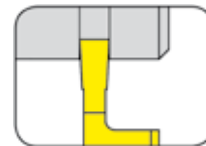
可转位刀片  
型号  
Indexable inserts type  
S274



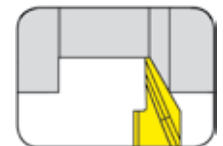
页/Page  
C10, C27



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C11, C28



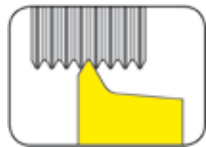
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C12-C14, C29-C31



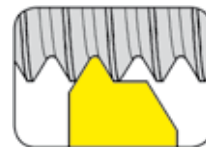
页/Page  
C15-C16, C32-C33



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C17-C22, C34-C39

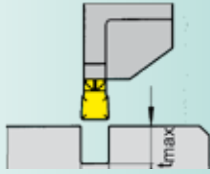


非全牙型/Partial profile  
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C23, C40

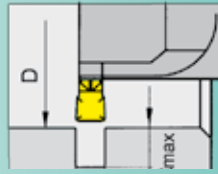


全牙型/Full profile  
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C24-C25, C41-C42

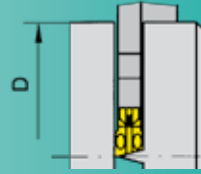




$w = 1.1 - 3 \text{ mm}$   
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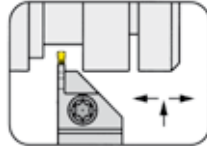


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 $t_{\text{max}} = 6.3 \text{ mm}$   
 $D \geq 16 \text{ mm}$

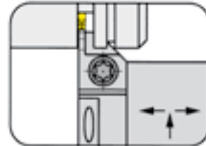


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 $D_{\text{max}} \leq 50 \text{ mm}$

切槽  
- 外圆 -  
Grooving  
- external -

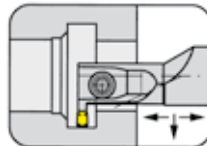


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D2

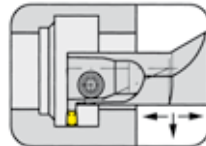


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D4

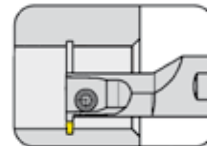
切槽  
- 内圆 -  
Grooving  
- internal -



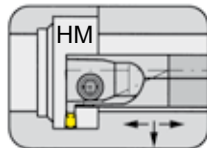
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D5



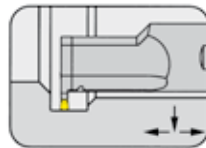
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D8



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D9



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D10



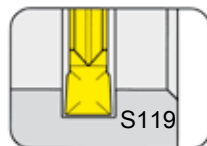
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D11

切断  
Parting off

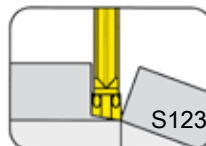


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D3

刀片型号  
Insert Type  
S119 / S123

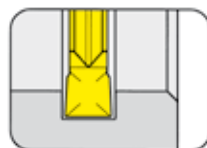


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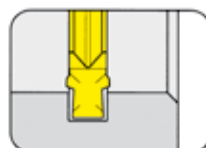


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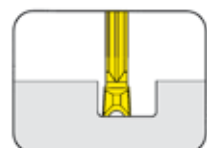
可转位刀片  
型号  
Indexable inserts type  
S223



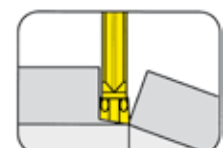
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D15, D17



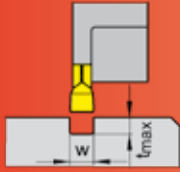
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D16



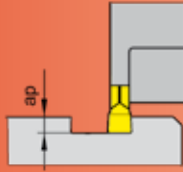
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D18



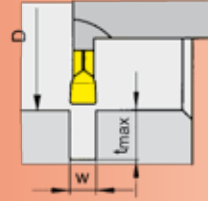
页 / Page  
D19-D20



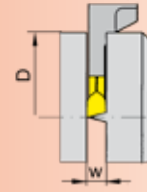
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 $t_{\text{max}} = 18 \text{ mm}$



$w = 3 - 6 \text{ mm}$   
 $a_{\text{pmax}} = 4 \text{ mm}$

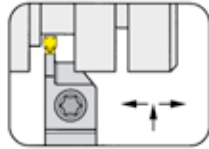


$w = 2 - 6 \text{ mm}$   
 $t_{\text{max}} = 13 \text{ mm}$   
 $D \geq 28 \text{ mm}$

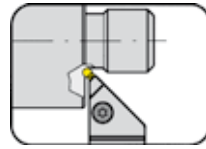


$w = 2 - 6 \text{ mm}$   
 $D = 56 \text{ mm}$   
 $t_{\text{max}} = 18 \text{ mm}$

切槽 和  
车削 (外圆)  
Grooving and  
Side turning (external)



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E2-E6, E8-E13

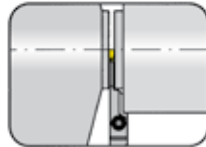


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E14

切断  
Parting off

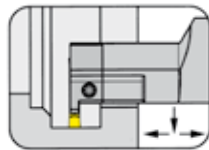


页/Page  
E15, E18-E19

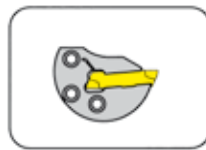


页/Page  
E7, E16-E17

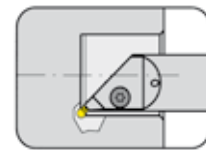
切槽 和  
车削 (内圆)  
Grooving and  
Side turning (internal)



页/Page  
E20-E24

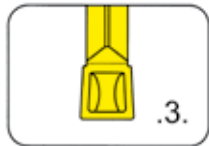


页/Page  
E25

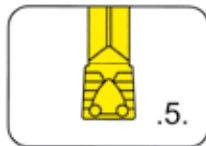


页/Page  
E26-E27

可转位刀片  
型号  
Indexable inserts type  
S224



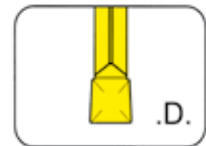
页/Page  
E28-E29



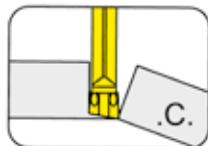
页/Page  
E30-E31



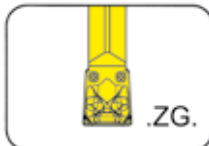
页/Page  
E32-E33



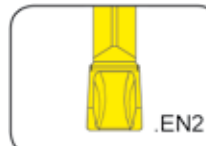
页/Page  
E34-E35



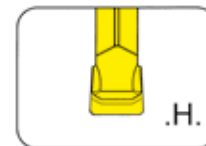
页/Page  
E36-E37



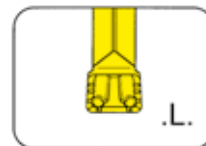
页/Page  
E38



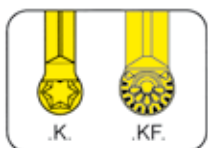
页/Page  
E39



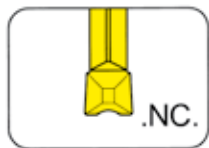
页/Page  
E40



页/Page  
E41



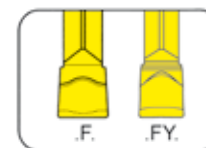
页/Page  
E42-E43



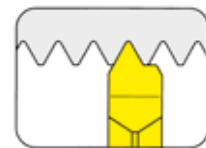
页/Page  
E44



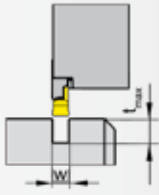
页/Page  
E45



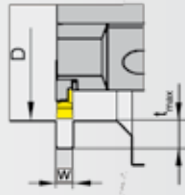
页/Page  
E46-E47



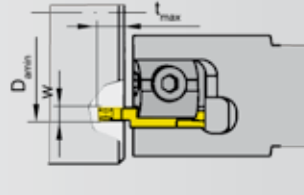
页/Page  
E48-E49



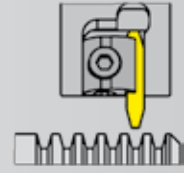
w = 2.5 - 10 mm  
t<sub>max</sub> = 11 mm



w = 4 - 10 mm  
t<sub>max</sub> = 5 - 9 mm  
D = 75 - 200 mm

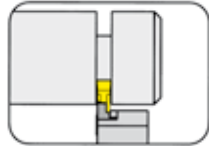


w = 3 - 10 mm  
t<sub>max</sub> = 8 mm  
D<sub>a min</sub> ≥ 30 mm



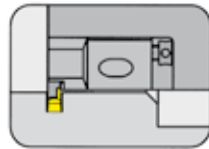
米制梯形螺纹  
metric trapezoidal thread

切槽  
- 外圆 -  
Grooving  
- external -



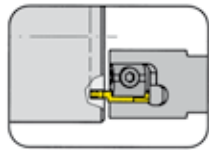
页 / Page  
F2-F3

切槽  
- 内圆 -  
Grooving  
- internal -

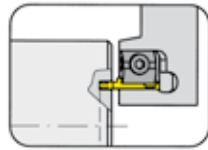


页 / Page  
F4-F5

端面切槽  
Face Grooving

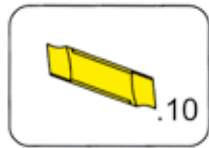


页 / Page  
F11

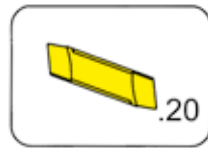


页 / Page  
F12

可转位刀片  
型号  
Indexable inserts type  
231



页 / Page  
F7-F8



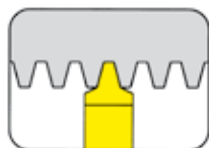
页 / Page  
F9-F10

切槽  
Grooving



页 / Page  
F13

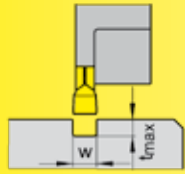
端面切槽  
Face Grooving



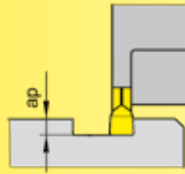
页 / Page  
F14

米制梯形螺纹  
metric trapezoidal thread

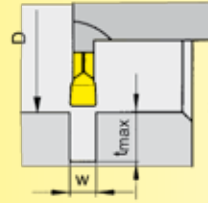




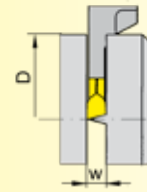
$w = 2.5 - 10 \text{ mm}$   
 $t_{\text{max}} = 25 \text{ mm}$



$w = 3 - 6 \text{ mm}$   
 $a_p \leq 4 \text{ mm}$

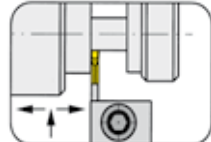


$w = 3 - 10 \text{ mm}$   
 $t_{\text{max}} = 15 \text{ mm}$   
 $D \geq 38 \text{ mm}$

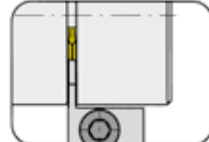


$w = 3 - 4 \text{ mm}$   
 $t_{\text{max}} = 25 \text{ mm}$

切槽  
- 外圆 -  
Grooving  
- external -



页 / Page G2-G13



页 / Page G14-G15



页 / Page G16

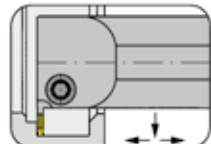


页 / Page G17-G18



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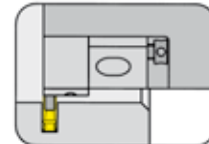
切槽  
- 内圆 -  
Grooving  
- internal -



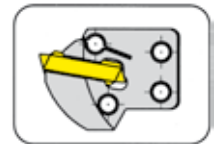
页 / Page G20-G27



页 / Page G28

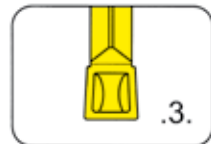


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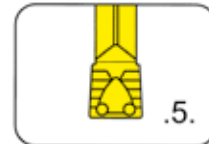


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可转位刀片  
型号  
Indexable inserts type  
**S229**



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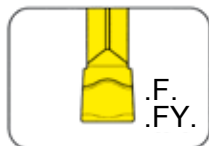
页 / Page G34-G35



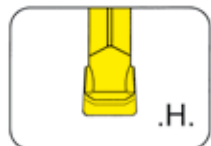
页 / Page G36-G37



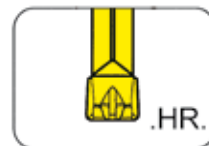
页 / Page G38



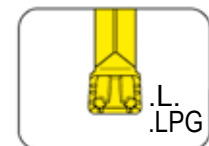
页 / Page G39-G40



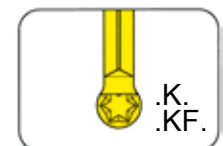
页 / Page G41



页 / Page G42

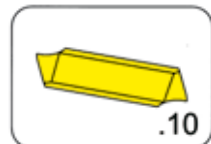


页 / Page G43, G45

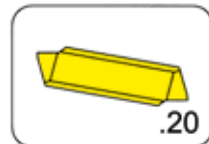


页 / Page G46-G47

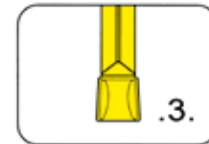
可转位刀片  
型号  
Indexable inserts type  
**229**



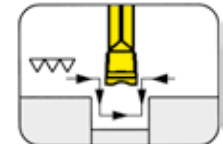
页 / Page G48-G49



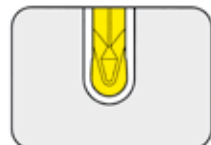
页 / Page G50-G51



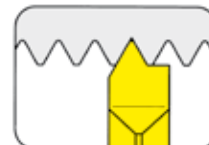
页 / Page G52-G53



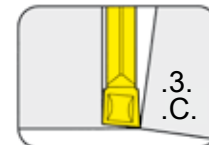
页 / Page G54-G55



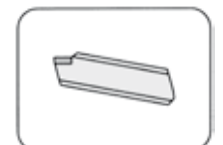
页 / Page G56



页 / Page G57-G59

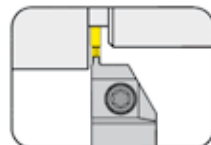


页 / Page G60-G62

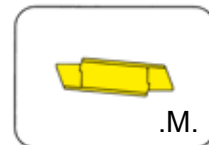


页 / Page G63  
CBN刀片  
CBN-tipped-insert

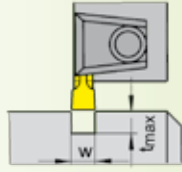
型号  
type  
**H259 / 259**



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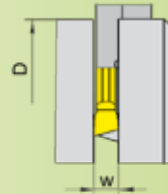
页 / Page G65



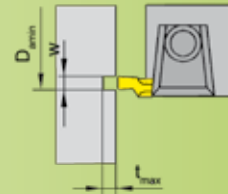
w = 0.5 - 6.3 mm  
t<sub>max</sub> = 8.0 mm



w = 0.5 - 6.3 mm  
t<sub>max</sub> = 5.5 mm  
D ≥ 46 mm



w = 0.5 - 6.3 mm  
D = 12 mm  
t<sub>max</sub> = 8 mm

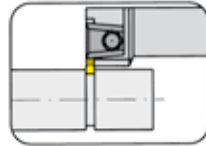


w = 1.5 - 3 mm  
t<sub>max</sub> = 3 mm  
D<sub>amin</sub> = 20 mm

切槽  
- 外圆 -  
Grooving  
- external -



页/Page  
H2-H6, H15-H16



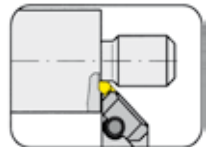
页/Page  
H10



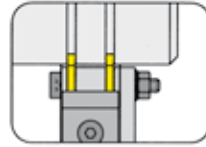
页/Page  
H11



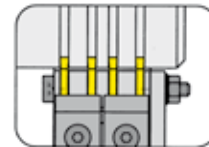
页/Page  
H12-H14



页/Page  
H17

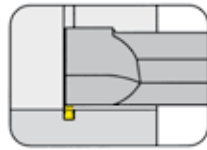


页/Page  
H18



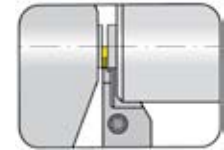
页/Page  
H19

切槽  
- 内圆 -  
Grooving  
- internal -



页/Page  
H20

切断  
Parting off

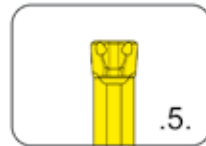


页/Page  
H7-H9

可转位刀片  
型号  
Indexable inserts type  
S312



页/Page  
H21



页/Page  
H22

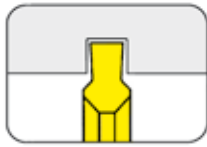


页/Page  
H23

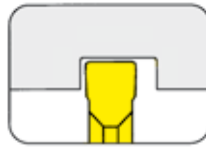


页/Page  
H24

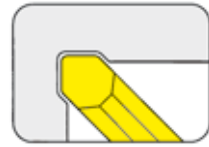
可转位刀片  
型号  
Indexable inserts type  
312



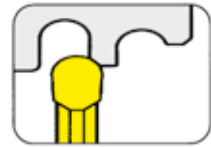
页/Page  
H25-H28



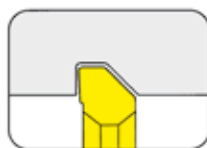
页/Page  
H29-H30



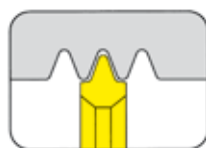
页/Page  
H31-H32



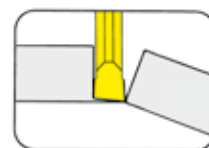
页/Page  
H31-H32



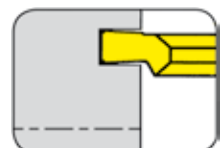
页/Page  
H25-H28



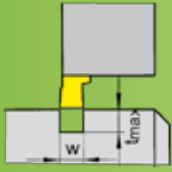
页/Page  
H36



页/Page  
H37-H40



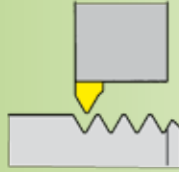
页/Page  
H41



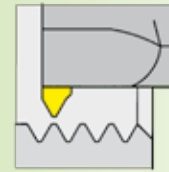
w = 0.5 - 7.5 mm  
t<sub>max</sub> = 5 mm



w = 0.5 - 3.5 mm  
t<sub>max</sub> = 5 mm  
D ≥ 43 mm



米制梯形螺纹  
metric trapezoidal thread



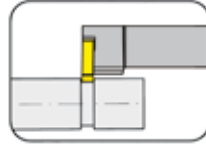
米制梯形螺纹  
metric trapezoidal thread

切槽和螺纹切削  
- 外圆 -

Grooving and threading  
- external -



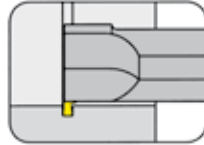
页 / Page  
J2-J4



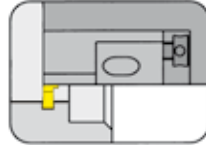
页 / Page  
J5-J6

切槽和螺纹切削  
- 内圆 -

Grooving and threading  
- internal -



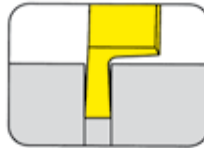
页 / Page  
J7



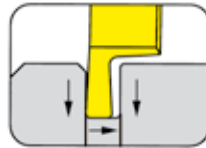
页 / Page  
J8-J9

可转位刀片  
型号

Indexable inserts type  
315



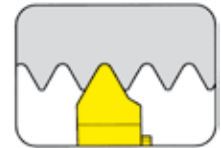
页 / Page  
J10-J11



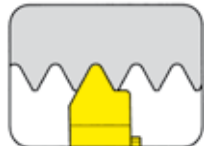
页 / Page  
J12



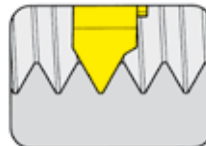
页 / Page  
J13-J14



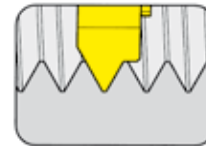
页 / Page  
J15



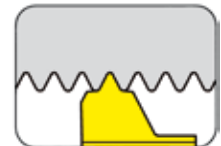
页 / Page  
J16



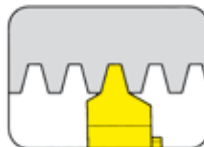
页 / Page  
J17



页 / Page  
J18



页 / Page  
J19

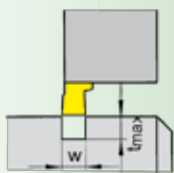


页 / Page  
J20



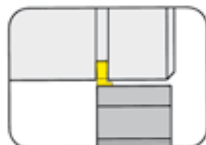
# 刀具系列 S316

## TOOLING SYSTEM S316



w = 1.5 - 3.0 mm  
t<sub>max</sub> = 8.0 mm

切槽  
- 外圆 -  
Grooving  
- external -

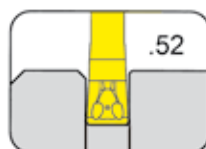


页 / Page  
K2, K8

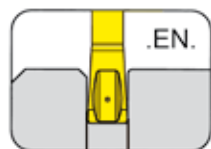


页 / Page  
K3, K9

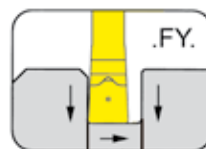
可转位刀片  
型号  
Indexable inserts type  
S316



页 / Page  
K3



页 / Page  
K4



页 / Page  
K5

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

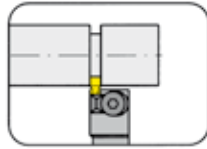
可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

刀具系列 217  
TOOLING SYSTEM 217

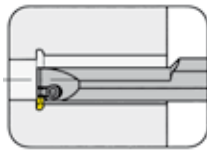
A

切槽  
- 外圆 -  
Grooving  
- external -

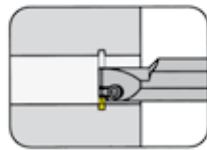


页 / Page  
A2-A4

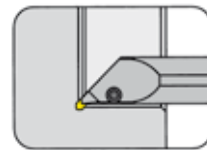
切槽  
- 内圆 -  
Grooving  
- internal -



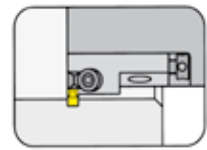
页 / Page  
A5, A7



页 / Page  
A6, A8

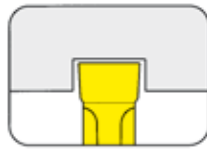


页 / Page  
A9



页 / Page  
A15-A16

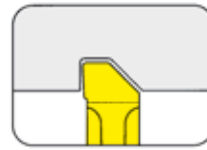
可转位刀片  
型号  
Indexable inserts type  
217



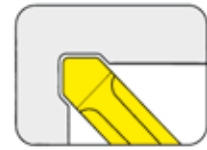
页 / Page  
A10



页 / Page  
A11



页 / Page  
A12



页 / Page  
A13



页 / Page  
A14

技术说明见章节Q  
For Technical Instructions please see chapter Q

# 切槽 ( 外圆 )

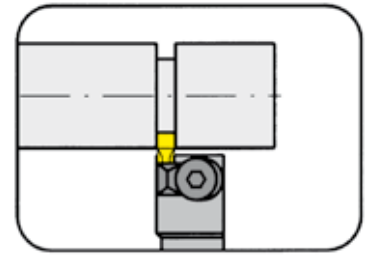
## GROOVING (external)



### 刀杆 型号

TOOLHOLDER Type

# 240



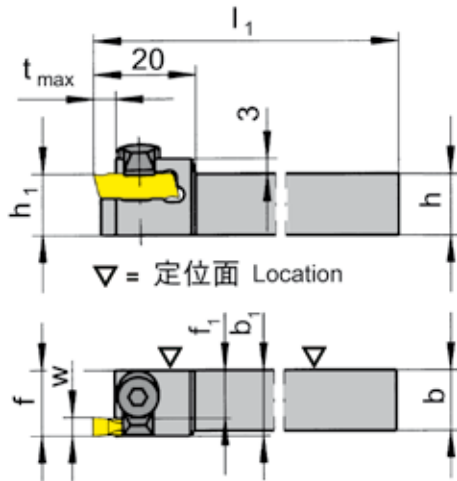
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

4.0 mm  
0.5 - 2.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$b_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L240.1010.01	10	10	80	10	13	11.5	$f_1+w-a_1$	4	01	0.5 - 1.7
R/L240.1212.01	12	12	100	12	13	11.5				
R/L240.1414.01	14	14	100	14	14	12.5				
R/L240.1616.01	16	16	125	16	16	14.5				
R/L240.2020.01	20	20	125	20	20	18.5				
R/L240.1010.02	10	10	80	10	13	10.5	$f_1+w-a_1$	4	02	1.7 - 2.7
R/L240.1212.02	12	12	100	12	13	10.5				
R/L240.1414.02	14	14	100	14	14	11.5				
R/L240.1616.02	16	16	125	16	16	13.5				
R/L240.2020.02	20	20	125	20	20	17.5				

注明R或L型

State R or L version

$w, a_1$ 见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L240....	8.3	5.14	SW2,5DIN911

# 切槽 ( 外圆 )

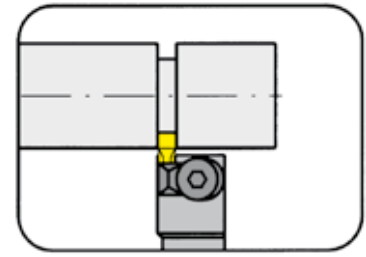
## GROOVING (external)



A

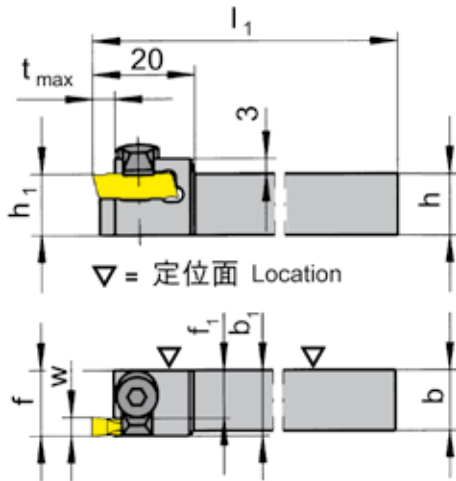
刀杆 型号  
TOOLHOLDER Type

# 240



槽深可达 4.0 mm  
夹持范围 2.7 - 5.3 mm

Depth of groove up to 4.0 mm  
Clamping range 2.7 - 5.3 mm



配合 可转位刀片  
for use with Indexable insert

型号 217  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$b_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L240.1010.03	10	10	80	10	13	9.5	$f_1+w-a_1$	4	03	2.7 - 3.7
R/L240.1212.03	12	12	100	12	13	9.5				
R/L240.1414.03	14	14	100	14	14	10.5				
R/L240.1616.03	16	16	125	16	16	12.5				
R/L240.2020.03	20	20	125	20	20	16.5				
R/L240.1010.04	10	10	80	10	15	9.8	$f_1+w-a_1$	4	04	3.7 - 5.3
R/L240.1212.04	12	12	100	12	15	9.8				
R/L240.1414.04	14	14	100	14	15	9.8				
R/L240.1616.04	16	16	125	16	16	10.8				
R/L240.2020.04	20	20	125	20	20	14.8				

注明R或L型  
State R or L version

$w, a_1$ 见刀片  
 $w, a_1$  see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L240...03	8.3	5.14	SW2,5DIN911
R/L240...04	8.4	5.14	SW2,5DIN911

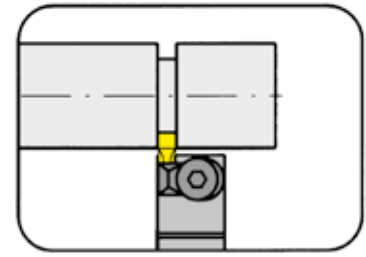
# 切槽 ( 外圆 )

## GROOVING (external)

### 刀杆 型号

TOOLHOLDER Type

# 248



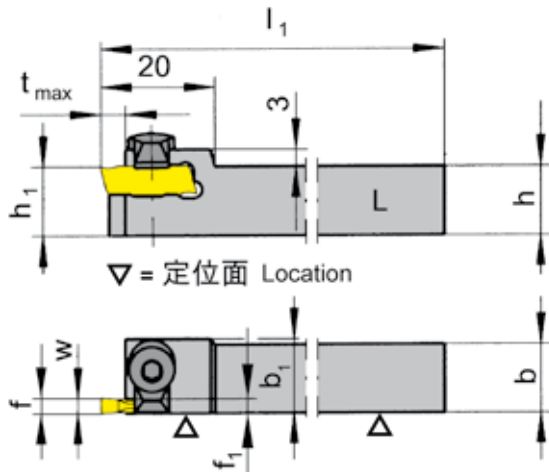
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

4.0 mm  
0.5 - 2.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$b_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
<b>R/L248.1212.01</b>	12	12	95	12	13	1.5	$f_1+a_1$	4	01	0.5 - 1.7
<b>R/L248.1212.02</b>	12	12	95	12	13	2.5	$f_1+a_1$	4	02	1.7 - 2.7

注明R或L型

State R or L version

w, a<sub>1</sub>见刀片

w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L248.1212.0...	<b>8.3</b>	<b>5.14</b>	<b>SW2,5DIN911</b>

# 切槽 (内圆)

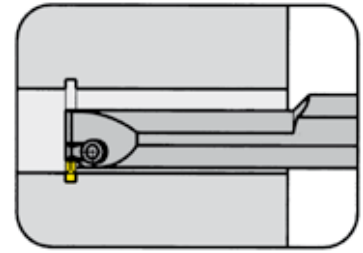
## GROOVING (internal)



A

刀杆型号  
TOOLHOLDER Type

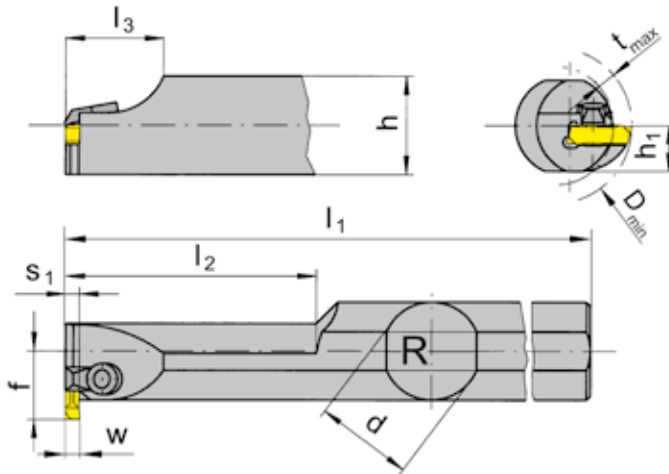
# 230/250



孔径Ø 自	Bore Ø from	20.0 mm
槽深可达	Depth of groove up to	4.7 mm
夹持范围	Clamping range	0.9 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

长悬伸  
long style

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	s <sub>1</sub>	l <sub>3</sub>	规格 Size	夹持范围 Clamping range
R/L230.0020.01	20	180	60	18	9.0	13.3	20	3.0		18	01	0.9 - 1.7
R/L250.0025.01	25	250	80	23	11.5	17.5	25	4.7	1.5	25		
R/L250.0032.01	32	250	80	30	15.0	21.0	32	4.7		25		
R/L230.0020.02	20	180	60	18	9.0	13.3	20	3.0		18	02	1.7 - 2.7
R/L250.0025.02	25	250	80	23	11.5	17.5	25	4.7	2.5	25		
R/L250.0032.02	32	250	80	30	15.0	21.0	32	4.7		25		
R/L230.0020.03	20	180	60	18	9.0	13.3	20	3.0		18	03	2.7 - 3.7
R/L250.0025.03	25	250	80	23	11.5	17.5	25	4.7	3.5	25		
R/L250.0032.03	32	250	80	30	15.0	21.0	32	4.7		25		
R/L230.0020.04	20	180	60	18	9.0	13.3	20	3.0		18	04	3.7 - 5.3
R/L250.0025.04	25	250	80	23	11.5	17.5	25	4.7	5.2	25		
R/L250.0032.04	32	250	80	30	15.0	21.0	32	4.7		25		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L2...01/02/03	8.3	5.14	SW2,5DIN911
R/L2...04	8.4	5.14	SW2,5DIN911

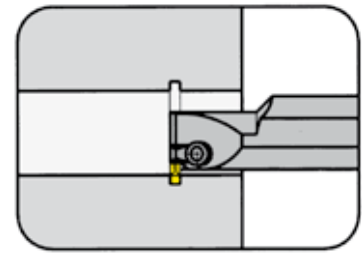
# 切槽 (内圆)

## GROOVING (internal)

### 刀杆 型号

TOOLHOLDER Type

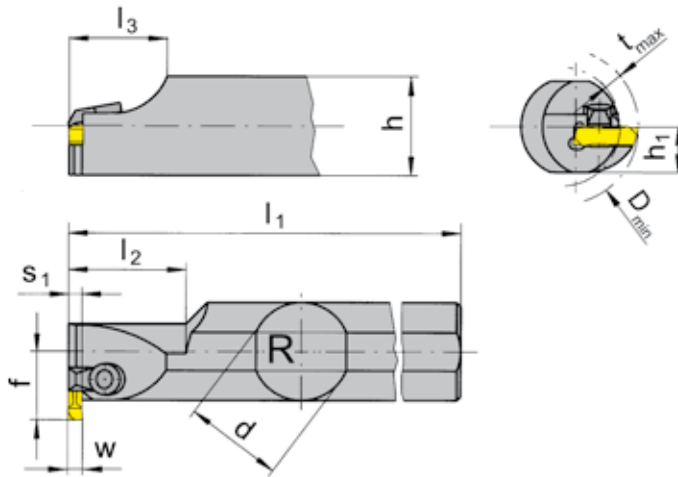
# 233/253



孔径Ø 自	Bore Ø from	20.0 mm
槽深可达	Depth of groove up to	4.7 mm
夹持范围	Clamping range	0.9 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

短悬伸  
short style

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	s <sub>1</sub>	l <sub>3</sub>	规格 Size	夹持范围 Clamping range
R/L233.0020.01	20	130	25	18	9.0	13.3	20	3.0		18	01	0.9 - 1.7
R/L253.0025.01	25	150	30	23	11.5	17.5	25	4.7	1.5	25		
R/L253.0032.01	32	150	30	30	15.0	21.0	32	4.7		25		
R/L233.0020.02	20	130	25	18	9.0	13.3	20	3.0		18	02	1.7 - 2.7
R/L253.0025.02	25	150	30	23	11.5	17.5	25	4.7	2.5	25		
R/L253.0032.02	32	150	30	30	15.0	21.0	32	4.7		25		
R/L233.0020.03	20	130	25	18	9.0	13.3	20	3.0		18	03	2.7 - 3.7
R/L253.0025.03	25	150	30	23	11.5	17.5	25	4.7	3.5	25		
R/L253.0032.03	32	150	30	30	15.0	21.0	32	4.7		25		
R/L233.0020.04	20	130	25	18	9.0	13.3	20	3.0		18	04	3.7 - 5.3
R/L253.0025.04	25	150	30	23	11.5	17.5	25	4.7	5.2	25		
R/L253.0032.04	32	150	30	30	15.0	21.0	32	4.7		25		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L2...01/02/03	8.3	5.14	SW2,5DIN911
R/L2...04	8.4	5.14	SW2,5DIN911



# 切槽 (内圆)

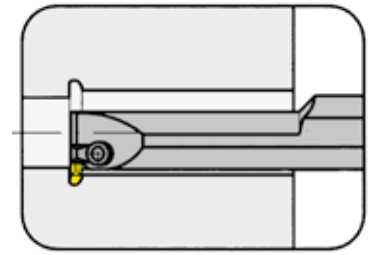
## GROOVING (internal)



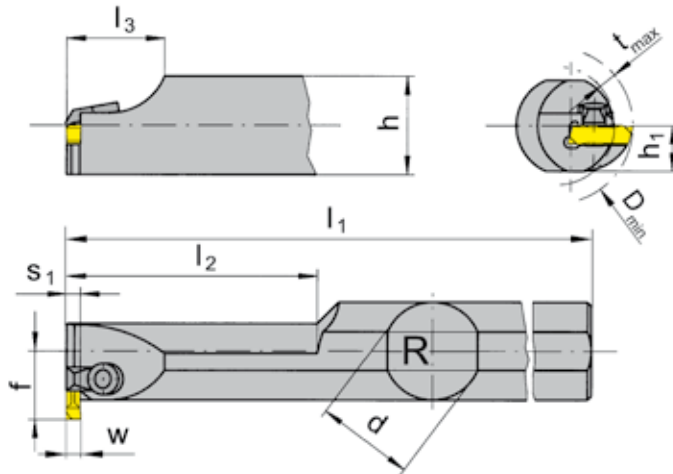
A

刀杆型号  
TOOLHOLDER Type

# 234/254



孔径Ø 自	Bore Ø from	20.0 mm
槽深可达	Depth of groove up to	4.7 mm
夹持范围	Clamping range	0.9 - 5.3 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



针对特殊刀片的长悬伸  
long style for special insert shapes

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	s <sub>1</sub>	l <sub>3</sub>	规格 Size	夹持范围 Clamping range
R/L234.0020.01	20	180	60	18	9.0	13.3	20	3.0		18		
R/L254.0025.01	25	250	80	23	11.5	17.5	25	4.7	1.5	25	01	0.9 - 1.7
R/L254.0032.01	32	250	80	30	15.0	21.0	32	4.7		25		
R/L234.0020.02	20	180	60	18	9.0	13.3	20	3.0		18		
R/L254.0025.02	25	250	80	23	11.5	17.5	25	4.7	2.5	25	02	1.7 - 2.7
R/L254.0032.02	32	250	80	30	15.0	21.0	32	4.7		25		
R/L234.0020.03	20	180	60	18	9.0	13.3	20	3.0		18		
R/L254.0025.03	25	250	80	23	11.5	17.5	25	4.7	3.5	25	03	2.7 - 3.7
R/L254.0032.03	32	250	80	30	15.0	21.0	32	4.7		25		
R/L234.0020.04	20	180	60	18	9.0	13.3	20	3.0		18		
R/L254.0025.04	25	250	80	23	11.5	17.5	25	4.7	5.2	25	04	3.7 - 5.3
R/L254.0032.04	32	250	80	30	15.0	21.0	32	4.7		25		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L2...01/02/03	8.3	5.14	SW2,5DIN911
R/L2...04	8.4	5.14	SW2,5DIN911

# 切槽 (内圆)

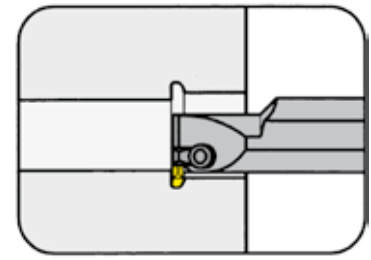
## GROOVING (internal)



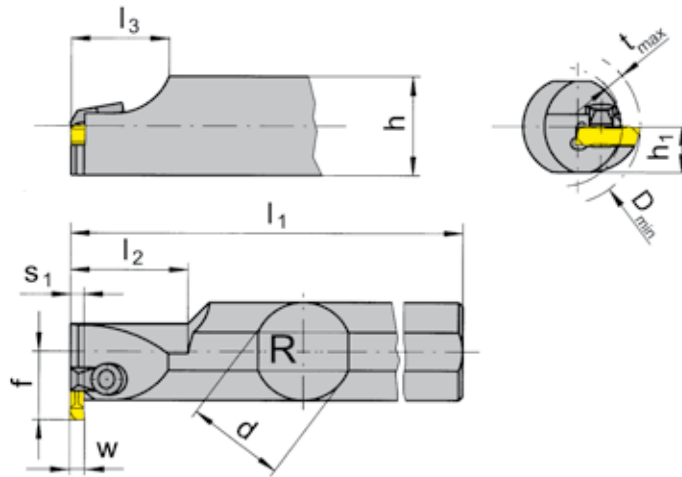
### 刀杆 型号

TOOLHOLDER Type

# 235/255



孔径Ø 自	Bore Ø from	20.0 mm
槽深可达	Depth of groove up to	4.7 mm
夹持范围	Clamping range	0.9 - 5.3 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



针对特殊刀片的短悬伸  
short style for special insert shapes

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	s <sub>1</sub>	l <sub>3</sub>	规格 Size	夹持范围 Clamping range
R/L235.0020.01	20	130	25	18	9.0	13.3	20	3.0		18		
R/L255.0025.01	25	150	30	23	11.5	17.5	25	4.7	1.5	25	01	0.9 - 1.7
R/L255.0032.01	32	150	30	30	15.0	21.0	32	4.7		25		
R/L235.0020.02	20	130	25	18	9.0	13.3	20	3.0		18		
R/L255.0025.02	25	150	30	23	11.5	17.5	25	4.7	2.5	25	02	1.7 - 2.7
R/L255.0032.02	32	150	30	30	15.0	21.0	32	4.7		25		
R/L235.0020.03	20	130	25	18	9.0	13.3	20	3.0		18		
R/L255.0025.03	25	150	30	23	11.5	17.5	25	4.7	3.5	25	03	2.7 - 3.7
R/L255.0032.03	32	150	30	30	15.0	21.0	32	4.7		25		
R/L235.0020.04	20	130	25	18	9.0	13.3	20	3.0		18		
R/L255.0025.04	25	150	30	23	11.5	17.5	25	4.7	5.2	25	04	3.7 - 5.3
R/L255.0032.04	32	150	30	30	15.0	21.0	32	4.7		25		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L2...01/02/03	8.3	5.14	SW2,5DIN911
R/L2...04	8.4	5.14	SW2,5DIN911

# 切退刀槽 (内圆)

## GROOVING CORNER RELIEFS (internal)

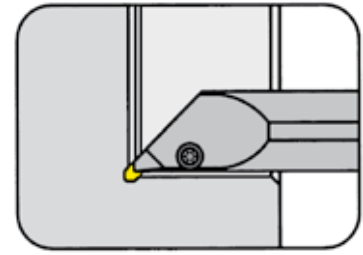


A

刀杆 型号

**245**

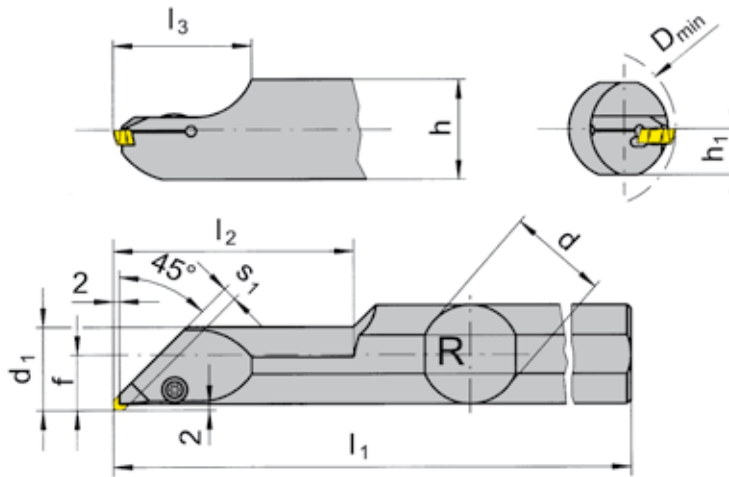
TOOLHOLDER Type



孔径Ø 自

Bore Ø from

20.0 mm



配合 可转位刀片

for use with Indexable insert

型号 217

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

类似于DIN509“F”型

similar to DIN 509 form "F"

产品型号 Part number	d	h	h <sub>1</sub>	l <sub>1</sub>	f	d <sub>1</sub>	s <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	D <sub>min</sub>	规格 Size	夹持范围 Clamping range
R/L245.0020.02	20	18	9	180	12	17.2	2.5	60.43	35.60	20	02	1.7 - 2.7
R/L245.0032.02	32	30	15	250	18	28.2	2.5	80.00	41.60	31	02	1.7 - 2.7
R/L245.0020.03	20	18	9	180	12	17.2	3.5	60.00	35.00	20	03	2.7 - 3.7
R/L245.0032.03	32	30	15	250	18	28.2	3.5	80.64	41.82	31	03	2.7 - 3.7
R/L245.0020.04	20	18	9	180	12	17.2	5.2	60.99	36.17	20	04	3.7 - 5.3
R/L245.0032.04	32	30	15	250	18	28.2	5.2	80.99	42.17	31	04	3.7 - 5.3

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

附件

Spare parts

刀杆 Toolholder	圆柱螺钉 Cylindrical Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L245.00...	51.27.984P	T15PQ

## 切槽 ( 内圆和外圆 )

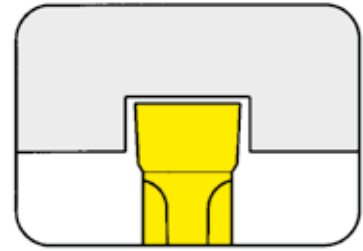
GROOVING (external and internal)



## 可转位刀片 型号

217

INDEXABLE INSERT Type



卡簧槽

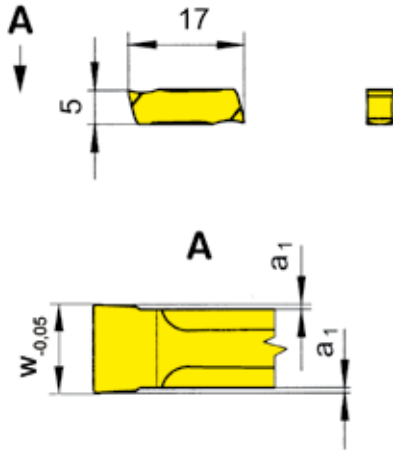
Circlip grooves

DIN471/472

卡簧宽度Nw

Width of circlip Nw

0.5 - 5.2 mm



配合 刀杆

for use with Toolholder

型号 230

Type 232

233

240

248

250

253

刀片长度重复定位精度  
±0.02mm

Indexability length ± 0,02 mm

产品型号 Part number	Nw	w	a <sub>1</sub>	规格 Size	K10	MG12	P20	H20	TN32	TN35	T125	TA45
217.0050.00	0.50	0.57	0.06	01	▲		▲		▲			
217.0060.00	0.60	0.67	0.06		▲		▲		▲			
217.0070.00	0.70	0.77	0.06		▲		▲		▲			
217.0080.00	0.80	0.87	0.06		▲		▲		▲			
217.0090.00	0.90	0.97	0.06		▲		▲		▲			
217.0100.00	1.00	1.07	0.06		▲		▲		▲			
217.0110.00	1.10	1.24	0.10		▲		▲		▲			
217.0130.00	1.30	1.44	0.10		▲		▲		▲			
217.0160.00	1.60	1.74	0.10		▲		▲		▲	▲		
217.0185.00	1.85	1.99	0.10		02	▲		▲	▲	▲		
217.0215.00	2.15	2.29		▲			▲	▲	▲			
217.0265.00	2.65	2.79		▲			▲	▲	▲			
217.0315.00	3.15	3.29	0.10	03	▲		▲	▲	▲			
217.0415.00	4.15	4.29	0.10	04	▲		▲	▲	▲			
217.0515.00	5.15	5.29			▲		▲	▲	▲	▲		
▲ 库存 / on stock Δ 4周 / 4 weeks					P	●	●	●	●	●		
● 主要应用 / main recommendation					M	○		○		●		
○ 可选推荐 / alternative recommendation					K	●				●		
■ 无涂层牌号 / uncoated grades					N	●				●		
■ 涂层牌号 / coated grades					S	○				●		
■ 钎焊/金属陶瓷 / brazed/Cermet					H							

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in right and left hand toolholders.

只有在切宽≥为1.1mm时才能达到最大切深

较小宽度刀片的最大切深 $t_{max}$  = 1 mm, 而且取决于工件的直径 $\varnothing$ 。Max. depth of groove can be reached only with width of cut  $\geq 1,1$  mmSmaller inserts have a limited depth of groove  $t_{max}$  = 1 mm and deeper depths are depending on  $\varnothing$  of workpiece.

硬质合金牌号

Carbide grades

# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)

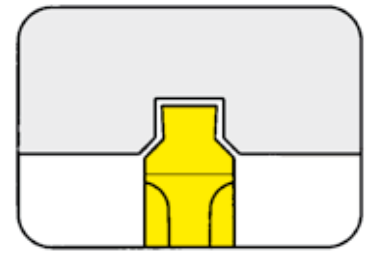


A

### 可转位刀片 型号

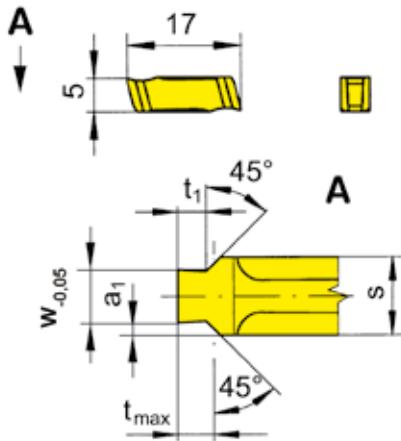
# 217

INDEXABLE INSERT Type



卡簧槽                      Circlip grooves                      DIN471/472  
卡簧宽度Nw                Width of circlip Nw                1.10 - 4.15 mm

带倒角  
with chamfer



配合 刀杆  
for use with Toolholder

型号 234  
Type 235  
240  
248  
254  
255

对于特殊尺寸，请注明：  
 $t_1, t_{max}, w$   
for special dimensions  
please state: w,  $t_1, t_{max}$

产品型号 Part number	Nw	w	$a_1$	$t_1$	$t_{max}$	s	规格 Size	MG12	P20	TN32	TN35	TI22	TA45
217.1101.25	1.10	1.24	0.64	0.19	0.20	2.5	02						
217.1102.25	1.10	1.24	0.64	0.24	0.25								
217.1103.25	1.10	1.24	0.64	0.29	0.30								
217.1104.25	1.10	1.24	0.64	0.33	0.35								
217.1105.25	1.10	1.24	0.64	0.36	0.40								
217.1306.25	1.30	1.44	0.54	0.45	0.55								
217.1607.33	1.60	1.74	0.79	0.60	0.70	3.3	03						
217.1608.33	1.60	1.74	0.79	0.75	0.85								
217.1609.33	1.60	1.74	0.79	0.85	1.00								
217.1810.33	1.85	1.99	0.67	0.85	1.00								
217.1812.33	1.85	1.99	0.67	1.10	1.25								
217.2115.43	2.15	2.29	1.02	1.35	1.50	4.3	04						
217.2616.43	2.65	2.79	0.77	1.35	1.50								
217.2617.43	2.65	2.79	0.77	1.60	1.75								
217.3118.53	3.15	3.29	1.02	1.60	1.75								
217.4120.53	4.15	4.29	0.52	1.85	2.00								
217.4125.53	4.15	4.29	0.52	2.35	2.50								

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●	●			
M					
K					
N					
S					
H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left** hand toolholders.

## 切槽 ( 内圆和外圆 )

GROOVING (external and internal)



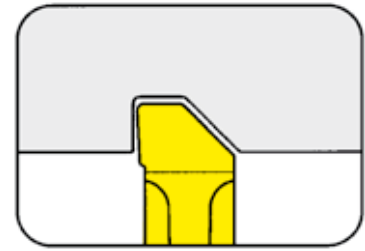
## 可转位刀片 型号

INDEXABLE INSERT Type

217

## DIN76短型螺纹退刀槽

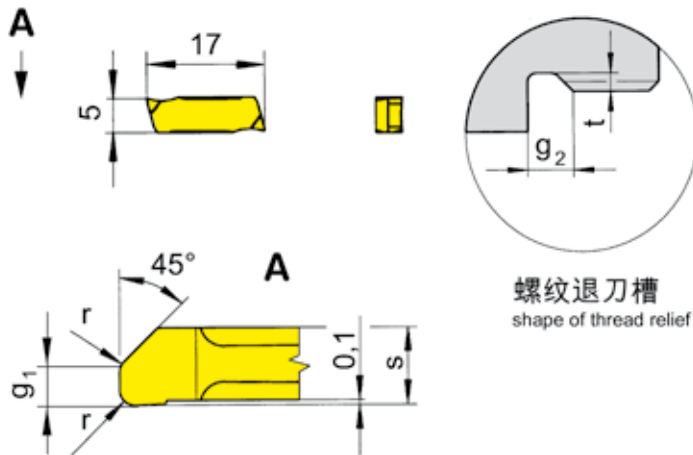
Thread relief DIN 76 "Short form"



## 配合 刀杆

for use with Toolholder

型号 234  
Type 235  
240  
248  
254  
255



螺纹退刀槽  
shape of thread relief

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	P	r	s	$g_1$	$g_2$	$t_{max}$	规格 Size	MG12	P20	TN32	TN35	TI22	TA45
R/L217.1050.17	0.50	0.2	1.7	1.25	1.75	0.50	01						
R/L217.1060.27	0.60			1.50	2.05	0.55	02		△/△				
R/L217.1070.27	0.70	0.4	2.7	1.75	2.35	0.60							
R/L217.1080.27	0.80			2.00	2.70	0.70							
R/L217.1100.37	1.00	0.6	3.7	2.50	3.40	0.90	03		▲/△				
R/L217.1125.53	1.25	0.6	5.3	3.20	4.25	1.05	04		△/△				
R/L217.1150.53	1.50	0.8		3.80	5.00	1.20			△/△				
▲ 库存 / on stock    △ 4周 / 4 weeks								P	•				
● 主要应用 / main recommendation								M					
○ 可选推荐 / alternative recommendation								K					
■ 无涂层牌号 / uncoated grades								N					
■ 涂层牌号 / coated grades								S					
■ 钎焊/金属陶瓷 / brazed/Cermet								H					

尺寸单位 : mm

Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

## 外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

## External machining:

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

## 内圆加工 :

右手型刀片配合左手型刀杆, 左手型刀片配合右手型刀杆

## Internal machining:

Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

# 切退刀槽 ( 内圆 )

## GROOVING CORNER RELIEFS (internal)

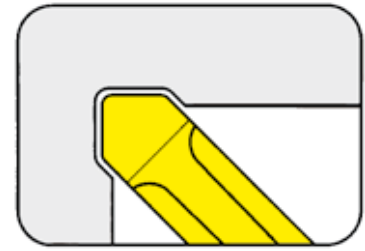


A

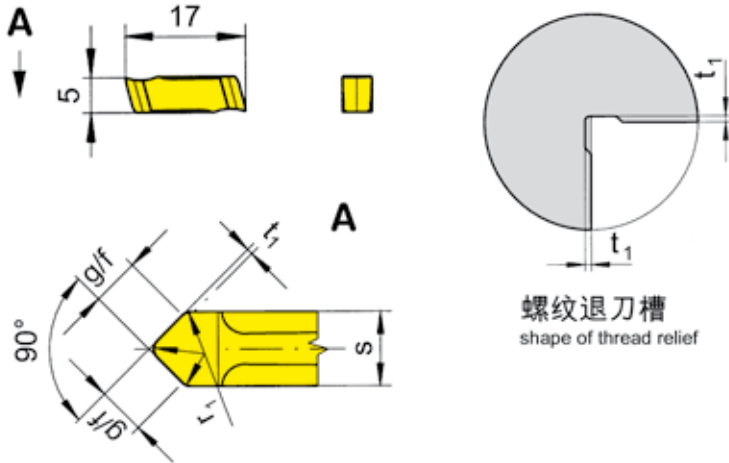
### 可转位刀片 型号

INDEXABLE INSERT Type

# 217



类似于DIN509F型退刀槽  
Corner reliefs similar to DIN 509 form "F"



螺纹退刀槽  
shape of thread relief

配合 刀杆  
for use with Toolholder

型号 245  
Type

产品型号 Part number	$r_1$	$g_f$	$s$	$t_1$	$D_{min}$	规格 Size	MG12	P20	TN32	TN35	TI22	TA45
217.0602.24	0.6	1.7	2.4	0.2	20	02		▲	▲			
217.0603.33	0.6	2.3	3.3	0.3	23	03		▲				
217.1002.30	1.0	2.1	3.0	0.2	22	03						
217.1004.50	1.0	3.6	5.0	0.4	27	04						
217.1603.50	1.6	3.6	5.0	0.3	27	04						
▲ 库存 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet							P	•	•			
							M					
							K					
							N					
							S					
							H					

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left** hand toolholders.

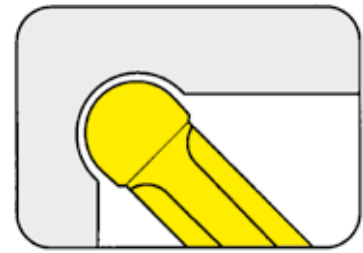
# 切退刀槽 (内圆)

## GROOVING CORNER RELIEFS (internal)

可转位刀片 型号

**217**

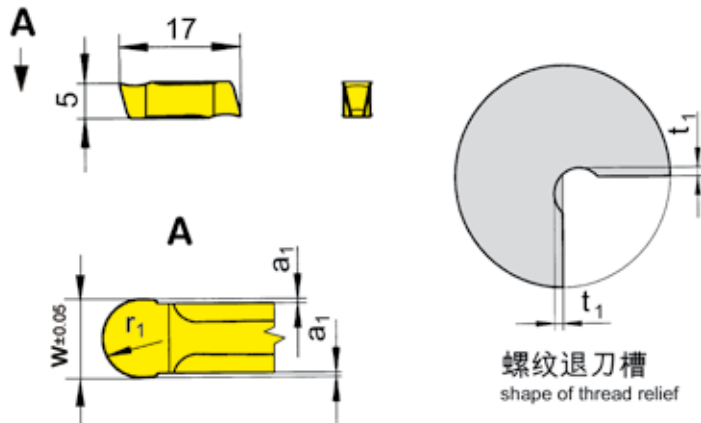
INDEXABLE INSERT Type



圆头

Full radius

r 1.0 - 2.5 mm



配合 刀杆

for use with Toolholder

型号 245

Type

产品型号 Part number	$r_1$	w	$a_1$	$t_1$	$D_{min}$	规格 Size		K10	P20	TN32	TN35	TI22	TA45
<b>217.0010.20</b>	1.0	2	0.1	0.75	<b>20</b>	02		▲	▲	▲	▲		
<b>217.0015.30</b>	1.5	3	0.1	1.00	<b>20</b>	03		▲	▲	▲	▲		
<b>217.0020.40</b>	2.0	4		1.25	<b>20</b>	04			▲		▲		
<b>217.0025.50</b>	2.5	5	0.1	1.50				Δ	▲				
▲ 库存 / on stock Δ 4周 / 4 weeks							P	•	•	•	•		
• 主要应用 / main recommendation							M	○				•	
○ 可选推荐 / alternative recommendation							K	•				•	
■ 无涂层牌号 / uncoated grades							N	•				•	
■ 涂层牌号 / coated grades							S	○				•	
■ 钎焊/金属陶瓷 / brazed/Cermet							H						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left** hand toolholders.硬质合金牌号  
Carbide grades



# 切槽 (内圆)

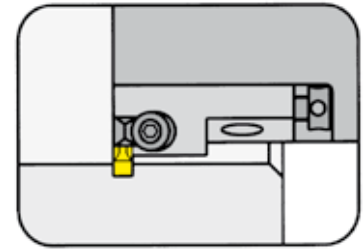
## GROOVING (internal)



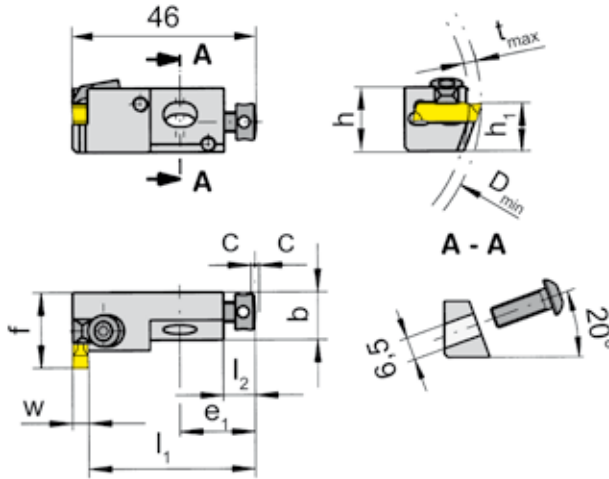
A

刀夹 型号  
CARTRIDGE Type

# 232



孔径Ø 自 Bore Ø from 40.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 217  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$h_1$	f	h	b	$l_1$	$D_{min}$	$t_{max}$	$e_1$	$l_2$	c	规格 Size	夹持范围 Clamping range
R/L232.1212.01	12	19	16	12	44.4	40	3	19	8	1	01	0.9 - 1.7
R/L232.1212.02	12	19	16	12	43.4	40	3	19	8	1	02	1.7 - 2.7
R/L232.1212.03	12	19	16	12	42.4	40	3	19	8	1	03	2.7 - 3.7
R/L232.1212.04	12	19	16	12	40.7	40	3	19	8	1	04	3.7 - 5.3

注明R或L型  
State R or L version

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

基座尺寸见下一页  
Dimensions of seating see following page

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

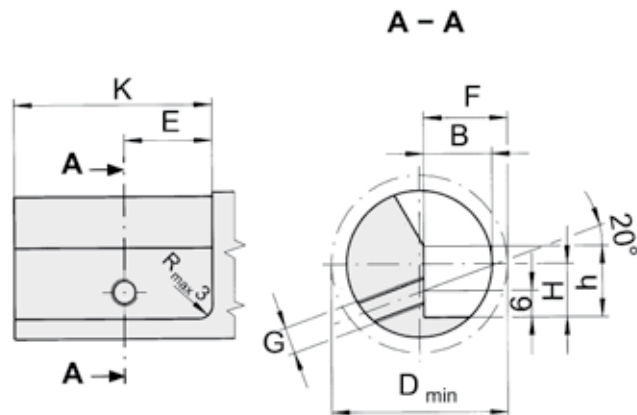
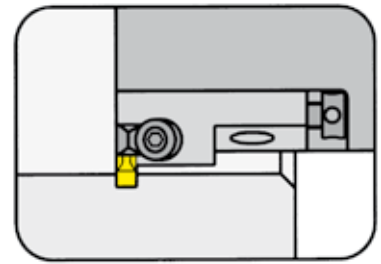
刀夹 Cartridge	压板 Clamp	螺钉 Screw	螺钉 Screw	螺钉 Screw	轴向调节螺钉 Adjust screw axial	扳手 Wrench
R/L232.1212.01/02/03	8.3	6.20.232	4.08.913	5.14	5.08.020	SW2,5DIN911
R/L232.1212.04	8.4	6.20.232	4.08.913	5.14	5.08.020	SW2,5DIN911

# 切槽 ( 内圆 )

## GROOVING (internal)

外形尺寸 刀夹 型号

SEATING DIMENSIONS CARTRIDGE type

**232**

刀夹 Cartridge	F	G	H	K	E	B	h	D <sub>min</sub>	紧固螺钉 Fastening screw
<b>232.1212...</b>	19	M6	12	45	20	15.5	16	40	6.20.232

尺寸单位 : mm  
Dimensions in mm

### 制动钳上密封槽

回转头控制镗杆的移动。根据制动钳形式不同，镗杆也将特殊设计。独特的夹持方式保证了刀片最大的夹持刚性。

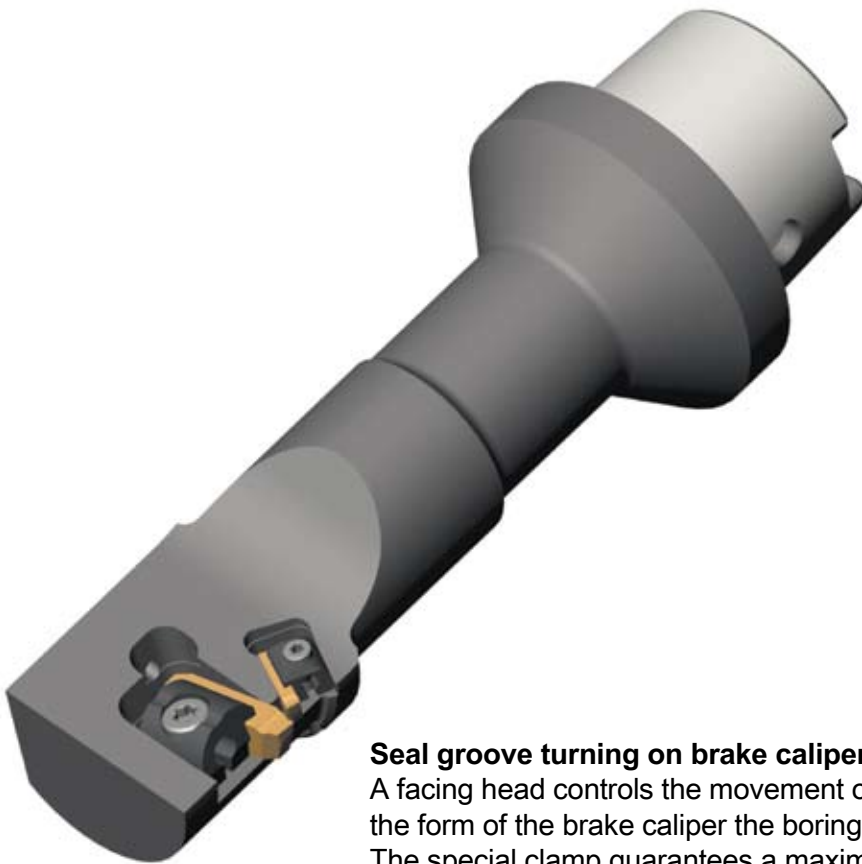
为了防止切屑停留在内孔槽内，231系列刀片的切削刃上设计了断屑尖角。槽圆度约 0.06 mm (.002")。

材料: GGG40

切削参数:

$$v_c = 160 \text{ m/min}$$

$$v_f = 0.12 \text{ mm}$$



槽型  
Profile of groove

### Seal groove turning on brake caliper

A facing head controls the movement of the boring bar. Due to the form of the brake caliper the boring bar has a specific design. The special clamp guarantees a maximum clamping rigidity of the insert.

To avoid remaining swarfs in the groove the insert of type 231 has a clip divider ground on the cutting edge.

Possible roundness of the groove appr. 0.06 mm (.002").

Material: GGG40

Cutting data:

$$v_c = 160 \text{ m/min}$$

$$v_f = 0.12 \text{ mm}$$

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

B

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
<b>加工 / Machining</b>										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
<b>加工 / Machining</b>										
割槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

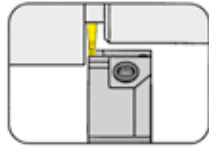
尺寸单位：mm  
Dimensions in mm

刀具系列 264

TOOLING SYSTEM 264

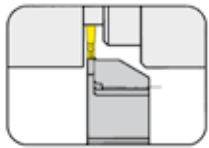
B

刀杆  
螺钉锁紧  
Toolholder  
with screwed clamping



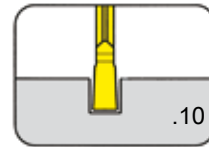
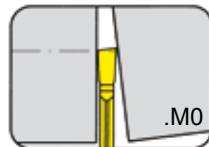
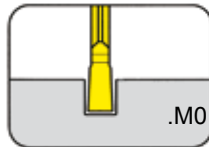
页 / Page  
B2-B4

刀杆  
自夹紧  
Toolholder  
with self clamping



页 / Page  
B5

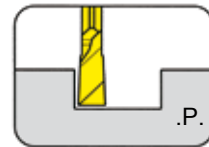
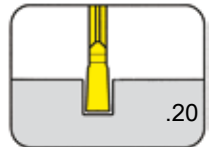
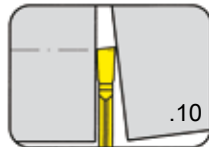
可转位刀片  
型号  
Indexable inserts type  
S264 / 264



页 / Page  
B6

页 / Page  
B7

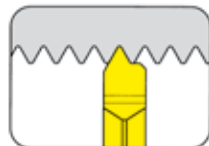
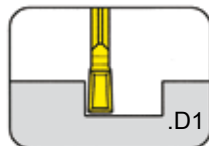
页 / Page  
B8



页 / Page  
B9

页 / Page  
B10

页 / Page  
B11



页 / Page  
B12

页 / Page  
B13

技术说明见章节Q

For Technical Instructions please see chapter Q

# 切槽和切断

## GROOVING and PARTING OFF



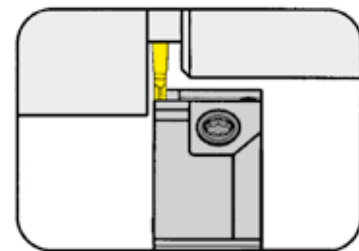
B

### 刀杆 型号

TOOLHOLDER Type

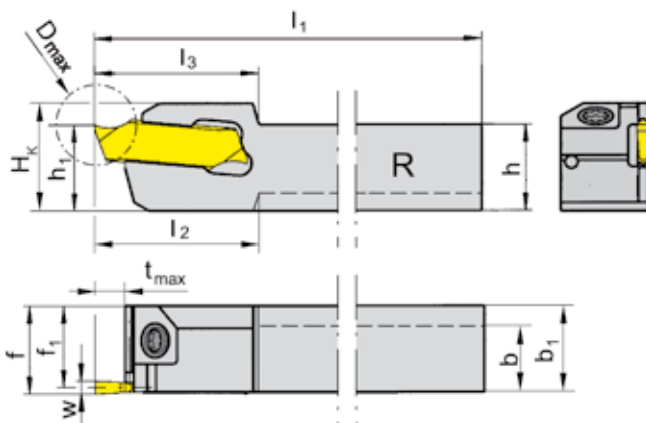
# H264

螺钉锁紧  
with screwed clamping



槽深可达  
槽宽

Depth of groove up to 16.0 mm  
Width of groove 1.5 - 2.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	b <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>K</sub>	规格 Size
R/LH264.0808.01	8	8		17.5		8	10	9.25	10			22	12.5	01
R/LH264.1010.01	10	10	120	-	17.5	10	-	9.25	10	4	1.5	22	12.5	
R/LH264.1212.01	12	12		-		12	-	11.25	12			22	14.5	
R/LH264.1616.01	16	16		-		16	-	15.25	16			32	18.5	
R/LH264.1010.11	10	10				10		9.25	10			20	12.5	01
R/LH264.1212.11	12	12	120	-	19.0	12	-	11.25	12	10	1.5	20	14.5	
R/LH264.1616.11	16	16				16		15.25	16			32	18.5	
R/LH264.1212.21	12	12	120	-	22.0	12	-	11.25	12	13	1.5	26	15.5	01
R/LH264.1616.21	16	16				16		15.25	16			32	19.5	
R/LH264.1010.02	10	10				10		9.00	10				12.5	02
R/LH264.1212.02	12	12	120	-	17.5	12	-	11.00	12	4	2.0	32	14.5	
R/LH264.1616.02	16	16				16		15.00	16				18.5	
R/LH264.1010.12	10	10				10		9.00	10				12.5	02
R/LH264.1212.12	12	12	120	-	19.0	12	-	11.00	12	10	2.0	32	14.5	
R/LH264.1616.12	16	16				16		15.00	16				18.5	
R/LH264.1212.22	12	12	120	-	25.0	12	-	11.00	12	16	2.0	32	14.5	02
R/LH264.1616.22	16	16				16		15.00	16				19.5	

注明R或L型  
State R or L version

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264....	3.5-12T10EP	T10PL

# 切槽和切断

## GROOVING and PARTING OFF



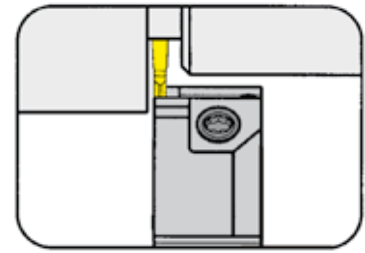
B

### 刀杆 型号

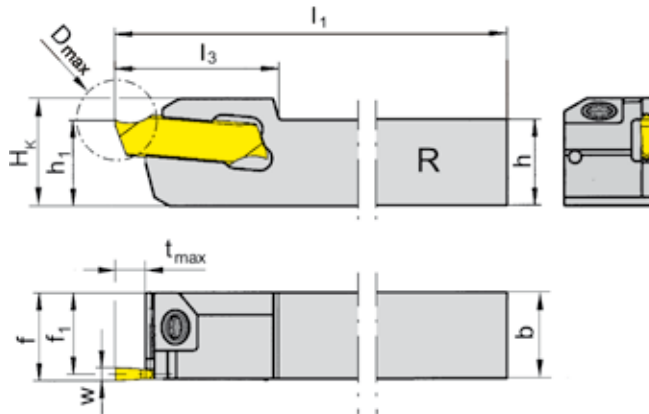
TOOLHOLDER Type

## H264

螺钉锁紧  
with screwed clamping



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	2.5 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	2.5	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	2.5	32	18.5	03
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	2.5	32	18.5	03
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	2.5	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	2.5	32	18.5	03

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL

# 切槽和切断

## GROOVING and PARTING OFF



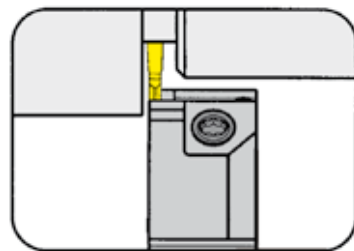
B

### 刀杆 型号

TOOLHOLDER Type

## H264

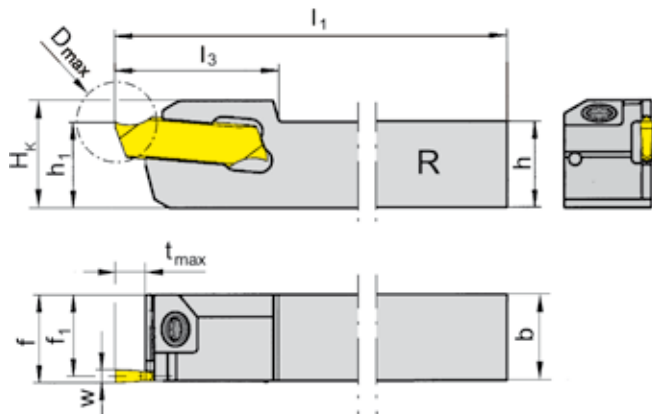
螺钉锁紧  
with screwed clamping



槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
3.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	3	32	15	04
R/LH264.1616.04	16	16			16	14.5	16					
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	3	32	15	04
R/LH264.1616.14	16	16			16	14.5	16					
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	3	32	15	04
R/LH264.1616.24	16	16			16	14.5	16					

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL



# 切槽和切断

## GROOVING and PARTING OFF

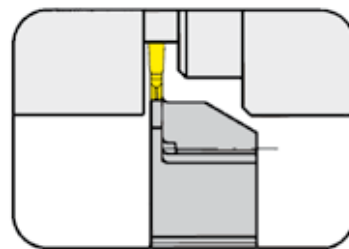


### 刀杆 型号

TOOLHOLDER Type

## H264

自锁紧  
with self clamping

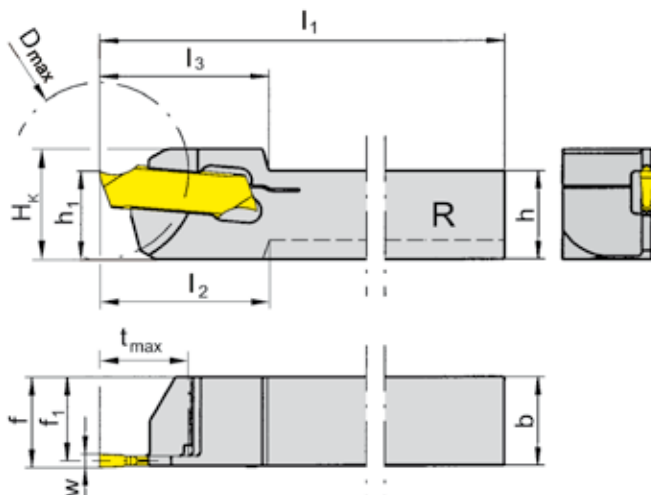


槽深可达  
槽宽

Depth of groove up to 10.0 mm  
Width of groove 1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>K</sub>	规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	1.5	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	1.5	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	2.0	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	2.0	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	3.0	32	14.5	04

注明R或L型

State R or L version

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项:

扳手P39L不包含在刀板中, 需单独订购!

Note:

Wrench P39L is not combined with blade - separate order required!

### 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
R/LH264....	P39L

# 切槽和切断

## GROOVING and PARTING OFF

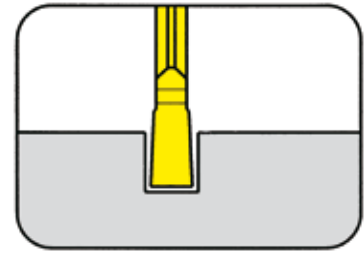


B

可转位刀片 型号

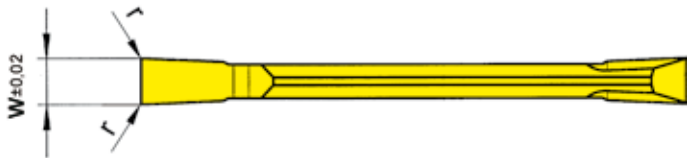
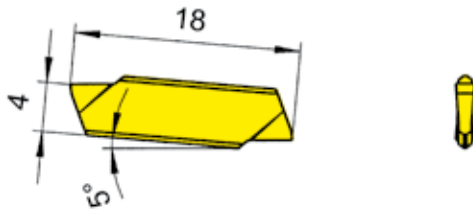
264

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	规格 Size	MG12	TN35	TI25	TA45
264.0150.M0	1.5	0.05	01	▲	▲		
264.0200.M0	2.0	0.05	02	▲	▲		
264.0250.M0	2.5	0.10	03	▲	△		
264.0300.M0	3.0	0.10	04	△	△		
				P	○	●	
				M	●	●	
				K	●	●	
				N	●	●	
				S	●	●	
				H			

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切断 PARTING OFF

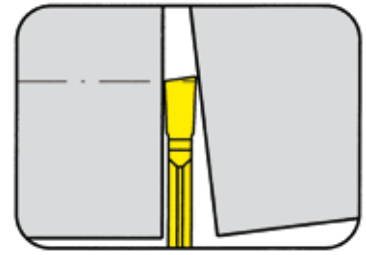


B

## 可转位刀片 型号

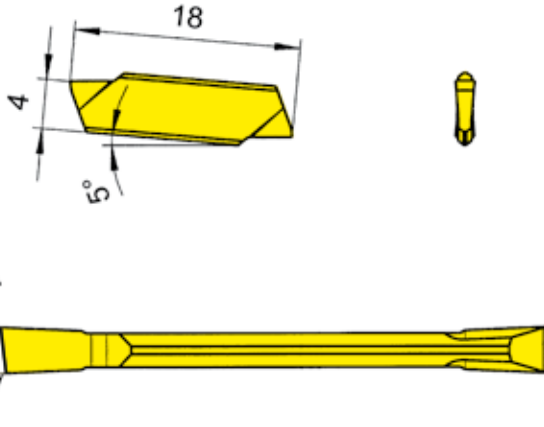
# 264

INDEXABLE INSERT Type



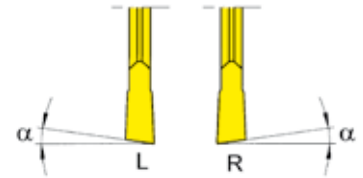
槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	规格 Size	硬质合金牌号			
					MG12	TN35	TI25	TA45
R/L264.0815.M0 R/L264.1515.M0	1.5	0.05	8° 15°	01	Δ/Δ ▲/Δ	▲/Δ ▲/Δ		
R/L264.0820.M0 R/L264.1520.M0	2.0	0.05	8° 15°	02	Δ/Δ Δ/Δ	Δ/Δ ▲/Δ		
R/L264.0825.M0 R/L264.1525.M0	2.5	0.10	8° 15°	03	/Δ Δ/Δ	Δ/Δ ▲/		
R/L264.0830.M0 R/L264.1530.M0	3.0	0.10	8° 15°	04	/Δ Δ/Δ		Δ/Δ Δ/Δ	
▲ 库存 / on stock   Δ 4周 / 4 weeks					P	○	●	●
● 主要应用 / main recommendation					M	●	●	●
○ 可选推荐 / alternative recommendation					K	●	●	●
■ 无涂层牌号 / uncoated grades					N	●	●	●
■ 涂层牌号 / coated grades					S	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet					H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

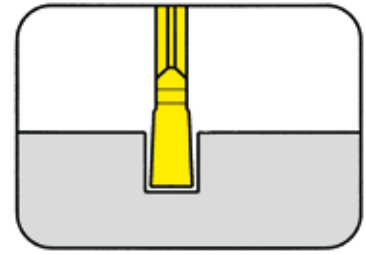


B

可转位刀片 型号

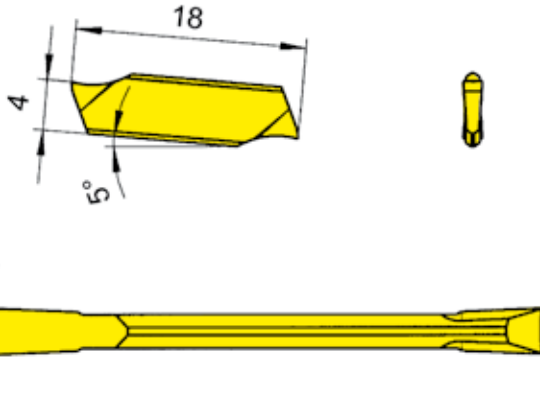
**264**

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	规格 Size	MG12	TN35	TI25	TA45
264.0150.10	1.5	0.05	01	▲	▲		
264.0200.10	2.0	0.05	02	▲	▲		
264.0250.10	2.5	0.10	03	△	▲		
264.0300.10	3.0	0.10	04	△	▲		
				P	○	●	■
				M	●	●	■
				K	●	●	■
				N	●	●	■
				S	●	●	■
				H			

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切断 PARTING OFF

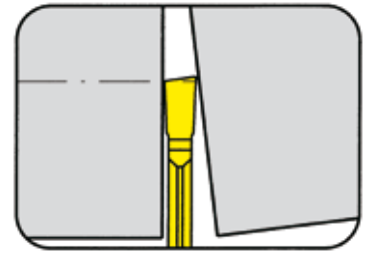


B

## 可转位刀片 型号

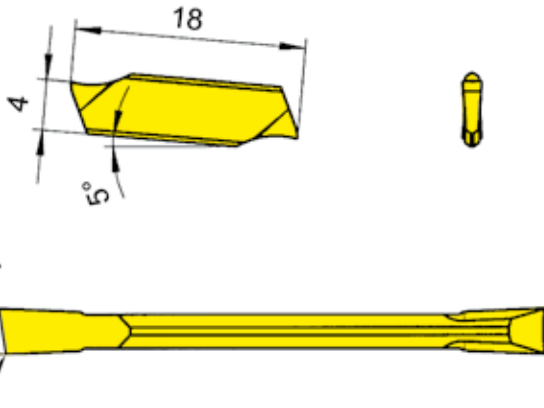
# 264

INDEXABLE INSERT Type



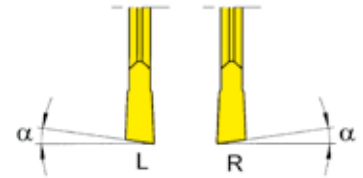
槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	规格 Size	硬质合金牌号			
					MG12	TN35	TI25	TA45
R/L264.0815.10 R/L264.1515.10	1.5	0.05	8° 15°	01	△/△ △/△	▲/▲ ▲/▲		
R/L264.0820.10 R/L264.1520.10	2.0	0.05	8° 15°	02	▲/△ ▲/△	▲/▲ ▲/▲		
R/L264.0825.10 R/L264.1525.10	2.5	0.10	8° 15°	03		▲/△ ▲/△		
R/L264.0830.10 R/L264.1530.10	3.0	0.10	8° 15°	04		△/△ ▲/▲		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	○	●	■	■
M	●	●	■	■
K	●	●	■	■
N	●	●	■	■
S	●	●	■	■
H				

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和切断

## GROOVING and PARTING OFF

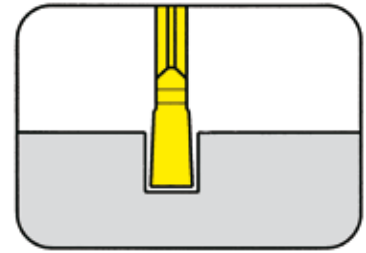


B

可转位刀片 型号

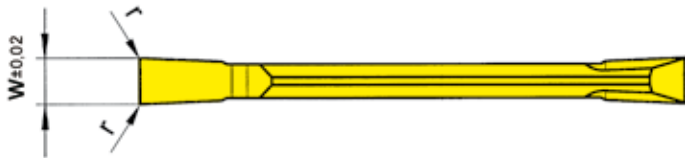
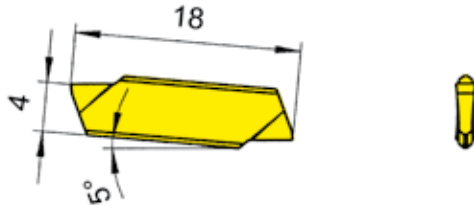
264

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	规格 Size	涂层 / Coating			
				MG12	TN35	TI25	TA45
264.0150.20	1.5	0.05	01		▲		
264.0200.20	2.0	0.05	02		▲		
264.0250.20	2.5	0.10	03		▲		
264.0300.20	3.0	0.10	04		▲		
				P	•	•	•
				M	•	•	•
				K	•	•	•
				N	•	•	•
				S	•	•	•
				H			

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽和侧车削

## GROOVING and SIDE TURNING

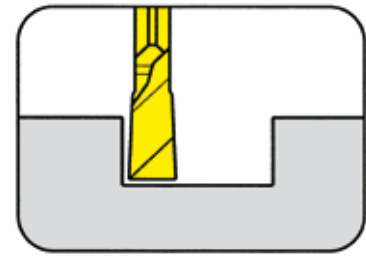


B

### 可转位刀片 型号

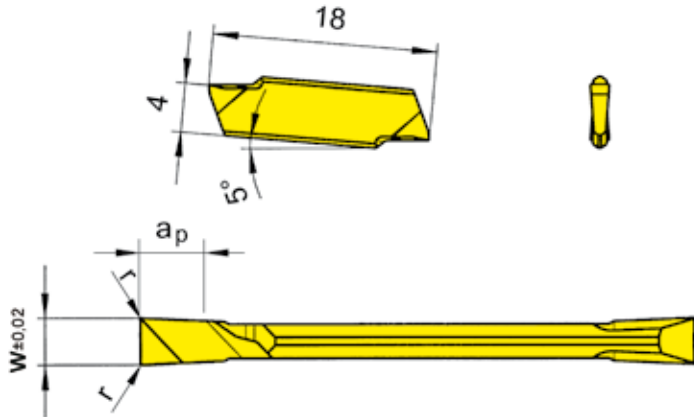
# 264

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	w	r	规格 Size	硬质合金牌号			
				MG12	TN35	TI25	TA45
R/L264.0150.P0	1.5	0.05	01		▲/▲	▲/▲	
R/L264.0200.P0 R/L264.0200.P2	2.0	0.05 0.20	02	▲/▲	▲/▲ ▲/▲	▲/▲	
R/L264.0250.P0 R/L264.0250.P2	2.5	0.10 0.20	03	▲/	▲/▲ ▲/▲	▲/▲	
R/L264.0300.P0 R/L264.0300.P2	3.0	0.10 0.20	04	▲/▲	▲/▲ ▲/▲	▲/▲	
▲ 库存 / on stock    ▲ 4周 / 4 weeks				P	○	●	●
● 主要应用 / main recommendation				M	●	●	●
○ 可选推荐 / alternative recommendation				K	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm  
Dimensions in mm

$a_p = 1.5 \times w$   
 $a_p = 1,5 \times w$

硬质合金牌号  
Carbide grades

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和侧车削

## GROOVING and SIDE TURNING

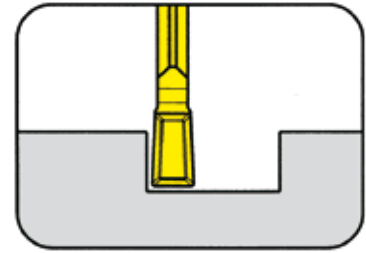


B

### 可转位刀片 型号

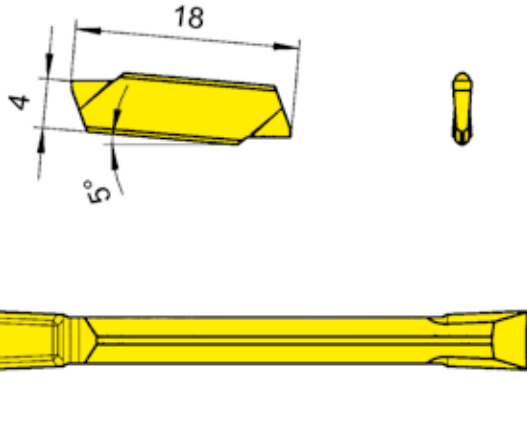
# S264

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	16.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密烧结  
precision sintered



配合 刀杆  
for use with Toolholder

型号 H264  
Type

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	规格 Size	MG12	TN35	TI25	TA45
S264.0150.D1	1.5	0.05	01	△	▲		
S264.0200.D1	2.0	0.05	02	△	▲		
S264.0250.D1	2.5	0.10	03		▲		
S264.0300.D1	3.0	0.10	04	△	▲		
				P	○	●	
				M	●	●	
				K	●	●	
				N	●	●	
				S	●	●	
				H			

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile



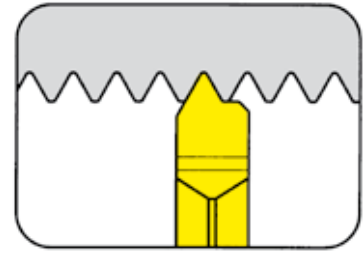
B

### 可转位刀片 型号

INDEXABLE INSERT Type

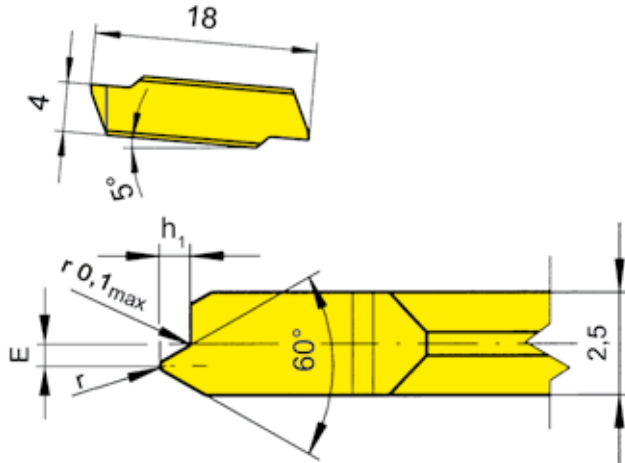
# 264

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 1.5 mm
----	-------	--------------

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H264  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	P	r	E	h <sub>1</sub>	规格 Size	MG12	TN35	TI25	TA45	TF45
R/L264.0305.02	0.50	0.07	0.90	0.31	03					▲/▲
R/L264.0306.02	0.60	0.09	0.90	0.37	03					△/△
R/L264.0307.02	0.70	0.10	0.80	0.43	03					▲/△
R/L264.0407.02	0.75	0.11	0.75	0.46	03					▲/▲
R/L264.0408.02	0.80	0.12	0.70	0.49	03					▲/△
R/L264.0610.02	1.00	0.12	0.60	0.61	03					▲/▲
R/L264.0712.02	1.25	0.15	0.50	0.77	03					▲/△
R/L264.0915.02	1.50	0.20	0.40	0.92	03					▲/△

- ▲ 库存 / on stock △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P					●
M					●
K					●
N					●
S					●
H					

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with full ground radial clearance.

# HCG - HORN Catalogue Guide

## 内部切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

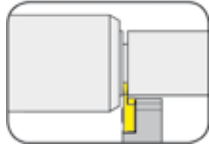
槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•	•	•	•	•	•	•		•
可达 / up to 10		•	•	•	•	•	•			
可达 / up to 14			•		•		•			
可达 / up to 18			•		•		•			
可达 / up to 25			•				•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•		•		•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

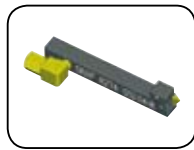
刀具系列 S274  
TOOLING SYSTEM S274 C

刀杆  
Toolholder

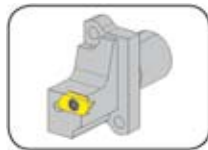


页 / Page  
C3-C4, C26

刀杆  
- 专用机 -  
Toolholder  
- machine-specific -



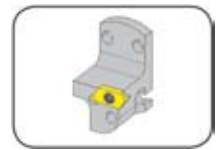
页 / Page  
C5



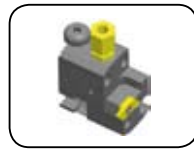
页 / Page  
C6



页 / Page  
C7

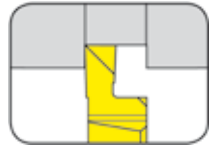


页 / Page  
C8

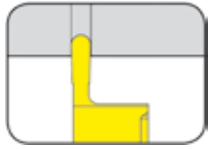


页 / Page  
C9

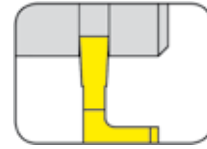
可转位刀片  
型号  
Indexable inserts type  
S274



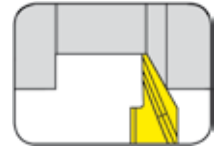
页 / Page  
C10, C27



页 / Page  
C11, C28



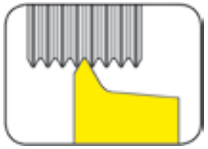
页 / Page  
C12-C14, C29-C31



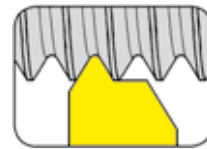
页 / Page  
C15-C16, C32-C33



页 / Page  
C17-C22, C34-C39



非全牙型  
Partial profile  
页 / Page  
C23, C40



全牙型  
Full profile  
页 / Page  
C24-C25, C41-C42

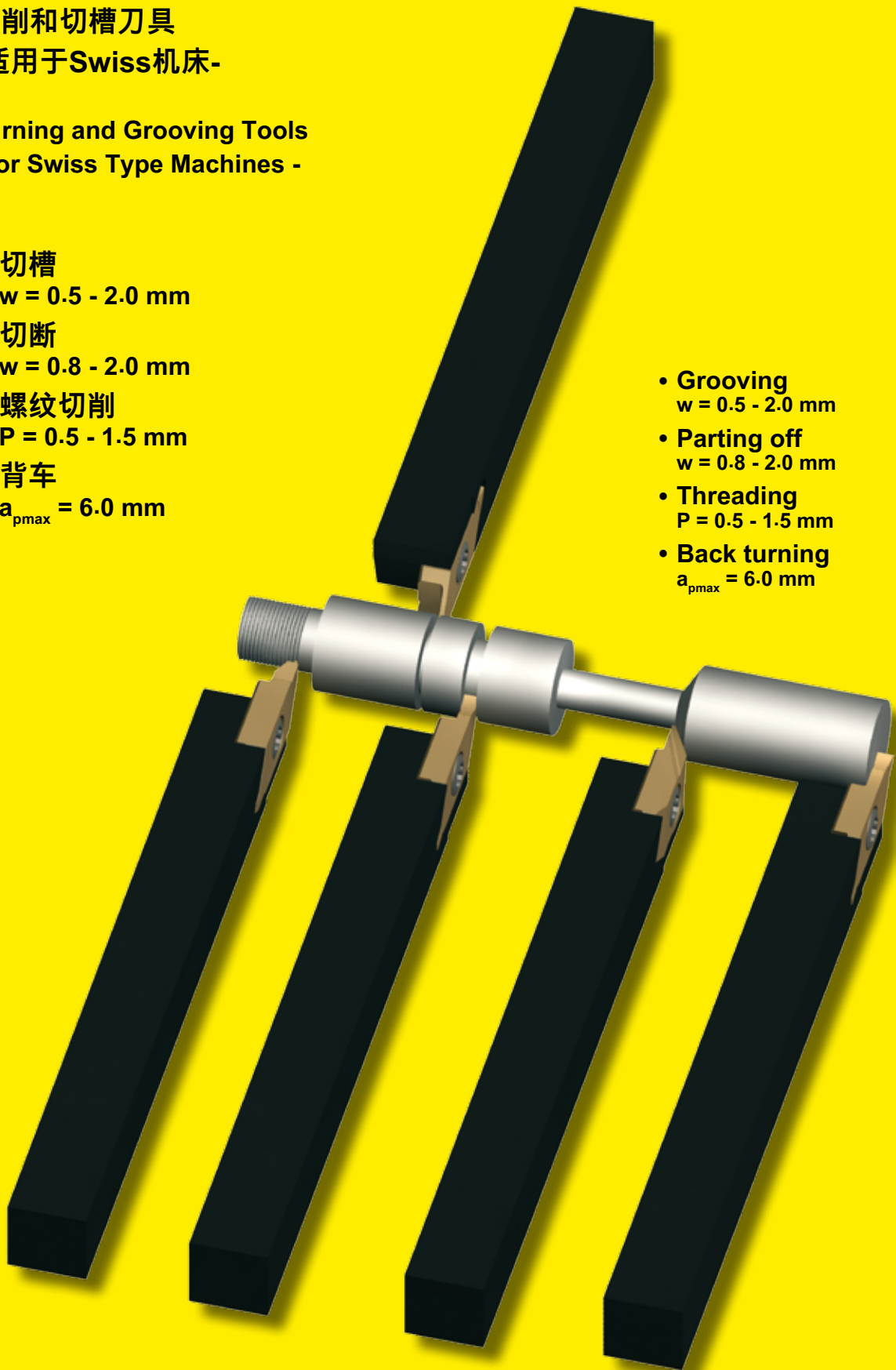
技术说明见章节Q  
For Technical Instructions please see chapter Q

车削和切槽刀具  
-适用于Swiss机床-

Turning and Grooving Tools  
- for Swiss Type Machines -

- 切槽  
w = 0.5 - 2.0 mm
- 切断  
w = 0.8 - 2.0 mm
- 螺纹切削  
P = 0.5 - 1.5 mm
- 背车  
a<sub>pmax</sub> = 6.0 mm

- Grooving  
w = 0.5 - 2.0 mm
- Parting off  
w = 0.8 - 2.0 mm
- Threading  
P = 0.5 - 1.5 mm
- Back turning  
a<sub>pmax</sub> = 6.0 mm



瑞士机床刀具，详见样本“硬质合金车槽刀具”-章节B

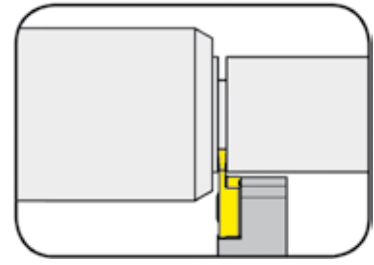
For further tools for Swiss type machines please see our catalogue  
"CARBIDE GROOVING TOOLS" - Chapter B.

# 切槽和车削 GROOVING and TURNING

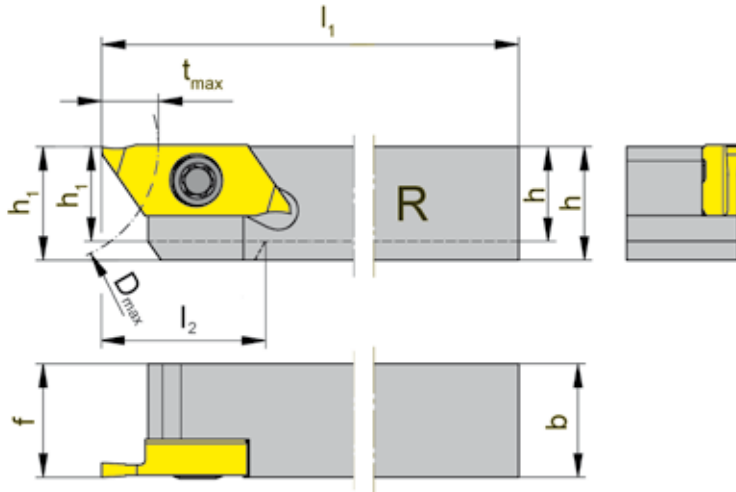


刀杆 型号  
TOOLHOLDER Type

## H274



槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.0808.04	8	8	100	16	8	8			
R/LH274.1010.04	10	10	100	-	10	10			
R/LH274.1212.04	12	12	100	-	12	12			
R/LH274.1414.04	14	14	100	-	14	14	6	25	04
R/LH274.1616.04	16	16	125	-	16	16			
R/LH274.2020.04	20	20	125	-	20	20			

注明R或L型  
State R or L version

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

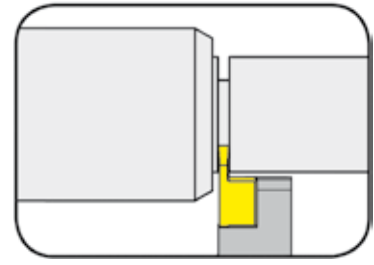
# 切槽和车削

## GROOVING and TURNING



刀杆 型号  
TOOLHOLDER Type

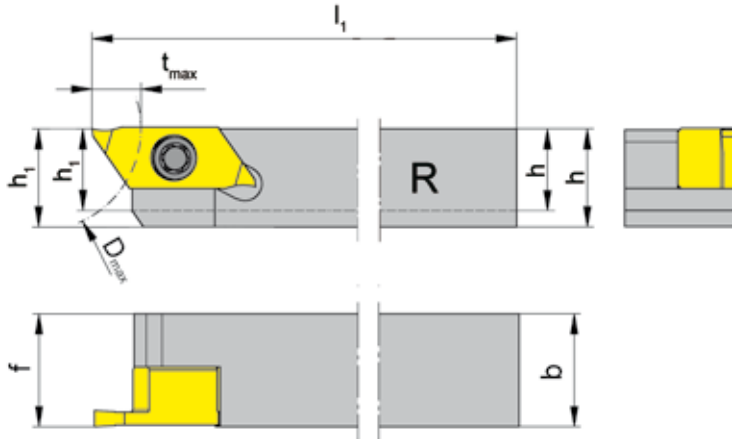
# H274



槽深	Depth of groove	6.0 mm
槽宽可达	Width of groove up to	7.0 mm

配合可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

适用于特殊宽度  
for special widths

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.1214.07	12	14	100	12	14	6	25	07
R/LH274.1616.07	16	16	125	16	16	6	25	07

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274.1...	030.3513.T15P	T15PQ

# 切槽和侧车削

## GROOVING and SIDE TURNING

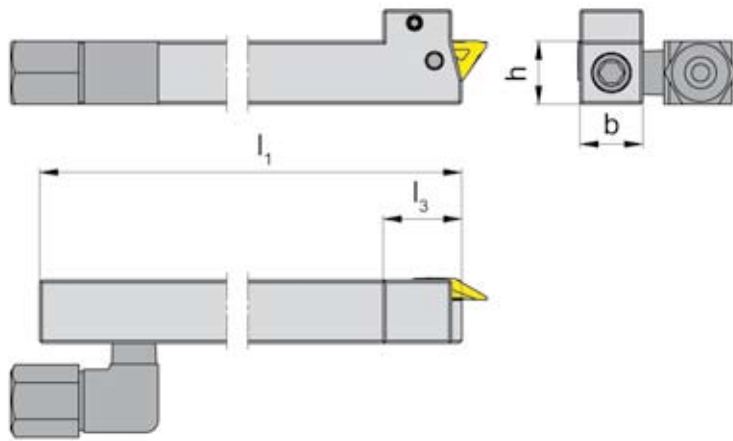


**GRAF刀杆 型号**  
TOOLHOLDER GRAF Type

**974**  
带内冷  
with through coolant supply

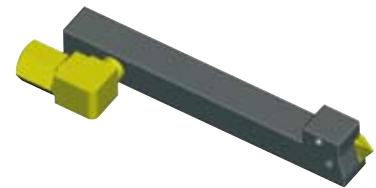


槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	规格 Size
974.R/L1010.04IK	10	10	100	15	04
974.R/L1212.04IK	12	12			
974.R/L1616.04IK	16	16			
974.R/L2020.04IK	20	20			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

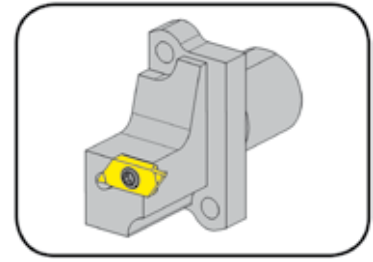
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

**附件**  
Spare parts

GRAF刀杆 Toolholder GRAF	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
974.R/L...	030.3509.T15P	T15PQ	004.00.22

刀杆型号  
TOOLHOLDER Type

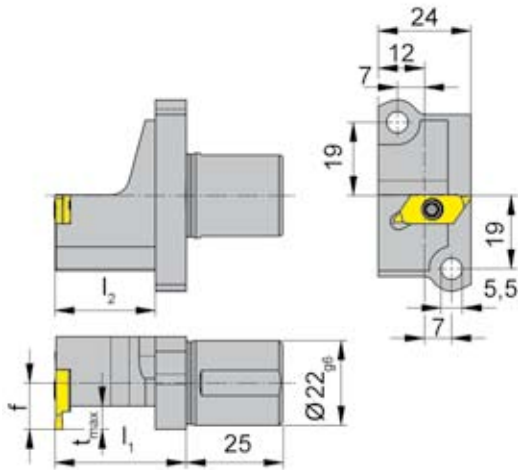
# H274



槽深可达	Depth of groove up to	6.0 mm
槽宽可达	Width of groove up to	7.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

Star SV12/20/32  
SR10/20/32和SB16  
Star SV 12/20/32  
SR 10/20/32 and SB 16

产品型号 Part number	$l_1$	$l_2$	f	$t_{max}$	规格 Size
R/LH274.A022.09.04			9		
R/LH274.A022.12.04	34	26	12	6	04
R/LH274.A022.16.04			16		
R/LH274.A022.09.07	34	26	9	6	07
R/LH274.A022.12.07			12		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274.A022....04	030.3509.T15P	T15PQ
R/LH274.A022....07	030.3513.T15P	T15PQ



# 切槽和侧车削

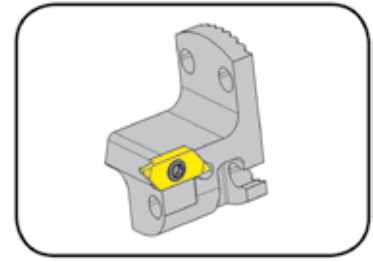
## GROOVING and SIDE TURNING



### 刀夹 型号

CARTRIDGE Type

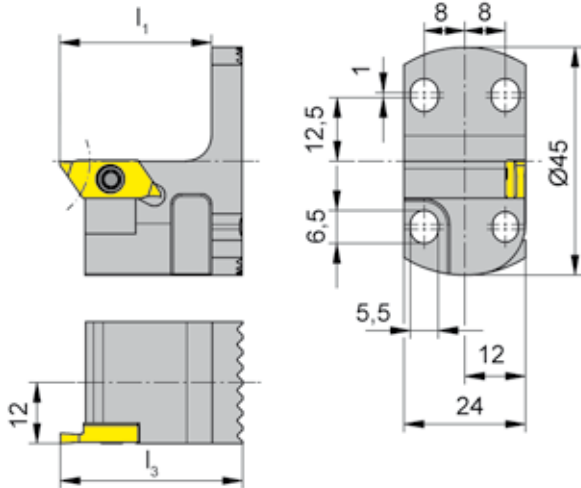
# KT274



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$l_1$	$l_3$	规格 Size
<b>R/LKT274.2445.04</b>	30	36	04

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀夹 Cartridge	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LKT274.2445.04	<b>030.3509.T15P</b>	<b>T15PQ</b>

# 切槽和侧车削

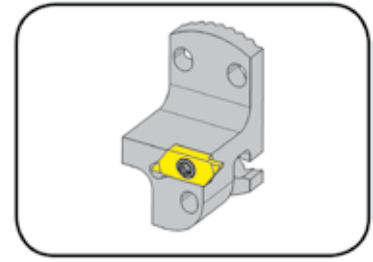
## GROOVING and SIDE TURNING



### 刀夹 型号

CARTRIDGE Type

# KTC274



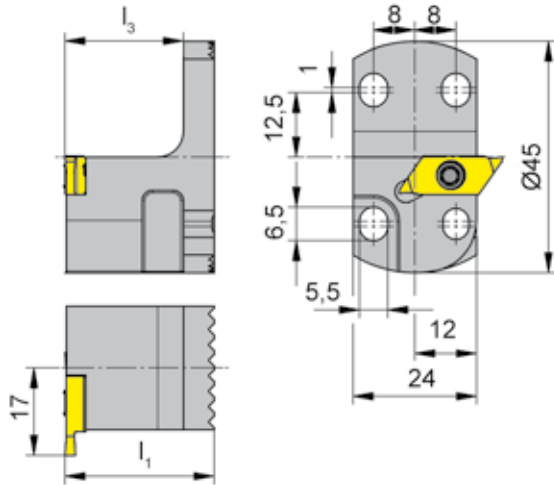
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

产品型号 Part number	$l_1$	$l_3$	规格 Size
<b>RKTC274.2445.04</b>	29	23	04

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀夹 Cartridge	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RKTC274.2445.04	<b>030.3509.T15P</b>	<b>T15PQ</b>

### GRAF刀夹 型号

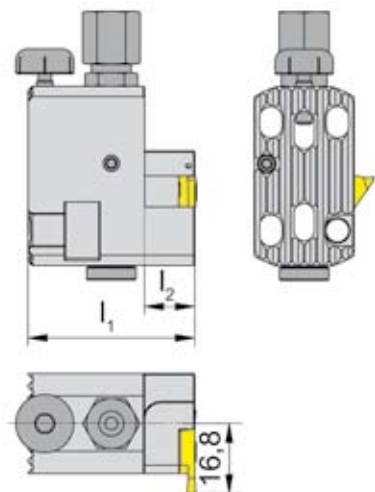
CARTRIDGE GRAF Type

## R76

带内冷  
with through coolant supply



槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm



R=右手型-如图  
R = right hand version shown

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



产品型号 Part number	$l_1$	$l_2$	规格 Size
<b>R76IK</b>	40	12	04

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

Graf刀夹 Cartridge Graf	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply
R76IK	030.3509.T15P	T15PQ	002.00.69	004.00.19

# 切槽和侧车削

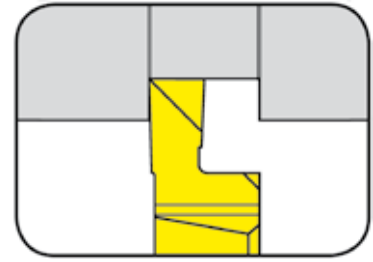
## GROOVING and SIDE TURNING



### 可转位刀片 型号

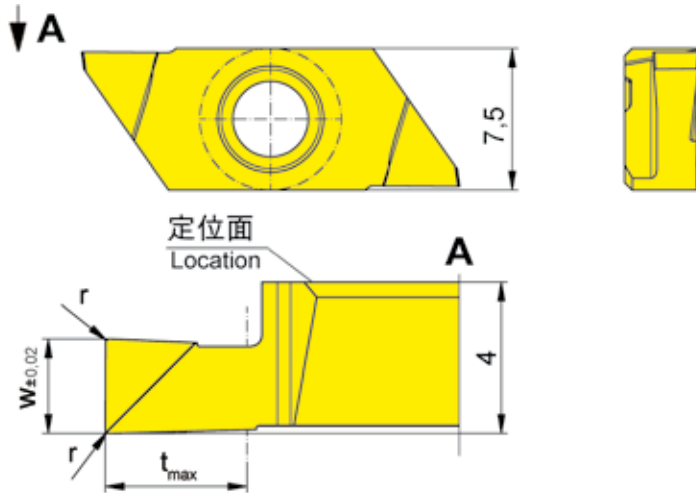
# S274

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	4.5 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0150.P0	1.5	0.05	2.25	04						▲/△
R/LS274.0200.P0	2.0	0.05	3.00							▲/△
R/LS274.0250.P0	2.5	0.10	3.75							▲/△
R/LS274.0300.P0	3.0	0.10	4.50							▲/△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P					●
M					●
K					●
N					●
S					●
H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

注明R或L型  
State R or L version

# 切槽和侧车削

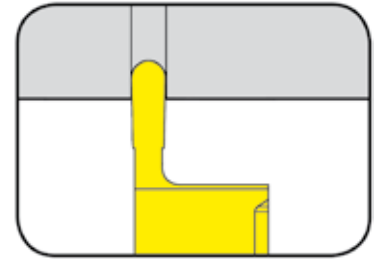
## GROOVING and SIDE TURNING



### 可转位刀片 型号

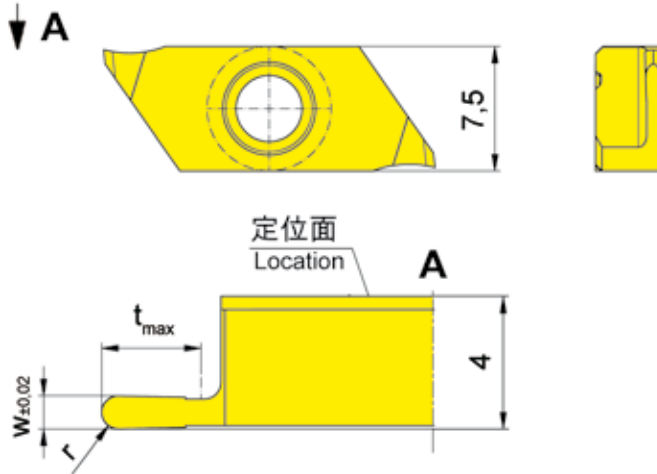
INDEXABLE INSERT Type

# S274



槽深可达 圆头	Depth of groove up to Full radius	4.00 mm 0.25 - 1.00 mm
------------	--------------------------------------	---------------------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0205.01.10	0.5	0.25	1.5	04						▲/△
R/LS274.0510.03.10	1.0	0.50	3.0							▲/▲
R/LS274.1020.04.10	2.0	1.00	4.0							▲/△
▲ 库存 / on stock    △ 4周 / 4 weeks						P				•
● 主要应用 / main recommendation						M				•
○ 可选推荐 / alternative recommendation						K				•
■ 无涂层牌号 / uncoated grades						N				•
■ 涂层牌号 / coated grades						S				•
■ 钎焊/金属陶瓷 / brazed/Cermet						H				

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

# 切槽和切断

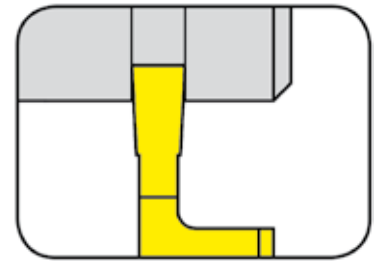
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274



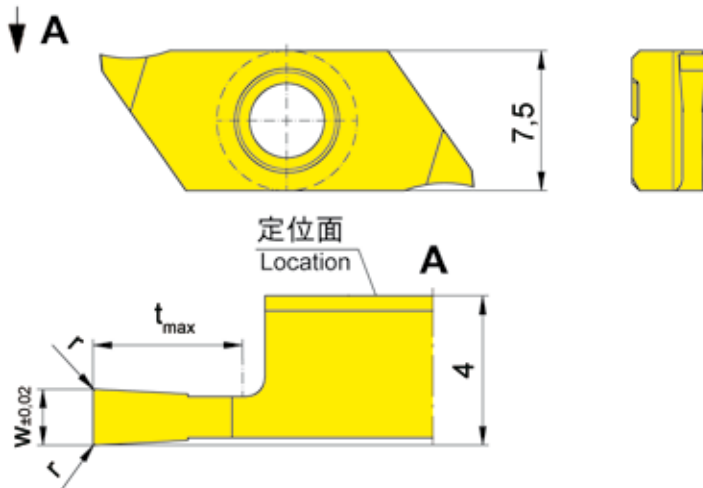
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 2.0 mm

精密磨削

precision ground



配合 刀杆

for use with Toolholder

型号

Type

H274

974

KT274

KTC274

R76

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0050.01.10	0.5		1.5							▲/▲
R/LS274.0070.02.10	0.7		2.0							▲/Δ
R/LS274.0080.03.10	0.8		3.0							▲/▲
R/LS274.0100.03.10	1.0		3.0							▲/▲
R/LS274.0120.03.10	1.2	0.05	3.0	04						▲/Δ
R/LS274.0150.04.10	1.5		4.0							▲/▲
R/LS274.0150.06.10	1.5		6.0							▲/▲
R/LS274.0200.04.10	2.0		4.0							▲/▲
R/LS274.0200.06.10	2.0		6.0							▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

无涂层牌号 / uncoated grades

涂层牌号 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

# 切槽和切断

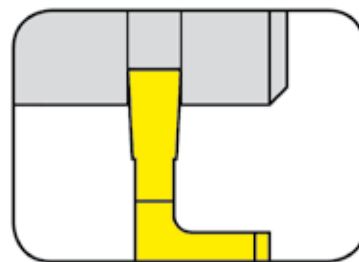
## GROOVING and PARTING OFF



### 可转位刀片 型号

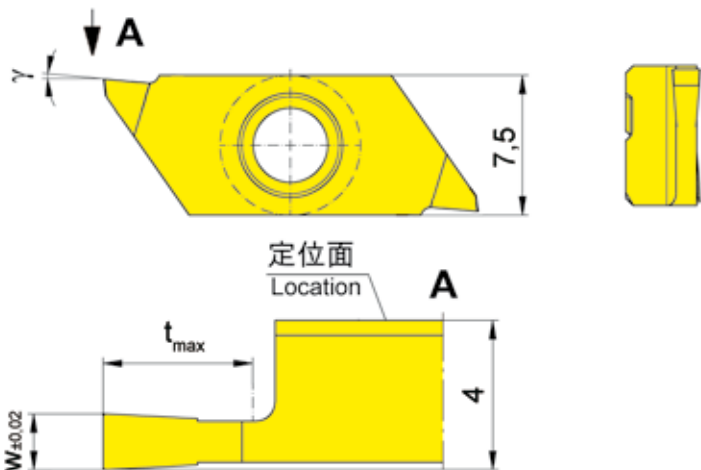
INDEXABLE INSERT Type

# S274



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.5 - 2.0 mm

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	W	t <sub>max</sub>	Y	规格 Size		K10	P20	TN32	TF45	TH35
R/LS274.0050.01.20	0.5	1.5								▲▲
R/LS274.0070.02.20	0.7	2.0								▲▲
R/LS274.0080.03.20	0.8	3.0								▲▲
R/LS274.0100.03.20	1.0	3.0								▲▲
R/LS274.0120.03.20	1.2	3.0	5°	04						▲▲
R/LS274.0150.04.20	1.5	4.0								▲▲
R/LS274.0150.06.20	1.5	6.0								▲▲
R/LS274.0200.04.20	2.0	4.0								▲▲
R/LS274.0200.06.20	2.0	6.0								▲▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

无涂层牌号 / uncoated grades

涂层牌号 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

P				●
M				●
K				●
N				●
S				●
H				

硬质合金牌号  
Carbide grades

# 切槽和切断

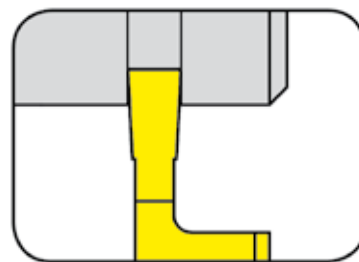
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274



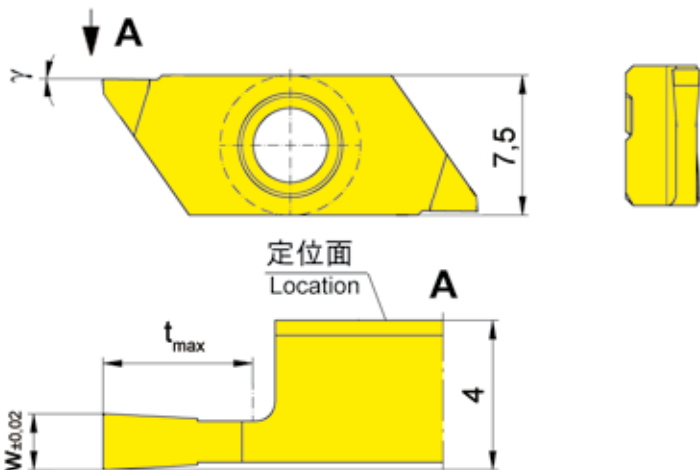
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 2.0 mm

精密磨削

precision ground



配合 刀杆

for use with Toolholder

型号

H274  
Type 974  
KT274  
KTC274  
R76

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	W	t <sub>max</sub>	γ	规格 Size		K10	P20	TN32	TF45	TH35
R/LS274.0050.01.M0	0.5	1.5								▲▲
R/LS274.0070.02.M0	0.7	2.0								▲▲
R/LS274.0080.03.M0	0.8	3.0								▲▲
R/LS274.0100.03.M0	1.0	3.0								▲▲
R/LS274.0120.03.M0	1.2	3.0	0°	04						▲▲
R/LS274.0150.04.M0	1.5	4.0								▲▲
R/LS274.0150.06.M0	1.5	6.0								▲▲
R/LS274.0200.04.M0	2.0	4.0								▲▲
R/LS274.0200.06.M0	2.0	6.0								▲▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

无涂层牌号 / uncoated grades

涂层牌号 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P					•
M					•
K					•
N					•
S					•
H					

硬质合金牌号

Carbide grades



# 背车削 ( 外圆 )

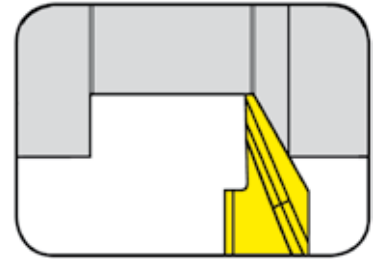
## BACKTURNING (external)



### 可转位刀片 型号

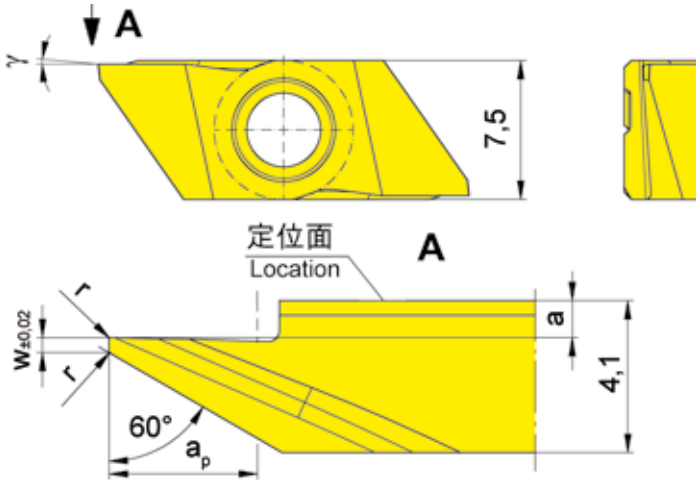
INDEXABLE INSERT Type

# S274



切深可达      Depth of cut up to      6.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	a <sub>p</sub>	γ	a	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0060.04.10	-	0.05	4	15°	1.00	04						▲/▲
R/LS274.0460.04.10 R/LS274.0460.04.M0	0.4	0.05	4	15° 0°	1.00	04		▲/▲				▲/▲
R/LS274.0560.06.11	0.5	0.10	6	15°	0.05	04						▲/▲

▲ 库存 / on stock    Δ 4周 / 4 weeks	P	•				•
• 主要应用 / main recommendation	M	○				•
○ 可选推荐 / alternative recommendation	K	•				•
■ 无涂层牌号 / uncoated grades	N	•				•
■ 涂层牌号 / coated grades	S	○				•
■ 钎焊/金属陶瓷 / brazed/Cermet	H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

γ=前角  
γ = rake angle

硬质合金牌号  
Carbide grades

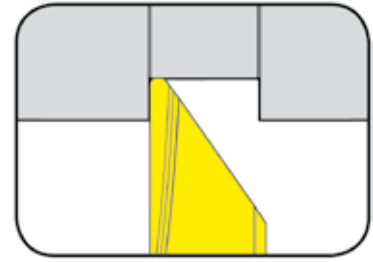
# 侧车削 SIDE TURNING



## 可转位刀片 型号

# S274

INDEXABLE INSERT Type



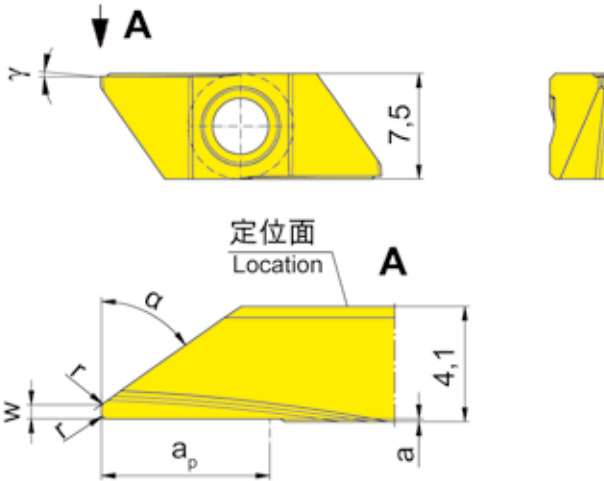
切深可达

Depth of cut up to

6.0 mm

精密磨削

precision ground



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 刀杆

for use with Toolholder

型号

H274

Type

974

KT274

KTC274

R76

刀片长度重复定位精度

$\pm 0.015$  mm

Indexability length  $\pm 0,015$  mm

产品型号 Part number	w	r	$a_p$	$\alpha$	$\gamma$	a	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0035.04.20	-	0.05	4										▲▲
R/LS274.0235.04.20	0.2	-	4	35°	5°	0.1	04						▲▲
R/LS274.0535.06.20	0.5	0.20	6										▲▲
R/LS274.0055.04.20	-	0.05	4										▲▲
R/LS274.0255.04.20	0.2	-	4	55°	5°	0.1	04						▲▲
R/LS274.0555.06.20	0.5	0.20	6										▲▲

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P				●
M				●
K				●
N				●
S				●
H				

硬质合金牌号

Carbide grades

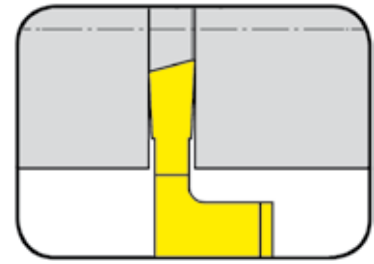
# 切断 PARTING OFF



## 可转位刀片 型号

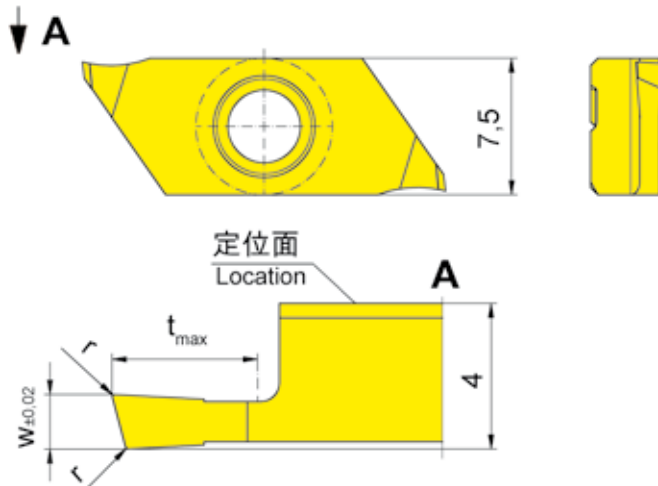
INDEXABLE INSERT Type

# S274



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground

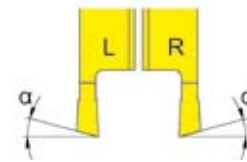


R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	α	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.10	0.8			3				▲/△
R/LS274.1510.03.10	1.0			3				▲/▲
R/LS274.1515.04.10	1.5	0.05	15°	4	04			▲/▲
R/LS274.1520.06.10	2.0			6				▲/▲

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:  
 $t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

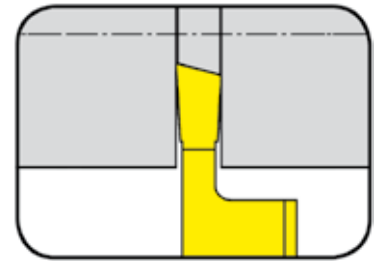
# 切断 PARTING OFF



## 可转位刀片 型号

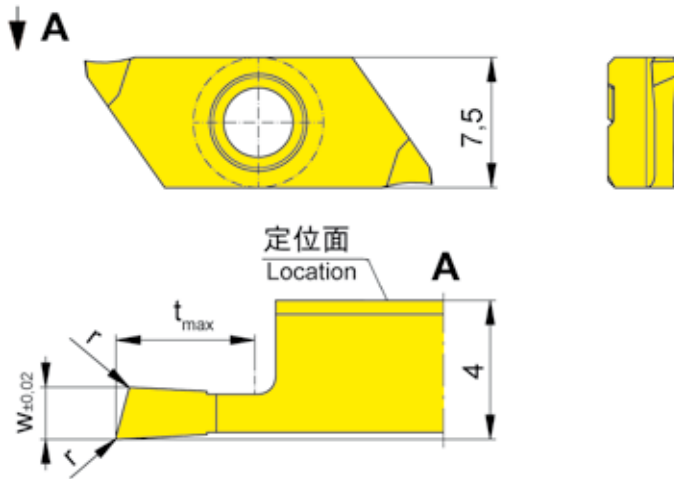
# S274

INDEXABLE INSERT Type



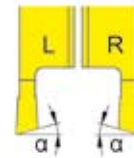
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1508.03.10R	0.8			3				Δ
LS274.1510.03.10R	1.0			3				Δ
LS274.1515.04.10R	1.5	0.05	15°	4	04			▲
LS274.1520.06.10R	2.0			6				▲
RS274.1508.03.10L	0.8			3				Δ
RS274.1510.03.10L	1.0			3				Δ
RS274.1515.04.10L	1.5	0.05	15°	4	04			Δ
RS274.1520.06.10L	2.0			6				Δ

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}}$  6mm。

Note:  
 $t_{\text{max}}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号  
Carbide grades

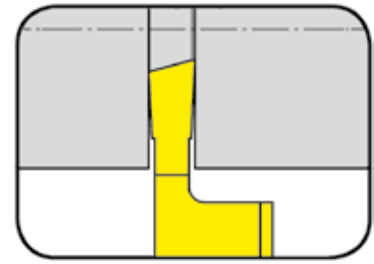
# 切断 PARTING OFF



## 可转位刀片 型号

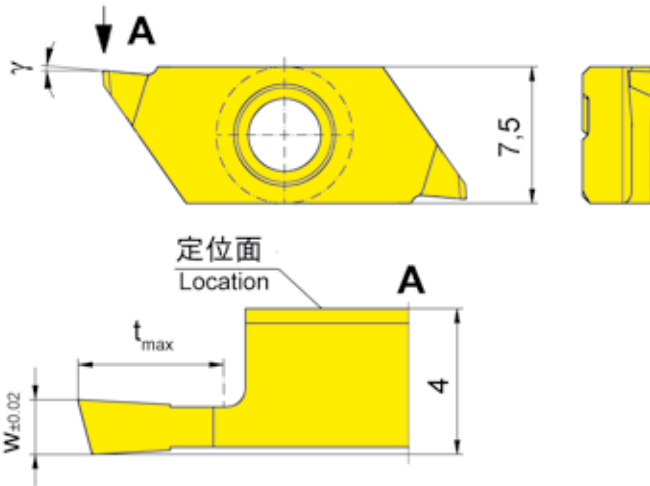
# S274

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削  
precision ground

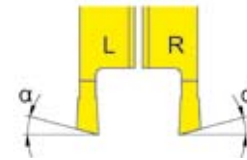


R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1515.04.20	1.5	15°	5°	4	04			▲/▲
R/LS274.1520.06.20	2.0			6		▲/▲		
▲ 库存 / on stock    Δ 4周 / 4 weeks						P		•
● 主要应用 / main recommendation						M		•
○ 可选推荐 / alternative recommendation						K		•
■ 无涂层牌号 / uncoated grades						N		•
■ 涂层牌号 / coated grades						S		•
■ 钎焊/金属陶瓷 / brazed/Cermet						H		

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件Ø≤25mm时才能达到最大切深t<sub>max</sub> 6mm。

Note:  
t<sub>max</sub> 6 mm can be reached only with workpiece Ø ≤ 25 mm.

硬质合金牌号  
Carbide grades

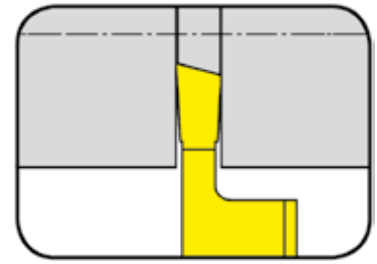
# 切断 PARTING OFF



## 可转位刀片 型号

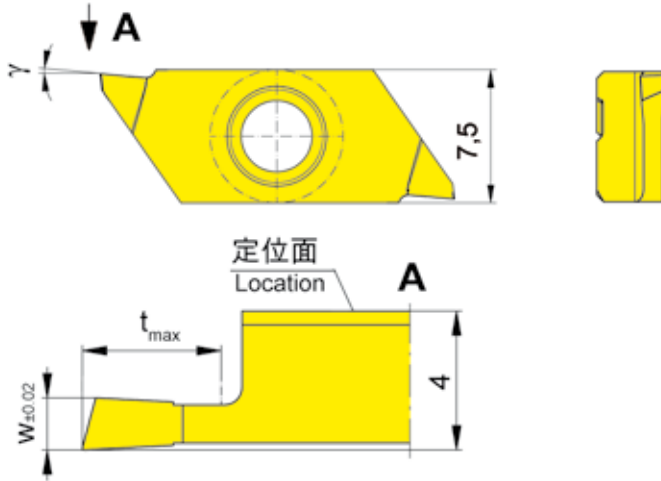
# S274

INDEXABLE INSERT Type



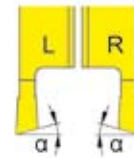
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1515.04.20R	1.5	15°	5°	4	04			▲
LS274.1520.06.20R	2.0	15°	5°	6	04			▲
RS274.1515.04.20L	1.5	15°	5°	4	04			▲
RS274.1520.06.20L	2.0	15°	5°	6	04			▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P		●
M		●
K		●
N		●
S		●
H		

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:  
 $t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

硬质合金牌号  
Carbide grades

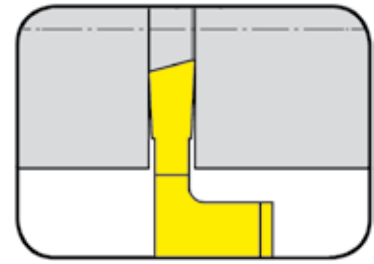
# 切断 PARTING OFF



## 可转位刀片 型号

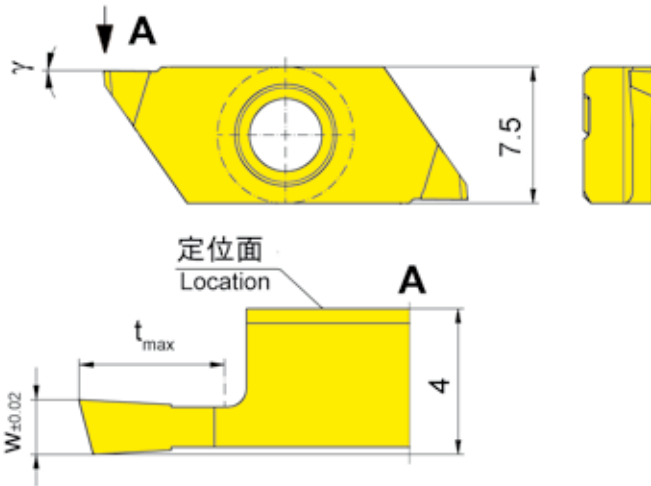
INDEXABLE INSERT Type

# S274



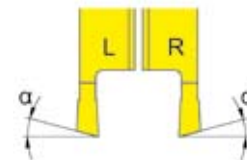
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.M0	0.8	15°	0°	3	04			▲▲
R/LS274.1510.03.M0	1.0			3		▲▲		
R/LS274.1515.04.M0	1.5			4		▲▲		
R/LS274.1520.06.M0	2.0			6		▲▲		
						P		•
						M		•
						K		•
						N		•
						S		•
						H		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm  
注明R或L型  
State R or L version

注意事项 :  
只有当零件Ø≤25mm时才能达到最大切深t<sub>max</sub>6mm。  
Note:  
t<sub>max</sub> 6 mm can be reached only with workpiece Ø ≤ 25 mm.

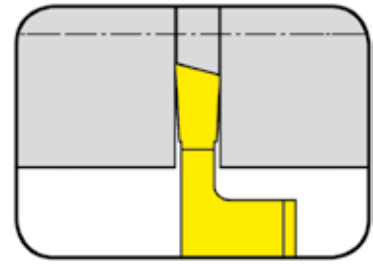
# 切断 PARTING OFF



## 可转位刀片 型号

# S274

INDEXABLE INSERT Type

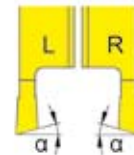
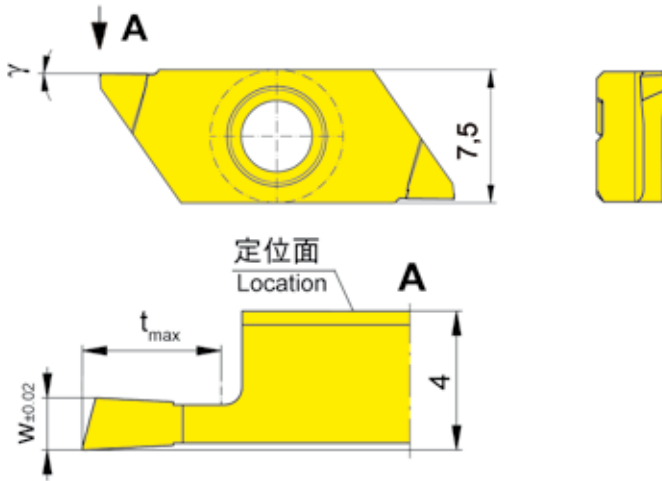


槽深可达      Depth of groove up to      6.0 mm  
槽宽              Width of groove                      0.8 - 2.0 mm

精密磨削  
precision ground

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1508.03.M0R	0.8	15°	0°	3	04			▲
LS274.1510.03.M0R	1.0			3				▲
LS274.1515.04.M0R	1.5			4				▲
LS274.1520.06.M0R	2.0			6				▲
RS274.1508.03.M0L	0.8	15°	0°	3	04			▲
RS274.1510.03.M0L	1.0			3				▲
RS274.1515.04.M0L	1.5			4				▲
RS274.1520.06.M0L	2.0			6				▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H		

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} = 6\text{mm}$ 。

Note:  
 $t_{\text{max}} = 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .



# 螺纹切削 ( 外圆 ) -非全牙型

## THREADING (external) Partial profile

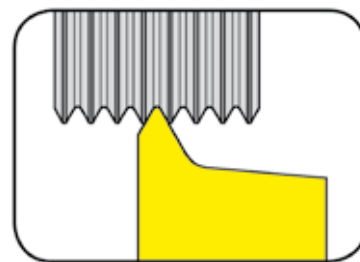


### 可转位刀片 型号

INDEXABLE INSERT Type

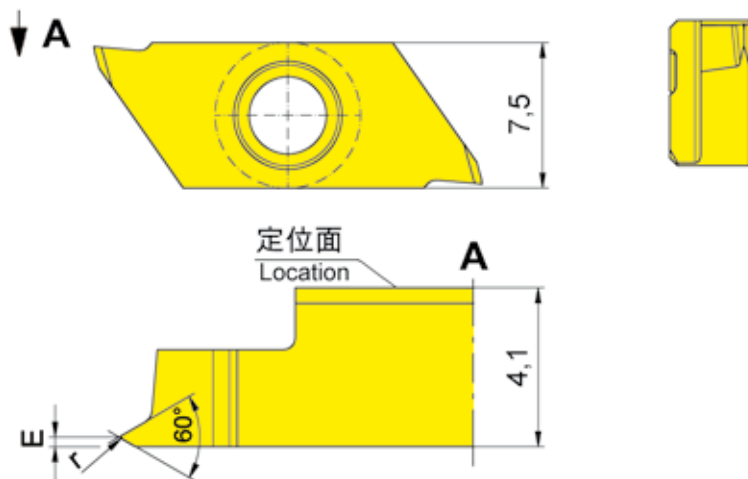
## S274

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.25 - 0.40 mm
----	-------	----------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	P	r	E	规格 Size		K10	MG12	TN35	TI25	TH35
RS274.0102.01	0.25	0.04	0.20	04						▲
RS274.0203.01	0.35	0.05	0.25							▲
RS274.0204.01	0.40	0.06	0.30							▲
					P					●
					M					●
					K					●
					N					●
					S					●
					H					

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

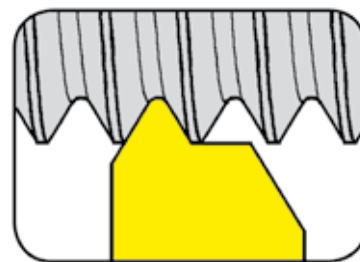


### 可转位刀片 型号

INDEXABLE INSERT Type

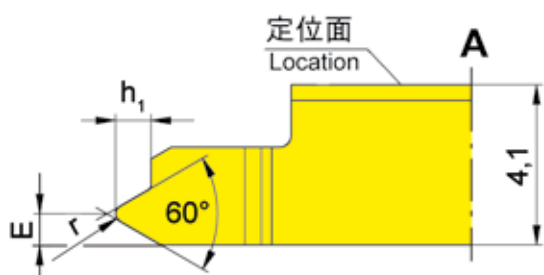
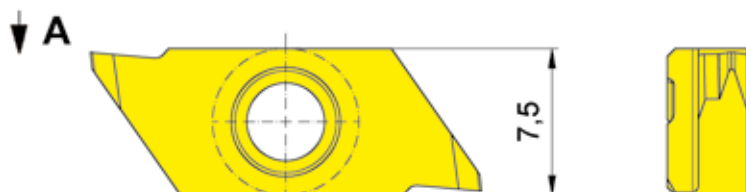
## S274

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 1.5 mm
----	-------	--------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	P	r	E	$h_1$	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0305.02	0.50	0.07	0.40	0.31	04						▲/△
R/LS274.0306.02	0.60	0.09	0.45	0.37							▲/△
R/LS274.0307.02	0.70	0.10	0.50	0.43							▲/△
R/LS274.0407.02	0.75	0.11	0.50	0.46							▲/▲
R/LS274.0408.02	0.80	0.12	0.55	0.49							▲/△
R/LS274.0610.02	1.00	0.12	0.60	0.61							▲/▲
R/LS274.0712.02	1.25	0.15	0.70	0.77							▲/▲
R/LS274.0915.02	1.50	0.20	0.80	0.92							▲/△
						P					•
						M					•
						K					•
						N					•
						S					•
						H					

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

硬质合金牌号  
Carbide grades

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

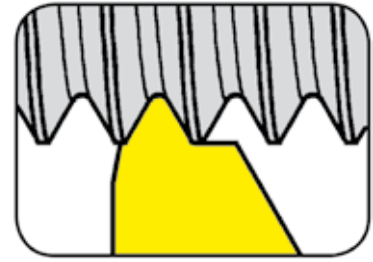


### 可转位刀片 型号

INDEXABLE INSERT Type

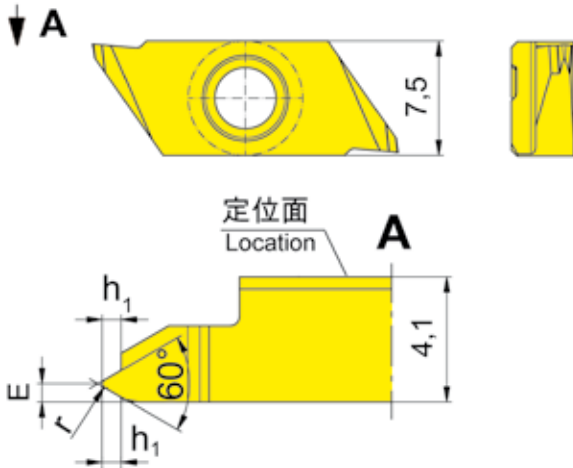
## S274

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 1.5 mm
----	-------	--------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274  
Type 974  
KT274  
KTC274  
R76

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	P	r	E	$h_1$	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0305.03	0.50	0.07	0.40	0.31	04						▲▲
R/LS274.0306.03	0.60	0.09	0.45	0.37							▲▲
R/LS274.0307.03	0.70	0.10	0.50	0.43							▲▲
R/LS274.0407.03	0.75	0.11	0.50	0.46							▲▲
R/LS274.0408.03	0.80	0.12	0.55	0.49							▲▲
R/LS274.0610.03	1.00	0.12	0.60	0.61							▲▲
R/LS274.0712.03	1.25	0.15	0.70	0.77							▲▲
R/LS274.0915.03	1.50	0.20	0.80	0.92							▲▲
						P					●
						M					●
						K					●
						N					●
						S					●
						H					

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

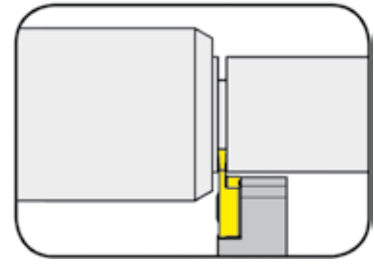
硬质合金牌号  
Carbide grades

# 切槽和车削 GROOVING and TURNING



刀杆 型号  
TOOLHOLDER Type

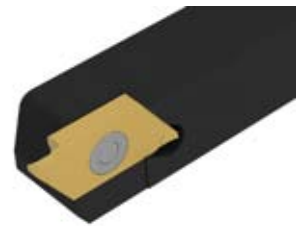
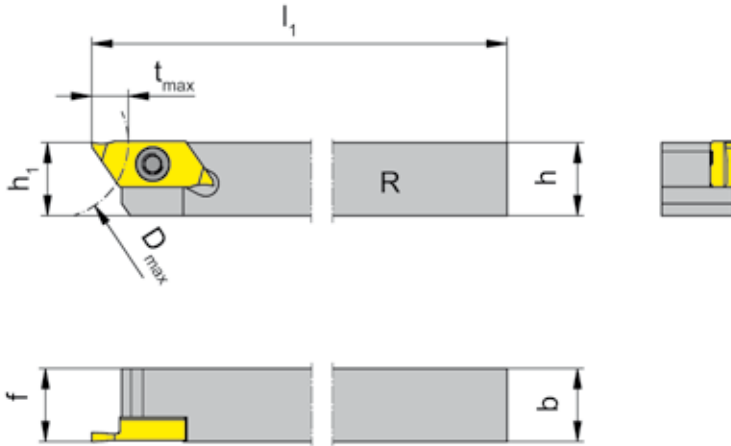
## H274...E



槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.1010.04.E	10	10	100	10	10	6	25	04
R/LH274.1212.04.E	12	12	100	12	12			
R/LH274.1616.04.E	16	16	125	16	16			
R/LH274.2020.04.E	20	20	125	20	20			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

# 切槽和侧车削

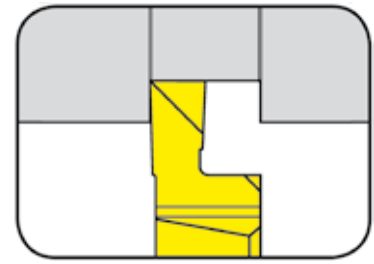
## GROOVING and SIDE TURNING



### 可转位刀片 型号

INDEXABLE INSERT Type

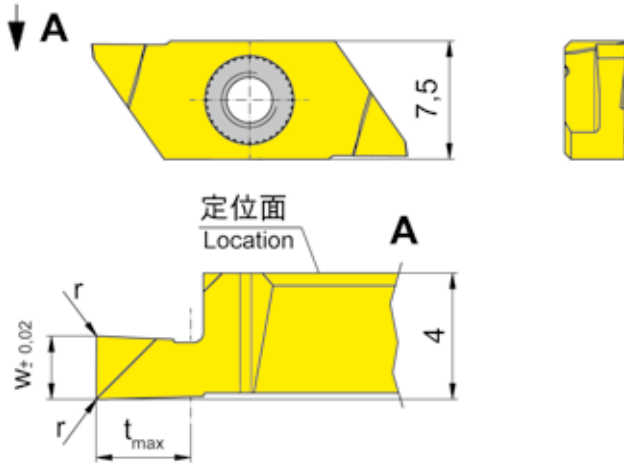
# S274...E



槽深可达	Depth of groove up to	4.5 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密磨削

precision ground



配合 刀杆

for use with Toolholder

型号 H274...E

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0150.P0.E	1.5	0.05	2.25	04						Δ/Δ
R/LS274.0200.P0.E	2.0	0.05	3.00							Δ/Δ
R/LS274.0250.P0.E	2.5	0.10	3.75							Δ/Δ
R/LS274.0300.P0.E	3.0	0.10	4.50							Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P					•
M					•
K					•
N					•
S					•
H					

硬质合金牌号

Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

# 切槽和侧车削

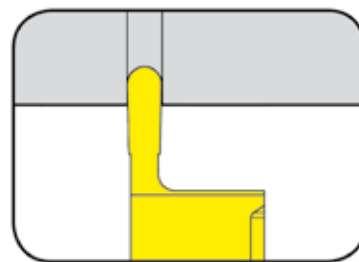
## GROOVING and SIDE TURNING



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274...E



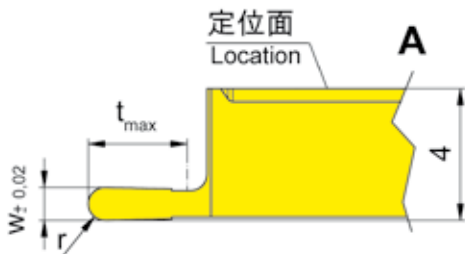
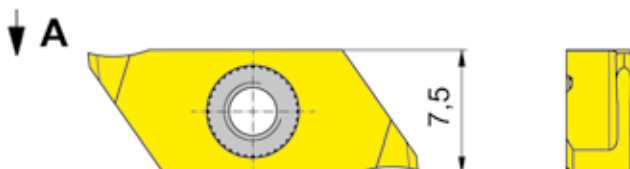
槽深可达  
圆头

Depth of groove up to  
Full radius

4.00 mm  
0.25 - 1.00 mm

精密磨削

precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0205.01.10.E	0.5	0.25	1.5	04						Δ/Δ
R/LS274.0510.03.10.E	1.0	0.50	3.0							Δ/Δ
R/LS274.1020.04.10.E	2.0	1.00	4.0							Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P					•
M					•
K					•
N					•
S					•
H					

硬质合金牌号

Carbide grades

# 切槽和切断

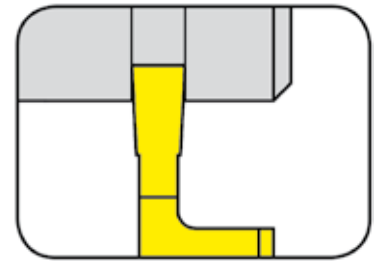
## GROOVING and PARTING OFF



### 可转位刀片 型号

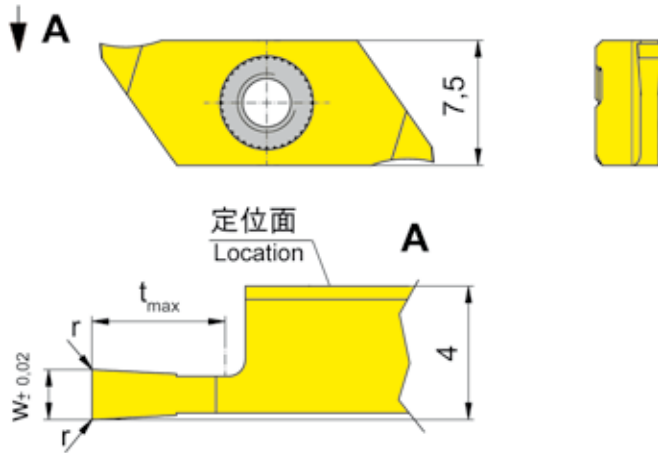
INDEXABLE INSERT Type

# S274...E



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.5 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	t <sub>max</sub>	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0050.01.10.E	0.5		1.5							ΔΔ
R/LS274.0070.02.10.E	0.7		2.0							ΔΔ
R/LS274.0080.03.10.E	0.8		3.0							ΔΔ
R/LS274.0100.03.10.E	1.0		3.0							ΔΔ
R/LS274.0120.03.10.E	1.2	0.05	3.0	04						ΔΔ
R/LS274.0150.04.10.E	1.5		4.0							ΔΔ
R/LS274.0150.06.10.E	1.5		6.0							ΔΔ
R/LS274.0200.04.10.E	2.0		4.0							ΔΔ
R/LS274.0200.06.10.E	2.0		6.0							ΔΔ

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

P					•
M					•
K					•
N					•
S					•
H					

硬质合金牌号  
Carbide grades

# 切槽和切断

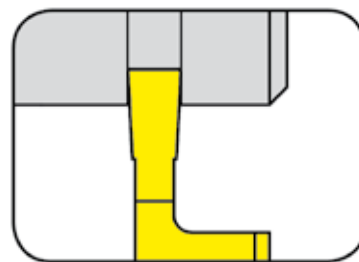
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274...E



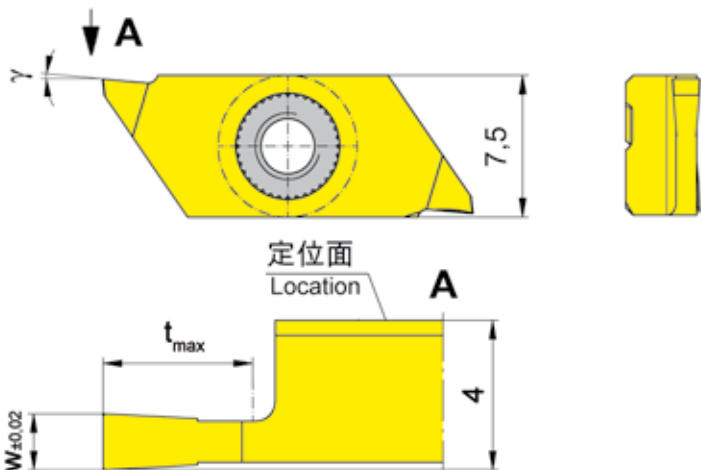
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 2.0 mm

精密磨削

precision ground



配合 刀杆

for use with Toolholder

型号 H274...E  
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	t <sub>max</sub>	γ	规格 Size		K10	MG12	TN35	TI25	TH35	
R/LS274.0050.01.20.E	0.5	1.5	5°	04						ΔΔ	
R/LS274.0070.02.20.E	0.7	2.0									ΔΔ
R/LS274.0080.03.20.E	0.8	3.0									ΔΔ
R/LS274.0100.03.20.E	1.0	3.0									ΔΔ
R/LS274.0120.03.20.E	1.2	3.0									ΔΔ
R/LS274.0150.04.20.E	1.5	4.0									ΔΔ
R/LS274.0150.06.20.E	1.5	6.0									ΔΔ
R/LS274.0200.04.20.E	2.0	4.0									ΔΔ
R/LS274.0200.06.20.E	2.0	6.0									ΔΔ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

□ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P					•
M					•
K					•
N					•
S					•
H					

硬质合金牌号

Carbide grades



# 切槽和切断

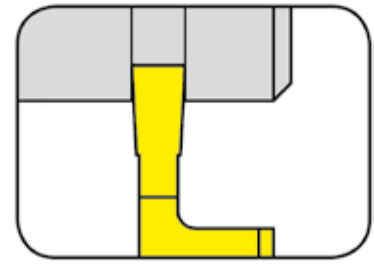
## GROOVING and PARTING OFF



### 可转位刀片 型号

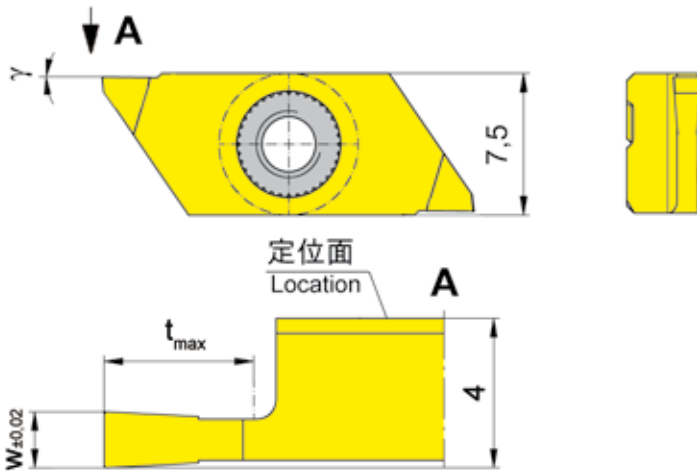
INDEXABLE INSERT Type

# S274...E



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.5 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	t <sub>max</sub>	Y	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0050.01.M0.E	0.5	1.5								ΔΔ
R/LS274.0070.02.M0.E	0.7	2.0								ΔΔ
R/LS274.0080.03.M0.E	0.8	3.0								ΔΔ
R/LS274.0100.03.M0.E	1.0	3.0								ΔΔ
R/LS274.0120.03.M0.E	1.2	3.0	0°	04						ΔΔ
R/LS274.0150.04.M0.E	1.5	4.0								ΔΔ
R/LS274.0150.06.M0.E	1.5	6.0								ΔΔ
R/LS274.0200.04.M0.E	2.0	4.0								ΔΔ
R/LS274.0200.06.M0.E	2.0	6.0								ΔΔ

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P					•
M					•
K					•
N					•
S					•
H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

注明R或L型  
State R or L version

# 背车削 ( 外圆 )

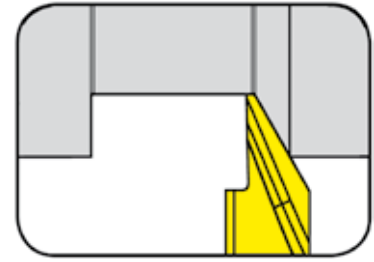
## BACKTURNING (external)



### 可转位刀片 型号

# S274...E

INDEXABLE INSERT Type



切深可达

Depth of cut up to

6.0 mm

精密磨削

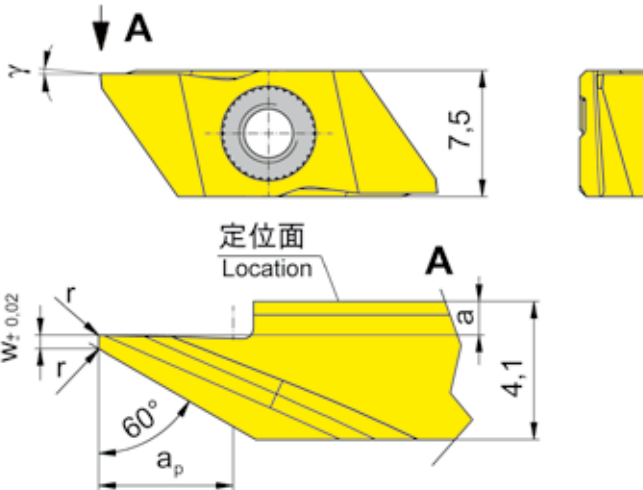
precision ground

配合 刀杆

for use with Toolholder

型号 H274...E

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

$\pm 0.015$  mm

Indexability length  $\pm 0,015$  mm

产品型号 Part number	w	r	a <sub>p</sub>	γ	a	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0060.04.10.E	-	0.05	4	15°	1.00	04						ΔΔ
R/LS274.0460.04.10.E	0.4	0.05	4	15°	1.00	04						ΔΔ
R/LS274.0460.04.M0.E	0.4	0.05	4	0°	1.00	04		ΔΔ				
R/LS274.0560.06.11.E	0.5	0.10	6	15°	0.05	04						ΔΔ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	●				●
M	○				●
K	●				●
N	●				●
S	○				●
H					

硬质合金牌号

Carbide grades

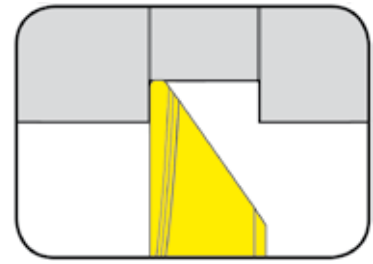
# 侧面车削 SIDE TURNING



## 可转位刀片 型号

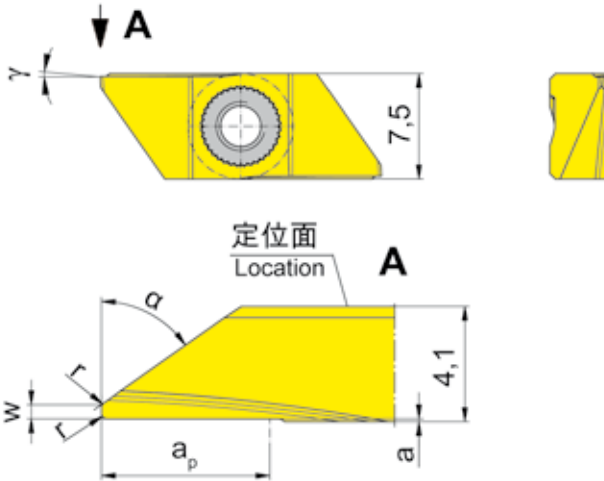
INDEXABLE INSERT Type

# S274...E



切深可达      Depth of cut up to      6.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	r	a <sub>p</sub>	α	γ	a	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0035.04.20.E	-	0.05	4										ΔΔ
R/LS274.0235.04.20.E	0.2	-	4	35°	5°	0.1	04						ΔΔ
R/LS274.0535.06.20.E	0.5	0.20	6										ΔΔ
R/LS274.0055.04.20.E	-	0.05	4										ΔΔ
R/LS274.0255.04.20.E	0.2	-	4	55°	5°	0.1	04						ΔΔ
R/LS274.0555.06.20.E	0.5	0.20	6										ΔΔ

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P													•
M													•
K													•
N													•
S													•
H													

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

注明R或L型  
State R or L version

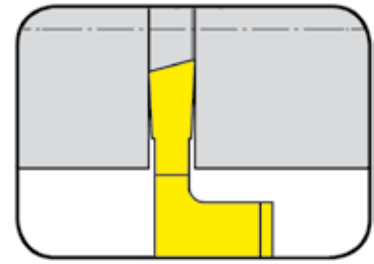
# 切断 PARTING OFF



## 可转位刀片 型号

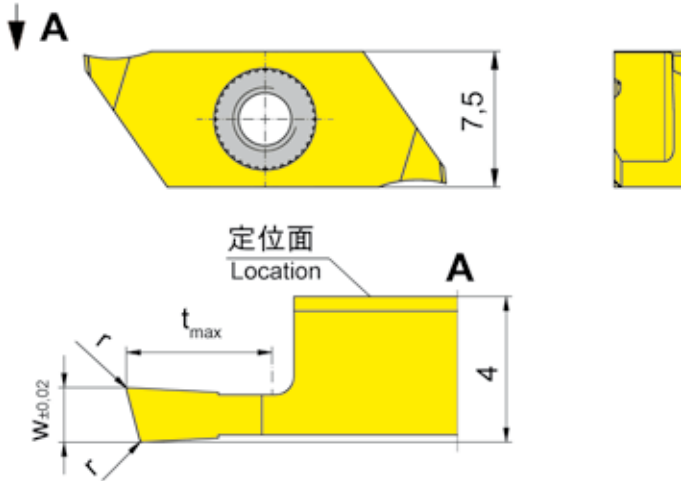
# S274...E

INDEXABLE INSERT Type



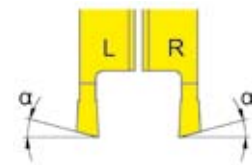
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	w	r	$\alpha$	$t_{max}$	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.10.E	0.8			3	04			△△
R/LS274.1510.03.10.E	1.0	0.05	15°	3				△△
R/LS274.1515.04.10.E	1.5			4				△△
R/LS274.1520.06.10.E	2.0			6				△△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$ 6mm。

Note:  
 $t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

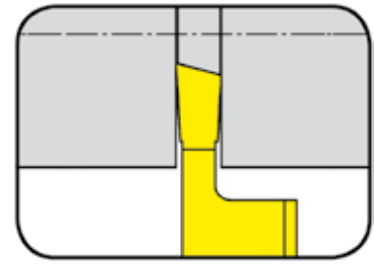
# 切断 PARTING OFF



## 可转位刀片 型号

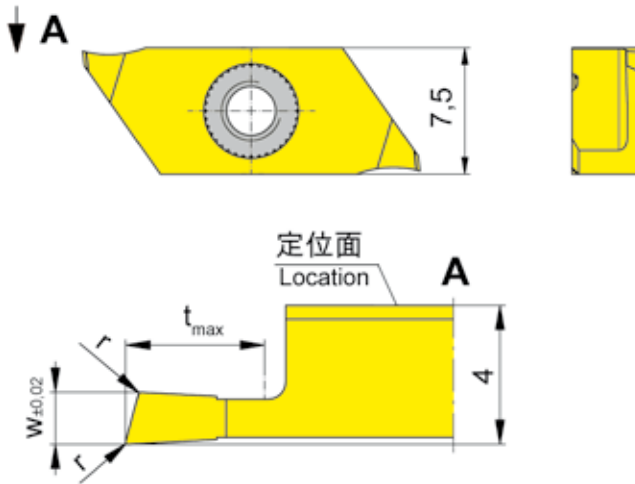
INDEXABLE INSERT Type

# S274...E



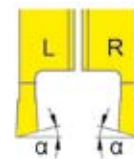
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	W	r	α	t <sub>max</sub>	规格 Size	硬质合金牌号		
						TN35	TI25	TH35
LS274.1508.03.1R.E	0.8			3				Δ
LS274.1510.03.1R.E	1.0			3				Δ
LS274.1515.04.1R.E	1.5	0.05	15°	4	04			Δ
LS274.1520.06.1R.E	2.0			6				Δ
RS274.1508.03.1L.E	0.8			3				Δ
RS274.1510.03.1L.E	1.0			3				Δ
RS274.1515.04.1L.E	1.5	0.05	15°	4	04			Δ
RS274.1520.06.1L.E	2.0			6				Δ

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件Ø≤25mm时才能达到最大切深t<sub>max</sub> 6mm。

Note:  
t<sub>max</sub> 6 mm can be reached only with workpiece Ø ≤ 25 mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号  
Carbide grades

# 切断

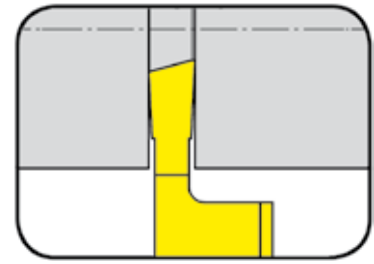
## PARTING OFF



### 可转位刀片 型号

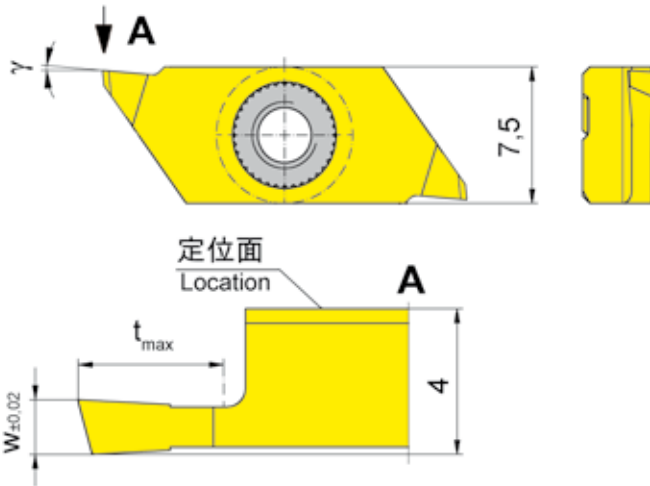
# S274...E

INDEXABLE INSERT Type



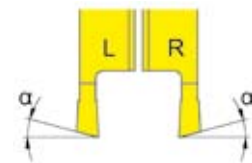
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1515.04.20.E	1.5	15°	5°	4	04			Δ/Δ
R/LS274.1520.06.20.E	2.0			6		Δ/Δ		
▲ 库存 / on stock    Δ 4周 / 4 weeks						P		•
● 主要应用 / main recommendation						M		•
○ 可选推荐 / alternative recommendation						K		•
■ 无涂层牌号 / uncoated grades						N		•
■ 涂层牌号 / coated grades						S		•
■ 钎焊/金属陶瓷 / brazed/Cermet						H		

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$  6mm。

Note:

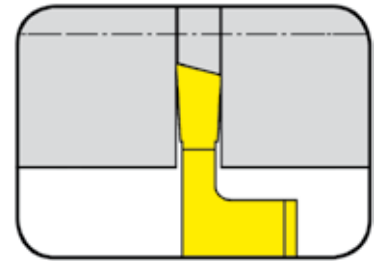
$t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

# 切断 PARTING OFF



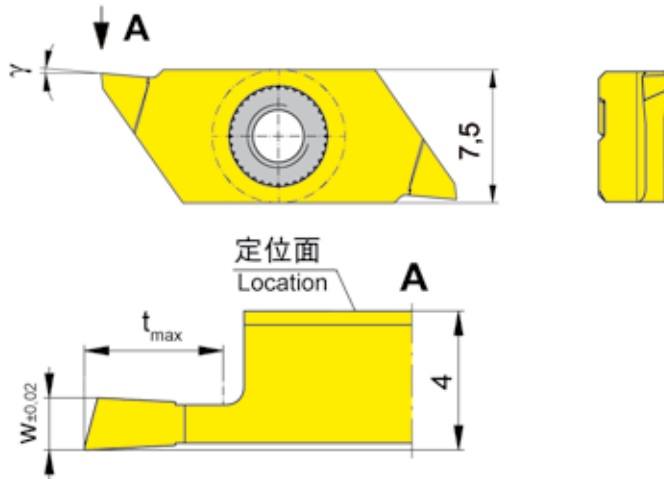
可转位刀片 型号  
INDEXABLE INSERT Type

## S274...E



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削  
precision ground

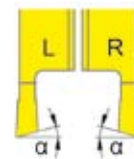


R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	Tl25	TH35
						LS274.1515.04.2R.E	1.5	15°
LS274.1520.06.2R.E	2.0	15°	5°	6	04			Δ
RS274.1515.04.2L.E	1.5	15°	5°	4	04			Δ
RS274.1520.06.2L.E	2.0	15°	5°	6	04			Δ

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:  
 $t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

	TN35	Tl25	TH35
P			●
M			●
K			●
N			●
S			●
H			

硬质合金牌号  
Carbide grades

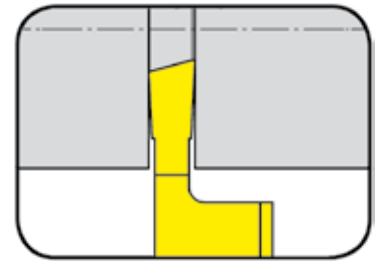
# 切断 PARTING OFF



## 可转位刀片 型号

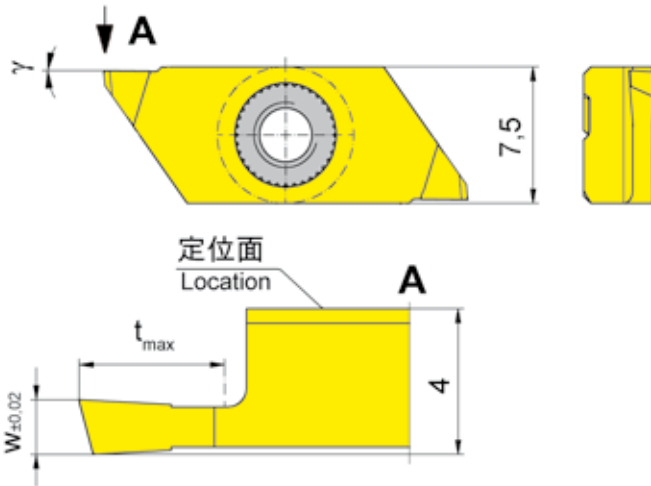
INDEXABLE INSERT Type

# S274...E



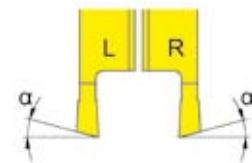
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.M0.E	0.8	15°	0°	3	04			Δ/Δ
R/LS274.1510.03.M0.E	1.0			3		Δ/Δ		
R/LS274.1515.04.M0.E	1.5			4		Δ/Δ		
R/LS274.1520.06.M0.E	2.0			6		Δ/Δ		

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:  
 $t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号  
Carbide grades



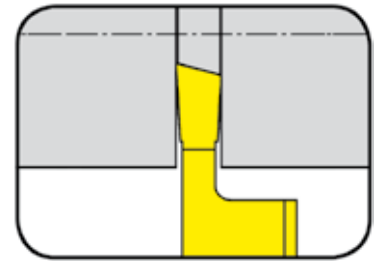
# 切断 PARTING OFF



## 可转位刀片 型号

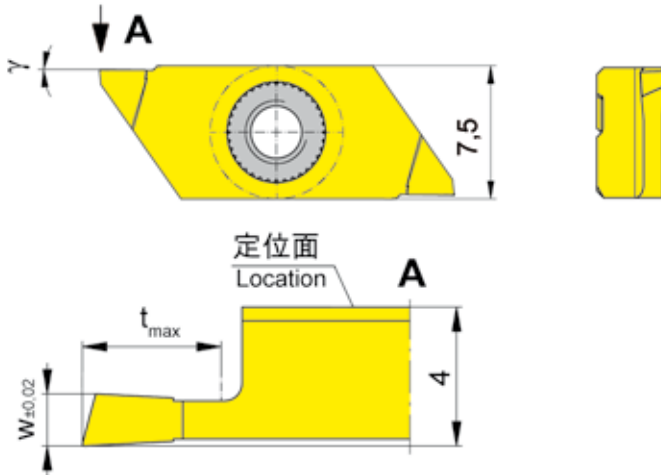
INDEXABLE INSERT Type

# S274...E



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground

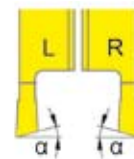


R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274...E  
Type



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	硬质合金牌号		
						TN35	TI25	TH35
LS274.1508.03.MR.E	0.8	15°	0°	3	04			Δ
LS274.1510.03.MR.E	1.0						Δ	
LS274.1515.04.MR.E	1.5						Δ	
LS274.1520.06.MR.E	2.0						Δ	
RS274.1508.03.ML.E	0.8	15°	0°	3	04			Δ
RS274.1510.03.ML.E	1.0						Δ	
RS274.1515.04.ML.E	1.5						Δ	
RS274.1520.06.ML.E	2.0						Δ	

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件Ø≤25mm时才能达到最大切深t<sub>max</sub> 6mm。

Note:  
t<sub>max</sub> 6 mm can be reached only with workpiece Ø ≤ 25 mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号  
Carbide grades

# 螺纹切削 ( 外圆 ) -非全牙型

## THREADING (external) Partial profile

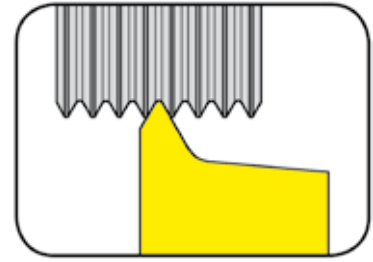


### 可转位刀片 型号

INDEXABLE INSERT Type

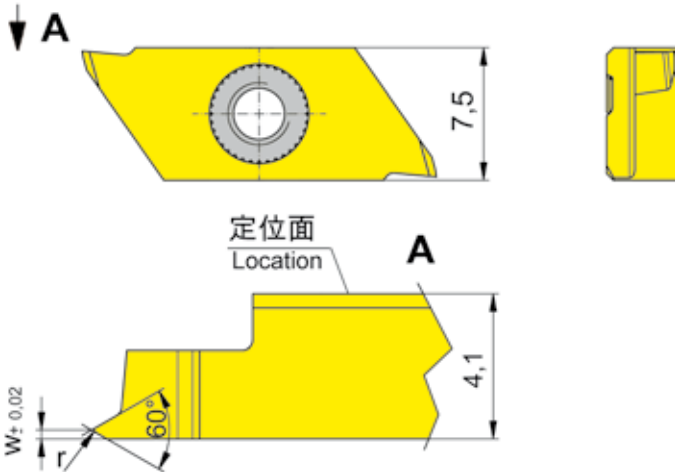
## S274...E

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.25 - 0.40 mm
----	-------	----------------

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图  
R = right hand version shown

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	P	r	E	规格 Size		K10	MG12	TN35	TI25	TH35
RS274.0102.01.E	0.25	0.04	0.20	04						Δ
RS274.0203.01.E	0.35	0.05	0.25							Δ
RS274.0204.01.E	0.40	0.06	0.30							Δ
					P					•
					M					•
					K					•
					N					•
					S					•
					H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

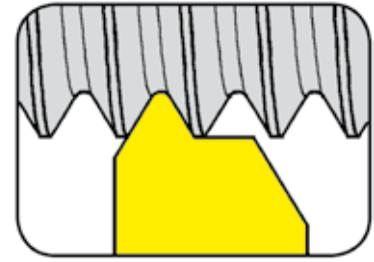


### 可转位刀片 型号

INDEXABLE INSERT Type

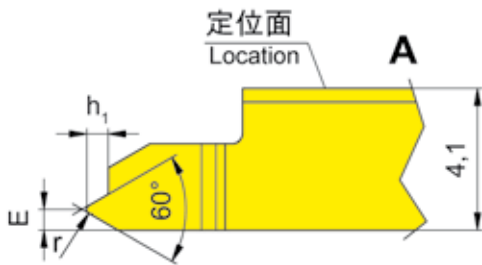
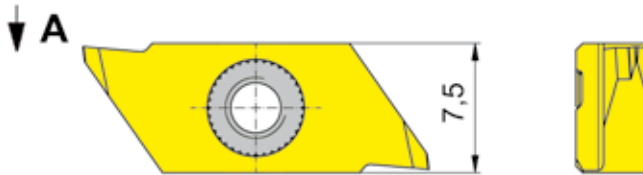
## S274...E

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 1.5 mm
----	-------	--------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	P	r	E	$h_1$	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0305.02.E	0.50	0.07	0.40	0.31	04						△△
R/LS274.0306.02.E	0.60	0.09	0.45	0.37							△△
R/LS274.0307.02.E	0.70	0.10	0.50	0.43							△△
R/LS274.0407.02.E	0.75	0.11	0.50	0.46							△△
R/LS274.0408.02.E	0.80	0.12	0.55	0.49							△△
R/LS274.0610.02.E	1.00	0.12	0.60	0.61							△△
R/LS274.0712.02.E	1.25	0.15	0.70	0.77							△△
R/LS274.0915.02.E	1.50	0.20	0.80	0.92							△△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

P					●
M					●
K					●
N					●
S					●
H					

硬质合金牌号  
Carbide grades

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

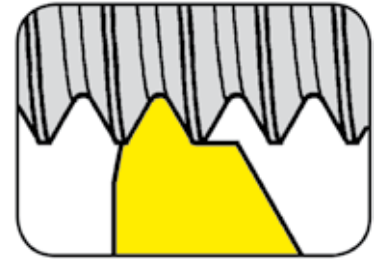


### 可转位刀片 型号

INDEXABLE INSERT Type

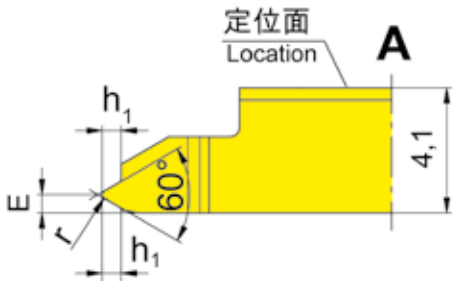
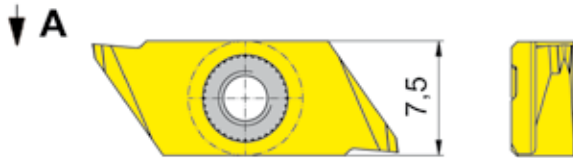
## S274...E

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 1.5 mm
----	-------	--------------

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274...E  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm

产品型号 Part number	P	r	E	$h_1$	规格 Size		K10	MG12	TN35	TI25	TH35
R/LS274.0305.03.E	0.50	0.07	0.40	0.31	04						△△
R/LS274.0306.03.E	0.60	0.09	0.45	0.37							△△
R/LS274.0307.03.E	0.70	0.10	0.50	0.43							△△
R/LS274.0407.03.E	0.75	0.11	0.50	0.46							△△
R/LS274.0408.03.E	0.80	0.12	0.55	0.49							△△
R/LS274.0610.03.E	1.00	0.12	0.60	0.61							△△
R/LS274.0712.03.E	1.25	0.15	0.70	0.77							△△
R/LS274.0915.03.E	1.50	0.20	0.80	0.92							△△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

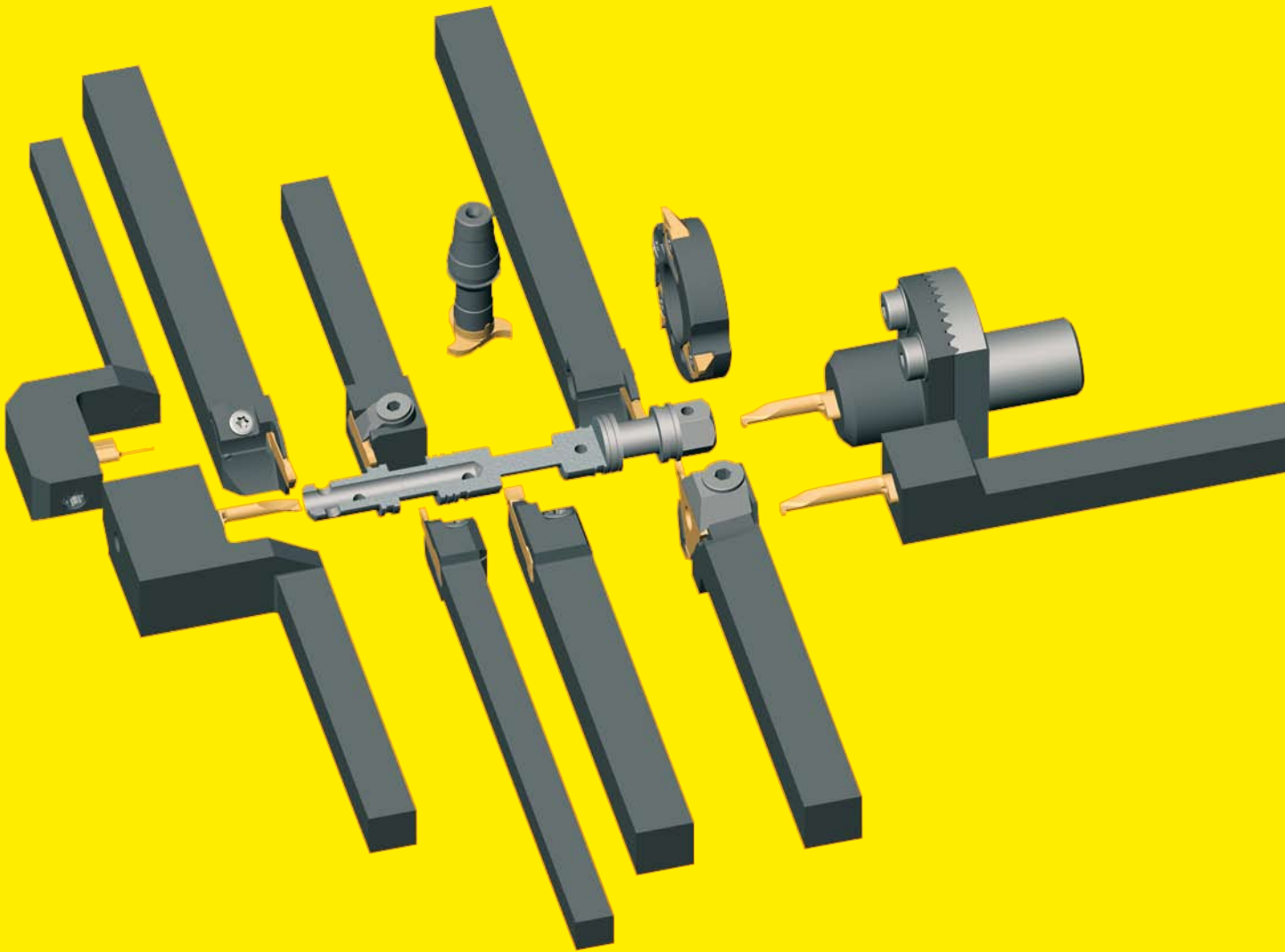
无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

P					●
M					●
K					●
N					●
S					●
H					

硬质合金牌号  
Carbide grades

切槽 - 切断 - 铣槽  
GROOVING - PARTING OFF - GROOVE MILLING

C



完整的解决方案!  
The complete solution!

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

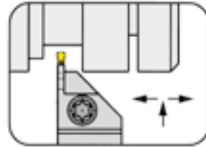
可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

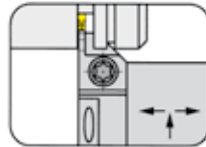
刀具系列 S119/S123/S223  
TOOLING SYSTEM S119/S123/S223

D

切槽  
- 外圆 -  
Grooving  
- external -

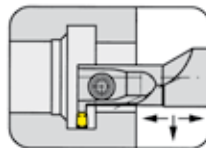


页 / Page  
D2

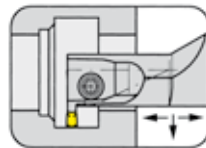


页 / Page  
D4

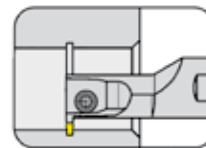
切槽  
- 内圆 -  
Grooving  
- internal -



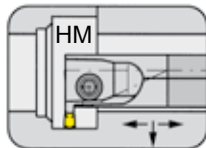
页 / Page  
D5



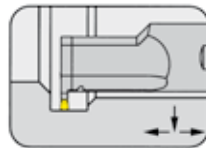
页 / Page  
D6-D7



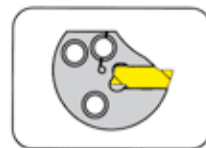
页 / Page  
D8



页 / Page  
D9



页 / Page  
D10



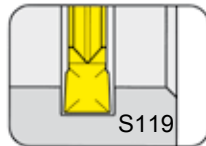
页 / Page  
D11

切断  
Parting off

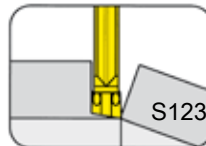


页 / Page  
D3

刀片型号  
Insert Type  
S119 / S123

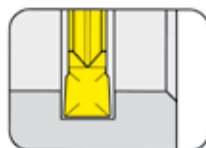


页 / Page  
D12

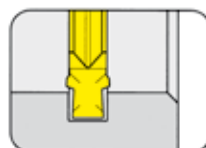


页 / Page  
D13-D14

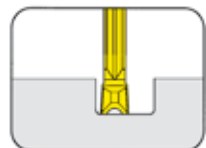
可转位刀片  
型号  
Indexable inserts type  
S223



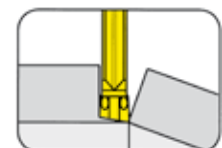
页 / Page  
D15, D17



页 / Page  
D16



页 / Page  
D18



页 / Page  
D19-D20

技术说明见章节Q  
For Technical Instructions please see chapter Q

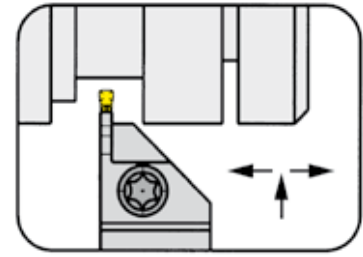
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



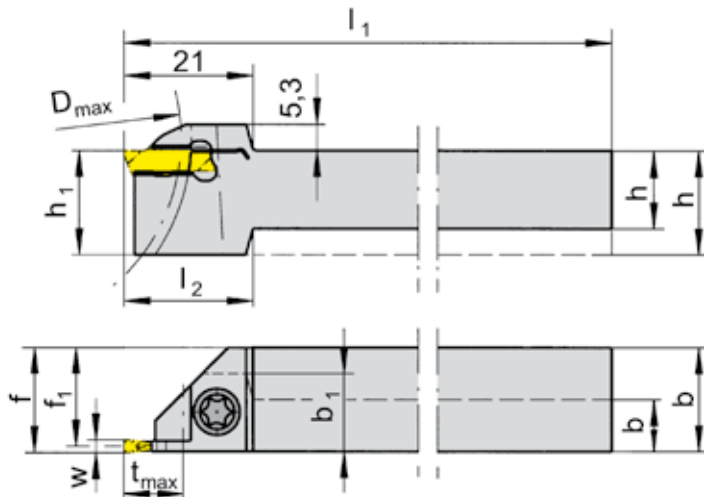
刀杆型号  
TOOLHOLDER Type

# H223



槽深可达 10.0 mm  
夹持范围 2.0 - 3.0 mm

Depth of groove up to 10.0 mm  
Clamping range 2.0 - 3.0 mm



配合刀片  
for use with Insert

型号 S123  
Type S223

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	b <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH223-1010-01	10	10	80	12	f <sub>1</sub> +w/2	9.20	20	12	8	25	01	2.0
R/LH223-1212-01	12	12	100	16		11.20	21	-	10	50		
R/LH223-1616-01	16	16	125	16		15.20	-	-	10	50		
R/LH223-2020-01	20	20	125	20		19.20	-	-	10	50		
R/LH223-2525-01	25	25	150	25		24.20	-	-	10	50		
R/LH223-1010-02	10	10	80	12	f <sub>1</sub> +w/2	9.05	20	12	8	25	02	2.5
R/LH223-1212-02	12	12	100	16		11.05	21	-	10	50		
R/LH223-1616-02	16	16	125	16		15.05	-	-	10	50		
R/LH223-2020-02	20	20	125	20		19.05	-	-	10	50		
R/LH223-2525-02	25	25	150	25		24.05	-	-	10	50		
R/LH223-1010-03	10	10	80	12	f <sub>1</sub> +w/2	8.80	20	12	8	25	03	3.0
R/LH223-1212-03	12	12	100	16		10.80	21	-	10	50		
R/LH223-1616-03	16	16	125	16		14.80	-	-	10	50		
R/LH223-2020-03	20	20	125	20		18.80	-	-	10	50		
R/LH223-2525-03	25	25	150	25		23.80	-	-	10	50		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH223....	5.11T15P	T15PL



# 切槽和切断

## GROOVING and PARTING OFF

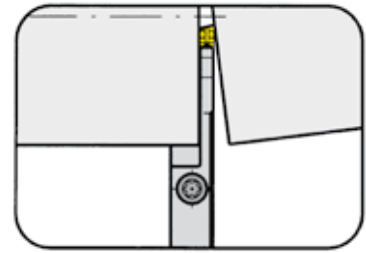


### 刀杆 型号

TOOLHOLDER Type

## H223

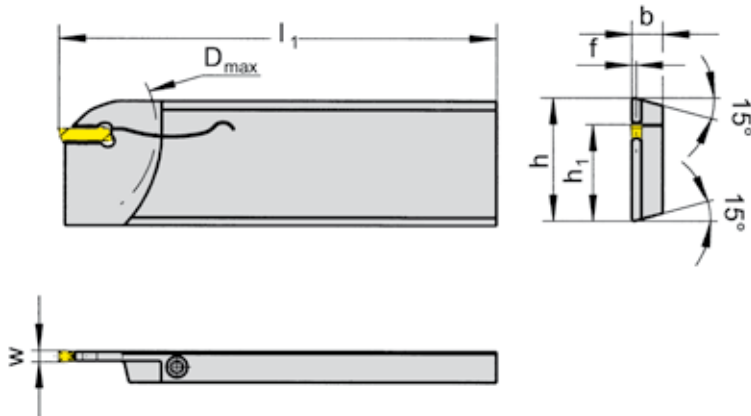
加强型  
reinforced version



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

25.0 mm  
2.0 - 3.0 mm



配合 刀片

for use with Insert

型号 S123

Type S223

D

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH223-2608-01 R/LH223-3208-01	26 32	7.9	110	21.4 24.8	0.80	50	01	2.0
R/LH223-2608-02 R/LH223-3208-02	26 32	7.9	110	21.4 24.8	0.95	50	02	2.5
R/LH223-2608-03 R/LH223-3208-03	26 32	7.9	110	21.4 24.8	1.20	50	03	3.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

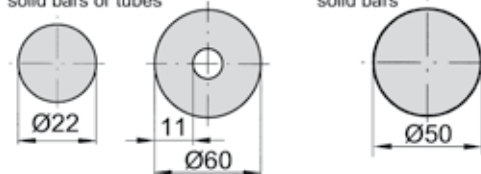
螺丝的扭矩规格，详见技术说明。

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

切断:

parting off:

实心棒料或空心棒料 (S223) 实心棒料 (S123)  
solid bars or tubes solid bars



### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH223....	4.15T15P	T15PL

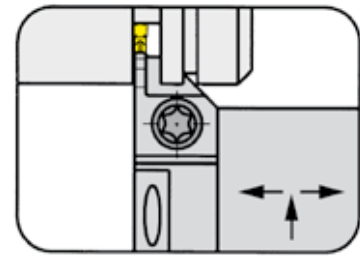
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀夹 型号  
CARTRIDGE Type

# E223

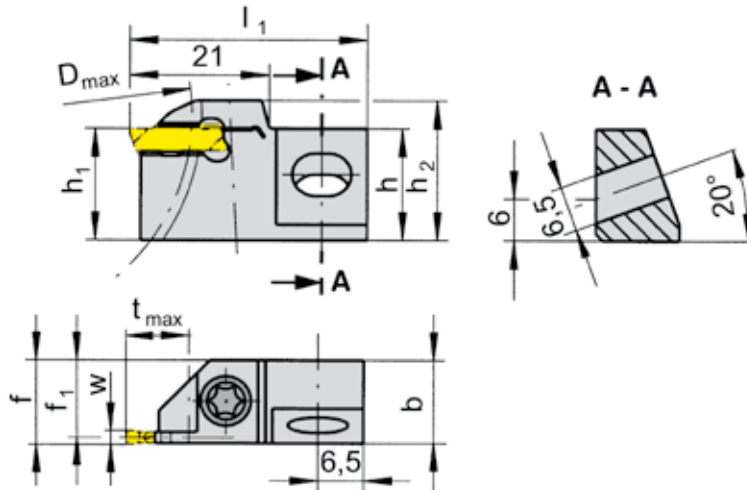


槽深可达 10.0 mm  
夹持范围 2.0 - 3.0 mm

Depth of groove up to 10.0 mm  
Clamping range 2.0 - 3.0 mm

配合 刀片  
for use with Insert

型号 S123  
Type S223



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	h <sub>2</sub>	f	b	l <sub>1</sub>	t <sub>max</sub>	f <sub>1</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LE223.1212.01 R/LE223.1616.01	16	12 16	17.3 21.3	f <sub>1</sub> +w/2	12	34	10	11.20	50	01	2.0
R/LE223.1212.02 R/LE223.1616.02	16	12 16	17.3 21.3	f <sub>1</sub> +w/2	12	34	10	11.05	50	02	2.5
R/LE223.1212.03 R/LE223.1616.03	16	12 16	17.3 21.3	f <sub>1</sub> +w/2	12	34	10	10.80	50	03	3.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cartridge	螺钉 Screw	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LE223.1...	6.20.232	5.11T15P	T15PL

# 切槽和侧车削 (内圆)

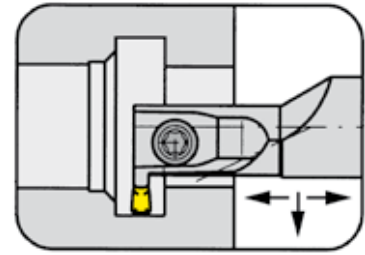
## GROOVING and SIDE TURNING (internal)



刀杆 型号  
TOOLHOLDER Type

# B119

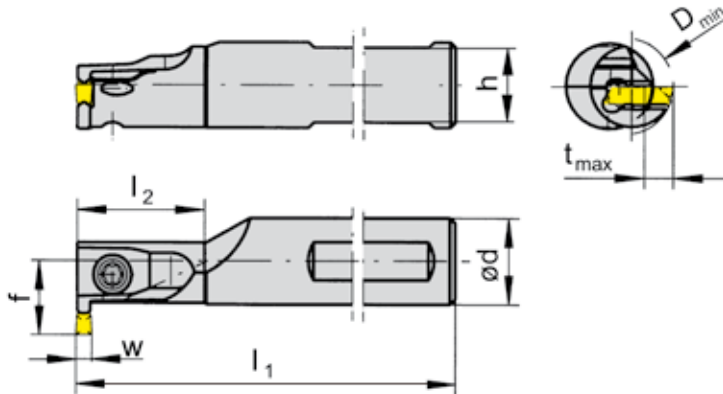
带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	16.0 mm
槽深可达	Depth of groove up to	3.0 mm
夹持范围可达	Clamping range up to	2.0 - 3.0 mm

配合 刀片  
for use with Insert

型号 S119  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB119.0016.1.32	16	110	25	14	11.8	16	3	02	2.0 - 2.99
R/LB119.0016.1.33	16	110	25	14	11.8	16	3	03	3.0

注明R或L型  
State R or L version

w见刀片  
w see inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB119.0016.1.3...	5.11T15P	T15PL

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

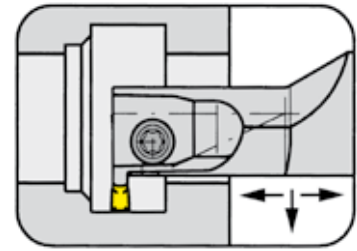


### 刀杆 型号

TOOLHOLDER Type

## B223

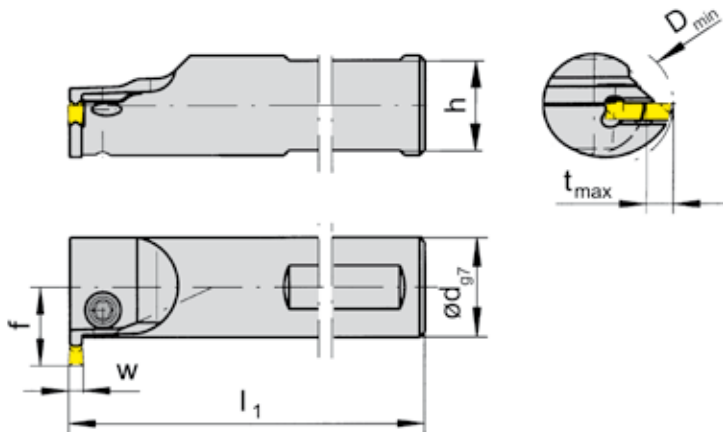
带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	22.0 mm
槽深可达	Depth of groove up to	6.3 mm
夹持范围	Clamping range	2.0 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S223  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	d	l <sub>1</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB223.0016.0.42	16	110	14	13.0	22	4.5	02	2.0 - 2.99
R/LB223.0020.0.52	20	120	18	15.7	27	5.3		
R/LB223.0025.0.62	25	150	23	19.3	33	6.3		
R/LB223.0016.0.43	16	110	14	13.0	22	4.5	03	3.0
R/LB223.0020.0.53	20	120	18	15.7	27	5.3		
R/LB223.0025.0.63	25	150	23	19.3	33	6.3		

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB223.00...	5.11T15P	T15PL

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

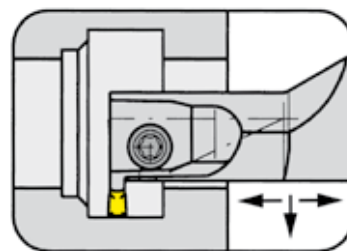


### 刀杆 型号

TOOLHOLDER Type

## B223

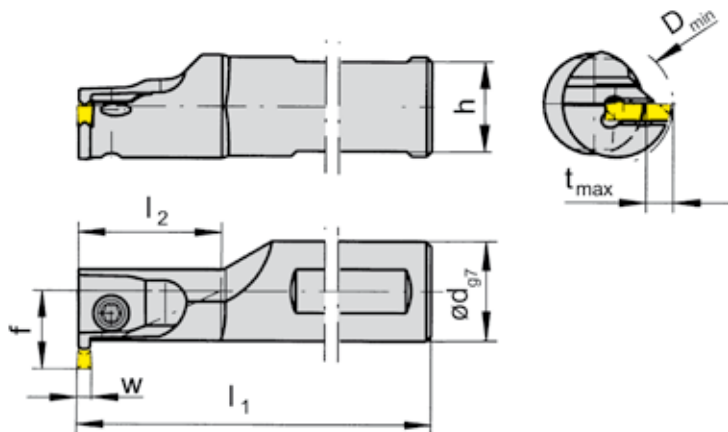
带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	18.0 mm
槽深可达	Depth of groove up to	6.3 mm
夹持范围	Clamping range	2.0 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S223  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB223.0016.1.42	16	110	25	14	13.0	18	4.5	02	2.0 - 2.99
R/LB223.0020.1.52	20	120	30	18	15.7	20	5.3		
R/LB223.0025.1.62	25	150	50	23	18.8	25	6.3		
R/LB223.0016.1.43	16	110	25	14	13.0	18	4.5	03	3.0
R/LB223.0020.1.53	20	120	30	18	15.7	20	5.3		
R/LB223.0025.1.63	25	150	50	23	18.8	25	6.3		

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB223.00...	5.11T15P	T15PL

# 切槽 ( 内圆 )

## GROOVING (internal)

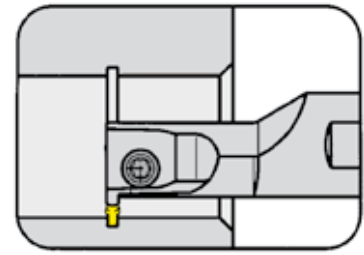


### 刀杆 型号

TOOLHOLDER Type

## B223

带内冷  
with through coolant supply

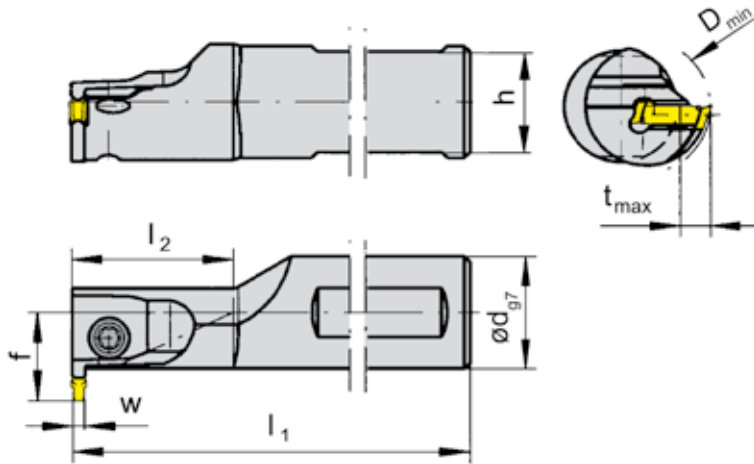


孔径Ø 自	Bore Ø from	18.0 mm
卡簧槽	Circlip grooves	DIN 471/472
夹持范围	Clamping range	2.0 - 2.9 mm

D

配合 可转位刀片  
for use with Indexable insert

型号 S223  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB223.0016.1.22	16	110	25	14	13.0	18	1.65	02	2.0 - 2.99
R/LB223.0020.1.22	20	120	30	18	15.7	20			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB223.00...	5.11T15P	T15PL

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

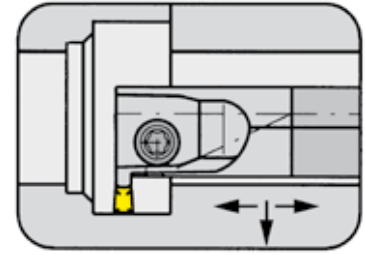


### 刀杆 型号

TOOLHOLDER Type

## B223

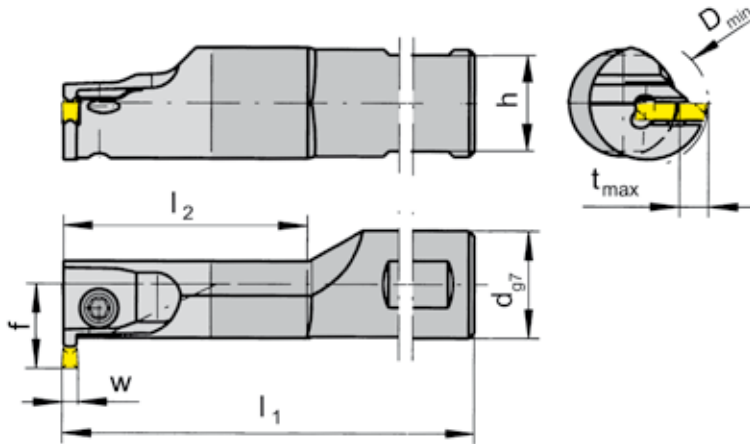
带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	18.0 mm
槽深可达	Depth of groove up to	6.3 mm
夹持范围	Clamping range	2.0 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S223  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

硬质合金刀杆  
Carbide shank

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB223.HM16.2.42	16	130	50	14	13.0	18	4.5	02	2.0 - 2.99
R/LB223.HM20.2.52	20	150	60	18	15.7	20	5.3		
R/LB223.HM25.2.62	25	160	70	23	18.8	25	6.3		
R/LB223.HM16.2.43	16	130	50	14	13.0	18	4.5	03	3.0
R/LB223.HM20.2.53	20	150	60	18	15.7	20	5.3		
R/LB223.HM25.2.63	25	160	70	23	18.8	25	6.3		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB223.HM...	5.11T15P	T15PL

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

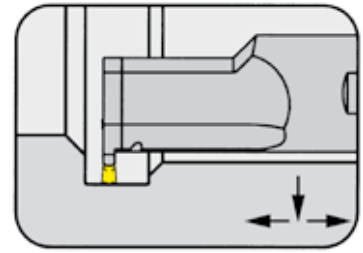


### 常规刀杆 型号

BASIC TOOLHOLDER Type

## B223

无刀夹  
without cassette

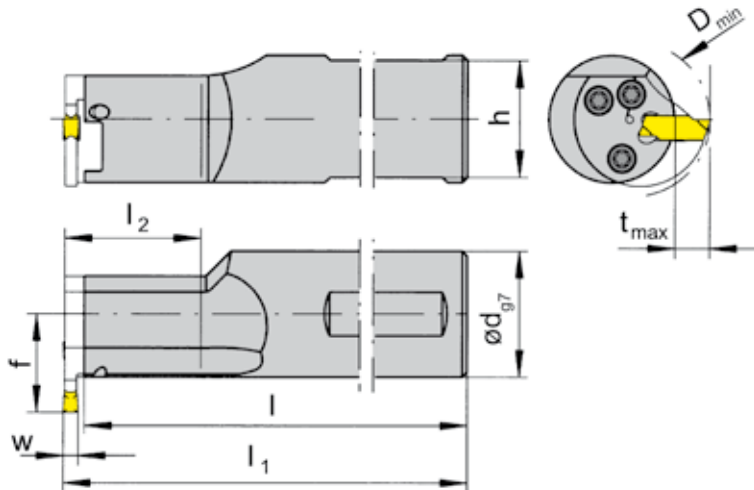


孔径	Bore Ø	28.0 mm
槽深可达	Depth of groove up to	6.3 mm
槽宽	Width of groove	2.0 - 3.0 mm

带内冷  
with through coolant supply

配合刀夹  
for use with Cassette

型号 BK223  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	h	f
R/LB223.0025.1.K2	25	116.1	l+b <sub>1</sub> +w/2	30	23	19.5
R/LB223.0025.2.K2		146.1		60		
R/LB223.0032.1.K2	32	146.1	l+b <sub>1</sub> +w/2	30	30	23.0
R/LB223.0032.2.K2		176.1		60		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

#### 注意事项:

D<sub>min</sub>, t<sub>max</sub>, w和 b<sub>1</sub>尺寸, 见刀夹

#### Note:

Dimensions for D<sub>min</sub>, t<sub>max</sub> and b<sub>1</sub> see cassettes

螺丝的扭矩规格, 详见技术说明。

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

#### 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB223.00...	4.09T15P	T15PL



# 切槽和侧车削 (内圆)

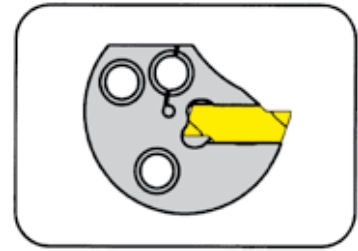
GROOVING and SIDE TURNING (internal)



## 刀夹 型号

CASSETTE Type

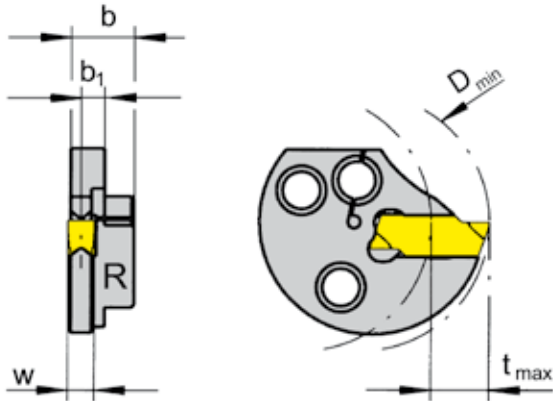
# BK223



孔径	Bore Ø	28.0 mm
槽深可达	Depth of groove up to	6.3 mm
夹持范围	Clamping range	2.0 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S223  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	b <sub>1</sub>	b	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LBK223-0028-01	3.10	7.4	28	6.3	01	2.0
R/LBK223-0028-02	2.95	7.4	28	6.3	02	2.5
R/LBK223-0028-03	2.70	7.4	28	6.3	03	3.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

右手型刀夹配合右手型常规刀杆,左手型刀夹配合左手型常规刀杆  
Use right hand cassettes in right hand basic toolholders and left hand cassettes in left hand basic toolholders.

### 配件

锁紧螺钉包含在刀杆内,不需要单独订购

### Spare parts

The fastening screw is combined with the basic toolholder - no separate order required.



# 切槽和侧车削

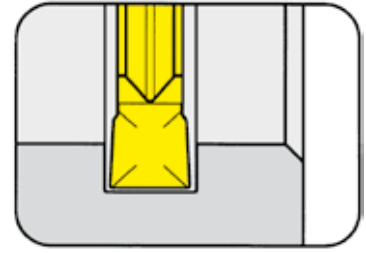
## GROOVING and SIDE TURNING



### 刀片型号

INSERT Type

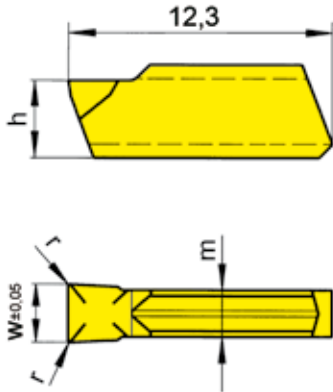
# S119



槽深可达  
槽宽

Depth of groove up to  
Width of groove

3.0 mm  
2.0 - 3.0 mm



配合刀杆

for use with Toolholder

型号 B119

Type

产品型号 Part number	w	r	m	h	规格 Size	MG12	TN35	TI25	TA45
<b>S119.0200.32</b>	2.0	0.2	1.6	3.65	02		▲		
<b>S119.0250.32</b>	2.5	0.2	2.0	3.75	02		▲		
<b>S119.0300.32</b>	3.0	0.2	2.4	3.95	03		▲		
▲ 库存 / on stock    Δ 4周 / 4 weeks						P	•	•	•
● 主要应用 / main recommendation						M	•	•	•
○ 可选推荐 / alternative recommendation						K	•	•	•
■ 无涂层牌号 / uncoated grades						N	•	•	•
■ 涂层牌号 / coated grades						S	•	•	•
■ 钎焊/金属陶瓷 / brazed/Cermet						H	•	•	•

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left** hand toolholders.

硬质合金牌号

Carbide grades



# 切槽和切断

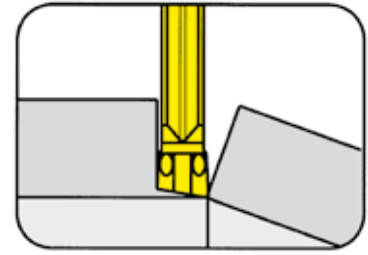
## GROOVING and PARTING OFF



### 刀片型号

INSERT Type

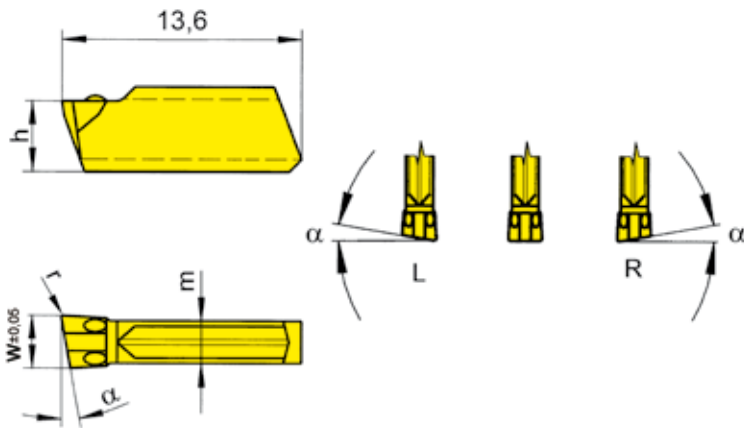
# S123



槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
2.0 - 3.0 mm



配合 刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
<b>S123.0020.C1</b>	2	0.15	0°	1.6	3.65	01		△	△	△
<b>R/LS123.1520.C1</b>			15°							
<b>R/LS123.0420.C1</b>			4°				△	△/△		
<b>R/LS123.0820.C1</b>			8°					△/		
<b>S123.0030.C1</b>	3	0.15	0°	2.4	3.95	03		△		
<b>R/LS123.0430.C1</b>			4°							
<b>R/LS123.0830.C1</b>			8°						△/	
▲ 库存 / on stock    △ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet							P	●	●	●
							M	●	●	●
							K	●	●	●
							N	●	●	●
							S	●	●	●
							H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手刀杆

Indexable inserts can be used in **right and left** hand toolholders.

# 切槽和侧车削

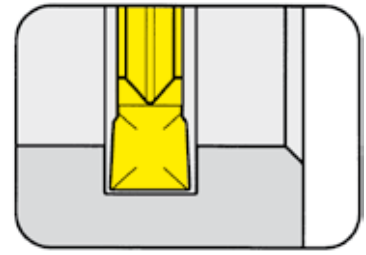
## GROOVING and SIDE TURNING



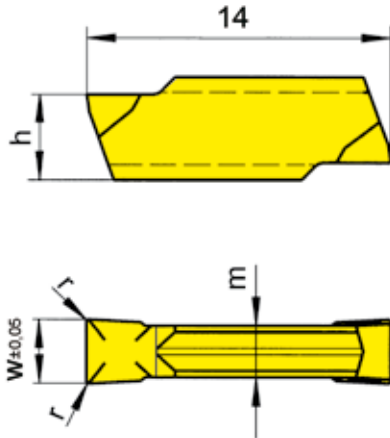
### 可转位刀片 型号

INDEXABLE INSERT Type

# S223



槽深可达	Depth of groove up to	11.0 mm
槽宽	Width of groove	2.0 - 3.0 mm



配合 刀杆  
for use with Toolholder

型号 B223  
Type BK223  
E223  
H223



产品型号 Part number	w	r	m	h	规格 Size	MG12	H54	TN35	Ti25	TA45
S223.0200.32	2.0	0.2	1.6	3.65	01	▲	▲	▲	▲	
S223.0250.32	2.5	0.2	2.0	3.75	02	▲	▲	▲	▲	
S223.0300.32	3.0	0.2	2.4	3.95	03	▲	▲	▲	▲	
▲ 库存 / on stock   Δ 4周 / 4 weeks						P	○	●	●	●
● 主要应用 / main recommendation						M	●	●	●	●
○ 可选推荐 / alternative recommendation						K	●	●	●	●
■ 无涂层牌号 / uncoated grades						N	●	●	●	●
■ 涂层牌号 / coated grades						S	●	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet						H				

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽 GROOVING

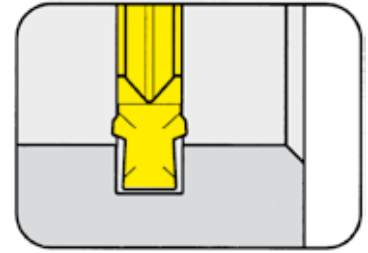


## 可转位刀片 型号

INDEXABLE INSERT Type

## S223

切削深度限制  
limited depth of cut



卡簧槽

Circlip grooves

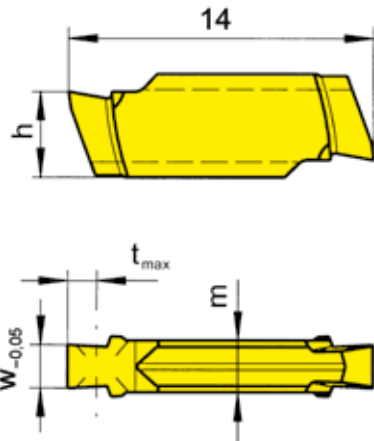
DIN 471/472

卡簧宽度Nw

Width of circlip Nw

1.10 - 2.15 mm

D



配合 刀杆

for use with Toolholder

型号 B223...1.22

Type E223  
H223

产品型号 Part number	Nw	w	t <sub>max</sub>	m	h	规格 Size	MG12	H54	TN35	T125	TA45
S223.0110.32	1.10	1.24	0.60	1.9	3.75	02			▲		
S223.0130.32	1.30	1.44	1.10	1.9	3.75	02			▲		
S223.0160.32	1.60	1.74	1.15	1.9	3.75	02			▲		
S223.0185.32	1.85	1.99	1.40	1.9	3.75	02			▲		
S223.0215.32	2.15	2.29	1.65	1.9	3.75	02			▲		
▲ 库存 / on stock    Δ 4周 / 4 weeks							P		•		
• 主要应用 / main recommendation							M		•		
○ 可选推荐 / alternative recommendation							K		•		
■ 无涂层牌号 / uncoated grades							N		•		
■ 涂层牌号 / coated grades							S		•		
■ 钎焊/金属陶瓷 / brazed/Cermet							H				

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和侧车削

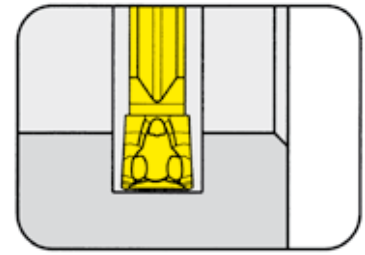
## GROOVING and SIDE TURNING



### 可转位刀片 型号

INDEXABLE INSERT Type

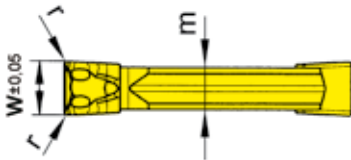
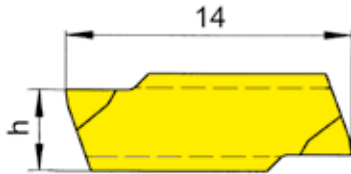
# S223



槽深可达  
槽宽

Depth of groove up to  
Width of groove

11.0 mm  
2.0 - 3.0 mm



配合 刀杆

for use with Toolholder

型号

Type B223  
BK223  
E223  
H223

D

产品型号 Part number	w	r	m	h	规格 Size						
						MG12	H54	TN35	TI25	TA45	TH35
<b>S223.0200.52</b>	2.0	0.2	1.6	3.65	01						▲
<b>S223.0250.52</b>	2.5	0.2	1.9	3.75	02				▲		
<b>S223.0300.52</b>	3.0	0.2	2.4	3.95	03						▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P				●		●
M				●		●
K				●		●
N				●		●
S				●		●
H						

硬质合金牌号

Carbide grades

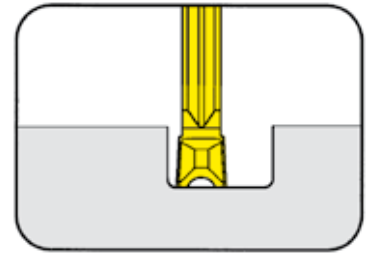
# 切槽和侧车削

## GROOVING and SIDE TURNING



刀片型号  
INSERT Type

**S223**  
带断屑槽  
with chip forming

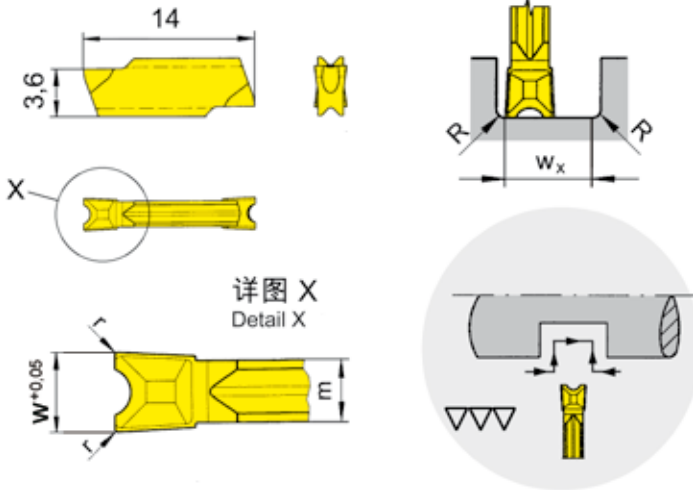


槽深可达	Depth of groove up to	10.0 mm
槽宽	Width of groove	2.0 mm

精密磨削  
precision ground

配合刀杆  
for use with Toolholder

型号 B223  
Type BK223  
E223  
H223



产品型号 Part number	w	r	w <sub>x</sub>	m	规格 Size		MG12	H54	TN35	TI25	TA45
<b>S223.NC20.D2</b>	2	0.2	2.7	1.6	01					▲	
						P				•	
						M				•	
						K				•	
						N				•	
						S				•	
						H					

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

$w_x = \text{槽宽} - R_{(右)} - R_{(左)}$   
 $w_x = \text{width of groove} - R_{(right)} - R_{(left)}$

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽和切断

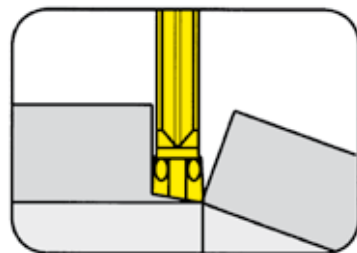
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

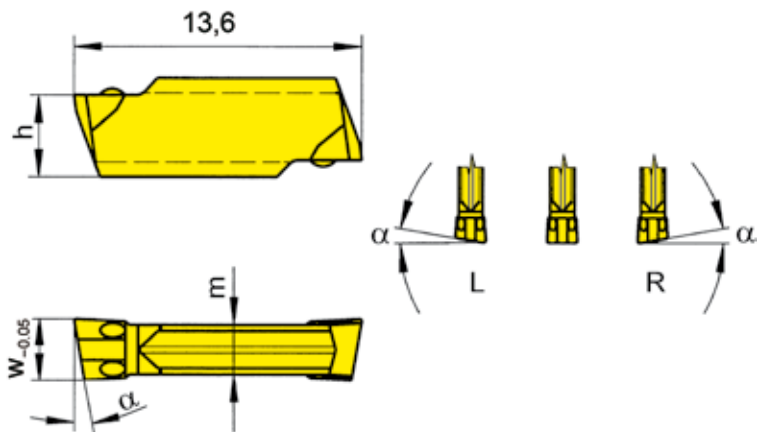
# S223



槽深可达	Depth of groove up to	11.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

配合 刀杆  
for use with Toolholder

型号 H223  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S223.0020.C0 R/LS223.1520.C0 R/LS223.0420.C0 R/LS223.0820.C0	2.0	0° 15° 4° 8°	1.6	3.65	01		▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲/▲ ▲/▲ ▲/▲
S223.0025.C0 R/LS223.0425.C0 R/LS223.0825.C0	2.5	0° 4° 8°	1.9	3.75	02		▲/▲ ▲/▲ ▲/▲	▲ ▲/ ▲/▲	▲ ▲/▲ ▲/▲
S223.0030.C0 R/LS223.0430.C0 R/LS223.0830.C0	3.0	0° 4° 8°	2.4	3.95	03		▲ ▲/▲ ▲/▲	▲ ▲/ ▲/▲	▲ /▲ ▲/▲
▲ 库存 / on stock    ▲ 4周 / 4 weeks						P	●	●	●
● 主要应用 / main recommendation						M	●	●	●
○ 可选推荐 / alternative recommendation						K	●	●	●
■ 无涂层牌号 / uncoated grades						N	●	●	●
■ 涂层牌号 / coated grades						S	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet						H	●	●	●

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.



# 切槽和切断

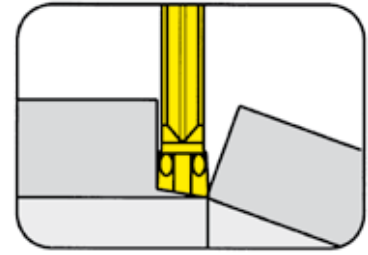
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

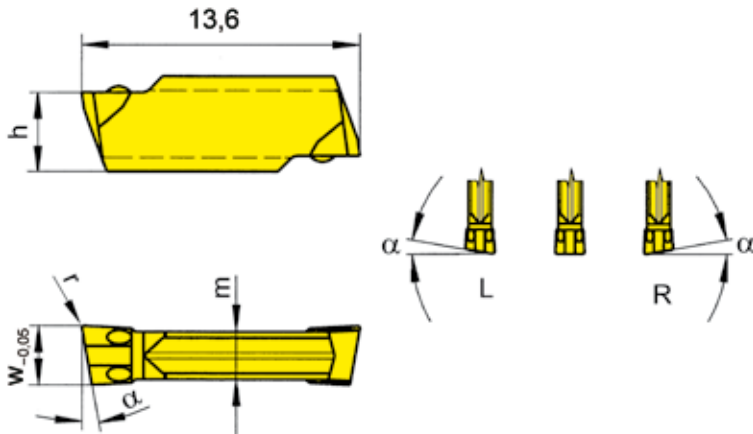
# S223



槽深可达  
槽宽

Depth of groove up to  
Width of groove

11.0 mm  
2.0 - 3.0 mm



配合 刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S223.0020.C1 R/LS223.1520.C1 R/LS223.0420.C1 R/LS223.0820.C1	2.0	0.15	0° 15° 4° 8°	1.6	3.65	01	▲	▲	▲	▲
S223.0025.C1 R/LS223.0425.C1 R/LS223.0825.C1	2.5	0.15	0° 4° 8°	1.9	3.75	02	△	▲	▲	△
S223.0030.C1 R/LS223.0430.C1 R/LS223.0830.C1	3.0	0.15	0° 4° 8°	2.4	3.95	03	▲	▲	▲	▲

▲ 库存 / on stock	△ 4周 / 4 weeks						P	•	•	•
• 主要应用 / main recommendation							M	•	•	•
○ 可选推荐 / alternative recommendation							K	•	•	•
■ 无涂层牌号 / uncoated grades							N	•	•	•
■ 涂层牌号 / coated grades							S	•	•	•
■ 钎焊/金属陶瓷 / brazed/Cermet							H			

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

## 面车削和倒角

带有ABS附件的刀具，用于加工弹簧座上的预铸槽。该刀具被用于加工各种主轴的转油线上，主要为面车削和倒角。

由于切削余量大，刀片被设计成单刃的，利于切削的排出，冷却液压力为15 bar。

**材料: GD-AISI9**

切削参数:

$$v_c = 270 \text{ m/min}$$

$$v_f = 0.1 \text{ mm}$$



## Facing and chamfering

Tools with ABS-attachment for facing operation of a spring seat in a pre-casted groove. The tools are used on various spindles on a transfer line. Process is facing and chamfering.

Because of the high volume of machined material the tool was designed with one cutting edge for a better swarf evacuation. The coolant pressure used was 15 bar.

**Material: GD-AISI9**

Cutting data:

$$v_c = 270 \text{ m/min}$$

$$v_f = 0.1 \text{ mm}$$

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
割槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

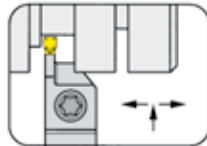
可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

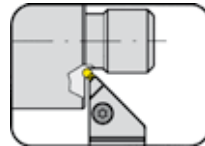
刀具系列 224  
TOOLING SYSTEM 224

E

切槽和  
侧车削(外圆)  
Grooving and  
Side turning (external)



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E2-E6, E8-E13

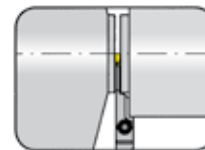


页/Page  
E14

切断  
Parting off

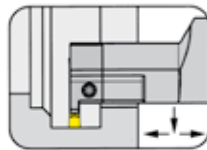


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E7, E16-E17

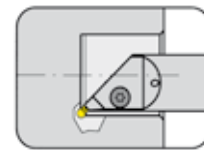
切槽和  
侧车削(内圆)  
Grooving and  
Side turning (internal)



页/Page  
E20-E24

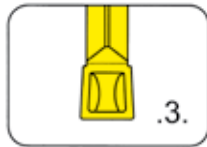


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E25

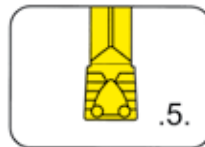


页/Page  
E26-E27

可转位刀片  
型号  
Indexable inserts type  
S224



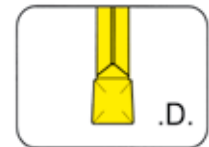
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E28-E29



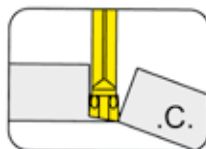
页/Page  
E30-E31



页/Page  
E32-E33



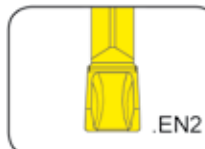
页/Page  
E34-E35



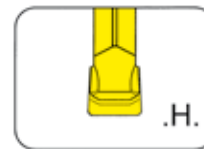
页/Page  
E36-E37



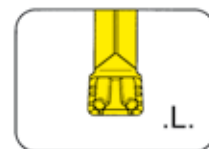
页/Page  
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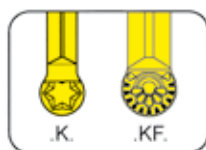
页/Page  
E39



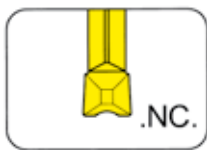
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E40



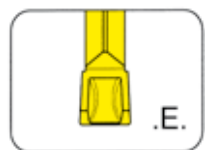
页/Page  
E41



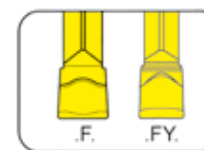
页/Page  
E42-E43



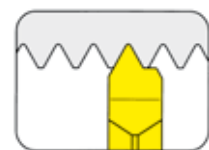
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E45



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E46-E47



页/Page  
E48-E49

技术说明见章节Q  
For Technical Instructions please see chapter Q

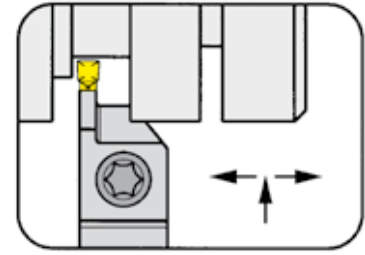
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀杆型号  
TOOLHOLDER Type

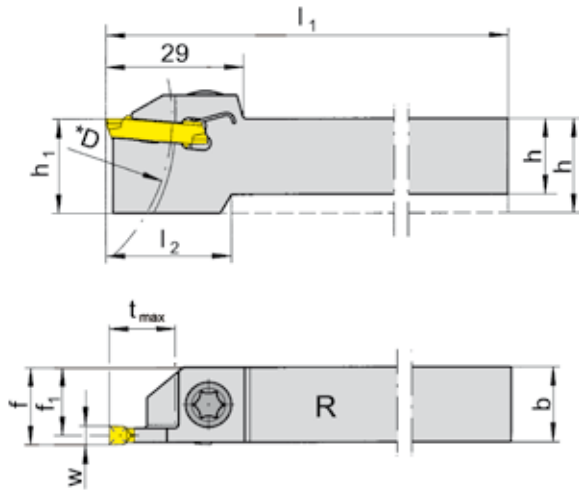
# H224



槽深可达 夹持范围	Depth of groove up to Clamping range	14.0 mm 2.0 - 3.7 mm
--------------	---	-------------------------

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.1616.01	16	16	125	20		15.3	25			
R/LH224.2020.01	20	20	125	20	f <sub>1</sub> +w/2	19.3	-	14	01	2.0 - 2.4
R/LH224.2525.01	25	25	150	25		24.3	-			
RH224.1608.02	16	8	100	20		7.1	30			
R/LH224.1616.02	16	16	125	20		15.1	25			
R/LH224.2020.02	20	20	125	20	f <sub>1</sub> +w/2	19.1	-	14	02	2.4 - 2.8
R/LH224.2525.02	25	25	150	25		24.1	-			
R/LH224.1616.03	16	16	125	20		14.9	25			
R/LH224.2020.03	20	20	125	20	f <sub>1</sub> +w/2	18.9	-	14	03	2.8 - 3.7
R/LH224.2525.03	25	25	150	25		23.9	-			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm  
\*t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....01/02/03	6.23T25P	T25PQ
RH224.1608.02	4.15T15P	T15PQ

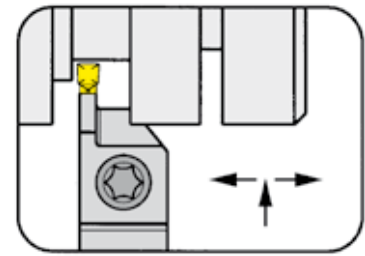
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

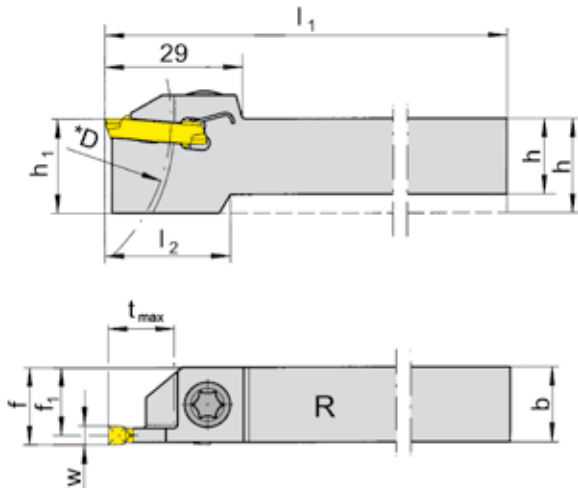
# H224



槽深可达 夹持范围	Depth of groove up to Clamping range	14.0 mm 3.7 - 6.1 mm
--------------	---	-------------------------

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.1616.04	16	16	125	20		14.55	25			
R/LH224.2020.04	20	20	125	20	f <sub>1</sub> +w/2	18.55	-	14	04	3.7 - 4.4
R/LH224.2525.04	25	25	150	25		23.55	-			
R/LH224.1616.05	16	16	125	20		18.15				
R/LH224.2020.05	20	20	125	20	f <sub>1</sub> +w/2	18.15	-	14	05	4.4 - 5.1
R/LH224.2525.05	25	25	150	25		23.15				
R/LH224.2020.06	20	20	125	20		17.75	-			
R/LH224.2525.06	25	25	150	25	f <sub>1</sub> +w/2	22.75	-	14	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm  
\* t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	6.23T25P	T25PQ

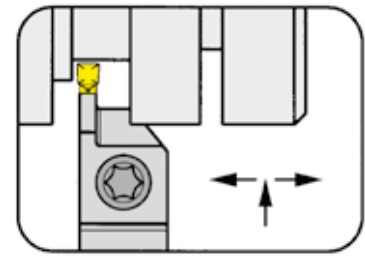
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀杆型号  
TOOLHOLDER Type

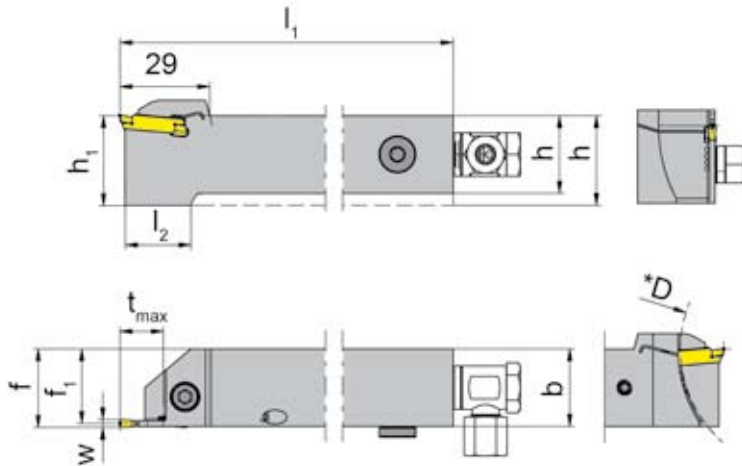
# H224



槽深可达 夹持范围	Depth of groove up to Clamping range	14.0 mm 2.0 - 3.7 mm
--------------	---	-------------------------

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224-1616-01.IK	16	16	125	20		15.3	25			
R/LH224-2020-01.IK	20	20	125	20	f <sub>1</sub> +w/2	19.3	-	14	01	2.0 - 2.4
R/LH224-2525-01.IK	25	25	150	25		24.3	-			
R/LH224-1616-02.IK	16	16	125	20		15.1	25			
R/LH224-2020-02.IK	20	20	125	20	f <sub>1</sub> +w/2	19.1	-	14	02	2.4 - 2.8
R/LH224-2525-02.IK	25	25	150	25		24.1	-			
R/LH224-1616-03.IK	16	16	125	20		14.9	25			
R/LH224-2020-03.IK	20	20	125	20	f <sub>1</sub> +w/2	18.9	-	14	03	2.8 - 3.7
R/LH224-2525-03.IK	25	25	150	25		23.9	-			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm  
\*t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH224....	6.23T25P	T25PQ	004.00.61



# 切槽和切断

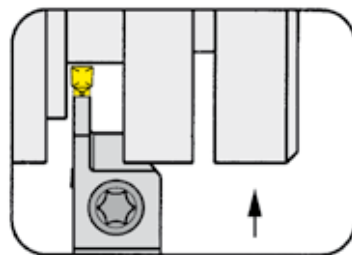
## GROOVING and PARTING OFF



### 刀杆 型号

TOOLHOLDER Type

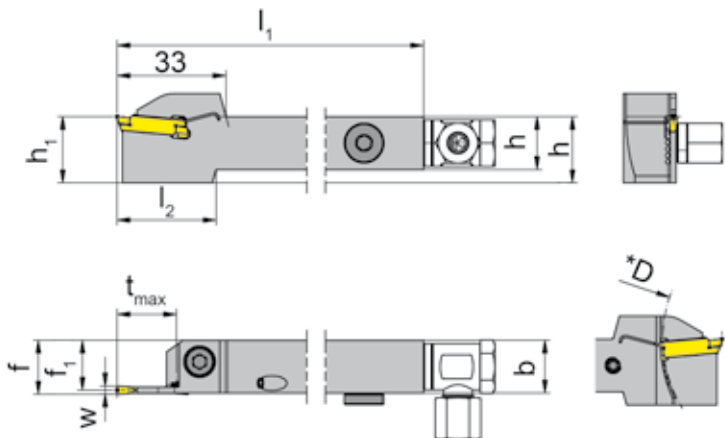
# H224



槽深可达	Depth of groove up to	18.0 mm
夹持范围	Clamping range	2.0 - 3.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.1212.21.IK	12	12	125	33	20	11.3	f <sub>1</sub> +w/2	18	01	2.0 - 2.4
R/LH224.1616.21.IK	16	16	125	30	20	15.3				
R/LH224.2020.21.IK	20	20	125	-	20	19.3				
R/LH224.2525.21.IK	25	25	150	-	25	24.3				
R/LH224.1212.22.IK	12	12	125	33	20	11.1	f <sub>1</sub> +w/2	18	02	2.4 - 2.8
R/LH224.1616.22.IK	16	16	125	30	20	15.1				
R/LH224.2020.22.IK	20	20	125	-	20	19.1				
R/LH224.2525.22.IK	25	25	150	-	25	24.1				
R/LH224.1212.23.IK	12	12	125	33	20	10.9	f <sub>1</sub> +w/2	18	03	2.8 - 3.7
R/LH224.1616.23.IK	16	16	125	30	20	14.9				
R/LH224.2020.23.IK	20	20	125	-	20	18.9				
R/LH224.2525.23.IK	25	25	150	-	25	23.9				

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm  
\*t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH224....	6.23T25P	T25PQ	004.00.61



# 切槽和切断

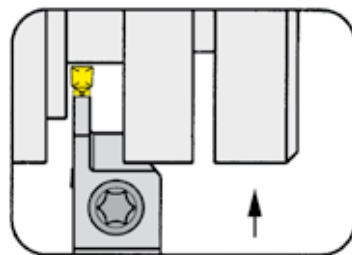
## GROOVING and PARTING OFF



### 刀杆 型号

TOOLHOLDER Type

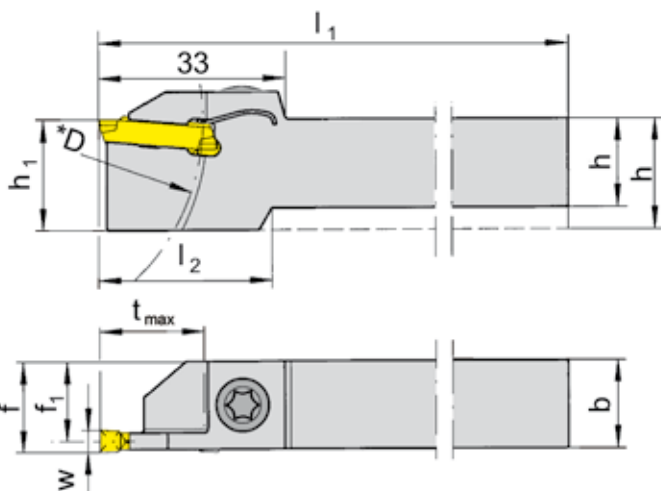
# H224



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.0 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.1212.21	12	12	125	33	20	11.3	f <sub>1</sub> +w/2	18	01	2.0 - 2.4
R/LH224.1616.21	16	16	125	30	20	15.3				
R/LH224.2020.21	20	20	125	-	20	19.3				
R/LH224.2525.21	25	25	150	-	25	24.3				
R/LH224.1212.22	12	12	125	33	20	11.1	f <sub>1</sub> +w/2	18	02	2.4 - 2.8
R/LH224.1616.22	16	16	125	30	20	15.1				
R/LH224.2020.22	20	20	125	-	20	19.1				
R/LH224.2525.22	25	25	150	-	25	24.1				
R/LH224.1212.23	12	12	125	33	20	10.9	f <sub>1</sub> +w/2	18	03	2.8 - 3.7
LH224.1608.23	16	8	100	-	20	6.9				
R/LH224.1616.23	16	16	125	30	20	14.9				
R/LH224.2020.23	20	20	125	-	20	18.9				
R/LH224.2525.23	25	25	150	-	25	23.9				

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm

\*t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....21/22/23 LH224.1608.23	6.23T25P 4.15T15P	T25PQ T15PQ

# 切槽和切断

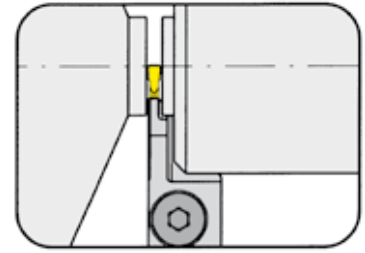
## GROOVING and PARTING OFF



### 刀杆 型号

TOOLHOLDER Type

# H224



槽深可达  
夹持范围

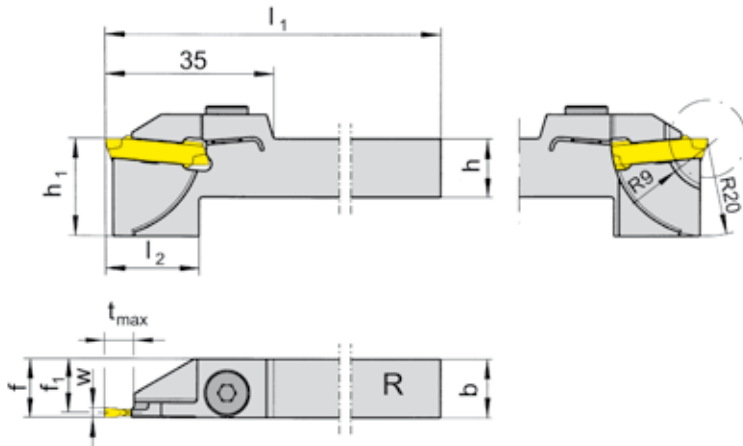
Depth of groove up to  
Clamping range

8.2 mm  
2.0 - 2.4 mm

用于TRAUB ( TNL12/7 ) 机床  
for machines TRAUB (TNL12/7)

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图

R = right hand version shown

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
<b>RH224.1212.81</b>	12	12	95	19.5	20	11.1	f <sub>1</sub> +w/2	8.2	01	2.0 - 2.4

按需提供更多尺寸  
Further sizes upon request

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RH224.1212.81	<b>6.17T25</b>	<b>T25PQ</b>

E

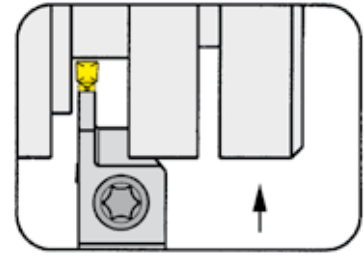
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# H224

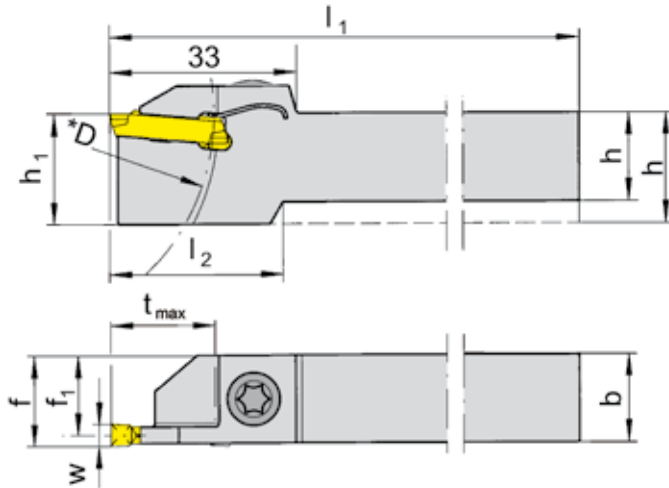


槽深可达 18.0 mm  
夹持范围 3.7 - 6.1 mm

Depth of groove up to 18.0 mm  
Clamping range 3.7 - 6.1 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
LH224.1608.24	16	8	100	-	16	6.55				
R/LH224.1616.24	16	16	125	30	20	14.55	f <sub>1</sub> +w/2	18	04	3.7 - 4.4
R/LH224.2020.24	20	20	125	-	20	18.55				
R/LH224.2525.24	25	25	150	-	25	23.55				
R/LH224.1616.25	16	16	125	30	20	14.15	f <sub>1</sub> +w/2	18	05	4.4 - 5.1
R/LH224.2020.25	20	20	125	-	20	18.15				
R/LH224.2525.25	25	25	150	-	25	23.15				
R/LH224.1616.26	16	16	125	30	20	13.75	f <sub>1</sub> +w/2	18	06	5.1 - 6.1
R/LH224.2020.26	20	20	125	-	20	17.75				
R/LH224.2525.26	25	25	150	-	25	22.75				

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

\*t<sub>max</sub> 取决于D = 80mm  
\*t<sub>max</sub> up to D = 80 mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LH224.1608.24 R/LH224.....24/25/26	4.15T15P 6.23T25P	T15PQ T25PQ

# 切槽和侧车削 (外圆)

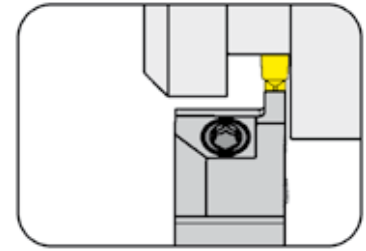
## GROOVING and SIDE TURNING (external)



刀杆型号  
TOOLHOLDER Type

# H224

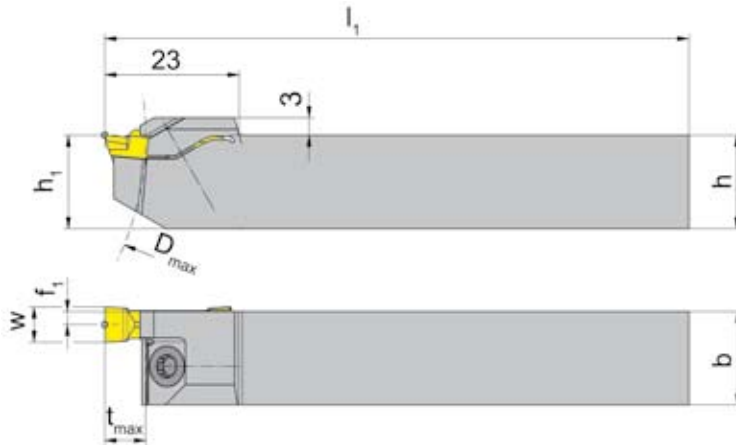
螺钉锁紧  
with screwed clamping



槽深可达	Depth of groove up to	7.0 mm
夹持范围	Clamping range	2.0 - 4.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1212.61	12	12		12					
R/LH224.1616.61	16	16	100	16	0.70	7	100	01	2.0 - 2.4
R/LH224.2020.61	20	20		20					
R/LH224.1212.62	12	12		12					
R/LH224.1616.62	16	16	100	16	0.90	7	100	02	2.4 - 2.8
R/LH224.2020.62	20	20		20					
R/LH224.1212.63	12	12		12					
R/LH224.1616.63	16	16	100	16	1.10	7	100	03	2.8 - 3.7
R/LH224.2020.63	20	20		20					
R/LH224.1212.64	12	12		12					
R/LH224.1616.64	16	16	100	16	1.45	7	100	04	3.7 - 4.4
R/LH224.2020.64	20	20		20					

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	4.12T15EP	T15PQ

# 切槽和侧车削 ( 外圆 )

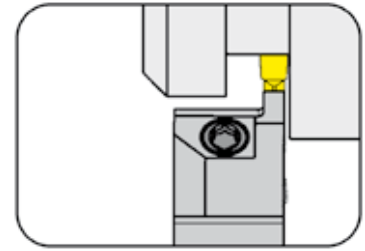
## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

# H224

螺钉锁紧  
with screwed clamping

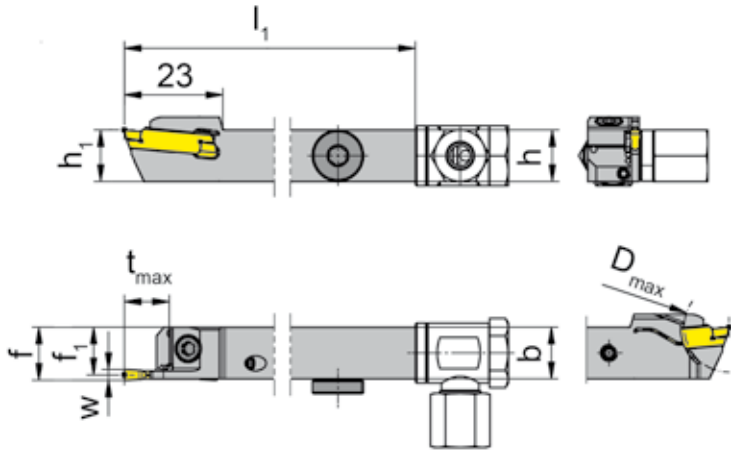


槽深可达 7.0 mm  
夹持范围 2.0 - 3.7 mm

Depth of groove up to 7.0 mm  
Clamping range 2.0 - 3.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	h	b	$l_1$	$h_1$	f	$f_1$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1212.61.IK R/LH224.1616.61.IK R/LH224.2020.61.IK	12 16 20	12 16 20	100	12 16 20	$f_1+w/2$	0.7	7	100	01	2.0 - 2.4
R/LH224.1212.62.IK R/LH224.1616.62.IK R/LH224.2020.62.IK	12 16 20	12 16 20	100	12 16 20	$f_1+w/2$	0.9	7	100	02	2.4 - 2.8
R/LH224.1212.63.IK R/LH224.1616.63.IK R/LH224.2020.63.IK	12 16 20	12 16 20	100	12 16 20	$f_1+w/2$	1.1	7	100	03	2.8 - 3.7

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH224....	4.12T15EP	T15PQ	004.00.61

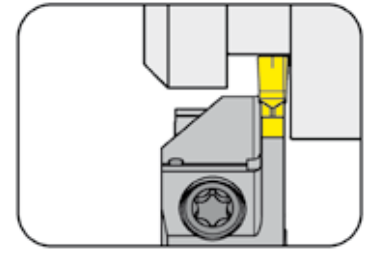
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

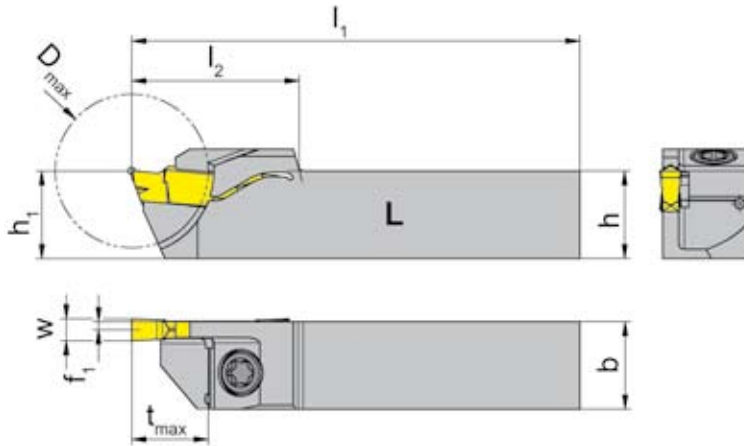
# H224



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

10.5 mm  
2.0 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$l_2$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1212.20.61	12	12	100	12	0.7	23	10.5	21	01	2.0 - 2.4
R/LH224.1212.20.62	12	12	100	12	0.9	23	10.5	21	02	2.4 - 2.8
R/LH224.1212.20.63	12	12	100	12	1.1	23	10.5	21	03	2.8 - 3.7

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.1212.20.6...	4.12T15EP	T15PQ

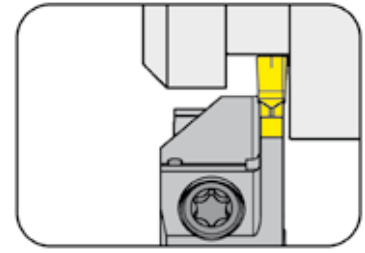
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

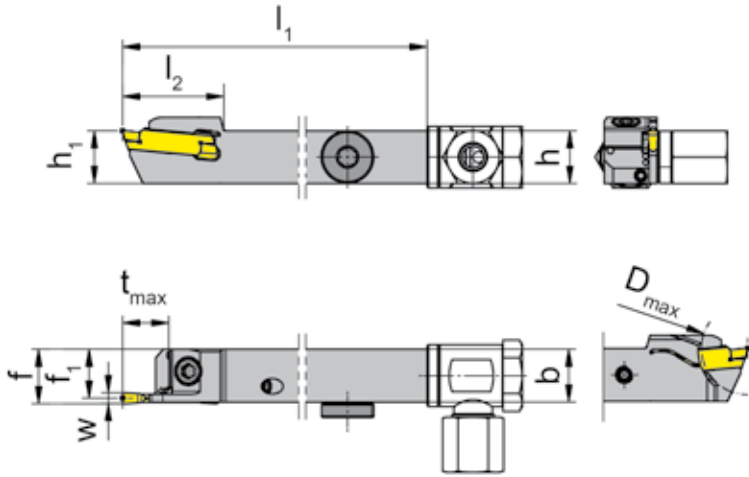
# H224



槽深可达	Depth of groove up to	10.5 mm
夹持范围	Clamping range	2.0 - 3.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.1212.20.61.IK	12	12	100	12	f <sub>1</sub> +w/2	0.7	23	10.5	21	01	2.0 - 2.4
R/LH224.1212.20.62.IK	12	12	100	12	f <sub>1</sub> +w/2	0.9	23	10.5	21	02	2.4 - 2.8
R/LH224.1212.20.63.IK	12	12	100	12	f <sub>1</sub> +w/2	1.1	23	10.5	21	03	2.8 - 3.7

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH224.1212.20.6...	4.12T15EP	T15PQ	004.00.61



# 切槽和侧车削 ( 外圆 )

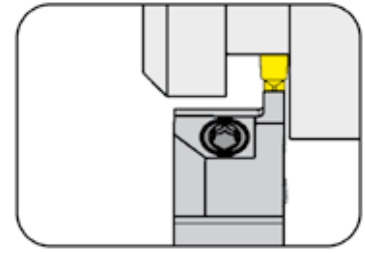
## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

# H224

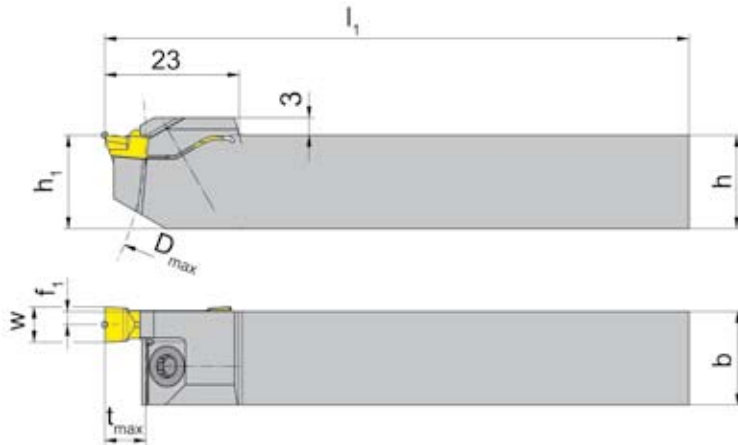
螺钉锁紧  
with screwed clamping



槽深可达	Depth of groove up to	7.0 mm
夹持范围	Clamping range	4.4 - 6.1 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1616.65	16	16	100	16	1.85	7	100	05	4.4 - 5.1
R/LH224.2020.65	20	20	100	20	1.85	7	100	05	4.4 - 5.1
R/LH224.1616.66	16	16	100	16	2.25	7	100	06	5.1 - 6.1
R/LH224.2020.66	20	20	100	20	2.25	7	100	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	5.13T20EP	T20PQ

E

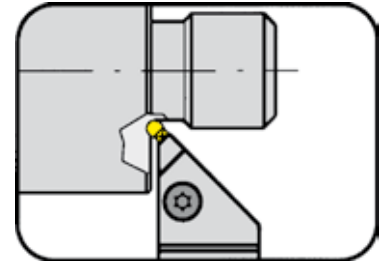
# 切退刀槽 ( 外圆 )

## GROOVING CORNER RELIEFS (external)



刀杆 型号  
TOOLHOLDER Type

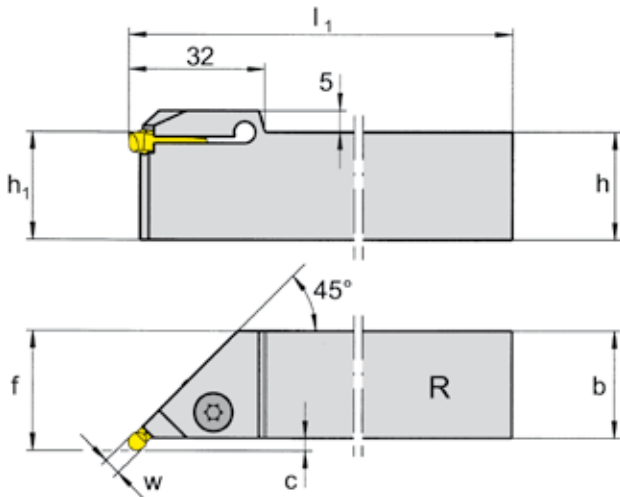
# H224



槽宽	Width of groove	2.0 - 6.1 mm
----	-----------------	--------------

配合 可转位刀片  
for use with Indexable insert

型号 S224...K  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅适用于圆头刀片  
S224...K  
only for full radius inserts S224...K

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	c	w	w	规格 Size	槽宽 Width of groove
R/LH224.4520.02	20	20	125	20	23.0	2.5	2.0	2.8	02	2.0 - 2.8
R/LH224.4525.02	25	25	150	25	28.0	2.5	2.0	2.8	02	2.0 - 2.8
R/LH224.4520.04	20	20	125	20	23.0	2.5	2.8	4.4	04	2.8 - 4.4
R/LH224.4525.04	25	25	150	25	28.0	2.5	2.8	4.4	04	2.8 - 4.4
R/LH224.4520.06	20	20	125	20	23.5	3.0	4.4	6.1	06	4.4 - 6.1
R/LH224.4525.06	25	25	150	25	28.5	3.0	4.4	6.1	06	4.4 - 6.1

注明R或L型  
State R or L version

w和D<sub>min</sub> 见可转位刀片  
w and D<sub>min</sub> see indexable inserts

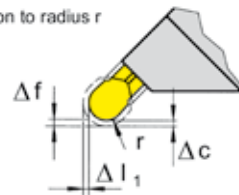
尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

半径r的相关修正因素Δl<sub>1</sub>、Δc和Δf  
Revision factor Δl<sub>1</sub>, Δc and Δf in relation to radius r

r	Δl <sub>1</sub>	Δc	Δf
3,0	0	0	0
2,5	-0,146	-0,146	-0,146
2,0	0	0	0
1,5	-0,146	-0,146	-0,146
1,0	0	0	0



附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.452...	6.23T25P	T25PQ

# 切槽和切断

## GROOVING and PARTING OFF

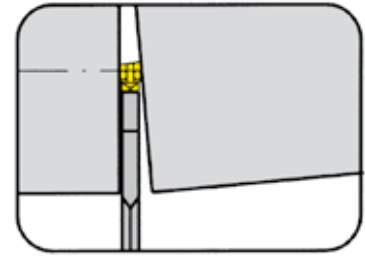


### 刀杆 型号

TOOLHOLDER Type

## H224

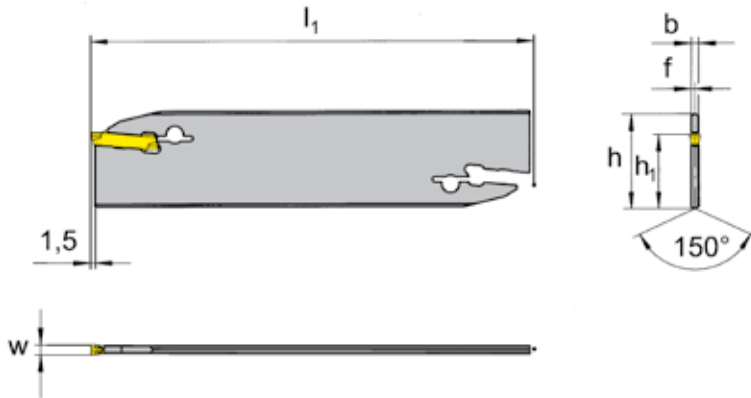
自锁紧  
with self clamping



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.4 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

E

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
H224-2602-02	26	1.9	110	21.4	0.95	18	02	2.4 - 2.8
H224-2603-03	26	2.3	110	21.4	1.15	18	03	2.8 - 3.7
H224-3203-03	32	2.3	150	24.8	1.15	18	03	2.8 - 3.7

按需提供更多尺寸  
Further sizes upon request

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

#### 注意事项：

扳手P39L不包含在刀板中，需单独订购！

#### Note:

Wrench P39L ist not combined with blade - separate order required!



#### 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
H224....	P39L

# 切槽和切断

## GROOVING and PARTING OFF

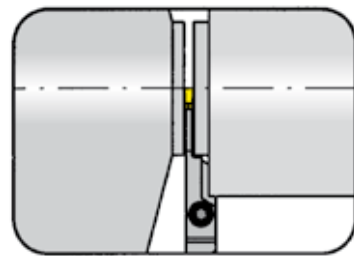


### 刀杆 型号

TOOLHOLDER Type

## H224

加强型  
reinforced version



槽深可达  
夹持范围

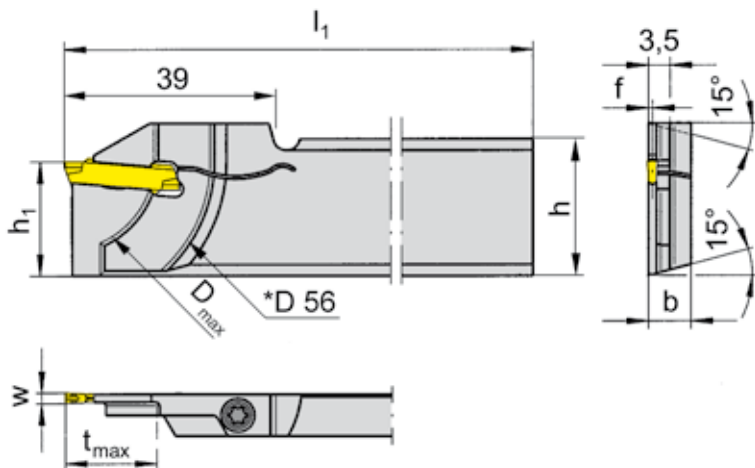
Depth of groove up to  
Clamping range

18.0 mm  
2.4 - 3.7 mm

用于TRAUB ( TNK28/TNK36/TNL26 ) 机床  
for machines TRAUB (TNK28/TNK36/TNL26)

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.2608.81	26	7.9	110	21.4	0.75	18	36	01	2.0 - 2.4
R/LH224.2608.82	26	7.9	110	21.4	0.95	18	36	02	2.4 - 2.8
R/LH224.2608.83	26	7.9	110	21.4	1.10	18	36	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

\*副主轴D<sub>max</sub>=D56

\*D 56 = D<sub>max</sub> of the subspindle

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.2608.8...	4.15T15P	T15PL

# 切槽和切断

## GROOVING and PARTING OFF

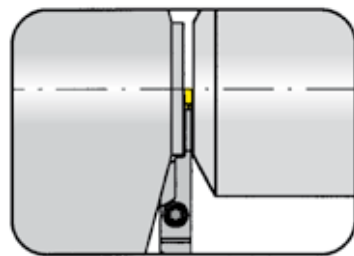


### 刀杆 型号

TOOLHOLDER Type

## H224

加强型  
reinforced version



槽深可达  
夹持范围

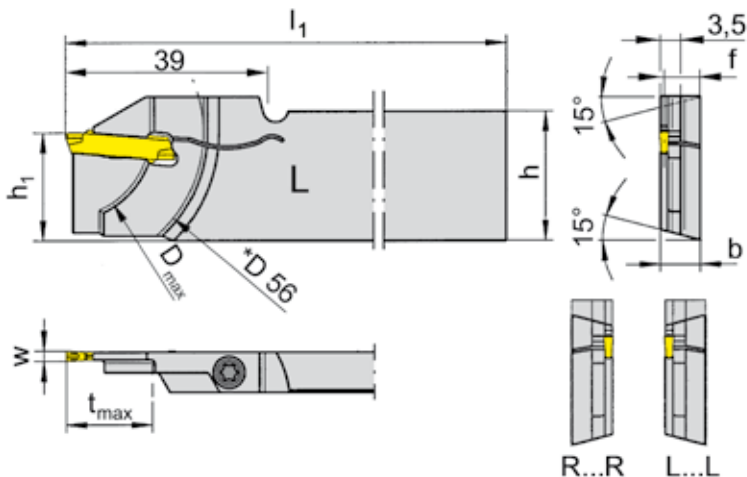
Depth of groove up to  
Clamping range

21.0 mm  
2.0 - 3.7 mm

用于TRAUB ( TNK28/TNK36/TNL26 ) 机床  
for machines TRAUB (TNK28/TNK36/TNL26)

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



L=左手型

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.2608.81R/L	26	7.9	110	21.4	7.15	18	36	01	2.0 - 2.4
R/LH224.2608.82R/L	26	7.9	110	21.4	6.95	18	36	02	2.4 - 2.8
R/LH224.2608.83R/L	26	7.9	110	21.4	6.75	18	36	03	2.8 - 3.7
RH224.3208.83R	32	7.9	110	24.8	6.80	21	42	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

\*副主轴D<sub>max</sub>=D56

\*D 56 = D<sub>max</sub> of the subspindle

\* 用于副主轴的特殊夹持装置(例如:HAINBUCH Axfixchuck)

\* For specific clamping device on subspindle  
(e.g. HAINBUCH Axfixchuck)

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.2608.81R/L/82R/L/83R/L RH224.3208.83R	4.15T15P 5.13T20P	T15PL T20PQ

# 切槽和切断

## GROOVING and PARTING OFF

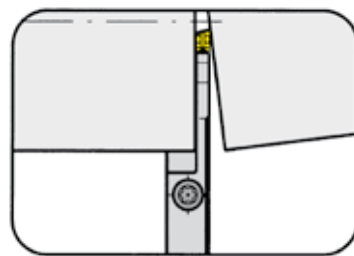


### 刀杆 型号

TOOLHOLDER Type

## H224

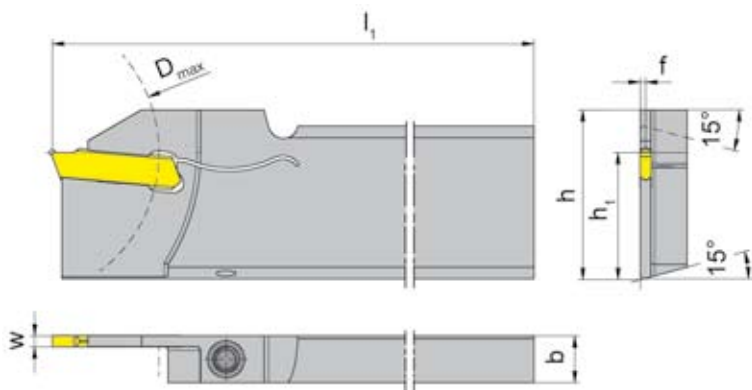
加强型  
reinforced version



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.0 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

E

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.2608.01 R/LH224.3208.01	26 32	7.9	110	21.4 24.8	0.7	18	50	01	2.0 - 2.4
R/LH224.2608.02 R/LH224.3208.02	26 32	7.9	110	21.4 24.8	0.9	18	50	02	2.4 - 2.8
R/LH224.2608.03 R/LH224.3208.03	26 32	7.9	110	21.4 24.8	1.1	18	50	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

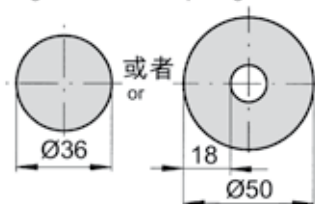
按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

实心棒料切断      空心棒料切断  
parting off solid bars      parting off tubes



### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	4.20T15P	T15PL

# 切槽和切断

## GROOVING and PARTING OFF

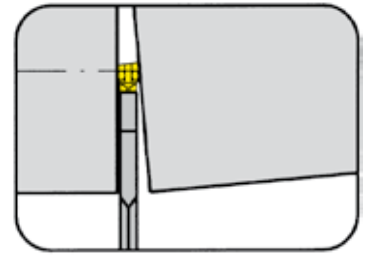


### 刀杆 型号

TOOLHOLDER Type

## H224

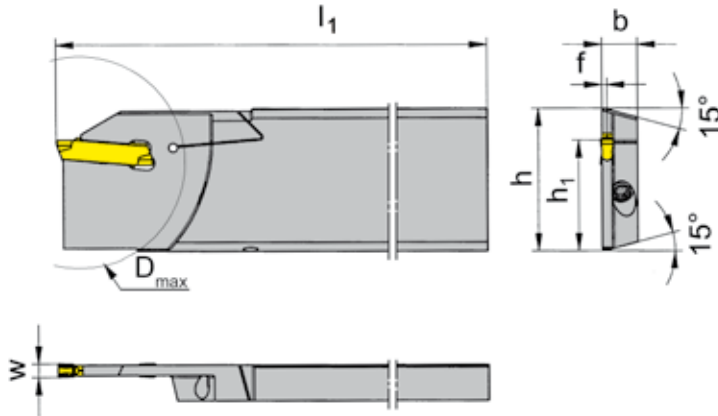
螺钉锁紧  
with screwed clamping



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

E

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.3208.93	32	8	112	24.8	1.15	18	50	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	销 Pin
R/LH224.3208.93	030.0413.T15P	T15PQ	020.0040.0999

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

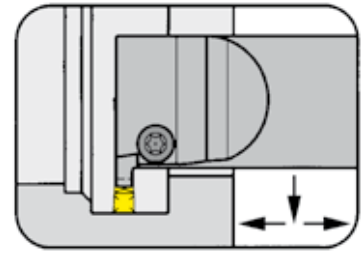


### 刀杆型号

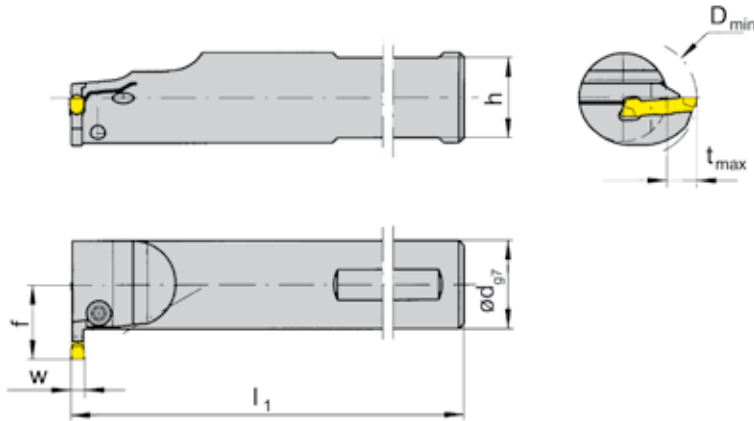
TOOLHOLDER Type

## B224

短悬伸  
Short style



孔径Ø 自	Bore Ø from	30.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	2.0 - 6.1 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

E

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB224.0020.0.01 R/LB224.0025.0.01	20 25	130	18 23	18.5 21.0	30 35	8	01	2.0 - 2.4
R/LB224.0020.0.02 R/LB224.0025.0.02	20 25	130	18 23	18.5 21.0	30 35	8	02	2.4 - 2.8
R/LB224.0020.0.03 R/LB224.0025.0.03 R/LB224.0032.0.03	20 25 32	130 130 150	18 23 30	18.5 21.0 24.5	30 35 42	8	03	2.8 - 3.7
R/LB224.0020.0.04 R/LB224.0025.0.04 R/LB224.0032.0.04	20 25 32	130 130 150	18 23 30	18.5 21.0 24.5	30 35 42	8	04	3.7 - 4.4
R/LB224.0020.0.05 R/LB224.0025.0.05 R/LB224.0032.0.05	20 25 32	130 130 150	18 23 30	18.5 21.0 24.5	30 35 42	8	05	4.4 - 5.1
R/LB224.0025.0.06 R/LB224.0032.0.06	25 32	130 150	23 30	21.0 24.5	35 42	8	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	5.13T20EP	T20PQ



# 切槽和侧车削 (内圆)

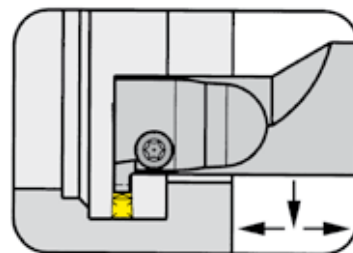
## GROOVING and SIDE TURNING (internal)



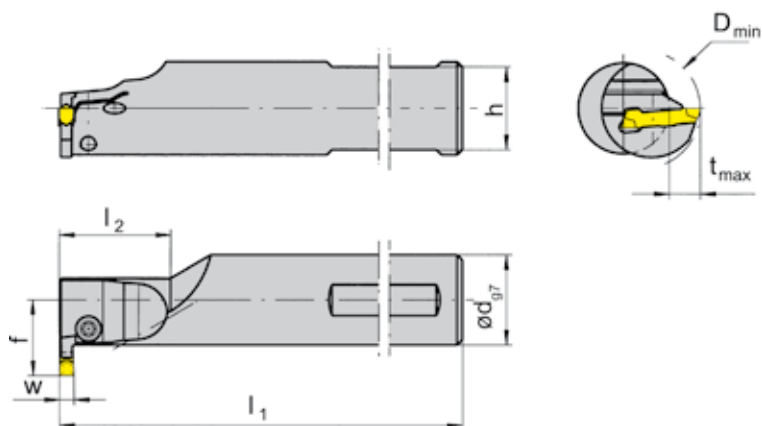
### 刀杆型号

TOOLHOLDER Type

# B224



孔径Ø 自	Bore Ø from	28.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	2.0 - 6.1 mm



配合可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB224.0020.1.01 R/LB224.0025.1.01	20 25	130	30	18 23	18.5 21.0	28	8	01	2.0 - 2.4
R/LB224.0020.1.02 R/LB224.0025.1.02	20 25	130	30	18 23	18.5 21.0	28	8	02	2.4 - 2.8
R/LB224.0020.1.03 R/LB224.0025.1.03 R/LB224.0032.1.03	20 25 32	130 130 150	30	18 23 30	18.5 21.0 24.5	28	8	03	2.8 - 3.7
R/LB224.0020.1.04 R/LB224.0025.1.04 R/LB224.0032.1.04	20 25 32	130 130 150	30	18 23 30	18.5 21.0 24.5	28	8	04	3.7 - 4.4
R/LB224.0025.1.05 R/LB224.0032.1.05	25 32	130 150	30	23 30	21.0 24.5	28	8	05	4.4 - 5.1
R/LB224.0025.1.06 R/LB224.0032.1.06	25 32	130 150	30	23 30	21.0 24.5	28	8	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	5.13T20EP	T20PQ

# 切槽和侧车削 (内圆)

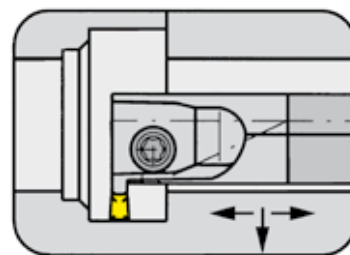
## GROOVING and SIDE TURNING (internal)



### 刀杆型号

TOOLHOLDER Type

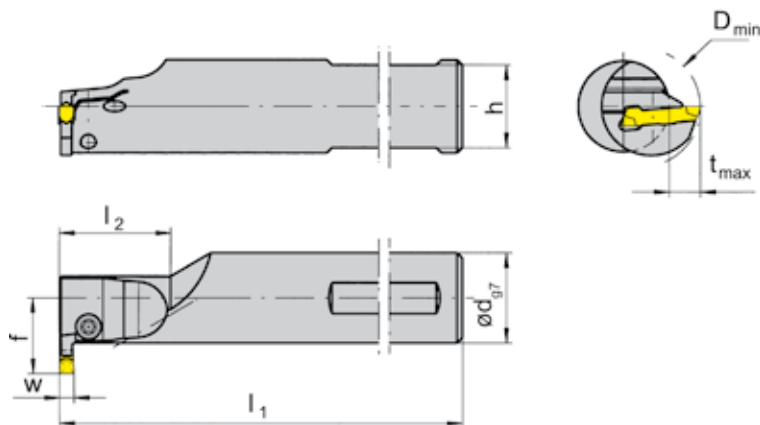
# B224



孔径Ø 自	Bore Ø from	32.0 mm
槽深可达	Depth of groove up to	13.0 mm
夹持范围	Clamping range	2.8 - 6.1 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB224.0025.1.13	25	130	30	23	23.5	32	10	03	2.8 - 3.7
R/LB224.0032.1.13	32	150	30	30	28.0	32	11	03	2.8 - 3.7
R/LB224.0025.1.14	25	130	30	23	23.5	32	10	04	3.7 - 4.4
R/LB224.0032.1.14	32	150	30	30	28.0	32	11	04	3.7 - 4.4
R/LB224.0032.1.15	32	150	30	30	28.0	32	11	05	4.4 - 5.1
R/LB224.0040.1.25	40	180	30	38	34.0	38	13	05	4.4 - 5.1
R/LB224.0032.1.16	32	150	30	30	28.0	32	11	06	5.1 - 6.1
R/LB224.0040.1.26	40	180	30	38	34.0	38	13	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	5.13T20EP	T20PQ

# 切槽和侧车削 (内圆)

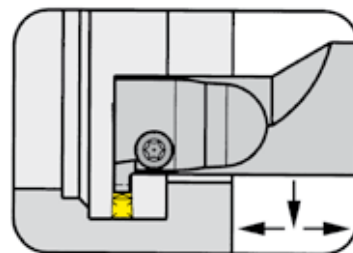
## GROOVING and SIDE TURNING (internal)



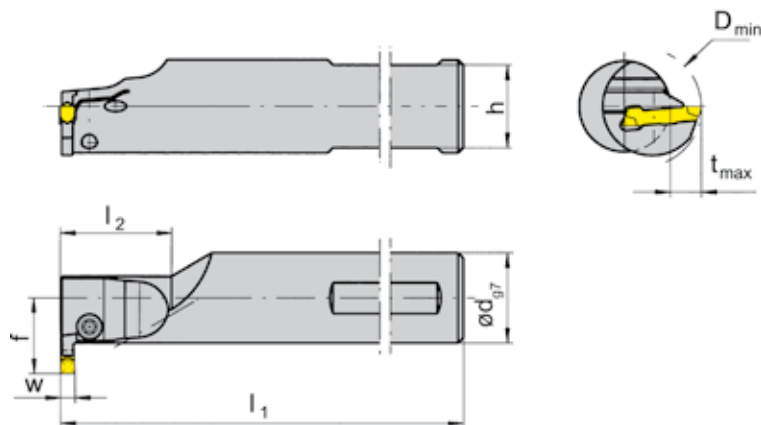
### 刀杆型号

# B224

TOOLHOLDER Type



孔径Ø 自	Bore Ø from	28.0 mm
槽深可达	Depth of groove up to	11.0 mm
夹持范围	Clamping range	2.0 - 4.4 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LB224.0020.2.01	20	130	45	18	18.5	28	8	01	2.0 - 2.4
R/LB224.0025.2.01	25	150	50	23	21.0	28	8	01	2.0 - 2.4
R/LB224.0020.2.02	20	130	45	18	18.5	28	8	02	2.4 - 2.8
R/LB224.0025.2.02	25	150	50	23	21.0	28	8	02	2.4 - 2.8
R/LB224.0025.2.03	25	150		23	21.0	28	8		
R/LB224.0032.2.03	32	180	50	30	24.5	28	8	03	2.8 - 3.7
R/LB224.0032.2.13	32	180		30	28.0	32	11		
R/LB224.0025.2.04	25	150		23	21.0	28	8		
R/LB224.0032.2.04	32	180	50	30	24.5	28	8	04	3.7 - 4.4
R/LB224.0032.2.14	32	180		30	28.0	32	11		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	5.13T20EP	T20PQ

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

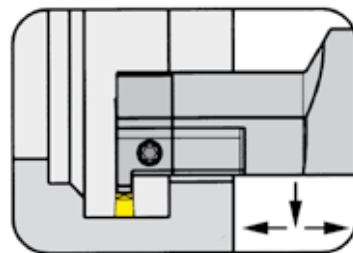


### 常规刀杆 型号

BASIC TOOLHOLDER Type

## B224

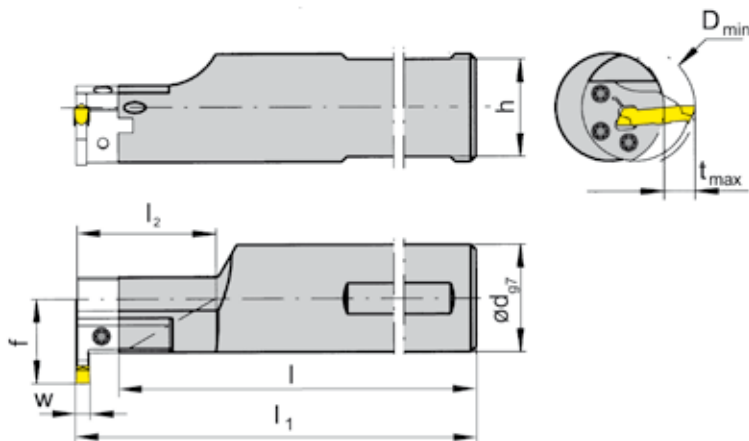
无刀夹  
without cassette



孔径Ø 自	Bore Ø from	40.0 mm
槽深可达	Depth of groove up to	11.0 mm
夹持范围	Clamping range	2.0 - 6.1 mm

配合刀夹  
for use with Cassette

型号 BK224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	h	f
R/LB224.0032.1.K2	32	136.3	l+b <sub>1</sub> +w/2	30	30	28
R/LB224.0032.2.K2		166.3		60		
R/LB224.0040.1.K2	40	166.3	l+b <sub>1</sub> +w/2	30	38	32
R/LB224.0040.2.K2		186.3		60		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

#### 注意事项:

D<sub>min</sub>, t<sub>max</sub>, w和 b<sub>1</sub>尺寸, 见刀夹

#### Note:

Dimensions for D<sub>min</sub>, t<sub>max</sub> and b<sub>1</sub> see cassettes

#### 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	030.0518.T20P	T20PQ

# 切槽和侧车削 (内圆)

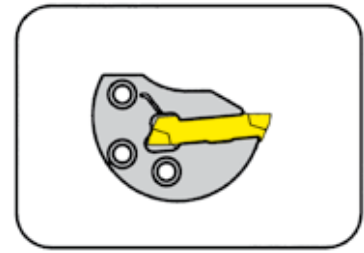
## GROOVING and SIDE TURNING (internal)



### 刀夹 型号

CASSETTE Type

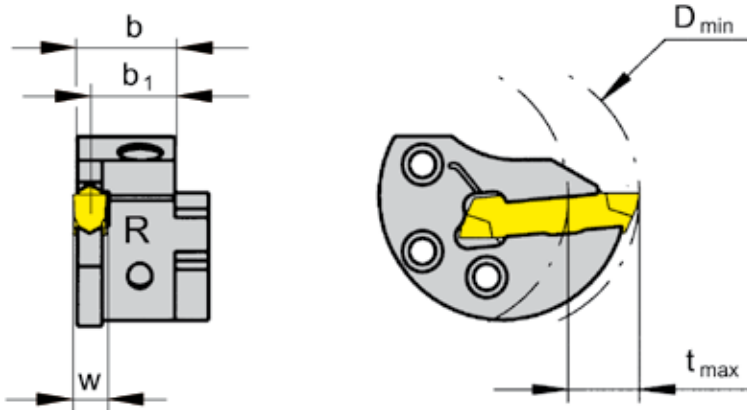
# BK224



孔径Ø 自	Bore Ø from	40.0 mm
槽深可达	Depth of groove up to	11.0 mm
夹持范围	Clamping range	2.0 - 6.1 mm

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	b <sub>1</sub>	b	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LBK224.0040.01	12.70	13.40	40	11	01	2.0 - 2.4
R/LBK224.0040.02	12.45	13.35	40	11	02	2.4 - 2.8
R/LBK224.0040.03	12.20	13.30	40	11	03	2.8 - 3.7
R/LBK224.0040.04	11.70	13.15	40	11	04	3.7 - 4.4
R/LBK224.0040.05	11.20	13.05	40	11	05	4.4 - 5.1
R/LBK224.0040.06	10.70	12.95	40	11	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

右手型刀夹配合右手型常规刀杆,左手型刀夹配合左手型常规刀杆  
Use right hand cassettes in right hand basic toolholders and left hand cassettes in left hand basic toolholders.

#### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

#### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

#### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LBK224.0040.0...	5.13T20EP	T20PQ

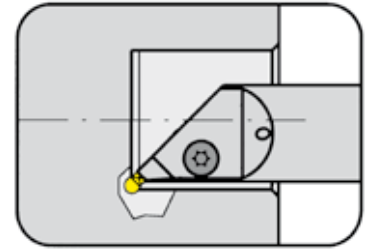
# 切退刀槽 (内圆)

## GROOVING CORNER RELIEFS (internal)



刀杆型号  
TOOLHOLDER Type

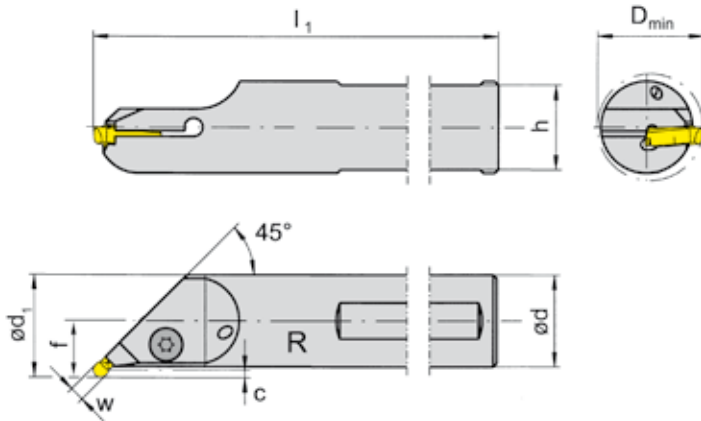
# B224



槽宽	Width of groove	2.0 - 6.1 mm
----	-----------------	--------------

配合 可转位刀片  
for use with Indexable insert

型号 S224...K  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅适用于圆头刀片  
S224...K  
only for full radius inserts S224...K

产品型号 Part number	d	h	l <sub>1</sub>	f	d <sub>1</sub>	c	D <sub>min</sub>	槽宽 Width of groove
R/LB224.4520.0.02	20	18	130	13.0	23.0	2.5	25.0	2.0 - 2.8
R/LB224.4525.0.02	25	23	150	15.5	28.0		29.0	
R/LB224.4532.0.02	32	30	150	19.0	35.0		36.0	
R/LB224.4540.1.02	40	38	200	23.0	43.0		44.0	
R/LB224.4520.0.04	20	18	130	13.0	23.0	2.5	25.0	> 2.8 - 4.4
R/LB224.4525.0.04	25	23	150	15.5	28.0		29.0	
R/LB224.4532.0.04	32	30	150	19.0	35.0		36.0	
R/LB224.4540.1.04	40	38	200	23.0	43.0		44.0	
R/LB224.4520.0.06	20	18	130	13.5	23.5	3.0	25.0	> 4.4 - 6.1
R/LB224.4525.0.06	25	23	150	16.0	28.5		29.5	
R/LB224.4532.0.06	32	30	150	19.0	35.5		36.5	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

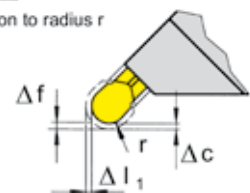
尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

半径r的相关修正因素  $\Delta l_1$ ,  $\Delta c$  和  $\Delta f$   
Revision factor  $\Delta l_1$ ,  $\Delta c$  and  $\Delta f$  in relation to radius r

r	$\Delta l_1$	$\Delta c$	$\Delta f$
3,0	0	0	0
2,5	-0,146	-0,146	-0,146
2,0	0	0	0
1,5	-0,146	-0,146	-0,146
1,0	0	0	0



附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.45...	6.14T25P	T25PQ

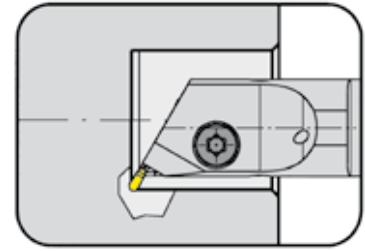
# 切退刀槽 (内圆)

## GROOVING CORNER RELIEFS (internal)



刀杆型号  
TOOLHOLDER Type

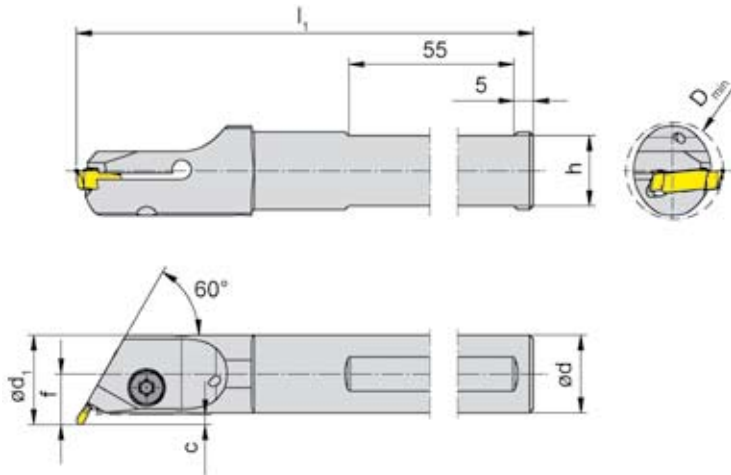
# B224



槽宽	Width of groove	2.0 - 6.1 mm
----	-----------------	--------------

配合 可转位刀片  
for use with Indexable insert

型号 S224...K  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅适用于圆头刀片  
S224...K  
only for full radius inserts S224...K

产品型号 Part number	d	h	l <sub>1</sub>	f	d <sub>1</sub>	c	D <sub>min</sub>	槽宽 Width of groove
R/LB224.6020.0.02	20	18	150	13.0	23.0	2.5	25.0	2.0 - 2.8
R/LB224.6025.0.02	25	23		15.5	28.0		29.0	
R/LB224.6032.0.02	32	30		19.0	35.0		36.0	
R/LB224.6020.0.04	20	18	150	13.0	23.0	2.5	25.0	> 2.8 - 4.4
R/LB224.6025.0.04	25	23		15.5	28.0		29.0	
R/LB224.6032.0.04	32	30		19.0	35.0		36.0	
R/LB224.6020.0.06	20	18	150	13.5	23.5	3.0	25.0	> 4.4 - 6.1
R/LB224.6025.0.06	25	23		16.0	28.5		29.5	
R/LB224.6032.0.06	32	30		19.5	35.5		36.5	

注明R或L型  
State R or L version

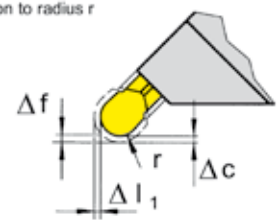
尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

半径r的相关修正因素  $\Delta l_1$ ,  $\Delta c$  和  $\Delta f$   
Revision factor  $\Delta l_1$ ,  $\Delta c$  and  $\Delta f$  in relation to radius r

r	$\Delta l_1$	$\Delta c$	$\Delta f$
3,0	0	0	0
2,5	-0,25	-0,067	-0,067
2,0	0	0	0
1,5	-0,25	-0,067	-0,067
1,0	0	0	0



附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.60...	6.14T25P	T25PQ

可转位刀片 型号  
INDEXABLE INSERT type

### S224...3.

精密烧结  
precision sintered



## 断屑槽 Geometry .3.

适用于所有材料有切屑成型的断屑槽。  
Geometry with chip forming for all materials.

### 特点 Characteristics

- 出色的切屑控制
- 适用于高强度的高合金钢
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 出色的切屑控制保证了生产的安全性

- excellent swarf control
- suitable for high alloy- high strength steels
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

### 应用 Applications

- 切槽:  
槽深 可达 18 mm
- 侧车削:  
切深  $a_p$  可达 3 mm\*

- Grooving:  
Depth of groove up to 18 mm
- Side turning:  
Depth of cut  $a_p$  up to 3 mm\*

### 进给率 $f$ Feed rate $f$

- 切槽: 0.15 可达 0.25 mm/转\*
- 侧车削: 可达 0.4 mm/转\*

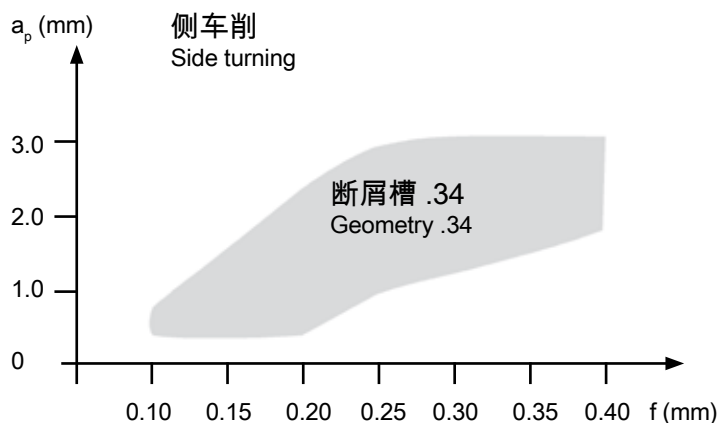
- Grooving: 0.15 up to 0.25 mm/rev\*
- Side turning: up to 0.4 mm/rev\*



\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request. Indexable inserts can be used in **right and left hand** toolholders.



229.0500.34加工16MnCr5时切屑控制图表

Chip control graph S224.0500.34 material 16MnCr5



# 切槽和侧车削

## GROOVING and SIDE TURNING

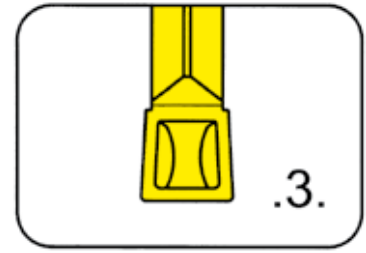


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

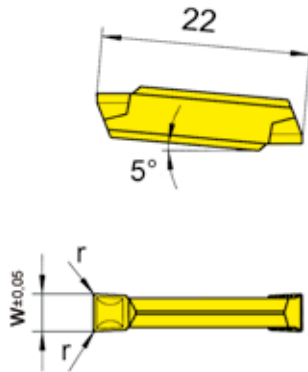
带断屑槽  
with chip former



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	3.0 - 6.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 B224  
Type BK224  
H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	W	r	规格 Size	TN32	TN35	TI22	TI25	TF45	AS62	AS66
S224.0300.32	3	0.2	03	▲	▲	▲	▲	▲	▲	▲
S224.0300.34		0.4		▲	▲	△	▲	▲	▲	▲
S224.0400.32	4	0.2	04	▲	▲	△	▲	▲	▲	▲
S224.0400.34		0.4		▲	▲	△	▲	▲	▲	▲
S224.0500.34	5	0.4	05	▲	▲	▲	▲	▲	▲	▲
S224.0500.38		0.8		▲	▲	▲	▲	▲	▲	▲
S224.0600.34	6	0.4	06	▲	▲	▲	▲	▲	▲	▲
S224.0600.38		0.8		▲	▲	▲	▲	▲	▲	▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	●	●	●	●	●	●
● 主要应用 / main recommendation				M	●	●	●	●	●	○
○ 可选推荐 / alternative recommendation				K	●	●	●	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●	●	●	○
■ 钎焊/金属陶瓷 / brazed/Cermet				H						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades



可转位刀片 型号  
INDEXABLE INSERT type

## S224...5.

精密烧结  
precision sintered



## 断屑槽 Geometry .5.

适用于中等强度材料的易切削断屑槽。  
Easy cutting geometry for materials with medium strength.

### 特点 Characteristics

- 在很宽的进给范围内都可形成很好的切屑
- 易切削-低功率要求
- 减小切屑宽度并保证侧面良好的表面粗糙度
- 良好的切屑控制保证了生产的安全性

- excellent swarf on a wide feed range
- easy cutting - low power requirement
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

### 应用 Applications

- 切槽:  
槽深 可达 18 mm
- 侧车削:  
切深  $a_p$  可达 3 mm\*
- Grooving:  
Depth of groove up to 18 mm
- Side turning:  
Depth of cut  $a_p$  up to 3 mm\*

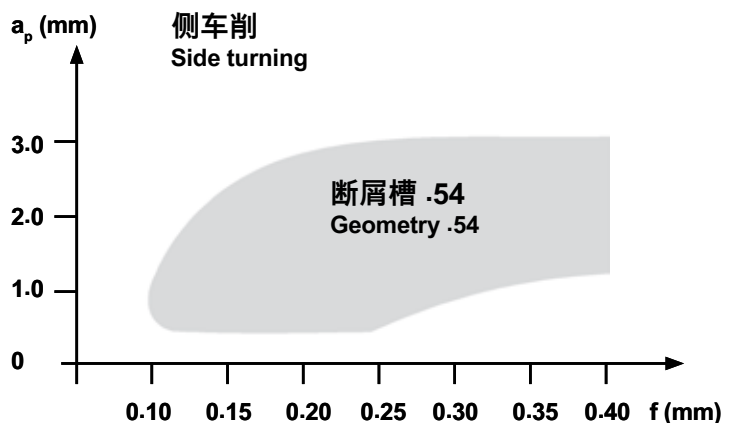
### 进给率 f Feed rate f

- 切槽: 可达 0.45 mm/转\*
- 侧车削: 可达 0.6 mm/转\*
- Grooving: up to 0.45 mm/rev\*
- Side turning: up to 0.6 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in right and left hand toolholders.



229-0500-54加工16MnCr5时切屑控制图表

Chip control graph S224.0500.54 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

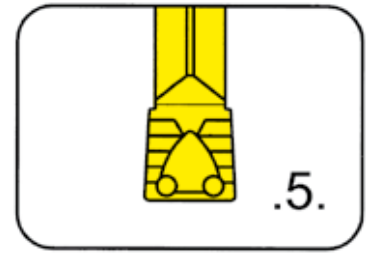


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

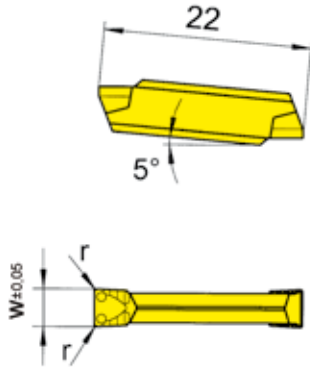
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	2.0 - 6.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 B224  
Type BK224  
H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TN32	TN35	TI22	TI25	TF45	AS62	AS66	AL96
S224.0200.52	2.0	0.2	01						▲	▲	
S224.0250.52	2.5	0.2	02						▲	▲	
S224.0300.52	3.0	0.2	03	▲	▲		▲	▲	▲	▲	
S224.0300.54		0.4									▲
S224.0400.52	4.0	0.2	04	▲	▲		▲	▲	▲	▲	▲
S224.0400.54		0.4									
S224.0500.54	5.0	0.4	05	▲	▲		▲	▲	▲	▲	
S224.0500.58		0.8						▲	▲	▲	▲
S224.0600.54	6.0	0.4	06				▲	▲	▲	▲	
S224.0600.58		0.8				▲					
▲ 库存 / on stock Δ 4周 / 4 weeks				P	●	●	●	●	●	●	●
● 主要应用 / main recommendation				M			●	●	●	○	
○ 可选推荐 / alternative recommendation				K	●		●	●	●	●	●
■ 无涂层牌号 / uncoated grades				N		●	●	●	●	●	●
■ 涂层牌号 / coated grades				S		●	●	●	●	○	
■ 钎焊/金属陶瓷 / brazed/Cermet				H							

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

E

可转位刀片 型号  
INDEXABLE INSERT type

# S224...A.

精密烧结  
precision sintered



## 断屑槽 Geometry .A.

适用于中等强度材料具有优异断屑效果的断屑槽  
Geometry with excellent chip breaking for materials with medium strength

### 特点 Characteristics

- 在很宽的进给范围内都可形成很好的切屑
- 良好的切屑控制，包括切断加工
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 良好的切屑控制保证了生产的安全性

### 应用 Applications

- 切槽：  
槽深 可达 18 mm
- 侧车削：  
切深  $a_p$  可达 2.5 mm\*
- Grooving:  
Depth of groove up to 18 mm
- Side turning:  
Depth of cut  $a_p$  up to 2.5 mm\*



- excellent swarf on a wide feed range
- excellent swarf control, also by partial cutting
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

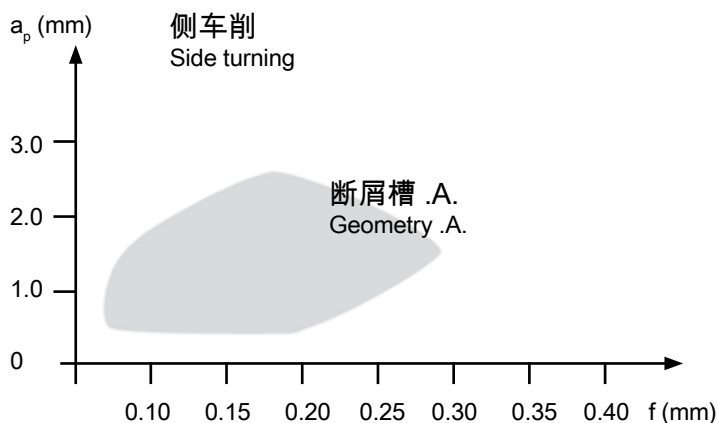
### 进给率 f Feed rate f

- 切槽： 可达 0.3 mm/转\*
- 侧车削： 可达 0.3 mm/转\*
- Grooving: up to 0.3 mm/rev\*
- Side turning: up to 0.3 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.



229.0500.A4加工16MnCr5时切屑控制图表

Chip control graph S224.0500.A4 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

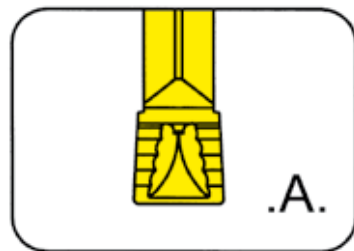


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



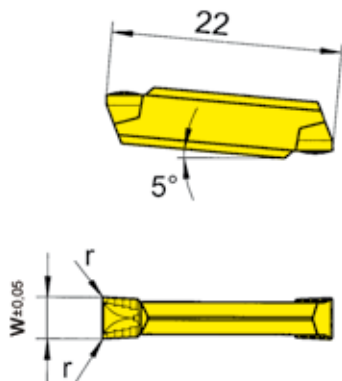
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
3.0 - 6.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TN32	TN35	TI22	TI25	TF45	AS62	AS66
S224.0300.A2	3	0.2	03	▲	▲	▲	▲	▲	▲	
S224.0300.A4		0.4		▲	▲	△	▲	▲	▲	
S224.0400.A2	4	0.2	04	△	▲		▲	▲	▲	
S224.0400.A4		0.4		▲	▲		▲	▲	▲	
S224.0500.A4	5	0.4	05	▲	▲	△	▲	▲	▲	
S224.0500.A8		0.8		▲	▲		▲	▲	▲	
S224.0600.A4	6	0.4	06	▲	▲		▲		△	
S224.0600.A8		0.8		▲	▲			▲		▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	●	●	●	●	●	●
● 主要应用 / main recommendation				M	●	●	●	●	●	●
○ 可选推荐 / alternative recommendation				K	●	●	●	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet				H						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades



可转位刀片 型号  
INDEXABLE INSERT type

# S224...D.

精密烧结  
precision sintered

## 断屑槽 Geometry

.D.

适用于所有材料有切屑成型的断屑槽。  
Easy cutting geometry with chip former.

### 特点 Characteristics

- 主要用于内圆切槽
- 非常有效的断屑槽
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 即使低进给率下也有良好的切屑控制

- mainly used for internal grooving
- very positive geometry
- reduced swarf width gives high flank surface finish
- reduced swarf even at low feedrate

### 应用 Applications

- 割槽:  
槽深 可达 18 mm
- 侧车削:  
切深  $a_p$  可达 3 mm\*
- Grooving:  
Depth of groove up to 18 mm
- Side turning:  
Depth of cut  $a_p$  up to 3 mm\*

### 进给率 $f$ Feed rate $f$

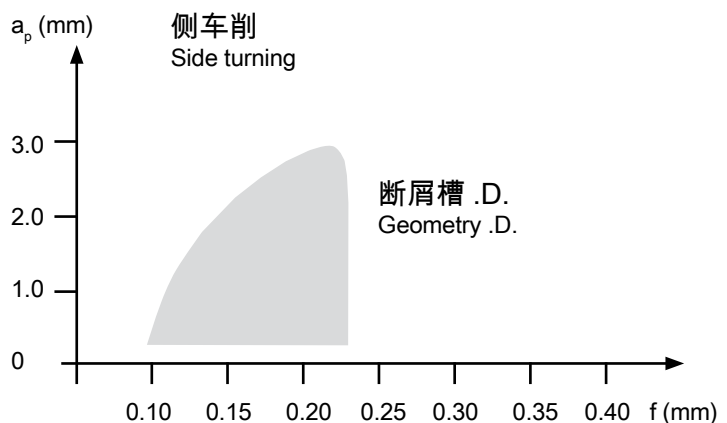
- 割槽: 可达 0.15 mm/转\*
- 侧车削: 可达 0.2 mm/转\*
- Grooving: up to 0.15 mm/rev\*
- Side turning: up to 0.2 mm/rev\*



可根据要求提供可转位仿形刀片，中等尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.

\* 取决于刀片宽度  
\* dependent upon width of insert



229.0500.D2加工16MnCr5时切屑控制图表

Chip control graph S224.0300.D2 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

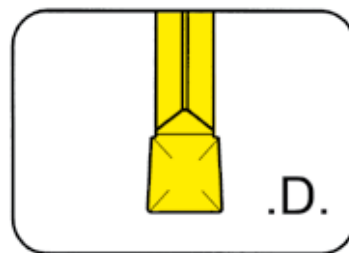


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

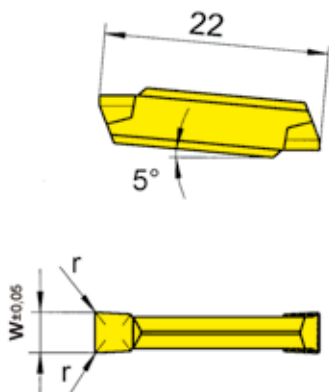
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	2.0 - 4.0 mm

D2精密烧结/\*D2.G精密磨削

D2 precision sintered / \*D2.G precision ground



配合 刀杆  
for use with Toolholder

型号 B224  
Type BK224  
H224

\*刀片长度重复定位精度  
±0.06 mm

\*Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	H54	TN32	TN35	T122	T125	TF45	TF46	AS62	AS66
S224.0200.D2.G S224.0200.D2	2.0	0.2	01	▲	▲	▲	▲	▲	▲	▲		
S224.0250.D2.G S224.0250.D2	2.5	0.2	02		▲	▲	▲	▲	▲	▲		
S224.0300.D2.G S224.0300.D2	3.0	0.2	03	▲	▲	▲	▲	▲	▲	▲		
S224.0400.D2.G S224.0400.D2	4.0	0.2	04		▲	▲	▲	▲	▲	▲		
▲ 库存 / on stock   Δ 4周 / 4 weeks				P	●	●	●	●	●	●		
● 主要应用 / main recommendation				M	●		●	●	●	○		
○ 可选推荐 / alternative recommendation				K			●	●	●	●		
■ 无涂层牌号 / uncoated grades				N			●	●	●	●		
■ 涂层牌号 / coated grades				S			●	●	●	○		
■ 钎焊/金属陶瓷 / brazed/Cermet				H								

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.



可转位刀片 型号

INDEXABLE INSERT type

# S224...C.

精密烧结

precision sintered



## 断屑槽 Geometry

### .C.

切断用断屑槽.

Geometry for parting off.

### 特点

#### Characteristics

- 在推荐的进给范围内都有良好的切屑控制
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 出色的切屑控制保证了生产的安全性

### 应用

#### Applications

- 切槽和切断:  
槽深 可达 18 mm
- Grooving and parting off:  
Depth of groove up to 18 mm

- excellent swarf control on the recommended feed range
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

### 进给率 f Feed rate f

- 切断: 0.02 可达 0.1 mm/转
- Parting off: 0.02 up to 0.1 mm/rev

### 请注意:

对于左手和右手刀片, 进给率都需在推荐进给率上降低20%到50%。

使用标准的直刀片可以得到最佳的刀具寿命和表面质量。切断实心棒料前需降低进给率。

### Please note:

The recommended feedrate has to be reduced by 20-50% with right or left hand inserts.

Best tool life and surfaces will be obtained with neutral inserts. Reduce the feed rate before parting off when machining solid bars.



# 切槽和切断

## GROOVING and PARTING OFF

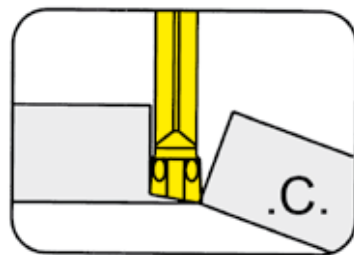


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



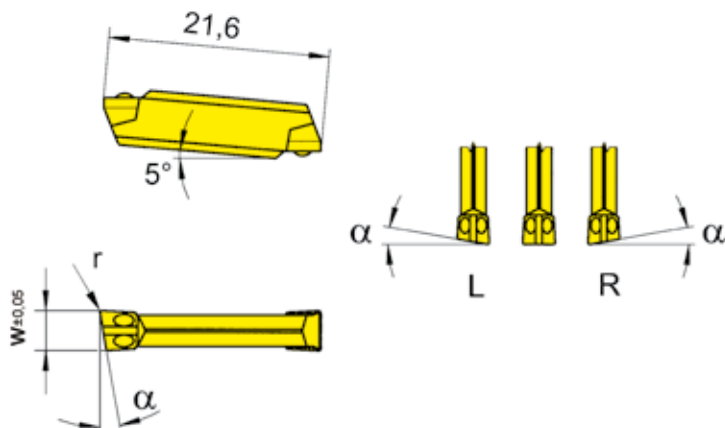
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

E

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	α	规格 Size	TN35	TI25	TF45
S224.0020.C1	2.0	0.15	0°	01	▲	▲	▲
R/LS224.1520.C1			15°		▲/▲	▲/▲	▲/▲
R/LS224.0520.C1			5°		▲/▲	▲/▲	▲/▲
R/LS224.0820.C1			8°		▲/▲	▲/▲	▲/▲
S224.0025.C1	2.5	0.15	0°	02	▲	▲	▲
R/LS224.0525.C1			5°		▲/▲	▲/▲	▲/▲
R/LS224.0825.C1			8°		▲/▲	▲/▲	▲/▲
S224.0030.C1	3.0	0.15	0°	03	▲	▲	▲
R/LS224.0530.C1			5°		▲/▲	▲/▲	▲/▲
R/LS224.0830.C1			8°		▲/▲	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H	●	●	●

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和侧车削

## GROOVING and SIDE TURNING

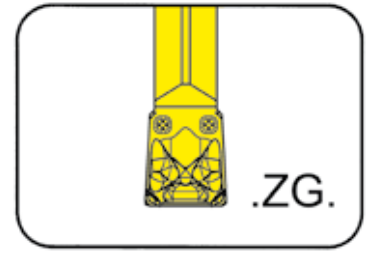


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



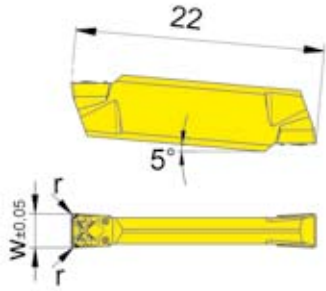
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
3.0 mm

ZG精密磨削

ZG precision ground



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	ALXT
<b>S224.0300.ZG2</b>	3	0.2	03	▲
▲ 库存 / on stock				●
● 主要应用 / main recommendation				○
○ 可选推荐 / alternative recommendation				
■ 无涂层牌号 / uncoated grades				
■ 涂层牌号 / coated grades				
■ 钎焊/金属陶瓷 / brazed/Cermet				

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

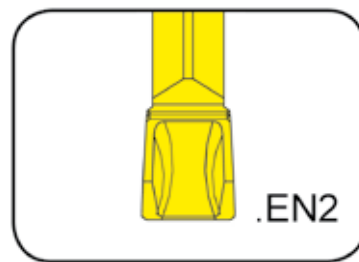


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip former

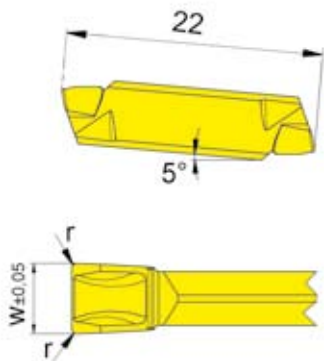


槽深可达  
槽宽

Depth of groove up to 18.0 mm  
Width of groove 2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	MG12	TN35	TI22	TI25	AS62
S224.0200.EN2	2.0	0.2	01					▲
S224.0250.EN2	2.5	0.2	02					▲
S224.0300.EN2	3.0	0.2	03					▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P								●
M								
K								
N								
S								
H								

硬质合金牌号

Carbide grades

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

E

# 切槽和侧车削

## GROOVING and SIDE TURNING

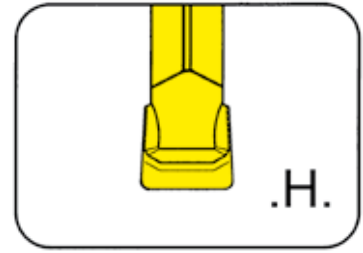


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

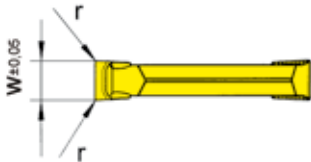
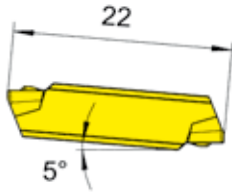
带断屑槽  
with chip breaker



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	3.0 - 6.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 B224

Type BK224

H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	硬质合金牌号			
				TN35	TI25	TA45	TF42
S224.0300.H4	3	0.4	03				▲
S224.0400.H4	4	0.4	04				▲
S224.0500.H6	5	0.6	05				▲
S224.0500.H8		0.8					△
S224.0600.H6	6	0.6	06				△
S224.0600.H8		0.8					△
▲ 库存 / on stock    △ 4周 / 4 weeks				P			●
● 主要应用 / main recommendation				M			
○ 可选推荐 / alternative recommendation				K			
■ 无涂层牌号 / uncoated grades				N			
■ 涂层牌号 / coated grades				S			
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽和侧车削

## GROOVING and SIDE TURNING

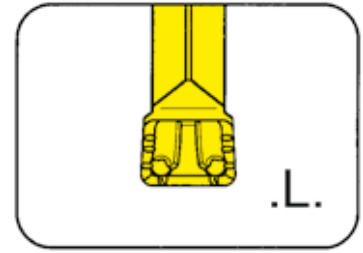


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



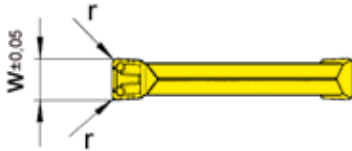
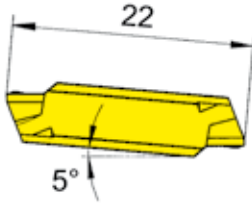
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
4.0 - 6.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	Tl22	TF42	AS62	AS65
<b>S224.0400.L4</b>	4	0.4	04	▲	▲	▲	
<b>S224.0500.L4</b> <b>S224.0500.L6</b>	5	0.4 0.6	05	▲ △	▲ ▲	▲ ▲	
<b>S224.0600.L4</b> <b>S224.0600.L6</b>	6	0.4 0.6	06	▲ ▲	▲ △	▲ ▲	
				P	•	•	•
				M			
				K			
				N			
				S			
				H			

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

E

# 切槽和侧车削

## GROOVING and SIDE TURNING

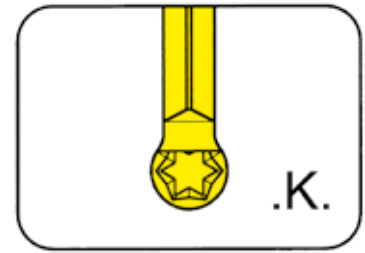


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

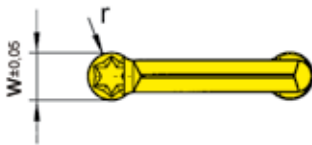
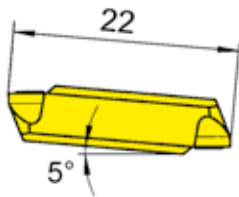
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	2.0 - 6.0 mm
圆头	Full radius	1.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 B224

Type BK224

H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	涂层牌号 / Coated grades					
				TN32	TN35	TI25	TF42	AS62	AS66
S224.0010.K2	2	1.0	01				▲	▲	▲
S224.0015.K3	3	1.5	03	▲			▲	▲	▲
S224.0020.K4	4	2.0	04	▲			▲	▲	▲
S224.0025.K5	5	2.5	05	▲			▲	▲	▲
S224.0030.K6	6	3.0	06					▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	●		●	●	●
● 主要应用 / main recommendation				M					○
○ 可选推荐 / alternative recommendation				K					●
■ 无涂层牌号 / uncoated grades				N					●
■ 涂层牌号 / coated grades				S					○
■ 钎焊/金属陶瓷 / brazed/Cermet				H					

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

使用45° 刀杆加工退刀槽时各尺寸刀片要求的D<sub>min</sub>

D<sub>min</sub> for corner reliefs with toolholder 45°

t <sub>max</sub>	S224.0010.K2	S224.0015.K3	S224.0020.K4	S224.0025.K5	S224.0030.K6
0,5	Ø 34	Ø 26	Ø 22	Ø 21	Ø 14
1,0	Ø 54	Ø 36	Ø 26	Ø 22	Ø 18
1,5	Ø 54	Ø 36	Ø 26	Ø 22	Ø 18
2,0	Ø 55	Ø 36	Ø 26	Ø 22	Ø 18
2,5	Ø 56	Ø 36	Ø 26	Ø 22	Ø 18
3,0	-	-	-	Ø 22	Ø 18

硬质合金牌号  
Carbide grades

# 切槽和侧车削

## GROOVING and SIDE TURNING

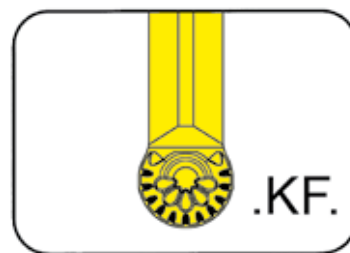


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

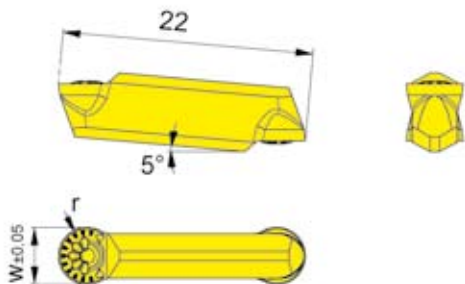
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	3.0 - 6.0 mm
圆头	Full radius	1.5 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 B224  
Type BK224  
H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	W	r	规格 Size
S224.0015.KF3	3	1.5	03
S224.0020.KF4	4	2.0	04
S224.0025.KF5	5	2.5	05
S224.0030.KF6	6	3.0	06

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

	P20	H54	TN32	TN35	TI25	TA42	AS62	AS66
P								▲
M								▲
K								▲
N								▲
S								○
H								

硬质合金牌号

Carbide grades

使用45° 刀杆加工退刀槽时各尺寸刀片要求的D<sub>min</sub>

D<sub>min</sub> for corner reliefs with toolholder 45°

t <sub>max</sub>	S224.0015.KF3	S224.0020.KF4	S224.0025.KF5	S224.0030.KF6
0,5	Ø 26	Ø 22	Ø 21	Ø 14
1,0	Ø 36	Ø 26	Ø 22	Ø 18
1,5	Ø 36	Ø 26	Ø 22	Ø 18
2,0	Ø 36	Ø 26	Ø 22	Ø 18
2,5	Ø 36	Ø 26	Ø 22	Ø 18
3,0	-	-	Ø 22	Ø 18

# 切槽和侧车削

## GROOVING and SIDE TURNING

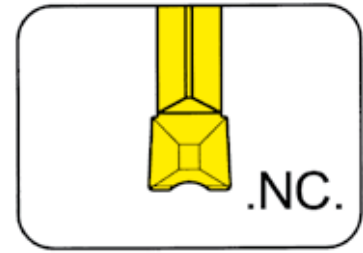


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.5 - 3.0 mm

精密磨削

precision ground

配合 刀杆

for use with Toolholder

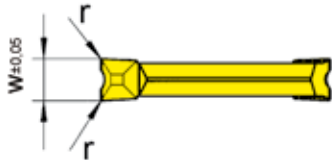
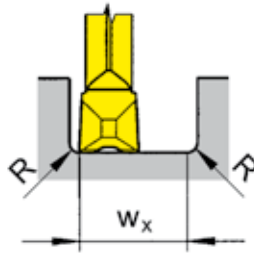
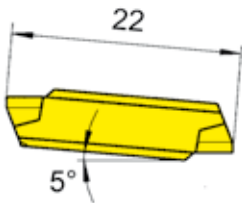
型号

B224

Type

BK224

H224



刀片长度重复定位精度  
±0.025mm

Indexability length ± 0,025 mm

产品型号 Part number	w	r	w <sub>x</sub>	规格 Size		H54	T122	T125	T126	TA45
S224.NC25.D2	2.5	0.2	3.6	02			△	▲	▲	
S224.NC30.D2	3.0	0.2	4.5	03			▲	▲	▲	
					P		•	•	•	
					M			•	○	
					K			•	•	
					N			•	•	
					S			•	○	
					H					

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

w<sub>x</sub> = 槽宽 - R<sub>(右)</sub> - R<sub>(左)</sub>

w<sub>x</sub> = width of groove - R<sub>(right)</sub> - R<sub>(left)</sub>

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

E



# 切槽和切断

## GROOVING and PARTING OFF

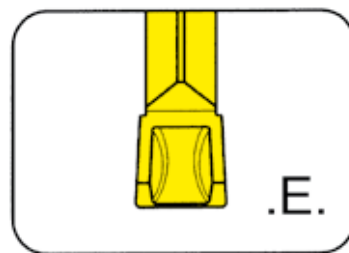


### 可转位刀片 型号

INDEXABLE INSERT Type

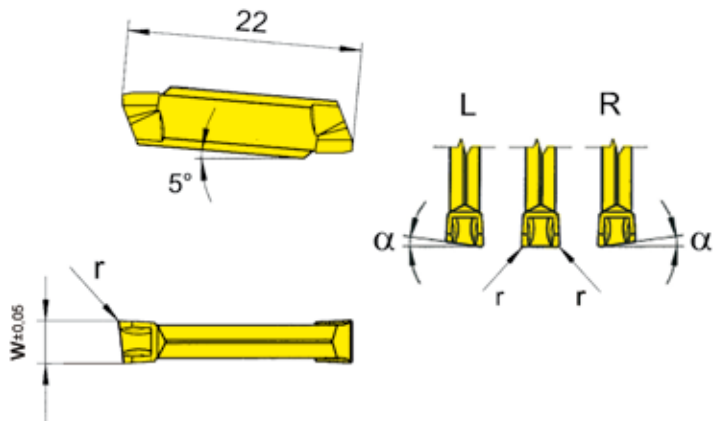
## S224

带断屑槽  
with chip former



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	2.0 - 4.0 mm

精密烧结  
precision sintered



配合 刀杆  
for use with Toolholder

型号 B224  
Type BK224  
H224

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	α	规格 Size	Tl22	Tl25	TF43	TF45	AS62
S224.0200.E2 R/LS224.0520.E2	2.0	0.2	0° 5°	01			▲	▲	▲
S224.0250.E2 R/LS224.0525.E2	2.5	0.2	0° 5°	02			▲	▲	▲
S224.0300.E2 S224.0300.E4 R/LS224.0530.E2	3.0	0.2 0.4 0.2	0° 0° 5°	03	▲	▲	▲	▲	▲
S224.0400.E2 S224.0400.E4	4.0	0.2 0.4	0°	04				▲	▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●	●	●	●
M		●		
K		●		
N		●		
S		●		
H				

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

按需提供更多尺寸  
Further sizes upon request

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.



# 切槽和切断

## GROOVING and PARTING OFF

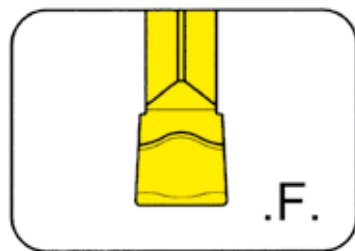


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



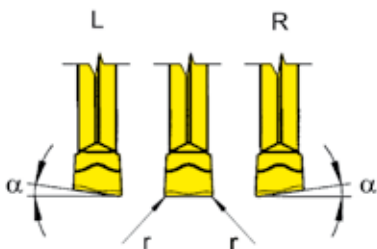
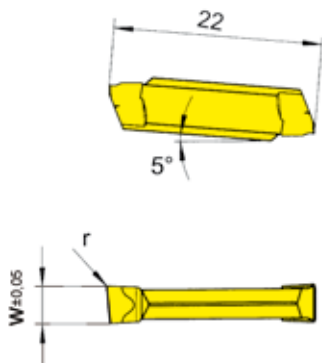
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.0 - 4.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号

B224

Type

BK224

H224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	α	规格 Size	Tl22	Tl25	TF42	TF43	TF45	TF46
S224.0200.F2 R/LS224.0520.F2	2.0	0.2	0° 5°	01	▲	▲		▲	▲	▲/▲
S224.0250.F2 R/LS224.0525.F2	2.5	0.2	0° 5°	02	▲			Δ	▲	Δ
S224.0300.F2 R/LS224.0530.F2	3.0	0.2	0° 5°	03	Δ/Δ	▲		▲	▲	▲
S224.0400.F2	4.0	0.2	0°	04	▲			Δ/Δ	▲/▲	
▲ 库存 / on stock Δ 4周 / 4 weeks					P	•	•	•	•	•
● 主要应用 / main recommendation					M		•		•	○
○ 可选推荐 / alternative recommendation					K		•		•	•
■ 无涂层牌号 / uncoated grades					N		•		•	•
■ 涂层牌号 / coated grades					S		•		•	○
■ 钎焊/金属陶瓷 / brazed/Cermet					H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

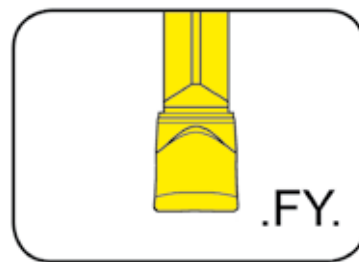


### 可转位刀片 型号

INDEXABLE INSERT Type

### S224

带断屑槽  
with chip forming



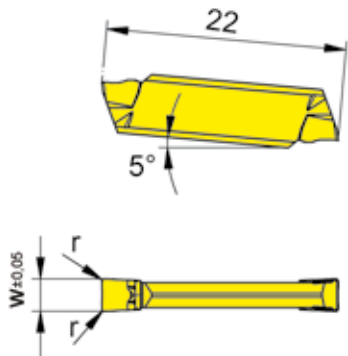
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 常规刀杆  
for use with Basic toolholder

型号 B224  
Type BK224  
H224

E

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TN35	TI25	TF45	AS45
				S224.0200.FY2	2.0	0.2	01
S224.0250.FY2	2.5	0.2	02		▲		
S224.0300.FY2	3.0	0.2	03		▲		
▲ 库存 / on stock Δ 4周 / 4 weeks				P	•		
● 主要应用 / main recommendation				M	•		
○ 可选推荐 / alternative recommendation				K	•		
■ 无涂层牌号 / uncoated grades				N	•		
■ 涂层牌号 / coated grades				S	•		
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

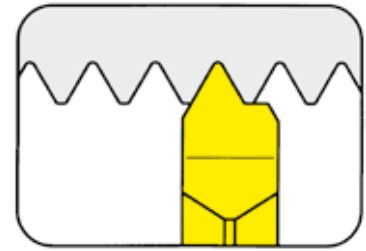


### 可转位刀片 型号

INDEXABLE INSERT Type

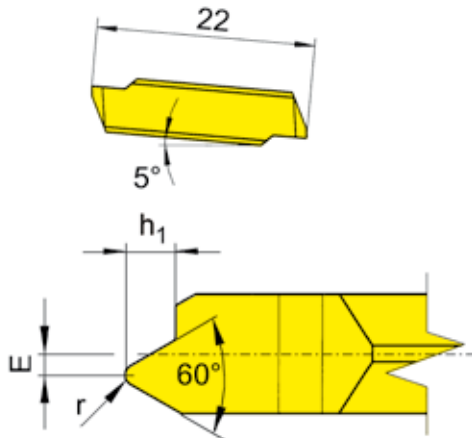
## S224

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	0.5 - 2.0 mm
----	-------	--------------

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H224  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	P	r	E	h <sub>1</sub>	规格 Size	TN35	TI25	TF45
R/LS224.0305.02	0.50	0.07	1.0	0.31	03			▲/▲
R/LS224.0407.02	0.75	0.11	0.9	0.46		▲/▲		
R/LS224.0610.02	1.00	0.12	0.8	0.61		▲/▲		
R/LS224.0712.02	1.25	0.15	0.7	0.77		▲/▲		
R/LS224.0915.02	1.50	0.20	0.5	0.92		▲/▲		
R/LS224.1017.02	1.75	0.25	0.4	1.07		▲/▲		
R/LS224.1220.02	2.00	0.25	0.3	1.23		▲/▲		

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

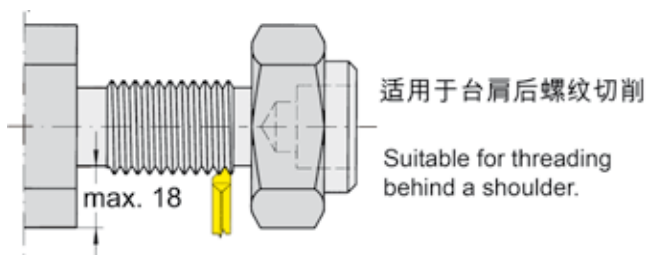
P	●
M	●
K	●
N	●
S	●
H	

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.



# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

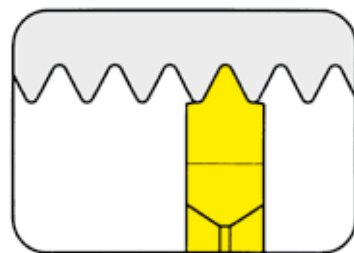


### 可转位刀片 型号

INDEXABLE INSERT Type

## NS224

惠氏管螺纹  
Whitworth pipe thread



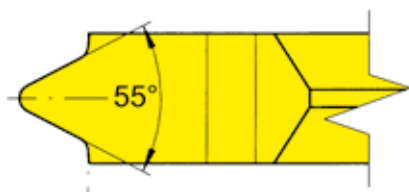
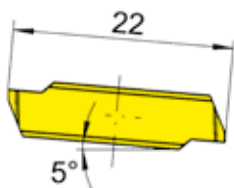
每英寸牙数

Threads per inch

28 - 11

精密磨削

precision ground



配合 刀杆

for use with Toolholder

型号 H224

Type

刀片长度重复定位精度

$\pm 0.025\text{mm}$

Indexability length  $\pm 0,025\text{ mm}$

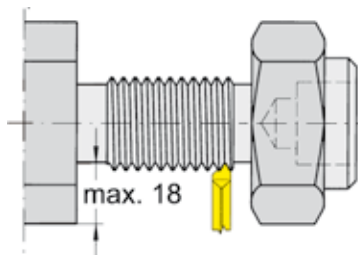
产品型号 Part number	每英寸螺牙数 Threads per Inch	规格 Size	TN35	Tl25	TA45
			▲	▲	▲
NS224.5511.02	11	03			▲
NS224.5514.02	14				▲
NS224.5519.02	19				▲
NS224.5528.02	28				▲
▲ 库存 / on stock    Δ 4周 / 4 weeks			P		•
● 主要应用 / main recommendation			M		•
○ 可选推荐 / alternative recommendation			K		•
■ 无涂层牌号 / uncoated grades			N		•
■ 涂层牌号 / coated grades			S		•
■ 钎焊/金属陶瓷 / brazed/Cermet			H		

尺寸单位 : mm

Dimensions in mm

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.



适用于台肩后螺纹切削

Suitable for threading behind a shoulder.

硬质合金牌号  
Carbide grades



# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
<b>加工 / Machining</b>										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
<b>槽宽</b> Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
<b>章 / Chapter</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
<b>加工 / Machining</b>										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
<b>槽宽</b> Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
<b>章 / Chapter</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

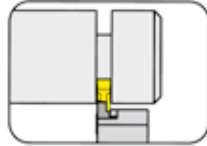
可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

刀具系列 231  
TOOLING SYSTEM 231

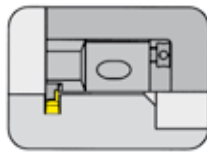
F

切槽  
- 外圆 -  
Grooving  
- external -



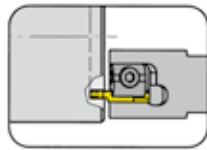
页 / Page  
F2-F3

切槽  
- 内圆 -  
Grooving  
- internal -

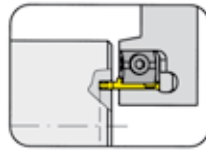


页 / Page  
F4-F5

端面切槽  
Face Grooving

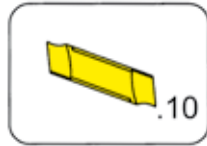


页 / Page  
F11

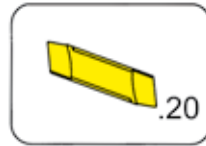


页 / Page  
F12

可转位刀片  
型号  
Indexable inserts type  
231

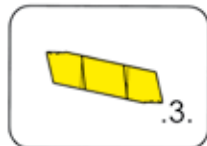


页 / Page  
F7-F8



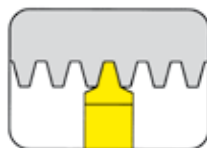
页 / Page  
F9-F10

切槽  
Grooving



页 / Page  
F13

端面切槽  
Face Grooving



页 / Page  
F14

米制梯形螺纹  
metric trapezoidal thread

技术说明见章节Q  
For Technical Instructions please see chapter Q

F

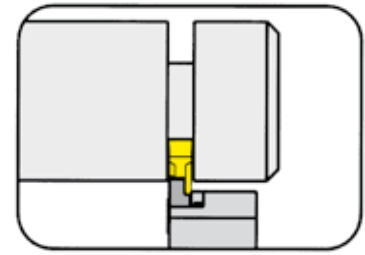
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 211

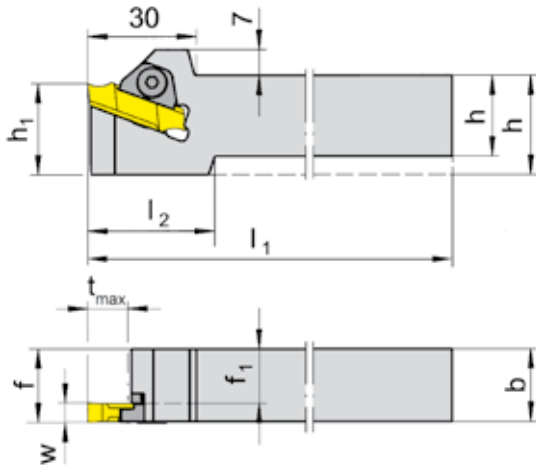


槽深可达 11.0 mm  
夹持范围 2.5 - 5.0 mm

Depth of groove up to 11.0 mm  
Clamping range 2.5 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L211.2020.02	20	20	125	35	25	17.5	f <sub>1</sub> +w-a <sub>1</sub>	11	02	2.5 - 3.0
R/L211.2525.02	25	25	150	-	25	22.5				
R/L211.3232.02	32	32	170	-	32	29.5				
R/L211.2020.03	20	20	125	35	25	17.0	f <sub>1</sub> +w-a <sub>1</sub>	11	03	3.0 - 4.0
R/L211.2525.03	25	25	150	-	25	22.0				
R/L211.3232.03	32	32	170	-	32	29.0				
R/L211.2020.04	20	20	125	35	25	16.0	f <sub>1</sub> +w-a <sub>1</sub>	11	04	4.0 - 5.0
R/L211.2525.04	25	25	150	-	25	21.0				
R/L211.3232.04	32	32	170	-	32	28.0				

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L211....02	2.16.2	6.19	SW3,0DIN911
R/L211....03	2.16.3	6.19	SW3,0DIN911
R/L211....04	2.16.7	6.19	SW3,0DIN911



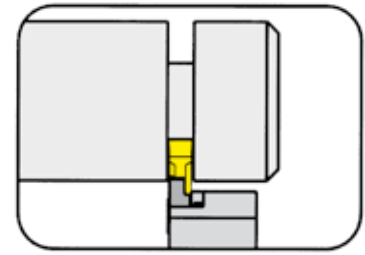
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 211

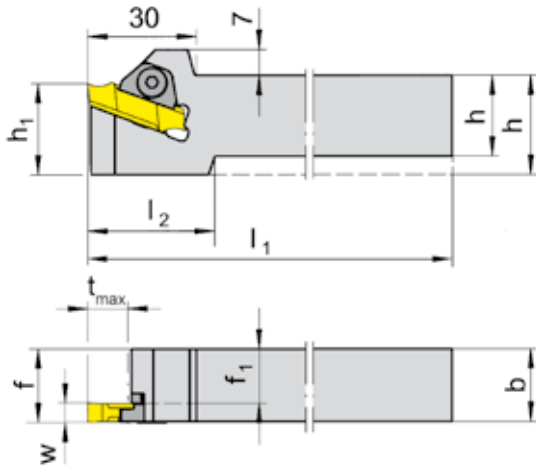


槽深可达 11.0 mm  
夹持范围 5.0 - 10.0 mm

Depth of groove up to 11.0 mm  
Clamping range 5.0 - 10.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L211.2020.05	20	20	125	35	25	15				
R/L211.2525.05	25	25	150	-	25	20	f <sub>1</sub> +w-a <sub>1</sub>	11	05	5.0 - 6.5
R/L211.3232.05	32	32	170	-	32	27				
R/L211.2020.07	20	20	125	35	25	13				
R/L211.2525.07	25	25	150	-	25	18	f <sub>1</sub> +w-a <sub>1</sub>	11	07	6.5 - 8.5
R/L211.3232.07	32	32	170	-	32	25				
R/L211.2020.09	20	20	125	35	25	11				
R/L211.2525.09	25	25	150	-	25	16	f <sub>1</sub> +w-a <sub>1</sub>	11	09	8.5 - 10.0
R/L211.3232.09	32	32	170	-	32	23				

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L211....	2.16.7	6.19	SW3,0DIN911

F

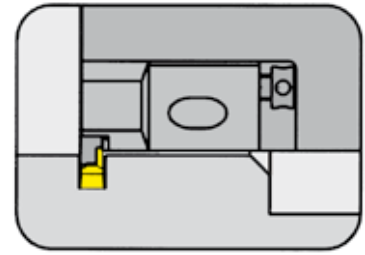
# 切槽 ( 内圆 )

## GROOVING (internal)

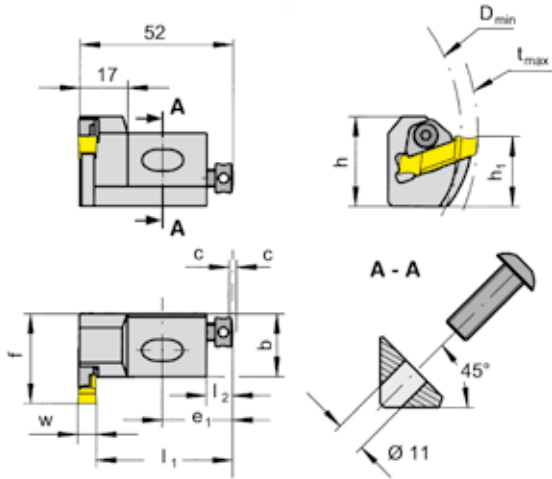


刀夹 型号  
CARTRIDGE Type

# 208



孔径 $\varnothing$  自 75.0 mm  
夹持范围 Clamping range 4.0 - 10.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 231  
Type

槽深与孔径的对应关系：  
Depth of groove in relation to bore  $\varnothing$

$D_{min}$	$t_{max}$
75	5,0
85	6,0
95	6,5
110	7,0
140	8,0
200	9,0

F

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$h_1$	f	h	b	$l_1$	$e_1$	$l_2$	c	规格 Size	夹持范围 Clamping range
R/L208.2520.04	25	32	32	20	47.8	25	9	2	04	4.0 - 5.0
R/L208.2520.05	25	32	32	20	46.8	25	9	2	05	5.0 - 6.5
R/L208.2520.07	25	32	32	20	44.8	25	9	2	07	6.5 - 8.5
R/L208.2520.09	25	32	32	20	42.8	25	9	2	09	8.5 - 10.0

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cartridge	压板 Clamp	螺钉 Screw	轴向调节螺钉 Axial Setscrew	径向调节螺钉 Radial Setscrew	扳手 Wrench
R/L208.2520.0...	2.16.7-K	0.30.208	6.12.020	4.08.913	SW3.0DIN911

# 切槽 (内圆)

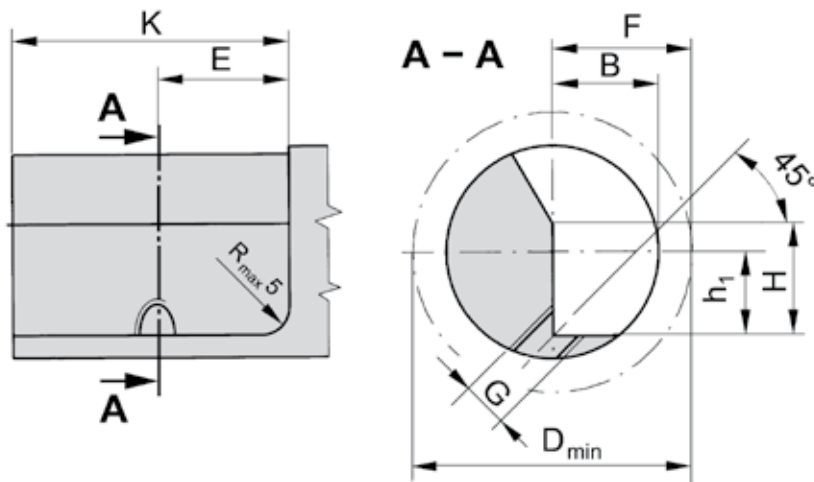
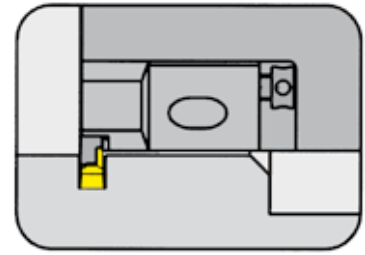
## GROOVING (internal)



外形尺寸 刀夹 型号

SEATING DIMENSIONS CARTRIDGE type

# 208



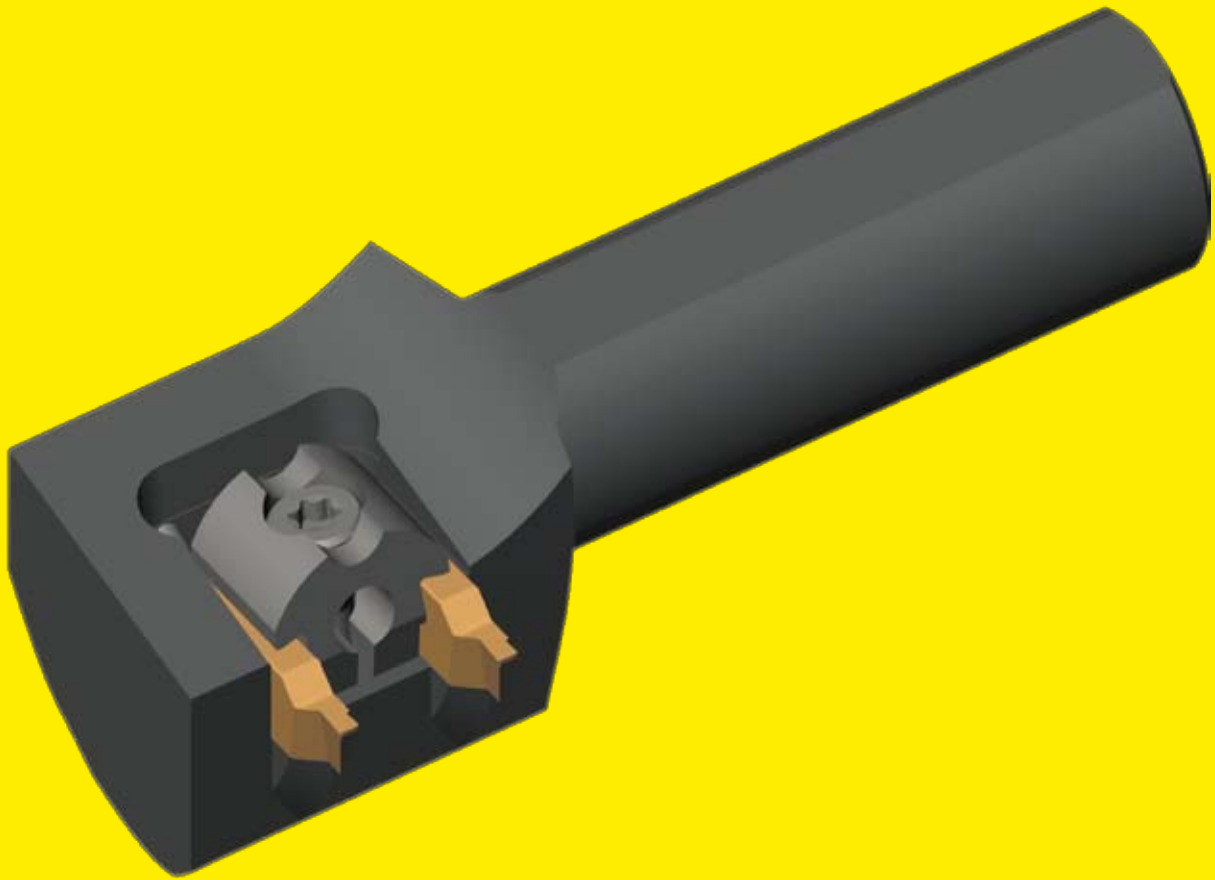
F

刀夹 Cartridge	F	G	H	K	E	B	$h_1$	$D_{min}$	紧固螺钉 Fastening screw
R/L208.2520...	32	M10	32	50	25	20	25	75	0.30.208

尺寸单位 : mm  
Dimensions in mm

适用于外圆和内圆加工夹持的多槽加工刀杆  
-提供最大程度的夹持刚性-

F



**Possible solutions of multigrooving toolholders  
with clamping for internal or external applications  
- offers the maximum clamping rigidity for the inserts**

# 切槽 ( 外圆 )

## GROOVING (external)

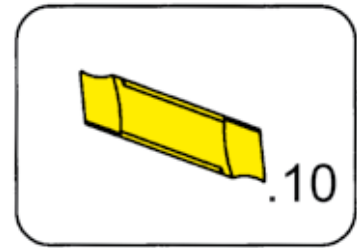


### 可转位刀片 型号

INDEXABLE INSERT Type

# 231

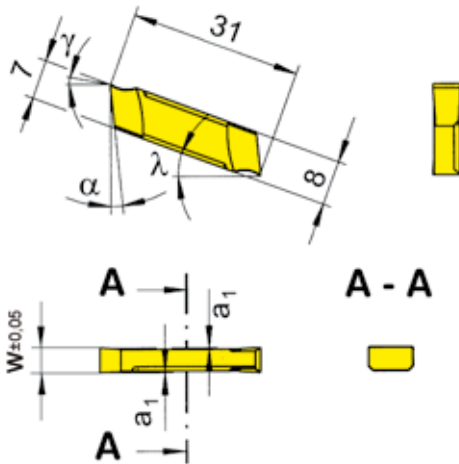
带圆形断屑槽  
with round chip breaker



槽深可达  
槽宽

Depth of groove up to  
Width of groove

11.0 mm  
2.5 - 3.5 mm



配合 刀杆  
for use with Toolholder

型号 211  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	w	a <sub>1</sub>	α	γ		规格 Size		K10	P20	TN32	Tl22	TA42	AS62
R/L231.0250.10	2.5	0.2	6°	20°	20°	02			▲/▲	▲/▲			
R/L231.0300.10	3.0	0.2	6°	20°	20°	03			Δ/Δ				
R/L231.0350.10	3.5	0.2	6°	20°	20°	03							

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

P	●	●			
M					
K					
N					
S					
H					

硬质合金牌号  
Carbide grades

F

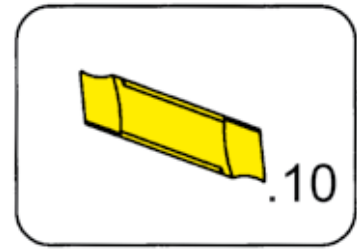
# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)



可转位刀片 型号  
INDEXABLE INSERT Type

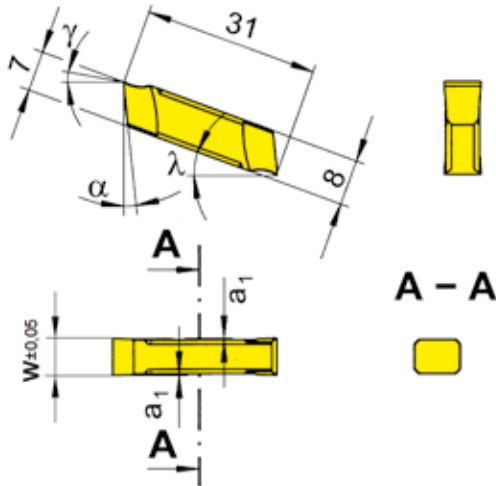
**231**  
带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	11.0 mm
槽宽	Width of groove	4.0 - 10.0 mm

配合 刀杆  
for use with Toolholder

型号 211  
Type 208



刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	w	a <sub>1</sub>	α	刀杆 Toolholder	规格 Size		K10	P20	TN32	TI22	TA42	TC92
231.0400.10	4	0.2	6°/11°	211/208	04		▲	▲	△			▲
231.0500.10	5	0.2	6°/11°	211/208	05			▲				▲
231.0600.10	6					△	▲			▲		
231.0700.10	7	0.2	6°/11°	211/208	07			▲				▲
231.0800.10	8					▲	▲	▲				
231.0900.10	9	0.2	6°/11°	211/208	09							
231.1000.10	10					△	△	△				
▲ 库存 / on stock    △ 4周 / 4 weeks						P	●	●	●			●
● 主要应用 / main recommendation						M	○					
○ 可选推荐 / alternative recommendation						K	●					
■ 无涂层牌号 / uncoated grades						N	●					
■ 涂层牌号 / coated grades						S	○					
■ 钎焊/金属陶瓷 / brazed/Cermet						H						

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽 ( 外圆 )

## GROOVING (external)

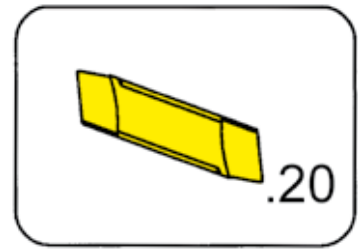


### 可转位刀片 型号

INDEXABLE INSERT Type

# 231

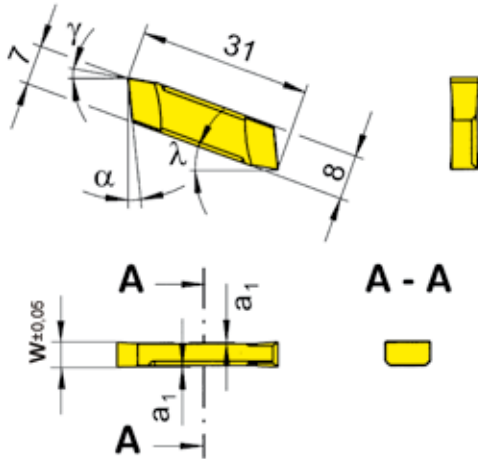
带直断屑槽  
with flat chip breaker



槽深可达  
槽宽

Depth of groove up to  
Width of groove

11.0 mm  
2.5 - 3.5 mm



配合 刀杆  
for use with Toolholder

型号 211  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
 $\pm 0.025\text{mm}$   
Indexability length  $\pm 0,025\text{ mm}$

产品型号 Part number	w	a <sub>1</sub>	α	γ	规格 Size	硬质合金牌号					
						K10	P20	TN32	TI22	TA42	TC92
R/L231.0250.20	2.5	0.2	6°	10°	02						
R/L231.0300.20	3.0	0.2	6°	10°	03						
R/L231.0350.20	3.5	0.2	6°	10°	03						
<ul style="list-style-type: none"> <li>▲ 库存 / on stock Δ 4周 / 4 weeks</li> <li>● 主要应用 / main recommendation</li> <li>○ 可选推荐 / alternative recommendation</li> <li>■ 无涂层牌号 / uncoated grades</li> <li>■ 涂层牌号 / coated grades</li> <li>■ 钎焊/金属陶瓷 / brazed/Cermet</li> </ul>						P					
						M					
						K					
						N					
						S					
						H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片  
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

硬质合金牌号  
Carbide grades

F

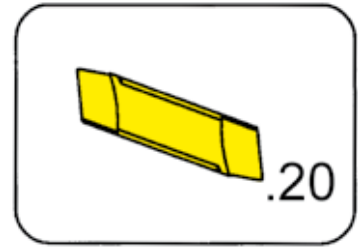
# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)



可转位刀片 型号  
INDEXABLE INSERT Type

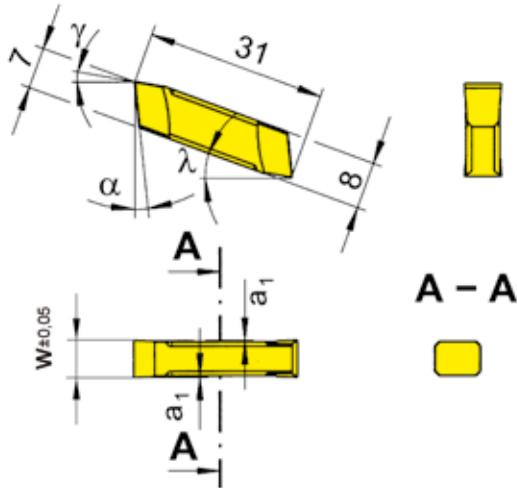
**231**  
带直断屑槽  
with flat chip breaker



槽深可达	Depth of groove up to	11.0 mm
槽宽	Width of groove	4.0 - 10.0 mm

配合 刀杆  
for use with Toolholder

型号 211  
Type 208



刀片长度重复定位精度  
 $\pm 0.025\text{mm}$   
Indexability length  $\pm 0,025\text{ mm}$

产品型号 Part number	w	a <sub>1</sub>	α	γ	刀杆 Toolholder	规格 Size	硬质合金牌号					
							K10	P20	TN32	TI22	TA42	TF45
231.0400.20	4	0.2	6°/11°	10°/5°	211/208	04						
231.0500.20 231.0600.20	5 6	0.2	6°/11°	10°/5°	211/208	05						
231.0700.20 231.0800.20	7 8	0.2	6°/11°	10°/5°	211/208	07						
231.0900.20 231.1000.20	9 10	0.2	6°/11°	10°/5°	211/208	09						
▲ 库存 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet							P					
							M					
							K					
							N					
							S					
							H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



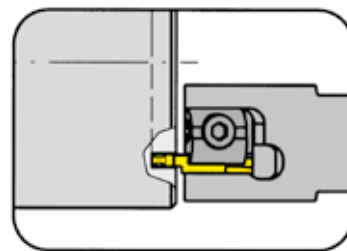
# 端面切槽 FACE GROOVING



## 刀杆 型号

# 221

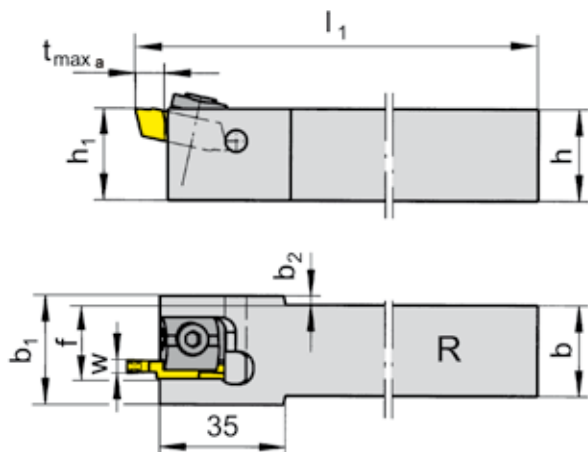
TOOLHOLDER Type



端面槽起始外径	from outer groove $\emptyset$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	3.0 - 10.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type N231



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	b	b <sub>1</sub>	b <sub>2</sub>	f	t <sub>max a</sub>	规格 Size	夹持范围 Clamping range
R/L221.2020.04	20	20	125	20	28	4.0	17.9	8	04	3.0 - 4.0
R/L221.2525.04	25	25	150	25	28	1.5	20.4	8	04	3.0 - 4.0
R/L221.2020.05	20	20	125	20	30	5.0	18.9	8	05	4.1 - 6.0
R/L221.2525.05	25	25	150	25	30	2.5	21.4	8	05	4.1 - 6.0
R/L221.2020.07	20	20	125	20	32	6.0	19.9	8	07	6.1 - 8.0
R/L221.2525.07	25	25	150	25	32	3.5	22.4	8	07	6.1 - 8.0
R/L221.2020.09	20	20	125	20	34	7.0	20.9	8	09	8.1 - 10.0
R/L221.2525.09	25	25	150	25	34	4.5	23.4	8	09	8.1 - 10.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

取决于切槽深度, 当D<sub>a</sub>=30 mm到∞时可以使用此刀杆。  
This toolholder can be used from D<sub>a</sub> = 30 mm up to ∞ depending on grooving depth.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

## 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	定位销 Position Pin
R/L221.2...	01.60.12	6.20.70P	T20PQ	3.6.28

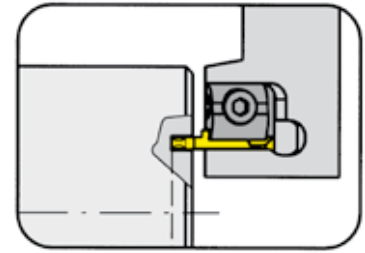
F

# 端面切槽 FACE GROOVING



刀杆 型号  
TOOLHOLDER Type

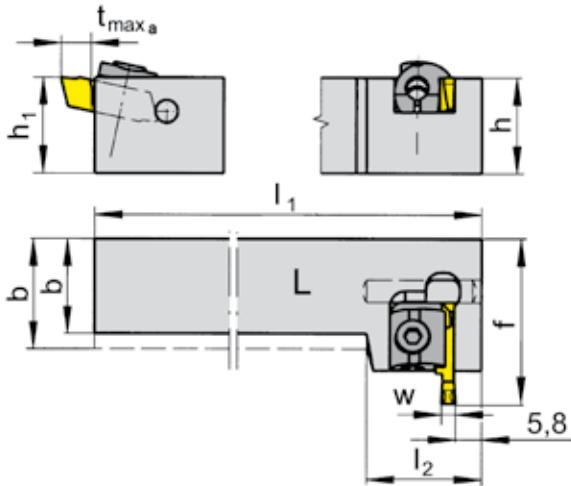
## 228



端面槽起始外径	from outer groove $\varnothing$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	3.0 - 10.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type N231



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$b$	$f$	$t_{max a}$	规格 Size	夹持范围 Clamping range
R/L228-2020-04	125	35.5	20	20	20	38.5	8	04	3.0 - 4.0
R/L228-2525-04	150	35.5	25	25	25	38.5	8	04	3.0 - 4.0
R/L228-2020-05	125	35.5	20	20	20	38.5	8	05	4.1 - 6.0
R/L228-2525-05	150	35.5	25	25	25	38.5	8	05	4.1 - 6.0
R/L228-2020-07	125	35.5	20	20	20	38.5	8	07	6.1 - 8.0
R/L228-2525-07	150	35.5	25	25	25	38.5	8	07	6.1 - 8.0
R/L228-2020-09	125	35.5	20	20	20	38.5	8	09	8.1 - 10.0
R/L228-2525-09	150	35.5	25	25	25	38.5	8	09	8.1 - 10.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

取决于切槽深度，当 $D_a = 30$  mm到 $\infty$ 时可以使用此刀杆。  
This toolholder can be used from  $D_a = 30$  mm up to  $\infty$  depending on grooving depth.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	定位销 Position Pin
R/L228.2...	01.60.12	6.20.70P	T20PQ	3.6.28

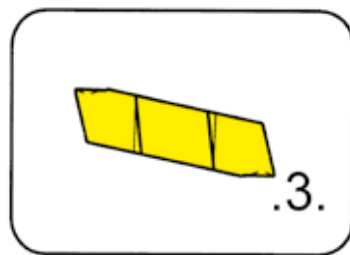
# 端面切槽 FACE GROOVING



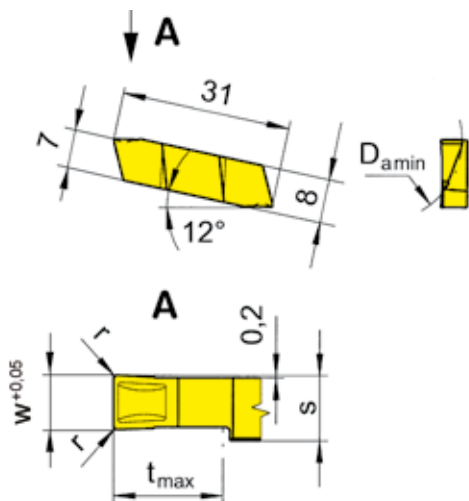
可转位刀片 型号  
INDEXABLE INSERT Type

## 231/N231

带断屑槽  
with chip former



端面槽起始外径	from outer groove $\varnothing$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	3.0 - 10.0 mm



配合 刀杆  
for use with Toolholder

型号 221  
Type 228

刀片长度重复定位精度  
 $\pm 0.025\text{mm}$   
Indexability length  $\pm 0,025\text{ mm}$

产品型号 Part number	w	s	r	t <sub>max</sub>	D <sub>a min</sub>	规格 Size	TN32	TN35	TA45
R/L231.4030.32 R/L231.4040.32	3 4	3.8	0.2	8	40	04		▲/▲ ▲/▲	
R/L231.4050.34 N231.4060.34	5 6	5.8	0.4	8	40	05		▲/▲ ▲	
N231.4070.36 N231.4080.36	7 8	7.8	0.6	8	40	07		▲ ▲	
N231.4090.38 N231.4100.38	9 10	9.8	0.8	8	40	09		▲ ▲	
							P	•	
							M	•	
							K	•	
							N	•	
							S	•	
							H		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R, L或N型  
State R, L or N version

槽外径 $\varnothing < 40\text{mm}$ 时可定制非标产品  
Outer- $\varnothing$  of groove  $< 40\text{ mm}$  upon request.

硬质合金牌号  
Carbide grades



# 螺纹切削 ( 外圆 ) -全牙型

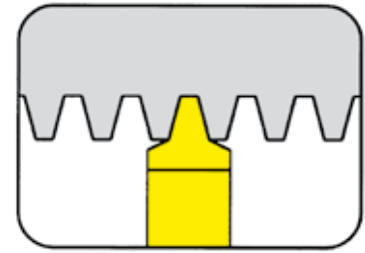
## THREADING (external) Full profile



可转位刀片 型号

# 231

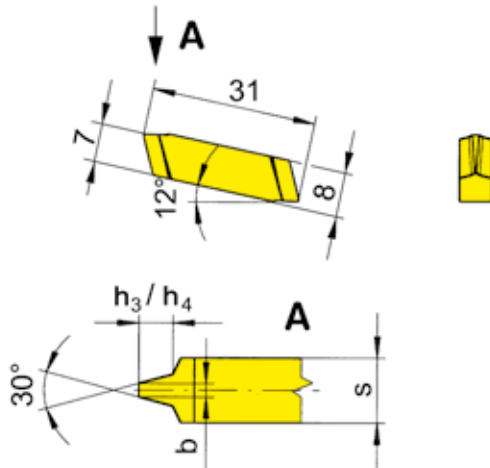
INDEXABLE INSERT Type



螺距	Pitch	7.0 - 12.0 mm
----	-------	---------------

配合 刀杆  
for use with Toolholder

型号 221  
Type 228



ISO米制梯形螺纹DIN103  
Metric ISO trapezoidal  
thread DIN 103

产品型号 Part number	P	b	s	$h_3 / h_4$	规格 Size	MG12	TN35	TI25	TA45
231.4070.02	7	2.29	5.8	4.0	05		△		
231.4580.02	8	2.66	5.8	4.5			▲		
231.5090.02	9	3.02	7.8	5.0	07		△		
231.5500.02	10	3.39	7.8	5.5			▲		
231.6020.02	12	4.12	9.8	6.5	09		△		
						P	•		
						M	•		
						K	•		
						N	•		
						S	•		
						H			

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

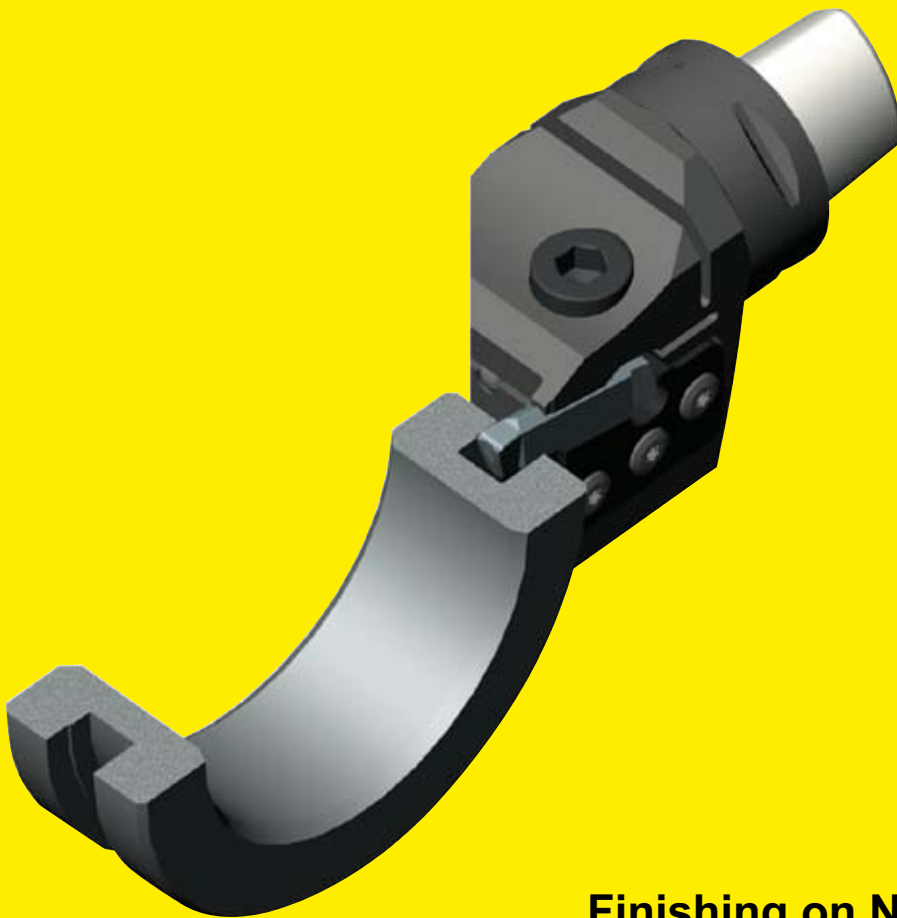
硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

F

**NC车床精加工**

**229系列金属陶瓷刀片**



**F**

**Finishing on NC-lathes  
type 229 in Cermet H20**

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

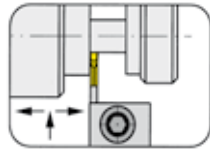
尺寸单位：mm  
Dimensions in mm

刀具系列 229

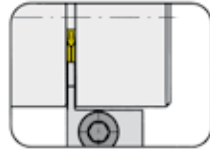
TOOLING SYSTEM 229

G

切槽  
- 外圆 -  
Grooving  
- external -



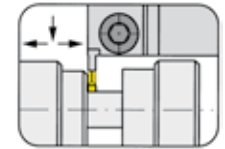
页 / Page G2-G13



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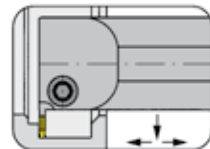


页 / Page G17-G18

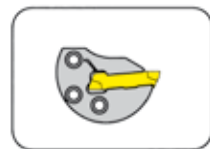


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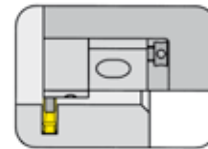
切槽  
- 内圆 -  
Grooving  
- internal -



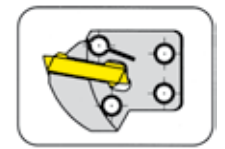
页 / Page G20-G27



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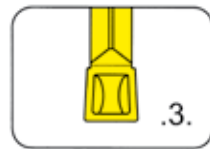


页 / Page G29

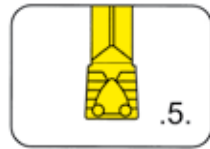


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可转位刀片  
型号  
Indexable inserts type  
S229



页 / Page G32-G33



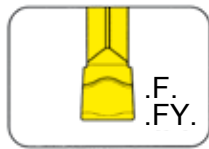
页 / Page G34-G35



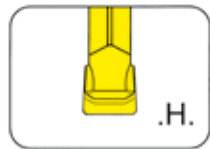
页 / Page G36-G37



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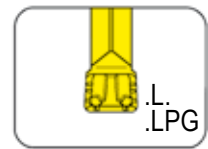
页 / Page G39-G40



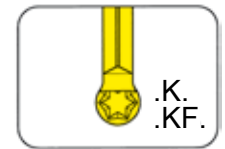
页 / Page G41



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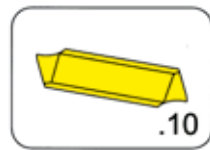


页 / Page G43, G45

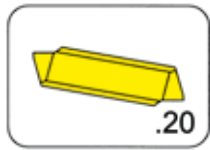


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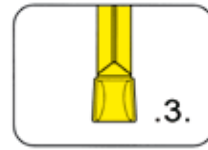
可转位刀片  
型号  
Indexable inserts type  
229



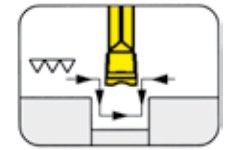
页 / Page G48-G49



页 / Page G50-G51



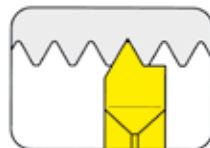
页 / Page G52-G53



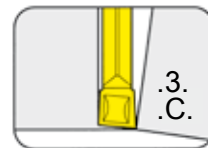
页 / Page G54-G55



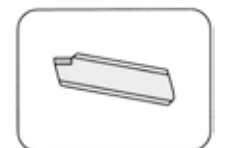
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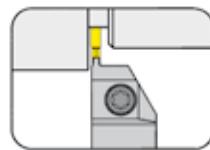


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页 / Page G63  
CBN刀片  
CBN-tipped-insert

型号  
type  
H259 / 259



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技术说明见章节Q

For Technical Instructions please see chapter Q

G

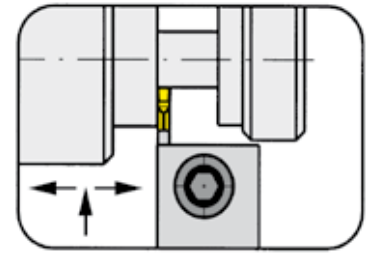
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



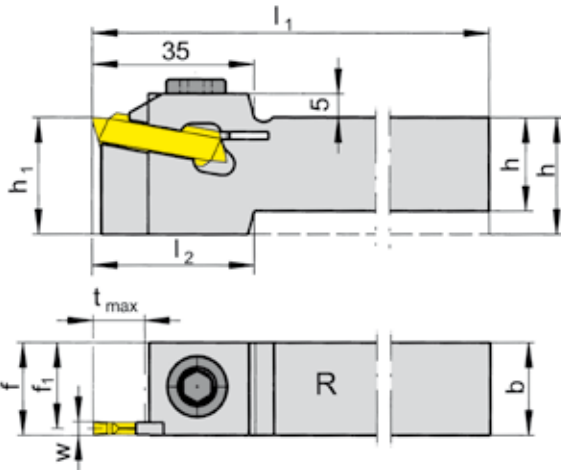
刀杆型号  
TOOLHOLDER Type

# 210



槽深可达 11.0 mm  
夹持范围 2.5 - 6.0 mm

Depth of groove up to 11.0 mm  
Clamping range 2.5 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L210.2020.02 R/L210.2525.02	20 25	20 25	150	25	f <sub>1</sub> +w/2	18.55 23.55	35 -	11	02	2.5 - 3.0
R/L210.1616.03 R/L210.2020.03 R/L210.2525.03 R/L210.3225.03	16 20 25 32	16 20 25 25	150 150 150 170	25 25 25 32	f <sub>1</sub> +w/2	14.55 18.55 23.55 23.55	45 35 - -	11	03	3.0 - 4.0
R/L210.2020.04 R/L210.2525.04 R/L210.3225.04	20 25 32	20 25 25	150 150 170	25 25 32	f <sub>1</sub> +w/2	17.70 22.70 22.70	35 - -	11	04	4.0 - 5.0
R/L210.2020.05 R/L210.2525.05 R/L210.3225.05	20 25 32	20 25 25	150 150 170	25 25 32	f <sub>1</sub> +w/2	17.20 22.20 22.20	35 - -	11	05	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

R/L 210...02在工件直径150mm以下可达最大切深  
R/L 210...02 max. depth of groove up to Ø 150 mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L210....	218.3	SW6.0DIN911



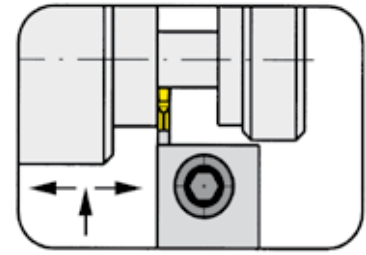
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

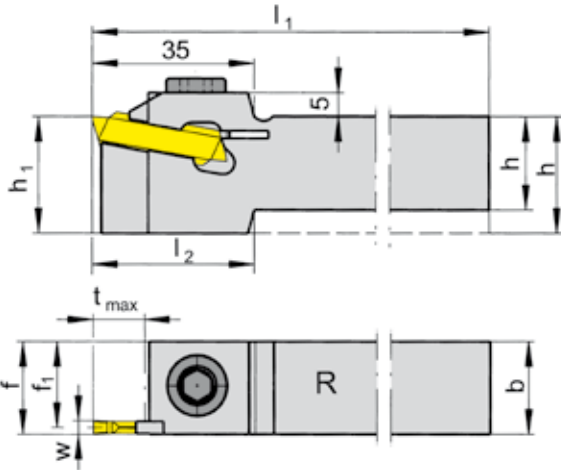
# 210



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

11.0 mm  
6.1 - 8.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L210.2020.07	20	20	150	25		16.2	35			
R/L210.2525.07	25	25	150	25	f <sub>1</sub> +w/2	21.2	-	11	07	6.1 - 8.0
R/L210.3225.07	32	25	170	32		21.2	-			
R/L210.2020.08	20	20	150	25	f <sub>1</sub> +w/2	16.2	35		08	7.6 - 8.0
R/L210.2525.08	25	25				21.2	-			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L210....	218.3	SW6,0DIN911

G

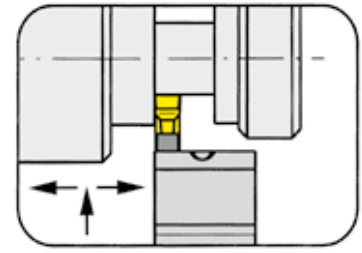
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

# 210

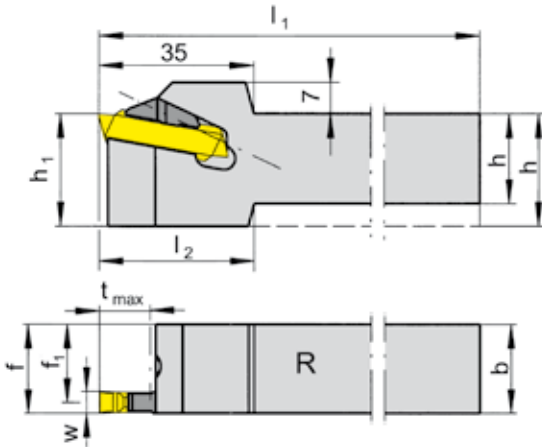


槽深可达 11.0 mm  
夹持范围 8.1 - 10.4 mm

Depth of groove up to 11.0 mm  
Clamping range 8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L210.2020.09	20	20	150	25		15.2	35			
R/L210.2525.09	25	25	150	25	f <sub>1</sub> +w/2	20.2	-	11	09	8.1 - 10.4
R/L210.3225.09	32	25	170	32		20.2	-			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项 :

请注意夹持方式

**Note:**

Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L210.....09 R210.....09	L218.9 R218.9	5.32T15P 5.32T15P	T15PQ T15PQ

# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)

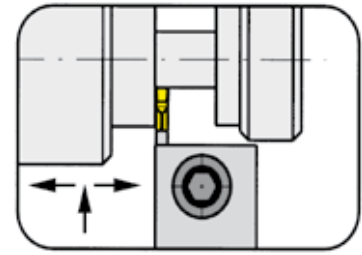


### 常规刀杆 型号

BASIC TOOLHOLDER Type

# 210

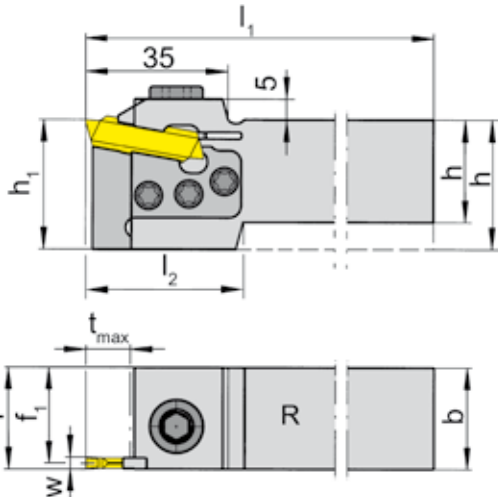
带可换刀夹  
with changeable cassette



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

11.0 mm  
3.0 - 8.0 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号

229

Type

N229

S229

G

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L210.2525.K3 R/L210.3225.K3	25 32	25	150 170	32	f <sub>1</sub> +w/2	23.55	35 -	11	03	3.0 - 4.0
R/L210.2525.K4 R/L210.3225.K4	25 32	25	150	32	f <sub>1</sub> +w/2	22.70	35 -	11	04	4.0 - 5.0
R/L210.2525.K5 R/L210.3225.K5	25 32	25	150 170	32	f <sub>1</sub> +w/2	22.20	35 -	11	05	5.1 - 6.0
R/L210.2525.K7 R/L210.3225.K7	25 32	25	150 170	32	f <sub>1</sub> +w/2	21.20	35 -	11	07	6.1 - 8.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

常规刀杆 Basic toolholder	刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L210....K3	NK210.32.03	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L210....K4	NK210.32.04	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L210....K5	NK210.32.05	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L210....K7	NK210.32.07	030.0518.T20P	218.3	SW6,0DIN911	T20PQ

# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)

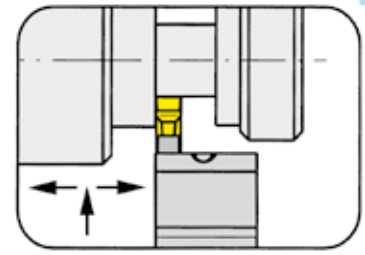


### 常规刀杆 型号

BASIC TOOLHOLDER Type

# 210

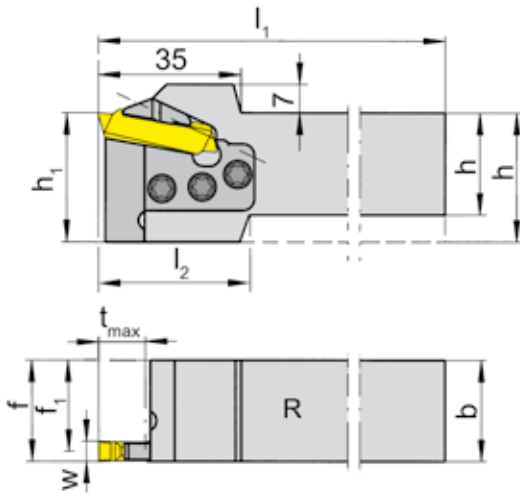
带可换刀夹  
with changeable cassette



槽深可达	Depth of groove up to	11.0 mm
夹持范围	Clamping range	8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L210.2525.K9	25	25	150	32	f <sub>1</sub> +w/2	20.2	35	11	09	8.1 - 10.4
R/L210.3225.K9	32	25	170				-			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项:

请注意夹持方式

**Note:**

Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

常规刀杆 Basic toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L210....K9 R210....K9	NK210.32.09 NK210.32.09	L218.9 R218.9	T15PQ T15PQ	030.0518.T20P 030.0518.T20P	5.32T15P 5.32T15P	T20PQ T20PQ

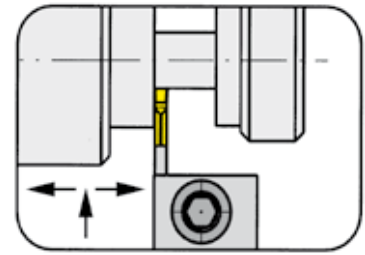
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



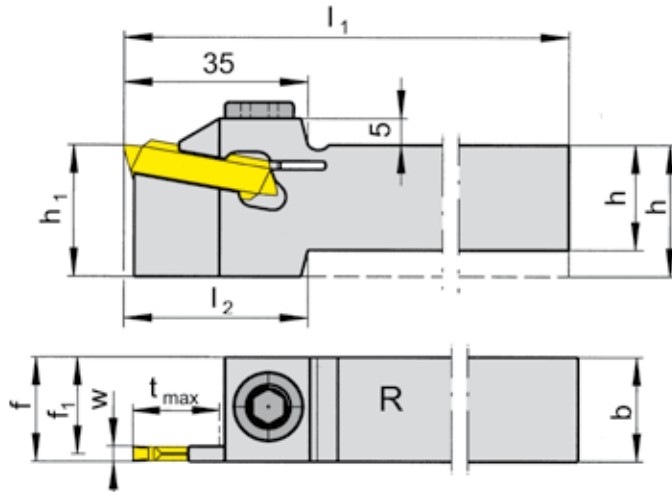
刀杆型号  
TOOLHOLDER Type

# 218



槽深可达 18.0 mm  
夹持范围 2.5 - 6.0 mm

Depth of groove up to 18.0 mm  
Clamping range 2.5 - 6.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229

G

产品型号 Part number	h	b	$l_1$	$h_1$	f	$f_1$	$l_2$	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L218-2020-02 R/L218-2525-02	20 25	20 25	150	25	$f_1+w/2$	18.55 23.55	35 -	18	02	2.5 - 3.0
R/L218-1616-03 R/L218-2020-03 R/L218-2525-03 R/L218-3225-03	16 20 25 32	16 20 25 25	150 150 150 170	25 25 25 32	$f_1+w/2$	14.55 18.55 23.55 23.55	45 35 - -	18	03	3.0 - 4.0
R/L218-2020-04 R/L218-2525-04 R/L218-3225-04	20 25 32	20 25 25	150 150 170	25 25 32	$f_1+w/2$	17.70 22.70 22.70	35 - -	18	04	4.0 - 5.0
R/L218-2020-05 R/L218-2525-05 R/L218-3225-05	20 25 32	20 25 25	150 150 170	25 25 32	$f_1+w/2$	17.20 22.20 22.20	35 - -	18	05	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

R/L 210...02最大切槽深度可达 $\varnothing$  60mm  
R/L 218...02 max. depth of groove up to  $\varnothing$  80 mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L218....	218.3	SW6.0DIN911

## 内冷型刀杆

Toolholder with through coolant supply

型号 **218**  
type



I关于“可移动高压系统”详见T28页

Information about "mobile high-pressure systems" see page T28

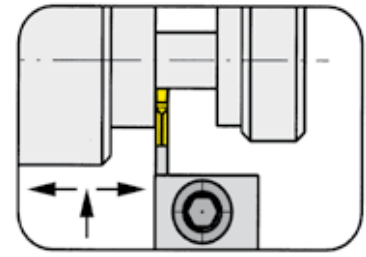
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀杆型号  
TOOLHOLDER Type

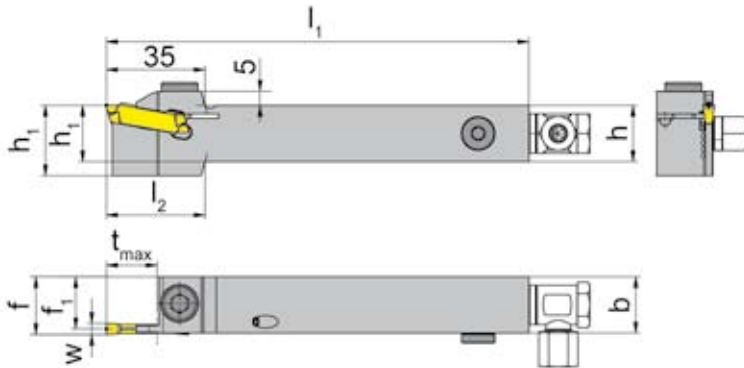
# 218



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.5 - 4.0 mm



配合刀片  
for use with Insert

型号 229  
Type N229  
S229

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

G

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218-2020-02-IK	20	20	150	25	f <sub>1</sub> +w/2	18.55	35	18	02	2.5 - 3.0
R/L218-2525-02-IK	25	25				23.55				
R/L218-1616-03-IK	16	16	150	25	f <sub>1</sub> +w/2	14.55	45	18	03	3.0 - 4.0
R/L218-2020-03-IK	20	20				18.55				
R/L218-2525-03-IK	25	25				23.55				
R/L218-3225-03-IK	32	25				23.55				

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

R/L 210...02最大切槽深度可达Ø 60mm  
R/L 218...02 max. depth of groove up to Ø 80 mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench	冷却接头 Coolant supply
R/L218....	218.3	SW6,0DIN911	004.00.61

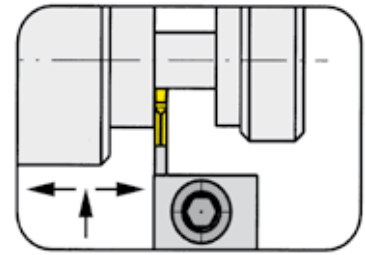
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

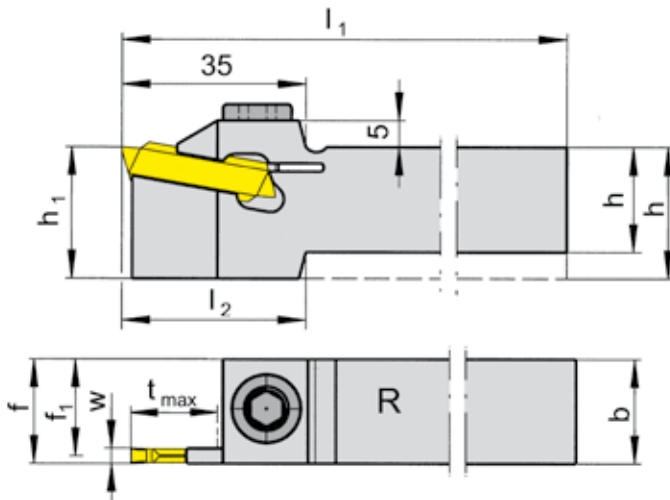
# 218



槽深可达 夹持范围	Depth of groove up to Clamping range	18.0 mm 6.1 - 8.0 mm
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配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218-2020-07	20	20	150	25		16.2	35			
R/L218-2525-07	25	25	150	25	f <sub>1</sub> +w/2	21.2	-	18	07	6.1 - 8.0
R/L218-3225-07	32	25	170	32		21.2	-			
R/L218-2525-08	25	25	150	25	f <sub>1</sub> +w/2	21.2	-	18	08	7.6 - 8.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L218....	218.3	SW6,0DIN911



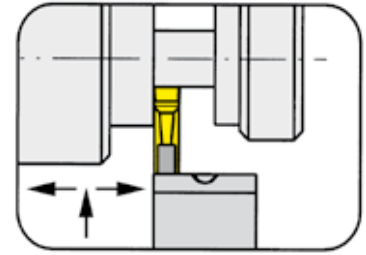
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

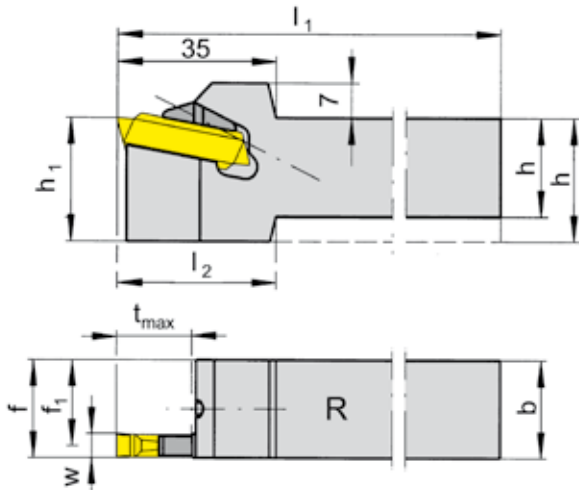
# 218



槽深可达 夹持范围	Depth of groove up to Clamping range	18.0 mm 8.1 - 10.4 mm
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配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218.2020.09	20	20	150	25		15.2	35			
R/L218.2525.09	25	25	150	25	f <sub>1</sub> +w/2	20.2	-	18	09	8.1 - 10.4
R/L218.3225.09	32	25	170	32		20.2	-			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
请注意夹持方式

**Note:**  
Please note type of clamp.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L218....09 R218....09	L218.9 R218.9	5.32T15P 5.32T15P	T15PQ T15PQ

G

# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)

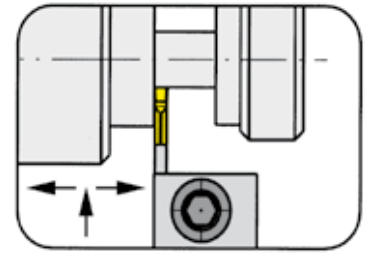


### 常规刀杆 型号

BASIC TOOLHOLDER Type

# 218

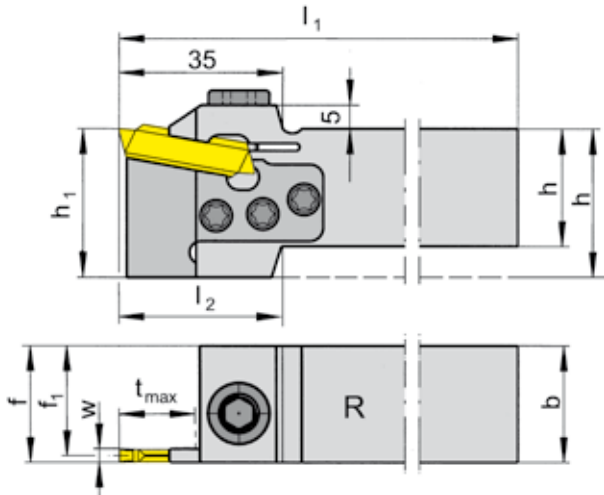
带可换刀夹  
with changeable cassette



槽深可达	Depth of groove up to	18.0 mm
夹持范围	Clamping range	3.0 - 8.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218.2525.K3	25	25	150	32	f <sub>1</sub> +w/2	23.55	35	18	03	3.0 - 4.0
R/L218.3225.K3	32	25	170	32	f <sub>1</sub> +w/2	23.55	-	18	03	3.0 - 4.0
R/L218.2525.K4	25	25	150	32	f <sub>1</sub> +w/2	22.70	35	18	04	4.0 - 5.0
R/L218.3225.K4	32	25	170	32	f <sub>1</sub> +w/2	22.70	-	18	04	4.0 - 5.0
R/L218.2525.K5	25	25	150	32	f <sub>1</sub> +w/2	22.20	35	18	05	5.1 - 6.0
R/L218.3225.K5	32	25	170	32	f <sub>1</sub> +w/2	22.20	-	18	05	5.1 - 6.0
R/L218.2525.K7	25	25	150	32	f <sub>1</sub> +w/2	21.20	35	18	07	6.1 - 8.0
R/L218.3225.K7	32	25	170	32	f <sub>1</sub> +w/2	21.20	-	18	07	6.1 - 8.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

常规刀杆 Basic toolholder	刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L218....K3	NK218.32.03	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L218....K4	NK218.32.04	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L218....K5	NK218.32.05	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L218....K7	NK218.32.07	030.0518.T20P	218.3	SW6,0DIN911	T20PQ

# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)

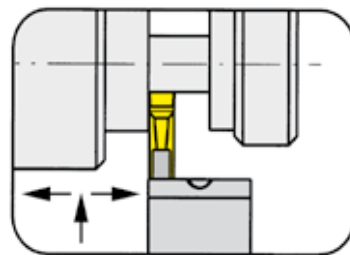


### 常规刀杆 型号

BASIC TOOLHOLDER Type

# 218

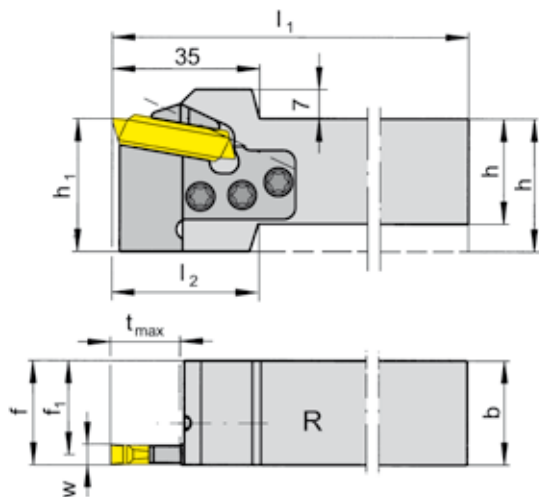
带可换刀夹  
with changeable cassette



槽深可达	Depth of groove up to	18.0 mm
夹持范围	Clamping range	8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218.2525.K9	25	25	150	32	f <sub>1</sub> +w/2	20.2	48	18	09	8.1 - 10.4
R/L218.3225.K9	32	25	170	32	f <sub>1</sub> +w/2	20.2	-	18	09	8.1 - 10.4

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项 :

请注意夹持方式

**Note:**

Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

常规刀杆 Basic toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L218....K9 R218....K9	NK218.32.09 NK218.32.09	L218.9 R218.9	T15PQ T15PQ	030.0518-T20P 030.0518-T20P	5.32T15P 5.32T15P	T20PQ T20PQ



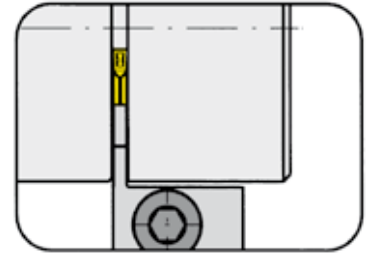
# 切槽 ( 外圆 )

## GROOVING (external)



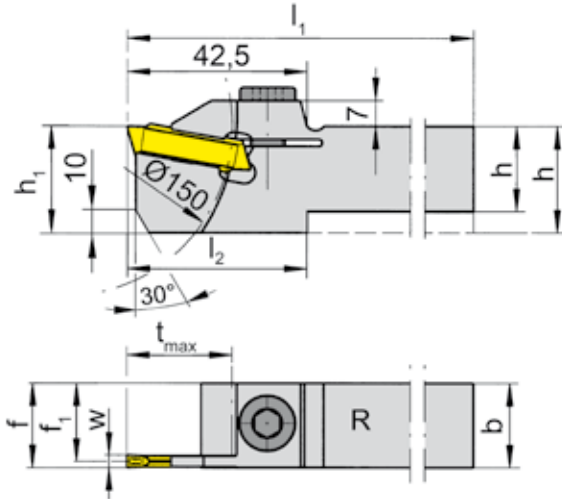
刀杆 型号  
TOOLHOLDER Type

# 226



槽深可达 25.0 mm  
夹持范围 3.0 - 6.0 mm

Depth of groove up to 25.0 mm  
Clamping range 3.0 - 6.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229

G

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L226-1616-03	16	16	150			18.55	52.5			
R/L226-2020-03	20	20	150	32	f <sub>1</sub> +w/2	18.55	42.5	25	03	3.0 - 4.0
R/L226-2525-03	25	25	150			23.55	-			
R/L226-3225-03	32	25	170			23.55	-			
R/L226-1616-04	16	16	150			13.70	52.5			
R/L226-2020-04	20	20	150	32	f <sub>1</sub> +w/2	17.70	42.5	25	04	4.0 - 5.0
R/L226-2525-04	25	25	150			22.70	-			
R/L226-3225-04	32	25	170			22.70	-			
R/L226-2020-05	20	20	150			17.20	42.5			
R/L226-2525-05	25	25	150	32	f <sub>1</sub> +w/2	22.20	42.5	25	05	5.1 - 6.0
R/L226-3225-05	32	25	170			22.20	-			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L226....	218.3	SW6.0DIN911

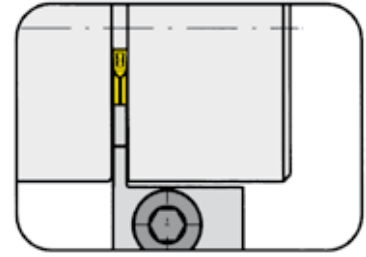
# 切槽 ( 外圆 )

## GROOVING (external)



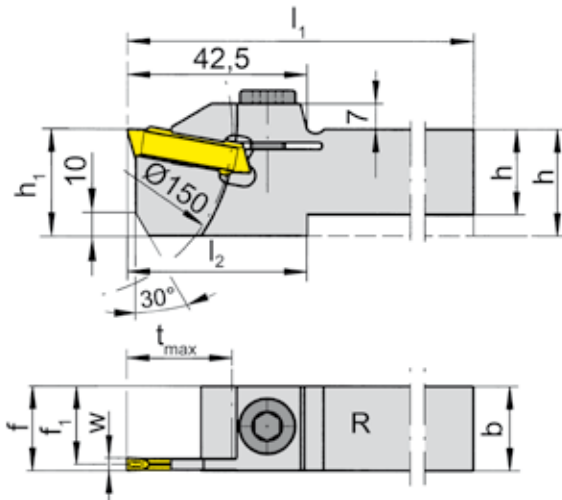
刀杆 型号  
TOOLHOLDER Type

# 226



槽深可达 25.0 mm  
夹持范围 6.1 - 8.0 mm

Depth of groove up to 25.0 mm  
Clamping range 6.1 - 8.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229

G

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L226-2525-07	25	25	150	32	f <sub>1</sub> +w/2	21.2	42.5	25	07	6.1 - 8.0
R/L226-3225-07	32	25	170	32	f <sub>1</sub> +w/2	21.2	-	25	07	6.1 - 8.0
R/L226-2525-08	25	25	150	32	f <sub>1</sub> +w/2	20.2	42.5	25	08	7.6 - 8.0
R/L226-3225-08	32	25	170	32	f <sub>1</sub> +w/2	21.2	-	25	08	7.6 - 8.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L226....	218.3	SW6,0DIN911

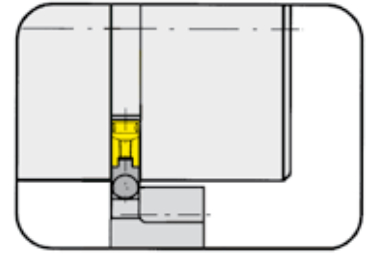
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 226

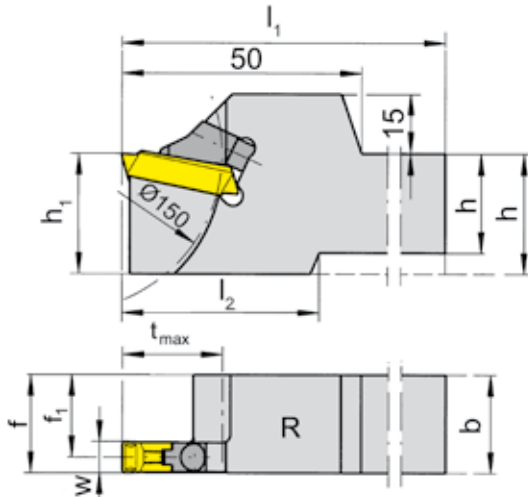


槽深可达 25.0 mm  
夹持范围 8.1 - 10.4 mm

Depth of groove up to 25.0 mm  
Clamping range 8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L226.2525.09	25	25	150	32	f <sub>1</sub> +w/2	20.2	42.5	25	09	8.1 - 10.4
R/L226.3225.09	32	25	170	32	f <sub>1</sub> +w/2	20.2	-	25	09	8.1 - 10.4

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L226....	020.1008.0041	5.32T15P	T15PQ

# 切槽和侧车削 ( 外圆 )

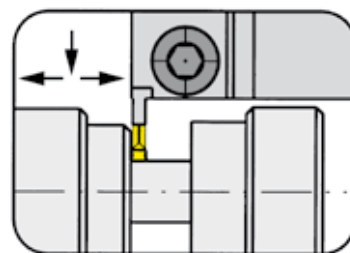
## GROOVING and SIDE TURNING (external)



### 刀杆 型号

TOOLHOLDER Type

# 219



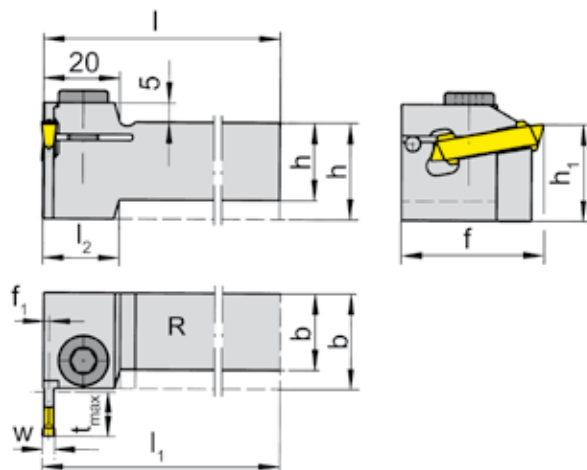
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

15.0 mm  
3.0 - 8.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	l <sub>2</sub>	f	f <sub>1</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L219.2020.03 R/L219.2525.03	20 25	25	20 25	150	l-f <sub>1</sub> +w/2	20 -	37	1.45	11	03	3.0 - 4.0
R/L219.2020.04 R/L219.2525.04	20 25	25	20 25	150	l-f <sub>1</sub> +w/2	20 -	37	2.30	11	04	4.0 - 5.0
R/L219.2020.05 R/L219.2525.05	20 25	25	20 25	150	l-f <sub>1</sub> +w/2	23 -	45	2.80	15	05	5.1 - 6.0
R/L219.2020.07 R/L219.2525.07	20 25	25	20 25	150	l-f <sub>1</sub> +w/2	23 -	45	3.80	15	07	6.1 - 8.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L219.2...	218.3	SW6,0DIN911



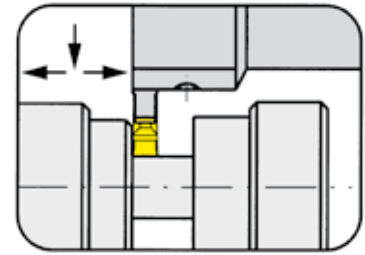
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀杆型号  
TOOLHOLDER Type

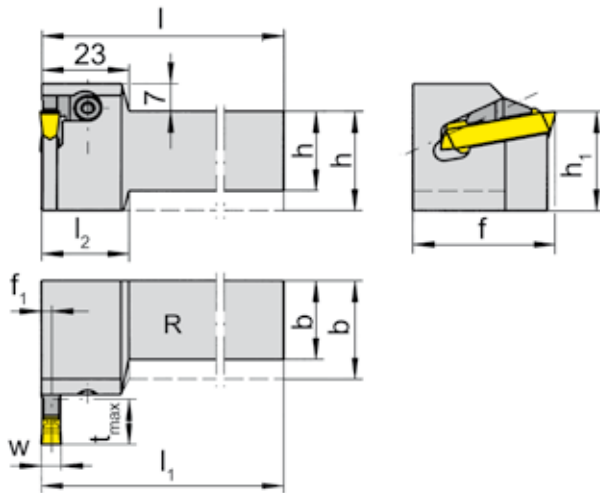
# 219



槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	l <sub>2</sub>	f	f <sub>1</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L219.2020.09	20	25	20	150	$l-f_1+w/2$	23	45	4.8	15	09	8.1- 10.4
R/L219.2525.09	25	25	25	150	$l-f_1+w/2$	-	45	4.8	15	09	8.1- 10.4

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项:  
请注意夹持方式

Note:  
Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L219.2020.09	R218.9.32		5.32.3T15	T15PQ
L219.2525.09	R218.9.32	T15PQ	5.32.3T15	
R219.2020.09	L218.9.32		5.32.3T15	T15PQ
R219.2525.09	L218.9.32	T15PQ	5.32.3T15	



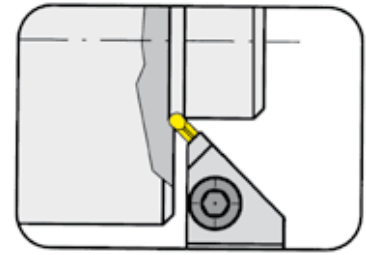
# 切退刀槽 ( 外圆 )

## GROOVING CORNER RELIEFS (external)



刀杆 型号  
TOOLHOLDER Type

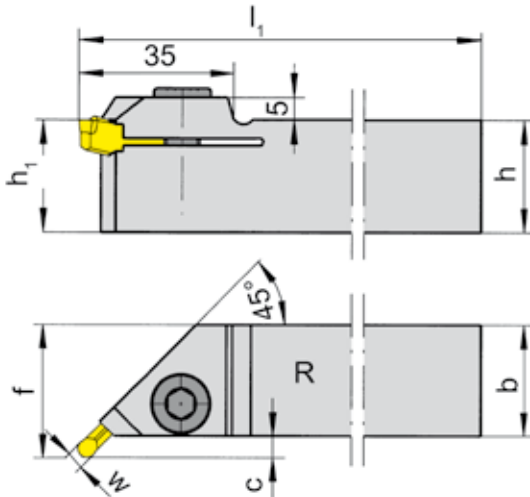
# 225



槽宽	Width of groove	3.0 - 6.0 mm
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配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	c	$D_{min}$	槽宽 Width of groove
R/L225.2525.04	25	25	150	25	30.0	5.0	50	3.0 - 5.0
R/L225.2525.05	25	25	150	25	30.5	5.5	50	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

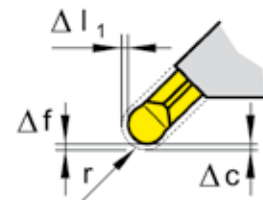
尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

半径r的相关修正因素  $\Delta l_1$ ,  $\Delta c$  和  $\Delta f$   
Revision factor  $\Delta l_1$ ,  $\Delta c$  and  $\Delta f$  in relation to radius r

r	$\Delta l_1$	$\Delta c$	$\Delta f$
2,5 - 3,0	0,000	0,000	0,000
2,0	-0,147	-0,147	-0,147
1,5	-0,293	-0,293	-0,293



附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L225.2525.0...	218.3	SW6,0DIN911

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

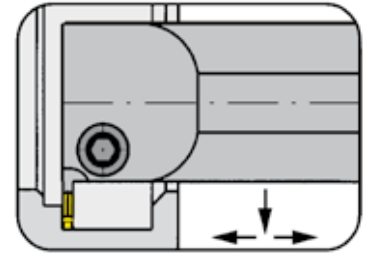


### 刀杆 型号

TOOLHOLDER Type

# 213

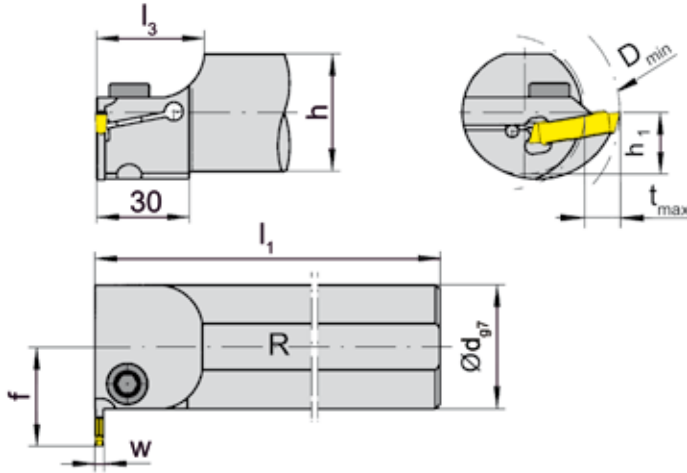
短悬伸  
Short style



孔径Ø 自	Bore Ø from	46.0 mm
槽深可达	Depth of groove up to	11.5 mm
夹持范围	Clamping range	3.0 - 6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>3</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L213.0032.0.03	32	150	35.0	30	15	28	46	11.5	03	3.0 - 4.0
R/L213.0040.0.03	40	180	39.4	38	19	32	54			
R/L213.0032.0.04	32	150	35.0	30	15	28	46	11.5	04	4.0 - 5.0
R/L213.0040.0.04	40	180	39.4	38	19	32	54			
R/L213.0032.0.05	32	150	35.0	30	15	28	46	11.5	05	5.1 - 6.0
R/L213.0040.0.05	40	180	39.4	38	19	32	54			

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L213.00...	218.3	SW6,0DIN911

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

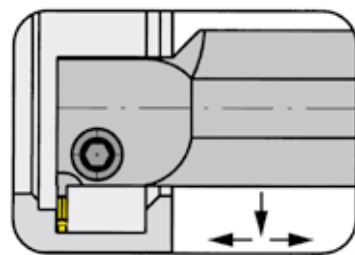


### 刀杆型号

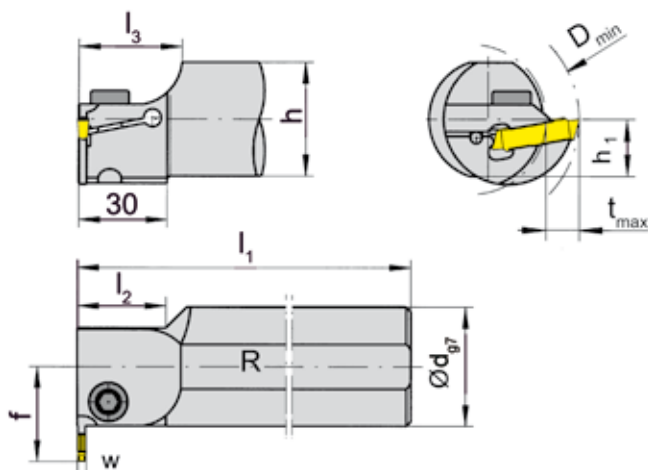
TOOLHOLDER Type

# 213

短悬伸  
Short style



孔径Ø 自	Bore Ø from	38.0 mm
槽深可达	Depth of groove up to	15.0 mm
夹持范围	Clamping range	3.0 - 8.0 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合可转位刀片  
for use with Indexable insert

型号 229  
Type S229

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L213.0025.03	25	150	-	31.8	23	11.5	24.5	38	7.5	03	3.0 - 4.0
R/L213.0032.03	32	150	30	35.0	30	15.0	28.0	38	7.5		
R/L213.0040.03	40	180	30	37.4	38	19.0	32.0	50	11.5		
R/L213.0050.03	50	200	30	39.1	47	23.5	40.5	60	15.0	04	4.0 - 5.0
R/L213.0025.04	25	150	-	31.8	23	11.5	24.5	38	7.5		
R/L213.0032.04	32	150	30	35.0	30	15.0	28.0	38	7.5		
R/L213.0040.04	40	180	30	37.4	38	19.0	32.0	50	11.5	05	5.1 - 6.0
R/L213.0050.04	50	200	30	39.1	47	23.5	40.5	60	15.0		
R/L213.0032.05	32	150	-	35.0	30	15.0	28.0	46	11.5		
R/L213.0040.05	40	180	30	35.0	38	19.0	32.0	50	11.5	07	6.1 - 8.0
R/L213.0050.05	50	200	30	40.0	47	23.5	40.5	60	15.0		
R/L213.0040.07	40	180	30	35.0	38	19.0	32.0	50	11.5		
R/L213.0050.07	50	200	30	40.0	47	23.5	40.5	60	15.0		

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

请注意刀杆柄径为Ø 25或32mm

当孔径大于D<sub>min</sub> 46 mm时可以达到最大切深t<sub>max</sub> = 11.5 mm

**Note toolholder with shank-Ø 25 or 32 mm**

The full depth of cut t<sub>max</sub> = 11,5 mm will be reached from D<sub>min</sub> 46 mm

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L213.00...	<b>218.3</b>	<b>SW6,0DIN911</b>



# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

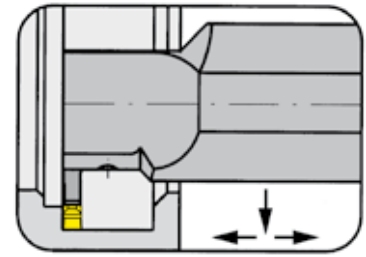


### 刀杆 型号

TOOLHOLDER Type

# 213

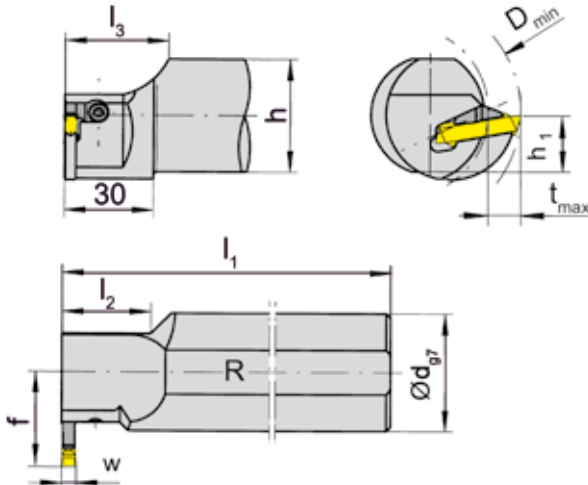
短悬伸  
Short style



孔径Ø 自	Bore Ø from	50.0 mm
槽深可达	Depth of groove up to	15.0 mm
夹持范围	Clamping range	8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L213.0040.09	40	180	30	35	38	19.0	32.0	50	11.5	09	8.1 - 10.4
R/L213.0050.09	50	200		40	47	23.5	40.5	60	15.0		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项:  
请注意夹持方式

**Note:**  
Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L213.00...09 R213.00...09	R218.9 L218.9	5.32T15P 5.32T15P	T15PQ T15PQ

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

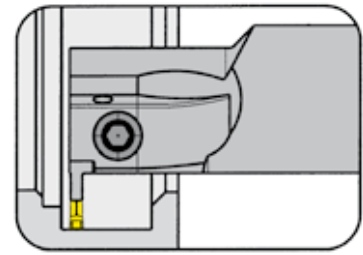


### 刀杆型号

TOOLHOLDER Type

# 213

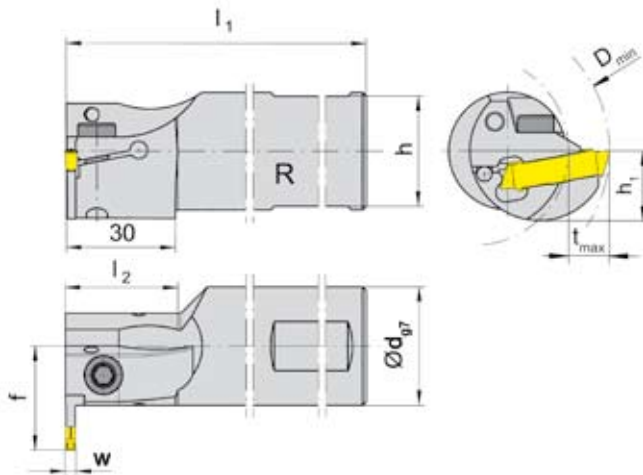
短悬伸  
Short style



孔径Ø 自	Bore Ø from	38.0 mm
槽深可达	Depth of groove up to	11.5 mm
夹持范围	Clamping range	3.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

G

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L213.0025.03IK	25	150	-	23	11.5	24.5	38	7.5		
R/L213.0032.03IK	32	150	30	30	15.0	28.0	38	7.5	03	3.0 - 4.0
R/L213.0040.03IK	40	180	30	38	19.0	32.0	50	11.5		
R/L213.0025.04IK	25	150	-	23	11.5	24.5	38	7.5	04	4.0 - 5.0
R/L213.0032.04IK	32	150	30	30	15.0	28.0				

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

请注意刀杆柄径为Ø 25或32mm

当孔径大于D<sub>min</sub> 46 mm时可以达到最大切深t<sub>max</sub> =11.5 mm

**Note toolholder with shank-Ø 25 or 32 mm**

The full depth of cut t<sub>max</sub> = 11,5 mm will be reached from D<sub>min</sub> 46 mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L213.00...	DIN912-M6x14	SW5.0DIN911

# 切槽和侧车削 (内圆)

GROOVING and SIDE TURNING (internal)

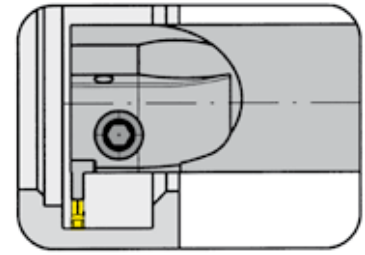


## 刀杆 型号

TOOLHOLDER Type

# 213

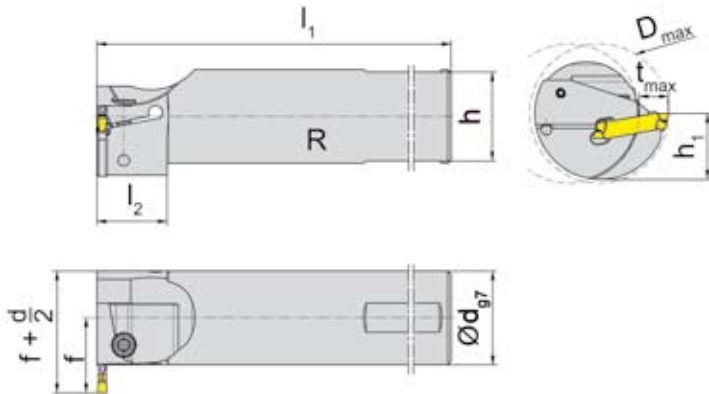
短悬伸  
Short style



孔径Ø 自	Bore Ø from	46.0 mm
槽深可达	Depth of groove up to	11.5 mm
夹持范围	Clamping range	3.0 - 6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



G

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L213.0032.0.03IK	32	150	30	15	28	46	11.5	03	3.0 - 4.0
R/L213.0032.0.04IK	32	150	30	15	28	46	11.5	04	4.0 - 5.0
R/L213.0040.0.04IK	40	180	38	19	32	54	11.5	04	4.0 - 5.0
R/L213.0040.0.05IK	40	180	38	19	32	54	11.5	05	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L213.00...	DIN912-M6x14	SW5.0DIN911

# 切槽和侧车削 (内圆)

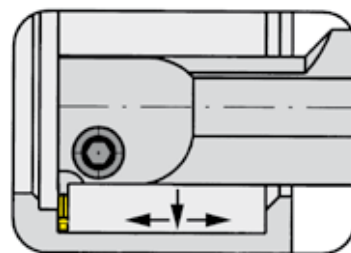
## GROOVING and SIDE TURNING (internal)



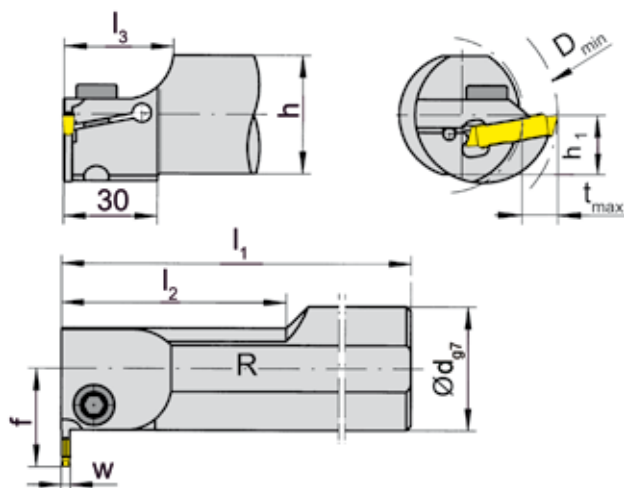
### 刀杆 型号

# 214

TOOLHOLDER Type



孔径Ø 自	Bore Ø from	38.0 mm
槽深可达	Depth of groove up to	15.0 mm
夹持范围	Clamping range	3.0 - 8.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L214.0032.03	32	200	70	35	30	15.0	28.0	38	7.5	03	3.0 - 4.0
R/L214.0040.03	40	250	80	35	38	19.0	32.0	50	11.5		
R/L214.0050.03	50	250	100	40	47	23.5	40.5	60	15.0		
R/L214.0032.04	32	200	70	35	30	15.0	28.0	38	7.5	04	4.0 - 5.0
R/L214.0040.04	40	250	80	35	38	19.0	32.0	50	11.5		
R/L214.0050.04	50	250	100	40	47	23.5	40.5	60	15.0		
R/L214.0032.05	32	200	-	35	30	15.0	28.0	46	11.5	05	5.1 - 6.0
R/L214.0040.05	40	250	80	35	38	19.0	32.0	50	11.5		
R/L214.0050.05	50	250	100	40	47	23.5	40.5	60	15.0		
R/L214.0040.07	40	250	80	35	38	19.0	32.0	50	11.5	07	6.1 - 8.0
R/L214.0050.07	50		100	40	47	23.5	40.5	60	15.0		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

请注意刀杆柄径为Ø 25或32mm

当孔径大于D<sub>min</sub> 46 mm时可以达到最大切深t<sub>max</sub> = 11.5 mm

**Note toolholder with shank-Ø 25 or 32 mm**

The full depth of cut t<sub>max</sub> = 11,5 mm will be reached from D<sub>min</sub> 46 mm

可根据需要提供其他尺寸刀杆或内冷型刀杆

Further shank sizes or with through coolant supply upon request.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L214.00...	<b>218.3</b>	<b>SW6,0DIN911</b>



# 切槽和侧车削 (内圆)

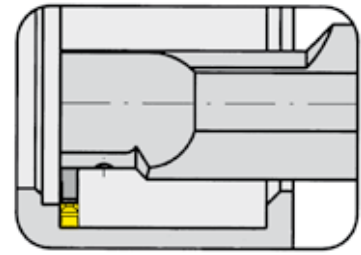
## GROOVING and SIDE TURNING (internal)



### 刀杆型号

TOOLHOLDER Type

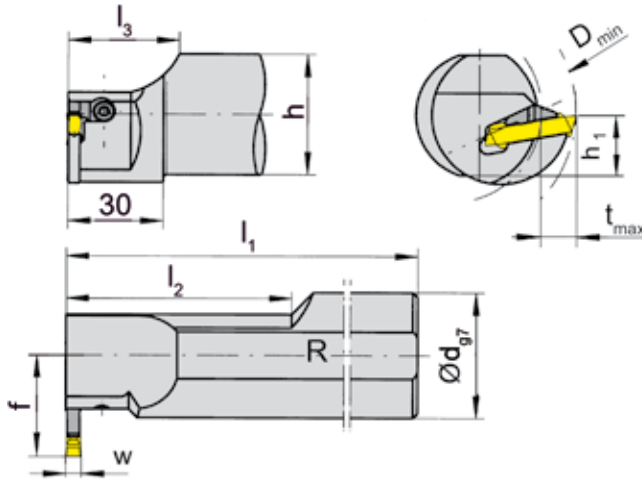
# 214



孔径Ø 自	Bore Ø from	50.0 mm
槽深可达	Depth of groove up to	15.0 mm
夹持范围	Clamping range	8.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L214.0040.09	40	250	80	35	38	19.0	32.0	50	11.5	09	8.1 - 10.4
R/L214.0050.09	50		100	40	47	23.5	40.5	60	15.0		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

可根据需要提供其他尺寸刀杆或内冷型刀杆  
Further shank sizes or with through coolant supply upon request.

注意事项:  
请注意夹持方式

Note:  
Please note type of clamp.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
L214.00...09	R218.9	5.32T15P	T15PQ
R214.00...09	L218.9	5.32T15P	T15PQ



# 切槽和侧车削 (内圆)

GROOVING and SIDE TURNING (internal)

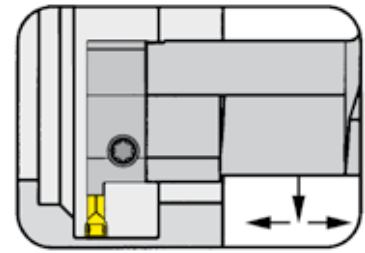


## 常规刀杆 型号

BASIC TOOLHOLDER Type

## B229

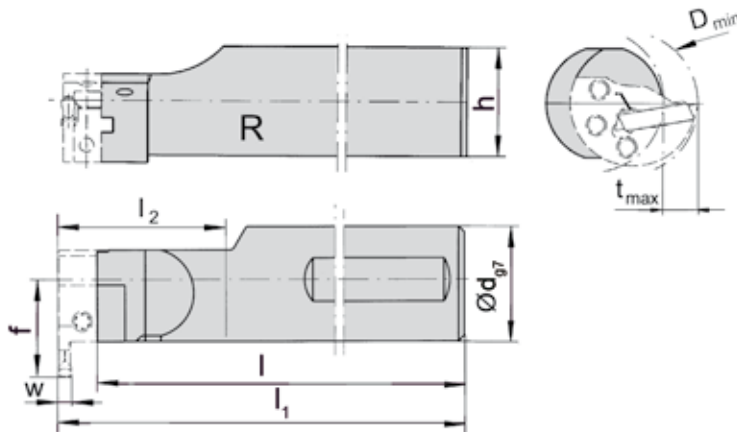
无刀夹  
without cassette



孔径	Bore Ø	50 / 60 mm
槽深可达	Depth of groove up to	12 / 15 mm
槽宽	Width of groove	3.0 - 6.0 mm

配合刀夹  
for use with Cassette

型号 BK229  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version



G

产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	h	f
R/LB229.0040.1.K2	40	166.3	187	30	38	35.5
R/LB229.0040.2.K2	40	186.3	200	60	38	35.5

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项:  
尺寸D<sub>min</sub>, t<sub>max</sub>和w见刀夹部分

Note:  
Dimensions for D<sub>min</sub>, t<sub>max</sub> see cassettes

## 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB229.0040....	030.0518.T20P	T20PQ

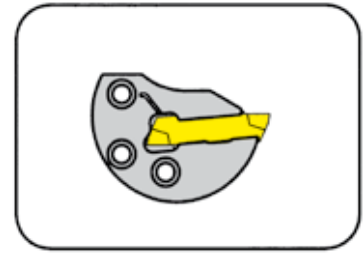
# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)



刀夹 型号  
CASSETTE Type

# BK229



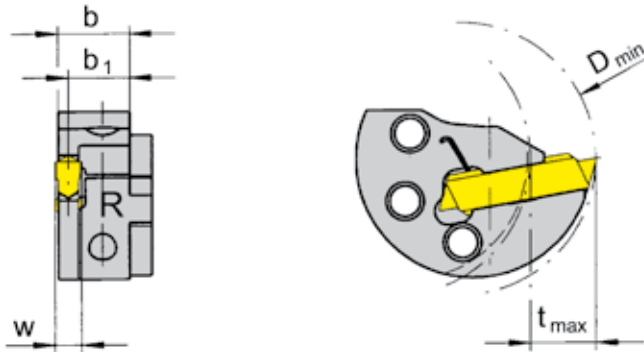
孔径Ø 自	Bore Ø from	50 / 60 mm
槽深	Depth of groove	12 / 15 mm
夹持范围	Clamping range	3.0 - 6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
50	12
60	15



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	D <sub>min</sub>	t <sub>max</sub>	b <sub>1</sub>	b	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LBK229.0050.03	60	15	13.0	14.25	50	12	03	3.00 - 4.00
R/LBK229.0050.04	60	15	12.5	14.20	50	12	04	4.00 - 5.09
R/LBK229.0050.05	60	15	11.5	13.85	50	12	05	5.10 - 6.00

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

右手型刀夹配合右手型常规刀杆,左手型刀夹配合左手型常规刀杆  
Use right hand cassettes in right hand basic toolholders and left hand cassettes in left hand basic toolholders.

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LBK229.0050.0...	5.13T20EP	T20PQ

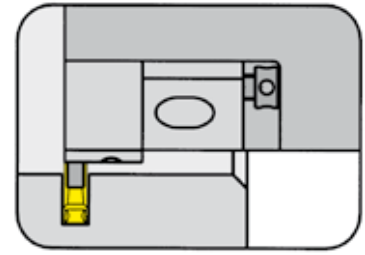
# 切槽 (内圆)

## GROOVING (internal)



刀夹 型号  
CARTRIDGE Type

# 257



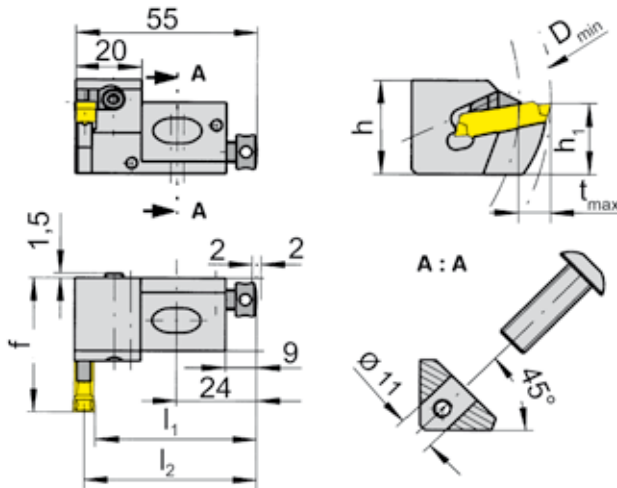
孔径Ø 自	Bore Ø from	80 / 120 mm
槽深	Depth of groove	10 / 15 mm
夹持范围	Clamping range	5.1 - 10.4 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
80	10
120	15



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h <sub>1</sub>	f	h	l <sub>1</sub>	l <sub>2</sub>	规格 Size	夹持范围 Clamping range
R/L257.2222.05	22	42	29	l <sub>2</sub> -w/2	52.2	05	5.1 - 6.0
R/L257.2222.07	22	42	29	l <sub>2</sub> -w/2	51.2	07	6.1 - 8.0
R/L257.2222.09	22	42	29	l <sub>2</sub> -w/2	50.2	09	8.1 - 10.4

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

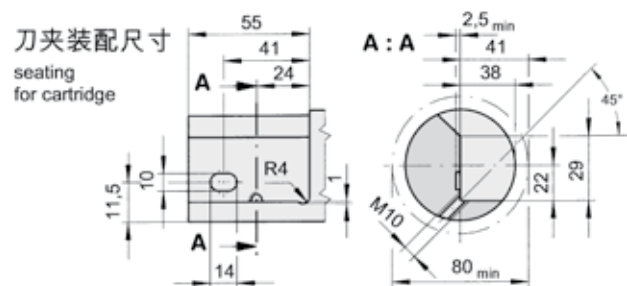
尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
请注意夹持方式

Ordering note:  
Please note type of clamp.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.



刀夹 Cartridge	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	螺钉 Screw	螺钉 Screw	轴向调节螺钉 Axial Setscrew	径向调节螺钉 Radial Setscrew	扳手 Wrench
R/L257...05			0.30.208		218-3	6.12.020	4.08.913	SW6-0DIN911
L257...07	R218.5.7.32	T15PQ	0.30.208	5.32.3T15P		6.12.020	4.08.913	
L257...09	R218.9.32	T15PQ	0.30.208	5.32.3T15P		6.12.020	4.08.913	
R257...07	L218.5.7.32	T15PQ	0.30.208	5.32.3T15P		6.12.020	4.08.913	
R257...09	L218.9.32	T15PQ	0.30.208	5.32.3T15P		6.12.020	4.08.913	



# 切槽 (内圆)

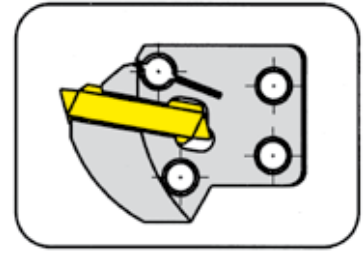
## GROOVING (internal)



### 刀夹 型号

CASSETTE Type

# 050

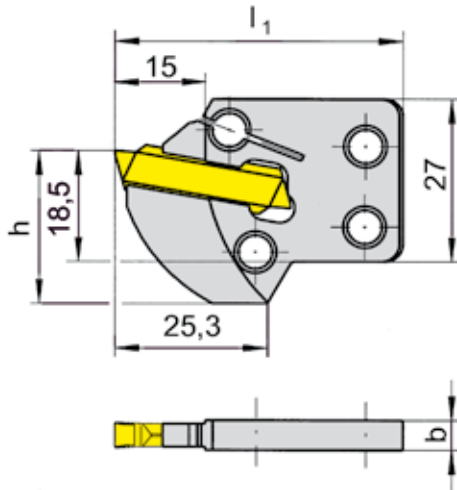


孔径Ø 自	Bore Ø from	62.0 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 5.0 mm

用于210系列安装刀夹的常规刀杆上 ( G5页 )  
for basic toolholder type 210 with cassette (page G5)

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
62	10
65	11
70	13
≥ 80	14

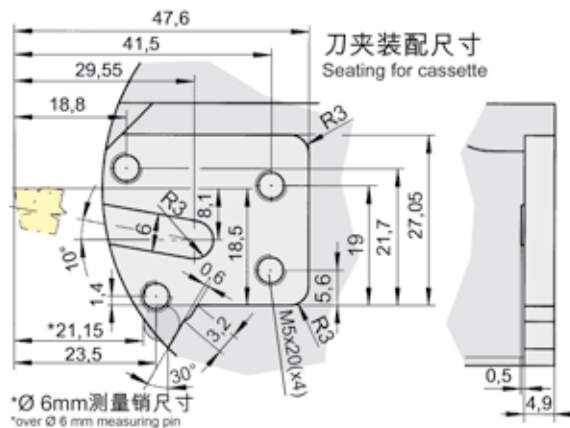
G

产品型号 Part number	l <sub>1</sub>	h	b	规格 Size	夹持范围 Clamping range
050.1827.0071	47	25.5	4.9	03	3.0 - 4.0
050.1827.0009	47	25.5	4.9	04	4.0 - 5.09

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.



附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
050.1827.00...	030.0518.T20P	T20PQ

可转位刀片

精密研磨和  
烧结断屑槽



G

**Indexable inserts**

**precision or peripheral ground  
with sintered geometry**

可转位刀片 型号  
INDEXABLE INSERT type

### S229...3.

精密烧结  
precision sintered



## 断屑槽 Geometry .3.

适用于所有材料有切屑成型的断屑槽。  
Geometry with chip forming for all materials.

### 特点 Characteristics

- 出色的切屑控制
- 适用于高强度的高合金钢
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 出色的切屑控制保证了生产的安全性

### 应用 Applications

- 切槽:  
槽深 可达 25 mm
- 侧车削:  
切深  $a_p$  可达 4 mm\*

- Grooving:  
Depth of groove up to 25 mm
- Side turning:  
Depth of cut  $a_p$  up to 4 mm\*

- excellent swarf control
- suitable for high alloy- high strength steels
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

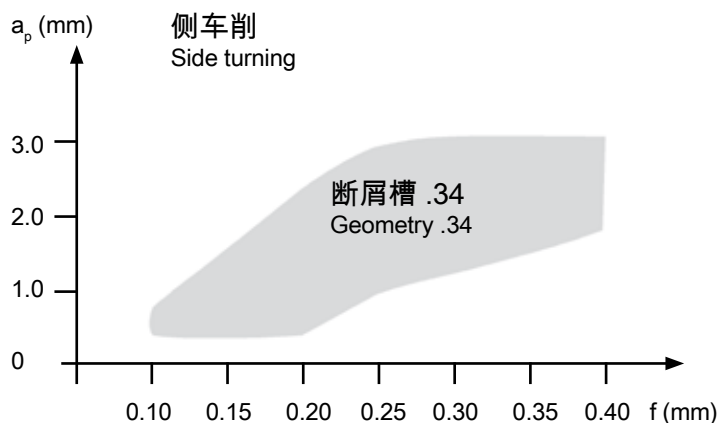
### 进给率 $f$ Feed rate $f$

- 切槽: 0.15 可达 0.25 mm/转\*
- 侧车削: 可达 0.4 mm/转\*
- Grooving: 0.15 up to 0.25 mm/rev\*
- Side turning: up to 0.4 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手型刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.



229.0500.34加工16MnCr5时切屑控制图表

Chip control graph S229.0500.34 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

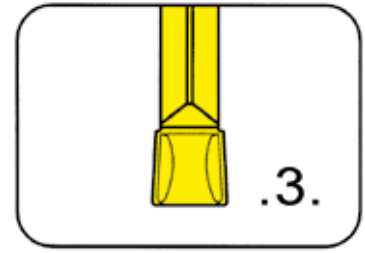


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

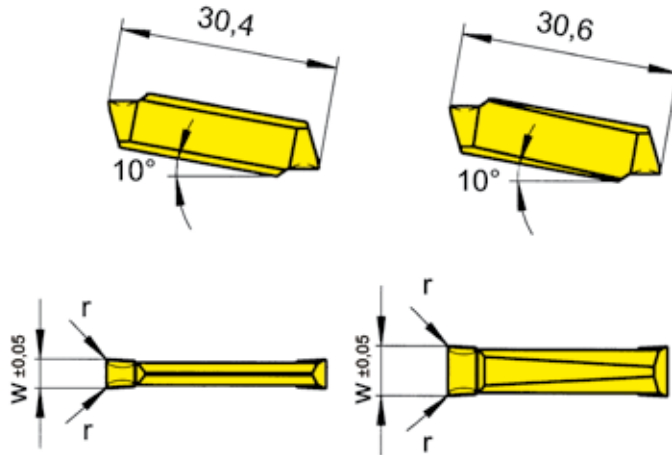
带断屑槽  
with chip former



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 10.0 mm

精密烧结

precision sintered



宽度3.0-5.0mm  
Width 3,0 - 5,0 mm

宽度6.0-10.0mm  
Width 6,0 - 10,0 mm

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

G

产品型号 Part number	W	r	规格 Size	硬质合金牌号									
				MG12	H54	TN32	TN35	TI22	TI25	TF42	TF45	AS62	AS66
S229.0300.32	3	0.2	03	▲	▲	▲	▲	△	▲		▲	▲	▲
S229.0300.34		0.4			▲	▲	▲	△	▲		▲	▲	▲
S229.0400.32	4	0.2	03 / 04		▲	▲	▲	△	▲		▲	▲	▲
S229.0400.34		0.4			▲	▲	▲		▲	▲	▲	▲	▲
S229.0500.34	5	0.4	04			▲	▲	▲	▲		▲	▲	▲
S229.0500.36		0.6					▲	▲	▲	▲		▲	▲
S229.0600.34	6	0.4	05			▲	▲	△	▲		▲	▲	▲
S229.0600.38		0.8					▲	▲	▲	▲		▲	▲
S229.0700.36	7	0.6	07				▲		▲			▲	▲
S229.0800.36	8	0.6				▲	▲	▲	▲			▲	▲
S229.0800.38	8	0.8				▲	▲	▲	▲			▲	▲
S229.0800.3K	8	1.2											
S229.1000.36	10	0.6	09				▲	▲	▲			▲	▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	○	●	●	●	●	●	●	●	●
● 主要应用 / main recommendation				M	●	●	●	●	●	●	●	●	○
○ 可选推荐 / alternative recommendation				K	●	●	●	●	●	●	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●	●	●	●	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●	●	●	●	●	●	○
■ 钎焊/金属陶瓷 / brazed/Cermet				H									

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



可转位刀片 型号  
INDEXABLE INSERT type

# S229...5.

精密烧结  
precision sintered



## 断屑槽 Geometry .5.

适用于中等强度材料的易切削断屑槽。  
Easy cutting geometry for materials with medium strength.

### 特点 Characteristics

- 在很宽的进给范围内都可形成很好的切屑
- 易切削-低功率要求
- 减小切屑宽度并保证侧面良好的表面粗糙度
- 良好的切屑控制保证了生产的安全性

### 应用 Applications

- 切槽:  
槽深 可达 25 mm
- 侧车削:  
切深  $a_p$  可达 4 mm\*

- Grooving:  
Depth of groove up to 25 mm
- Side turning:  
Depth of cut  $a_p$  up to 4 mm\*

- excellent swarf on a wide feed range
- easy cutting - low power requirement
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

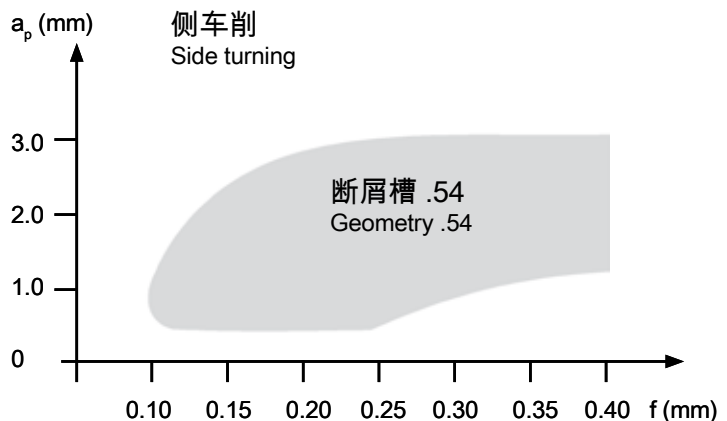
### 进给率 f Feed rate f

- 切槽: 可达 0.45 mm/转\*
- 侧车削: 可达 0.6 mm/转\*
- Grooving: up to 0.45 mm/rev\*
- Side turning: up to 0.6 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手型刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.



229.0500.54加工16MnCr5时切屑控制图表

Chip control graph S229.0500.54 material 16MnCr5



# 切槽和侧车削

## GROOVING and SIDE TURNING

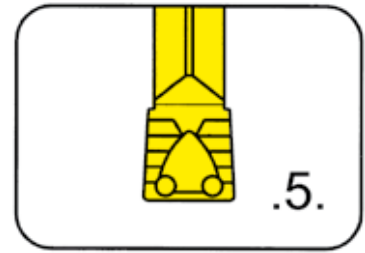


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming

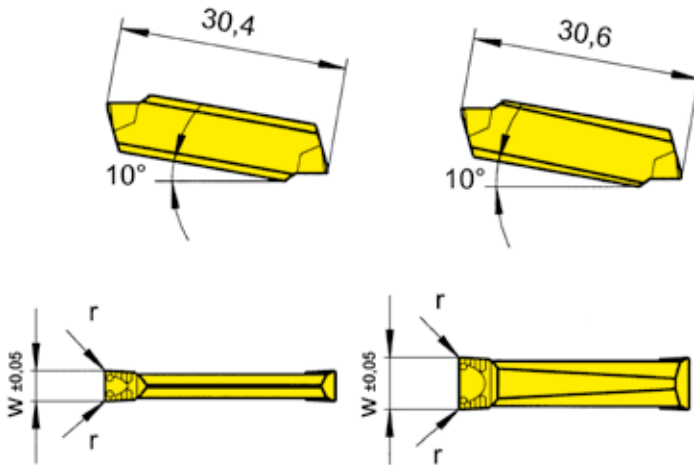


槽深可达  
槽宽

Depth of groove up to 25.0 mm  
Width of groove 3.0 - 10.0 mm

精密烧结

precision sintered



宽度3.0-5.0mm  
Width 3,0 - 5,0 mm

宽度6.0-10.0mm  
Width 6,0 - 10,0 mm

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

G

产品型号 Part number	W	r	规格 Size	P20	H54	TN32	TN35	TI22	TI25	TF42	TF45	AS62	
S229.0300.52	3	0.2	03			▲	▲	▲	▲		▲	▲	
S229.0300.54		0.4					▲	▲	▲	▲		▲	▲
S229.0400.52	4	0.2	03 / 04			▲	▲	▲	▲		▲	▲	
S229.0400.54		0.4					▲	▲	▲	▲		▲	▲
S229.0500.54	5	0.4	04			▲	▲	▲	▲		▲	▲	
S229.0500.56		0.6					▲	▲	▲	▲		▲	▲
S229.0600.54	6	0.4	05			▲	▲		▲		▲	▲	
S229.0600.56		0.6					▲	▲		▲		▲	▲
S229.0600.58		0.8						▲	▲			▲	▲
S229.0700.56	7	0.6	07					▲				▲	
S229.0800.56	8	0.6				▲		▲				▲	
S229.0800.58	8	0.8						▲			▲	▲	
S229.0800.5K	8	1.2						▲			▲	▲	
S229.1000.56	10	0.6	09					▲					
▲ 库存 / on stock    Δ 4周 / 4 weeks				P		•	•	•	•	•	•	•	
● 主要应用 / main recommendation				M			•		•		•		
○ 可选推荐 / alternative recommendation				K			•		•		•		
■ 无涂层牌号 / uncoated grades				N			•		•		•		
■ 涂层牌号 / coated grades				S			•		•		•		
■ 钎焊/金属陶瓷 / brazed/Cermet				H									

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

可转位刀片 型号  
INDEXABLE INSERT type

# S229...A.

精密烧结  
precision sintered



## 断屑槽 Geometry .A.

适用于中等强度材料具有优异断屑效果的断屑槽  
Geometry with excellent chip breaking for materials with medium strength

### 特点 Characteristics

- 在很宽的进给范围内都可形成很好的切屑
- 良好的切屑控制，包括切断加工
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 良好的切屑控制保证了生产的安全性

### 应用 Applications

- 切槽：  
槽深 可达 25 mm
- 侧车削：  
切深  $a_p$  可达 2.5 mm\*
- Grooving:  
Depth of groove up to 18 mm
- Side turning:  
Depth of cut  $a_p$  up to 2.5 mm\*



- excellent swarf on a wide feed range
- excellent swarf control, also by partial cutting
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

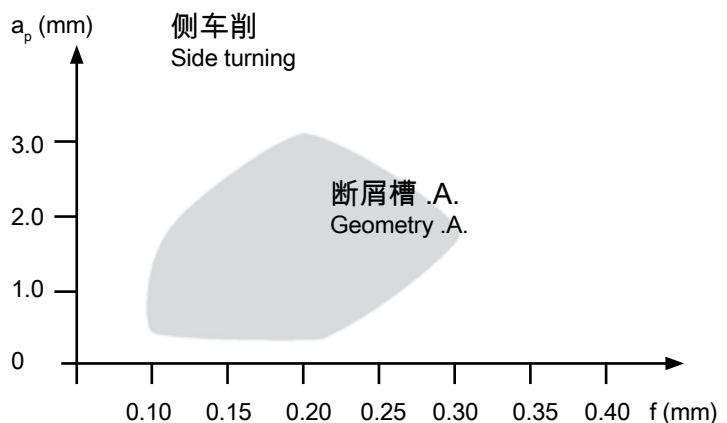
### 进给率 f Feed rate f

- 切槽： 可达 0.3 mm/转\*
- 侧车削： 可达 0.3 mm/转\*
- Grooving: up to 0.3 mm/rev\*
- Side turning: up to 0.3 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手型刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.



229.0500.A4加工16MnCr5时切屑控制图表

Chip control graph S229.0500.A4 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

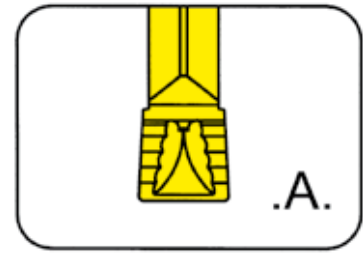


### 可转位刀片 型号

INDEXABLE INSERT Type

### S229

带断屑槽  
with chip forming

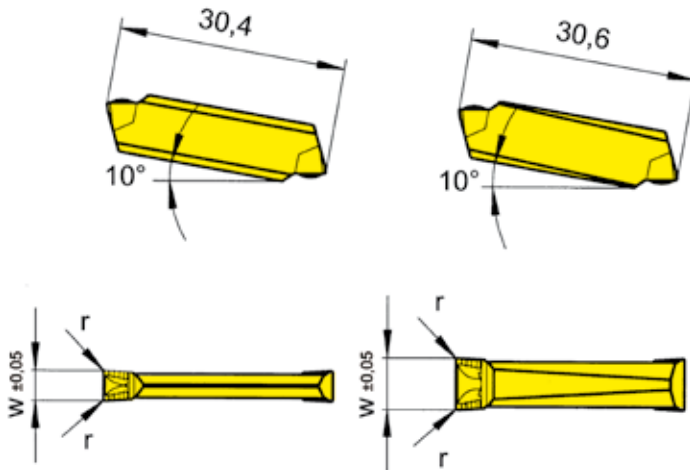


槽深可达  
槽宽

Depth of groove up to 25.0 mm  
Width of groove 3.0 - 10.0 mm

精密烧结

precision sintered



宽度3.0-5.0mm  
Width 3,0 - 5,0 mm

宽度6.0-10.0mm  
Width 6,0 - 10,0 mm

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size	P20	TN32	TN35	TI22	TI25	TF42	TF45	AS62
S229.0300.A2 S229.0300.A4	3	0.2 0.4	03		▲	▲	▲	▲		▲	▲
S229.0400.A2 S229.0400.A4	4	0.2 0.4	03 / 04		▲	▲	▲	▲	▲		▲
S229.0500.A4 S229.0500.A6	5	0.4 0.6	04		▲	▲	▲			▲	▲
S229.0600.A4 S229.0600.A8	6	0.4 0.8	05		▲	▲	▲	▲	▲	▲	▲
S229.0700.A6 S229.0800.A6 S229.0800.A8 S229.0800.AK	7 8 8 8	0.6 0.6 0.8 1.2	07		▲ ▲		▲		▲		▲
S229.1000.A6 S229.1000.A8	10	0.6 0.8	09								▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	●	●	●	●	●	●	●
● 主要应用 / main recommendation				M		●		●		●	
○ 可选推荐 / alternative recommendation				K		●		●		●	
■ 无涂层牌号 / uncoated grades				N		●		●		●	
■ 涂层牌号 / coated grades				S		●		●		●	
■ 钎焊/金属陶瓷 / brazed/Cermet				H							

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in right and left hand toolholders.

# 切槽和切断

## GROOVING and PARTING OFF

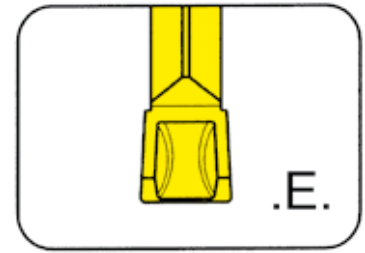


### 可转位刀片 型号

INDEXABLE INSERT Type

### S229

带断屑槽  
with chip forming



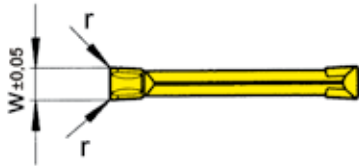
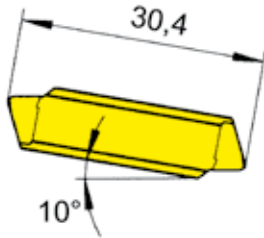
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size	TN35	Ti25	TF45	TF46
S229.0300.E2 S229.0300.E4	3	0.2 0.4	03		▲	▲	▲
S229.0400.E2 S229.0400.E4	4	0.2 0.4	03 / 04		▲	▲	▲
				P	•	•	•
				M	•	•	○
				K	•	•	•
				N	•	•	•
				S	•	•	○
				H			

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

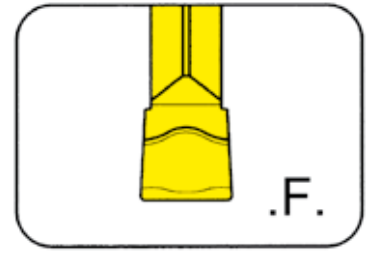


### 可转位刀片 型号

INDEXABLE INSERT Type

### S229

带断屑槽  
with chip forming



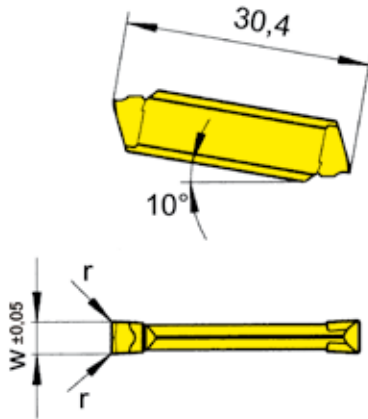
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size		TI22	TI25	TF43	TF45	TF46
S229.0300.F2	3	0.2	03		▲		▲	▲	▲
S229.0300.F4		0.4						▲	
S229.0400.F2	4	0.2	03 / 04					▲	△
S229.0400.F4		0.4						▲	
▲ 库存 / on stock    △ 4周 / 4 weeks				P	●	●	●	●	●
● 主要应用 / main recommendation				M			●	○	
○ 可选推荐 / alternative recommendation				K			●	●	
■ 无涂层牌号 / uncoated grades				N			●	●	
■ 涂层牌号 / coated grades				S			●	○	
■ 钎焊/金属陶瓷 / brazed/Cermet				H					

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

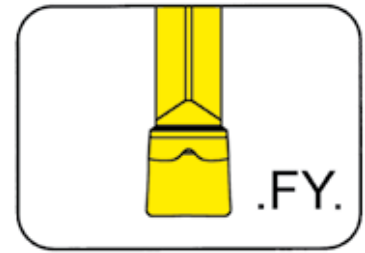


### 可转位刀片 型号

INDEXABLE INSERT Type

### S229

带断屑槽  
with chip forming



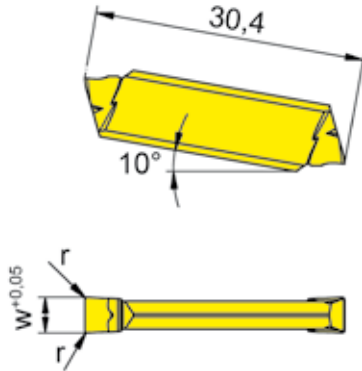
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	W	r	规格 Size		K10	MG12	TI25	TF45	TF46	AS45
S229.0300.FY2	3	0.2	03				▲			
S229.0400.FY3	4	0.3	03 / 04				▲			
▲ 库存 / on stock Δ 4周 / 4 weeks				P			•			
● 主要应用 / main recommendation				M			•			
○ 可选推荐 / alternative recommendation				K			•			
■ 无涂层牌号 / uncoated grades				N			•			
■ 涂层牌号 / coated grades				S			•			
■ 钎焊/金属陶瓷 / brazed/Cermet				H						

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

G

# 切槽和侧车削

## GROOVING and SIDE TURNING

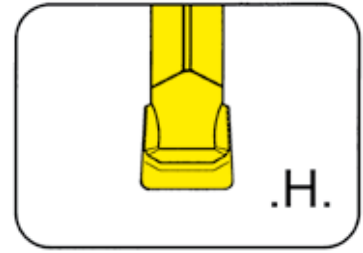


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

带断屑槽  
with chip breaker



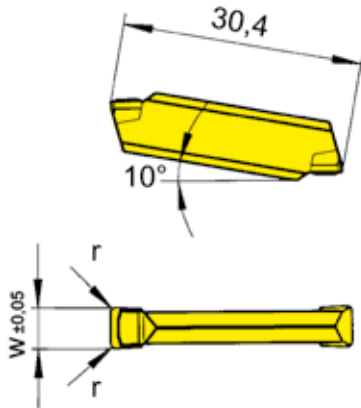
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 6.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size	TF42	AL96
S229.0300.H4 S229.0300.H6	3	0.4 0.6	03	△ ▲	▲ ▲
S229.0400.H4 S229.0400.H6 S229.0400.H8	4	0.4 0.6 0.8	03 / 04	▲ △ ▲	△ ▲ ▲
S229.0500.H4 S229.0500.H6 S229.0500.H8	5	0.4 0.6 0.8	04	▲ △ △	△ ▲ △
S229.0600.H4 S229.0600.H6 S229.0600.H8 S229.0600.HK	6	0.4 0.6 0.8 1.2	05	△ ▲ ▲ △	△ △ △ △

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	●	●
M		
K		●
N		●
S		
H		

硬质合金牌号  
Carbide grades

# 切槽和侧车削

## GROOVING and SIDE TURNING

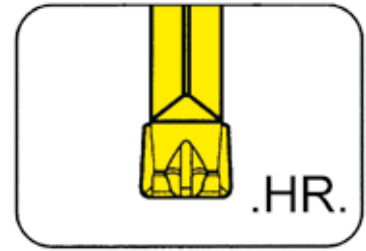


### 可转位刀片 型号

INDEXABLE INSERT Type

### S229

带断屑槽  
with chip forming



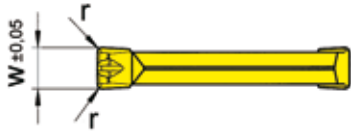
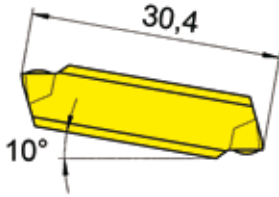
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 8.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TA42	AS62	AS66
S229.0300.HR4	3	0.4	03		▲	
S229.0400.HR4	4	0.4	03 / 04		▲	▲
S229.0500.HR4	5	0.4	04		▲	△
S229.0500.HR6		0.6		▲	▲	
S229.0500.HR8		0.8		▲		
S229.0600.HR4	6	0.4	05		▲	▲
S229.0600.HR6		0.6		▲	▲	
S229.0600.HR8		0.8		▲		
S229.0800.HR8PG	8	0.8	07 / 08		▲	
▲ 库存 / on stock    △ 4周 / 4 weeks				P	•	•
● 主要应用 / main recommendation				M		○
○ 可选推荐 / alternative recommendation				K		•
■ 无涂层牌号 / uncoated grades				N		•
■ 涂层牌号 / coated grades				S		○
■ 钎焊/金属陶瓷 / brazed/Cermet				H		

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

G



# 切槽和侧车削

## GROOVING and SIDE TURNING

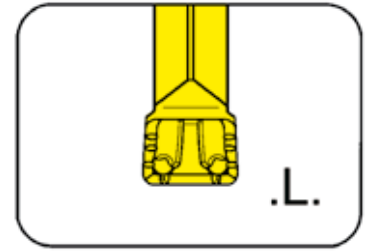


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming



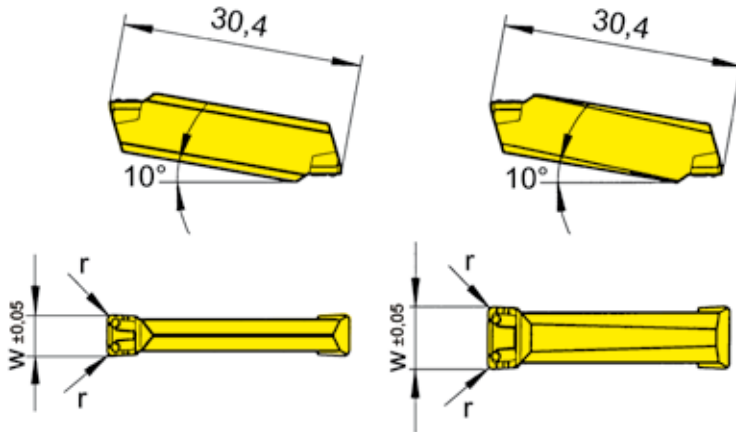
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
4.0 - 8.0 mm

精密烧结

precision sintered



宽度4.0-5.0mm  
Width 4,0 - 5,0 mm

宽度6.0-8.0mm  
Width 6,0 - 8,0 mm

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size	Tl22	TA42	TF42	AS62	AS66	AL96
S229.0400.L4	4	0.4	03 / 04	▲		▲	▲	▲	▲
S229.0500.L4	5	0.4	04	▲		▲	▲	▲	▲
S229.0500.L6		0.6		△		▲	▲	▲	▲
S229.0500.L8		0.8				▲	▲	▲	▲
S229.0600.L4	6	0.4	05	▲		▲	▲	▲	▲
S229.0600.L6		0.6		▲		▲	▲	▲	▲
S229.0800.L6	8	0.6	07	▲		▲	▲	▲	▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	●	●	●	●	●
● 主要应用 / main recommendation				M				○	
○ 可选推荐 / alternative recommendation				K				●	●
■ 无涂层牌号 / uncoated grades				N				●	●
■ 涂层牌号 / coated grades				S				○	
■ 钎焊/金属陶瓷 / brazed/Cermet				H					

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

## 加工柴油活塞环槽

加工耐蚀高镍合金活塞环槽使用**CBN**刀片229系列。

工艺流程是预切槽，然后加工槽的侧面。为了避免切削压力可能损坏环的基座，刀片切削刃进行了特别设计。

切削参数:

$v_c = 220 \text{ m/min}$

$v_f = 0.06 \text{ mm}$



G

### Machining of Ni-resist ring on "Diesel Piston"

**CBN-tipped** insert of type 229 is used to do the grooving application in the Ni-resist ring.

The process is pregrooving followed by profiling the flanks of the groove.

To avoid a high cutting pressure which forces the possibility to damage the seating of the ring, the cutting edge of the insert has a special preparation.

Cutting data:

$v_c = 220 \text{ m/min}$

$v_f = 0.06 \text{ mm}$

# 切槽和侧车削

## GROOVING and SIDE TURNING

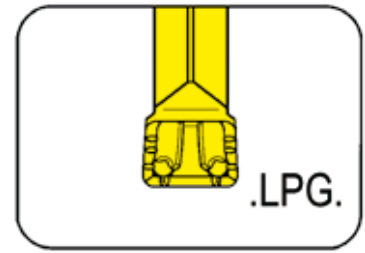


### 可转位刀片 型号

INDEXABLE INSERT Type

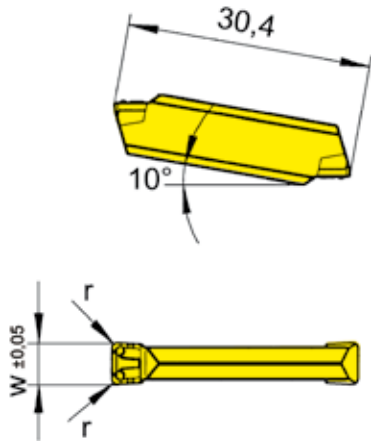
## S229

带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 - 8.0 mm

精密烧结  
precision sintered



PG=磨削外边缘  
PG = inserts with ground periphery

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

G

产品型号 Part number	w	r	规格 Size	TI22	TA42	AS62	AS66
<b>S229.0600.L4PG</b>	6	0.4	05			▲	
<b>S229.0800.L8PG</b>	8	0.8	07			▲	
▲ 库存 / on stock Δ 4周 / 4 weeks				P		●	
● 主要应用 / main recommendation				M			
○ 可选推荐 / alternative recommendation				K			
■ 无涂层牌号 / uncoated grades				N			
■ 涂层牌号 / coated grades				S			
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和侧车削

## GROOVING and SIDE TURNING

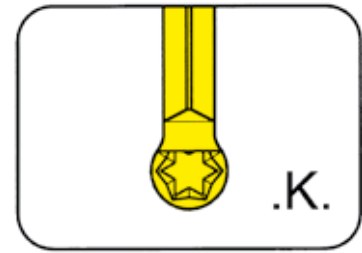


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

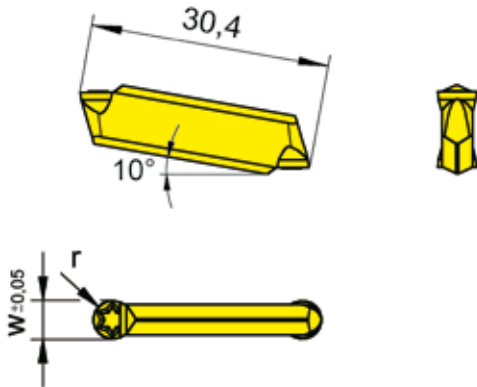
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 8.0 mm
圆头	Full radius	r 1.5 - 4.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TA42	TA45	AS62	AS66
S229.0015.K3	3	1.5	02 / 03			▲	▲
S229.0020.K4	4	2.0	03 / 04			▲	▲
S229.0025.K5	5	2.5	04			▲	▲
S229.0030.K6	6	3.0	05			▲	▲
S229.0040.K8	8	4.0	07 / 08			▲	
▲ 库存 / on stock    Δ 4周 / 4 weeks				P		•	•
• 主要应用 / main recommendation				M			○
○ 可选推荐 / alternative recommendation				K			•
■ 无涂层牌号 / uncoated grades				N			•
■ 涂层牌号 / coated grades				S			○
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

使用45° 刀杆加工退刀槽时各尺寸刀片要求的D<sub>min</sub>  
D<sub>min</sub> for corner reliefs with toolholder 45°

t <sub>max</sub>	S229.0015.K3	S229.0020.K4	S229.0025.K5	S229.0030.K6
0,5	Ø 26	Ø 26	Ø 32	Ø 32
1,0	Ø 76	Ø 55	Ø 42	Ø 37
1,5	Ø 78	Ø 58	Ø 45	Ø 41
2,0	Ø 80	Ø 59	Ø 46	Ø 42
2,5	Ø 82	Ø 60	Ø 47	Ø 43
3,0	Ø 84	Ø 62	Ø 48	Ø 44
3,5	Ø 87	Ø 63	Ø 49	Ø 46
4,0	Ø 89	Ø 65	Ø 50	Ø 47

硬质合金牌号  
Carbide grades

# 切槽和侧车削

## GROOVING and SIDE TURNING

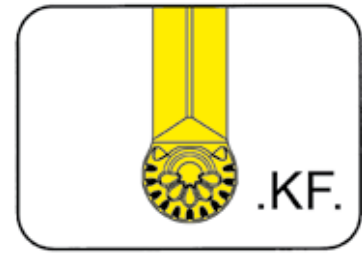


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

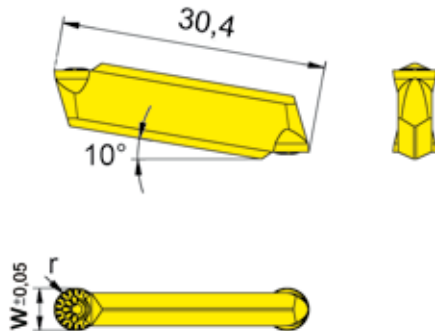
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 6.0 mm
圆头	Full radius	r 1.5 - 3.0 mm

精密烧结

precision sintered



刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

G

产品型号 Part number	W	r	规格 Size	Tl22	Tl25	TA42	TA45	AS62	AS66
S229.0015.KF3	3	1.5	02 / 03						▲
S229.0020.KF4	4	2.0	03 / 04						▲
S229.0025.KF5	5	2.5	04						▲
S229.0030.KF6	6	3.0	05						▲
				P					●
				M					○
				K					●
				N					●
				S					○
				H					

硬质合金牌号  
Carbide grades

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

使用45° 刀杆加工退刀槽时各尺寸刀片要求的Dmin

D<sub>min</sub> for corner reliefs with toolholder 45°

t <sub>max</sub>	S229.0015.KF3	S229.0020.KF4	S229.0025.KF5	S229.0030.KF6
0,5	Ø 26	Ø 26	Ø 32	Ø 32
1,0	Ø 76	Ø 55	Ø 42	Ø 37
1,5	Ø 78	Ø 58	Ø 45	Ø 41
2,0	Ø 80	Ø 59	Ø 46	Ø 42
2,5	Ø 82	Ø 60	Ø 47	Ø 43
3,0	Ø 84	Ø 62	Ø 48	Ø 44
3,5	Ø 87	Ø 63	Ø 49	Ø 46
4,0	Ø 89	Ø 65	Ø 50	Ø 47

可转位刀片 型号  
INDEXABLE INSERT type

229...10

精密研磨  
precision ground



## 断屑槽 Geometry .10

易切削无切屑成型的断屑槽  
Easy cutting geometry without chip former

### 特点 Characteristics

- 易切削-低功率要求
- 适用于不稳定零件
- 限制孔内圆切槽
- 适用于低进给

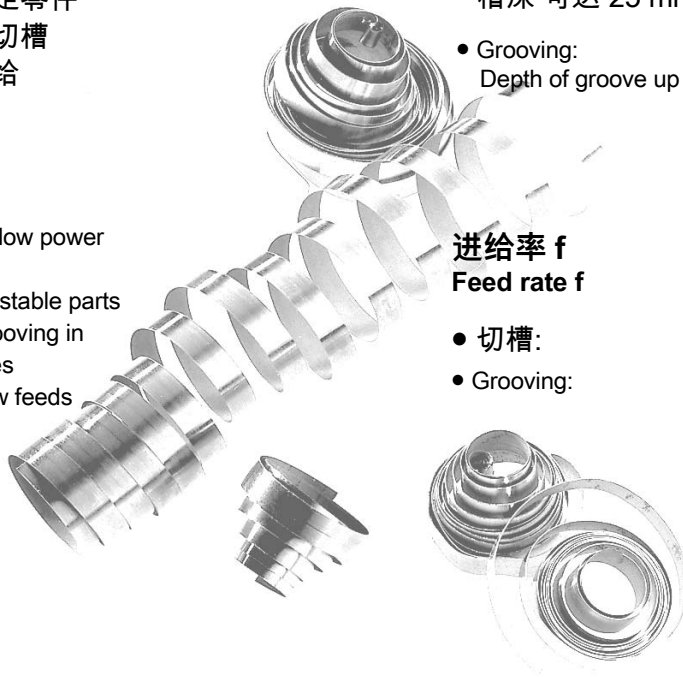
- easy cutting - low power requirement
- suitable for unstable parts
- for internal grooving in restricted bores
- suitable for low feeds

### 应用 Applications

- 切槽:  
槽深 可达 25 mm
- Grooving:  
Depth of groove up to 18 mm

### 进给率 f Feed rate f

- 切槽: 可达 0.3 mm/转
- Grooving: up to 0.3 mm/rev



以切削刃圆角为切深进行仿形加工  
根据要求可提供可转位仿形刀片，中间尺寸及不同切削刃圆角。  
此可转位刀片可用于右手和左手刀杆。

Profiling with a cutting depth of the edge radius is possible.  
Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和侧车削

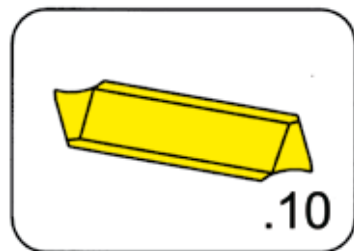
## GROOVING and SIDE TURNING



### 可转位刀片 型号

INDEXABLE INSERT Type

# 229

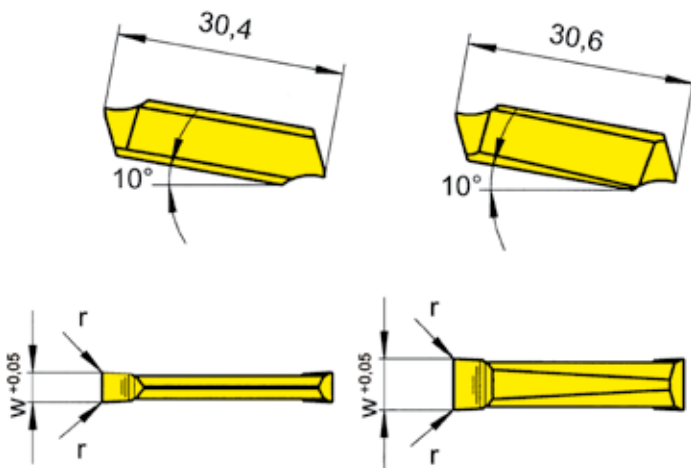


槽深可达  
槽宽

Depth of groove up to 25.0 mm  
Width of groove 2.5 - 10.0 mm

精密磨削

precision ground



宽度2.5-5.0 mm  
Width 2,5 - 5,0 mm

宽度5.1-10.4mm  
Width 5,1 - 10,4 mm

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	w	r	规格 Size
229.0250.10	2.5	0.2	02
229.0300.10	3.0	0.2	03
229.0400.10	4.0	0.2	03 / 04
229.0500.10	5.0	0.2	04
229.0600.10	6.0	0.4	05
229.0700.10	7.0	0.4	07
229.0800.10	8.0	0.4	07
229.0900.10	9.0	0.4	09
229.1000.10	10.0	0.4	09

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

□ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

	K10	MG12	P20	H20	TN32	TN35	T125	TA45
P	●	○	●	●	●	●		
M	○	●		○		●		
K	●	●				●		
N	●	●				●		
S	○	●				●		
H								

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.



可转位刀片 型号  
INDEXABLE INSERT type

229...20

精密研磨  
precision ground



## 断屑槽 Geometry .20

适用于灰铸铁和高拉伸强度材料无切屑成型的断屑槽  
Geometry without chip forming for grey cast iron and materials with higher tensile strength

### 特点 Characteristics

- 稳定的楔角
- 适合大深度的成型刀片
- 适用于断续切削
- 适用于低进给切削

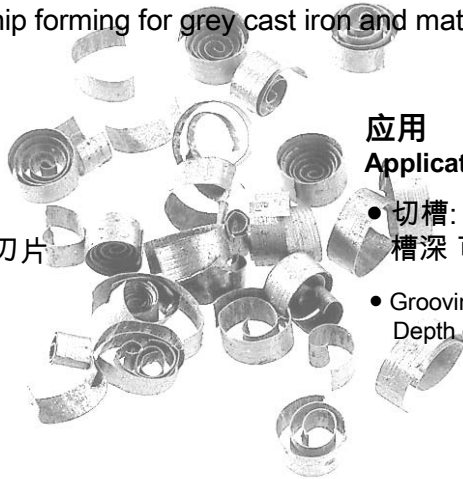
- strong wedge angle
- for inserts with larger depth of profile
- recommended for interrupted cut
- suitable for low feeds

### 应用 Applications

- 切槽:  
槽深 可达 25 mm
- Grooving:  
Depth of groove up to 25 mm

### 进给率 f Feed rate f

- 切槽: 0.07 可达 0.25 mm/转
- Grooving: 0.07 up to 0.25 mm/rev



以切削刃圆角为切深进行仿形加工  
根据要求可提供可转位仿形刀片，中间尺寸及不同切削刃圆角。  
此可转位刀片可用于右手和左手刀杆。

Profiling with a cutting depth of the edge radius is possible.  
Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.





可转位刀片 型号  
INDEXABLE INSERT type

# 229...3.

精密研磨  
precision ground



## 断屑槽 Geometry .3.

适用于所有材料有切屑成型的断屑槽。  
Geometry with chip forming for all materials.

### 特点 Characteristics

- 出色的切屑控制
- 适用于高强度的高合金钢
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 出色的切屑控制保证了生产的安全性

### 应用 Applications

- 切槽:  
槽深 可达 25 mm
- 侧车削:  
切深  $a_p$  可达 4 mm\*
- Grooving:  
Depth of groove up to 25 mm
- Side turning:  
Depth of cut  $a_p$  up to 4 mm\*



- excellent swarf control
- suitable for high alloy- high strength steels
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

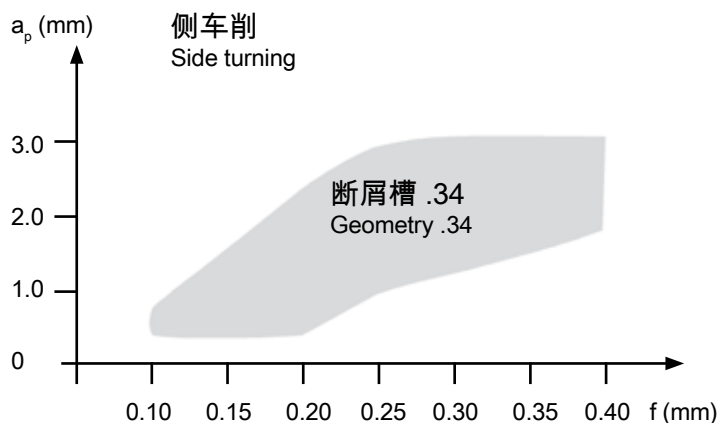
### 进给率 f Feed rate f

- 切槽: 0.15 可达 0.25 mm/转\*
- 侧车削: 可达 0.4 mm/转\*
- Grooving: 0.15 up to 0.25 mm/rev\*
- Side turning: up to 0.4 mm/rev\*

\* 取决于刀片宽度  
\* dependent upon width of insert

可根据要求提供可转位仿形刀片，中间尺寸或其他圆角刀片。  
此可转位刀片可用于右手和左手刀杆。

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.  
Indexable inserts can be used in **right and left hand** toolholders.



229.0500.34加工16MnCr5时切屑控制图表

Chip control graph 229.0500.34 material 16MnCr5

# 切槽和侧车削

## GROOVING and SIDE TURNING

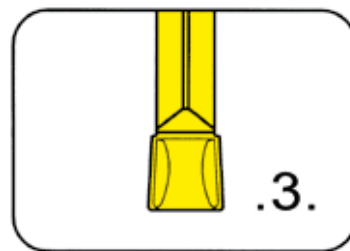


### 可转位刀片 型号

INDEXABLE INSERT Type

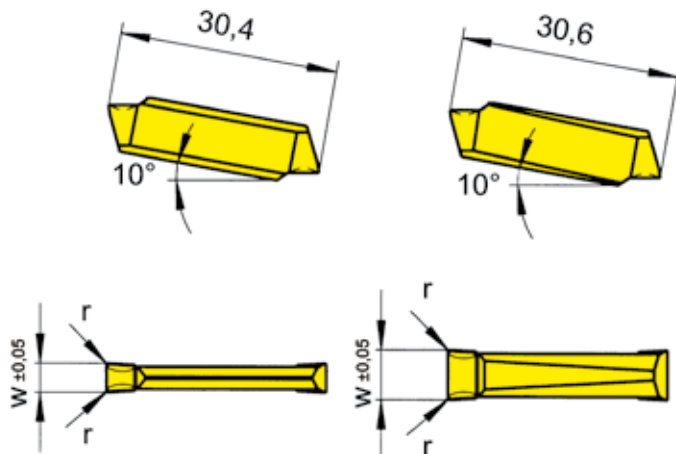
# 229

带断屑槽  
with chip former



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 10.0 mm

精密磨削  
precision ground



宽度3.0-5.0mm  
Width 3,0 - 5,0 mm

宽度5.1-10.4mm  
Width 5,1 - 10,4 mm

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	W	r	规格 Size	K10	MG12	P20	H20	TN32	TN35	TI22	TI25	AS62
				▲	▲	▲		▲	▲		▲	▲
229.0300.31 229.0350.31	3.0 3.5	0.2	03	▲	▲	▲		▲	▲		▲	▲
229.0300.34 229.0400.31 229.0400.34	3.0 4.0 4.0	0.4 0.2 0.4	03 / 04	▲		▲		▲	▲			▲
229.0500.31 229.0500.34 229.0500.36		0.2 0.4 0.6	04	▲		▲		▲		▲		▲
229.0600.31 229.0600.38	6.0	0.4 0.8	05			▲		▲				▲
229.0700.31 229.0800.31	7.0 8.0	0.4	07			▲		▲				▲
229.0900.31 229.1000.31	9.0 10.0	0.4	09					▲	▲			▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	●	○	●	●	●	●	●	●
● 主要应用 / main recommendation				M	○	●			●		●	
○ 可选推荐 / alternative recommendation				K	●	●			●		●	
■ 无涂层牌号 / uncoated grades				N	●	●			●		●	
■ 涂层牌号 / coated grades				S	○	●			●		●	
■ 钎焊/金属陶瓷 / brazed/Cermet				H								

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

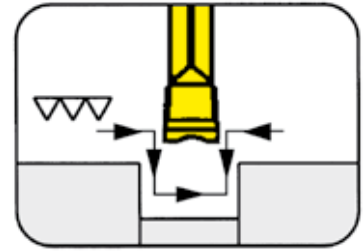


## 可转位刀片 型号

INDEXABLE INSERT Type

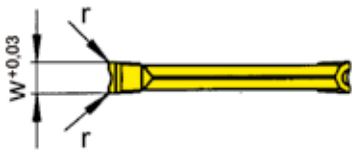
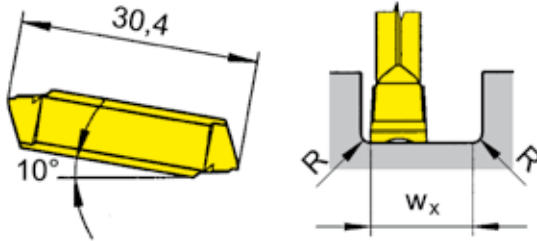
# 229

带断屑槽  
with chip breaker



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密磨削  
precision ground



刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	W	r	W <sub>x</sub>	规格 Size
229.NC30.02	3	0.2	4.5	03 / 04
229.NC40.02	4	0.2	6.4	03 / 04

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

w<sub>x</sub> = 槽宽 - R<sub>(右)</sub> - R<sub>(左)</sub>  
w<sub>x</sub> = width of groove - R<sub>(right)</sub> - R<sub>(left)</sub>

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

	K10	MG12	P20	H20	TN32	TN35	TI22	TI25
P				▲				
M				○				
K								
N								
S								
H								

硬质合金牌号  
Carbide grades

# 切槽和侧车削

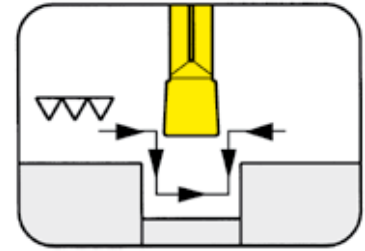
## GROOVING and SIDE TURNING



### 可转位刀片 型号

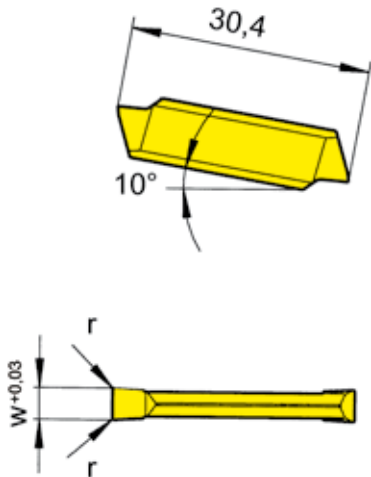
# 229

INDEXABLE INSERT Type



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密磨削  
precision ground



刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm



产品型号 Part number	w	r	规格 Size	K10	MG12	H20	TN32	TN35	TI25	TA45
229.0300.02	3	0.2	03 / 04			▲				
229.0400.02	4	0.2	03 / 04			▲				
▲ 库存 / on stock    Δ 4周 / 4 weeks				P		•				
● 主要应用 / main recommendation				M		○				
○ 可选推荐 / alternative recommendation				K						
■ 无涂层牌号 / uncoated grades				N						
■ 涂层牌号 / coated grades				S						
■ 钎焊/金属陶瓷 / brazed/Cermet				H						

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)

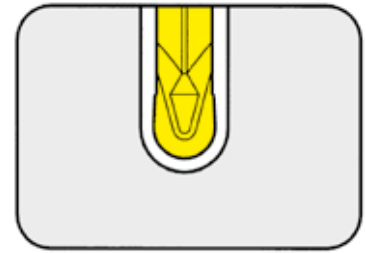


### 可转位刀片 型号

INDEXABLE INSERT Type

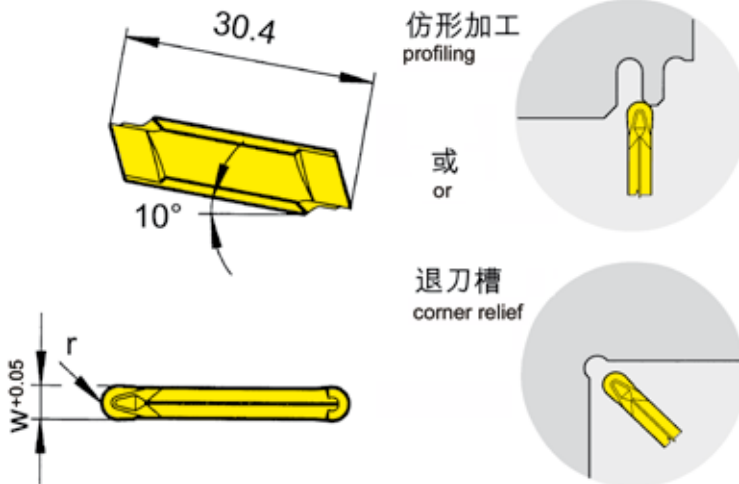
# 229

带环形断屑槽  
with surrounding chip breaker



槽深可达 圆头	Depth of groove up to Full radius	25.0 mm r 1.50 - 3.00 mm
------------	--------------------------------------	-----------------------------

精密磨削  
precision ground



刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

G

产品型号 Part number	W	r	规格 Size	夹持范围 Clamping range	K10	MG12	P20	H20	TN32	TN35	TI25	AS62	AS66
229.0015.30	3	1.5	225...04 03	3.0 - 5.0 3.0 - 4.0		▲	▲	▲	▲			▲	
229.0020.40	4	2.0	225...04 03 04	3.0 - 5.0 3.0 - 4.0 4.0 - 5.0		▲	▲		▲			▲	
229.0025.50	5	2.5	225...04 04	3.0 - 5.0 4.0 - 5.0		▲	▲		▲			△	△
229.0030.60	6	3.0	05	5.1 - 6.0			▲		▲			△	
▲ 库存 / on stock    △ 4周 / 4 weeks					P	○	●	●	●			●	●
● 主要应用 / main recommendation					M	●		○					○
○ 可选推荐 / alternative recommendation					K	●							●
■ 无涂层牌号 / uncoated grades					N	●							●
■ 涂层牌号 / coated grades					S	●							○
■ 钎焊/金属陶瓷 / brazed/Cermet					H								

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

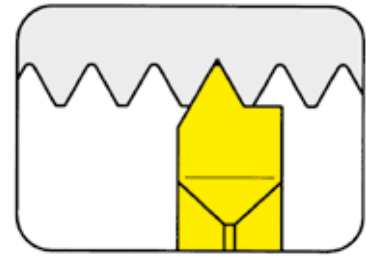


### 可转位刀片 型号

INDEXABLE INSERT Type

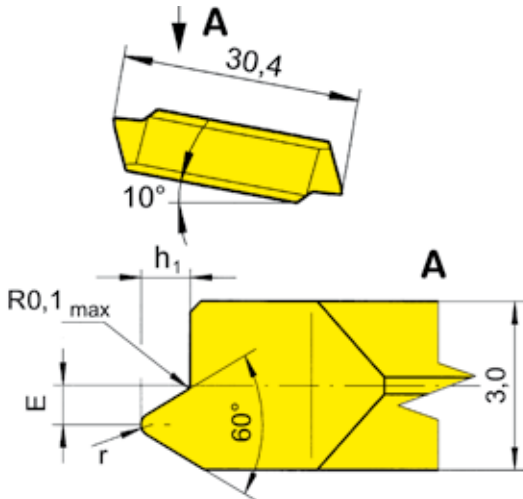
# 229

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 2.5 mm
----	-------	--------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm



产品型号 Part number	P	r	E	h <sub>1</sub>	规格 Size	TN35	TI25	TA45
R/L229.0610.02	1.00	0.140	0.8	0.62	03 / 04	▲/▲		
R/L229.0712.02	1.25	0.175	0.8	0.78		▲/▲		
R/L229.0915.02	1.50	0.210	0.7	0.93		▲/▲		
R/L229.1017.02	1.75	0.250	0.5	1.08		▲/▲		
R/L229.1220.02	2.00	0.280	0.5	1.24		▲/▲		
R/L229.1525.02	2.50	0.360	0.3	1.54		▲/▲		

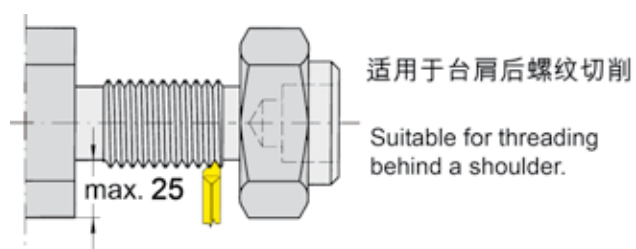
- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●		
M	●		
K	●		
N	●		
S	●		
H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm  
注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.



# 螺纹切削 ( 外圆 ) -非全牙型

## THREADING (external) Partial profile

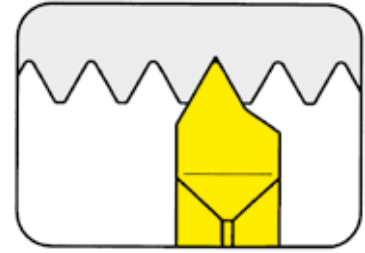


### 可转位刀片 型号

INDEXABLE INSERT Type

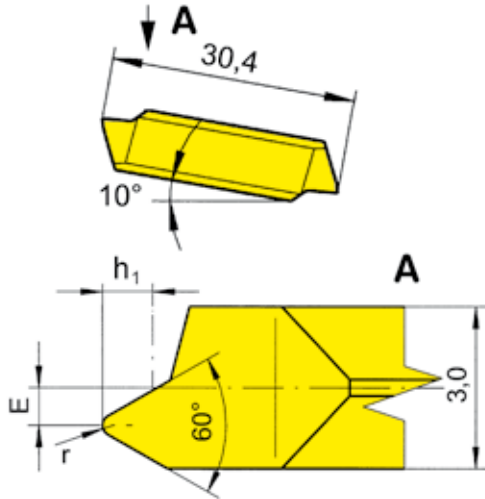
# 229

ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 2.5 mm
----	-------	--------------

精密磨削  
precision ground



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

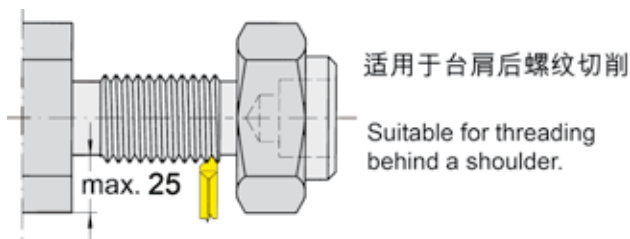
产品型号 Part number	P	r	E	h <sub>1</sub>	规格 Size	TN35	TI25	TA45
R/L229.0610.01	1.00	0.12	0.8	0.61	03 / 04	▲/△		
R/L229.0712.01	1.25	0.15	0.8	0.77		▲/△		
R/L229.0915.01	1.50	0.20	0.7	0.92		▲/▲		
R/L229.1017.01	1.75	0.25	0.5	1.07		▲/▲		
R/L229.1220.01	2.00	0.25	0.5	1.23		▲/△		
R/L229.1525.01	2.50	0.35	0.3	1.53		▲/▲		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.



P	●		
M	●		
K	●		
N	●		
S	●		
H			

硬质合金牌号  
Carbide grades



# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

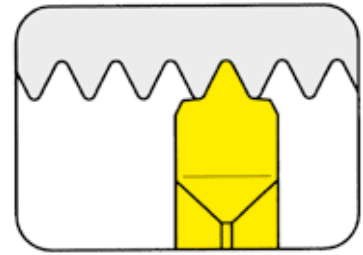


### 可转位刀片 型号

INDEXABLE INSERT Type

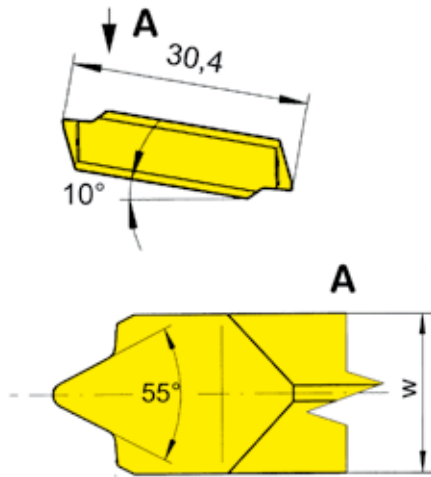
### N229

惠氏管螺纹  
Whitworth pipe thread



每英寸牙数	Threads per inch	28 - 11
-------	------------------	---------

精密磨削  
precision ground



刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm



产品型号 Part number	每英寸螺牙数 Threads per Inch	w	规格 Size	TN35	TI25	TA45
				N229.5511.02	11	3.5
N229.5514.02	14			▲		▲
N229.5519.02	19	3.0	03 / 04	▲		
N229.5528.02	28			▲		
				P	•	•
				M	•	•
				K	•	•
				N	•	•
				S	•	•
				H		

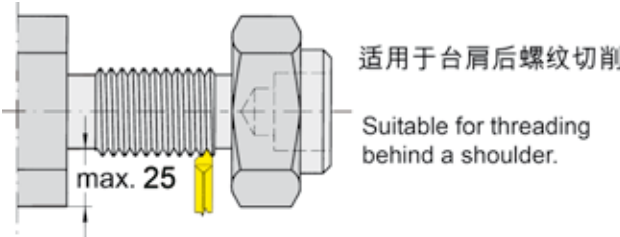
- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

无需垫片。所有HORN螺纹刀片具有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.



# 切断

## PARTING OFF

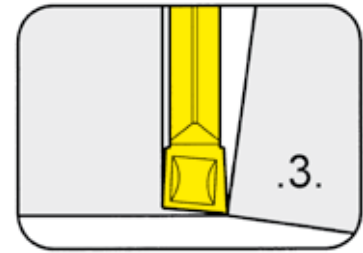


### 可转位刀片 型号

INDEXABLE INSERT Type

## 229/S229

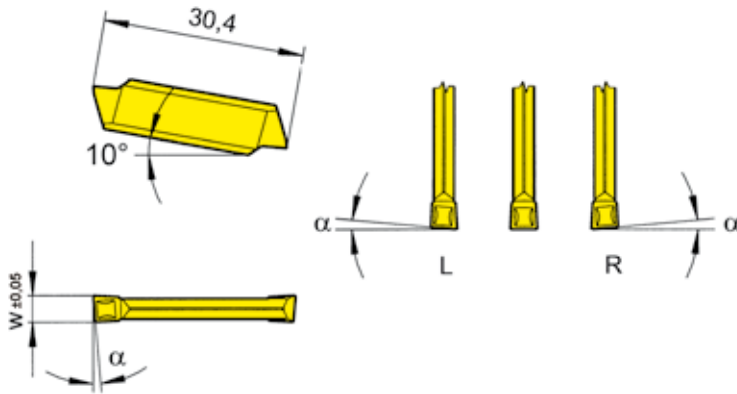
带断屑槽  
with chip former



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密烧结

precision sintered



长度重复定位精度  
±0.04 mm

Indexability length  
± 0,04 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	规格 Size
R/L229.5300.31 R/LS229.0530.32 S229.0300.32	3	5° 5° 0°	03
R/LS229.0540.32 S229.0400.32	4	5° 0°	03 / 04

	MG12	H54	TN32	TN35	TI22	TI25	TF45	AS62
	▲/▲		▲/▲	▲/▲		▲/▲		▲/▲
	▲	▲	▲	▲	Δ	▲	▲	▲
		▲	▲	▲	Δ	▲	▲	▲
P	○	●	●	●	●	●	●	●
M	●	●	●	●	●	●	●	●
K	●	●	●	●	●	●	●	●
N	●	●	●	●	●	●	●	●
S	●	●	●	●	●	●	●	●
H								

硬质合金牌号  
Carbide grades

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

无涂层牌号 / uncoated grades

涂层牌号 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R/L229.5300.31精密磨削, 长度30.0mm

Note:

R/L229.5300.31 precision ground, length 30,0 mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in right and left hand toolholders.

G

# 切断

## PARTING OFF

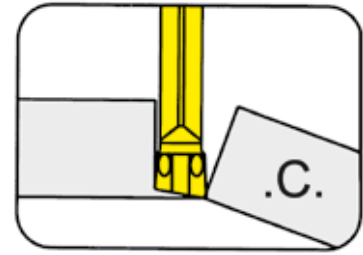


### 可转位刀片 型号

INDEXABLE INSERT Type

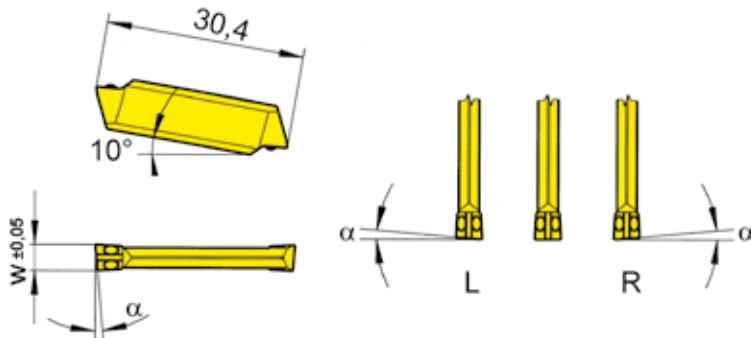
## S229

带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密烧结  
precision sintered



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

G

产品型号 Part number	w	α	规格 Size	TN35	TI25	TF45
R/LS229.0530.C0 R/LS229.0830.C0 S229.0030.C0	3	5° 8° 0°	03	▲/▲ ▲/▲ ▲	△/△ ▲/▲ ▲	▲/▲ ▲/▲ ▲
R/LS229.0540.C0 R/LS229.0840.C0 S229.0040.C0	4	5° 8° 0°	03 / 04	▲/△ ▲/△ ▲	△/△ ▲/△ ▲	

▲ 库存 / on stock    △ 4周 / 4 weeks  
● 主要应用 / main recommendation  
○ 可选推荐 / alternative recommendation  
■ 无涂层牌号 / uncoated grades  
■ 涂层牌号 / coated grades  
■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm  
注明R或L型  
State R or L version  
此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

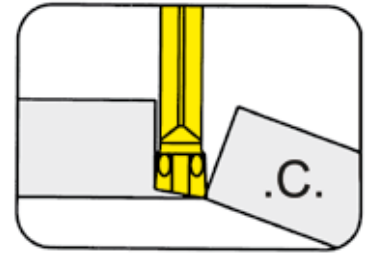
硬质合金牌号  
Carbide grades

# 切断 PARTING OFF



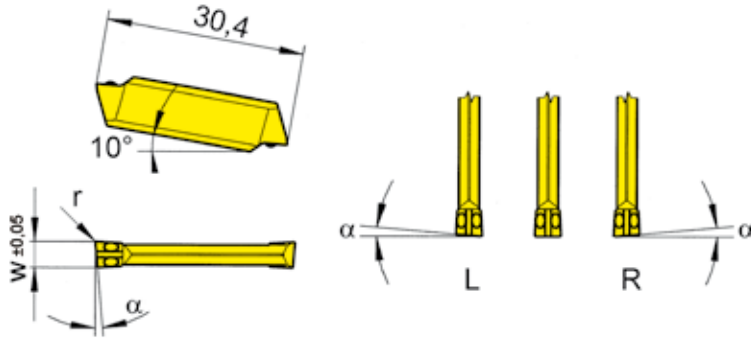
可转位刀片 型号  
INDEXABLE INSERT Type

**S229**  
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密烧结  
precision sintered



G

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.025mm  
Indexability length ± 0,025 mm

产品型号 Part number	w	r	α	规格 Size	TN35	TI25	TF45
R/LS229.0530.C1 R/LS229.0830.C1 S229.0030.C1	3	0.15	5° 8° 0°	03	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲
R/LS229.0540.C1 R/LS229.0840.C1 RS2290540.C1 S229.0040.C1	4	0.15	5° 8° 5° 0°	03 / 04	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

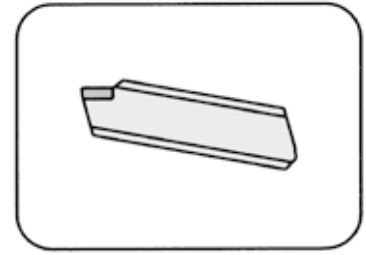
此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H	●	●	●

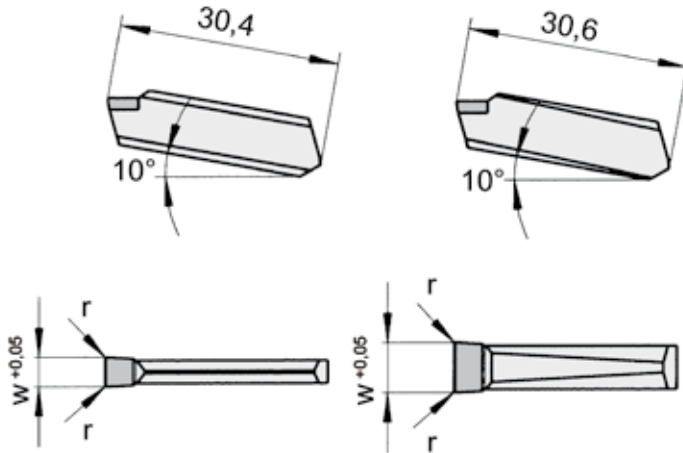
硬质合金牌号  
Carbide grades

刀片型号  
INSERT Type

# 229



槽深可达                      Depth of groove up to                      18.0 mm  
槽宽                              Width of groove                              3.0 - 6.0 mm



宽度3.0-5.0mm  
Width 3,0 - 5,0 mm

宽度6.0mm  
Width 6,0 mm

CBN刀片  
CBN tipped

**G**

产品型号 Part number	w	r	规格 Size	CB10	CB50
229.0300.22.B	3	0.2	03	▲	▲
229.0300.24.B		0.4		▲	▲
229.0400.22.B	4	0.2	04	▲	△
229.0400.24.B		0.4		▲	▲
229.0500.22.B	5	0.2	04	△	△
229.0500.24.B		0.4		▲	▲
229.0600.24.B	6	0.4	05	△	△
229.0600.26.B		0.6		△	△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left** hand toolholders.

硬质合金牌号 Carbide grades	CB10	CB50
P	■	■
M	■	■
K	■	■
N	■	■
S	■	■
H	●	●

# 切槽和切断

## GROOVING and PARTING OFF

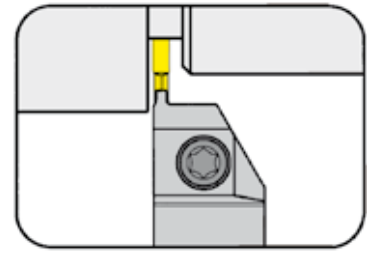


### 刀杆 型号

TOOLHOLDER Type

## H259

加工铜  
Machining brass



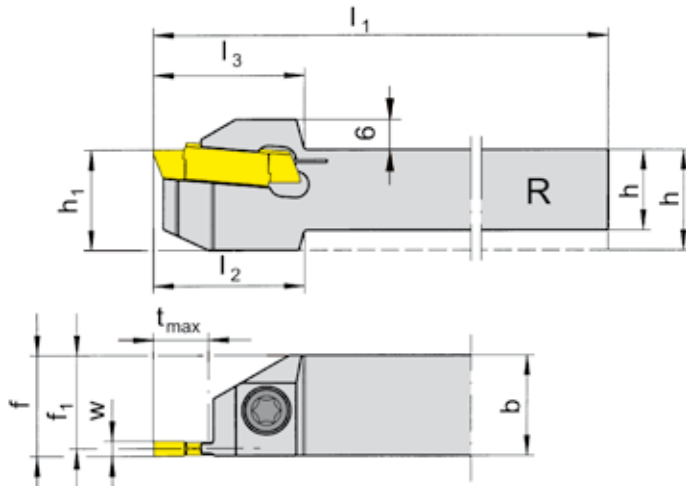
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
3.0 - 4.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 259  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	规格 Size
R/LH259.1616.03	16	16		30		20	14.55			
R/LH259.2020.03	20	20	135	-	30	20	18.55	$f_1+w/2$	11	03
R/LH259.2525.03	25	25		-		25	23.55			
R/LH259.1616.13	16	16		33		20	14.55			
R/LH259.2020.13	20	20	135	-	33	20	18.55	$f_1+w/2$	18	03
R/LH259.2525.13	25	25		-		25	23.55			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH259....	6.23T25P	T25PQ

# 切槽和切断

## GROOVING and PARTING OFF

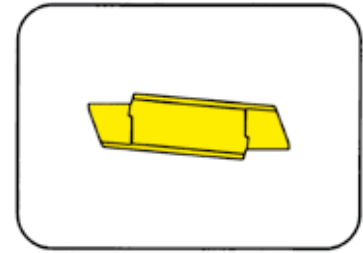


### 可转位刀片 型号

INDEXABLE INSERT Type

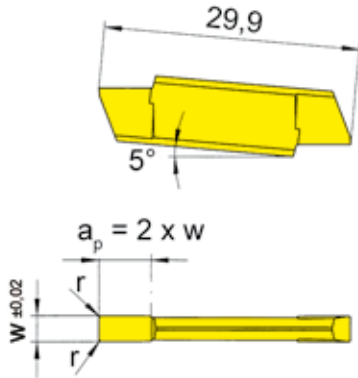
# 259

加工铜  
Machining brass



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H259  
Type

较小切削刃的可用长度  $a_p$   
Usable length of minor cutting edge  $a_p$

$2 \times w$  用于加工黄铜 (Ms58)  
 $2 \times w$  for machining brass (Ms58)

刀片长度重复定位精度  
 $\pm 0.015$  mm  
Indexability length  $\pm 0,015$  mm



产品型号 Part number	w	r	规格 Size	MG12	TN35	TI25
259.0300.M1	3	0.15	03	△		
259.0300.M2		0.20		▲		
259.0400.M1	4	0.15	03	△		
259.0400.M2		0.20		▲		
				P	○	
				M	●	
				K	●	
				N	●	
				S	●	
				H		

- ▲ 库存 / on stock △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

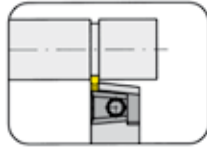


刀具系列 312

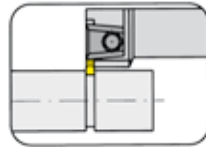
TOOLING SYSTEM 312

H

切槽  
- 外圆 -  
Grooving  
- external -



页 / Page  
H2-H6, H15-H16



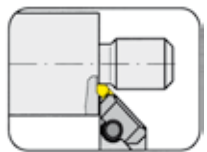
页 / Page  
H10



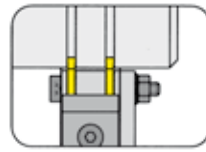
页 / Page  
H11



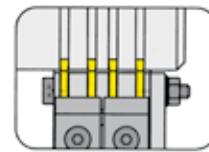
页 / Page  
H12-H14



页 / Page  
H17

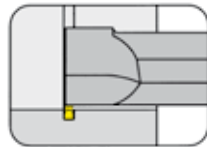


页 / Page  
H18



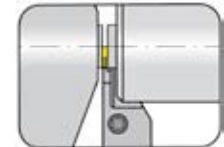
页 / Page  
H19

切槽  
- 内圆 -  
Grooving  
- internal -



页 / Page  
H20

切断  
Parting off

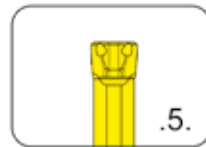


页 / Page  
H7-H9

可转位刀片  
型号  
Indexable inserts type  
S312



页 / Page  
H21



页 / Page  
H22

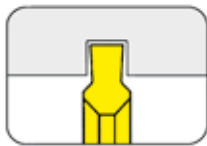


页 / Page  
H23

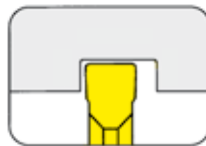


页 / Page  
H24

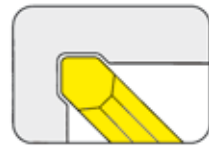
可转位刀片  
型号  
Indexable inserts type  
312



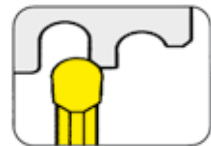
页 / Page  
H25-H28



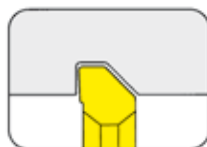
页 / Page  
H29-H30



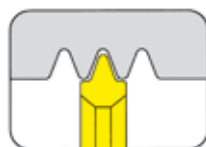
页 / Page  
H31-H32



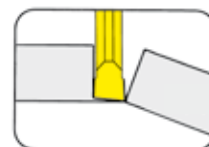
页 / Page  
H31-H32



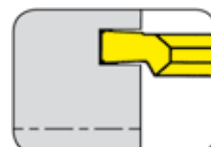
页 / Page  
H25-H28



页 / Page  
H36



页 / Page  
H37-H40



页 / Page  
H41

技术说明见章节Q

For Technical Instructions please see chapter Q

# 切槽和切断

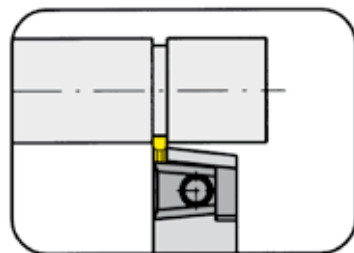
## GROOVING and PARTING OFF



### 刀杆 型号

# 360

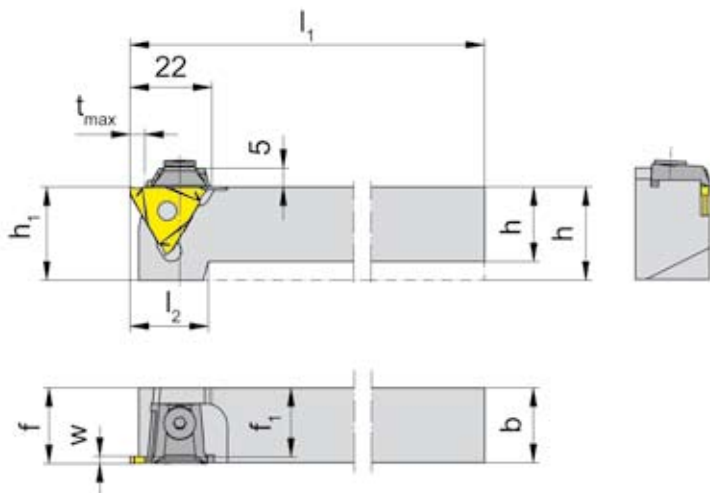
TOOLHOLDER Type



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
0.5 - 2.9 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L360.1212.01	12	12	100	24	25	10.5	$f_1+w-a_1$	4	01	0.5 - 1.9
R/L360.1616.01	16	16	125	22	25	14.5				
R/L360.2020.01	20	20	125	21	25	18.5				
R/L360.2525.01	25	25	150	-	25	23.5				
R/L360.3232.01	32	32	170	-	32	30.5				
R/L360.1212.02	12	12	100	24	25	9.5	$f_1+w-a_1$	6	02	1.9 - 2.9
R/L360.1616.02	16	16	125	22	25	13.5				
R/L360.2020.02	20	20	125	21	25	17.5				
R/L360.2525.02	25	25	150	-	25	22.5				
R/L360.3232.02	32	32	170	-	32	29.5				

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40$ mm时才能达到 $t_{max}$

$t_{max}$  can be reached only with workpiece  $\varnothing \leq 40$  mm

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L360.1...01/02	11.3	6.25	SW3.0DIN911
R/L360....01/02	16.4	6.25	SW3.0DIN911

# 切槽和切断

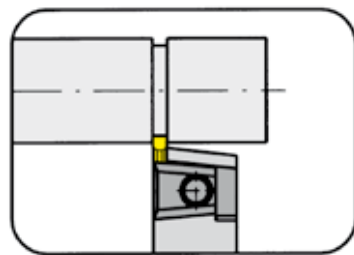
## GROOVING and PARTING OFF



### 刀杆 型号

# 360

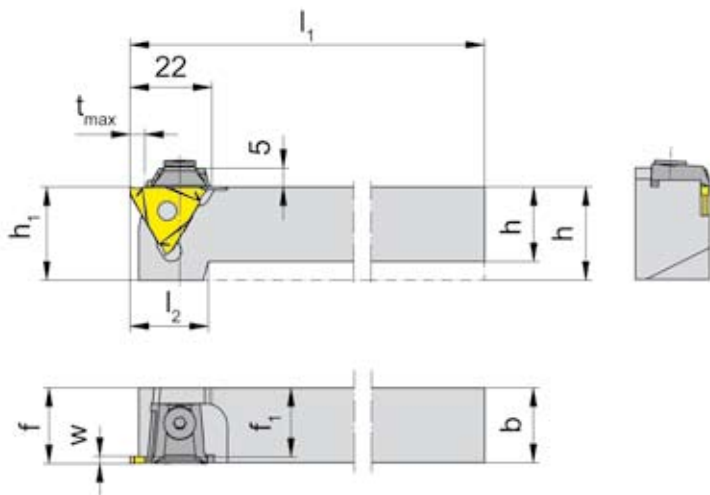
TOOLHOLDER Type



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
2.9 - 6.3 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L360.1212.03	12	12	100	24	25	8.5	f <sub>1</sub> +w-a <sub>1</sub>	6	03	2.9 - 3.9
R/L360.1616.03	16	16	125	22	25	12.5				
R/L360.2020.03	20	20	125	21	25	16.5				
R/L360.2525.03	25	25	150	-	25	21.5				
R/L360.3232.03	32	32	170	-	32	28.5				
R/L360.1616.04	16	16	125	22	25	10.8	f <sub>1</sub> +w-a <sub>1</sub>	6	04	3.9 - 6.3
R/L360.2020.04	20	20	125	21	25	14.8				
R/L360.2525.04	25	25	150	-	25	19.8				
R/L360.3232.04	32	32	170	-	32	26.8				

注明R或L型

State R or L version

w, a<sub>1</sub>见刀片

w, a<sub>1</sub> see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到t<sub>max</sub>

t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L360.1...03	11.3	6.25	SW3,0DIN911
R/L360.1616.04	13.4	6.25	SW3,0DIN911
R/L360....03/04	16.4	6.25	SW3,0DIN911

# 切槽和切断

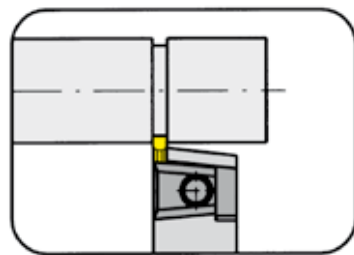
## GROOVING and PARTING OFF



### 刀杆 型号

# 360

TOOLHOLDER Type



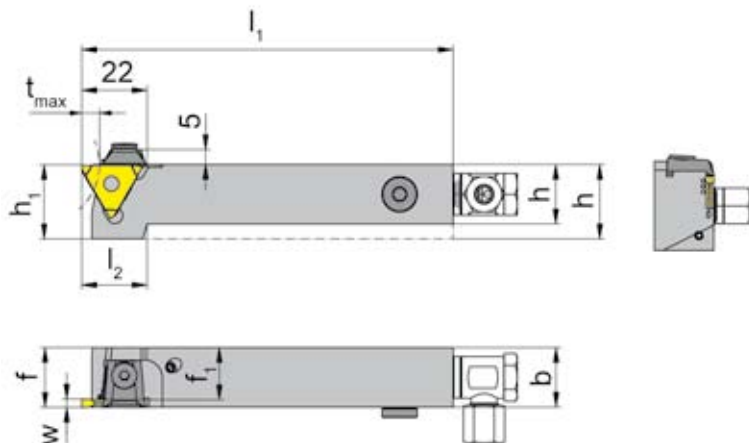
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
0.5 - 2.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

带内冷

with through coolant supply

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L360.1212.01.IK	12	12	100	24		10.5				
R/L360.1616.01.IK	16	16	125	22	25	14.5	f <sub>1</sub> +w-a <sub>1</sub>	4	01	0.5 - 1.9
R/L360.2020.01.IK	20	20	125	21		18.5				
R/L360.2525.01.IK	25	25	150	-		23.5				
R/L360.1212.02.IK	12	12	100	24		9.5				
R/L360.1616.02.IK	16	16	125	22	25	13.5	f <sub>1</sub> +w-a <sub>1</sub>	6	02	1.9 - 2.9
R/L360.2020.02.IK	20	20	125	21		17.5				
R/L360.2525.02.IK	25	25	150	-		22.5				

注明R或L型

State R or L version

w, a<sub>1</sub>见刀片

w, a<sub>1</sub> see indexable inserts

尺寸单位: mm

Dimensions in mm

只有当工件直径 $\varnothing \leq 40$ mm时才能达到t<sub>max</sub>

t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40$  mm

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench	冷却接头 Coolant supply
R/L360.1...IK	11.3	6.25	SW3,0DIN911	004.00.61
R/L360.2...IK	16.4	6.25	SW3,0DIN911	004.00.61

# 切槽和切断

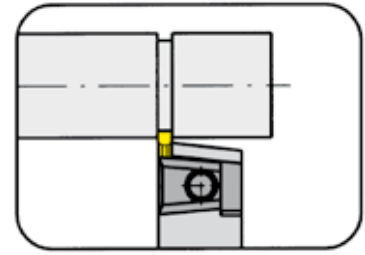
## GROOVING and PARTING OFF



### 刀杆 型号

# 360

TOOLHOLDER Type



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
2.9 - 3.9 mm

配合 可转位刀片

for use with Indexable insert

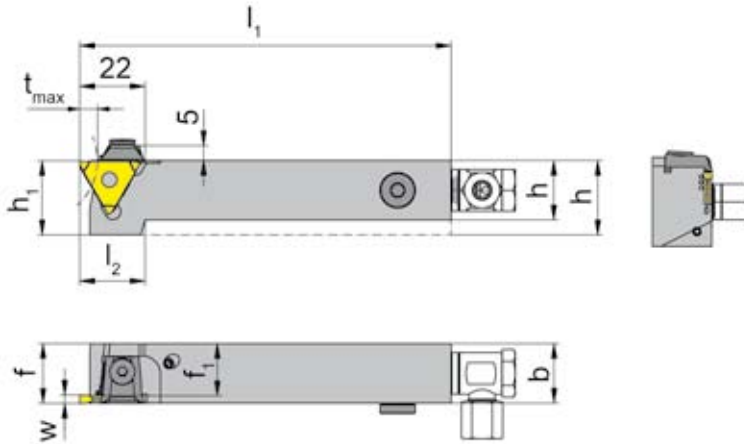
型号

312

Type

N312

S312



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

带内冷

with through coolant supply

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L360.1212.03.IK	12	12	100	24		8.5				
R/L360.1616.03.IK	16	16	125	22	25	12.5				
R/L360.2020.03.IK	20	20	125	21		16.5	f <sub>1</sub> +w-a <sub>1</sub>	6	03	2.9 - 3.9
R/L360.2525.03.IK	25	25	150	-		21.5				

注明R或L型

State R or L version

w, a<sub>1</sub>见刀片

w, a<sub>1</sub> see indexable inserts

尺寸单位: mm

Dimensions in mm

只有当工件直径 $\varnothing \leq 40$ mm时才能达到t<sub>max</sub>  
t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40$  mm

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench	冷却接头 Coolant supply
R/L360.1...IK	11.3	6.25	SW3,0DIN911	004.00.61
R/L360.2...IK	16.4	6.25	SW3,0DIN911	004.00.61

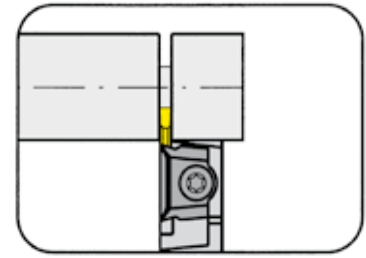
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

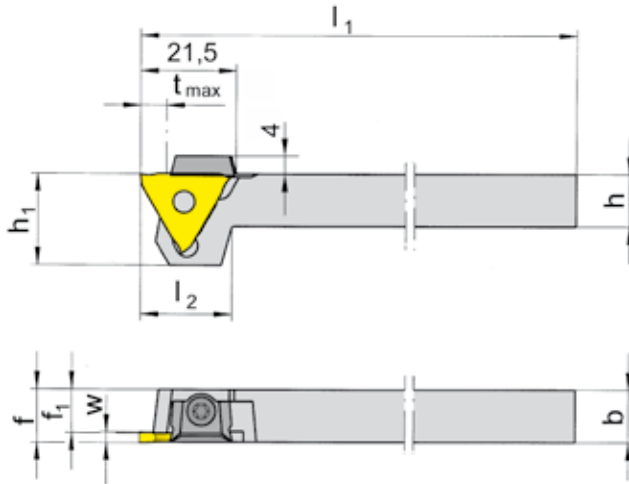
**361**  
减小头部尺寸  
reduced head size



槽深可达 夹持范围	Depth of groove up to Clamping range	6.0 mm 0.5 - 3.9 mm
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配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L361.1212.01	12	12	100	17	19	10.5	f <sub>1</sub> +w-a <sub>1</sub>	4	01	0.5-1.9
R/L361.1212.02	12	12	100	17	19	9.5	f <sub>1</sub> +w-a <sub>1</sub>	6	02	1.9-2.9
R/L361.1212.03	12	12	100	21	21	8.5	f <sub>1</sub> +w-a <sub>1</sub>	6	03	2.9-3.9

注明R或L型  
State R or L version

w, a<sub>1</sub> 见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到t<sub>max</sub>  
t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

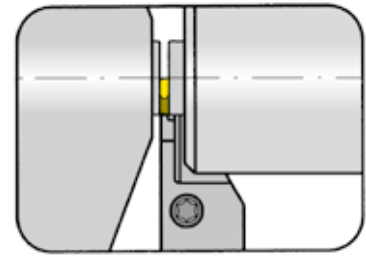
刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L361.1212.0...	12.3	030.0422.T10P	T10PL

# 切断 PARTING OFF



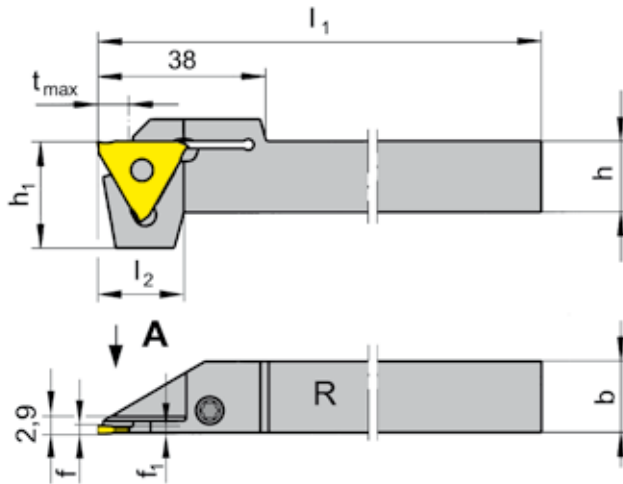
刀杆 型号  
TOOLHOLDER Type

## 368



槽深可达 8.0 mm  
槽宽 0.5 - 1.5 mm

用于TRAUB ( TNL12/7 ) 机床  
for machines TRAUB (TNL12/7)

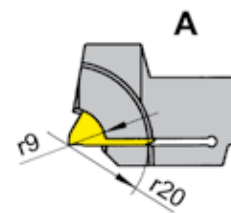


R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



仅用于周边轮廓磨削刀片  
only for periferal grounded profiled inserts

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>
R/L368.1212.08	12	12	95	19.5	24	1.0	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.08	16	16	95	19.5	24	1.0	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1212.11	12	12	95	19.5	24	1.3	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.11	16	16	95	19.5	24	1.3	f <sub>1</sub> +a <sub>1</sub>	8

注明R或L型  
State R or L version

a<sub>1</sub> 见刀片  
a<sub>1</sub> see indexable inserts

尺寸单位: mm  
Dimensions in mm

刀杆R/L368...08适合安装以下刀片:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片:

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格, 详见技术说明。

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

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L368.1...	4.15T15P	T15PQ

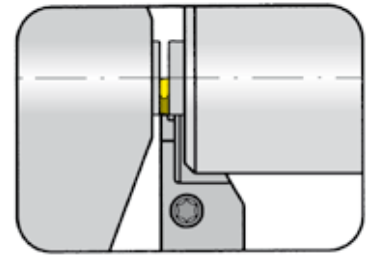
H

# 切断 PARTING OFF



刀杆型号  
TOOLHOLDER Type

**368**  
带内冷  
with through coolant supply

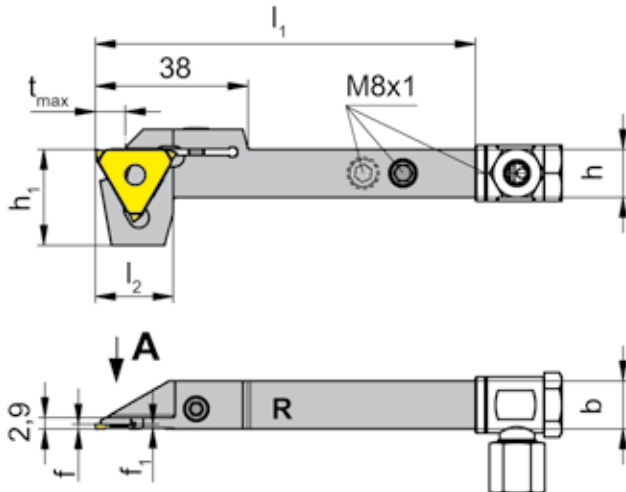
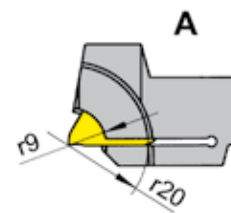


槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	0.5 - 1.5 mm

用于TRAUB ( TNL12/7 ) 机床  
for machines TRAUB (TNL12/7)

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled inserts

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>
R/L368.1212.08.IK	12	12	95	19.5	24	1.0	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.08.IK	16	16						
R/L368.1212.11.IK	12	12	95	19.5	24	1.3	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.11.IK	16	16						

注明R或L型  
State R or L version

a<sub>1</sub> 见刀片  
a<sub>1</sub> see indexable inserts

尺寸单位: mm  
Dimensions in mm

刀杆R/L368...08.IK用于可转位刀片:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08.IK for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11.IK用于可转位刀片:

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11.IK for indexable inserts

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格, 详见技术说明。

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

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	螺纹锁紧销 Threaded pin	冷却接头 Coolant supply
R/L368.1...	4.15T15P	T15PQ	DIN913-M8x1x5	004.00.61

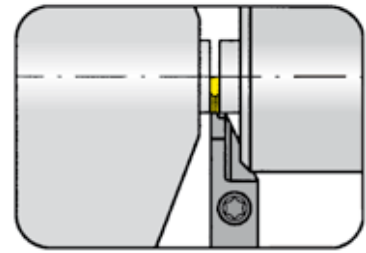


# 切断 PARTING OFF



刀杆 型号  
TOOLHOLDER Type

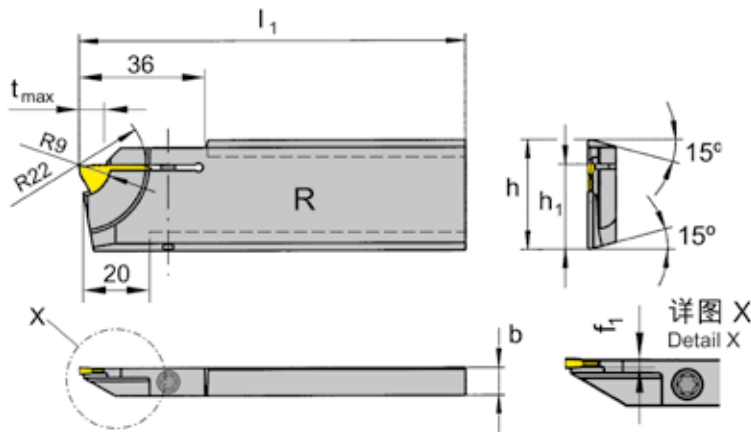
**368**  
加强型  
reinforced version



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	0.5 - 1.5 mm

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled inserts

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>
R/L368-2608-08	26	8	110	21.4	1.0	8
R/L368-3208-08	32	8	110	24.8	1.0	8
R/L368-2608-11	26	8	110	21.4	1.3	8
R/L368-3208-11	32	8	110	24.8	1.3	8

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格，详见技术说明。

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

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L368....	4.15T15P	T15PQ

H

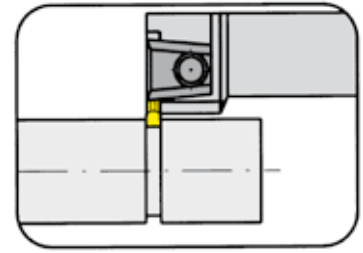
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 369

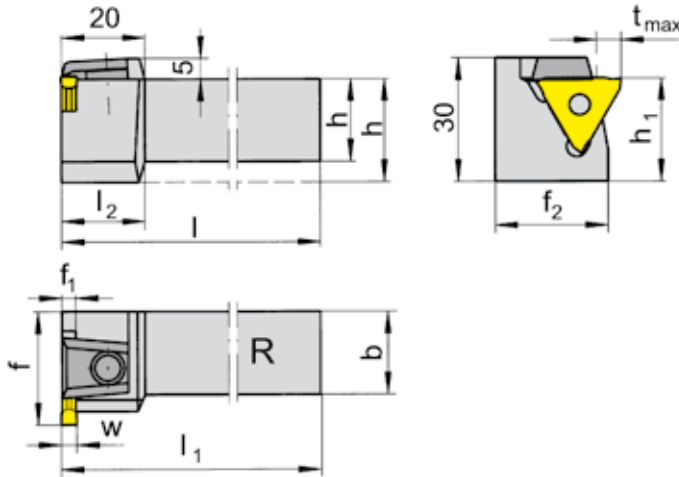


槽深可达 6.0 mm  
夹持范围 0.5 - 6.3 mm

Depth of groove up to 6.0 mm  
Clamping range 0.5 - 6.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	l <sub>2</sub>	f	f <sub>1</sub>	f <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L369.2020.01 R/L369.2525.01	20 25	25	20 25	125 150	l-f <sub>1</sub> +w-a <sub>1</sub>	20 -	27 32	1.5	23.5 28.5	4	01	0.5 - 1.9
R/L369.2020.02 R/L369.2525.02	20 25	25	20 25	125 150	l-f <sub>1</sub> +w-a <sub>1</sub>	20 -	27 32	2.5	23.5 28.5	6	02	1.9 - 2.9
R/L369.2020.03 R/L369.2525.03	20 25	25	20 25	125 150	l-f <sub>1</sub> +w-a <sub>1</sub>	20 -	27 32	3.5	23.5 28.5	6	03	2.9 - 3.9
R/L369.2020.04 R/L369.2525.04	20 25	25	20 25	125 150	l-f <sub>1</sub> +w-a <sub>1</sub>	20 -	27 32	4.5	23.5 28.5	6	04	3.9 - 6.3

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 $t_{\text{max}}$   
 $t_{\text{max}}$  can be reached only with workpiece  $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L369.2...	16.4	6.25	SW3,0DIN911

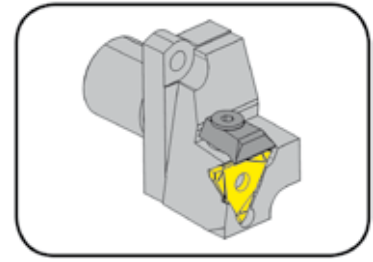
# 切槽和车削

## GROOVING and TURNING



刀杆 型号  
TOOLHOLDER Type

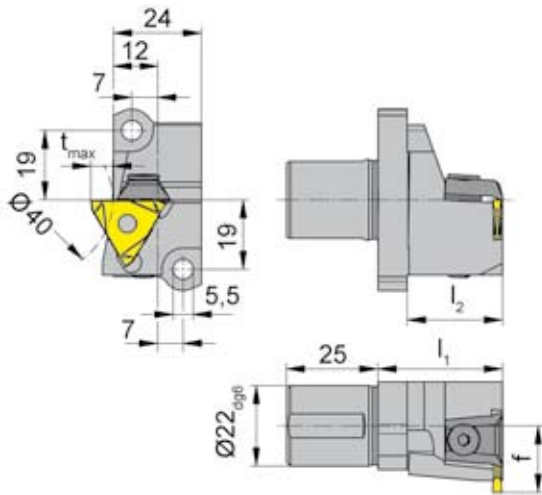
# 369



槽深	Depth of groove	4.0 - 6.0 mm
夹持范围	Clamping range	0.5 - 2.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



L=左手型  
L = left hand version shown

Star SV12/20/32  
SR10/20/32和SB16  
Star SV 12/20/32  
SR 10/20/32 and SB 16

产品型号 Part number	$l_1$	$l_2$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
<b>L369.A022.18.01</b>	34	26	18.2	4	01	0.5 - 1.9
<b>L369.A022.18.02</b>	34	26	18.2	6	02	1.9 - 2.9

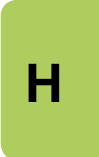
按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
L369.A022.18.0...	<b>16.4</b>	<b>6.25</b>	<b>SW3,0DIN911</b>

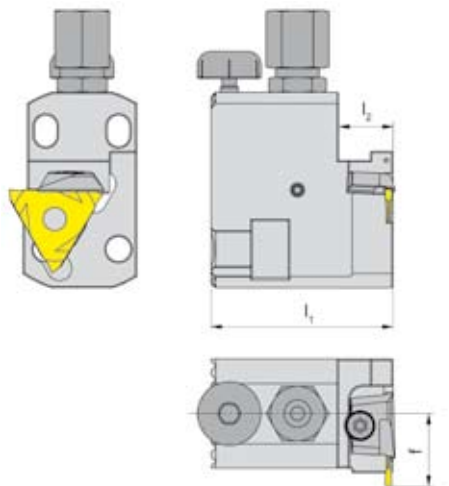


**GRAF刀夹 型号**  
CARTRIDGE GRAF Type

**64/65**  
带内冷  
with through coolant supply



槽深	Depth of groove	4.0 mm
夹持范围	Clamping range	0.5 - 2.9 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$l_1$	$l_2$	f	规格 Size	夹持范围 Clamping range
<b>R/L64IK</b>	40	12	16	01	0.5 - 1.9
<b>R/L65IK</b>	40	12	16	02	1.9 - 2.9

注明R或L型  
State R or L version

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

**附件**  
Spare parts

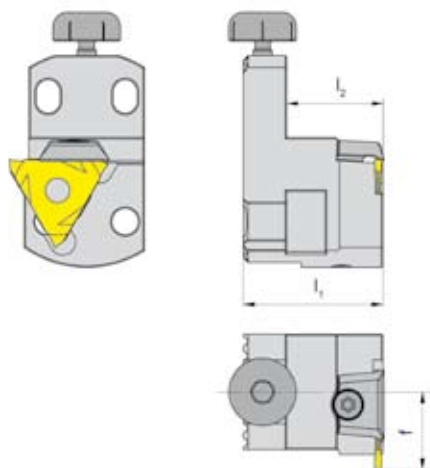
Graf刀夹 Cartridge Graf	压板 Clamp	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply
L6...	<b>4.082L</b>	<b>002.00.69</b>	<b>004.00.19</b>
R6...	<b>4.081R</b>	<b>002.00.69</b>	<b>004.00.19</b>

**GRAF刀夹 型号**  
CARTRIDGE GRAF Type

# 64/65/99

无内冷  
no coolant supply

槽深	Depth of groove	4.0 mm
夹持范围	Clamping range	0.5 - 3.9 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

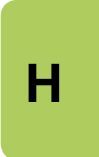
产品型号 Part number	$l_1$	$l_2$	f	规格 Size	夹持范围 Clamping range
R/L64	29	20	16	01	0.5 - 1.9
R/L65	29	20	16	02	1.9 - 2.9
R/L99	29	20	16	03	2.9 - 3.9

注明R或L型  
State R or L version  
按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

附件  
Spare parts

Graf刀夹 Cartridge Graf	压板 Clamp	高度调节螺钉 Height adjustment screw
R/L...	4.078	002.00.69

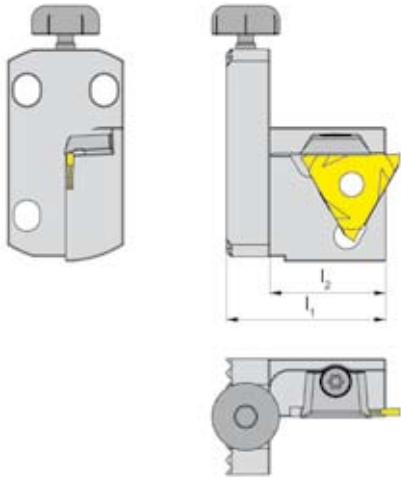


可调刀杆 型号  
ADJUSTABLE HOLDER Type

### N67/N68/N98

无内冷  
no coolant supply

槽深	Depth of groove	4.0 mm
夹持范围	Clamping range	0.5 - 3.9 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



H

产品型号 Part number	$l_1$	$l_2$	规格 Size	夹持范围 Clamping range
N67	33	29	01	0.5 - 1.9
N68	33	29	02	1.9 - 2.9
N98	33	29	02	2.9 - 3.9

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

附件  
Spare parts

可调刀杆 Adjustable holder	压板 Clamp	高度调节螺钉 Height adjustment screw
N...	4.078	002.00.69

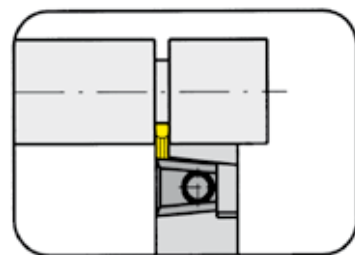
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 390

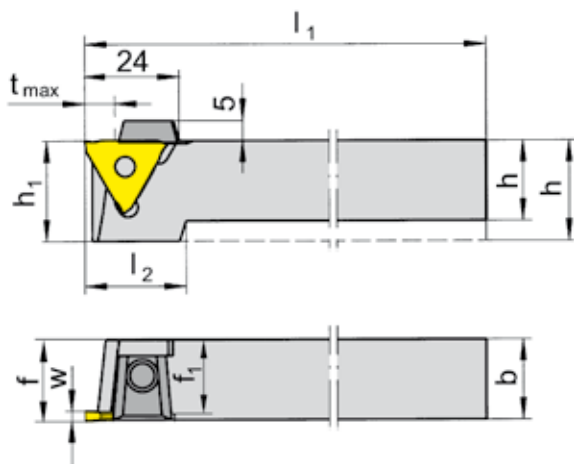


槽深可达 8.0 mm  
夹持范围 1.4 - 5.3 mm

Depth of groove up to 8.0 mm  
Clamping range 1.4 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L390.2020.01 R/L390.2525.01	20 25	20 25	125 150	22 -	25	18.5 23.5	f <sub>1</sub> +w-a <sub>1</sub>	8	01	1.4 - 1.9
R/L390.2020.02 R/L390.2525.02 R/L390.3232.02	20 25 32	20 25 32	125 150 170	22 - -	25 25 32	17.5 22.5 29.5	f <sub>1</sub> +w-a <sub>1</sub>	8	02	1.9 - 2.9
R/L390.2020.03 R/L390.2525.03 R/L390.3232.03	20 25 32	20 25 32	125 150 170	22 - -	25 25 32	16.5 21.5 28.5	f <sub>1</sub> +w-a <sub>1</sub>	8	03	2.9 - 3.9
R/L390.2020.04 R/L390.2525.04 R/L390.3232.04	20 25 32	20 25 32	125 150 170	22 - -	25 25 32	14.8 19.8 26.8	f <sub>1</sub> +w-a <sub>1</sub>	8	04	3.9 - 5.3

注明R或L型  
State R or L version

w, a<sub>1</sub> 见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

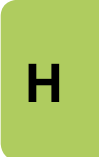
按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 125\text{mm}$ 时才能达到最大切深t<sub>max</sub>  
t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 125\text{ mm}$

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L390....	16.4	6.25	SW3,0DIN911



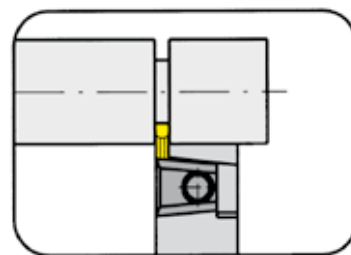
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

# 391

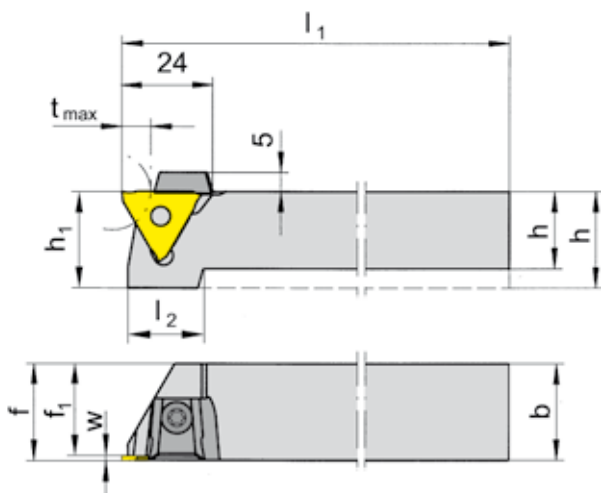


槽深可达 8.0 mm  
夹持范围 0.5 - 1.9 mm

Depth of groove up to 8.0 mm  
Clamping range 0.5 - 1.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L391.1212.01	12	12	100	21	21	10.5	$f_1+w-a_1$	8	01	0.5-1.9
R/L391.1616.01	16	16	125	21	21	14.5				
R/L391.2020.01	20	20	125	21	21	18.5				
R/L391.2525.01	25	25	150	-	25	23.8				

注明R或L型  
State R or L version

$w, a_1$  见刀片  
 $w, a_1$  see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 20\text{mm}$ 时才能达到 $t_{max}$   
 $t_{max}$  can be reached only with workpiece  $\varnothing \leq 20\text{mm}$

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L391.1212.01	12.3	030.0422.T10P	SW3.0DIN911	T10PL
R/L391.1616.01	14.4	5.32.3T15P		T15PQ
R/L391.2...01	16.4	6.25		



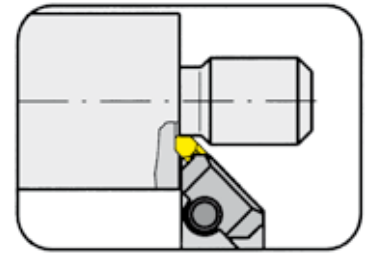
# 切退刀槽 ( 外圆 )

## GROOVING CORNER RELIEFS (external)



刀杆 型号  
TOOLHOLDER Type

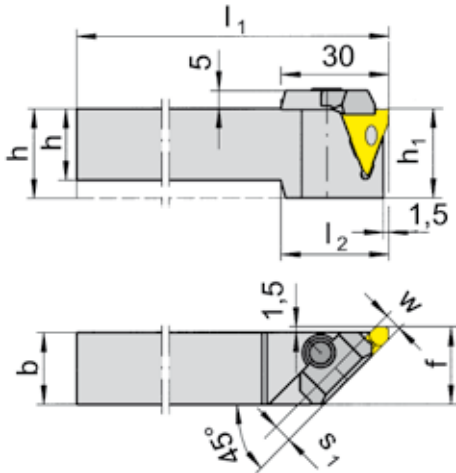
# 309



类似于DIN509F型退刀槽  
Corner reliefs similar to DIN 509 form "F"

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	$s_1$	$l_2$	规格 Size	夹持范围 Clamping range
R/L309.1616.01	16	16	125	25	21.5	1.5	30	01	0.5 - 1.9
R/L309.2020.02	20	20	125	25	21.5	-	30	02	1.9 - 2.9
R/L309.2525.02	25	25	150	25	26.5	2.5	-	02	1.9 - 2.9
R/L309.3232.02	32	32	170	32	33.5	-	-	-	-
R/L309.2020.03	20	20	125	25	21.5	-	30	03	2.9 - 3.9
R/L309.2525.03	25	25	150	25	26.5	3.5	-	03	2.9 - 3.9
R/L309.3232.03	32	32	170	32	33.5	-	-	-	-
R/L309.2020.04	20	20	125	25	21.5	-	30	04	3.9 - 5.3
R/L309.2525.04	25	25	150	25	26.5	5.2	-	04	3.9 - 5.3
R/L309.3232.04	32	32	170	32	33.5	-	-	-	-

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L309....	21.4	6.25	SW3,0DIN911

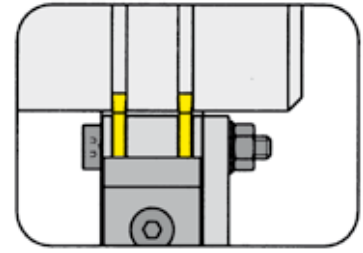
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

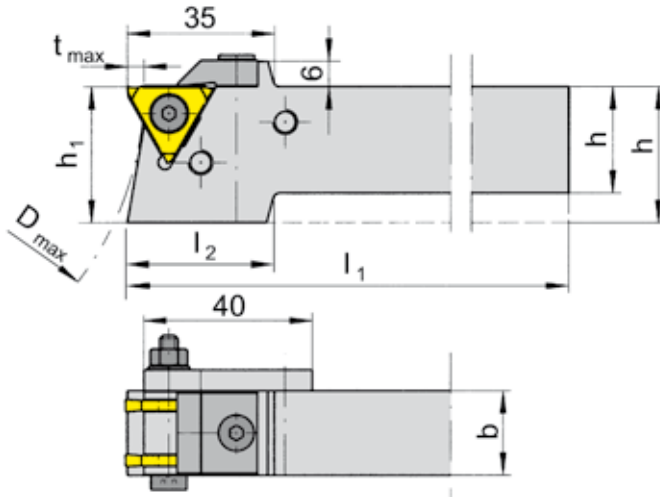
# 340



多槽切削  
Multi grooving

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



仅适用于磨削外边缘"G"型  
use only with special inserts  
ground periphery type "G"

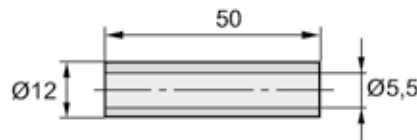
产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
340.2020.01	20			35				
340.2520.01	25	20	170	35	32	4	160	01
340.3220.01	32			-				

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

用于间隔环的管子  
产品型号:340.0012.50  
需单独订购  
Tube for producing spacing rings  
Part number 340.0012.50 separate order required



附件  
Spare parts

刀杆 Toolholder	六角螺母 Hex nut	压板 Clamp	螺钉 Screw	螺钉 Screw	螺钉 Screw	扳手 Wrench	弹簧片 Spring Plate	垫圈 Washer
340....	M5DIN439	340.0200	5.30.7984	6.25	6.16.7991	SW3.0DIN911	5.12.03	B5.3DIN125

刀杆 Toolholder	法兰 Flange	螺纹垫圈 Thread Ring
340....	24.40	12.3.8.5

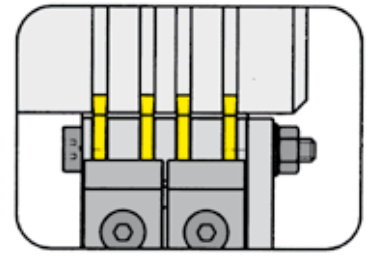
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

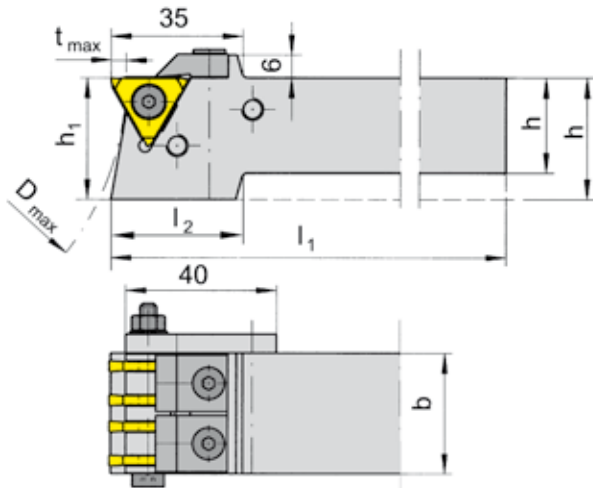
# 340



多槽切削  
Multi grooving

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



右手安装  
Right hand mounted

仅适用于磨削外边缘"G"型  
use only with special inserts  
ground periphery type "G"

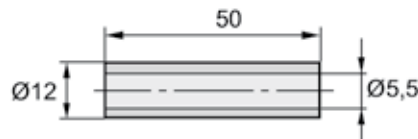
产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
340.2532.02	25	32	170	35	32	4	160	02
340.3232.02	32	32	170	-	32	4	160	02

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

用于间隔环的管子  
产品型号:340.0012.50  
需单独订购  
Tube for producing spacing rings  
Part number 340.0012.50 separate order required



附件  
Spare parts

刀杆 Toolholder	六角螺母 Hex nut	压板 Clamp	螺钉 Screw	螺钉 Screw	螺钉 Screw	扳手 Wrench	弹簧片 Spring Plate	垫圈 Washer
340....	M5DIN439	22.16	5.40.7984	6.25	6.16.7991	SW3.0DIN911	5.12.03	B5.3DIN125

刀杆 Toolholder	法兰 Flange	螺纹垫圈 Thread Ring
340....	24.40	12.3.8.5

# 切槽 ( 内圆 )

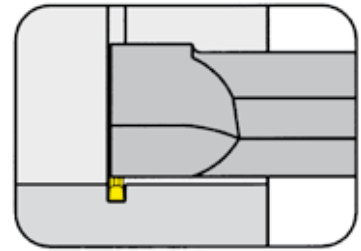
## GROOVING (internal)



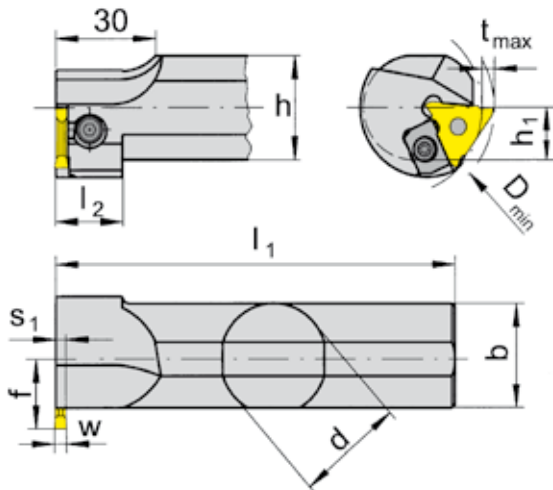
### 常规刀杆 型号

# 330

BASIC TOOLHOLDER Type



孔径Ø 自	Bore Ø from	46.0 mm
夹持范围	Clamping range	1.9 - 6.3 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
46	2,0
50	3,0
60	4,0
80	4,5
100	5,0

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	s <sub>1</sub>	b	规格 Size	夹持范围 Clamping range
R/L330.0025.K2	25	170	20	23	11.5	20	46	2.5	25	02	1.9 - 2.9
R/L330.0032.K2	32	200	20	30	15.0	20			30		
R/L330.0040.K2	40	250	-	38	19.0	24			38		
R/L330.0025.K3	25	170	20	23	11.5	20	46	3.5	25	03	2.9 - 3.9
R/L330.0032.K3	32	200	20	30	15.0	20			30		
R/L330.0040.K3	40	250	-	38	19.0	24			38		
R/L330.0025.K4	25	170	20	23	11.5	20	46	5.5	25	04	3.9 - 6.3
R/L330.0032.K4	32	200	20	30	15.0	20			30		
R/L330.0040.K4	40	250	-	38	19.0	24			38		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

常规刀杆 Basic toolholder	压板 Clamp	导向块 Guide Strip	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L330.00...	15.4	020.1025.0170	5.12T20P	SW3.0DIN911	T20PQ

# 切槽和切断

## GROOVING and PARTING OFF

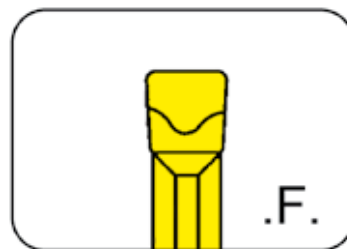


### 可转位刀片 型号

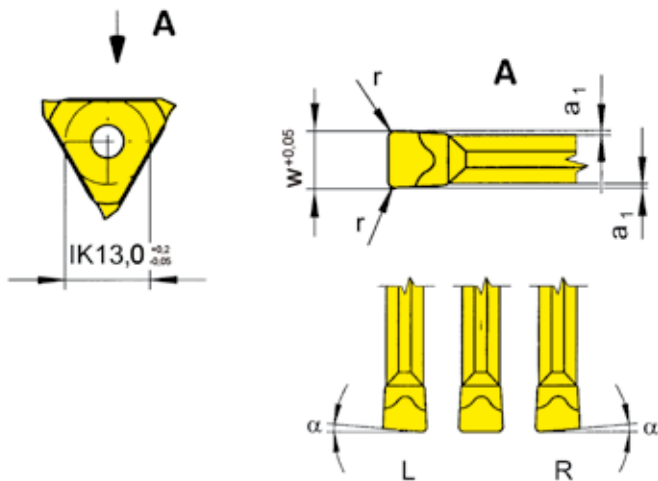
INDEXABLE INSERT Type

### S312

带烧结槽型  
with sintered geometries



槽宽	Width of groove	2.0 - 5.0 mm
----	-----------------	--------------



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

- 型号 309
- Type 330
- 360
- 361
- 369
- 390

槽型.F  
Geometry .F

产品型号 Part number	w	r	a <sub>1</sub>	α	规格 Size	硬质合金牌号				
						TN35	TI25	TA45	TF46	
R/LS312.0520.F2	2.0			5°	02		▲/▲		▲/Δ	
S312.0200.F2	2.0			0°			▲		▲	
R/LS312.0525.F2	2.5	0.2	0.25	5°			▲/▲		▲/Δ	
S312.0250.F2	2.5			0°			▲		▲	
S312.0400.F2	4.0	0.2		0°	04				▲	
S312.0400.F4	4.0	0.4	0.25					▲		Δ
S312.0500.F2	5.0	0.2								▲
S312.0500.F4	5.0	0.4								▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●	●	●
M	●	○	○
K	●	●	●
N	●	●	●
S	●	○	○
H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)

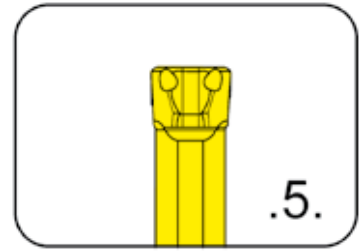


### 可转位刀片 型号

INDEXABLE INSERT Type

## S312

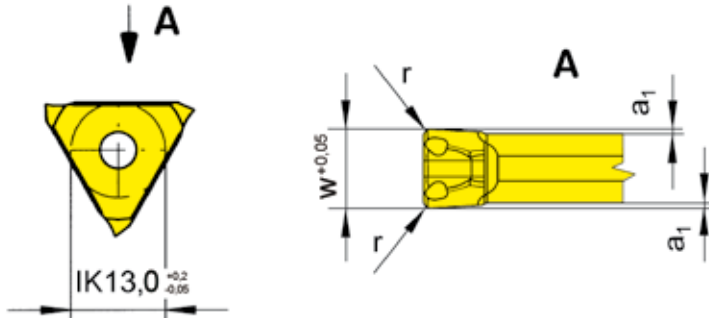
带烧结槽型  
with sintered geometries



槽宽

Width of groove

2.5 - 5.0 mm



配合 刀杆

for use with Toolholder

型号 309  
Type 330  
360  
361  
369  
390

槽型.5

Geometry .5

产品型号 Part number	w	r	a <sub>1</sub>	规格 Size	TN32	TN35	TI25	TF45	TF46	AS62	AS66	
S312.0250.52 S312.0250.54	2.5	0.2 0.4	0.25	02	▲ ▲	▲	▲ ▲	▲ ▲	▲ ▲	▲ ▲	▲ ▲	
S312.0300.52 S312.0300.54	3.0	0.2 0.4	0.25	03	▲ ▲		▲ ▲	▲ ▲	▲ ▲	▲ ▲	▲ ▲	
S312.0400.52 S312.0400.54	4.0	0.2 0.4	0.25	04	▲		▲		▲	▲	▲	
S312.0500.52 S312.0500.54	5.0	0.2 0.4			▲ ▲		▲		▲	▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks					P	•	•	•	•	•	•	
● 主要应用 / main recommendation					M		•	•	•	○	○	
○ 可选推荐 / alternative recommendation					K		•	•	•	•	•	
■ 无涂层牌号 / uncoated grades					N		•	•	•	•	•	
■ 涂层牌号 / coated grades					S		•	•	•	○	○	
■ 钎焊/金属陶瓷 / brazed/Cermet					H							

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

H

# 切断 PARTING OFF

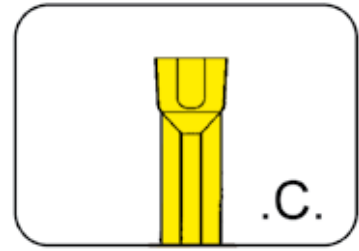


## 可转位刀片 型号

INDEXABLE INSERT Type

## S312

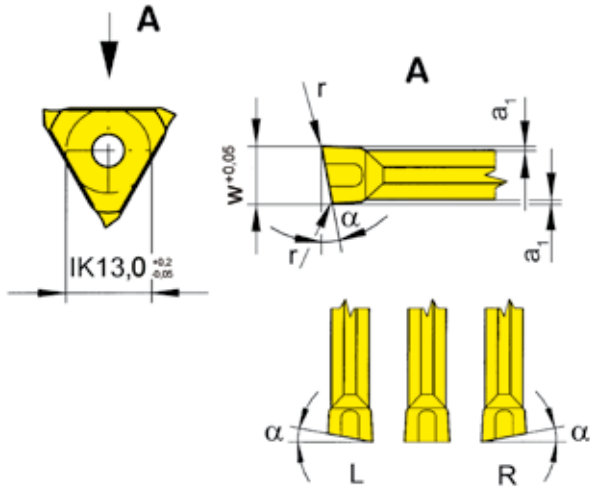
带烧结槽型  
with sintered geometries



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
2.0 - 3.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 360  
Type 361  
369

槽型.C  
Geometry .C

产品型号 Part number	w	r	a <sub>1</sub>	α	规格 Size	硬质合金牌号 Carbide grades			
						TN32	TI25	TA45	TF46
S312.0200.C2	2.0			0°	02		▲		▲
R/LS312.0520.C2	2.0	0.2	0.25	5°			▲/▲		▲/▲
S312.0250.C2	2.5			0°			▲		▲
R/LS312.0525.C2	2.5			5°			▲/▲		▲/Δ
S312.0300.C2	3.0	0.2	0.25	0°	03		▲		Δ
R/LS312.0530.C2				5°			▲/▲		Δ/Δ
▲ 库存 / on stock   Δ 4周 / 4 weeks						P	•		•
• 主要应用 / main recommendation						M	•		o
o 可选推荐 / alternative recommendation						K	•		•
■ 无涂层牌号 / uncoated grades						N	•		•
■ 涂层牌号 / coated grades						S	•		o
■ 钎焊/金属陶瓷 / brazed/Cermet						H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

H

# 切槽和切断

## GROOVING and PARTING OFF

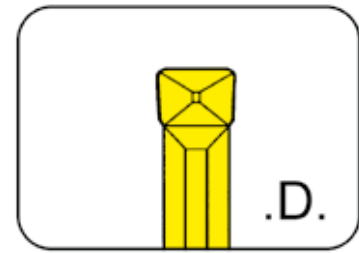


### 可转位刀片 型号

INDEXABLE INSERT Type

### S312

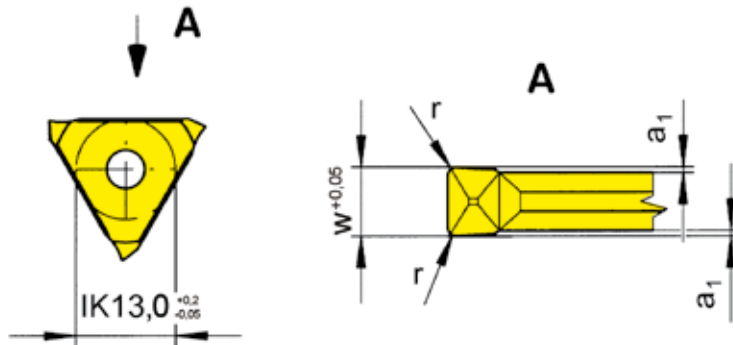
带烧结槽型  
with sintered geometries



槽宽

Width of groove

2.0 - 3.0 mm



配合 刀杆

for use with Toolholder

型号 309

Type 330

360

361

369

390

槽型.D

Geometry .D

H

产品型号 Part number	w	r	a <sub>1</sub>	规格 Size	硬质合金牌号					
					TN32	TI25	TF45	TF46	AS62	AS66
S312.0200.D2	2.0	0.2	0.25	02	▲	▲		▲	▲	▲
S312.0200.D4	2.0	0.4			▲	▲		▲	▲	▲
S312.0250.D2	2.5	0.2			▲	▲	▲	▲	▲	▲
S312.0250.D4	2.5	0.4			▲	▲	▲	▲	▲	▲
S312.0300.D2	3.0	0.2	0.25	03	▲	▲	▲	▲	▲	▲
S312.0300.D4		0.4					▲	▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet					P	●	●	●	●	●
					M		●	●	○	○
					K		●	●	●	●
					N		●	●	●	●
					S		●	●	○	○
					H					

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽 ( 外圆 )

## GROOVING (external)

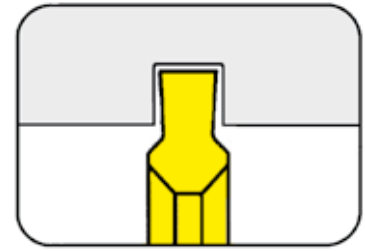


### 可转位刀片 型号

INDEXABLE INSERT Type

# 312

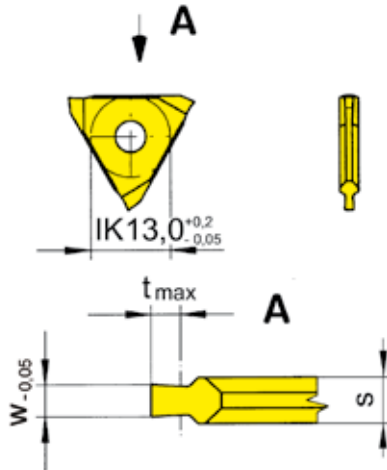
带圆形断屑槽  
with round chip breaker



卡簧槽  
卡簧宽度 Nw

Circlip grooves  
Width of circlip Nw

DIN 471/472  
0.5 - 1.0 mm



配合 刀杆  
for use with Toolholder

型号 360...01  
Type 361...01  
369...01

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	Nw	w	t <sub>max</sub>	s	规格 Size	MG12	P20	H20	TN32	TN35	TI25	TA45
312.0050.15	0.5	0.57	0.7	1.5	01				▲			
312.0060.15	0.6	0.67	0.8			▲						
312.0070.15	0.7	0.77	1.1			▲						
312.0080.15	0.8	0.87	1.2			▲						
312.0090.15	0.9	0.97	1.4			▲						
312.0100.15	1.0	1.07	1.6			▲						
						P			●			
						M						
						K						
						N						
						S						
						H						

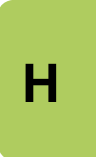
- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

按需提供更多尺寸  
Further sizes upon request

硬质合金牌号  
Carbide grades



# 切槽 ( 内圆和外圆 )

## GROOVING (external and internal)

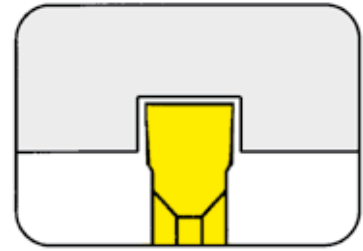


### 可转位刀片 型号

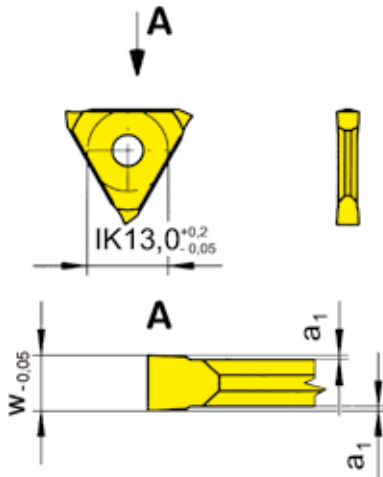
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



卡簧槽	Circlip grooves	DIN 471/472
卡簧宽度Nw	Width of circlip Nw	0.50 - 5.15 mm



配合 刀杆  
for use with Toolholder

- 型号 309  
Type 330  
360  
361  
369  
390

刀片长度重复定位精度  
±0.02mm  
Indexability length ± 0,02 mm

H

产品型号 Part number	Nw	w	a <sub>1</sub>	规格 Size	K10	MG12	P20	H20	TN32	TN35	TI25	TF45	TF46
312.0050.00	0.50	0.57	0.07	01	▲		▲		▲			▲	▲
312.0060.00	0.60	0.67	0.07		▲		▲		▲			▲	▲
312.0070.00	0.70	0.77	0.08		▲		▲		▲			▲	▲
312.0080.00	0.80	0.87	0.08		▲		▲		▲			▲	▲
312.0090.00	0.90	0.97	0.08		▲		▲		▲	▲		▲	▲
312.0100.00	1.00	1.07	0.09		▲		▲		▲	▲		▲	▲
312.0110.00	1.10	1.24	0.20		▲		▲		▲	▲		▲	▲
312.0130.00	1.30	1.44	0.20		▲		▲		▲	▲		▲	▲
312.0160.00	1.60	1.74	0.20		▲		▲		▲	▲		▲	▲
312.0185.00	1.85	1.99	0.20		▲	▲	▲	▲	▲	▲	▲	▲	▲
312.0215.00	2.15	2.29	0.20	02	▲		▲	▲	▲	▲		▲	▲
312.0265.00	2.65	2.79			▲		▲	▲	▲	▲	▲		▲
312.0315.00	3.15	3.29	0.20	03	▲		▲	▲	▲	▲		▲	▲
312.0415.00	4.15	4.29	0.20	04	▲		▲		▲	▲		▲	▲
312.0515.00	5.15	5.29			▲		▲	▲	▲	▲	▲		▲
▲ 库存 / on stock    Δ 4周 / 4 weeks					P	●	○	●	●	●	●	●	●
● 主要应用 / main recommendation					M	○	●	○	●	●	●	○	○
○ 可选推荐 / alternative recommendation					K	●	●		●	●	●	●	●
■ 无涂层牌号 / uncoated grades					N	●	●		●	●	●	●	●
■ 涂层牌号 / coated grades					S	○	●		●	●	●	○	○
■ 钎焊/金属陶瓷 / brazed/Cermet					H								

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

# 切槽 (外圆)

## GROOVING (external)

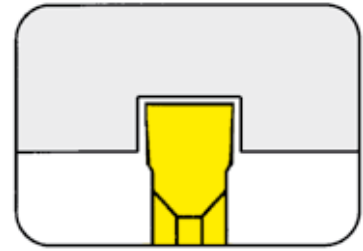


### 可转位刀片 型号

INDEXABLE INSERT Type

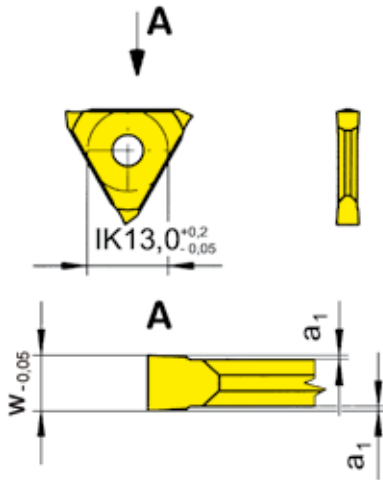
# 312

带圆形断屑槽  
with round chip breaker



卡簧槽	Circlip grooves	DIN 471/472
卡簧宽度 Nw	Width of circlip Nw	1.10 - 5.15 mm

推荐用于断续切削  
recommended for interrupted cut



配合 刀杆  
for use with Toolholder

型号 360  
Type 361  
369  
390

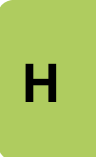
刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	Nw	w	a <sub>1</sub>	规格 Size	MG12	P20	TN32	TN35	TI25	TA45
312.0110.80	1.10	1.24	0.2	01				▲		
312.0130.80	1.30	1.44			▲					
312.0160.80	1.60	1.74			▲					
312.0185.80	1.85	1.99			▲					
312.0215.80	2.15	2.29	0.2	02			▲			
312.0265.80	2.65	2.79			▲					
312.0315.80	3.15	3.29	0.2	03			▲			
312.0415.80	4.15	4.29			▲					
312.0515.80	5.15	5.29			▲					
<ul style="list-style-type: none"> <li>▲ 库存 / on stock    Δ 4周 / 4 weeks</li> <li>● 主要应用 / main recommendation</li> <li>○ 可选推荐 / alternative recommendation</li> <li>■ 无涂层牌号 / uncoated grades</li> <li>■ 涂层牌号 / coated grades</li> <li>■ 钎焊/金属陶瓷 / brazed/Cermet</li> </ul>					P			●		
					M			●		
					K			●		
					N			●		
					S			●		
					H					

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



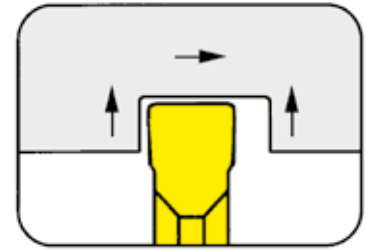


## 可转位刀片 型号

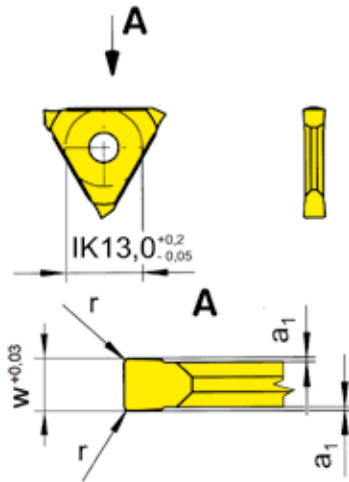
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.0 - 4.0 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 369

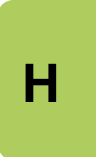
刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	w	r	a <sub>1</sub>	规格 Size		K10	MG12	P20	H20	TN32	TN35	TI22	TI25	TF45	AS62	
312.0100.02	1.0	0.2	0.10	01												
312.0150.02	1.5		0.25													
312.0200.02	2.0	0.2	0.25	02				▲								
312.0200.04		0.4								▲						
312.0300.02	3.0	0.2	0.25	03				▲								
312.0300.06	3.0	0.6		03				▲								
312.0300.08	3.0	0.8		03				▲								
312.0400.02	4.0	0.2		04					▲							
312.0400.08	4.0	0.8	0.25	04				▲								
312.0400.12		1.2								▲						
▲ 库存 / on stock    △ 4周 / 4 weeks					P	•		•	•	•	•	•	•	•	•	
● 主要应用 / main recommendation					M	○			○		•		•	•		
○ 可选推荐 / alternative recommendation					K	•					•		•	•		
■ 无涂层牌号 / uncoated grades					N	•					•		•	•		
■ 涂层牌号 / coated grades					S	○					•		•	•		
■ 钎焊/金属陶瓷 / brazed/Cermet					H											

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽和侧车削

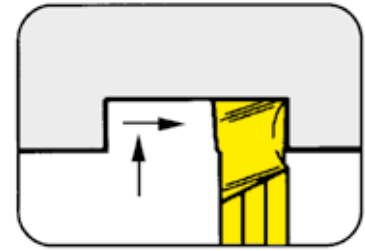
## GROOVING and SIDE TURNING



### 可转位刀片 型号

# 312

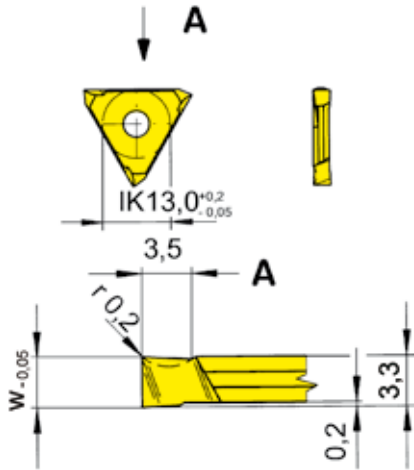
INDEXABLE INSERT Type



切深可达

Depth of cut up to

3.5 mm



L=左手型

L = left hand version shown

R=右手型

R = right hand version

配合 刀杆

for use with Toolholder

型号 360

Type 361

刀片长度重复定位精度  
±0.02mm

Indexability length ± 0,02 mm

产品型号 Part number	w	规格 Size	MG12	P20	TN32	TN35	TI22	TA45
<b>R/L312.3031.33</b>	3.29	03		▲/▲	▲/▲			
▲ 库存 / on stock Δ 4周 / 4 weeks			P	•	•			
● 主要应用 / main recommendation			M					
○ 可选推荐 / alternative recommendation			K					
■ 无涂层牌号 / uncoated grades			N					
■ 涂层牌号 / coated grades			S					
■ 钎焊/金属陶瓷 / brazed/Cermet			H					

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

特殊的刀尖几何结构在径向和轴向右侧切槽时都有一个正切削角。

The special cutting geometry permits a positive chip breaking angle when keeping a straight and right angled cutting edge.

硬质合金牌号

Carbide grades

# 切退刀槽 ( 外圆 )

## GROOVING CORNER RELIEFS (external)

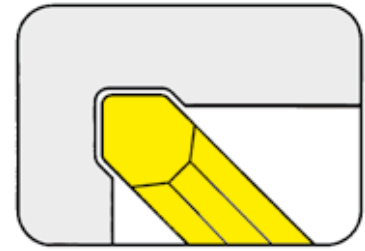


### 可转位刀片 型号

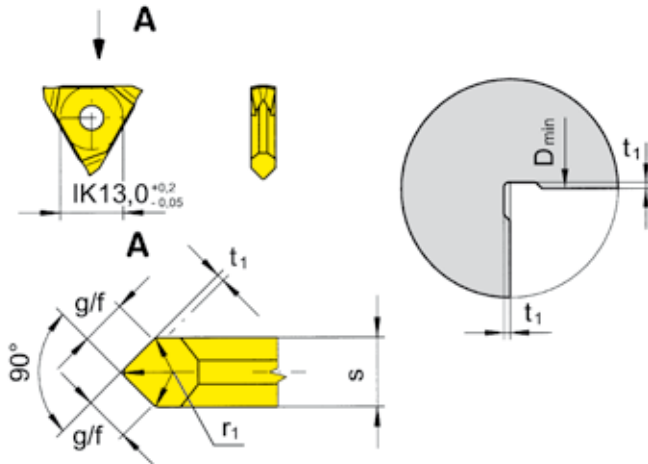
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



类似于DIN509F型退刀槽  
Corner reliefs similar to DIN 509 form "F"



配合 刀杆  
for use with Toolholder

型号 309  
Type

刀片长度重复定位精度  
±0.02mm  
Indexability length ± 0,02 mm

产品型号 Part number	r <sub>1</sub>	g <sub>f</sub>	s	t <sub>1</sub>	D <sub>min</sub>	规格 Size	MG12	P20	TN32	TN35	TI25	TA45	
312.0602.24	0.6	1.7	2.4	0.2	19	02		▲					
312.0603.33	0.6	2.3	3.3	0.3	23	03		▲					
312.1002.30	1.0	2.1	3.0	0.2	20			▲					
312.1004.50	1.0	3.6	5.0	0.4	29	04		▲					
312.1603.50	1.6			0.3	25			▲					
▲ 库存 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet							P	●					
							M						
							K						
							N						
							S						
							H						

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

H

# 切退刀槽 ( 外圆 )

## GROOVING CORNER RELIEFS (external)

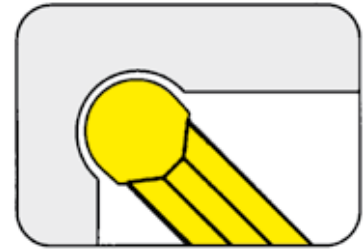


### 可转位刀片 型号

INDEXABLE INSERT Type

# 312

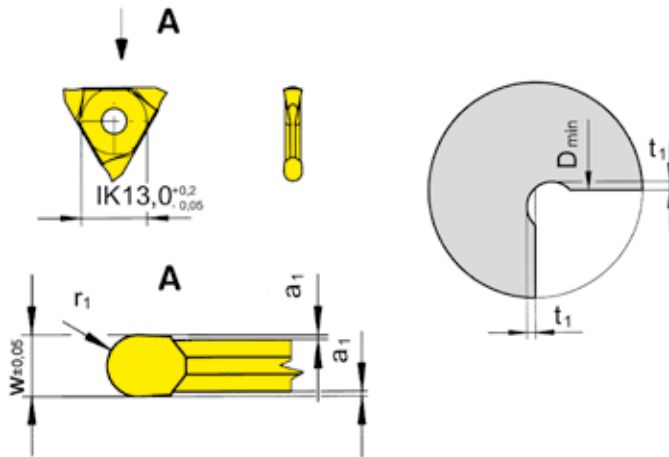
带圆形断屑槽  
with round chip breaker



圆头	Full radius	r 1.0 - 2.5 mm
----	-------------	----------------

配合 刀杆  
for use with Toolholder

型号 309  
Type



刀片长度重复定位精度  
±0.02mm  
Indexability length ± 0,02 mm

H

产品型号 Part number	r <sub>1</sub>	w	a <sub>1</sub>	t <sub>1</sub>	D <sub>min</sub>	规格 Size	K10	P20	TN32	TN35	TI25	TA45	AS62
312.0010.20	1.0	2	0.2	0.7	22	02	▲	▲	▲	▲			
312.0015.30	1.5	3	0.2	1.0	27	03	▲	▲	▲				
312.0020.40	2.0	4		1.2	30	04	▲	▲	▲				
312.0025.50	2.5	5	0.2	1.5	35		▲	▲	▲				
▲ 库存 / on stock    Δ 4周 / 4 weeks							P	●	●	●	●		
● 主要应用 / main recommendation							M	○			●		
○ 可选推荐 / alternative recommendation							K	●			●		
■ 无涂层牌号 / uncoated grades							N	●			●		
■ 涂层牌号 / coated grades							S	○			●		
■ 钎焊/金属陶瓷 / brazed/Cermet							H						

尺寸单位 : mm  
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽和仿形加工 (圆头)

## GROOVING and PROFILING (Full radius)

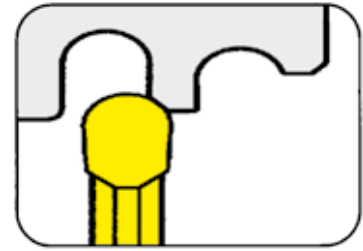


### 可转位刀片 型号

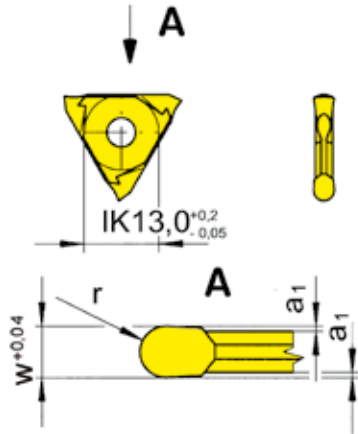
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	6.0 mm
圆头	Full radius	r 0.25 - 2.00 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 369

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	w	r	a <sub>1</sub>	规格 Size	涂层 / Coating					
					MG12	P20	TN32	TN35	TI22	AS62
312.0050.02	0.5	0.25	0.07	01		▲	▲			
312.0100.05	1.0	0.50	0.09		▲	▲				
312.0120.06	1.2	0.60	0.20		▲	▲				
312.0160.08	1.6	0.80	0.25		▲	▲				
312.0200.10	2.0	1.00	0.25		▲	▲				
312.0250.12	2.5	1.25	0.25	02	▲	▲				
312.0300.15	3.0	1.50	0.25		▲	▲				
312.0400.20	4.0	2.00	0.25	03	▲	▲				
▲ 库存 / on stock    Δ 4周 / 4 weeks					P	●	●			
● 主要应用 / main recommendation					M					
○ 可选推荐 / alternative recommendation					K					
■ 无涂层牌号 / uncoated grades					N					
■ 涂层牌号 / coated grades					S					
■ 钎焊/金属陶瓷 / brazed/Cermet					H					

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further radii upon request

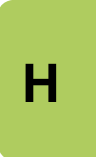
**注意事项 :**

切宽1.6mm以上只推荐用于切槽

**Note:**  
Width of groove up to 1,6 mm recommend only for grooving

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades



# 切槽 ( 外圆 )

## GROOVING (external)

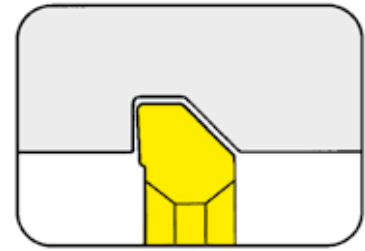


### 可转位刀片 型号

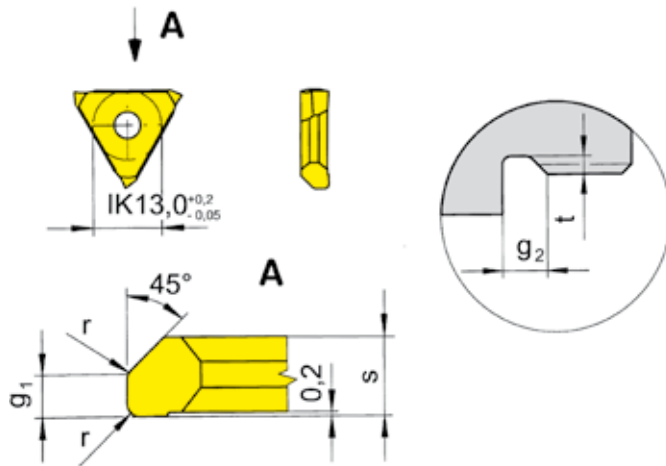
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



DIN76短型螺纹退刀槽  
Thread relief DIN 76 "Short form"



配合 刀杆  
for use with Toolholder

型号 360  
Type 369

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	P	r	s	g <sub>1</sub>	g <sub>2</sub>	t <sub>max</sub>	规格 Size							
								MG12	P20	TN32	TN35	TI22	TA45	
R/L312.1050.17	0.50	0.2		0.60	1.0	0.40	01				▲/			
R/L312.1060.17	0.60	0.4	1.7	0.70	1.2	0.50								
R/L312.1070.17	0.70	0.4		0.85	1.4	0.55								
R/L312.1080.27	0.80	0.4		0.95	1.6	0.65	02				▲/▲			
R/L312.1100.27	1.00	0.6	2.7	1.20	2.0	0.80			▲/			▲/		
R/L312.1125.27	1.25	0.6		1.50	2.5	1.00						▲/▲		
R/L312.1150.37	1.50	0.8	3.7	1.85	3.0	1.15	03				▲/▲			
R/L312.1175.37	1.75	1.0		2.20	3.5	1.30								
R/L312.1200.53	2.00	1.0	5.3	2.50	4.0	1.50	04		▲/▲					
R/L312.1250.53	2.50	1.2	5.3	3.20	5.0	1.80								
R/L312.1300.63	3.00	1.6	6.3	3.80	6.0	2.20								

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●			●		
M				●		
K				●		
N				●		
S				●		
H						

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片  
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

# 切槽 (外圆)

## GROOVING (external)

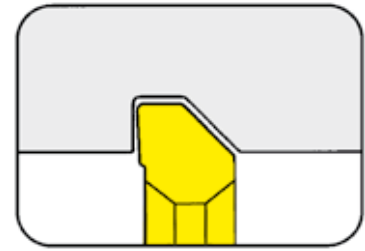


### 可转位刀片 型号

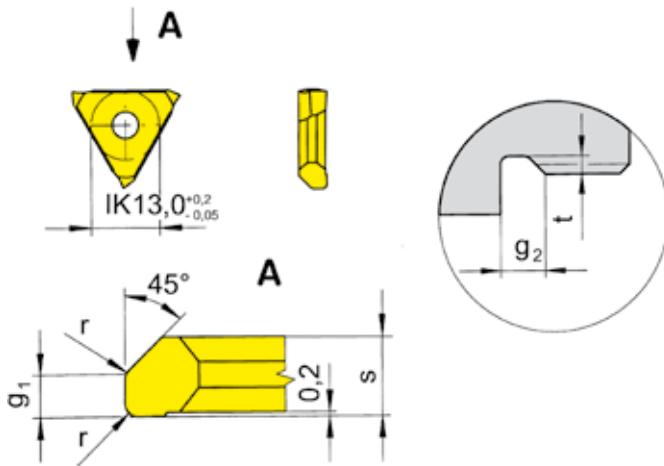
INDEXABLE INSERT Type

# 312

带圆形断屑槽  
with round chip breaker



DIN76标准型螺纹退刀槽  
Thread relief DIN 76 "Standard form"



配合 刀杆  
for use with Toolholder

型号 360  
Type 369

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	P	r	s	$g_1$	$g_2$	$t_{\max}$	规格 Size	MG12	P20	TN32	TN35	TI22	TA45
R/L312.3050.17	0.50	0.2	1.7	1.10	1.5	0.40	01				▲/▲		
R/L312.3060.27	0.60			1.30	1.8	0.50	02				▲/▲		
R/L312.3070.27	0.70	0.4	2.7	1.55	2.1	0.55							
R/L312.3080.27	0.80			1.75	2.4	0.65							
R/L312.3100.37	1.00	0.6	3.7	2.20	3.0	0.80	03				▲/▲		
R/L312.3125.53	1.25	0.6	5.3	2.80	3.8	1.00	04				▲/▲		
R/L312.3150.53	1.50	0.8	5.3	3.35	4.5	1.15							
R/L312.3175.56	1.75	1.0	5.6	4.00	5.3	1.30							
R/L312.3200.63	2.00	1.0	6.3	4.50	6.0	1.50							
▲ 库存 / on stock    ▲ 4周 / 4 weeks								P			•		
● 主要应用 / main recommendation								M			•		
○ 可选推荐 / alternative recommendation								K			•		
■ 无涂层牌号 / uncoated grades								N			•		
■ 涂层牌号 / coated grades								S			•		
■ 钎焊/金属陶瓷 / brazed/Cermet								H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片  
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

硬质合金牌号  
Carbide grades

H

# 切槽 ( 外圆 )

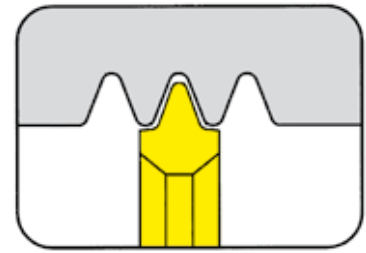
## GROOVING (external)



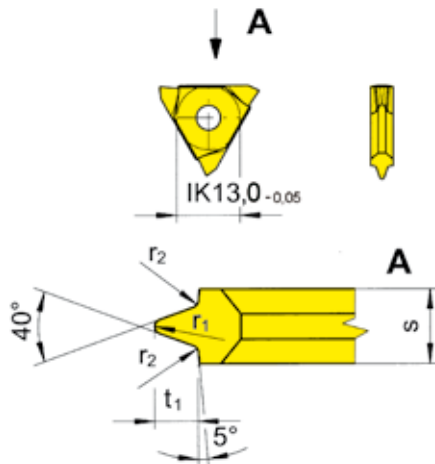
### 可转位刀片 型号

INDEXABLE INSERT Type

# 312



"J"型复合V形皮带轮槽  
Poly-V-belt grooves profile "J"



配合 刀杆  
for use with Toolholder

型号 ...23=340  
Type ...30=360/369

刀片长度重复定位精度  
±0.02mm  
Indexability length ± 0,02 mm

H

产品型号 Part number	s	t <sub>1</sub>	r <sub>1</sub>	r <sub>2</sub>	规格 Size	P20	TN32
312.0223.23	2.34	2.3	0.25	0.2	02	▲	▲
312.0223.30	3.00	2.3	0.25	0.2	03	▲	▲

▲ 库存 / on stock    Δ 4周 / 4 weeks  
● 主要应用 / main recommendation  
○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades  
■ 涂层牌号 / coated grades  
■ 钎焊/金属陶瓷 / brazed/Cermet

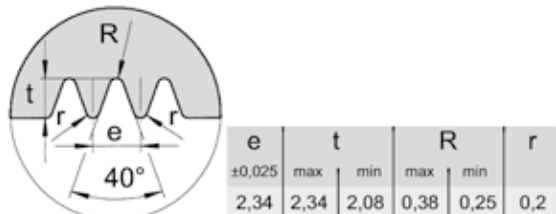
尺寸单位 : mm  
Dimensions in mm

312.0223.23刀片用于多槽切削  
312.0223.30刀片用于单槽切削  
Insert 312.0223.23 for multi grooving  
Insert 312.0223.30 for single grooving

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

槽型 :  
"J"型复合V形皮带轮槽

Shape of groove:  
Poly-V-belt grooves profile "J"



硬质合金牌号  
Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

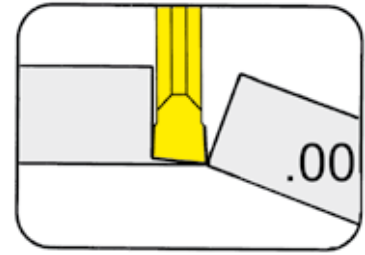


### 可转位刀片 型号

INDEXABLE INSERT Type

### 312

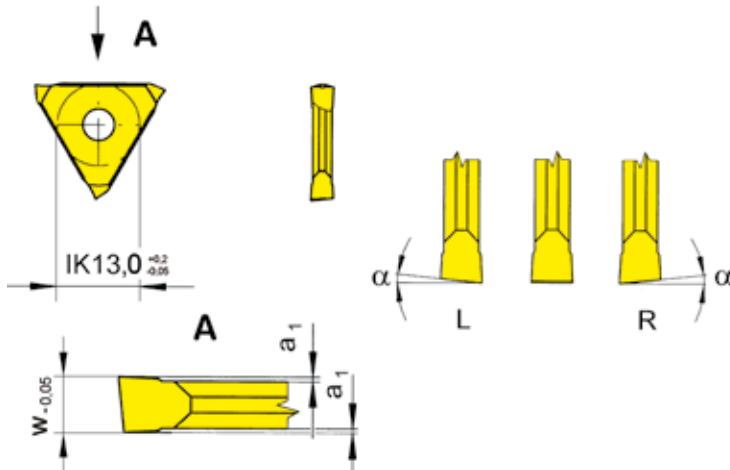
带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	5.00 mm
槽宽	Width of groove	1.07 - 1.44 mm

配合 刀杆  
for use with Toolholder

型号 360  
Type 361



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	a <sub>1</sub>	规格 Size	K10	P20	TN32	TN35	TI25	TF45	TF46
312.0100.00	1.07	0°	0.09	01 / 02	▲	▲	▲	▲		▲	▲
312.0130.00	1.44	0°	0.20		▲	▲	▲	▲		▲	▲
R/L312.0614.00		6°					▲/▲	▲/▲	▲/▲	▲/▲	
					P	●	●	●	●	●	●
					M	○	●	●	●	●	○
					K	●	●	●	●	●	●
					N	●	●	●	●	●	●
					S	○	●	●	●	●	○
					H						

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

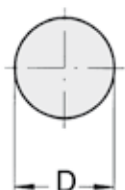
#### 外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:  
for Toolholder type 360

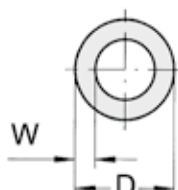
use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

实心棒料切断  
parting off solid bars



D 可达 11 mm  
D up to 11 mm

空心棒料切断  
parting off tubes



D ≥ 50 mm 可达 W ≈ 5 mm  
D ≤ 50 mm 可达 W ≈ 4 mm  
D ≥ 50 mm up to W ≈ 5 mm  
D ≤ 50 mm up to W ≈ 4 mm

# 切断

## PARTING OFF

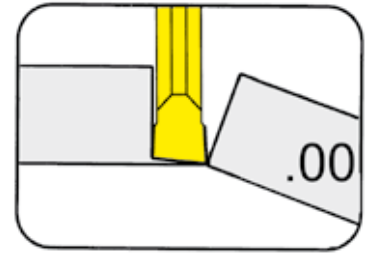


### 可转位刀片 型号

INDEXABLE INSERT Type

# 312

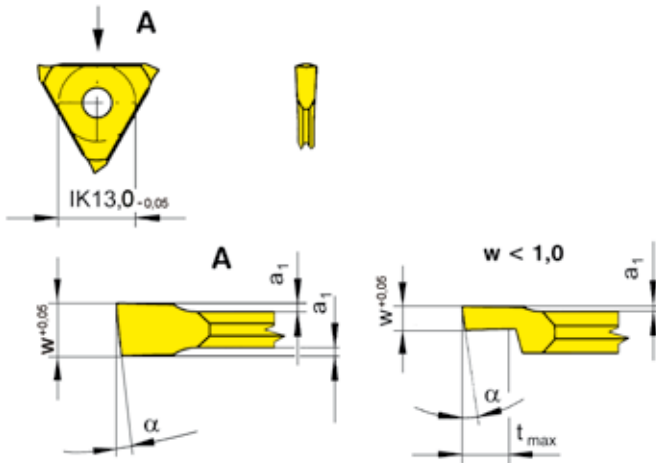
带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	0.5 - 1.5 mm

配合 刀杆  
for use with Toolholder

型号 368  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	t <sub>max</sub>	a <sub>1</sub>	α	规格 Size	TN35	TI25	TF45
R/L312.0805.00	0.5	1.0	0.1	8°	01			▲/▲
R/L312.0808.00	0.8	1.5	0.1	8°				▲/▲
R/L312.1210.00	1.0	8.0	0.1	12°		▲/▲		▲/▲
R/L312.0510.00	1.0	8.0	0.1	5°				▲/▲
R/L312.0512.00	1.2	8.0	0.2	5°				▲/▲
R/L312.0515.00	1.5	8.0	0.2	5°				▲/▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H			

硬质合金牌号  
Carbide grades

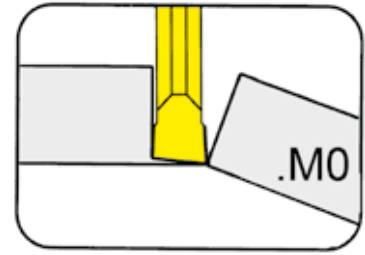
# 切断 PARTING OFF



## 可转位刀片 型号

# 312

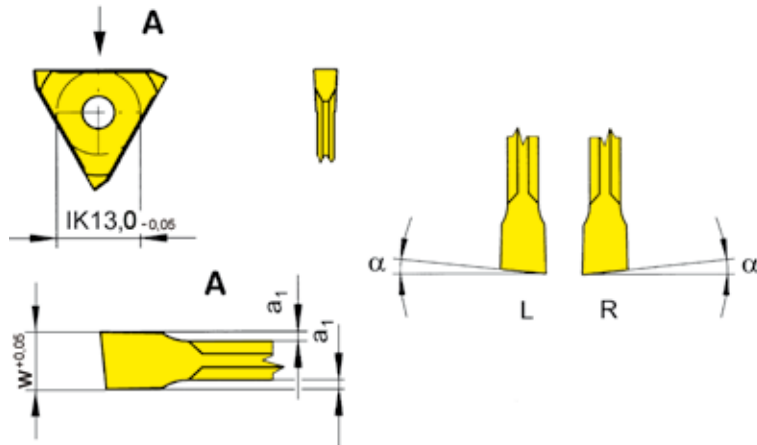
INDEXABLE INSERT Type



槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
1.2 - 1.5 mm



配合 刀杆  
for use with Toolholder

型号 368  
Type

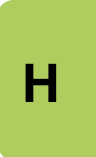
R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	a <sub>1</sub>	α	规格 Size	K10	TN35	TI25	TF45
<b>R/L312.0512.M0</b>	1.2	0.2	5°	01	/Δ			▲/Δ
<b>R/L312.0515.M0</b>	1.5	0.2	5°	01	▲/			▲/Δ
▲ 库存 / on stock    Δ 4周 / 4 weeks					P	•	•	•
● 主要应用 / main recommendation					M	○		•
○ 可选推荐 / alternative recommendation					K	•		•
■ 无涂层牌号 / uncoated grades					N	•		•
■ 涂层牌号 / coated grades					S	○		•
■ 钎焊/金属陶瓷 / brazed/Cermet					H			

尺寸单位 : mm  
Dimensions in mm  
注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades



# 切槽和切断

## GROOVING and PARTING OFF

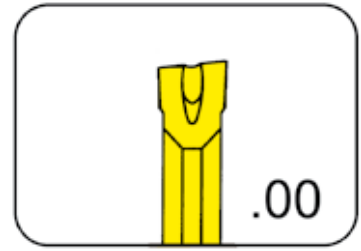


### 可转位刀片 型号

INDEXABLE INSERT Type

# 312

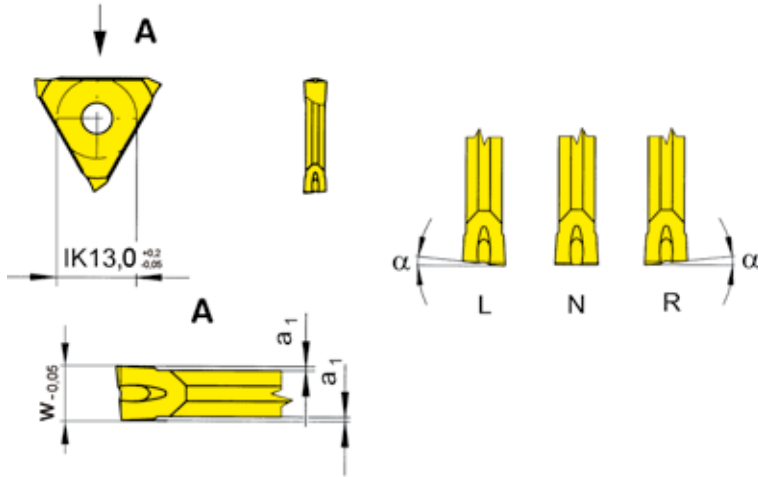
带圆形断屑槽  
with round chip breaker



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
1.44 - 2.29 mm



配合 刀杆

for use with Toolholder

型号 360

Type 361

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	a <sub>1</sub>	α	规格 Size	P20	TN32	TN35	TI25	TF45	
<b>N312.0014.00</b> <b>R/L312.0514.00</b>	1.44	0.2	0° 5°	01 / 02					▲	
<b>N312.0018.00</b> <b>R/L312.0518.00</b>	1.99	0.2	0° 5°	02	▲/▲	▲/▲	▲/▲		▲	
<b>N312.0021.00</b> <b>R/L312.0521.00</b>	2.29		0° 5°			▲				
	2.29					▲/▲	▲/▲	▲/▲		
					P	M	K	N	S	H

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

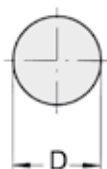
外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:  
for Toolholder type 360

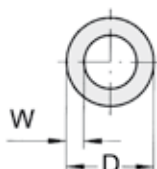
use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

实心棒料切断  
parting off solid bars



D 可达 10 mm  
D up to 10 mm

空心棒料切断  
parting off tubes



D ≥ 50 mm 可达 W ≈ 5 mm  
D ≤ 50 mm 可达 W ≈ 4 mm  
D ≥ 50 mm up to W ≈ 5 mm  
D ≤ 50 mm up to W ≈ 4 mm

硬质合金牌号  
Carbide grades



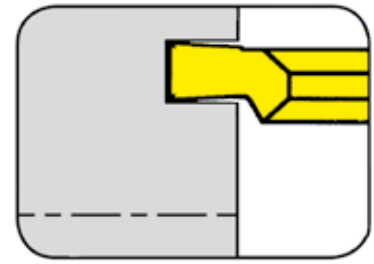
# 端面切槽 FACE GROOVING



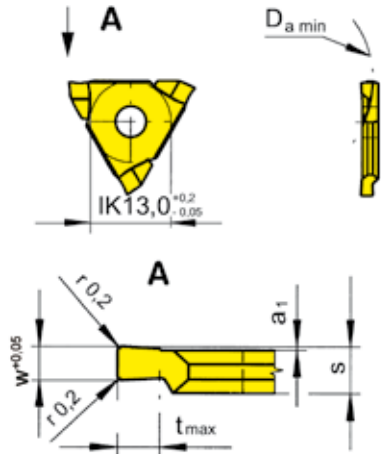
## 可转位刀片 型号

# 312

INDEXABLE INSERT Type



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.5 - 3.0 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 361  
369

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	s	t <sub>max</sub>	D <sub>a min</sub>	a <sub>1</sub>	规格 Size	TN35	TI25	TA45
R/L312.2015.02	1.5	2.7	2	20	0.2	02	▲/▲		
R/L312.3020.02	2.0	2.7	3	30	0.2	02	▲/▲		
R/L312.3030.02	3.0	3.7	3	30	0.2	03	▲/▲		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

### 360系列刀杆注意事项

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

#### Note for toolholder type 360

Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

### 369系列刀杆注意事项

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

#### Note for toolholder type 369

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H	●	●	●

硬质合金牌号  
Carbide grades

H

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

刀具系列 315

TOOLING SYSTEM 315

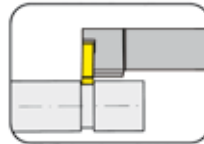
J

切槽和螺纹切削  
- 外圆 -

Grooving and threading  
- external -



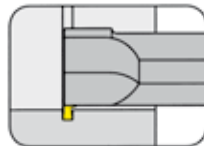
页 / Page  
J2-J4



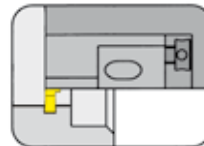
页 / Page  
J5-J6

切槽和螺纹切削  
- 内圆 -

Grooving and threading  
- internal -

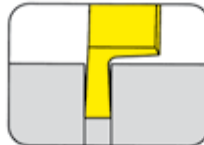


页 / Page  
J7

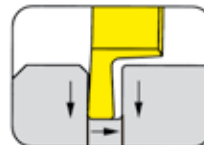


页 / Page  
J8-J9

可转位刀片  
型号  
Indexable inserts type  
315



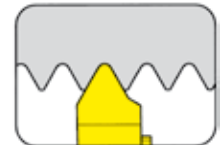
页 / Page  
J10-J11



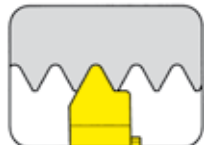
页 / Page  
J12



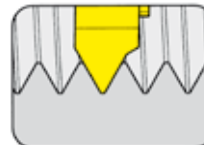
页 / Page  
J13-J14



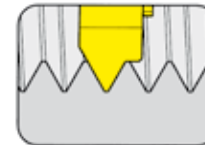
页 / Page  
J15



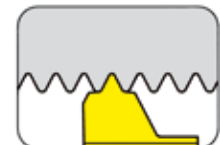
页 / Page  
J16



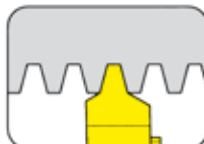
页 / Page  
J17



页 / Page  
J18



页 / Page  
J19



页 / Page  
J20

技术说明见章节Q

For Technical Instructions please see chapter Q

# 切槽和螺纹切削 (外圆)

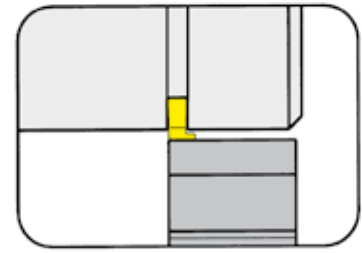
## GROOVING and THREADING (external)



刀杆型号

# 356

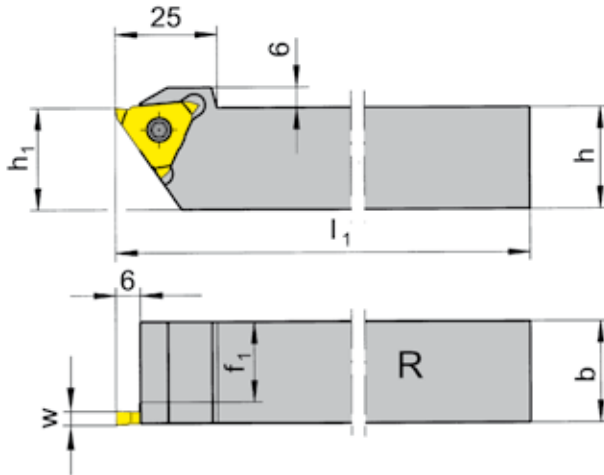
TOOLHOLDER Type



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
0.5 - 7.3 mm



配合 可转位刀片  
for use with Indexable insert

型号 315  
Type A315

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	规格 Size
R/L356.1616.03	16	16	125	20	13.0	03
R/L356.2020.03	20	20	125	20	17.0	
R/L356.2525.03	25	25	150	25	22.0	
R/L356.3232.03	32	32	170	32	29.0	
R/L356.1616.05	16	16	125	20	10.8	05
R/L356.2020.05	20	20	125	20	14.8	
R/L356.2525.05	25	25	150	25	19.8	
R/L356.3232.05	32	32	170	32	26.8	
R/L356.2020.07	20	20	125	20	13.0	07
R/L356.2525.07	25	25	150	25	18.0	
R/L356.3232.07	32	32	170	32	25.0	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L356....03/05	5.12T20P	T20PQ
R/L356....07	5.15T20P	T20PQ

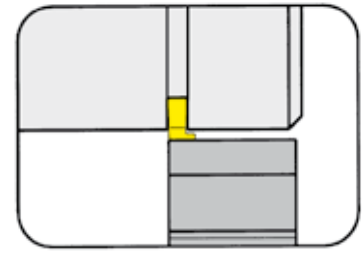
# 切槽和螺纹切削 (外圆)

## GROOVING and THREADING (external)



刀杆型号  
TOOLHOLDER Type

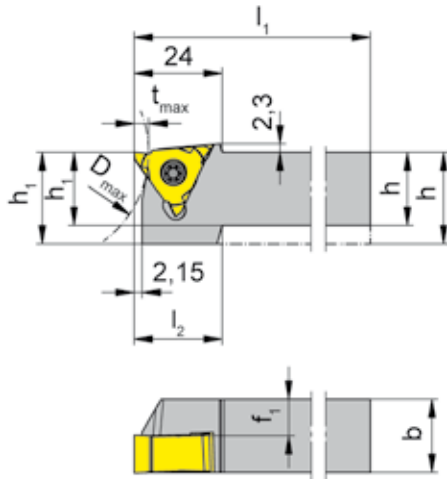
# 356



槽深可达	Depth of groove up to	5.0 mm
槽宽	Width of groove	0.5 - 10.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 315  
Type A315



槽深与外径Ø的对应关系  
Depth of groove in relation to outer-Ø

D <sub>max</sub>	t <sub>max</sub>
30	5.0
40	4.5
60	4.0
115	3.5
185	3.0

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	规格 Size
R/L356.1616.13	16	16	125	21	20	13.0	03
R/L356.2020.13	20	20	125	-	20	17.1	
R/L356.2525.13	25	25	150	-	25	22.1	
R/L356.1616.15	16	16	125	21	20	10.8	05
R/L356.2020.15	20	20	125	21	20	14.8	
R/L356.2525.15	25	25	150	-	25	19.8	
R/L356.1616.16	16	16	125	21	20	10.0	06
R/L356.2020.16	20	20	125	21	25	14.0	
R/L356.2525.16	25	25	150	-	25	19.0	
R/L356.2020.17	20	20	125	21	25	13.0	07
R/L356.2525.17	25	25	150	-		18.1	
R/L356.2020.10	20	20	125	21	25	10.0	10

注明R或L型  
State R or L version

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L356....13/15	5.12T20P	T20PQ
R/L356....10/16/17	5.15T20P	T20PQ



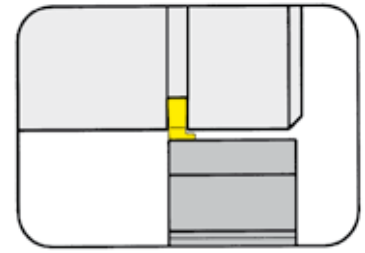
# 切槽和螺纹切削 (外圆)

## GROOVING and THREADING (external)



刀杆型号  
TOOLHOLDER Type

# 356



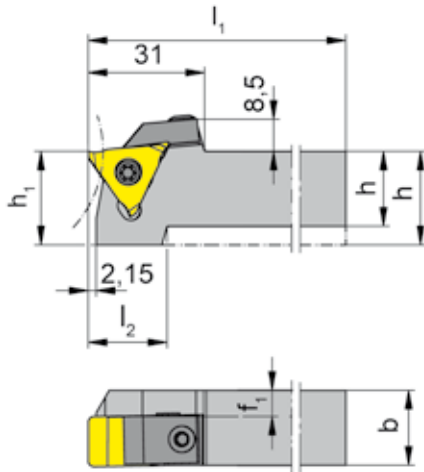
槽深可达	Depth of groove up to	5.0 mm
槽宽	Width of groove	10.3 - 13.3 mm

配合可转位刀片  
for use with Indexable insert

型号 315  
Type

槽深与外径 $\varnothing$ 的对应关系  
Depth of groove in relation to outer- $\varnothing$

$D_{max}$	$t_{max}$
30	5.0
40	4.5
60	4.0
115	3.5
185	3.0



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	规格 Size
R/L356.2020.2.13	20	20	125	21	20	7	13
R/L356.2525.2.13	25	25	150	-	25	12	

注明R或L型  
State R or L version

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L356.2...	010.2013.0468	5.15T20P	T20PQ

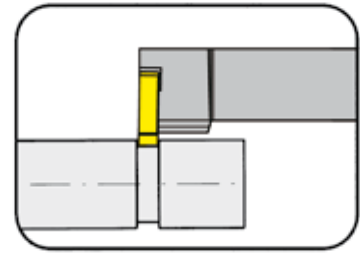
# 切槽和螺纹切削 (外圆)

## GROOVING and THREADING (external)



刀杆型号  
TOOLHOLDER Type

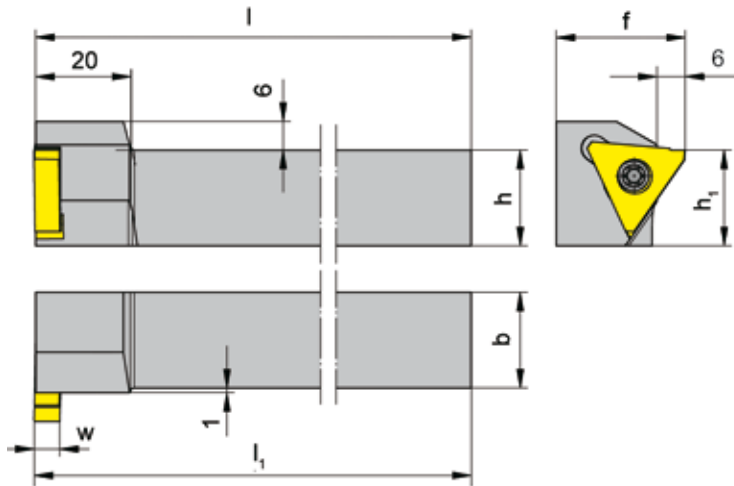
# 357



槽深可达	Depth of groove up to	5.0 mm
槽宽	Width of groove	0.5 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 315  
Type A315



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	f	规格 Size
R/L357.2020.05	20	25	20	125	125.3	27	05
R/L357.2525.05	25	25	25	150	150.3	32	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L357.2...	5.12T20P	T20PQ



# 切槽和螺纹切削 (外圆)

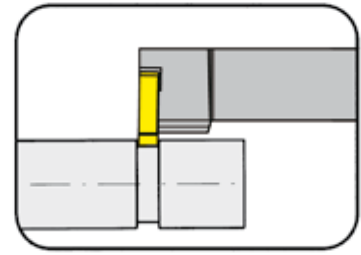
## GROOVING and THREADING (external)



刀杆 型号

# 357

TOOLHOLDER Type



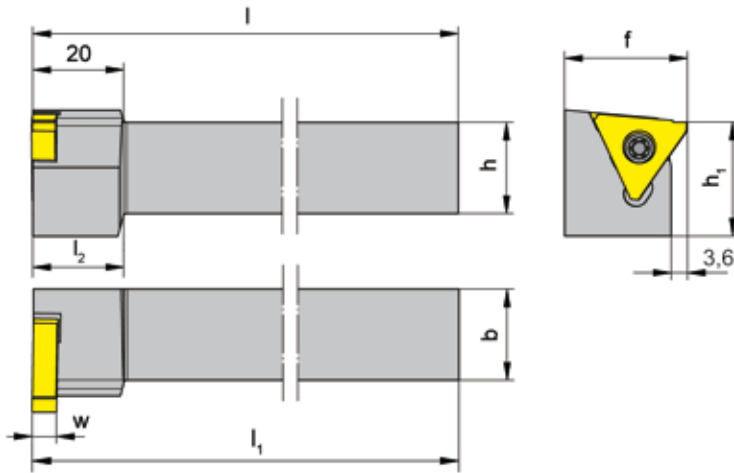
槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
0.5 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 315  
Type A315



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	l <sub>2</sub>	f	f <sub>1</sub>	f <sub>2</sub>	规格 Size
R/L357.2020.15	20	25	20	125	125.3	20	27	5.2	23.4	05
R/L357.2525.15	25	25	25	150	150.3	-	32	5.2	28.4	

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L357.2...	5.12T20P	T20PQ



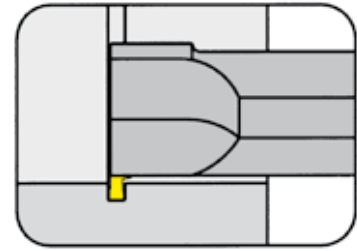
# 切槽和螺纹切削 (内圆)

## GROOVING and THREADING (internal)

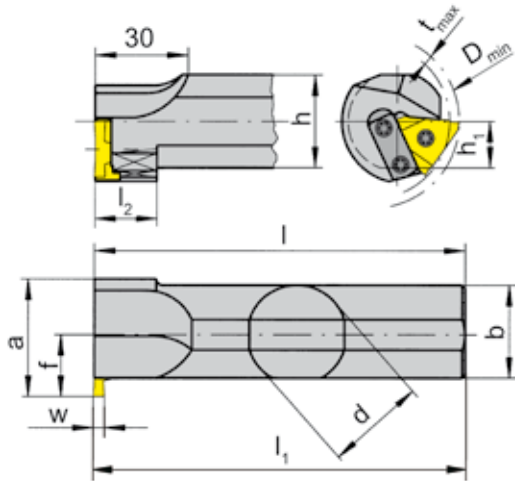


刀杆型号  
TOOLHOLDER Type

# 333



孔径Ø 自 Bore Ø from 43.0 mm  
槽宽 Width of groove 0.5 - 5.3 mm



配合 可转位刀片  
for use with Indexable insert

型号 315  
Type

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
43	1,8
46	2,0
50	3,0
60	4,0
80	4,5
100	5,0

产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	h	h <sub>1</sub>	f	D <sub>min</sub>	b	a	规格 Size
R/L333.0025.03	25	170	170.3		23	11.5					
R/L333.0032.03	32	200	200.3	20	30	15.0	20	43	30	38	03
R/L333.0025.05	25	170	170.3	20	23	11.5	20	43	25	38	
R/L333.0032.05	32	200	200.3	20	30	15.0	20	43	30	38	05
R/L333.0040.05	40	250	250.3	-	38	19.0	24	45	38	44	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	导向块 Guide Strip	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L333.00...	020.7000.0193	5.12T20P	T20PQ



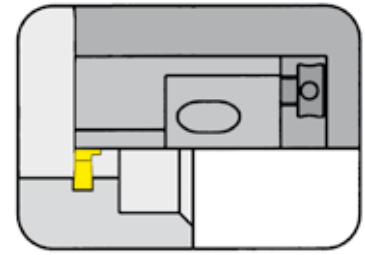
# 切槽和螺纹切削 (内圆)

## GROOVING and THREADING (internal)



刀夹 型号  
CARTRIDGE Type

# 357



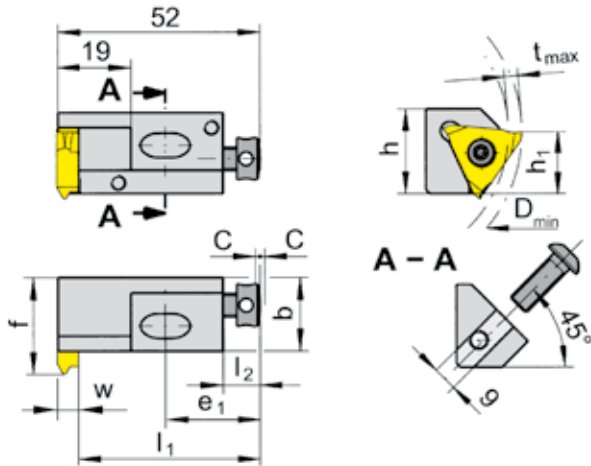
孔径Ø 自	Bore Ø from	50.0 mm
槽宽	Width of groove	0.5 - 5.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 315  
Type A315

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

$D_{min}$	$t_{max}$
50	3,0
60	4,0
80	4,5
100	5,0



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$h_1$	f	h	b	$l_1$	$e_1$	$l_2$	c	规格 Size
<b>R/L357.1619.05</b>	16	25	21	19	46.8	24	9	2	05

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

底座尺寸见下一页  
Dimensions of seating see following page

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cartridge	螺钉 Screw	螺钉 Screw	轴向调节螺钉 Axial Setscrew	径向调节螺钉 Radial Setscrew	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L357.1619.05	<b>8.25.351</b>	<b>5.12T20P</b>	<b>6.12.020</b>	<b>4.08.913</b>	<b>T20PQ</b>

# 切槽 (内圆)

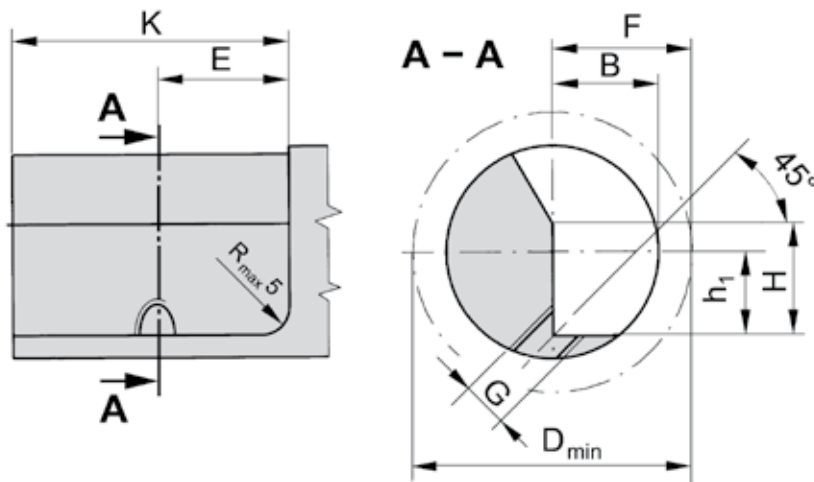
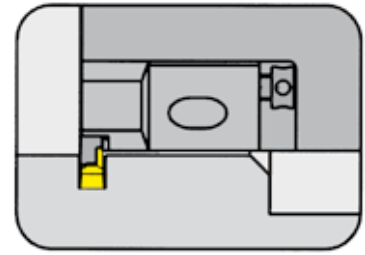
Grooving (internal)



外形尺寸 刀夹 型号

## 357

SEATING DIMENSIONS CARTRIDGE type



刀夹 Cartridge	F	G	H	K	E	B	$h_1$	$D_{min}$	紧固螺钉 Fastening screw
<b>357.1619.05</b>	25	M8	21	50	24	19	16	50	8.25.351

尺寸单位 : mm  
Dimensions in mm

J

# 切槽 ( 外圆 )

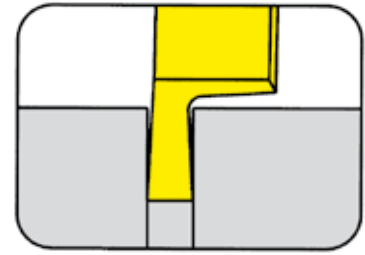
## GROOVING (external)



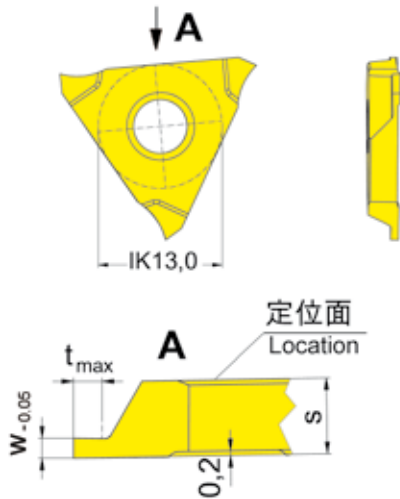
### 可转位刀片 型号

# 315

INDEXABLE INSERT Type



卡簧槽	Circlip grooves	DIN471/472
卡簧宽度Nw	Width of circlip Nw	0.50 - 1.00 mm



配合 刀杆  
for use with Toolholder

型号 356...03  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	Nw	w	t <sub>max</sub>	s	规格 Size	TN32	TN35	TI25	TA45
						R/L315.0050.32.00	0.5	0.57	0.7
R/L315.0060.32.00	0.6	0.67	0.8	△△					
R/L315.0070.32.00	0.7	0.77	1.1	△△					
R/L315.0080.32.00	0.8	0.87	1.2	△△					
R/L315.0090.32.00	0.9	0.97	1.4	△△					
R/L315.0100.32.00	1.0	1.07	1.6	△△					
<ul style="list-style-type: none"> <li>▲ 库存 / on stock △ 4周 / 4 weeks</li> <li>● 主要应用 / main recommendation</li> <li>○ 可选推荐 / alternative recommendation</li> <li>■ 无涂层牌号 / uncoated grades</li> <li>■ 涂层牌号 / coated grades</li> <li>■ 钎焊/金属陶瓷 / brazed/Cermet</li> </ul>						P	•		
						M			
						K			
						N			
						S			
						H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

#### 外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

#### External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

# 切槽 ( 内圆和外圆 )

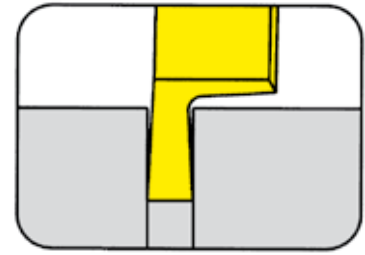
## GROOVING (external and internal)



### 可转位刀片 型号

INDEXABLE INSERT Type

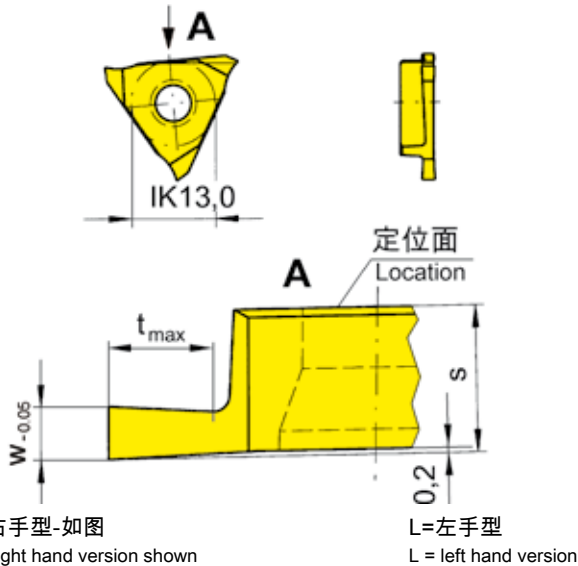
# 315



卡簧槽	Circlip grooves	DIN471/472
卡簧宽度Nw	Width of circlip Nw	1.10 - 4.15 mm

配合 刀杆  
for use with Toolholder

型号 333  
Type 356  
357



产品型号 Part number	Nw	w	t <sub>max</sub>	s	规格 Size	TN32	TN35	TI25	TF45
R/L315.0110.00	1.10	1.24	2	5.4	05		▲/▲		▲/△
R/L315.0130.00	1.30	1.44	2			▲/▲	▲/▲		
R/L315.0160.00	1.60	1.74	3			▲/▲	/△		
R/L315.0185.00	1.85	1.99	3			▲/▲	△/△		
R/L315.0215.00	2.15	2.29	4			▲/▲	/△		
R/L315.0265.00	2.65	2.79	4			▲/▲	△/△		
R/L315.0315.00	3.15	3.29	5			▲/▲	▲/△		
R/L315.0415.00	4.15	4.29	5			▲/▲	▲/△		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

外圆加工 :  
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

**External machining:**  
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工 :  
左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。

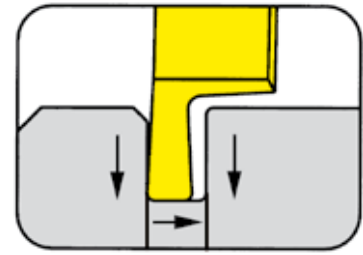
**Internal machining:**  
Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.



### 可转位刀片 型号

INDEXABLE INSERT Type

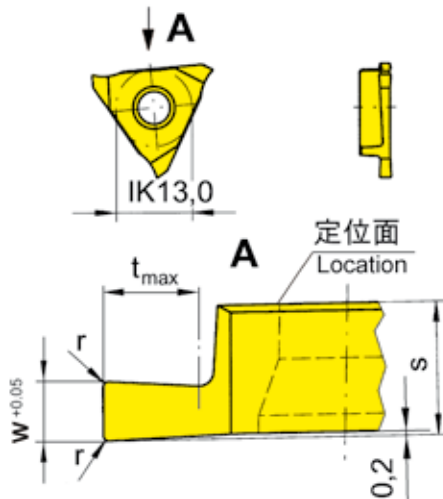
# 315



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
2.0 - 4.0 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 刀杆

for use with Toolholder

型号 333

Type 356

357

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$

Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	W	r	s	t <sub>max</sub>	规格 Size	TN32	TN35	TF45	AS42	AS46
R/L315.0200.02	2	0.2		3	05		▲/▲		▲/▲	△/△
R/L315.0200.04	2	0.4		3			▲/△		▲/▲	△/△
R/L315.0300.02	3	0.2		4			▲/▲		▲/▲	△/△
R/L315.0300.04	3	0.4	5.4	4			▲/▲	△	▲/▲	△/△
R/L315.0400.02	4	0.2		5			▲/▲		▲/▲	△/△
R/L315.0400.04	4	0.4		5			▲/▲		▲/▲	△/△

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工 :

左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。

Internal machining:

Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.

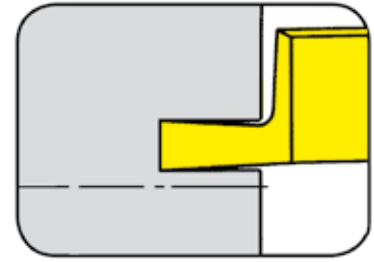
# 端面切槽 FACE GROOVING



## 可转位刀片 型号

INDEXABLE INSERT Type

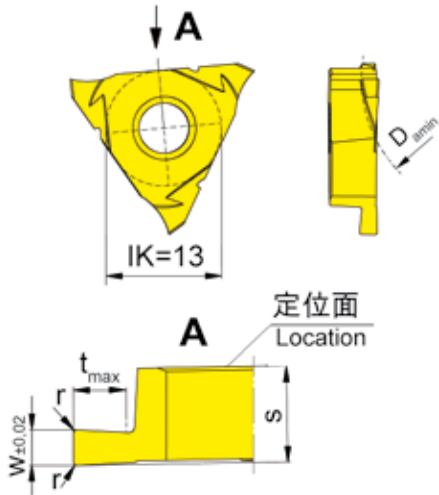
# A315



槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

配合 刀杆  
for use with Toolholder

型号 357  
Type 356...03-07



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	W	s	r	t <sub>max</sub>	D <sub>a min</sub>	规格 Size	TN32	TN35	TI22	TA45	TH35
LA315.2015.02R	1.5			2	20	05					▲
LA315.3020.02R	2.0	5.4	0.2	3	30						▲
LA315.3030.02R	3.0			3	30						▲
RA315.2015.02L	1.5			2	20	05					▲
RA315.3020.02L	2.0	5.4	0.2	3	30						▲
RA315.3030.02L	3.0			3	30						▲
							P				•
							M				•
							K				•
							N				•
							S				•
							H				

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades



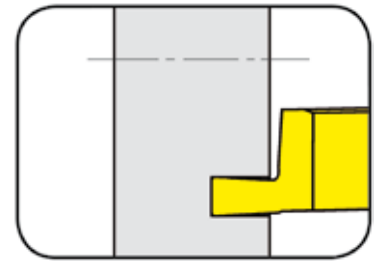
# 端面切槽 FACE GROOVING



## 可转位刀片 型号

# A315

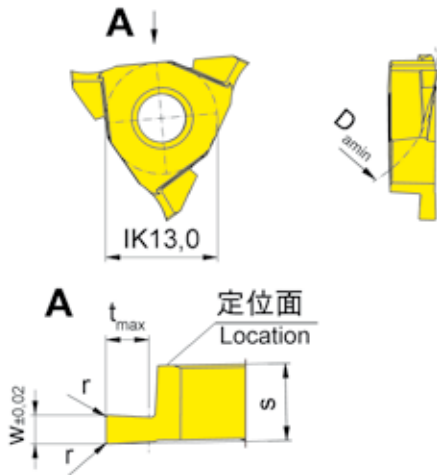
INDEXABLE INSERT Type



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

配合 刀杆  
for use with Toolholder

型号 356  
Type 357



R=右手型-如图  
R = right hand version shown

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	w	s	r	t <sub>max</sub>	D <sub>a min</sub>	规格 Size	Tl25	TA45	TH35
RA315.2015.02R	1.5			2	20				△
RA315.3020.02R	2.0	5.4	0.2	3	30	05			△
RA315.3030.02R	3.0			3	30				△

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P		●
M		●
K		●
N		●
S		●
H		

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades



# 螺纹切削 ( 外圆 ) -非全牙型

## THREADING (external) Partial profile

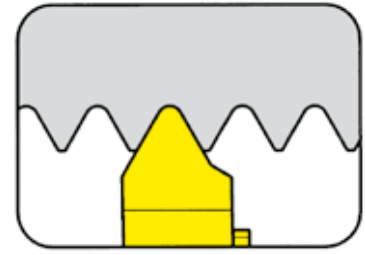


### 可转位刀片 型号

INDEXABLE INSERT Type

# 315

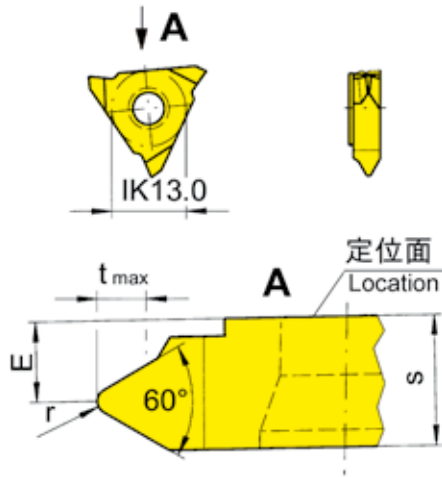
ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 3.5 mm
----	-------	--------------

配合 刀杆  
for use with Toolholder

型号 356  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	P	t <sub>max</sub>	r	E	s	规格 Size	TN35	TI25	TA45
R/L315.0610.01	1.00	0.61	0.12	4.50	5.45	05	▲/△		
R/L315.0712.01	1.25	0.77	0.15	4.50	5.45	05	▲/△		
R/L315.0915.01	1.50	0.92	0.20	4.15	5.45	05	▲/△		
R/L315.1017.01	1.75	1.07	0.25	4.15	5.45	05	▲/△		
R/L315.1220.01	2.00	1.23	0.25	4.15	5.45	05	▲/△		
R/L315.1525.01	2.50	1.53	0.35	3.80	5.45	05	▲/△		
R/L315.1830.01	3.00	1.84	0.40	3.60	5.45	05	▲/△		
R/L315.3060.01	3.0-6.0	4.15	0.40	3.00	6.10	05	▲/△		
R/L315.2135.01	3.50	2.15	0.50	3.40	5.45	05	▲/△		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●		
M	●		
K	●		
N	●		
S	●		
H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

外圆加工：  
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:  
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.



# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

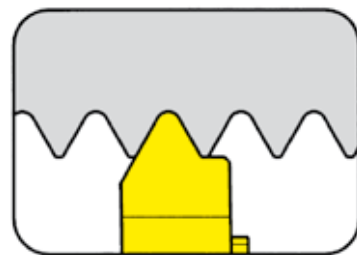


### 可转位刀片 型号

INDEXABLE INSERT Type

# 315

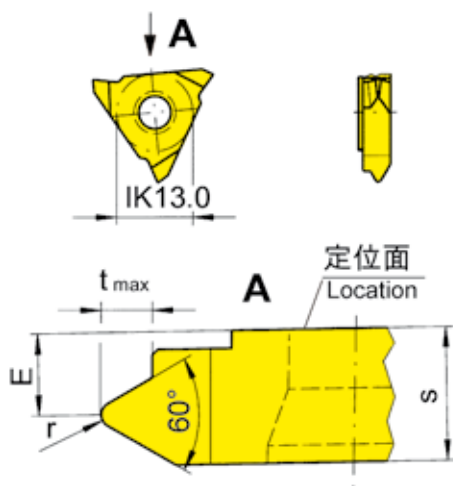
ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 6.0 mm
----	-------	--------------

配合 刀杆  
for use with Toolholder

型号 356  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	P	t <sub>max</sub>	r	E	s	规格 Size	TN35	TI25	TA45
R/L315.0610.02	1.00	0.61	0.12	4.50	5.45	05	▲/▲		
R/L315.0712.02	1.25	0.77	0.15	4.50	5.45	05	▲/△		
R/L315.0915.02	1.50	0.92	0.20	4.15	5.45	05	▲/▲		
R/L315.1017.02	1.75	1.07	0.25	4.15	5.45	05	▲/△		
R/L315.1220.02	2.00	1.23	0.25	4.15	5.45	05	▲/△		
R/L315.1525.02	2.50	1.53	0.35	3.80	5.45	05	▲/△		
R/L315.1830.02	3.00	1.84	0.40	3.60	5.45	05	▲/▲		
R/L315.2135.02	3.50	2.15	0.50	3.40	5.45	05	▲/△		
R/L315.2440.02	4.00	2.45	0.55	3.30	5.45	05	△/△		
R/L315.3050.02	5.00	3.07	0.70	4.00	6.50	05	▲/△		
R/L315.3660.02	6.00	3.68	0.85	4.10	7.00	05	△/△		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●		
M	●		
K	●		
N	●		
S	●		
H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

外圆加工：  
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。  
External machining:  
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

# 螺纹切削 (内圆) -非全牙型

## THREADING (internal) Partial profile

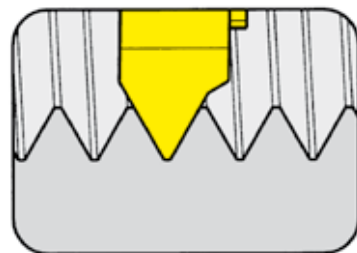


### 可转位刀片型号

INDEXABLE INSERT Type

# 315

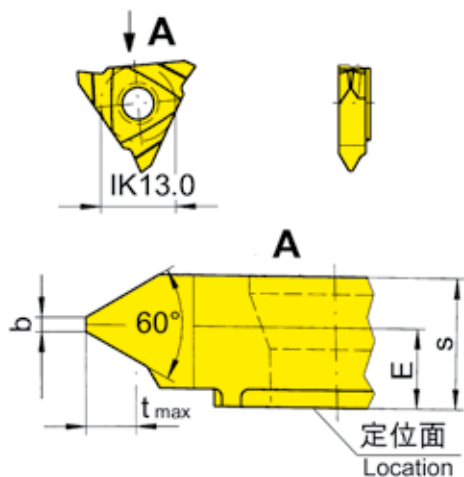
ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 3.5 mm
----	-------	--------------

配合刀杆  
for use with Toolholder

型号 333  
Type 357



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	P	t <sub>max</sub>	E	b	s	D <sub>min</sub>	规格 Size	TN35	TI25	TA45
R/L315.0510.01	1.0	0.55	4.85	0.12	5.45	40	05	Δ/Δ		
R/L315.0815.01	1.5	0.81	4.65	0.18	5.45	40	05	Δ/Δ		
R/L315.1020.01	2.0	1.08	4.45	0.25	5.45	40	05	Δ/		
R/L315.1325.01	2.5	1.35	4.25	0.31	5.45	43	05	Δ/		
R/L315.1630.01	3.0	1.62	4.05	0.37	5.45	43	05	Δ/		
R/L315.1835.01	3.5	1.89	3.90	0.43	5.45	43	05	Δ/		

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●		
M	●		
K	●		
N	●		
S	●		
H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

#### 内圆加工 :

右手型螺纹刀片配合右手型333/357刀杆, 左手型螺纹刀片配合左手型333/357刀杆

#### Internal machining:

Right hand threading insert in right hand toolholder 333/357, left hand threading insert in left hand toolholder 333/357



# 螺纹切削-全牙型 (内圆)

## THREADING (internal) Full profile

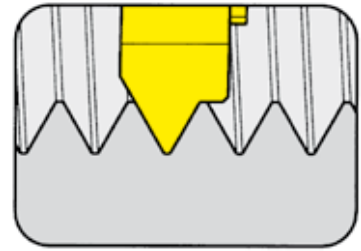


### 可转位刀片 型号

INDEXABLE INSERT Type

# 315

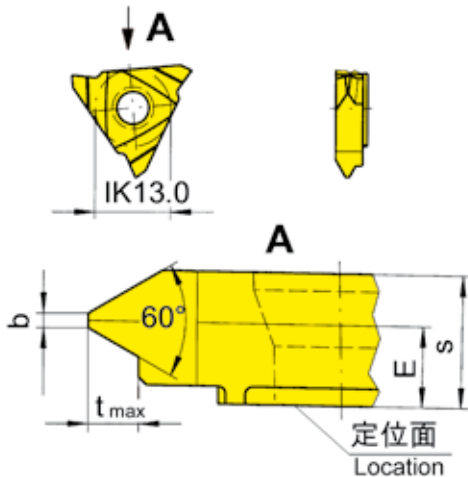
ISO米制螺纹  
Metric ISO thread



螺距	Pitch	1.0 - 3.5 mm
----	-------	--------------

配合 刀杆  
for use with Toolholder

型号 333  
Type 357



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	P	t <sub>max</sub>	E	b	s	D <sub>min</sub>	规格 Size	TN35	TI25	TA45
R/L315.0510.02	1.0	0.55	4.85	0.12	5.45	40	05	Δ/		
R/L315.0815.02	1.5	0.81	4.65	0.18	5.45	40	05	▲/		
R/L315.1020.02	2.0	1.08	4.45	0.25	5.45	40	05	▲/Δ		
R/L315.1325.02	2.5	1.35	4.25	0.31	5.45	43	05	Δ/		
R/L315.1630.02	3.0	1.62	4.05	0.37	5.45	43	05	▲/Δ		
R/L315.1835.02	3.5	1.89	3.90	0.43	5.45	43	05	Δ/		

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

#### 内圆加工 :

右手型螺纹刀片配合右手型333/357刀杆, 左手型螺纹刀片配合左手型333/357刀杆

#### Internal machining:

Right hand threading insert in right hand toolholder 333/357, left hand threading insert in left hand toolholder 333/357

# 螺纹切削 ( 外圆 ) -全牙型

## THREADING (external) Full profile

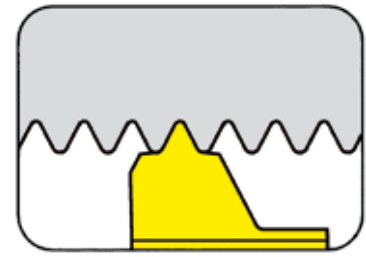


### 可转位刀片 型号

INDEXABLE INSERT Type

# 315

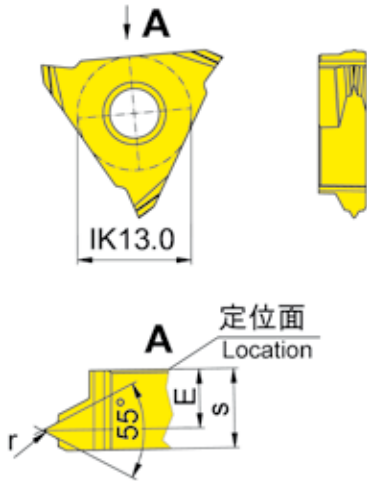
惠氏管螺纹  
Whitworth pipe thread



每英寸牙数	Threads per inch	11.0 - 28.0 mm
-------	------------------	----------------

配合 刀杆  
for use with Toolholder

型号 356  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	每英寸螺牙数 Threads per Inch	r	E	s	规格 Size	TN35	TI25	TA45	TH35
R/L315.5528.02	28	0.11	4.35	5.45	05				▲/▲
R/L315.5519.02	19	0.17	4.05	5.45	05				▲/▲
R/L315.5514.02	14	0.23	3.75	5.45	05				▲/▲
R/L315.5511.02	11	0.30	3.55	5.45	05				▲/▲
						P			•
						M			•
						K			•
						N			•
						S			•
						H			

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

外圆加工：  
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。  
**External machining:**  
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.



# 螺纹切削-全牙型

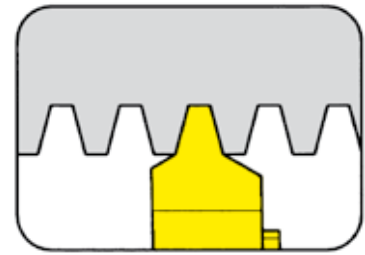
## THREADING Full profile



### 可转位刀片 型号

INDEXABLE INSERT Type

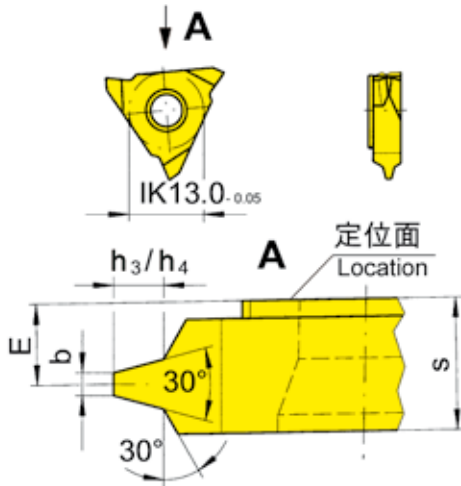
# 315



螺距	Pitch	1.5 - 6.0 mm
----	-------	--------------

配合 刀杆  
for use with Toolholder

型号 333  
Type 356  
357



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

ISO米制梯形螺纹DIN103  
Metric ISO trapezoidal  
thread DIN 103

产品型号 Part number	P	E	b	s	D <sub>min</sub>	h <sub>3</sub> / h <sub>4</sub>	规格 Size	TN35	TI25	TA45
R/L315.1015.02	1.5	4.5	0.47	5.45	43	0.90	05	▲/△		
R/L315.1320.02	2.0	4.3	0.60	5.45	43	1.25	05	▲/△		
R/L315.1730.02	3.0	4.0	0.96	5.45	43	1.75	05	▲/▲		
R/L315.2240.02	4.0	3.6	1.33	5.45	43	2.25	05	△/▲		
R/L315.2750.02	5.0	3.3	1.70	5.45	43	2.75	05	▲/△		
R/L315.3560.02	6.0	3.0	1.93	5.45	43	3.50	05	▲/▲		

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

硬质合金牌号 Carbide grades	TN35	TI25	TA45
P	●		
M	●		
K	●		
N	●		
S	●		
H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。  
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

外圆加工 :  
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。  
**External machining:**  
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工 :  
左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。  
**Internal machining:**  
Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.

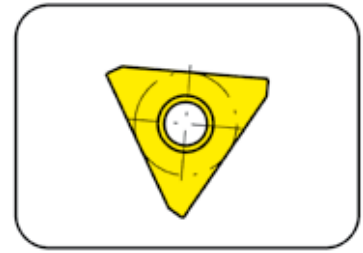
# 基本规格 型号 315

## Basic sizes type 315

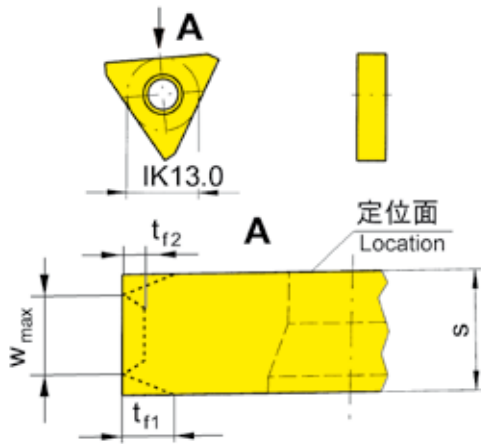


可转位刀片 型号  
INDEXABLE INSERT type

# 315



基本规格 型号 315  
Basic sizes type 315



用于 刀杆  
for Toolholder

型号 356  
type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品编号 Part number	$W_{max}$	$t_{f2}$	$t_{f2}$	s	规格 Size	TN35	TI25	TA45	TA46
R/L315...	3.05	5.0	-	3.25	03				
R/L315...	5.25	5.0	2.0	5.45	05				
R/L315...	5.90	5.0	2.0	6.10	05 / 06				
R/L315...	6.40	5.0	2.0	6.60	06 / 07				
R/L315...	6.90	5.0	2.0	7.10	07				
R/L315...	7.30	5.0	2.0	7.50	07				
R/L315...	8.30	5.0	2.0	8.50	07				
R/L315...	9.30	5.0	2.0	9.50	10				
R/L315...	10.30	5.0	2.0	10.50	10				
R/L315...	13.30	5.0	2.0	13.50	13				
R/L315...	15.30	5.0	2.0	15.50	13				
						按照要求 UPON REQUEST			
						P			
						M			
						K			
						N			
						S			
						H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/陶瓷 / brazed/Cermet

### 外圆加工:

右手刀片安装于356右手刀杆, 左手刀片安装于356左手刀杆

### External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356 useable.



# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
加工 / Machining										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

尺寸单位：mm  
Dimensions in mm

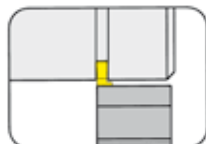


刀具系列 S316

TOOLING SYSTEM S316

K

切槽  
- 外圆 -  
Grooving  
- external -

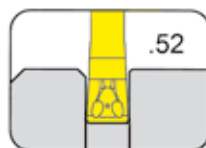


页 / Page  
K2, K8

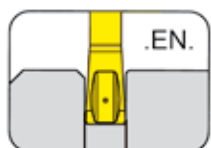


页 / Page  
K3, K9

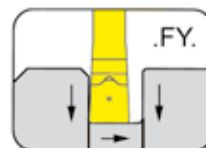
可转位刀片  
型号  
S316  
Indexable inserts type



页 / Page  
K4



页 / Page  
K5



页 / Page  
K6

技术说明见章节Q

For Technical Instructions please see chapter Q

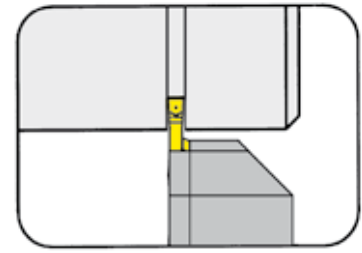
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

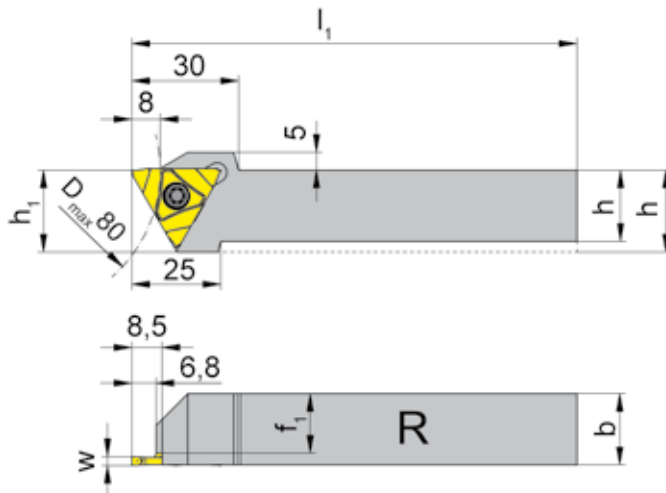
# H316



槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S316  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	规格 Size
R/LH316.1616.S3.03	16	16	125	23	12.7	03
R/LH316.2020.S3.03	20	20	125	23	16.7	
R/LH316.2525.S3.03	25	25	150	25	21.7	
R/LH316.3225.S3.03	32	25	150	32	21.7	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH316....	5.12T20P	T20PQ

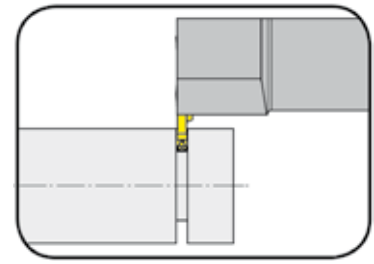
# 切槽和螺纹切削 (外圆)

## GROOVING and THREADING (external)



刀杆型号  
TOOLHOLDER Type

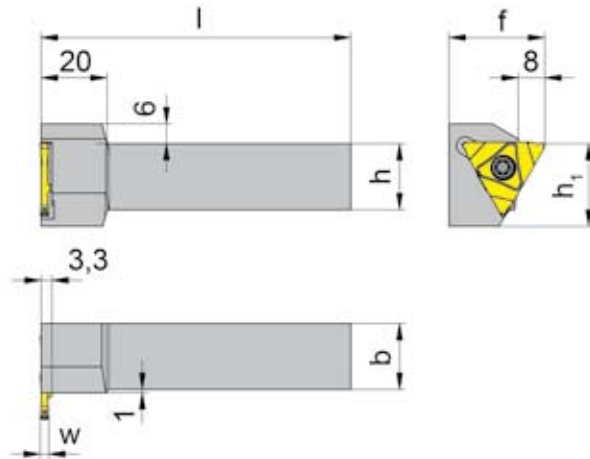
# HC316



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S316  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	f	规格 Size
R/LHC316.1616.S3.03	16	25	16	125	29	03
R/LHC316.2020.S3.03	20	25	20	125	29	
R/LHC316.2525.S3.03	25	25	25	150	34	
R/LHC316.3225.S3.03	32	32	25	150	34	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

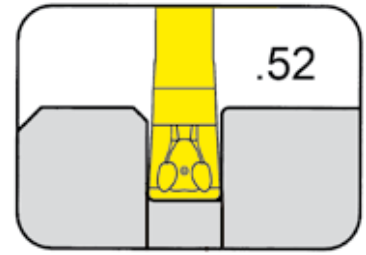
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC316....	5.12T20P	T20PQ

K

### 可转位刀片 型号

INDEXABLE INSERT Type

# S316



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

精密烧结

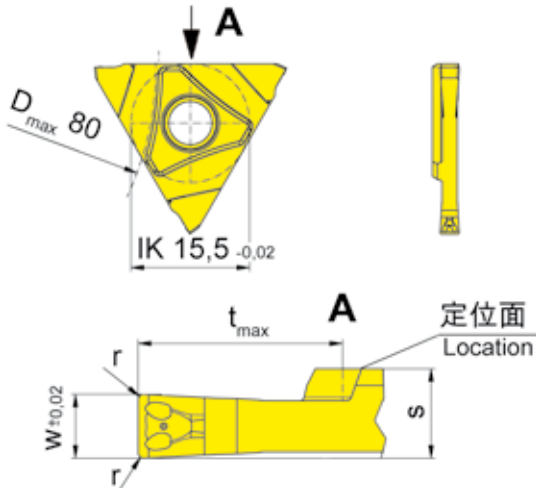
precision sintered

配合 刀杆

for use with Toolholder

型号 H316...S3.03

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.02mm

Indexability length ± 0,02 mm

产品型号 Part number	w	r	s	t <sub>max</sub>	规格 Size	TN35	TI25	TF45	TF46	AS45
R/LS316.0200.52	2.0									▲/▲
R/LS316.0250.52	2.5	0.2	3.5	8	03					▲/▲
R/LS316.0300.52	3.0									▲/▲
▲ 库存 / on stock    Δ 4周 / 4 weeks						P				•
● 主要应用 / main recommendation						M				•
○ 可选推荐 / alternative recommendation						K				•
■ 无涂层牌号 / uncoated grades						N				○
■ 涂层牌号 / coated grades						S				•
■ 钎焊/金属陶瓷 / brazed/Cermet						H				

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

K

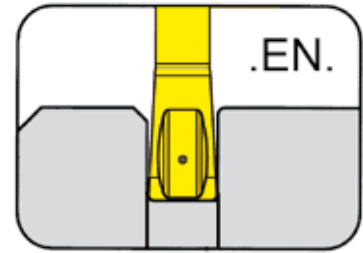
# 切断 PARTING OFF



## 可转位刀片 型号

INDEXABLE INSERT Type

# S316

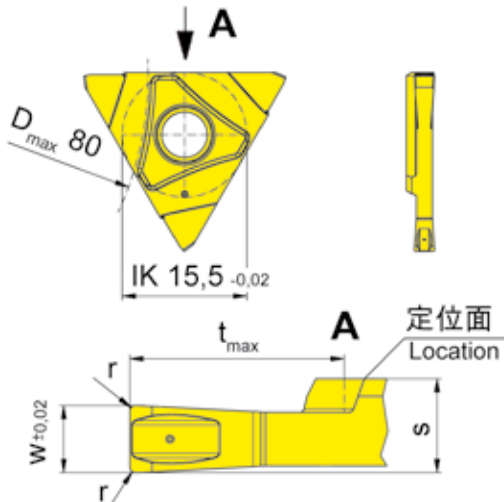


槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

精密烧结  
precision sintered

配合 刀杆  
for use with Toolholder

型号 H316...S3.03  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.02mm  
Indexability length ± 0,02 mm

产品型号 Part number	w	r	s	t <sub>max</sub>	规格 Size	TN35	TF45	TF46	AS62	AS6G
R/LS316.0200.EN2	2.0									▲/▲
R/LS316.0250.EN2	2.5	0.2	3.5	8	03					▲/▲
R/LS316.0300.EN2	3.0									▲/▲
▲ 库存 / on stock    Δ 4周 / 4 weeks						P				•
● 主要应用 / main recommendation						M				•
○ 可选推荐 / alternative recommendation						K				•
■ 无涂层牌号 / uncoated grades						N				•
■ 涂层牌号 / coated grades						S				•
■ 钎焊/金属陶瓷 / brazed/Cermet						H				

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

外圆加工：  
右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

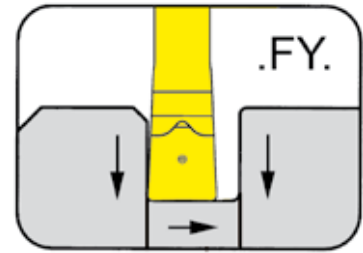
External machining:  
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders



## 可转位刀片 型号

INDEXABLE INSERT Type

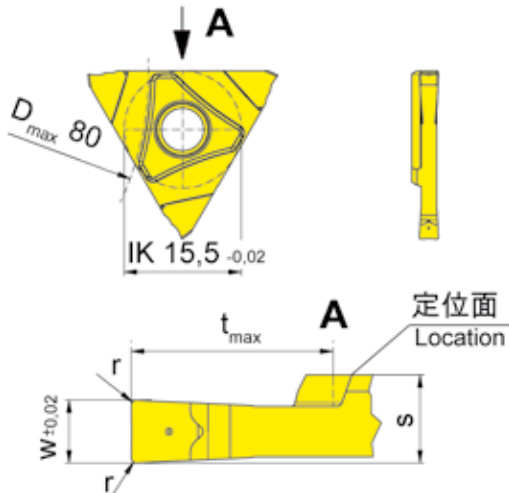
# S316



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	1.5 - 3.0 mm

精密烧结

precision sintered



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 刀杆

for use with Toolholder

型号 H316...S3.03

Type

刀片长度重复定位精度  
±0.02mm

Indexability length ± 0,02 mm

产品型号 Part number	w	r	s	t <sub>max</sub>	规格 Size	硬质合金牌号			
						TN35	TI25	TF45	TF46
R/LS316.0150.FY1	1.5	0.1	3.3	8	03		▲/▲		
R/LS316.0200.FY2	2.0	0.2	3.5			▲/▲			
R/LS316.0250.FY2	2.5	0.2	3.5			▲/▲			
R/LS316.0300.FY2	3.0	0.2	3.5			▲/▲			
▲ 库存 / on stock    Δ 4周 / 4 weeks						P	•		
● 主要应用 / main recommendation						M	•		
○ 可选推荐 / alternative recommendation						K	•		
■ 无涂层牌号 / uncoated grades						N	•		
■ 涂层牌号 / coated grades						S	•		
■ 钎焊/金属陶瓷 / brazed/Cermet						H			

尺寸单位 : mm

Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

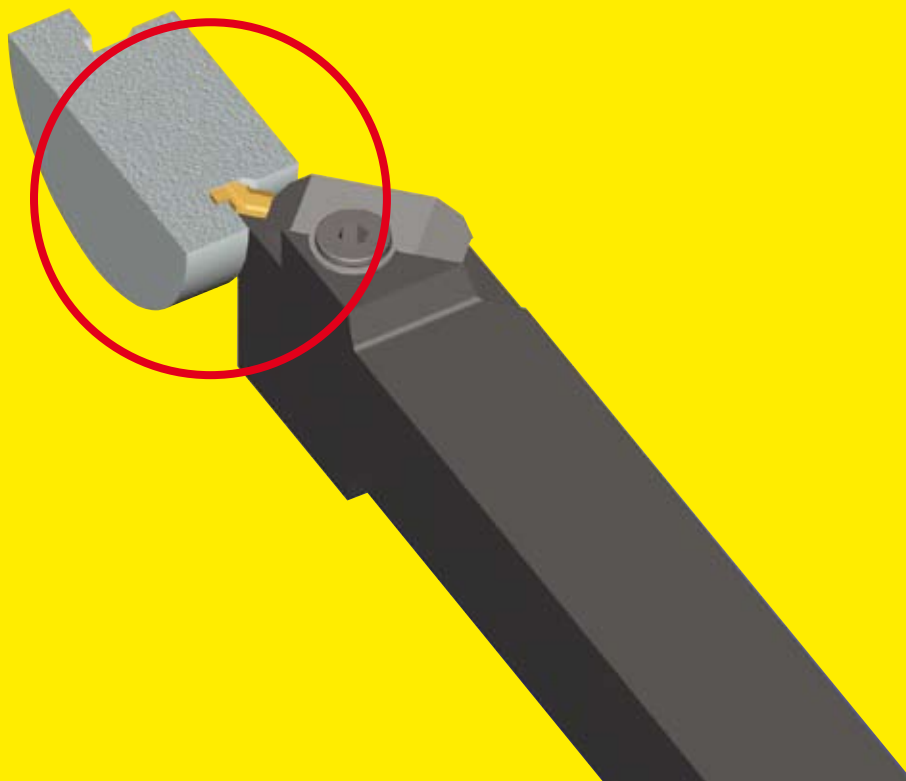
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

## 可转位刀片 型号 312 Indexable Insert type 312



加工轴向o型槽最经济的方法

The economic way to produce  
axial o-ring grooves



# 切槽 ( 外圆 )

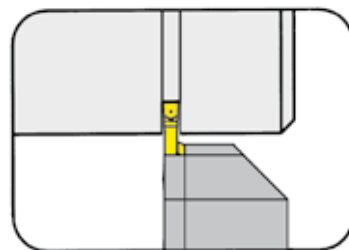
## GROOVING (external)



### 刀杆 型号

# H316

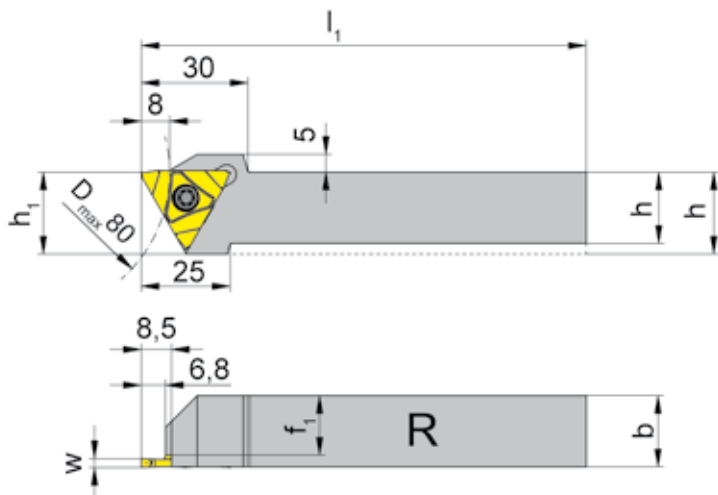
TOOLHOLDER Type



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

8.0 mm  
1.5 - 3.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 316  
Type 按照要求  
upon request

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled  
inserts

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	规格 Size
R/LH316.1616.03	16	16	125	23	12.7	03
R/LH316.2020.03	20	20	125	23	16.7	
R/LH316.2525.03	25	25	150	25	21.7	
R/LH316.3225.03	32	25	150	32	21.7	

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH316....	5.12T20P	T20PQ



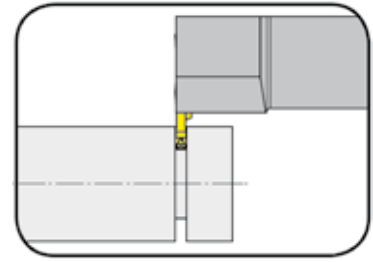
# 切槽和螺纹切削 (外圆)

## GROOVING and THREADING (external)



刀杆型号  
TOOLHOLDER Type

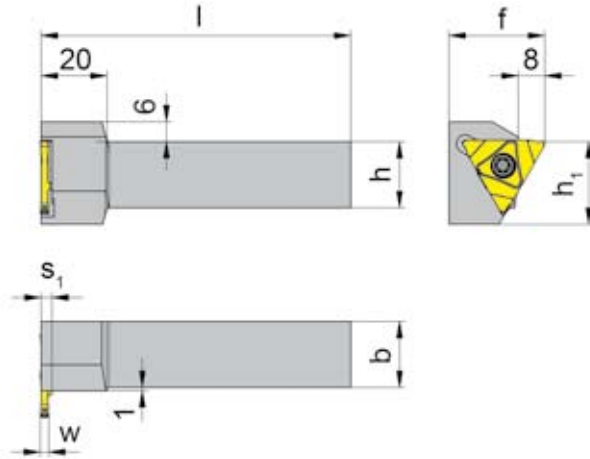
# HC316



槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
1.5 - 3.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 316  
Type 按照要求  
upon request

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled  
inserts

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	f	s <sub>1</sub>	规格 Size
R/LHC316-1616-03	16	25	16	125	29		
R/LHC316-2020-03	20	25	20	125	29	3.3	03
R/LHC316-2525-03	25	25	25	150	34		
R/LHC316-3225-03	32	32	25	150	34		
R/LHC316-2020-05	20	25	20	125	29		
R/LHC316-2525-05	25	25	25	150	34	5.2	05
R/LHC316-3225-05	32	32	25	150	34		

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC316....	5.12T20P	T20PQ

K

# HCG - HORN Catalogue Guide

## 内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 8										
8 可达 / up to 18										
18 可达 / up to 28	•			•						
28 可达 / up to 38	•				•					
自 / from 38					•		•	•	•	
<b>加工 / Machining</b>										
镗孔 / Boring										
切槽和车削 / Grooving and turning	•			•	•		•	•		
螺纹切削 / Thread						•			•	
仿形加工 / Profiling	•			•	•	•	•	•	•	
槽宽 Width of groove	0.9 - 5.3			1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

## 外圆切槽 / EXTERNAL GROOVING

槽深 Depth of groove	产品线 / Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
可达 / up to 4	•	•	•	•	•	•	•	•	•	•
可达 / up to 6		•	•	•	•	•	•	•		•
可达 / up to 8		•		•	•	•	•	•		•
可达 / up to 10		•		•	•	•	•			
可达 / up to 14					•		•			
可达 / up to 18					•		•			
可达 / up to 25							•			
<b>加工 / Machining</b>										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
侧车削 / Side turning		•	•	•	•		•	•		
切断 / Parting off	•	•	•	•	•		•	•		•
螺纹切削 / Thread		•	•			•	•		•	
仿形加工 / Profiling	•				•		•	•	•	
槽宽 Width of groove	0.9 - 5.3	1.5 - 3.0	0.5 - 7.0	1.2 - 3.0	2.0 - 6.0	2.5 - 10.0	2.5 - 10.0	1.9 - 6.3	0.5 - 5.3	1.5 - 3.0
章 / Chapter	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>G</b>	<b>H</b>	<b>J</b>	<b>K</b>

可应要求提供非标刀具  
Special tools upon request

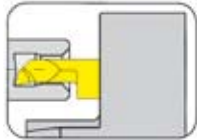
尺寸单位：mm  
Dimensions in mm

适用于SWISS机床的刀具  
TOOLS FOR SWISS TYPE MACHINES

L

用于 刀片 型号  
for Inserts type

105



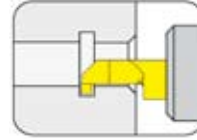
页 / Page  
L2-L4



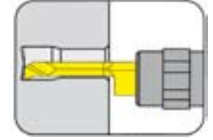
页 / Page  
L5



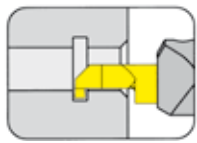
页 / Page  
L6



页 / Page  
L7



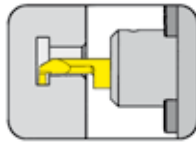
页 / Page  
L8



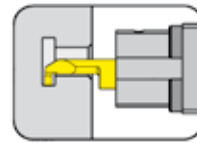
页 / Page  
L9



页 / Page  
L11



页 / Page  
L12-L13,L16

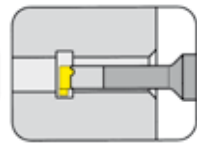


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L14-L15



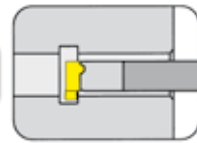
页 / Page  
L17-L26

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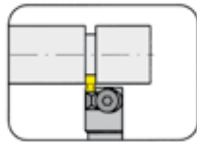
页 / Page  
L28

111



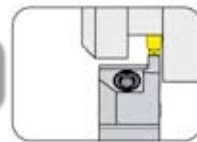
页 / Page  
L27

217

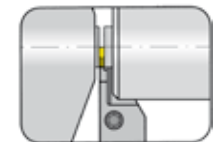


页 / Page  
L33

S224

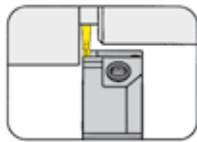


页 / Page  
L37-L38

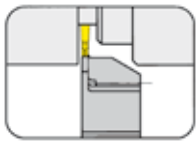


页 / Page  
L40-L41

264



页 / Page  
L29-L31

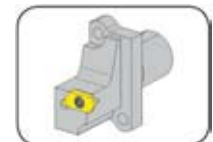


页 / Page  
L32

S274

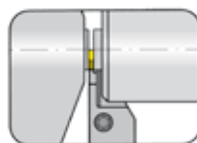


页 / Page  
L34-L35

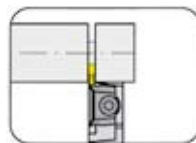


页 / Page  
L36

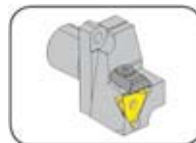
312



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L39-L41,L43



页 / Page  
L42



页 / Page  
L44

附加设备  
Additional equipment

页 / Page  
L45

相关刀片详见本样本和Supermi® 样本  
For the inserts see the respective chapters in this and in the Supermini® catalogue.

# 切槽和镗孔

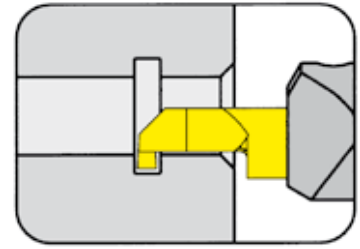
## GROOVING and BORING



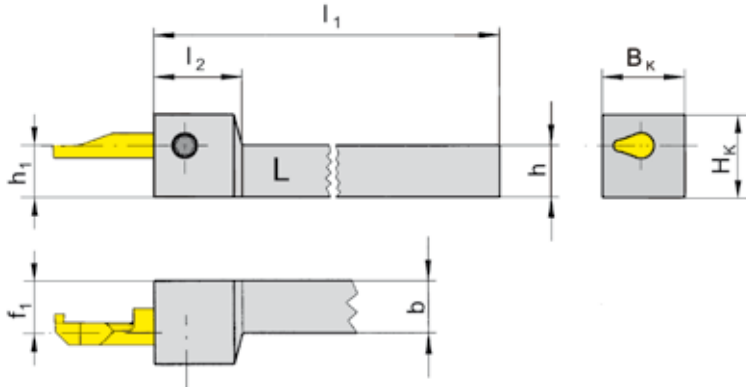
刀杆 型号  
TOOLHOLDER Type

### H105

螺钉锁紧  
with screwed clamping



孔径Ø 自 Bore Ø from 0.2 mm



配合 刀片  
for use with Insert

型号 105  
Type

L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$b$	$B_K$	$H_K$
R/LH105.0808.01	90	17	8	8	7.5	8	16	14
R/LH105.1010.01	90	17	10	10	7.5	10	16	16
R/LH105.1212.01	90	17	12	12	7.5	12	16	18
R/LH105.1616.01	110	17	16	16	7.5	16	16	22

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

L

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH105....	6.075T15P	T15PQ

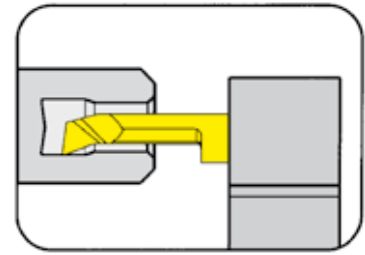
# 切槽和镗孔

## GROOVING and BORING



刀杆 型号  
TOOLHOLDER Type

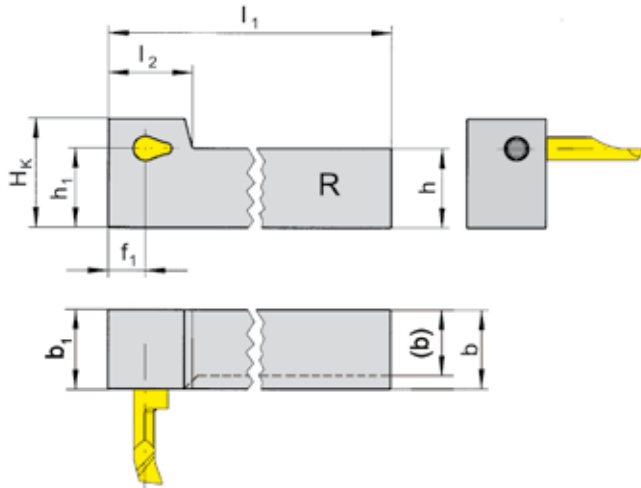
**HC105**  
螺钉锁紧  
with screwed clamping



孔径Ø 自 Bore Ø from 0.2 mm

配合 刀片  
for use with Insert

型号 105  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$b$	$b_1$	$H_k$
<b>R/LHC105.1212.01</b>	90	17	12	12	7.5	12	16	18
<b>R/LHC105.1616.01</b>	130	17	16	16	7.5	16	16	22

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC105.1...	<b>6.075T15P</b>	<b>T15PQ</b>

L

# 切槽和镗孔

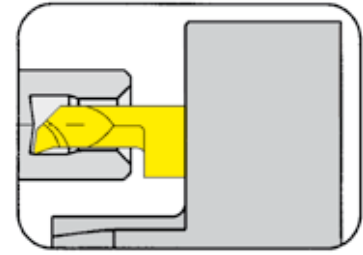
## GROOVING and BORING



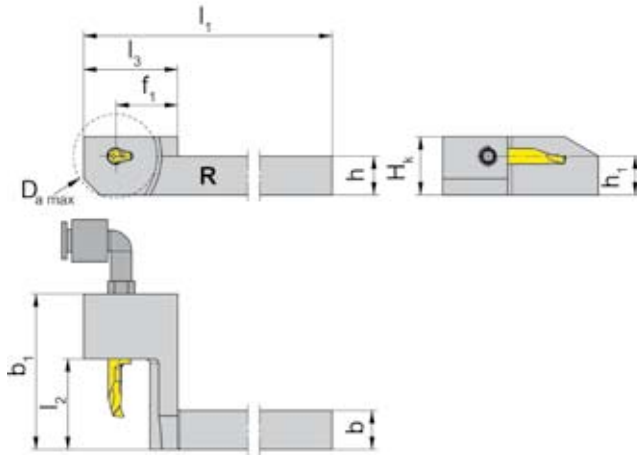
刀杆 型号  
TOOLHOLDER Type

# HC105

螺钉锁紧  
with screwed clamping



孔径Ø 自                      Bore Ø from                      0.2 mm



配合 刀片  
for use with Insert

型号 105  
Type

通过曲型接头供给冷却液  
Coolant supply through cranked fitting

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$l_3$	$b$	$b_1$	$D_{a \max}$	$H_K$	备注 Remark
R/LHC105.0707.21	99	18	7	7	19	29	7	32.0	26	13	*
R/LHC105.0808.21	99	18	8	8	19	29	8	32.0	26	13	*
RHC105.1010.11	99	8	10	10	19	29	10	22.7	26	16	*
R/LHC105.1010.21	99	18	10	10	19	29	10	38.0	26	16	
R/LHC105.1010.41		28						48.0			
R/LHC105.1212.21	99	18	12	12	19	29	12	38.0	26	18	
R/LHC105.1212.41		28						48.0			
R/LHC105.1616.21	104	18	16	16	24	34	16	38.0	36	22	
R/LHC105.1616.41		28						48.0			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
\*=无内冷!

Note:  
\* = no through coolant supply!

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

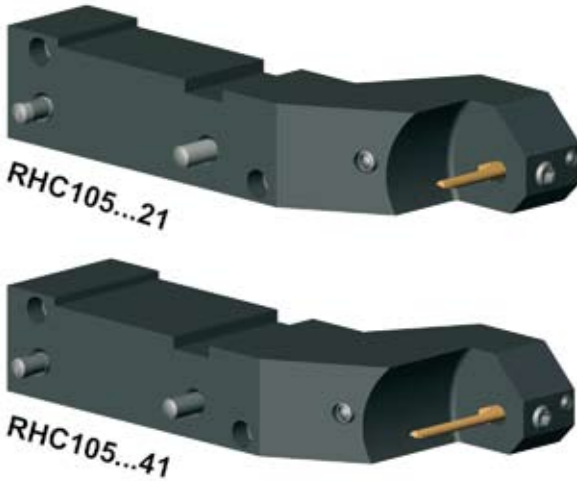
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	旋紧型角度接头 Screwed angle fitting
R...11/21	6.075T15P	T15PQ	KQ2L06-M5
R/LHC105.1...21/41	6.075T15P	T15PQ	

常规刀杆 型号  
BASIC TOOLHOLDER Type

# HC105

孔径Ø 自	Bore Ø from	0.2 mm
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用于机床Tornos DECO2000的刀具  
Tool for Tornos DECO2000



配合 刀片  
for use with Insert

型号 105  
Type



产品型号 Part number	机床型号 Type of machine	刀片 Insert
RHC105.0710.21	DECO 7/10	105...21 $l_2$ 可达 / up to 15 mm
RHC105.0710.41		105...41 $l_2$ 可达 / up to 25 mm

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

常规刀杆 Basic toolholder	销 Clamp	螺钉 Screw	圆柱螺钉 Cylindrical Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	旋紧型角度接头 Screwed angle fitting	销 Pin
RHC105...	020.0518.1610	6.075T15P	DIN912-M5x45	T15PQ	KQ2L06-M5	DIN6325-5H6x20

常规刀杆 型号  
BASIC TOOLHOLDER Type

# L760

孔径Ø 自                      Bore Ø from                      0,2 mm

用于机床Tornos DECO2000的刀具  
Tool for Tornos DECO2000



配合刀夹  
for use with Cassette

型号 RKC760  
Type



产品型号 Part number	机床型号 Type of machine	刀夹 Cassette	刀片 Insert
L760.0013.K1	DECO13	RKC760.0105.21	105...21 l <sub>2</sub> 可达 / up to 15 mm
L760.2026.K1	DECO20/26	RKC760.0105.41	105...41 l <sub>2</sub> 可达 / up to 25 mm

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

附件  
Spare parts

常规刀杆 Basic toolholder	圆柱螺钉 Cylindrical Screw	扳手 Wrench	冷却喷嘴 Coolant spray nozzle
L760.0013.K1	DIN7984-M16x35	SW5,0DIN911	-
L760.2026.K1	DIN7984-M16x35	SW5,0DIN911	05.032.902



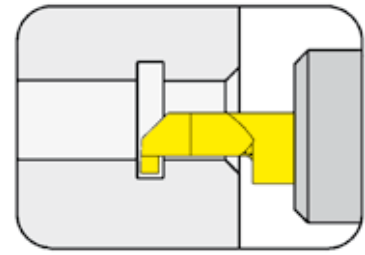
# 切槽和镗孔

## GROOVING and BORING



刀杆 型号  
TOOLHOLDER Type

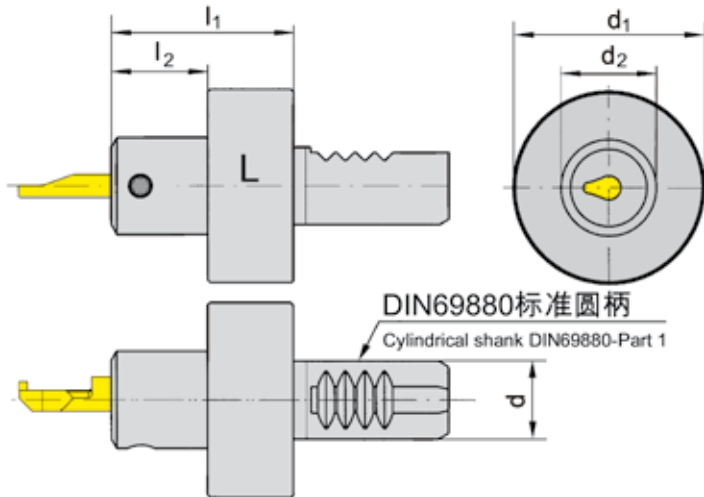
**VDI**  
带内冷  
with through coolant supply



孔径Ø 自 Bore Ø from 0.2 mm

配合 刀片  
for use with Insert

型号 105  
Type



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	d <sub>1</sub>
<b>VDI16-R/L105.20.01</b>	16	38	20	20	40
<b>VDI20-R/L105.20.01</b>	20	38	20	20	50
<b>VDI25-R/L105.20.01</b>	25	38	20	20	58
<b>VDI30-R/L105.20.01</b>	30	38	20	20	68
<b>VDI40-R/L105.20.01</b>	40	38	20	20	83

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
VDI...	<b>6.075T15P</b>	<b>T15PQ</b>



# 切槽和镗孔

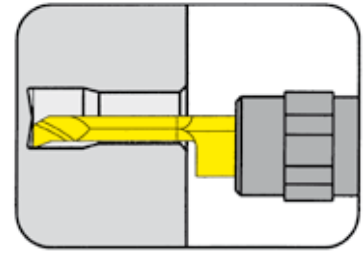
## GROOVING and BORING



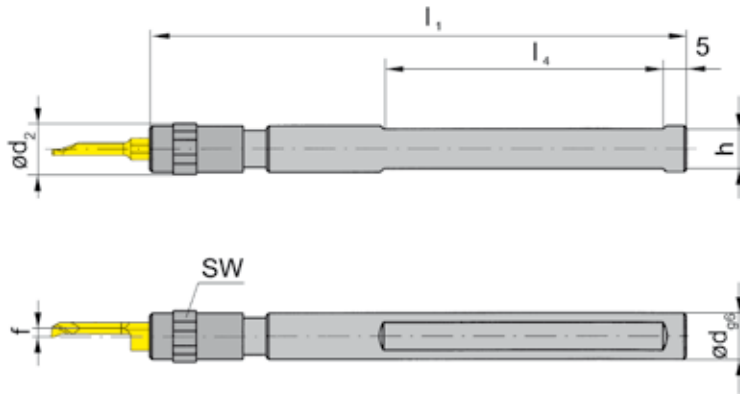
刀杆型号  
TOOLHOLDER Type

### B105

带内冷  
with through coolant supply



孔径Ø 自 Bore Ø from <3,0/>5,0 mm



配合刀片  
for use with Insert

型号 105 (Ø ≤ 3,0)  
Type 105 (Ø ≥ 5,0)

图示=右手型  
Picture = right hand cutting version

产品型号 Part number	d	l <sub>1</sub>	h	f	d <sub>2</sub>	l <sub>4</sub>	孔径范围 Bore Range	SW
<b>B105.0010.9.01</b>	10	100	9	1.6	11	50	* ≤ 3.0	10
<b>B105.0012.11.01</b>	12	100	11	1.2	16	50	* ≥ 5.0	13
<b>B105.0016.11.01</b>	16		15					

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

\*仅适用于标准刀片  
\* only valid for standard inserts

订货须知：  
刀杆可以安装左，右手刀片

Ordering note:  
Toolholders can be used with right and left hand inserts.

附件  
Spare parts

刀杆 Toolholder	锁紧螺母 Chucking nut
B105.0010.9.01	<b>020.0010.1719</b>
B105.001...01	<b>020.0016.1999</b>

# 切槽和镗孔

## GROOVING and BORING

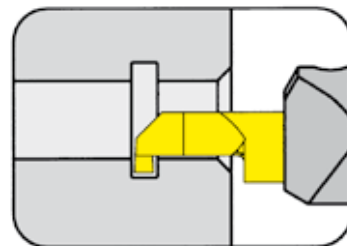


### 刀杆 型号

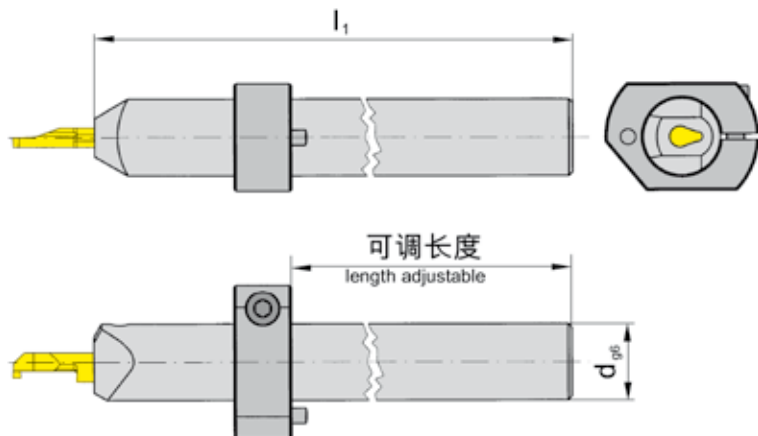
TOOLHOLDER Type

## B105

带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	0.2 mm
槽深	Depth of groove	2.5 mm
槽宽	Width of groove	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l <sub>1</sub>
<b>B105.0020.2.01</b>	20	150
<b>B105.0025.2.01</b>	25	

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

#### 订货须知：

刀杆可以安装左，右手刀片

#### Ordering note:

Toolholders can be used with right and left hand inserts.

调整环不包含在刀杆内-需要单独订购！

Adjusting ring is not combined with the toolholder - separate order required!

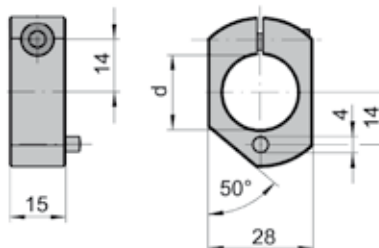
螺丝的扭矩规格，详见技术说明。

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

#### 调整环

Adjusting ring

产品型号 Part number	d	机床型号 Type of machine
<b>020.0020.1665</b>	20	Tornos DECO
<b>020.0025.2234</b>	25	



#### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.002...	<b>6.075T15P</b>	<b>T15PQ</b>



L

# 切槽和镗孔

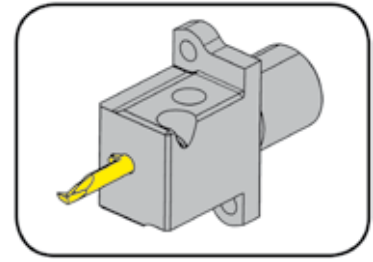
## GROOVING and BORING



刀杆 型号  
TOOLHOLDER Type

### B105

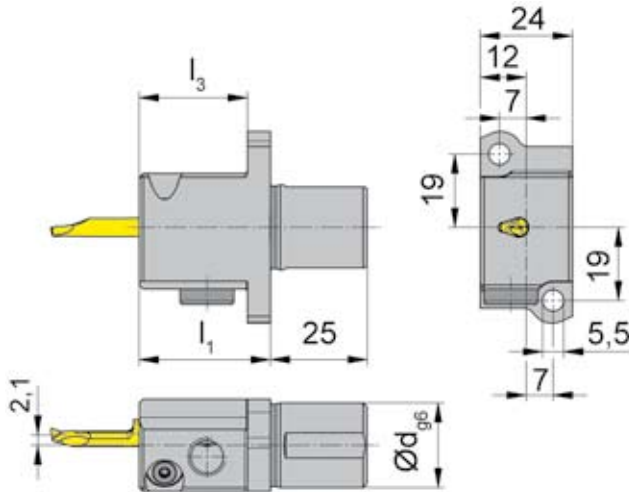
带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	0.2 mm
槽深	Depth of groove	2.5 mm
槽宽	Width of groove	2.0 mm

配合 刀片  
for use with Insert

型号 105  
Type



图示=左手型切削  
Picture = left hand cutting version

Star SV12/20/32  
SR10/20/32和SB16  
Star SV 12/20/32  
SR 10/20/32 and SB 16

产品型号 Part number	d	l <sub>1</sub>	l <sub>3</sub>
<b>LB105.A022.26.31</b>	22	34	28

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	楔形块 Tensioning wedge	螺钉 Screw	圆柱螺钉 Cylindrical Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
LB105.A022.26.31	<b>070.0010.0118</b>	<b>030.0422.T10P</b>	<b>DIN7984-M5x12</b>	<b>SW3,0DIN911</b>	<b>T10PL</b>



# 切槽和镗孔

## GROOVING and BORING

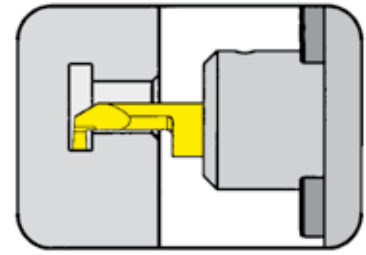


### 常规刀杆 型号

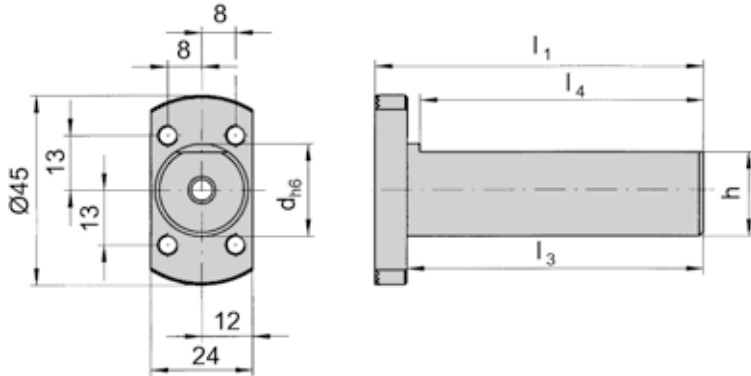
BASIC TOOLHOLDER Type

## BGT

无刀夹  
without cartridge



配合BKT105.2445.01/2刀杆的可调圆刀杆  
Adjustable round shanks for toolholder BKT105.2445.01/02



带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	h	l <sub>3</sub>	l <sub>4</sub>	机床 Machine tool
<b>BGT001.0010.50</b>	10	57.50	9	50	47	
<b>BGT001.0016.21</b> <b>BGT001.0R16.21</b>	16	28.50	14	21	18	Star
<b>BGT001.0020.100</b>	20	107.50	18	100	97	Tornos
<b>BGT001.0022.30</b> <b>BGT001.0022.70</b>	22	36.35 77.50	20	30 70	27 67	Star
<b>BGT001.0025.70</b>	25	77.50	23	70	67	
<b>BGT001.0028.80</b>	28	87.50	26	81	77	Traub

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

#### 注意事项：

BGT001.0022.30无内冷

#### Note:

BGT001.0022.30 without through coolant supply

#### 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	扳手 Wrench	O型圈 O-ring
BGT001.0...	<b>DIN912-M5x10</b>	<b>SW4,0DIN911</b>	<b>DIN3770-7x3</b>

# 切槽和镗孔

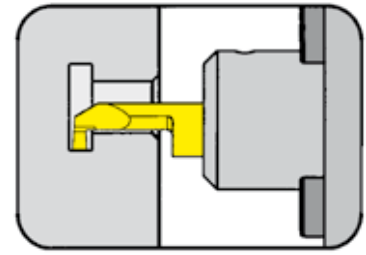
## GROOVING and BORING



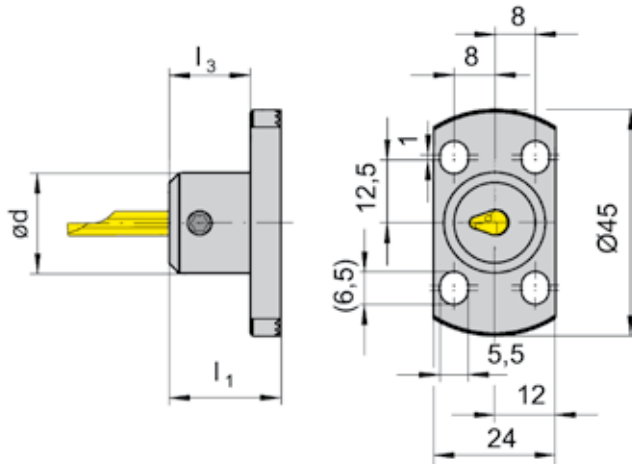
### 可调刀杆 型号

ADJUSTABLE HOLDER Type

## BKT



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type



带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	l <sub>3</sub>
<b>BKT105.2445.01</b>	20	22	16
<b>BKT105.2445.02</b>	20	32	26

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

#### 注意事项：

如果使用Horn BKT刀夹配合Graf G型 或者Graf N型和Z型，将会 有内冷

#### Note:

If using cartridge HORN type BKT with basic toolholder Graf G or adaptor Graf type N and Z, no through coolant supply will be possible.

螺丝的扭矩规格，详见技术说明。

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

#### 附件

Spare parts

可调刀杆 Adjustable holder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
BKT105.2445.0...	<b>6.075T15P</b>	<b>T15PQ</b>

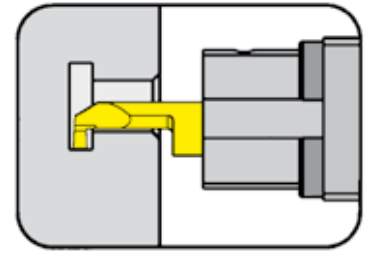
# 切槽和镗孔

## GROOVING and BORING

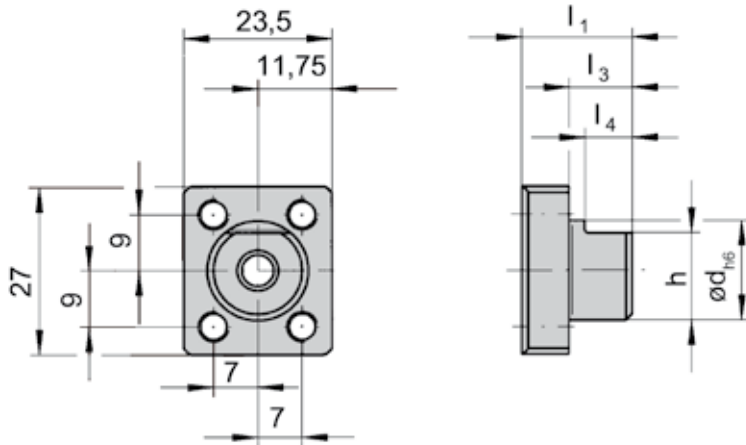


常规刀杆 型号  
BASIC TOOLHOLDER Type

**BGT**  
无刀夹  
without cartridge



配合BKT105.2327.01刀杆的可调圆柄  
Adjustable round shanks for toolholder BKT105.2327.01



带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	h	l <sub>3</sub>	l <sub>4</sub>	机床 Machine tool
<b>BGT001.1627.10</b>	16	17.5	14	10	7.5	Star

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

附件  
Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	扳手 Wrench	O型圈 O-ring
BGT001.1627.10	<b>DIN912-M5x10</b>	<b>SW4,0DIN911</b>	<b>DIN3770-7x3</b>



# 切槽和镗孔

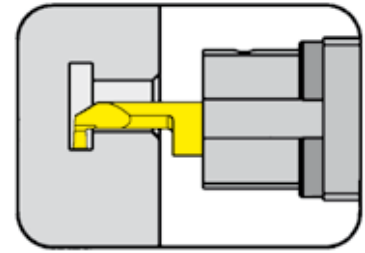
## GROOVING and BORING



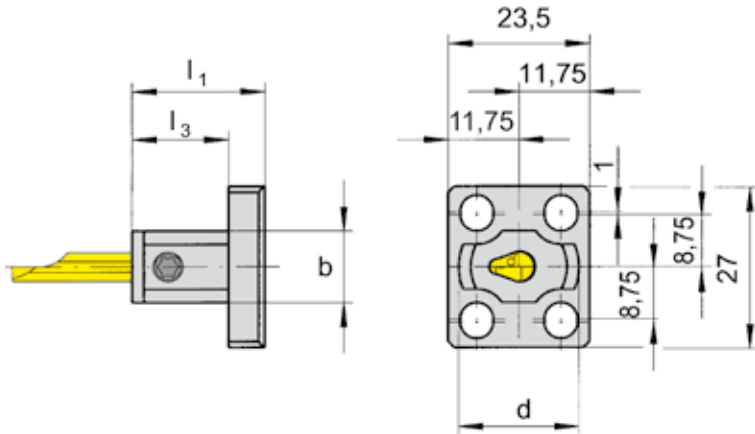
### 可调刀杆 型号

ADJUSTABLE HOLDER Type

## BKT



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type



BKT105.2327.01

带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	l <sub>3</sub>	b
<b>BKT105.2327.01</b>	20	22	16	12

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

可调刀杆 Adjustable holder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
BKT105.2327.01	6.075T15P	T15PQ

# 切槽和镗孔

## GROOVING and BORING

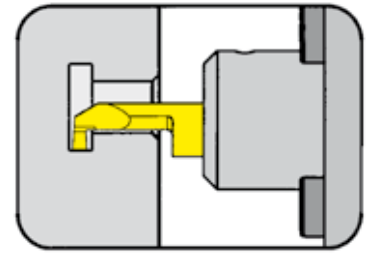


### 常规刀杆 型号

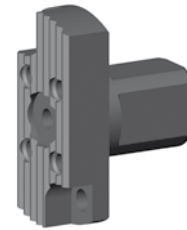
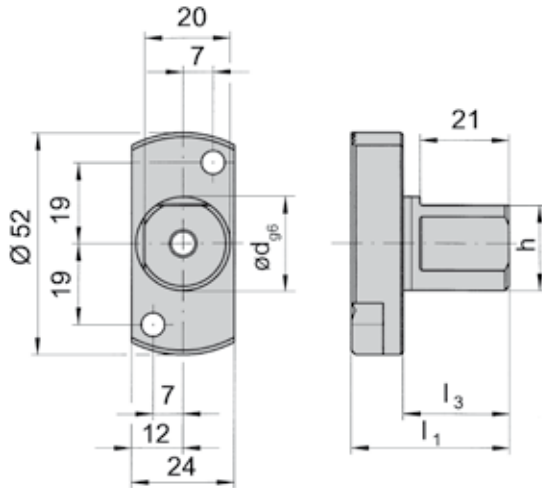
BASIC TOOLHOLDER Type

### BGT

无刀夹  
without cartridge



配合BKT105.2327.01刀杆的可调圆柄  
Adjustable round shanks for toolholder BKT105.2327.01



带内冷  
with through coolant supply

产品型号 Part number	d	l <sub>1</sub>	h	l <sub>3</sub>
<b>BGT001.0R22.25</b>	22	37	20	25

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	扳手 Wrench
BGT001.0R22.25	<b>DIN912-M5x10</b>	<b>SW4,0DIN911</b>

# 切槽和镗孔

## GROOVING and BORING

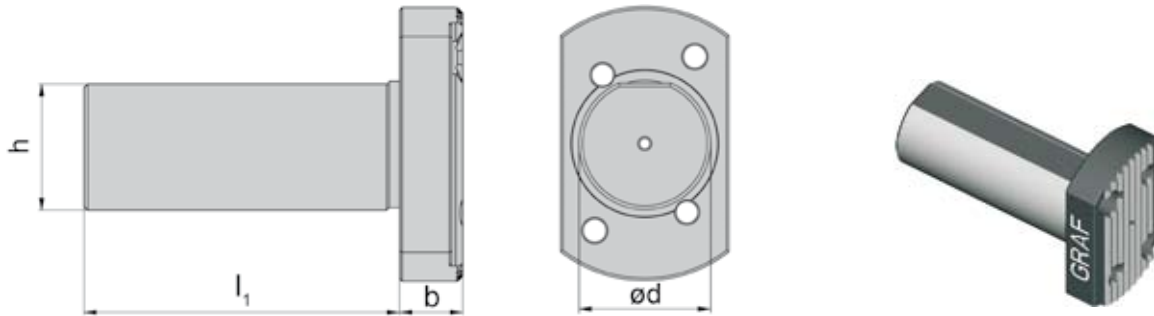


**GRAF常规刀柄 型号**  
BASIC TOOLHOLDER GRAF Type

**G**  
无刀夹  
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2  
for adjustable holder Graf type N and HORN BKT105.2445.01/02



产品型号 Part number	d	l <sub>1</sub>	h	b	机床 Machine tool
G016021	16	21	14	6	Star Traub/Manurhin
G016040		40			
G034040	3/4"	40	18	6	Citizen
G034050		50			
G034120		120			
G020030	20	30	18	6	Citizen Hanwha Tornos Manurhin/Tornos
G020040		40			
G020100		100			
G020150		150			
G022023	22	23	20	6	Star
G022025SR16/20R		25			
G022030		30			
G022030SR32		30			
G022070		70			

按需提供更多尺寸  
Further sizes upon request

单位：mm和inch  
Dimensions in mm and inch



# 切槽和镗孔

## GROOVING and BORING

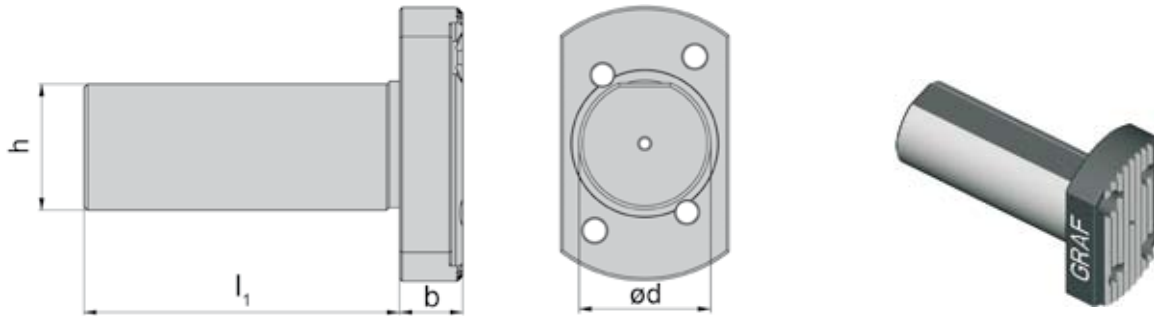


**GRAF常规刀柄 型号**  
BASIC TOOLHOLDER GRAF Type

**G**  
无刀夹  
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2  
for adjustable holder Graf type N and HORN BKT105.2445.01/02



产品型号 Part number	d	l <sub>1</sub>	h	b	机床 Machine tool
G025060	25	60	23	12	Hanwha Manurhin/Tornos Manurhin/Tornos Manurhin/Tornos
G025070		70		6	
G025100		100		6	
G025160		160		6	
G010060	1"	60	23	6	Citizen
G010100		100			
G028006	28	6	26	12	Hanwha Traub
G028080		80			
G030045	30	45	27	12	Maier
G033040	33	40	31	12	Hanwha
G034020	34	20	32	12	Maier Maier/Hanwha
G034044		44			

按需提供更多尺寸  
Further sizes upon request

单位：mm和inch  
Dimensions in mm and inch

L

# 切槽和镗孔

## GROOVING and BORING

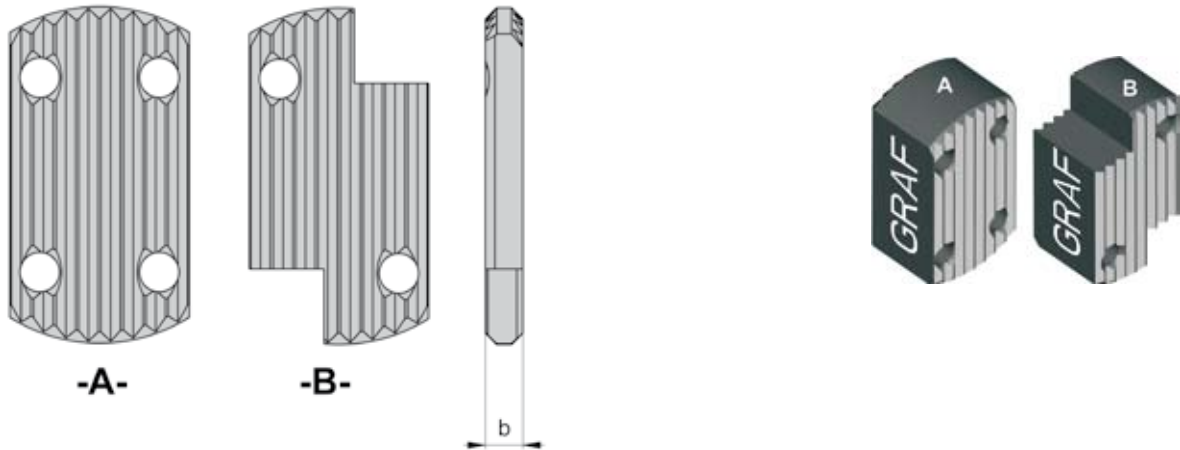


**GRAF接头 型号**  
ADAPTOR GRAF Type

**Z**  
无刀夹  
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2  
for adjustable holder Graf type N and HORN BKT105.2445.01/02



产品型号 Part number	b	自 Form
Z5	5	A
Z10	10	
Z15	15	
Z20	20	
Z25	25	
Z30	30	
Z5SR16/20R	5	B
Z10SR16/20R	10	
Z15SR16/20R	15	
Z20SR16/20R	20	
Z25SR16/20R	25	
Z30SR16/20R	30	

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

L

**GRAF型中间板**  
PLATE BETWEEN GRAF type

**N**  
无刀夹  
without Cartridge

**GRAF**  
WERKZEUGSYSTEME

用于可调Graf N型或者Horn BKT105.2445.01/02刀柄  
for adjustable holder Graf type N and HORN BKT105.2445.01/02

用于 面加工  
for back working

**产品编号 N11**  
Part number

安装2个可更换刀夹  
For alternatively 2 cartridges



**产品编号 N12**  
Part number

安装3个可更换刀夹  
For alternatively 3 cartridges



**产品编号 N93IK**  
Part number

带内冷  
with through coolant supply



# 切槽和镗孔

## GROOVING and BORING



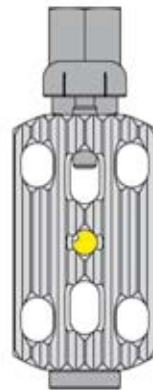
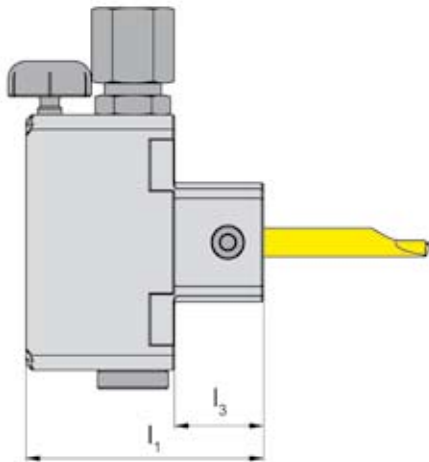
### 可调刀杆 型号

ADJUSTABLE HOLDER Type

# N



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type



带内冷  
with through coolant supply

产品型号 Part number	$l_1$	$l_3$
<b>N09IK</b>	40	15

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

可调刀杆 Adjustable holder	螺钉 Screw	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply
N09IK	6.075T15P	002.00.69	004.00.19

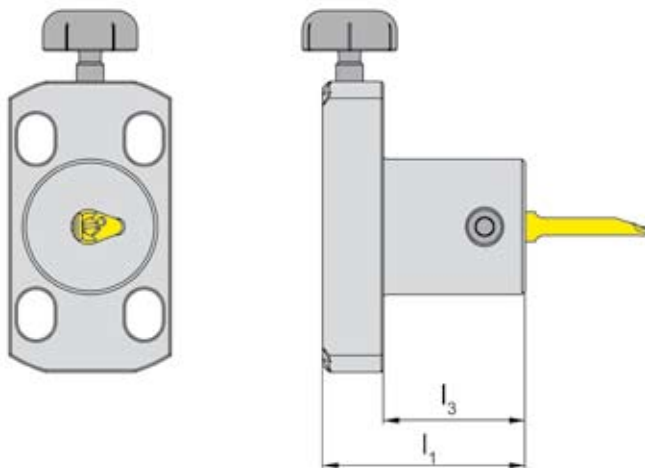
L

### 可调刀杆 型号

ADJUSTABLE HOLDER Type

# N

孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type



带内冷  
with through coolant supply

产品型号 Part number	$l_1$	$l_3$
<b>N09</b>	30	20

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

可调刀杆 Adjustable holder	螺钉 Screw	高度调节螺钉 Height adjustment screw
N09	<b>6.075T15P</b>	<b>002.00.69</b>



# 切槽和镗孔

## GROOVING and BORING



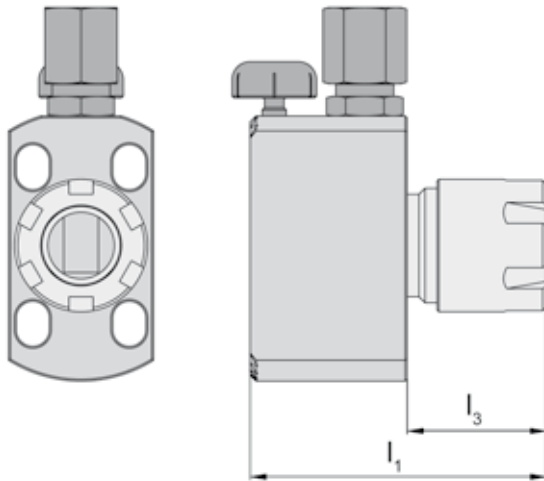
### 可调刀杆 型号

ADJUSTABLE HOLDER Type

# N



配合Graf ER16/ER20 夹  
with chucking nut ER16 / E20 system Graf



带内冷  
with through coolant supply

产品型号 Part number	$l_1$	$l_3$	备注 Remark
N07IK	54	18	ER16
N41IK	64	26	ER20

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

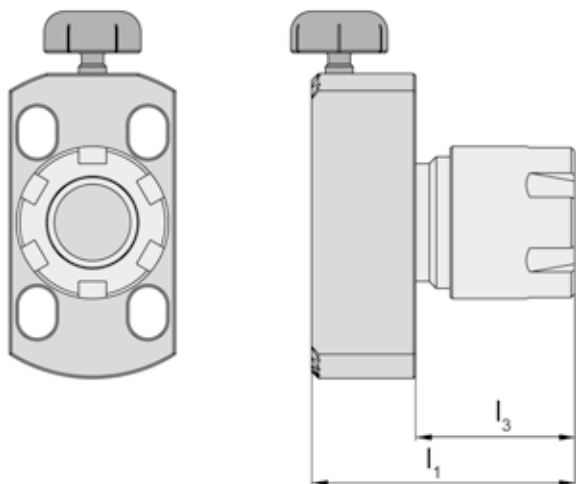
可调刀杆 Adjustable holder	锁紧螺母 Chucking nut	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply	垫圈组D3 Set of seals D3
N07IK	62.000.16	002.00.69	004.00.19	64.600.16.3-10
N41IK	62.000.20	002.00.69	004.00.19	64.600.20.3-13



可调刀杆 型号  
ADJUSTABLE HOLDER Type

**N**

配合Graf系统 ER16 夹  
with chucking nut ER16 system Graf



配合常规刀杆  
for use with Basic toolholder

型号 Horn BGT  
Type Graf G



产品型号 Part number	$l_1$	$l_3$	备注 Remark
<b>N07</b>	37	18	ER16

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

L

附件  
Spare parts

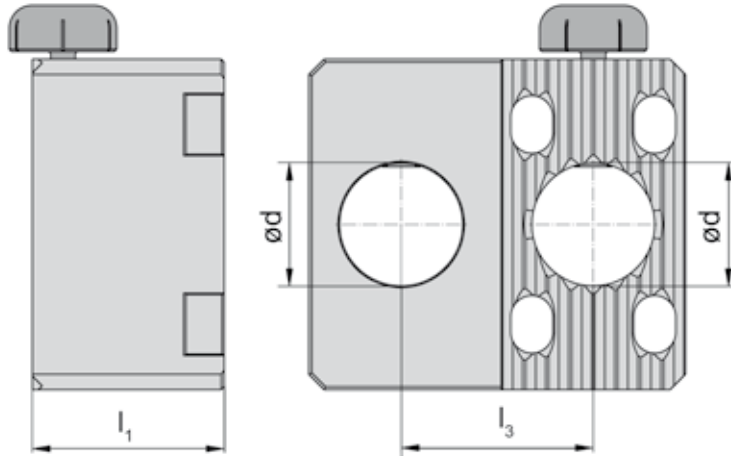
可调刀杆 Adjustable holder	锁紧螺母 Chucking nut	高度调节螺钉 Height adjustment screw
N07	<b>62.000.16</b>	<b>002.00.69</b>

可调刀杆 型号  
ADJUSTABLE HOLDER Type

**N**

**GRAF**  
WERKZEUGSYSTEME

带Graf ER11/ER16夹紧螺母  
with chucking nut ER11 / E16 system Graf



配合常规刀杆  
for use with Basic toolholder

型号 Horn BGT  
Type Graf G



产品型号 Part number	d	$l_1$	$l_3$	备注 Remark
<b>N10</b>	16	25	25	ER11 + ER16

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

附件  
Spare parts

可调刀杆 Adjustable holder	螺纹锁紧销 Threaded pin	高度调节螺钉 Height adjustment screw	夹刀柄 Collet holder
N10	002.00.11	002.00.69	GZ66.1620.11ER11

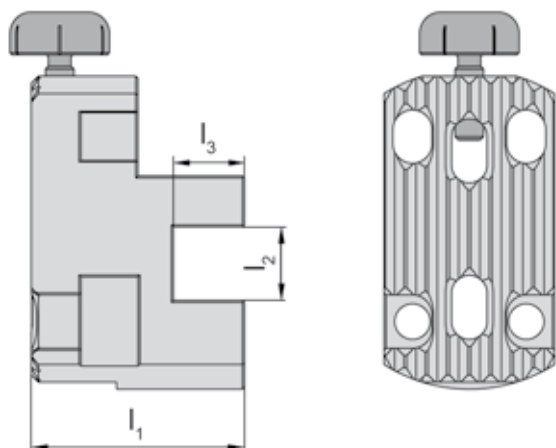
L

可调刀杆 型号  
ADJUSTABLE HOLDER Type

**N**

**GRAF**  
WERKZEUGSYSTEME

配合Graf方刀杆  
for square shank system Graf



配合常规刀杆  
for use with Basic toolholder

型号 Horn BGT  
Type Graf G



产品型号 Part number	$l_1$	$l_2$	$l_3$
<b>N06</b>	10	10	30

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

L

附件  
Spare parts

可调刀杆 Adjustable holder	螺纹锁紧销 Threaded pin	高度调节螺钉 Height adjustment screw
N06	<b>002.00.11</b>	<b>002.00.69</b>

# 切槽和镗孔

## GROOVING and BORING

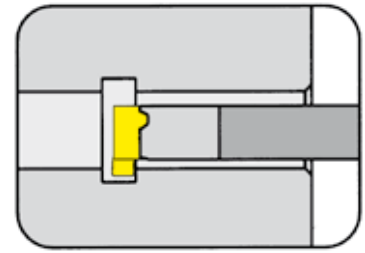


### 刀杆 型号

TOOLHOLDER Type

## B111

带内冷  
with through coolant supply



孔径Ø 自	Bore Ø from	11.0 mm
槽深	Depth of groove	2.3 mm
槽宽可达	Width of groove up to	3.0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能

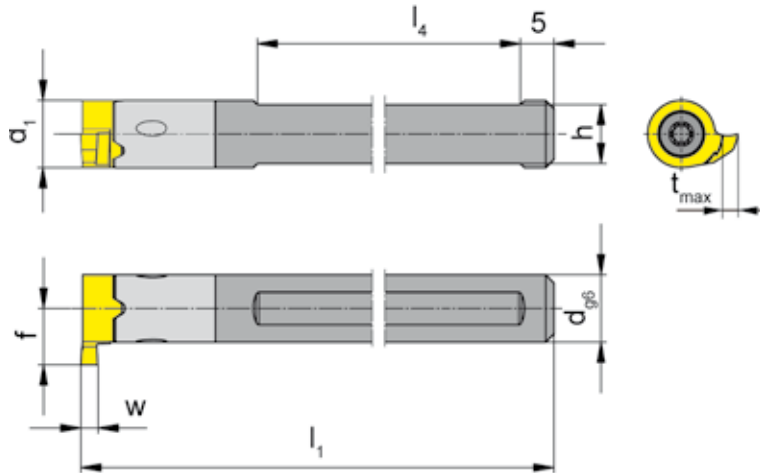
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片

for use with Insert

型号 111

Type



图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l <sub>1</sub>	h	f	t <sub>max</sub>	w	a	l <sub>4</sub>	d <sub>1</sub>
<b>B111.0008.01</b>	8	80	7	6.7	2.3	3	10.7	55	8

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

订货须知：

刀杆可以安装左手型或右手型刀片。

HORN可以返修刀杆上损坏的的基座。

**Ordering note:**

Toolholders can be used with right and left hand inserts.

Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B111.0008.01	<b>3.5-12T10EP</b>	<b>T10PL</b>

# 切槽和镗孔

## GROOVING and BORING

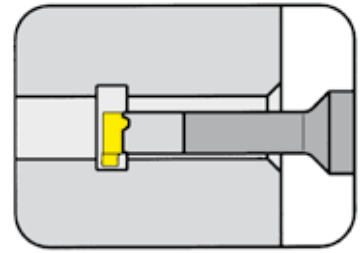


### 刀杆 型号

TOOLHOLDER Type

## B108

带内冷  
with through coolant supply

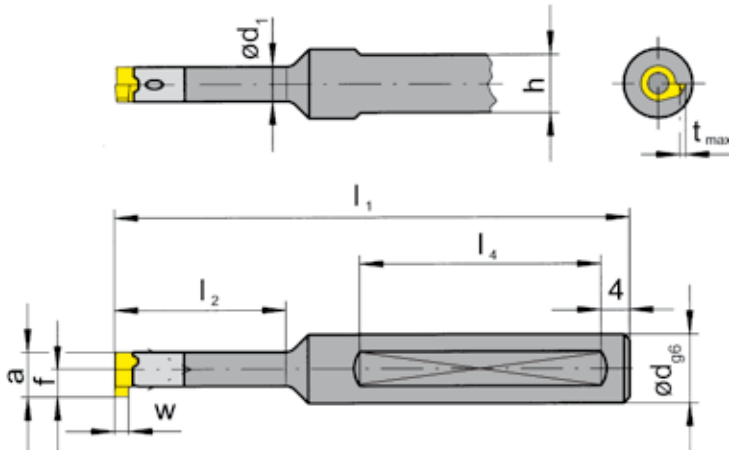


孔径Ø 自 槽宽可达	Bore Ø from Width of groove up to	8.0 mm 2.0 mm
---------------	--------------------------------------	------------------

刀杆材质：整体硬质合金 - 良好的抗振性能  
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片  
for use with Insert

型号 108  
Type



图示=右手型  
Picture = right hand cutting version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	t <sub>max</sub>	w	a	l <sub>4</sub>	d <sub>1</sub>
<b>B108.0008.00</b>	8	60	12.5	7	4.8	1	2	7.8	35	6
<b>B108.0008.01</b>	8	70	21.0	7	4.8	1	2	7.8	40	6

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
刀杆可以安装左手型或右手型刀片。  
HORN可以返修刀杆上损坏的的基座。

**Ordering note:**  
Toolholders can be used with right and left hand inserts.  
Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B108.0008.0...	<b>2.6-5T8EP</b>	<b>T8PL</b>

# 切槽和镗孔

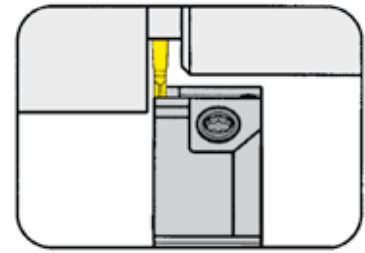
## GROOVING and BORING



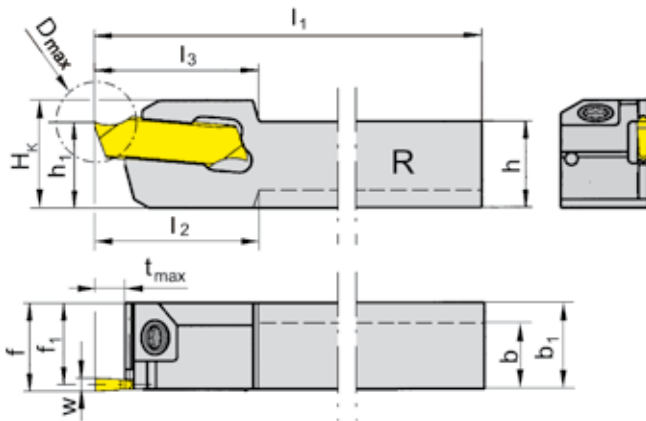
刀杆 型号  
TOOLHOLDER Type

# H264

螺钉锁紧  
with screwed clamping



槽深可达  
槽宽  
Depth of groove up to  
Width of groove  
16.0 mm  
1.5 - 2.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$b_1$	$f_1$	f	$t_{max}$	w	$D_{max}$	$H_K$	规格 Size
R/LH264.0808.01	8	8		17.5		8	10	9.25	10			22	12.5	01
R/LH264.1010.01	10	10	120	-	17.5	10	-	9.25	10	4	1.5	22	12.5	
R/LH264.1212.01	12	12		-		12	-	11.25	12			22	14.5	
R/LH264.1616.01	16	16		-		16	-	15.25	16			32	18.5	
R/LH264.1010.11	10	10				10	-	9.25	10			20	12.5	01
R/LH264.1212.11	12	12	120	-	19.0	12	-	11.25	12	10	1.5	20	14.5	
R/LH264.1616.11	16	16				16	-	15.25	16			32	18.5	
R/LH264.1212.21	12	12	120	-	22.0	12	-	11.25	12	13	1.5	26	15.5	01
R/LH264.1616.21	16	16				16	-	15.25	16			32	19.5	
R/LH264.1010.02	10	10				10	-	9.00	10				12.5	02
R/LH264.1212.02	12	12	120	-	17.5	12	-	11.00	12	4	2.0	32	14.5	
R/LH264.1616.02	16	16				16	-	15.00	16				18.5	
R/LH264.1010.12	10	10				10	-	9.00	10				12.5	02
R/LH264.1212.12	12	12	120	-	19.0	12	-	11.00	12	10	2.0	32	14.5	
R/LH264.1616.12	16	16				16	-	15.00	16				18.5	
R/LH264.1212.22	12	12	120	-	25.0	12	-	11.00	12	16	2.0	32	14.5	02
R/LH264.1616.22	16	16				16	-	15.00	16				19.5	

注明R或L型  
State R or L version

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264....	3.5-12T10EP	T10PL

# 切槽和切断

## GROOVING and PARTING OFF

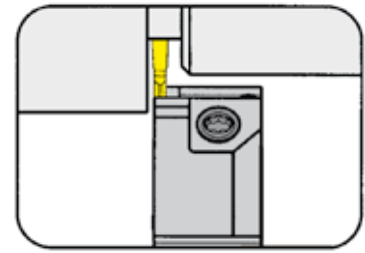


### 刀杆 型号

TOOLHOLDER Type

## H264

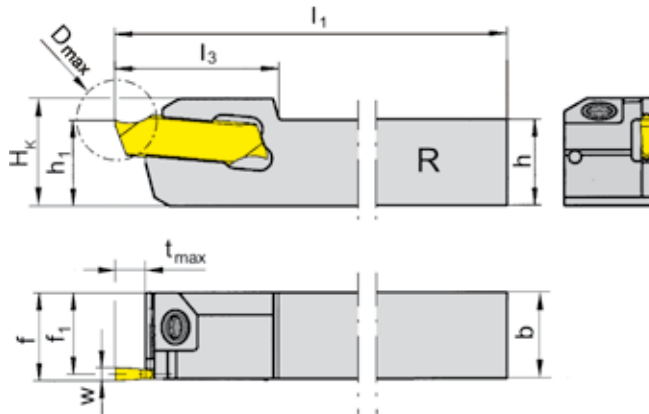
螺钉锁紧  
with screwed clamping



槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
2.5 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	2.5	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	2.5	32	18.5	
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	2.5	32	18.5	
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	2.5	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	2.5	32	18.5	

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL



# 切槽和切断

## GROOVING and PARTING OFF

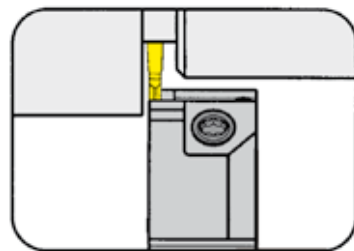


### 刀杆 型号

TOOLHOLDER Type

## H264

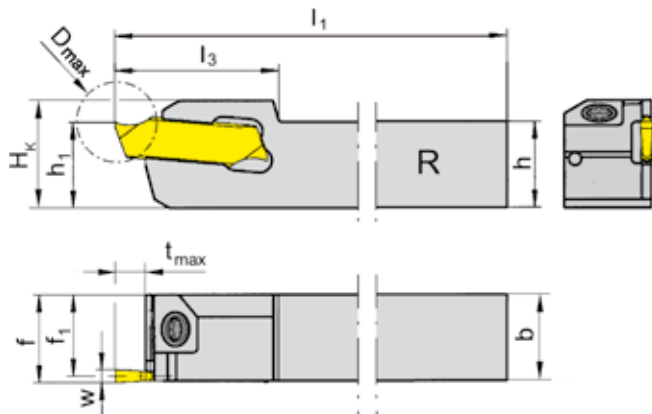
螺钉锁紧  
with screwed clamping



槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
3.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	3	32	15	04
R/LH264.1616.04	16	16			16	14.5	16					
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	3	32	15	04
R/LH264.1616.14	16	16			16	14.5	16					
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	3	32	15	04
R/LH264.1616.24	16	16			16	14.5	16					

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL

L

# 切槽和切断

## GROOVING and PARTING OFF

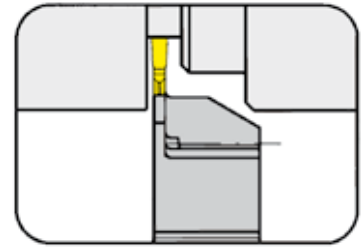


### 刀杆 型号

TOOLHOLDER Type

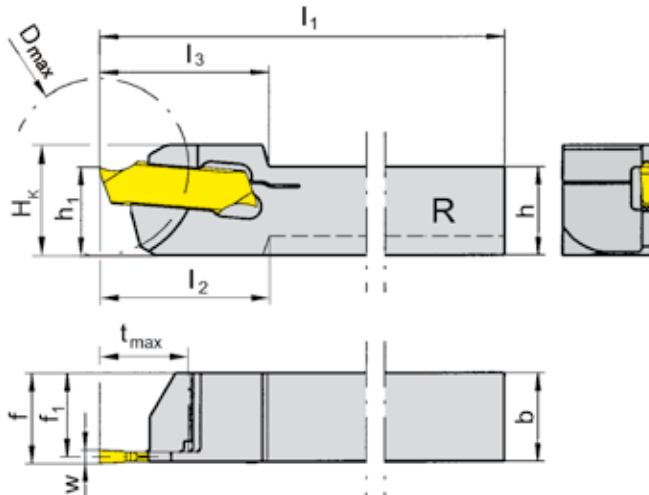
## H264

自锁紧  
with self clamping



槽深可达  
槽宽

Depth of groove up to 10.0 mm  
Width of groove 1.5 - 3.0 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 264

Type S264



产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>K</sub>	规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	1.5	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	1.5	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	2.0	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	2.0	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	3.0	32	14.5	04

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

Wrench P39L is not combined with blade - separate order required!

### 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
R/LH264....	P39L

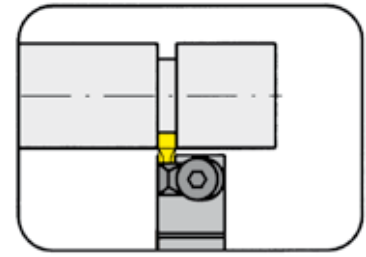
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

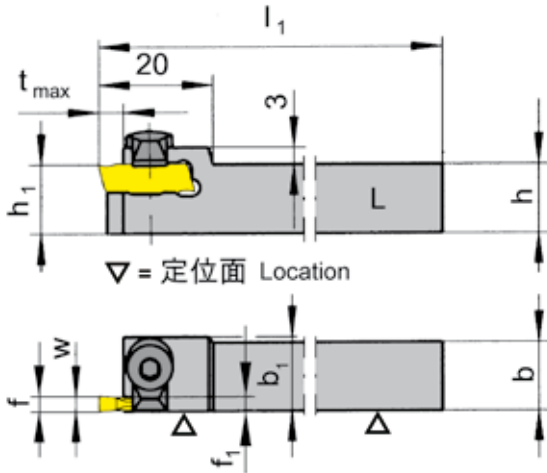
# 248



槽深可达	Depth of groove up to	4.0 mm
夹持范围	Clamping range	0.5 - 2.7 mm

配合 可转位刀片  
for use with Indexable insert

型号 217  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	b <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
<b>R/L248.1212.01</b>	12	12	95	12	13	1.5	f <sub>1</sub> +a <sub>1</sub>	4	01	0.5 - 1.7
<b>R/L248.1212.02</b>	12	12	95	12	13	2.5	f <sub>1</sub> +a <sub>1</sub>	4	02	1.7 - 2.7

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L248.1212.0...	<b>8.3</b>	<b>5.14</b>	<b>SW2,5DIN911</b>

L

# 切槽和侧车削

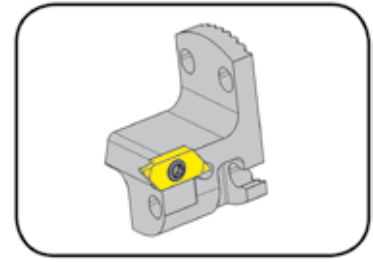
## GROOVING and SIDE TURNING



### 刀夹 型号

CARTRIDGE Type

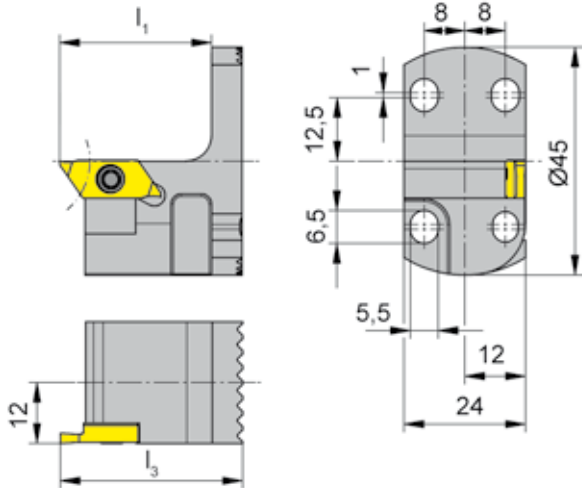
# KT274



槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 3.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type

产品型号 Part number	$l_1$	$l_3$	规格 Size
<b>R/LKT274.2445.04</b>	30	36	04

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

L

### 附件 Spare parts

刀夹 Cartridge	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LKT274.2445.04	<b>030.3509.T15P</b>	<b>T15PQ</b>

# 切槽和侧车削

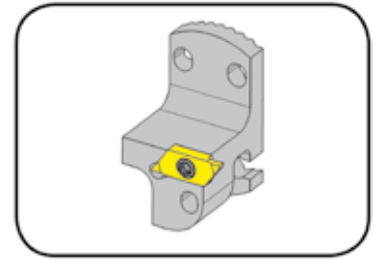
## GROOVING and SIDE TURNING



### 刀夹 型号

CARTRIDGE Type

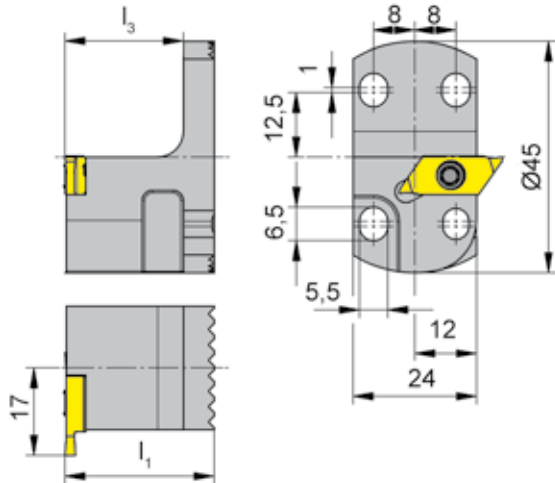
# KTC274



槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.5 - 3.0 mm



R=右手型-如图

R = right hand version shown

配合 可转位刀片

for use with Indexable insert

型号 S274

Type

产品型号 Part number	$l_1$	$l_3$	规格 Size
<b>RKTC274.2445.04</b>	29	23	04

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cartridge	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RKTC274.2445.04	<b>030.3509.T15P</b>	<b>T15PQ</b>

L

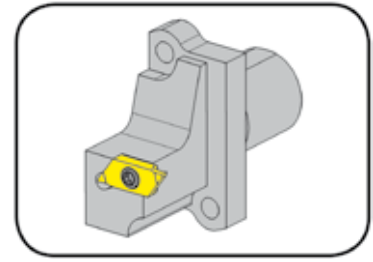
# 切槽和车削

## GROOVING and TURNING



刀杆型号  
TOOLHOLDER Type

# H274



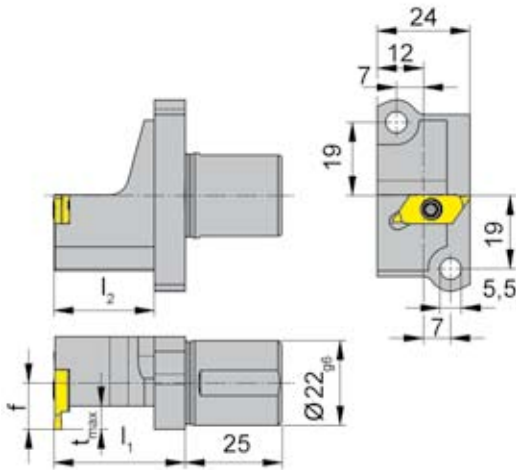
槽深可达  
槽宽可达

Depth of groove up to  
Width of groove up to

6.0 mm  
7.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

Star SV12/20/32  
SR10/20/32和SB16  
Star SV 12/20/32  
SR 10/20/32 and SB 16

产品型号 Part number	$l_1$	$l_2$	f	$t_{max}$	规格 Size
R/LH274.A022.09.04			9		
R/LH274.A022.12.04	34	26	12	6	04
R/LH274.A022.16.04			16		
R/LH274.A022.09.07	34	26	9	6	07
R/LH274.A022.12.07			12		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

L

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274.A022....04	030.3509.T15P	T15PQ
R/LH274.A022....07	030.3513.T15P	T15PQ

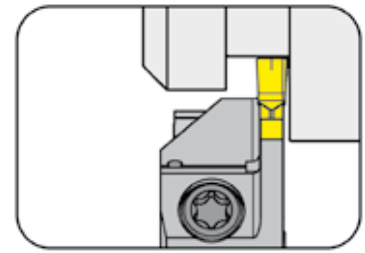
# 切槽和侧车削 ( 外圆 )

## GROOVING and SIDE TURNING (external)



刀杆 型号  
TOOLHOLDER Type

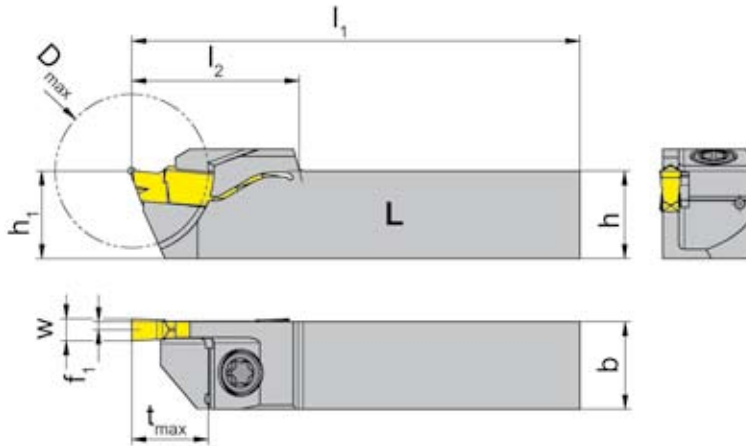
# H224



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

10.5 mm  
2.0 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$l_2$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1212.20.61	12	12	100	12	0.7	23	10.5	21	01	2.0 - 2.4
R/LH224.1212.20.62	12	12	100	12	0.9	23	10.5	21	02	2.4 - 2.8
R/LH224.1212.20.63	12	12	100	12	1.1	23	10.5	21	03	2.8 - 3.7

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.1212.20.6...	4.12T15EP	T15PQ

L

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

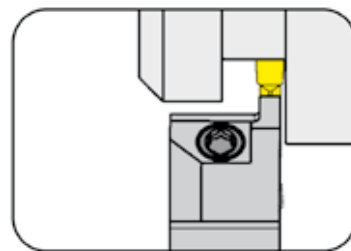


### 刀杆型号

TOOLHOLDER Type

## H224

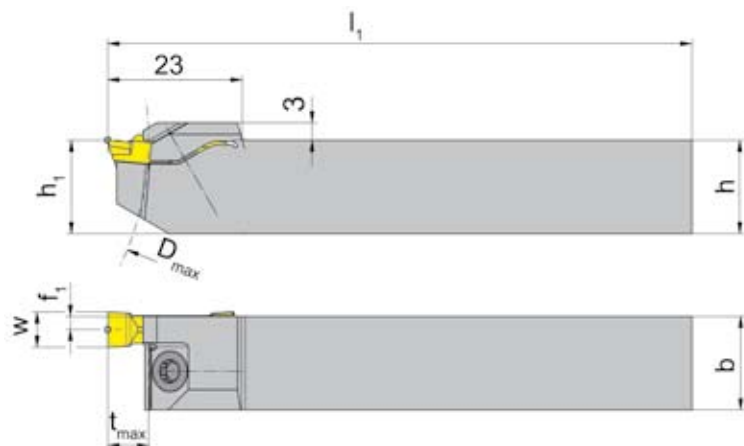
螺钉锁紧  
with screwed clamping



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

7.0 mm  
2.0 - 6.1 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1212.61	12	12	100	12	0.70	7	100	01	2.0 - 2.4
R/LH224.1616.61	16	16	100	16	0.70	7	100	01	2.0 - 2.4
R/LH224.1212.62	12	12	100	12	0.90	7	100	02	2.4 - 2.8
R/LH224.1616.62	16	16	100	16	0.90	7	100	02	2.4 - 2.8
R/LH224.1212.63	12	12	100	12	1.10	7	100	03	2.8 - 3.7
R/LH224.1616.63	16	16	100	16	1.10	7	100	03	2.8 - 3.7
R/LH224.1212.64	12	12	100	12	1.45	7	100	04	3.7 - 4.4
R/LH224.1616.64	16	16	100	16	1.45	7	100	04	3.7 - 4.4
R/LH224.1616.65	16	16	100	16	1.85	7	100	05	4.4 - 5.1
R/LH224.1616.66	16	16	100	16	2.25	7	100	06	5.1 - 6.1

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.1...61/62/63/64	4.12T15EP	T15PQ
R/LH224.1616.65/66	5.13T20EP	T20PQ



# 切槽和切断

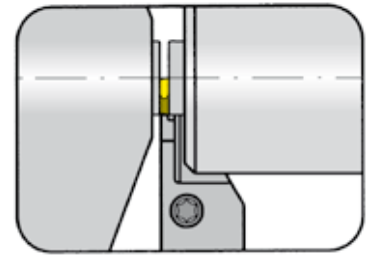
## GROOVING and PARTING OFF



### 刀杆 型号

TOOLHOLDER Type

# L368

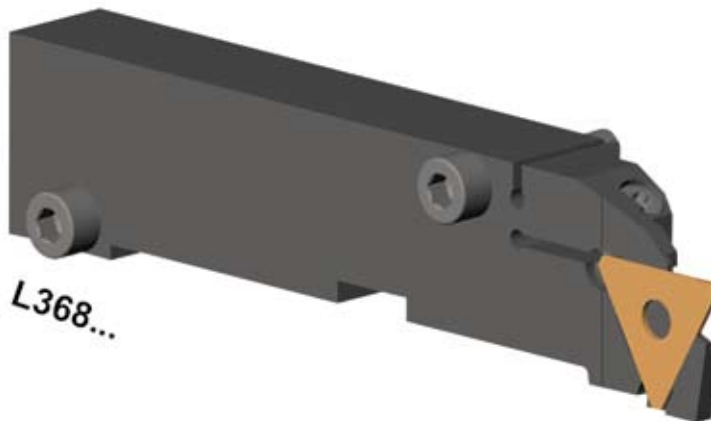


槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	0.5 - 1.5 mm

用于机床Tornos DECO2000的刀具  
Tool for Tornos DECO2000

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



产品型号 Part number	t <sub>max</sub>	w	w	机床型号 Type of machine	刀片 Insert
<b>L368.0710.08</b>	8	0.5	1.2	DECO 7/10	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1012... 312.0012...
<b>L368.0710.11</b>	8	1.5	1.5	DECO 7/10	R/L312.0515... 312.0015...

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	螺钉 Screw	圆柱螺钉 Cylindrical Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench	销 Pin
L368.0710....	<b>020.0518.1610</b>	<b>4.18T15EP</b>	<b>DIN912-M5x25</b>	<b>SW4.0DIN911</b>	<b>T15PQ</b>	<b>DIN6325-5H6x20</b>

# 切槽和切断

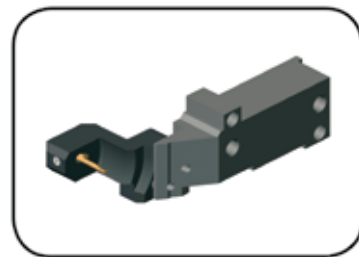
## GROOVING and PARTING OFF



### 常规刀杆 型号

BASIC TOOLHOLDER Type

## L760



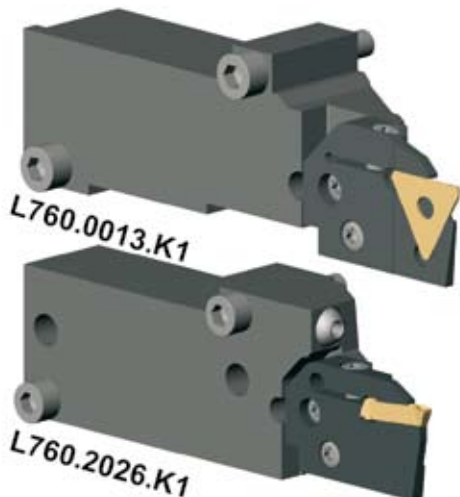
槽深可达  
槽宽

Depth of groove up to  
Width of groove

15.0 mm  
0.5 - 3.7 mm

用于机床Tornos DECO2000的刀具

Tool for Tornos DECO2000



配合刀夹

for use with Cassette

型号 LNK368

Type LNK760



产品型号 Part number	t <sub>max</sub>	w	机床型号 Type of machine	刀夹 Cassette	刀片 Insert
L760.0013.K1	8	0.5 - 1.2	DECO13	LNK368.0760.08	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...
		1.5		LNK368.0760.11	R/L312.0515... 312.0015...
L760.2026.K1	15	2.0 - 2.4 2.4 - 2.8 2.8 - 3.7	DECO20/26	LNK760.0224.01 LNK760.0224.02 LNK760.0224.03	S224...

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

常规刀杆 Basic toolholder	圆柱螺钉 Cylindrical Screw	扳手 Wrench	冷却喷嘴 Coolant spray nozzle
L760.0013.K1	DIN7984-M16x35	SW5,0DIN911	-
L760.2026.K1	DIN7984-M16x35	SW5,0DIN911	05.032.902

L40

# 切槽和切断

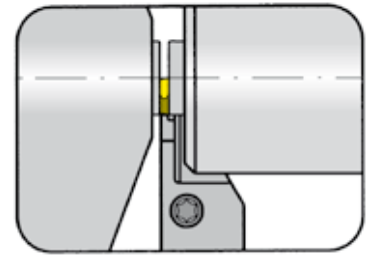
## GROOVING and PARTING OFF



### 刀夹 型号

CASSETTE Type

# LNK368/ LNK760



槽深可达  
槽宽

Depth of groove up to  
Width of groove

15.0 mm  
0.5 - 3.7 mm

用于机床Tornos DECO2000的刀具  
Tool for Tornos DECO2000



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type S224



产品型号 Part number	t <sub>max</sub>	w	机床型号 Type of machine	刀片 Insert
LNK368.0760.08	9	0,5 - 1,2	DECO13	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...
LNK368.0760.11		1,5		R/L312.0515... 312.0015...
LNK760.0224.01 LNK760.0224.02 LNK760.0224.03	15	2,0 - 2,4 2,4 - 2,8 2,8 - 3,7	DECO20/26	S224...

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LNK368.0760.08/11 LNK760.0224.01/02/03	5.17T20P 5.12T20P	5.10T20P 5.13T20EP	T20PQ T20PQ

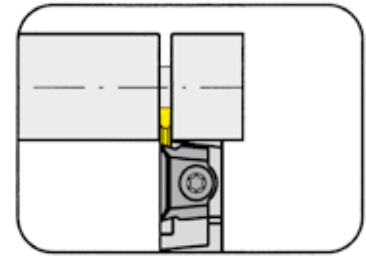
# 切槽 ( 外圆 )

## GROOVING (external)



刀杆 型号  
TOOLHOLDER Type

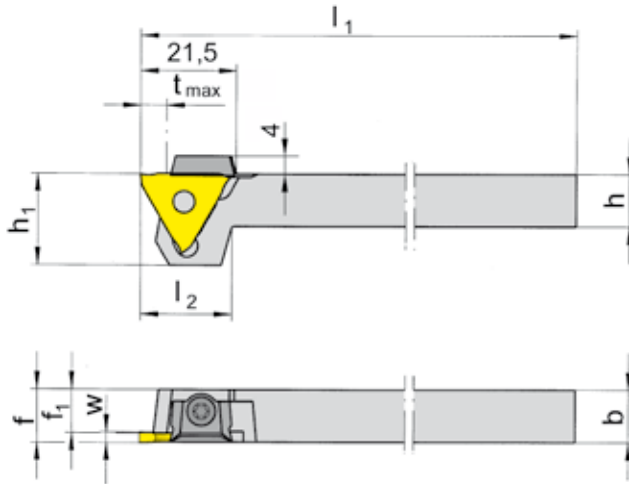
**361**  
减小头部尺寸  
reduced head size



槽深可达 夹持范围	Depth of groove up to Clamping range	6.0 mm 0.5 - 3.9 mm
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配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L361.1212.01	12	12	100	17	19	10.5	f <sub>1</sub> +w-a <sub>1</sub>	4	01	0.5-1.9
R/L361.1212.02	12	12	100	17	19	9.5	f <sub>1</sub> +w-a <sub>1</sub>	6	02	1.9-2.9
R/L361.1212.03	12	12	100	21	21	8.5	f <sub>1</sub> +w-a <sub>1</sub>	6	03	2.9-3.9

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 40$ mm时才能达到t<sub>max</sub>  
t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40$  mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

L

附件  
Spare parts

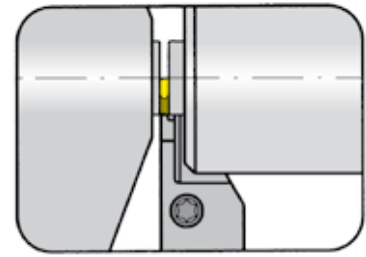
刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L361.1212.0...	12.3	030.0422.T10P	T10PL

# 切断 PARTING OFF



刀杆 型号  
TOOLHOLDER Type

## 368

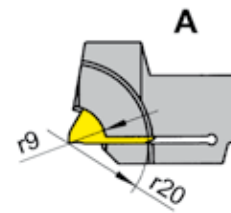
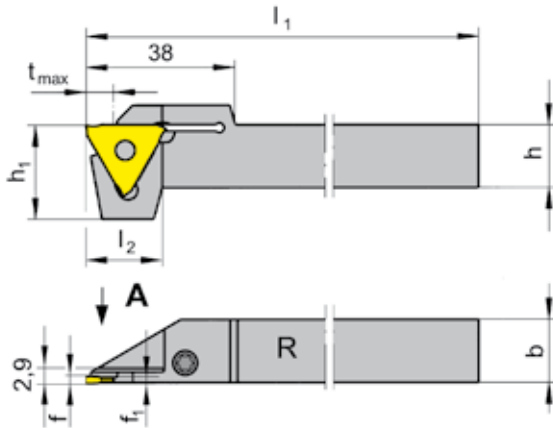


槽深可达 8.0 mm  
槽宽 0.5 - 1.5 mm  
Depth of groove up to 8.0 mm  
Width of groove 0.5 - 1.5 mm

用于TRAUB ( TNL12/7 ) 机床  
for machines TRAUB (TNL12/7)

配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



仅用于周边轮廓磨削刀片  
only for periferal grounded profiled inserts

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>
R/L368.1212.08	12	12	95	19.5	24	1.0	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.08	16	16	95	19.5	24	1.0	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1212.11	12	12	95	19.5	24	1.3	f <sub>1</sub> +a <sub>1</sub>	8
R/L368.1616.11	16	16	95	19.5	24	1.3	f <sub>1</sub> +a <sub>1</sub>	8

注明R或L型  
State R or L version

a<sub>1</sub> 见刀片  
a<sub>1</sub> see indexable inserts

尺寸单位: mm  
Dimensions in mm

刀杆R/L368...08适合安装以下刀片:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片:

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格, 详见技术说明。

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

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L368.1...	4.15T15P	T15PQ

L

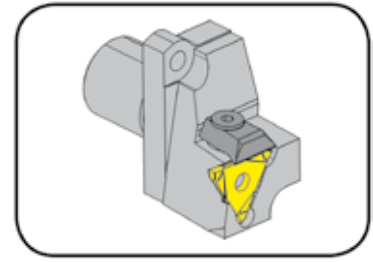
# 切槽和车削

## GROOVING and TURNING



刀杆 型号  
TOOLHOLDER Type

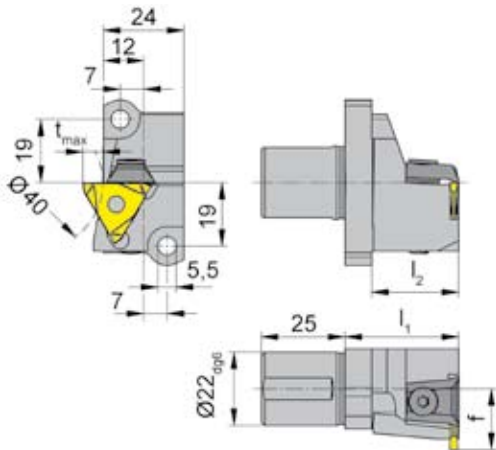
# 369



槽深	Depth of groove	4.0 - 6.0 mm
夹持范围	Clamping range	0.5 - 2.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



L=左手型  
L = left hand version shown

Star SV12/20/32  
SR10/20/32和SB16  
Star SV 12/20/32  
SR 10/20/32 and SB 16

产品型号 Part number	$l_1$	$l_2$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
<b>L369.A022.18.01</b>	34	26	18.2	4	01	0.5 - 1.9
<b>L369.A022.18.02</b>	34	26	18.2	6	02	1.9 - 2.9

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

L

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
L369.A022.18.0...	16.4	6.25	SW3,0DIN911

冷却系统标准接头  
Standard connection for through cooling



冷却系统接头  
Connection for through cooling  
004.00.19



用于管子 Ø 6 mm  
for pipe Ø 6 mm



冷却系统快速接头  
Clip connection for through cooling

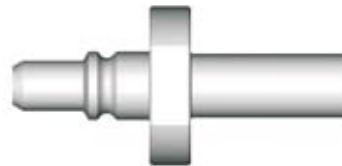
M10 x 1



快速夹头  
Clip connection  
004.00.49



栓塞  
Plug  
M8 x 1 - 004.00.56  
G1/8" - 004.00.57



栓塞  
Plug  
Ø 6 mm - 004.00.59

用于管子 Ø 6 mm  
for pipe Ø 6 mm



接头  
Coupling  
M8 x 1 - 004.00.61  
G1/8" - 004.00.16

# HCG - HORN Catalogue Guide

## 模块化刀具系列 / MODULAR TOOLING SYSTEM

连接系统 Couplings	刀杆系列 / Toolholder system												
	Super-mini®	Mini	100	117	264	274	360	356	368	224	220	B224	B229
HORN多边形刀柄 HORN Polygon shank			•				•	•	•	•	•	•	•
HORN TS			•				•	•	•	•	•	•	•
KM Micro	•	•			•	•							
HSK-C63			•				•	•		•	•	•	•
HSK-T63			•				•	•		•	•	•	•
HSK-T40 (..840..)			•		•	•	•	•	•	•			
HSKW (Schütte..849..)	•		•	•			•	•	•	•	•		
HORN多边形刀柄 HORN Polygon shank (Schütte..849..)	•		•	•			•	•	•	•	•		

加工 Machining														
内圆切槽 Internal grooving	•	•											•	•
外圆切槽 Extern. grooving			•		•	•	•	•	•	•	•			
端面切槽 Face grooving							•	•		•	•			
切断 Parting off			•		•	•	•	•	•	•	•			
仿形加工 Profiling				•										

刀夹 Cassette														
			•		•	•	•	•	•	•	•	•	•	•

刀夹 型号 Cassette type	刀片 型号 / Inserts type													
R/L/NK100			S100											
R/L/NK264					S264									
R/L/NK274						S274								
R/L/NK360							S312 312							
R/L/NK356								315						
R/L/NK368									S312 312					
R/L/NK,R/LIK,R/LAK224										S224				
R/L/NK,R/LIK,R/LAK220											S229 229			
R/LBK224												S224		
R/LBK229													S229 229	

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相对应的刀具系列 中选取刀片

Inserts can be selected in the chapters of the responsible tooling system.

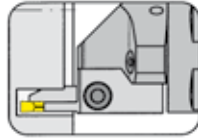


模块化刀具系列

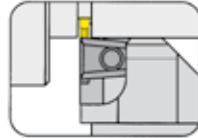
MODULAR TOOLING SYSTEM

M

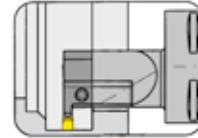
HORN多边形刀柄  
HORN Polygon shank  
ISO 26623



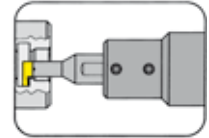
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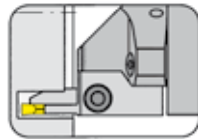


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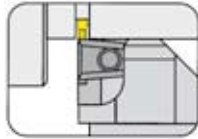


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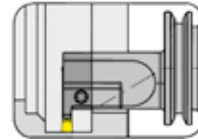
HORN刀柄 TS  
HORN Toolholder TS  
ISO 26622



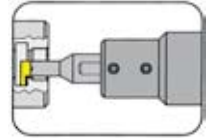
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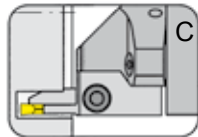


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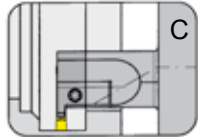


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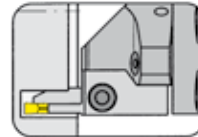
HORN HSK-C63  
HORN HSK-T63  
HORN HSKT-100



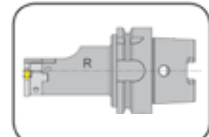
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M32-M35

刀夹  
Cassettes

径向 / radial  
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轴向 / axial  
页 / Page M46-M69

HORN HSK-T40



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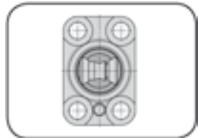
刀夹  
Cassettes

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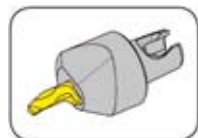
HORN KM16 Micro



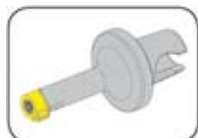
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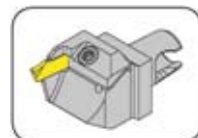
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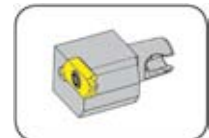
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HORN 849



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M100, M102-M103

刀夹  
Cassettes

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M101  
M104-M105

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不同刀夹安装于HORN ISO26623刀柄，HORN ISO26622 TS刀柄和HSK刀柄上，适于切槽，切断和端面槽加工。  
HORN特殊设计的刀夹和转接器的接触面保证了系统的稳定性。刀夹系统可应用于312, S224, S229 and S100刀片系列上。

Adapters for the modular systems HORN Polygon shank according to ISO 26623, HORN Toolholder TS according to ISO 26622 and HSK with different cassettes are suitable for grooving, parting off and face grooving. Excellent stability is guaranteed through the HORN designed interface between the cassette and adapter. The cassettes are available for four insert systems - 312, S224, S229 and S100.

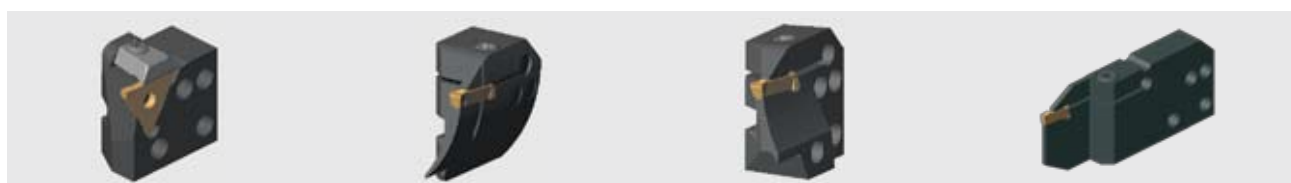
模块化刀具系列  
Modular Tooling System

外圆加工  
External machining

连接系统 Coupling system	HORN多边形刀柄 HORN Polygon shank ISO 26623	HORN TS ISO 26622	HSK DIN 69893
0° 直 straight			
90° 曲柄 cranked			
型 Version		左手和右手 right and left hand	

刀夹方案  
Cassette programme

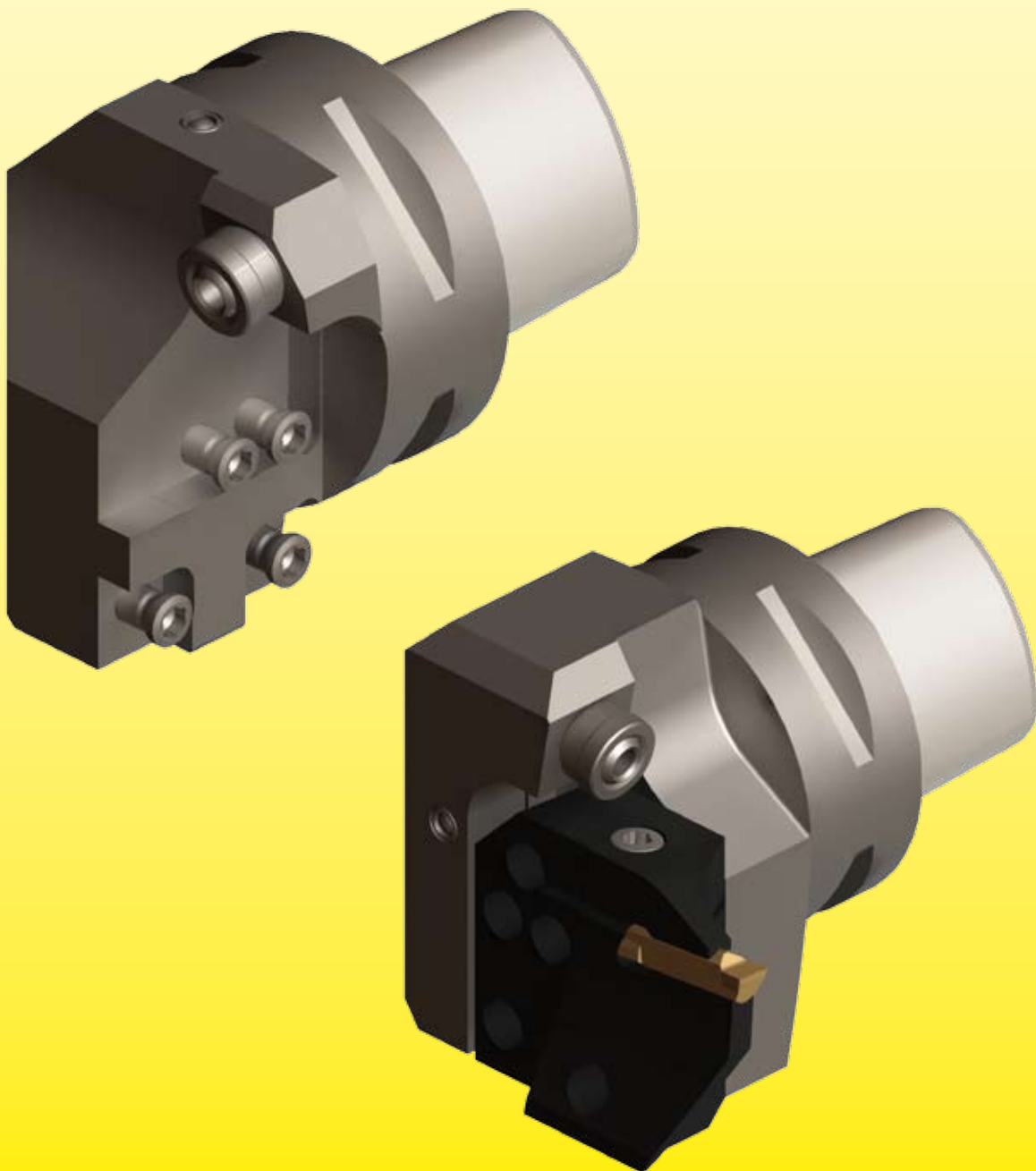
型号 type	刀片 Insert	RNK/LNK	RIK/LIK	RAK/LAK	刀具长度 Tool length
360	312	•	-	-	$l = l_1 + l_K$ (刀夹) (Cassette)
224	S224	•	•	•	
220	S229	•	•	•	
220	S100	•	-	-	



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## HORN- 合ISO 26623的多边形刀柄

HORN Polygon shank according to ISO 26623



# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

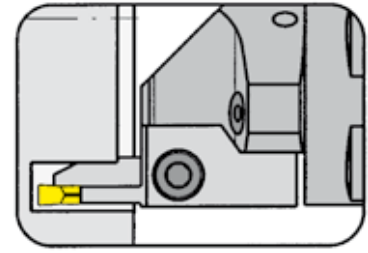


### 常规刀柄 型号

BASIC TOOLHOLDER Type

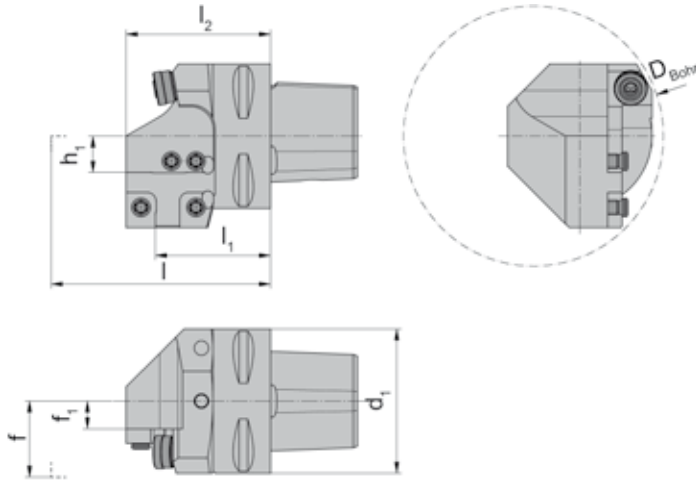
## 220C

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN多边形刀柄  
( ISO26623 )

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
R/L220.00C3.K1	36	50	32	12.5	4.6	$f_1+f_3$	$l_1+l_k$
R/L220.00C4.K1	40	50	40		4.6		
R/L220.00C5.K1	40	50	50	9.6			
R/L220.00C6.K1	42	52	63	16.1			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸 $D_{Bohr}$ ,  $f_3$  and  $l_k$  见刀夹

Note:  
Dimensions for  $D_{Bohr}$ ,  $f_3$  and  $l_k$  see cassettes

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L220.00C...	5.12T20P	T20PQ	020.1008.2977

M4

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

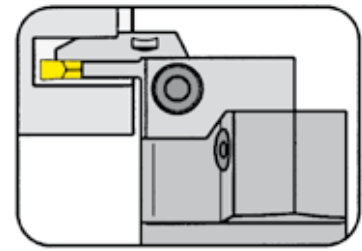


### 常规刀柄 型号

BASIC TOOLHOLDER Type

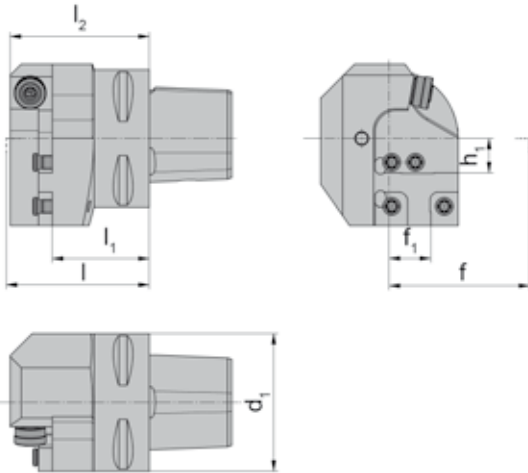
## 220C

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN多边形刀柄  
( ISO26623 )

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
R/L220.00C3.K2	31.2	46.5	32		10.0		
R/L220.00C4.K2	35.2	50.5	40	12.5	10.0	$f_1+l_k$	$l_1+f_3$
R/L220.00C5.K2	35.2	50.5	50		15.0		
R/L220.00C6.K2	37.2	52.5	63		21.5		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $D_{min}$ ,  $f_3$  and  $l_k$  见刀夹

Note:  
Dimensions for  $D_{min}$ ,  $f_3$  and  $l_k$  see cassettes

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L220.00C...	5.12T20P	T20PQ	020.1008.2977

M

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

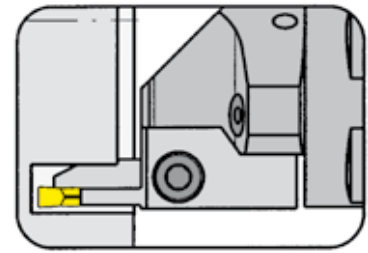


### 常规刀柄 型号

BASIC TOOLHOLDER Type

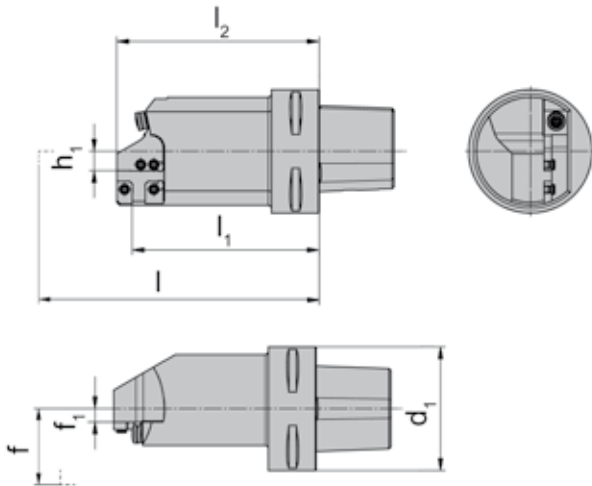
### C5/C8

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN多边形刀柄  
(ISO26623)

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
C5.L220.120.K1 C5.R220.120.K1	91	101	50	12.5	9.6	$f_1+f_3$	$l_1+l_k$
C8.L220.150.K1 C8.R220.150.K1	121	131	80	12.5	8.6	$f_1+f_3$	$l_1+l_k$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $f_3$ 和 $l_k$ 见刀夹

Note:  
Dimensions for  $f_3$  and  $l_k$  see cassettes

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
C...	5.12T20P	T20PQ	020.1008.2977

M6

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

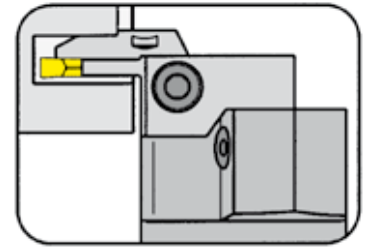


### 常规刀柄 型号

BASIC TOOLHOLDER Type

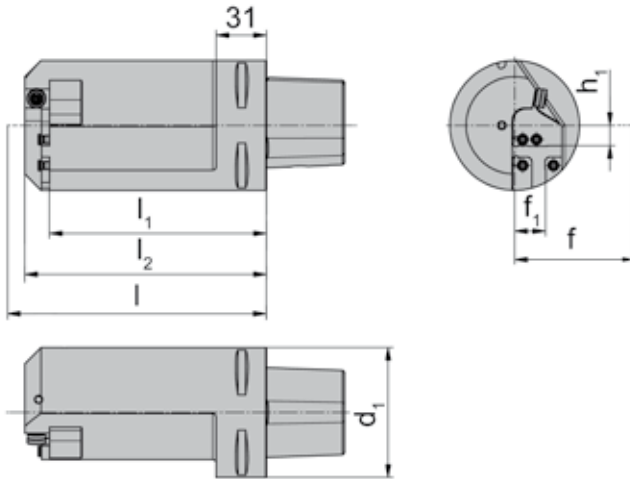
### C8

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN多边形刀柄  
( ISO26623 )

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
<b>C8.L220.150.K2</b> <b>C8.R220.150.K2</b>	133.6	148.8	80	12.5	19	$f_1+l_k$	$l_1+f_3$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $f_3$ 和 $l_k$ 见刀夹

**Note:**  
Dimensions for  $f_3$  and  $l_k$  see cassettes

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
C8.R/L220.150.K2	<b>5.12T20P</b>	<b>T20PQ</b>	<b>020.1008.2977</b>

# 切槽 ( 外圆 )

## GROOVING (external)

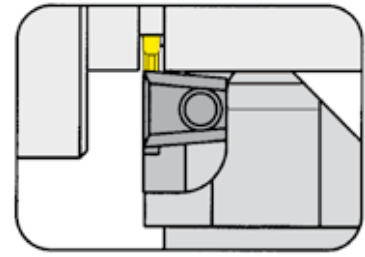


### 刀柄 型号

TOOLHOLDER Type

## 360C

配合刀夹  
with cassette



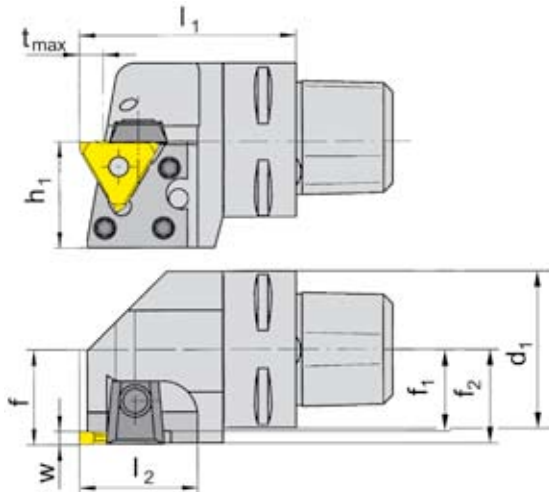
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
0.5 - 2.9 mm

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 312

Type

HORN多边形刀柄  
( ISO26623 )

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$t_{max}$	$f_2$	规格 Size	夹持范围 Clamping range
R/L360.00C3.K1	45	31	32	27.3	15.0	$f_1+w-a_1$	4	16.5	01	0.5 - 1.9
R/L360.00C4.K1	50		40	27.3	19.0			20.5		
R/L360.00C5.K1	50		50	27.3	24.0			25.5		
R/L360.00C6.K1	55		63	31.5	30.5			32.0		
R/L360.00C3.K2	45	31	32	27.3	14.0	$f_1+w-a_1$	6	16.5	02	1.9 - 2.9
R/L360.00C4.K2	50		40	27.3	18.0			20.5		
R/L360.00C5.K2	50		50	27.3	23.0			25.5		
R/L360.00C6.K2	55		63	31.5	29.5			32.0		

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀柄 Toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	扳手 Wrench
L360.00C...K1	LK360.00.01	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
L360.00C...K2	LK360.00.02	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.00C...K1	RK360.00.01	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.00C...K2	RK360.00.02	16.4	T15PQ	030.0410.T15P	SW3,0DIN911

M8

M



# 切槽 ( 外圆 )

## GROOVING (external)

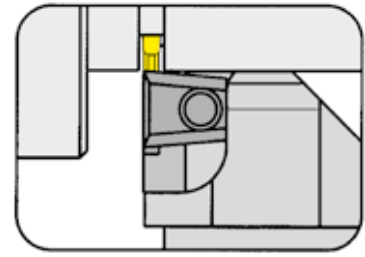


### 刀柄 型号

TOOLHOLDER Type

## 360C

配合刀夹  
with cassette



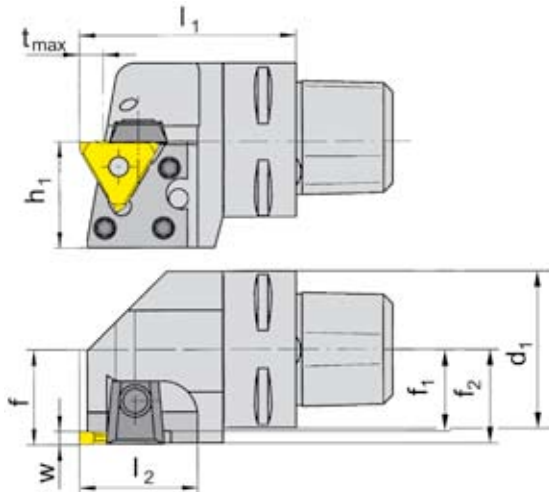
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
2.9 - 6.3 mm

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type

HORN多边形刀柄  
( ISO26623 )

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$t_{max}$	$f_2$	规格 Size	夹持范围 Clamping range
R/L360.00C3.K3	45	31	32	27.3	13.0	$f_1+w-a_1$	6	16.5	03	2.9 - 3.9
R/L360.00C4.K3	50		40	27.3	17.0			20.5		
R/L360.00C5.K3	50		50	27.3	22.0			25.5		
R/L360.00C6.K3	55		63	31.5	28.5			32.0		
R/L360.00C3.K4	45	31	32	27.3	11.3	$f_1+w-a_1$	6	16.5	04	3.9 - 6.3
R/L360.00C4.K4	50		40	27.3	15.3			20.5		
R/L360.00C5.K4	50		50	27.3	20.3			25.5		
R/L360.00C6.K4	55		63	31.5	26.8			32.0		

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀柄 Toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	扳手 Wrench
L360.00C...K3	LK360.00.03	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
L360.00C...K4	LK360.00.04	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.00C...K3	RK360.00.03	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.00C...K4	RK360.00.04	16.4	T15PQ	030.0410.T15P	SW3,0DIN911

M

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

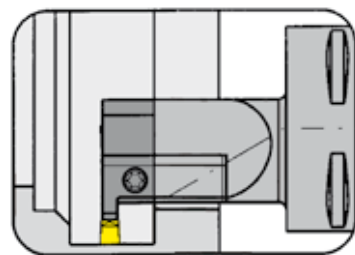


### 常规刀柄 型号

BASIC TOOLHOLDER Type

## B224C

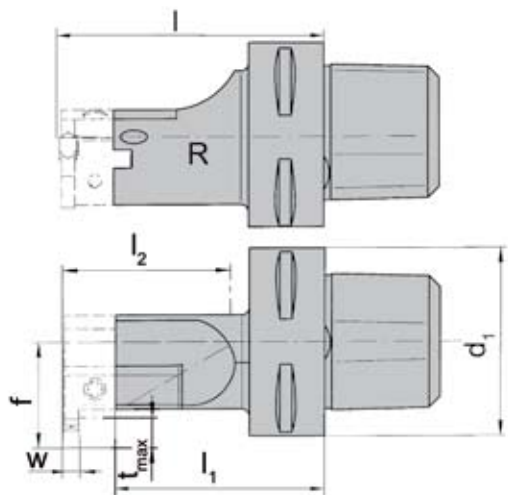
无刀夹  
without cassette



配合BK224型刀夹的常规刀柄  
Basic toolholder for cassettes type BK224

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

HORN多边形刀柄  
(ISO26623)

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	$d_1$	$l$	$l_1$	$l_2$	$f$
R/LB224.00C3.1.K2 R/LB224.00C3.2.K2	32	$l_1 + b_1 + w/2$	39.3 54.3	35 50	32
R/LB224.00C4.1.K2 R/LB224.00C4.2.K2	40	$l_1 + b_1 + w/2$	49.3 69.3	40 60	32
R/LB224.00C5.1.K2 R/LB224.00C5.2.K2	50	$l_1 + b_1 + w/2$	59.3 79.3	50 70	32
R/LB224.00C6.1.K2 R/LB224.00C6.2.K2	63	$l_1 + b_1 + w/2$	69.3 89.3	58 78	32
R/LB224.00C8.1.K2 R/LB224.00C8.2.K2	80	$l_1 + b_1 + w/2$	80.3 100.3	60 80	32

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

注意事项:

尺寸 $D_{min}$ ,  $t_{max}$ 和 $w$ 见刀夹部分

Note:

Dimensions for  $D_{min}$ ,  $t_{max}$  see cassettes

尺寸单位: mm

Dimensions in mm

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00C...	030.0518.T20P	T20PQ

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

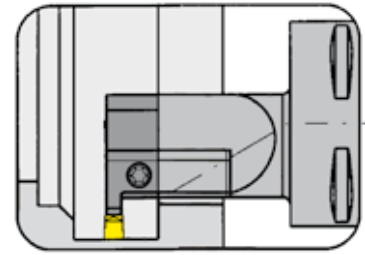


### 常规刀柄 型号

BASIC TOOLHOLDER Type

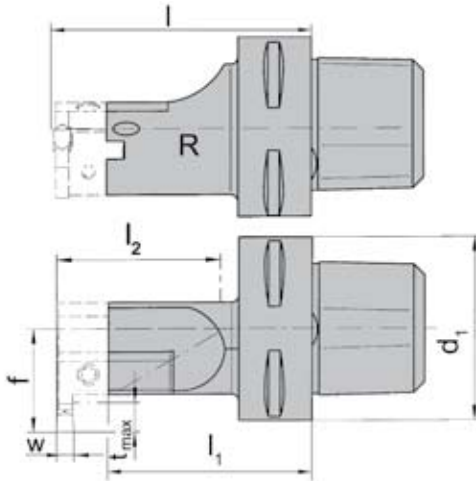
## B229C

无刀夹  
without cassette



配合BK229型刀夹的常规刀柄  
Basic toolholder for cassettes type BK229

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN多边形刀柄  
(ISO26623)

HORN Polygon shank  
according to ISO 26623

产品型号 Part number	d <sub>1</sub>	l	l <sub>1</sub>	l <sub>2</sub>	f
R/LB229.00C3.1.K2 R/LB229.00C3.2.K2	32	$l_1 + b_1 + w/2$	38.5 53.5	35 50	35.5
R/LB229.00C4.1.K2 R/LB229.00C4.2.K2	40	$l_1 + b_1 + w/2$	48.5 68.5	40 60	35.5
R/LB229.00C5.1.K2 R/LB229.00C5.2.K2	50	$l_1 + b_1 + w/2$	58.5 78.5	50 70	35.5
R/LB229.00C6.1.K2 R/LB229.00C6.2.K2	63	$l_1 + b_1 + w/2$	68.5 88.5	58 78	35.5
R/LB229.00C8.1.K2 R/LB229.00C8.2.K2	80	$l_1 + b_1 + w/2$	84.5 109.5	65 90	35.5

注明R或L型  
State R or L version

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项:  
尺寸D<sub>min</sub>, t<sub>max</sub>和w见刀夹部分

Note:  
Dimensions for D<sub>min</sub>, t<sub>max</sub> see cassettes

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB229.00C...	030.0518.T20P	T20PQ

M

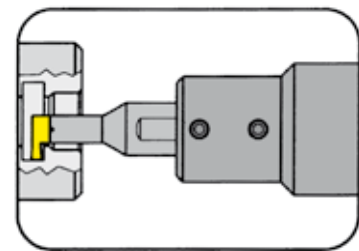
# 切槽 ( 内圆 )

## GROOVING (internal)



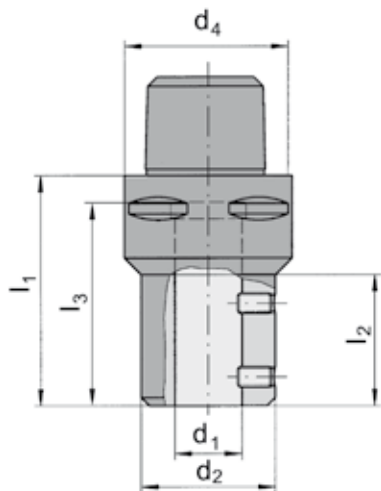
接头 型号  
ADAPTOR Type

# 001C



HORN多边形刀柄 ( ISO26623 )  
HORN Polygon shank according ISO 26623

用于带标准夹持面的圆刀柄  
for cylindrical shanks with standard clamping flat



产品型号 Part number	$l_1$	$l_2$	$l_3$	$d_2$	$d_1$	$d_4$
001.00C3.16	65	-	55	40	16	32
001.00C3.20	70	-	58	40	20	32
001.00C4.16	65	-	55	40	16	40
001.00C4.20	70	-	58	40	20	40
001.00C5.16	65	44	55	40	16	50
001.00C5.20	70	49	58	40	20	50
001.00C6.20	70	45	58	40	20	63

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

M

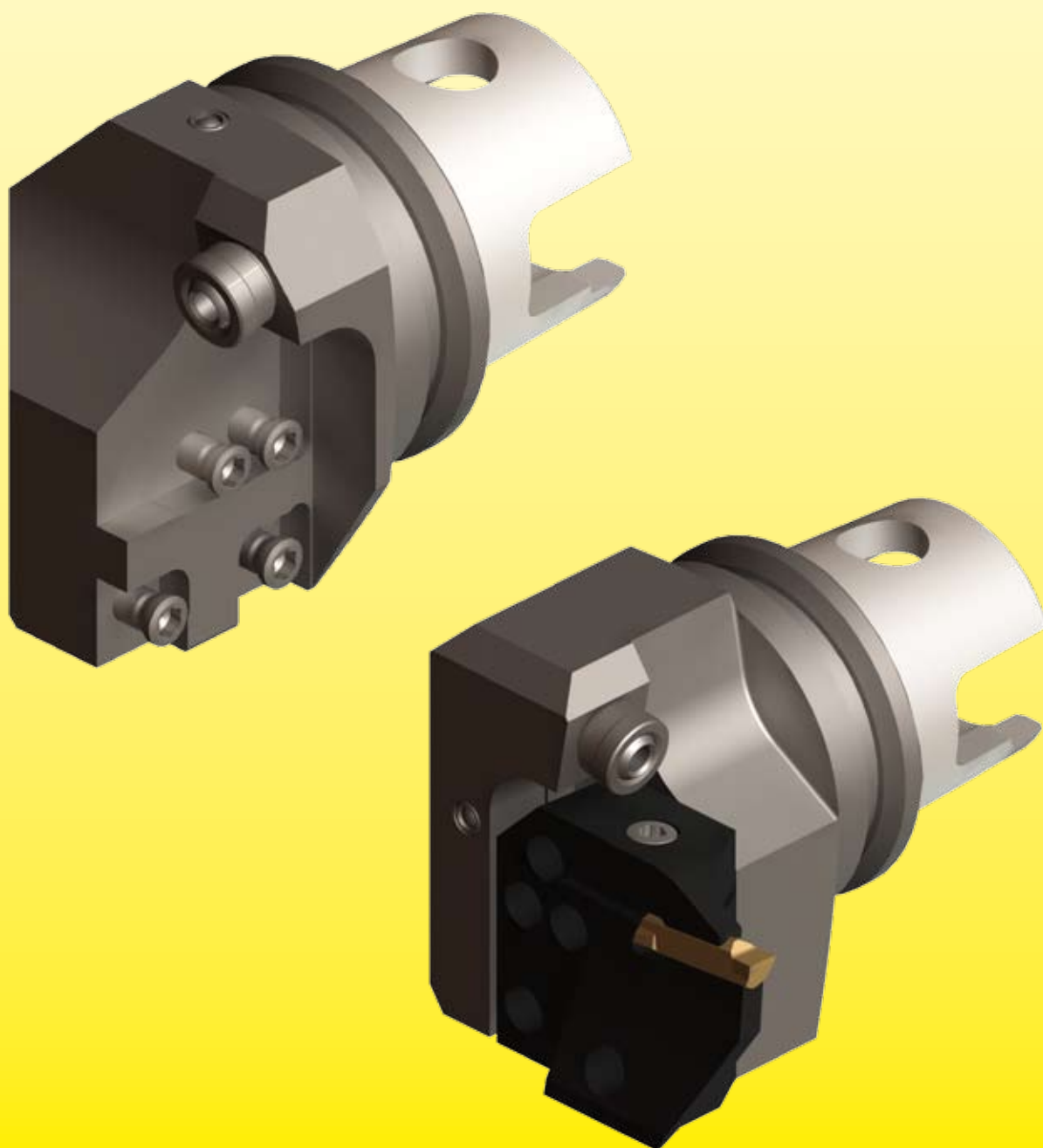
附件  
Spare parts

接头 Adaptor	螺钉 Screw	扳手 Wrench
001.00C...	DIN1835-B M10x12	SW5.0DIN911

M12

## HORN TS刀柄 合ISO26622标准

HORN Toolholder TS according to ISO 26622



# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

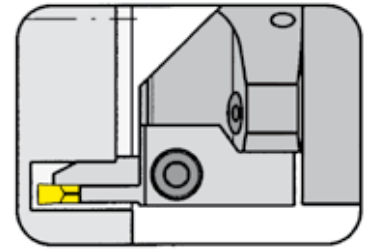


### 常规刀柄 型号

BASIC TOOLHOLDER Type

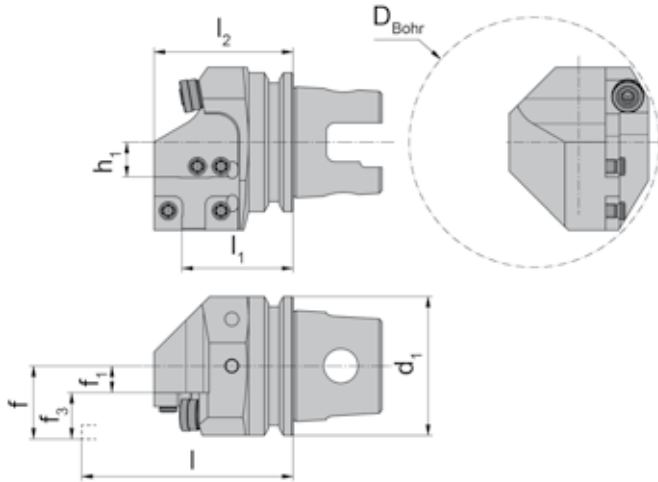
## 220TS

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN刀柄TS  
(DIN 26622 )  
HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
R/L220.TS40.K1			40		4.6		
R/L220.TS50.K1	40	50	50	12.5	9.6	$f_1+f_3$	$l_1+l_k$
R/L220.TS63.K1			63		16.1		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸 $D_{Bohr}$ ,  $f_3$  and  $l_k$ 见刀夹

**Note:**  
Dimensions for  $D_{Bohr}$ ,  $f_3$  and  $l_k$  see cassettes

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L220.TS...	5.12T20P	T20PQ	020.1008.2977

M14

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

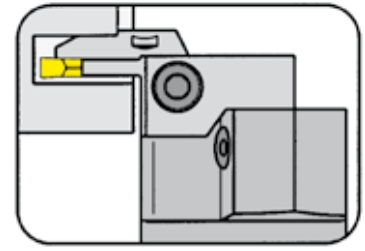


### 常规刀柄 型号

BASIC TOOLHOLDER Type

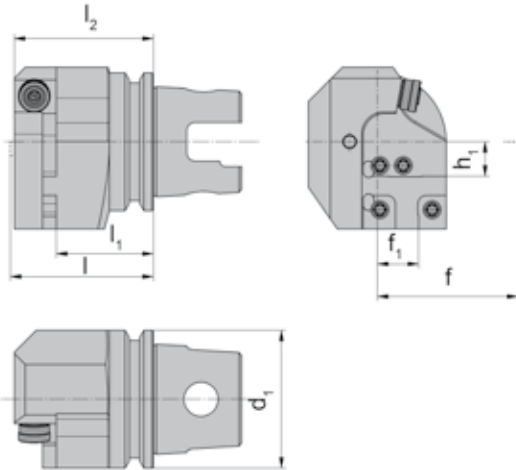
## 220TS

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN刀柄TS  
(DIN 26622 )  
HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
R/L220.TS40.K2			40		10.0		
R/L220.TS50.K2	35.2	50.5	50	12.5	15.0	$f_1+l_k$	$l_1+f_3$
R/L220.TS63.K2			63		21.5		

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $D_{min}$ ,  $f_3$  and  $l_k$  见刀夹

Note:  
Dimensions for  $D_{min}$ ,  $f_3$  and  $l_k$  see cassettes

### 附件 Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L220.TS...	5.12T20P	T20PQ	020.1008.2977

M

# 切槽 ( 外圆 )

## GROOVING (external)

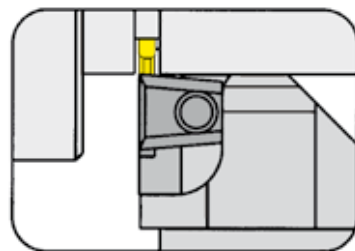


### 刀柄 型号

TOOLHOLDER Type

## 360TS

配合刀夹  
with cassette



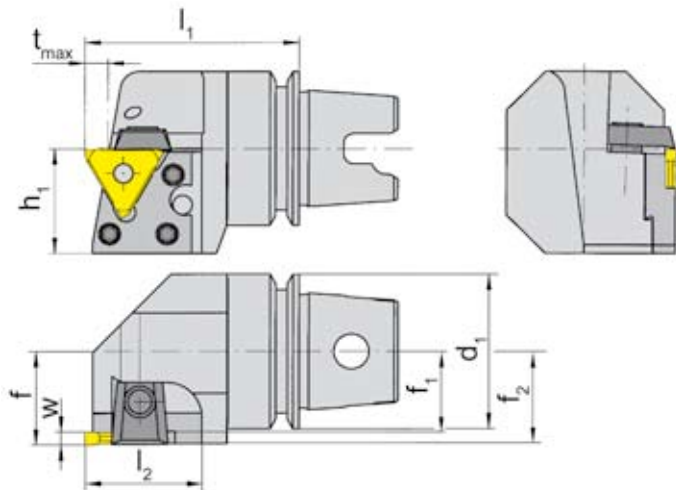
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
0.5 - 2.9 mm

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type

HORN刀柄TS  
(DIN 26622 )

HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$t_{max}$	$f_2$	规格 Size	夹持范围 Clamping range
R/L360.TS40.K1	40		40	27.3	19.0			20.5		
R/L360.TS50.K1	45	31	50	27.3	24.0	$f_1+w-a_1$	4	25.5	01	0.5 - 1.9
R/L360.TS63.K1	50		63	31.5	30.5			32.0		
R/L360.TS40.K2	40		40	27.3	18.0			20.5		
R/L360.TS50.K2	45	31	50	27.3	23.0	$f_1+w-a_1$	6	25.5	02	1.9 - 2.9
R/L360.TS63.K2	50		63	31.5	29.5			32.0		

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀柄 Toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	扳手 Wrench
L360.TS...K1	LK360.00.01	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
L360.TS...K2	LK360.00.02	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.TS...K1	RK360.00.01	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.TS...K2	RK360.00.02	16.4	T15PQ	030.0410.T15P	SW3,0DIN911



# 切槽 ( 外圆 )

## GROOVING (external)

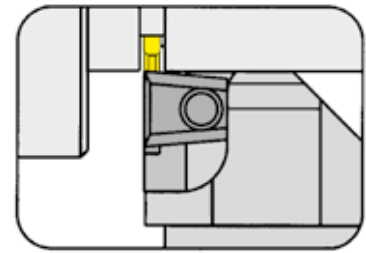


### 刀柄 型号

TOOLHOLDER Type

# 360TS

配合刀夹  
with cassette



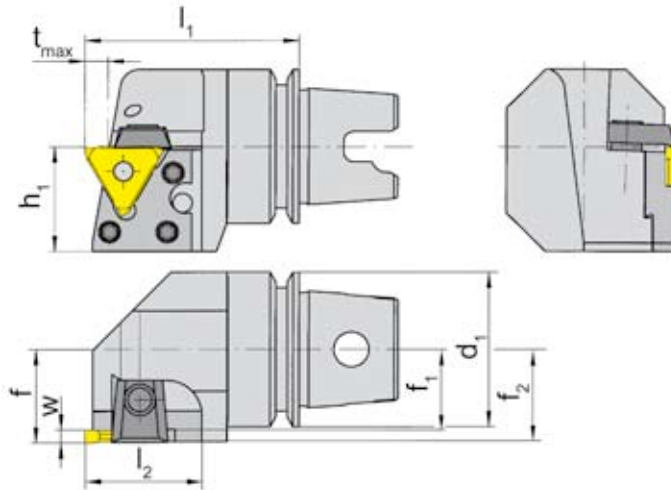
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
2.9 - 6.3 mm

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 312

Type

HORN刀柄TS  
(DIN 26622 )

HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$t_{max}$	$f_2$	规格 Size	夹持范围 Clamping range
R/L360.TS40.K3	40		40	27.3	17.0			20.5		
R/L360.TS50.K3	45	31	50	27.3	22.0	$f_1+w-a_1$	6	25.5	03	2.9 - 3.9
R/L360.TS63.K3	50		63	31.5	28.5			32.0		
R/L360.TS40.K4	40		40	27.3	15.3			20.5		
R/L360.TS50.K4	45	31	50	27.3	20.3	$f_1+w-a_1$	6	25.5	04	3.9 - 6.3
R/L360.TS63.K4	50		63	31.5	26.8			32.0		

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀柄 Toolholder	刀夹 Cassette	压板 Clamp	TORX PLUS® 扳手 TORX PLUS® Wrench	螺钉 Screw	扳手 Wrench
L360.TS...K3	LK360.00.03	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
L360.TS...K4	LK360.00.04	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.TS...K3	RK360.00.03	16.4	T15PQ	030.0410.T15P	SW3,0DIN911
R360.TS...K4	RK360.00.04	16.4	T15PQ	030.0410.T15P	SW3,0DIN911

M

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

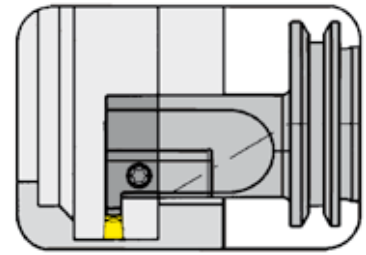


### 常规刀柄 型号

BASIC TOOLHOLDER Type

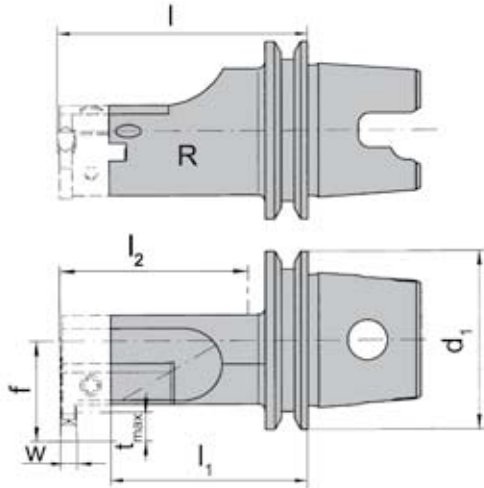
## B224TS

无刀夹  
without cassette



配合BK224型刀夹的常规刀柄  
Basic toolholder for cassettes type BK224

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN刀柄TS  
(DIN 26622)  
HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	d <sub>1</sub>	l	l <sub>1</sub>	l <sub>2</sub>	f
R/LB224.TS40.1.K2 R/LB224.TS40.2.K2	40	l <sub>1</sub> +b <sub>1</sub> +w/2	49.3 69.3	48 68	32
R/LB224.TS50.1.K2 R/LB224.TS50.2.K2	50	l <sub>1</sub> +b <sub>1</sub> +w/2	59.3 79.3	54 74	32
R/LB224.TS63.1.K2 R/LB224.TS63.2.K2	63	l <sub>1</sub> +b <sub>1</sub> +w/2	69.3 89.3	62 82	32

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项:  
尺寸D<sub>min</sub>, t<sub>max</sub>和w见刀夹部分  
Note:  
Dimensions for D<sub>min</sub>, t<sub>max</sub> see cassettes

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.TS...	030.0518.T20P	T20PQ

M18

# 切槽和侧车削 (内圆)

## GROOVING and SIDE TURNING (internal)

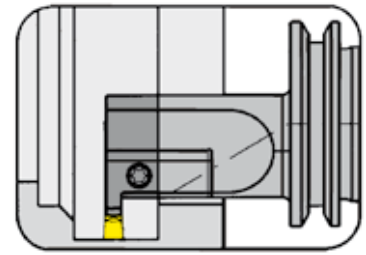


### 常规刀柄 型号

BASIC TOOLHOLDER Type

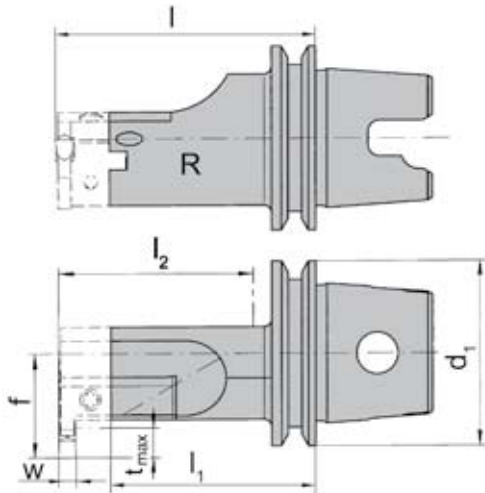
## B229TS

无刀夹  
without cassette



配合BK229型刀夹的常规刀柄  
Basic toolholder for cassettes type BK229

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN刀柄TS  
(DIN 26622)

HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	d <sub>1</sub>	l	l <sub>1</sub>	l <sub>2</sub>	f
R/LB229.TS40.1.K2 R/LB229.TS40.2.K2	40	l <sub>1</sub> +b <sub>1</sub> +w/2	48.5 68.5	48 68	35.5
R/LB229.TS50.1.K2 R/LB229.TS50.2.K2	50	l <sub>1</sub> +b <sub>1</sub> +w/2	58.5 78.5	54 74	35.5
R/LB229.TS63.1.K2 R/LB229.TS63.2.K2	63	l <sub>1</sub> +b <sub>1</sub> +w/2	68.5 88.5	62 82	35.5

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

#### 注意事项:

尺寸D<sub>min</sub>, t<sub>max</sub>和w见刀夹部分

Note:  
Dimensions for D<sub>min</sub>, t<sub>max</sub> see cassettes

#### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB229.TS...	030.0518.T20P	T20PQ

M

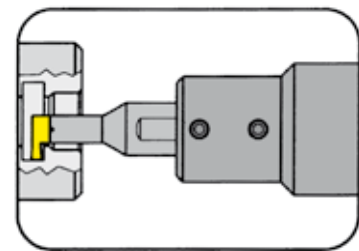
# 切槽 ( 内圆 )

## GROOVING (internal)



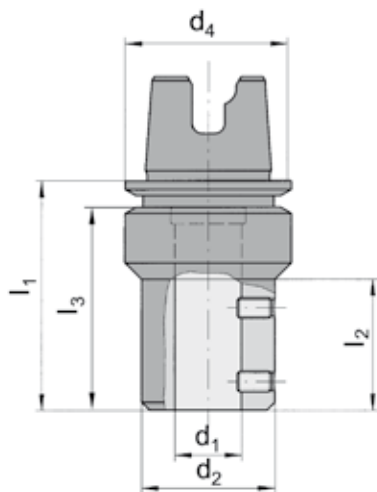
接头 型号  
ADAPTOR Type

# 001TS



配合Ø16/20mm镗杆的圆刀柄  
Cylindrical adaptor for boring bars Ø 16 / 20 mm

用于带标准夹持面的圆刀柄  
for cylindrical shanks with standard clamping flat



HORN刀柄TS  
(DIN 26622 )  
HORN Toolholder TS  
according to DIN 26622

产品型号 Part number	$l_1$	$l_2$	$l_3$	$d_2$	$d_1$	$d_4$
001.TS40.16	65	-	55	40	16	40
001.TS40.20	70	-	58	40	20	40
001.TS50.16	65	44	55	40	16	50
001.TS50.20	70	49	55	40	20	50
001.TS63.16	65	40	55	40	16	63
001.TS63.20	70	45	58	40	20	63

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

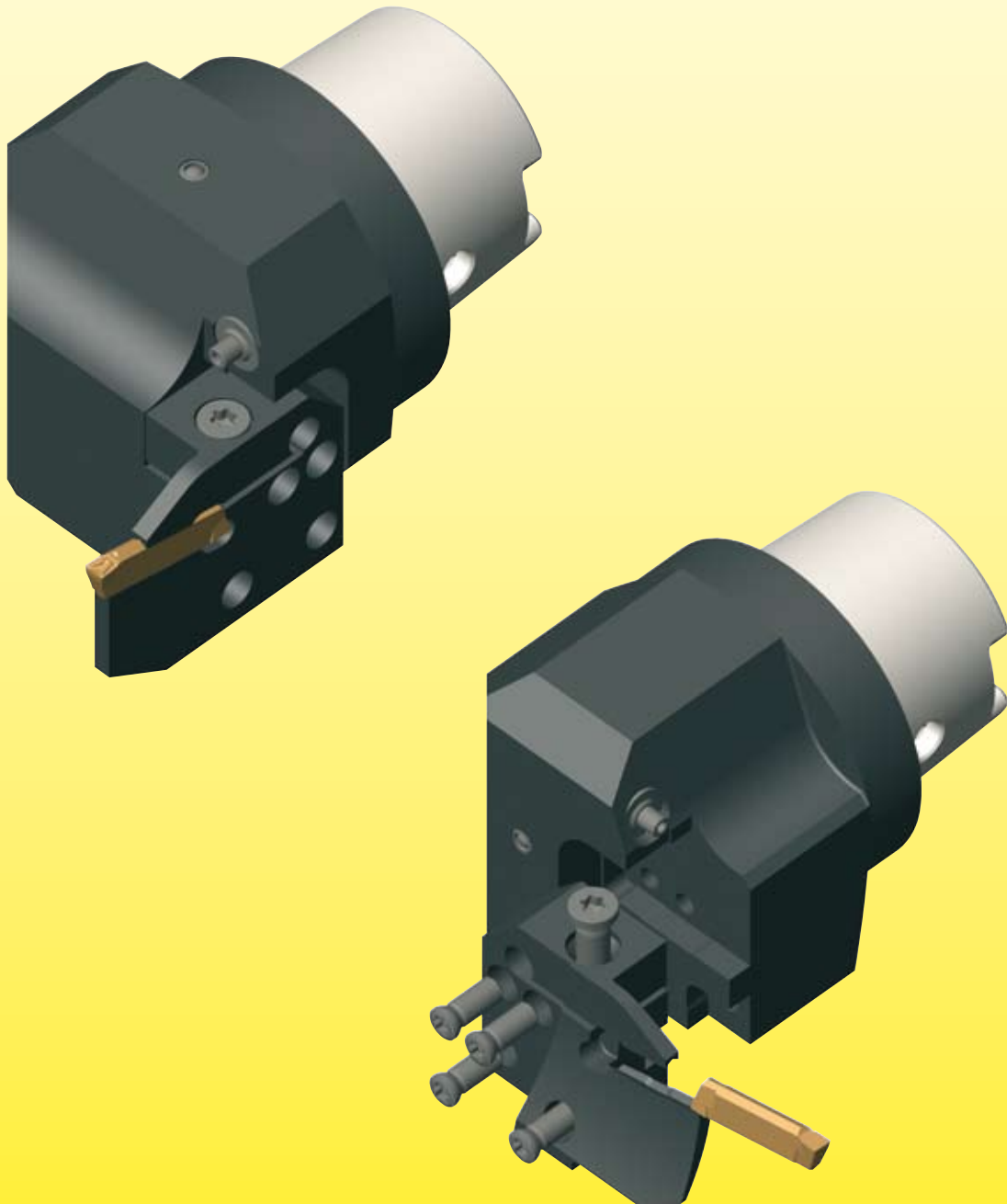
M

附件  
Spare parts

接头 Adaptor	螺钉 Screw	扳手 Wrench
001.TS...	DIN1835-B M10x12	SW5.0DIN911

M20

## HORN HSK-C63 DIN 69893



# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

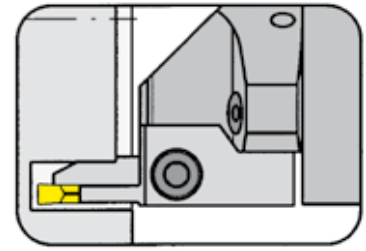


### 常规刀柄 型号

BASIC TOOLHOLDER Type

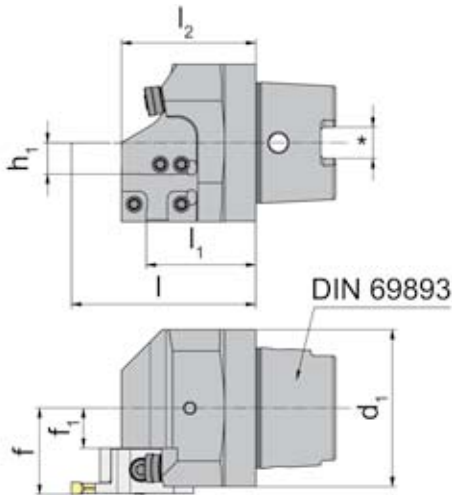
## HSK-220

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

用于手动换刀，带内冷  
for manual tool change, with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN HSK-C63  
DIN69893  
HORN HSK-C63 DIN 69893

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
<b>HSK-R/L220.0063.K1</b>	44	54	63	12.5	16.1	$f_1+f_3$	$l_1+l_k$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸及型号(例如:HSK-B50)  
Further sizes and versions (e.g. HSK-B50) upon request

#### 注意事项：

尺寸： $D_{min}$ ,  $f_3$  and  $l_k$  见刀夹

**Note:**  
Dimensions for  $D_{min}$ ,  $f_3$  and  $l_k$  see cassettes

\*键槽公差 Slot=12.38±0.01/Key=12.34±0.01

\* controlled keyway-tolerance

Slot=12,38 ± 0.01 / Key=12,34 ± 0.01

M

#### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
HSK-R/L220.0063.K1	<b>5.12T20P</b>	<b>T20PQ</b>	<b>020.1008.2977</b>

M22

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

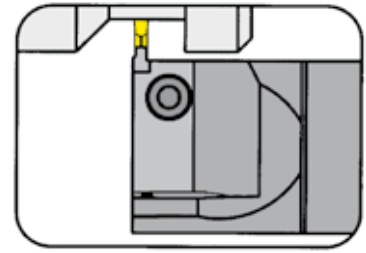


### 常规刀柄 型号

BASIC TOOLHOLDER Type

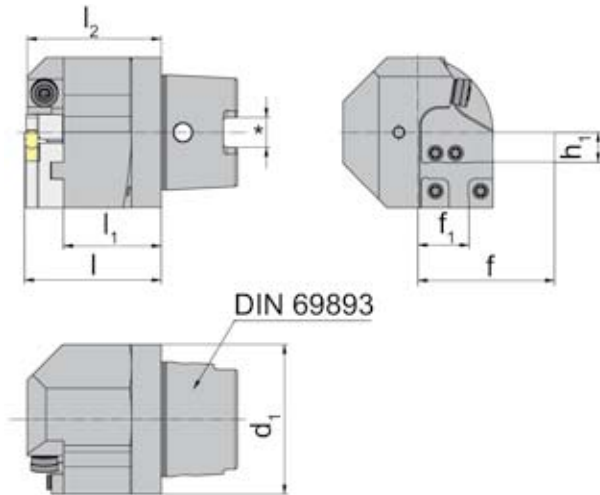
## HSK-220

无刀夹  
without cassette



配合100/220/224/360系列刀夹的常规刀柄  
Basic toolholder for cassettes type 100/220/224/356/360

用于手动换刀，带内冷  
for manual tool change, with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN HSK-C63  
DIN69893  
HORN HSK-C63 DIN 69893

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
<b>HSK-R/L220.0063.K2</b>	41.2	56.5	63	12.5	21.5	$f_1+l_k$	$l_1+f_3$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸及型号(例如:HSK-B50)  
Further sizes and versions (e.g. HSK-B50) upon request

#### 注意事项：

尺寸： $D_{min}$ ,  $f_3$  and  $l_k$  见刀夹

#### Note:

Dimensions for  $D_{min}$ ,  $f_3$  and  $l_k$  see cassettes

\*键槽公差 Slot=12.38±0.01/Key=12.34±0.01

\* controlled keyway-tolerance

Slot=12,38 ± 0.01 / Key=12,34 ± 0.01

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
HSK-R/L220.0063.K2	<b>5.12T20P</b>	<b>T20PQ</b>	<b>020.1008.2977</b>

M

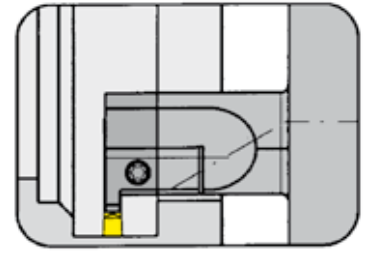
# 切槽 (内圆)

## GROOVING (internal)



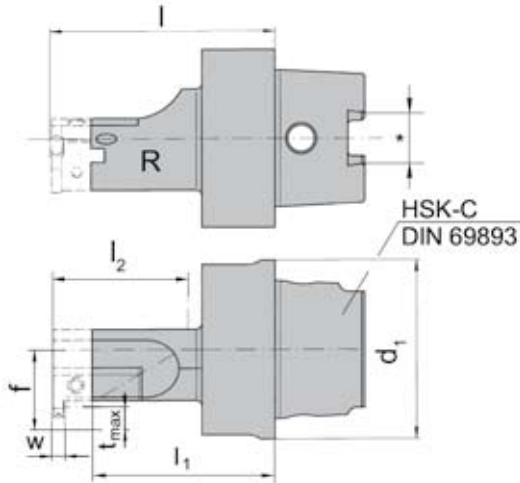
常规刀柄 型号  
BASIC TOOLHOLDER Type

**HSK224**  
无刀夹  
without cassette



配合BK224型刀夹的常规刀柄  
Basic toolholder for cassettes type BK224

用于手动换刀，带内冷  
for manual tool change, with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN HSK-C63  
DIN69893  
HORN HSK-C63 DIN 69893

产品型号 Part number	d <sub>1</sub>	l	l <sub>1</sub>	l <sub>2</sub>	f
HSKR/L224.0063.1.K2	63	l <sub>1</sub> +b <sub>1</sub> +w/2	70.3	58	32
HSKR/L224.0063.2.K2			90.3	78	

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸及型号(例如:HSK-B50)  
Further sizes and versions (e.g. HSK-B50) upon request

注意事项：  
尺寸D<sub>min</sub>, t<sub>max</sub>和w见刀夹部分

**Note:**  
Dimensions for D<sub>min</sub>, t<sub>max</sub> see cassettes

\*键槽公差Slot=12.38±0.01/Key=12.34±0.01  
\* controlled keyway-tolerance  
Slot=12,38 ± 0.01 / Key=12,34 ± 0.01

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
HSKR/L224.0063....	030.0518.T20P	T20PQ

M24



# 切槽 (内圆)

## GROOVING (internal)

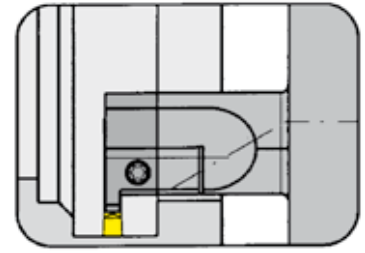


### 常规刀柄 型号

BASIC TOOLHOLDER Type

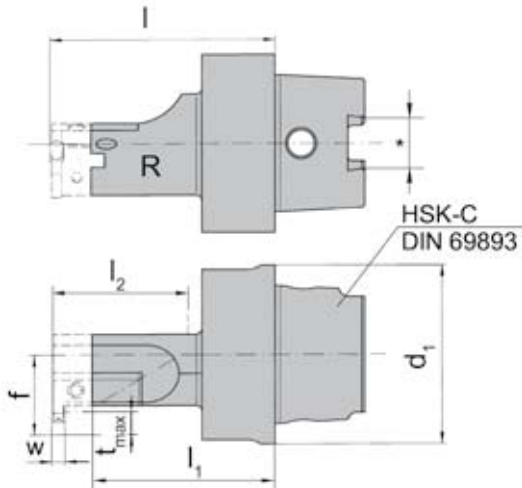
## HSK229

无刀夹  
without cassette



配合BK229型刀夹的常规刀柄  
Basic toolholder for cassettes type BK229

用于手动换刀，带内冷  
for manual tool change, with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

HORN HSK-C63  
DIN69893  
HORN HSK-C63 DIN 69893

产品型号 Part number	$d_1$	$l$	$l_1$	$l_2$	$f$
HSKR/L229.0063.1.K2	63	$l_1 + b_1 + w/2$	70.3	58	35.5
HSKR/L229.0063.2.K2			90.3	78	

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸及型号(例如:HSK-B50)  
Further sizes and versions (e.g. HSK-B50) upon request

#### 注意事项：

尺寸 $D_{min}$ 、 $t_{max}$ 和 $w$ 见刀夹部分

**Note:**  
Dimensions for  $D_{min}$ ,  $t_{max}$  see cassettes

\*键槽公差Slot=12.38±0.01/Key=12.34±0.01  
\* controlled keyway-tolerance  
Slot=12,38 ± 0.01 / Key=12,34 ± 0.01

#### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
HSKR/L229.0063....	030.0518.T20P	T20PQ

M

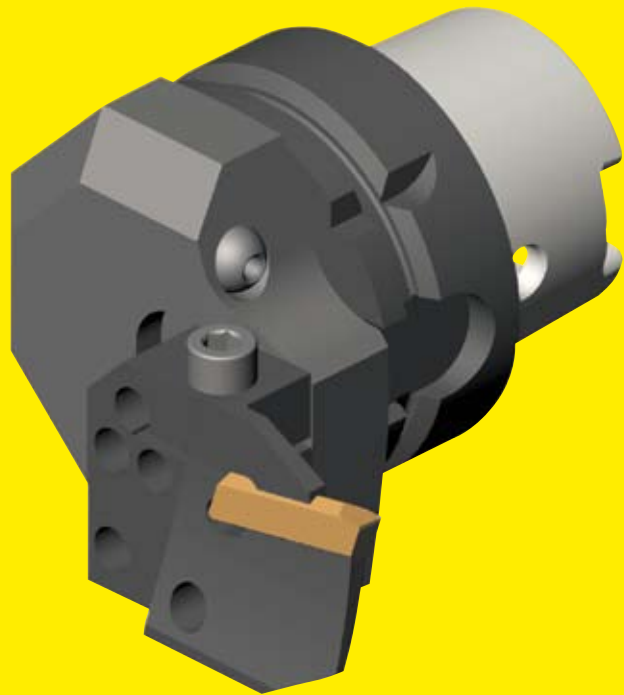
## HORN HSK-C63 DIN 69893

### 库存产品

- 无换刀卡槽
- 低公差槽

### Stock item

- **without** tool changing groove
- with reduced groove tolerance



## HORN HSKT....

- 低公差槽

由于换刀卡槽的原因，此刀具相对于“C”型刀具长度可更长

- with reduced groove tolerance

The tool length will be increased compared to type "C" due to the tool changing groove.

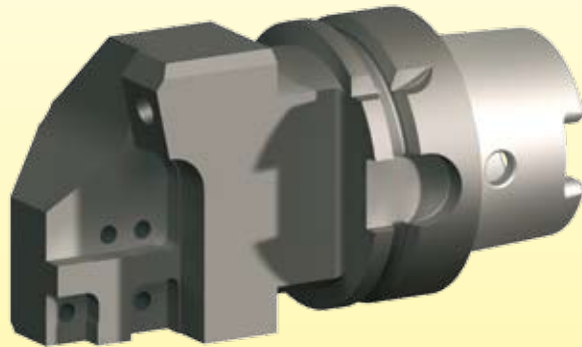
M

## HORN HSKT 根据 DIN 12164 HORN HSKT according DIN 12164

### 常规刀柄 HSKT..220

用于外圆加工

Basic toolholder HSKT...220  
for external machining



220系列刀夹  
Pocket seat system 220



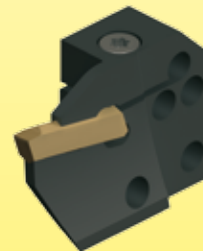
RNK360...



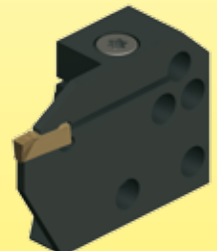
RNK356...



RAK224...



RAK220...



RNK100...

### 常规刀柄 HSKT...224 / ...229

用于内圆加工

Basic toolholder HSKT...224 / ...229  
for internal machining



RBK229...



### B224/B229刀夹系列

用于镗刀柄

Pocket seat system B224 / B229  
for boring bars

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

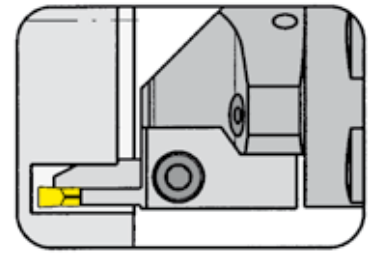


### 常规刀柄 型号

BASIC TOOLHOLDER Type

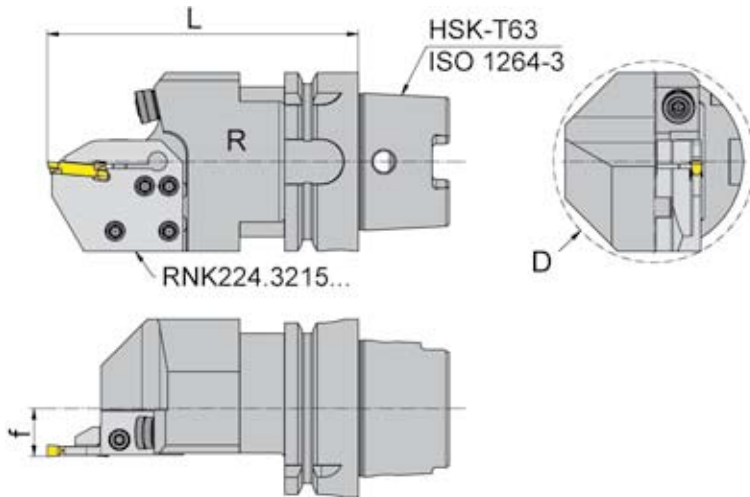
## HSKT63

无刀夹  
without cassette



用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

220系列刀座

Pocket seat system 220

产品型号 Part number	刀夹 Cassette	...NK224...			...NK220...			...NK356...			...NK360...		
		L	D	f	L	D	f	L	D	f	L	D	f
HSKT63.L220.110.K1	L	110			117			110			100		
HSKT63.L220.120.K1		120			127			120			110		
HSKT63.L220.130.K1		130	71.2	17	137	71.2	17	130	71.5	16.9	120	74.7	19.8
HSKT63.L220.150.K1		150			157			150			140		
HSKT63.L220.175.K1		175			182			175			165		
HSKT63.R220.110.K1	R	110			117			110			100		
HSKT63.R220.120.K1		120			127			120			110		
HSKT63.R220.130.K1		130	71.2	17	137	71.2	17	130	71.5	16.9	120	74.7	19.8
HSKT63.R220.150.K1		150			157			150			140		
HSKT63.R220.175.K1		175			182			157			165		
配合可转位刀片/for Indexable Insert		S224			S229			315			312		

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

M

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT63.R/L220.1...	5.12T20P	T20PQ	020.1008.2977	HSK63KMZ

M28

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

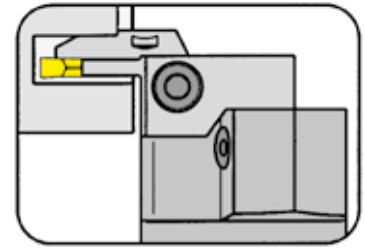


### 常规刀柄 型号

BASIC TOOLHOLDER Type

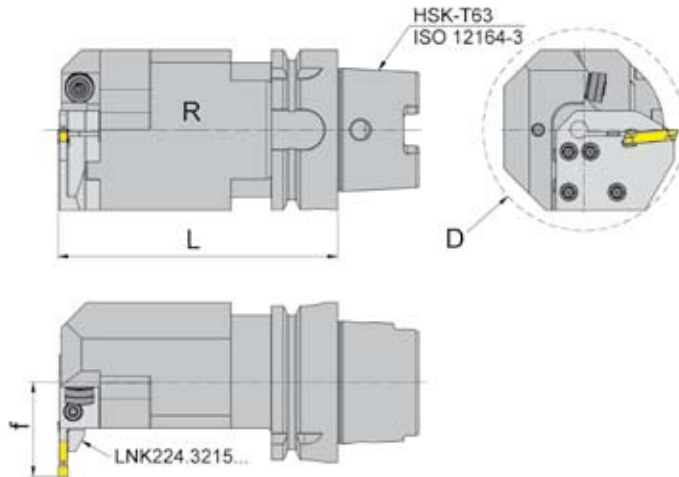
## HSKT63

无刀夹  
without cassette



用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

220系列刀座  
Pocket seat system 220

产品型号 Part number	刀夹 Cassette	...AK224...			...AK220...			...NK356...			...NK360...		
		L	D	f	L	D	f	L	D	f	L	D	f
HSKT63.L220.110.K2	R	110			110			109.9			112.8		
HSKT63.L220.130.K2		130	79.5	37	130	88.1	44	129.9	74	37	132.8	79.2	27
HSKT63.L220.150.K2		150			150			149.9			152.8		
HSKT63.L220.175.K2		175			175			174.9			177.8		
HSKT63.R220.110.K2	L	110			110			109.9			112.8		
HSKT63.R220.130.K2		130	79.5	37	130	88.1	44	129.9	74	37	132.8	79.2	27
HSKT63.R220.150.K2		150			150			149.9			152.8		
HSKT63.R220.175.K2		175			175			174.9			177.8		
配合可转位刀片/for Indexable Insert		S224			S229			315			312		

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT63.R/L220.1...	5.12T20P	T20PQ	020.1008.2977	HSK63KMZ

M

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

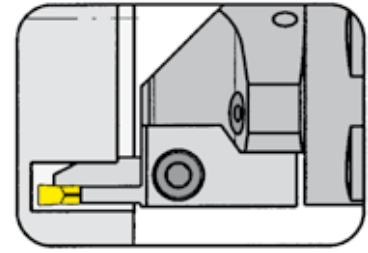


### 常规刀柄 型号

BASIC TOOLHOLDER Type

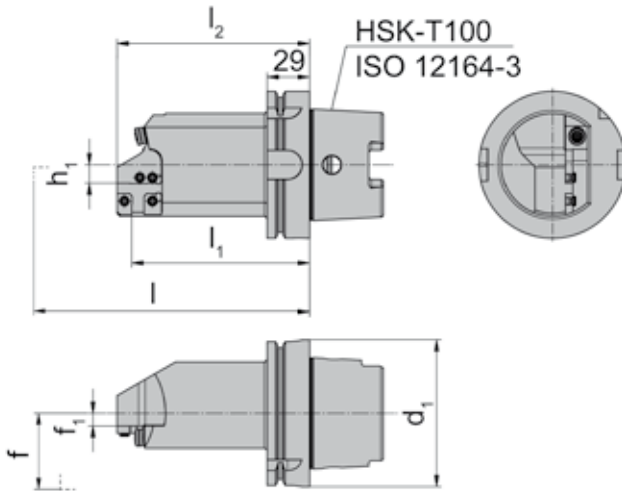
## HSKT100

无刀夹  
without cassette



用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

220系列刀座  
Pocket seat system 220

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
HSKT100.L220.150.K1 HSKT100.R220.150.K1	121	131	100	12.5	8.6	$f_1+f_3$	$l_1+l_k$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $f_3$ 和 $l_k$ 见刀夹

Note:  
Dimensions for  $f_3$  and  $l_k$  see cassettes

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT100.R/L220.150.K1	5.12T20P	T20PQ	020.1008.2977	HSK100KMZ

M30

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

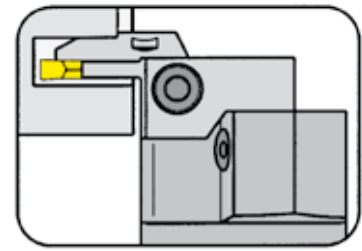


### 常规刀柄 型号

BASIC TOOLHOLDER Type

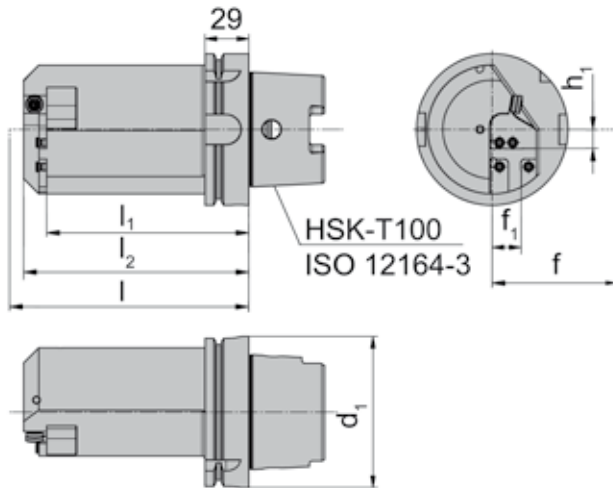
## HSKT100

无刀夹  
without cassette



用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply



型号 NS224  
Type S224

220系列刀座

Pocket seat system 220

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$l_1$	$l_2$	$d_1$	$h_1$	$f_1$	$f$	$l$
HSKT100.L220.150.K2 HSKT100.R220.150.K2	133.6	148.8	100	12.5	19	$f_1+l_k$	$l_1+f_3$

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

注意事项：  
尺寸： $f_3$ 和 $l_k$ 见刀夹

Note:  
Dimensions for  $f_3$  and  $l_k$  see cassettes

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT100.R/L220.150.K2	5.12T20P	T20PQ	020.1008.2977	HSK100KMZ

M

# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

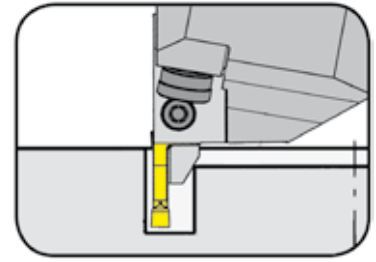


### 常规刀柄 型号

BASIC TOOLHOLDER Type

## HSKT63

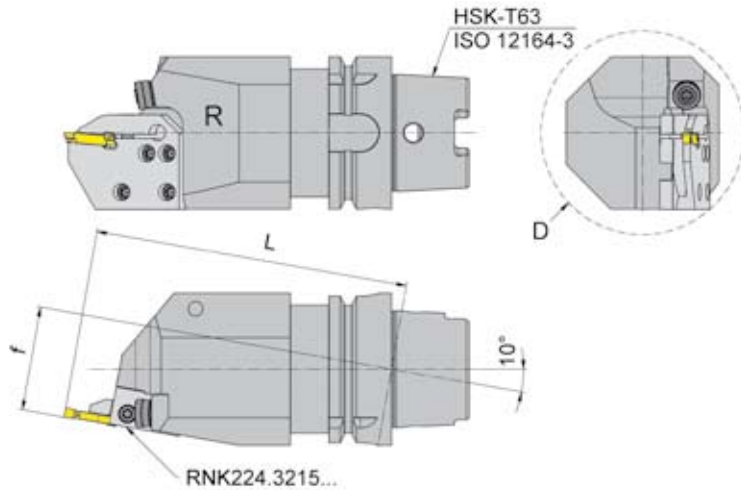
无刀夹  
without cassette



用于有10°刀具安装倾斜角度的多任务机床  
for using on multi-tasking machines with 10° orientation to spindle

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

220系列刀座

Pocket seat system 220

产品型号 Part number	刀夹 Cassette	...NK224...			...NK220...			...NK356...			...NK360...		
		L	D	f	L	D	f	L	D	f	L	D	f
HSKT63.L220.110.K3	L	110			117			110			100		
HSKT63.L220.120.K3		120			127			120			110		
HSKT63.L220.130.K3		130	83.8	39.7	137	84.1	33.7	130	84.4	39.6	120	88.7	42.5
HSKT63.L220.150.K3		150			157			150			140		
HSKT63.L220.175.K3		175			182			175			165		
HSKT63.R220.110.K3	R	110			117			110			100		
HSKT63.R220.120.K3		120			127			120			110		
HSKT63.R220.130.K3		130	83.8	39.7	137	84.1	33.7	130	84.4	39.6	120	88.7	42.5
HSKT63.R220.150.K3		150			157			150			140		
HSKT63.R220.175.K3		175			182			157			165		
配合可转位刀片/for Indexable Insert		S224			S229			315			312		

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

M

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT63.R/L220.1...	5.12T20P	T20PQ	020.1008.2977	HSK63KMZ

M32



# 切槽，切断，端面切槽

## GROOVING, PARTING OFF, FACE GROOVING

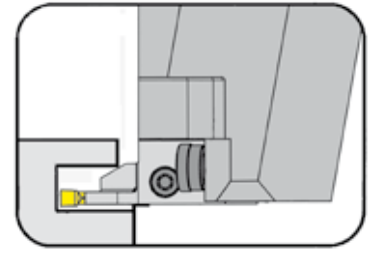


### 常规刀柄 型号

BASIC TOOLHOLDER Type

## HSKT63

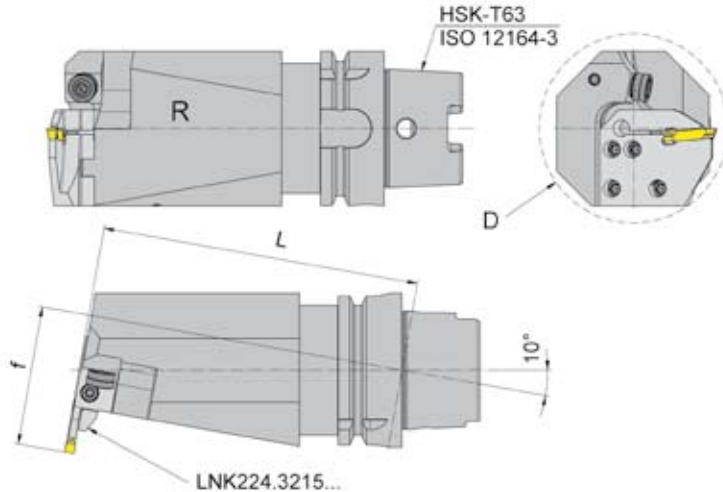
无刀夹  
without cassette



用于有10°刀具安装倾斜角度的多任务机床  
for using on multi-tasking machines with 10° orientation to spindle

带内冷

with through coolant supply



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

220系列刀座

Pocket seat system 220

产品型号 Part number	刀夹 Cassette	...AK224...			...AK220...			...NK356...			...NK360...		
		L	D	f	L	D	f	L	D	f	L	D	f
HSKT63.L220.110.K4	R	110			110			109.9			112.8		
HSKT63.L220.130.K4		130	75.8	53.2	130	83.7	60.2	129.9	72	33.2	132.8	76.5	43.2
HSKT63.L220.150.K4		150			150			149.9			152.8		
HSKT63.L220.175.K4		175			175			174.9			177.8		
HSKT63.R220.110.K4	L	110			110			109.9			112.8		
HSKT63.R220.130.K4		130	75.8	53.2	130	83.7	60.2	129.9	72	33.2	132.8	76.5	43.2
HSKT63.R220.150.K4		150			150			149.9			152.8		
HSKT63.R220.175.K4		175			175			174.9			177.8		
配合可转位刀片/for Indexable Insert		S224			S229			315			312		

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

### 附件

Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT63.R/L220.1...	5.12T20P	T20PQ	020.1008.2977	HSK63KMZ

M

# 切槽 (内圆)

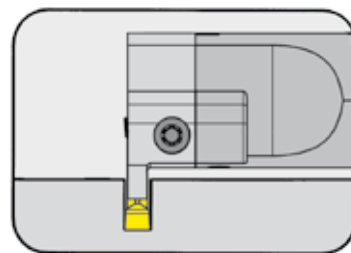
## GROOVING (internal)



常规刀柄 型号  
BASIC TOOLHOLDER Type

# HSKT63

无刀夹  
without cassette

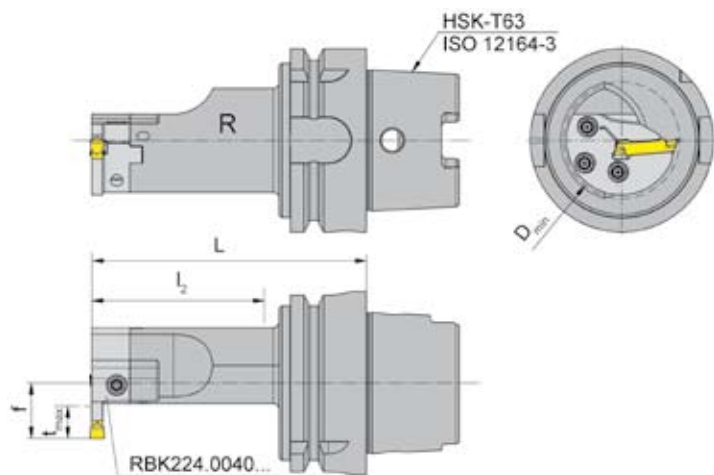


用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply

配合可转位刀片  
for use with Indexable insert

型号 S224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

224系列刀座  
Pocket seat system 224

产品型号 Part number	刀夹 Cassette	L	$l_2$	f	$D_{min}$	$t_{max}$
HSKT63.LB224.095.K2	LBK224	95	60	19	39	11
HSKT63.LB224.115.K2		115	80			
HSKT63.RB224.095.K2	RBK224	95	60	19	39	11
HSKT63.RB224.115.K2		115	80			
配合可转位刀片/for Indexable Insert		S224				

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却管 Coolant tube
HSKT63.R/LB224....	030.0518.T20P	T20PQ	HSK63KMZ

M34

# 切槽 (内圆)

## GROOVING (internal)

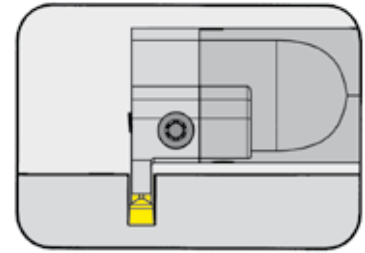


### 常规刀柄 型号

BASIC TOOLHOLDER Type

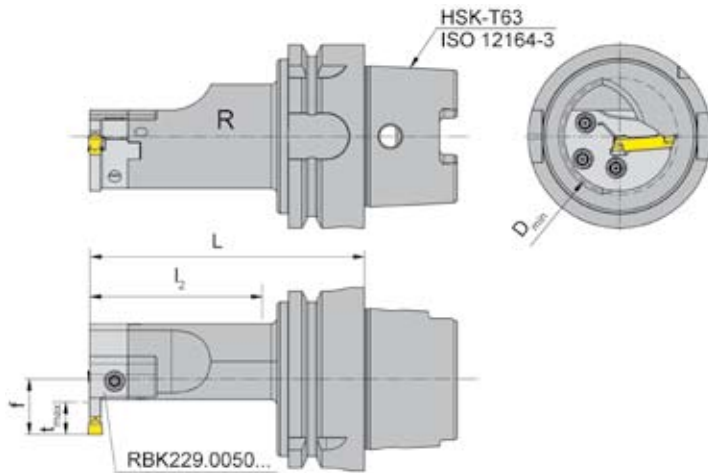
## HSKT63

无刀夹  
without cassette



用于多任务机床  
for using on multi-tasking machines

带内冷  
with through coolant supply



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

229系列刀座  
Pocket seat system 229

产品型号 Part number	刀夹 Cassette	L	D <sub>min</sub>	t <sub>max</sub>	l <sub>2</sub>	f	D <sub>min</sub>	t <sub>max</sub>
HSKT63.LB229.095.K2 HSKT63.LB229.115.K2	LBK229	95 115	60	15	60 80	24.2	50	12
HSKT63.RB229.095.K2 HSKT63.RB229.115.K2	RBK229	95 115	60	15	60 80	24.2	50	12
配合可转位刀片/for Indexable Insert					S229			

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

### 附件 Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却管 Coolant tube
HSKT63.R/LB229....	030.0518.T20P	T20PQ	HSK63KMZ

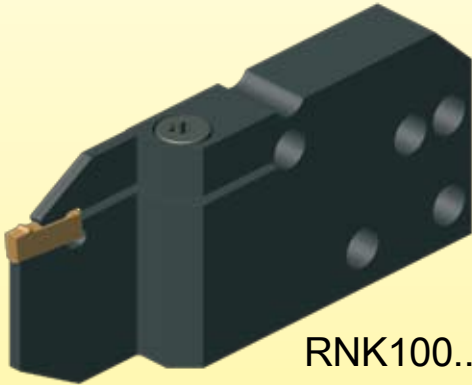
M

刀夹 型号 RNK 和 LNK

- 外圆 -

Cassettes type RNK and LNK

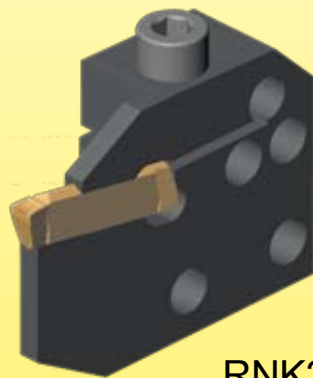
- external -



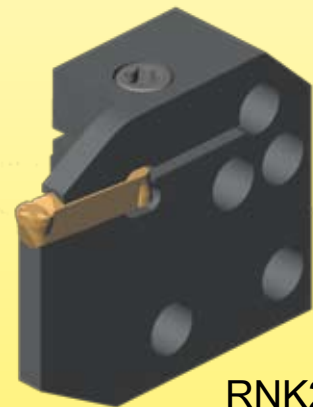
RNK100...



RNK360...



RNK220...



RNK224...

刀夹 型号 RBK 和 LBK

- 内圆 -

Cassettes type RBK and LBK

- internal -



RBK229...



RBK224...

# 切槽和切断 ( 外圆 )

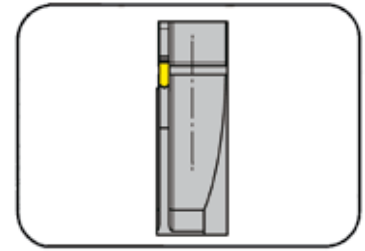
GROOVING and PARTING OFF (external)



刀夹 型号

CASSETTE Type

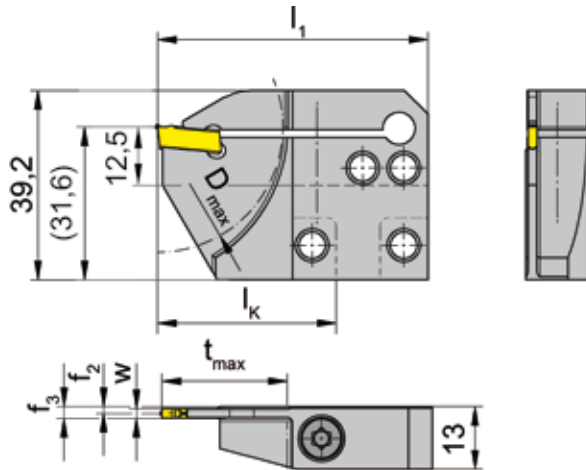
## NK100



槽深可达  
槽宽

Depth of groove up to  
Width of groove

26.0 mm  
2.5 - 3.0 mm



配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

产品型号 Part number	$l_1$	$t_{max}$	w	$D_{max}$	$f_2$	$f_3$	$l_k$
<b>RNK100.5625.02L</b>	56	26	2.5	52	1.40	$f_2+w/2$	37
<b>RNK100.7025.02L</b>	70						51
<b>RNK100.5625.03L</b>	56	26	3.0	52	1.65	$f_2+w/2$	37
<b>RNK100.7025.03L</b>	70						51

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

w见刀片  
w see inserts

尺寸单位 : mm  
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RNK100....	<b>5.13T20P</b>	<b>T20PQ</b>

M

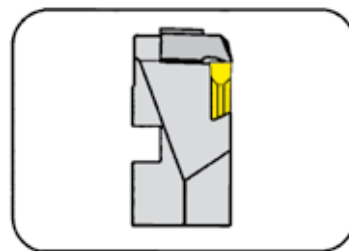
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK360



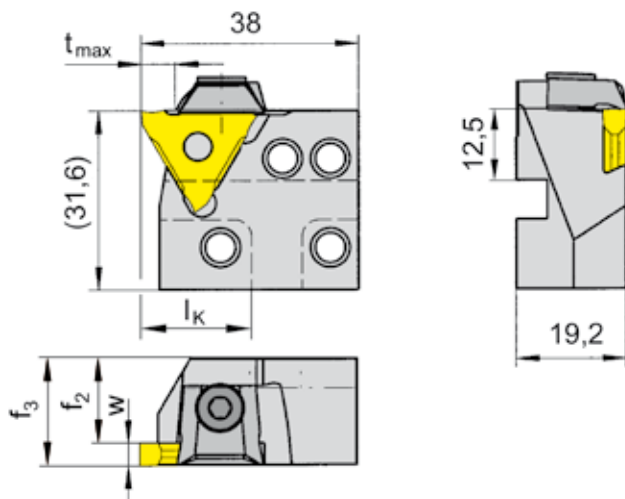
槽深可达  
夹持范围

Depth of groove up to  
Clamping range

6.0 mm  
0.5 - 6.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	t <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	l <sub>K</sub>	夹持范围 Clamping range
R/LNK360.0220.01	4	17.7	f <sub>2</sub> +w-a <sub>1</sub>	19	0.5 - 1.9
R/LNK360.0220.02	6	16.7	f <sub>2</sub> +w-a <sub>1</sub>	19	1.9 - 2.9
R/LNK360.0220.03	6	15.7	f <sub>2</sub> +w-a <sub>1</sub>	19	2.9 - 3.9
R/LNK360.0220.04	6	14.0	f <sub>2</sub> +w-a <sub>1</sub>	19	3.9 - 6.3

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

只有当工件直径 $\varnothing \leq 40$ mm时才能达到t<sub>max</sub>  
t<sub>max</sub> can be reached only with workpiece  $\varnothing \leq 40$  mm

### 订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

M

### 附件

Spare parts

刀夹 Cassette	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK360.0220.0...	14.4	5.32.3T15P	T15PQ

M38

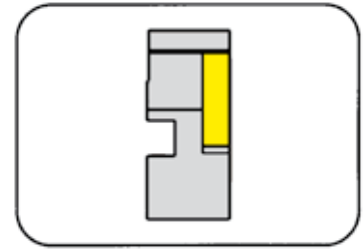
# 切槽 ( 外圆 )

## GROOVING (external)



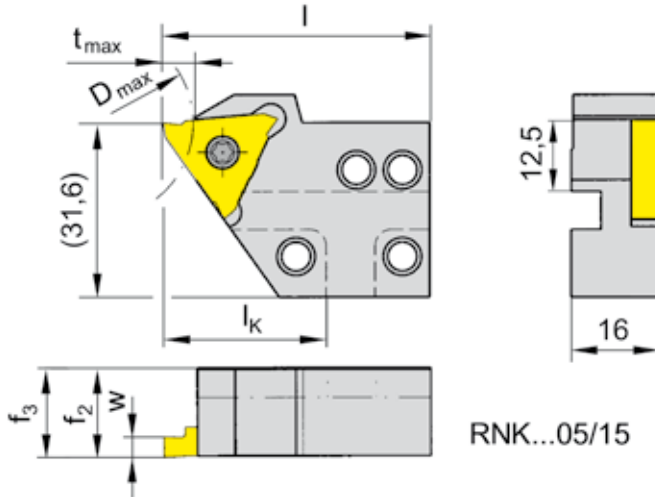
刀夹 型号  
CASSETTE Type

# NK356



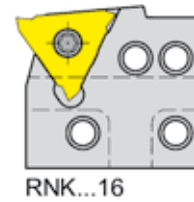
槽深可达 6.0 mm  
夹持范围 1.1 - 6.6 mm

Depth of groove up to 6.0 mm  
Clamping range 1.1 - 6.6 mm



配合 可转位刀片  
for use with Indexable insert

型号 315  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	l	l <sub>k</sub>	夹持范围 Clamping range
R/LNK356.0220.05	6	-	16.3	f <sub>3</sub> =f <sub>2</sub>	48	29	1.1 - 5.4
R/LNK356.0220.15							
R/LNK356.1220.16	5	35	16.3	f <sub>3</sub> =f <sub>2</sub>	38	19	1.1 - 6.6

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK356....	5.12T20P	T20PQ

M

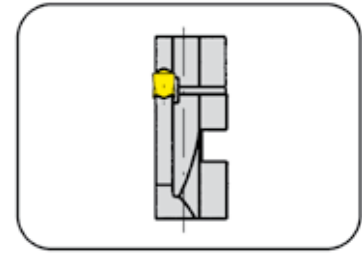
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

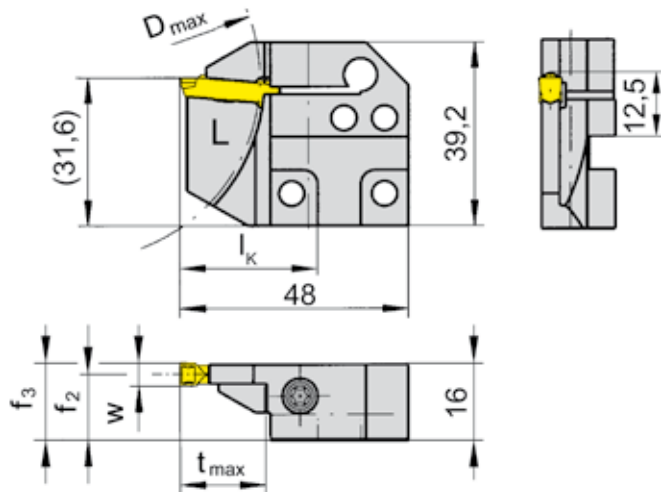
# NK224



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.0 - 6.0 mm



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

产品型号 Part number	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	l <sub>k</sub>	夹持范围 Clamping range
R/LNK224.3215.01	18	80	15.40	f <sub>2</sub> +w/2	29	2.0 - 2.4
R/LNK224.3215.02	18	80	15.15	f <sub>2</sub> +w/2	29	2.4 - 2.8
R/LNK224.3215.03	18	80	14.90	f <sub>2</sub> +w/2	29	2.8 - 3.7
R/LNK224.3215.04	18	80	14.40	f <sub>2</sub> +w/2	29	3.7 - 4.4
R/LNK224.3215.05	18	80	13.90	f <sub>2</sub> +w/2	29	4.4 - 5.1
R/LNK224.3215.06	18	80	13.40	f <sub>2</sub> +w/2	29	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK224.3215.0...	5.13T20P	T20PQ

M40



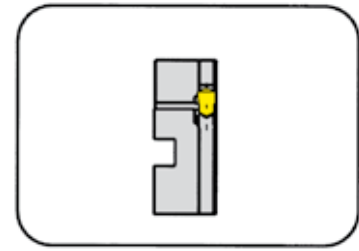
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK220

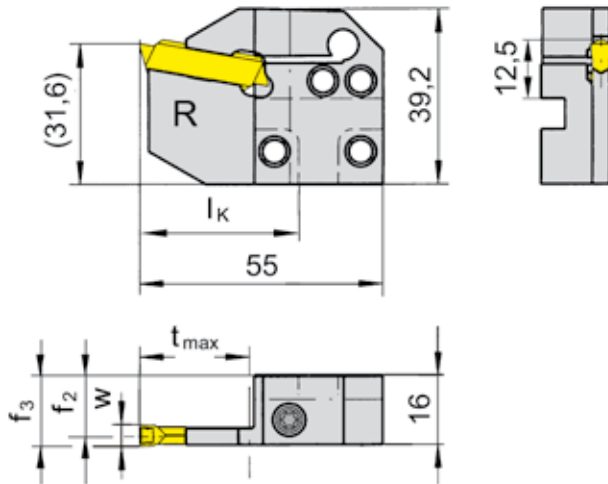


槽深可达  
夹持范围

Depth of groove up to 25.0 mm  
Clamping range 3.00 - 6.09 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$t_{max}$	$f_2$	$f_3$	$l_K$	夹持范围 Clamping range
R/LNK220.3215.03	25	14.9	$f_2+w/2$	36	3.0 - 3.8
R/LNK220.3215.04	25	14.4	$f_2+w/2$	36	3.8 - 4.4
R/LNK220.3215.05	25	13.9	$f_2+w/2$	36	4.4 - 5.09
R/LNK220.3215.06	25	13.4	$f_2+w/2$	36	5.1 - 6.09

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知:

锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK220.3215.0...	6.23T25P	T25PQ

M

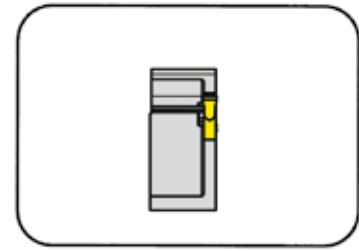
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK220

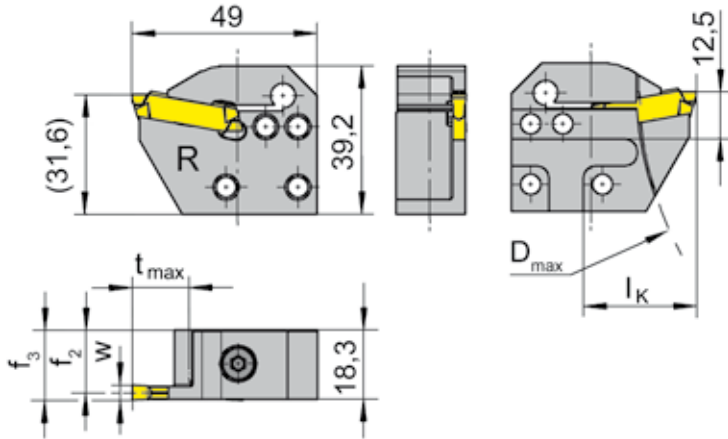


槽深可达 15.0 mm  
夹持范围 3.00 - 6.09 mm

Depth of groove up to 15.0 mm  
Clamping range 3.00 - 6.09 mm

配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	l <sub>k</sub>	夹持范围 Clamping range
R/LNK220.3218.13	15	180	17.10	f <sub>2</sub> +w/2	30	3.0 - 3.8
R/LNK220.3218.14	15	180	16.60	f <sub>2</sub> +w/2	30	3.8 - 4.4
R/LNK220.3218.15	15	180	16.10	f <sub>2</sub> +w/2	30	4.4 - 5.09
R/LNK220.3218.16	15	180	15.65	f <sub>2</sub> +w/2	30	5.1 - 6.09

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK220.3218.1...	6.23T25P	T25PQ

M42

# 切槽和侧车削 (内圆)

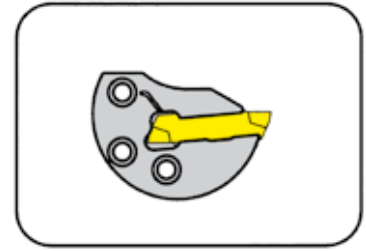
## GROOVING and SIDE TURNING (internal)



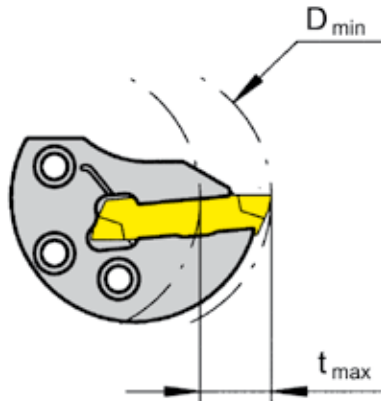
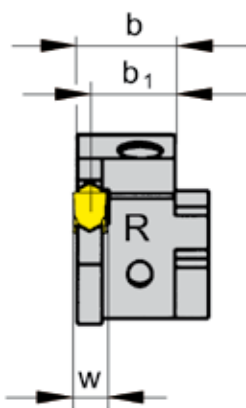
### 刀夹 型号

CASSETTE Type

# BK224



孔径Ø 自	Bore Ø from	40.0 mm
槽深可达	Depth of groove up to	11.0 mm
夹持范围	Clamping range	2.0 - 6.1 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	b <sub>1</sub>	b	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LBK224.0040.01	12.70	13.40	40	11	01	2.0 - 2.4
R/LBK224.0040.02	12.45	13.35	40	11	02	2.4 - 2.8
R/LBK224.0040.03	12.20	13.30	40	11	03	2.8 - 3.7
R/LBK224.0040.04	11.70	13.15	40	11	04	3.7 - 4.4
R/LBK224.0040.05	11.20	13.05	40	11	05	4.4 - 5.1
R/LBK224.0040.06	10.70	12.95	40	11	06	5.1 - 6.1

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

右手型刀夹配合右手型常规刀柄,左手型刀夹配合左手型常规刀柄  
Use right hand cassettes in right hand basic toolholders and left hand cassettes in left hand basic toolholders.

#### 订货须知:

锁紧螺钉包含在刀柄内,不需要单独订购

#### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

#### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LBK224.0040.0...	5.13T20EP	T20PQ

M

# 切槽和侧车削 (内圆)

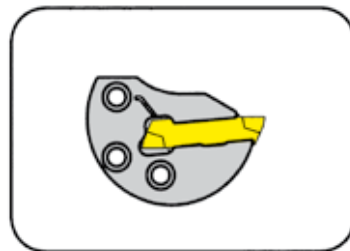
## GROOVING and SIDE TURNING (internal)



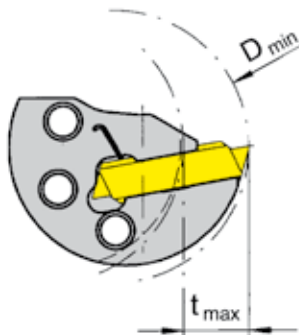
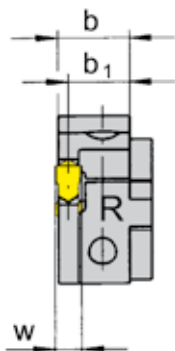
### 刀夹 型号

CASSETTE Type

# BK229



孔径Ø 自	Bore Ø from	50 / 60 mm
槽深	Depth of groove	12 / 15 mm
夹持范围	Clamping range	3.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 229  
Type N229  
S229

槽深与孔径的对应关系：  
Depth of groove in relation to bore Ø

D <sub>min</sub>	t <sub>max</sub>
50	12
60	15

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	D <sub>min</sub>	t <sub>max</sub>	b <sub>1</sub>	b	D <sub>min</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LBK229.0050.03	60	15	13.0	14.25	50	12	03	3.00 - 4.00
R/LBK229.0050.04	60	15	12.5	14.20	50	12	04	4.00 - 5.09
R/LBK229.0050.05	60	15	11.5	13.85	50	12	05	5.10 - 6.00

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

右手型刀夹配合右手型常规刀柄,左手型刀夹配合左手型常规刀柄  
Use right hand cassettes in right hand basic toolholders and left hand cassettes in left hand basic toolholders.

#### 订货须知：

锁紧螺钉包含在刀柄内,不需要单独订购

#### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

M

#### 附件

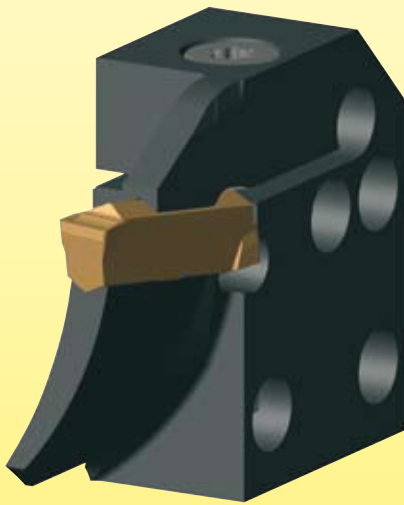
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LBK229.0050.0...	5.13T20EP	T20PQ

M44

## 端面切槽刀夹

Cassettes for face grooving



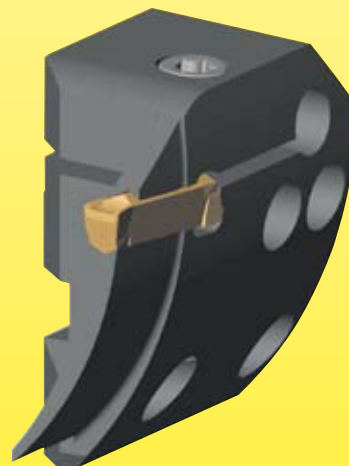
RIK220...



RAK220...



RAK224...



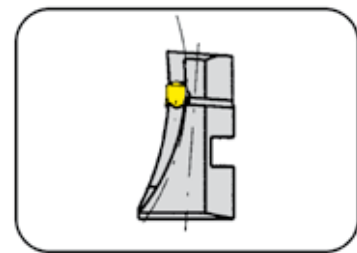
RIK224...

# 端面切槽 FACE GROOVING

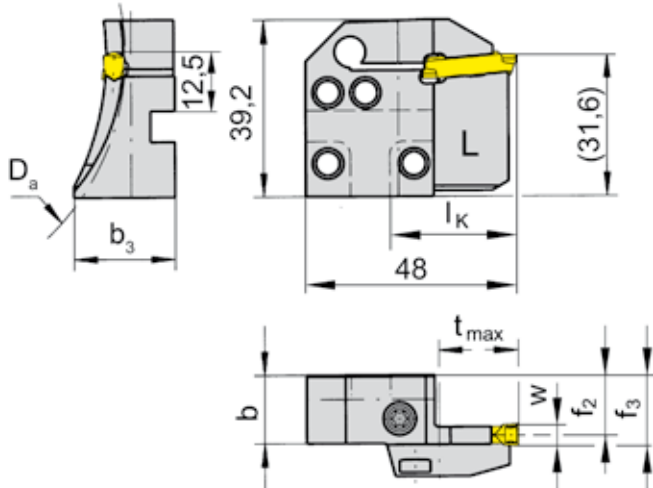


刀夹 型号  
CASSETTE Type

## LAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK224.5060.03	50	60			21.0				
LAK224.6075.03	60	75			21.0				
LAK224.7590.03	75	90			21.0				
LAK224.9011.03	90	110			21.0				
LAK224.1113.03	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1318.03	130	180			20.0				
LAK224.1830.03	180	300			19.0				
LAK224.3000.03	300	1000			16.4				
LAK224.3847.04	38	47			21.0				
LAK224.4760.04	47	60			21.0				
LAK224.6075.04	60	75			21.0				
LAK224.7590.04	75	90			21.0				
LAK224.9013.04	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1318.04	130	180			21.0				
LAK224.1830.04	180	300			19.0				
LAK224.3000.04	300	1000			16.7				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

### 订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

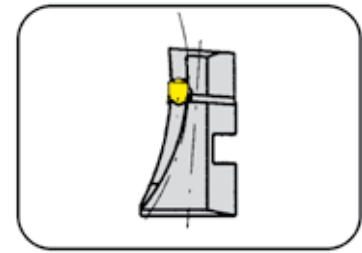
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK224....	5.13T20P	T20PQ

# 端面切槽 FACE GROOVING

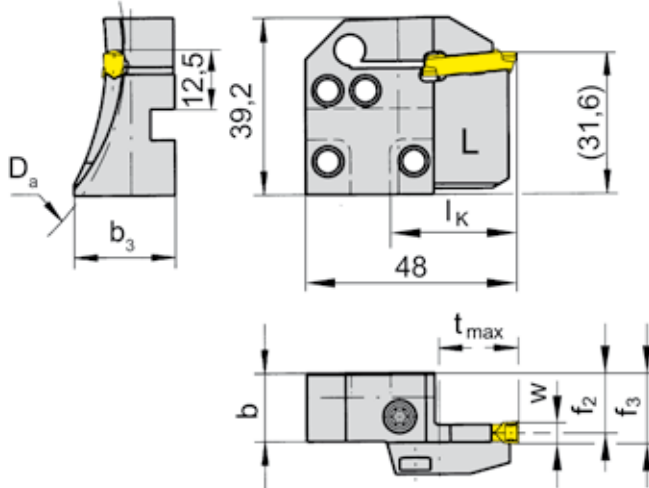


刀夹 型号  
CASSETTE Type

## LAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK224.3847.05	38	47			21.0				
LAK224.4760.05	47	60			21.0				
LAK224.6075.05	60	75			21.0				
LAK224.7590.05	75	90			21.0				
LAK224.9013.05	90	130	14	15.7	21.0	13.9	$f_2+w/2$	5	29
LAK224.1318.05	130	180			21.0				
LAK224.1830.05	180	300			19.0				
LAK224.3000.05	300	1000			16.7				
LAK224.6075.06	60	75			23.0				
LAK224.7590.06	75	90			23.0				
LAK224.9013.06	90	130	14	15.7	21.0	13.4	$f_2+w/2$	6	29
LAK224.1318.06	130	180			21.0				
LAK224.1830.06	180	300			19.0				
LAK224.3000.06	300	1000			16.7				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 订货须知：

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK224....	5.13T20P	T20PQ

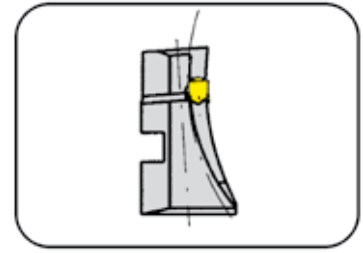
M

# 端面切槽 FACE GROOVING

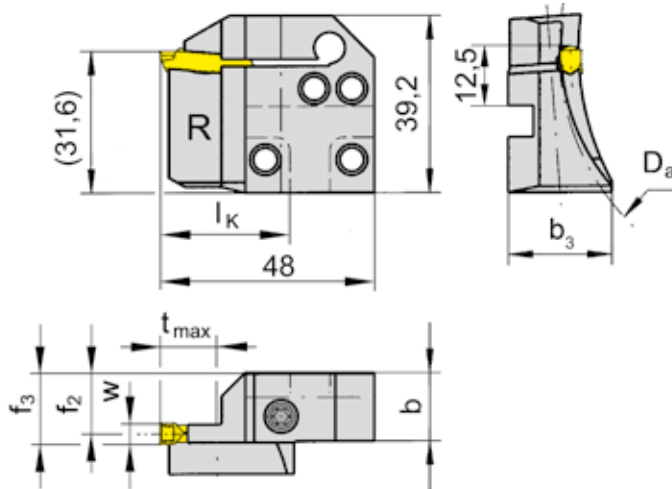


刀夹 型号  
CASSETTE Type

## RAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK224.5060.03	50	60			21.0				
RAK224.6075.03	60	75			21.0				
RAK224.7590.03	75	90			21.0				
RAK224.9011.03	90	110			21.0				
RAK224.1113.03	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
RAK224.1318.03	130	180			20.0				
RAK224.1830.03	180	300			19.0				
RAK224.3000.03	300	1000			16.4				
RAK224.3847.04	38	47			21.0				
RAK224.4760.04	47	60			21.0				
RAK224.6075.04	60	75			21.0				
RAK224.7590.04	75	90			21.0				
RAK224.9013.04	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
RAK224.1318.04	130	180			21.0				
RAK224.1830.04	180	300			19.0				
RAK224.3000.04	300	1000			16.7				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK224....	5.13T20P	T20PQ

M48

M

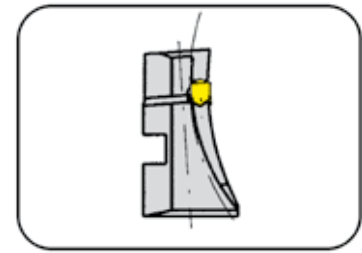


# 端面切槽 FACE GROOVING

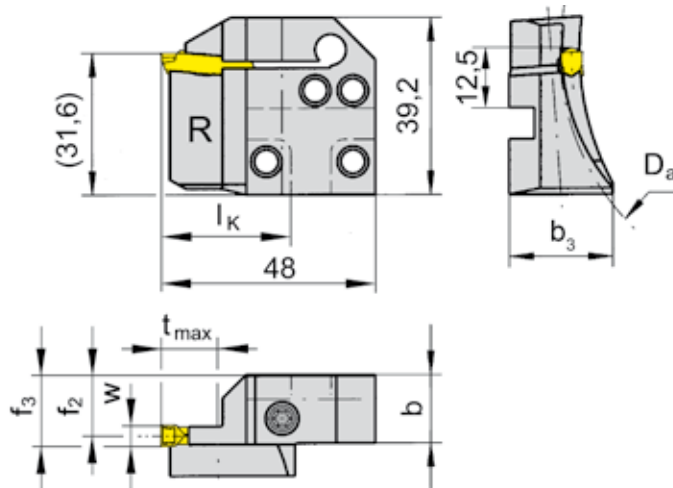


刀夹 型号  
CASSETTE Type

## RAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK224.3847.05	38	47			21.0				
RAK224.4760.05	47	60			21.0				
RAK224.6075.05	60	75			21.0				
RAK224.7590.05	75	90			21.0				
RAK224.9013.05	90	130	14	15.7	21.0	13.9	$f_2+w/2$	5	29
RAK224.1318.05	130	180			21.0				
RAK224.1830.05	180	300			19.0				
RAK224.3000.05	300	1000			16.7				
RAK224.6075.06	60	75			23.0				
RAK224.7590.06	75	90			23.0				
RAK224.9013.06	90	130			21.0				
RAK224.1318.06	130	180	14	15.7	21.0	13.4	$f_2+w/2$	6	29
RAK224.1830.06	180	300			19.0				
RAK224.3000.06	300	1000			16.7				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK224....	5.13T20P	T20PQ

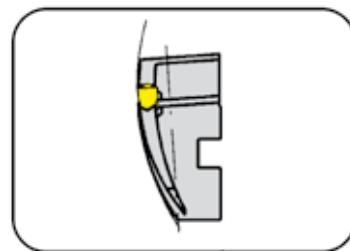
M

# 端面切槽 FACE GROOVING

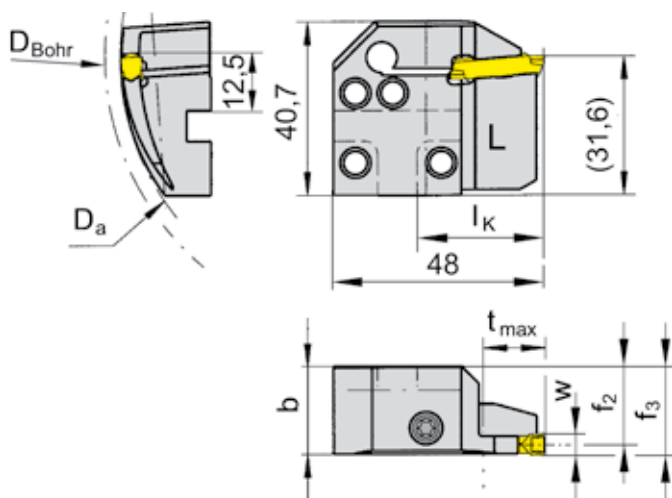


刀夹 型号  
CASSETTE Type

## LIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_k$
LIK224.5060.03	50	60					90		
LIK224.6075.03	60	75					90		
LIK224.7590.03	75	90					90	3	29
LIK224.9011.03	90	110	14	19	17.9	$f_2+w/2$	90		
LIK224.1113.03	110	130					110		
LIK224.1318.03	130	180					130		
LIK224.3847.04	38	47					90		
LIK224.4760.04	47	60					90		
LIK224.6075.04	60	75					90		
LIK224.7590.04	75	90	14	19	17.4	$f_2+w/2$	90	4	29
LIK224.9013.04	90	130					90		
LIK224.1318.04	130	180					130		
LIK224.3000.04	300	1000					300		

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK224....	5.13T20P	T20PQ

M50

M

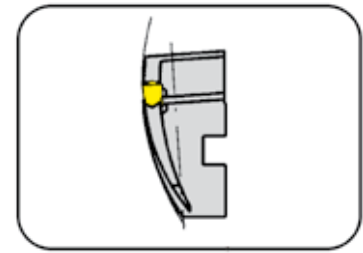
# 端面切槽 FACE GROOVING



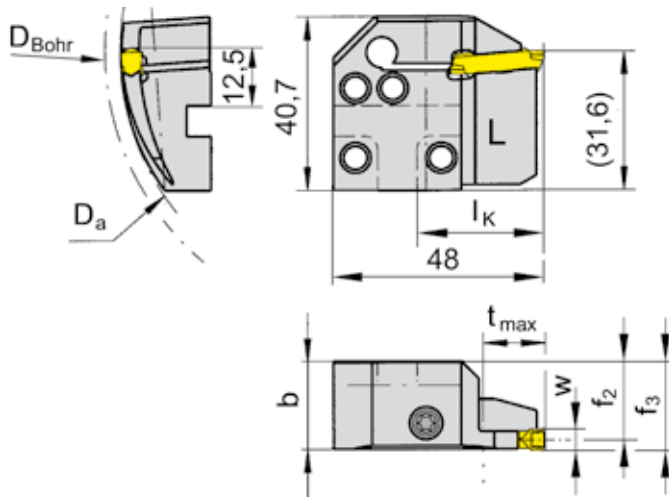
## 刀夹 型号

CASSETTE Type

# LIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_K$
LIK224.3847.05	38	47					90		
LIK224.4760.05	47	60					90		
LIK224.6075.05	60	75					90		
LIK224.7590.05	75	90					90		
LIK224.9013.05	90	130	14	19	16.9	$f_2+w/2$	90	5	29
LIK224.1318.05	130	180					130		
LIK224.1830.05	180	300					180		
LIK224.3000.05	300	1000					300		
LIK224.6075.06	60	75					90		
LIK224.7590.06	75	90					90		
LIK224.9013.06	90	130					90		
LIK224.1318.06	130	180	14	19	16.4	$f_2+w/2$	130	6	29
LIK224.1830.06	180	300					180		
LIK224.3000.06	300	1000					300		

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK224....	5.13T20P	T20PQ

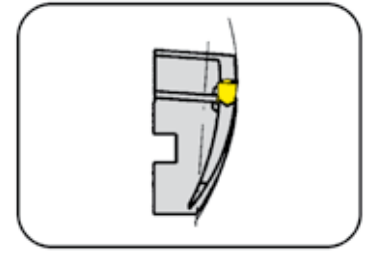
M

# 端面切槽 FACE GROOVING

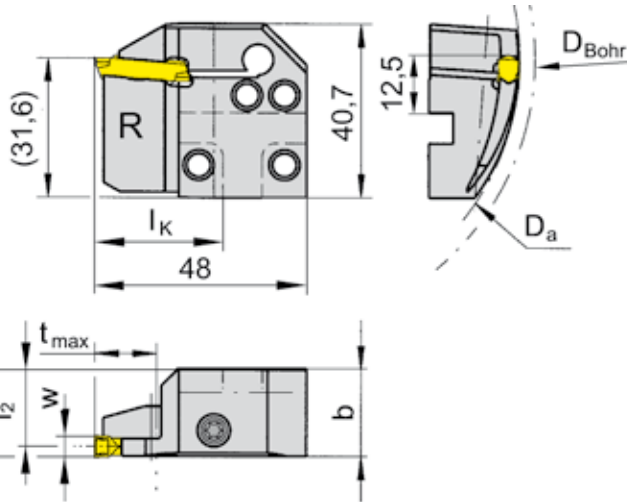


刀夹 型号  
CASSETTE Type

## RIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_K$
RIK224.5060.03	50	60					90		
RIK224.6075.03	60	75					90		
RIK224.7590.03	75	90					90		
RIK224.9011.03	90	110	14	19	17.9	$f_2+w/2$	90	3	29
RIK224.1113.03	110	130					110		
RIK224.1318.03	130	180					130		
RIK224.1830.03	180	300					180		
RIK224.3847.04	38	47					90		
RIK224.4760.04	47	60					90		
RIK224.6075.04	60	75					90		
RIK224.7590.04	75	90	14	19	17.4	$f_2+w/2$	90	4	29
RIK224.9013.04	90	130					90		
RIK224.1318.04	130	180					130		
RIK224.3000.04	300	1000					300		

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 订货须知：

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK224....	5.13T20P	T20PQ

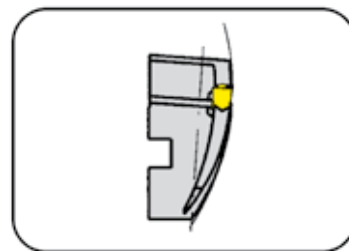
# 端面切槽 FACE GROOVING



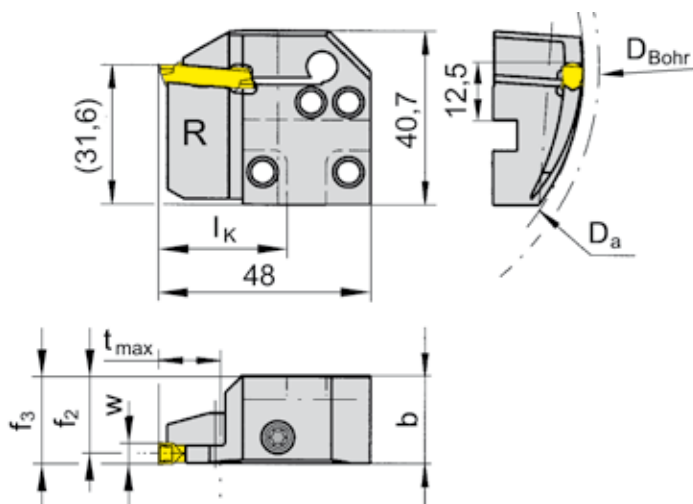
## 刀夹 型号

CASSETTE Type

# RIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$I_K$
RIK224.3847.05	38	47					90		
RIK224.4760.05	47	60					90		
RIK224.6075.05	60	75					90		
RIK224.7590.05	75	90					90		
RIK224.9013.05	90	130	14	19	16.9	$f_2+w/2$	90	5	29
RIK224.1318.05	130	180					130		
RIK224.1830.05	180	300					180		
RIK224.3000.05	300	1000					300		
RIK224.6075.06	60	75					90		
RIK224.7590.06	75	90					90		
RIK224.9013.06	90	130					90		
RIK224.1318.06	130	180	14	19	16.4	$f_2+w/2$	130	6	29
RIK224.1830.06	180	300					180		
RIK224.3000.06	300	1000					300		

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK224....	5.13T20P	T20PQ

M

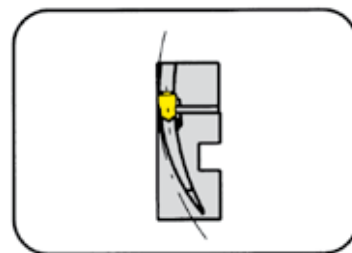
# 端面切槽 FACE GROOVING



## 刀夹 型号

CASSETTE Type

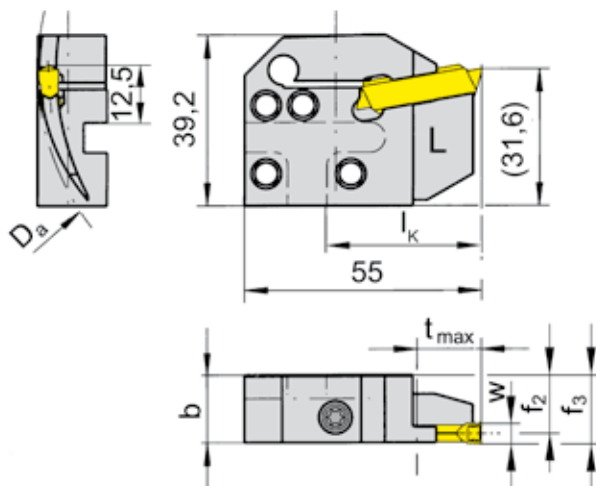
# LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型

L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6575.14	65	75	10					
LIK220.7595.14	75	95	15					
LIK220.9513.14	95	130	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.1318.14	130	180	15					
LIK220.1830.14	180	300	15					
LIK220.6075.15	60	75	10					
LIK220.7595.15	75	95	15					
LIK220.9513.15	95	130	15	15.7	13.9	$f_2+w/2$	5	36
LIK220.1318.15	130	180	15					
LIK220.1830.15	180	300	15					

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

### 订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

M54

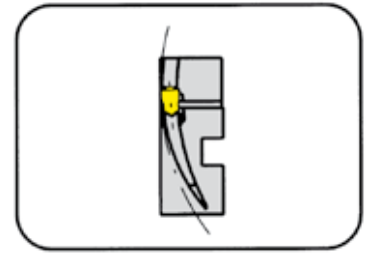
M

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

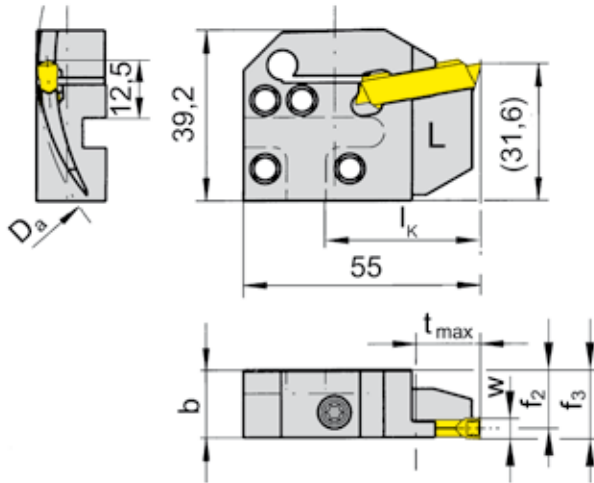
## LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6075.16	60	75	10					
LIK220.7595.16	75	95	15					
LIK220.9513.16	95	130	15	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.16	130	180	15					
LIK220.1830.16	180	300	15					

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

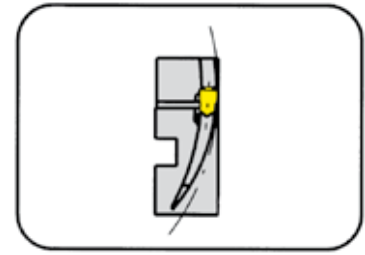
M

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

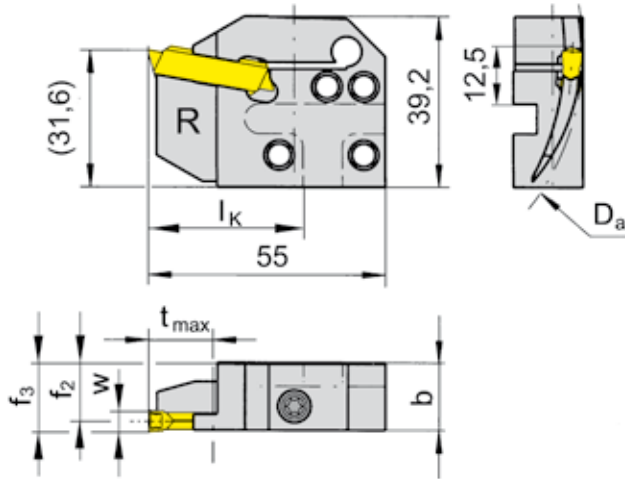
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6575.14	65	75	10					
RIK220.7595.14	75	95	15					
RIK220.9513.14	95	130	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.1318.14	130	180	15					
RIK220.1830.14	180	300	15					
RIK220.6075.15	60	75	10					
RIK220.7595.15	75	95	15					
RIK220.9513.15	95	130	15	15.7	13.9	$f_2+w/2$	5	36
RIK220.1318.15	130	180	15					
RIK220.1830.15	180	300	15					

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

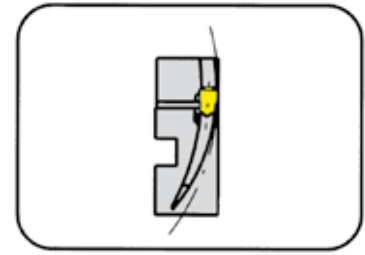


# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

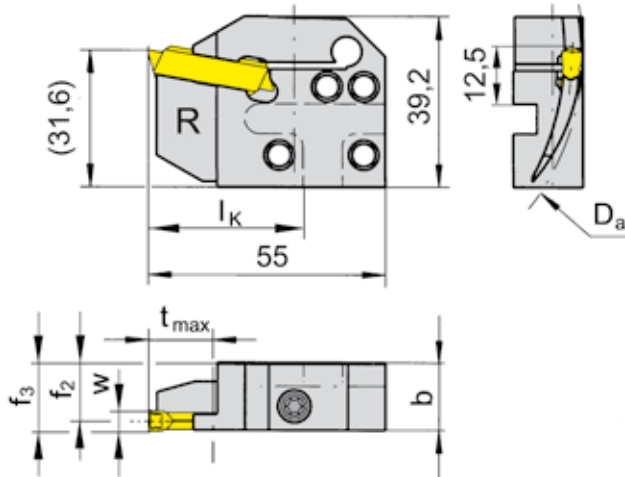
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6075.16	60	75	10					
RIK220.7595.16	75	95	15					
RIK220.9513.16	95	130	15	15.7	13.4	$f_2+w/2$	6	36
RIK220.1318.16	130	180	15					
RIK220.1830.16	180	300	15					

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

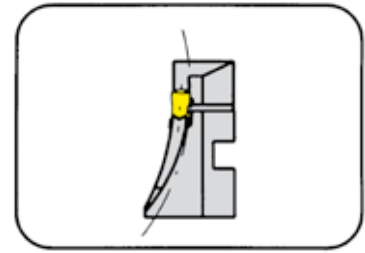
M

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

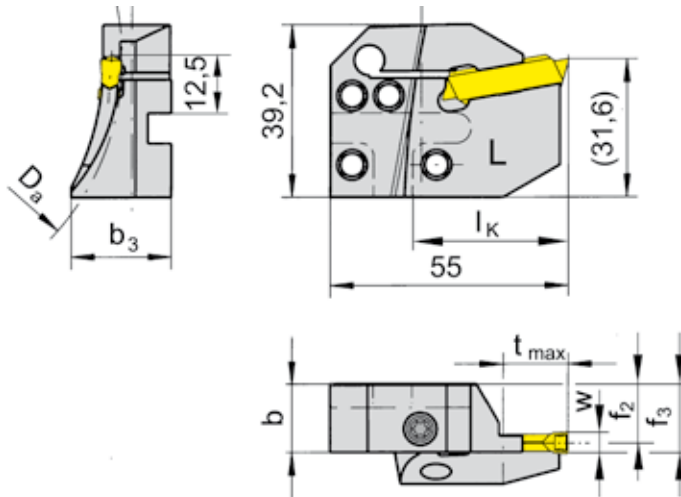
## LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6575.14	65	75	10		23.0				
LAK220.7595.14	75	95	15		23.0				
LAK220.9513.14	95	130	15	15.7	21.2	14.4	$f_2+w/2$	4	36
LAK220.1318.14	130	180	15		21.2				
LAK220.1830.14	180	300	15		19.0				
LAK220.6075.15	60	75	10		23.0				
LAK220.7595.15	75	95	15		23.0				
LAK220.9513.15	95	130	15	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.1318.15	130	180	15		21.2				
LAK220.1830.15	180	300	15		19.0				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

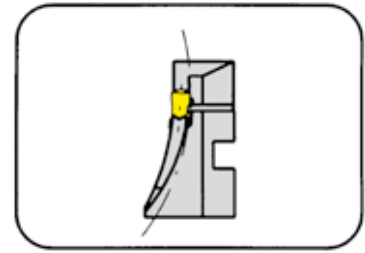
# 端面切槽

## FACE GROOVING



刀夹 型号  
CASSETTE Type

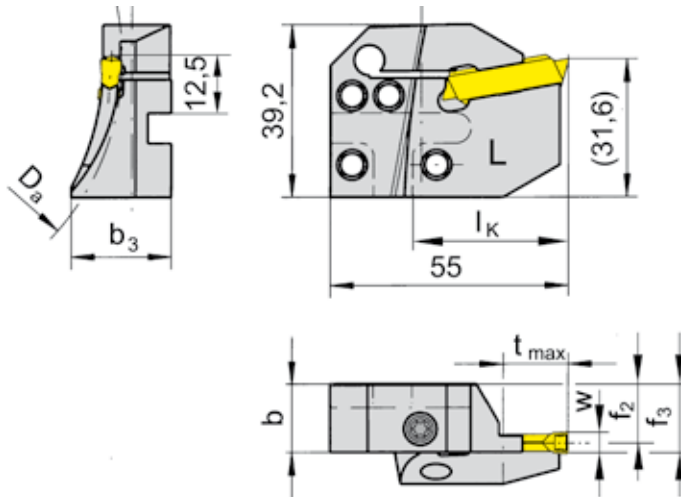
# LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6075.16	60	75	10		23.0				
LAK220.7595.16	75	95	15		23.0				
LAK220.9513.16	95	130	15	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.1318.16	130	180	15		21.2				
LAK220.1830.16	180	300	15		19.0				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

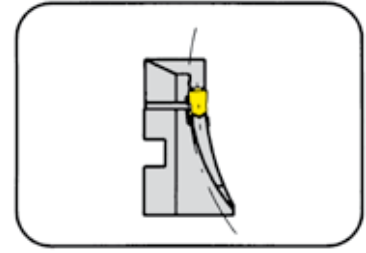
M

# 端面切槽 FACE GROOVING

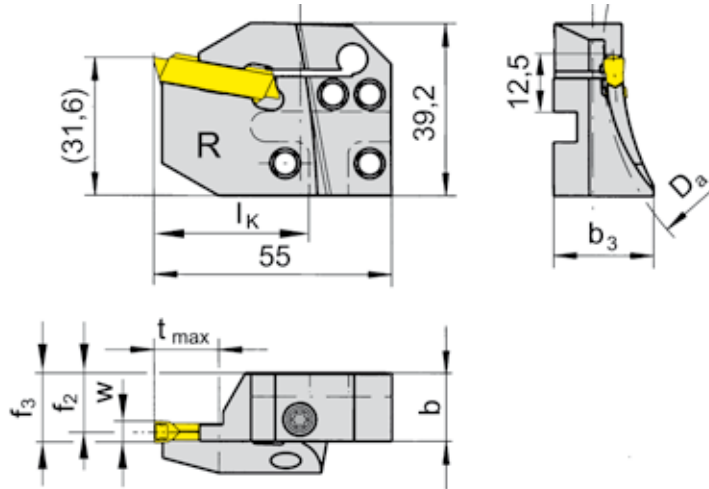


刀夹 型号  
CASSETTE Type

## RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6575.14	65	75	10		23.0				
RAK220.7595.14	75	95	15		23.0				
RAK220.9513.14	95	130	15	15.7	21.2	14.4	$f_2+w/2$	4	36
RAK220.1318.14	130	180	15		21.2				
RAK220.1830.14	180	300	15		19.0				
RAK220.6075.15	60	75	10		23.0				
RAK220.7595.15	75	95	15		23.0				
RAK220.9513.15	95	130	15	15.7	23.0	13.9	$f_2+w/2$	5	36
RAK220.1318.15	130	180	15		21.2				
RAK220.1830.15	180	300	15		19.0				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

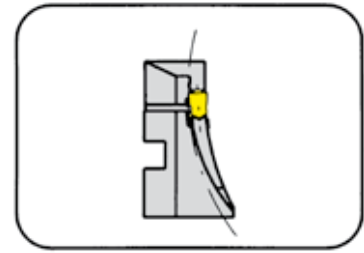
# 端面切槽 FACE GROOVING



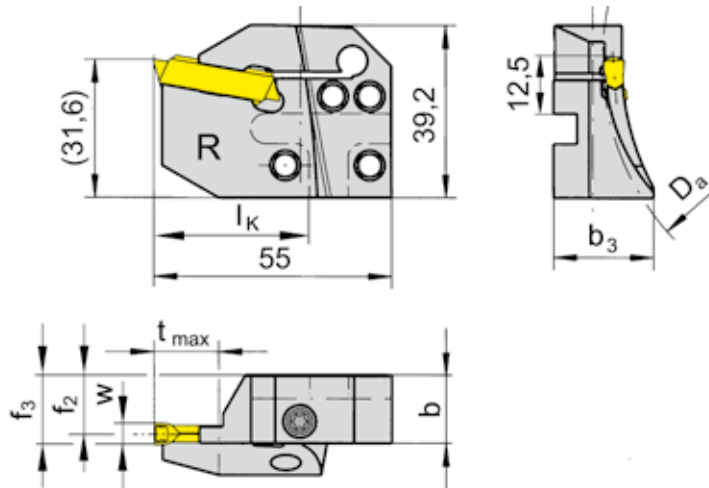
## 刀夹 型号

CASSETTE Type

# RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6075.16	60	75	10		23.0				
RAK220.7595.16	75	95	15		23.0				
RAK220.9513.16	95	130	15	15.7	23.0	13.4	$f_2+w/2$	6	36
RAK220.1318.16	130	180	15		21.2				
RAK220.1830.16	180	300	15		19.0				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

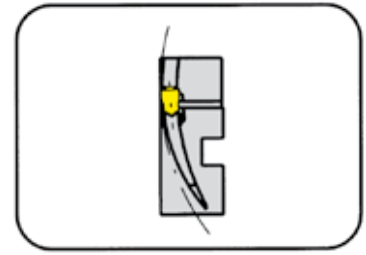
M

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

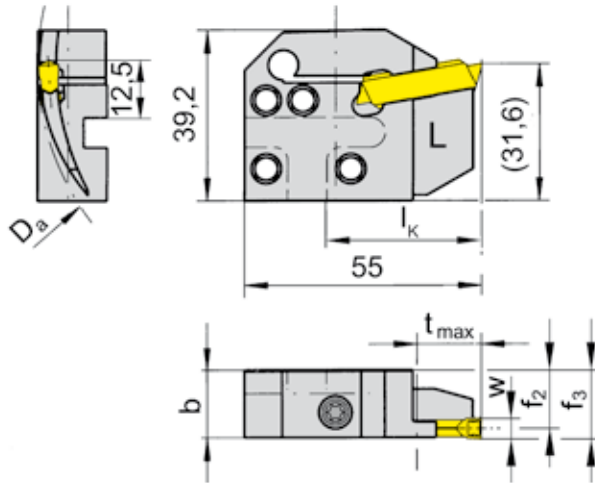
## LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6575.04	65	10	75	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.7595.04	75	15	95	25					
LIK220.9513.04	95	25	130	25					
LIK220.1318.04	130	25	180	25					
LIK220.1830.04	180	25	300	25					
LIK220.3000.04	300	25	1000	25					
LIK220.6075.05	60	10	75	17	15.7	13.9	$f_2+w/2$	5	36
LIK220.7595.05	75	17	95	25					
LIK220.9513.05	95	25	130	25					
LIK220.1318.05	130	25	180	25					
LIK220.1830.05	180	25	300	25					
LIK220.3000.05	300	25	1000	25					

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

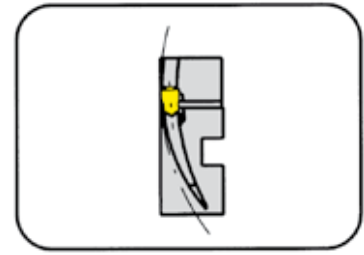
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

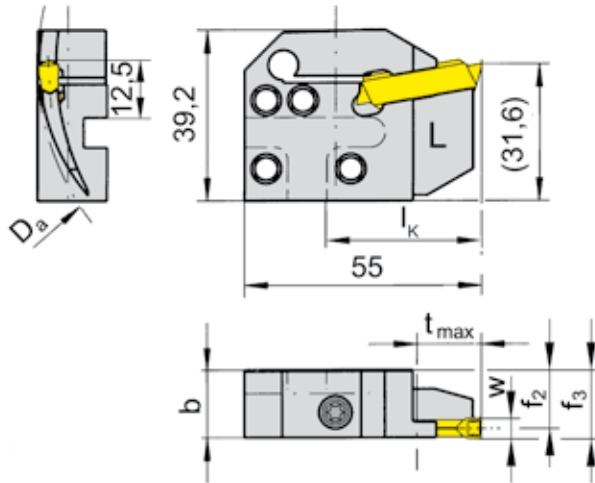
## LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6075.06	60	10	75	17					
LIK220.7595.06	75	17	95	25					
LIK220.9513.06	95	25	130	25	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.06	130	25	180	25					
LIK220.1830.06	180	25	300	25					
LIK220.3000.06	300	25	1000	25					

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知:  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

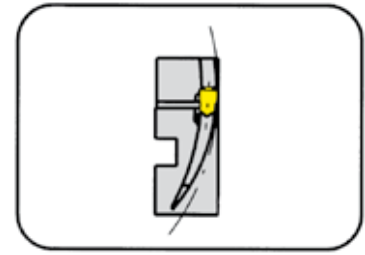
M

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

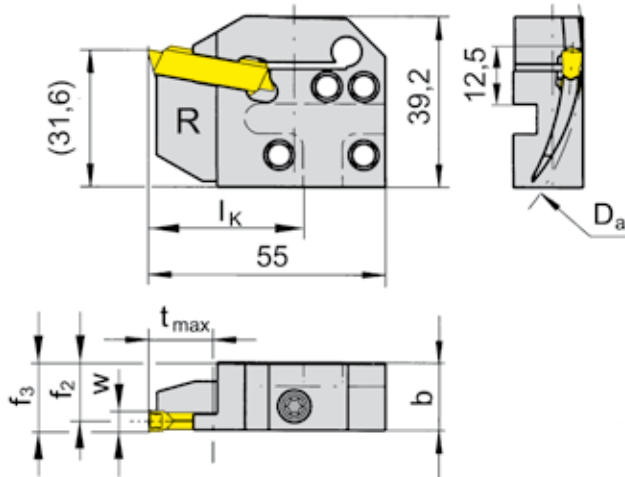
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6575.04	65	10	75	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.7595.04	75	15	95	25					
RIK220.9513.04	95	25	130	25					
RIK220.1318.04	130	25	180	25					
RIK220.1830.04	180	25	300	25					
RIK220.3000.04	300	25	1000	25					
RIK220.6075.05	60	10	75	17	15.7	13.9	$f_2+w/2$	5	36
RIK220.7595.05	75	17	95	25					
RIK220.9513.05	95	25	130	25					
RIK220.1318.05	130	25	180	25					
RIK220.1830.05	180	25	300	25					
RIK220.3000.05	300	25	1000	25					

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

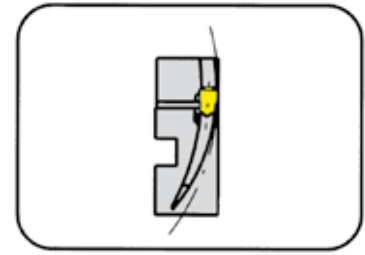


# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

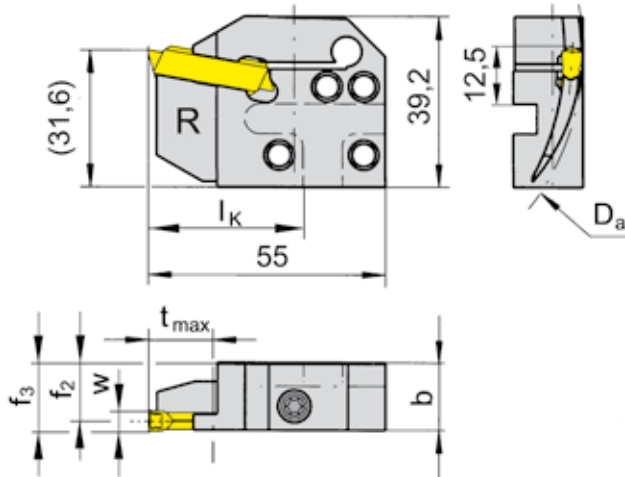
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深	Depth of groove	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6075.06	60	10	75	17					
RIK220.7595.06	75	17	95	25					
RIK220.9513.06	95	25	130	25	15.7	13.4	$f_2 + w/2$	6	36
RIK220.1318.06	130	25	180	25					
RIK220.1830.06	180	25	300	25					
RIK220.3000.06	300	25	1000	25					

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

M

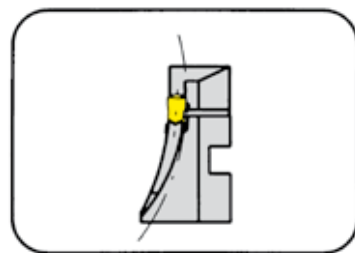
# 端面切槽

## FACE GROOVING



刀夹 型号  
CASSETTE Type

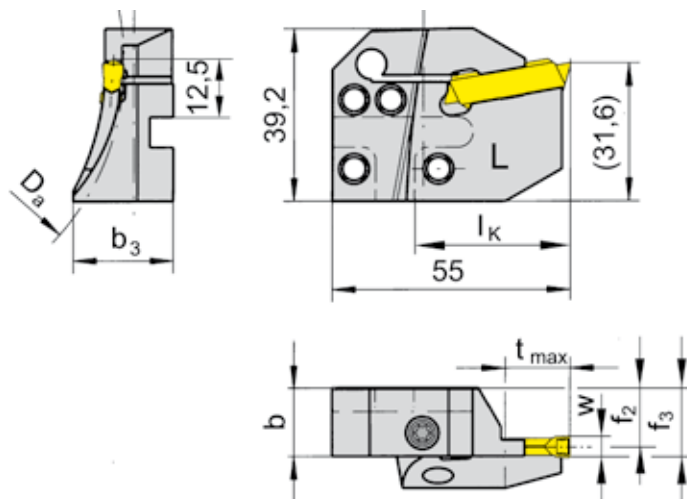
# LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6575.04	65	10	75	15	15.7	23.0	14.4	$f_2+w/2$	4	36
LAK220.7595.04	75	15	95	25		23.0				
LAK220.9513.04	95	25	130	25		21.2				
LAK220.1318.04	130	25	180	25		21.2				
LAK220.1830.04	180	25	300	25		21.2				
LAK220.3000.04	300	25	1000	25		16.8				
LAK220.6075.05	60	10	75	17	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.7595.05	75	17	95	25		23.0				
LAK220.9513.05	95	25	130	25		23.0				
LAK220.1318.05	130	25	180	25		21.2				
LAK220.1830.05	180	25	300	25		21.2				
LAK220.3000.05	300	25	1000	25		16.8				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

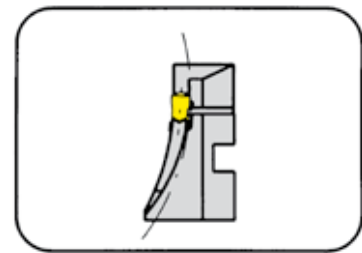
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

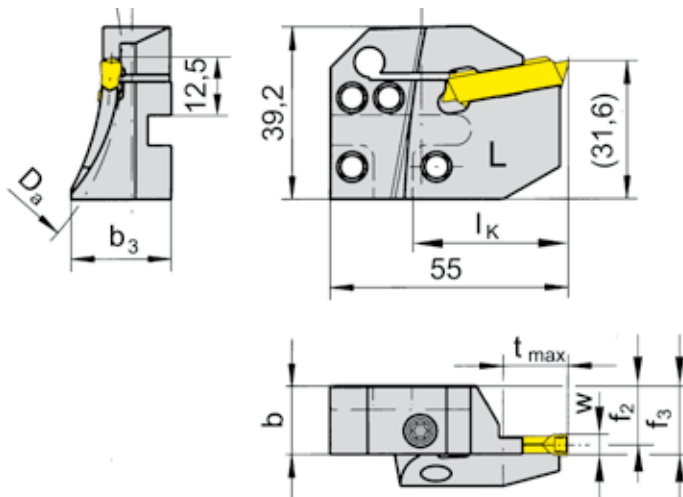
## LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6075.06	60	10	75	17	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.7595.06	75	17	95	25		23.0				
LAK220.9513.06	95	25	130	25		23.0				
LAK220.1318.06	130	25	180	25		21.2				
LAK220.1830.06	180	25	300	25		21.2				
LAK220.3000.06	300	25	1000	25		16.8				

配合常规刀柄L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

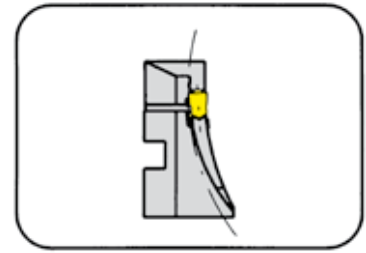
M

# 端面切槽 FACE GROOVING

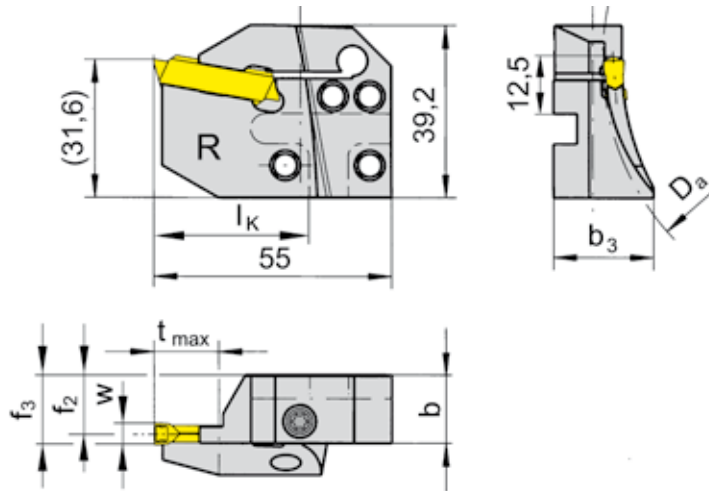


刀夹 型号  
CASSETTE Type

## RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6575.04	65	10	75	15		23.0				
RAK220.7595.04	75	15	95	25		23.0				
RAK220.9513.04	95	25	130	25	15.7	21.2	14.4	$f_2+w/2$	4	36
RAK220.1318.04	130	25	180	25		21.2				
RAK220.1830.04	180	25	300	25		21.2				
RAK220.3000.04	300	25	1000	25		16.8				
RAK220.6075.05	60	10	75	17		23.0				
RAK220.7595.05	75	17	95	25		23.0				
RAK220.9513.05	95	25	130	25	15.7	23.0	13.9	$f_2+w/2$	5	36
RAK220.1318.05	130	25	180	25		21.2				
RAK220.1830.05	180	25	300	25		21.2				
RAK220.3000.05	300	25	1000	25		16.8				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

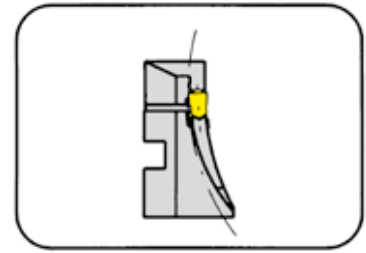
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

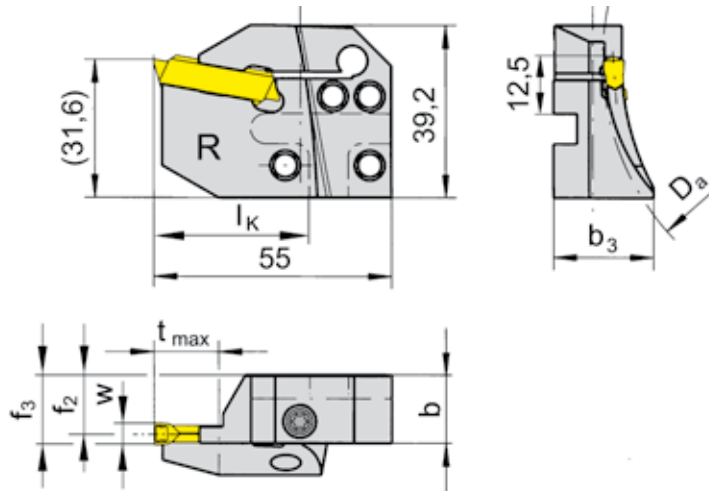
## RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6075.06	60	10	75	17		23.0				
RAK220.7595.06	75	17	95	25		23.0				
RAK220.9513.06	95	25	130	25		23.0				
RAK220.1318.06	130	25	180	25	15.7	21.2	13.4	$f_2+w/2$	6	36
RAK220.1830.06	180	25	300	25		21.2				
RAK220.3000.06	300	25	1000	25		16.8				

配合常规刀柄R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

M

# HORN HSKT40 DIN 12164-3

常规刀柄 HSKT40..840  
用于外圆加工

Basic toolholder HSKT40..840  
for external machining



840系列刀具  
Pocket seat system 840



RNK368-0840...



RNK360-0840...



RNK264-0840...



RNK356-0840...



RNK274-0840...



RNK224-0840...



RNK100-0840...

M

M70

# 切槽 ( 外圆 )

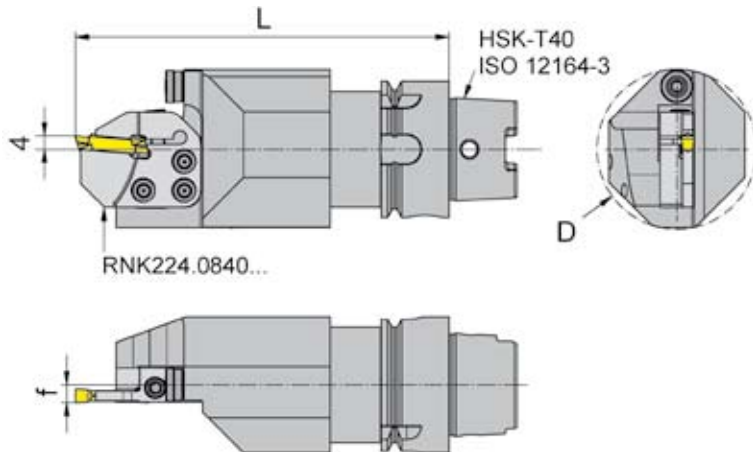
## GROOVING (external)



常规刀柄 型号  
BASIC TOOLHOLDER Type

**HSKT40**  
带内冷  
with through coolant supply

用于多任务机床  
for using on multi-tasking machines



配合 可转位刀片  
for use with Indexable insert

型号 NS224  
Type S224

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

840系列刀夹  
Pocket seat system 840

产品型号 Part number	刀夹 Cassette	...NK224...			...NK368...			...NK356...			...NK360...		
		L	D	f	L	D	f	L	D	f	L	D	f
<b>HSKT40.L840.110.K1</b>	L	110	47	5.2	110	47	3.7	110	47	6.4/ 7.3	110	47	*
<b>HSKT40.R840.110.K1</b>	R												
配合可转位刀片/for Indexable Insert		S224			312			315			312		

\*和w见刀夹部分  
\* see Cassettes

产品型号 Part number	刀夹 Cassette	...NK100...			...NK264...			...NK274...		
		L	D	f	L	D	f	L	D	f
<b>HSKT40.L840.110.K1</b>	L	110	47	5.2	110	47	5.2	110	47	5.0
<b>HSKT40.R840.110.K1</b>	R									
配合可转位刀片/for Indexable Insert		S100			S264			S274		

尺寸单位 : mm  
Dimensions in mm

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle	冷却管 Coolant tube
HSKT40.R/L840.110.K1	<b>030.518P.0732</b>	<b>T20PQ</b>	<b>020.0806.3116</b>	<b>HSK40KMZ</b>

M

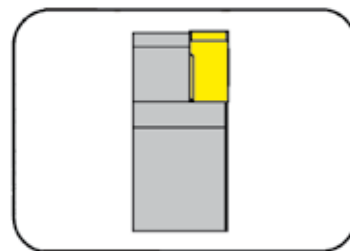
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

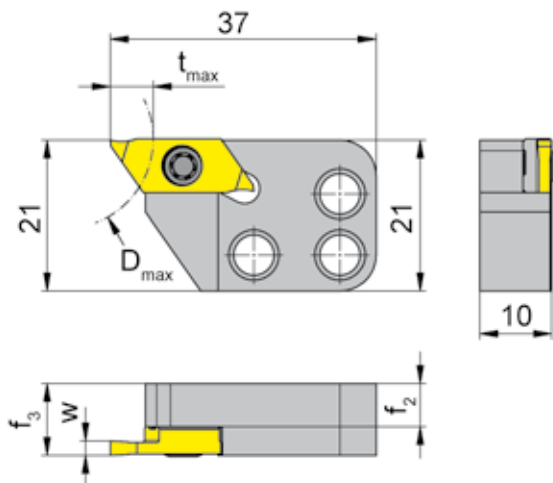
# NK274



槽深可达	Depth of groove up to	6.0 mm
夹持范围	Clamping range	0.5 - 4.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$t_{max}$	$D_{max}$	$f_2$	$f_3$	夹持范围 Clamping range
R/LNK274.0840.1.04	6	25	6	$f_2+w$	0.5 - 4

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

### 订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

M

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK274.0840.1.04	030.3509.T15P	T15PQ

M72



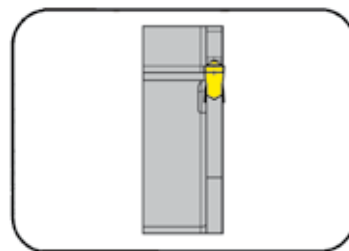
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK264

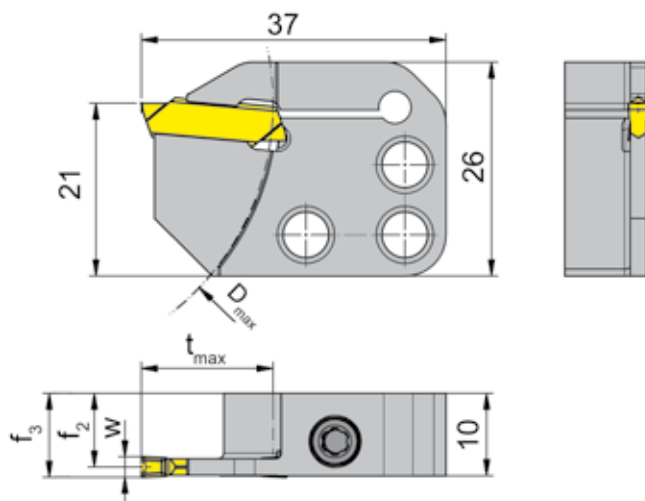


槽深可达 16.0 mm  
夹持范围 1.5 - 3.0 mm

Depth of groove up to 16.0 mm  
Clamping range 1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S264  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$t_{max}$	$D_{max}$	$f_2$	$f_3$	夹持范围 Clamping range
R/LNK264.0840.1.01	13	65	10.2	$f_2 + w/2$	1.5
R/LNK264.0840.1.02	16				2.0
R/LNK264.0840.1.03	16				2.5
R/LNK264.0840.1.04	16				3.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK264.0840.1.0...	4.20T15P	T15PL

M

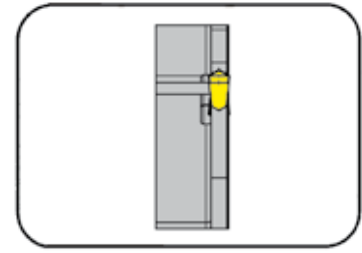
# 切槽 ( 外圆 )

## GROOVING (external)



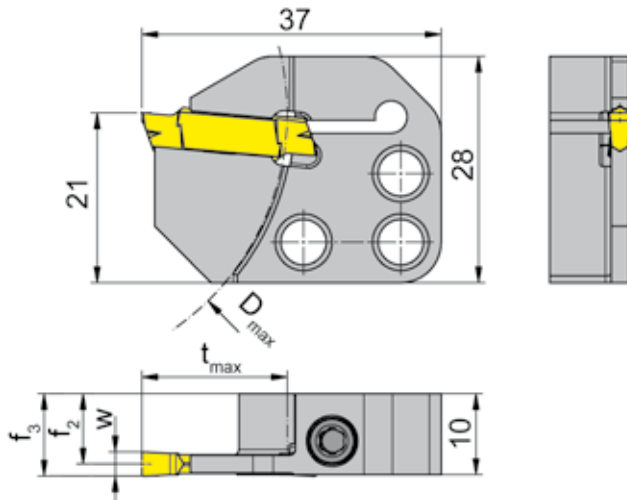
刀夹 型号  
CASSETTE Type

# NK224



槽深可达 18.0 mm  
夹持范围 2.0 - 6.0 mm

Depth of groove up to 18.0 mm  
Clamping range 2.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	夹持范围 Clamping range
R/LNK224.0840.1.01	18	65	9.20	f <sub>2</sub> +w/2	2.0 - 2.4
R/LNK224.0840.1.02	18	65	8.95	f <sub>2</sub> +w/2	2.4 - 2.8
R/LNK224.0840.1.03	18	65	8.70	f <sub>2</sub> +w/2	2.8 - 3.7
R/LNK224.0840.1.04	18	65	8.20	f <sub>2</sub> +w/2	3.7 - 4.4
R/LNK224.0840.1.05	18	65	7.70	f <sub>2</sub> +w/2	4.4 - 5.1
R/LNK224.0840.1.06	18	65	7.20	f <sub>2</sub> +w/2	5.1 - 6.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK224.0840.1.0...	5.12T20P	T20PQ

M74

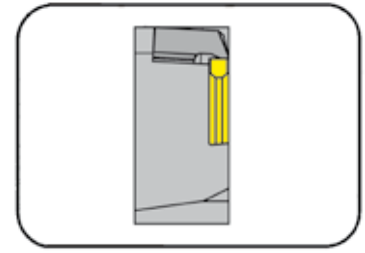
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK360

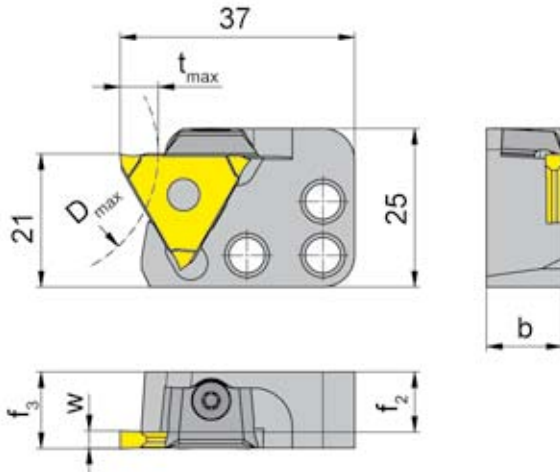


槽深可达 6.0 mm  
夹持范围 0.5 - 6.3 mm

Depth of groove up to 6.0 mm  
Clamping range 0.5 - 6.3 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	b	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	夹持范围 Clamping range
R/LNK360.0840.1.01	12	4	40	10.5	f <sub>2</sub> +w-a <sub>1</sub>	0.5 - 1.9
R/LNK360.0840.1.02	12	6	40	9.5	f <sub>2</sub> +w-a <sub>1</sub>	1.9 - 2.9
R/LNK360.0840.1.03	12	6	40	8.5	f <sub>2</sub> +w-a <sub>1</sub>	2.9 - 3.9
R/LNK360.0840.1.04	16	6	40	10.8	f <sub>2</sub> +w-a <sub>1</sub>	3.9 - 6.3

注明R或L型  
State R or L version

w, a<sub>1</sub>见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

### 订货须知 :

锁紧螺钉包含在刀柄内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK360.0840.1.01/02/03	12.3	030.0422.T10P	T10PL
R/LNK360.0840.1.04	14.4	5.32.3T15P	T15PQ

M

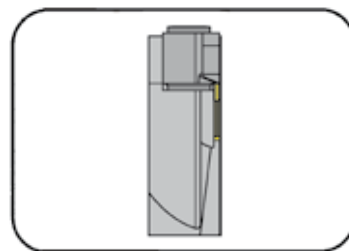
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

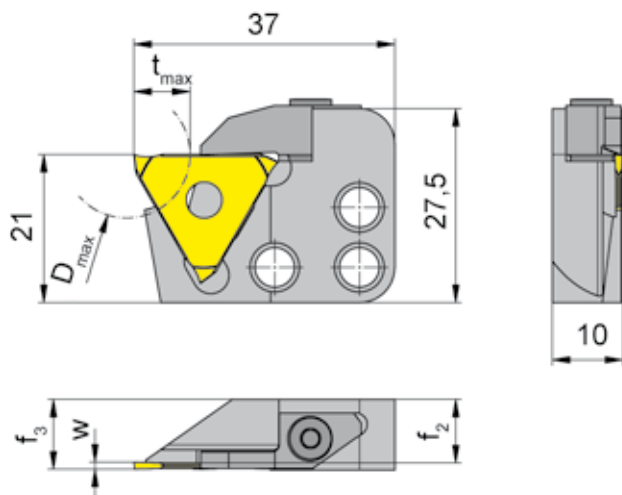
# NK368



槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	0.5 - 1.5 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$t_{max}$	$D_{max}$	$f_2$	$f_3$	夹持范围 Clamping range
R/LNK368.0840.1.08	8	18	9.0	$f_2+w$	0.5 - 1.2
R/LNK368.0840.1.11	8	18	8.7	$f_2+w$	1.2 - 1.5

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀夹 Cassette	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK368.0840.1....	010.0004.0427	030.400P.0602	T10PL

M76

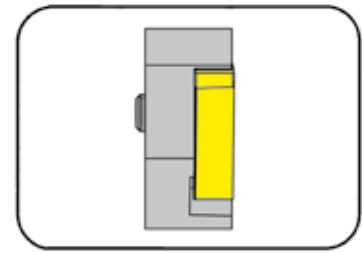
# 切槽 ( 外圆 )

## GROOVING (external)



刀夹 型号  
CASSETTE Type

# NK356

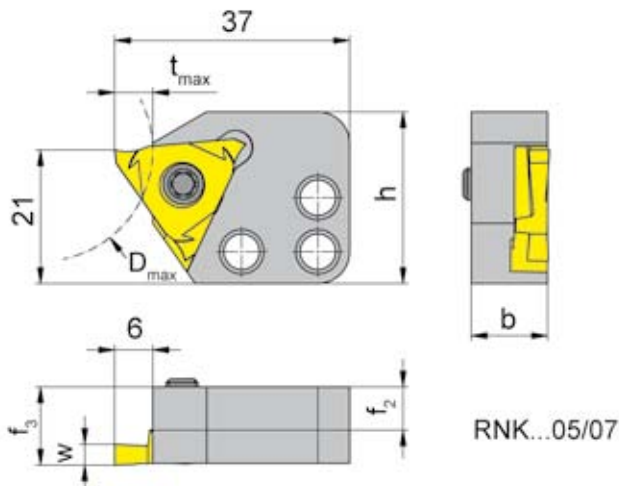


槽深可达 5.00 mm  
夹持范围 3.25 - 7.50 mm

Depth of groove up to 5.00 mm  
Clamping range 3.25 - 7.50 mm

配合 可转位刀片  
for use with Indexable insert

型号 315  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	夹持范围 Clamping range
R/LNK356.0840.1.05	27.0	12	5	-	6.8	f <sub>2</sub> +w	3.25 - 5.45
R/LNK356.0840.1.07	27.0	13	5	-	6.0	f <sub>2</sub> +w	6.60 - 7.50
R/LNK356.0840.1.16	23.4	12	5	35	6.0	f <sub>2</sub> +w	5.45 - 6.60
R/LNK356.0840.1.17	23.4	13	5	35	6.1	f <sub>2</sub> +w	6.60 - 7.50

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK356.0840.1....	5.12T20P	T20PQ

M

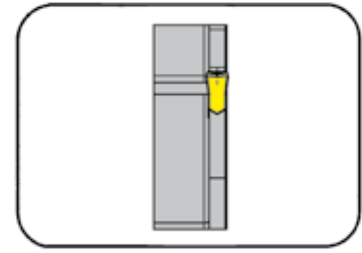
# 切槽 ( 外圆 )

## GROOVING (external)



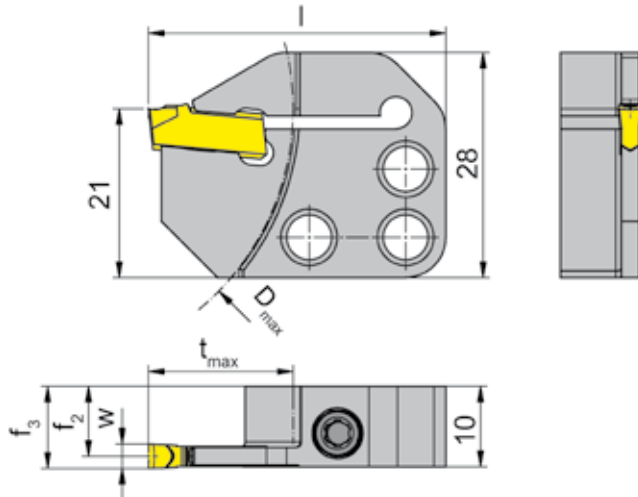
刀夹 型号  
CASSETTE Type

# NK100



槽深可达 25.0 mm  
夹持范围 2.0 - 5.0 mm

Depth of groove up to 25.0 mm  
Clamping range 2.0 - 5.0 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀片  
for use with Insert

型号 S100  
Type

产品型号 Part number	t <sub>max</sub>	D <sub>max</sub>	f <sub>2</sub>	f <sub>3</sub>	l	夹持范围 Clamping range
R/LNK100.0840.1.01	18	65	9.2	f <sub>2</sub> + w/2	37	2.0
R/LNK100.0840.1.02			9.0			2.5
R/LNK100.0840.1.03			8.7			3.0
R/LNK100.0840.1.04			8.2			4.0
R/LNK100.0840.1.05			7.7			5.0
R/LNK100.0840.3.02	25	65	9.0	f <sub>2</sub> + w/2	44	2.5
R/LNK100.0840.3.03			8.7			3.0

注明R或L型  
State R or L version

w见刀片  
w see inserts

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀柄内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK100.0840....	4.20T15P	T15PL

M78

## HORN KM16 Micro

用于内圆和外圆加工  
for external and internal machining

**Supermini® 105** 自 Ø 0.2 mm

**Mini 108** 自 Ø 8.0 mm

**264切槽系列**

Supermini® 105 from Ø 0.2 mm

Mini 108 from Ø 8.0 mm

Grooving system 264



**274切槽系列**

适用于直刀柄或者弯刀柄

Grooving system 274

for straight and cranked toolholder



# 切槽和侧车削

## GROOVING and SIDE TURNING

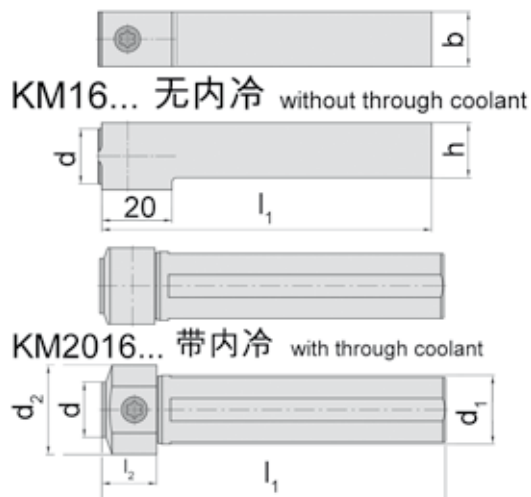


常规刀柄 型号  
BASIC TOOLHOLDER Type

# KM16



配合...KM16...刀柄的常规刀柄  
Basic toolholder for use with toolholder ...KM16...



Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	b	d <sub>1</sub>	d <sub>2</sub>
<b>KM16 NCM 1616 100</b>	16	100	-	16	16	-	-
<b>KM2016 NCM SS20 16</b> <b>KM2016 NCM SS22 16</b>	20	100	16	-	-	20 22	26 28

尺寸单位：mm  
Dimensions in mm

# M

附件  
Spare parts

常规刀柄 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Blade
KM16 NCM 1616 100 KM2016 NCM SS2...	<b>KM16-NSPKG</b> <b>KM16-NAPKG</b>	<b>DT27PQ</b> <b>DT27PQ</b>

M80

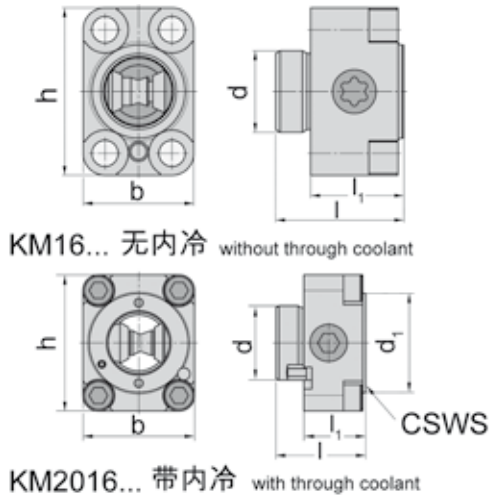


型号  
FLANGE Type

**KM16**



配合...KM16...刀柄的常规刀柄  
Basic toolholder for use with toolholder ...KM16...



Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	l	d	l <sub>1</sub>	h	b	d <sub>1</sub>
<b>KM16NCMSF1928</b>	22	14	16	27.5	19	-
<b>KM2016NCMSF2434</b>	22	20	16	33.0	25	20

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

附件  
Spare parts

法兰 Flange	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Blade
KM16NCMSF1928 KM2016NCMSF2434	<b>KM16-NSPKG</b> <b>KM16-NAPKG</b>	<b>DT27PQ</b> <b>DT27PQ</b>

M

# 切槽 ( 内圆 ) $\geq \varnothing 0.2 \text{ mm}$

## GROOVING (internal)

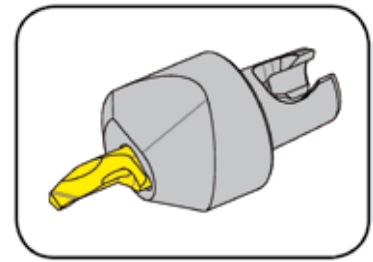


### 刀柄 型号

TOOLHOLDER Type

## B105KM

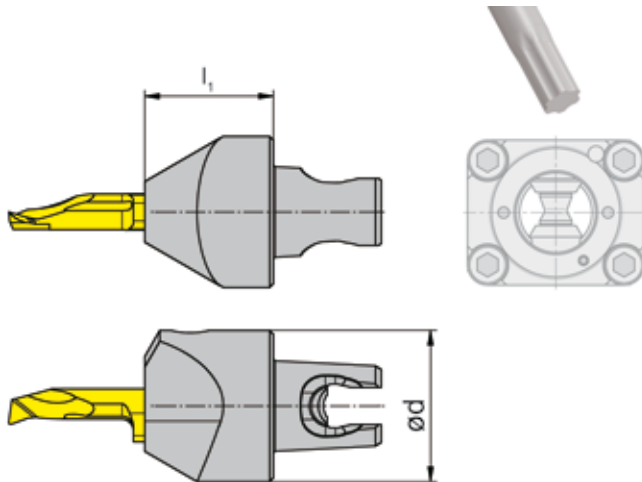
带内冷  
with through coolant supply



孔径 $\varnothing$  自

Bore  $\varnothing$  from

0.2 mm



配合 刀片  
for use with Insert

型号 105  
Type

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	d	l <sub>1</sub>
<b>B105.KM16.90.01</b>	20	17

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.KM16.90.01	<b>6.075T15P</b>	<b>T15PQ</b>

M82

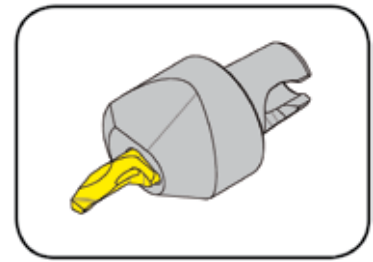
# 切槽 ( 内圆 ) $\geq \varnothing 0.2 \text{ mm}$

## GROOVING (internal)

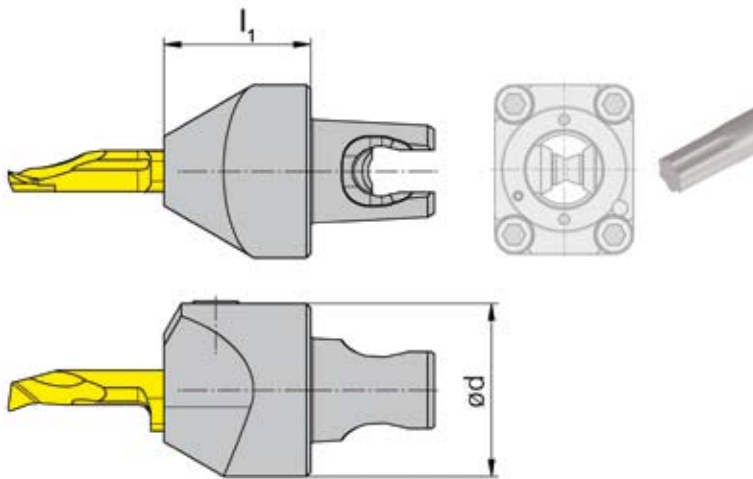


刀柄 型号  
TOOLHOLDER Type

**B105KM**  
带内冷  
with through coolant supply



孔径 $\varnothing$  自                      Bore  $\varnothing$  from                      0.2 mm



配合 刀片  
for use with Insert

型号 105  
Type

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	d	l <sub>1</sub>
<b>B105.KM16.01</b>	20	17

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.KM16.01	<b>6.075T15P</b>	<b>T15PQ</b>

M

# 切槽 ( 内圆 ) $\geq \varnothing 8.0 \text{ mm}$

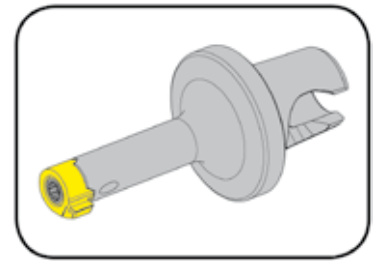
## GROOVING (internal)



刀柄 型号  
TOOLHOLDER Type

### B108KM

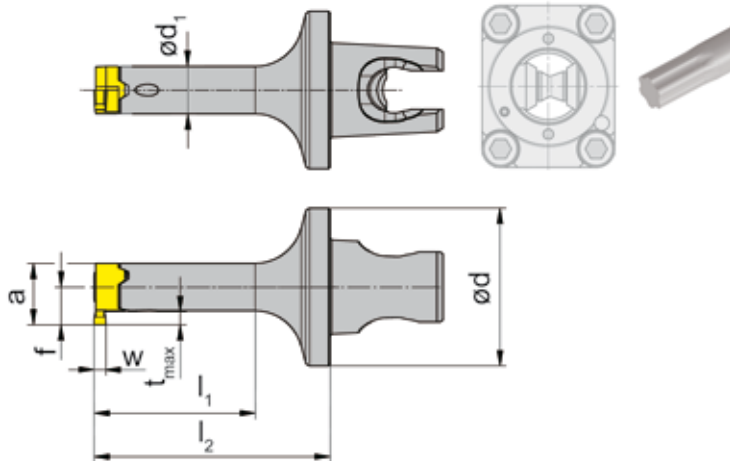
带内冷  
with through coolant supply



孔径 $\varnothing$  自 Bore  $\varnothing$  from 8.0 mm

配合 刀片  
for use with Insert

型号 108  
Type S108



Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	d	$l_1$	$l_2$	$d_1$
B108.KM16.01	20	21	30	6
B108.KM16.02		26	35	

按需提供更多尺寸  
Further sizes upon request

$w, a, t_{max}$  和  $f$  见刀片  
 $w, a, t_{max}$  and  $f$  see inserts

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B108.KM16.0...	2.6-5T8EP	T8PL

M84

# 切槽 ( 内圆 ) $\geq \varnothing 8.0 \text{ mm}$

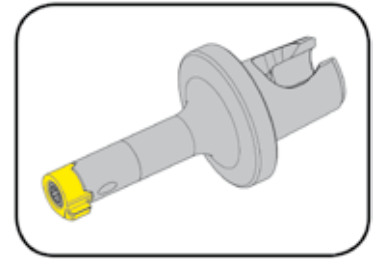
## GROOVING (internal)



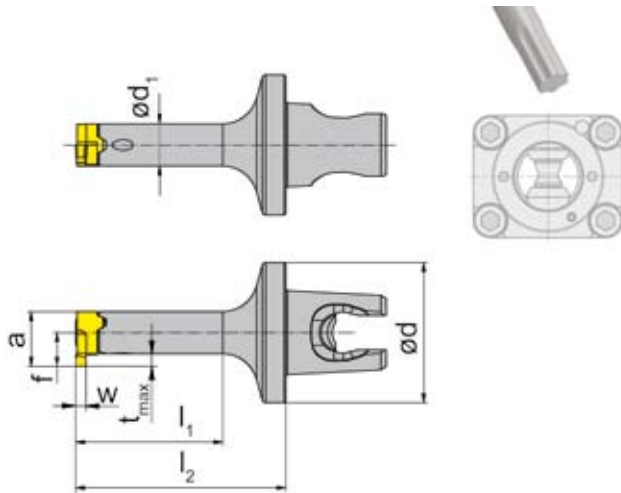
刀柄 型号  
TOOLHOLDER Type

### B108KM

带内冷  
with through coolant supply



孔径 $\varnothing$ 自	Bore $\varnothing$ from	8.0 mm
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配合 刀片  
for use with Insert

型号 108  
Type S108

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	d	$l_1$	$l_2$	$d_1$
B108.KM16.90.01	20	21	30	6
B108.KM16.90.02		26	35	

按需提供更多尺寸  
Further sizes upon request

w, a,  $t_{max}$  和 f 见刀片  
w, a,  $t_{max}$  and f see inserts

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B108.KM16.90.0...	2.6-5T8EP	T8PL

M

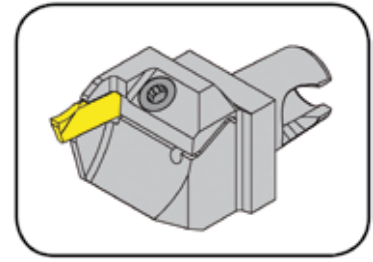
# 切槽和侧车削 (外圆)

## GROOVING and SIDE TURNING (external)



刀柄 型号  
TOOLHOLDER Type

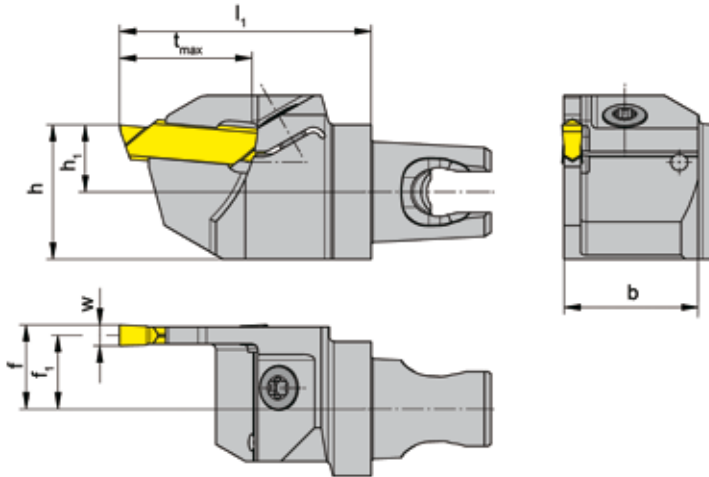
# H264KM



槽宽	Width of groove	1.5 - 2.0 mm
----	-----------------	--------------

配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



L=左手型  
L = left hand version shown

R=右手型  
R = right hand version

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	t <sub>max</sub>	w	D <sub>max</sub>	规格 Size
R/LH264.KM16.01	16	16	24	8	10	9.25	4	1.5	32	01
R/LH264.KM16.11			24				10			
R/LH264.KM16.21			27				13			
R/LH264.KM16.02	16	16	24	8	10	9.00	4	2.0	32	02
R/LH264.KM16.12			24				10			
R/LH264.KM16.22			30				16			

注明R或L型  
State R or L version

尺寸单位: mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

附件  
Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.KM16....	3.5.12T10EP	T10PL

M86

# 切槽和侧车削 (外圆)

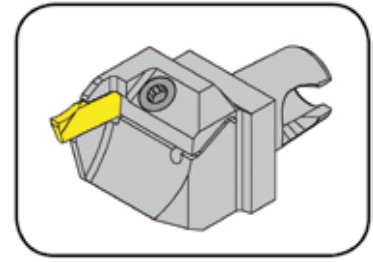
GROOVING and SIDE TURNING (external)



## 刀柄 型号

TOOLHOLDER Type

# H264KM



槽宽

Width of groove

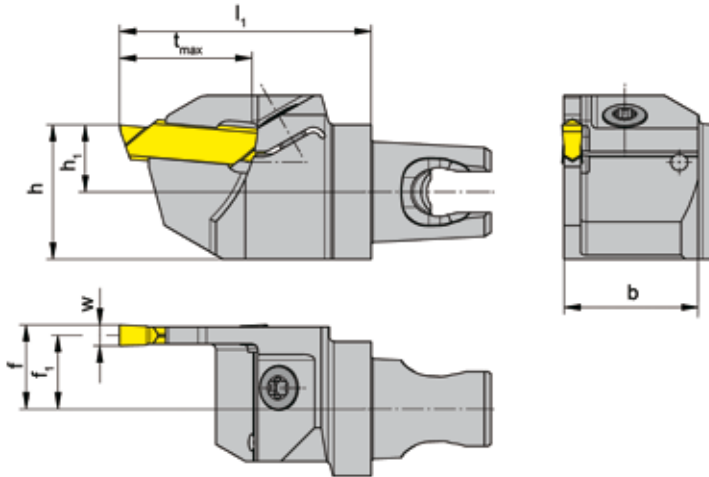
2.5 - 3.0 mm

配合 可转位刀片

for use with Indexable insert

型号 264

Type S264



L=左手型

L = left hand version shown

R=右手型

R = right hand version

Kennametal KM16 Micro  
系列

System Kennametal

KM16 Micro

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	t <sub>max</sub>	w	D <sub>max</sub>	规格 Size
R/LH264.KM16.03	16	16	24	8	10	8.75	4	2.5	32	03
R/LH264.KM16.13			24				10			
R/LH264.KM16.23			30				16			
R/LH264.KM16.04	16	16	24	8	10	8.50	5	3.0	32	04
R/LH264.KM16.14			24				10			
R/LH264.KM16.24			30				16			

注明R或L型

State R or L version

尺寸单位: mm

Dimensions in mm

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.KM16....	3.5.12T10EP	T10PL

M

# 切槽和侧车削

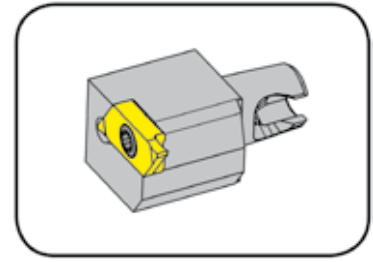
## GROOVING and SIDE TURNING



### 刀柄 型号

TOOLHOLDER Type

# HC274KM



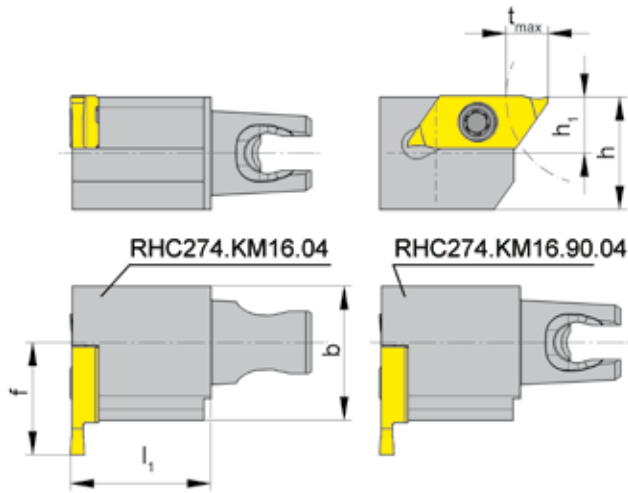
槽宽

Width of groove

0.5 - 2.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LHC274.KM16.04 R/LHC274.KM16.90.04	16	19.1	20	8	16	6	25	04

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

M

### 附件

Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC274.KM16....	030.3509.T15P	T15PQ

M88



# 切槽和侧车削

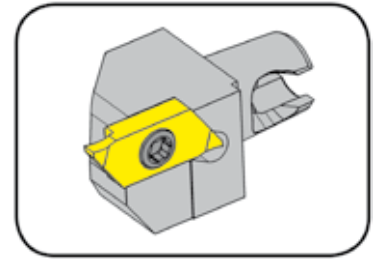
## GROOVING and SIDE TURNING



### 刀柄 型号

TOOLHOLDER Type

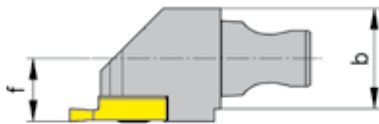
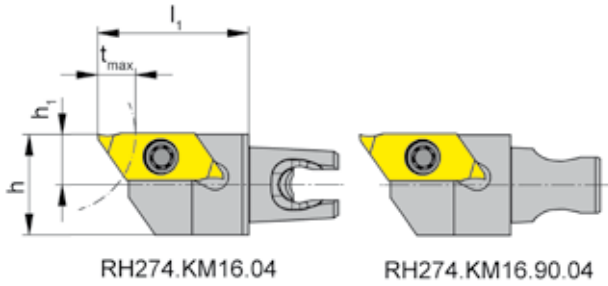
# H274KM



槽宽	Width of groove	0.5 - 2.0 mm
----	-----------------	--------------

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

Kennametal KM16 Micro  
系列  
System Kennametal  
KM16 Micro

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.KM16.04 R/LH274.KM16.90.04	16	16	24	8	10	6	25	04

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀柄 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274.KM16....	030.3509.T15P	T15PQ

M



**D515QL**  
型号 5-15 Nm  
Model

带刻度的扭矩扳手  
-扭矩可调  
-屏幕显示调整扭矩

扭矩无极调节，符合人体工程学的多组件手柄，轻而紧凑的设计，当达到设定扭矩时单击信号按钮。  
(标准: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)  
(精度:  $\pm 6\%$ )

**Torque screw driver with scale**  
- variable torque setting  
- adjusted torque is shown on display

The Torque can be adjusted with a special torque setter (included). Ergonomical form gives perfect handling abilities. Audible signal when set torque is reached.  
(Standard: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)  
(Precision:  $\pm 6\%$ )



**DT27Q**

刀头-Torx螺钉

刀头： 高品质铬钒钢，硬化处理，镀铬  
Wiha镀铬刀头保证了最好的精密度。  
颜色代码为绿色

用途： 拧紧螺钉到指定扭矩，  
和Wiha扭矩扳手手柄组合。

**Blade for TORX-Plus® screws**

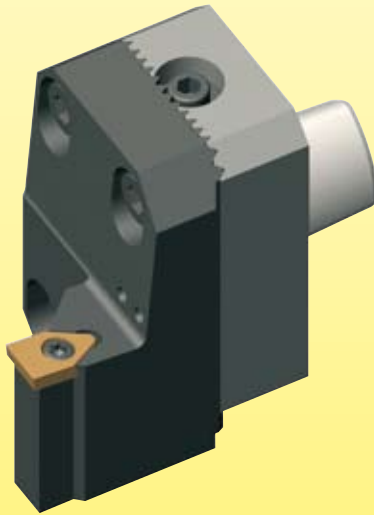
Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.  
Wiha Chrome Blade guarantees maximum precision.  
Colored code dark green

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle.



## HORN 849

高度可调并带内冷  
height-adjustable and with through coolant supply



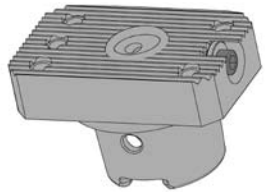
HORN多边形刀柄  
HORN Polygon shank



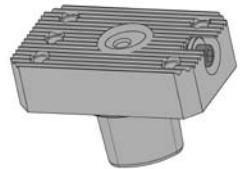
HSKW



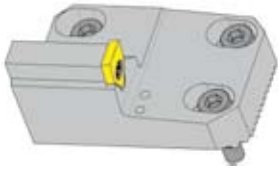
HSKW...849  
页/Page M90



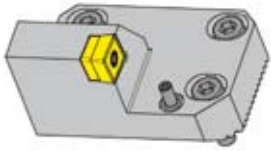
或者  
or



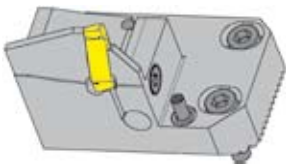
N849.00C...  
页/Page M91



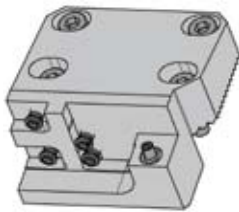
N849.0117...  
页/Page M92-93



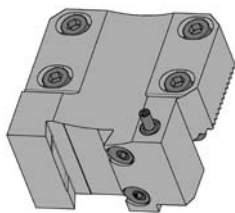
R849...  
页/Page M94



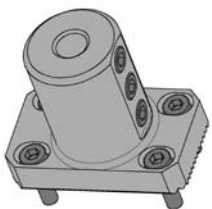
R/L849.0226...  
页/Page M95



R/L849.0220...  
页/Page M96



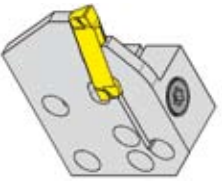
R849.26008R.13.00  
页/Page M97



N849.00...N60.K1  
页/Page M98



N849.00...R50.K2  
页/Page M99



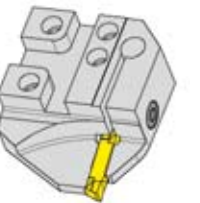
220...



360...



356...



224...

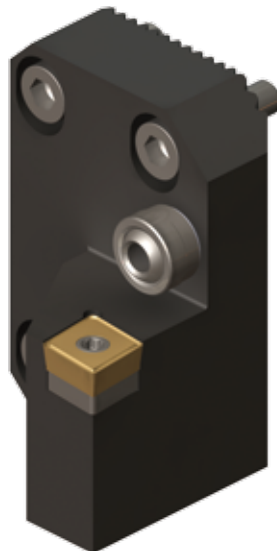
刀夹  
Cassettes



整体式，高度可调  
Monobloc, height-adjustable

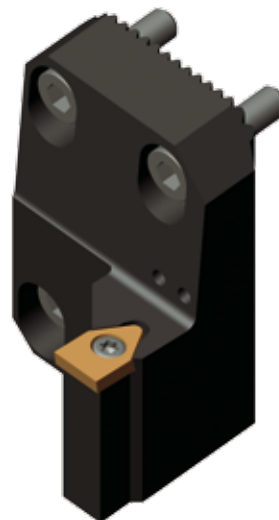
**R849.SCLCR...**

用于 DIN 刀片  
for DIN Insert



**N849.0117R...**

用于 仿形刀片 S117...  
for Profiled insert S117...



**R849.0226R...**

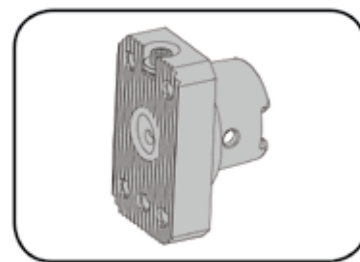
用于 刀片 S229...  
for Insert S229...



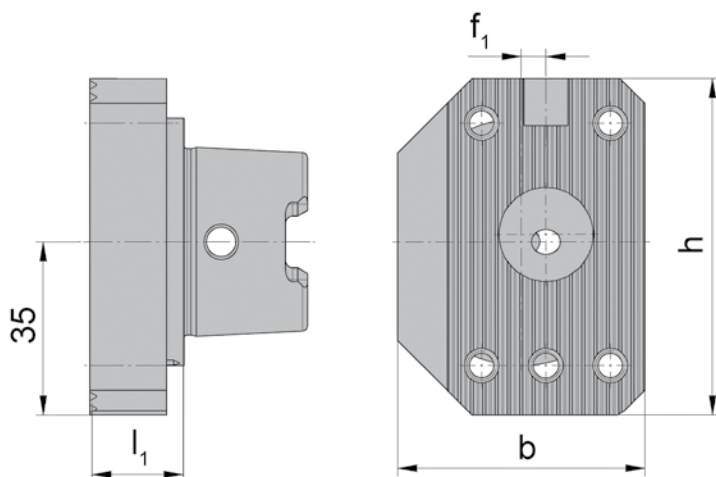
M

常规刀柄 型号  
BASIC TOOLHOLDER Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



传动键槽-低公差 ( ICTM )  
Drive slots with reduced  
tolerance per ICTM

产品型号 Part number	接口系统 Coupling System	h	b	f <sub>1</sub>	刀夹 Cassette
HSKW-N849.0040.01	HSK-C40 ICTM	68	40	-	N/R/L849...
HSKW-L849.0050.01	HSK-C50 ICTM		50	5	N/L849...
HSKW-R849.0050.01	HSK-C50 ICTM		50	5	N/R849...

尺寸单位 : mm  
Dimensions in mm

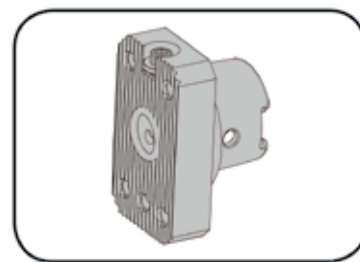
# M

附件  
Spare parts

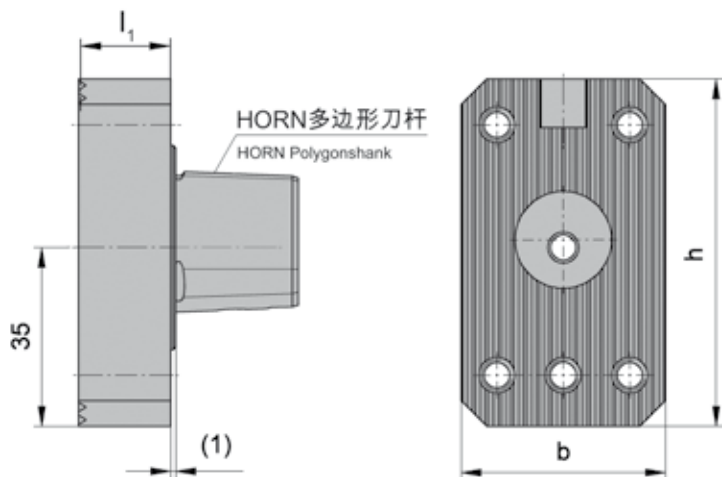
常规刀柄 Basic toolholder	轴向调节螺钉 Adjust screw axial	扳手 Wrench	O型圈 O-ring
HSKW-...	030.0006.0503	SW4,0DIN911	DIN3771-14x2.65B

常规刀柄 型号  
BASIC TOOLHOLDER Type

849C



多主轴SCX系列  
Multispindle Serie SCX



HORN多边形刀柄  
( ISO26623 )  
HORN Polygon shank  
according to ISO 26623

产品型号 Part number	h	b	l <sub>1</sub>	刀夹 Cassette
N849.00C3.01	68	40	18.5	N/L/R849...
N849.00C4.01	68	40	18.5	N/L/R849...

尺寸单位 : mm  
Dimensions in mm

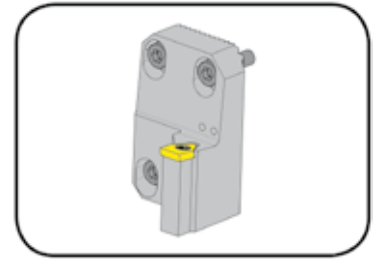
附件  
Spare parts

常规刀柄 Basic toolholder	轴向调节螺钉 Adjust screw axial	扳手 Wrench	O型圈 O-ring
N849.00C...	030.0006.0503	SW4,0DIN911	DIN3771-14x2.65B

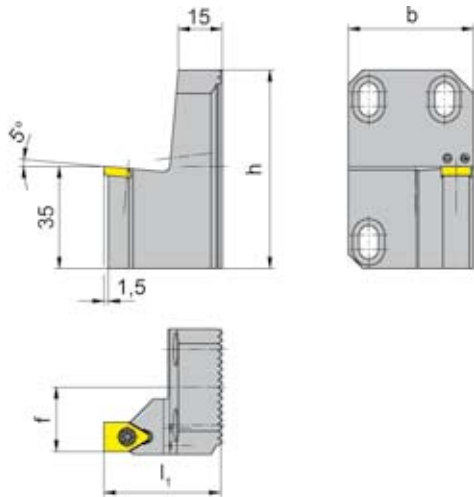
M

刀夹 型号  
CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



高度可调+3.0/-1.0mm  
Height-adjustable  
+3,0/-1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	刀片 Insert
N849.0117R.10.00	68	43	40	22.0	S117...10...
N849.0117R.12.00		43	40	22.0	S117...12...
N849.0117R.16.00		43	45	21.0/22.0	S117...14.../16...
N849.0117R.20.00		43	50	21.0/22.5	S117...18.../20...
N849.0117R.26.00		43	55	22.0	S117...26...
N849.0117R.32.00		41	40	22.0	S117...32...

尺寸单位：mm  
Dimensions in mm

可用刀片，几何槽形及硬质合金牌号见章节O/仿形加工  
For available inserts, geometries and carbide grades please see the **Chapter O / Profiling**.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

# M

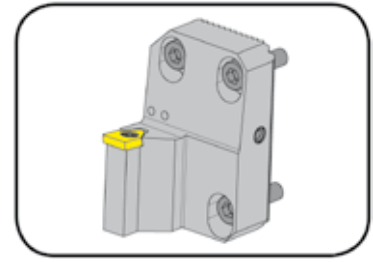
附件  
Spare parts

刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
N849..10.00/..12.00	DIN912-M6x20	4.09T15P	SW5.0DIN911	T15PQ
N849..16.00/..32.00	DIN912-M6x20	5.12T20P	SW5.0DIN911	T20PQ
N849..20.00/..26.00	DIN912-M6x20	6.17T20P	SW5.0DIN911	T20PQ

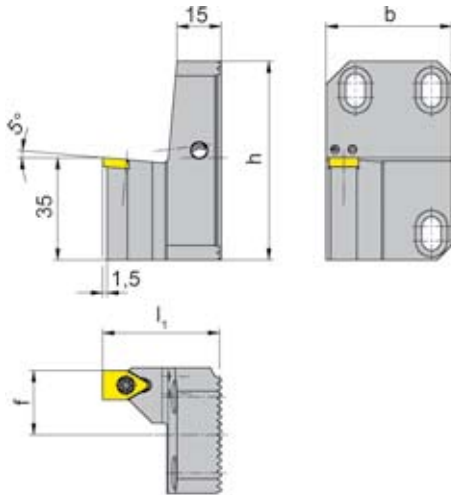


刀夹 型号  
CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



高度可调+3.0/-1.0mm  
Height-adjustable  
+3,0/-1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	刀片 Insert
N849.0117L.10.00	68	43	40	22.0	S117...10...
N849.0117L.12.00		43	40	22.0	S117...12...
N849.0117L.16.00		43	45	21.0/22.0	S117...14.../16...
N849.0117L.20.00		43	50	21.0/22.5	S117...18.../20...
N849.0117L.26.00		43	55	22.0	S117...26...
N849.0117L.32.00		41	40	22.0	S117...32...

尺寸单位：mm  
Dimensions in mm

可用刀片，几何槽形及硬质合金牌号见章节O/仿形加工  
For available inserts, geometries and carbide grades please see the **Chapter O / Profiling**.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

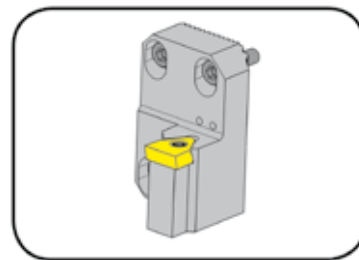
刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
N849..10.00/..12.00	DIN912-M6x20	4.09T15P	SW5.0DIN911	T15PQ
N849..16.00/..32.00	DIN912-M6x20	5.12T20P	SW5.0DIN911	T20PQ
N849..20.00/..26.00	DIN912-M6x20	6.17T20P	SW5.0DIN911	T20PQ

M

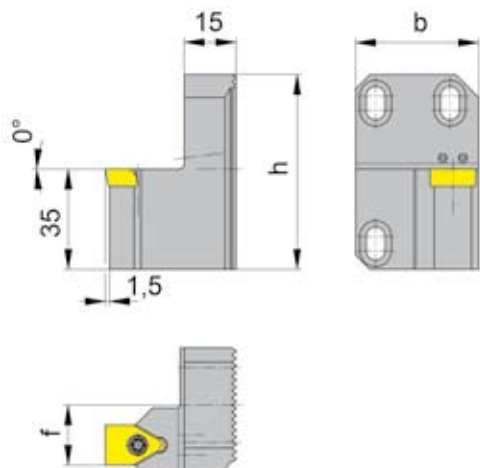
### 刀夹 型号

CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



高度可调+3.0/-1.0mm  
Height-adjustable  
+3,0/-1,0 mm

产品型号 Part number	h	b	$l_1$	f	刀片 Insert
<b>N849.0117R.16.M0</b>	68	43	45	22.0	S117...14.../16...
<b>N849.0117R.20.M0</b>	68	43	50	22.5	S117...18.../20...
<b>N849.0117R.26.M0</b>	68	43	55	22.0	S117...26...
<b>N849.0117R.32.M0</b>	68	41	40	22.0	S117...32...

尺寸单位：mm  
Dimensions in mm

#### 注意事项：

加工黄铜时安装角/前角0°

#### Note:

Mounting angle / rake angle 0° for brass machining

可用刀片，几何槽形及硬质合金牌号见章节O/仿形加工

For available inserts, geometries and carbide grades please see the **Chapter O / Profiling**.

螺丝的扭矩规格，详见技术说明。

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

# M

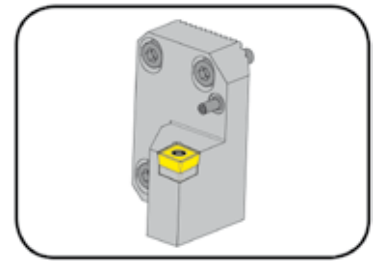
#### 附件

Spare parts

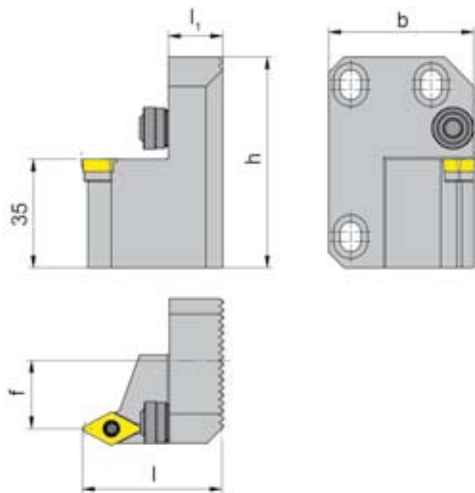
刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
N849..16.M0/..32.M0	<b>DIN912-M6x20</b>	<b>5.12T20P</b>	<b>SW5.0DIN911</b>	<b>T20PQ</b>
N849..20.M0/..26.M0	<b>DIN912-M6x20</b>	<b>6.17T20P</b>	<b>SW5.0DIN911</b>	<b>T20PQ</b>

刀夹 型号  
CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	l	刀片 Insert
R849.SCLCR.12.00	68	45.1	17	27.0	45	CCMT 120408
R849.SCLCR.09.00		45.5		27.0	45	CCMT 09T308
R849.SDNCR.11.00		45.5		22.0	45	DCMT 11T308
R849.SVJBR.16.00		46.2		27.0	50	VBMT 160408
R849.SDJCR.11.00		46.7		27.0	45	DCMT 11T308
R849.SVJBL.16.00		49.5		14.9	50	VBMT 160408

尺寸单位：mm  
Dimensions in mm



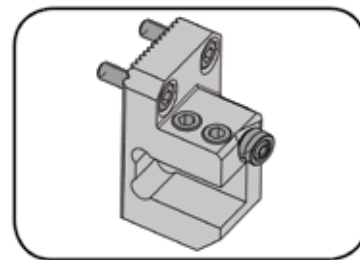
附件  
Spare parts

刀夹 Cassette	冷却喷嘴 Coolant spray nozzle
R849.S...	020.1210.2966

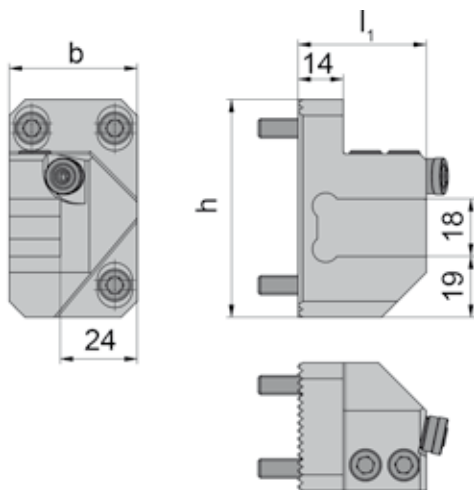
M

接头 型号  
ADAPTOR Type

# N849



多主轴SCX系列  
Multispindle Serie SCX



高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	刀柄 Toolholder
<b>N849.1616L.60.K1</b>	68	40	40	...1616...

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

# M

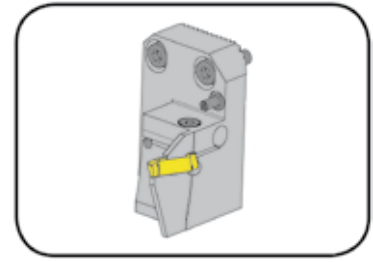
附件  
Spare parts

接头 Adaptor	螺钉 Screw	圆柱螺钉 Cylindrical Screw	扳手 Wrench	冷却喷嘴 Coolant spray nozzle
N849.1616L.60.K1	<b>DIN1835-B M10x12</b>	<b>DIN912-M6x20</b>	<b>SW5,0DIN911</b>	<b>020.1008.2976</b>

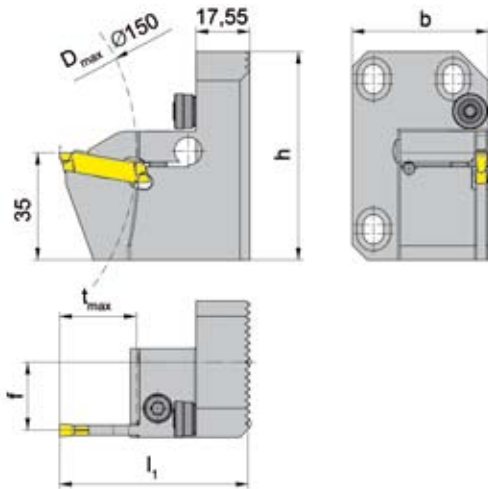
M100

刀夹 型号  
CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	t <sub>max</sub>	刀片 Insert
L849.0226L.00.03	68	45.5	61.5	23.0	25	S229.0300/0400...
L849.0226L.00.04				22.2		S229.0400/0500...
L849.0226L.00.05				21.7		S229.0600...
L849.0226L.00.07				20.7		S229.0800...
R849.0226R.00.03	68	45.5	61.5	23.0	25	S229.0300/0400...
R849.0226R.00.04				22.2		S229.0400/0500...
R849.0226R.00.05				21.7		S229.0600...
R849.0226R.00.07				20.7		S229.0800...

尺寸单位：mm  
Dimensions in mm

可用刀片，几何槽形及硬质合金牌号见章节G/229系列  
For available inserts, geometries and carbide grades please see the **Chapter G / System 229**.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

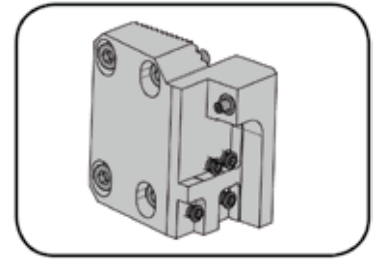
刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L849.0226R/L.00.0...	DIN912-M6x20	6-23T25P	SW5,0DIN911	T25PQ	020.1008.2976

M

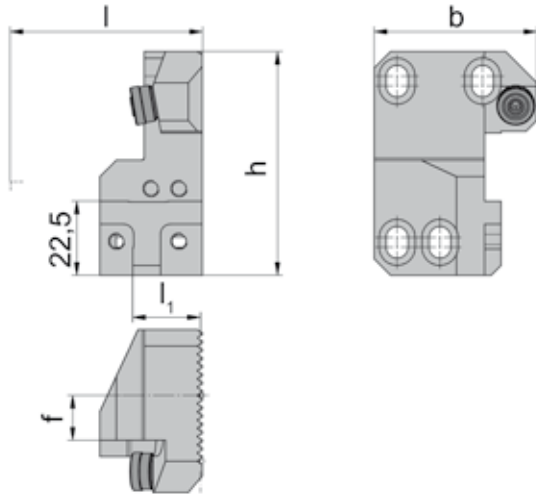
### 刀夹接 型号

ADAPTER FOR CASSETTES Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	l	刀夹 Cassette
L849.0220L.49.00 R849.0220R.49.00	68	49.5	20.5	13.6	l <sub>1</sub> +l <sub>k</sub>	LNK... RNK...
L849.0220L.41.00 R849.0220R.41.00	68	65.5	14.5	30.6	l <sub>1</sub> +l <sub>k</sub>	LNK... RNK...

l<sub>k</sub>见刀夹  
l<sub>k</sub> see cassettes

尺寸单位：mm  
Dimensions in mm

# M

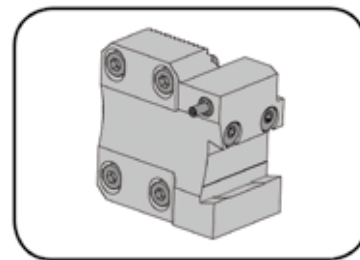
### 附件 Spare parts

刀夹接口 Adapter for cassettes	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却喷嘴 Coolant spray nozzle
R/L849.0220R/L.4...	DIN912-M6x20	5.12T20P	SW5,0DIN911	T20PQ	020.1008.2976

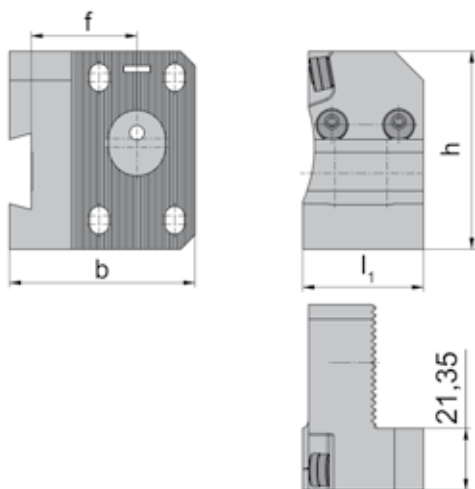
### 配合刀板的接头 型号

ADAPTOR FOR BLADES Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	f	刀板 Blade
<b>R849.2608R.13.00</b>	68	63.8	41.5	36.3	...2608...

尺寸单位：mm  
Dimensions in mm

可用刀板见 **P/切断**  
For the available blades please see the **Chapter P / Parting off**.

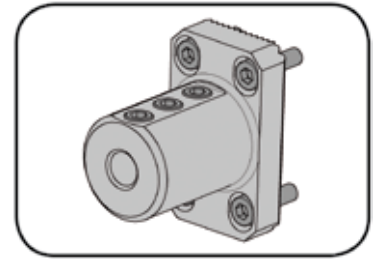
### 附件

Spare parts

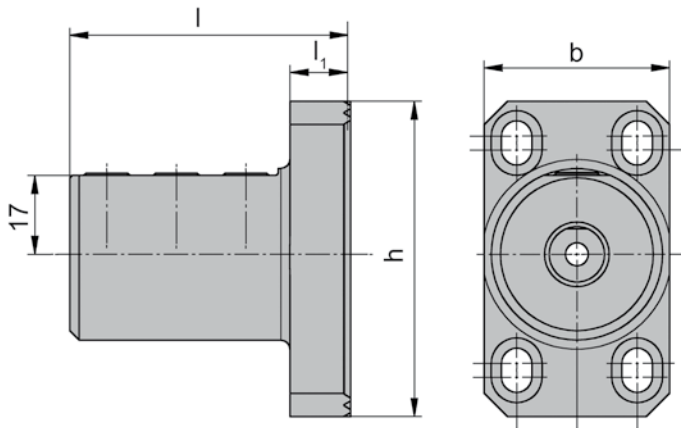
配合刀板的接头 Adaptor for blades	螺钉 Screw	扳手 Wrench	楔形块 Wedge	冷却喷嘴 Coolant spray nozzle
R849.2608R.13.00	<b>DIN912-M6x25</b>	<b>SW5,0DIN911</b>	<b>020.0011.1002</b>	<b>020.1008.2977</b>

刀夹 型号  
CASSETTE Type

849



多主轴SCX系列  
Multispindle Serie SCX



高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	l	镗杆 Boring bar
N849.0012N.60.K1	68	40	12.45	60	Ø 12
N849.0016N.60.K1					Ø 16
N849.0020N.60.K1					Ø 20

尺寸单位：mm  
Dimensions in mm

可用镗刀柄见Supermini®&Mini样本(KMINI100)  
For the available boring bars please see our Supermini® & Mini catalog (KMINI100)

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

M

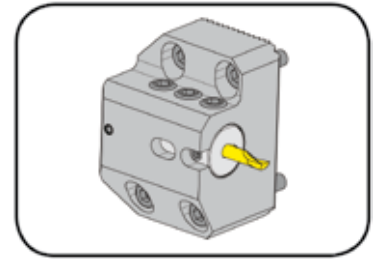
附件  
Spare parts

刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench
N849.00...	DIN912-M6x20	DIN1835-B M10x12	SW5,0DIN911

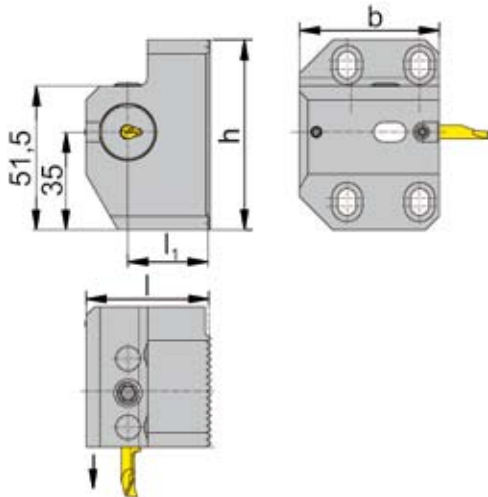


刀夹 型号  
CASSETTE Type

# 849



多主轴SCX系列  
Multispindle Serie SCX



可调长度+2mm  
Lenght adjustable + 2 mm



高度可调  
±1.0mm  
Height-adjustable  
± 1,0 mm

产品型号 Part number	h	b	l <sub>1</sub>	l	镗杆 Boring bar
<b>R849.0012R.50.K2</b>	68	50	29	40	B105.0012.0351
<b>R849.0016R.50.K2</b>				42	B105.0016.0352
<b>R849.0020R.50.K2</b>				44	B105.0020.0325

尺寸单位：mm  
Dimensions in mm

### 订货须知：

镗刀柄不包括在内-需另行订购

### Ordering note:

Boring bars are not included - separate order required!

可用刀片见样本**KMINI100**.

For the available inserts please see our catalogue **KMINI100**.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	螺钉 Screw	螺钉 Screw	轴向调节螺钉 Adjust screw axial	扳手 Wrench
R849.0012R.50.K2	<b>DIN912-M6x20</b>	<b>DIN912-M6x40</b>	<b>DIN913-M8x12</b>	<b>030.5060.0596</b>	<b>SW2.5DIN911</b>
R849.0016R.50.K2	<b>DIN912-M6x20</b>	<b>DIN912-M6x40</b>	<b>DIN913-M8x12</b>	<b>030.5060.0596</b>	<b>SW5.0DIN911</b>
R849.0020R.50.K2	<b>DIN912-M6x20</b>	<b>DIN912-M6x40</b>	<b>DIN913-M8x12</b>	<b>030.5060.0596</b>	<b>SW5.0DIN911</b>

刀夹 Cassette	螺纹锁紧销 Threaded pin	扳手 Wrench	扳手 Wrench
R849.0012R.50.K2	<b>030.1008.0648</b>	<b>SW5.0DIN911</b>	<b>SW4.0DIN911</b>
R849.0016R.50.K2		<b>SW5.0DIN911</b>	<b>SW4.0DIN911</b>
R849.0020R.50.K2		<b>SW5.0DIN911</b>	

M

# HCG - HORN Catalogue Guide

## 端面切槽 / FACE GROOVING

槽外径 Ø Outer groove Ø	产品线 / Product line						
	105	A110	114	312	231/N231	S224	S229
自 / from 5	•						
自 / from 12			•				
自 / from 20		•		•			
自 / from 38						•	
自 / from 40					•		
自 / from 60							•

槽深 Depth of groove	产品线 / Product line						
	105	A110	114	312	231/N231	S224	S229
可达 / up to 3				•			
可达 / up to 6	•		•				
可达 / up to 8					•		
可达 / up to 14							
可达 / up to 18						•	
可达 / up to 25							•
可达 / up to 30		•					

槽宽 Width of groove	105	A110	114	312	231/N231	S224	S229
	1.0 - 3.0	3.0	1.0 - 3.0	1.5 - 3.0	3.0 - 10.0	3.0 - 6.0	4.0 - 6.0

章 Chapter	N						
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端面切槽  
FACE GROOVING

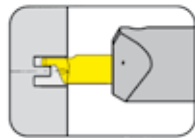
N

范围  
Range

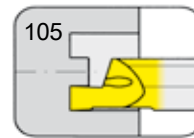
刀杆  
Toolholder

刀片  
Inserts

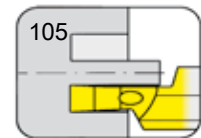
槽外径 $\varnothing$   $\geq 5$  mm  
槽深 max. 6 mm  
槽宽 可达 3 mm  
Outer groove  $\varnothing$   $\geq 5$  mm  
Depth of groove max. 6 mm  
Width of groove up to 3 mm



页/Page  
N2-N6

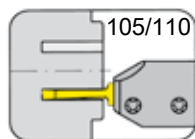


页/Page  
N7-N9, N11

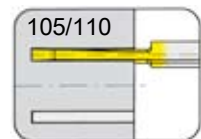


页/Page  
N10

槽外径 $\varnothing$   $\geq 20$  mm  
槽深 max. 30 mm  
槽宽 3 mm  
Outer groove  $\varnothing$   $\geq 20$  mm  
Depth of groove max. 30 mm  
Width of groove 3 mm

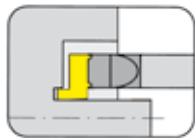


页/Page  
N12/N16

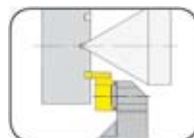


页/Page  
N13/N17-N18

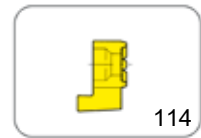
槽外径 $\varnothing$   $\geq 12$  mm  
槽深 max. 6 mm  
槽宽 可达 3 mm  
Outer groove  $\varnothing$   $\geq 12$  mm  
Depth of groove max. 6 mm  
Width of groove up to 3 mm



页/Page  
N20-N22

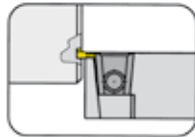


页/Page  
N23

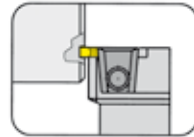


页/Page  
N24-N27

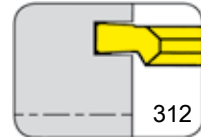
槽外径 $\varnothing$   $\geq 20$  mm  
槽深 max. 3 mm  
槽宽 1.5 - 3 mm  
Outer groove  $\varnothing$   $\geq 20$  mm  
Depth of groove max. 3 mm  
Width of groove 1.5 - 3 mm



页/Page  
N30

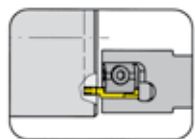


页/Page  
N31

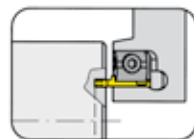


页/Page  
N32

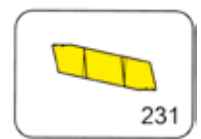
槽外径 $\varnothing$   $\geq 40$  mm  
槽深 max. 8 mm  
槽宽 3 - 10 mm  
Outer groove  $\varnothing$   $\geq 40$  mm  
Depth of groove max. 8 mm  
Width of groove 3 - 10 mm



页/Page  
N34

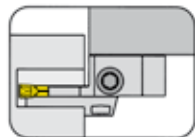


页/Page  
N35

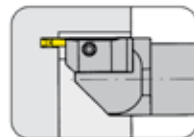


页/Page  
N36

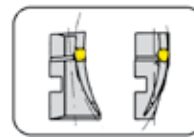
槽外径 $\varnothing$  38-1000 mm  
槽深 max. 18 mm  
槽宽 3 - 6 mm  
Outer groove  $\varnothing$  38-1000 mm  
Depth of groove max. 18 mm  
Width of groove 3 - 6 mm



页/Page  
N38-N39



页/Page  
N40

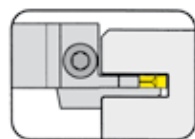


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N41-N48

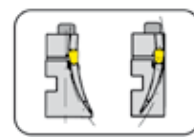


页/Page  
N49-N51

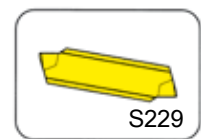
槽外径 $\varnothing$  60-1000 mm  
槽深 max. 25 mm  
槽宽 4 - 6 mm  
Outer groove  $\varnothing$  60-1000 mm  
Depth of groove max. 25 mm  
Width of groove 4 - 6 mm



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N52-N55



页/Page  
N56-N71



页/Page  
N72-N75

技术说明见章节Q

For Technical Instructions please see chapter Q

# 端面切槽

## FACE GROOVING

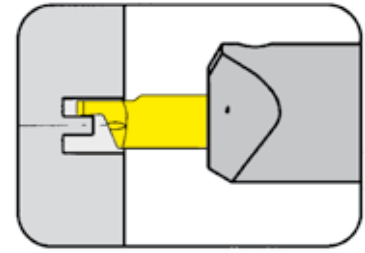


### 刀杆 型号

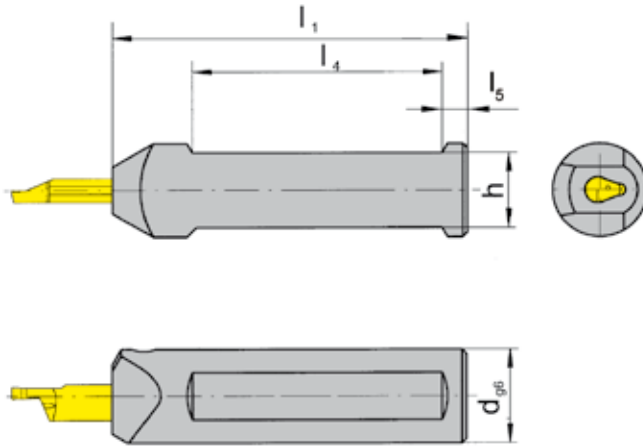
TOOLHOLDER Type

## B105

带内冷  
with through coolant supply



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深	Depth of groove	6.0 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type

图示=左手型切削  
Picture = left hand cutting version

产品型号 Part number	d	$l_1$	h	$l_4$
<b>B105.0010.01</b>	10	75	9	50
<b>B105.0012.01</b>	12	75	11	50
<b>B105.0016.01</b>	16	75	14	50
<b>B105.0020.01</b>	20	90	18	55
<b>B105.0025.01</b>	25	100	23	55

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

#### 订货须知：

刀杆可以安装左，右手刀片

#### Ordering note:

Toolholders can be used with right and left hand inserts.

螺丝的扭矩规格，详见技术说明。

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

#### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.00...	<b>6.075T15P</b>	<b>T15PQ</b>

# 端面切槽

## FACE GROOVING

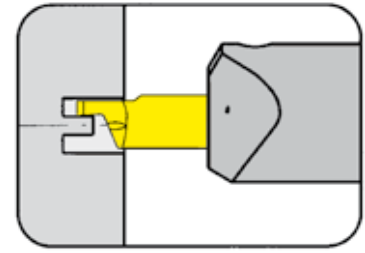


### 刀杆 型号

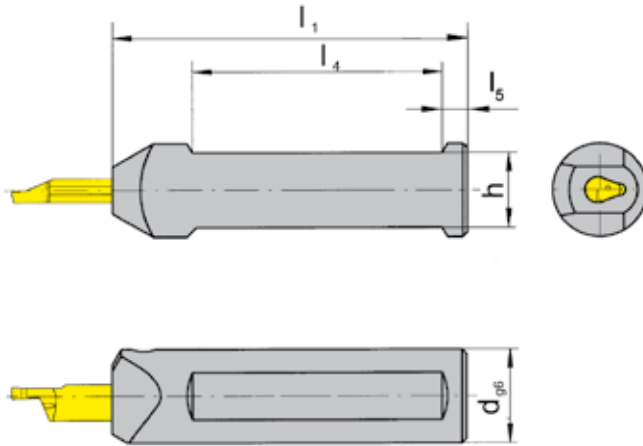
TOOLHOLDER Type

## B105/BU105

带内冷  
with through coolant supply



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀片  
for use with Insert

型号 105  
Type

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	$l_1$	h	$l_4$	$l_5$	备注 Remark
<b>B105.0022.01</b>	22	90	20.00	55	5	-
<b>B105.0028.01</b>	28	120	26.00	72	12	**
<b>BU105.0750.5.01</b>	3/4"	90	17.04	70	5	**
<b>BU105.1000.5.01</b>	1"	90	23.40	65	5	**

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

\*\* 用于Traub机床带有M12x1.5冷却管接头的刀杆

\*\* Adapter of cooling M12x1,5 for Traub

订货须知：

刀杆可以安装左，右手刀片

**Ordering note:**

Toolholders can be used with right and left hand inserts.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B/BU105...	<b>6.075T15P</b>	<b>T15PQ</b>

# 端面切槽 FACE GROOVING

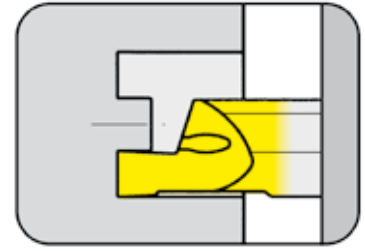


## 刀杆 型号

TOOLHOLDER Type

## H105

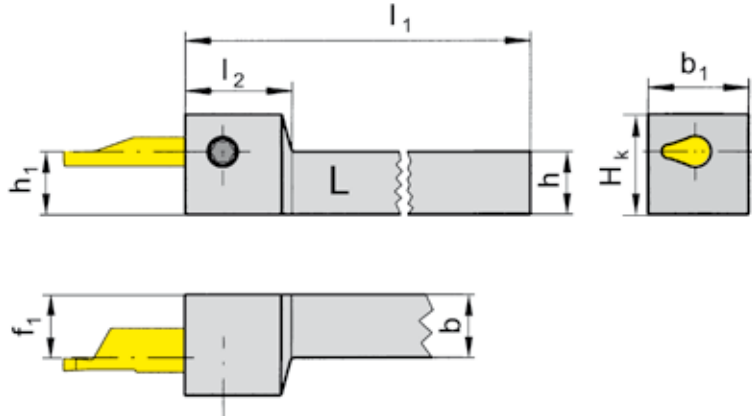
螺钉锁紧  
with screwed clamping



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽可达	Width of groove up to	3.0 mm

带内冷

with through coolant supply



配合 刀片

for use with Insert

型号 105

Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	$l_1$	$l_2$	h	$h_1$	$f_1$	b	$b_1$	$H_k$
R/LH105.0808.01	90	17	8	8	7.5	8	16	14
R/LH105.1010.01	90	17	10	10	7.5	10	16	16
R/LH105.1212.01	90	17	12	12	7.5	12	16	18
R/LH105.1616.01	110	17	16	16	7.5	16	16	22

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH105....	6.075T15P	T15PQ

# 端面切槽 FACE GROOVING

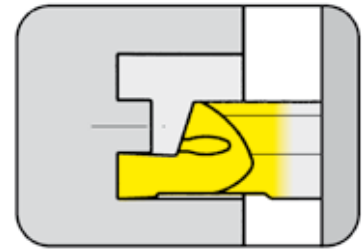


## 刀杆 型号

TOOLHOLDER Type

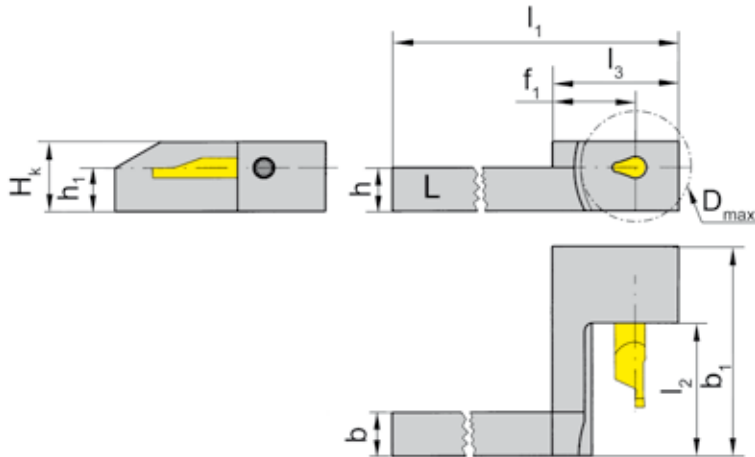
## HC105

螺钉锁紧  
with screwed clamping



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽可达	Width of groove up to	3.0 mm

通过曲型接头供给冷却液  
Coolant supply through cranked fitting



配合 刀片  
for use with Insert

型号 105  
Type

L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$l_3$	$b$	$b_1$	$D_{max}$	$H_K$	备注 Remark
R/LHC105.0707.21	99	18	7	7	19	29	7	32.0	26	13	*
R/LHC105.0808.21	99	18	8	8	19	29	8	32.0	26	13	*
RHC105.1010.11	99	8	10	10	19	29	10	22.7	26	16	*
R/LHC105.1010.21	99	18	10	10	19	29	10	38.0	26	16	
R/LHC105.1010.41		28						48.0			
R/LHC105.1212.21	99	18	12	12	19	29	12	38.0	26	18	
R/LHC105.1212.41		28						48.0			
R/LHC105.1616.21	104	18	16	16	24	34	16	38.0	36	22	
R/LHC105.1616.41		28						48.0			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

注意事项：  
\*=无内冷!

按需提供更多尺寸  
Further sizes upon request

Note:  
\* = no through coolant supply!

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	旋紧型角度接头 Screwed angle fitting
R/LHC105..07./08..	6.075T15P	T15PQ	
RHC105...11	6.075T15P	T15PQ	-
R/LHC105.1...21/41	6.075T15P	T15PQ	KQ2L06-M5

# 端面切槽 FACE GROOVING

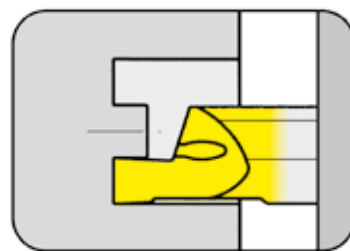


## 刀杆 型号

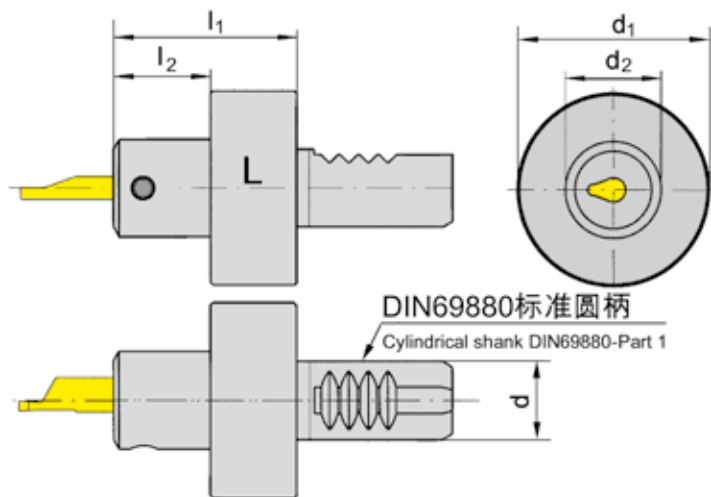
TOOLHOLDER Type

## VDI

带内冷  
with through coolant supply



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽可达	Width of groove up to	3.0 mm



DIN69880标准圆柄  
Cylindrical shank DIN69880-Part 1

L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

配合 刀片  
for use with Insert

型号 105  
Type

产品型号 Part number	d	$l_1$	$l_2$	$d_2$	$d_1$
VDI16-R/L105.20.01	16	38	20	20	40
VDI20-R/L105.20.01	20	38	20	20	50
VDI25-R/L105.20.01	25	38	20	20	58
VDI30-R/L105.20.01	30	38	20	20	68
VDI40-R/L105.20.01	40	38	20	20	83

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

## 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
VDI...	6.075T15P	T15PQ

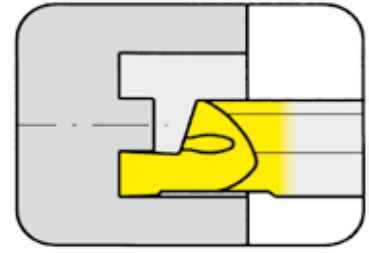


# 端面切槽 FACE GROOVING

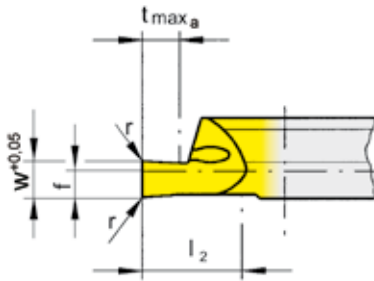
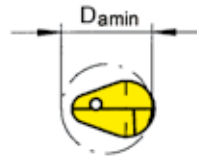
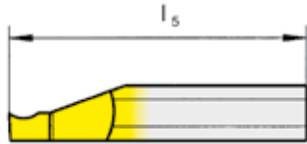


刀片型号  
INSERT Type

## 105



端面槽起始外径	from outer groove $\varnothing$	5.0 mm
槽深	Depth of groove	5.0 mm
槽宽可达	Width of groove up to	2.0 mm



配合 刀杆  
for use with Toolholder

型号 B105  
Type H105  
HC105  
VDI

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	f	$l_2$	$l_5$	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
R/L105.0510.1.8	1.0					2		▲/△		▲/▲	
R/L105.0515.1.8	1.5	0.05	2	10	25	3	5	▲/△		▲/▲	
R/L105.0520.1.8	2.0					5		▲/△		▲/▲	
R/L105.0510.2.8	1.0					2		△/△		▲/▲	
R/L105.0515.2.8	1.5	0.05	2	15	35	3	5	△/△		▲/▲	
R/L105.0520.2.8	2.0					5		△/△		▲/▲	
								P	○	●	●
								M	●	●	●
								K	●	●	●
								N	●	●	●
								S	●	●	●
								H			

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

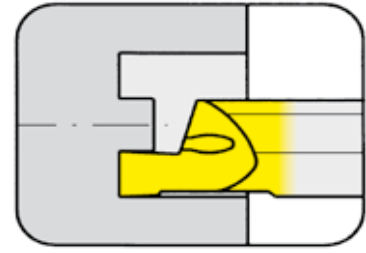
# 端面切槽

## FACE GROOVING



刀片型号  
INSERT Type

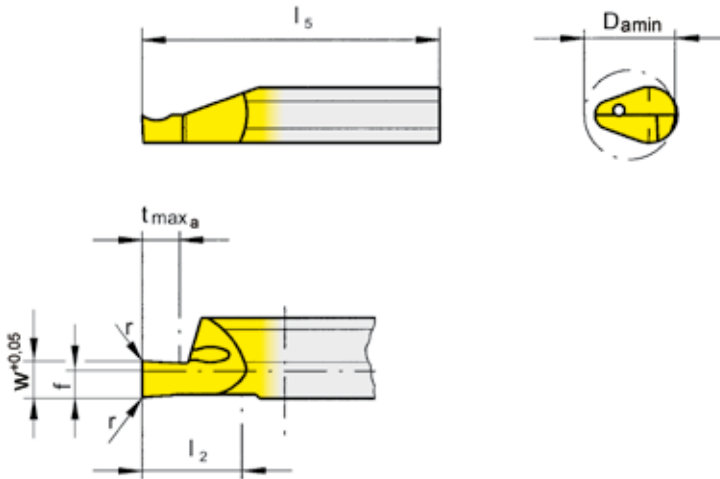
# 105



端面槽起始外径	from outer groove $\varnothing$	6.0 mm
槽深	Depth of groove	5.0 mm
槽宽可达	Width of groove up to	2.0 mm

配合刀杆  
for use with Toolholder

型号 B105  
Type H105  
HC105  
VDI



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	f	l <sub>2</sub>	l <sub>5</sub>	t <sub>max a</sub>	D <sub>a min</sub>	硬质合金牌号			
								MG12	TN35	TI25	TH35
R/L105.0610.1.8	1.0					2		▲/△		▲/▲	
R/L105.0615.1.8	1.5	0.05	2	10	25	3	6	▲/△		▲/▲	
R/L105.0620.1.8	2.0					5		▲/△		▲/▲	
R/L105.0610.2.8	1.0					2		△/△		▲/△	
R/L105.0615.2.8	1.5	0.05	2	15	35	3	6	▲/		▲/△	
R/L105.0620.2.8	2.0					5		▲/△		▲/▲	
▲ 库存 / on stock    △ 4周 / 4 weeks								P	○		●
● 主要应用 / main recommendation								M	●		●
○ 可选推荐 / alternative recommendation								K	●		●
■ 无涂层牌号 / uncoated grades								N	●		●
■ 涂层牌号 / coated grades								S	●		●
■ 钎焊/金属陶瓷 / brazed/Cermet								H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

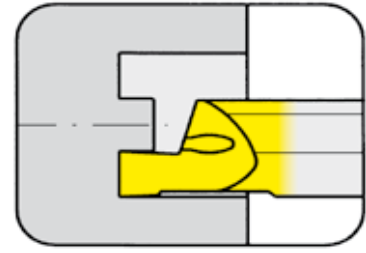
硬质合金牌号  
Carbide grades

# 端面切槽 FACE GROOVING



刀片型号  
INSERT Type

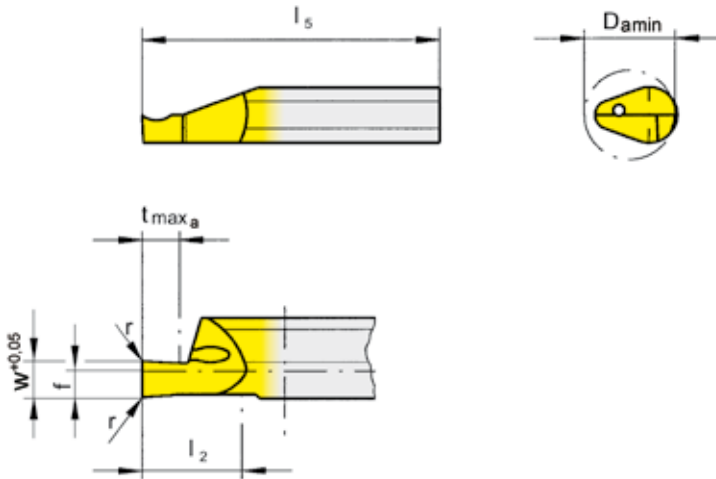
## 105



端面槽起始外径	from outer groove $\varnothing$	8.0 mm
槽深	Depth of groove	6.0 mm
槽宽可达	Width of groove up to	3.0 mm

配合刀杆  
for use with Toolholder

型号 B105  
Type H105  
HC105  
VDI



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	f	$l_2$	$l_5$	$t_{max a}$	$D_{a min}$		MG12	TN35	TI25	TH35
R/L105.0810.1.8	1.0					2					▲/▲	
R/L105.0815.1.8	1.5					3					▲/▲	
R/L105.0820.1.8	2.0	0.15	2	10	25	4	8				▲/▲	
R/L105.0825.1.8	2.5					5					▲/▲	
R/L105.0830.1.8	3.0					6					▲/▲	
R/L105.0810.2.8	1.0					2					▲/▲	
R/L105.0815.2.8	1.5					3					▲/▲	
R/L105.0820.2.8	2.0	0.15	2	15	35	4	8				▲/▲	
R/L105.0825.2.8	2.5					5					▲/▲	
R/L105.0830.2.8	3.0					6					▲/▲	
▲ 库存 / on stock									P		•	
● 主要应用 / main recommendation									M		•	
○ 可选推荐 / alternative recommendation									K		•	
■ 无涂层牌号 / uncoated grades									N		•	
■ 涂层牌号 / coated grades									S		•	
■ 钎焊/金属陶瓷 / brazed/Cermet									H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

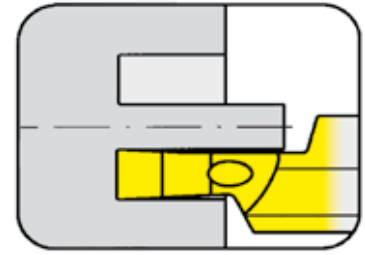
硬质合金牌号  
Carbide grades

# 端面切槽 FACE GROOVING



刀片型号  
INSERT Type

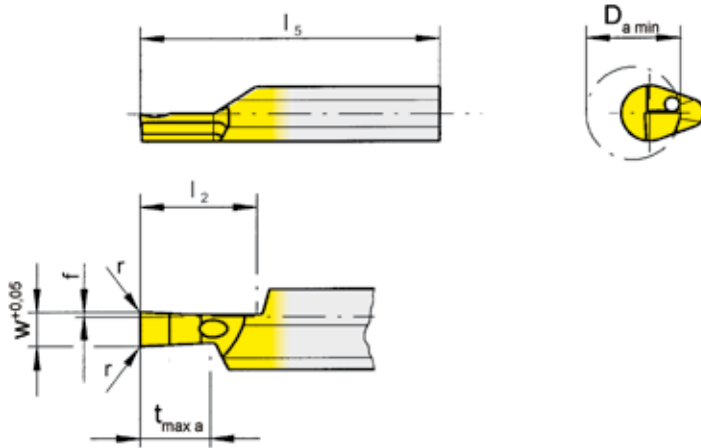
## 105



端面槽起始外径	from outer groove $\varnothing$	8.0 mm
槽深	Depth of groove	6.0 mm
槽宽可达	Width of groove up to	3.0 mm

配合刀杆  
for use with Toolholder

型号 B105  
Type H105  
HC105  
VDI



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	f	$l_2$	$l_5$	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
R/L105.0810.1.9	1.0					2				▲/▲	
R/L105.0815.1.9	1.5					3				▲/▲	
R/L105.0820.1.9	2.0	0.15	0.4	10	25	4	8			▲/▲	
R/L105.0825.1.9	2.5					5				▲/▲	
R/L105.0830.1.9	3.0					6				▲/▲	
▲ 库存 / on stock    Δ 4周 / 4 weeks								P		•	
● 主要应用 / main recommendation								M		•	
○ 可选推荐 / alternative recommendation								K		•	
■ 无涂层牌号 / uncoated grades								N		•	
■ 涂层牌号 / coated grades								S		•	
■ 钎焊/金属陶瓷 / brazed/Cermet								H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

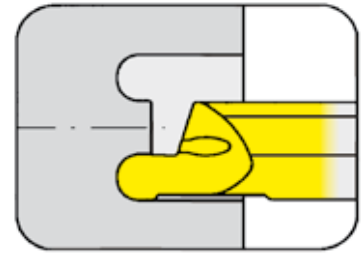
硬质合金牌号  
Carbide grades

# 端面切槽 FACE GROOVING

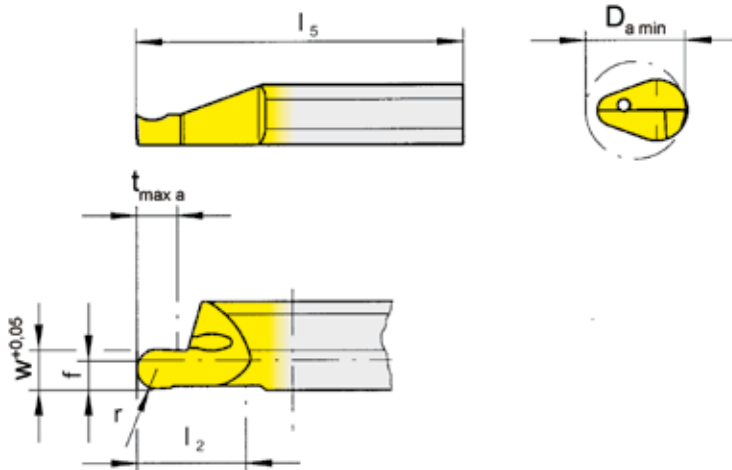


刀片型号  
INSERT Type

## 105



端面槽起始外径	from outer groove $\varnothing$	8.0 mm
槽深	Depth of groove	6.0 mm
槽宽可达	Width of groove up to	3.0 mm



配合刀杆  
for use with Toolholder

型号 B105  
Type H105  
HC105  
VDI

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

圆头  
Full radius

产品型号 Part number	w	r	f	$l_2$	$l_5$	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
R/L105.8V10.1.8	1.0	0.50				2				▲/▲	
R/L105.8V16.1.8	1.6	0.80				3				▲/▲	
R/L105.8V20.1.8	2.0	1.00	2	10	25	4	8			▲/▲	
R/L105.8V25.1.8	2.5	1.25				5				▲/▲	
R/L105.8V30.1.8	3.0	1.50				6				▲/▲	
R/L105.8V10.2.8	1.0	0.50				2				▲/▲	
R/L105.8V16.2.8	1.6	0.80				3				▲/▲	
R/L105.8V20.2.8	2.0	1.00	2	15	35	4	8			▲/▲	
R/L105.8V25.2.8	2.5	1.25				5				▲/▲	
R/L105.8V30.2.8	3.0	1.50				6				▲/▲	

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P			●
M			●
K			●
N			●
S			●
H			

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

注明R或L型  
State R or L version



# 端面切槽

## FACE GROOVING

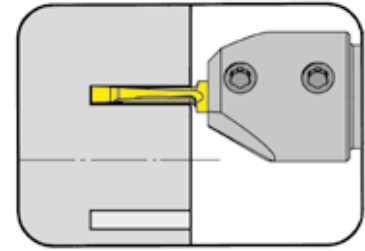


### 刀杆 型号

TOOLHOLDER Type

## B105

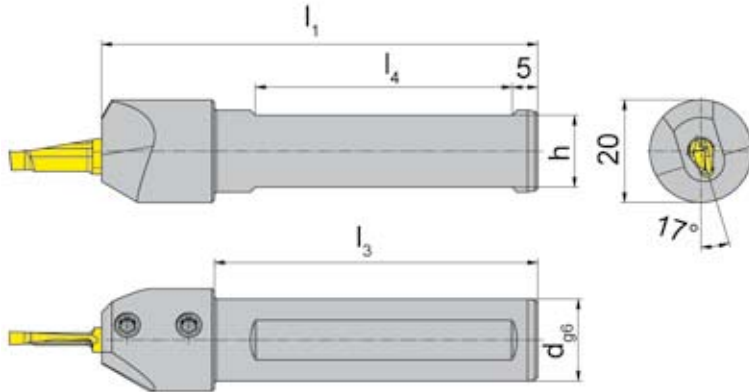
带内冷  
with through coolant supply



端面槽起始外径	from outer groove $\varnothing$	10.0 mm
槽深	Depth of groove	15.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

加长型刀杆

Extended depth of insert seat



配合 刀片

for use with Insert

型号 A105

Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	d	$l_1$	h	$l_3$	$l_4$
R/LB105.0016.12.2	16	85	14	63	50
R/LB105.0020.12.2	20	100	18	-	55

注明R或L型

State R or L version

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB105.00...	6.075T15P	T15PQ

# 端面切槽

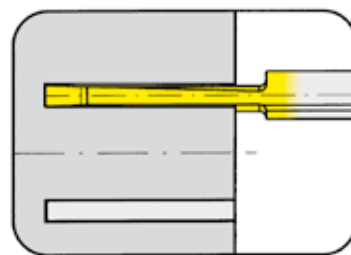
## FACE GROOVING



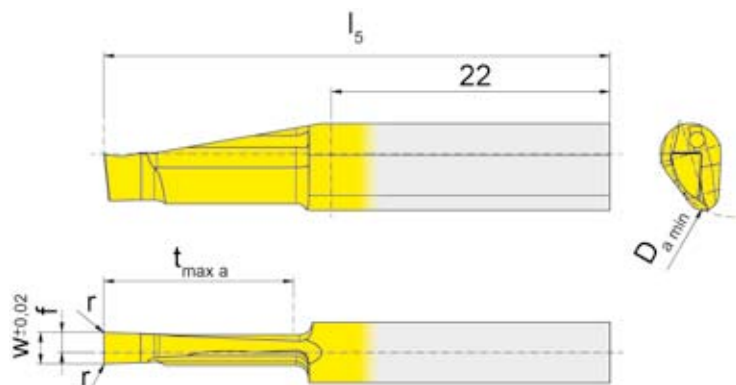
### 刀片型号

INSERT Type

## A105



端面槽起始外径	from outer groove $\varnothing$	10.0 mm
槽深	Depth of groove	15.0 mm
槽宽	Width of groove	2.0 - 3.0 mm



### 配合刀杆

for use with Toolholder

型号 B105...12.2

Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	w	r	f	l <sub>5</sub>	t <sub>max a</sub>	D <sub>a min</sub>	硬质合金牌号			
							MG12	TN35	TI25	TH35
R/LA105.1020.2.2	2.0		1.4					▲/△		
R/LA105.1025.2.2	2.5	0.1	1.6	40	15	10		▲/△		
R/LA105.1030.2.2	3.0		1.9					▲/△		
▲ 库存 / on stock    △ 4周 / 4 weeks							P		●	
● 主要应用 / main recommendation							M		●	
○ 可选推荐 / alternative recommendation							K		●	
■ 无涂层牌号 / uncoated grades							N		●	
■ 涂层牌号 / coated grades							S		●	
■ 钎焊/金属陶瓷 / brazed/Cermet							H			

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

刀片RA105安装于刀杆RB105上

刀片LA105安装于刀杆LB105上

**Note:**

Use insert RA105 in toolholder RB105

Use insert LA105 in toolholder LB105

Dmin在10和40mm之间时, 可达到满切情况下的最大切深

Face grooving with full width of the full depth only possible between D<sub>amin</sub> 10 - 40 mm!

硬质合金牌号

Carbide grades

### 端面切槽-多刀片

基于224系列的刀具可以用于前端面和后端面的切槽加工。  
刀杆配有可更换和可调节的刀夹

材料: 20MnCr5

切削参数:

$$v_c = 180 \text{ m/min}$$

$$v_f = 0.16 \text{ mm}$$



#### Face grooving - Multitool

based on the insert system S224, the tool is used to do a front and back face grooving operation.

The toolholder is equipped with exchangeable and adjustable cartridges.

**Material : 20MnCr5**

Cutting data:

$$v_c = 180 \text{ m/min}$$

$$v_f = 0.16 \text{ mm}$$



# 刀片 型号 110 - 精密研磨 -

Insert type 110  
- precision ground -



自 槽外径 $\varnothing$	20 mm
槽深 可达	30 mm

from Outer groove $\varnothing$	20 mm
Depth of groove up to	30 mm

# 端面切槽

## FACE GROOVING

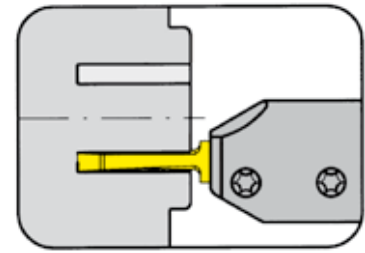


### 刀杆 型号

TOOLHOLDER Type

## B110

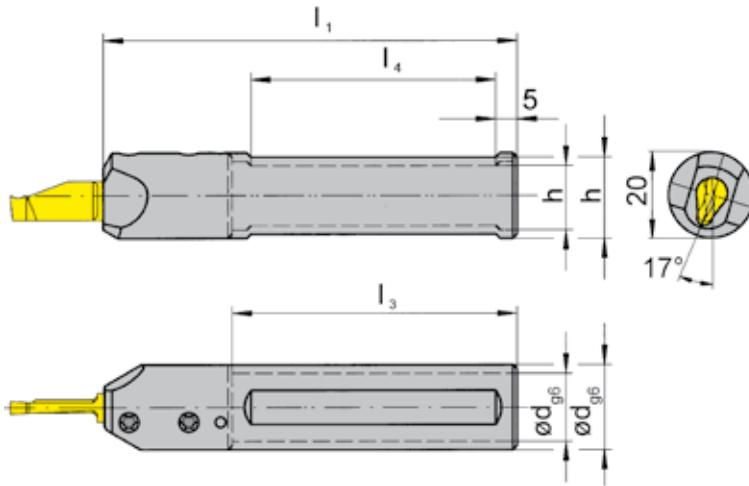
带内冷  
with through coolant supply



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深	Depth of groove	30.0 mm
槽宽可达	Width of groove up to	3.0 mm

加长型刀杆

Extended depth of insert seat



配合 刀片

for use with Insert

型号 A110

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	d	$l_1$	h	$l_3$	$l_4$
R/LB110.0016.16.2	16	100	14	70	55
R/LB110.0020.16.2	20	100	18	-	55

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB110.00...	6.075T15P	T15PQ

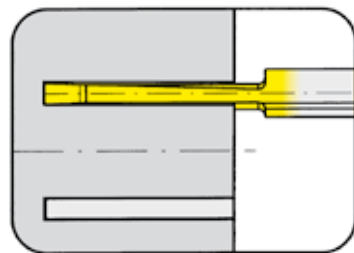
# 端面切槽 FACE GROOVING



## 刀片型号

INSERT Type

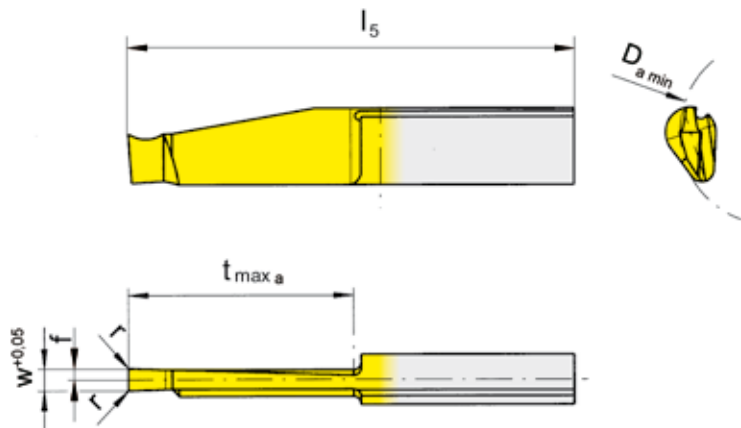
# A110



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深	Depth of groove	30.0 mm
槽宽	Width of groove	3.0 mm

配合 刀杆  
for use with Toolholder

型号 B110  
Type



L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	w	r	f	$l_5$	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
R/LA110.2030.3.0	3	0.2	1.5	50	20	20		▲/▲	▲/▲	▲/▲
R/LA110.2030.5.0				60	30		▲/▲	▲/▲	▲/▲	
R/LA110.5030.3.0	3	0.2	1.5	50	20	50			▲/▲	
R/LA110.5030.5.0				60	30		▲/▲	▲/▲		
							P	•	•	•
							M	•	•	•
							K	•	•	•
							N	•	•	•
							S	•	•	•
							H			

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
RB110刀杆配合RA110刀片  
LB110刀杆配合LA110刀片

Note:  
Use insert RA110 in toolholder RB110  
Use insert LA110 in toolholder LB110

Dmin在20和50mm之间时，端面切槽可达满切下的最大切深。  
Face grooving with full width of the full depth only possible between  $D_{amin}$  20 - 50 mm.

硬质合金牌号  
Carbide grades

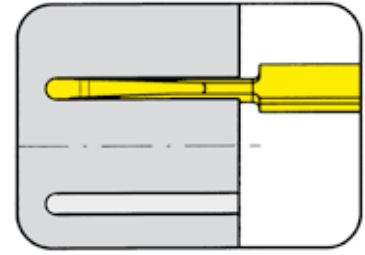


# 端面切槽 FACE GROOVING



刀片 型号  
INSERT Type

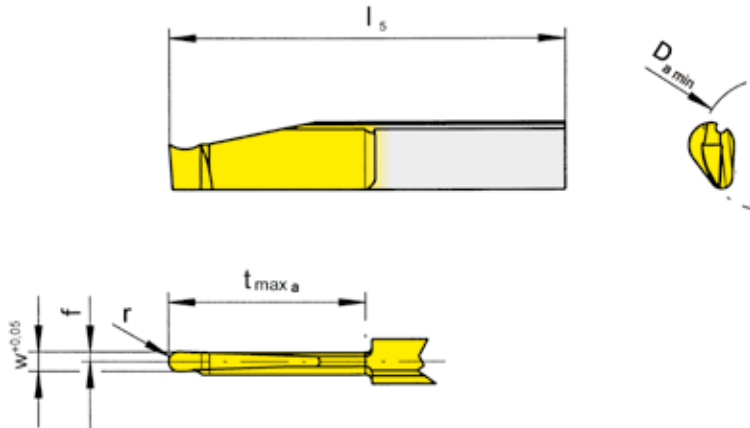
## A110



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深	Depth of groove	30.0 mm
槽宽	Width of groove	3.0 mm

配合 刀杆  
for use with Toolholder

型号 B110  
Type VDI



L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

圆头  
Full radius

产品型号 Part number	w	r	f	$l_s$	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
<b>R/LA110.2030.15.5.0</b>	3	1.5	1.5	60	30	20		▲/▲		
▲ 库存 / on stock							P	•		
● 主要应用 / main recommendation							M	•		
○ 可选推荐 / alternative recommendation							K	•		
■ 无涂层牌号 / uncoated grades							N	•		
■ 涂层牌号 / coated grades							S	•		
■ 钎焊/金属陶瓷 / brazed/Cermet							H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
RB110刀杆配合RA110刀片  
LB110刀杆配合LA110刀片

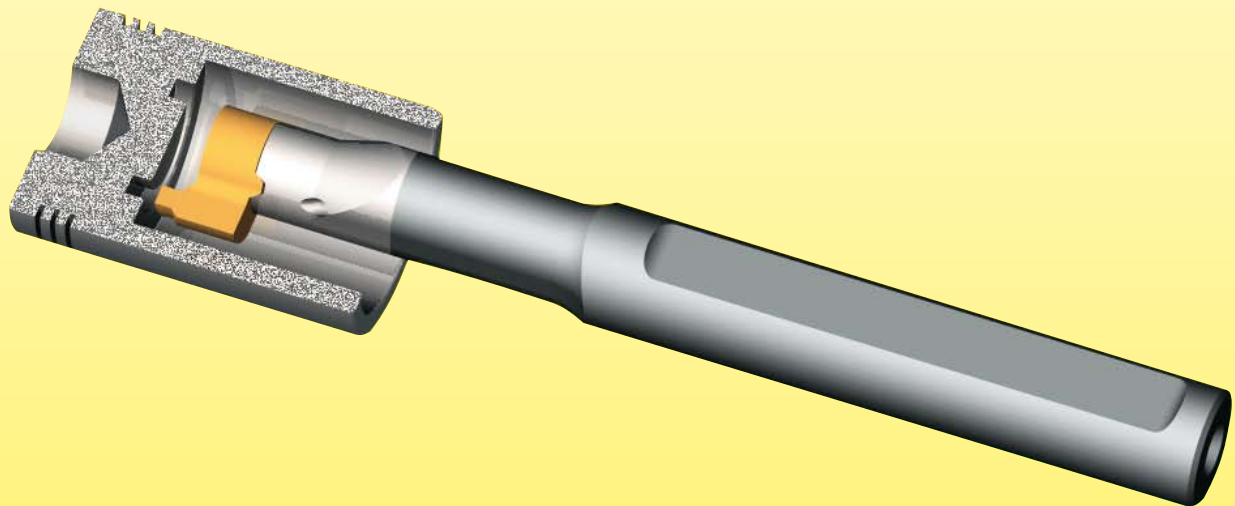
Note:  
Use insert RA110 in toolholder RB110  
Use insert LA110 in toolholder LB110

Dmin在20和50mm之间时, 端面切槽可达满切下的最大切深。  
Face grooving with full width of the full depth only possible between  $D_{a min}$  20 - 50 mm.

硬质合金牌号  
Carbide grades

刀片 型号 114  
- 精密研磨 -

Insert type 114  
- precision ground -



自 槽外径 $\varnothing$   
槽深 可达

12 mm  
6 mm

from Outer groove  $\varnothing$   
Depth of groove up to

12 mm  
6 mm

# 端面切槽

## FACE GROOVING

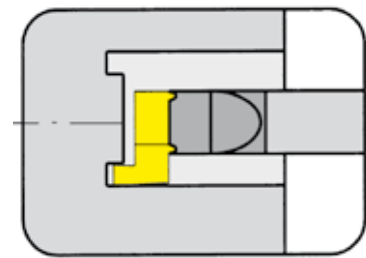


### 刀杆 型号

TOOLHOLDER Type

## B114

带内冷  
with through coolant supply

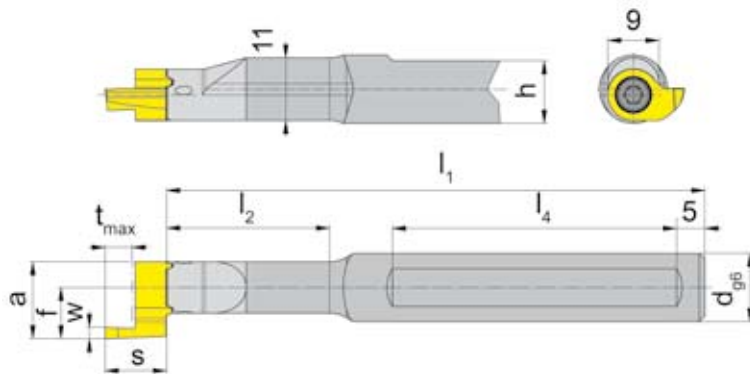


孔深可达	Depth of bore up to	64.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1,0 - 3,0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能  
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片  
for use with Insert

型号 114  
Type S114



图示=右手型  
Picture = right hand cutting version

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	l <sub>4</sub>
B114.0012.00	12	69.7	14.2	11	40
B114.0012.01		94.7	28.7		50
B114.0012.02		104.7	39.7		50
B114.0012.03		124.7	58.7		50
B114.0016.00	16	74.7	14.2	15	40
B114.0016.01		94.7	28.7		50
B114.0016.02		104.7	39.7		50
B114.0016.03		124.7	58.7		50

按需提供更多尺寸  
Further sizes upon request

w, a, s, t<sub>max</sub> 和 f 见刀片  
w, a, s, t<sub>max</sub> and f see inserts

尺寸单位：mm  
Dimensions in mm

#### 订货须知：

刀杆可以安装左手型或右手型刀片。  
HORN 可以返修刀杆上损坏的的基座。

**Ordering note:**  
Toolholders can be used with right and left hand inserts.  
Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

#### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B114.001...	4.12T15EP	T15PQ

# 端面切槽 $\geq \text{Ø } 14.0 \text{ mm}$ FACE GROOVING

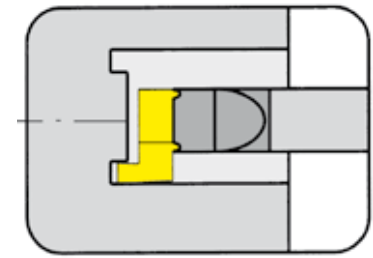


## 刀杆 型号

TOOLHOLDER Type

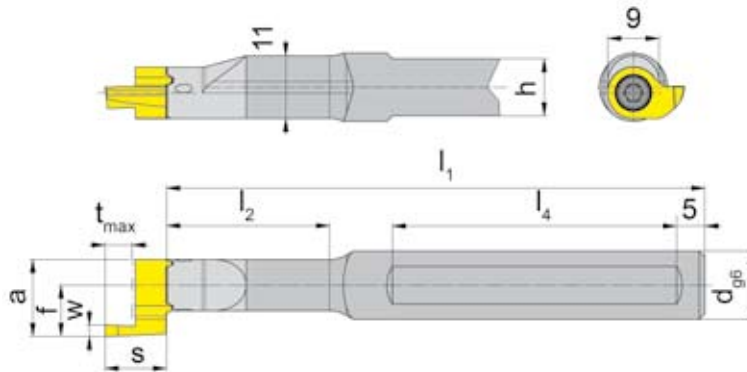
# B114

带内冷  
with through coolant supply



孔深可达	Depth of bore up to	64.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1,0 - 3,0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能  
Material of shank: Carbide - Giving a good vibration resistance



配合 刀片  
for use with Insert

型号 114  
Type S114

图示=右手型  
Picture = right hand cutting version

带2个夹持面  
with 2 clamping flats

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	l <sub>4</sub>
B114.0012.2.00	12	69.7	14.2	11	40
B114.0012.2.01		94.7	28.7		50
B114.0012.2.02		104.7	39.7		50
B114.0012.2.03		124.7	58.7		50
B114.0016.2.00	16	74.7	14.2	14	40
B114.0016.2.01		94.7	28.7		50
B114.0016.2.02		104.7	39.7		50
B114.0016.2.03		124.7	58.7		50

按需提供更多尺寸  
Further sizes upon request

w, a, s, t<sub>max</sub> 和 f 见刀片  
w, a, s, t<sub>max</sub> and f see inserts

尺寸单位：mm  
Dimensions in mm

### 订货须知：

刀杆可以安装左手型或右手型刀片。  
HORN 可以返修刀杆上损坏的的基座。

**Ordering note:**  
Toolholders can be used with right and left hand inserts.  
Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B114.001...	4.12T15EP	T15PQ



# 端面切槽 FACE GROOVING

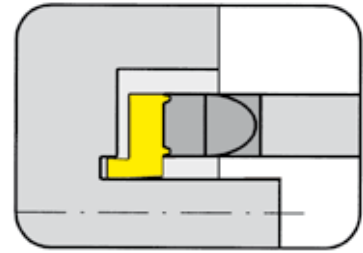


## 刀杆 型号

TOOLHOLDER Type

# B114

带内冷  
with through coolant supply

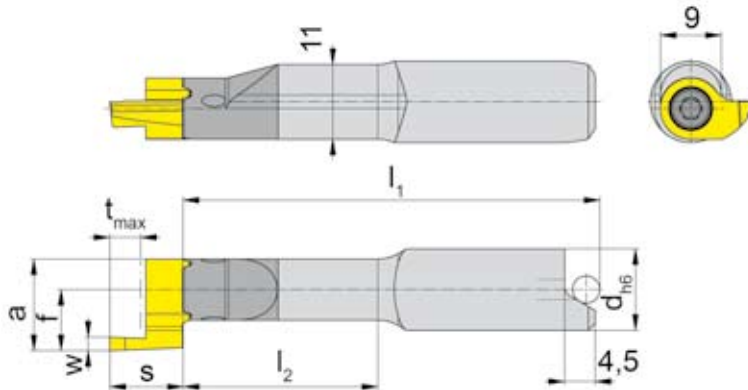


孔径Ø 自	Bore Ø from	14.0 mm
槽深可达	Depth of groove up to	6,0 mm
槽宽	Width of groove	1,0 - 3,0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能  
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片  
for use with Insert

型号 114  
Type S114



图示=右手型  
Picture = right hand cutting version

用于收缩型定位  
S=方向  
for shrinkage location  
S = orientation

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>
B114.0012.00S	12	47.4	14.2
B114.0012.01S		61.4	28.7
B114.0012.02S		72.4	39.7
B114.0012.03S		91.4	58.7

按需提供更多尺寸  
Further sizes upon request

w,a,s,t<sub>max</sub> 和f见刀片  
w, a, s, t<sub>max</sub> and f see inserts

尺寸单位：mm  
Dimensions in mm

### 订货须知：

刀杆可以安装左手型或右手型刀片。  
HORN可以返修刀杆上损坏的的基座。

**Ordering note:**  
Toolholders can be used with right and left hand inserts.  
Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.



"W&F"系统组装实例  
Example of assembly System "W&F"

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B114.0012.0...	4.12T15EP	T15PQ



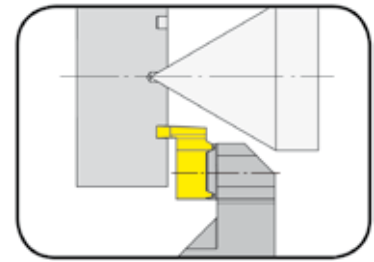
# 切槽和端面切槽

## GROOVING and FACE GROOVING

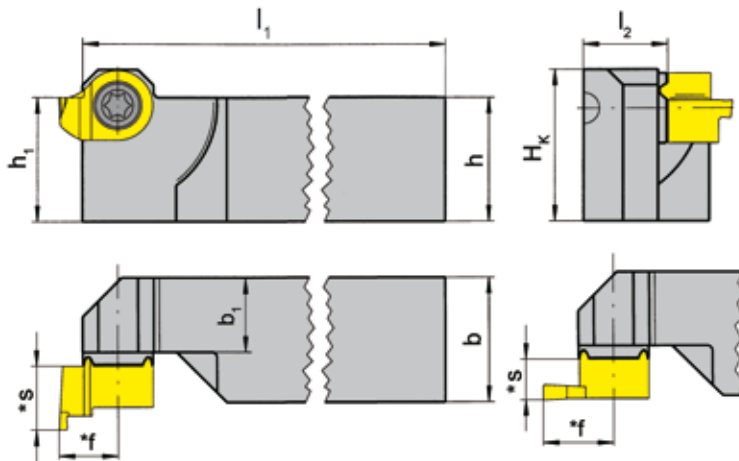


刀杆 型号  
TOOLHOLDER Type

# HC114



槽深可达                      Depth of groove up to                      6,0 mm  
槽宽可达                      Width of groove up to                      3.0 mm



配合 刀片  
for use with Insert

型号    114  
Type    S114  
          U114

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

轴向和径向  
axial and radial

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	b	b <sub>1</sub>	H <sub>k</sub>
R/LHC114.1212.01	12	12	122	11.2	12	9.5	15.6
R/LHC114.1616.01	16	16	122	11.2	16	9.5	19.6
R/LHC114.2020.01	20	20	122	15.2	20	13.5	23.6
R/LHC114.2525.01	25	25	147	20.2	25	18.5	28.6

按需提供更多尺寸  
Further sizes upon request

\*见刀片  
\* see inserts

尺寸单位：mm  
Dimensions in mm

注明R或L型  
State R or L version

订货须知：  
右手刀杆配合左手刀片  
左手刀杆配合右手刀片

Ordering note:  
Right hand toolholders use left hand inserts.  
Left hand toolholders use right hand inserts.

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC114....	4.12T15EP	T15PQ

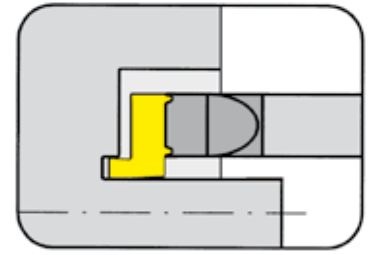
N

# 端面切槽 FACE GROOVING



刀片型号  
INSERT Type

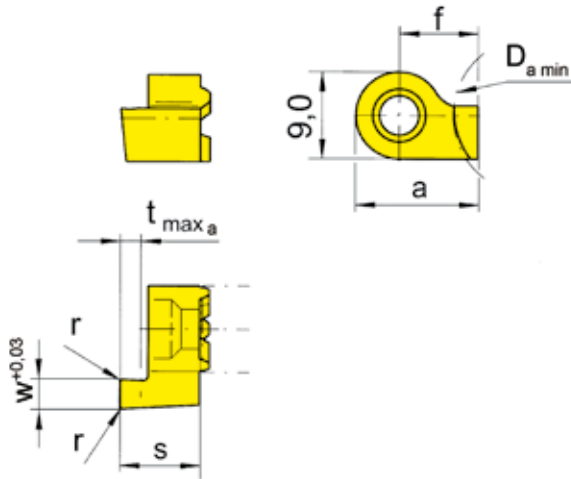
## 114



端面槽起始外径	from outer groove $\emptyset$	12.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.0 - 3.0 mm

配合 刀杆  
for use with Toolholder

型号 B114  
Type HC114



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

适用于中心线后加工  
Machining **BEHIND** centre line

产品型号 Part number	w	r	s	f	a	t <sub>max a</sub>	D <sub>a min</sub>	MG12	TN35	TI25	TH35
R/L114.1210.00	1.0	-				1.5			▲/▲		
R/L114.1215.00	1.5	0.2				2.5			▲/▲		
R/L114.1220.00	2.0	0.2	8.3	7.5	12	3.0	12		▲/▲		
R/L114.1225.00	2.5	0.2				3.0			▲/▲		
R/L114.1230.00	3.0	0.2				3.0			▲/▲		
R/L114.1220.5.00	2.0	0.2	10.8	7.5	12	5.0	12		▲/▲		
R/L114.1225.5.00	2.5	0.2				5.0			▲/▲		
R/L114.1230.6.00	3.0	0.2	11.8	7.5	12	6.0	12		▲/▲		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	●		
M	●		
K	●		
N	●		
S	●		
H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :

R=逆时针方向旋转  
使用114系列端面槽刀片和B114刀杆时, I<sub>1</sub>和 I<sub>2</sub> 会增加3.0/5.5或者 6.5mm。

Note:

R = rotation anti-clockwise!  
Using the face grooving insert type 114 on toolholder type B114 the size I<sub>1</sub> and I<sub>2</sub> will be enlarged by 3,0 / 5,5 or 6,5 mm.

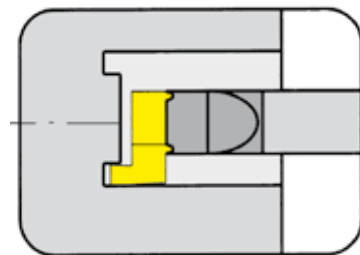
# 端面切槽 FACE GROOVING



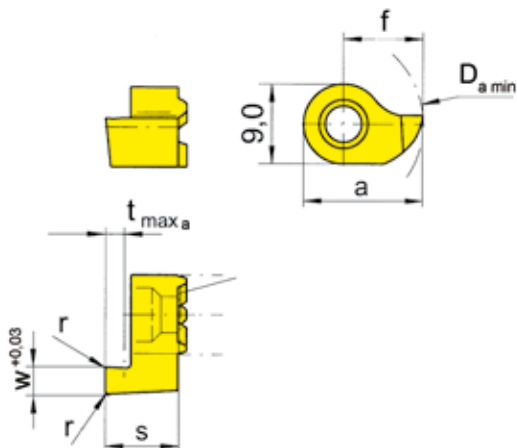
## 刀片型号

# 114

INSERT Type



端面槽起始外径	from outer groove $\varnothing$	14.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.0 - 3.0 mm



配合刀杆  
for use with Toolholder

型号 B114  
Type HC114

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

适用于中心线前加工  
Machining **IN-FRONT** of centre line

产品型号 Part number	w	r	s	f	a	t <sub>max a</sub>	D <sub>a min</sub>	MG12	TN35	TI25	TH35
R/L114.1410.00	1.0	-				1.5		Δ	▲/▲		
R/L114.1415.00	1.5	0.2				2.5			▲/▲		
R/L114.1420.00	2.0	0.2	8.3	9	13.5	3.0	14		▲/▲		
R/L114.1425.00	2.5	0.2				3.0			▲/▲		
R/L114.1430.00	3.0	0.2				3.0		▲	▲/▲		
R/L114.1420.5-00	2.0	0.2	10.8	9	13.5	5.0	14		▲/▲		
R/L114.1425.5-00	2.5	0.2							▲/▲		
R/L114.1430.6-00	3.0	0.2	11.8	9	13.5	6.0	14		▲/▲		

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	○	●	
M	●	●	
K	●	●	
N	●	●	
S	●	●	
H			

硬质合金牌号  
Carbide grades

尺寸单位：mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项：

R=顺时针旋转！  
使用114刀片和B114刀杆时刀杆时， $l_1$ 和 $l_2$ 会相应增加3.0/5.5或6.5 mm。

Note:

R = rotation clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size  $l_1$  and  $l_2$  will be enlarged by 3,0 / 5,5 or 6,5 mm.



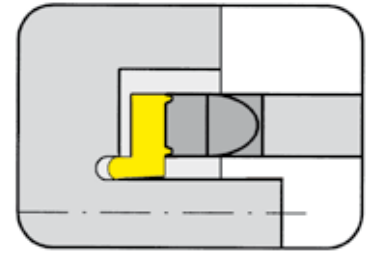
# 端面切槽

## FACE GROOVING

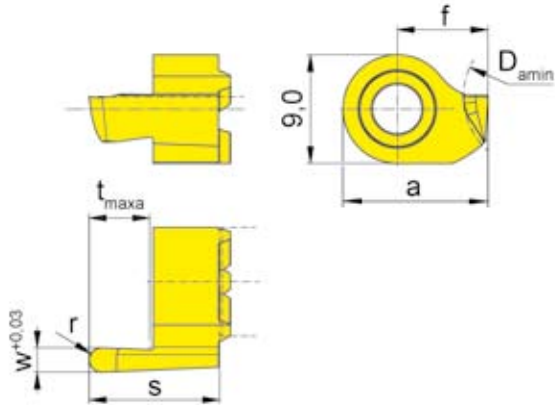


刀片型号  
INSERT Type

# 114



端面槽起始外径	from outer groove $\varnothing$	12.0 mm
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	2.0 - 3.0 mm



配合刀杆  
for use with Toolholder

型号 B114  
Type HC114

圆头刀片  
适用于中心线后加工  
Full radius  
Machining **BEHIND** centre line

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	s	f	a	t <sub>max a</sub>	D <sub>a min</sub>	MG12	TN35	TI25	TH35
R/L114.1220.5.10	2.0	1.00	10.8			5			▲/▲		
R/L114.1225.5.12	2.5	1.25	10.8	7.5	12	5	12		▲/▲		
R/L114.1230.6.15	3.0	1.50	11.8			6			▲/▲		
▲ 库存 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet								P	•		
								M	•		
								K	•		
								N	•		
								S	•		
								H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :

R = 顺时针旋转!  
使用114系列端面槽刀片和B114刀杆时,  $l_1$ 和 $l_2$ 将会增加5.5 mm或6.5mm。

Note:

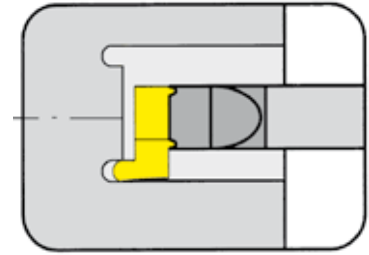
R = rotation anti-clockwise!  
Using the face grooving insert type 114 on toolholder type B114 the size  $l_1$  and  $l_2$  will be enlarged by 5,5 mm or 6,5 mm.

# 端面切槽 FACE GROOVING



刀片型号  
INSERT Type

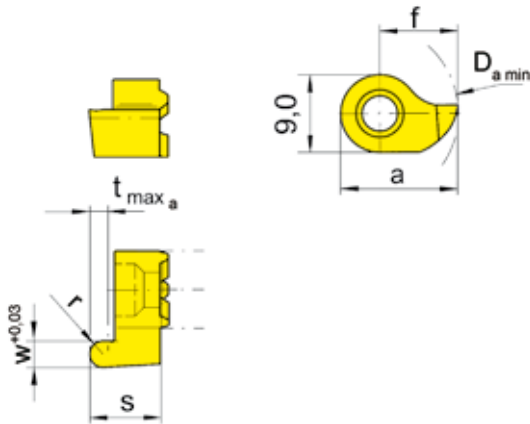
## 114



端面槽起始外径	from outer groove $\varnothing$	14.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.0 - 3.0 mm

配合刀杆  
for use with Toolholder

型号 B114  
Type HC114



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

圆头刀片  
适用于中心线 前加工  
Full radius  
Machining **IN-FRONT** of centre line

产品型号 Part number	w	r	s	f	a	t <sub>max a</sub>	D <sub>a min</sub>	MG12	TN35	TI25	TH35
R/L114.1410.05	1.0	0.50				1.5	14		▲/▲		
R/L114.1416.08	1.6	0.80				2.5			▲/▲		
R/L114.1420.10	2.0	1.00	8.3	9	13.5	3.0			▲/▲		
R/L114.1425.12	2.5	1.25				3.0			▲/▲		
R/L114.1430.15	3.0	1.50				3.0			▲/▲		
									P	•	•
								M	•	•	•
								K	•	•	•
								N	•	•	•
								S	•	•	•
								H			

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm  
Dimensions in mm

注明R或L型  
State R or L version

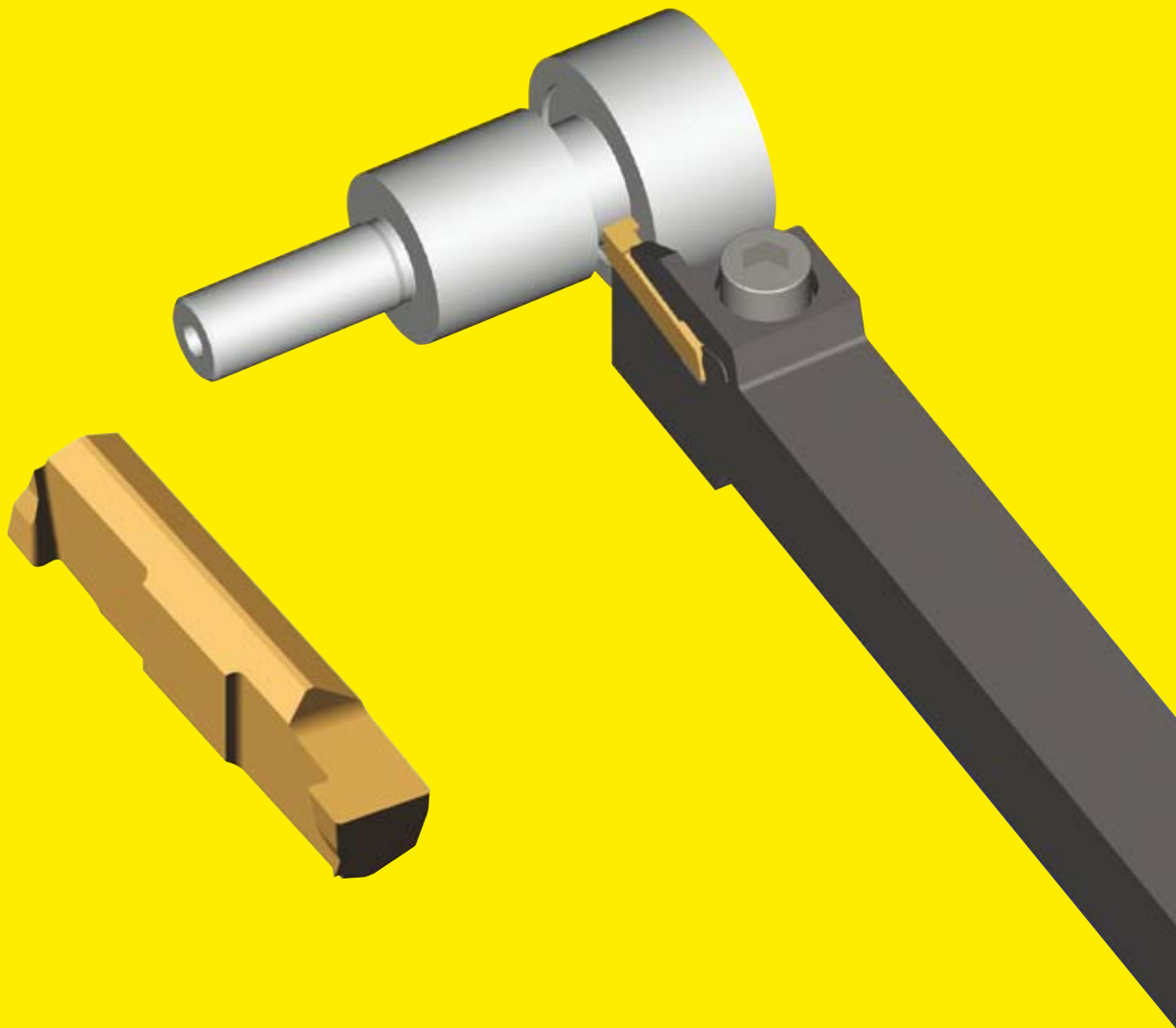
注意事项：  
R=逆时针旋转  
使用114系列端面切槽刀片和B114刀杆时， $l_1$ 和 $l_2$ 会增大3.0 mm。

**Note:**  
R = rotation clockwise!  
Using the face grooving insert type 114 on toolholder type B114 the size  $l_1$  and  $l_2$  will be enlarged by 3.0 mm.

硬质合金牌号  
Carbide grades

## 经济的解决方案

The economic solution

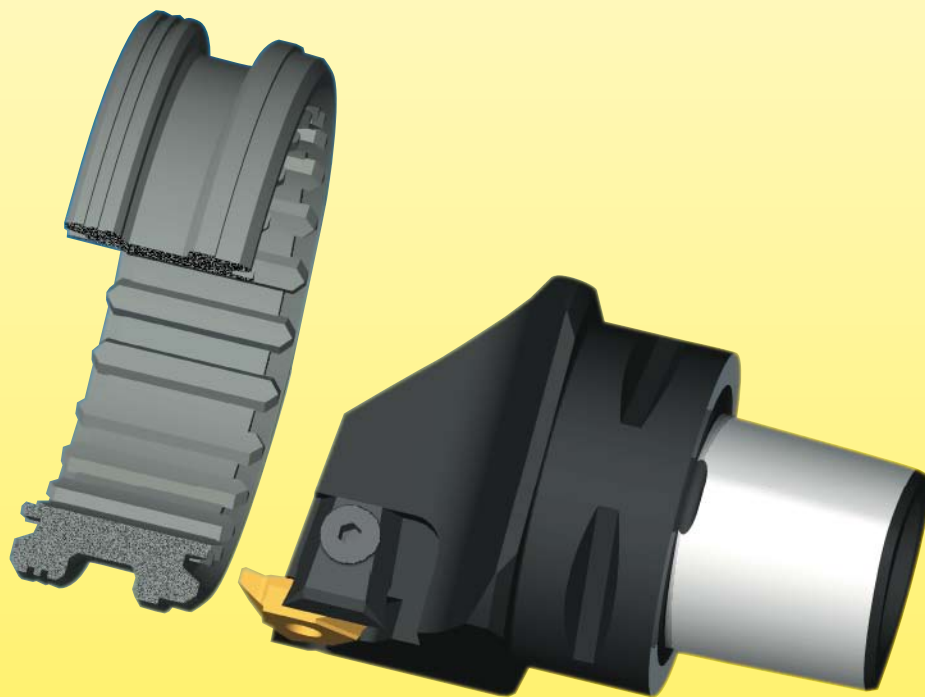


改进的S224和S229刀片适用于有限的加工空间内轴向切槽。

Modified inserts type S224/S229 for axial  
grooving at limited machining space.

## 可转位刀片 型号 312 - 精密研磨 -

Indexable Insert type 312  
- precision ground -



自 槽外径 $\varnothing$   
槽深 可达

20 mm  
3 mm

from Outer groove  $\varnothing$   
Depth of groove up to

20 mm  
3 mm

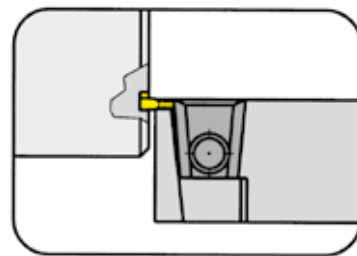
# 端面切槽 FACE GROOVING



## 刀杆 型号

# 360

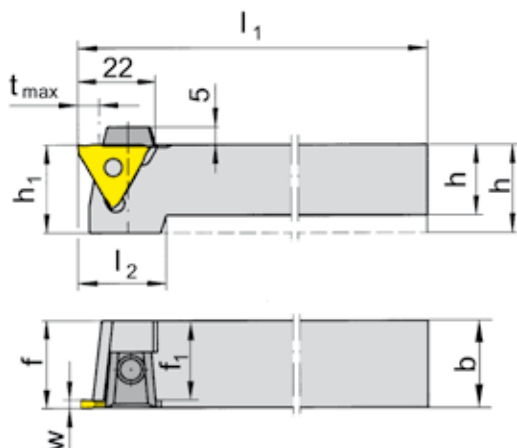
TOOLHOLDER Type



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深可达	Depth of groove up to	3.0 mm
夹持范围	Clamping range	1.9 - 3.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max a}$	规格 Size	夹持范围 Clamping range
R/L360.1212.02	12	12	100	24	25	9.5	$f_1+w-a_1$	3	02	1.9 - 2.9
R/L360.1616.02	16	16	125	22	25	13.5				
R/L360.2020.02	20	20	125	21	25	17.5				
R/L360.2525.02	25	25	150	-	25	22.5				
R/L360.3232.02	32	32	170	-	32	29.5				
R/L360.1212.03	12	12	100	24	25	8.5	$f_1+w-a_1$	3	03	2.9 - 3.9
R/L360.1616.03	16	16	125	22	25	12.5				
R/L360.2020.03	20	20	125	21	25	16.5				
R/L360.2525.03	25	25	150	-	25	21.5				
R/L360.3232.03	32	32	170	-	32	28.5				

注明R或L型

State R or L version

$w, a_1$  见刀片

$w, a_1$  see indexable inserts

尺寸单位 : mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L360.1...02/03	11.3	6.25	SW3.0DIN911
R/L360....02/03	16.4	6.25	SW3.0DIN911

N30

N

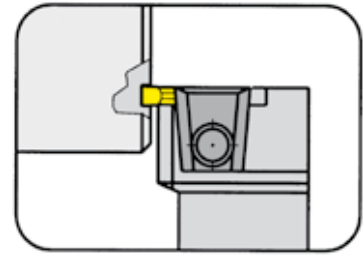


# 端面切槽 FACE GROOVING



刀杆 型号  
TOOLHOLDER Type

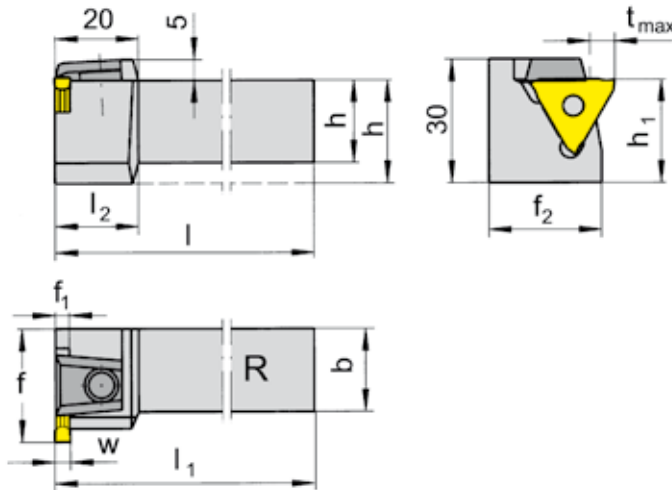
## 369



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深可达	Depth of groove up to	3.0 mm
夹持范围	Clamping range	1.9 - 3.9 mm

配合 可转位刀片  
for use with Indexable insert

型号 312  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	b	l	l <sub>1</sub>	l <sub>2</sub>	f	f <sub>1</sub>	f <sub>2</sub>	t <sub>max a</sub>	规格 Size	夹持范围 Clamping range
R/L369.2020.02	20	25	20	125	$l-f_1+w-a_1$	20	27	2.5	23.5	3	02	1.9 - 2.9
R/L369.2525.02	25	25	25	150	$l-f_1+w-a_1$	-	32	2.5	28.5	3	02	1.9 - 2.9
R/L369.2020.03	20	25	20	125	$l-f_1+w-a_1$	20	27	3.5	23.5	3	03	2.9 - 3.9
R/L369.2525.03	25	25	25	150	$l-f_1+w-a_1$	-	32	3.5	28.5	3	03	2.9 - 3.9

注明R或L型  
State R or L version

w, a<sub>1</sub> 见刀片  
w, a<sub>1</sub> see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L369.2...	16.4	6.25	SW3,0DIN911

N

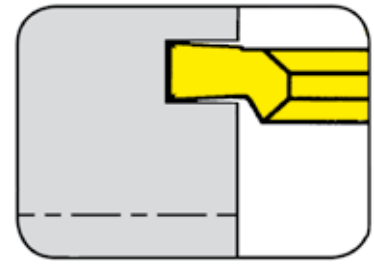
# 端面切槽 FACE GROOVING



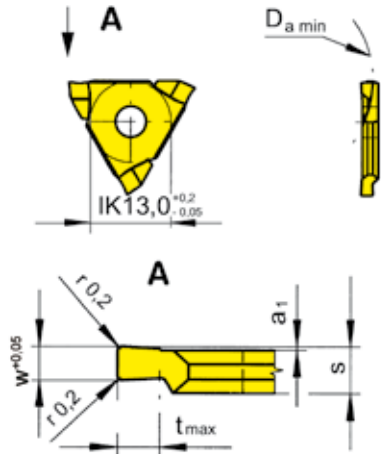
## 可转位刀片 型号

# 312

INDEXABLE INSERT Type



端面槽起始外径	from outer groove $\varnothing$	20.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.5 - 3.0 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 361  
369

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$   
Indexability length  $\pm 0,02\text{ mm}$

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	s	t <sub>max</sub>	D <sub>a min</sub>	a <sub>1</sub>	规格 Size	TN35	TI25	TA45
R/L312.2015.02	1.5	2.7	2	20	0.2	02	▲/▲		
R/L312.3020.02	2.0	2.7	3	30	0.2	02	▲/▲		
R/L312.3030.02	3.0	3.7	3	30	0.2	03	▲/▲		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

### 360系列刀杆注意事项

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

#### Note for toolholder type 360

Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

### 369系列刀杆注意事项

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

#### Note for toolholder type 369

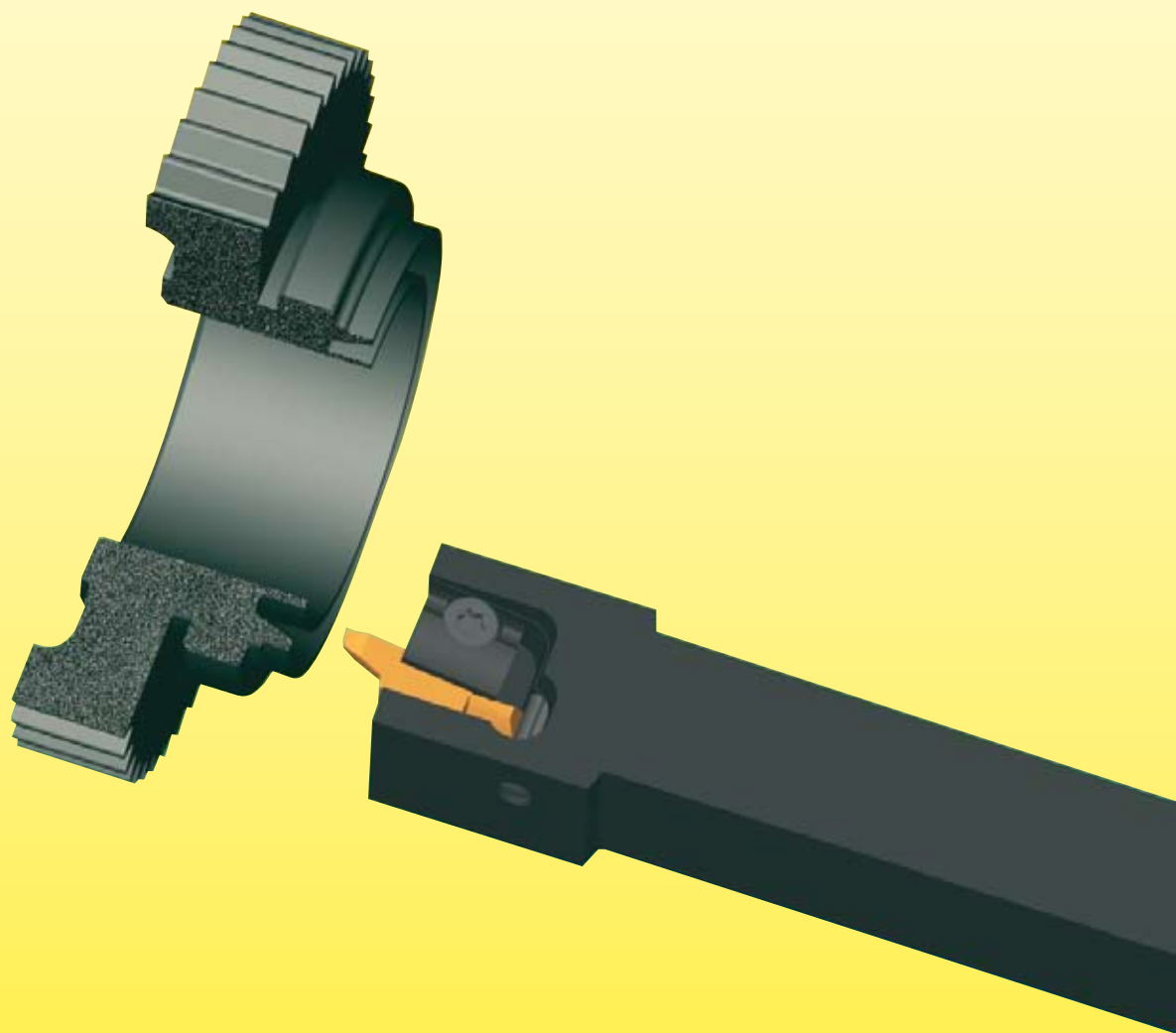
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

	P	M	K	N	S	H
TN35	•	•	•	•	•	•
TI25	•	•	•	•	•	•
TA45	•	•	•	•	•	•

硬质合金牌号  
Carbide grades

# 可转位刀片 型号 231 - 精密研磨 -

Indexable Insert type 231  
- precision ground -



自 槽外径 $\varnothing$   
槽深 可达

40 mm  
8 mm

from Outer groove  $\varnothing$   
Depth of groove up to

40 mm  
8 mm

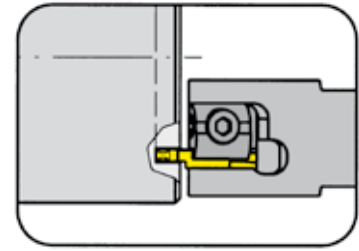
# 端面切槽 FACE GROOVING



## 刀杆 型号

# 221

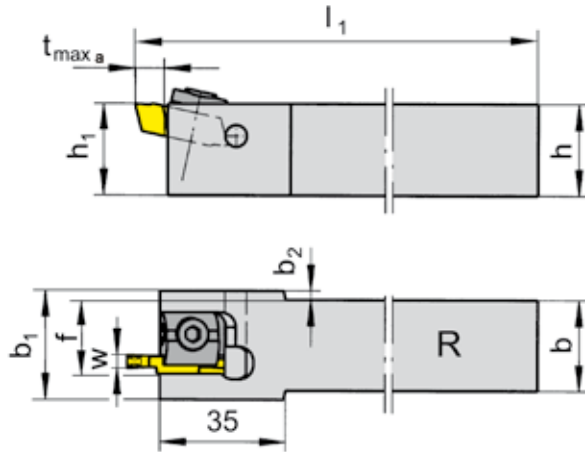
TOOLHOLDER Type



端面槽起始外径	from outer groove $\varnothing$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	3.0 - 10.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type N231



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	b	b <sub>1</sub>	b <sub>2</sub>	f	t <sub>max a</sub>	规格 Size	夹持范围 Clamping range
R/L221.2020.04	20	20	125	20	28	4.0	17.9	8	04	3.0 - 4.0
R/L221.2525.04	25	25	150	25	28	1.5	20.4	8	04	3.0 - 4.0
R/L221.2020.05	20	20	125	20	30	5.0	18.9	8	05	4.1 - 6.0
R/L221.2525.05	25	25	150	25	30	2.5	21.4	8	05	4.1 - 6.0
R/L221.2020.07	20	20	125	20	32	6.0	19.9	8	07	6.1 - 8.0
R/L221.2525.07	25	25	150	25	32	3.5	22.4	8	07	6.1 - 8.0
R/L221.2020.09	20	20	125	20	34	7.0	20.9	8	09	8.1 - 10.0
R/L221.2525.09	25	25	150	25	34	4.5	23.4	8	09	8.1 - 10.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

取决于切槽深度, 当D<sub>a</sub>=30 mm到∞时可以使用此刀杆。  
This toolholder can be used from D<sub>a</sub> = 30 mm up to ∞ depending on grooving depth.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	定位销 Position Pin
R/L221.2...	01.60.12	6.20.70P	T20PQ	3.6.28

N34

N

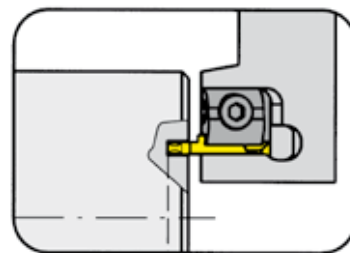
# 端面切槽 FACE GROOVING



## 刀杆 型号

# 228

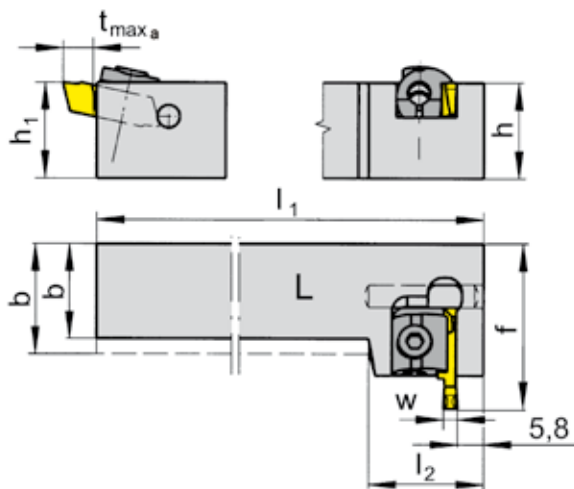
TOOLHOLDER Type



端面槽起始外径	from outer groove $\varnothing$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	3.0 - 10.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 231  
Type N231



L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$b$	$f$	$t_{max a}$	规格 Size	夹持范围 Clamping range
R/L228-2020-04	125	35.5	20	20	20	38.5	8	04	3.0 - 4.0
R/L228-2525-04	150	35.5	25	25	25	38.5	8	04	3.0 - 4.0
R/L228-2020-05	125	35.5	20	20	20	38.5	8	05	4.1 - 6.0
R/L228-2525-05	150	35.5	25	25	25	38.5	8	05	4.1 - 6.0
R/L228-2020-07	125	35.5	20	20	20	38.5	8	07	6.1 - 8.0
R/L228-2525-07	150	35.5	25	25	25	38.5	8	07	6.1 - 8.0
R/L228-2020-09	125	35.5	20	20	20	38.5	8	09	8.1 - 10.0
R/L228-2525-09	150	35.5	25	25	25	38.5	8	09	8.1 - 10.0

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

取决于切槽深度, 当 $D_a = 30$  mm到 $\infty$ 时可以使用此刀杆。  
This toolholder can be used from  $D_a = 30$  mm up to  $\infty$  depending on grooving depth.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

## 附件 Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	定位销 Position Pin
R/L228.2...	01.60.12	6.20.70P	T20PQ	3.6.28



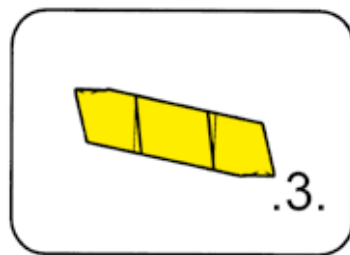
# 端面切槽 FACE GROOVING



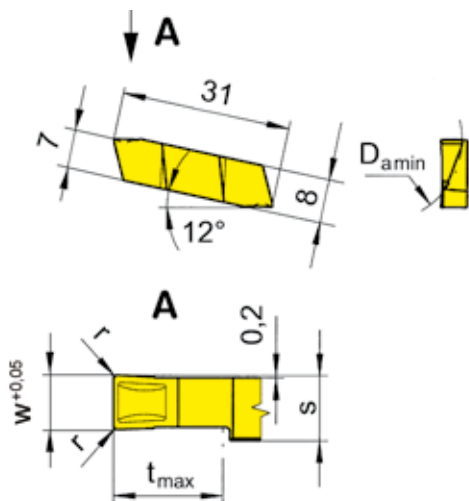
可转位刀片 型号  
INDEXABLE INSERT Type

## 231/N231

带断屑槽  
with chip former



端面槽起始外径	from outer groove $\varnothing$	40.0 mm
槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	3.0 - 10.0 mm



配合 刀杆  
for use with Toolholder

型号 221  
Type 228

刀片长度重复定位精度  
 $\pm 0.025\text{mm}$   
Indexability length  $\pm 0,025\text{ mm}$

产品型号 Part number	w	s	r	t <sub>max</sub>	D <sub>a min</sub>	规格 Size	TN32	TN35	TA45
R/L231.4030.32 R/L231.4040.32	3 4	3.8	0.2	8	40	04		▲/▲ ▲/▲	
R/L231.4050.34 N231.4060.34	5 6	5.8	0.4	8	40	05		▲/▲ ▲	
N231.4070.36 N231.4080.36	7 8	7.8	0.6	8	40	07		▲ ▲	
N231.4090.38 N231.4100.38	9 10	9.8	0.8	8	40	09		▲ ▲	
<ul style="list-style-type: none"> <li>▲ 库存 / on stock    △ 4周 / 4 weeks</li> <li>● 主要应用 / main recommendation</li> <li>○ 可选推荐 / alternative recommendation</li> <li>■ 无涂层牌号 / uncoated grades</li> <li>■ 涂层牌号 / coated grades</li> <li>■ 钎焊/金属陶瓷 / brazed/Cermet</li> </ul>							P	●	
							M	●	
							K	●	
							N	●	
							S	●	
							H		

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

注明R, L或N型  
State R, L or N version

槽外径 $\varnothing < 40\text{mm}$ 时可定制非标产品  
Outer- $\varnothing$  of groove  $< 40\text{ mm}$  upon request.



R

R = 右手型  
R = right hand version



L

L = 左手型  
L = left hand version

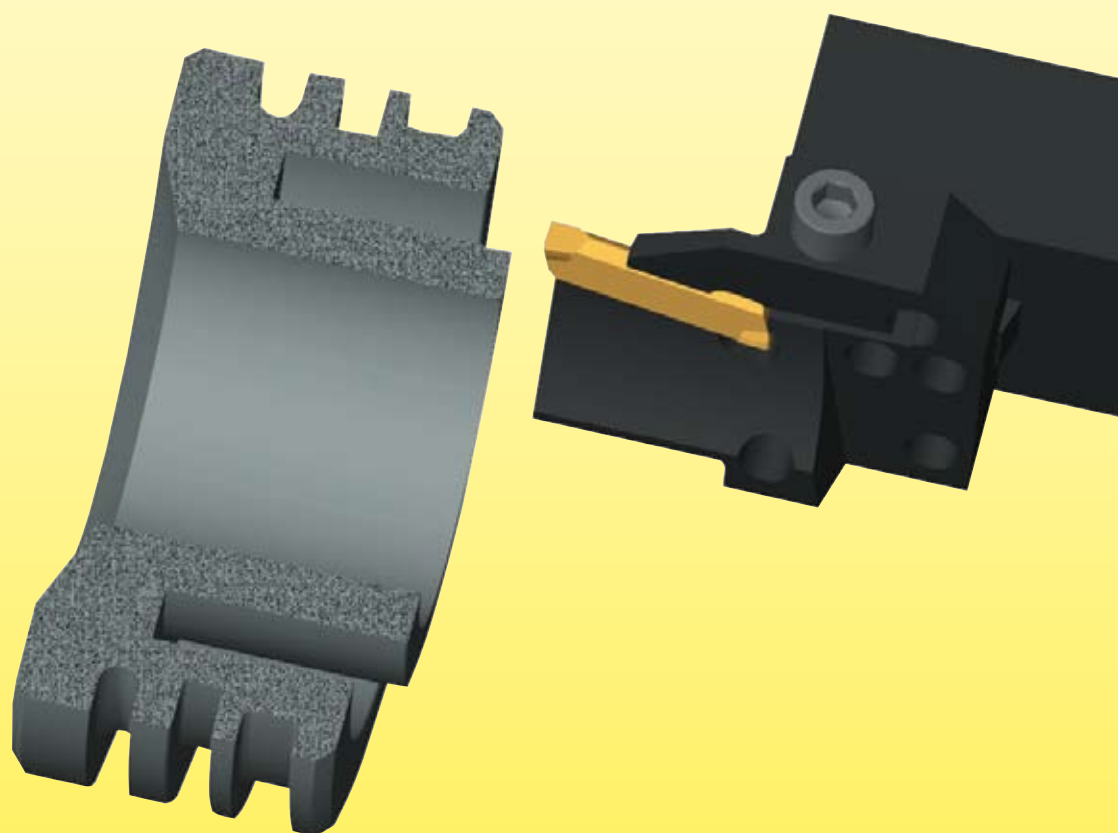


N

N = 右手型和左手型  
N = right and left hand version

## 可转位刀片 型号 S224 + S229 - 精密烧结 -

Indexable Insert type S224 + S229  
- precision sintered -



槽外径 $\varnothing$  38-1000 mm  
槽深 可达 25 mm

Outer groove  $\varnothing$  38-1000 mm  
Depth of groove up to 25 mm

# 端面切槽 FACE GROOVING

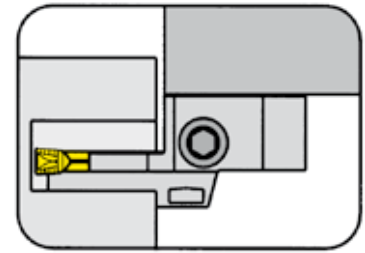


## 常规刀杆 型号

BASIC TOOLHOLDER Type

# 220

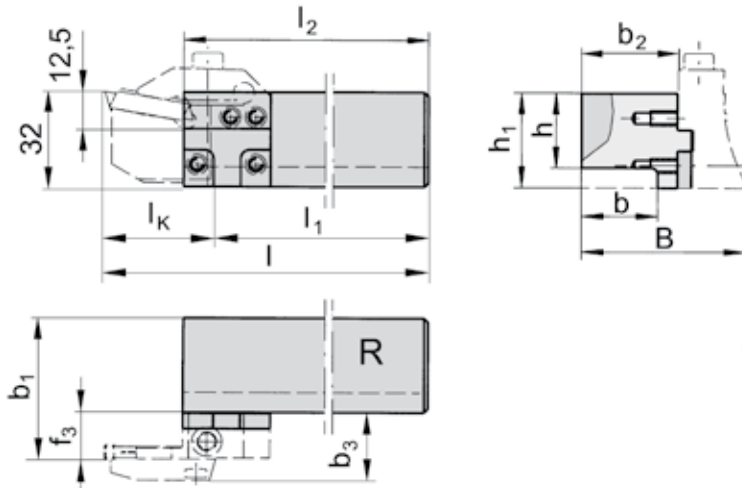
无刀夹  
without cassette



配合220/224型刀夹的常规刀柄  
Basic toolholder for cassettes type 220/224

刀杆平行于工件轴线

Shank parallel to the axis of workpiece



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	b	b <sub>1</sub>	b <sub>2</sub>	l	B
R/L220.1616.K1	16			64	16		25		
R/L220.2020.K1	20			74	20		27		
R/L220.2525.K1	25	32	l <sub>2</sub> -10	94	25	b <sub>2</sub> +f <sub>3</sub>	32	l <sub>1</sub> +l <sub>k</sub>	b <sub>2</sub> +b <sub>3</sub>
R/L220.3225.K1	32			109	-		25		
R/L220.3232.K1	32			109	-		32		

注明R或L型

State R or L version

l<sub>k</sub>, b<sub>3</sub> 和 f<sub>3</sub> 见刀夹

l<sub>k</sub>, b<sub>3</sub> and f<sub>3</sub> see cassettes

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

右手型刀杆配合右手型刀夹, 左手型刀杆配合左手型刀夹。

Use right hand basic toolholder for right hand cassettes and left hand basic toolholder for left hand cassettes.

## 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L220....	5.12T20P	T20PQ



# 端面切槽 FACE GROOVING

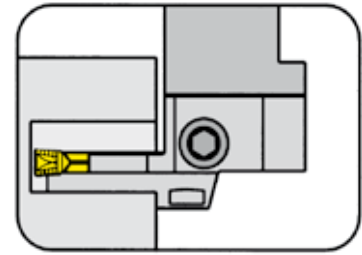


## 常规刀杆 型号

BASIC TOOLHOLDER Type

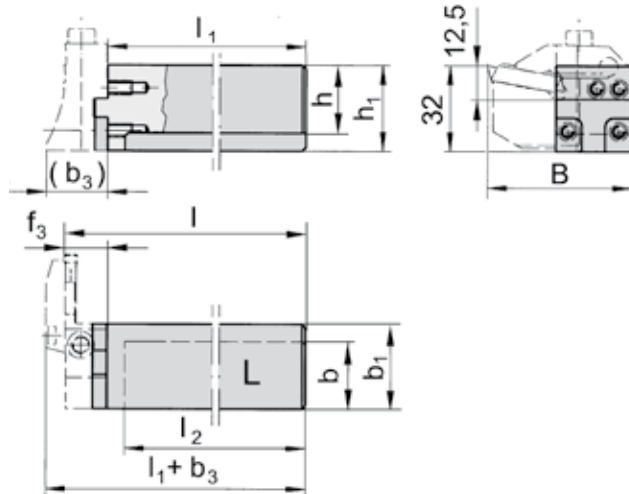
# 220

无刀夹  
without cassette



配合220/224型刀夹的常规刀柄  
Basic toolholder for cassettes type 220/224

刀杆90°于工件轴线  
Shank 90° to the axis of workpiece



L=左手型-如图  
L = left hand version shown

R=右手型  
R = right hand version

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	b	b <sub>1</sub>	l	B
R/L220.1616.K2	16		70	60	16	29		l <sub>k</sub> +19
R/L220.2020.K2	20		85	75	20	29		l <sub>k</sub> +19
R/L220.2525.K2	25	32	100	93	25	32	l <sub>1</sub> +f <sub>3</sub>	l <sub>k</sub> +22
R/L220.3225.K2	32		115	108	-	29		l <sub>k</sub> +19
R/L220.3232.K2	32		115	115	-	32		l <sub>k</sub> +22

注明R或L型  
State R or L version

l<sub>k</sub>, b<sub>3</sub> 和 f<sub>3</sub> 见刀夹  
l<sub>k</sub>, b<sub>3</sub> and f<sub>3</sub> see cassettes

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

右手型刀杆配合左手型刀夹, 左手型刀杆配合右手型刀夹。  
Use right hand basic toolholder for left hand cassettes and left hand basic toolholder for right hand cassettes.

## 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L220....	5.12T20P	T20PQ

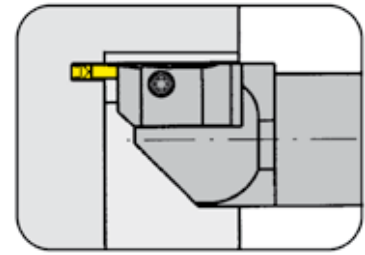
N

# 端面切槽 FACE GROOVING



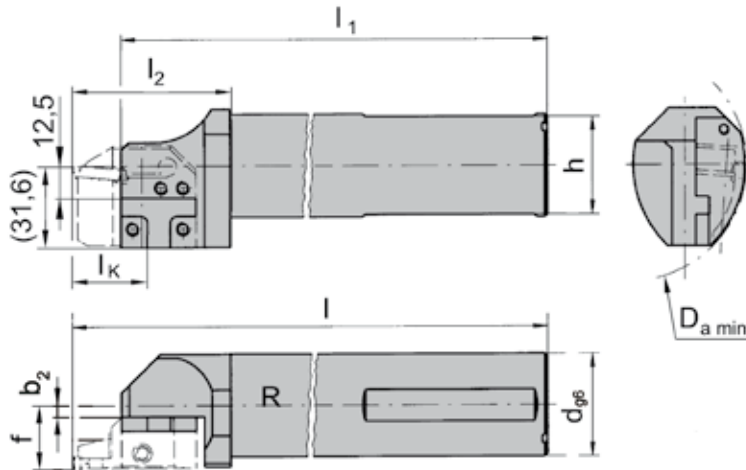
常规刀杆 型号  
BASIC TOOLHOLDER Type

**B224**  
无刀夹  
without cassette



配合RIK/LIK224型刀夹的常规刀柄  
Basic toolholder for cassettes type RIK/LIK224

带内冷  
with through coolant supply



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	l <sub>1</sub>	l <sub>2</sub>	b <sub>2</sub>	f	D <sub>Bohr</sub>	d	l
R/LB224.0032.K1	30	181	59	0.41	b <sub>2</sub> +f <sub>3</sub>	90	32	200
R/LB224.0040.K1	38	231	59	4.41	b <sub>2</sub> +f <sub>3</sub>	90	40	250

注明R或L型  
State R or L version  
按需提供更多尺寸  
Further sizes upon request

D<sub>a min</sub>/f<sub>3</sub> 见刀夹  
D<sub>a min</sub>/f<sub>3</sub> see cassettes

尺寸单位: mm  
Dimensions in mm

附件  
Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB224.00...	5.12T20P	T20PQ

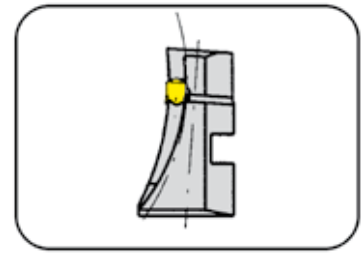


# 端面切槽 FACE GROOVING

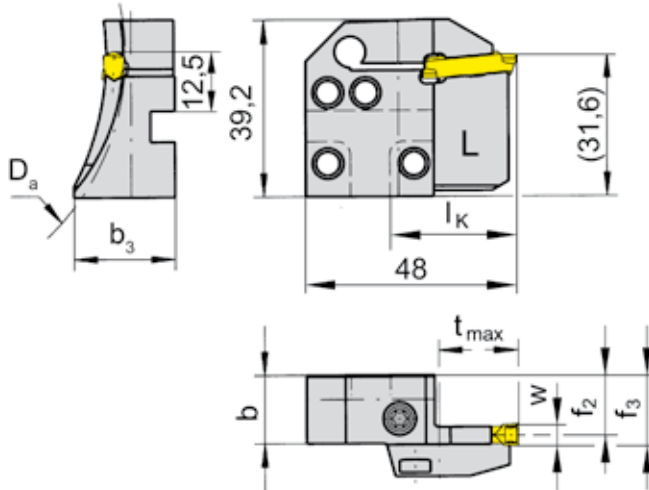


刀夹 型号  
CASSETTE Type

## LAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK224.5060.03	50	60			21.0				
LAK224.6075.03	60	75			21.0				
LAK224.7590.03	75	90			21.0				
LAK224.9011.03	90	110			21.0				
LAK224.1113.03	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1318.03	130	180			20.0				
LAK224.1830.03	180	300			19.0				
LAK224.3000.03	300	1000			16.4				
LAK224.3847.04	38	47			21.0				
LAK224.4760.04	47	60			21.0				
LAK224.6075.04	60	75			21.0				
LAK224.7590.04	75	90			21.0				
LAK224.9013.04	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1318.04	130	180			21.0				
LAK224.1830.04	180	300			19.0				
LAK224.3000.04	300	1000			16.7				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

订货须知:  
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK224....	5.13T20P	T20PQ

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

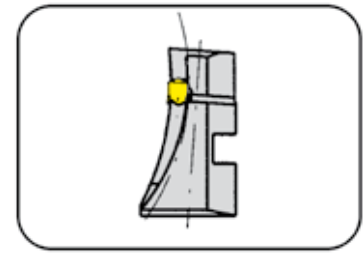
N

# 端面切槽 FACE GROOVING

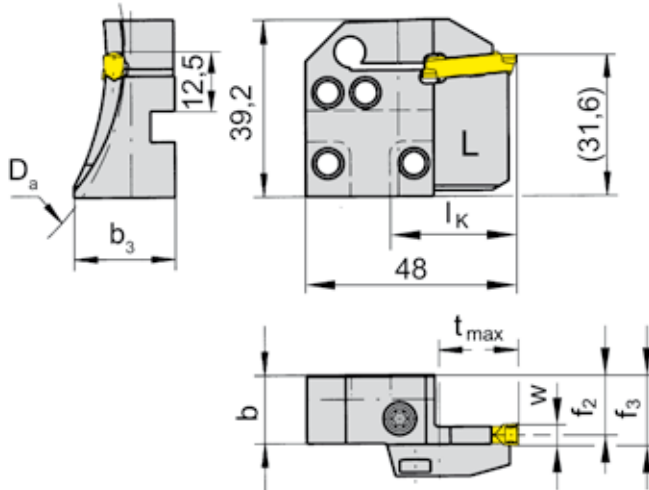


刀夹 型号  
CASSETTE Type

## LAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK224.3847.05	38	47			21.0				
LAK224.4760.05	47	60			21.0				
LAK224.6075.05	60	75			21.0				
LAK224.7590.05	75	90			21.0				
LAK224.9013.05	90	130	14	15.7	21.0	13.9	$f_2+w/2$	5	29
LAK224.1318.05	130	180			21.0				
LAK224.1830.05	180	300			19.0				
LAK224.3000.05	300	1000			16.7				
LAK224.6075.06	60	75			23.0				
LAK224.7590.06	75	90			23.0				
LAK224.9013.06	90	130			21.0				
LAK224.1318.06	130	180	14	15.7	21.0	13.4	$f_2+w/2$	6	29
LAK224.1830.06	180	300			19.0				
LAK224.3000.06	300	1000			16.7				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

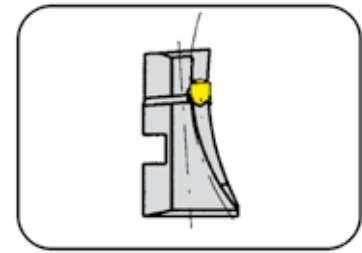
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK224....	5.13T20P	T20PQ

# 端面切槽 FACE GROOVING

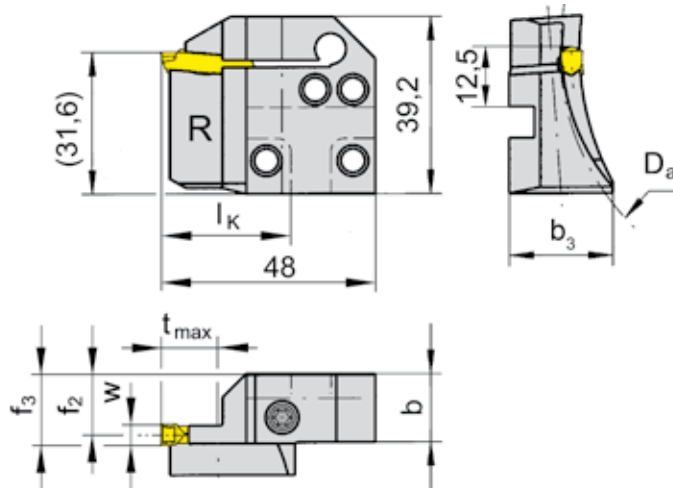


刀夹 型号  
CASSETTE Type

## RAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK224.5060.03	50	60			21.0				
RAK224.6075.03	60	75			21.0				
RAK224.7590.03	75	90			21.0				
RAK224.9011.03	90	110			21.0				
RAK224.1113.03	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
RAK224.1318.03	130	180			20.0				
RAK224.1830.03	180	300			19.0				
RAK224.3000.03	300	1000			16.4				
RAK224.3847.04	38	47			21.0				
RAK224.4760.04	47	60			21.0				
RAK224.6075.04	60	75			21.0				
RAK224.7590.04	75	90			21.0				
RAK224.9013.04	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
RAK224.1318.04	130	180			21.0				
RAK224.1830.04	180	300			19.0				
RAK224.3000.04	300	1000			16.7				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK224....	5.13T20P	T20PQ

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

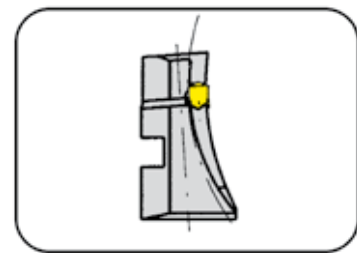
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# 端面切槽 FACE GROOVING

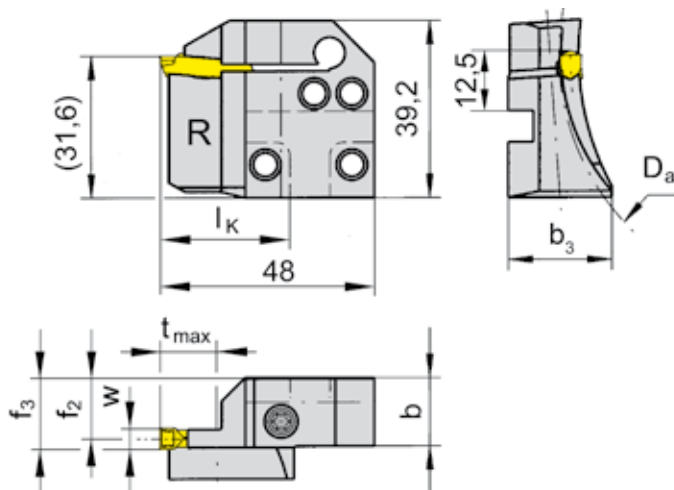


刀夹 型号  
CASSETTE Type

## RAK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert  
型号  
Type S224

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK224.3847.05	38	47			21.0				
RAK224.4760.05	47	60			21.0				
RAK224.6075.05	60	75			21.0				
RAK224.7590.05	75	90			21.0				
RAK224.9013.05	90	130	14	15.7	21.0	13.9	$f_2+w/2$	5	29
RAK224.1318.05	130	180			21.0				
RAK224.1830.05	180	300			19.0				
RAK224.3000.05	300	1000			16.7				
RAK224.6075.06	60	75			23.0				
RAK224.7590.06	75	90			23.0				
RAK224.9013.06	90	130			21.0				
RAK224.1318.06	130	180	14	15.7	21.0	13.4	$f_2+w/2$	6	29
RAK224.1830.06	180	300			19.0				
RAK224.3000.06	300	1000			16.7				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

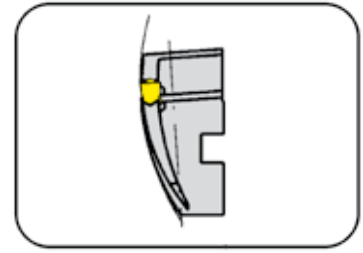
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK224....	5.13T20P	T20PQ

# 端面切槽 FACE GROOVING

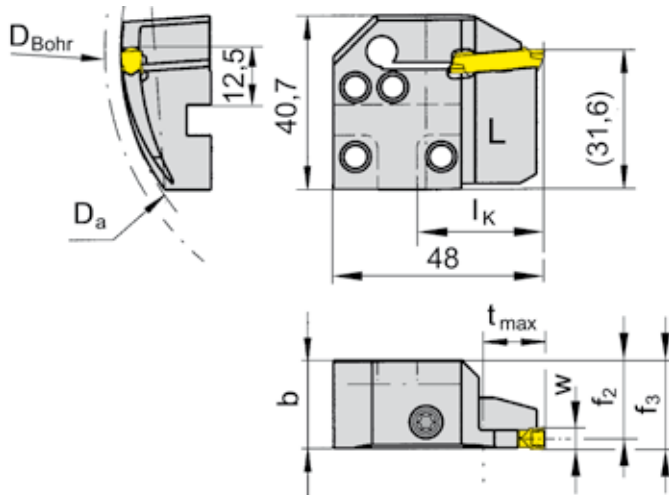


刀夹 型号  
CASSETTE Type

## LIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_k$
LIK224.5060.03	50	60					90		
LIK224.6075.03	60	75					90		
LIK224.7590.03	75	90					90	3	29
LIK224.9011.03	90	110	14	19	17.9	$f_2+w/2$	90		
LIK224.1113.03	110	130					110		
LIK224.1318.03	130	180					130		
LIK224.3847.04	38	47					90		
LIK224.4760.04	47	60					90		
LIK224.6075.04	60	75					90		
LIK224.7590.04	75	90	14	19	17.4	$f_2+w/2$	90	4	29
LIK224.9013.04	90	130					90		
LIK224.1318.04	130	180					130		
LIK224.3000.04	300	1000					300		

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK224....	5.13T20P	T20PQ

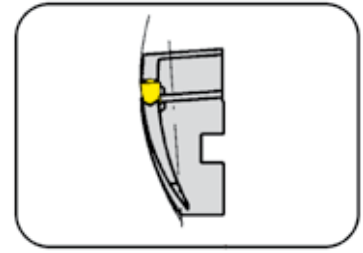
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# 端面切槽 FACE GROOVING

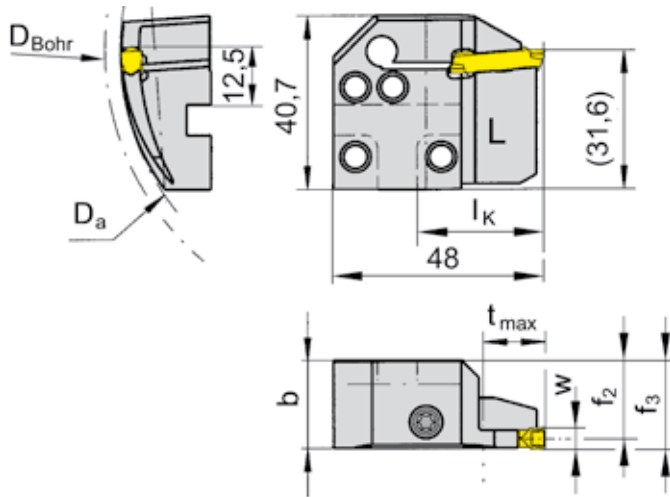


刀夹 型号  
CASSETTE Type

## LIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_k$
LIK224.3847.05	38	47					90		
LIK224.4760.05	47	60					90		
LIK224.6075.05	60	75					90		
LIK224.7590.05	75	90					90		
LIK224.9013.05	90	130	14	19	16.9	$f_2+w/2$	90	5	29
LIK224.1318.05	130	180					130		
LIK224.1830.05	180	300					180		
LIK224.3000.05	300	1000					300		
LIK224.6075.06	60	75					90		
LIK224.7590.06	75	90					90		
LIK224.9013.06	90	130					90		
LIK224.1318.06	130	180	14	19	16.4	$f_2+w/2$	130	6	29
LIK224.1830.06	180	300					180		
LIK224.3000.06	300	1000					300		

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK224....	5.13T20P	T20PQ



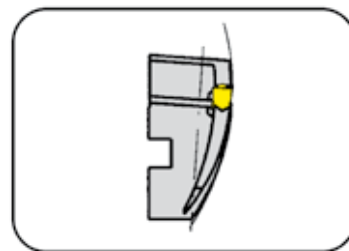
# 端面切槽 FACE GROOVING



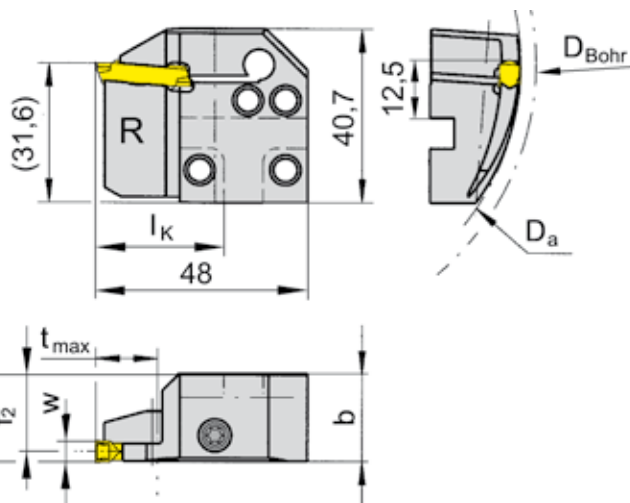
## 刀夹 型号

CASSETTE Type

# RIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	3.0 - 4.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_k$
RIK224.5060.03	50	60					90		
RIK224.6075.03	60	75					90		
RIK224.7590.03	75	90					90		
RIK224.9011.03	90	110	14	19	17.9	$f_2+w/2$	90	3	29
RIK224.1113.03	110	130					110		
RIK224.1318.03	130	180					130		
RIK224.1830.03	180	300					180		
RIK224.3847.04	38	47					90		
RIK224.4760.04	47	60					90		
RIK224.6075.04	60	75					90		
RIK224.7590.04	75	90	14	19	17.4	$f_2+w/2$	90	4	29
RIK224.9013.04	90	130					90		
RIK224.1318.04	130	180					130		
RIK224.3000.04	300	1000					300		

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK224....	5.13T20P	T20PQ

N

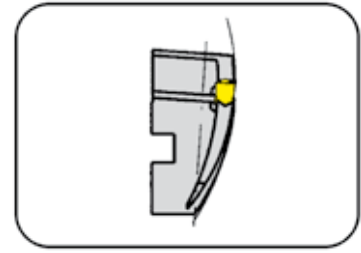
# 端面切槽 FACE GROOVING



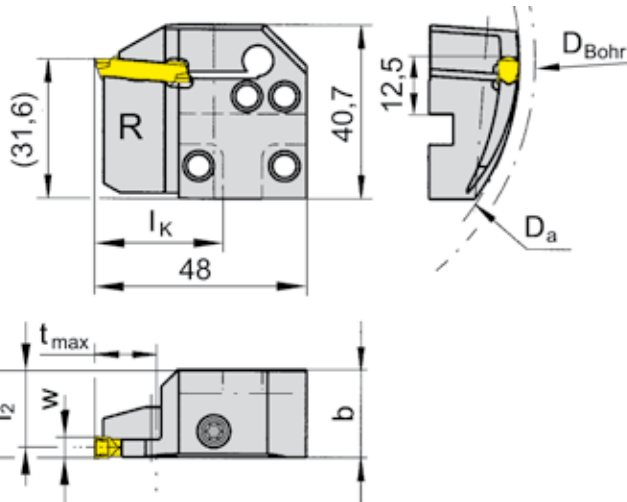
## 刀夹 型号

CASSETTE Type

# RIK224



槽外径 $\varnothing$	Outer groove $\varnothing$	38 - 1000 mm
槽深可达	Depth of groove up to	14.0 mm
槽宽	Width of groove	5.0 - 6.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	$D_{\text{Bohr}}$	w	$l_k$
RIK224.3847.05	38	47					90		
RIK224.4760.05	47	60					90		
RIK224.6075.05	60	75					90		
RIK224.7590.05	75	90					90		
RIK224.9013.05	90	130	14	19	16.9	$f_2+w/2$	90	5	29
RIK224.1318.05	130	180					130		
RIK224.1830.05	180	300					180		
RIK224.3000.05	300	1000					300		
RIK224.6075.06	60	75					90		
RIK224.7590.06	75	90					90		
RIK224.9013.06	90	130					90		
RIK224.1318.06	130	180	14	19	16.4	$f_2+w/2$	130	6	29
RIK224.1830.06	180	300					180		
RIK224.3000.06	300	1000					300		

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

### 订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK224....	5.13T20P	T20PQ

# 端面切槽

## FACE GROOVING

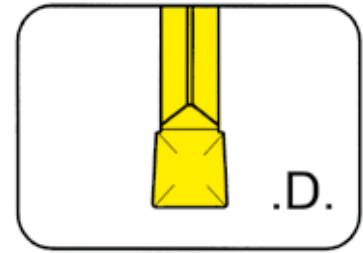


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

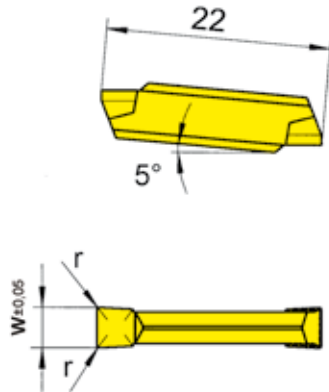
带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	3.0 - 4.0 mm

D2精密烧结/D2.G精密磨削

D2 precision sintered / D2.G precision ground



配合 刀夹

for use with Cassette

型号 L/RAK224

Type L/RIK224

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	H54	TN32	TN35	Ti22	Ti25	TF45	TF46
S224.0300.D2.G S224.0300.D2	3	0.2	03	▲	▲	▲	▲	▲	▲	▲
S224.0400.D2.G S224.0400.D2	4	0.2	04		▲	▲	▲	▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	•	•	•	•	•	•
● 主要应用 / main recommendation				M	•	•	•	•	•	○
○ 可选推荐 / alternative recommendation				K		•	•	•	•	•
■ 无涂层牌号 / uncoated grades				N		•	•	•	•	•
■ 涂层牌号 / coated grades				S		•	•	•	•	○
■ 钎焊/金属陶瓷 / brazed/Cermet				H						

尺寸单位 : mm

Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。

Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

硬质合金牌号

Carbide grades

# 端面切槽 FACE GROOVING

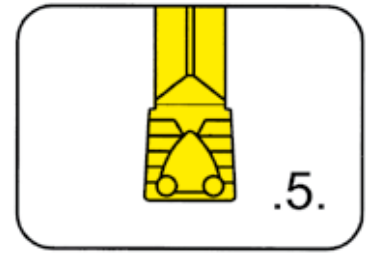


## 可转位刀片 型号

INDEXABLE INSERT Type

## S224

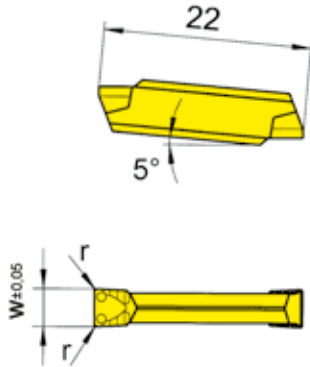
带断屑槽  
with chip forming



槽深可达  
槽宽

Depth of groove up to 18.0 mm  
Width of groove 3.0 - 5.0 mm

精密烧结  
precision sintered



配合 刀夹  
for use with Cassette

型号 L/RAK224  
Type L/RIK224

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TN32	TN35	TI25	TF45	AL96
S224.0300.52 S224.0300.54	3	0.2 0.4	03	▲	▲	▲	▲	▲
S224.0400.52 S224.0400.54	4	0.2 0.4	04	▲	▲	▲	▲	▲
S224.0500.54 S224.0500.58	5	0.4 0.8	05	▲	▲	▲	▲	▲
▲ 库存 / on stock   Δ 4周 / 4 weeks				P	●	●	●	●
● 主要应用 / main recommendation				M	●	●	●	●
○ 可选推荐 / alternative recommendation				K	●	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet				H	●	●	●	●

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。  
Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

# 端面切槽

## FACE GROOVING

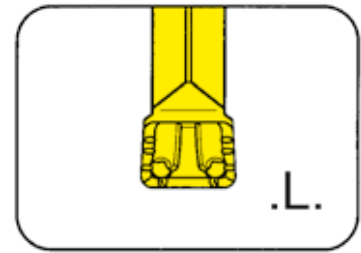


### 可转位刀片 型号

INDEXABLE INSERT Type

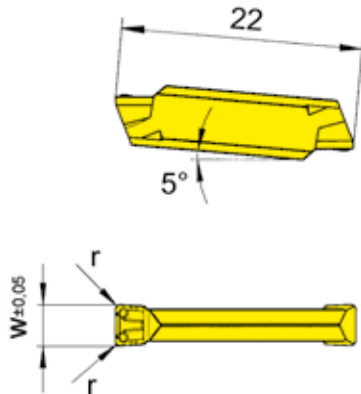
## S224

带断屑槽  
with chip forming



槽深可达	Depth of groove up to	18.0 mm
槽宽	Width of groove	4.0 - 6.0 mm

精密烧结  
precision sintered



配合 刀夹  
for use with Cassette

型号 L/RAK224  
Type L/RIK224

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TI22	TF42	AL96
S224.0400.L4	4	0.4	04	▲	▲	▲
S224.0500.L4 S224.0500.L6	5	0.4 0.6	05	▲ △	▲ ▲	▲ △
S224.0600.L4 S224.0600.L6	6	0.4 0.6	06	▲ ▲	▲ △	▲ ▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	•	•
● 主要应用 / main recommendation				M		
○ 可选推荐 / alternative recommendation				K		•
■ 无涂层牌号 / uncoated grades				N		•
■ 涂层牌号 / coated grades				S		
■ 钎焊/金属陶瓷 / brazed/Cermet				H		

尺寸单位 : mm  
Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。  
Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

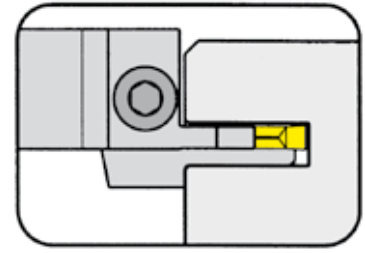
硬质合金牌号  
Carbide grades

# 端面切槽 FACE GROOVING



刀杆 型号  
TOOLHOLDER Type

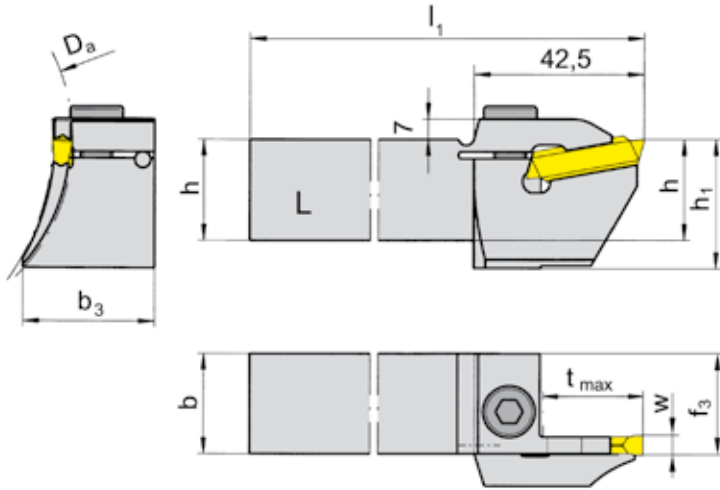
## LA226



端面槽起始外径	from outer groove $\varnothing$	95.0 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	h	$h_1$	$l_1$	b	$b_3$	$f_3$	w
LA226.20.1318.04	130	180	25	20	32	150	20	25	205.0	4
LA226.20.9513.04	95	130	25	20	32	150	20	26	205.0	4
LA226.25.1318.04	130	180	25	25	32	150	25	30	255.0	4
LA226.25.9513.04	95	130	25	25	32	150	25	31	255.0	4
LA226.20.1318.05	130	180	25	20	32	150	20	25	205.0	5
LA226.20.9513.05	95	130	25	20	32	150	20	28	205.0	5
LA226.25.1318.05	130	180	25	25	32	150	25	30	255.0	5
LA226.25.9513.05	95	130	25	25	32	150	25	33	255.0	5

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
LA226.2...	218.3	SW6.911

N52

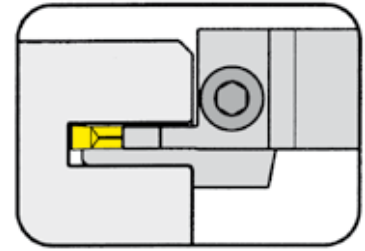
N

# 端面切槽 FACE GROOVING



刀杆 型号  
TOOLHOLDER Type

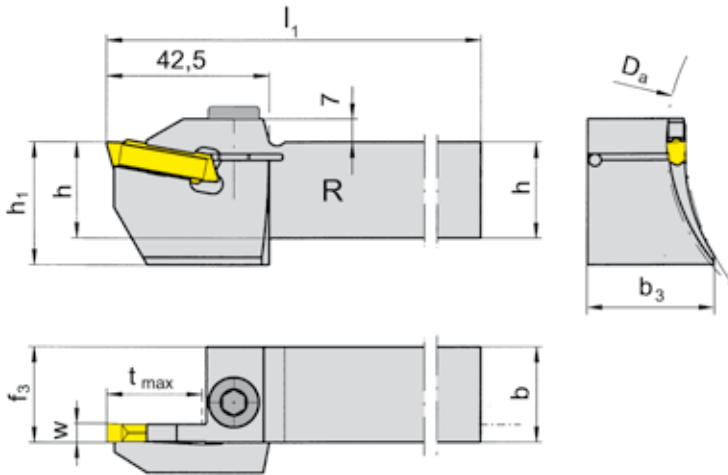
## RA226



端面槽起始外径	from outer groove $\varnothing$	95.0 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	h	$h_1$	$l_1$	b	$b_3$	$f_3$	w
RA226.20.1318.04	130	180	25	20	32	150	20	25	205.0	4
RA226.20.9513.04	95	130	25	20	32	150	20	26	205.0	4
RA226.25.1318.04	130	180	25	25	32	150	25	30	255.0	4
RA226.25.9513.04	95	130	25	25	32	150	25	31	255.0	4
RA226.20.1318.05	130	180	25	20	32	150	20	25	205.0	5
RA226.20.9513.05	95	130	25	20	32	150	20	28	205.0	5
RA226.25.1318.05	130	180	25	25	32	150	25	30	255.0	5
RA226.25.9513.05	95	130	25	25	32	150	25	33	255.0	5

按需提供更多尺寸  
Further sizes upon request

尺寸单位: mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
RA226.2...	218.3	SW6.911

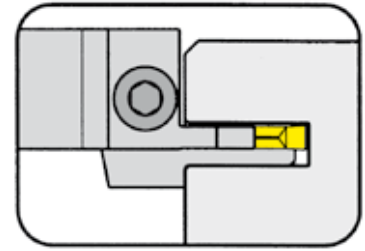
N

# 端面切槽 FACE GROOVING



刀杆 型号  
TOOLHOLDER Type

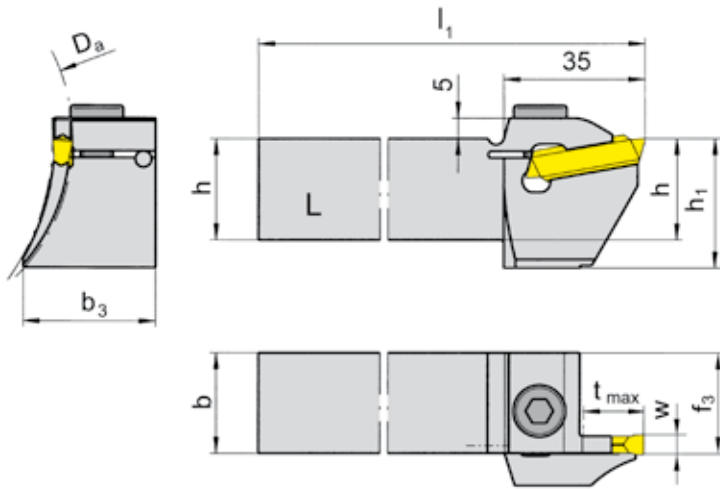
## LA210



端面槽起始外径	from outer groove $\varnothing$	95.0 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 8.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	h	$h_1$	$l_1$	b	$b_3$	$f_3$	w
LA210.20.1318.14	130	180	15	20	32	150	20	25.0	205.0	4
LA210.20.9513.14	95	130	15	20	32	150	20	26.0	205.0	4
LA210.25.1318.14	130	180	15	25	32	150	25	30.0	255.0	4
LA210.25.9513.14	95	130	15	25	32	150	25	31.0	255.0	4
LA210.20.1318.15	130	180	15	20	32	150	20	25.0	205.0	5
LA210.20.9513.15	95	130	15	20	32	150	20	28.0	205.0	5
LA210.25.1318.15	130	180	15	25	32	150	25	30.0	255.0	5
LA210.25.9513.15	95	130	15	25	32	150	25	33.0	255.0	5
LA210.25.1318.18	130	180	15	25	32	150	25	30.5	255.0	8

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
LA210.2...	218.3	SW6.911

N54

N

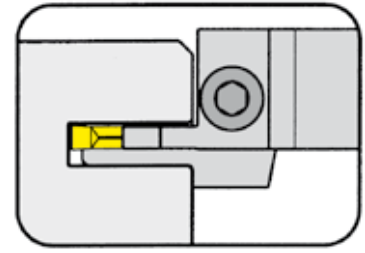


# 端面切槽 FACE GROOVING

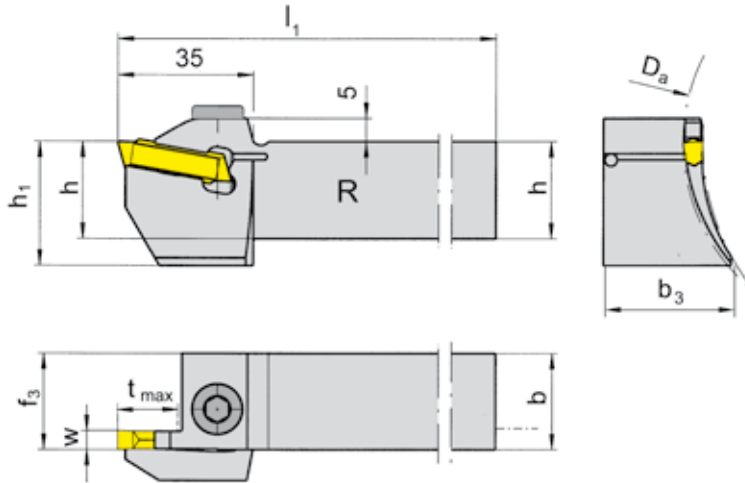


刀杆 型号  
TOOLHOLDER Type

## RA210



端面槽起始外径	from outer groove $\varnothing$	95.0 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 8.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	h	$h_1$	$l_1$	b	$b_3$	$f_3$	w
RA210.20.9513.14	95	130	15	20	32	150	20	26.0	205.0	4
RA210.25.9513.14				25			31.0	255.0		
RA210.20.9513.15	95	130	15	20	32	150	20	28.0	205.0	5
RA210.25.9513.15				25			33.0	255.0		
RA210.20.1318.14	130	180	15	20	32	150	20	25.0	205.0	4
RA210.25.1318.14				25			30.0	255.0		
RA210.20.1318.15	130	180	15	20	32	150	20	25.0	205.0	5
RA210.25.1318.15				25			30.0	255.0		
RA210.32.1318.15				32			37.0	325.0		
RA210.25.1318.18	130	180	15	25	32	150	25	30.5	255.0	8

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
RA210....	218.3	SW6.911

N

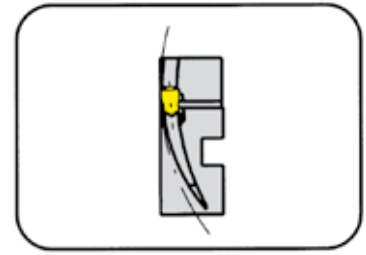
# 端面切槽 FACE GROOVING



## 刀夹 型号

CASSETTE Type

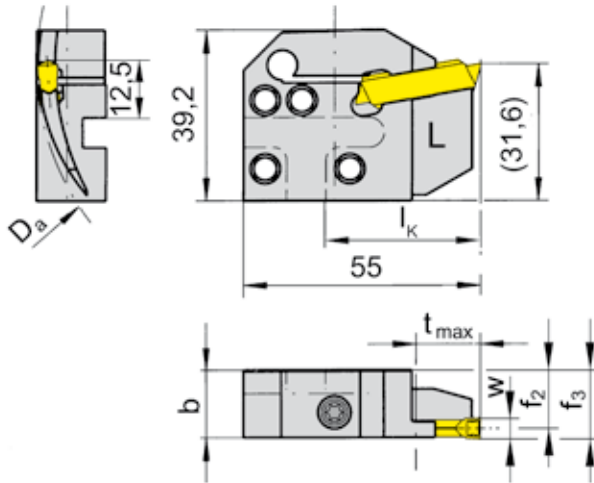
# LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6575.14	65	75	10					
LIK220.7595.14	75	95	15					
LIK220.9513.14	95	130	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.1318.14	130	180	15					
LIK220.1830.14	180	300	15					
LIK220.6075.15	60	75	10					
LIK220.7595.15	75	95	15					
LIK220.9513.15	95	130	15	15.7	13.9	$f_2+w/2$	5	36
LIK220.1318.15	130	180	15					
LIK220.1830.15	180	300	15					

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀杆内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

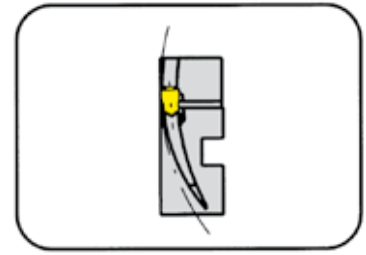
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

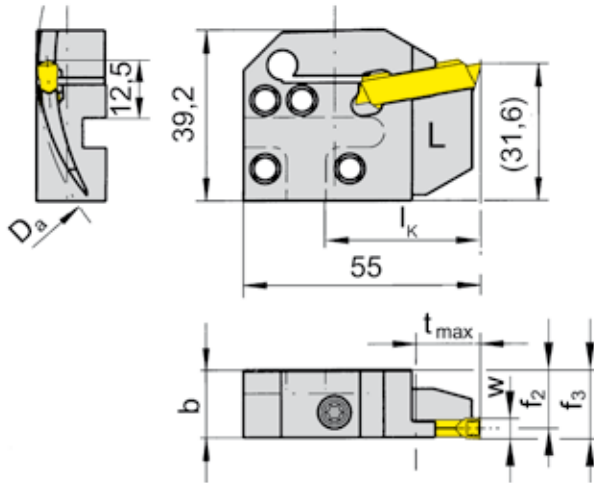
## LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6075.16	60	75	10					
LIK220.7595.16	75	95	15					
LIK220.9513.16	95	130	15	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.16	130	180	15					
LIK220.1830.16	180	300	15					

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

N

# 端面切槽

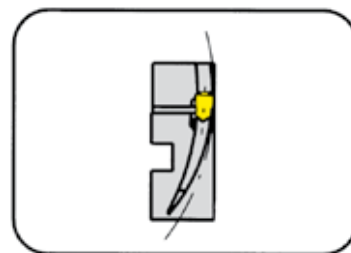
## FACE GROOVING



### 刀夹 型号

CASSETTE Type

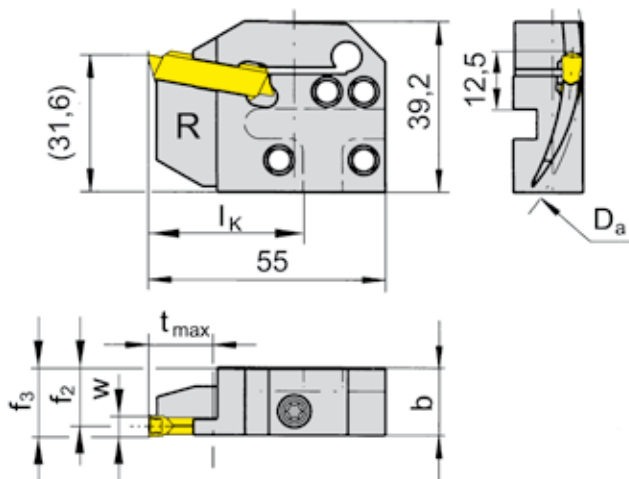
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6575.14	65	75	10					
RIK220.7595.14	75	95	15					
RIK220.9513.14	95	130	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.1318.14	130	180	15					
RIK220.1830.14	180	300	15					
RIK220.6075.15	60	75	10					
RIK220.7595.15	75	95	15					
RIK220.9513.15	95	130	15	15.7	13.9	$f_2+w/2$	5	36
RIK220.1318.15	130	180	15					
RIK220.1830.15	180	300	15					

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀杆内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

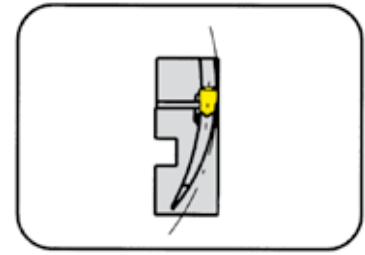
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

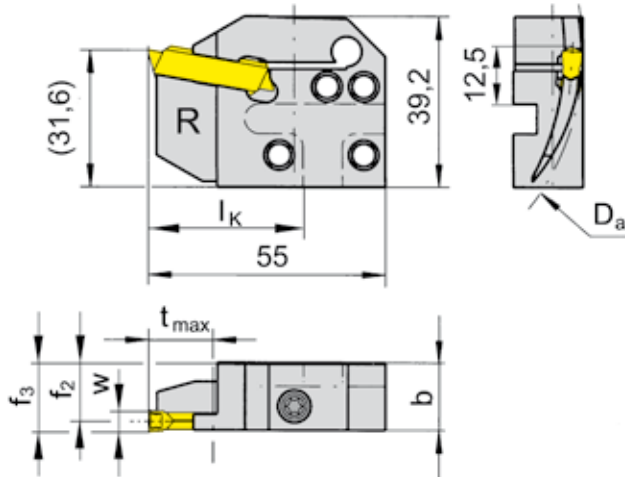
## RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
RIK220.6075.16	60	75	10					
RIK220.7595.16	75	95	15					
RIK220.9513.16	95	130	15	15.7	13.4	$f_2+w/2$	6	36
RIK220.1318.16	130	180	15					
RIK220.1830.16	180	300	15					

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知 :  
锁紧螺钉包含在刀杆内,不需要单独订购  
**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

N

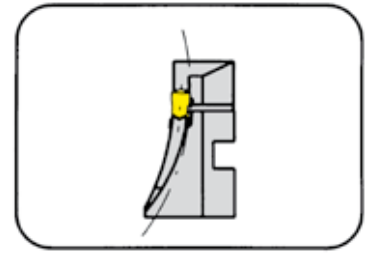
# 端面切槽 FACE GROOVING



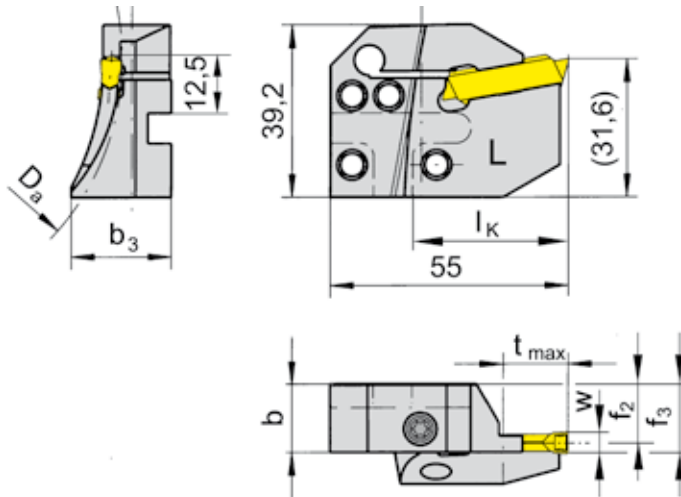
## 刀夹 型号

CASSETTE Type

# LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6575.14	65	75	10		23.0				
LAK220.7595.14	75	95	15		23.0				
LAK220.9513.14	95	130	15	15.7	21.2	14.4	$f_2+w/2$	4	36
LAK220.1318.14	130	180	15		21.2				
LAK220.1830.14	180	300	15		19.0				
LAK220.6075.15	60	75	10		23.0				
LAK220.7595.15	75	95	15		23.0				
LAK220.9513.15	95	130	15	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.1318.15	130	180	15		21.2				
LAK220.1830.15	180	300	15		19.0				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购  
Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

# 端面切槽

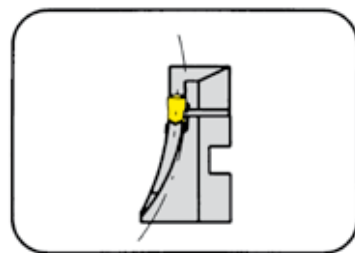
## FACE GROOVING



### 刀夹 型号

CASSETTE Type

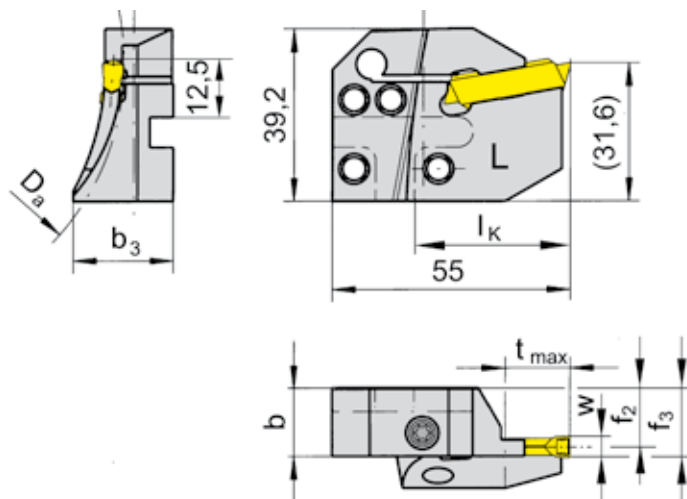
# LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	$b$	$b_3$	$f_2$	$f_3$	$w$	$l_k$
LAK220.6075.16	60	75	10		23.0				
LAK220.7595.16	75	95	15		23.0				
LAK220.9513.16	95	130	15	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.1318.16	130	180	15		21.2				
LAK220.1830.16	180	300	15		19.0				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ



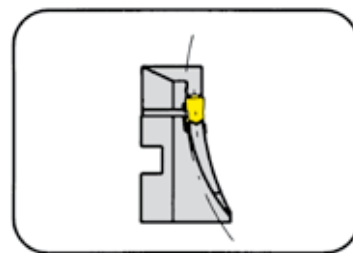
# 端面切槽 FACE GROOVING



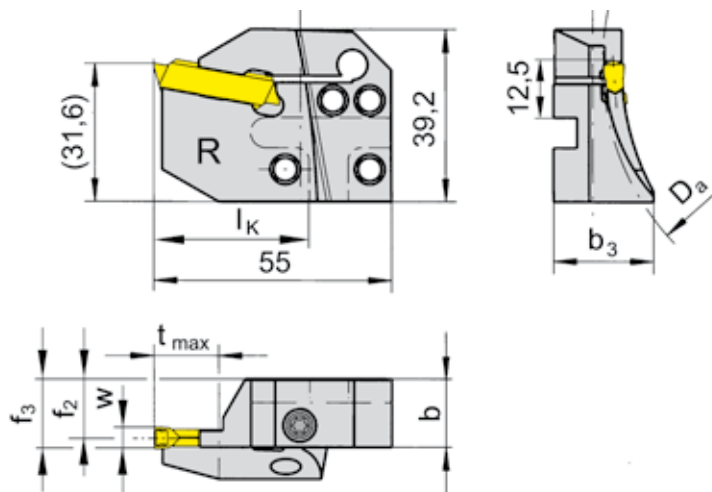
## 刀夹 型号

CASSETTE Type

# RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	4.0 - 5.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6575.14	65	75	10		23.0				
RAK220.7595.14	75	95	15		23.0				
RAK220.9513.14	95	130	15	15.7	21.2	14.4	$f_2+w/2$	4	36
RAK220.1318.14	130	180	15		21.2				
RAK220.1830.14	180	300	15		19.0				
RAK220.6075.15	60	75	10		23.0				
RAK220.7595.15	75	95	15		23.0				
RAK220.9513.15	95	130	15	15.7	23.0	13.9	$f_2+w/2$	5	36
RAK220.1318.15	130	180	15		21.2				
RAK220.1830.15	180	300	15		19.0				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

### 订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

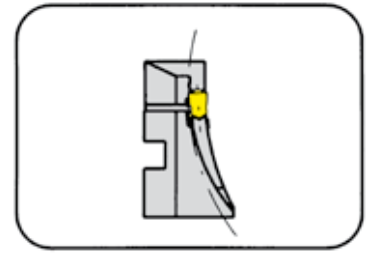


# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

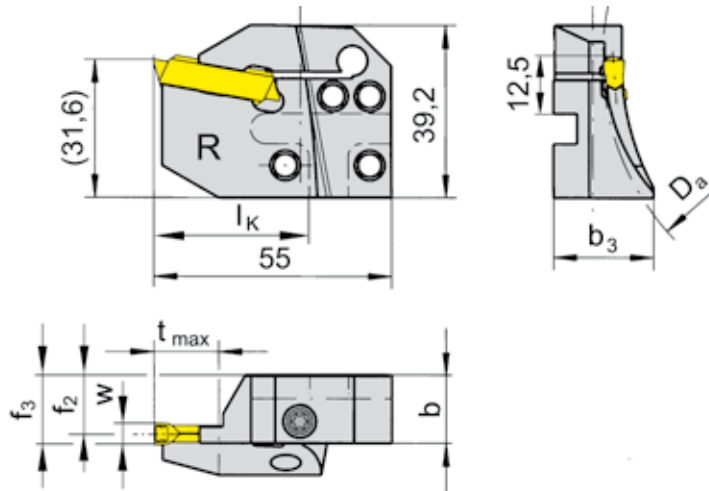
## RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 300 mm
槽深可达	Depth of groove up to	15.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6075.16	60	75	10		23.0				
RAK220.7595.16	75	95	15		23.0				
RAK220.9513.16	95	130	15	15.7	23.0	13.4	$f_2+w/2$	6	36
RAK220.1318.16	130	180	15		21.2				
RAK220.1830.16	180	300	15		19.0				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

N

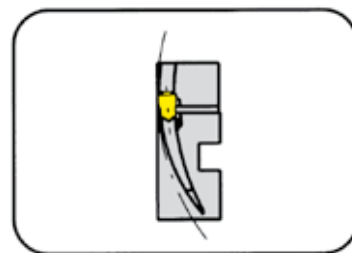
# 端面切槽 FACE GROOVING



## 刀夹 型号

CASSETTE Type

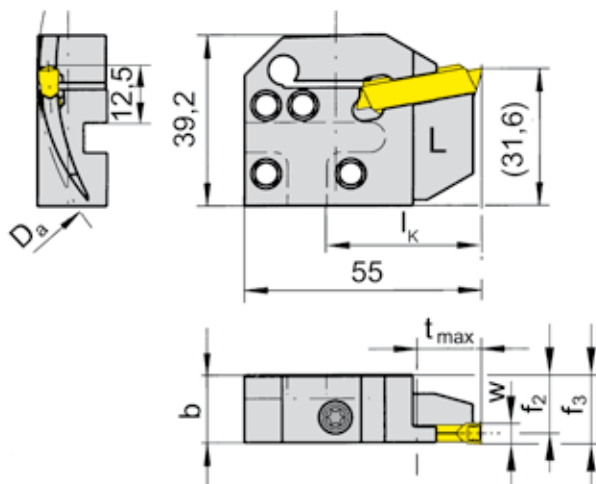
# LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型

L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6575.04	65	10	75	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.7595.04	75	15	95	25					
LIK220.9513.04	95	25	130	25					
LIK220.1318.04	130	25	180	25					
LIK220.1830.04	180	25	300	25					
LIK220.3000.04	300	25	1000	25	15.7	13.9	$f_2+w/2$	5	36
LIK220.6075.05	60	10	75	17					
LIK220.7595.05	75	17	95	25					
LIK220.9513.05	95	25	130	25					
LIK220.1318.05	130	25	180	25					
LIK220.1830.05	180	25	300	25					
LIK220.3000.05	300	25	1000	25					

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

### 订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

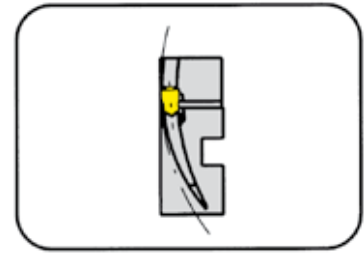
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

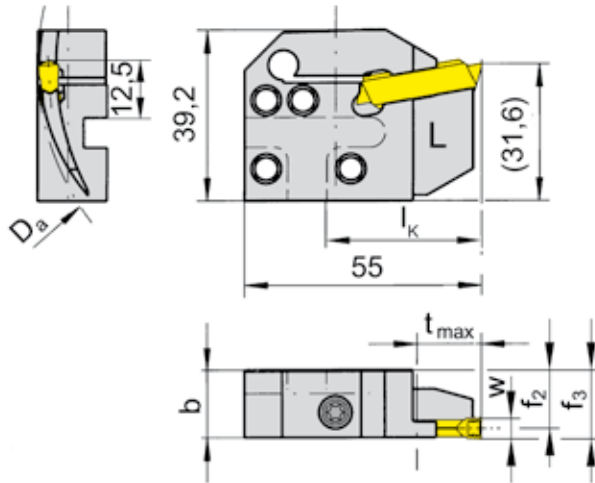
## LIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
LIK220.6075.06	60	10	75	17					
LIK220.7595.06	75	17	95	25					
LIK220.9513.06	95	25	130	25	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.06	130	25	180	25					
LIK220.1830.06	180	25	300	25					
LIK220.3000.06	300	25	1000	25					

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知:  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LIK220....	6.23T25P	T25PQ

N

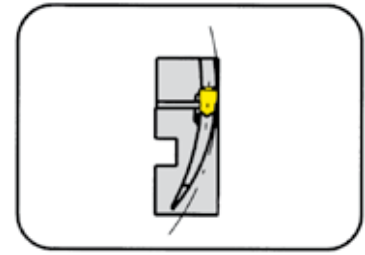
# 端面切槽 FACE GROOVING



## 刀夹 型号

CASSETTE Type

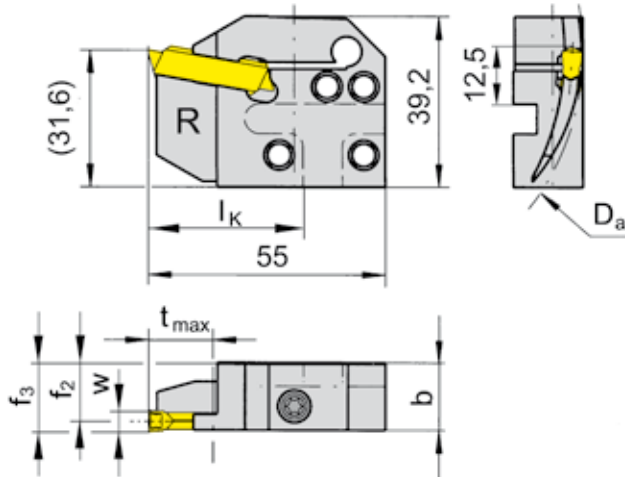
# RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$I_k$
RIK220.6575.04	65	10	75	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.7595.04	75	15	95	25					
RIK220.9513.04	95	25	130	25					
RIK220.1318.04	130	25	180	25					
RIK220.1830.04	180	25	300	25					
RIK220.3000.04	300	25	1000	25					
RIK220.6075.05	60	10	75	17	15.7	13.9	$f_2+w/2$	5	36
RIK220.7595.05	75	17	95	25					
RIK220.9513.05	95	25	130	25					
RIK220.1318.05	130	25	180	25					
RIK220.1830.05	180	25	300	25					
RIK220.3000.05	300	25	1000	25					

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

### 订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no seperate order required.

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	6.23T25P	T25PQ

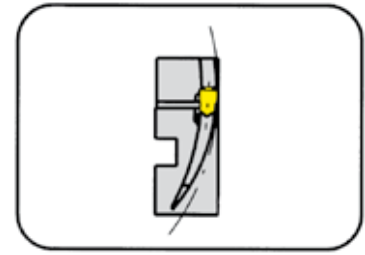
# 端面切槽 FACE GROOVING



## 刀夹 型号

CASSETTE Type

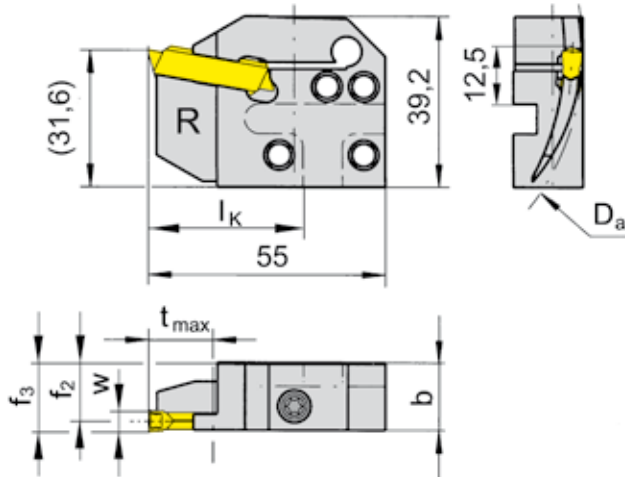
# RIK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深	Depth of groove	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$f_2$	$f_3$	w	$l_k$
<b>RIK220.6075.06</b>	60	10	75	17					
<b>RIK220.7595.06</b>	75	17	95	25					
<b>RIK220.9513.06</b>	95	25	130	25	15.7	13.4	$f_2+w/2$	6	36
<b>RIK220.1318.06</b>	130	25	180	25					
<b>RIK220.1830.06</b>	180	25	300	25					
<b>RIK220.3000.06</b>	300	25	1000	25					

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位 : mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RIK220....	<b>6.23T25P</b>	<b>T25PQ</b>

N

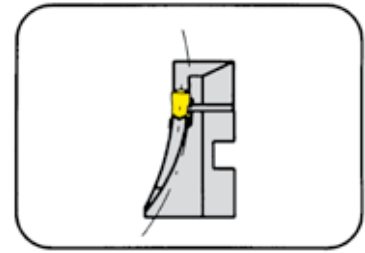
# 端面切槽

## FACE GROOVING



刀夹 型号  
CASSETTE Type

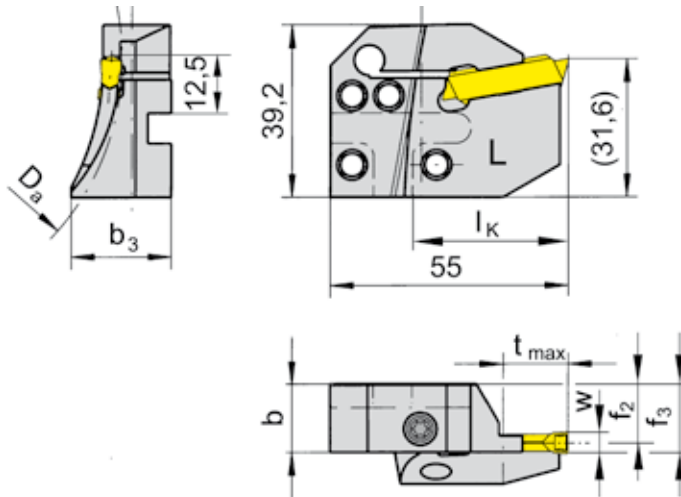
# LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6575.04	65	10	75	15	15.7	23.0	14.4	$f_2+w/2$	4	36
LAK220.7595.04	75	15	95	25		23.0				
LAK220.9513.04	95	25	130	25		21.2				
LAK220.1318.04	130	25	180	25		21.2				
LAK220.1830.04	180	25	300	25		21.2				
LAK220.3000.04	300	25	1000	25		16.8				
LAK220.6075.05	60	10	75	17	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.7595.05	75	17	95	25		23.0				
LAK220.9513.05	95	25	130	25		23.0				
LAK220.1318.05	130	25	180	25		21.2				
LAK220.1830.05	180	25	300	25		21.2				
LAK220.3000.05	300	25	1000	25		16.8				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

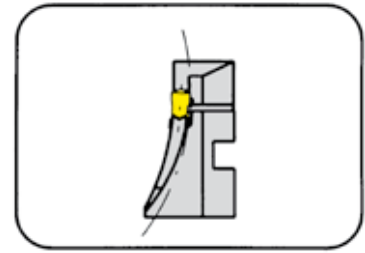
刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

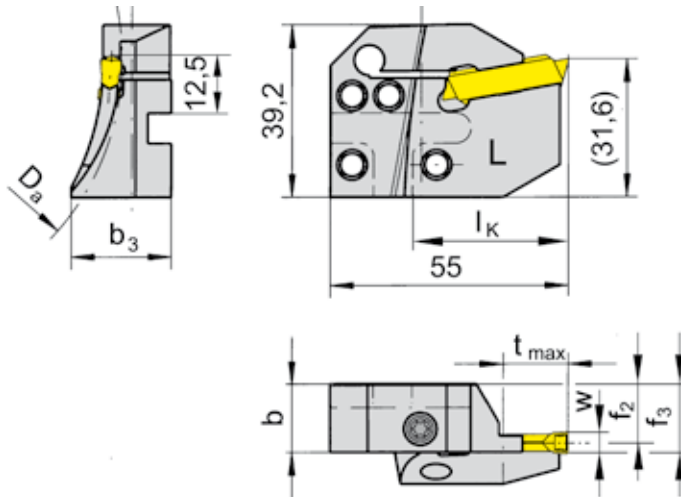
## LAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



L=左手型  
L = left hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
LAK220.6075.06	60	10	75	17	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.7595.06	75	17	95	25		23.0				
LAK220.9513.06	95	25	130	25		23.0				
LAK220.1318.06	130	25	180	25		21.2				
LAK220.1830.06	180	25	300	25		21.2				
LAK220.3000.06	300	25	1000	25		16.8				

配合常规刀杆L...K1和R...K2  
For basic toolholder L...K1 and R...K2

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LAK220....	6.23T25P	T25PQ

N

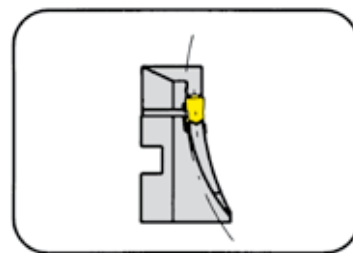
# 端面切槽 FACE GROOVING



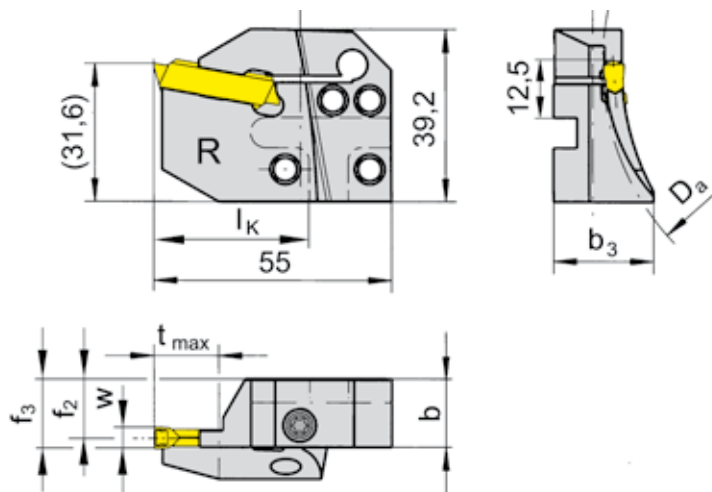
## 刀夹 型号

CASSETTE Type

# RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 5.0 mm



配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type

R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6575.04	65	10	75	15		23.0				
RAK220.7595.04	75	15	95	25		23.0				
RAK220.9513.04	95	25	130	25	15.7	21.2	14.4	$f_2+w/2$	4	36
RAK220.1318.04	130	25	180	25		21.2				
RAK220.1830.04	180	25	300	25		21.2				
RAK220.3000.04	300	25	1000	25		16.8				
RAK220.6075.05	60	10	75	17		23.0				
RAK220.7595.05	75	17	95	25		23.0				
RAK220.9513.05	95	25	130	25	15.7	23.0	13.9	$f_2+w/2$	5	36
RAK220.1318.05	130	25	180	25		21.2				
RAK220.1830.05	180	25	300	25		21.2				
RAK220.3000.05	300	25	1000	25		16.8				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

### 订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

### Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

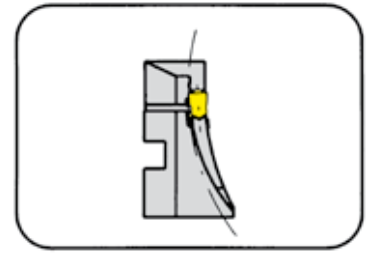


# 端面切槽 FACE GROOVING



刀夹 型号  
CASSETTE Type

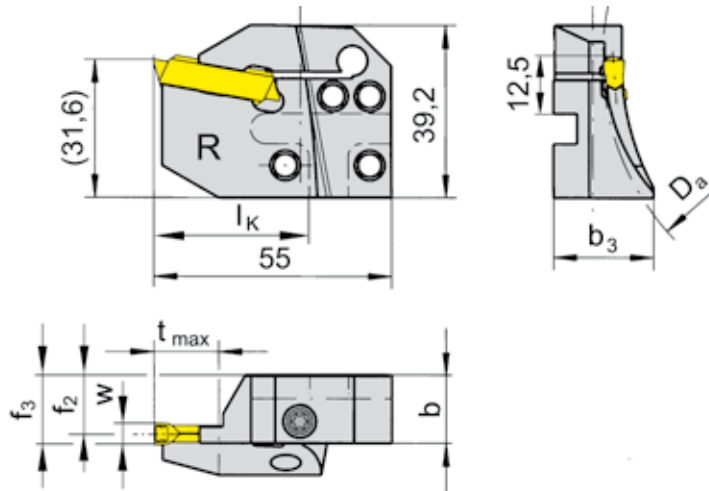
## RAK220



槽外径 $\varnothing$	Outer groove $\varnothing$	60 - 1000 mm
槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	6.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S229  
Type



R=右手型  
R = right hand version

产品型号 Part number	$D_{a \min}$	$t_{\max}$	$D_{a \max}$	$t_{\max}$	b	$b_3$	$f_2$	$f_3$	w	$l_k$
RAK220.6075.06	60	10	75	17		23.0				
RAK220.7595.06	75	17	95	25		23.0				
RAK220.9513.06	95	25	130	25		23.0				
RAK220.1318.06	130	25	180	25	15.7	21.2	13.4	$f_2+w/2$	6	36
RAK220.1830.06	180	25	300	25		21.2				
RAK220.3000.06	300	25	1000	25		16.8				

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

订货须知：  
锁紧螺钉包含在刀杆内,不需要单独订购

**Ordering note:**  
The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RAK220....	6.23T25P	T25PQ

N

# 端面切槽 FACE GROOVING

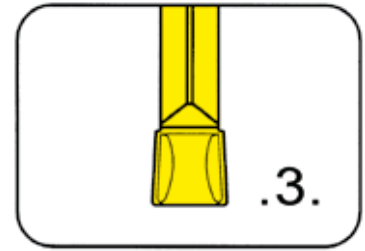


## 可转位刀片 型号

INDEXABLE INSERT Type

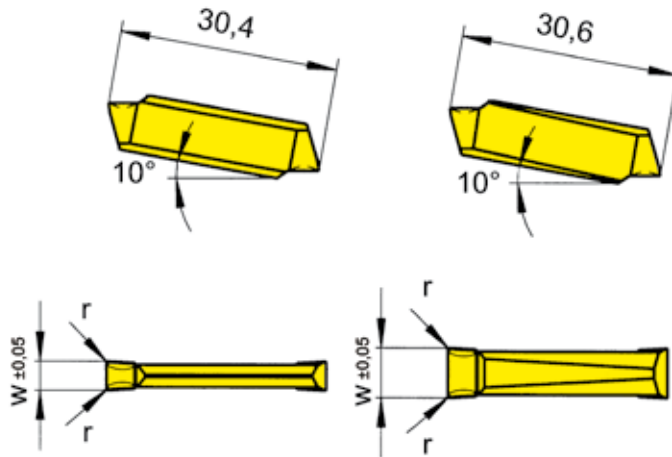
## S229

带断屑槽  
with chip former



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 6.0 mm

精密烧结  
precision sintered



宽度4.0-5.0mm  
Width 4,0 - 5,0 mm

宽度6.0mm  
Width 6,0 mm

配合 刀夹  
for use with Cassette

型号 L/RAK220  
Type L/RIK220

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	H54	TN32	TN35	T122	T125	TF42	TF45	AS62	AS66
S229.0400.32	4	0.2	03 / 04	▲	▲	▲	△	▲		▲	▲	▲
S229.0400.34		0.4		▲	▲	▲		▲	▲	▲	▲	
S229.0500.34	5	0.4	04			▲	▲	▲		▲	▲	▲
S229.0500.36		0.6										
S229.0600.34	6	0.4	05			▲	△	▲		▲	▲	▲
S229.0600.38		0.8										▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	•	•	•	•	•	•	•	•
● 主要应用 / main recommendation				M	•			•		•		○
○ 可选推荐 / alternative recommendation				K			•	•		•		•
■ 无涂层牌号 / uncoated grades				N				•		•		•
■ 涂层牌号 / coated grades				S				•		•		○
■ 钎焊/金属陶瓷 / brazed/Cermet				H								

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。  
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

# 端面切槽 FACE GROOVING

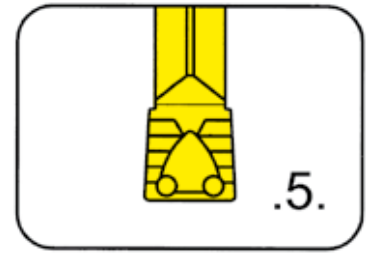


## 可转位刀片 型号

INDEXABLE INSERT Type

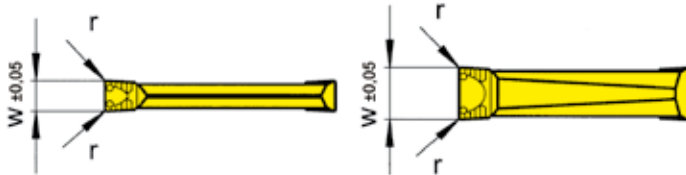
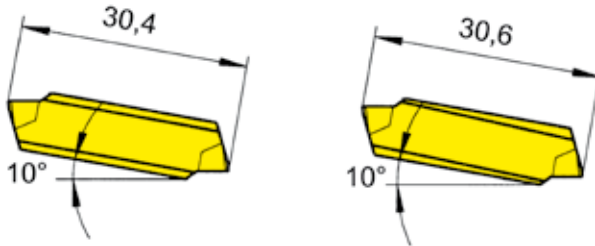
## S229

带断屑槽  
with chip forming



槽深可达	Depth of groove up to	25.0 mm
槽宽	Width of groove	4.0 - 6.0 mm

精密烧结  
precision sintered



宽度4.0-5.0mm  
Width 4,0 - 5,0 mm

宽度6.0mm  
Width 6,0 mm

配合 刀夹  
for use with Cassette

型号 L/RAK220  
Type L/RIK220

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TN32	TN35	TI22	TI25	TF45	AS62
S229.0400.52 S229.0400.54	4	0.2 0.4	03 / 04	▲ ▲	▲ ▲	▲ ▲	▲ ▲	▲ ▲	▲ ▲
S229.0500.54 S229.0500.56	5	0.4 0.6	04	▲	▲	▲	▲	▲	▲
S229.0600.54 S229.0600.56	6	0.4 0.6	05	▲	▲		▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	•	•	•	•	•
● 主要应用 / main recommendation				M	•		•	•	
○ 可选推荐 / alternative recommendation				K	•		•	•	
■ 无涂层牌号 / uncoated grades				N	•		•	•	
■ 涂层牌号 / coated grades				S	•		•	•	
■ 钎焊/金属陶瓷 / brazed/Cermet				H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。  
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

# 端面切槽 FACE GROOVING

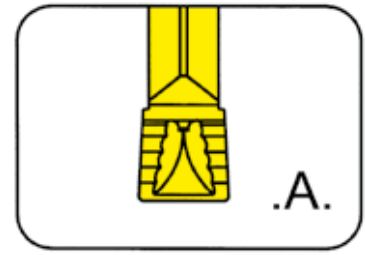


## 可转位刀片 型号

INDEXABLE INSERT Type

## S229

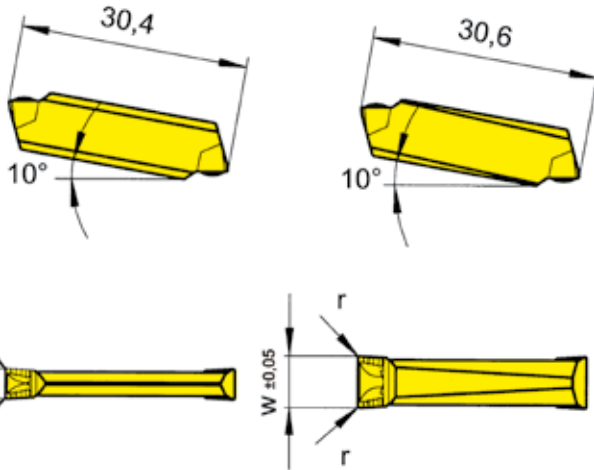
带断屑槽  
with chip forming



槽深可达  
槽宽

Depth of groove up to 25.0 mm  
Width of groove 4.0 - 6.0 mm

精密烧结  
precision sintered



宽度4.0-5.0mm  
Width 4,0 - 5,0 mm

宽度6.0mm  
Width 6,0 mm

配合 刀夹  
for use with Cassette

型号 L/RAK220  
Type L/RIK220

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	W	r	规格 Size	TN32	TN35	TI22	TI25	TF42	TF45	AS62
S229.0400.A2	4	0.2	03 / 04	▲	▲	▲	▲		▲	▲
S229.0400.A4		0.4		▲	▲	▲	▲	▲		▲
S229.0500.A4	5	0.4	04	▲	▲	▲			▲	▲
S229.0600.A4	6	0.4	05	▲	▲	▲	▲	▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks										
● 主要应用 / main recommendation										
○ 可选推荐 / alternative recommendation										
■ 无涂层牌号 / uncoated grades										
■ 涂层牌号 / coated grades										
■ 钎焊/金属陶瓷 / brazed/Cermet										
P	●	●	●	●	●	●	●	●	●	●
M		●			●				●	
K		●			●				●	
N		●			●				●	
S		●			●				●	
H										

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。  
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

# 端面切槽 FACE GROOVING

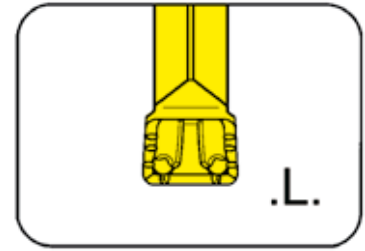


## 可转位刀片 型号

INDEXABLE INSERT Type

## S229

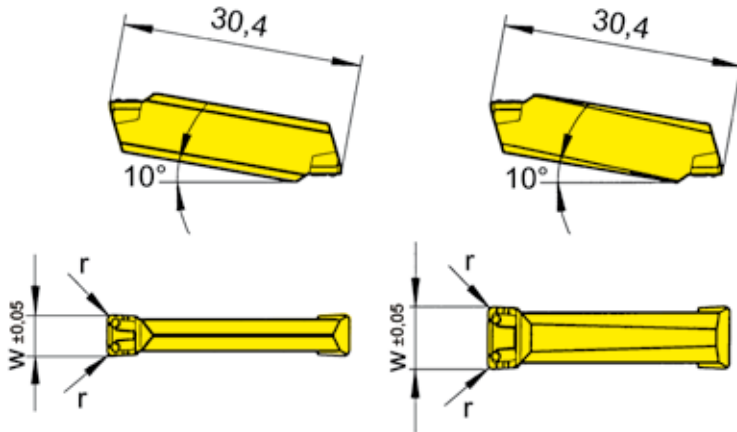
带断屑槽  
with chip forming



槽深可达  
槽宽

Depth of groove up to 25.0 mm  
Width of groove 4.0 - 6.0 mm

精密烧结  
precision sintered



配合 刀夹  
for use with Cassette

型号 L/RAK220  
Type L/RIK220

宽度4.0-5.0mm  
Width 4,0 - 5,0 mm

宽度6.0mm  
Width 6,0 mm

刀片长度重复定位精度  
±0.06 mm  
Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	TI22	TF42	AS62	AS66
S229.0400.L4	4	0.4	03 / 04	▲	▲	▲	▲
S229.0500.L4 S229.0500.L6	5	0.4 0.6	04	▲ △	▲ ▲	▲ ▲	▲ ▲
S229.0600.L4 S229.0600.L6	6	0.4 0.6	05	▲ ▲	▲ ▲	▲ ▲	▲ ▲
▲ 库存 / on stock    △ 4周 / 4 weeks				P	●	●	●
● 主要应用 / main recommendation				M	●	●	○
○ 可选推荐 / alternative recommendation				K	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●
■ 涂层牌号 / coated grades				S	●	●	○
■ 钎焊/金属陶瓷 / brazed/Cermet				H	●	●	●

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。  
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.



# HCG - HORN Catalogue Guide

## 仿形加工 / PROFILING

轮廓宽度 Width of profile	刀片 / Inserts <b>S117...</b>								
	.0010...	.0012...	.0014...	.0016...	.0018...	.0020...	.0026...	.0032...	.0045...
可达 / up to	10	12	14	16	18	20	26	32	45

轮廓深度 Depth of profile	刀片 / Inserts <b>S117...</b> 角度 / Angle <b>5°</b>								
	.0010.00	.0012.00	.0014.00	.0016.00	.0018.00	.0020.00	.0026.00	.0032.00	.0045.00
可达 / up to 3.5	•								
可达 / up to 4.5		•							
可达 / up to 6.0			•	•					
可达 / up to 6.5								•	•
可达 / up to 9.0					•	•			
可达 / up to 10.0							•		

轮廓深度 Depth of profile	刀片 / Inserts <b>S117...</b> 角度 / Angle <b>0°</b>				
	.0010.02.00	.0012.02.00	.0016.02.00	.0020.02.00	.0026.02.00
可达 / up to 6.5	•				
可达 / up to 7.5		•			
可达 / up to 9.0			•		
可达 / up to 12.0				•	
可达 / up to 13.0					•

章 / Chapter

0

仿形加工

Profiling

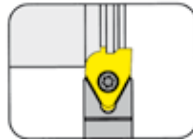


宽度  
Width

刀杆  
Toolholder

刀片  
Inserts

10 mm

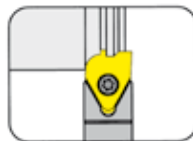


页/Page  
02,08,011,016



页/Page  
02,010,011,017

12 mm

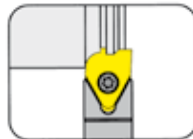


页/Page  
03,08,012,016



页/Page  
03,010,012,017

14 / 16 mm

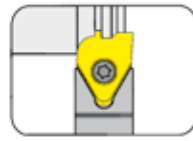


页/Page  
04,09,013,016



页/Page  
04,010,013,017

18 / 20 mm

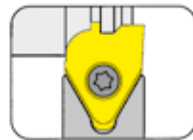


页/Page  
05,09,014,016



页/Page  
05,010,014,017

26 mm

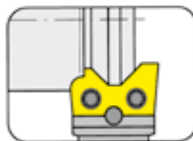


页/Page  
06,09,015,016

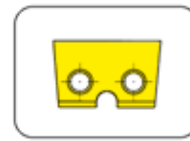


页/Page  
06,010,015,017

32 / 45 mm

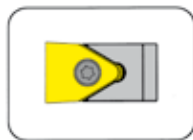


页/Page  
018



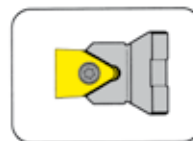
页/Page  
019

PWP  
10/12/16/32/45 mm



页/Page  
020

AWN  
10/12/16/20/32/45 mm



页/Page  
021

技术说明见章节Q

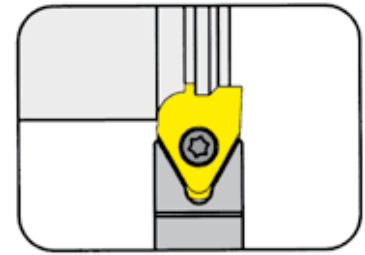
For Technical Instructions please see chapter Q



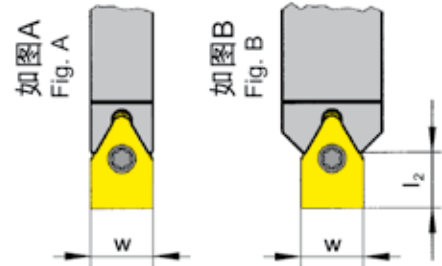
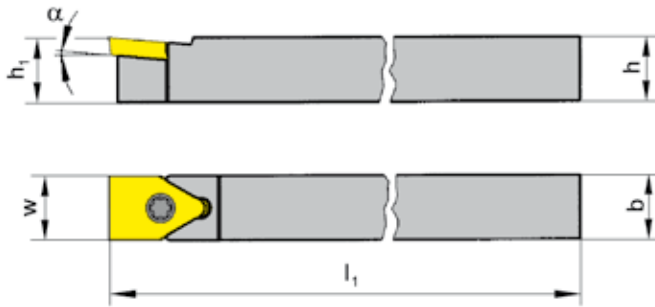
### 刀杆 型号

# H117

TOOLHOLDER type



轮廓深度 可达      Depth of profile up to      3.5 mm  
 轮廓宽度 可达      Width of profile      10.0 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.1010.10	5°	A	10	10	10	100	-		
H117.1212.10	5°	B	12	12	12	125	9	10	S117.0010.00
H117.1616.10	5°	B	16	16	16	125	9		

尺寸单位: mm  
Dimensions in mm

### 备件

Spare parts

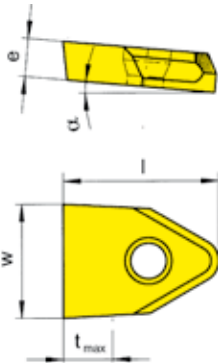
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117.1010.10 H117...10	<b>030-400P-0227</b> <b>4.09T15P</b>	<b>T15PQ</b> <b>T15PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

### 刀片 型号

# S117.0010.00

INSERT type



半精加工刀片:  
仅磨削接触区域和主切削刃  
Semi finished insert:  
Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0010.00	5°	10	3	16	3.5	H117...10



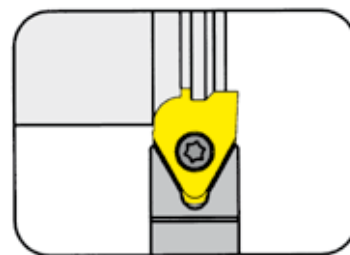
# 仿形加工 (外圆) PROFILING (external)



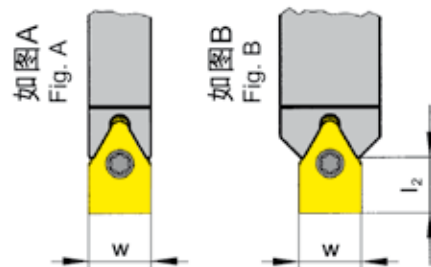
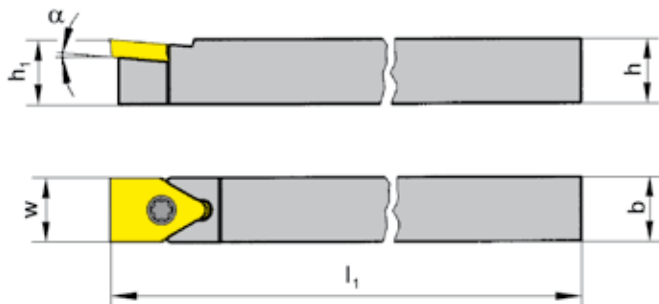
## 刀杆 型号

# H117

TOOLHOLDER type



轮廓深度 可达      Depth of profile up to      4.5 mm  
轮廓宽度 可达      Width of profile      12.0 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.1212.12	5°	A	12	12	12	125	-	12	S117.0012.00
H117.1414.12	5°	B	14	14	14	125	8		
H117.1612.12	5°	A	16	16	12	125	-		
H117.1616.12	5°	B	16	16	16	125	8		
H117.2020.12	5°	B	20	20	20	150	8		

尺寸单位: mm  
Dimensions in mm

## 备件

Spare parts

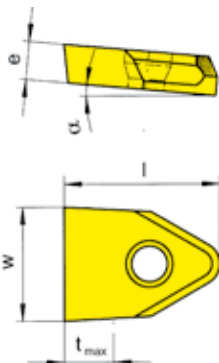
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...12	<b>4.09T15P</b>	<b>T15PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

# S117.0012.00

INSERT type



**半精加工刀片:**  
仅磨削接触区域和主切削刃  
**Semi finished insert:**  
Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0012.00	5°	12	4.5	17	4.5	H117...12

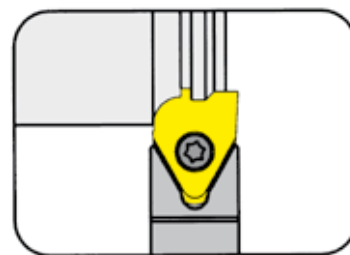
# 仿形加工 (外圆) PROFILING (external)



## 刀杆 型号

# H117

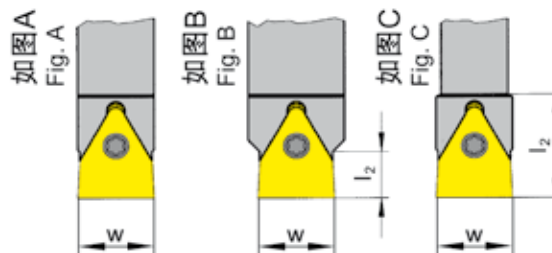
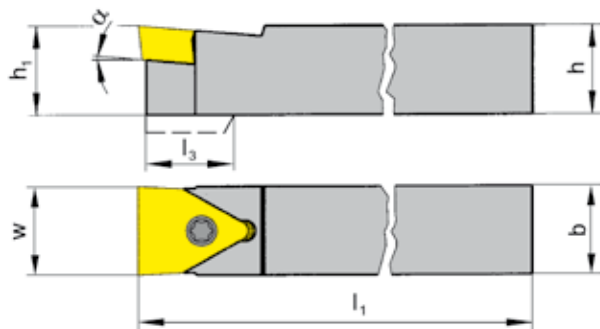
TOOLHOLDER type



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

6 mm  
14 - 16 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	$l_3$	w	半精加工刀片 Semi finished insert
<b>H117-1414-16</b>	5°	C	14	14	14	125	22	18	14	S117.0014.00
	5°	C	14	14	14	125	22	18	16	S117.0016.00
<b>H117-1616-16</b>	5°	B	16	16	16	125	11	-	14	S117.0014.00
	5°	A	16	16	16	125	-	-	16	S117.0016.00
<b>H117-2020-16</b>	5°	B	20	20	20	150	11	-	14	S117.0014.00
	5°	B	20	20	20	150	11	-	16	S117.0016.00
<b>H117-2525-16</b>	5°	B	25	25	25	150	11	-	14	S117.0014.00
	5°	B	25	25	25	150	11	-	16	S117.0016.00

## 备件

Spare parts

尺寸单位: mm  
Dimensions in mm

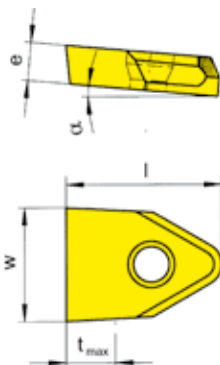
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...16	<b>5-12T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

INSERT type

# S117.0014.00 S117.0016.00



### 半精加工刀片:

仅磨削接触区域和主切削刃

### Semi finished insert:

Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
<b>S117.0014.00</b>	5°	14	6	21	6	H117...16
<b>S117.0016.00</b>	5°	16	6	21	6	

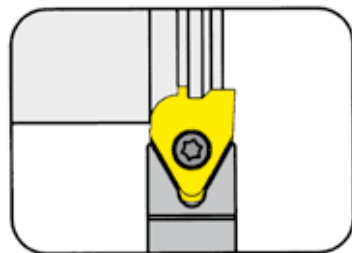
# 仿形加工 (外圆) PROFILING (external)



## 刀杆 型号

# H117

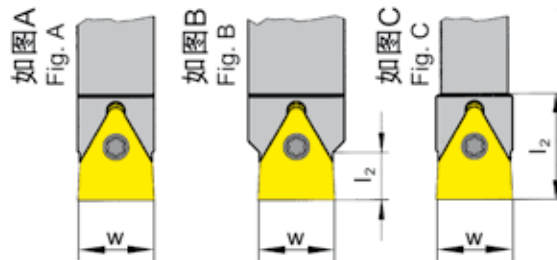
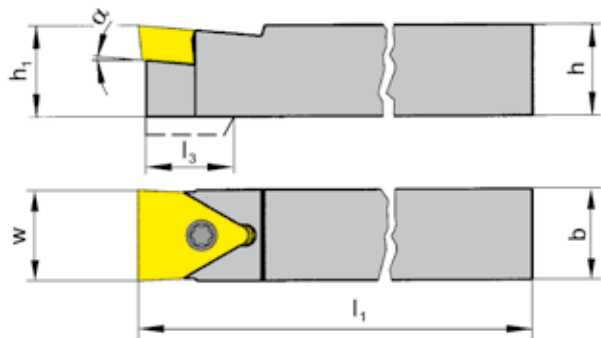
TOOLHOLDER type



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

9 mm  
18 - 20 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	$l_3$	w	半精加工刀片 Semi finished insert
H117.1616.20	5°	C	16	16	16	125	30	23	18	S117.0018.00
	5°	C	16	16	16	125	30	23	20	S117.0020.00
H117.2020.20	5°	B	20	20	20	150	15	-	18	S117.0018.00
	5°	A	20	20	20	150	-	-	20	S117.0020.00
H117.2525.20	5°	B	25	25	25	150	15	-	18	S117.0018.00
	5°	B	25	25	25	150	16	-	20	S117.0020.00

尺寸单位: mm  
Dimensions in mm

## 备件

Spare parts

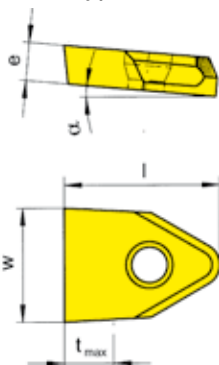
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...20	<b>6.17T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

INSERT type

# S117.0018.00 S117.0020.00



### 半精加工刀片:

仅磨削接触区域和主切削刃

### Semi finished insert:

Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0018.00	5°	18	7	29	9	H117...20
S117.0020.00	5°	20	7	29	9	

# 仿形加工 (外圆)

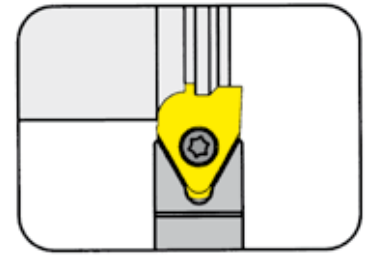
## PROFILING (external)



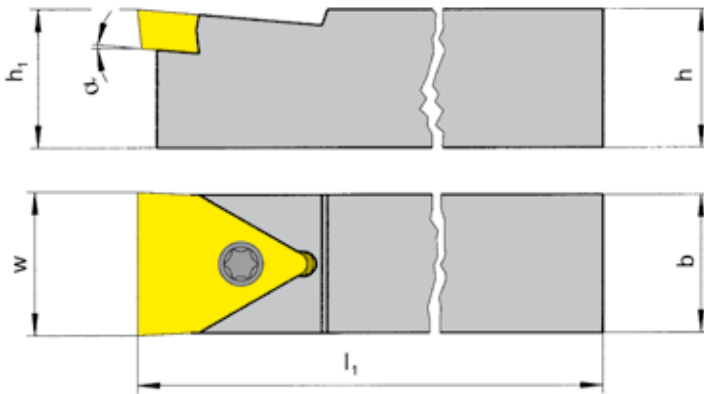
### 刀杆 型号

# H117

TOOLHOLDER type



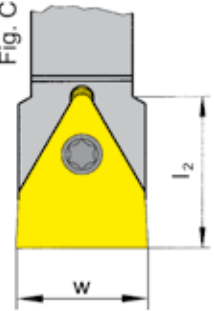
轮廓深度 可达      Depth of profile up to      13 mm  
 轮廓宽度 可达      Width of profile      26 mm



如图A  
Fig. A



如图C  
Fig. C



产品型号 Part number	$\alpha$	如图 Figure	h	h <sub>1</sub>	b	l <sub>1</sub>	l <sub>2</sub>	w	半精加工刀片 Semi finished insert
H117-2020-26	5°	C	20	20	20	150	30	26	S117.0026.00
H117-2525-26	5°	A	25	25	25	150	-		

尺寸单位：mm  
Dimensions in mm

### 备件

Spare parts

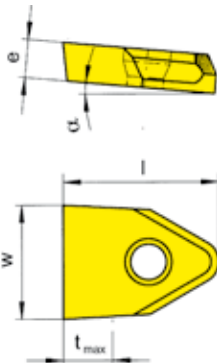
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...26	<b>6.17T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩，请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

### 刀片 型号

# S117.0026.00

INSERT type



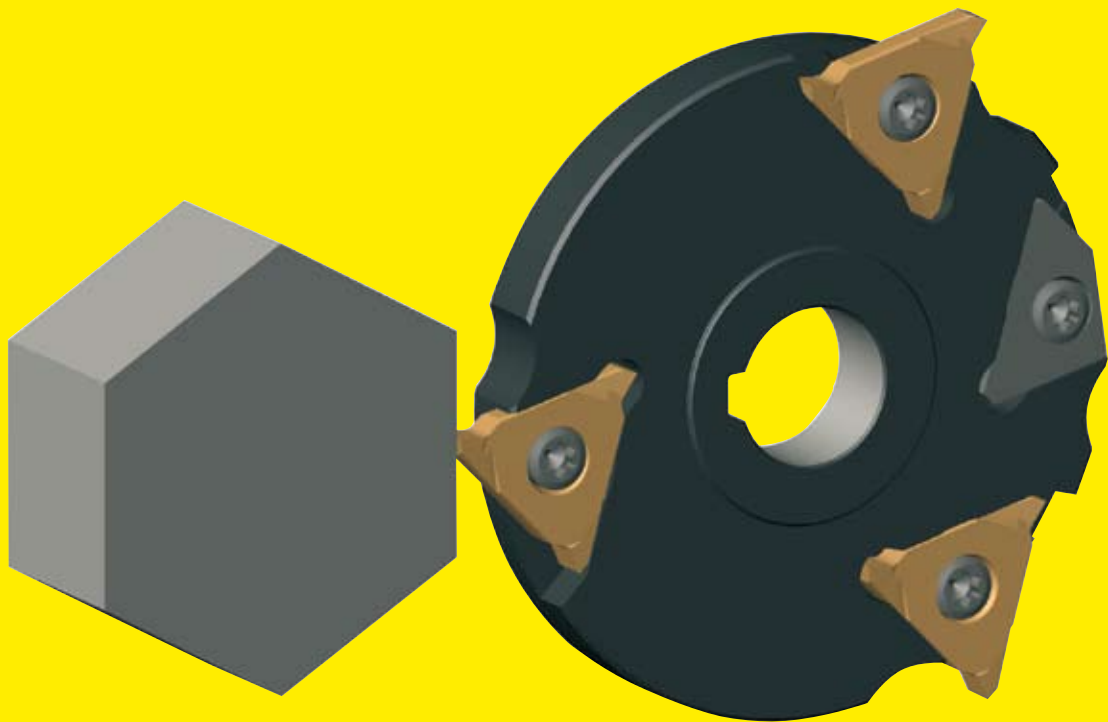
**半精加工刀片：**  
仅磨削接触区域和主切削刃  
**Semi finished insert:**  
Only contact areas and main cutting edge ground.

尺寸单位：mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	t <sub>max</sub>	刀杆 Toolholder
S117.0026.00	5°	26	7	32	10	H117...26

## 多边形铣刀头

适用于可加工多边形的车床  
更多信息  
见HORN样本“硬质合金旋转刀具”



### Cutter

For use on lathes with ability to machine polygon profiles.  
For further information please see the HORN catalogue  
"ROTATING TOOLS".

# 仿形加工 ( 外圆 )

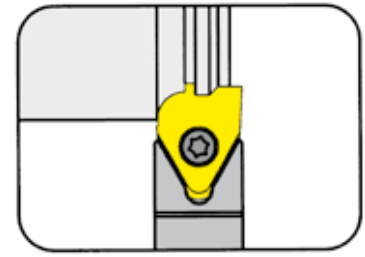
## PROFILING (external)



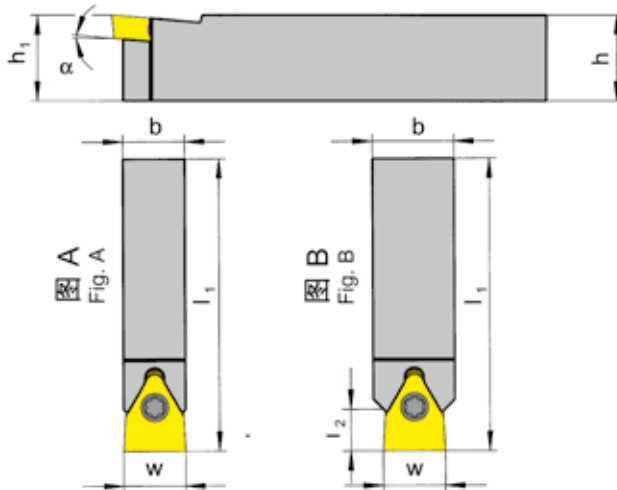
### 刀杆 型号

# H117

TOOLHOLDER Type



轮廓深度                      Depth of form up to                      4.5 mm  
 轮廓宽度可达                Width of form up to                      12.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

**概述**  
**OVERVIEW**

产品型号 Part number	$\alpha$	图型 Figure	h	$h_1$	b	$l_1$	$l_2$	w	刀片 Insert
H117.1010.10	5°	A	10	10	10	100	-	10	S117.0010.00
H117.1212.10		B	12	12	12	125	9		
H117.1616.10		B	16	16	16	125	9		
H117.1212.12	5°	A	12	12	12	125	-	12	S117.0012.00
H117.1414.12		B	14	14	14	125	8		
H117.1612.12		A	16	16	12	125	-		
H117.1616.12		B	16	16	16	125	8		
H117.2020.12		B	20	20	20	150	8		

按需提供更多角度  
Further angles upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117.1010.10	<b>030.400P.0227</b>	<b>T15PQ</b>
H117....10/12	<b>4.09T15P</b>	<b>T15PQ</b>

# 仿形加工 ( 外圆 )

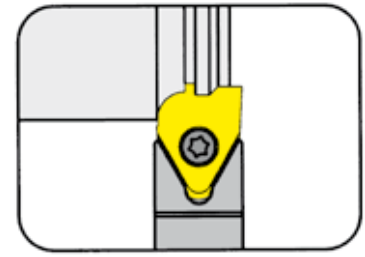
## PROFILING (external)



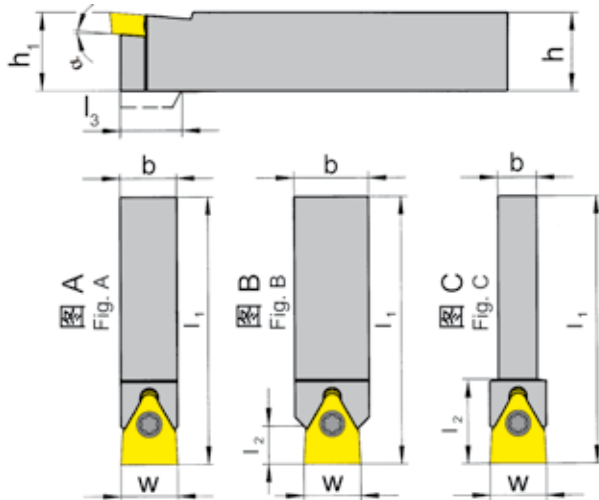
### 刀杆 型号

# H117

TOOLHOLDER Type



轮廓深度                      Depth of form up to                      10.0 mm  
 轮廓宽度可达                      Width of form up to                      26.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

概述  
OVERVIEW

产品型号 Part number	$\alpha$	图型 Figure	h	h <sub>1</sub>	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	w	刀片 Insert
H117.1414.16	5°	C	14	14	14	125	22.0	18	16	S117.0014/16.00
H117.1616.16		A / B	16	16	16	125	11.0	-		
H117.2020.16		B	20	20	20	150	11.0	-		
H117.2525.16		B	25	25	25	150	8.5	-		
H117.1616.20	5°	C	16	16	16	125	30.0	23	20	S117.0018/20.00
H117.2020.20		A / B	20	20	20	150	15.0	-		
H117.2525.20		B	25	25	25	150	15.0	-		
H117.2020.26	5°	C	20	20	20	150	30.0	-	26	S117.0026.00
H117.2525.26		A	25	25	25					

按需提供更多角度  
Further angles upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117....16	5.12T20P	T20PQ
H117....20/26	6.17T20P	T20PQ

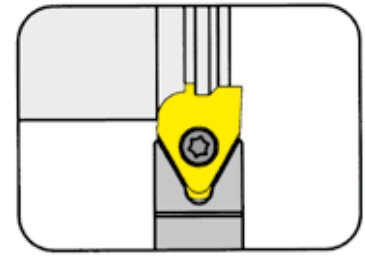


# 仿形加工 ( 外圆 ) PROFILING (external)

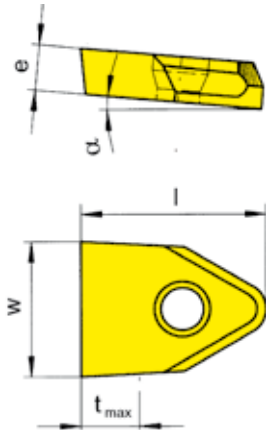


刀片 型号  
INSERT Type

## S117



轮廓深度                      Depth of form up to                      10.0 mm  
轮廓宽度可达                  Width of form up to                      26.0 mm



配合 刀杆  
for use with Toolholder

型号 H117  
Type

### 概述 OVERVIEW

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder	MG12	H54
S117.0010.00	5°	10	3.0	16	3.5	H117...10	▲	
S117.0012.00	5°	12	4.5	17	4.5	H117...12	▲	△
S117.0014.00	5°	14	6.0	21	6.0	H117...16	▲	
S117.0016.00	5°	16	6.0	21	6.0	H117...16	▲	
S117.0018.00	5°	18	7.0	29	9.0	H117...20	▲	
S117.0020.00	5°	20	7.0	29	9.0	H117...20	▲	
S117.0026.00	5°	26	7.0	32	10.0	H117...26	▲	

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	○	●
M	●	●
K	●	●
N	●	●
S	●	●
H		

尺寸单位 : mm  
Dimensions in mm



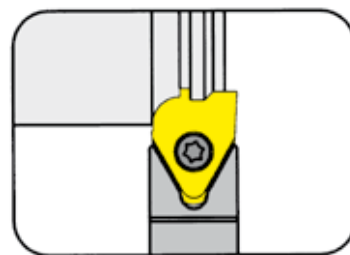
根据客户要求生产的各种仿形刀片  
Profile inserts upon request.



### 刀杆 型号

# H117

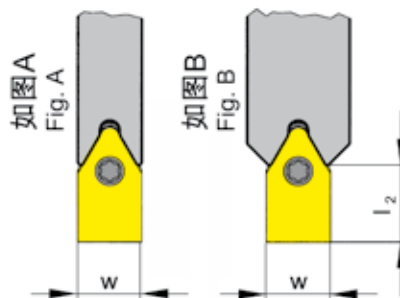
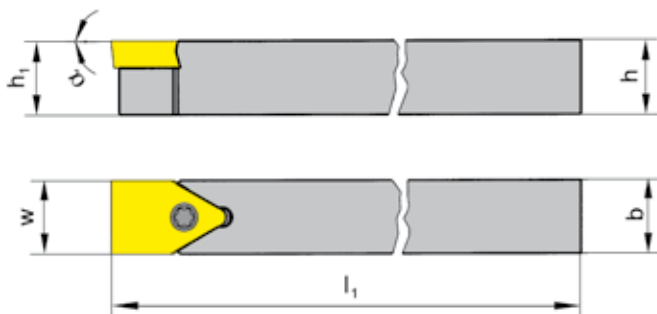
TOOLHOLDER type



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

6.5 mm  
10.0 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.1010.02.10	0°	A	10	10	10	100	-		
H117.1212.02.10	0°	B	12	12	12	125	12	10	S117.0010.02.00
H117.1616.02.10	0°	B	16	16	16	125	12		

### 备件

Spare parts

尺寸单位: mm  
Dimensions in mm

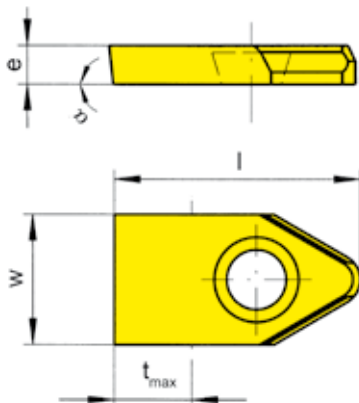
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...02.10	<b>4.09T15P</b>	<b>T15PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

### 刀片 型号

INSERT type

# S117.0010.02.00



半精加工刀片:  
仅磨削接触区域和主切削刃  
Semi finished insert:  
Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0010.02.00	0°	10	3	19	6.5	H117...02.10

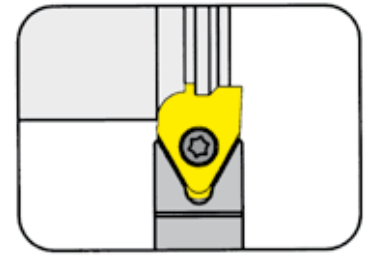
# 仿形加工 (外圆) PROFILING (external)



## 刀杆 型号

# H117

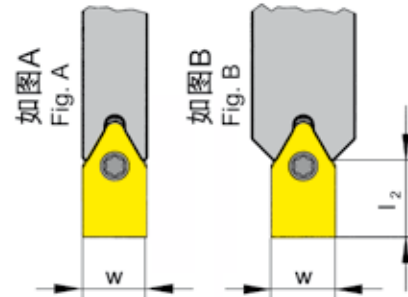
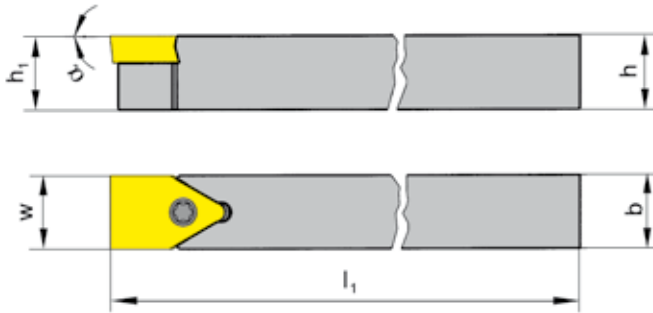
TOOLHOLDER type



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

7.5 mm  
12.0 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.1212.02.12	0°	A	12	12	12	125	-		S117.0012.02.00
H117.1616.02.12	0°	B	16	16	16	125	11	12	
H117.2020.02.12	0°	B	20	20	20	150	11		

尺寸单位 : mm  
Dimensions in mm

## 备件

Spare parts

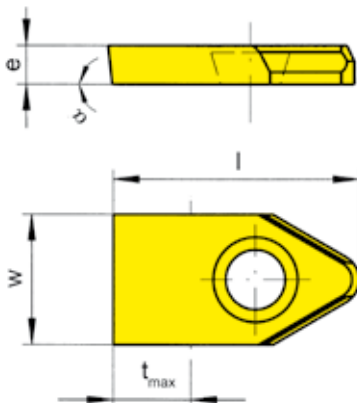
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...02.12	<b>4.09T15P</b>	<b>T15PQ</b>

对于螺钉的锁定扭矩，请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

# S117.0012.02.00

INSERT type



半精加工刀片：  
仅磨削接触区域和主切削刃  
Semi finished insert:  
Only contact areas and main cutting edge ground.

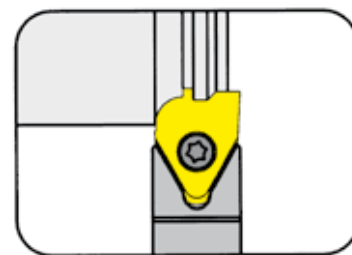
尺寸单位 : mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0012.02.00	0°	12	4.5	20	7.5	H117...02.12

### 刀杆 型号

# H117

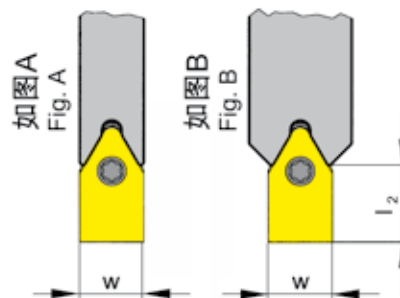
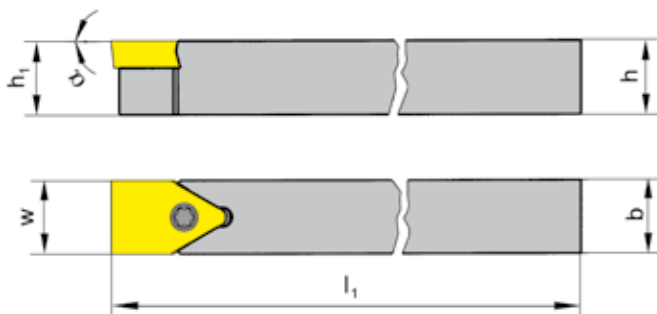
TOOLHOLDER type



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

9 mm  
16 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.1616.02.16	0°	A	16	16	16	125	-	16	S117.0016.02.00
H117.2020.02.16	0°	B	20	20	20	150	14	16	

尺寸单位: mm  
Dimensions in mm

### 备件

Spare parts

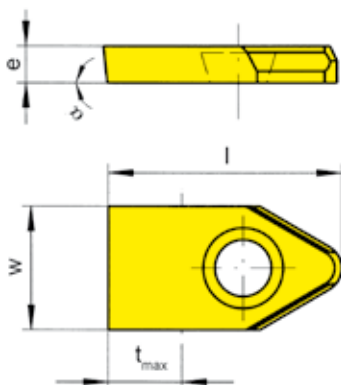
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...02.16	<b>5.12T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

### 刀片 型号

# S117.0016.02.00

INSERT type



半精加工刀片:  
仅磨削接触区域和主切削刃  
Semi finished insert:  
Only contact areas and main cutting edge ground.

尺寸单位: mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0016.02.00	0°	16	6	24	9	H117...02.16

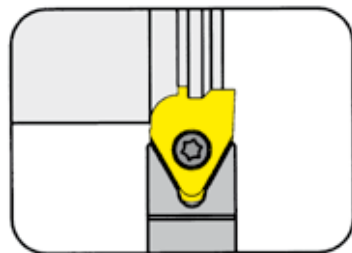
# 仿形加工 (外圆) PROFILING (external)



## 刀杆 型号

TOOLHOLDER type

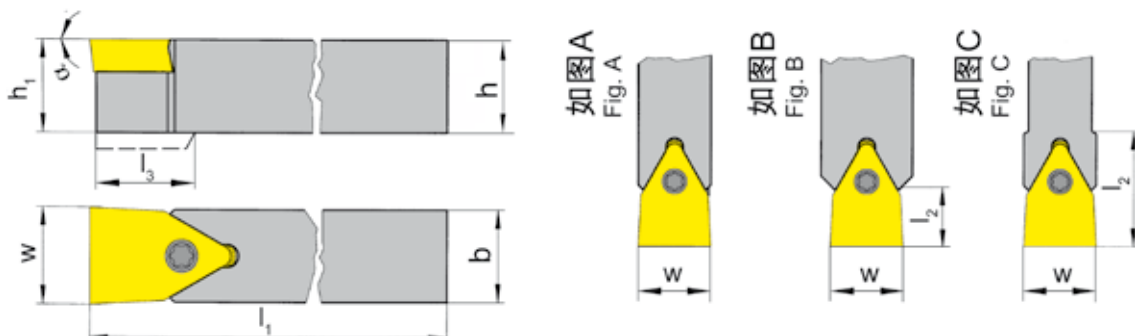
# H117



轮廓深度 可达  
轮廓宽度 可达

Depth of profile up to  
Width of profile

12 mm  
20 mm



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	$l_3$	w	半精加工刀片 Semi finished insert
H117.1616.02.20	0°	C	16	16	16	125	33	26		
H117.2020.02.20	0°	A	20	20	20	150	-	-	20	S117.0020.02.00
H117.2525.02.20	0°	B	25	25	25	150	19	-		

尺寸单位 : mm  
Dimensions in mm

## 备件

Spare parts

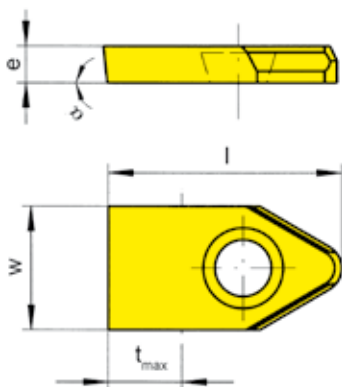
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...02.20	<b>6.17T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩, 请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

INSERT type

# S117.0020.02.00



半精加工刀片:  
仅磨削接触区域和主切削刃  
Semi finished insert:  
Only contact areas and main cutting edge ground.

尺寸单位 : mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0020.02.00	0°	20	7	32	12	H117...02.20

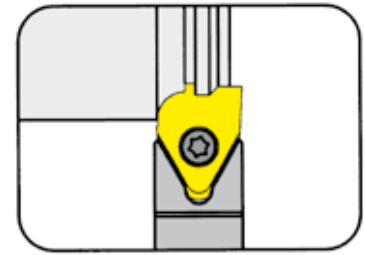
# 仿形加工 (外圆) PROFILING (external)



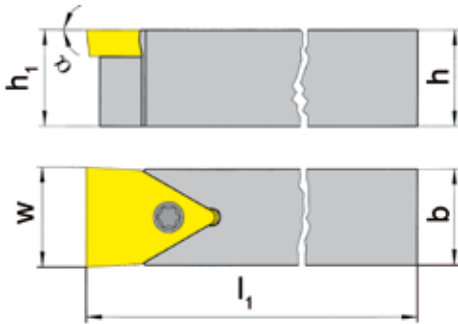
## 刀杆 型号

TOOLHOLDER type

# H117



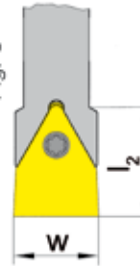
轮廓深度 可达      Depth of profile up to      13 mm  
轮廓宽度 可达      Width of profile      26 mm



如图A  
Fig. A



如图C  
Fig. C



产品型号 Part number	$\alpha$	如图 Figure	h	$h_1$	b	$l_1$	$l_2$	w	半精加工刀片 Semi finished insert
H117.2020.02.26	0°	C	20	20	20	150	33	26	S117.0026.02.00
H117.2525.02.26	0°	A	25	25	25	150	-	26	

尺寸单位：mm  
Dimensions in mm

## 备件

Spare parts

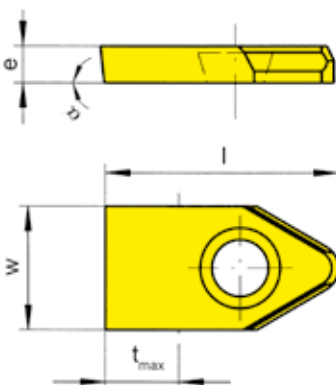
刀杆 Toolholder	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...02.26	<b>6.17T20P</b>	<b>T20PQ</b>

对于螺钉的锁定扭矩，请参阅技术说明  
For the locking torque of the screws please see the Technical Instructions.

## 刀片 型号

INSERT type

# S117.0026.02.00



### 半精加工刀片：

仅磨削接触区域和主切削刃

### Semi finished insert:

Only contact areas and main cutting edge ground.

尺寸单位：mm  
Dimensions in mm

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder
S117.0026.02.00	0°	26	7	35	13	H117...02.26



# 仿形加工 ( 外圆 )

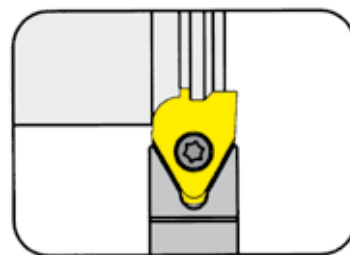
## PROFILING (external)



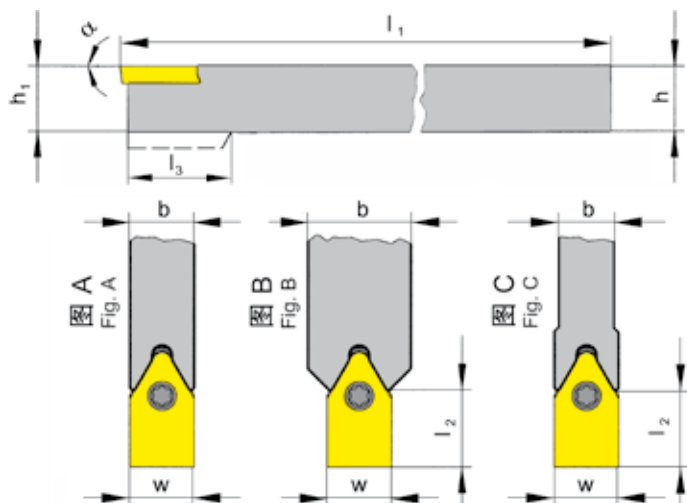
### 刀杆 型号

# H117

TOOLHOLDER Type



轮廓深度                      Depth of form up to                      13.0 mm  
 轮廓宽度可达                      Width of form up to                      26.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

**概述**  
**OVERVIEW**

产品型号 Part number	$\alpha$	图型 Figure	h	$h_1$	b	$l_1$	$l_2$	$l_3$	w	刀片 Insert
H117.1010.02.10		A	10	10	10	100	-	-		
H117.1212.02.10	0°	B	12	12	12	125	12	-	10	S117.0010.02.00
H117.1616.02.10		B	16	16	16	125	12			
H117.1212.02.12		A	12	12	12	125	-	-		
H117.1616.02.12	0°	B	16	16	16	125	11	-	12	S117.0012.02.00
H117.2020.02.12		B	20	20	20	150	11			
H117.1616.02.16		A	16	16	16	125	-	-		
H117.2020.02.16	0°	B	20	20	20	150	14	-	16	S117.0016.02.00
H117.1616.02.20		C	16	16	16	125	33	26		
H117.2020.02.20	0°	A	20	20	20	150	-	-	20	S117.0020.02.00
H117.2525.02.20		B	25	25	25	150	19	-		
H117.2020.02.26		C	20	20	20	150	33	-		
H117.2525.02.26	0°	A	25	25	25	150	-	-	26	S117.0026.02.00

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117....10/12	4.09T15P	T15PQ
H117....16	5.12T20P	T20PQ
H117....20/26	6.17T20P	T20PQ

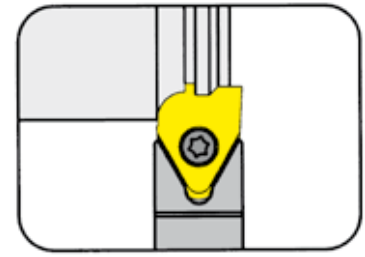
# 仿形加工 ( 外圆 )

## PROFILING (external)



刀片 型号  
INSERT Type

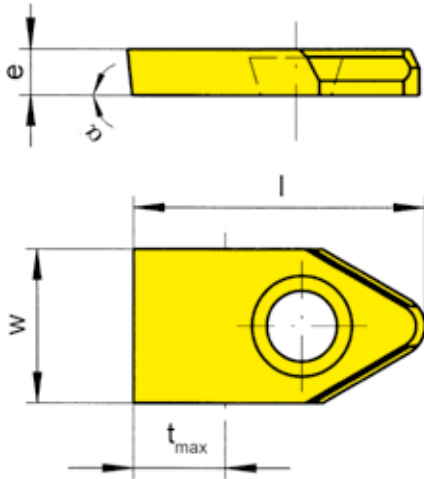
# S117



轮廓深度	Depth of form up to	13.0 mm
轮廓宽度可达	Width of form up to	26.0 mm

配合 刀杆  
for use with Toolholder

型号 H117  
Type



### 概述 OVERVIEW

产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder	MG12
S117.0010.02.00	0°	10	3.0	19	6.5	H117...02.10	▲
S117.0012.02.00	0°	12	4.5	20	7.5	H117...02.12	▲
S117.0016.02.00	0°	16	6.0	24	9.0	H117...02.16	▲
S117.0020.02.00	0°	20	7.0	32	12.0	H117...02.20	▲
S117.0026.02.00	0°	26	7.0	35	13.0	H117...02.26	▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	○
M	●
K	●
N	●
S	●
H	●

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm



根据客户要求生产的各种仿形刀片  
Profile inserts upon request.



# 仿形加工 ( 外圆 )

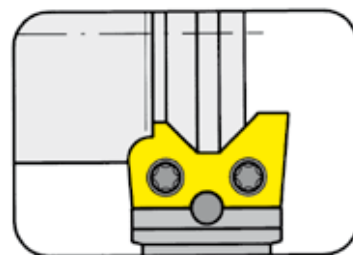
## PROFILING (external)



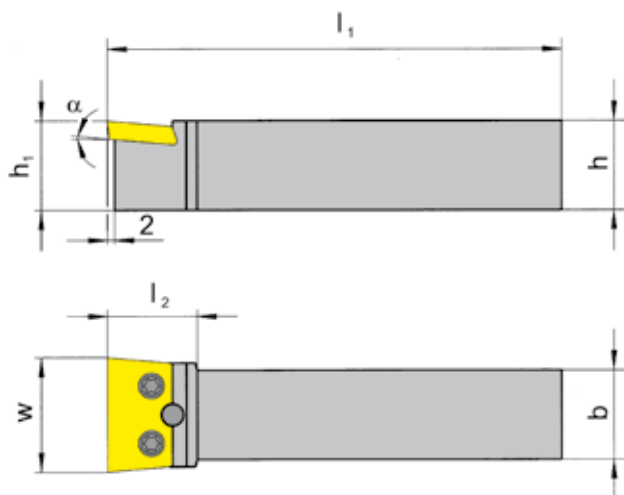
### 刀杆 型号

# H117

TOOLHOLDER Type



轮廓深度	Depth of form up to	6.5 mm
轮廓宽度可达	Width of form up to	45.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

概述  
OVERVIEW

产品型号 Part number	$\alpha$	h	$h_1$	b	$l_1$	$l_2$	w	刀片 Insert
H117-2020-32	5°	20	20	20	150	25	32	S117.0032.00
H117-2525-32		25	25	25				
H117-2525-45	5°	25	25	25	150	27	45	S117.0045.00
H117-3232-45		32	32	32				

按需提供更多角度  
Further angles upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件 Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117....	5.12T20P	T20PQ



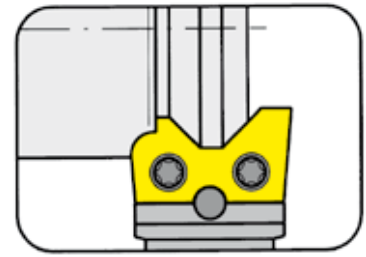
# 仿形加工 ( 外圆 )

## PROFILING (external)



刀片 型号  
INSERT Type

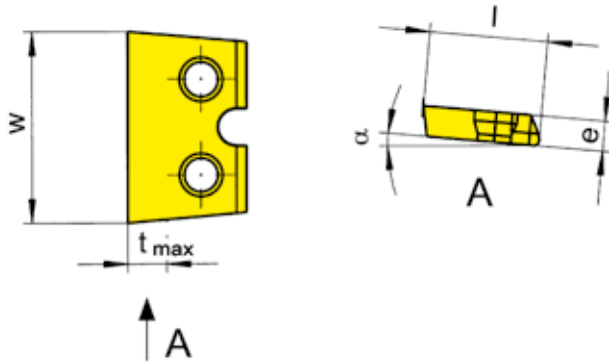
# S117



轮廓深度	Depth of form up to	6.5 mm
轮廓宽度可达	Width of form up to	45.0 mm

配合 刀杆  
for use with Toolholder

型号 H117  
Type



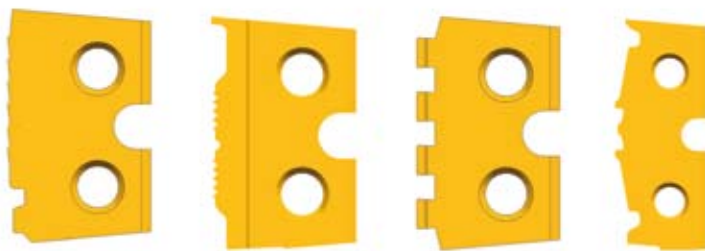
产品型号 Part number	$\alpha$	w	e	l	$t_{max}$	刀杆 Toolholder	MG12
<b>S117.0032.00</b>	5°	32	5	19.7	6.5	H117...32	▲
<b>S117.0045.00</b>	5°	45	5	19.7	6.5	H117...45	▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P	○
M	●
K	●
N	●
S	●
H	●

按需提供更多尺寸  
Further sizes upon request

尺寸单位 : mm  
Dimensions in mm



根据客户要求生产的各种仿形刀片  
Profile inserts upon request.



# 仿形加工 ( 外圆 )

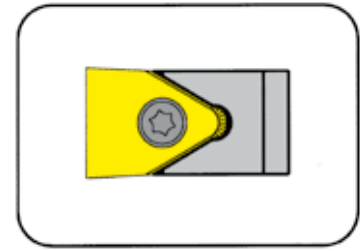
## PROFILING (external)



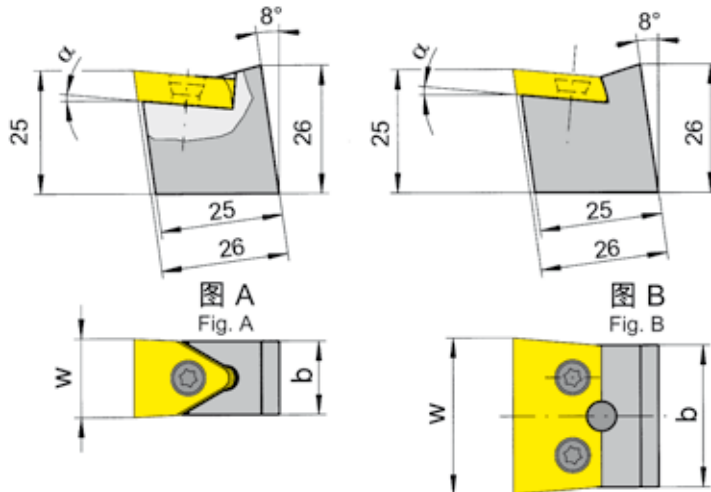
### 刀杆 型号

TOOLHOLDER Type

# H117



轮廓深度	Depth of form up to	6.5 mm
轮廓宽度可达	Width of form up to	45.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

适用于PWP-系统  
with PWP-System

产品型号 Part number	$\alpha$	图型 Figure	b	w	刀片 Insert
H117.PWP.10	5°	A	10	10	S117.0010.00
H117.PWP.12	5°	A	12	12	S117.0012.00
H117.PWP.16	5°	A	16	16	S117.0014/16.00
H117.PWP.32	5°	B	28	32	S117.0032.00
H117.PWP.45	5°	B	42	45	S117.0045.00

按需提供更多角度  
Further angles upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117.PWP.10/12	4.09T15P	T15PQ
H117.PWP.16/32/45	5.12T20P	T20PQ

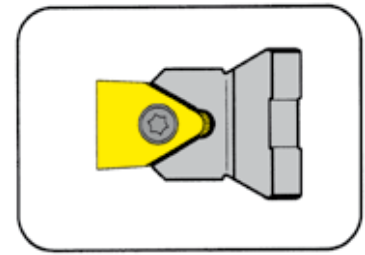
# 仿形加工 ( 外圆 )

## PROFILING (external)

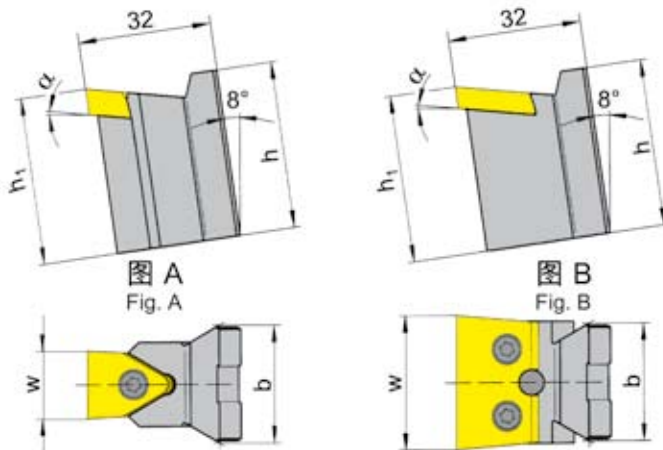


刀杆 型号  
TOOLHOLDER Type

# H117



轮廓深度                      Depth of form up to                      10.0 mm  
轮廓宽度可达                  Width of form up to                      45.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

适用于AWN-系统  
with AWN-System

产品型号 Part number	$\alpha$	图型 Figure	h	$h_1$	b	w	$t_{max}$	刀片 Insert
H117.AW20.10 H117.AW28.10	5°	A	36	40	20 28	10	3.5	S117.0010.00
H117.AW20.12 H117.AW28.12	5°	A	36	40	20 28	12	4.5	S117.0012.00
H117.AW20.16 H117.AW28.16	5°	A	36	40	20 28	16	6.5	S117.0014/16.00
H117.AW28.20	5°	A	36	40	28	20	9.0	S117.0018/20.00
H117.AW28.26	5°	A	36	40	28	26	10.0	S117.0026.00
H117.AW28.32	5°	B	36	40	28	32	6.5	S117.0032.00
H117.AW40.45	5°	B	50	50	40	45	6.5	S117.0045.00

按需提供更多角度  
Further angles upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117.AW2...10/12	4.09T15P	T15PQ
H117.AW...16/32/45	5.12T20P	T20PQ
H117.AW28.20/26	6.17T20P	T20PQ



# HCG - HORN Catalogue Guide

## 切断 / PARTING OFF

槽深 Depth of groove	产品线 / Product line								
	S274	264	312/S312	S316	S223	S224	S123	229/S229	S100
可达 / up to	6	16	8	8	11	18	25	25	
自 / from									25

槽宽 Width of groove									
0.5 - 1.44	•		•						
1.5	•	•	•						
2	•	•	•	•	•	•	•		•
2.2			•						•
2.5		•	•	•	•	•			•
3		•	•	•	•	•	•	•	•
4								•	•
5								•	•
6								•	•
8									•
10									•
12									•

章 / Chapter	P
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切断

PARTING OFF

P

刀片 型号 Insert type	S274	264	312 S312	S316	S123	S223	S224	229 S229	S100
槽深 / Depth of groove									
可达 / up to	6 mm	16 mm	8 mm	8 mm	25 mm	11 mm	18 mm	25 mm	
自 / from									25 mm

槽宽 / Width of groove									
0.5 - 1.44 mm	•		•						
1.5 mm	•	•	•						
2.0 mm	•	•	•	•	•	•	•		•
2.2 mm			•						•
2.5 mm		•	•	•		•	•		•
3.0 mm		•	•	•	•	•	•	•	•
4.0 mm								•	•
5.0 mm								•	•
6.0 mm								•	•
8.0 mm									•
10.0 mm									•
12.0 mm									•
页 / Page	P3-P8 P10-P15	P20-P21	P26-P33	P35	P39-P40	P41-P43	P53-P57	P63-P67	P97- P101

刀杆 型号 Toolholder type	H274	H264	360 368 391	H316	H223	H223	H224	218 226	H100 NK100 220
 DIN-刀杆 DIN-Shank	•	•	•	•	•	•	•	•	•
 增强型刀板 Reinforced blade					•	•	•	•	•
 刀板 Blade							•	•	•
页 / Page	P2 P9	P16-P19	P22-P25	P34	P37-P38	P37-P38	P45-P52	P39-P62	P69-P96

技术说明见章节Q

For Technical Instructions please see chapter Q

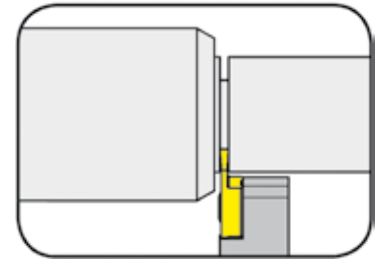
# 切断

## PARTING OFF



刀杆 型号  
TOOLHOLDER Type

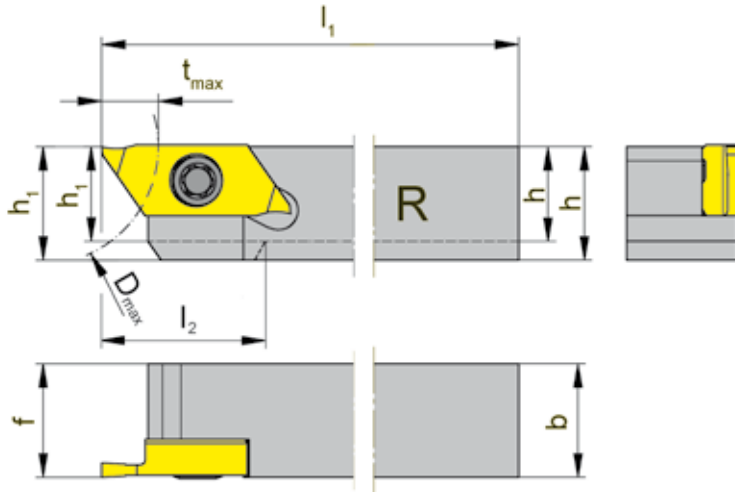
# H274



槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.0808.04	8	8	100	16	8	8			
R/LH274.1010.04	10	10	100	-	10	10			
R/LH274.1212.04	12	12	100	-	12	12			
R/LH274.1414.04	14	14	100	-	14	14	6	25	04
R/LH274.1616.04	16	16	125	-	16	16			
R/LH274.2020.04	20	20	125	-	20	20			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

# 切断

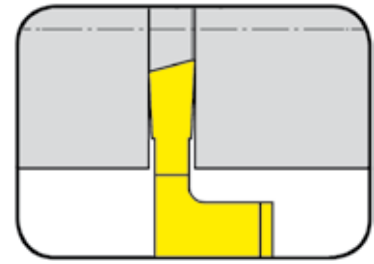
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274



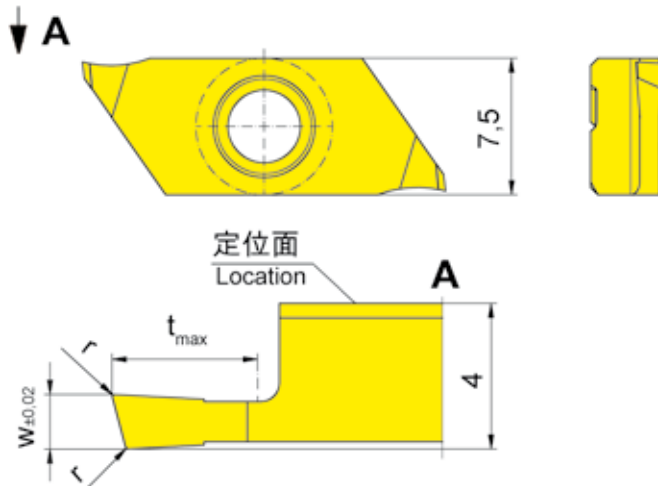
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

precision ground

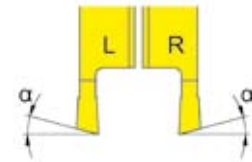


配合 刀杆

for use with Toolholder

型号 H274

Type



刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.10	0.8			3				▲/△
R/LS274.1510.03.10	1.0			3				▲/▲
R/LS274.1515.04.10	1.5	0.05	15°	4	04			▲/▲
R/LS274.1520.06.10	2.0			6				▲/▲

▲ 库存 / on stock    △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号

Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$ 6mm。

Note:

$t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

# 切断

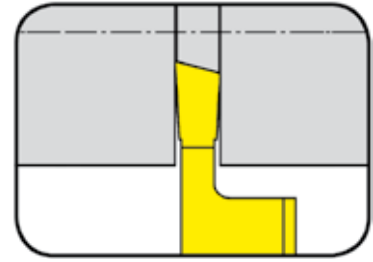
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274



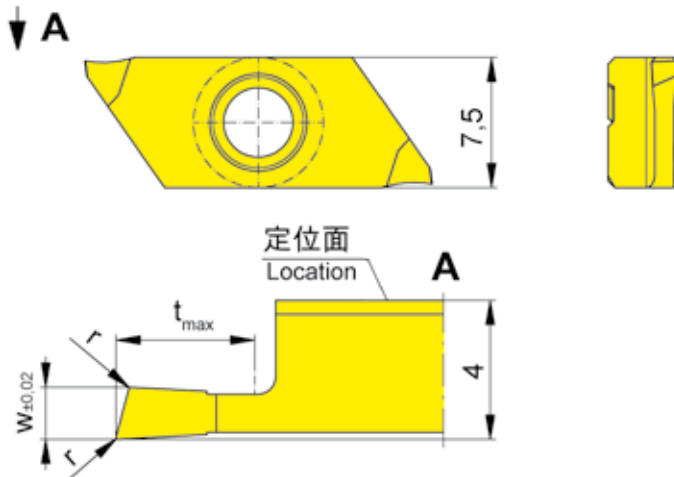
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

precision ground

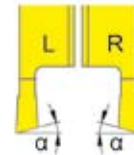


配合 刀杆

for use with Toolholder

型号 H274

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	r	α	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1508.03.10R	0.8			3				Δ
LS274.1510.03.10R	1.0			3				Δ
LS274.1515.04.10R	1.5	0.05	15°	4	04			▲
LS274.1520.06.10R	2.0			6				▲
RS274.1508.03.10L	0.8			3				Δ
RS274.1510.03.10L	1.0			3				Δ
RS274.1515.04.10L	1.5	0.05	15°	4	04			Δ
RS274.1520.06.10L	2.0			6				Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}}$  6mm。

Note:

$t_{\text{max}}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号

Carbide grades



# 切断

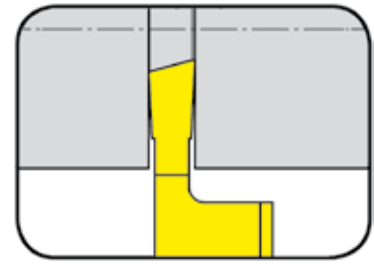
## PARTING OFF



### 可转位刀片 型号

# S274

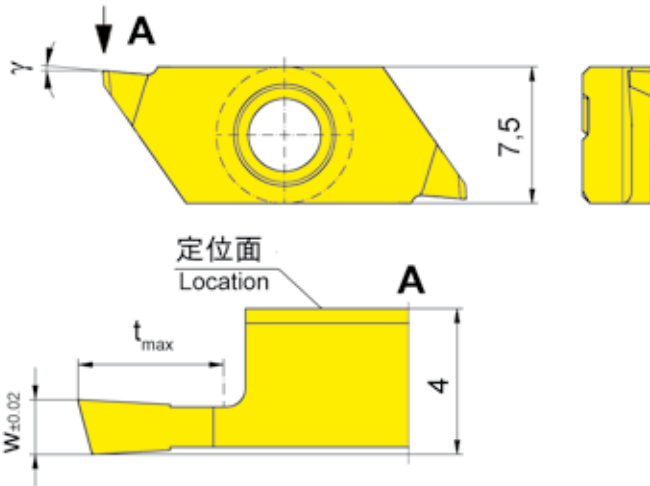
INDEXABLE INSERT Type



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

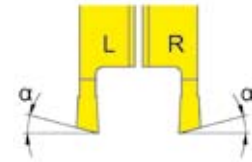
精密磨削

precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type



刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1515.04.20	1.5	15°	5°	4	04	P	M	▲/▲
R/LS274.1520.06.20	2.0			6				▲/▲
▲ 库存 / on stock   Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet						K		●
						N		●
						S		●
						H		

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}}$  6mm。

Note:

$t_{\text{max}}$  6 mm can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

硬质合金牌号  
Carbide grades

# 切断

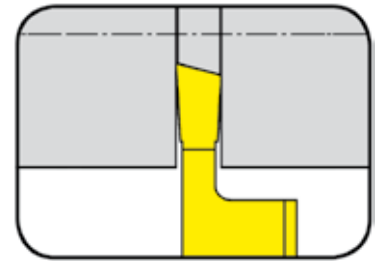
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

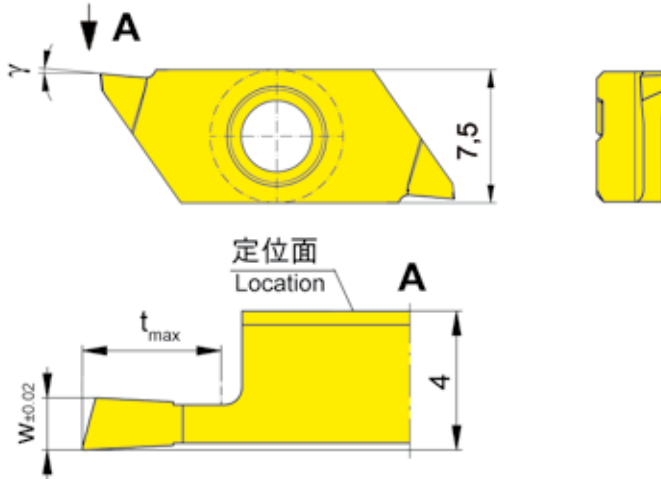
# S274



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削

precision ground

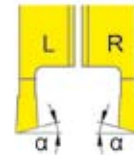


配合 刀杆

for use with Toolholder

型号 H274

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1515.04.20R	1.5	15°	5°	4	04			▲
LS274.1520.06.20R	2.0	15°	5°	6	04			▲
RS274.1515.04.20L	1.5	15°	5°	4	04			▲
RS274.1520.06.20L	2.0	15°	5°	6	04			▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:

$t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号

Carbide grades

# 切断

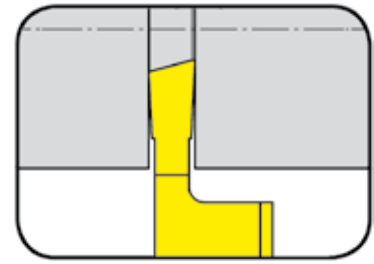
## PARTING OFF



### 可转位刀片 型号

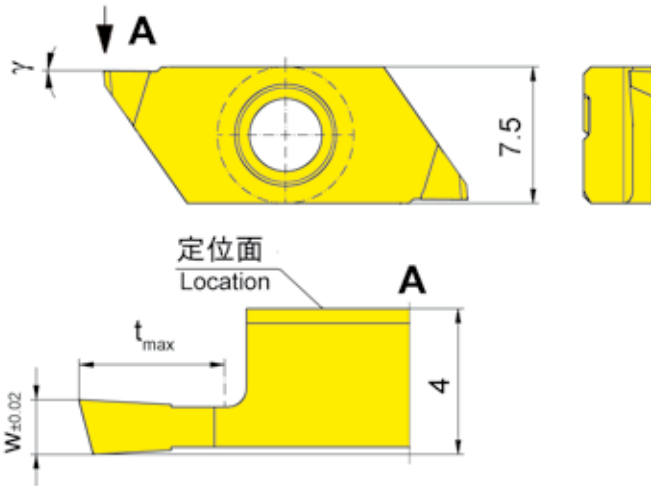
# S274

### INDEXABLE INSERT Type



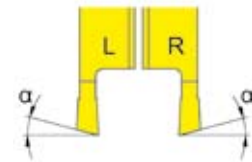
槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削  
precision ground



配合 刀杆  
for use with Toolholder

型号 H274  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

刀片长度重复定位精度  
±0.015 mm  
Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	硬质合金牌号		
						TN35	TI25	TH35
R/LS274.1508.03.M0	0.8	15°	0°	3	04			▲/▲
R/LS274.1510.03.M0	1.0						▲/▲	
R/LS274.1515.04.M0	1.5						▲/▲	
R/LS274.1520.06.M0	2.0						▲/▲	

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

注意事项 :  
只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:  
 $t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

	TN35	TI25	TH35
P			●
M			●
K			●
N			●
S			●
H			

硬质合金牌号  
Carbide grades

# 切断

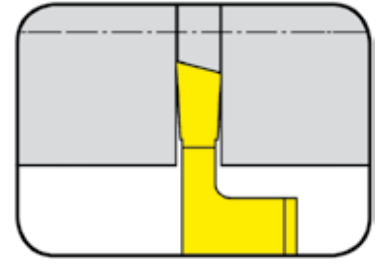
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

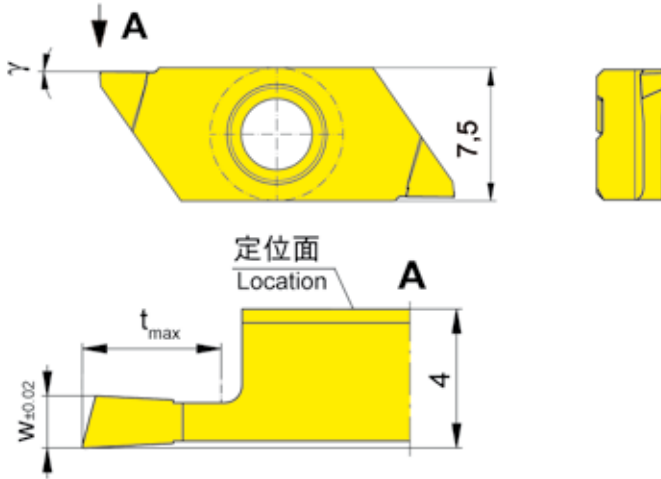
# S274



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	0.8 - 2.0 mm

精密磨削

precision ground

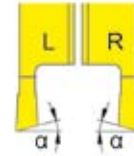


配合 刀杆

for use with Toolholder

型号 H274

Type



刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	硬质合金牌号		
						TN35	TI25	TH35
LS274.1508.03.M0R	0.8	15°	0°	3	04			▲
LS274.1510.03.M0R	1.0						▲	
LS274.1515.04.M0R	1.5						▲	
LS274.1520.06.M0R	2.0						▲	
RS274.1508.03.M0L	0.8	15°	0°	3	04			▲
RS274.1510.03.M0L	1.0						▲	
RS274.1515.04.M0L	1.5						▲	
RS274.1520.06.M0L	2.0						▲	

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:

$t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

	TN35	TI25	TH35
P	●		●
M	●		●
K	●		●
N	●		●
S	●		●
H			

硬质合金牌号

Carbide grades

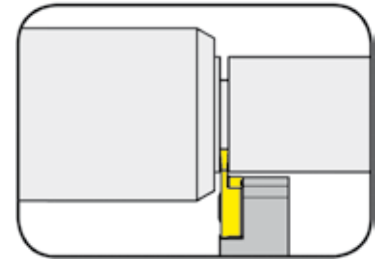
# 切断

## PARTING OFF



刀杆 型号  
TOOLHOLDER Type

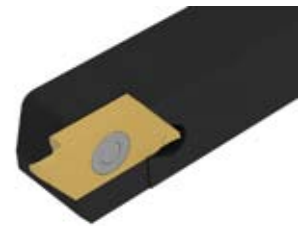
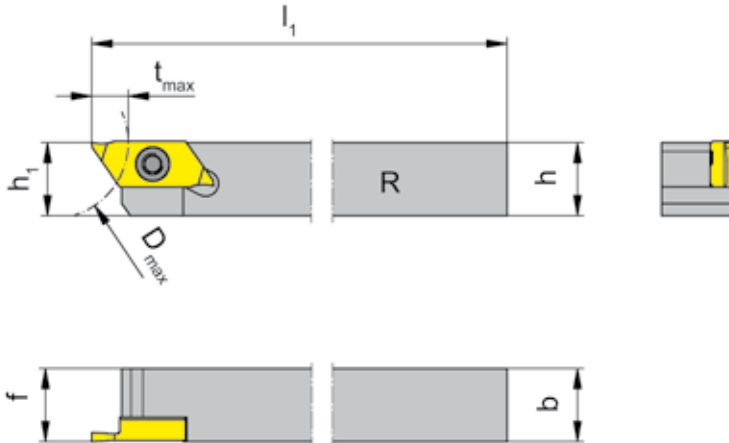
# H274...E



槽深	Depth of groove	6.0 mm
槽宽	Width of groove	0.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S274...E  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH274.1010.04.E	10	10	100	10	10	6	25	04
R/LH274.1212.04.E	12	12	100	12	12			
R/LH274.1616.04.E	16	16	125	16	16			
R/LH274.2020.04.E	20	20	125	20	20			

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

# 切断

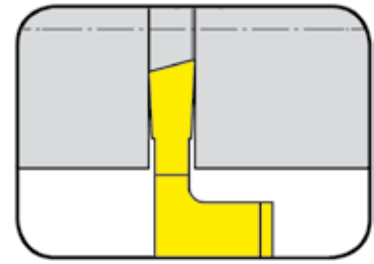
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

## S274...E



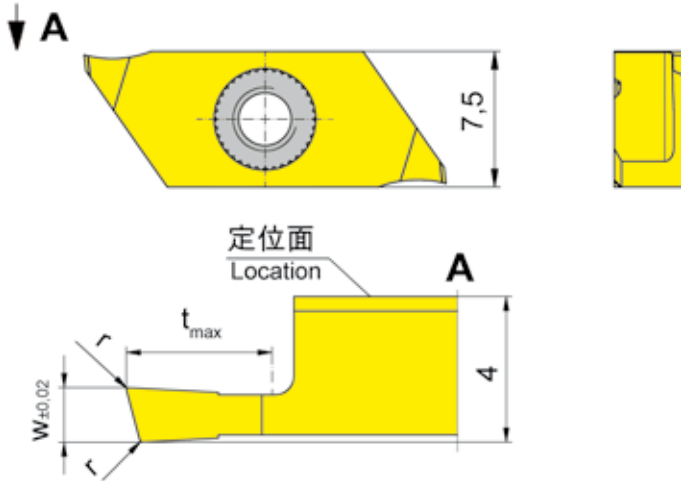
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

precision ground

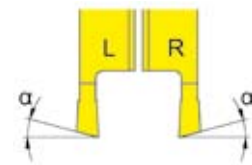


配合 刀杆

for use with Toolholder

型号 H274...E

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	r	α	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.10.E	0.8			3	04			Δ/Δ
R/LS274.1510.03.10.E	1.0	0.05	15°	3				Δ/Δ
R/LS274.1515.04.10.E	1.5			4				Δ/Δ
R/LS274.1520.06.10.E	2.0			6				Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号

Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$ 6mm。

Note:

$t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

# 切断

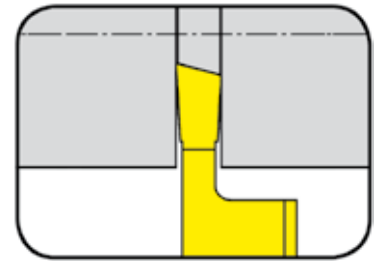
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

## S274...E



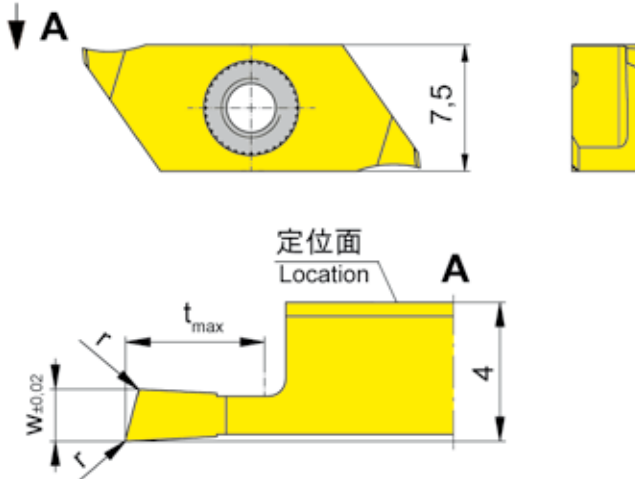
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

precision ground

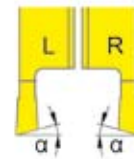


配合 刀杆

for use with Toolholder

型号 H274...E

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	W	r	α	t <sub>max</sub>	规格 Size	硬质合金牌号		
						TN35	TI25	TH35
LS274.1508.03.1R.E	0.8			3				Δ
LS274.1510.03.1R.E	1.0			3				Δ
LS274.1515.04.1R.E	1.5	0.05	15°	4	04			Δ
LS274.1520.06.1R.E	2.0			6				Δ
RS274.1508.03.1L.E	0.8			3				Δ
RS274.1510.03.1L.E	1.0			3				Δ
RS274.1515.04.1L.E	1.5	0.05	15°	4	04			Δ
RS274.1520.06.1L.E	2.0			6				Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}}$  6mm。

Note:

$t_{\text{max}}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号

Carbide grades

# 切断

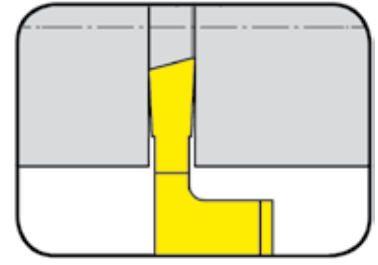
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

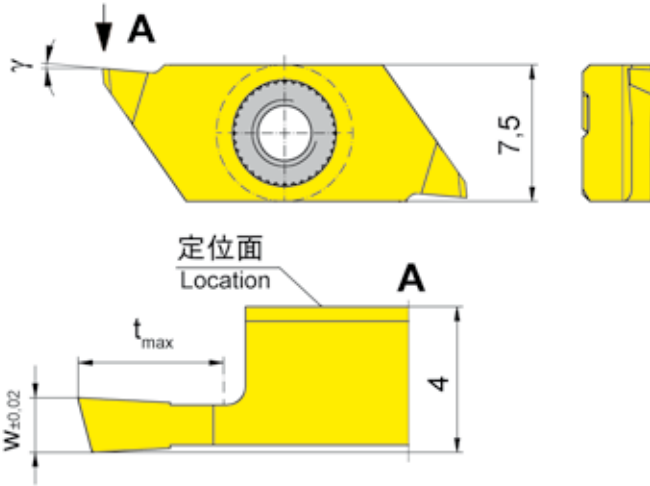
# S274...E



槽深可达	Depth of groove up to	6.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

精密磨削

precision ground



R=右手型-如图

R = right hand version shown

L=左手型

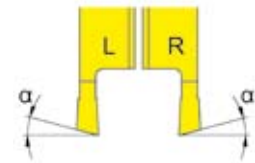
L = left hand version

配合 刀杆

for use with Toolholder

型号 H274...E

Type



刀片长度重复定位精度  
±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1515.04.20.E	1.5	15°	5°	4	04	P	M	K
R/LS274.1520.06.20.E	2.0			6				

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$  6mm。

Note:

$t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

硬质合金牌号  
Carbide grades



# 切断

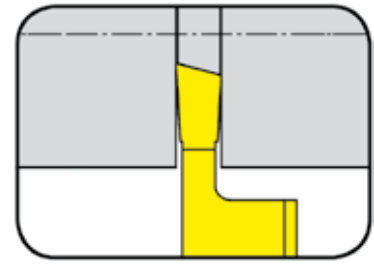
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

## S274...E



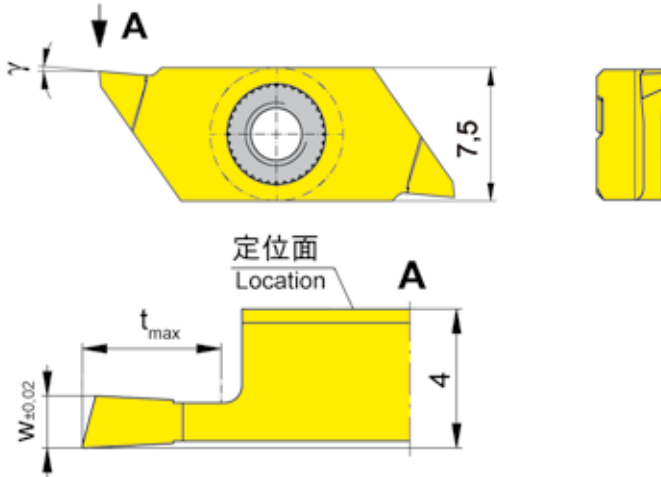
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
1.5 - 2.0 mm

精密磨削

precision ground

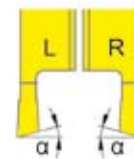


配合 刀杆

for use with Toolholder

型号 H274...E

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1515.04.2R.E	1.5	15°	5°	4	04			Δ
LS274.1520.06.2R.E	2.0	15°	5°	6	04			Δ
RS274.1515.04.2L.E	1.5	15°	5°	4	04			Δ
RS274.1520.06.2L.E	2.0	15°	5°	6	04			Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}}$  6mm。

Note:

$t_{\text{max}}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

P		●
M		●
K		●
N		●
S		●
H		

硬质合金牌号

Carbide grades

# 切断

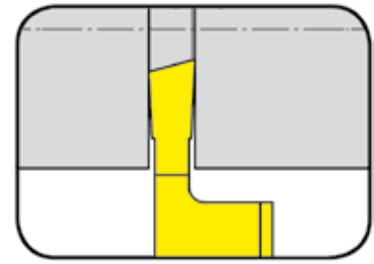
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S274...E



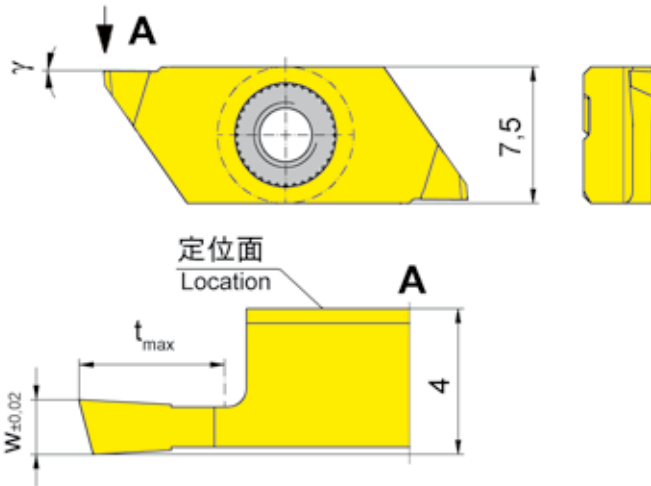
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

precision ground

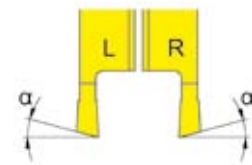


配合 刀杆

for use with Toolholder

型号 H274...E

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
R/LS274.1508.03.M0.E	0.8	15°	0°	3	04			Δ/Δ
R/LS274.1510.03.M0.E	1.0			3		Δ/Δ		
R/LS274.1515.04.M0.E	1.5			4		Δ/Δ		
R/LS274.1520.06.M0.E	2.0			6		Δ/Δ		

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25$ mm时才能达到最大切深 $t_{max}$ 6mm。

Note:

$t_{max}$  6 mm can be reached only with workpiece  $\varnothing \leq 25$  mm.

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号

Carbide grades

# 切断

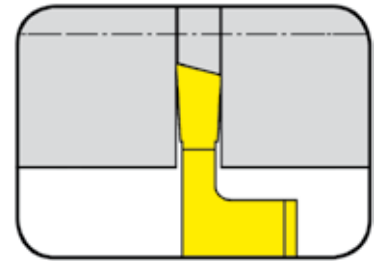
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

## S274...E



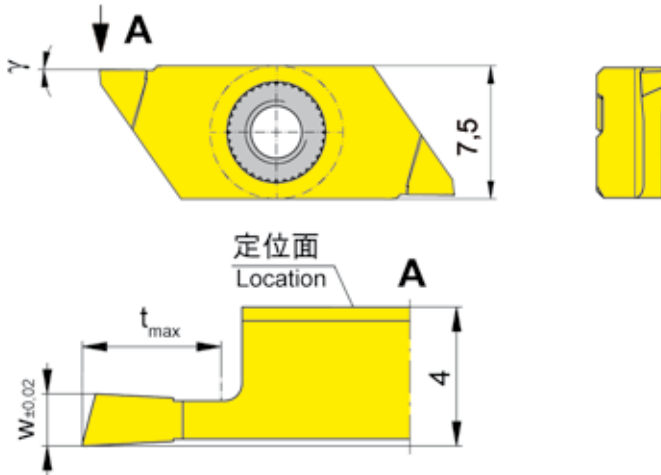
槽深可达  
槽宽

Depth of groove up to  
Width of groove

6.0 mm  
0.8 - 2.0 mm

精密磨削

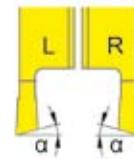
precision ground



配合 刀杆

for use with Toolholder

型号 H274...E  
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

产品型号 Part number	w	α	γ	t <sub>max</sub>	规格 Size	TN35	TI25	TH35
LS274.1508.03.MR.E	0.8	15°	0°	3	04			Δ
LS274.1510.03.MR.E	1.0			3				Δ
LS274.1515.04.MR.E	1.5			4				Δ
LS274.1520.06.MR.E	2.0			6				Δ
RS274.1508.03.ML.E	0.8	15°	0°	3	04			Δ
RS274.1510.03.ML.E	1.0			3				Δ
RS274.1515.04.ML.E	1.5			4				Δ
RS274.1520.06.ML.E	2.0			6				Δ

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 $t_{\text{max}} 6\text{mm}$ 。

Note:

$t_{\text{max}} 6\text{ mm}$  can be reached only with workpiece  $\varnothing \leq 25\text{ mm}$ .

P		•
M		•
K		•
N		•
S		•
H		

硬质合金牌号

Carbide grades

## 切槽和镗孔

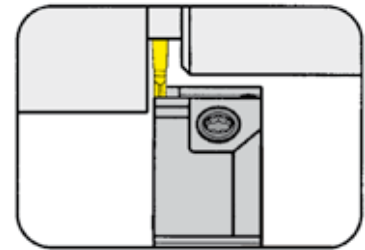
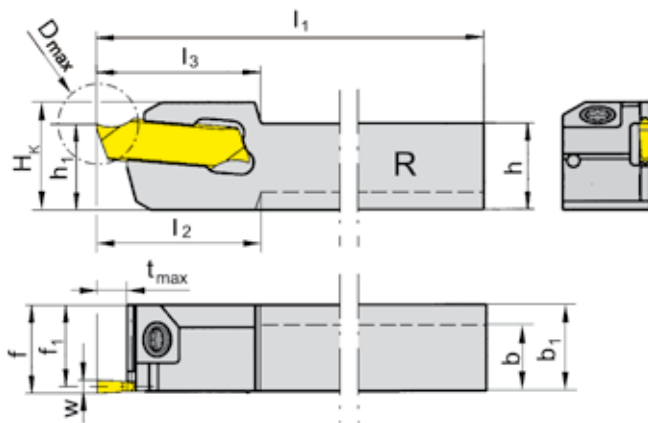
## GROOVING and BORING



## 刀杆 型号

TOOLHOLDER Type

## H264

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to 16.0 mm  
Width of groove 1.5 - 2.0 mm配合 可转位刀片  
for use with Indexable insert型号 264  
Type S264

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	b <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.0808.01	8	8		17.5		8	10	9.25	10			22	12.5	01
R/LH264.1010.01	10	10	120	-	17.5	10	-	9.25	10	4	1.5	22	12.5	
R/LH264.1212.01	12	12		-		12	-	11.25	12			22	14.5	
R/LH264.1616.01	16	16		-		16	-	15.25	16			32	18.5	
R/LH264.1010.11	10	10				10		9.25	10			20	12.5	01
R/LH264.1212.11	12	12	120	-	19.0	12	-	11.25	12	10	1.5	20	14.5	
R/LH264.1616.11	16	16				16		15.25	16			32	18.5	
R/LH264.1212.21	12	12	120	-	22.0	12	-	11.25	12	13	1.5	26	15.5	01
R/LH264.1616.21	16	16				16		15.25	16			32	19.5	
R/LH264.1010.02	10	10				10		9.00	10				12.5	02
R/LH264.1212.02	12	12	120	-	17.5	12	-	11.00	12	4	2.0	32	14.5	
R/LH264.1616.02	16	16				16		15.00	16				18.5	
R/LH264.1010.12	10	10				10		9.00	10				12.5	02
R/LH264.1212.12	12	12	120	-	19.0	12	-	11.00	12	10	2.0	32	14.5	
R/LH264.1616.12	16	16				16		15.00	16				18.5	
R/LH264.1212.22	12	12	120	-	25.0	12	-	11.00	12	16	2.0	32	14.5	02
R/LH264.1616.22	16	16				16		15.00	16				19.5	

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

尺寸单位: mm

Dimensions in mm

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264....	3.5-12T10EP	T10PL

# 切槽和切断

## GROOVING and PARTING OFF

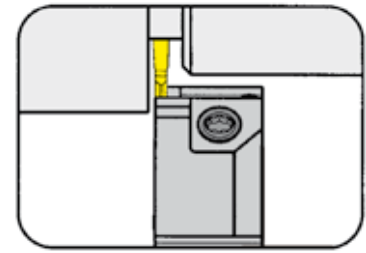


### 刀杆 型号

TOOLHOLDER Type

## H264

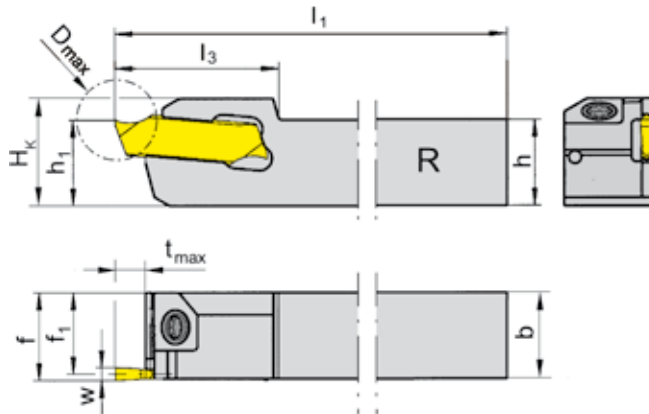
螺钉锁紧  
with screwed clamping



槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
2.5 mm



配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	w	$D_{max}$	$H_k$	规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	2.5	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	2.5	32	18.5	
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	2.5	32	18.5	
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	2.5	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	2.5	32	18.5	

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL

## 切槽和切断

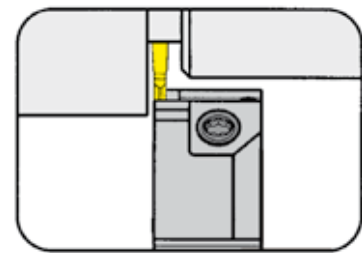
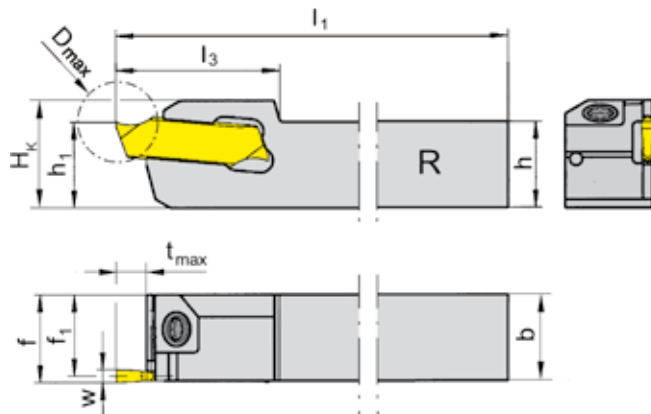
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H264

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove16.0 mm  
3.0 mm配合 可转位刀片  
for use with Indexable insert型号 264  
Type S264

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	3	32	15	04
R/LH264.1616.04	16	16			16	14.5	16					
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	3	32	15	04
R/LH264.1616.14	16	16			16	14.5	16					
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	3	32	15	04
R/LH264.1616.24	16	16			16	14.5	16					

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH264.1...	3.5-12T10EP	T10PL

# 切槽和切断

## GROOVING and PARTING OFF

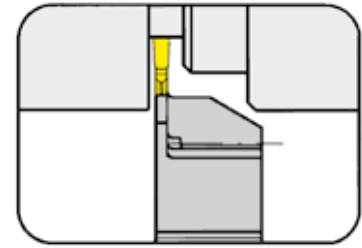


### 刀杆 型号

TOOLHOLDER Type

## H264

自锁紧  
with self clamping

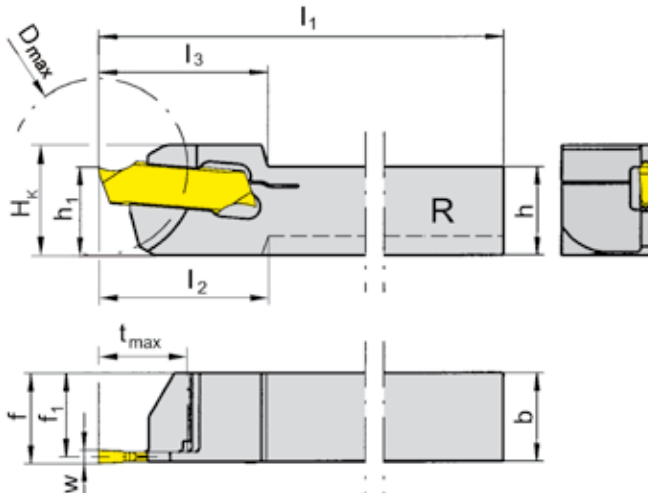


槽深可达  
槽宽

Depth of groove up to 10.0 mm  
Width of groove 1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 264  
Type S264



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version



产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	H <sub>K</sub>	规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	1.5	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	1.5	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	2.0	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	2.0	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	2.5	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	3.0	32	14.5	04

注明R或L型

State R or L version

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

Wrench P39L ist not combined with blade - separate order required!

### 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
R/LH264....	P39L

# 切断

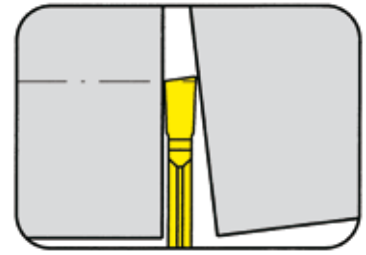
## PARTING OFF



### 可转位刀片 型号

# 264

### INDEXABLE INSERT Type



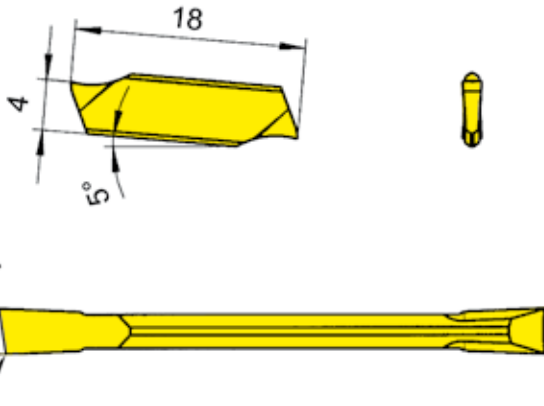
槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
1.5 - 3.0 mm

精密磨削

precision ground

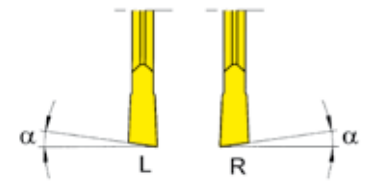


配合 刀杆

for use with Toolholder

型号 H264

Type



刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	规格 Size	硬质合金牌号			
					MG12	TN35	TI25	TA45
R/L264.0815.10 R/L264.1515.10	1.5	0.05	8°	01	△/△	▲/▲		
15°			▲/▲					
R/L264.0820.10 R/L264.1520.10	2.0	0.05	8°	02	▲/▲	▲/▲		
15°			▲/▲					
R/L264.0825.10 R/L264.1525.10	2.5	0.10	8°	03		▲/▲		
15°			▲/▲					
R/L264.0830.10 R/L264.1530.10	3.0	0.10	8°	04		△/△		
15°			▲/▲					

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	○	●		
M	●	●		
K	●	●		
N	●	●		
S	●	●		
H				

硬质合金牌号  
Carbide grades



# 切断

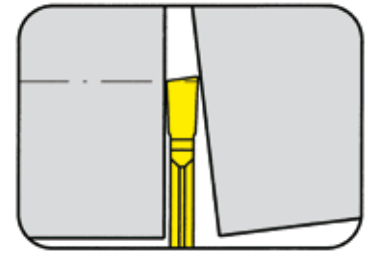
## PARTING OFF



### 可转位刀片 型号

# 264

### INDEXABLE INSERT Type



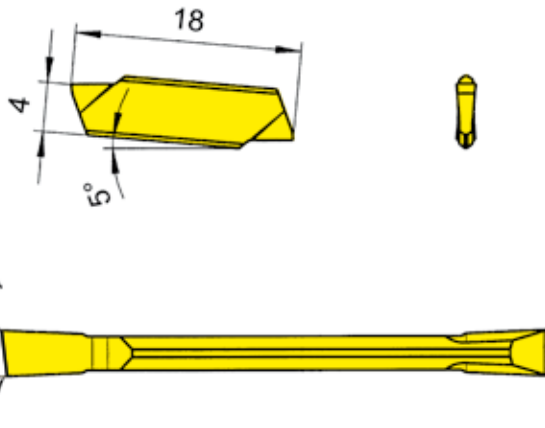
槽深可达  
槽宽

Depth of groove up to  
Width of groove

16.0 mm  
1.5 - 3.0 mm

精密磨削

precision ground

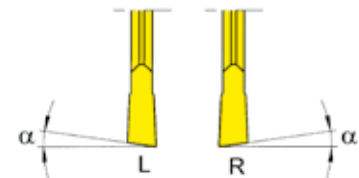


配合 刀杆

for use with Toolholder

型号 H264

Type



刀片长度重复定位精度

±0.015 mm

Indexability length ± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	规格 Size	硬质合金牌号			
					MG12	TN35	TI25	TA45
R/L264.0815.M0 R/L264.1515.M0	1.5	0.05	8°	01	Δ/Δ	▲/Δ		
15°			▲/Δ		▲/Δ			
R/L264.0820.M0 R/L264.1520.M0	2.0	0.05	8°	02	Δ/Δ	Δ/Δ		
15°			Δ/Δ		▲/Δ			
R/L264.0825.M0 R/L264.1525.M0	2.5	0.10	8°	03	/Δ	Δ/Δ		
15°			Δ/Δ		▲/			
R/L264.0830.M0 R/L264.1530.M0	3.0	0.10	8°	04		Δ/Δ		
15°			/Δ		Δ/Δ			

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

## 切槽和切断

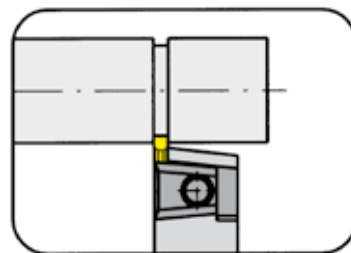
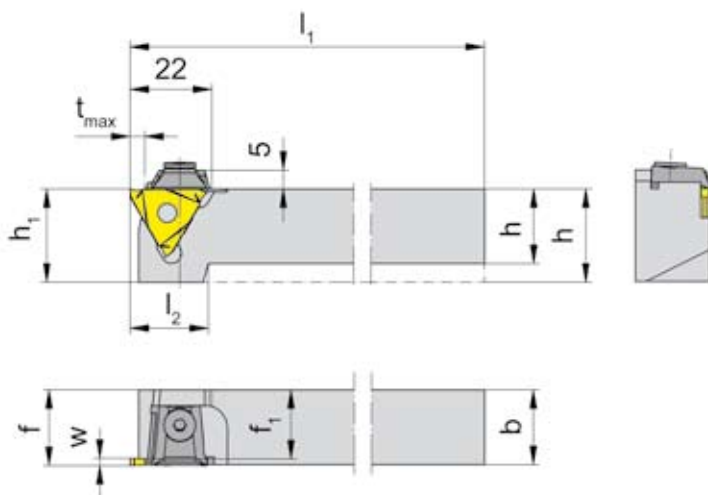
## GROOVING and PARTING OFF



## 刀杆 型号

360

TOOLHOLDER Type

槽深可达  
夹持范围Depth of groove up to  
Clamping range6.0 mm  
1.9 - 2.9 mm配合 可转位刀片  
for use with Indexable insert型号 312  
Type S312

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L360.1212.02	12	12	100	24	25	9.5	$f_1 + w - a_1$	6	02	1.9 - 2.9
R/L360.1616.02	16	16	125	22	25	13.5				
R/L360.2020.02	20	20	125	21	25	17.5				
R/L360.2525.02	25	25	150	-	25	22.5				
R/L360.3232.02	32	32	170	-	32	29.5				

注明R或L型

State R or L version

w, a<sub>1</sub>见刀片w, a<sub>1</sub> see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40$ mm时才能达到 $t_{max}$  $t_{max}$  can be reached only with workpiece  $\varnothing \leq 40$  mm

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench
R/L360.1...02	11.3	6.25	SW3.0DIN911
R/L360....02	16.4	6.25	SW3.0DIN911

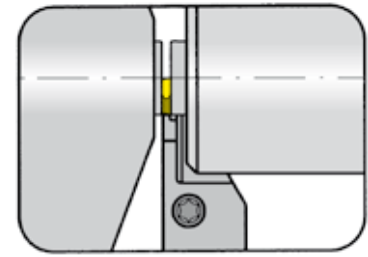
# 切断

## PARTING OFF



刀杆型号  
TOOLHOLDER Type

# 368

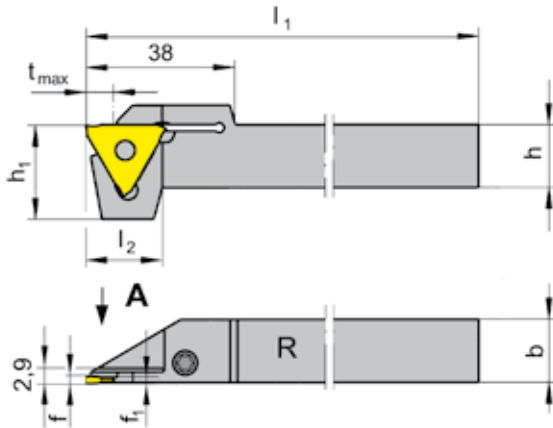


槽深可达  
槽宽

Depth of groove up to  
Width of groove

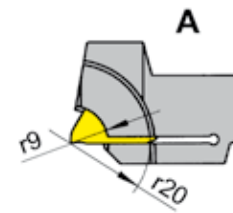
8.0 mm  
0.5 - 1.5 mm

用于TRAUB ( TNL12/7 ) 机床  
for machines TRAUB (TNL12/7)



配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled  
inserts

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$
R/L368.1212.08	12	12	95	19.5	24	1.0	$f_1+a_1$	8
R/L368.1616.08	16	16	95	19.5	24	1.0	$f_1+a_1$	8
R/L368.1212.11	12	12	95	19.5	24	1.3	$f_1+a_1$	8
R/L368.1616.11	16	16	95	19.5	24	1.3	$f_1+a_1$	8

注明R或L型  
State R or L version

a<sub>1</sub> 见刀片  
a<sub>1</sub> see indexable inserts

尺寸单位：mm  
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格，详见技术说明。

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

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L368.1...	4.15T15P	T15PQ

# 切断

## PARTING OFF

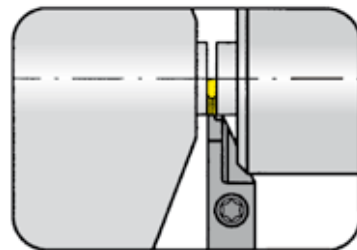


### 刀杆 型号

TOOLHOLDER Type

# 368

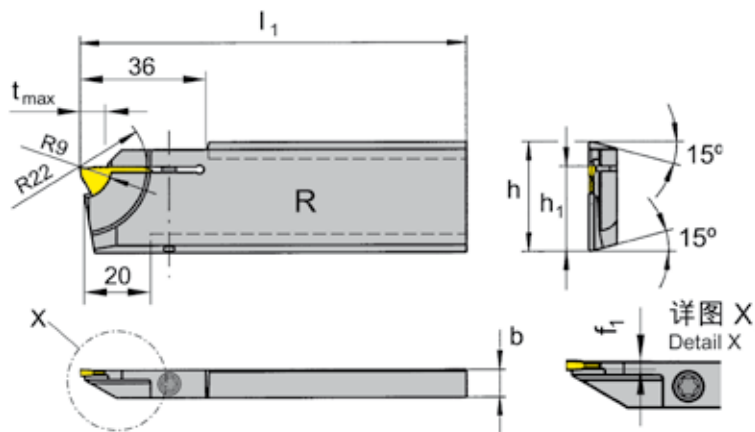
加强型  
reinforced version



槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
0.5 - 1.5 mm



配合 可转位刀片  
for use with Indexable insert

型号 312 "G"  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

仅用于周边轮廓磨削刀片  
only for periferal grounded profiled  
inserts

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>
R/L368-2608.08	26	8	110	21.4	1.0	8
R/L368-3208.08	32	8	110	24.8	1.0	8
R/L368-2608.11	26	8	110	21.4	1.3	8
R/L368-3208.11	32	8	110	24.8	1.3	8

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：

R/L312.0515... / R/L312.0015...

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

螺丝的扭矩规格，详见技术说明。

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

### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L368....	4.15T15P	T15PQ

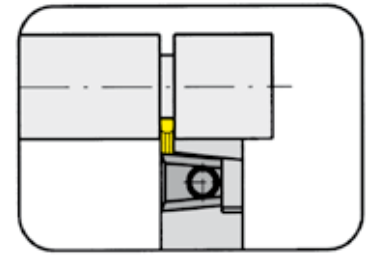
# 切断

## PARTING OFF



刀杆 型号  
TOOLHOLDER Type

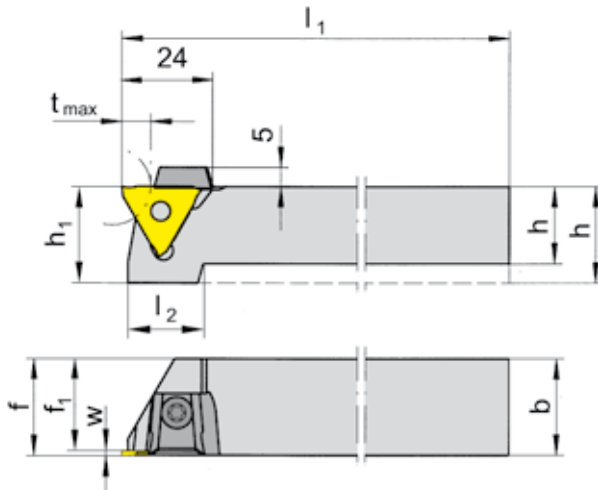
# 391



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

8.0 mm  
0.5 - 1.9 mm



配合 可转位刀片  
for use with Indexable insert

型号 312  
Type N312  
S312

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L391.1212.01	12	12	100	21	21	10.5	$f_1+w-a_1$	8	01	0.5-1.9
R/L391.1616.01	16	16	125	21	21	14.5				
R/L391.2020.01	20	20	125	21	21	18.5				
R/L391.2525.01	25	25	150	-	25	23.8				

注明R或L型  
State R or L version

$w, a_1$ 见刀片  
 $w, a_1$  see indexable inserts

尺寸单位: mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

只有当工件直径 $\varnothing \leq 20\text{mm}$ 时才能达到 $t_{max}$   
 $t_{max}$  can be reached only with workpiece  $\varnothing \leq 20\text{ mm}$

螺丝的扭矩规格, 详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	压板 Clamp	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L391.1212.01	12.3	030.0422.T10P	SW3.0DIN911	T10PL
R/L391.1616.01	14.4	5.32.3T15P		T15PQ
R/L391.2...01	16.4	6.25		

# 切断

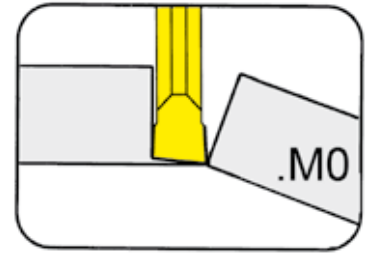
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

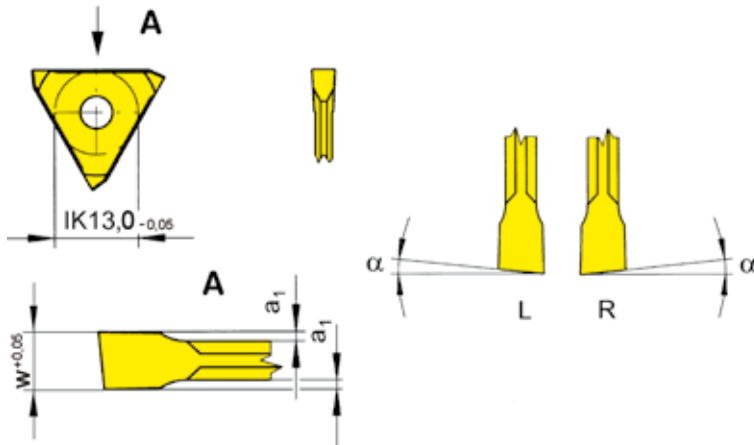
# 312



槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
1.2 - 1.5 mm



配合 刀杆

for use with Toolholder

型号 368

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	a <sub>1</sub>	α	规格 Size	K10	TN35	TI25	TF45
<b>R/L312.0512.M0</b>	1.2	0.2	5°	01	/Δ			▲/Δ
<b>R/L312.0515.M0</b>	1.5	0.2	5°	01	▲/			▲/Δ
▲ 库存 / on stock Δ 4周 / 4 weeks					P	•	•	•
● 主要应用 / main recommendation					M	○		•
○ 可选推荐 / alternative recommendation					K	•		•
■ 无涂层牌号 / uncoated grades					N	•		•
■ 涂层牌号 / coated grades					S	○		•
■ 钎焊/金属陶瓷 / brazed/Cermet					H			

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

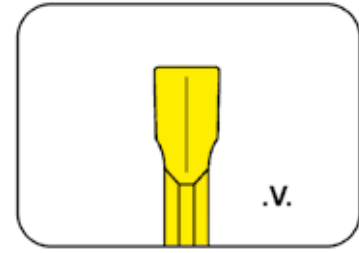
Carbide grades

# 切断 PARTING OFF



可转位刀片 型号  
INDEXABLE INSERT Type

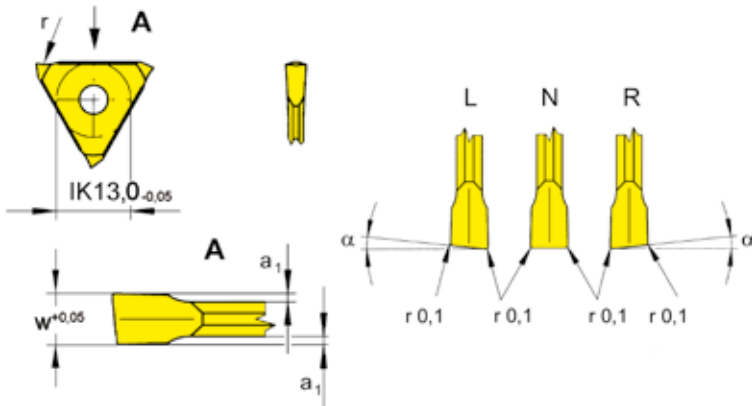
## 312



槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	1.2 - 2.0 mm

配合 刀杆  
for use with Toolholder

型号 368  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	a <sub>1</sub>	α	规格 Size	TN35	Tl25	TF45	TH35
					312.0012.V1 R/L312.0512.V1	1.2	0.2	0° 5°
312.0015.V1 R/L312.0515.V1	1.5	0.2	0° 5°	01		▲ ▲/▲		
R/L312.0520.V2	2.0	0.2	5°	01			▲/▲	
					P		•	•
					M		•	•
					K		•	•
					N		•	•
					S		•	•
					H			

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

# 切断

## PARTING OFF

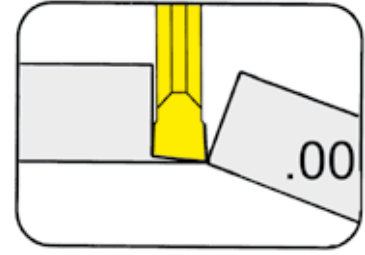


### 可转位刀片 型号

INDEXABLE INSERT Type

# 312

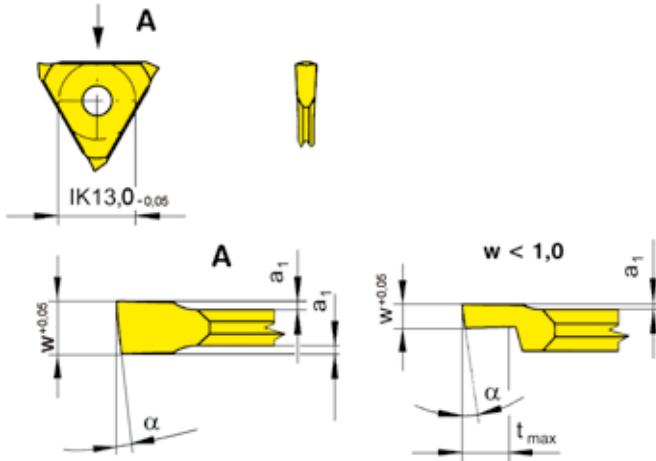
带圆形断屑槽  
with round chip breaker



槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
0.5 - 1.5 mm



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 368  
Type

产品型号 Part number	w	t <sub>max</sub>	a <sub>1</sub>	α	规格 Size	TN35	TI25	TF45
R/L312.0805.00	0.5	1.0	0.1	8°	01			▲/▲
R/L312.0808.00	0.8	1.5	0.1	8°				▲/▲
R/L312.1210.00	1.0	8.0	0.1	12°		▲/▲		▲/▲
R/L312.0510.00	1.0	8.0	0.1	5°				▲/▲
R/L312.0512.00	1.2	8.0	0.2	5°				▲/▲
R/L312.0515.00	1.5	8.0	0.2	5°				▲/▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

	P	M	K	N	S	H
TN35	●					
TI25		●				
TF45			●			

硬质合金牌号  
Carbide grades



# 切槽和切断

## GROOVING and PARTING OFF

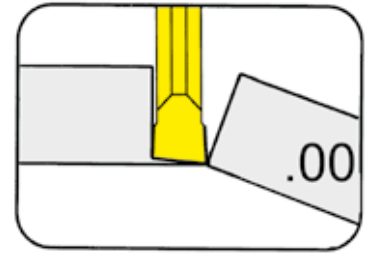


### 可转位刀片 型号

INDEXABLE INSERT Type

### 312

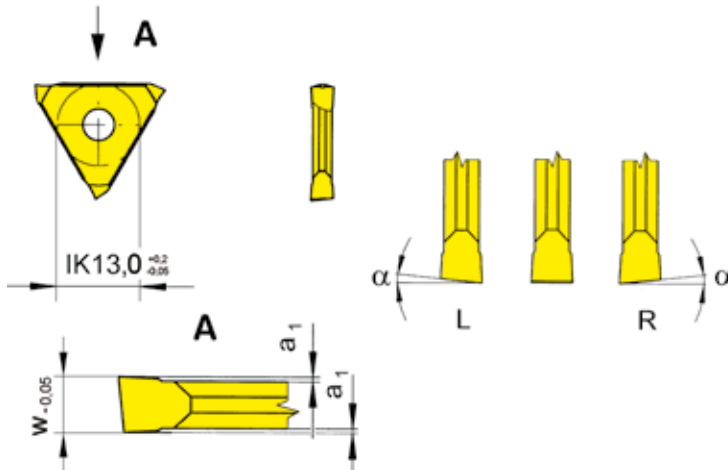
带圆形断屑槽  
with round chip breaker



槽深可达	Depth of groove up to	5.00 mm
槽宽	Width of groove	1.07 - 1.44 mm

配合 刀杆  
for use with Toolholder

型号 360  
Type 361



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	α	a <sub>1</sub>	规格 Size	K10	P20	TN32	TN35	TI25	TF45	TF46
312.0100.00	1.07	0°	0.09	01	▲	▲	▲	▲		▲	▲
312.0130.00	1.44	0°	0.20	01	▲	▲	▲	▲		▲	▲
R/L312.0614.00		6°		01 / 02				▲/▲	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock   Δ 4周 / 4 weeks					P	●	●	●	●	●	●
● 主要应用 / main recommendation					M	○	●	●	●	●	○
○ 可选推荐 / alternative recommendation					K	●	●	●	●	●	●
■ 无涂层牌号 / uncoated grades					N	●	●	●	●	●	●
■ 涂层牌号 / coated grades					S	○	●	●	●	●	○
■ 钎焊/金属陶瓷 / brazed/Cermet					H						

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

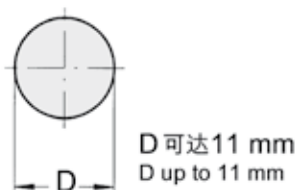
#### 外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:  
for Toolholder type 360

use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

#### 实心棒料切断 parting off solid bars



#### 空心棒料切断 parting off tubes



## 切槽和切断

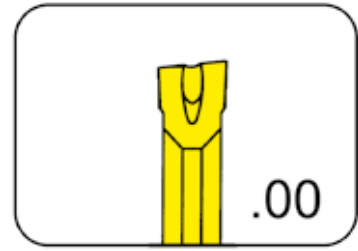
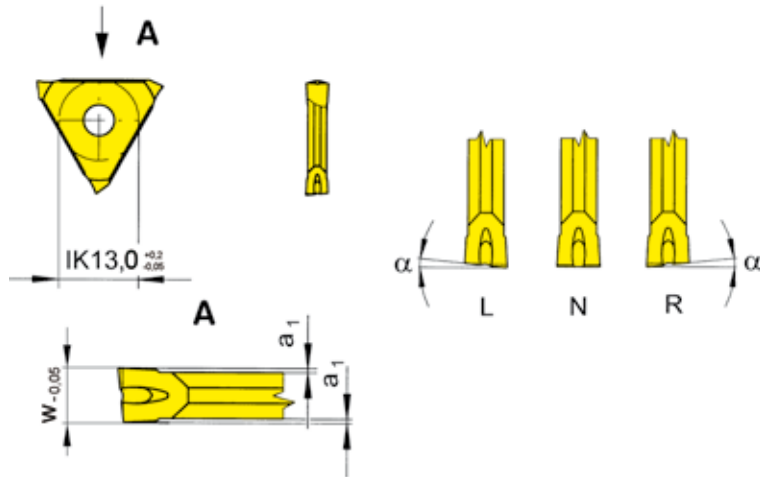
## GROOVING and PARTING OFF



## 可转位刀片 型号

INDEXABLE INSERT Type

312

带圆形断屑槽  
with round chip breaker槽深可达  
槽宽Depth of groove up to  
Width of groove5.0 mm  
1.44 - 2.29 mm

配合 刀杆

for use with Toolholder

型号 360

Type 361

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	a <sub>1</sub>	α	规格 Size	P20	TN32	TN35	TI25	TF45
N312.0014.00 R/L312.0514.00	1.44	0.2	0° 5°	01 / 02					▲
N312.0018.00 R/L312.0518.00	1.99	0.2	0° 5°	02	▲/▲	▲/▲	▲/▲		▲
N312.0021.00 R/L312.0521.00	2.29		0° 5°			▲			
	2.29				▲/▲	▲/▲	▲/▲		
					P	•	•	•	•
					M		•		•
					K		•		•
					N		•		•
					S		•		•
					H				

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

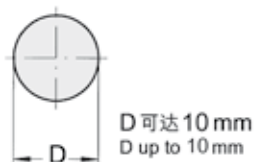
State R or L version

外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:  
for Toolholder type 360

use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

实心棒料切断  
parting off solid bars空心棒料切断  
parting off tubes

# 切断 PARTING OFF



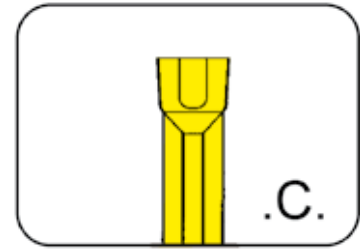
P

## 可转位刀片 型号

INDEXABLE INSERT Type

## S312

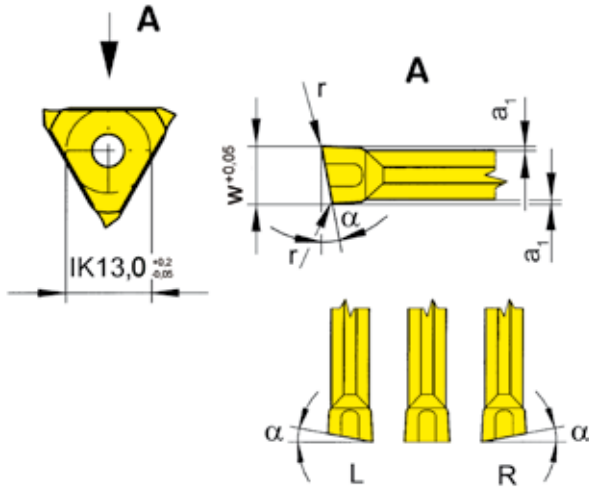
带烧结断屑槽  
with sintered geometries



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
2.0 - 3.0 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 361  
369

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

槽型.C  
Geometry .C

产品型号 Part number	w	r	a <sub>1</sub>	α	规格 Size	硬质合金牌号 Carbide grades			
						TN32	TI25	TA45	TF46
S312.0200.C2	2.0			0°	02		▲		▲
R/LS312.0520.C2	2.0	0.2	0.25	5°		▲/▲		▲/▲	▲/▲
S312.0250.C2	2.5			0°		▲			▲
R/LS312.0525.C2	2.5			5°		▲/▲			▲/Δ
S312.0300.C2	3.0	0.2	0.25	0°	03		▲		Δ
R/LS312.0530.C2				5°		▲/▲		Δ/Δ	
▲ 库存 / on stock   Δ 4周 / 4 weeks						P	•		•
● 主要应用 / main recommendation						M	•		○
○ 可选推荐 / alternative recommendation						K	•		•
■ 无涂层牌号 / uncoated grades						N	•		•
■ 涂层牌号 / coated grades						S	•		○
■ 钎焊/金属陶瓷 / brazed/Cermet						H			

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

# 切断

## PARTING OFF

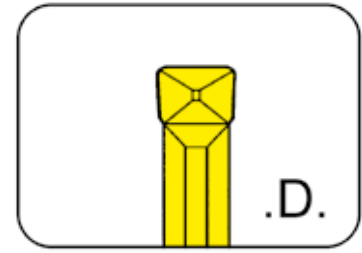


### 可转位刀片 型号

INDEXABLE INSERT Type

## S312

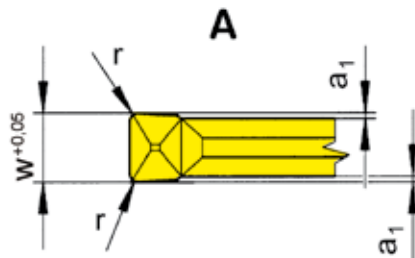
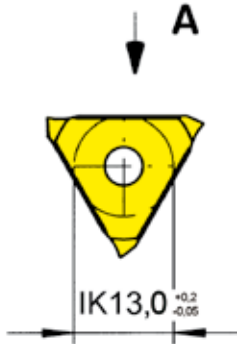
带烧结断屑槽  
with sintered geometries



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
2.0 - 3.0 mm



配合 刀杆  
for use with Toolholder

型号 360  
Type 369

槽型.D  
Geometry .D

产品型号 Part number	w	r	a <sub>1</sub>	规格 Size						
					TN32	TI25	TF45	TF46	AS62	AS66
S312.0200.D2 S312.0200.D4	2.0	0.2 0.4	0.25	02	▲	▲		▲	▲	▲
S312.0250.D2 S312.0250.D4		0.2 0.4			▲	▲	▲	▲	▲	
S312.0300.D2 S312.0300.D4	3.0	0.2 0.4	0.25	03	▲	▲	▲	▲	▲	▲
▲ 库存 / on stock   Δ 4周 / 4 weeks					P	•	•	•	•	•
• 主要应用 / main recommendation					M		•	•	○	○
○ 可选推荐 / alternative recommendation					K		•	•	•	•
■ 无涂层牌号 / uncoated grades					N		•	•	•	•
■ 涂层牌号 / coated grades					S		•	•	○	○
■ 钎焊/金属陶瓷 / brazed/Cermet					H					

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

# 切断

## PARTING OFF

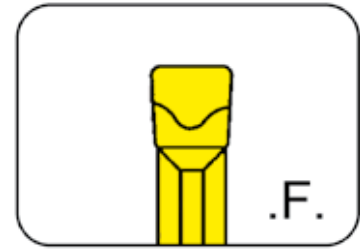


### 可转位刀片 型号

INDEXABLE INSERT Type

## S312

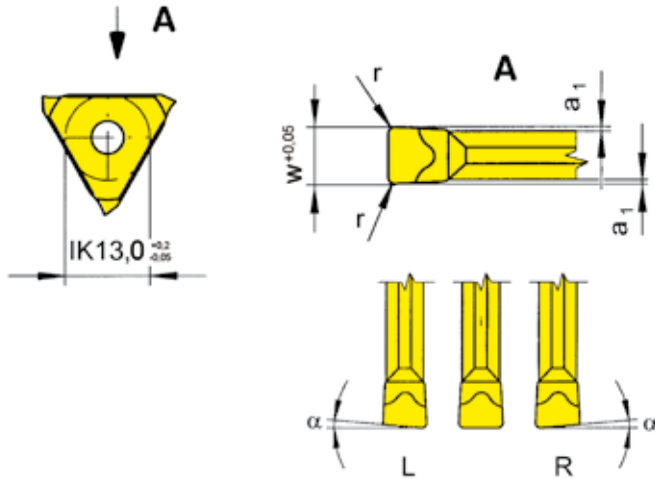
带烧结断屑槽  
with sintered geometries



槽深可达  
槽宽

Depth of groove up to  
Width of groove

5.0 mm  
2.0 - 2.5 mm



R=右手型  
R = right hand version

L=左手型  
L = left hand version

配合 刀杆  
for use with Toolholder

型号 360  
Type 369

槽型.F  
Geometry .F

产品型号 Part number	w	r	a <sub>1</sub>	α	规格 Size	TN35	Ti25	TA45	TF46
						R/LS312.0520.F2 S312.0200.F2	2.0	0.2	0.25
R/LS312.0525.F2 S312.0250.F2	2.5	0.2	0.25	5° 0°	02	▲	▲/▲	▲	▲
						P	•	•	•
						M	•	•	○
						K	•	•	•
						N	•	•	•
						S	•	•	○
						H	•	•	•

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

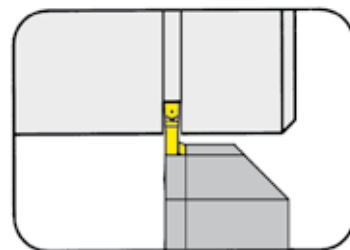
# 切断

## PARTING OFF



刀杆 型号  
TOOLHOLDER Type

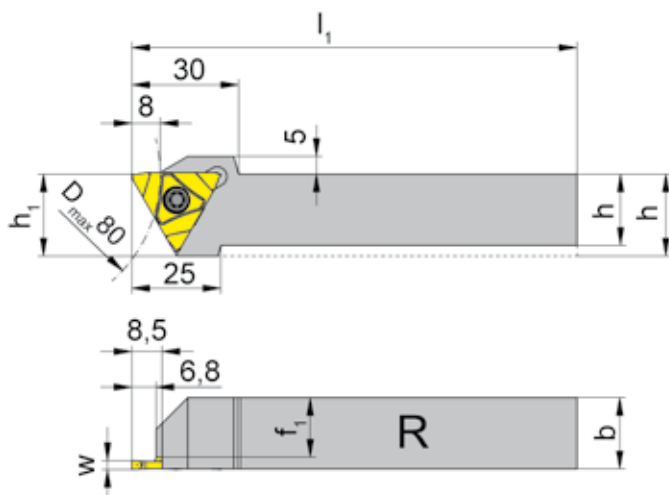
# H316



槽深可达	Depth of groove up to	8.0 mm
夹持范围	Clamping range	1.5 - 3.0 mm

配合 可转位刀片  
for use with Indexable insert

型号 S316  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	规格 Size
R/LH316.1616.S3.03	16	16	125	23	12.7	03
R/LH316.2020.S3.03	20	20	125	23	16.7	
R/LH316.2525.S3.03	25	25	150	25	21.7	
R/LH316.3225.S3.03	32	25	150	32	21.7	

注明R或L型  
State R or L version

w见刀片  
w see indexable inserts

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH316....	5.12T20P	T20PQ

# 切断

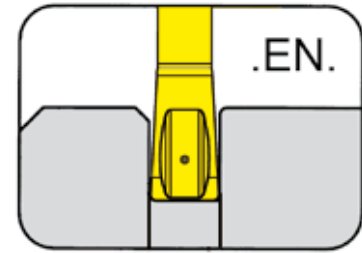
## PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

# S316



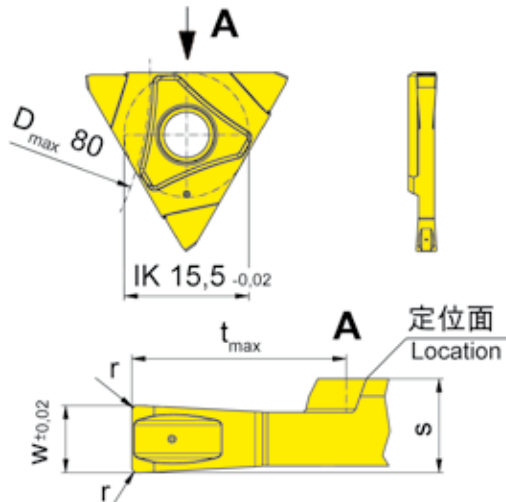
槽深可达  
槽宽

Depth of groove up to  
Width of groove

8.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 刀杆

for use with Toolholder

型号 H316...S3.03

Type

刀片长度重复定位精度  
 $\pm 0.02\text{mm}$

Indexability length  $\pm 0,02\text{ mm}$

产品型号 Part number	w	r	s	t <sub>max</sub>	规格 Size	TN35	TF45	TF46	AS62	AS6G
R/LS316.0200.EN2	2.0									▲/▲
R/LS316.0250.EN2	2.5	0.2	3.5	8	03					▲/▲
R/LS316.0300.EN2	3.0									▲/▲
▲ 库存 / on stock    Δ 4周 / 4 weeks						P				•
● 主要应用 / main recommendation						M				•
○ 可选推荐 / alternative recommendation						K				•
■ 无涂层牌号 / uncoated grades						N				•
■ 涂层牌号 / coated grades						S				•
■ 钎焊/金属陶瓷 / brazed/Cermet						H				

尺寸单位 : mm

Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片 , 左手型刀杆配合左手型刀片

External machining:

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

可转位刀片 型号 S223 + S123  
带断屑槽  
- 精密烧结 -

Indexable Insert type S223 + S123  
with chip forming  
- precision sintered -



槽宽 2 - 3 mm  
槽深 可达 25 mm

Width of groove 2 - 3 mm  
Depth of groove up to 25 mm



## 切槽和切断

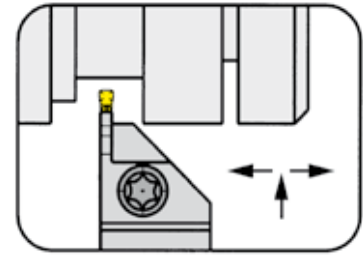
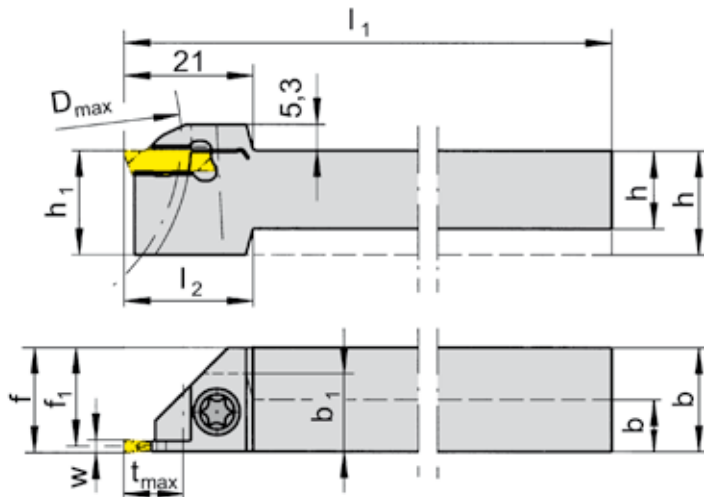
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H223

槽深可达  
槽宽Depth of groove up to  
Width of groove10.0 mm  
2.0 - 3.0 mm

配合 刀片

for use with Insert

型号 S123

Type S223

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	b <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH223.1010.01	10	10	80	12	f <sub>1</sub> +w/2	9.20	20	12	8	25	01	2.0
R/LH223.1212.01	12	12	100	16		11.20	21	-	10	50		
R/LH223.1616.01	16	16	125	16		15.20	-	-	10	50		
R/LH223.2020.01	20	20	125	20		19.20	-	-	10	50		
R/LH223.2525.01	25	25	150	25		24.20	-	-	10	50		
R/LH223.1010.02	10	10	80	12	f <sub>1</sub> +w/2	9.05	20	12	8	25	02	2.5
R/LH223.1212.02	12	12	100	16		11.05	21	-	10	50		
R/LH223.1616.02	16	16	125	16		15.05	-	-	10	50		
R/LH223.2020.02	20	20	125	20		19.05	-	-	10	50		
R/LH223.2525.02	25	25	150	25		24.05	-	-	10	50		
R/LH223.1010.03	10	10	80	12	f <sub>1</sub> +w/2	8.80	20	12	8	25	03	3.0
R/LH223.1212.03	12	12	100	16		10.80	21	-	10	50		
R/LH223.1616.03	16	16	125	16		14.80	-	-	10	50		
R/LH223.2020.03	20	20	125	20		18.80	-	-	10	50		
R/LH223.2525.03	25	25	150	25		23.80	-	-	10	50		

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH223....	5.11T15P	T15PL

## 切槽和切断

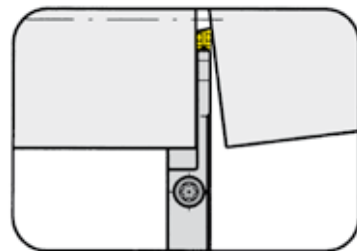
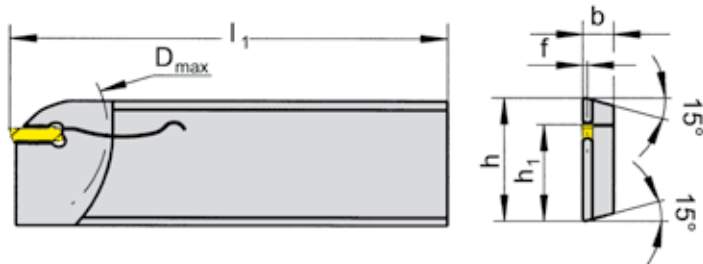
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H223

加强型  
reinforced version槽深可达  
夹持范围Depth of groove up to  
Clamping range25.0 mm  
2.0 - 3.0 mm

配合 刀片

for use with Insert

型号 S123

Type S223

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH223.2608.01 R/LH223.3208.01	26 32	7.9	110	21.4 24.8	0.80	50	01	2.0
R/LH223.2608.02 R/LH223.3208.02	26 32	7.9	110	21.4 24.8	0.95	50	02	2.5
R/LH223.2608.03 R/LH223.3208.03	26 32	7.9	110	21.4 24.8	1.20	50	03	3.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

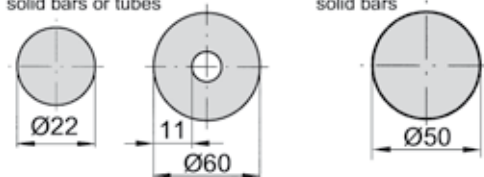
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

切断:  
parting off:实心棒料或空心棒料 (S223) 实心棒料 (S123)  
solid bars or tubes solid bars

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH223....	4.15T15P	T15PL

## 切槽和切断

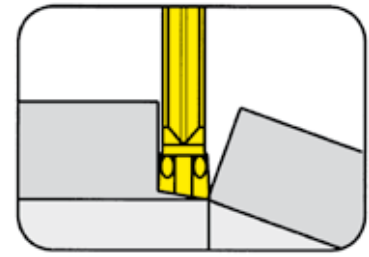
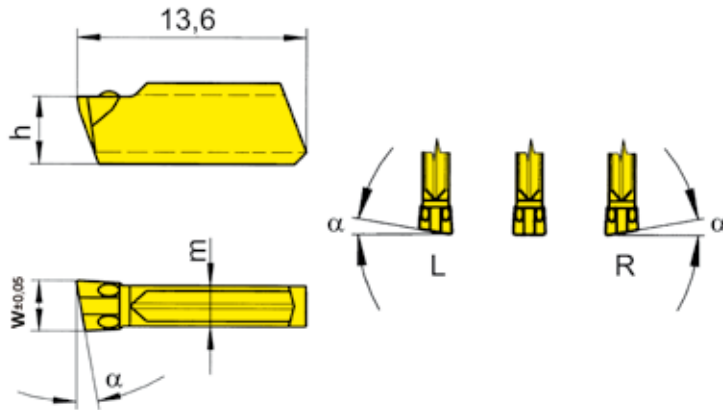
## GROOVING and PARTING OFF



## 刀片型号

INSERT Type

## S123

槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
2.0 - 3.0 mm

配合刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S123.0020.C0 R/LS123.1520.C0 R/LS123.0420.C0 R/LS123.0820.C0	2	0° 15° 4° 8°	1.6	3.65	01		Δ ▲/ ΔΔ/ Δ/ Δ/ Δ/		Δ ▲/ Δ/ Δ/ Δ/
S123.0030.C0 R/LS123.0430.C0 R/LS123.0830.C0	3	0° 4° 8°	2.4	3.95	03		Δ	Δ/ Δ/	
▲ 库存 / on stock   Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet						P	●	●	●
						M	●	●	●
						K	●	●	●
						N	●	●	●
						S	●	●	●
						H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left** hand toolholders.

## 切槽和切断

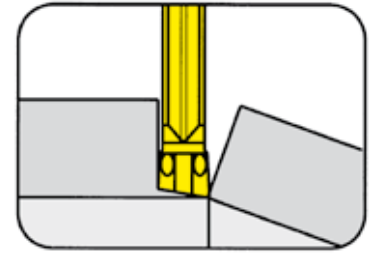
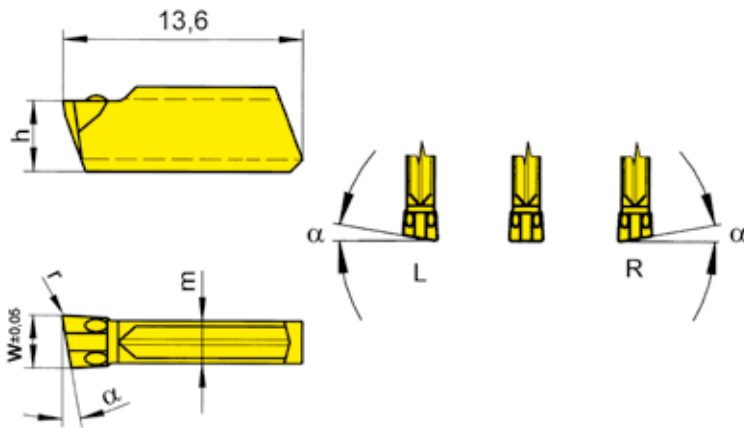
## GROOVING and PARTING OFF



## 刀片型号

INSERT Type

## S123

槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
2.0 - 3.0 mm

配合 刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S123.0020.C1 R/LS123.1520.C1 R/LS123.0420.C1 R/LS123.0820.C1	2	0.15	0° 15° 4° 8°	1.6	3.65	01		△	△	△
S123.0030.C1 R/LS123.0430.C1 R/LS123.0830.C1	3	0.15	0° 4° 8°	2.4	3.95	03		△		△
▲ 库存 / on stock    △ 4周 / 4 weeks							P	•	•	•
● 主要应用 / main recommendation							M	•	•	•
○ 可选推荐 / alternative recommendation							K	•	•	•
■ 无涂层牌号 / uncoated grades							N	•	•	•
■ 涂层牌号 / coated grades							S	•	•	•
■ 钎焊/金属陶瓷 / brazed/Cermet							H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left** hand toolholders.

## 切槽和切断

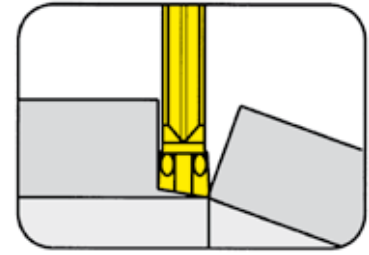
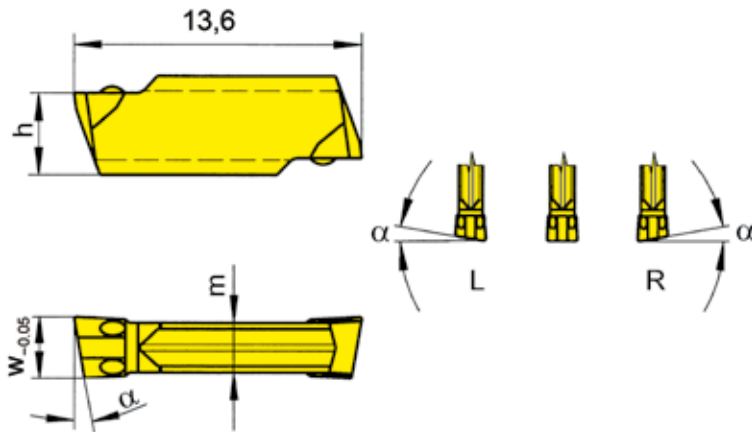
## GROOVING and PARTING OFF



## 可转位刀片 型号

INDEXABLE INSERT Type

## S223

槽深可达  
槽宽Depth of groove up to  
Width of groove11.0 mm  
2.0 - 3.0 mm

配合 刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S223.0020.C0 R/LS223.1520.C0 R/LS223.0420.C0 R/LS223.0820.C0	2.0	0° 15° 4° 8°	1.6	3.65	01		▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲/▲ ▲/▲ ▲/▲
S223.0025.C0 R/LS223.0425.C0 R/LS223.0825.C0	2.5	0° 4° 8°	1.9	3.75	02		▲/▲ ▲/▲ ▲/▲	▲ ▲/ ▲/▲	▲ ▲/▲ ▲/▲
S223.0030.C0 R/LS223.0430.C0 R/LS223.0830.C0	3.0	0° 4° 8°	2.4	3.95	03		▲ ▲/▲ ▲/▲	▲ ▲/ ▲/▲	▲ /▲ ▲/▲
▲ 库存 / on stock    ▲ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可选推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet						P	●	●	●
						M	●	●	●
						K	●	●	●
						N	●	●	●
						S	●	●	●
						H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

## 切槽和切断

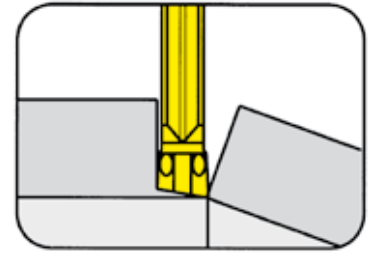
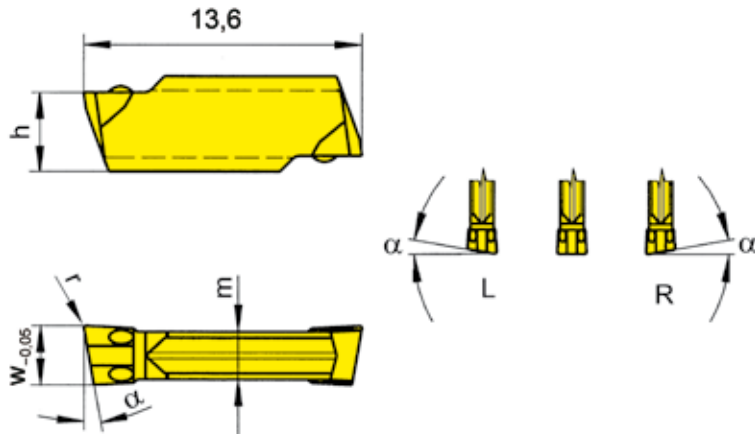
## GROOVING and PARTING OFF



## 可转位刀片 型号

INDEXABLE INSERT Type

## S223

槽深可达  
槽宽Depth of groove up to  
Width of groove11.0 mm  
2.0 - 3.0 mm

配合 刀杆

for use with Toolholder

型号 H223

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	$\alpha$	m	h	规格 Size	MG12	TN35	TI25	TF45
S223.0020.C1 R/LS223.1520.C1 R/LS223.0420.C1 R/LS223.0820.C1	2.0	0.15	0° 15° 4° 8°	1.6	3.65	01		▲ ▲/Δ ▲/Δ ▲/▲	▲ ▲/Δ ▲/ ▲/	▲ ▲/Δ ▲/ ▲/Δ
S223.0025.C1 R/LS223.0425.C1 R/LS223.0825.C1	2.5	0.15	0° 4° 8°	1.9	3.75	02		Δ /Δ	▲ Δ/ ▲/	Δ Δ/Δ
S223.0030.C1 R/LS223.0430.C1 R/LS223.0830.C1	3.0	0.15	0° 4° 8°	2.4	3.95	03		▲ Δ/Δ ▲/	▲ Δ/ ▲/Δ	▲ ▲/
▲ 库存 / on stock    Δ 4周 / 4 weeks							P	•	•	•
● 主要应用 / main recommendation							M	•	•	•
○ 可选推荐 / alternative recommendation							K	•	•	•
■ 无涂层牌号 / uncoated grades							N	•	•	•
■ 涂层牌号 / coated grades							S	•	•	•
■ 钎焊/金属陶瓷 / brazed/Cermet							H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

# 切槽和切断

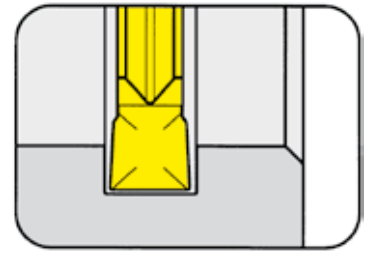
## GROOVING and PARTING OFF



### 可转位刀片 型号

INDEXABLE INSERT Type

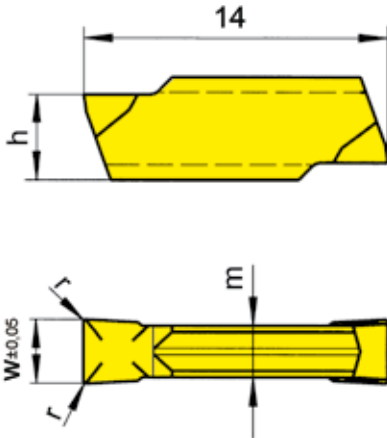
## S223



槽深可达  
槽宽

Depth of groove up to  
Width of groove

11.0 mm  
2.0 - 3.0 mm



配合 刀杆

for use with Toolholder

型号 H223

Type

产品型号 Part number	w	r	m	h	规格 Size	MG12	H54	TN35	TI25	TF45
<b>S223.0200.32</b>	2.0	0.2	1.6	3.65	01	▲	▲	▲	▲	
<b>S223.0250.32</b>	2.5	0.2	2.0	3.75	02	▲	▲	▲	▲	
<b>S223.0300.32</b>	3.0	0.2	2.4	3.95	03	▲	▲	▲	▲	

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

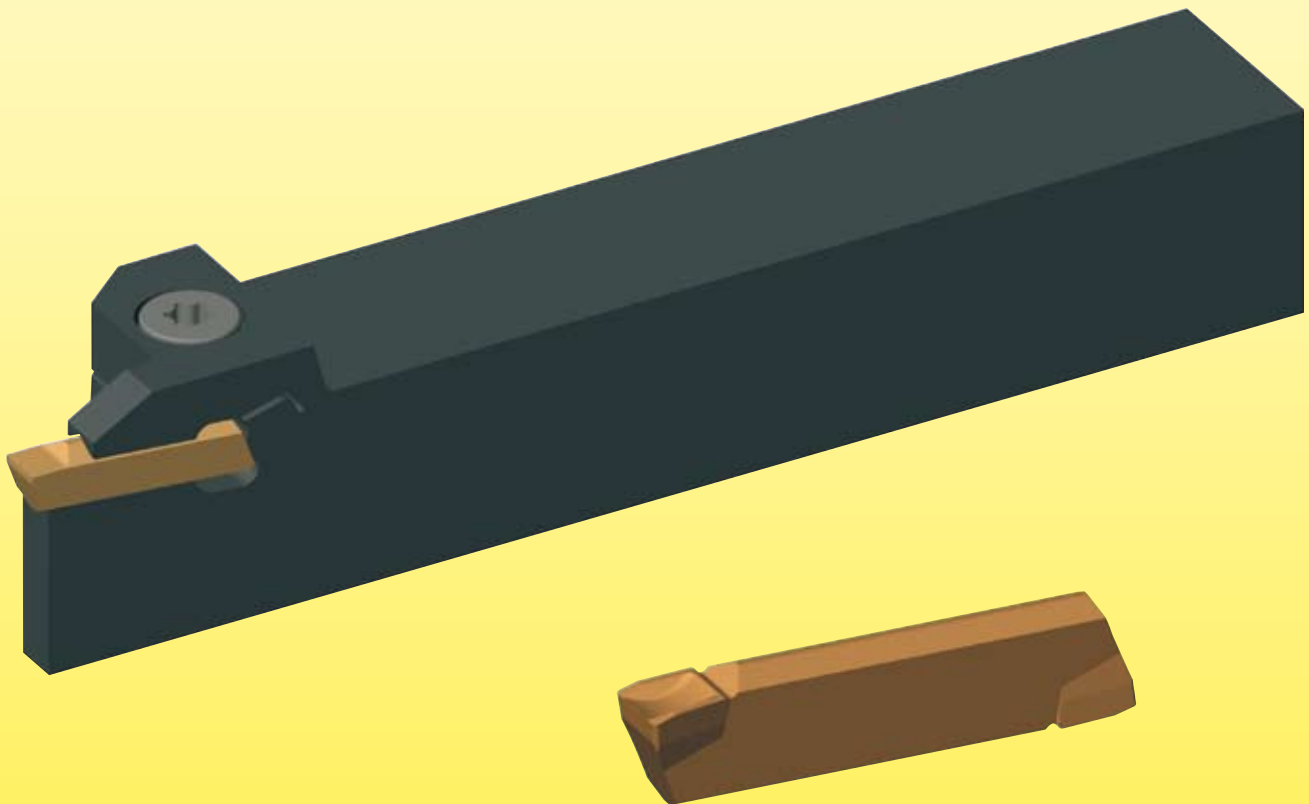
P	○	●	●	●	●	
M	●	●	●	●	●	
K	●	●	●	●	●	
N	●	●	●	●	●	
S	●	●	●	●	●	
H						

硬质合金牌号

Carbide grades

可转位刀片 型号 S224  
带断屑槽  
- 精密烧结 -

Indexable Insert type S224  
with chip forming  
- precision sintered -



槽宽 2 - 3 mm  
槽深 可达 18 mm

Width of groove 2 - 3 mm  
Depth of groove up to 18 mm



## 切槽和切断

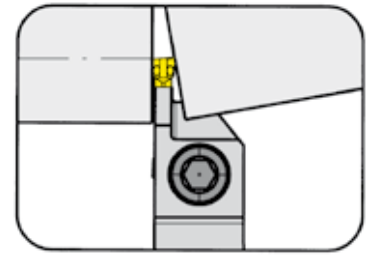
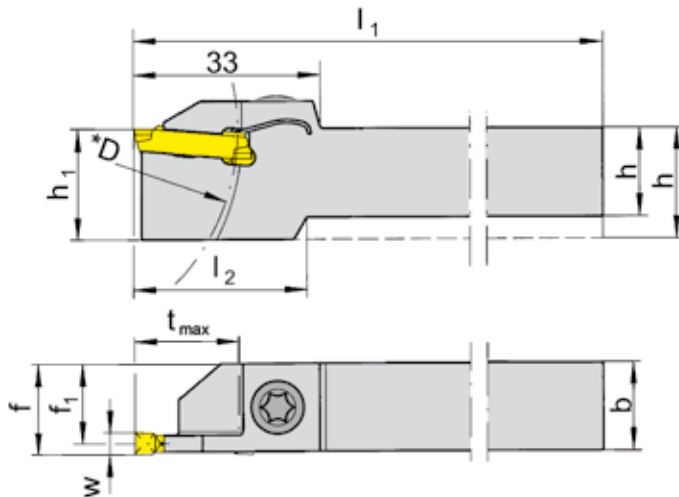
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

槽深可达  
夹持范围Depth of groove up to  
Clamping range14.0 mm  
2.0 - 3.7 mm

配合 可转位刀片

for use with Indexable insert

型号 S224

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	$f_1$	$l_2$	$t_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1616.01	16	16	125	20		15.3	25			
R/LH224.2020.01	20	20	125	20	$f_1+w/2$	19.3	-	14	01	2.0 - 2.4
R/LH224.2525.01	25	25	150	25		24.3	-			
R/LH224.1616.02	16	16	125	20		15.1	25			
R/LH224.2020.02	20	20	125	20	$f_1+w/2$	19.1	-	14	02	2.4 - 2.8
R/LH224.2525.02	25	25	150	25		24.1	-			
R/LH224.1616.03	16	16	125	20		14.9	25			
R/LH224.2020.03	20	20	125	20	$f_1+w/2$	18.9	-	14	03	2.8 - 3.7
R/LH224.2525.03	25	25	150	25		23.9	-			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

\*D=80mm以内可达 $t_{max}$ \* $t_{max}$  up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	6.23T25P	T25PQ

## 切槽和切断

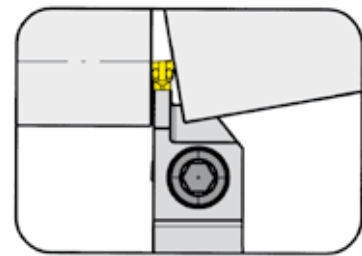
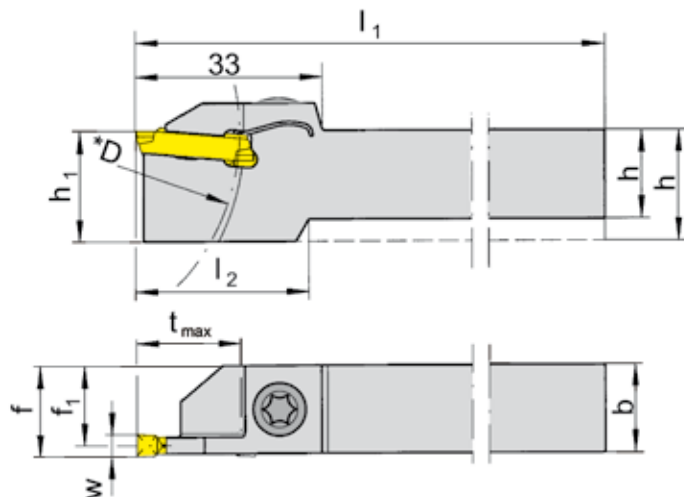
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
2.0 - 3.7 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 S224

Type

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	$f_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.1616.21	16	16	125	30	20	15.3	$f_1+w/2$	18	01	2.0 - 2.4
R/LH224.2020.21	20	20	125	-	20	19.3				
R/LH224.2525.21	25	25	150	-	25	24.3	$f_1+w/2$	18	02	2.4 - 2.8
R/LH224.1616.22	16	16	125	30	20	15.1				
R/LH224.2020.22	20	20	125	-	20	19.1				
R/LH224.2525.22	25	25	150	-	25	24.1	$f_1+w/2$	18	03	2.8 - 3.7
R/LH224.1608.23	16	8	100	-	20	6.9				
R/LH224.1616.23	16	16	125	30	20	14.9				
R/LH224.2020.23	20	20	125	-	20	18.9				
R/LH224.2525.23	25	25	150	-	25	23.9				

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

\*D=80mm以内可达 $t_{max}$ \*  $t_{max}$  up to D = 80 mm

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.1608.23	4.15T15P	T15PQ
R/LH224....21/22/23	6.23T25P	T25PQ

## 切槽和切断

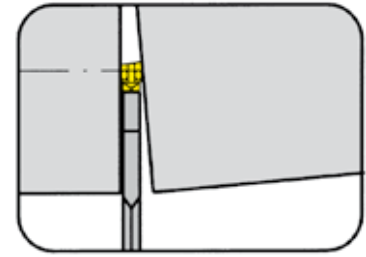
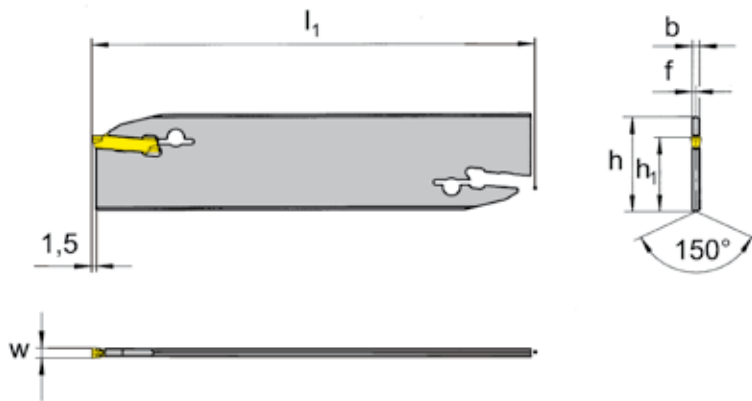
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

自锁紧  
with self clamping槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
2.4 - 3.7 mm

配合 可转位刀片

for use with Indexable insert

型号 S224

Type

产品型号 Part number	h	b	$l_1$	$h_1$	f	$t_{max}$	规格 Size	夹持范围 Clamping range
H224-2602-02	26	1.9	110	21.4	0.95	18	02	2.4 - 2.8
H224-2603-03	26	2.3	110	21.4	1.15	18	03	2.8 - 3.7
H224-3203-03	32	2.3	150	24.8	1.15	18	03	2.8 - 3.7

按需提供更多尺寸  
Further sizes upon requestw见刀片  
w see indexable inserts尺寸单位：mm  
Dimensions in mm

## 注意事项：

扳手P39L不包含在刀板中，需单独订购！

## Note:

Wrench P39L ist not combined with blade - separate order required!



## 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
H224....	P39L

## 切槽和切断

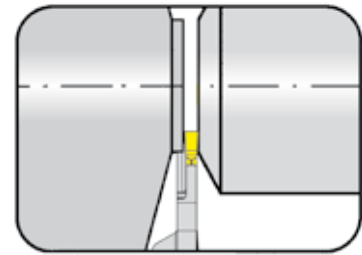
## GROOVING and PARTING OFF



## 刀杆 型号

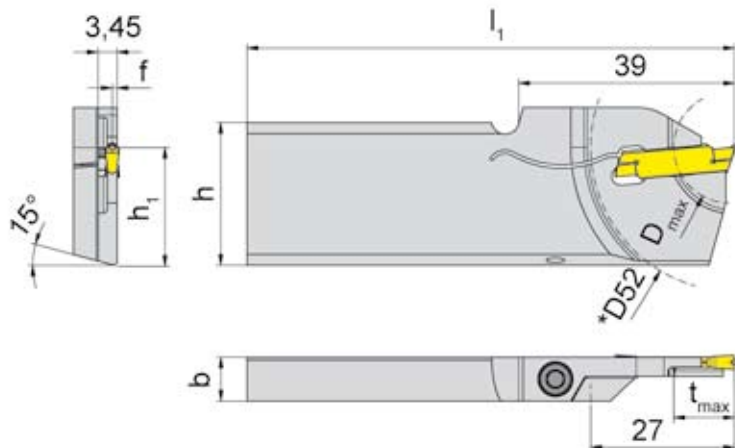
TOOLHOLDER Type

## H224

加强型  
reinforced version槽深可达  
槽宽Depth of groove up to  
Width of groove

11.0 mm

2.0 - 3.0 mm

用于机床：TRAUB (TNL18P)  
for machines TRAUB (TNL18P)配合 可转位刀片  
for use with Indexable insert型号 S224  
Type

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
LH224.2608.20.T.81	26	7.9	88	21.4	0.7	11	20	01	2.0
LH224.2608.20.T.82	26	7.9	88	21.4	0.9	11	20	02	2.5
LH224.2608.20.T.83	26	7.9	88	21.4	1.1	11	20	03	3.0

按需提供更多尺寸

Further sizes upon request

\*副主轴的 $D_{max}$  = D52\*D 52 =  $D_{max}$  of the subspindle

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LH224.2608.20.T.8...	4.15T15P	T15PL

## 切槽和切断

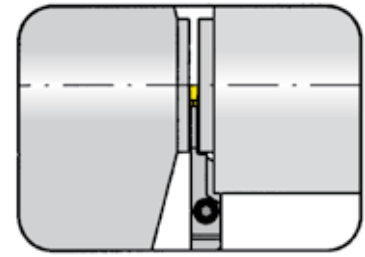
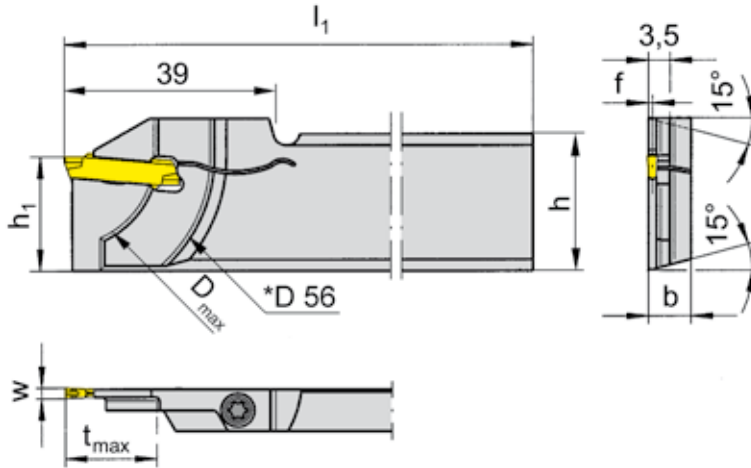
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

加强型  
reinforced version槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
2.4 - 3.7 mm用于TRAUB ( TNK28/TNK36/TNL26 ) 机床  
for machines TRAUB (TNK28/TNK36/TNL26)配合 可转位刀片  
for use with Indexable insert型号 S224  
TypeR=右手型-如图  
R = right hand version shownL=左手型  
L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	$t_{max}$	$D_{max}$	规格 Size	夹持范围 Clamping range
R/LH224.2608.81	26	7.9	110	21.4	0.75	18	36	01	2.0 - 2.4
R/LH224.2608.82	26	7.9	110	21.4	0.95	18	36	02	2.4 - 2.8
R/LH224.2608.83	26	7.9	110	21.4	1.10	18	36	03	2.8 - 3.7

注明R或L型  
State R or L versionw见刀片  
w see indexable inserts尺寸单位：mm  
Dimensions in mm\*副主轴 $D_{max}$ =D56  
\* $D_{56} = D_{max}$  of the subspindle按需提供更多尺寸  
Further sizes upon request螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.2608.8...	4.15T15P	T15PL

## 切槽和切断

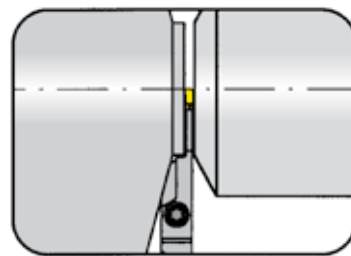
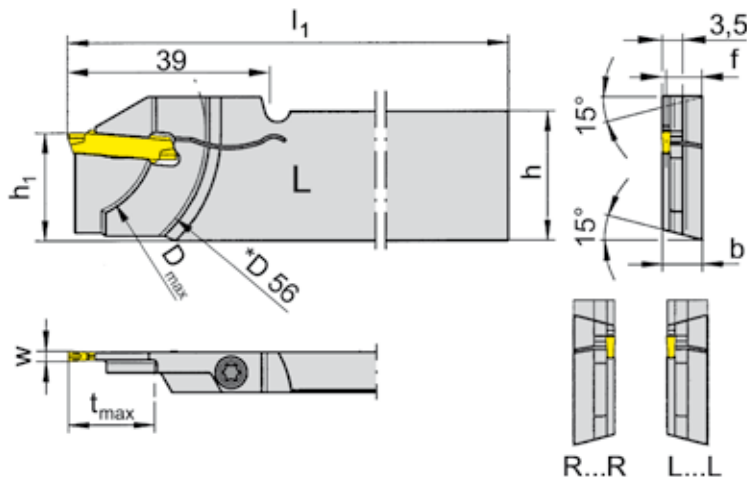
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

加强型  
reinforced version槽深可达  
夹持范围Depth of groove up to  
Clamping range21.0 mm  
2.0 - 3.7 mm用于TRAUB ( TNK28/TNK36/TNL26 ) 机床  
for machines TRAUB (TNK28/TNK36/TNL26)配合 可转位刀片  
for use with Indexable insert型号 S224  
Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.2608.81R/L	26	7.9	110	21.4	7.15	18	36	01	2.0 - 2.4
R/LH224.2608.82R/L	26	7.9	110	21.4	6.95	18	36	02	2.4 - 2.8
R/LH224.2608.83R/L	26	7.9	110	21.4	6.75	18	36	03	2.8 - 3.7
RH224.3208.83R	32	7.9	110	24.8	6.80	21	42		

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

\*副主轴D<sub>max</sub>=D56\*D 56 = D<sub>max</sub> of the subspindle

\* 用于副主轴的特殊夹持装置(例如:HAINBUCH Axfixchuck)

\* For specific clamping device on subspindle  
(e.g. HAINBUCH Axfixchuck)

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224.2608.81R/L/82R/L/83R/L RH224.3208.83R	4.15T15P 5.13T20P	T15PL T20PQ

# 切槽和切断

## GROOVING and PARTING OFF

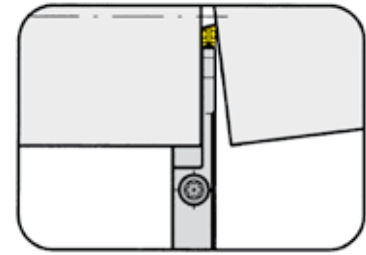


### 刀杆 型号

TOOLHOLDER Type

## H224

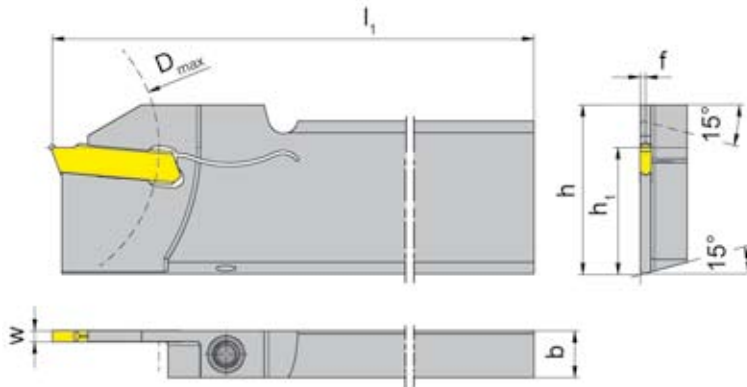
加强型  
reinforced version



槽深可达  
夹持范围

Depth of groove up to  
Clamping range

18.0 mm  
2.0 - 3.7 mm



配合 可转位刀片  
for use with Indexable insert

型号 S224  
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.2608.01 R/LH224.3208.01	26 32	7.9	110	21.4 24.8	0.7	18	50	01	2.0 - 2.4
R/LH224.2608.02 R/LH224.3208.02	26 32	7.9	110	21.4 24.8	0.9	18	50	02	2.4 - 2.8
R/LH224.2608.03 R/LH224.3208.03	26 32	7.9	110	21.4 24.8	1.1	18	50	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

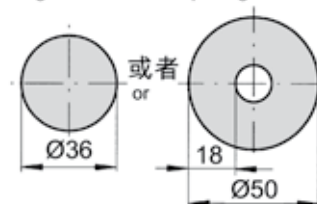
按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

实心棒料切断      空心棒料切断  
parting off solid bars      parting off tubes



### 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH224....	4.20T15P	T15PL

## 切槽和切断

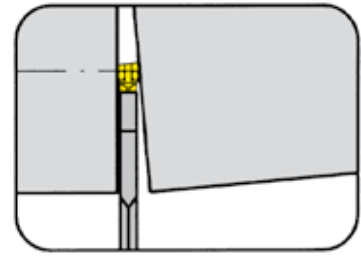
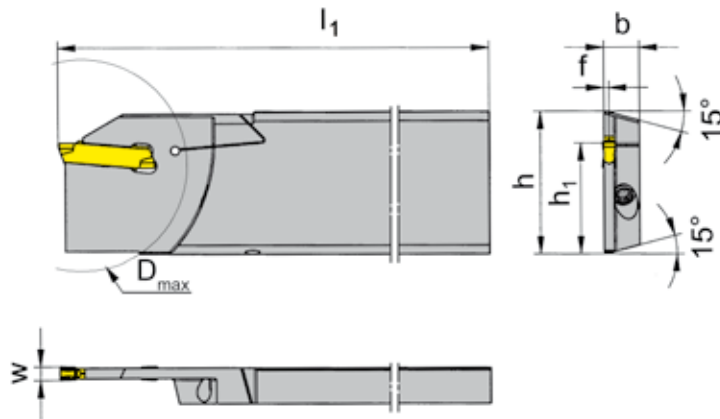
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H224

螺钉锁紧  
with screwed clamping槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
3.7 mm

配合 可转位刀片

for use with Indexable insert

型号 S224

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/LH224.3208.93	32	8	112	24.8	1.15	18	50	03	2.8 - 3.7

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	销 Pin
R/LH224.3208.93	030.0413.T15P	T15PQ	020.0040.0999



# 切槽和切断

## GROOVING and PARTING OFF

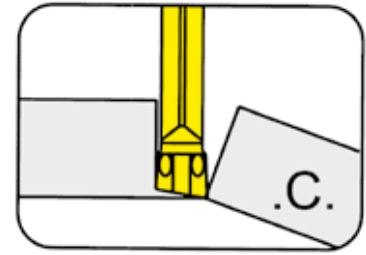


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



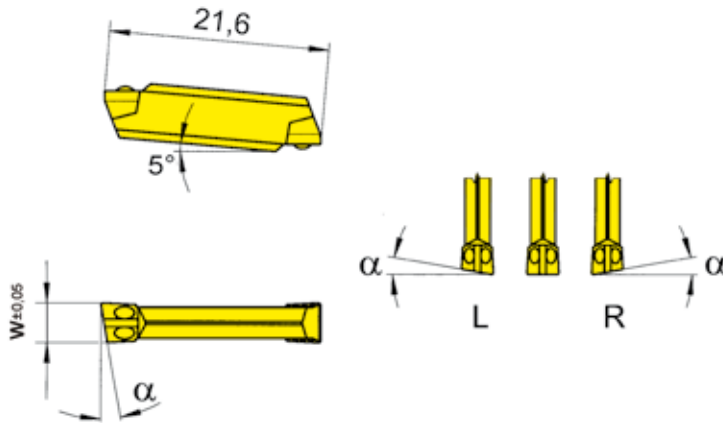
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 H224

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	$\alpha$	规格 Size	TN35	TI25	TF45
S224.0020.C0 R/LS224.1520.C0 R/LS224.0520.C0 R/LS224.0820.C0	2.0	0° 15° 5° 8°	01	▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲ ▲ ▲	▲ ▲/▲ ▲/▲ ▲/▲
S224.0025.C0 R/LS224.0525.C0 R/LS224.0825.C0	2.5	0° 5° 8°	02	▲ ▲/▲ ▲/▲	▲ ▲/ ▲	▲ ▲/▲ ▲/
S224.0030.C0 R/LS224.0530.C0 R/LS224.0830.C0	3.0	0° 5° 8°	03	▲ ▲/▲ ▲/▲	▲ ▲ ▲	▲ ▲/▲ ▲/▲

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H			

硬质合金牌号  
Carbide grades

## 切槽和切断

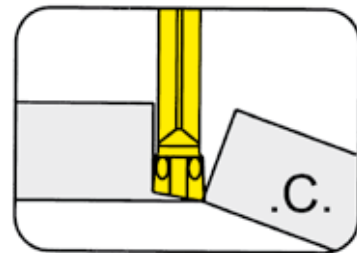
## GROOVING and PARTING OFF



## 可转位刀片 型号

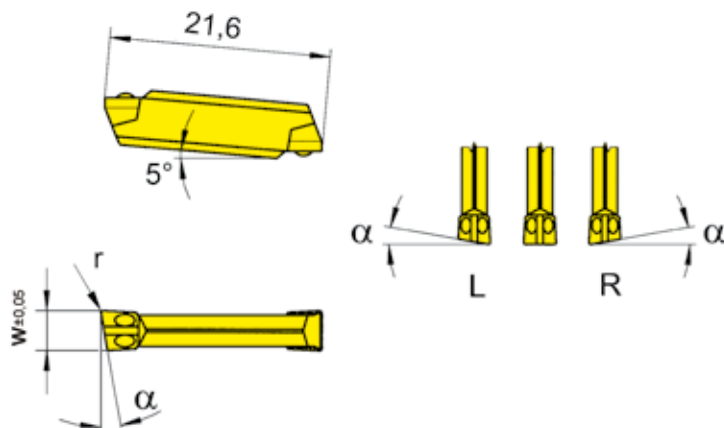
INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming槽深可达  
槽宽Depth of groove up to  
Width of groove18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 H224

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	$\alpha$	规格 Size	TN35	TI25	TF45
S224.0020.C1 R/LS224.1520.C1 R/LS224.0520.C1 R/LS224.0820.C1	2.0	0.15	0° 15° 5° 8°	01	▲ ▲/▲ ▲/▲ ▲/▲	▲ ▲ ▲ ▲	▲ ▲/▲ ▲/▲ ▲/▲
S224.0025.C1 R/LS224.0525.C1 R/LS224.0825.C1	2.5	0.15	0° 5° 8°	02	▲ ▲/▲	▲ ▲	▲ ▲/▲ ▲/▲
S224.0030.C1 R/LS224.0530.C1 R/LS224.0830.C1	3.0	0.15	0° 5° 8°	03	▲ ▲/▲ ▲/▲	▲ ▲	▲ ▲/▲ ▲/▲

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	•	•	•
M	•	•	•
K	•	•	•
N	•	•	•
S	•	•	•
H			

硬质合金牌号  
Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

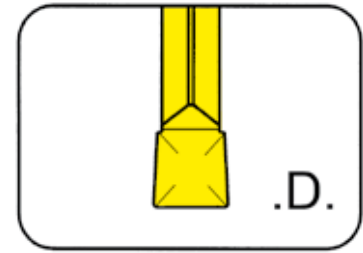


### 可转位刀片 型号

INDEXABLE INSERT Type

## S224

带断屑槽  
with chip forming



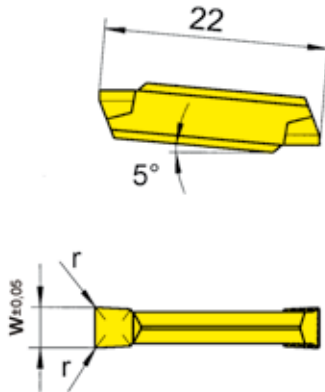
槽深可达  
槽宽

Depth of groove up to  
Width of groove

18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 H224

Type

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size		H54	TN32	TN35	TI25	TF45	TF46
<b>S224.0200.D2</b>	2.0	0.2	01		▲	▲	▲	▲	▲	▲
<b>S224.0250.D2</b>	2.5	0.2	02			▲	▲	▲	▲	▲
<b>S224.0300.D2</b>	3.0	0.2	03		▲	▲	▲	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks					P	•	•	•	•	•
● 主要应用 / main recommendation					M	•	•	•	•	○
○ 可选推荐 / alternative recommendation					K	•	•	•	•	•
■ 无涂层牌号 / uncoated grades					N	•	•	•	•	•
■ 涂层牌号 / coated grades					S	•	•	•	•	○
■ 钎焊/金属陶瓷 / brazed/Cermet					H	•	•	•	•	•

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

## 切槽和切断

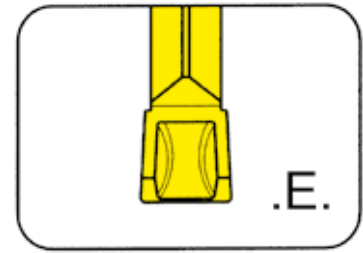
## GROOVING and PARTING OFF



## 可转位刀片 型号

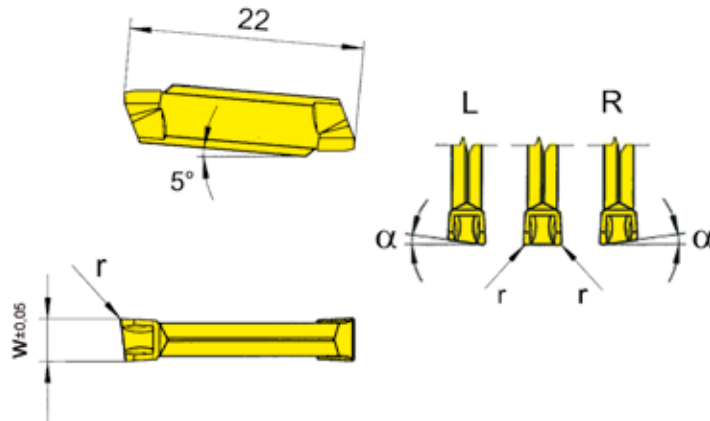
INDEXABLE INSERT Type

## S224

带断屑槽  
with chip former槽深可达  
槽宽Depth of groove up to  
Width of groove18.0 mm  
2.0 - 3.0 mm

精密烧结

precision sintered



配合 刀杆

for use with Toolholder

型号 H224

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	规格 Size	TN35	TI22	TI25	TF43	TF45	AS62
					S224.0200.E2 R/LS224.0520.E2	2.0	0.2	0° 5°	01	
S224.0250.E2 R/LS224.0525.E2	2.5	0.2	0° 5°	02				▲	▲	▲
S224.0300.E2 S224.0300.E4 R/LS224.0530.E2	3.0	0.2 0.4 0.2	0° 0° 5°	03		▲	▲	▲	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	●	●	●	●	●
M		●		●	
K		●		●	
N			●		●
S			●		●
H					

硬质合金牌号

Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

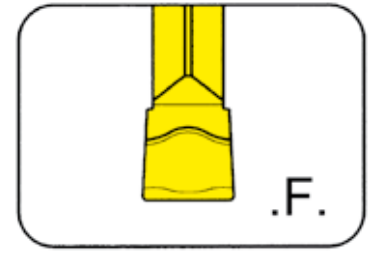


### 可转位刀片 型号

INDEXABLE INSERT Type

### S224

带断屑槽  
with chip forming

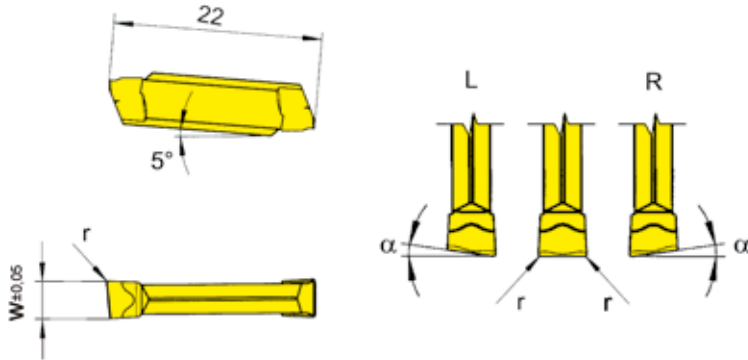


槽深可达  
槽宽

Depth of groove up to 18.0 mm  
Width of groove 2.0 - 3.0 mm

配合 刀杆  
for use with Toolholder

型号 H224  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	规格 Size	TN35	TI22	TI25	TF43	TF45	TF46
S224.0200.F2 R/LS224.0520.F2	2.0	0.2	0° 5°	01		▲	▲	▲	▲	▲/▲
S224.0250.F2 R/LS224.0525.F2	2.5	0.2	0° 5°	02		▲		△	▲	△
S224.0300.F2 R/LS224.0530.F2	3.0	0.2	0° 5°	03			▲	▲	▲	▲
					P	●	●	●	●	●
					M		●		●	○
					K		●		●	●
					N		●		●	●
					S		●		●	○
					H					

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

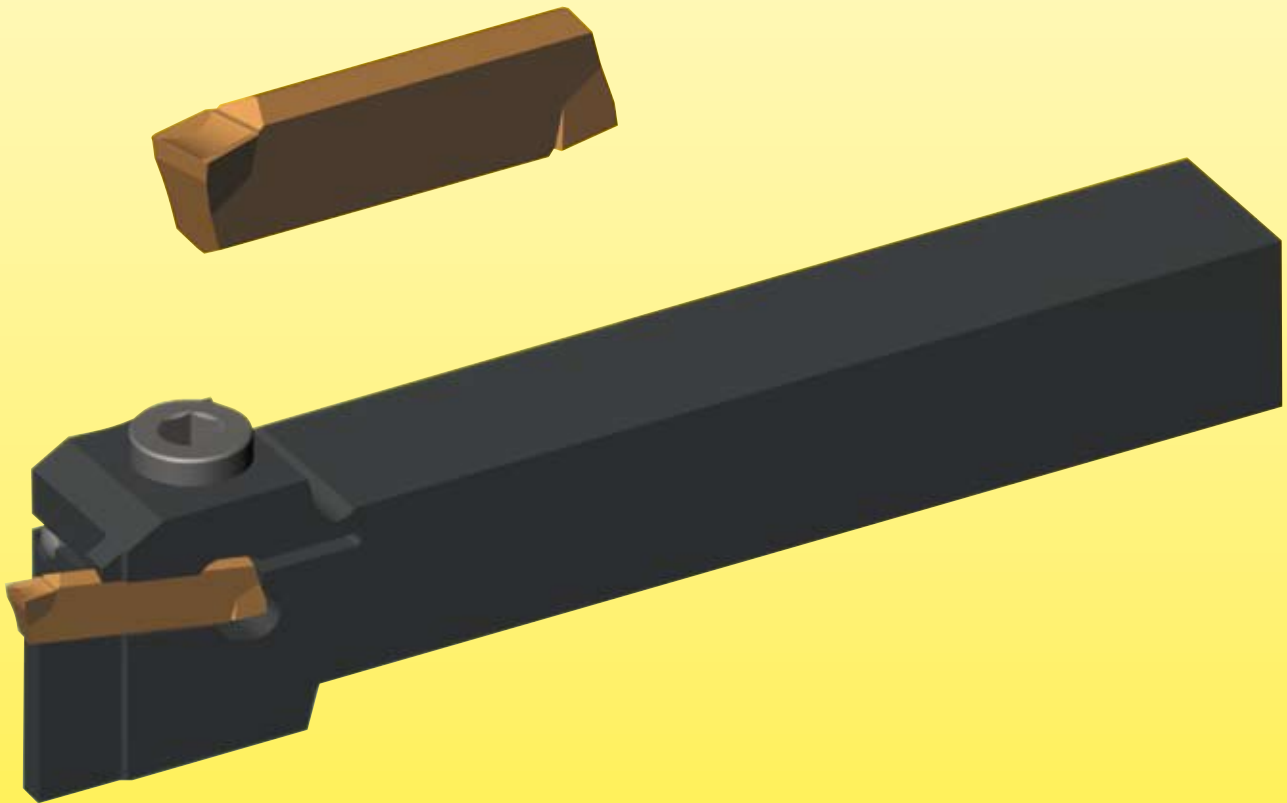
注明R或L型  
State R or L version

此可转位刀片可用于右手和左手型刀杆  
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号  
Carbide grades

可转位刀片 型号 S229  
带断屑槽  
- 精密烧结 -

Indexable Insert type S229  
with chip forming  
- precision sintered -



槽宽 3 - 5 mm  
槽深 可达 25 mm

Width of groove 3 - 5 mm  
Depth of groove up to 25 mm

## 切槽和切断

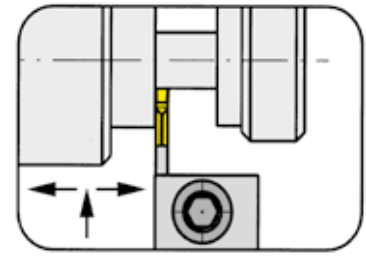
## GROOVING and PARTING OFF



## 刀杆 型号

218

TOOLHOLDER Type

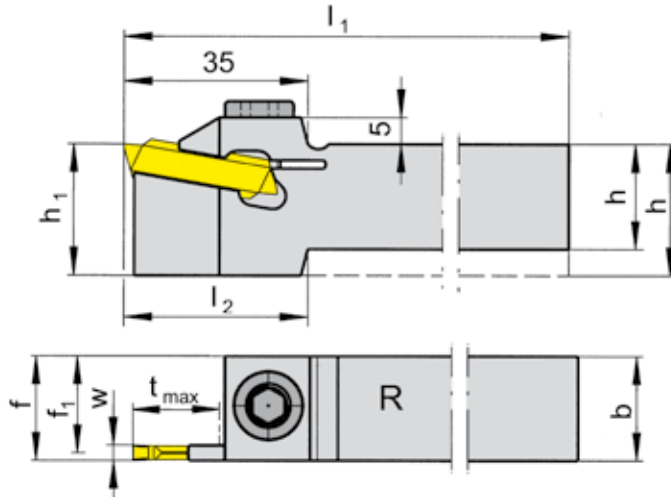
槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
3.0 - 5.0 mm

配合 可转位刀片

for use with Indexable insert

型号 229

Type S229



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$h_1$	f	$f_1$	$l_2$	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L218.1616.03	16	16	150	25		14.55	45			
R/L218.2020.03	20	20	150	25	$f_1+w/2$	18.55	35	18	03	3.0 - 4.0
R/L218.2525.03	25	25	150	25		23.55	-			
R/L218.3225.03	32	25	170	32		23.55	-			
R/L218.2020.04	20	20	150	25		17.70	35			
R/L218.2525.04	25	25	150	25	$f_1+w/2$	22.70	-	18	04	4.0 - 5.0
R/L218.3225.04	32	25	170	32		22.70	-			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

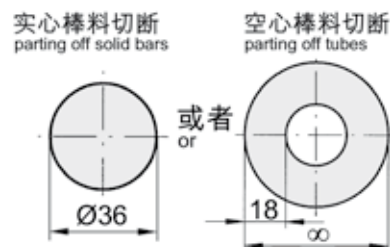
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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



## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L218....	218.3	SW6.0DIN911

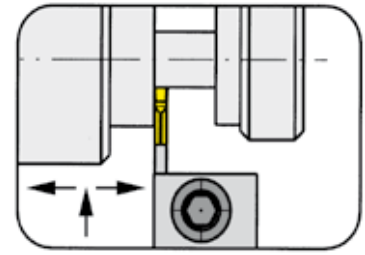
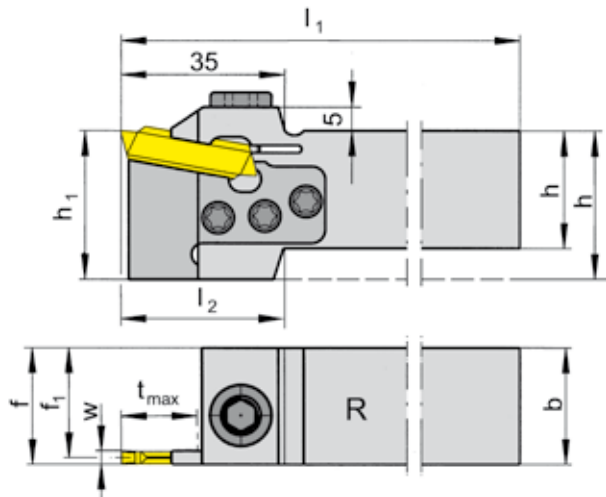
## 切槽和切断

## GROOVING and PARTING OFF



## 常规刀杆 型号

BASIC TOOLHOLDER Type

**218**带可换刀夹  
with changeable cassette槽深可达  
夹持范围Depth of groove up to  
Clamping range18.0 mm  
3.0 - 5.0 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 229

Type S229

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L218.2525.K3	25	25	150	32	f <sub>1</sub> +w/2	23.55	35	18	03	3.0 - 4.0
R/L218.3225.K3	32	25	170	32	f <sub>1</sub> +w/2	23.55	-	18	03	3.0 - 4.0
R/L218.2525.K4	25	25	150	32	f <sub>1</sub> +w/2	22.70	35	18	04	4.0 - 5.0
R/L218.3225.K4	32	25	170	32	f <sub>1</sub> +w/2	22.70	-	18	04	4.0 - 5.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

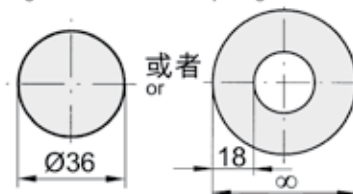
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

实心棒料切断  
parting off solid bars空心棒料切断  
parting off tubes

## 附件

Spare parts

常规刀杆 Basic toolholder	刀夹 Cassette	螺钉 Screw	螺钉 Screw	扳手 Wrench	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L218....K3	NK218.32.03	030.0518.T20P	218.3	SW6,0DIN911	T20PQ
R/L218....K4	NK218.32.04	030.0518.T20P	218.3	SW6,0DIN911	T20PQ



## 切槽和切断

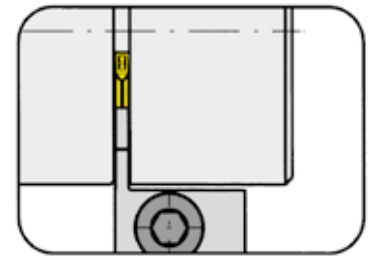
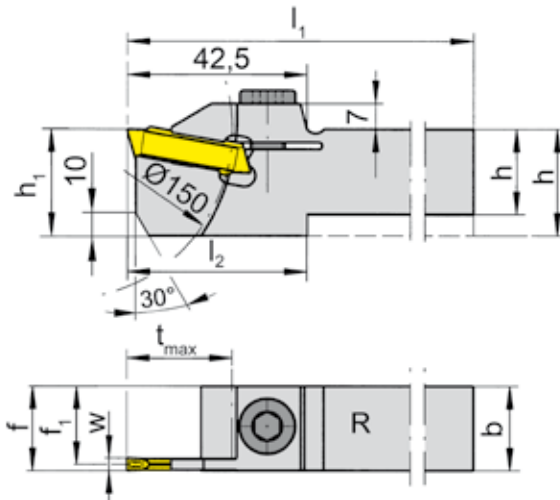
## GROOVING and PARTING OFF



## 刀杆 型号

226

TOOLHOLDER Type

槽深可达  
夹持范围Depth of groove up to  
Clamping range25.0 mm  
3.0 - 5.0 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 可转位刀片

for use with Indexable insert

型号 229

Type S229

产品型号 Part number	h	b	$l_1$	$h_1$	f	$f_1$	$l_2$	$t_{max}$	规格 Size	夹持范围 Clamping range
R/L226.1616.03	16	16	150			18.55	52.5			
R/L226.2020.03	20	20	150	32	$f_1+w/2$	18.55	42.5	25	03	3.0 - 4.0
R/L226.2525.03	25	25	150			23.55	-			
R/L226.3225.03	32	25	170			23.55	-			
R/L226.1616.04	16	16	150			13.70	52.5			
R/L226.2020.04	20	20	150	32	$f_1+w/2$	17.70	42.5	25	04	4.0 - 5.0
R/L226.2525.04	25	25	150			22.70	-			
R/L226.3225.04	32	25	170			22.70	-			

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

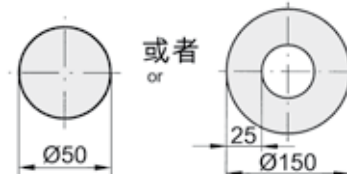
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

实心棒料切断  
parting off solid bars空心棒料切断  
parting off tubes

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/L226....	218.3	SW6.0DIN911

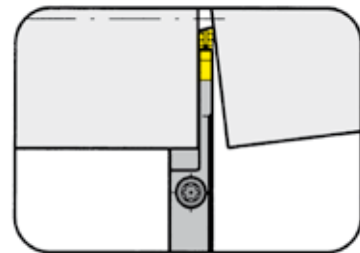
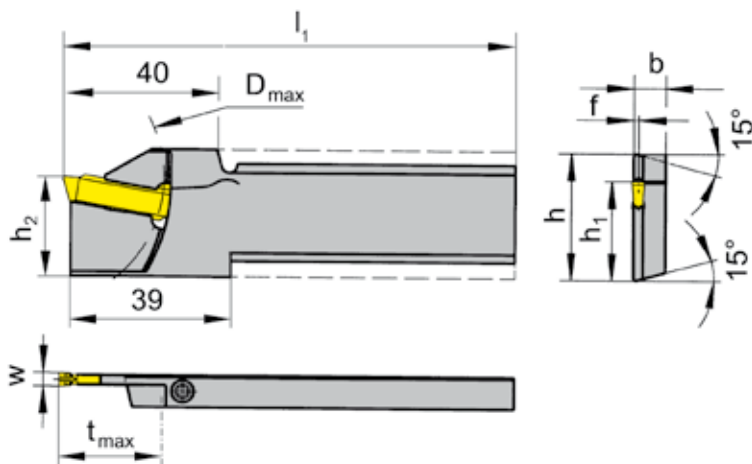
## 切槽和切断

## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

**226**加强型  
reinforced version槽深可达  
夹持范围Depth of groove up to  
Clamping range25.0 mm  
3.0 - 4.0 mm配合 可转位刀片  
for use with Indexable insert型号 S229  
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	h <sub>2</sub>	f	t <sub>max</sub>	D <sub>max</sub>	规格 Size	夹持范围 Clamping range
R/L226-2608-03	26	8	110	21.4	24.8	1.2	25	150	03	3
R/L226-3208-03	32	8	110	24.8	24.8	1.2	25	150	03	3
R/L226-2608-04	26	8	110	21.4	24.8	1.7	25	150	04	4
R/L226-3208-04	32	8	110	24.8	24.8	1.7	25	150	04	4

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位: mm

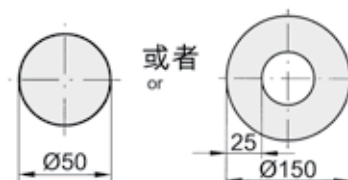
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

实心棒料切断  
parting off solid bars空心棒料切断  
parting off tubes

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L226....	4.15T15P	T15PQ

# 切断

## PARTING OFF

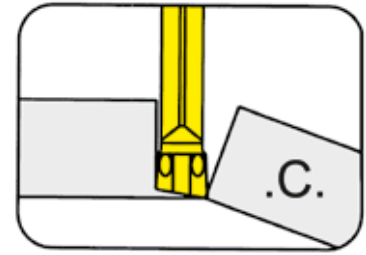


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming



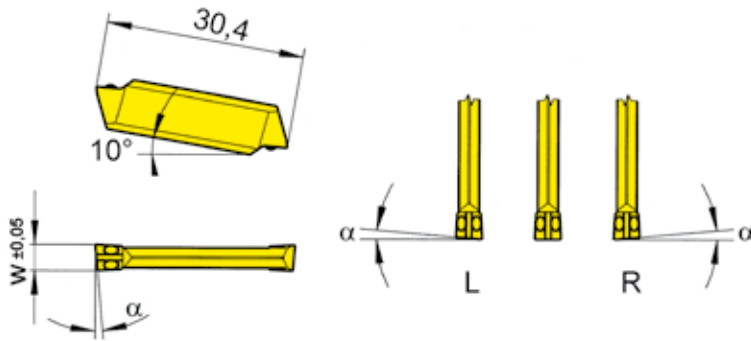
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.025mm

Indexability length ± 0,025 mm

产品型号 Part number	w	α	规格 Size	TN35	TI25	TF45
R/LS229.0530.C0 R/LS229.0830.C0 S229.0030.C0	3	5° 8° 0°	03	▲/▲ ▲/▲ ▲	△/△ ▲/▲ ▲	▲/▲ ▲/▲ ▲
R/LS229.0540.C0 R/LS229.0840.C0 S229.0040.C0	4	5° 8° 0°	03 / 04	▲/△ ▲/△ ▲	△/△ ▲/△ ▲	

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H			

硬质合金牌号  
Carbide grades

# 切断

## PARTING OFF

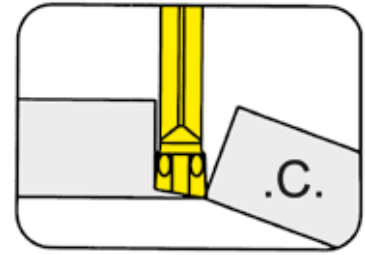


### 可转位刀片 型号

INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming



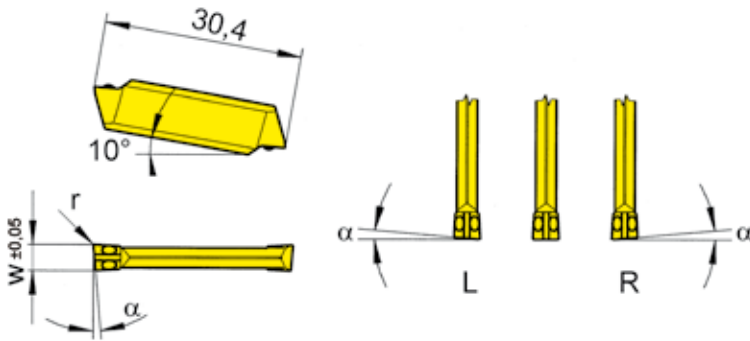
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度  
±0.025mm

Indexability length ± 0,025 mm

产品型号 Part number	w	r	α	规格 Size	TN35	TI25	TF45
R/LS229.0530.C1 R/LS229.0830.C1 S229.0030.C1	3	0.15	5° 8° 0°	03	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲	▲ ▲ ▲
R/LS229.0540.C1 R/LS229.0840.C1 RS2290540.C1 S229.0040.C1	4	0.15	5° 8° 5° 0°	03 / 04	▲/▲ ▲/▲ ▲	▲/▲ ▲/▲ ▲	▲ ▲ ▲

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H	●	●	●

硬质合金牌号  
Carbide grades

# 切断

## PARTING OFF

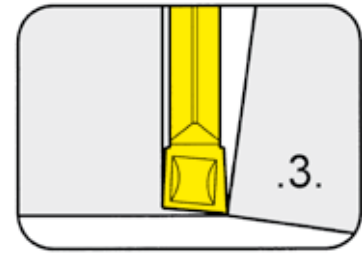


### 可转位刀片 型号

INDEXABLE INSERT Type

## 229/S229

带断屑槽  
with chip former



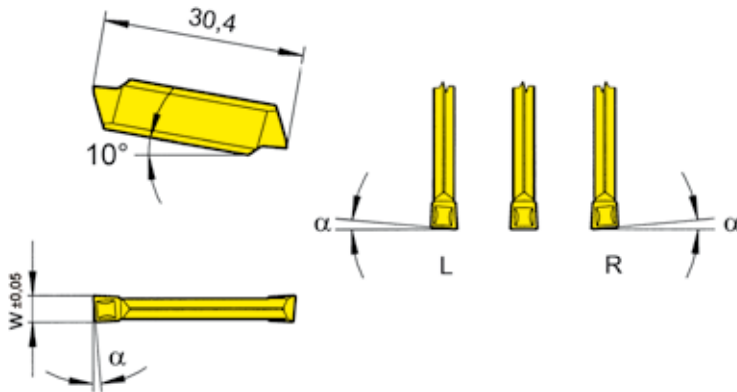
槽深可达  
槽宽

Depth of groove up to  
Width of groove

25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

长度重复定位精度  
±0.04 mm

Indexability length  
± 0,04 mm

产品型号 Part number	w	α	规格 Size	MG12	H54	TN32	TN35	TI22	TI25	TF45	AS62
R/L229.5300.31	3	5°	03	▲/▲		▲/▲	▲/▲		▲/▲		▲/▲
R/LS229.0530.32		5°		▲/▲		▲/▲		▲/▲	▲/▲	▲/▲	
S229.0300.32		0°		▲	▲	▲	▲	▲	▲	▲	
R/LS229.0540.32	4	5°	03 / 04			▲/▲			▲/▲	▲/▲	▲/▲
S229.0400.32		0°		▲	▲	▲	▲	▲	▲	▲	▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P	○	●	●	●	●	●	●
● 主要应用 / main recommendation				M	●	●	●	●	●	●	●
○ 可选推荐 / alternative recommendation				K	●	●	●	●	●	●	●
■ 无涂层牌号 / uncoated grades				N	●	●	●	●	●	●	●
■ 涂层牌号 / coated grades				S	●	●	●	●	●	●	●
■ 钎焊/金属陶瓷 / brazed/Cermet				H							

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R/L229.5300.31精密磨削, 长度30.0mm

Note:

R/L229.5300.31 **precision ground**, length 30,0 mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

## 切槽和切断

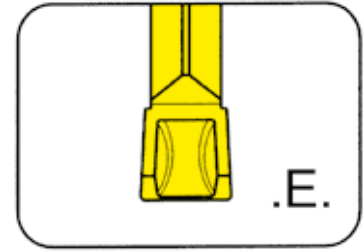
## GROOVING and PARTING OFF



## 可转位刀片 型号

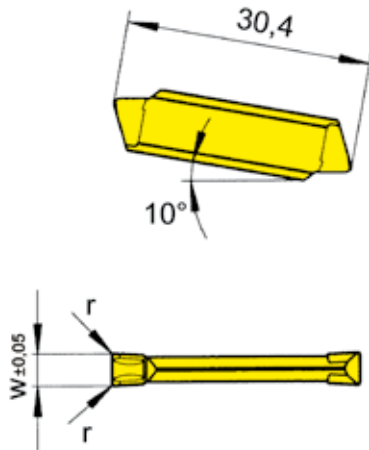
INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	硬质合金牌号			
				TN35	TI25	TF45	TF46
S229.0300.E2 S229.0300.E4	3	0.2 0.4	03		▲	▲	▲
S229.0400.E2 S229.0400.E4	4	0.2 0.4	03 / 04		▲	▲	▲
				P	•	•	•
				M	•	•	○
				K	•	•	•
				N	•	•	•
				S	•	•	○
				H			

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号

Carbide grades

## 切槽和切断

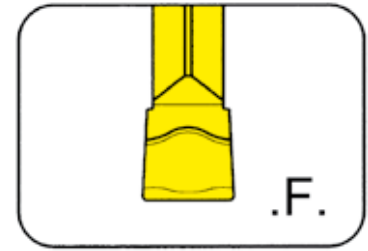
## GROOVING and PARTING OFF



## 可转位刀片 型号

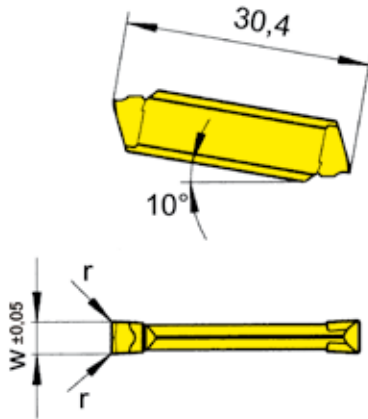
INDEXABLE INSERT Type

## S229

带断屑槽  
with chip forming槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
3.0 - 4.0 mm

精密烧结

precision sintered

刀片长度重复定位精度  
±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	规格 Size	Tl22	Tl25	TF43	TF45	TF46
S229.0300.F2	3	0.2	03	▲		▲	▲	▲
S229.0300.F4		0.4				▲	▲	
S229.0400.F2	4	0.2	03 / 04				▲	△
S229.0400.F4		0.4					▲	
▲ 库存 / on stock    △ 4周 / 4 weeks				P	•	•	•	•
● 主要应用 / main recommendation				M			•	○
○ 可选推荐 / alternative recommendation				K			•	•
■ 无涂层牌号 / uncoated grades				N			•	•
■ 涂层牌号 / coated grades				S			•	○
■ 钎焊/金属陶瓷 / brazed/Cermet				H				

尺寸单位 : mm

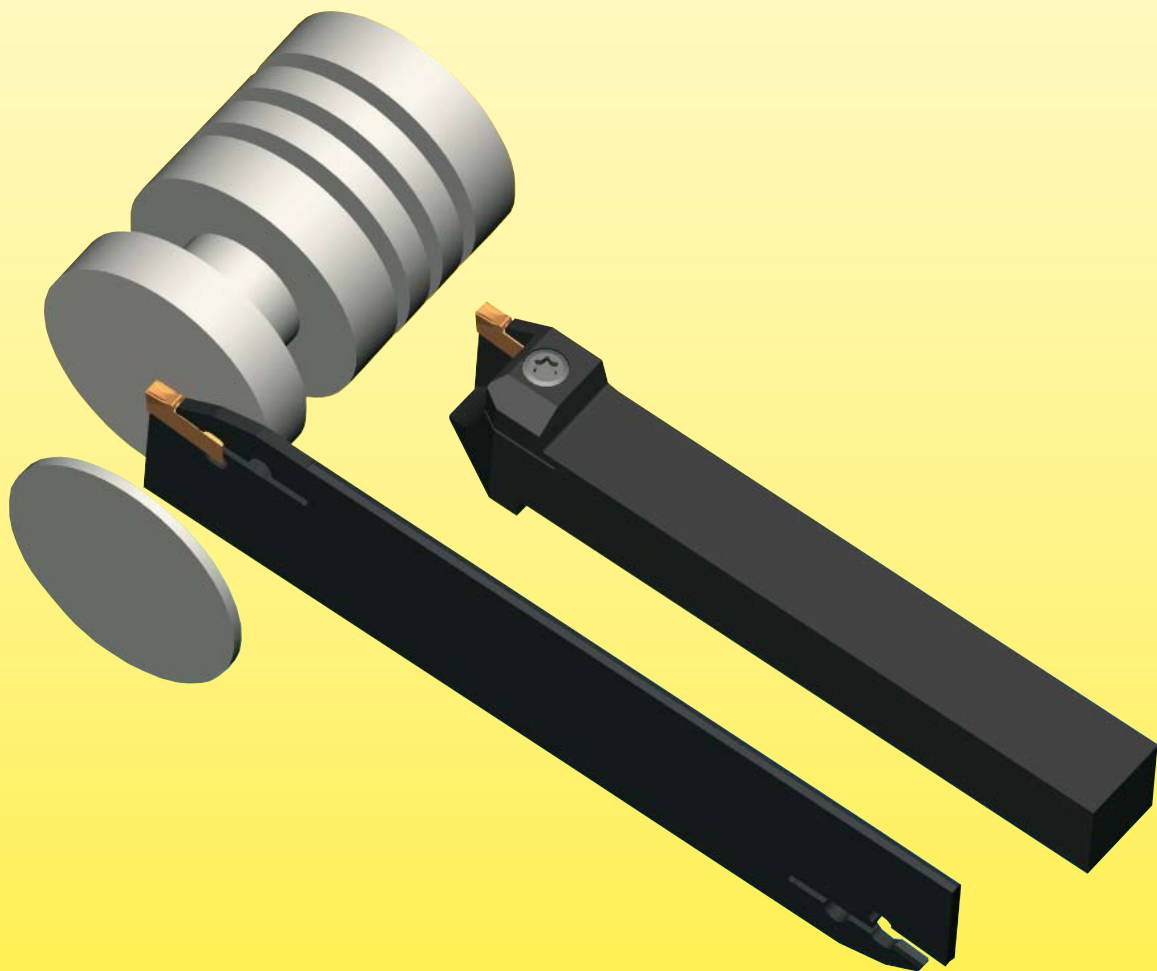
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left hand** toolholders.硬质合金牌号  
Carbide grades

刀体 型号 H100  
- 螺钉锁紧或自夹紧 -

CUTTER BODY type H100  
- with screwed or self clamping -



槽宽 2 - 5 mm  
槽深 可达 55 mm

Width of groove 2 - 5 mm  
Depth of groove up to 55 mm



## 切槽和切断

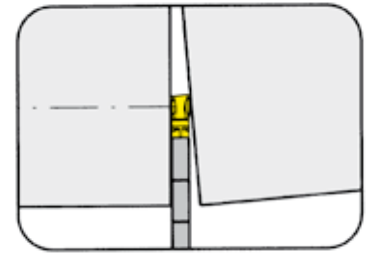
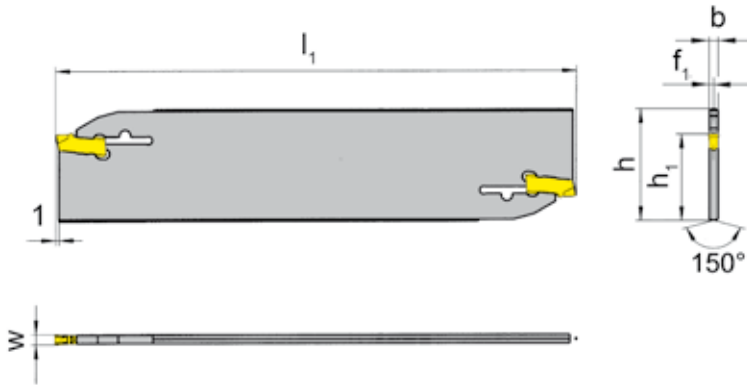
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

自锁紧  
with self clamping槽深可达  
槽宽Depth of groove up to  
Width of groove55.0 mm  
2.0 - 5.0 mm

配合 刀片

for use with Insert

型号 S100

Type

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
H100.2601.01	26	1.5	110	21.4	0.75	25.0	50	01
H100.3201.01	32		150	24.8				
H100.2602.02	26	1.9	110	21.4	0.95	37.5	75	02
H100.3202.02	32		150	24.8				
H100.2603.03	26	2.3	110	21.4	1.15	37.5	75	03
H100.3203.03	32		150	24.8				
H100.2604.04	26	3.1	110	21.8	1.65	40.0	80	04
H100.3204.04	32		160	24.8				
H100.3205.05	32	3.9	160	24.8	2.00	55.0	110	05

按需提供更多尺寸  
Further sizes upon requestw见刀片  
w see inserts尺寸单位：mm  
Dimensions in mm

## 注意事项：

扳手P39L不包含在刀板中，需单独订购！

## Note:

Wrench P39L ist not combined with blade - separate order required!



## 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
H100....	P39L

## 切槽和切断

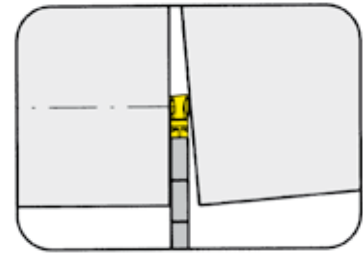
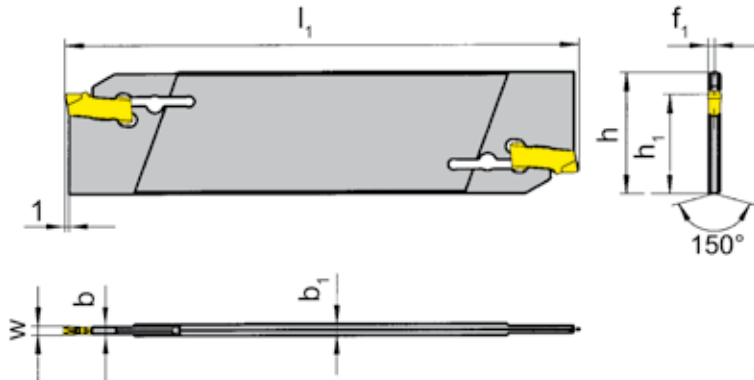
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

自锁紧  
with self clamping槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
2.0 - 2.5 mm

配合 刀片

for use with Insert

型号 S100

Type

产品型号 Part number	h	b	$l_1$	$h_1$	$b_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size
H100.2603.01	26	1.5	110	21.4	2.3	1.15	21	42	01
H100.3203.01	32		150	24.8			25	50	
H100.2603.02	26	1.9	110	21.4	2.3	1.15	21	42	02
H100.3203.02	32		150	24.8			25	50	

按需提供更多尺寸  
Further sizes upon request

w见刀片  
w see inserts

尺寸单位：mm  
Dimensions in mm

## 注意事项：

扳手P39L不包含在刀板中，需单独订购！

## Note:

Wrench P39L ist not combined with blade - separate order required!



## 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
H100....	P39L

## 切槽和切断

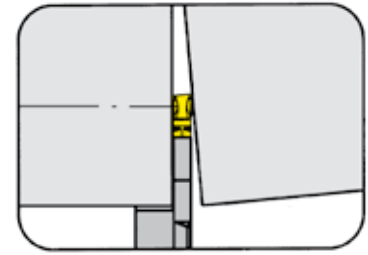
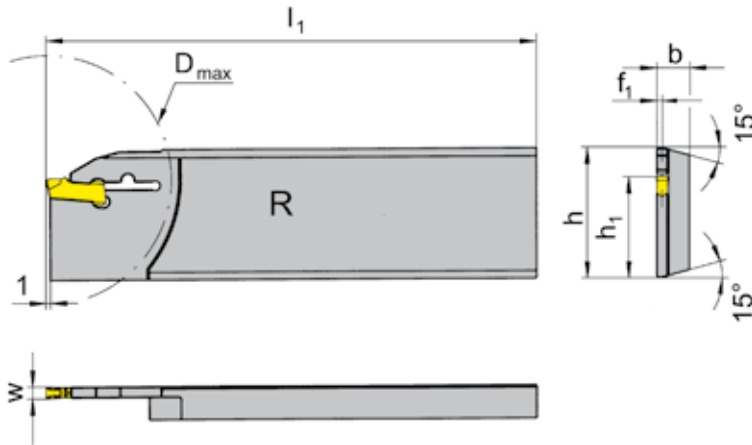
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

自锁紧  
with self clamping槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
2.0 - 4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH100.2608.31	26	7.9	110	21.4	0.75	21.0	42	01
R/LH100.3208.31	32		112	24.8		25.0	50	
R/LH100.2608.32	26	7.9	110	21.4	0.95	25.0	50	02
R/LH100.3208.32	32		112	24.8		32.5	65	
R/LH100.2608.33	26	7.9	110	21.4	1.15	25.0	50	03
R/LH100.3208.33	32		112	24.8		32.5	65	
R/LH100.2608.34	26	7.9	110	21.4	1.55	25.0	50	04
R/LH100.3208.34	32		112	24.8		32.5	65	

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

Wrench P39L ist not combined with blade - separate order required!



推荐用于Traub系列机床

Recommended for Traub machines type:

R/L100.2608.31-34

R/LH100.3208.31-34

TNC 30  
TNM 28  
TNS 26  
TNS 30/42  
TNA 300  
TNK 28/36  
TNL 26TNC 42/65  
TNM 42/65  
TNS 65  
TNS 60  
TNA 400  
TNA 300

附件

Spare parts

刀杆 Toolholder	扳手 Wrench
R/LH100....	P39L

## 切槽和切断

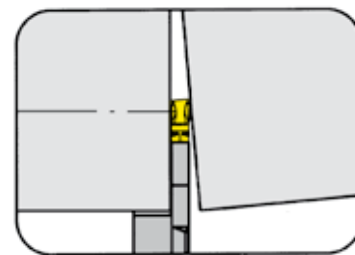
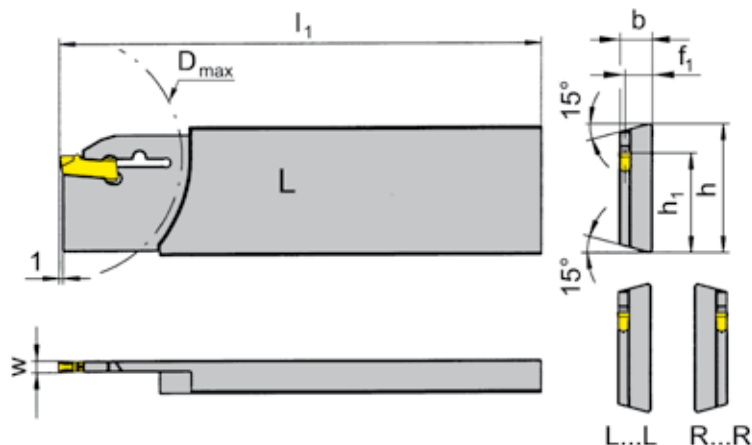
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

自锁紧  
with self clamping槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
2.0 - 4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH100.2608.31R/L	26	7.9	110	21.4	7.15	21.0	42	01
R/LH100.3208.31R/L	32		112	24.8		25.0	50	
R/LH100.2608.32R/L	26	7.9	110	21.4	6.95	25.0	50	02
R/LH100.3208.32R/L	32		112	24.8		32.5	65	
R/LH100.2608.33R/L	26	7.9	110	21.4	6.75	25.0	50	03
R/LH100.3208.33R/L	32		112	24.8		32.5	65	
R/LH100.2608.34R/L	26	7.9	110	21.4	6.35	25.0	50	04
R/LH100.3208.34R/L	32		112	24.8		32.5	65	

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项:

扳手P39L不包含在刀板中, 需单独订购!

Note:

Wrench P39L ist not combined with blade - separate order required!



附件

Spare parts

刀杆 Toolholder	扳手 Wrench
R/LH100....	<b>P39L</b>

# 切槽和切断

## GROOVING and PARTING OFF

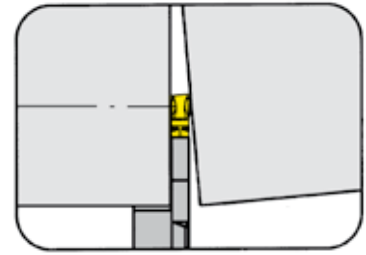


### 刀杆 型号

TOOLHOLDER Type

## H100

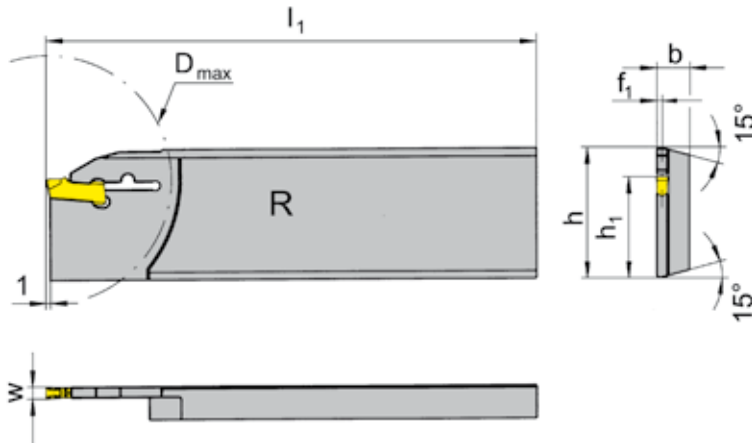
自锁紧  
with self clamping



槽深可达  
槽宽

Depth of groove up to  
Width of groove

41.0 mm  
4.0 mm



配合 刀片

for use with Insert

型号 S100

Type

R=右手型

R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size
<b>RH100.3208.2.44</b>	32	7.9	160	24.8	1.55	41	80	04
<b>RH100.3208.44</b>			130					

按需提供更多尺寸  
Further sizes upon request

w见刀片  
w see inserts

尺寸单位：mm  
Dimensions in mm

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

Wrench P39L ist not combined with blade - separate order required!



### 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
RH100.3208....	<b>P39L</b>

## 切槽和切断

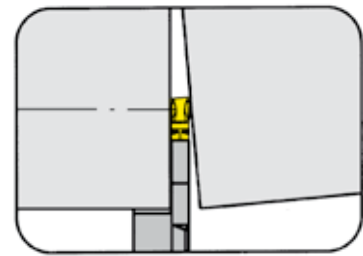
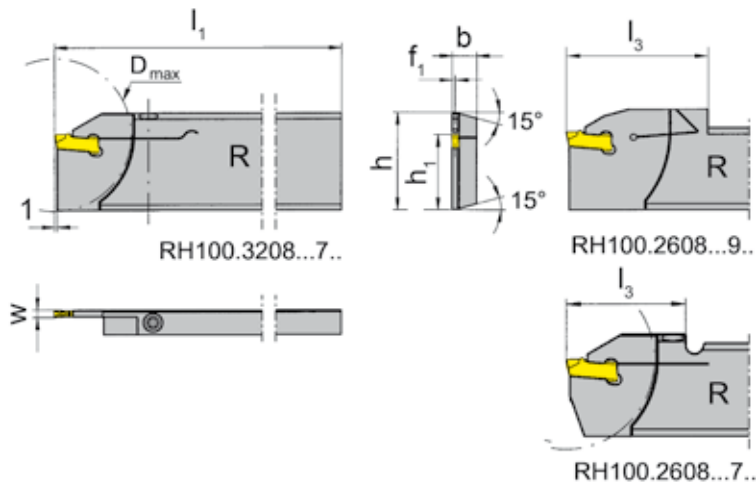
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
2.0 - 3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size
R/LH100.2608.71	26	7.9	110	33.8	21.4	0.75	25.0	50	01
R/LH100.3208.71	32		112		24.8				
R/LH100.2608.72	26	7.9	110	33.8	21.4	0.95	25.0	50	02
R/LH100.3208.72	32		112		24.8				
R/LH100.2608.93	26	8.0	112	40.0	21.4	1.15	25.0	50	03
R/LH100.3208.93	32				24.8				

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	销 Pin
R/LH100....71/72	<b>4.15T15P</b>	<b>T15PQ</b>	<b>020.0040.0999</b>
R/LH100....93	<b>030.0413.T15P</b>	<b>T15PQ</b>	

## 切槽和切断

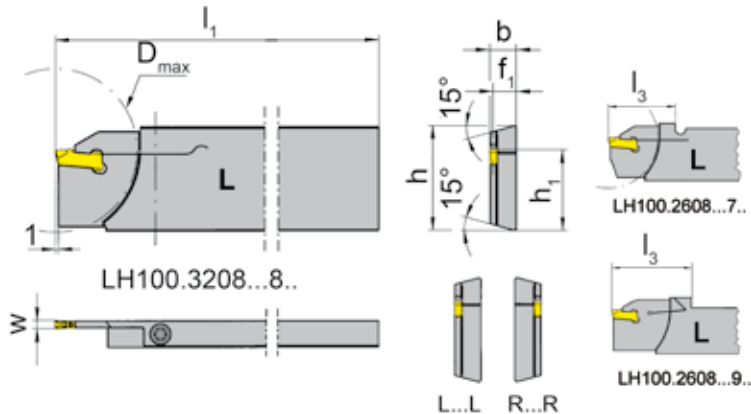
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
2.0 - 3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size
R/LH100.2608.71R/L R/LH100.3208.71R/L	26 32	7.9	110 112	33.8	21.4 24.8	7.15	25.0	50	01
R/LH100.2608.72R/L R/LH100.3208.72R/L	26 32	7.9	110 112	33.8	21.4 24.8	6.95	25.0	50	02
R/LH100.2608.93R/L R/LH100.3208.93R/L	26 32	8.0	115 112	40.0 42.0	21.4 24.8	6.85	25.0 32.5	50 65	03

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	销 Pin
R/LH100.....71R/L/72R/L R/LH100.....93R/L	4.15T15P 030.0413.T15P	T15PQ T15PQ	020.0040.0999

## 切槽和切断

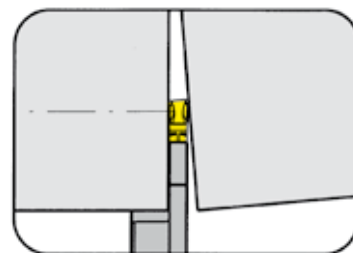
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

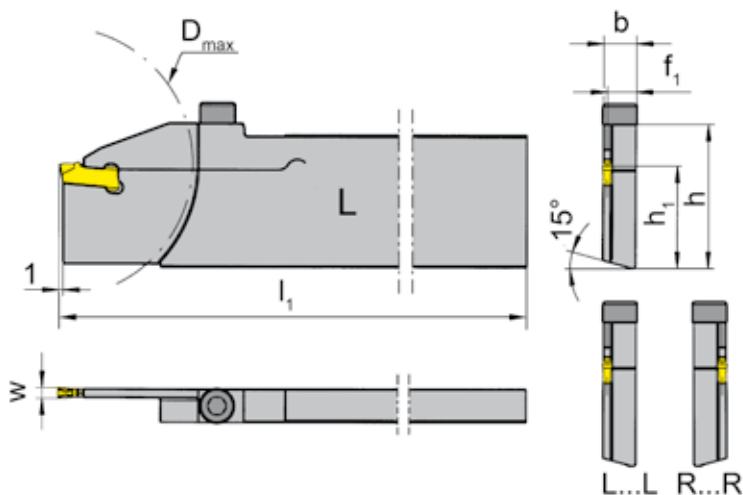
槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
3.0 - 4.0 mm用于TRAUB ( TNX65 ) 机床  
for machines TRAUB (TNX65)

配合 刀片

for use with Insert

型号 S100

Type



L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	$l_1$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size
R/LH100.3280.73R/L	32	7.9	130	24.8	6.75	32.5	65	03
R/LH100.3280.74R/L	32	7.9	130	24.8	6.35	32.5	65	04

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	扳手 Wrench
R/LH100.3280.7...	DIN912-M5x20	SW4.0DIN911



## 切槽和切断

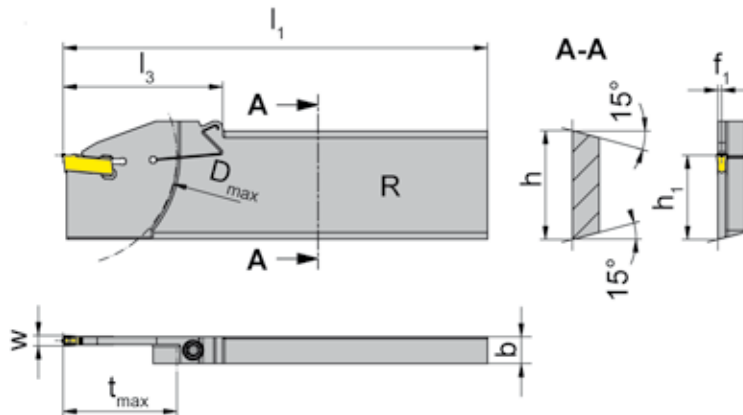
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove33.5 mm  
3.0 - 4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

适用于TRAUB和INDEX  
机床

for machines TRAUB and INDEX

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	规格 Size	机床型号 Type of machine
R/LH100.3208.83 LH100.3208.15.83	32	8	125 150	47	24.8	1.15	33.5	65	03	TraubTNX65/42.IndexC65
R/LH100.3208.84 LH100.3208.15.84	32	8	125 150	47	24.8	1.50	33.5	65	04	TraubTNX65/42.IndexC65

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH100.3208...	030.505P.0718	T15PQ

## 切槽和切断

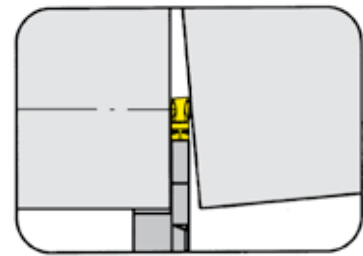
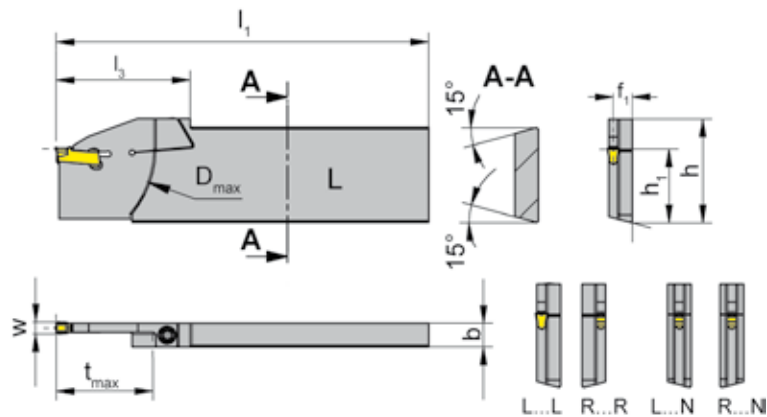
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove41.0 mm  
3.0 - 4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

适用于TRAUB和INDEX  
机床

for machines TRAUB and INDEX

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	$f_1$	$t_{max}$	$D_{max}$	规格 Size	机床型号 Type of machine
R/LH100.3208.83R/L	32	8	125	47.0	24.8	6.75	33.5	65	03	TraubTNX65/42.IndexC65
R/LH100.3208.83N	32	8	125	47.0	24.8	4.00	33.5	65	03	TraubTNX65/42.IndexC65
R/LH100.3208.84R/L	32	8	125	47.0	24.8	6.35	33.5	65	04	TraubTNX65/42.IndexC65
R/LH100.3208.84N	32	8	134	54.5	24.8	4.00	41.0	80	04	TraubTNX80/65

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH100.3208.8...	030.505P.0660	T15PQ

## 切槽和切断

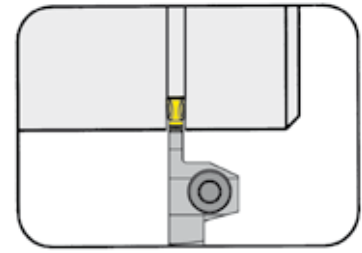
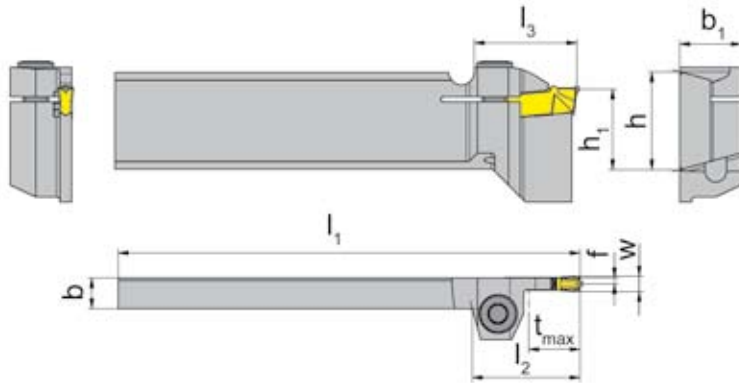
## GROOVING and PARTING OFF



## 刀杆 型号

H100

TOOLHOLDER Type

槽深可达  
槽宽Depth of groove up to  
Width of groove10.0 mm  
3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

L=左手型-如图

L = left hand version shown

适用于  
for

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	f	$t_{max}$	规格 Size
<b>LH100.1908.R.13</b>	19	6	90	20	15.7	1.15	10	03

按需提供更多尺寸  
Further sizes upon request

w见刀片  
w see inserts

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LH100.1908.R.13	<b>5.17T20P</b>	<b>T20PQ</b>

## 切槽和切断

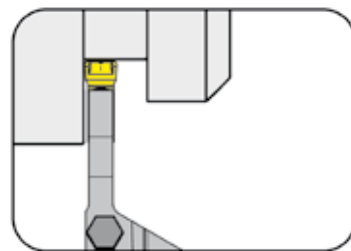
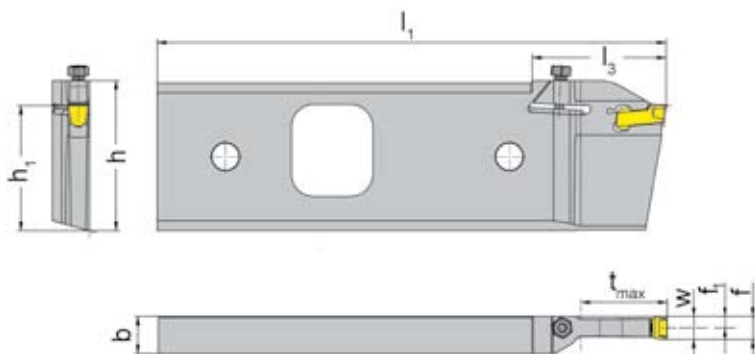
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove65.0 mm  
8.0 - 12.0 mm

配合 刀片

for use with Insert

型号 S100

Type

L=左手型-如图

L = left hand version shown

适用于  
for

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	规格 Size
LH100.5517.38.8.08 LH100.5517.54.8.08	65	16.4	224	59 75	55	4	$f_1+w/2$	38 54	08
LH100.5517.38.8.10 LH100.5517.54.8.10	65	16.4	224	59 75	55	5	$f_1+w/2$	38 54	10
LH100.5517.44.8.12 LH100.5517.65.8.12	65	16.4	224	65 86	55	6	$f_1+w/2$	44 65	12

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
LH100.5517....	030.6075.T20P	T20PQ

## 切槽和切断

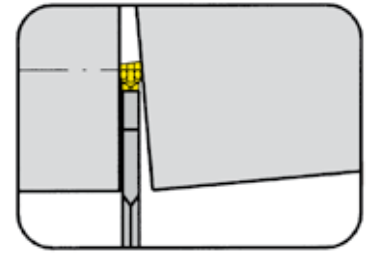
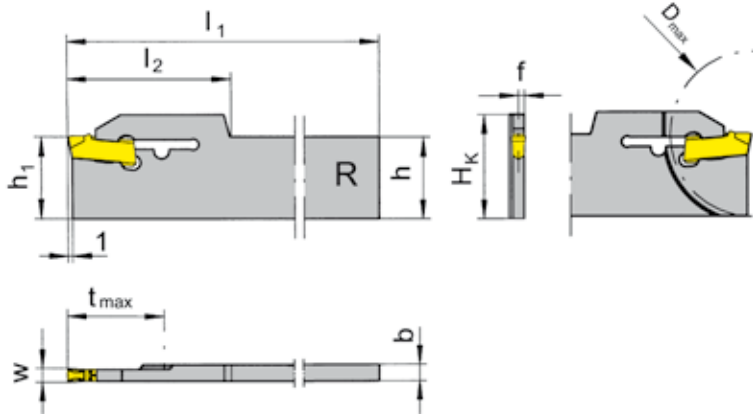
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

自锁紧  
with self clamping槽深可达  
槽宽Depth of groove up to  
Width of groove38.0 mm  
2.0 - 3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型

R = right hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$h_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size
RH100.1703.21	17.4	3.2	110	32.0	17.4	0.75	17.5	35	22.1	01
RH100.2203.21	22.1		150		22.2		38.0		26.9	
RH100.1703.33	17.4	3.2	110	34.5	17.4	1.15	30.0	60	22.1	03
RH100.2203.33	22.1		150		22.2		38.0		26.9	

按需提供更多尺寸  
Further sizes upon requestw见刀片  
w see inserts尺寸单位：mm  
Dimensions in mm

## 注意事项：

扳手P39L不包含在刀板中，需单独订购！

## Note:

Wrench P39L ist not combined with blade - separate order required!



## 附件

Spare parts

刀杆 Toolholder	扳手 Wrench
RH100....	P39L

## 切槽和切断

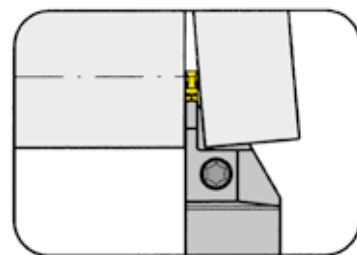
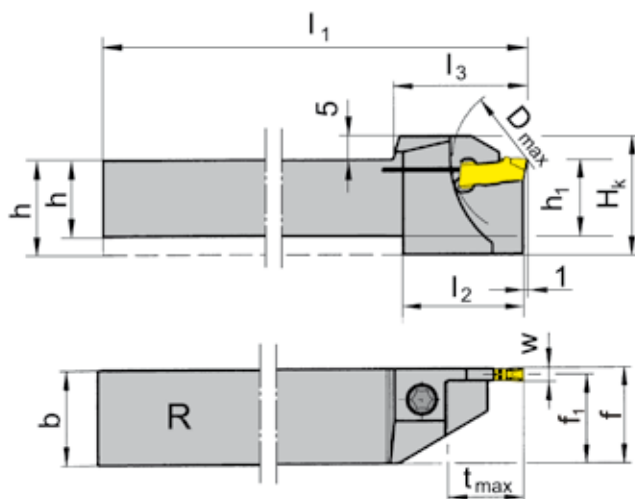
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove21.0 mm  
2.0 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合 刀片

for use with Insert

型号 S100

Type

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_K$	规格 Size
R/LH100.1010.01 R/LH100.1010.11	10	10	125	19 21	21.0 23.0	10	9.25	$f_1+w/2$	10.5 13.0	21 42	18 21	01
R/LH100.1212.01 R/LH100.1212.11	12	12	125	21	23.0 26.0	12	11.25	$f_1+w/2$	13.0 16.0	26 42	21	01
R/LH100.1616.11 R/LH100.1616.21	16	16	125	24 30	26.0 33.5	16	15.25	$f_1+w/2$	16.0 21.0	42	25	01
R/LH100.2020.11 R/LH100.2020.21	20	20	125	-	33.5	20	19.25	$f_1+w/2$	16.0 21.0	42	25	01
R/LH100.2525.21	25	25	150	-	33.5	25	24.30	$f_1+w/2$	21.0	42	30	01

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH100....	4.15T15P	T15PQ

## 内冷型刀杆

Toolholder with through coolant supply

型号 **H100**  
type

冷却  
Coolant



## 切槽和切断

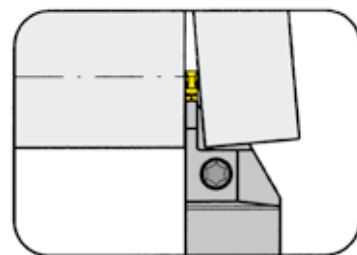
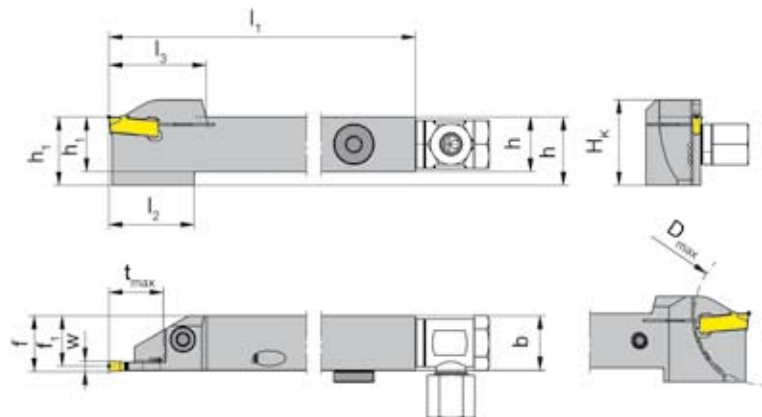
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

螺钉锁紧  
with screwed clamping槽深可达  
槽宽Depth of groove up to  
Width of groove21.0 mm  
2.0 mm

配合 刀片

for use with Insert

型号 S100

Type

带内冷

with through coolant supply

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	H <sub>k</sub>	规格 Size
R/LH100.1212.01.IK R/LH100.1212.11.IK	12	12	125	21	23.0 26.0	12	11.25	f <sub>1</sub> +w/2	13 16	26 42	21	01
R/LH100.1616.11.IK R/LH100.1616.21.IK	16	16	125	24 30	26.0 33.5	16	15.25	f <sub>1</sub> +w/2	16 21	42	25	01
R/LH100.2020.11.IK R/LH100.2020.21.IK	20	20	125	-	33.5	20	19.25	f <sub>1</sub> +w/2	16 21	42	25	01
R/LH100.2525.21.IK	25	25	150	-	33.5	25	24.30	f <sub>1</sub> +w/2	21	42	30	01

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH100....	4.15T15P	T15PQ	004.00.61



## 切槽和切断

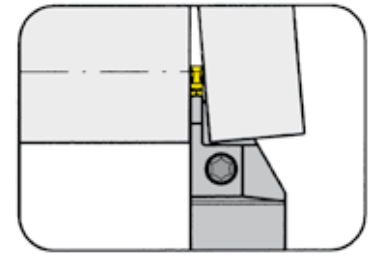
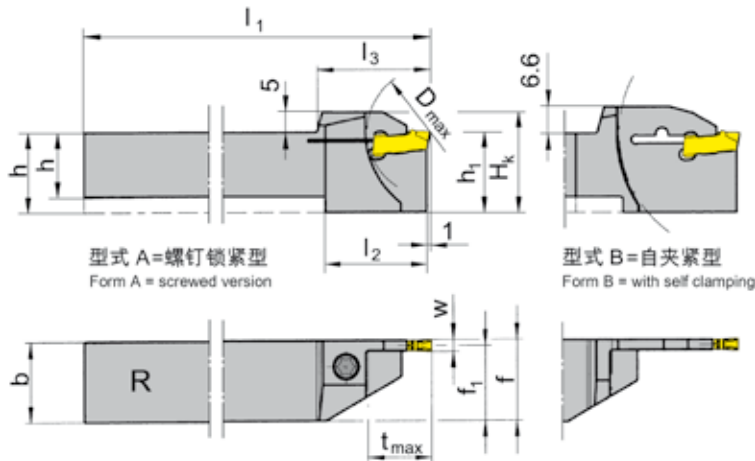
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
2.5 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_K$	规格 Size	自 Form
R/LH100.1212.02	12	12	125	21	23.0	16	11.05	$f_1+w/2$	13.0	25	21.0	02	A
R/LH100.1616.02	16	16		19	21.0	20	15.05		10.5	42	25.0		
R/LH100.1212.12	12	12	125	24	26.0	16	11.05	$f_1+w/2$	16.0	42	25.0	02	A
R/LH100.1616.12	16	16		24		20	15.05						
R/LH100.2020.12	20	20	-	-	-	20	19.05	-	-	-	-	-	-
R/LH100.1616.22	16	16	125	30	33.5	20	15.05	$f_1+w/2$	21.0	42	25.0	02	A
R/LH100.2020.22	20	20	125	-		20	19.05				25.0		
R/LH100.2525.22	25	25	150	-	-	25	24.05	-	-	-	30.0	-	-
R/LH100.2020.32	20	20	125	35	38.5	25	19.05	$f_1+w/2$	32.5	65	31.6	02	B

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade - separate order required!

螺丝的扭矩规格，详见技术说明。

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

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100....02/12/22 R/LH100.2020.32	4.15T15P	T15PQ	P39L



## 切槽和切断

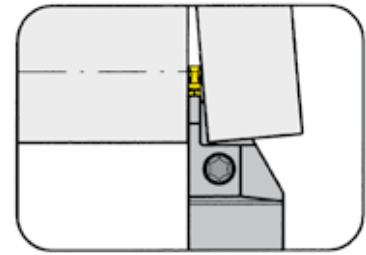
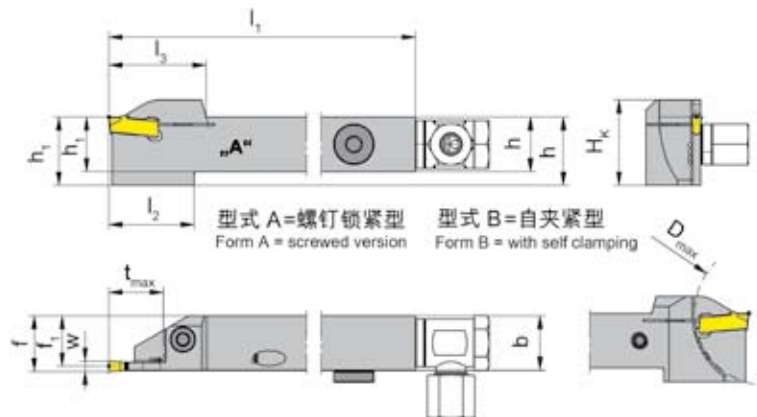
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove21.0 mm  
2.5 mm

配合 刀片

for use with Insert

型号 S100

Type

带内冷

with through coolant supply

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size	自 Form
R/LH100.1212.02.IK	12	12	125	21	23.0	16	11.05	$f_1+w/2$	13.0	25	21	02	A
R/LH100.1616.02.IK	16	16	125	19	21.0	20	15.05	$f_1+w/2$	10.5	42	25	02	A
R/LH100.1212.12.IK	12	12	125	24	26.0	16	11.05	$f_1+w/2$	16.0	42	25	02	A
R/LH100.1616.12.IK	16	16	125	24	26.0	20	15.05	$f_1+w/2$	16.0	42	25	02	A
R/LH100.2020.12.IK	20	20	125	-	20	20	19.05	$f_1+w/2$	21.0	42	25	02	A
R/LH100.1616.22.IK	16	16	125	30	33.5	20	15.05	$f_1+w/2$	21.0	42	25	02	A
R/LH100.2020.22.IK	20	20	125	-	33.5	20	19.05	$f_1+w/2$	21.0	42	25	02	A
R/LH100.2525.22.IK	25	25	150	-	33.5	25	24.05	$f_1+w/2$	21.0	42	30	02	A

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
R/LH100....	4.15T15P	T15PQ	004.00.61

## 切槽和切断

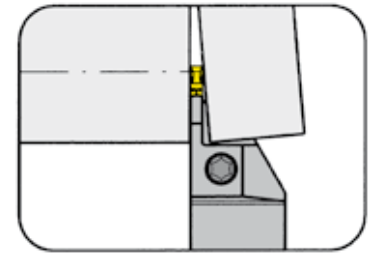
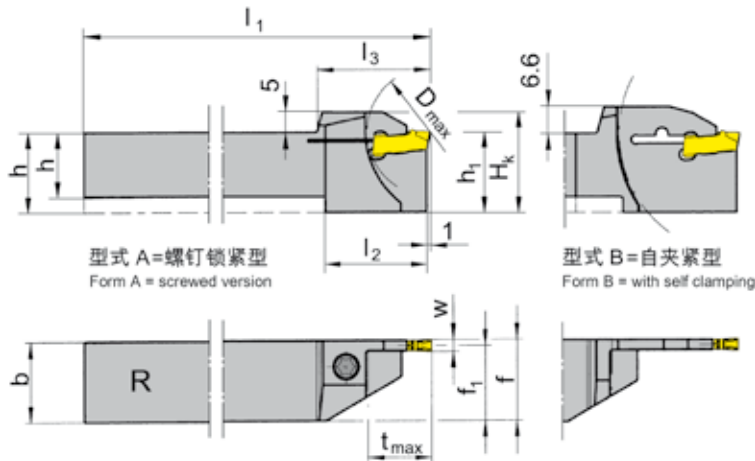
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size	自 Form
R/LH100.1616.03 R/LH100.1212.03	16 12	16 12	125	19.5 21.0	23.0	20 16	14.85 10.85	$f_1+w/2$	10.5 13.0	42 26	25.0	03	A
R/LH100.1616.13 R/LH100.2020.13 R/LH100.2525.13	16 20 25	16 20 25	125	25.0 - -	28.5	20 25	14.85 18.85 23.85	$f_1+w/2$	16.0	42	25.0 25.0 30.0	03	A
R/LH100.1616.23 R/LH100.2020.23	16 20	16 20	125	30.0 -	33.5	20	14.85 18.85	$f_1+w/2$	21.0	42	25.0	03	A
R/LH100.2020.33 R/LH100.2525.33	20 25	20 25	125 150	35.0 -	38.5	25	18.85 23.85	$f_1+w/2$	32.5	65	31.6	03	B

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade - separate order required!

螺丝的扭矩规格，详见技术说明。

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

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100....03/13/23 R/LH100.2...33	5.17T20P	T20PQ	P39L



## 切槽和切断

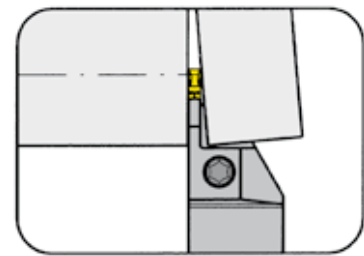
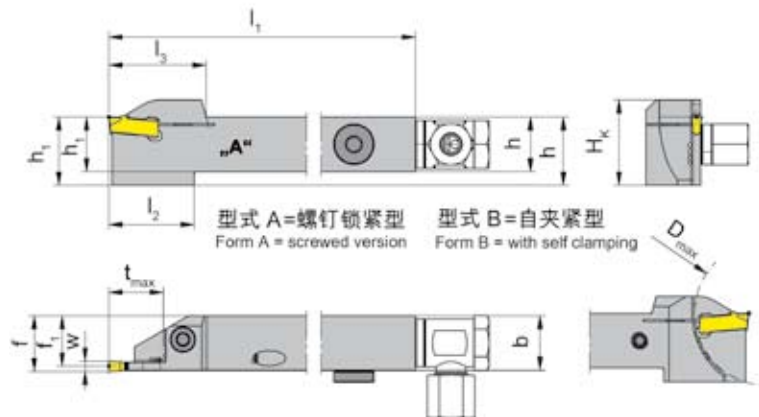
## GROOVING and PARTING OFF



## 刀杆 型号

H100

TOOLHOLDER Type

槽深可达  
槽宽Depth of groove up to  
Width of groove32.5 mm  
3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

带内冷

with through coolant supply

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size	自 Form
R/LH100.1212.03.IK	12	12	125	21.0	23.0	16	10.85	$f_1+w/2$	13.0	26	25.0	03	A
R/LH100.1616.03.IK	16	16	125	19.5	23.0	20	14.85	$f_1+w/2$	10.5	42	25.0	03	A
R/LH100.1616.13.IK	16	16	125	25.0	-	20	14.85	$f_1+w/2$	16.0	42	25.0	03	A
R/LH100.2020.13.IK	20	20	125	-	28.5	20	18.85	$f_1+w/2$	16.0	42	25.0	03	A
R/LH100.2525.13.IK	25	25	150	-	-	25	23.85	$f_1+w/2$	16.0	42	30.0	03	A
R/LH100.1616.23.IK	16	16	125	30.0	33.5	20	14.85	$f_1+w/2$	21.0	42	25.0	03	A
R/LH100.2020.23.IK	20	20	125	-	33.5	20	18.85	$f_1+w/2$	21.0	42	25.0	03	A
R/LH100.2020.33.IK	20	20	125	35.0	38.5	25	18.85	$f_1+w/2$	32.5	65	31.6	03	B
R/LH100.2525.33.IK	25	25	150	-	38.5	25	23.85	$f_1+w/2$	32.5	65	31.6	03	B

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知:

扳手P39L不包含在刀板中, 需单独订购!

Ordering note:

Wrench P39L ist not combined with blade - separate order required!

螺丝的扭矩规格, 详见技术说明。

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

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply	扳手 Wrench
R/LH100....IK R/LH100.2...IK	5-17T20P	T20PQ	004.00.61 004.00.61	P39L

## 切槽和切断

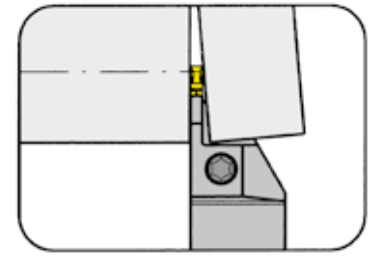
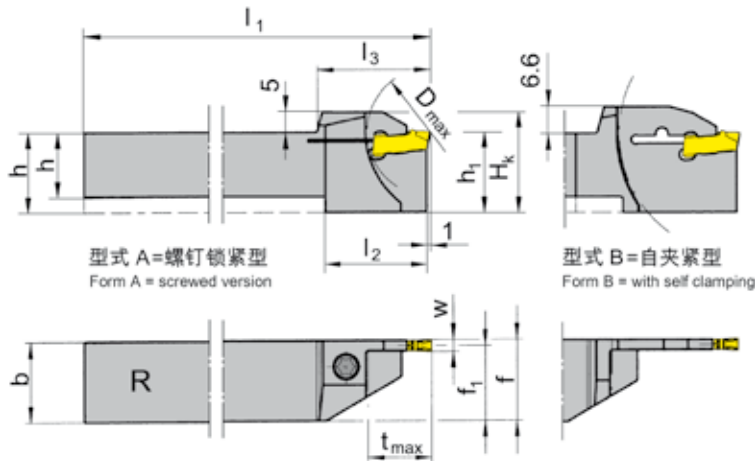
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove40.5 mm  
4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size	自 Form
R/LH100.1616.04	16	16	125	19.5	23.0	20	14.45	$f_1+w/2$	10.5	42	25.0	04	A
R/LH100.1616.14	16	16	125	25.0		20	14.45				25.0		
R/LH100.2020.14	20	20	125	-	28.5	20	18.45	$f_1+w/2$	16.0	42	25.0	04	A
R/LH100.2525.14	25	25	150	-		25	23.45				30.0		
R/LH100.1616.24	16	16	125	30.0	33.5	20	14.45	$f_1+w/2$	21.0	42	25.0	04	A
R/LH100.2020.34	20	20	125	35.0	38.5	25	18.45	$f_1+w/2$	32.5	65	31.6	04	B
R/LH100.2525.34	25	25	150	40.0	46.5	32	23.45	$f_1+w/2$	40.5	81			

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade - separate order required!

螺丝的扭矩规格，详见技术说明。

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



附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100....04/14/24 R/LH100.2...34	5.17T20P	T20PQ	P39L

## 切槽和切断

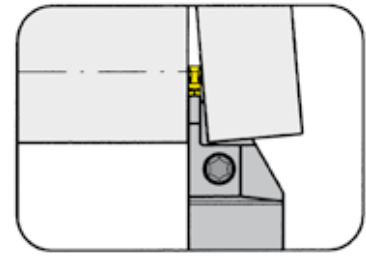
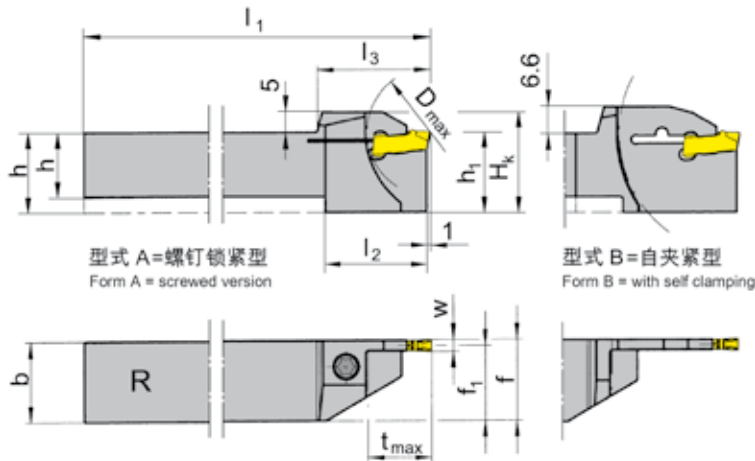
## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

## H100

槽深可达  
槽宽Depth of groove up to  
Width of groove40.5 mm  
5.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_K$	规格 Size	自 Form
R/LH100.2020.15	20	20	125	-	28.5	20	18.05	$f_1+w/2$	16.0	42	25.0	05	A
R/LH100.2525.15	25	25	150	-	28.5	25	23.05	$f_1+w/2$	16.0	42	30.0	05	A
R/LH100.2020.35	20	20	125	35	38.5	25	18.05	$f_1+w/2$	32.5	65	31.6	05	B
R/LH100.2525.35	25	25	150	40	46.5	32	23.05	$f_1+w/2$	40.5	81	38.6	05	B

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade - separate order required!

螺丝的扭矩规格，详见技术说明。

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



## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100.2...15 R/LH100.2...35	5.17T20P	T20PQ	P39L

## 切槽和切断

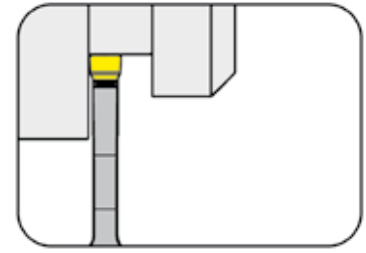
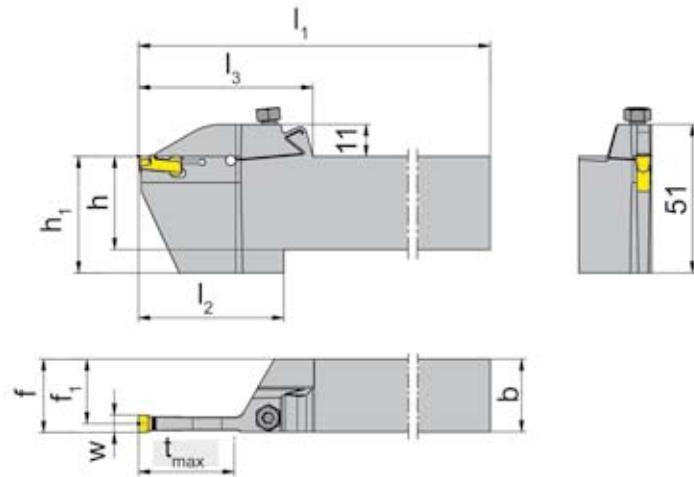
## GROOVING and PARTING OFF



## 刀杆 型号

H100

TOOLHOLDER Type

槽深可达  
槽宽Depth of groove up to  
Width of groove41.0 mm  
4.0 - 12.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	$l_1$	$l_2$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	规格 Size
R/LH100.2020.3.04	20	20	150	50	60	32	18.2	$f_1+w/2$	33	04
R/LH100.2020.3.05	20	20	150	50	60	32	17.7	$f_1+w/2$	33	05
R/LH100.2525.3.06	25	25	150	50	60	40	22.2	$f_1+w/2$	33	06
R/LH100.3225.3.08	32	25	170	50	60	40	21.2	$f_1+w/2$	33	08
R/LH100.3225.38				50	60				35	
R/LH100.3225.4.08				55	65				41	
R/LH100.3225.4.10	32	25	170	55	65	40	20.3	$f_1+w/2$	41	10
R/LH100.3225.4.12	32	25	170	55	65	40	19.3	$f_1+w/2$	41	12

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH100....	030.6075.T20P	T20PQ

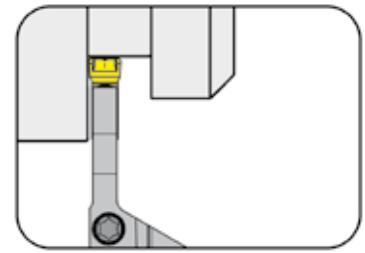
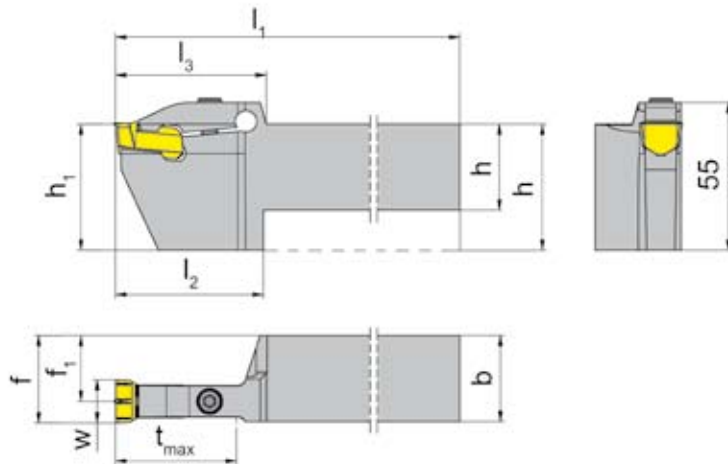
## 切槽和切断

## GROOVING and PARTING OFF



## 刀杆 型号

TOOLHOLDER Type

**H100**槽深可达  
槽宽Depth of groove up to  
Width of groove45.0 mm  
16.0 mm

配合刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	规格 Size
<b>R/LH100.3232.5.16</b>	32	32	170	55	56	47	24.5	f <sub>1</sub> +w/2	45	16

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	垫圈 Washer
R/LH100.3232.5.16	<b>030.0625.T25P</b>	<b>T25PQ</b>	<b>020.0006.3526</b>



## 切槽和切断

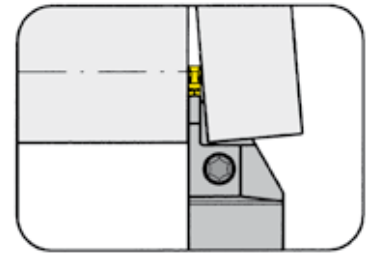
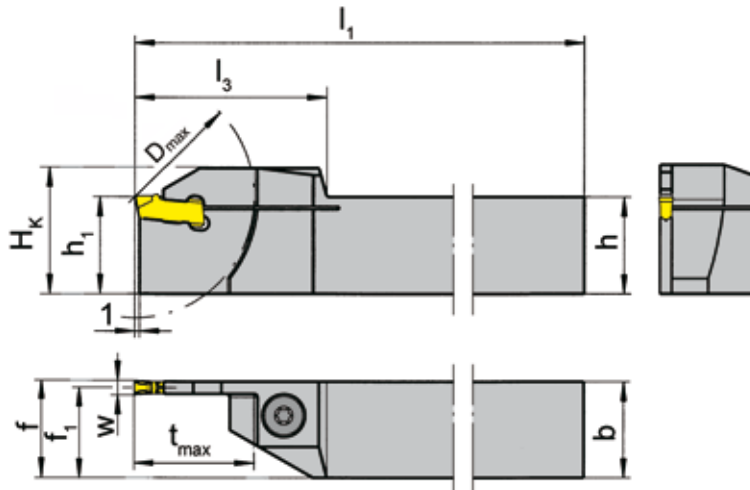
## GROOVING and PARTING OFF



## 刀杆 型号

H100

TOOLHOLDER Type

槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
3.0 - 4.0 mm

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

配合 刀片

for use with Insert

型号 S100

Type

产品型号 Part number	h	b	$l_1$	$l_3$	$h_1$	$f_1$	f	$t_{max}$	$D_{max}$	$H_k$	规格 Size
R/LH100.2020.73	20	20	125	40	20	18.85	$f_1+w/2$	25	50	26	03
R/LH100.2525.73	25	25	150	40	25	23.85	$f_1+w/2$	25	50	31	03
R/LH100.2020.74	20	20	125	40	20	18.85	$f_1+w/2$	25	50	26	04

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH100.2...	6.23T25P	T25PQ

# 切断

## PARTING OFF

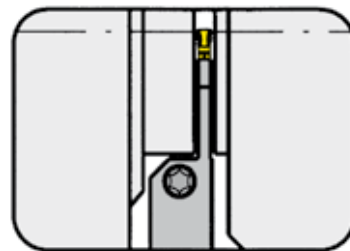


### 常规刀杆 型号

BASIC TOOLHOLDER Type

# 220

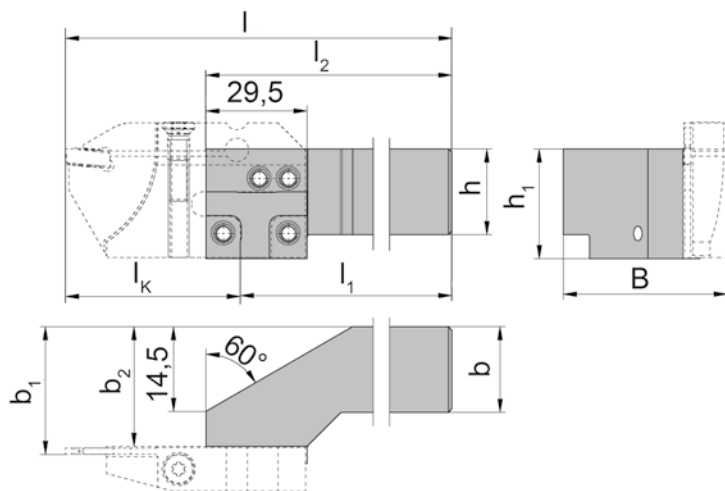
无刀夹  
without cassette



配合RNK100的常规刀杆  
Basic adapter for cassettes type RNK100

刀杆平行于工件轴线

Shank parallel to the axis of workpiece



R=右手型

R = right hand version

多主轴MS52系统

Multi spindle system MS52

产品型号 Part number	h	h <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	b	b <sub>1</sub>	b <sub>2</sub>	l	B
<b>R220.2529.60.K1</b>	25	32	l <sub>2</sub> - 10	160	25	b <sub>2</sub> +f <sub>3</sub>	29.5	l <sub>1</sub> +l <sub>k</sub>	b <sub>2</sub> +b <sub>3</sub>
<b>R220.2535.60.K1</b>							34.9		

按需提供更多尺寸

Further sizes upon request

l<sub>k</sub>, b<sub>3</sub> 和 f<sub>3</sub> 见刀夹

l<sub>k</sub>, b<sub>3</sub> and f<sub>3</sub> see cassettes

尺寸单位: mm

Dimensions in mm

螺丝的扭矩规格, 详见技术说明。

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

### 附件

Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R220.25...	<b>5.12T20P</b>	<b>T20PQ</b>

## 切槽和切断 ( 外圆 )

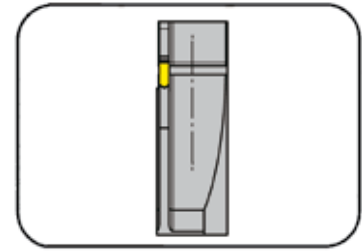
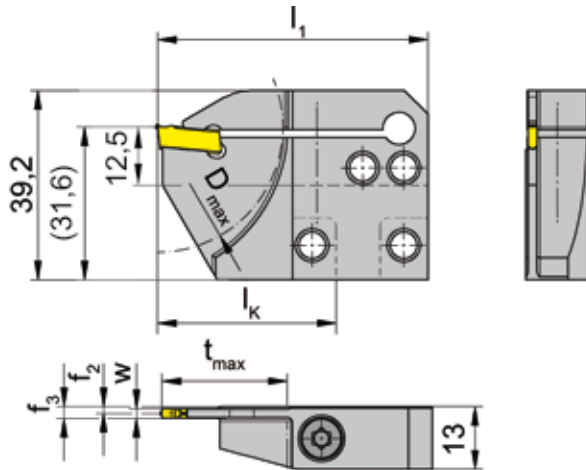
GROOVING and PARTING OFF (external)



## 刀夹 型号

CASSETTE Type

## NK100

槽深可达  
槽宽Depth of groove up to  
Width of groove26.0 mm  
2.5 - 3.0 mm

配合 刀片

for use with Insert

型号 S100

Type

R=右手型-如图

R = right hand version shown

产品型号 Part number	$l_1$	$t_{max}$	w	$D_{max}$	$f_2$	$f_3$	$l_k$
<b>RNK100.5625.02L</b>	56	26	2.5	52	1.40	$f_2+w/2$	37
<b>RNK100.7025.02L</b>	70						51
<b>RNK100.5625.03L</b>	56	26	3.0	52	1.65	$f_2+w/2$	37
<b>RNK100.7025.03L</b>	70						51

配合常规刀杆R...K1和L...K2  
For basic toolholder R...K1 and L...K2w见刀片  
w see inserts尺寸单位 : mm  
Dimensions in mm

## 订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

## Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格, 详见技术说明。

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

## 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RNK100....	<b>5.13T20P</b>	<b>T20PQ</b>

## 切槽和切断 ( 外圆 )

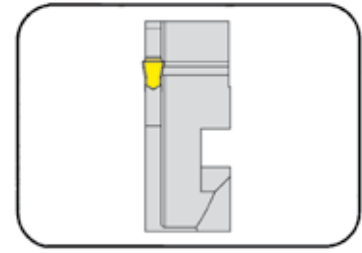
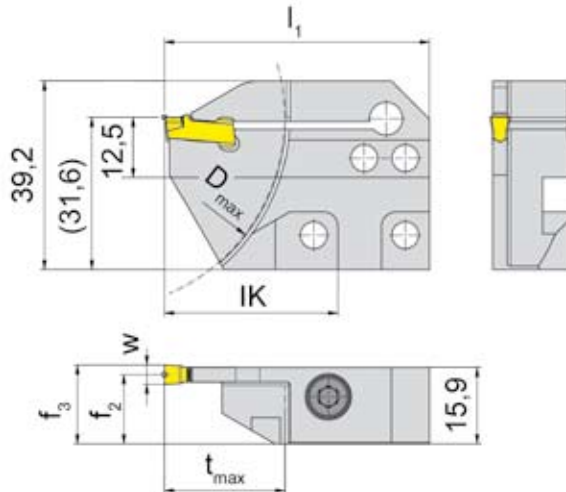
GROOVING and PARTING OFF (external)



## 刀夹 型号

CASSETTE Type

## NK100

槽深可达  
槽宽Depth of groove up to  
Width of groove25.0 mm  
2.0 - 4.0 mm

配合 刀片

for use with Insert

型号 S100

Type

L=左手型-如图

L = left hand version shown

产品型号 Part number	$l_1$	$t_{max}$	w	$D_{max}$	$f_2$	$f_3$	$l_k$
R/LNK100.3215.21	55	25	2	80	15.4	$f_2+w/2$	36
R/LNK100.3215.23	55	25	3	80	14.9	$f_2+w/2$	36
R/LNK100.3215.24	55	25	4	80	14.4	$f_2+w/2$	36

配合常规刀杆R...K1和L...K2

For basic toolholder R...K1 and L...K2

尺寸单位：mm

Dimensions in mm

## 订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

## Ordering note:

The fastening screw is combined with the basic toolholder - no separate order required.

螺丝的扭矩规格，详见技术说明。

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

## 附件

Spare parts

刀夹 Cassette	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LNK100.3215.2...	6.23T25P	T25PQ

# 切槽和切断

## GROOVING and PARTING OFF

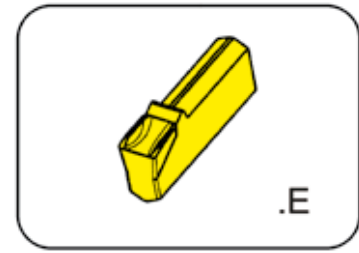


### 刀片型号

INSERT Type

### S100

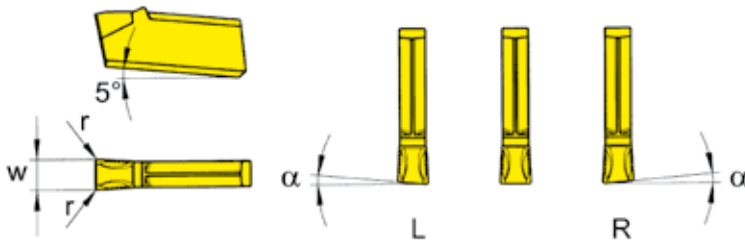
带断屑槽  
with chip former



槽宽	Width of groove	2.0 - 4.0 mm
----	-----------------	--------------

配合刀杆  
for use with Toolholder

型号 H100  
Type



R=右手型  
R = right hand version

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	规格 Size	T122	TF42	TF43	TF45	TF46	TC93	ALX2	ALX3	AS6G
S100.0200.E2 R/LS100.0520.E2	2.0	0.2	0° 5°	01	Δ Δ/Δ		▲ ▲/Δ	▲ ▲/Δ	▲ Δ/	Δ		▲	
S100.0250.E2 R/LS100.0525.E2	2.5	0.2	0° 5°	02	▲ /Δ		▲ Δ/	▲ ▲/	▲ Δ/▲	Δ ▲/			
S100.0300.E2 R/LS100.0530.E2	3.0	0.2	0° 5°	03	▲ ▲/Δ	▲ ▲/	▲ ▲/▲	▲ ▲/▲	▲ ▲/▲	▲ ▲/	▲	▲	
R/LS100.0540.E2	4.0	0.2	5°	04	Δ/Δ		▲/▲	▲/▲	Δ/	Δ/Δ			
▲ 库存 / on stock   Δ 4周 / 4 weeks					P	●	●	●	●	●	●	●	●
● 主要应用 / main recommendation					M			●	○				
○ 可选推荐 / alternative recommendation					K			●	●				
■ 无涂层牌号 / uncoated grades					N			●	●				
■ 涂层牌号 / coated grades					S			●	○				
■ 钎焊/金属陶瓷 / brazed/Cermet					H								

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

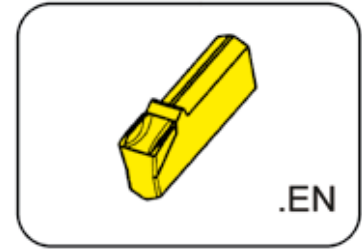
## 切槽和切断

## GROOVING and PARTING OFF



## 刀片型号

INSERT Type

**S100**带断屑槽  
with chip former

槽宽

Width of groove

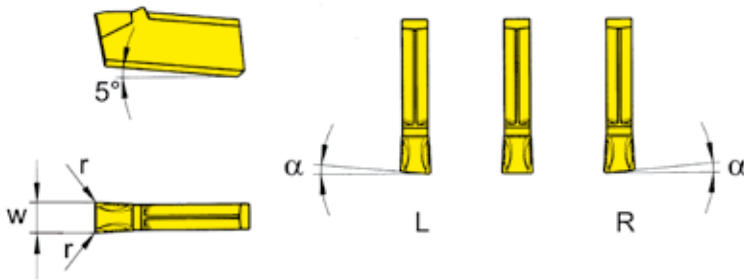
2.0 - 12.0 mm

配合 刀杆

for use with Toolholder

型号 H100

Type



R=右手型

R = right hand version

L=左手型

L = left hand version

产品型号 Part number	w	r	α	规格 Size	Tl22	TA45	ALX3	AS6G	AS62	AS66
<b>S100.0200.EN2</b>	2.0	0.2	0°	01			▲	▲		
<b>S100.0220.EN2</b>	2.2							▲		
<b>S100.0250.EN2</b>	2.5	0.2	0°	02			▲	▲		
<b>S100.0300.EN2</b>	3.0	0.2	0°	03			▲	▲	△	▲
<b>RS100.0530.EN2</b>			5°							
<b>S100.0400.EN3</b>	4.0	0.3	0°	04			▲	▲		
<b>R/LS100.0540.EN2</b>		0.2	5°				▲/▲			
<b>S100.0500.EN3</b>	5.0	0.3	0°	05			▲			
<b>S100.0600.EN6</b>	6.0	0.8	0°	06				▲		
<b>S100.0800.EN8</b>	8.0	0.8	0°	08				▲		
<b>LS100.0480.EN8</b>			4°							
<b>S100.1000.EN8</b>	10.0	0.8	0°	10				▲		
<b>S100.1200.EN8</b>	12.0	0.8	0°	12				▲		
▲ 库存 / on stock    △ 4周 / 4 weeks					P		●	●	●	●
● 主要应用 / main recommendation					M			●		○
○ 可选推荐 / alternative recommendation					K			●		●
■ 无涂层牌号 / uncoated grades					N			●		●
■ 涂层牌号 / coated grades					S			●		○
■ 钎焊/金属陶瓷 / brazed/Cermet					H					

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

# 切槽和切断

## GROOVING and PARTING OFF

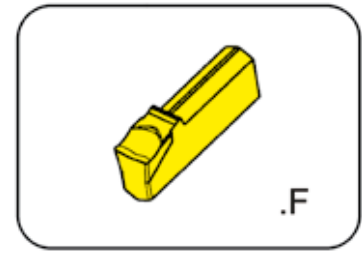


### 刀片型号

INSERT Type

## S100

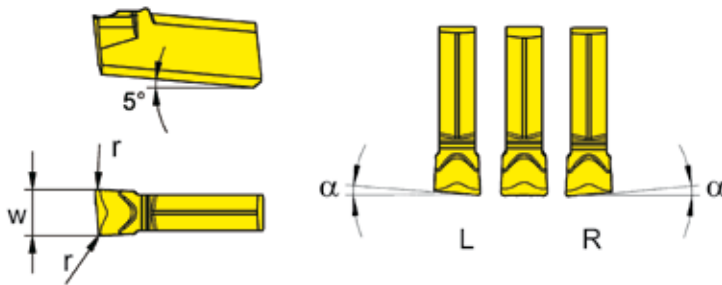
带断屑槽  
with chip forming



槽宽	Width of groove	2.0 - 5.0 mm
----	-----------------	--------------

配合 刀杆  
for use with Toolholder

型号 H100  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	w	r	α	规格 Size	Tl22	TF42	TF43	TF45	TF46	AS6G
S100.0200.F2 R/LS100.0520.F2	2.0	0.2	0° 5°	01	▲		▲	▲	▲	
S100.0250.F2 R/LS100.0525.F2	2.5	0.2	0° 5°	02	▲		▲	▲	▲	
S100.0300.F2 R/LS100.0530.F2	3.0	0.2	0° 5°	03	▲ ▲/▲	▲	▲	▲	▲	
S100.0400.F3 R/LS100.0540.F2	4.0	0.3 0.2	0° 5°	04	▲		▲	▲	▲	
S100.0500.F3	5.0	0.3	0°	05	▲		▲	▲	▲	
▲ 库存 / on stock    ▲ 4周 / 4 weeks					P	●	●	●	●	●
● 主要应用 / main recommendation					M			●	○	
○ 可选推荐 / alternative recommendation					K			●	●	
■ 无涂层牌号 / uncoated grades					N			●	●	
■ 涂层牌号 / coated grades					S			●	○	
■ 钎焊/金属陶瓷 / brazed/Cermet					H					

尺寸单位 : mm  
Dimensions in mm

注明R或L型  
State R or L version

硬质合金牌号  
Carbide grades

## 切槽和切断

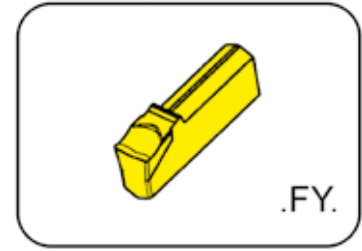
## GROOVING and PARTING OFF



## 刀片型号

INSERT Type

## S100

带断屑槽  
with chip forming

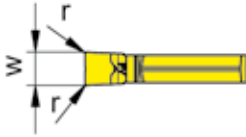
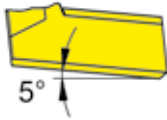
槽宽

Width of groove

2.0 - 4.0 mm

精密烧结

precision sintered



配合刀杆

for use with Toolholder

型号 H100

Type

产品型号 Part number	w	r	规格 Size	TI25	TF45	TF46	AS45
S100.0200.FY2	2.0	0.2	01	▲			
S100.0220.FY2	2.2			▲			
S100.0250.FY2	2.5	0.2	02	▲			
S100.0300.FY2	3.0			▲			
S100.0400.FY3	4.0	0.3	04	▲			
▲ 库存 / on stock Δ 4周 / 4 weeks				P	•	•	•
● 主要应用 / main recommendation				M	•	•	•
○ 可选推荐 / alternative recommendation				K	•	•	•
□ 无涂层牌号 / uncoated grades				N	•	•	•
■ 涂层牌号 / coated grades				S	•	•	•
■ 钎焊/金属陶瓷 / brazed/Cermet				H	•	•	•

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

Indexable inserts can be used in **right and left** hand toolholders.

硬质合金牌号

Carbide grades



## 切槽和切断

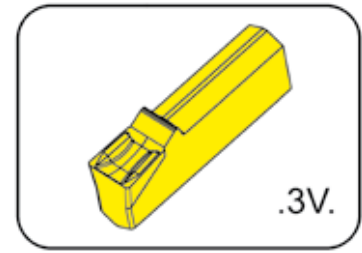
## GROOVING and PARTING OFF



## 刀片型号

INSERT Type

## S100

带断屑槽  
with chip forming

槽宽

Width of groove

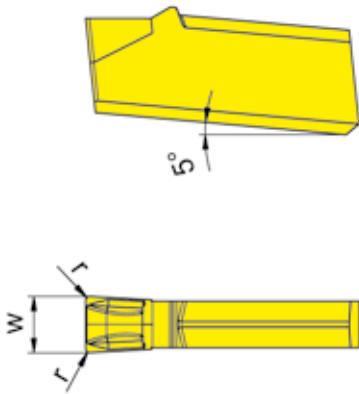
2.0 - 4.0 mm

配合 刀杆

for use with Toolholder

型号 H100

Type



产品型号 Part number	w	r	规格 Size	TI25	TA45	TF46	AS45
S100.0200.3V2	2	0.2	01				▲
S100.0300.3V2	3	0.2	03				▲
S100.0400.3V3	4	0.3	04				▲
▲ 库存 / on stock    Δ 4周 / 4 weeks				P			•
● 主要应用 / main recommendation				M			•
○ 可选推荐 / alternative recommendation				K			•
■ 无涂层牌号 / uncoated grades				N			○
■ 涂层牌号 / coated grades				S			•
■ 钎焊/金属陶瓷 / brazed/Cermet				H			

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

### 凸轮轴加工

由于产品设计，加工凸轮轴座时通常需要左手刀和右手刀，由于刀具的更换增加了非生产性的时间周期。

而使用229系列的刀具，加工凸轮和轴座时不再需要更换刀具，切削余量可达2.5mm (.098")，干切。

轴承基座内的锥度和圆柱度可达 $\leq 0.02$  mm.

**材料: 16MnCr5 - 锻造**

#### 切削参数

凸轮:

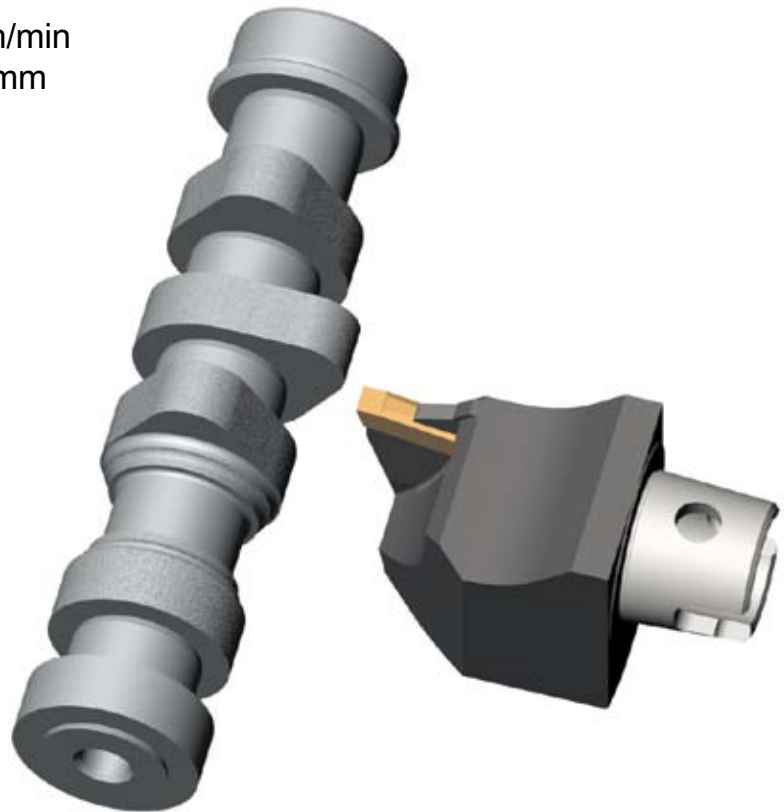
$$v_c = 160 \text{ m/min}$$

$$v_f = 0.25 \text{ mm}$$

基座:

$$v_c = 160 \text{ m/min}$$

$$v_f = 0.25 \text{ mm}$$



#### Machining on camshafts

Because of its design, turning the camshafts seats usually require left and right hand tools. Due to the toolchanges this results in high nonproductive time periods.

With the inserts of type 229, the cams and seats can be machines without a toolchange.

Stock removal is up to 2,5 mm (.098"). No coolant.

The amount of taper and cylindricity at the bearing seat we achieved is  $\leq 0,02$  mm.

**Material: 16MnCr5 - forged**

#### Cutting data

Cam:

$$v_c = 160 \text{ m/min}$$

$$v_f = 0.25 \text{ mm}$$

Seat:

$$v_c = 160 \text{ m/min}$$

$$v_f = 0.25 \text{ mm}$$

技术说明

TECHNICAL INSTRUCTIONS



页 / Page

夹紧螺丝的拧紧扭矩

Q2 - Q6

Clamping torque of the screws

技术信息

Technical Information

- 切槽 / 侧车削  
Grooving / Side turning Q7 - Q10
- 端面切槽  
Face grooving Q11
- 仿形加工  
Profiling Q12
- 螺纹切削  
Threading Q13 - Q14
- 切断  
Parting off Q15 - Q16

断屑槽和进给率

Geometries and feed rates

- 刀片 型号  
Inserts type
- 217 Q17
- 264 / S264 Q18
- 274 Q19
- S119 / S223 Q20
- S224 Q21
- 229 / S229 Q22
- 231 Q23
- 312 / S312 Q24 - Q25
- 315 Q26
- S316 Q27
- 切断  
Parting off Q28

切削参数

Cutting data

- 切槽和切断  
Grooving and parting off Q29
- 端面切槽  
Face grooving Q30
- 仿形加工  
Profiling Q31

用于切槽和切断的硬质合金牌号

Q32 - Q33

Carbide grades for grooving and parting off

硬质合金牌号描述

Q34 - Q36

Description carbide grades

# 螺钉扭矩

## TORQUE OF SCREWS



Q

以下扭矩适用于刀片的螺钉，我们建议对螺钉不要额外使用润滑剂（如铜膏）。

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

关于扭矩扳手，见章节辅助装置

For torque screw drivers please see chapter additional equipment.

型号 type	螺钉 Screw	M <sub>d</sub> Nm	夹紧扳手 Clamping wrench	刀板 Blade
050	030.0518.T20P	5.0	T20PQ	DT20PK
208	6.16	3.0	SW3DIN911	DSW30K
210	218.3	6.5 - 7.0	SW6DIN911	DSW60K
210...09/...K9	5.32T15P	4.5 - 5.0	T15PQ	DT15PK
211	6.19	3.0	SW3DIN911	DSW30K
213	218.3	6.5 - 7.0	SW6DIN911	DSW60K
213...IK	DIN912-M6x14	6.0	SW5DIN911	DSW50K
213...09	5.32T15P	4.5 - 5.0	T15PQ	DT15PK
214	218.3	6.5 - 7.0	SW6DIN911	DSW60K
214...09	5.32T15P	4.5 - 5.0	T15PQ	DT15PK
218	218.3	6.5 - 7.0	SW6DIN911	DSW60K
218...09/...K9	5.32T15P	4.5 - 5.0	T15PQ	DT15PK
219	218.3	6.5 - 7.0	SW6DIN911	DSW60K
219...09	5.32.3T15P	4.5 - 5.0	T15PQ	DT15PK
221	6.20.70P	5.0	T20PQ	DT20PK
225	218.3	6.5 - 7.0	SW6DIN911	DSW60K
226	218.3	6.5 - 7.0	SW6DIN911	DSW60K
226...09	5.32T15P	4.5	T15PQ	DT15PK
226.2608.../3208...	4.15T15P	5.0	T15PQ	DT15PQ
228	6.20.70P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
230	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
232	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
233	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
234	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
235	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
240	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
245	51.27.984P	4.0	T15PQ	DT15PK
248	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
250	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
253	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
254	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
255	5.14	2.0 - 2.5	SW2.5DIN911	DSW25K
257...05	218.3	6.5	SW6DIN911	DSW60K

型号 type	螺钉 Screw	M <sub>0</sub> Nm	夹紧扳手 Clamping wrench	刀板 Blade
257...07/...09	5.32.3T15P	5.0	T15PQ	DT15PK
309	6.25	4.0 - 4.5	SW3DIN911	DSW30K
330	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
333	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
340	6.25	4.0 - 4.5	SW3DIN911	DSW30K
356...3/...5	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
356...6/...7/...10/...2.13	5.15T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
357	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
360	6.25	4.0 - 4.5	SW3DIN911	DSW30K
361	030.0422.T10P	3.0	T10PL	DT10PK
368	4.15T15P	4.0	T15PQ	DT15PK
369	6.25	4.0 - 4.5	SW3DIN911	DSW30K
390	6.25	4.0 - 4.5	SW3DIN911	DSW30K
391.1212...	030.0422.T10P	3.0	T10PL	DT10PK
391.1616...	5.32.3T15P	5.0	T15PQ	DT15PK
391.2...	6.25	4.0 - 4.5	SW3DIN911	DSW30K
974	030.3509.T15P	5.0	T15PQ	DT15PK
B105/BU105 B105KM BU105	6.075T15P	5.0	T15PQ	DT15PK
B105.A022...	030.0422.T10P	3.0	T10PL	DT10PK
B105MD	DIN913-M5x5	1.0	SW2.5DIN911	DSW25K
B108 B108KM	2.6.5T8EP	1.2	T8PL	DT8PK
B110	6.075T15P	5.0	T15PQ	DT15PK
B111	3.5.12T10EP	3.0	T10PL	DT10PK
B114	4.2T15EP	5.0	T15PQ	DT15PK
B119	5.11T15P	2.5 - 3.0	T15PL	DT15PK
B223	5.11T15P	2.5 - 3.0	T15PL	DT15PK
B223...K2	4.09T15P	2.5 - 3.0	T15PL	DT15PK
B224.00...	5.13T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
B224.45... B224.60...	6.14T25P	7.0	T25PQ	DT25PK/DT25PQ
BK224	5.13T20EP	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
BK229	5.13T20EP	6.0	T20PQ	DT20PK/DT20PQ
BKT	6.075T15P	5.0 - 5.5	T15PQ	DT15PK
E223	5.11T15P	2.5 - 3.0	T15PL	DT15PK
H105	6.075T15P	5.0	T15PQ	DT15PK
H100...01/...11/...21 + IK H100...02/...12/...22 + IK	4.15T15P	5.0	T15PQ	DT15PK

# 螺钉扭矩

## TORQUE OF SCREWS



Q

型号 type	螺钉 Screw	M <sub>d</sub> Nm	夹紧扳手 Clamping wrench	刀板 Blade
H100...71/...72 H100...71R/L/...72R/L	4.15T15P	5.0	T15PQ	DT15PK
H100...03/...13/...23 H100...04/...14/...24 H100...15	5.17T20P	6.5	T20PQ	DT20PK/DT20PQ
H100...73/...74	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
H100...73R/L/...74R/L	DIN912-M5x20	4.0	SW4DIN911	DSW40K
H100...83/...84	030.505P.0718	5.0	T15PQ	DT15PK
H100..83R/L/N/..84R/L/N	030.505P.0660	5.0	T15PQ	DT15PK
H100...93/...93R/L	030.0413.T15P	3.0	T15PQ	DT15PK
H100.2020.3.0.. H100.2525.3.0.. H100.3225.3.0./...38 H100.3225.4.0./...4.1.. H100...08/...10/...12	030.6075.T20P	5.0	T20PQ	DT20PK
H100.3232...	030.0625.T25P	7.0	T25PQ	DT25PK/DT25PQ?
H117...10/...12 ...1407/...1439/ ...1441/...1442	4.09T15P	4.5 - 5.0	T15PQ	DT15PK
H117.1010.10	030.400P0227	5.0	T15PQ	DT15PK
H117...16/...32/...45 ...1419/...1440	5.12T20P	6.0	T20PQ	DT20PK/DT20PQ
H117...20/...26	6.17T20P	7.0	T20PQ	DT20PK/DT20PQ
H117MD	030.400P.0227	5.0	T15PQ	DT15PK
H223	5.11T15P	2.5 - 3.0	T15PL	DT15PK
H223.2608.../3208...	4.15T15P	5.0	T15PL	DT15PK
H224	6.23T25P	6.0	T25PQ	DT25PK/DT25PQ
H224.1212.81	6.17T25P	5.0	T25PQ	DT15PK
H224.1608.02/.23/.24 H224.2608.81/.82/.83	4.15T15P	5.0	T15PQ	DT15PK
H224.2608.01/.02/.03 H224.3208.01/.02/.03	4.20T15P	4.3	T15PL	DT15PK
H224.3208.93	030.0413T15P	3.0	T15PQ	DT15PK
H224..61/..62/..63/..64+IK	4.12.T15EP	5.0	T15PQ	DT15PK
H224...65/...66/...83R	5.13.T20EP	6.5	T20PQ	DT20PK/DT20PQ
H264 H264KM	3.5.12T10EP	2.5 - 3.0	T10PL	DT10PK
H274...04/...04.E	030.3509.T15P	5.0	T15PQ	DT15PK
H274...07	030.3513.T15P	5.0	T15PQ	DT15PK
H274KM	030.3509.T15P	5.0	T15PQ	DT15PK
H316	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
HC105	6.075T15P	5.0 - 5.5	T15PQ	DT15PK
HC105MD	DIN911-M4x5	1.0	SW2.0DIN911	SW20K

# 螺钉扭矩

## TORQUE OF SCREWS



Q

型号 type	螺钉 Screw	M <sub>d</sub> Nm	夹紧扳手 Clamping wrench	刀板 Blade
HC114	4.12T15EP	5.0	T15PQ	DT15PK
HC274KM	030.3509.T15P	5.0	T15PQ	DT15PK
HC316	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
KT274 KTC274	030.3509.T15P	5.0	T15PQ	DT15PK
L368	4.18T15EP	4.0	T15PQ	DT15PK
L849.0220.L...	5.12.T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
L849.0226.L...	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
LA210	218.3	6.5 - 7.0	SW6.911	DSW60K
LA226	218.3	6.5 - 7.0	SW6.911	DSW60K
LAK220	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6.0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6.0	T20PQ	DT20PK/DT20PQ
LNK368	5.10T20P	6.0	T20PQ	DT20PK/DT20PQ
LNK760	5.13T20EP	6.0	T20PQ	DT20PK/DT20PQ
N849...10/...12	4.09T15P	4.5 - 5.0	T15PQ	DT15PK
N849...16/...32	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
N849...20/...26	6.17T20P	7.0	T20PQ	DT20PK/DT20PQ
N849...K1	DIN1835-B M10x12	6.0	SW5.0DIN911	DSW50K
NH105MD	DIN911-M4x5	1.0	SW2.0DIN911	SW20K
NK100	5.13T20P	6.5	T20PQ	DT20PK/DT20PQ
NK100.0840...	4.20T15P	4.3	T15PL	DT15PK
NK100.3215...	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
NK220	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6.0	T20PQ	DT20PK/DT20PQ
NK224.0840...	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
NK264	4.20T15P	4.3	T15PL	DT15PK
NK274	030.3509.T15P	5.0	T15PQ	DT15PK
NK356	5.12T20P	6.0	T20PQ	DT20PK/DT20PQ
NK360	5.12T20P	6.0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	4.5 - 5.0	T15PQ	DT15PK
NK360.0840.1.01/02/03	030.0422.T10P	3.0	T10PL	DT10PK
NK360.0840.1.04	5.32.3T15P	4.5 - 5.0	T15PQ	DT15PK
NK368	030.400P.0602	4.0	T10PL	DT10PK
R76	030.3509.T15P	5.0	T15PQ	DT15PK
RA210	218.3	6.5 - 7.0	SW6.911	DSW60K
RA226	218.3	6.5 - 7.0	SW6.911	DSW60K
R849.0220.R...	5.12.T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ

# 螺钉扭矩

## TORQUE OF SCREWS



Q

型号 type	螺钉 Screw	M <sub>d</sub> Nm	夹紧扳手 Clamping wrench	刀板 Blade
R849.0226.R...	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
R849...K2	DIN913-M8x12	7.0	SW5DIN911	DSW50K
RAK220	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6.0	T20PQ	DT20PK/DT20PQ
RIK220	6.23T25P	7.0	T25PQ	DT25PK/DT25PQ
RIK224	5.13T20P	6.0	T20PQ	DT20PK/DT20PQ
SB105	6.075T15P	5.0	T15PQ	DT15PQ
SB110	6.075T15P	5.0	T15PQ	DT15PQ
SH117...08	030.3509.T15P	3.5	T15PQ	DT15PK
SH117...10	4.09T15P	4.5 - 5.0	T15PQ	DT15PK
SH117...16	5.12T20P	6.0 - 6.5	T20PQ	DT20PK/DT20PQ
VDI	6.075T15P	5.0	T15PQ	DT15PK



## 侧车削 SIDE TURNING

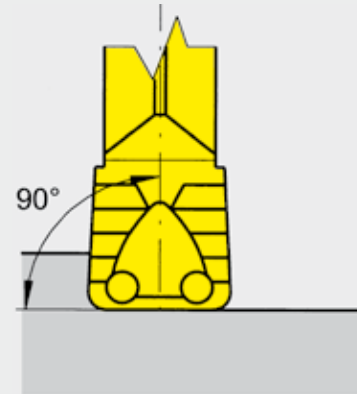
HORN的切槽刀具能为您提供轮廓和角度的绝对精度，即使使用单边侧刃切削时。具有韧性的刀片可能适合一般车削，但不适合精密槽加工。

**HORN-Grooving Tools will give you absolute accuracy of profile and angles, even when profiling with one-sided cutting forces.**

A flexible cutting edge would be desirable for turning, but not useful for precision grooving.

请注意刀具的设置：  
确保刀具一直和工件轴向成直角。

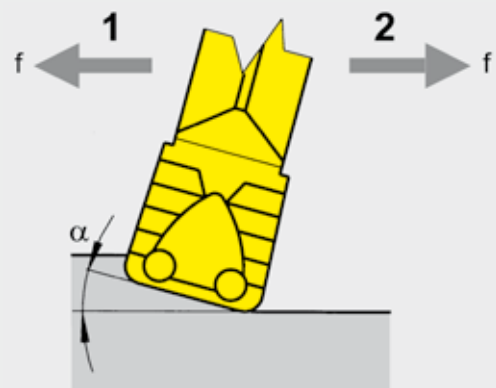
**Please note when setting tool:**  
Always ensure that the tool is perpendicular to the axis of the workpiece.



不正确的操作：  
进给方向 1 将会产生振动，并将增加刚性工件的振动倾向。  
进给方向 2 适合车削，对于操作不会有负面影响。

### Improper setting:

Feed direction 1 will create vibrations. The tendency to vibrate will increase on rigid workpieces.  
Feed direction 2 is suitable for turning and will have no negative effects to the operation.



Q

## 侧车削 SIDE TURNING

槽刀不能作为车刀的替代品使用，但某些加工中，使用槽刀进行车削，可以降低换刀次数并缩短加工周期。

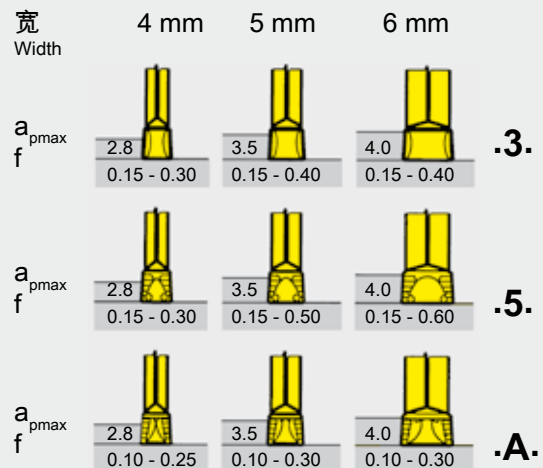
The grooving tool should not be seen as a replacement for a turning tool with ISO-inserts. On certain operations, for instance grooving and turning can reduce the number of tool changes and offer reduced cycle time.

### 刀片宽度:

4、5和6mm宽的刀片适合侧走，工件的轮廓和刚性决定了刀片宽度，并尽可能的选择最大的刀尖圆角。

### Width of insert:

The width 4, 5 and 6 mm are recommended for side turning. The profile and rigidity of the workpiece determines the width of insert. Always choose the largest possible edge radius.



### 切深 $a_p$ :

当需要横向切削时时，切削深度决定于刀片宽度及工件的材质和刚性，最大切深受限于切削刃的长度。

计算的经验:

$$a_{p\max} = w \times 0.7 \text{ 或者 } \max. 3.0 \text{ mm}$$

$$a_{p\min} = \text{圆角半径 } r$$

最小的切削深度  $a_{p\min}$  来自刀尖圆角半径，如果切深小于刀尖圆角半径，切削状况将很差。

### 最大进给率 $f_{\max}$ :

根据经验计算:

$$f_{\max} = w \times 0,1$$

### Cutting depth $a_p$ :

When side turning the cutting depth is dependent upon the width of insert as well as on the material and the rigidity of the workpiece. The max. depth would be limited by the length of the cutting edge.

Rule of thumb for calculation:  $a_{p\max} = w \times 0,7 \text{ or } \max. 3,0 \text{ mm}$   
 $a_{p\min} = \text{corner radius } (r)$

The smallest cutting depth  $a_{p\min}$  is governed by the edge radius of the insert. Cutting depth below the corner radius will create poor cutting conditions.

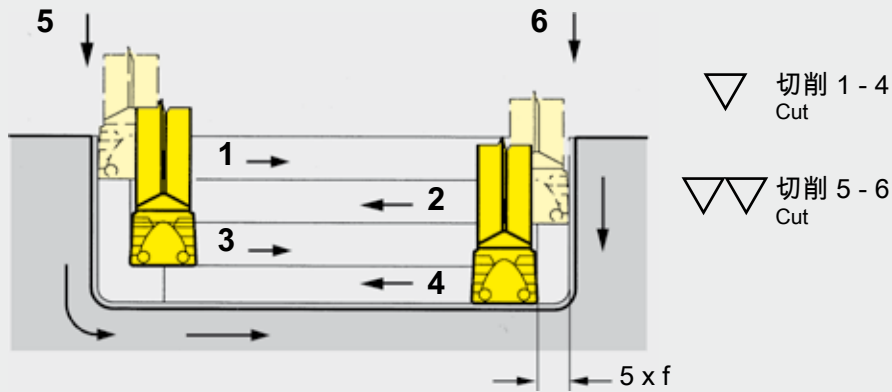
### Max. feed rate $f_{\max}$ :

Rule of thumb for calculation:  $f_{\max} = w \times 0,1$

## 侧车削 SIDE TURNING

### 双肩间的横向切削

Side turning between shoulders



刀片横走总是自一侧面开始至另一面结束。这样的横走影响切屑的排出并有刀片崩损的危险。切槽和车削的建议见图所示。

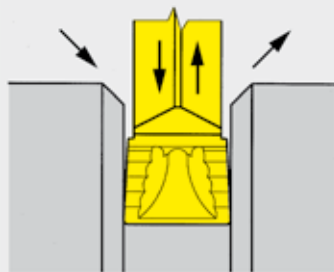
切削步骤2及之后切削的起始位置都离肩部  $5 \times f$  的距离，这样可以避免切屑卡在前行中的切削刃上。

Always start at the shoulder when side turning, towards shoulder. An operation towards the shoulder will influence the run off the chip and creates the risk of insert breaking. Grooving and turning is recommended as shown.

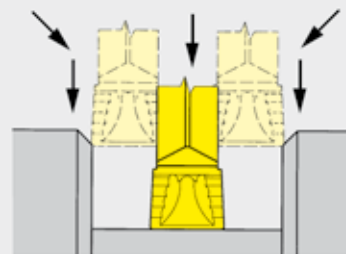
Cut 2 and subsequent cuts leave a distance of  $5 \times f$  to the shoulder. This cut width will help to prevent swarf being trapped under the advancing cutting edge.

## 倒角 配合标准刀片

CHAMFERING with standard inserts



槽和刀片的宽度相等  
Width of groove and insert are equal



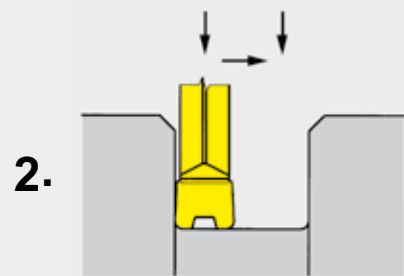
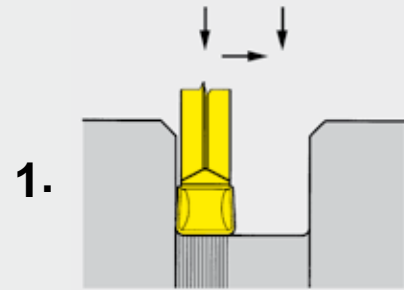
槽比刀片宽  
Groove wider than insert

### 精加工槽 (密封槽)

### FINISHING OF GROOVES (Sealing grooves)

该工艺要求车削和切槽都达到很高的表面光洁度。  
图2为修改后的S224...NC...D2刀片

This process requires both turning and grooving where very high quality surface finishes are required.  
Diagram 2 shows the modified insert type S224...NC...D2.

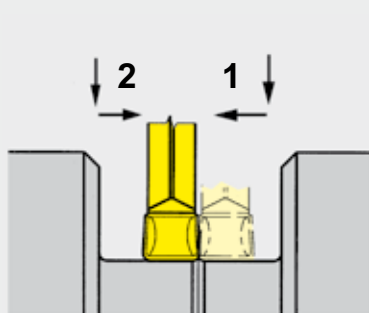


### 环形余屑

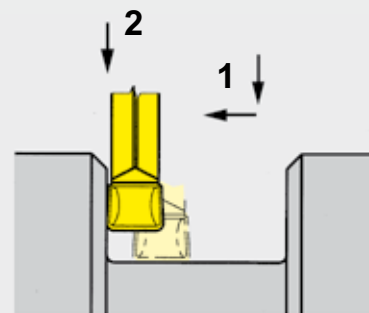
### SWARF RING CREATION

通过切削时通过重叠区域可以避免余屑环的产生。  
锋利的切削刃和更小的刀尖角能够降低余屑环的产生。

Swarf ring creation can be avoided by turning across the smaller diameter in one continuous pass.  
Well defined cutting edges and small corner radii will reduce the tendency to create rings.



产生环形余屑  
Ring creation



无环形铁屑  
No ring creation

## 端面切槽 FACE GROOVING

### 刀夹的选择

选择适合加工端面槽大径的刀夹。

### Cassette Selection

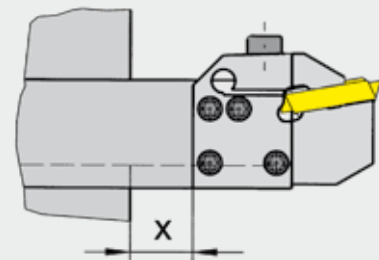
Select the cassette to suit the major diameter of the face groove to be cut.

### 稳定设置

刀具应该使用允许的最小悬伸以达到最大的稳定性。

### Stable Setup

The tool should be set to give the minimum overhang to achieve maximum stability.

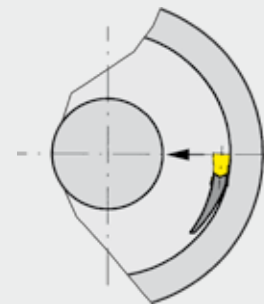


### 实践

当车端面槽时加工方向是由大径 $\varnothing$ 向小径 $\varnothing$ 。

### Working Practice

When turning to open up the face groove the cut should be taken from the major  $\varnothing$  towards the minor  $\varnothing$ .

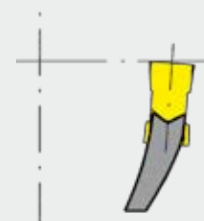


### 刀具设置

刀具应设定至中心高，确保正确的切削和支撑间隙。

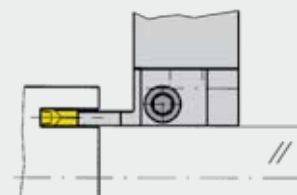
### Tool Setup

The tool should be set to centre height to ensure correct cutting and support clearance.



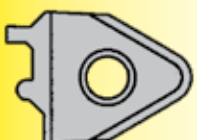
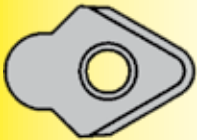
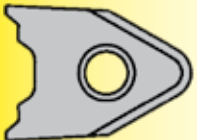
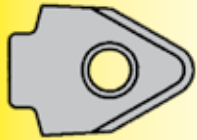
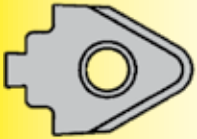
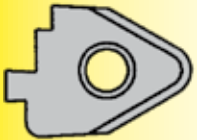
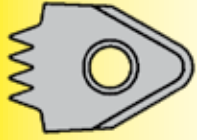
刀具必须平行于工件的旋转轴。

The tool must be set parallel to the rotation axis of the workpiece.



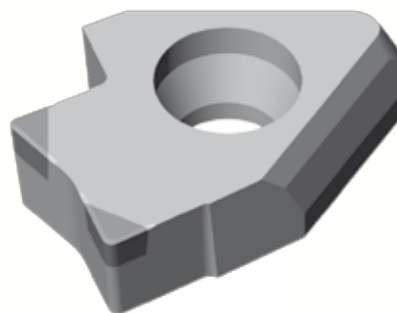
仿形刀片  
PROFILED INSERTS

仿形实例  
Examples of profiles

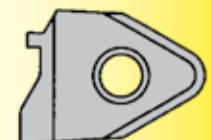
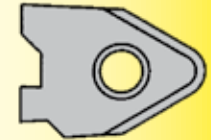
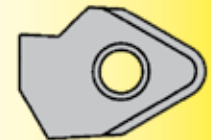
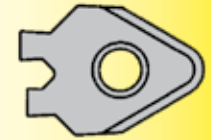
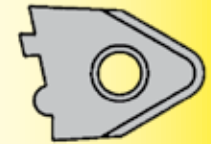
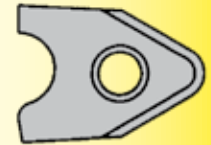
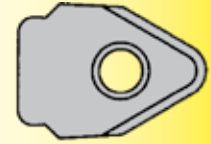


根据客户要求生产仿形刀片。  
我们提供各种后角的刀片。如果客户想重磨刀片，建议使用小后角刀片。  
每个刀片可重磨的次数决定于其磨损或破损的程度。

Profiled inserts are manufactured according to customer special requirements.  
It is also possible to supply inserts with different relief angles. If the customer wants to regrind or resharpen the insert, we recommend to use small relief angles around the cutting edge profile.  
How many times the customer can regrind the insert, depends on the condition of each individual insert.

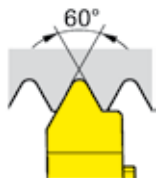


根据要求提供PCD或CBN刀片  
PCD- or CBN-tipped inserts upon request.



### ISO米制标准螺纹 (外圆)

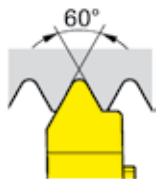
Metric ISO standard  
thread  
(external)



螺纹 Thread	非全牙型 Partial profile	页 Page	全牙型 Full profile	页 Page
M6 (M7)	R/L315.0610.01	J14	R/L315.0610.02	J15
M8 (M9)	R/L315.0712.01	J14	R/L315.0712.02	J15
M10 (M11)	R/L315.0915.01	J14	R/L315.0915.02	J15
M12	R/L315.1017.01	J14	R/L315.1017.02	J15
M14; M16	R/L315.1220.01	J14	R/L315.1220.02	J15
M18; M20; M22	R/L315.1525.01	J14	R/L315.1525.02	J15
M24; M27	R/L315.1830.01	J14	R/L315.1525.02	J15
M30; M33	R/L315.2135.01	J14	R/L315.2135.02	J15
M36	-	-	R/L315.2440.02	J15
M24 - M68	R/L315.3060.01	J14	-	-
M48; M52	-	-	R/L315.3050.02	J15
M64; M68	-	-	R/L315.3660.02	J15

### ISO米制细牙螺纹 (外圆)

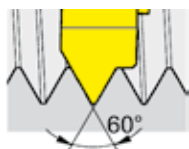
Metric ISO fine thread  
(external)



螺纹 Thread	非全牙型 Partial profile	页 Page	全牙型 Full profile	页 Page
M7.5x1	R/L315.0610.01	J14	R/L315.0610.02	J15
M10x1.25	R/L315.0712.01	J14	R/L315.0712.02	J15
M12x1.5	R/L315.0915.01	J14	R/L315.0915.02	J15
M17x2	R/L315.1220.01	J14	R/L315.1220.02	J15
M24x2.5	R/L315.1525.01	J14	R/L315.1525.02	J15
M30x3	R/L315.1830.01	J14	R/L315.1525.02	J15

### ISO米制细牙螺纹 (内圆)

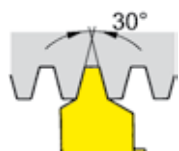
Metric ISO fine thread  
(internal)



螺纹 Thread	非全牙型 Partial profile	页 Page	全牙型 Full profile	页 Page
M45x1	R/L315.0510.01	J16	R/L315.0510.02	J17
M45x1.5	R/L315.0815.01	J16	R/L315.0815.02	J17
M48x2	R/L315.1020.01	J16	R/L315.1020.02	J17
M48x2.5	R/L315.1325.01	J16	R/L315.1325.02	J17
M48x3	R/L315.1630.01	J16	R/L315.1630.02	J17
M48x3.5	R/L315.1835.01	J16	R/L315.1835.02	J17

### ISO米制梯形螺纹 DIN103 (外圆)

Metric ISO trapezoidal  
thread DIN103  
(external)



螺纹 Thread	全牙型 Full profile	页 Page
Tr8x1.5	R/L315.1015.02	J18
Tr9-10x2	R/L315.1320.02	J18
Tr12-14x3	R/L315.1730.02	J18
Tr16-20x4	R/L315.2240.02	J18
Tr22-28x5	R/L315.2750.02	J18
Tr30-36x6	R/L315.3560.02	J18

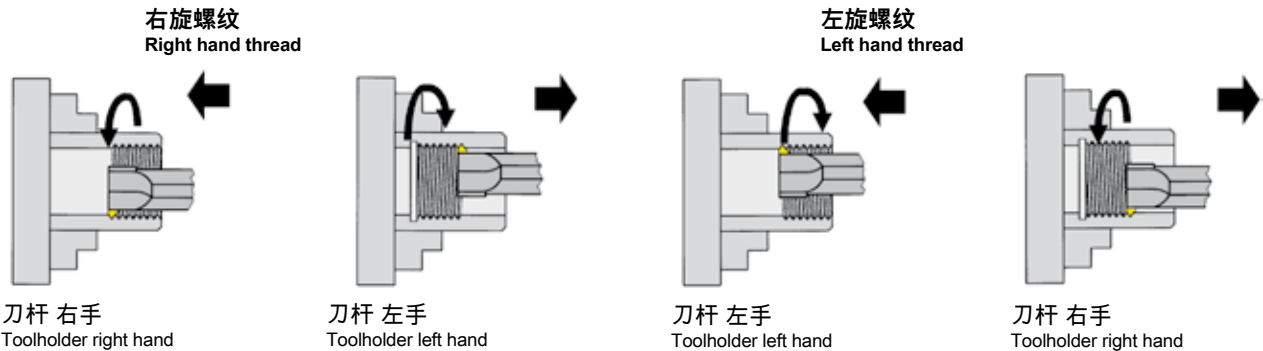
### 推荐切削参数

#### RECOMMENDED NUMBER OF PASSES

硬质合金牌号 / Carbide grade	钢 (N/mm <sup>2</sup> 拉伸强度) / Steel (N/mm <sup>2</sup> Tensile strength)					不锈钢 / Stainless steel	灰铸铁 / Grey cast iron	铝 / Aluminium	
	TN35	400-500	500-700	700-850	850-1150				> 1150
V <sub>max</sub> m/min	160	140	120	90	70	90	100	300	
螺距 / Pitch		程数 / Number of passes							
mm	每英寸齿数 / tpi								
0.8	32	8	8	9	9	10	10	9	8
1.0	24	10	10	12	12	12	12	12	10
1.25	20-19	12	12	14	14	15	15	14	12
1.5	16	15	15	17	17	18	18	17	15
1.75	14	17	17	19	19	21	21	18	17
2.0	12-11	19	20	22	22	25	25	20	18
2.5	10	22	24	26	26	31	31	22	20
3.0-3.5	8	28	30	32	32	38	38	24	22

### 进给率 内圆纹加工

#### FEED RATE internal threading

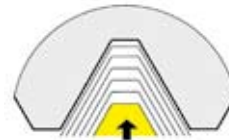


### 进给

#### IN-FEED

#### 径向进给 / RADIAL IN-FEED

同时切削刀片两边的材料，这是加工螺纹时最普通的方法。  
Metal removed on both sides of the insert simultaneously. The most commonly used method for thread production.



#### 改进的侧进给 / MODIFIED FLANK IN-FEED

更小的后刀面磨损和相应的工件侧面上的更好的表面光洁度。  
Less wear of the trailing edge and better surface finish on corresponding flank.



#### 变化的后刀面进给 / ALTERNATING FLANK IN-FEED

两个刃都被充分利用，意味着刀片寿命更长。  
Both edges are being fully utilised which means longer insert life.



#### 后刀面进给 / FLANK IN-FEED

更好的断屑和散热。  
More easily formed chip and better heat dissipation.





## 切断

### PARTING OFF

#### 方形切削刃的可转位刀片

方形切削刃的刀片是加工中的最佳选择，尽可能的使用该类刀片。

优点：

- 增加刀具寿命
- 更好的切屑控制和表面质量
- 可选择更高的切削参数

#### Indexable inserts with square cutting edge

The best selection for applications are inserts with a square cutting edge, wherever possible to use them.

- Advantages:
- increased tool life
  - better swarf control and a high surface quality will be obtained
  - possibility to choose the maximum cutting data

#### 进给率

使用正切削角时进给率最高可能降低40%，这也会受到零件材质的拉伸强度的影响。

#### Feed rates

The feed rate when cutting with front cutting angle will need to be reduced up to 40 %. This may also be influenced by the tensile strength of the material to be cut.

#### 切屑控制

通过选择合适的切削速度和进给率以得到最好的切屑控制和表面光洁度。

#### Swarf control

Best swarf control and highest surface finish will be obtained by choosing the right speed and feed rate.

#### 避免尖角

通过使用左手或右手刀具并调整正确的中心高可以减小尖角和毛刺的发生。

#### Avoiding Pips

By using right or left handed inserts and the correct centre height occurring of pips and burrs can be reduced.

#### 切断时有副主轴或工件夹具

具有副主轴或夹持夹具可以在切断加工时保护切削刃。如果无夹持的话在切断时要求越接近工件中心进给越小。

#### Parting off with a sub spindle or part catcher

The cutting edge will be protected by having a second spindle or fixture to pick up the workpiece. Parting off without a support requires the feed rate to be reduced as the tool approaches centre.

#### 凸或凹曲面

曲面的产生可以通过使用左手或右手刀降低进给率避免。

#### Convex or concave surfaces

Convex or concave surfaces will be avoided when using right or left hand inserts by reducing the feed rate.

#### 冷却

丰富而有目的性的冷却能够延续刀具寿命。

#### Coolant

A copious well aimed coolant supply will give long tool life.

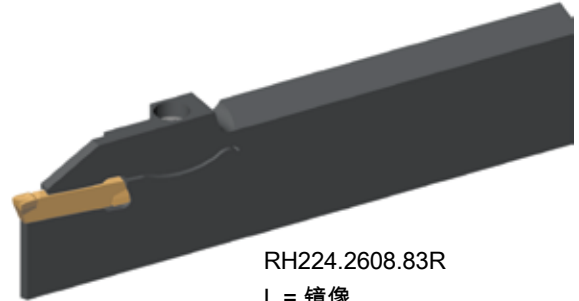
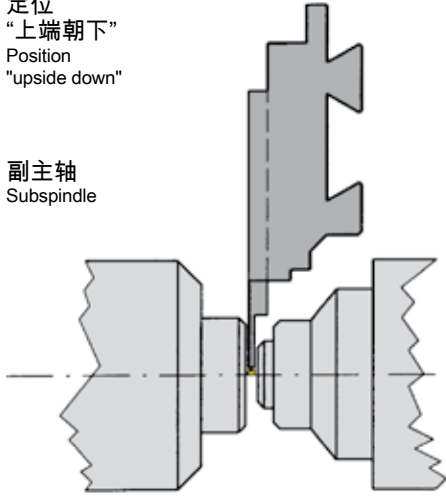
Q  
强化型刀片-定位  
Reinforced Blades - Positioning

定位  
“上端朝下”  
Position  
“upside down”

副主轴  
Subspindle

主轴  
Mainspindle

M4 逆时针  
M4 Anticlockwise



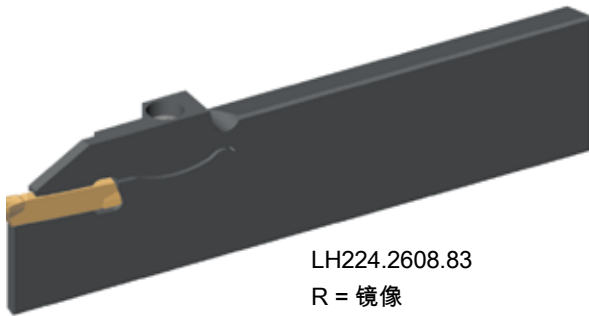
RH224.2608.83R  
L = 镜像  
L = mirror inverted

定位  
“正常”  
Position  
“normal”

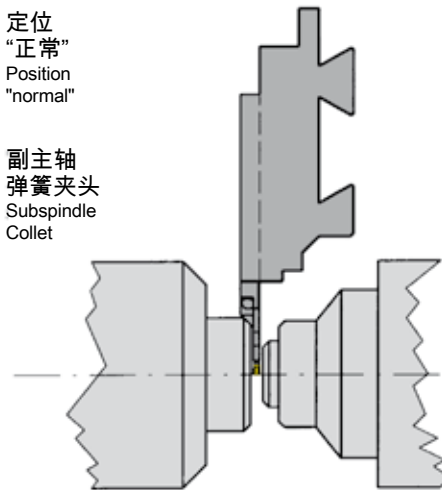
副主轴  
弹簧夹头  
Subspindle  
Collet

主轴  
Mainspindle

M3 顺时针方向  
M3 Clockwise



LH224.2608.83  
R = 镜像  
R = mirror inverted

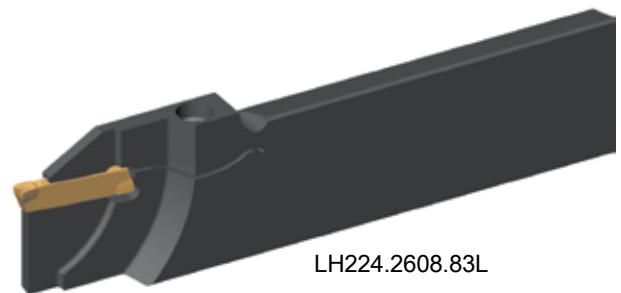
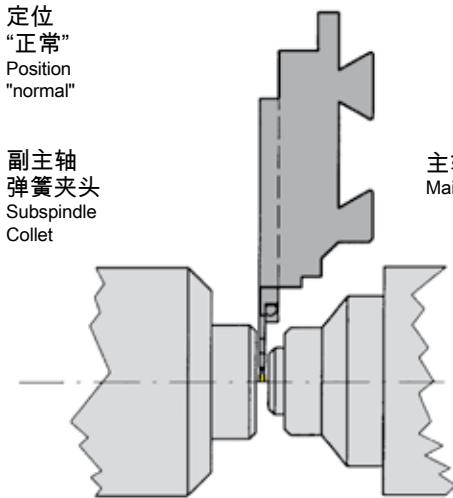


定位  
“正常”  
Position  
“normal”

副主轴  
弹簧夹头  
Subspindle  
Collet

主轴  
Mainspindle

M3 顺时针方向  
M3 Clockwise



LH224.2608.83L  
R = 镜像  
R = mirror inverted

所有的刀片都可增加这些增强结构的非标设计  
These special reinforced form can be produced on all blades.

# 断屑槽和进给率 型号 217

## Geometries and feed rates type 217



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
<p>.00</p> 	<p>切槽，槽精加工，长切屑材料，低进给率</p> <p>grooving, finishing of grooves, for long chipping materials, low feed rates</p>	<p>↓ 0.02 - 0.12</p>
<p>非标刀片的断屑槽 Chipbreaker for special inserts</p> 	<p>切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料</p> <p>grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength</p>	<p>↓ 0.02 - 0.12</p>






↓ 切槽  
Grooving
↔ 侧车削  
Side turning

# 断屑槽和进给率 型号 264/S264

## Geometries and feed rates type 264/S264



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.10 	切槽和切断 Grooving and parting off	↓ 0.02 - 0.08
.20 	切槽和切断 用于加工高拉伸强度的材质 Grooving and parting off for materials high tensile strength	↓ 0.02 - 0.08
.D1 	切槽和车削 Grooving and turning	↓ 0.02 - 0.08 ↔ 0.02 - 0.04 $a_{pmax} = 1.5 \times w$
.M0 	切槽、车削和切断 用于 黄铜 (Ms58) Grooving, turning and parting off for Brass (Ms58)	↓ 0.02 - 0.10 ↔ 0.02 - 0.15
.P0 	切槽和切断 Grooving and parting off	↓ 0.02 - 0.08 ↔ 0.02 - 0.04 $a_{pmax} = 1.5 \times w$




↓ 切槽 Grooving      ↔ 侧车削 Side turning

# 断屑槽和进给率 型号 S274

## Geometries and feed rates type S274



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.10 	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.02 - 0.12
.M. 	切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0.02 - 0.12
.P. 	切槽和车削 (在一个方向) Grooving and turning (in one direction)	↓ 0.02 - 0.10 ↔ 0.02 - 0.10

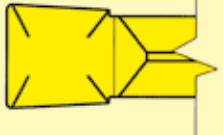
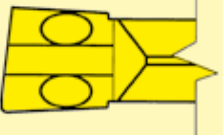
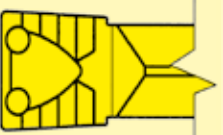
↓ 切槽 Grooving      ↔ 侧车削 Side turning

# 断屑槽和进给率 型号 S119/S223

## Geometries and feed rates type S119/S223



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.3. 	切槽，槽精加工， 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料  grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0.05 - 0.15 ↔ 0.05 - 0.20  $a_{pmax} 1.5$
.C. 	切断，适合长切屑材料  parting off, for long chipping materials	↓ 0.02 - 0.12
.5. 	切槽，侧车削，仿形槽加工，加工中等拉伸强度的材料时能很好的减小切屑宽度  grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0.08 - 0.20 ↔ 0.05 - 0.20  $a_{pmax} 1.5$



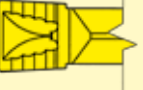
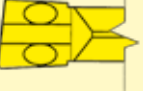
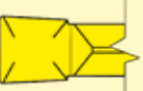
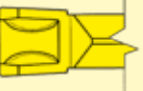
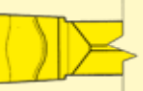
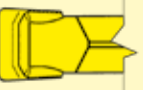

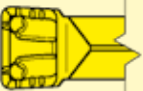
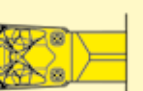
↓ 切槽 Grooving      ↔ 侧车削 Side turning

# 断屑槽和进给率 型号 S224

## Geometries and feed rates type S224



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.3. 	切槽，侧车削，仿形槽加工，适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0.15 - 0.25 ↔ 0.15 - 0.40*
.5. 	切槽，侧车削，仿形槽加工，加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0.10 - 0.45 ↔ 0.15 - 0.60*
.A. 	切槽，侧车削，仿形槽加工，加工中等拉伸强度材料时出色的断屑性能 grooving, side turning, finishing or profiling of grooves, excellent chip breaking in materials with medium tensile strength	↓ 0.05 - 0.30 ↔ 0.10 - 0.30*
.C. 	切断，适合长切屑材料 parting off, for long chipping materials	↓ 0.02 - 0.10
.D. 	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.05 - 0.15 ↔ 0.05 - 0.20
.E./EN. 	切槽，侧车削，仿形槽加工，适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0.08 - 0.30
.F./FY 	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.03 - 0.15
.H. 	啄削槽，局部轮廓切削，长切屑 grooving in "pecking process", profiling in partial cut, for long chipping	↓ 0.15 - 0.25 ↔ 0.10 - 0.25
.K./KF 	切槽，侧车削，仿形槽加工 grooving, side turning, finishing or profiling of grooves	↓ 0.05 - 0.25 ↔ 0.05 - 0.25
.L. 	全刃或局部切削时都有良好的切屑控制 grooving in full and partial cut with excellent chip control	↓ 0.10 - 0.22 ↔ 0.05 - 0.20
.ZG. 	切槽，侧车削，仿形槽加工 grooving, side turning, profiling of grooves	↓ 0.10 - 0.22 ↔ 0.05 - 0.20

\* 决定于刀片宽度，刃尖圆角和材质  
\* dependent upon insert width, edge radii and material

↓ 切槽  
Grooving

↔ 侧车削  
Side turning

# 断屑槽和进给率 型号 229/S229

## Geometries and feed rates type 229/S229



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.10	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.05 - 0.15
.20	切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0.07 - 0.25
.3.	切槽，侧车削，仿形槽加工，适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ ↔ 0.15 - 0.40*
.5.	切槽，侧车削，仿形槽加工，加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ ↔ 0.15 - 0.60*
.A.	切槽，侧车削，仿形槽加工，加工中等拉伸强度材料时出色的断屑性能 grooving, side turning, finishing or profiling of grooves, excellent chip breaking in materials with medium tensile strength	↓ ↔ 0.10 - 0.30*
.C.	切断，适合长切屑材料 parting off, for long chipping materials	↓ 0.02 - 0.10
.E./EN	切槽，侧车削，仿形槽加工，适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0.08 - 0.30
.F./FY	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.03 - 0.15
.H.	啄削槽，局部轮廓切削，长切屑 grooving in "pecking process", profiling in partial cut, for long chipping	↓ ↔ 0.10 - 0.25
.HR.	全刃或局部切削时都有良好的切屑控制 grooving in full and partial cut with excellent chip control	↓ 0.20 - 0.30
.L.	全刃或局部切削时都有良好的切屑控制 grooving in full and partial cut with excellent chip control	↓ ↔ 0.05 - 0.20
.K./KF	切槽，侧车削，仿形槽加工 grooving, side turning, finishing or profiling of grooves	↓ ↔ 0.05 - 0.25

\* 决定于刀片宽度，刃尖圆角和材质  
\* dependent upon insert width, edge radii and material

↓ 切槽 Grooving      ↔ 侧车削 Side turning



# 断屑槽和进给率 型号 231

## Geometries and feed rates type 231



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.10 	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.02 - 0.12
.20 	切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0.02 - 0.12
.30 	切槽，侧车削，仿形槽加工，适合长切屑和高拉伸强度的材料 grooving, side turning, profiling and finishing of grooves, for long chipping materials with high tensile strength	↓ 0.15 - 0.25 ↔ 0.15 - 0.40*

\* 决定于刀片宽度，刃尖圆角和材质  
\* dependent upon insert width, edge radii and material

↓ 切槽 Grooving ↔ 侧车削 Side turning

Q

切槽和侧车削的三刃刀片-精密烧结断屑槽

Triple edge for grooving and side-turning  
with precision **sintered** geometrie

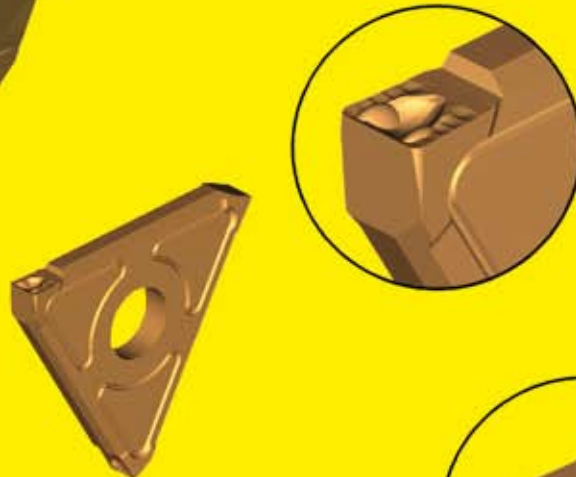
断屑槽  
Geometry **.F**

进给率  
Feed rate  
 $f = 0.03 - 0.15 \text{ mm}$



断屑槽  
Geometry **.5**

进给率  
Feed rate  
 $f = 0.08 - 0.25 \text{ mm}$



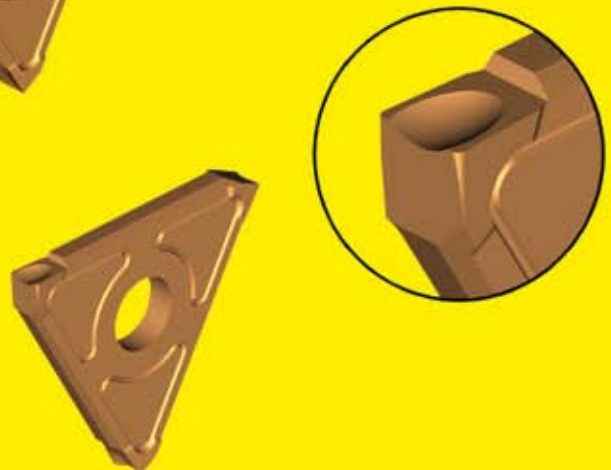
断屑槽  
Geometry **.D**

进给率  
Feed rate  
 $f = 0.03 - 0.15 \text{ mm}$



断屑槽  
Geometry **.C**

进给率  
Feed rate  
 $f = 0.02 - 0.15 \text{ mm}$


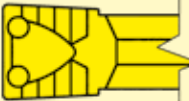


# 断屑槽和进给率 型号 312/S312

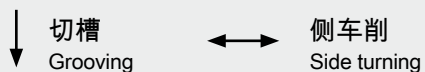
## Geometries and feed rates type 312/S312



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.00  312	切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0.02 - 0.12
非标刀片的断屑槽  Chipbreaker for special inserts 312	切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0.02 - 0.12
.V.  312	切槽，出色的切削控制 grooving, with excellent chip control	↓ 0.04 - 0.15
.F.  S312	切槽，仿形槽加工，易切削 grooving, profiling of grooves, easy cut	↓ 0.03 - 0.15
.5.  S312	切槽，侧车削，仿形槽加工，加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0.08 - 0.25 ↔ 0.15 - 0.30*
.D.  S312	切槽，仿形槽加工，适合加工拉伸强度材料 grooving, profiling of grooves, suitable for materials with high tensile strength	↓ 0.03 - 0.15
.C.  S312	切断，切槽 parting off, grooving	↓ 0.02 - 0.10

\* 决定于刀片宽度，刃尖圆角和材质  
\* dependent upon insert width, edge radii and material



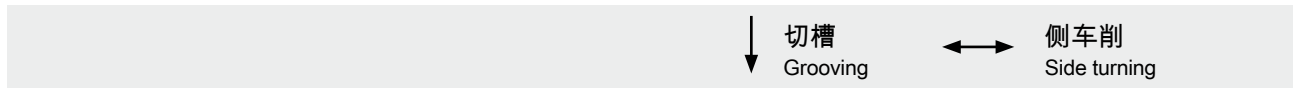
# 断屑槽和进给率 型号 315

## Geometries and feed rates type 315



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
<p>.00</p> 	<p>切槽，槽精加工，长切屑材料，低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates</p>	<p>↓ 0.02 - 0.12</p>
<p>非标刀片的断屑槽</p>  <p>Chipbreaker for special inserts</p>	<p>切槽，槽精加工，刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength</p>	<p>↓ 0.02 - 0.12</p>



# 断屑槽和进给率 型号 S316

## Geometries and feed rates type S316



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.5. 	切槽，侧车削，仿形槽加工，加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0.06 - 0.25
.EN. 	切槽，侧车削，仿形槽加工，适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0.08 - 0.20
.FY. 	切槽，精加工槽，长屑材料，“低进给率”出色切屑控制 grooving, finishing of grooves, for long chipping materials, "low feed rates" with excellent chip control	↓ 0.03 - 0.15


↓ 切槽 Grooving      ↔ 侧车削 Side turning

# 断屑槽和进给率 切断

## Geometries and feed rates Parting off



Q

断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)	可选的几何槽型和前角 Available geometries and lead angle							
			S100	S123/S223	S274	S264	S224	229/S229	312/S312	S316
 .00	切断 Parting off	0.02 - 0.10							0°	
		0.02 - 0.08							5°	
	薄壁零件切断 Tubes with small thickness	0.02 - 0.06				8°			8°	
		0.02 - 0.05			15°	15°			12°	
 .00	切断带断屑槽 Parting off with chip former	0.02 - 0.15							0°	
		0.02 - 0.15							5°	
 .M.	切断脆性材料 (MS58) Parting off brittle materials (MS58)	0.02 - 0.15							0°	
		0.02 - 0.15							5°	
		0.02 - 0.12				8°				
		0.02 - 0.10				15°				
 .V.	切断带切屑成型 Parting off with chip forming	0.02 - 0.12							0°	
		0.02 - 0.08							5°	
 .C.	切断 Parting off	0.02 - 0.10		0°			0°	0°	0°	
		0.02 - 0.08		4°			5°	5°	5°	
		0.02 - 0.06		8°			8°	8°	8°	
		0.02 - 0.05		15°			15°			
 .E.	切断 Parting off	0.02 - 0.12	0°				0°	0°		
		0.05 - 0.12	5°				5°			
 .EN	切断 Parting off	0.10 - 0.25	0°				0°	0°		0°
		0.10 - 0.20	5°							
 *.D. (.32)	切断 Parting off	0.02 - 0.10		0°			0°		0°	
 .F.	切断 Parting off	0.02 - 0.12	0°				0°	0°		
		0.02 - 0.10	5°				5°			
 .3.	切断 Parting off	0.10 - 0.15					0°	0°		
		0.08 - 0.12						5°		

\* 仅 刀片 S123 / S223

\* only Inserts S123 / S223

# 切削参数 切槽和切断

## Cutting data Grooving and parting off



Q

材料 Material	硬度 Hardness Brinell (HB)	切削速度 $v_c$ (m/min) Cutting speed $v_c$ (m/min)												
		K10	MG12	P20	TI22 TN32	TI25 TN35	TF45 TA45 TH35	TF46 TA46	AS62	AL96 AS66	H20	H54		
<b>P</b> 碳钢 Carbon steel	0,2% C	140			180-120	200-160	180-130	200-160	280-180	250-180	300-180	230-170	200-140	
	0,4% C	180			160-110	180-150	170-120	180-150	250-140	230-170	270-150	220-160	180-120	
	0,6% C	200			140-90	180-140	150-100		230-120	220-160	250-120	210-150	160-100	
	合金钢 Alloyed steel (<5%)	退火 annealed	180			140-100	180-140	160-110	180-140	230-100	200-150	250-100	210-150	180-120
		淬火 quenched	280			110-90	160-110	130-90		190-90	160-110	220-90	170-120	160-100
		淬火 quenched	350			80	140-90	100-70		170-80	130-100	200-80	140-80	120-80
	高合金钢 high alloyed steel (>5%)	退火 annealed	200			120-80	120-90			200-140	180-120	220-140	120-100	100-90
		硬化 hardened	-											
	铸钢 Cast steel	非合金 unalloyed	180				130-100				200-150	200-150	180-120	
		合金 alloyed	220				110-80				160-100	150-90	140-90	
<b>M</b> 不锈钢 Stainless steel	马氏体, 铁素体 martensitic, ferritic	200		90-70		130-100	120-60		180-120	170-120	190-140	190-120		
	奥氏体 austenitic	180		90-60			100-70		140-110		140-110	170-120		
<b>K</b> 灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	180	90-60	80-60				130-90	180-120	180-120	200-120			
	高拉伸强度 high tensile strength	250	90-60	80-60				90-70	140-100	140-100	160-120			
	球墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160				90-70	90-70	120-80	170-90	170-90	180-130		
		珠光体 perlitic	250				70-60	70-60	110-80	180-80	150-80	160-120		
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125		100-80		140-120	100-70		120-100	190-140	220-120		
		珠光体 perlitic	225		70-50		100-80	80-60		90-80	140-100	190-100		
<b>N</b> 铝合金 Al-alloys	不进行热处理 not heat treatable	30-80	1000-600	800-400				1000-600						
	可热处理 heat treatable	80-120	400-220	300-200				400-220						
	铸铝合金 Al-cast-alloy	不进行热处理 not heat treatable	80	1000-600	800-400				1000-600					
		可热处理 heat treatable	100	600-300	400-250				600-300					
	铜合金 Copper-alloys	不进行热处理 not heat treatable	90	200-120			200-150	210-130		200-150				
		可热处理 heat treatable	100	150-90			150-60	160-90		150-110				
<b>S</b> 耐热合金 Heat resistant alloy (Fe)	退火 annealed	200		50-30			50-30							
	硬化 hardened	275		40-20			40-20							
	耐热合金 Heat resistant alloy (Ni, Co)	退火 annealed	250		30-20			30-20						
		硬化 hardened	350		20-10			20-10						

# 切削参数 端面切槽

## Cutting data Face grooving



Q

材料 Material	硬度 Hardness Brinell (HB)	切削速度 $v_c$ (m/min) Cutting speed $v_c$ (m/min)												
		K10	MG12	P20	TI22 TN32	TI25 TN35	TF45 TA45 TH35	TF46 TA45	AS62	AS66	H20	H54		
<b>P</b> 碳钢 Carbon steel	0,2% C	140			140-100	160-130	140-110	160-130	220-140	200-140	240-140	190-140	200-140	
	0,4% C	180			130-90	140-120	130-100	140-120	200-120	190-130	220-120	180-130	180-120	
	0,6% C	200			120-80	140-120	120-180		190-100	180-130	200-100	170-120	160-100	
	合金钢 Alloyed steel (<5%)	退火 annealed	180			120-80	140-120	140-100	140-120	190-80	160-120	200-80	170-120	180-120
		淬火 quenched	280			90-70	140-90	110-80		170-80	140-90	180-80	140-100	160-100
		淬火 quenched	350			60	120-70	80-60		140-60	110-80	160-70	120-60	120-80
	高合金钢 high alloyed steel (>5%)	退火 annealed	200			100-60	100-70			160-120	150-100	180-120	110-80	100-90
		硬化 hardened	-											
	铸钢 Cast steel	非合金 unalloyed	180				110-80				160-120	160-120	140-100	
合金 alloyed		220				90-60				140-80	120-80	120-80		
<b>M</b> 不锈钢 Stainless steel	马氏体, 铁素体 martensitic, ferritic	200		80-60		110-80	110-50		160-100	130-110	150-120	150-100		
	奥氏体 austenitic	180		60-40			80-60		120-100		110-80	140-100		
<b>K</b> 灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	180	70-50	70-50				110-70	140-100	140-100	160-100			
	高拉伸强度 high tensile strength	250	70-50	70-50				80-60	120-80	120-80	140-100			
	球墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160				90-60	80-60	100-60	140-80	150-70	150-110		
		珠光体 perlitic	250				80-60	60-50	90-60	130-70	120-60	140-100		
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125		80-60		120-100	80-60		100-80	160-110	180-100		
珠光体 perlitic		225		60-40		80-60	60-50		80-60	120-80	150-120			
<b>N</b> 铝合金 Al-alloys	不进行热处理 not heat treatable	30-80	1000-600	800-400			1000-600							
	可热处理 heat treatable	80-120	400-220	300-200			400-220							
	铸铝合金 Al-cast-alloy	不进行热处理 not heat treatable	80	1000-600	800-400			1000-600						
		可热处理 heat treatable	100	600-300	400-250			600-300						
	铜合金 Copper-alloys	不进行热处理 not heat treatable	90	160-100			160-130	190-110						
		可热处理 heat treatable	100	130-80			130-60	140-80						
<b>S</b> 耐热合金 Heat resistant alloy (Fe)	退火 annealed	200		40-30			40-30							
	硬化 hardened	275		35-20			35-20							
	耐热合金 Heat resistant alloy (Ni, Co)	退火 annealed	250		25-20			20-10						
		硬化 hardened	350		20-10			20-10						



### Horn各牌号对应的名义切削速度

Nominal cutting speeds with HORN grades

材料 Material	硬度 Hardness Brinell (HB)	* 切削速度 $v_c$ (m/min) *Cutting speed $v_c$ (m/min)					
		MG12	TN35	TI25	TF45 / TA45 / TH35		
<b>P</b> 碳钢, 非合金 Carbon steel, unalloyed	C < 0.4%	125	14-110	14-180	14-180	14-180	
	C > 0.4% < 0.6%	150	14-110	14-180	14-180	14-180	
	C > 0.6% < 0.8%	200	14-110	14-180	14-180	14-180	
	低合金钢 low alloyed steel	退火 annealed	180	16-90	16-150	16-150	
		淬火 quenched	275	16-90	16-150	16-150	
		淬火 quenched	160	16-90	16-150	16-150	
	高合金钢 high alloyed steel	退火 annealed	200		19-90	19-90	
		淬火 quenched	325		19-90	19-90	
	铸钢 Cast steel	非合金 unalloyed	180	19-110	19-180	19-180	
		低合金 low alloyed	200	19-110	19-180	19-180	
高合金 high alloyed		225	19-110	19-180	19-180		
<b>M</b> 不锈钢 Stainless steel	马氏体, 铁素体, 退火 martensitic, ferritic, annealed	200		19-90	19-90		
	奥氏体 austenitic Ni>8%/Cr 18-20%	180		16-80			
<b>N</b> 铝合金 Al-alloys			14-220	16-600	16-600		
	铜和黄铜合金类 Copper and brass alloys		14-220	14-700	14-700		
<b>S</b> 耐热合金 Heat resistant alloy	NiFe			18-75	18-75		
	NiCo			18-40	18-40		

$v_c$  决定于孔径及机床的最大转速。

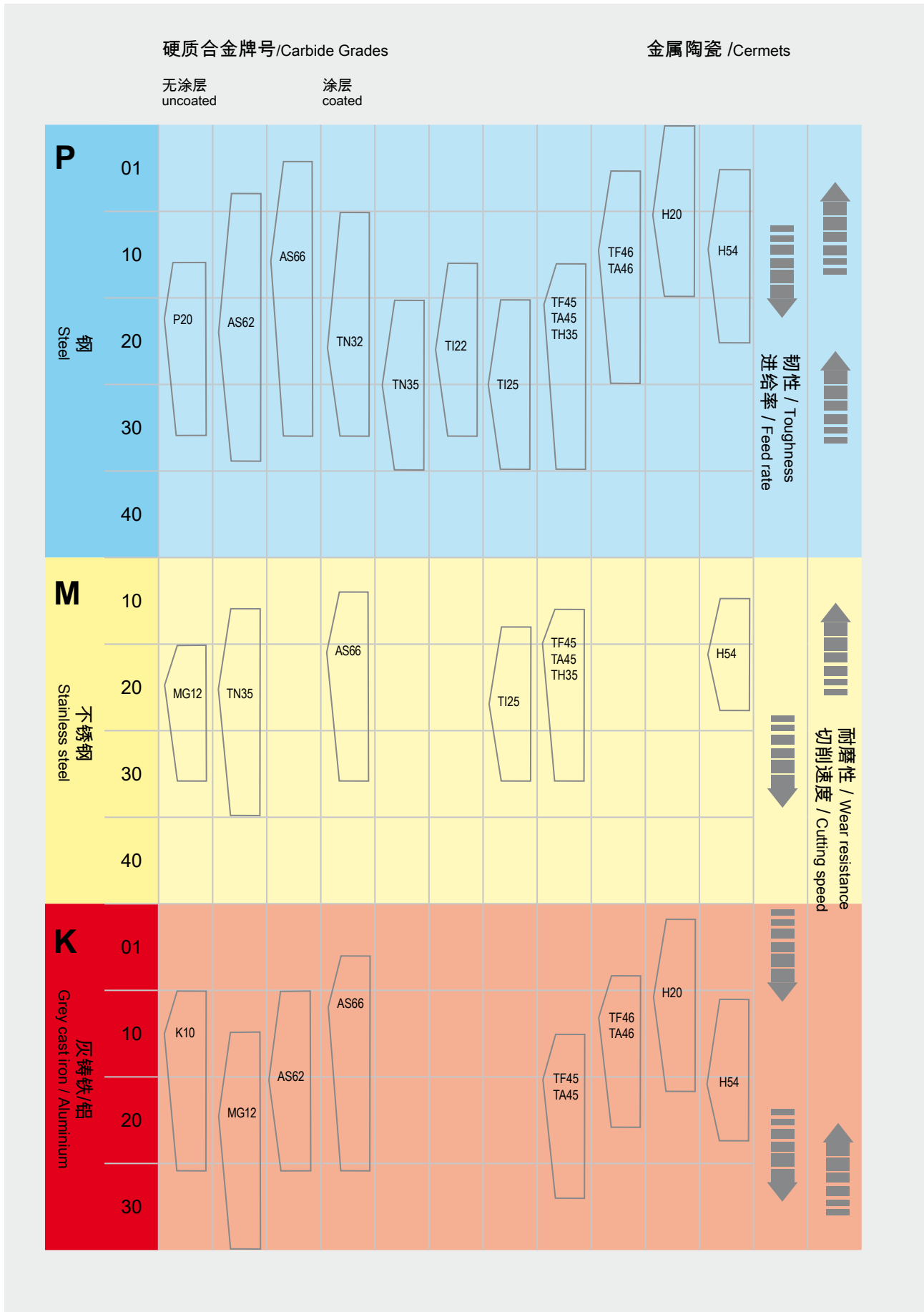
$v_c$  is depending on the bore diameter and therefore of the maximum numbers of revolutions of the machine.

# 用于切槽和切断的硬质合金牌号

## Carbide grades for grooving and parting off



Q



# 用于切槽和切断的硬质合金牌号

## Carbide grades for grooving and parting off



Q

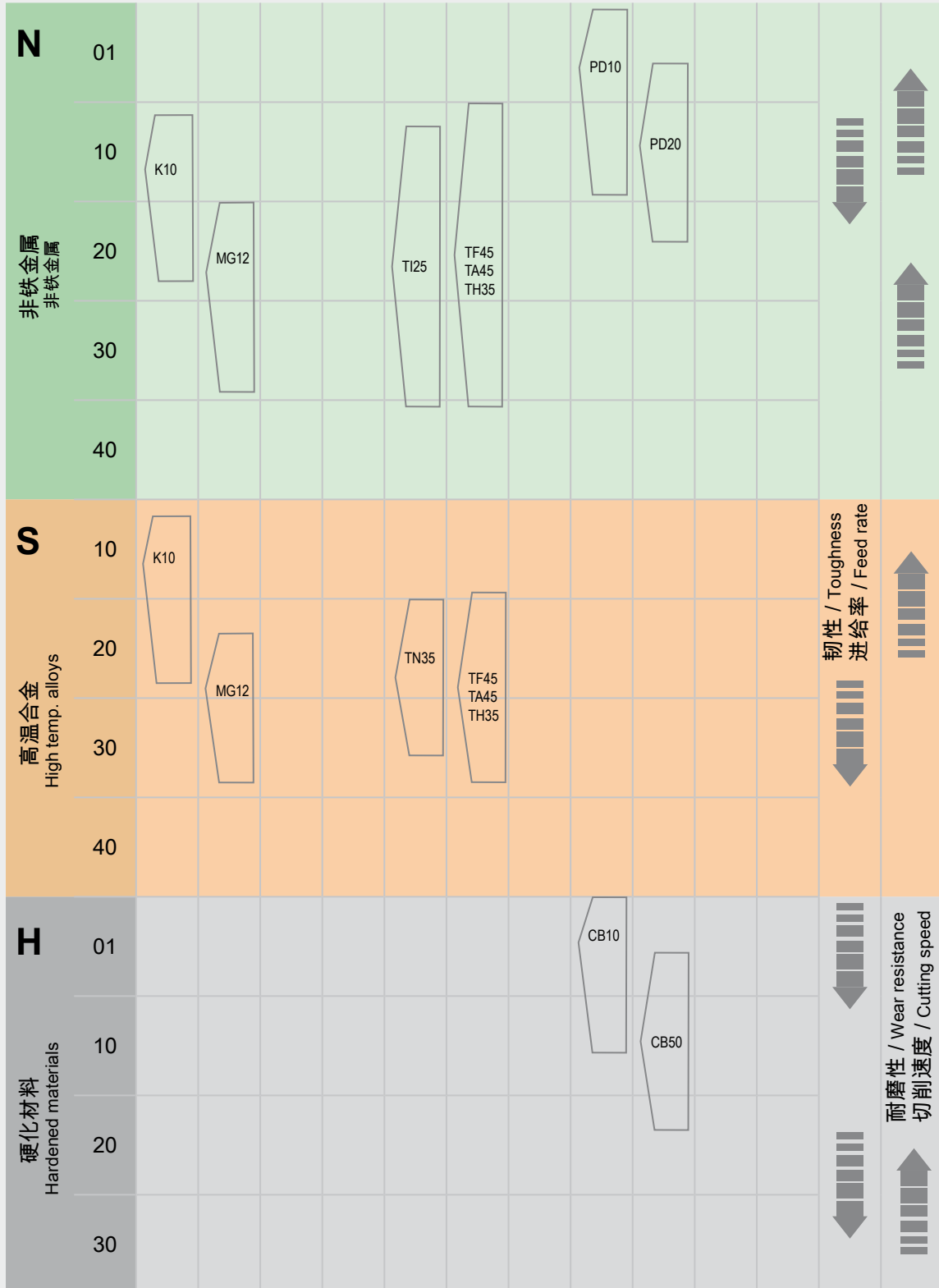
硬质合金牌号/Carbide Grades

合成切削刀具材料

Synthetic cutting-tool material

无涂层  
uncoated

涂层  
coated



HORN-牌号	ISO513	性能	工件材质	推荐应用
<b>H20</b>	HT	金属陶瓷	碳钢， 低合金钢， 铸钢，不锈钢，特种合金	适于切槽和精加工，适于最佳的表面质量，不易产生积屑瘤，耐磨损
<b>H54</b>	HT	金属陶瓷	碳钢， 低合金钢， 铸钢，不锈钢，特种合金	适于切槽和精加工，适于最佳的表面质量，不易产生积屑瘤，耐磨损
<b>P20</b>	HW	无涂层牌号	钢，铸钢， 可锻铸铁	适用于中等切削速度切槽和精加工
<b>AS62</b>	HC	TiAlN-涂层	钢，铸钢 可锻铸铁	适于高速切槽和精加工
<b>AS66</b>	HC	TiAlN-涂层	钢、铸钢、可锻铸铁、马氏体不锈钢	用于切槽和精加工，高切削速度，热抗性，干切削稳定
<b>AL96</b>	HC	多层涂层(Al <sub>2</sub> O <sub>3</sub> )	钢、铸钢、可锻铸铁、马氏体不锈钢	用于高切削速度、较高热抗性的开槽和精加工，适用于干式切削
<b>TN32</b>	HC	TiN-涂层	钢，铸钢 可锻铸铁	适用于切槽和精加工，高速切削
<b>TN35</b>	HC	TiN-涂层	钢，铸钢， 可锻铸铁， 马氏体不锈钢	适用于切槽和精加工，低切削速度，螺纹加工，不理想加工条件
<b>TI22</b>	HC	TiCN-涂层	钢，铸钢 可锻铸铁	适用于高速切削下切槽和精加工
<b>TI25</b>	HC	TiCN-涂层	钢，铸钢 可锻铸铁， 马氏体不锈钢	适用于切槽和精加工，低切削速度，螺纹加工，不理想加工条件
<b>TH35 AS6G</b>	HC	TiAlN-涂层	钢，铸钢， 可锻铸铁， 马氏体不锈钢	用于切槽和精加工，高切削速度，热抗性，干切削稳定
<b>TA45 TF45</b>	HC	TiAlN-涂层	钢，铸钢， 可锻铸铁， 马氏体不锈钢	适用于高切削速度下切槽和精加工，油冷
<b>TA46 TF46</b>	HC	TiAlN-涂层	钢，铸钢， 可锻铸铁， 马氏体不锈钢	适用于切槽和精加工，高切削速度，热抗性，适用于干切削
<b>K10</b>	HW	无涂层牌号	灰铸铁，可锻铸铁，硅铝和铜合金，耐热合金	用于切槽和精加工
<b>MG12</b>	HW	无涂层牌号 (微粒)	灰铸铁，可锻铸铁，铝和铜合金，耐热性合金	适用于不利条件下低速切槽和精加工

根据要求提供PCD或CBN刀片。

可以在样本和价格或库存清单中查有库存的硬质合金牌号。  
未提及的牌号只提供给稳定的订单。

# Description carbide grades



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HORN-Grades	ISO513	Properties	Workpiece material	Recommended applications
<b>H20</b>	HT	Cermet	carbon steels, low alloyed steels, cast steel, stainless steel, exotic alloys	for grooving and finishing, for best surface qualities, no tendency to built up edge, resistant to wear
<b>H54</b>	HT	Cermet	carbon steels, low alloyed steels, cast steel, stainless steel, exotic alloys	for grooving and finishing, for best surface qualities, no tendency to built up edge, resistant to wear
<b>P20</b>	HW	uncoated grades	steel, cast steel, malleable cast iron	for grooving and finishing at moderate cutting speed
<b>AS62</b>	HC	TiAlN-Coating	steel, cast steel, malleable cast iron,	for grooving and finishing at high cutting speed
<b>AS66</b>	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
<b>AL96</b>	HC	multilayer coating (AL <sub>2</sub> O <sub>3</sub> )	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at very high cutting speed, heat resistant, suitable for dry cutting
<b>TN32</b>	HC	TiN-Coating	steel, cast steel, malleable cast iron	for grooving and finishing, at high cutting speed
<b>TN35</b>	HC	TiN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at low cutting speed, thread cutting, unfavourable conditions
<b>TI22</b>	HC	TiCN-Coating	steel, cast steel, malleable cast iron	for grooving and finishing at high cutting speed
<b>TI25</b>	HC	TiCN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at low cutting speed, thread cutting, unfavourable conditions
<b>TH35 AS6G</b>	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
<b>TA45 TF45</b>	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing at low cutting speed, cooling with oil
<b>TA46 TF46</b>	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
<b>K10</b>	HW	uncoated grades	grey cast iron, malleable cast iron, Si-aluminium and copper alloys, heat resistant alloys	for grooving and finishing
<b>MG12</b>	HW	uncoated grades (micro grain)	grey cast iron, malleable cast iron, aluminium and copper alloys, heat resistant alloys	for grooving and finishing, at low cutting speed, unfavourable conditions

PCD- or CBN-tipped inserts upon request .

Carbide grades on stock are shown in the catalogue or in the price- and stocklist.  
Not mentioned grades can be supplied only against firm order..

# 硬质合金涂层描述

## Description carbide grades



Q

HORN- 牌号	ISO513	工件材质	推荐应用
CB07	BN	淬硬钢 > 56 HRC , 非断续切削	<b>满切切槽</b> vc ≈ 150 m/min , f = 0.03 - 0.04 mm <b>精加工</b> ap 0.1 - 0.2 mm vc ≈ 160 m/min , f = 0.04 - 0.08 mm
		淬硬钢 > 56 HRC , 非断续切削	<b>满切切槽</b> vc ≈ 140 m/min , f = 0.03 - 0.04 mm <b>精加工</b> ap 0.1 - 0.2 mm vc ≈ 150 m/min , f = 0.04 - 0.08 mm
CB50	BN	淬硬钢 > 56 HRC , 断续切削	<b>满切切槽</b> vc ≈ 140 m/min , f = 0.03 - 0.04 mm <b>精加工</b> ap 0.1 - 0.2 mm vc ≈ 150 m/min , f = 0.04 - 0.08 mm
		灰铸铁, 珠光体	<b>满切切槽</b> vc ≈ 1200 m/min , f = 0.1 - 0.25 mm <b>部分切削</b> ap 0.3 - 1.0 mm vc ≈ 1300 m/min , f = 0.2 - 0.4 mm
		球墨铸铁	<b>满切切槽</b> vc ≈ 900 m/min , f = 0.07 - 0.2 mm <b>部分切削</b> ap 0.1 - 0.7 mm vc ≈ 1000 m/min , f = 0.1 - 0.3 mm

根据要求提供PCD或CBN刀片。

可以在样本和价格或库存清单中查有库存的硬质合金牌号。未提及的牌号只提供稳定的订单。

HORN- Grades	ISO513	Workpiece material	Recommended applications
CB07	BN	hardened Steel > 56 HRC, non interrupted cut	<b>Grooving in full material</b> vc ≈ 150 m/min, f = 0,03 - 0,04 mm <b>Finishing</b> with ap 0,1 - 0,2 mm vc ≈ 160 m/min, f = 0,04 - 0,08 mm
		hardened Steel > 56 HRC, non interrupted cut	<b>Grooving in full material</b> vc ≈ 140 m/min, f = 0,03 - 0,04 mm <b>Finishing</b> with ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
CB50	BN	hardened Steel > 45 HRC, interrupted cut	<b>Grooving in full material</b> vc ≈ 140 m/min, f = 0,03 - 0,04 mm <b>Finishing</b> with ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
		Grey cast iron, perlitic	<b>Grooving in full material</b> vc ≈ 1200 m/min, f = 0,1 - 0,25 mm <b>Partial cut</b> with ap 0,3 - 1,0 mm vc ≈ 1300 m/min, f = 0,2 - 0,4 mm
		Spheroidal graphite cast iron	<b>Grooving in full material</b> vc ≈ 900 m/min, f = 0,07 - 0,2 mm <b>Partial cut</b> with ap 0,1 - 0,7 mm vc ≈ 1000 m/min, f = 0,1 - 0,3 mm

PCD- or CBN-tipped inserts upon request .

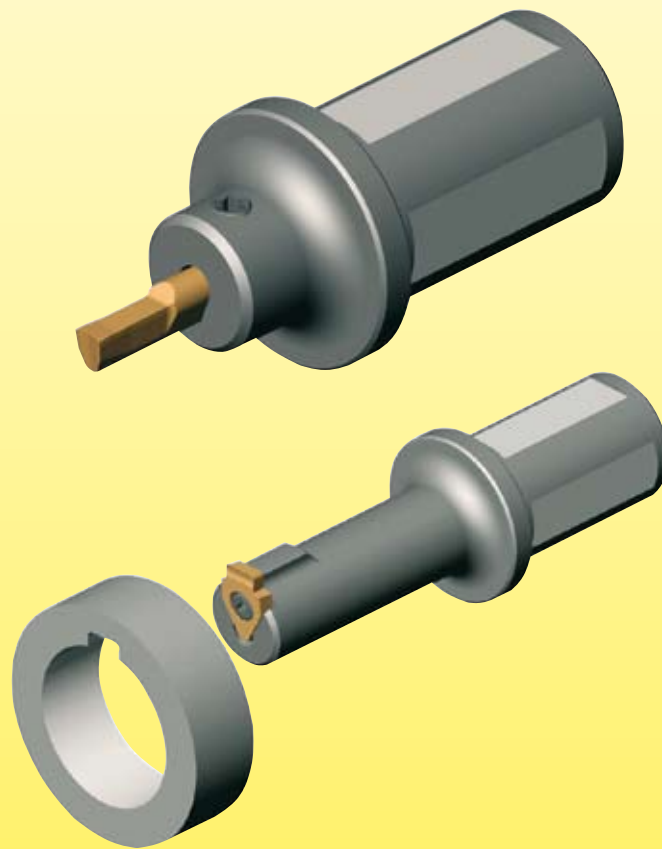
Carbide grades on stock are shown in the catalogue or in the price- and stocklist..  
Not mentioned grades can be supplied only against firm order..

## 插削 用于CNC机床

插削刀具 型号 SB105/SB110 和 SH117

### BROACHING on CNC machines

BROACHING TOOLS TYPE SB105/SB110 and SH117



直接安装于车床或铣床上，也可安装于以下公司的专用插削装置上：

For direct mounting in lathes and mills as well as mounting  
in a live broaching attachment from the companies:

- BENZ
- EWS
- Schwarzer
- AR2P

# HCG - HORN Catalogue Guide

## 插削 / BROACHING

### 键槽 Keyways

宽 Width	孔径自 Bore Ø from									
	6.0	6.5	9.0	14.0	17.0	22.0	27.0	30.0	38.0	65.0
2.0	N105									
3.0		N105		S117						
4.0		N105	N110	S117						
5.0			N110	S117	S117					
6.0					S117					
7.0							S117			
8.0						S117				
10.0								S117		
12.0									S117	
> 12.0										S117

### 内六角 Hexagon socket

扳手型号 SW Wrench size SW	底孔 Pilot Ø		
	SW	SW+0.1	SW+0.2
2.5 - 2.9	N105		
2.9 - 3.5	N105		
3.5 - 4.0	N105		
4.0 - 4.5	N105		
4.5 - 5.0	N105		
5.0 - 6.0		N105	
8.0 - 10.0		N105	
10.0 - 14.0		N110	
14.0 - 16.5		N110	
16.5 - 18.0			N110

### TORX

Torx	底孔 Pilot Ø			
	2.41	2.85	3.24	4.03
T15	N105			
T20		N105		
T25			N105	
T30				N105

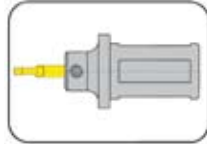


插削 105 / 110 / 117

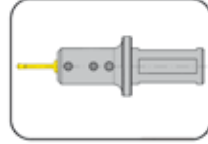
BROACHING 105 / 110 / 117

R

刀杆 型号  
Toolholder type  
105 / 110

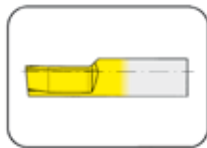


页 / Page  
R4-R8



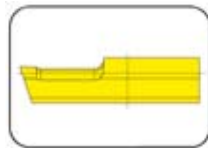
页 / Page  
R9-R10

刀片 型号  
Insert type  
105 / 110



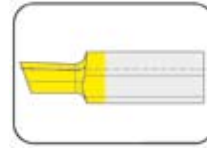
键槽  
Keyways

页 / Page  
R11-R13



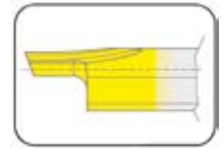
倒角  
Chamfering

页 / Page  
R14



内六角  
Hexagon socket

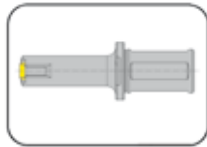
页 / Page  
R15



Torx

页  
R16

刀杆 型号  
Toolholder type  
117



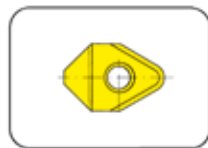
页 / Page  
R18-R24

刀片 型号  
Insert type  
117



键槽  
Keyways

页 / Page  
R26-R28



倒角  
Chamfering

页 / Page  
R29

技术信息  
Technical Information

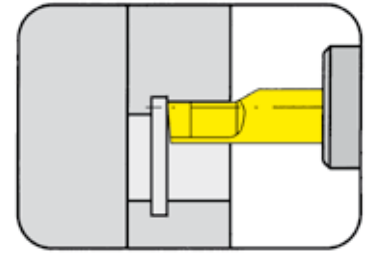
页 / Page  
R17, R30-R40

技术说明见章节Q

For Technical Instructions please see chapter Q

刀杆 型号  
TOOLHOLDER Type

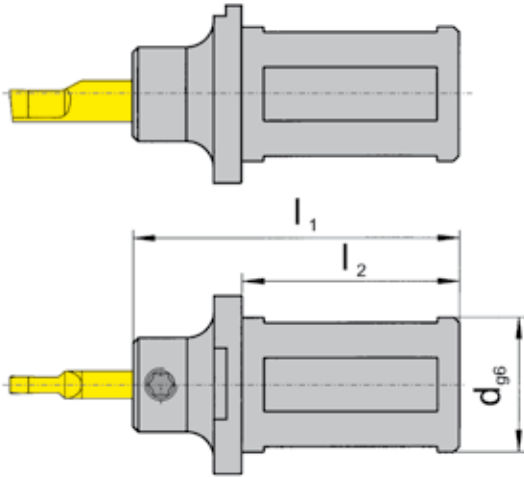
**SB105**



孔径Ø 自 Bore Ø from 6.0 mm

配合 刀片  
for use with Insert

型号 N105  
Type



产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>SB105.0020.1.01</b>	20	60	40	<b>6</b>
<b>SB105.0022.1.01</b>	22	60	40	<b>6</b>
<b>SB105.0025.1.01</b>	25	60	40	<b>6</b>

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

刀片的夹持长度=12mm!  
Clamping length of inserts = 12 mm!

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

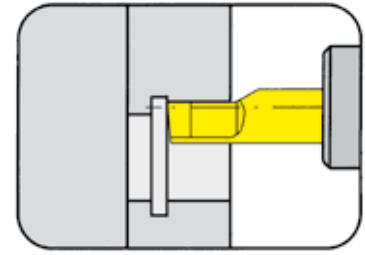
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB105.002...	<b>6.075T15P</b>	<b>T15PQ</b>

# 插削 BROACHING



刀杆 型号  
TOOLHOLDER Type

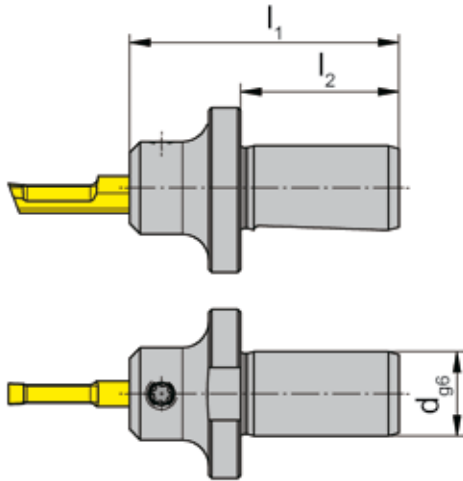
## SB105



R

孔径Ø 自	Bore Ø from	6.0 mm
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只适用于插削动力座EWS-Slot和BENZ LinA  
only usable for broaching devices EWS-Slot and BENZ LinA



配合 刀片  
for use with Insert

型号 N105  
Type

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
SB105.0016.E1.01	16	51	30	6

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

刀片的夹持长度=12mm!  
Clamping length of inserts = 12 mm!

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

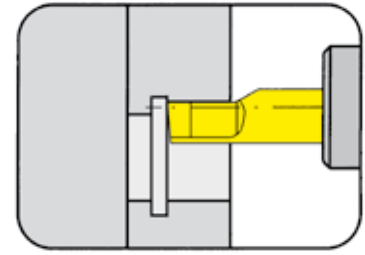
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB105.0016.E1.01	6.075T15P	T15PQ

# 插削 BROACHING



刀杆 型号  
TOOLHOLDER Type

## B105

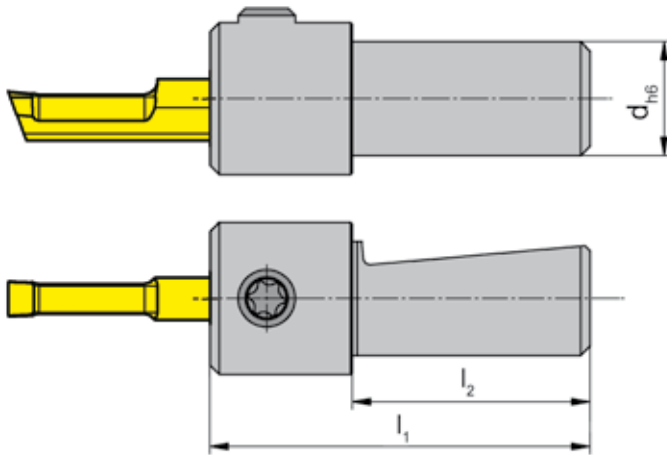


孔径Ø 自 Bore Ø from 6.0 mm

用于插削动力座Schwarzer  
for broaching device Schwarzer

配合 刀片  
for use with Insert

型号 N105  
Type



产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>B105.0012.0220</b>	12	40	25	<b>6</b>

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

刀片的夹持长度=12mm!  
Clamping length of inserts = 12 mm!

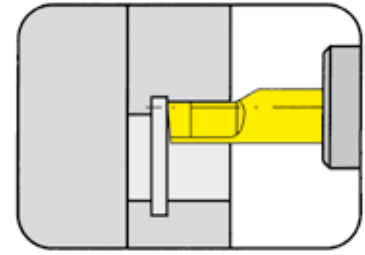
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.0012.0220	<b>6.075T15P</b>	<b>T15PQ</b>

刀杆 型号  
TOOLHOLDER Type

**SB105/SB110**



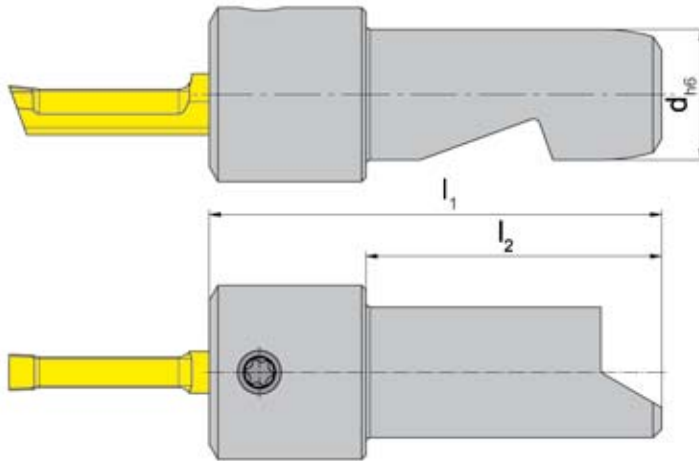
R

孔径Ø 自	Bore Ø from	6.0 mm
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用于插削动力座Schwarzer“2in1”  
for broaching device Schwarzer "2in1"

配合 刀片  
for use with Insert

型号 N105  
Type N110



产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>SB105.0015.S1.01</b>	15	52	34	<b>6</b>
<b>SB110.0015.S1.02</b>	15	66	34	<b>9</b>

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

刀片夹持长度=12mm(105)/26mm(110)!  
Clamping length of inserts = 12 mm (105) / 26 mm (110)!

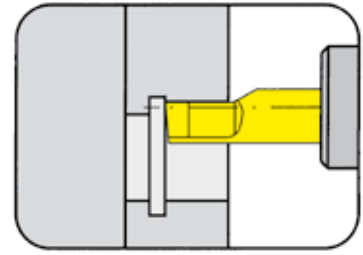
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB1...	<b>6.075T15P</b>	<b>T15PQ</b>

刀杆 型号  
TOOLHOLDER Type

**SB105/SB110**

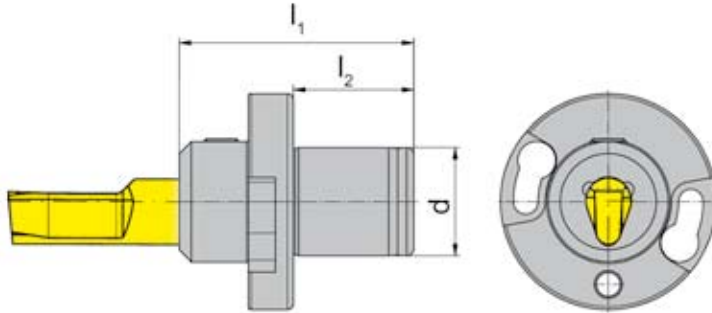


孔径Ø 自 Bore Ø from 6.0 mm

用于插削设备AR2P  
for broaching device AR2P

配合 刀片  
for use with Insert

型号 N105  
Type N110



产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>SB105.0018.A.01</b>	18	38	20	6
<b>SB110.0018.A.01</b> <b>SB110.0018.A.02</b>	18	39 52	20	6

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

刀片夹持长度=12mm(105)/26mm(110)!  
Clamping length of inserts = 12 mm (105) / 26 mm (110)!

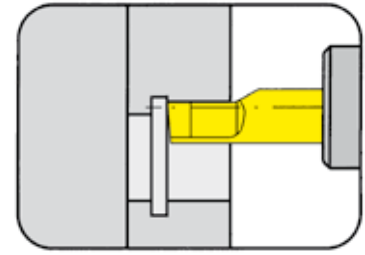
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB1...	<b>6.075T15P</b>	<b>T15PQ</b>

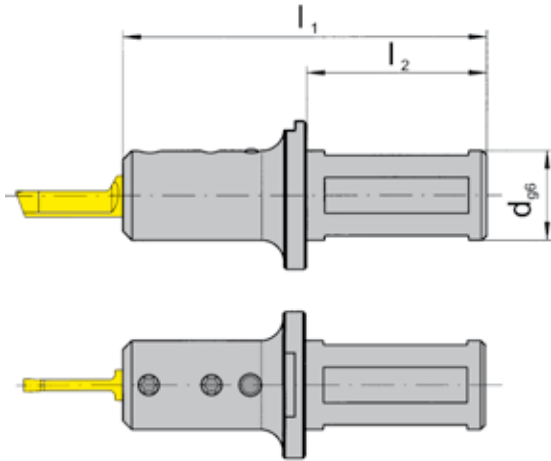
刀杆 型号  
TOOLHOLDER Type

**SB110**



R

孔径Ø 自 Bore Ø from 9.0 mm



配合 刀片  
for use with Insert

型号 N110  
Type

产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>SB110.0025.1.02</b>	25	81	40	<b>9</b>
<b>SB110.0032.1.02</b>	32	81	40	<b>9</b>

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

刀片的夹持长度=26mm !  
Clamping length of inserts = 26 mm!

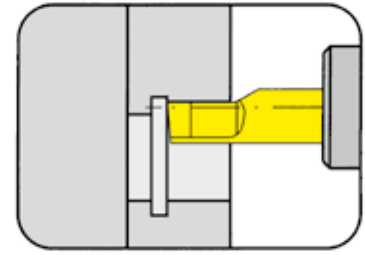
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB110.00...	<b>6.075T15P</b>	<b>T15PQ</b>

刀杆 型号  
TOOLHOLDER Type

## SB110

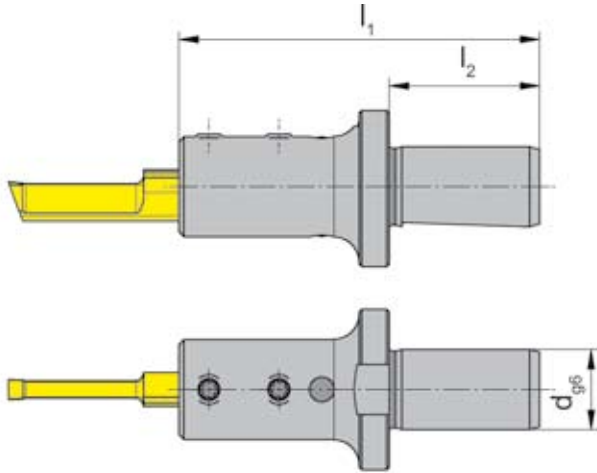


孔径Ø 自 Bore Ø from 9.0 mm

只适用于插削动力座EWS-Slot和BENZ LinA  
only usable for broaching devices EWS-Slot and BENZ LinA

配合 刀片  
for use with Insert

型号 N110  
Type



产品型号 Part number	d	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>
<b>SB110.0016.E1.02</b>	16	72	30	<b>9</b>

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

刀片的夹持长度=26mm !  
Clamping length of inserts = 26 mm!

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SB110.0016.E1.02	<b>6.075T15P</b>	<b>T15PQ</b>



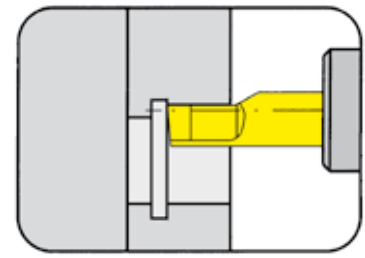
# 插削 BROACHING



刀片 型号  
INSERT type

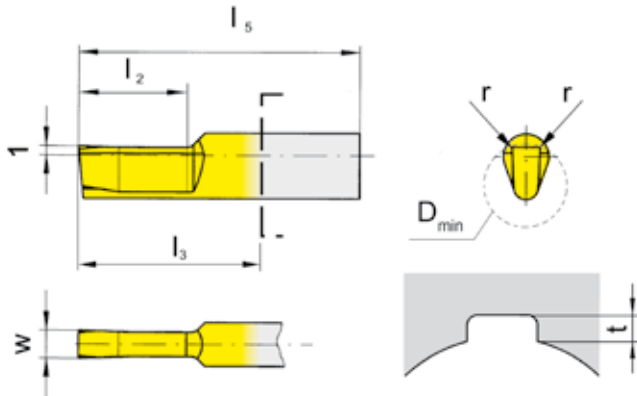
## N105/N110

公差等级 C11  
Tolerance grade C11



R

孔径 自 Bore Ø from 6.0 mm



用于刀杆  
for use with Toolholder

型号 SB105  
type SB110

DIN138标准键槽  
Keyways according to DIN138

产品编号 Part number	DIN槽的尺寸 Dimensions of groove DIN			w	r	l <sub>5</sub>	l <sub>2</sub>	l <sub>3</sub>	可用于自 Ø usable from Ø	刀杆 Toolholder		MG12	TA45	TI25
	宽 C11 Width C11	D <sub>min</sub>	t											
N105.0210.2.08	2	8	1.0	2.11	0.35				6.0	SB105			▲	
N105.0310.2.10	3	10	1.8	3.11	0.35				6.5				▲	
N105.0310.2.13	3	13	1.8	3.11	0.50	30	12	18	6.5				▲	
N105.0410.2.16	4	16	2.0	4.13	0.50				6.5				▲	
N110.0410.05.04	4	16	2.0	4.13	0.50	60	25	34	9.0	SB110			▲	
N110.0410.05.07						75	40	49					▲	
N110.0510.05.04	-	-	-	5.13	0.50	60	25	34	9.0					▲
N110.0510.05.07						75	40	49				▲		

- ▲ 库存品 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可替换推荐 / alternative recommendation
- 无涂层牌号 / uncoatet grades
- 涂层牌号 / coatet grades
- 钎焊/陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

P	●
M	●
K	●
N	●
S	●
H	

硬质合金牌号  
Carbide Grades

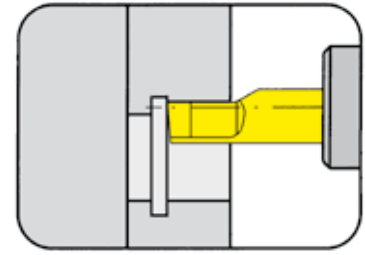
# 插削 BROACHING



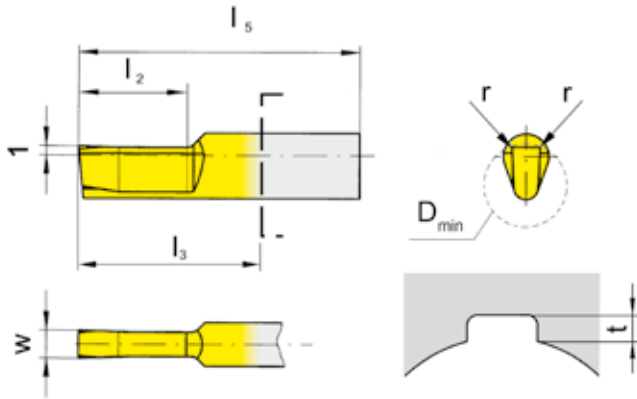
刀片 型号  
INSERT type

## N105/N110

公差等级 P9  
Tolerance grade P9



孔径 自 Bore Ø from 6.0 mm



用于刀杆  
for use with Toolholder

型号 SB105  
type SB110

DIN6885标准键槽  
Keyways according to DIN6885

产品编号 Part number	DIN槽的尺寸 Dimensions of groove DIN			w	r	l <sub>5</sub>	l <sub>2</sub>	l <sub>3</sub>	可用于自Ø usable from Ø	刀杆 Toolholder		MG12	TA45	TI25		
	宽 P9 Width P9	D <sub>min</sub>	t													
N105.0198.01.01	2	6	1.1	1.98		30	12	18	6.0	SB105			▲			
N105.0298.01.01	3	8	1.5	2.98	0.1	30	12	18	6.5					▲		
N105.0397.01.01	4	10	1.9	3.98		35	15	23	6.5					▲		
N110.0397.02.04	4	10	1.9	3.98		60	25	34	9.0	SB110			▲			
N110.0397.02.07	4	10	1.9	3.98	0.2	75	40	49							▲	
N110.0497.02.04	5	12	2.4	4.98		60	25	34							▲	
N110.0497.02.07	5	12	2.4	4.98		75	40	49							▲	

- ▲ 库存品 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可替换推荐 / alternative recommendation
- 无涂层牌号 / uncoatet grades
- 涂层牌号 / coatet grades
- 钎焊/陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号 Carbide Grades	P	M	K	N	S	H
	●	●	●	●	●	

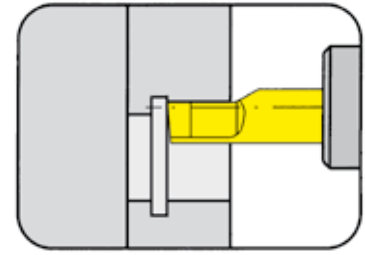
# 插削 BROACHING



刀片 型号  
INSERT type

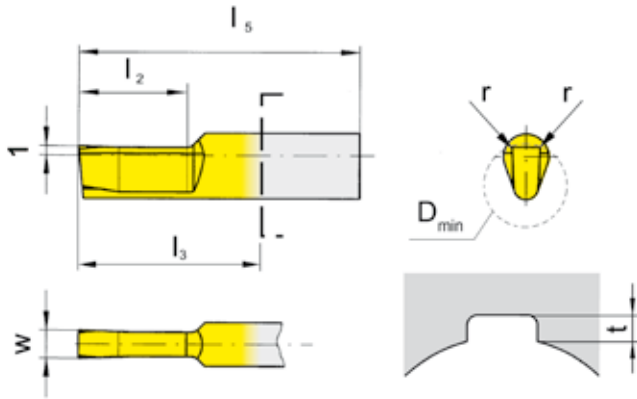
## N105/N110

公差等级 JS9  
Tolerance grade JS9



R

孔径 自 Bore Ø from 6.0 mm



用于刀杆  
for use with Toolholder

型号 SB105  
type SB110

DIN6885标准键槽  
Keyways according to DIN6885

产品编号 Part number	DIN槽的尺寸 Dimensions of groove DIN			w	r	l <sub>5</sub>	l <sub>2</sub>	l <sub>3</sub>	可用于自 Ø usable from Ø	刀杆 Toolholder		MG12	TA45	TI25		
	宽 JS9 Width JS9	D <sub>min</sub>	t													
N105.0200.01.01	2	6	1.1	2	0.1	30	12	18	6.0	SB105			▲			
N105.0300.01.01	3	8	1.5	3	0.1	30	12	18	6.5					▲		
N105.0400.01.01	4	10	1.9	4	0.1	35	15	23	6.5					▲		
N105.0400.02.01	4	10	1.9	4	0.2	35	15	23	6.5					▲		
N110.0400.02.04	4	10	1.9	4	0.2	60	25	34	9.0	SB110				▲		
N110.0400.02.07	4	10	1.9	4		75	40	49								▲
N110.0500.02.04	5	12	2.4	5		60	25	34								▲
N110.0500.02.07	5	12	2.4	5		75	40	49								▲

- ▲ 库存品 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可替换推荐 / alternative recommendation
- 无涂层牌号 / uncoatet grades
- 涂层牌号 / coatet grades
- 钎焊/陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

P	●
M	●
K	●
N	●
S	●
H	

硬质合金牌号  
Carbide Grades

# 插削 - 倒角

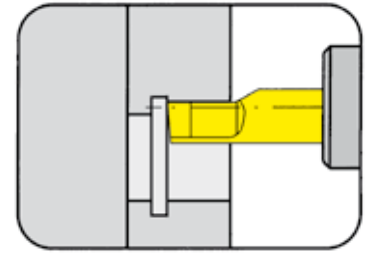
## BROACHING - CHAMFERING



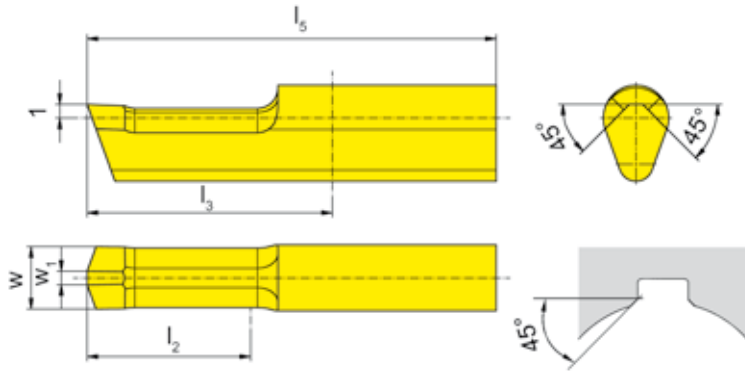
刀片 型号

# N105/N110

INSERT type



孔径 自 Bore Ø from 6.0 mm



用于刀杆  
for use with Toolholder

型号 SB105  
type SB110

倒角  
Chamfering

产品编号 Part number	倒角 Chamfer	w	w <sub>1</sub>	l <sub>5</sub>	l <sub>2</sub>	l <sub>3</sub>	可用于自Ø usable from Ø	刀杆 Toolholder	MG12	TA45	Tl25
<b>N105.4545.2.6</b>	45°	4.5	1	30	12	18	6	<b>SB105</b>		▲	
<b>N105.4545.3.6</b>				35	20	23				▲	
<b>N110.4545.4.9</b>	45°	6.3	2	60	25	34	9	<b>SB110</b>		▲	
<b>N110.4545.7.9</b>				75	40	49				▲	

- ▲ 库存品 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可替换推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

P	●	
M	●	
K	●	
N	●	
S	●	
H		

硬质合金牌号  
Carbide Grades

# 插削 - 内六角

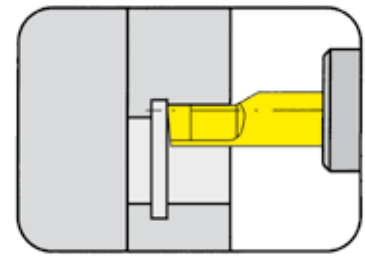
## BROACHING - HEXAGON SOCKET



### 刀片型号

INSERT Type

# N105/N110

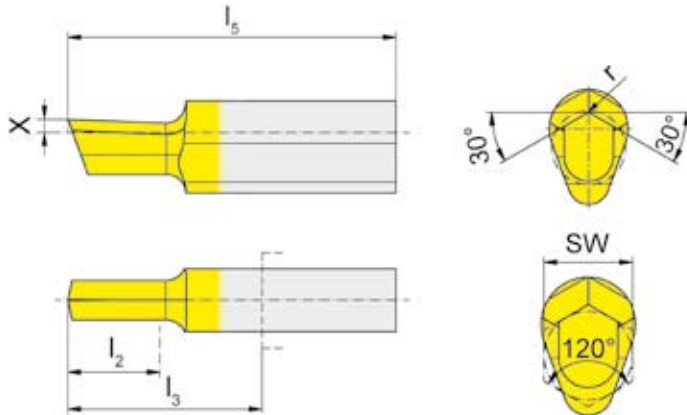


R

内六角自

Hexagon socket from

SW 2,5



配合 刀杆

for use with Toolholder

型号 SB105

Type SB110

内六角

Hexagon socket

产品型号 Part number	SW	r	l <sub>2</sub>	l <sub>3</sub>	l <sub>5</sub>	底孔 Pilot Ø	X	刀杆 Toolholder	MG12	TA45	TI25
<b>N105.SW25.25.01</b>	2.5-2.9	0.05	4.0	13	25	SW		<b>SB105</b>		▲	
<b>N105.SW30.30.01</b>	2.9-3.5	0.05	4.5	13	25	SW				▲	
<b>N105.SW35.35.01</b>	3.5-4.0	0.05	5.5	13	25	SW				▲	
<b>N105.SW40.40.01</b>	4.0-4.5	0.10	6.0	13	25	SW	1.0			▲	
<b>N105.SW45.45.01</b>	4.5-5.0	0.10	7.0	13	25	SW				▲	
<b>N105.SW56.56.01</b>	5.0-8.0	0.10	9.0	13	25	SW+0.1				▲	
<b>N105.SW80.80.01</b>	8.0-10.0	0.10	12.0	18	30	SW+0.1				▲	
<b>N110.SW14.14.03</b>	10.0-14.0	0.20	20.0	29	55	SW+0.1	1.5	<b>SB110</b>		▲	
<b>N110.SW16.16.04</b>	14.0-16.5/ 16.5-18.0		SW+0.1/ SW+0.2			2.0			▲		

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●	
M	●	
K	●	
N	●	
S	●	
H		

硬质合金牌号  
Carbide grades

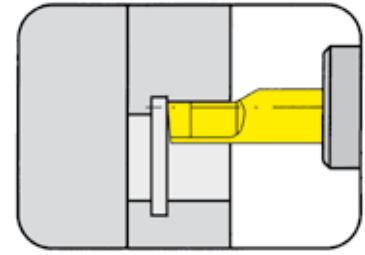
# 插削 - TORX

## BROACHING - TORX



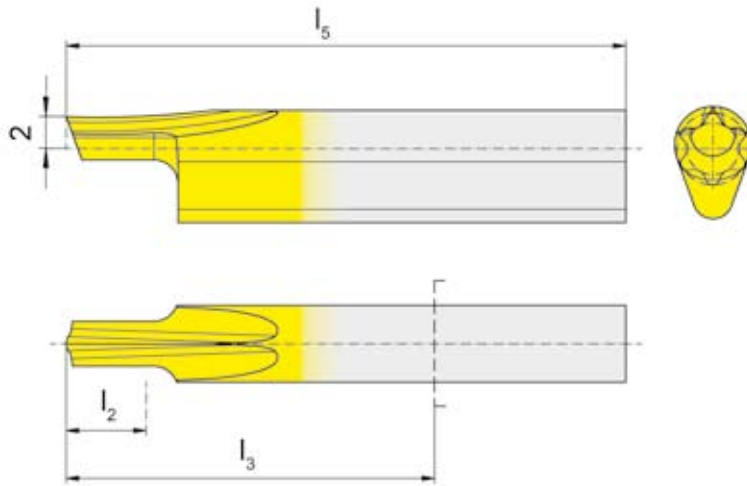
刀片型号  
INSERT Type

# N105



配合刀杆  
for use with Toolholder

型号 SB105  
Type



产品型号 Part number	Torx	l <sub>2</sub>	l <sub>3</sub>	l <sub>5</sub>	底孔 Pilot Ø	刀杆 Toolholder	MG12	TA45	TI25
N105.TX15.24.03	T15	4			2.41	SB105		▲	
N105.TX20.28.03	T20	4			2.85			▲	
N105.TX25.32.03	T25	5	23	35	3.24			▲	
N105.TX30.40.03	T30	5			4.03			▲	
							P	•	
							M	•	
							K	•	
							N	•	
							S	•	
							H		

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

# 概要 - 插削刀具

## SUMMARY - BROACHING TOOLS



型号 **SB105/SB110** - 刀杆可以直接安装在刀塔和m/c主轴上

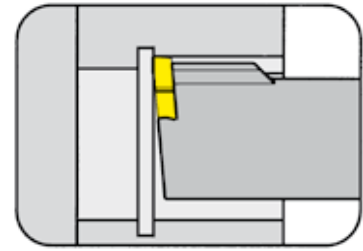
type **SB105/SB110** - Holder can be located directly in the turret or m/c spindle

尺寸 DIN Dimensions DIN				插削 Broaching		倒角 Chamfering		
宽 Width	公差等级 Tolerance grade	$D_{min}$	t	刀片 Inserts	$l_2$	刀杆 Toolholder	刀片 Inserts	刀杆 Toolholder
2	C11	8	1.0	N105.0210.2.08	12			
3	C11	10	1.8	N105.0310.2.10	12	SB105.0020.1.01	N105.4545.2.6	SB105.0020.1.01 SB105.0025.1.01
3	C11	13	1.8	N105.0310.2.13	12	SB105.0025.1.01		
4	C11	16	2.0	N105.0410.2.16	12			
4	C11	16	2.0	N110.0410.05.04	25	SB110.0025.1.02	N110.4545.4.9	SB110.0025.1.02
4	C11	16	2.0	N110.0410.05.07	40	SB110.0032.1.02	N110.4545.7.9	SB110.0032.1.02
5	C11	-	-	N110.0510.05.04	25	SB110.0025.1.02	N110.4545.4.9	SB110.0025.1.02
5	C11	-	-	N110.0510.05.07	40	SB110.0032.1.02	N110.4545.7.9	SB110.0032.1.02
2	P9	6	1.1	N105.0198.01.01	12		N105.4545.2.6	SB105.0020.1.01
3	P9	8	1.5	N105.0298.01.01	12	SB105.0020.1.01		
4	P9	10	1.9	N105.0397.01.01	15	SB105.0025.1.01	N105.4545.3.6	SB105.0025.1.01
4	P9	10	1.9	N110.0397.02.04	25		N110.4545.4.9	
4	P9	10	1.9	N110.0397.02.07	40	SB110.0025.1.02	N110.4545.7.9	SB110.0025.1.02
5	P9	12	2.4	N110.0497.02.04	25	SB110.0032.1.02	N110.4545.4.9	SB110.0032.1.02
5	P9	12	2.4	N110.0497.02.07	40		N110.4545.7.9	
2	JS9	6	1.1	N105.0200.01.01	12		N105.4545.2.6	SB105.0020.1.01 SB105.0025.1.01
3	JS9	8	1.5	N105.0300.01.01	12	SB105.0020.1.01		
4	JS9	10	1.9	N105.0400.01.01	15	SB105.0025.1.01		
4	JS9	10	1.9	N105.0400.02.01	15		N105.4545.3.6	
4	JS9	10	1.9	N110.0400.02.04	25		N110.4545.4.9	
4	JS9	10	1.9	N110.0400.02.07	40	SB110.0025.1.02	N110.4545.7.9	SB110.0025.1.02
5	JS9	12	2.4	N110.0500.02.04	25	SB110.0032.1.02	N110.4545.4.9	SB110.0032.1.02
5	JS9	12	2.4	N110.0500.02.07	40		N110.4545.7.9	

R

刀杆 型号  
TOOLHOLDER Type

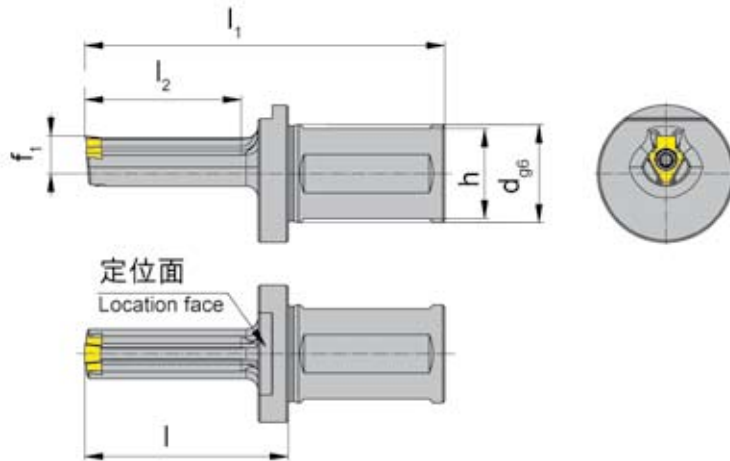
**SH117**



孔径Ø 自 Bore Ø from 14.0 mm

配合 刀片  
for use with Insert

型号 S117  
Type



产品型号 Part number	d	h	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	自 Form
<b>SH117.1425.1.3.08</b>	25	23	32	72	20	<b>14</b>	9.6	G
<b>SH117.1425.1.08</b>	25	23	42	82	30	<b>14</b>	9.6	F
<b>SH117.1425.2.08</b>	25	23	52	92	40	<b>14</b>	9.6	F

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SH117.1425....	<b>030.3509.T15P</b>	<b>T15PQ</b>



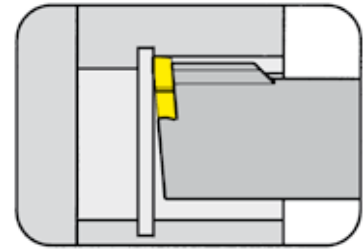
# 插削 BROACHING



刀杆 型号  
TOOLHOLDER Type

## SHM117

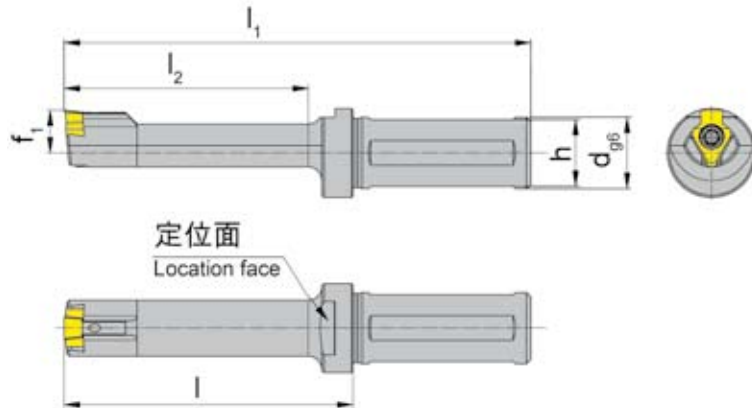
带内冷  
with through coolant supply



R

孔径Ø 自                      Bore Ø from                      14.0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能  
Material of shank: Carbide - Giving a good vibration resistance



配合 刀片  
for use with Insert

型号 S117...08  
Type

带内冷  
with through coolant supply

产品型号 Part number	d	h	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	自 Form
<b>SHM117.1416.3.08</b>	16	15	65	105	55	<b>14</b>	9.6	F

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

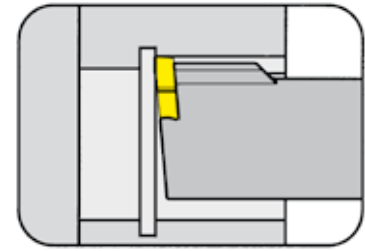
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

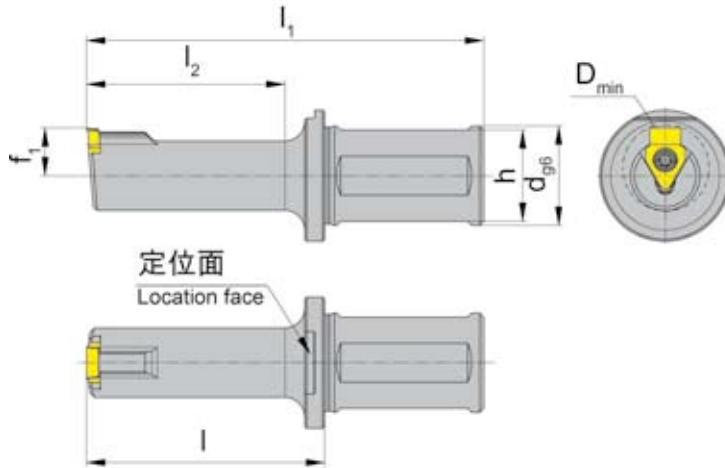
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SHM117.1416.3.08	<b>030.3509.T15P</b>	<b>T15PQ</b>

刀杆 型号  
TOOLHOLDER Type

SH117



孔径Ø 自 Bore Ø from 17.0 mm



配合 刀片  
for use with Insert

型号 S117  
Type

产品型号 Part number	d	h	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	自 Form
SH117.1725.1.10 SH117.1725.2.10	25	23	50 65	90 105	40 55	17	9.5	A
SH117.0025.1.10 SH117.0025.2.10	25	23	60 80	100 120	50 70	22	12.0	B
SH117.3032.1.16 SH117.3032.2.16 SH117.3032.3.16	32	30	60 85 110	100 125 170	50 75 100	30	16.5	C
SH117.0032.1.16 SH117.0032.2.16 SH117.0032.3.16	32	30	60 85 110	100 125 170	50 75 100	38	22.0	D
SH117.4032.1.16 SH117.4032.2.16 SH117.4032.3.16	32	30	62 87 112	122 147 172	50 75 100	40	21.5	E

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

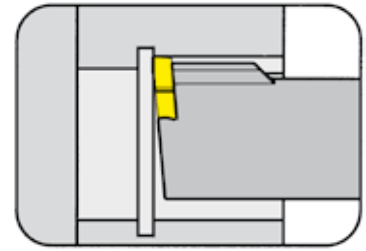
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SH117....10 SH117....16	4.09T15P 5.12T20P	T15PQ T20PQ

刀杆 型号  
TOOLHOLDER Type

**SH117**



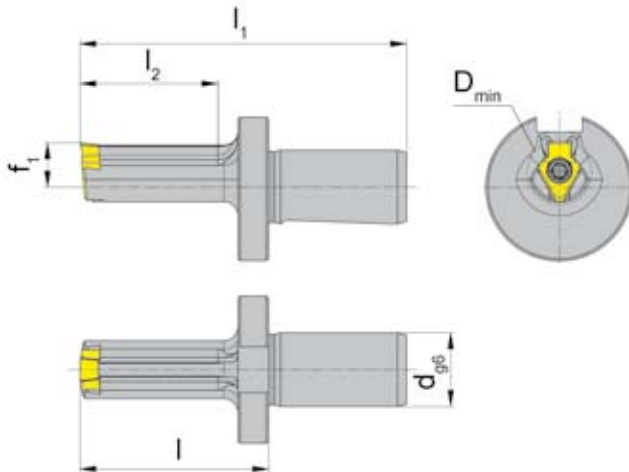
R

孔径Ø 自 Bore Ø from 14.0 mm

只适用于插削动力座EWS-Slot和BENZ LinA  
only usable for broaching devices EWS-Slot and BENZ LinA

配合 刀片  
for use with Insert

型号 S117  
Type



产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	自 Form
SH117.1416.E1.08	16	41	71	30	14	9.6	F
SH117.1716.E1.10 SH117.1716.E2.10	16	41 51	71 81	30 40	17	9.5	A
SH117.0016.E1.10 SH117.0016.E2.10	16	41 51	71 81	30 40	22	12.0	B

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

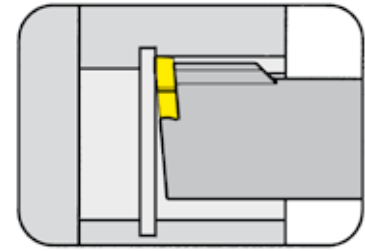
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SH117....10 SH117.1416.E1.08	4.09T15P 030.3509.T15P	T15PQ T15PQ

刀杆 型号  
TOOLHOLDER Type

## H117/SH117

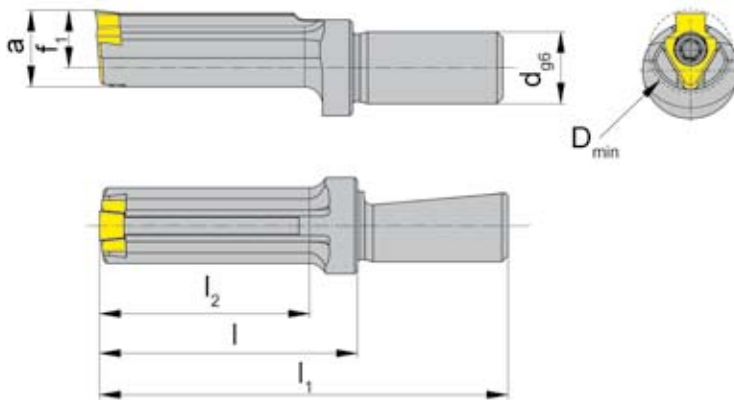


孔径Ø 自 Bore Ø from 14.0 mm

用于插削动力座Schwarzer  
for broaching device Schwarzer

配合 刀片  
for use with Insert

型号 S117  
Type



产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	a	自 Form
SH117.1412.S1.08 SH117.1412.S2.08	12	33 43	58 68	25 35	14	9.6	12.80	F
H117.1712.1439 H117.1712.1407	12	33 43	58 68	25 35	17	9.5	16.00	A
H117.2212.1441 H117.2212.1442	12	33 43	58 68	25 35	22	12.0	20.75	B
H117.3012.1440 H117.3012.1419	12	33 43	58 68	25 35	30	16.5	28.50	C

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位 : mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

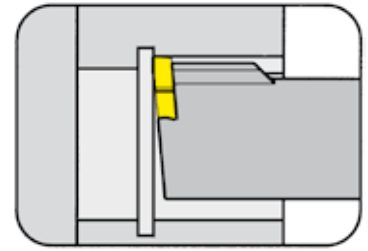
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117....1407/1439/1441/1442 H117.3012.1419/1440 SH117.1412.S...08	4.09T15P 5.12T20P 030.3509.T15P	T15PQ T20PQ T15PQ

# 插削 BROACHING



刀杆 型号  
TOOLHOLDER Type

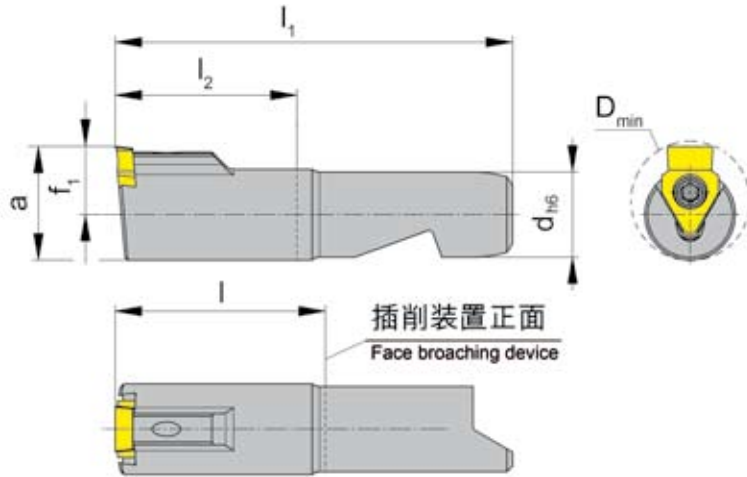
**SH117**  
带内冷  
with through coolant supply



R

孔径Ø 自	Bore Ø from	14.0 mm
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用于插削动力座Schwarzer“2in1”  
for broaching device Schwarzer "2in1"



配合 刀片  
for use with Insert

型号 S117  
Type

产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	a	自 Form
SH117.0932.S.08	15	37	70	32	14	9.6	12.8	F
SH117.0932.S.10	15	37	70	32	17	9.5	16.0	A
SH117.1532.S.10	15	37	70	32	22	12.0	20.0	B
SH117.1538.S.16	15	43	76	38	30	15.0	24.0	C
SH117.1544.S.16	15	49	82	44	30	15.0	24.0	C

按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

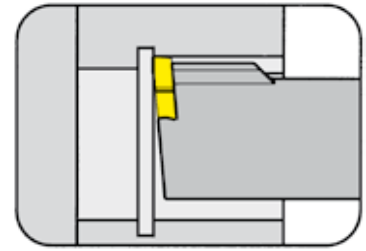
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SH117.0932.S.08	030.3509.T15P	T15PQ
SH117....10	4.09T15P	T15PQ
SH117.15...16	5.12T20P	T20PQ

刀杆 型号  
TOOLHOLDER Type

**SH117**

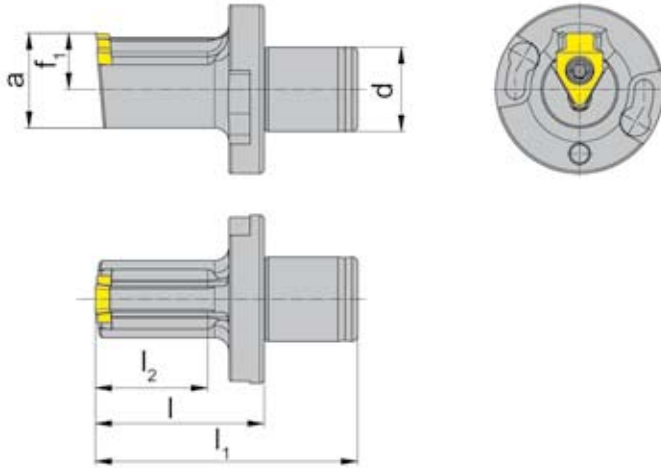


孔径Ø 自 Bore Ø from 22.0 mm

用于插削设备AR2P  
for broaching device AR2P

配合 刀片  
for use with Insert

型号 S117  
Type



产品型号 Part number	d	l	l <sub>1</sub>	l <sub>2</sub>	D <sub>min</sub>	f <sub>1</sub>	a	自 Form
<b>SH117.2218.A1.10</b>	18	36	56	24	22	12	20.25	B

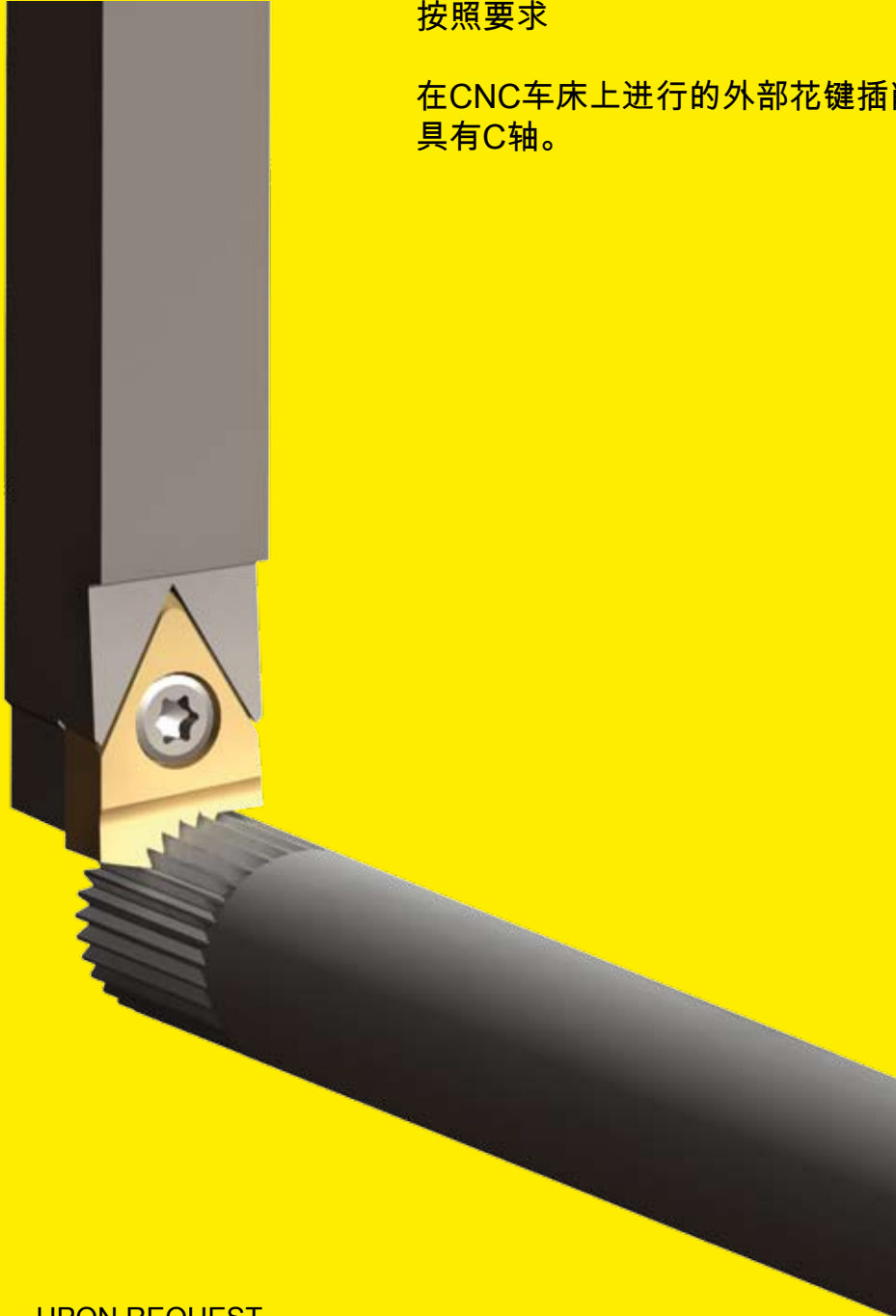
按需提供其他类型接口  
Further sizes for other device interfaces upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
SH117.2218.A1.10	<b>4.09T15P</b>	<b>T15PQ</b>



按照要求

在CNC车床上进行的外部花键插削精加工要求车床必须具有C轴。

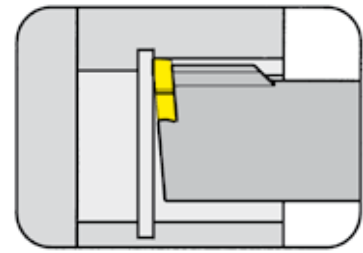
UPON REQUEST

External serration broaching for finish machining on  
CNC turning machines.  
Machine MUST have C-Axis for this application!

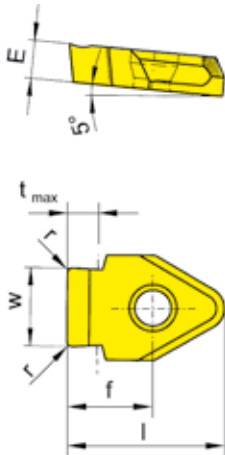
刀片型号  
INSERT Type

## S117

公差等级C11  
Tolerance grade C11



孔径Ø 自	Bore Ø from	14.0 mm
切槽深度可达	Depth of groove up to	8.5 mm



配合 刀杆  
for use with Toolholder

型号 SH117  
Type SHM117

键槽 ( DIN138 )  
Keyways according to DIN138

产品型号 Part number	Nw	w	r	E	l	t <sub>max</sub>	D <sub>min</sub>	f	自 Form	MG12	TA45	TN35	TI25
S117.0310.04.08	3	3.10	0.35	4	13	2.0	14	6.0	G		▲		
S117.0410.05.08	4	4.12	0.50	4	13	2.1	14	6.0	F		▲		
S117.0610.22	6	6.12	0.85			2.6					▲		△
S117.0710.27	7	7.13	0.85	3	16	3.3	22	8.0	B		▲		△
S117.0810.32	8	8.13	1.05			3.4					▲		▲
S117.1014.40	10	10.13	1.05			4.2	30		C		▲		△
S117.1214.50	12	12.15	1.35			5.1	38		D		▲		△
S117.1614.70	16	12.15	1.75	6	21	6.6	38	11.2	D		△		
S117.2414.100	24	12.15	2.25			8.5	38		D		△		
▲ 库存 / on stock    △ 4周 / 4 weeks										P	●		●
● 主要应用 / main recommendation										M	●		●
○ 可选推荐 / alternative recommendation										K	●		●
■ 无涂层牌号 / uncoated grades										N	●		●
■ 涂层牌号 / coated grades										S	●		●
■ 钎焊/金属陶瓷 / brazed/Cermet										H			

尺寸单位 : mm  
Dimensions in mm

注意事项 :  
刀片类型应与刀杆类型相对应。  
例如 : A型刀杆配A型刀片

**Note:**  
The insert form must correspond to the holder form.  
E.g.: Form A Toolholder = Form A Insert

硬质合金牌号  
Carbide grades



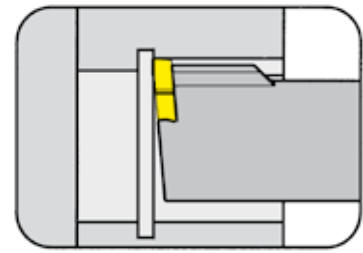
# 插削 BROACHING



刀片 型号  
INSERT Type

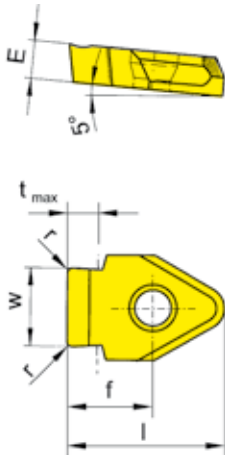
## S117

公差等级P9  
Tolerance grade P9



R

孔径Ø 自	Bore Ø from	14.0 mm
切槽深度可达	Depth of groove up to	6.8 mm



配合 刀杆  
for use with Toolholder

型号 SH117  
Type SHM117

键槽 ( DIN6885 )  
Keyways according to DIN6885

产品型号 Part number	Nw	w	r	E	l	t <sub>max</sub>	D <sub>min</sub>	f	自 Form	MG12	TA45	TN35	TI25
S117.0298.01.08	3	2.99	0.12	4	13.0	2.0	14	6.0	G		▲		
S117.0397.01.08	4	3.98	0.12	4	13.0	2.1	14	6.0	F		▲		
S117.0497.02.08	5	4.98	0.20	4	13.0	2.7	14	6.0	F		▲		
S117.0497.02.10	5	4.98	0.20	3	14.5	2.7	17	6.5	A		▲		
S117.0597.02.10	6	5.98	0.20	3	14.5	3.4	17	6.5	A		▲		
S117.0796.02.10	8	7.98	0.20	3	16.0	4.1	22	8.0	B		▲		
S117.0996.03.14	10	9.98	0.30	6	21.0	4.2	30	11.2	C		▲		
S117.1196.03.14	12	11.97	0.30	6	21.0	5.7	38	11.2	D		▲		
S117.1396.03.16	14	13.97	0.30	6	21.0	6.8	40	11.2	E		▲		
▲ 库存 / on stock    Δ 4周 / 4 weeks										P	•		
● 主要应用 / main recommendation										M	•		
○ 可选推荐 / alternative recommendation										K	•		
■ 无涂层牌号 / uncoated grades										N	•		
■ 涂层牌号 / coated grades										S	•		
■ 钎焊/金属陶瓷 / brazed/Cermet										H			

硬质合金牌号  
Carbide grades

尺寸单位 : mm  
Dimensions in mm

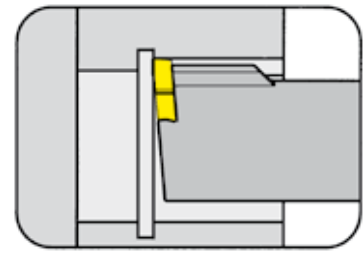
注意事项 :  
刀片类型应与刀杆类型相对应。  
例如 : A型刀杆配A型刀片

Note:  
The insert form must correspond to the holder form.  
E.g.: Form A Toolholder = Form A Insert

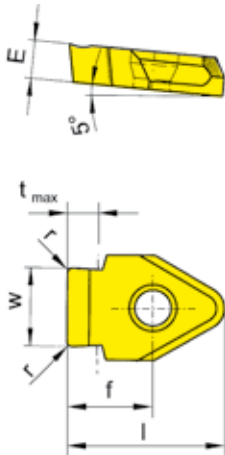
刀片型号  
INSERT Type

## S117

公差等级JS9  
Tolerance grade JS9



孔径Ø 自	Bore Ø from	14.0 mm
切槽深度可达	Depth of groove up to	8.5 mm



配合 刀杆  
for use with Toolholder

型号 SH117  
Type SHM117

键槽 ( DIN6885 )  
Keyways according to DIN6885

产品型号 Part number	Nw	w	r	E	l	t <sub>max</sub>	D <sub>min</sub>	f	自 Form	MG12	TA45	TN35	TI25
S117.0300.01.08	3	3.01	0.12	4	13.0	2.0	14	6.0	G		▲		
S117.0400.01.08	4	4.01	0.12	4	13.0	2.1	14	6.0	F		▲		
S117.0500.02.08	5	5.01	0.20	4	13.0	2.7	14	6.0	F		▲		
S117.0500.02.10	5	5.01	0.20	3	14.5	2.7	17	6.5	A		▲		
S117.0600.02.10	6	6.01	0.20	3	14.5	3.4	17	6.5	A		▲		
S117.0800.02.10	8	8.01	0.20	3	16.0	4.1	22	8.0	B		▲		
S117.1000.03.14	10	10.01	0.30	6	21.0	4.2	30	11.2	C		▲		
S117.1200.05.14	12	12.00	0.50	6	21.0	8.5	38	11.2	D		▲		
S117.1200.03.14	12	12.01	0.30	6	21.0	5.7	38	11.2	D		▲		
S117.1400.03.16	14	14.01	0.30	6	21.0	6.8	40	11.2	E		▲		
										P	•		
										M	•		
										K	•		
										N	•		
										S	•		
										H			

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

**注意事项 :**

刀片S117.1200.05.14=Nw自 12mm开始!

**Note:**

Insert S117.1200.05.14 = Nw **from** 12 mm!

刀片类型应与刀杆类型相对应。

例如 : A型刀杆配A型刀片

The insert form must correspond to the holder form.

E.g.: Form A Toolholder = Form A Insert

硬质合金牌号  
Carbide grades

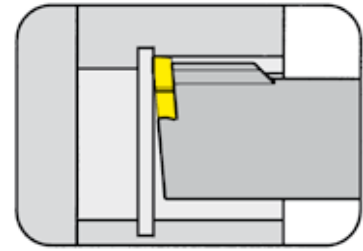
# 插削 - 倒角

## BROACHING-CHAMFERING



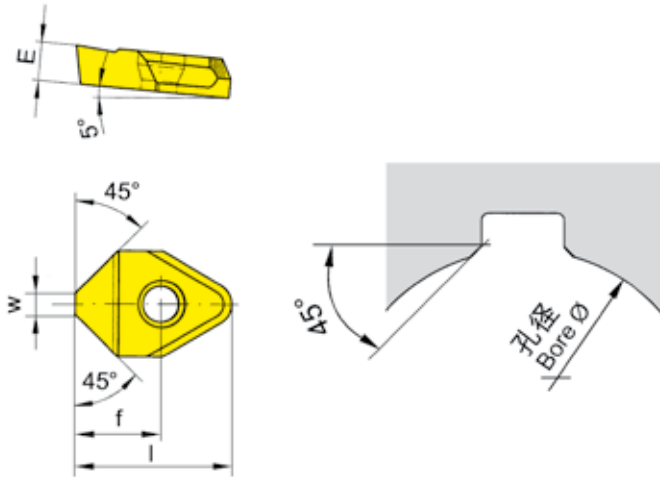
刀片型号  
INSERT Type

# S117



R

孔径Ø 自	Bore Ø from	14.0 mm
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配合 刀杆  
for use with Toolholder

型号 SH117  
Type SHM117

倒角  
Chamfering

产品型号 Part number	w	l	D <sub>min</sub>	f	自 Form	MG12	TA45	TN35	TI25
S117.2445.08	2.4	13	14	6.0	F		▲		
S117.1545.10	1.5	16	17	8.0	A		▲		
S117.3045.10	3.0	16	22	8.0	B		▲		
S117.6045.14	6.0	21	30	11.2	C/D		▲		
						P	•	•	•
						M	•	•	•
						K	•	•	•
						N	•	•	•
						S	•	•	•
						H			

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

注意事项 :  
刀片类型应与刀杆类型相对应。  
例如 : A型刀杆配A型刀片

**Note:**  
The insert form must correspond to the holder form.  
E.g.: Form A Toolholder = Form A Insert

硬质合金牌号  
Carbide grades

# 概要 - 插削刀具

## SUMMARY - BROACHING TOOLS



型号 SH117 / SHM117 - 刀杆可以直接安装在刀塔和m/c主轴上

type SH117 / SHM117 - Holder can be located directly in the turret or m/c spindle

尺寸 DIN Dimensions DIN				插削 Broaching		倒角 Chamfering			
宽 Width	公差等级 Tolerance g	D <sub>min</sub>	t	刀片 Inserts	w	刀杆 Toolholder	刀具长度 l <sub>2</sub> Tool length l <sub>2</sub>		
							1.	2.	3.
				刀片 Inserts	刀杆 Toolholder	刀具长度 l <sub>2</sub> Tool length l <sub>2</sub>			
						1.	2.	3.	
3		14	2.0	S117.0310.04.08	3.1	SH117.1425.1.3.08	20	40	55
4		14	2.1	S117.0410.05.08	4.12	SH/SHM117...08	30	40	55
6		22	2.6	S117.0610.22	6.12	SH117.0025...10	50	70	70
7		27	3.3	S117.0710.27	7.13	SH117.0025...10	50	70	70
8	C11	32	3.4	S117.0810.32	8.13	SH117.0025...10	50	70	70
10		40	4.2	S117.1014.40	10.13	SH117.0032...16	50	75	100
12		50	5.1	S117.1214.50	12.15	SH117.0032...16	50	75	100
16		70	6.6	S117.1614.70	12.15	SH117.0032...16	50	75	100
24		100	8.5	S117.2414.100	12.15	SH117.0032...16	50	75	100
3		14	2.0	S117.0298.01.08	2.99	SH117.1425.1.3.08	20	40	55
4		14	2.1	S117.0397.01.08	3.98	SH/SHM117...08	30	40	55
5		14	2.7	S117.0497.02.08	4.98	SH/SHM117...08	30	40	55
5		17	2.7	S117.0497.02.10	4.98	SH117.1725...10	40	55	55
6	P9	17	3.4	S117.0597.02.10	5.98	SH117.1725...10	40	55	55
8		22	4.1	S117.0796.02.10	7.98	SH117.0025...10	50	70	70
10		30	4.2	S117.0996.03.14	9.98	SH117.3032...16	50	75	100
12		38	5.7	S117.1196.03.14	11.97	SH117.0032...16	50	75	100
14		40	6.8	S117.1396.03.16	13.97	SH117.4032...16	50	75	100
3		14	2.0	S117.0300.01.08	3.01	SH117.1425.1.3.08	20	40	55
3		14	2.1	S117.0400.01.08	4.01	SH/SHM117...08	30	40	55
5		14	2.7	S117.0500.02.08	5.01	SH/SHM117...08	30	40	55
5		17	2.7	S117.0500.02.10	5.01	SH117.1725...10	40	55	55
6	JS9	17	3.4	S117.0600.02.10	6.01	SH117.1725...10	40	55	55
8		22	4.1	S117.0800.02.10	8.01	SH117.0025...10	50	70	70
10		30	4.2	S117.1000.03.14	10.01	SH117.3032...16	50	75	100
12		38	5.7	S117.1200.03.14	12.01	SH117.0032...16	50	75	100
12		38	8.5	S117.1200.05.14	12.00	SH117.0032...16	50	75	100
14		40	6.8	S117.1400.03.16	14.01	SH117.4032...16	50	75	100

R

**技巧和窍门**

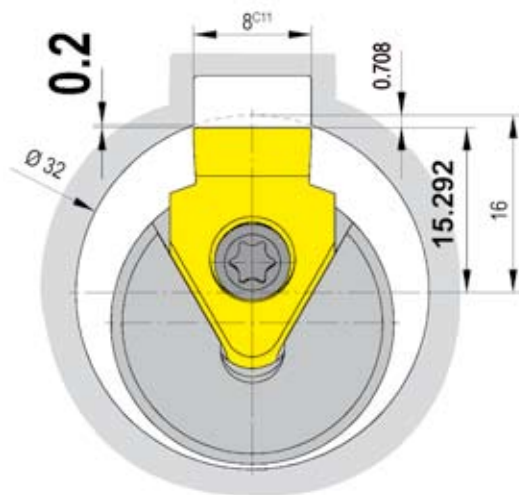
- 插削末端的退刀槽是必需的
- 刀片应与材料接触
- 冷却油或冷却乳液的使用有助于提高刀具寿命和表面光洁度，并有助于切屑的排出
- 刀具应被设定在12点钟方向，确保切屑从成槽中排出
- 刀具的设定非常重要，进行第一步前一定要仔细检查工件直径
- 测量刀具的精度，并在加工第一刀时仔细观察工件直径
- 第一冲程中定位刀具的初始位置，并在程序中编入停止项，以便去目测是否存在碰撞。

**Application Tips:**

- It is important to use a machine with mechanical spindle lock.
- The use of proper coolant is key to a good surface finish, long tool life as well as chip evacuation.
- A relief groove or the possibility for a "ramp down" exit out of the cut is necessary at the end of the broached groove.
- Setting of the tool if very important. Double check the component diameter before taking the first pass.
- The tool should be set at the 12 o'clock position to ensure that chips fall away from the groove.
- Take an accurate measurement of the insert and program the dimension into the machine tool parameter.
- Position the tool at the start position of the first stroke and program a stop to perform a visual check to assure a collision free first pass of the tool.

**加工实例:**

孔径32mm，槽宽8mm：  
半径16mm，安全间隙0.2mm，刀尖圆角r0.2mm，刀刃在X轴方向设定在15.292处，避免开始加工时碰撞。



**Machining example:**

Bore diameter 32 mm, groove width 8 mm:  
At a radius of 16 mm and with a clearance of 0,2 mm for safety at the r 0,2 mm corner radii, the tool has to be set at 15,292 mm in X-axis to avoid any collision at the beginning of the process.

**计算起始位置  $b_1$ :**

Calculation of the start position  $b_1$ :

$$c^2 = a^2 + b^2$$

$$b^2 = c^2 - a^2$$

$$b = \sqrt{c^2 - a^2}$$

$$b = \sqrt{16^2 - 4^2}$$

$$b = 15.491933$$

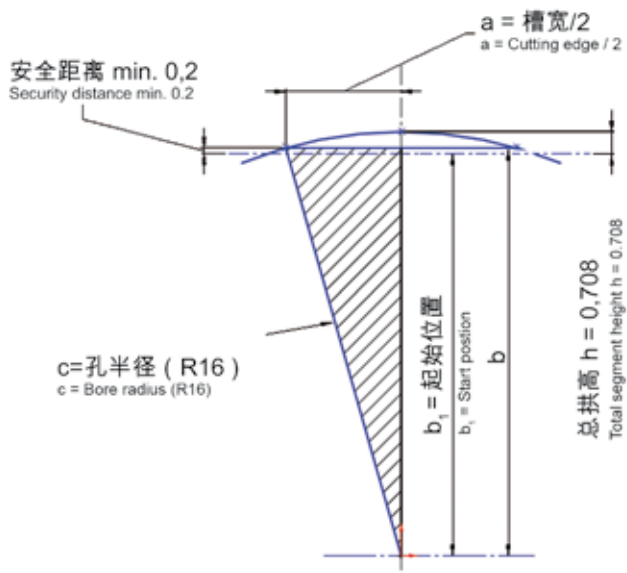
$$b_1 = b - \text{安全距离}$$

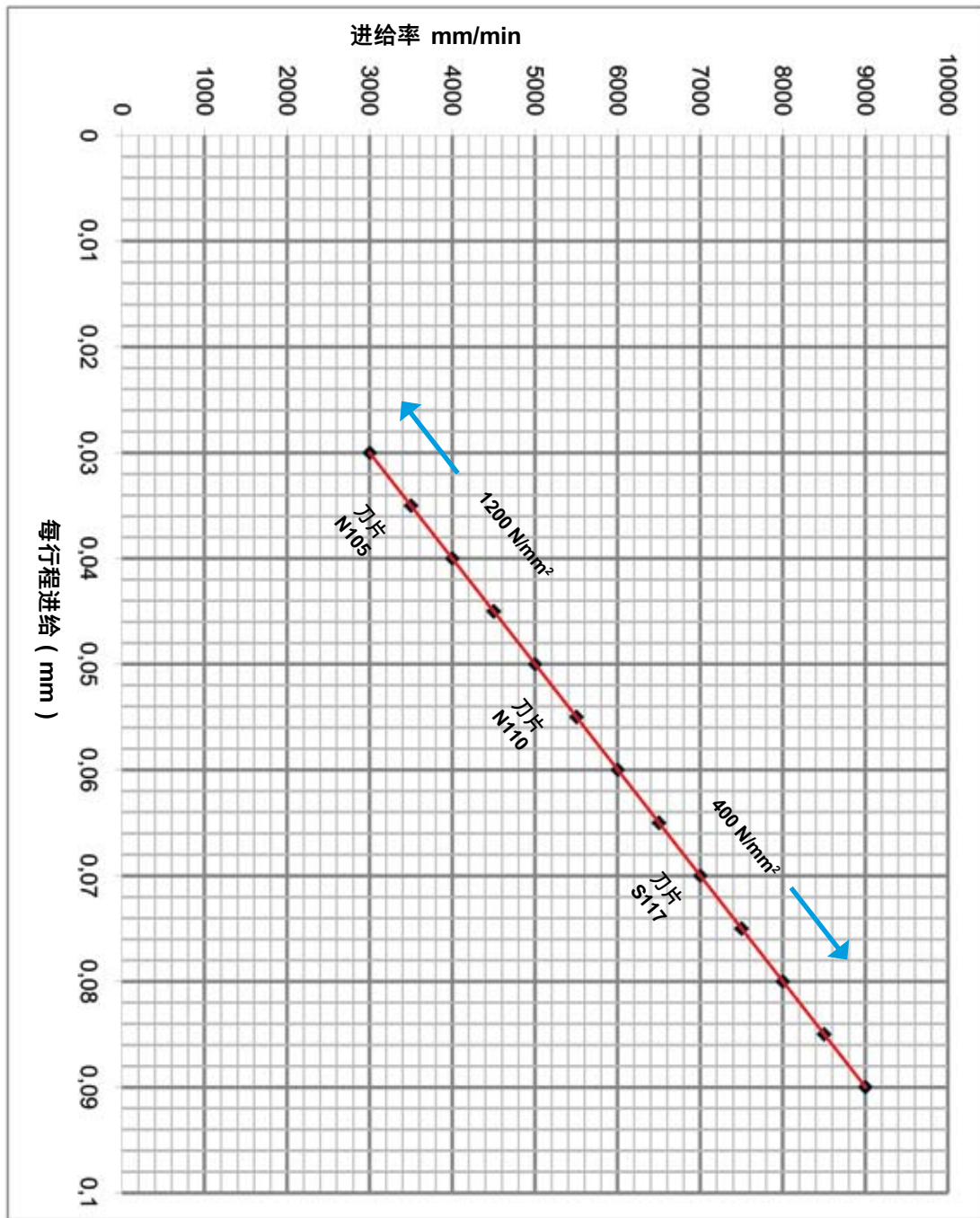
Clearance distance

$$b_1 = 15.492 - 0.2 = 15.292 \text{ mm}$$

→ 相当于起始位置  $\varnothing 30.584\text{mm}$

→ equals as a start position at  $\varnothing 30.584 \text{ mm}$



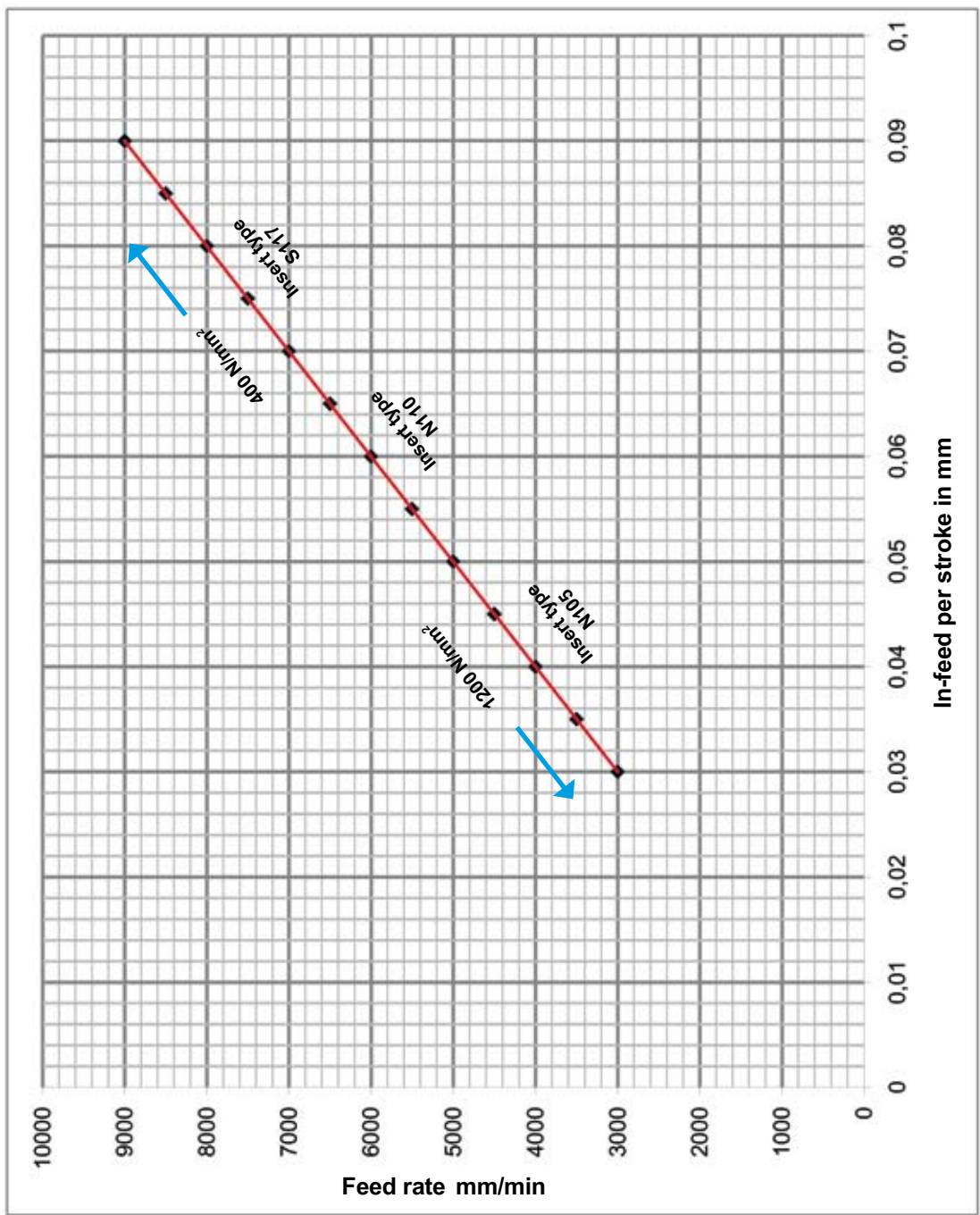


上述值仅供参考，机床情况、工件轮廓、夹紧方式以及工件材质都影响切深和进给率。

应用细节：

- 插槽时需要退刀槽或者底部的斜面以便退刀。
- 退刀之前切削刃必须在槽外设定正确的位置。
- 精确测量刀片并将尺寸编程进入刀具参数内。
- 在第一冲程中定位刀具的初始位置，并在程序中编入停止项，以便去目测是否存在碰撞。
- 使用合适的冷却液是提高表面光洁度、刀具寿命和将切屑排出盲孔的关键





The above values are guidelines only. The physical condition of the machine, the work piece profile and clamping, as well as the type of material have great influence on the depth of cut and feed rate.

Application Tips:

- A relief groove or the possibility for a 'ramp down' exit out of the groove is necessary at the end of the broached groove.
- The insert cutting edge has to be positioned outside the groove before retracting the tool.
- Take an accurate measurement of the insert and program the dimension into the machine tool parameter.
- Position the tool at the start position of the first stroke and program a stop to perform a visual check to assure a collision free first pass of the tool.
- The use of proper coolant is key to a good surface finish, long tool life as well as chip evacuation out of a blind hole.

**TRAUB TNA 400 ( 含C轴 ) 上的插削实例**

NC - 程序

N.....(插削)	编号及应用
G97 T.....	M5 恒定转速，刀具调出，主轴停止
M17	开启C轴
G94	进给率 mm/min
L1 = 30.584	选择初始参数 $\emptyset$
M8 M19	冷却开, 主轴暂停开
N100 开始	重复START
G0 XL1 Z5	零件前面X和Z轴方向上的起始位置
G1 Z-25 F8000	Z方向直线进给速率8000 mm/min
G0 X30.584	X方向快速移动至起始 $\emptyset$ i.e. 停止位置
G0 Z5	Z方向快速移动至起始位置
L1 = L1+0.16	编程中 $\emptyset$ 增加两倍切深
N200	重复END编号
G22 P100 Q200 H45	重复循环自START到END

例如：

- 按照表格孔径 $\emptyset$ 32mm内的槽
- 槽宽 $8^{C11}$
- 进给0.08mm
- 行程数是完整的槽深，即自起始位置到槽底，除以每行程切深。
- 这个数值必须是2的倍数（因为 $\emptyset$ 编程需要），它将被在NC程序中设定为行程数。

计算：

- 起始位置=安全距离+距离自 $\emptyset$ 切削刃起32mm（见P25页实例）  
拱高0.508 mm +0.20 mm安全距离共0.708 mm
- 起始位置=30.584 mm (32 - [0.708 x 2] = 30.584 mm.  
槽深2.90 mm加上 0.708 mm = 3.608 mm。
- 这是在 $\emptyset$ 编程使用的尺寸：自起始位置到槽底的距离
- 3.608是起始位置到槽底的尺寸，编程过程中3.608需乘以2等于7.216mm
- 7.216除以每行程（2\*0.08mm）0.16得出行程数45

用于精加工的最后尺寸的0.1行程必须精确计算然后编入程序内

**注意：刀片的真实切深为0.08mm**



## Example for broaching on a TRAUB TNA 400 with C-Axis

NC - Programme

N.....(BROACHING)	Sequence Number and Application
G97 T..... M5	constant RPM, Tool callout, Spindle Stop
M17	C - axis ON
G94	Feed Rate in mm/min
L1 = 30.584	choose Parameter for start Ø
M8 M19	Coolant ON, Spindle Break ON
N100	Sequence Number for repetition START
G0 XL1 Z5	Start position in X and Z in front of part
G1 Z-25 F8000	Linear move in Z at feed rate of 8000 mm/min
G0 X30.584	Rapid move in X to start Ø i.e. drop down position
G0 Z5	Rapid move in Z to start position.
L1 = L1+0.16	As Ø programming is in effect the depth of cut must be doubled (Depth of Cut is 0.08 mm)
N200	Sequence Number of repetition END.
G22 P100 Q200 H45	Repetition Cycle with Sequence Number from START to END and Number of repetitions

Example:

- Groove according to table in bore **Ø 32 mm**
- Groove width **8<sup>c11</sup>**
- Depth of Cut per Stroke 0.08 mm
- The **Number of Strokes** resulted out of complete cutting depth from start position to the bottom of the groove divided by depth of cut per stroke
- This Value must then be multiplied by 2 ( because Ø Programming) and Value is programmed as the Number of Strokes in the NC-Programme.

Calculation:

- Starting Position = Security Distance + Distance from Ø 32 mm to Cutting Edge (see Example on Page R25) equals a segment height of **0.508 mm** + Security Distance of **0.20 mm** to a total of **0.708 mm**.
- Starting Position = **30.584 mm** (32 - [0.708 x 2] = 30.584 mm).
- The groove depth of **2.90 mm** added to the **0.708 mm** = **3.608 mm**.
- This is the dimension from the starting position to the bottom of the groove and in order to program this on the Ø, the **3.608 mm** dimension must be **multiplied by 2** which will equal the sum of **7.216 mm**.
- When the **7.216 mm** is divided by (**2 x 0.08 mm**) = **0.16 mm** depth per stroke the Result will be **45.1 Strokes** and therefore **45 total Strokes** are programmed.

The remainder of 0.1 Strokes to achieve the finish dimension must be programmed using the fine correction.

**Attention: The true depth of cut for the insert will be 0.08 mm.**

## 可锁定主轴的机床上 ( 西门子程序 ) 的加工实例

## NC - 程序

N.....(插削)	编号及应用
T..... M5 LF	刀具调出, 主轴停止
M..... LF	暂停开
G94 LF	进给率 in mm/min
R1 = 30.584 LF	选择初始参数 $\emptyset$
M8 LF	冷却开
N100 LF START	编号
G0 XR1 Z5 LF	X和Z方向起始位置
G1 Z-25 F8000 LF	Z方向直线进给速率8000 mm/min
G0 X30.584	X方向快速复位
G0 Z5	Z方向快速移动至起始位置
R1 = R1+0.16	编程中 $\emptyset$ 增加两倍切深
N200	重复END编号
.....LF	重复循环自START到END

例如：

- 按照表格孔径 $\emptyset$ 32mm内的槽
- 槽宽8<sup>C11</sup>
- 进给0.08mm
- 行程数是完整的槽深，即自起始位置到槽底，除以每行程切深。
- 这个数值必须是2的倍数（因为 $\emptyset$ 编程需要），它将被在NC程序中设定为行程数。

计算：

- 起始位置=安全距离+距离自 $\emptyset$ 切削刃起32mm ( 见P25页实例 )  
拱高0.508 mm +0.20 mm安全距离共0.708 mm
- 起始位置=30.584 mm (32 - [0.708 x 2] = 30.584 mm.  
槽深2.90 mm加上 0.708 mm = 3.608 mm。
- 这是在 $\emptyset$ 编程使用的尺寸：自起始位置到槽底的距离
- 3.608是起始位置到槽底的尺寸，编程过程中3.608需乘以2等于7.216mm
- 7.216除以每行程 ( 2\*00.08mm ) 0.16得出行程数45

用于精加工的最后尺寸的0.1行程必须精确计算然后编入程序内



## Example for broaching on SIEMENS Control Machines with lockable Spindle

NC - Programme

N.....(BROACHING)	Sequence Number and Application
T..... M5 LF	Tool callout, Spindle Stop
M..... LF	Brake ON
G94 LF	Feed Rate in mm/min
R1 = 30.584 LF	choose Parameter for start Ø
M8 LF	Coolant ON
N100 LF	Sequence Number for repetition START
G0 XR1 Z5 LF	Start position in X and Z in front of part
G1 Z-25 F8000 LF	Linear move in Z at feed rate of 8000 mm/min
G0 X30.584	Rapid move in X to start Ø i.e. drop down position
G0 Z5	Rapid move in Z to start position.
R1 = R1+0.16	As Ø programming is in effect the depth of cut must be doubled (Depth of Cut is 0.08 mm)
N200	Sequence Number of repetition END.
.....LF	Repetition Cycle with Sequence Number from START to END and Number of repetitions

Example:

- Groove according to table in bore **Ø 32 mm**
- Groove width **8<sup>c11</sup>**
- Depth of Cut per Stroke 0.08 mm
- The **Number of Strokes** resulted out of complete cutting depth from start position to the bottom of the groove divided by depth of cut per stroke
- This Value must then be multiplied by 2 ( because Ø Programming) and Value is programmed as the Number of Strokes in the NC-Programme.

Calculation:

- Starting Position = Security Distance + Distance from Ø 32 mm to Cutting Edge (see Example on Page R25) equals a segment height of **0.508 mm** + Security Distance of **0.20 mm** to a total of **0.708 mm**.
- Starting Position = **30.584 mm** (32 - [0.708 x 2] = 30.584 mm).
- The groove depth of **2.90 mm** added to the **0.708 mm** = **3.608 mm**.
- This is the dimension from the starting position to the bottom of the groove and in order to program this on the Ø, the **3.608 mm** dimension must be **multiplied by 2** which will equal the sum of **7.216 mm**.
- When the **7.216 mm** is divided by (**2 x 0.08 mm**) = **0.16 mm** depth per stroke the Result will be **45.1 Strokes** and therefore **45 total Strokes** are programmed.

The remainder of 0.1 Strokes to achieve the finish dimension must be programmed using the fine correction.

# 硬质合金牌号的选择 I

## CHOICE OF CARBIDE GRADES I

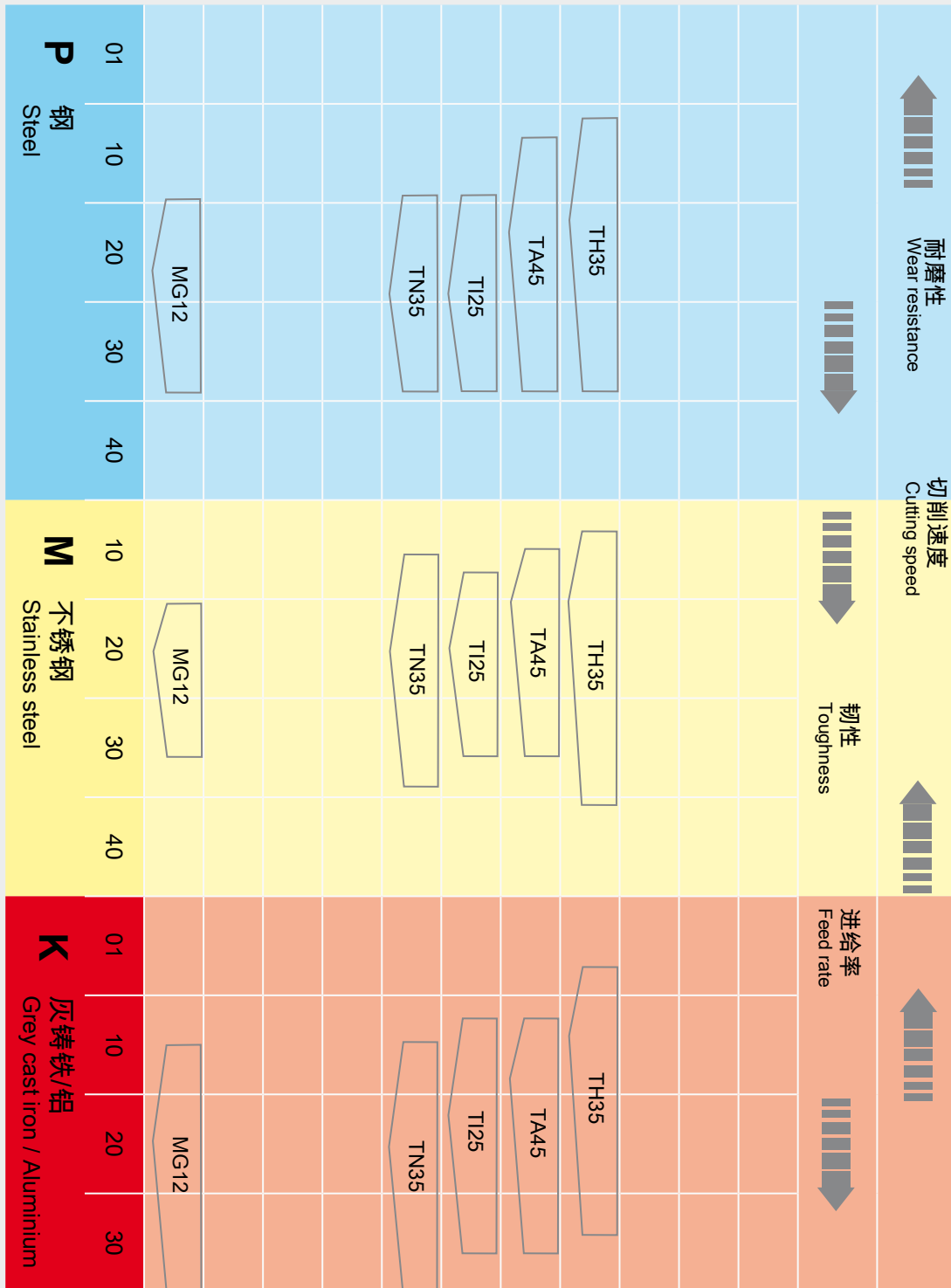


R

硬质合金牌号  
Carbide Grades

无涂层  
uncoated

涂层  
coated



# 硬质合金牌号的选择 II

## CHOICE OF CARBIDE GRADES II



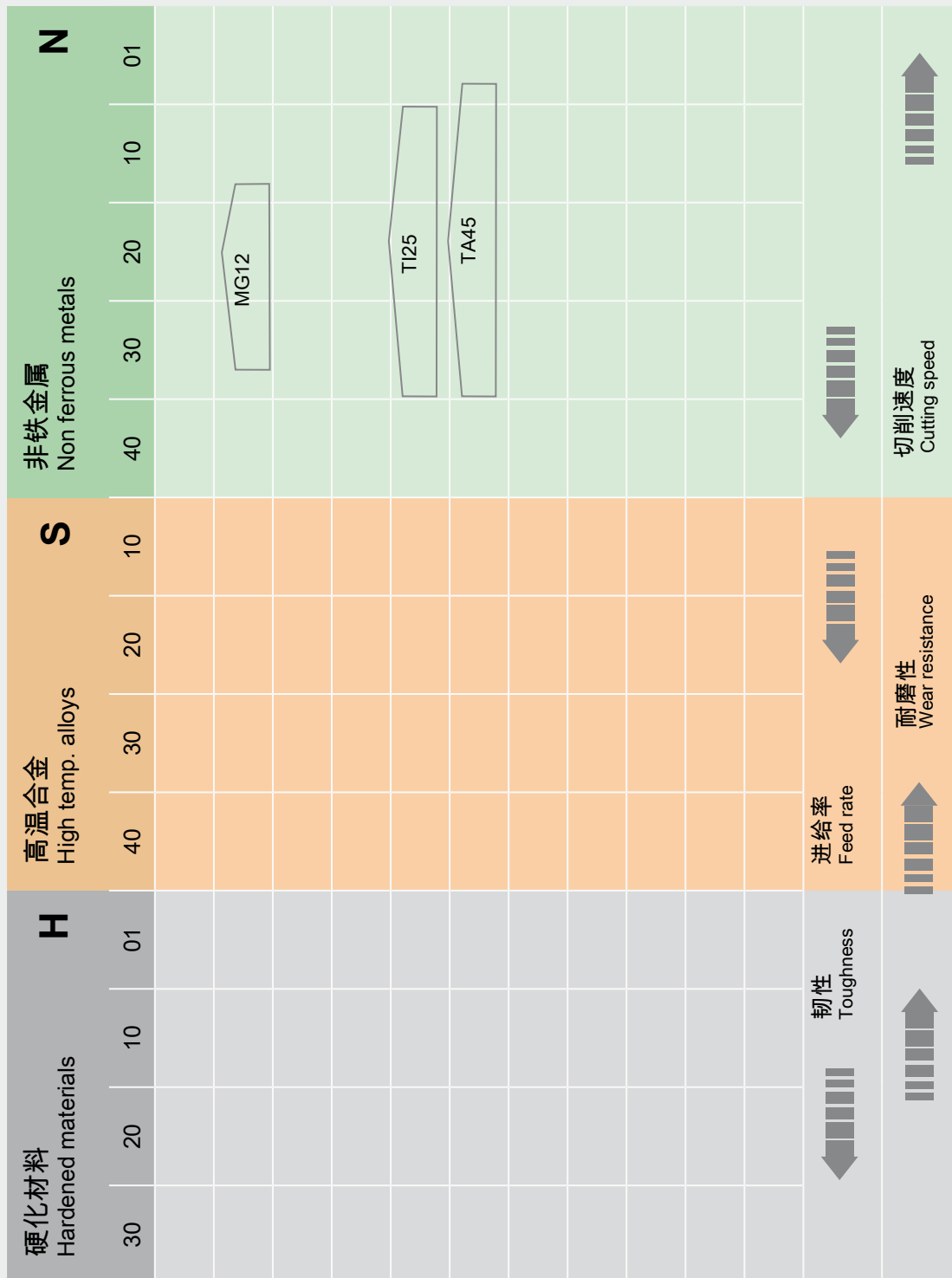
R

硬质合金牌号  
Carbide Grades

合成切削刀具材料  
Synthetic cutting-tool material

无涂层  
uncoated

涂层  
coated



### 无涂层牌号

MG12 - 一种具有良好耐磨性的牌号，用于中低速加工钢件，铸铁和非铁材料。

TN35 - 一种非常受欢迎的涂层TiN,用于中低速切削，推荐用于加工不锈钢和特种合金。

TI25 - TiCN涂层具有很高的耐磨性，推荐用于中速加工钢和有色金属材料

TA45 - 一种TiAlN涂层，具有非常好的热稳定性和高硬度

TH35 - 新的标准牌号-出色的热稳定性和高硬度，并且有非常低的摩擦系数。

### UNCOATED GRADES

MG12 - a universal grade with good wear resistance. Used at low or medium cutting speeds for machining steel, cast iron and non ferrous materials

TN35 - a very popular grade TiN coated used to low or medium cutting speeds. Also recommended for machining stainless steel or exotic alloyed materials

TI25 - a TiCN coated grade with high abrasion resistance. Recommended for machining steel and non ferrous materials at medium cutting speeds

TA45 - a TiAlN coated grade. This coating has a very high temperature stability and high hardness.

TH35 - new standard grade - extreme Oxidation resistance with high hardness and very good coefficient of friction.

高抛光车削  
105及117系列金刚石刀具

S



Polish turning with  
diamond tools type 105 and S117

**H10**  
*technische Diamanten*

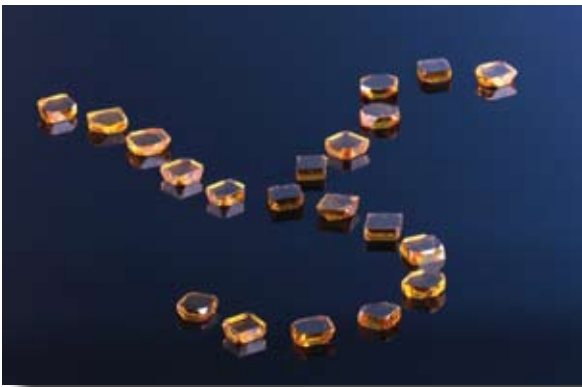
## 金刚石切削材质

- 单晶和天然钻石是最硬的材料
- 颜色：黄色至灰色，有时是绿色
- 面晶体结构
- 单晶金刚石是一种用于极精加工的非常理想的切削材料。

S

### Diamond cutting materials

- Monocrystalline and natural diamonds are the hardest materials
- Colour: yellowish to grey, sometimes greenish
- Oriented crystalline structure
- Monocrystalline diamond is the perfect cutting material for brilliant finish and high-precision machining with geometrically determined cutter



- |                              |   |
|------------------------------|---|
| - 含碳量大于99%                   | - min. 99% carbon                       |
| - < 1%的氢，氮和氧                 | - < 1% hydrogen, nitrogen and oxygen    |
| - 硬度10000 kg/mm <sup>2</sup> | - Hardness of 10,000 kg/mm <sup>2</sup> |
| - 莫氏硬度20° C: 10              | - Mohs hardness at 20° C: 10            |
| - 密度3.52 g/cm <sup>3</sup>   | - Density 3.52 g/cm <sup>3</sup>        |
| - 沸点: 4827°C                 | - Boiling point: 4827°C                 |
| - 导热系数0.0000011/K            | - Thermal coefficient: 0.0000011/K      |



抛光车削  
POLISH TURNING

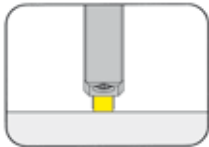
S

刀杆 型号  
Toolholder type  
B105

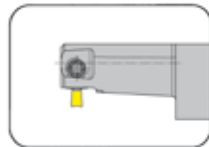


页 / Page  
S4

刀杆 型号  
Toolholder type  
105

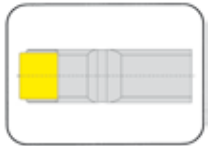


页 / Page  
S5

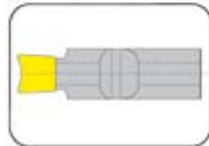


页 / Page  
S10

刀片 型号  
Insert type  
105



页 / Page  
S6-S7



页 / Page  
S11-S12

刀杆 型号  
Toolholder type  
H117



页 / Page  
S8

刀片 型号  
Insert type  
S117



页 / Page  
S9

刀片 型号  
Insert type  
VCGW



页 / Page  
S13

切削参数  
Cutting data

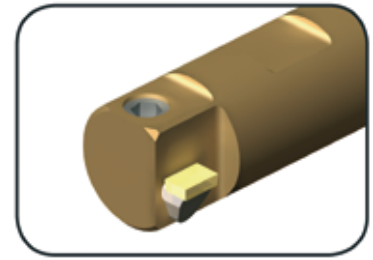
页 / Page  
S14

技术说明见章节Q  
For Technical Instructions please see chapter Q

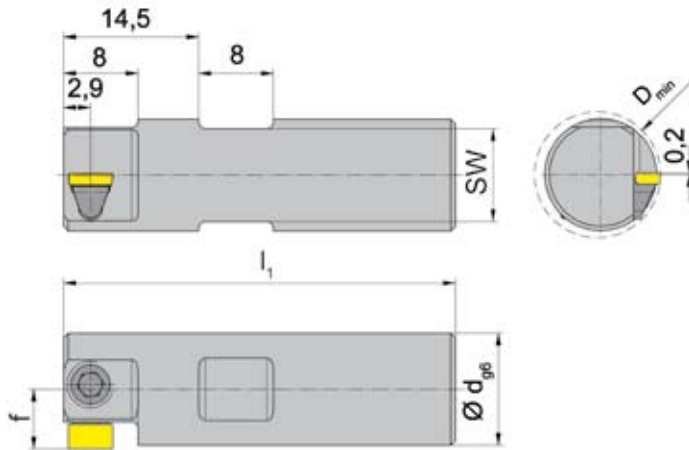
S

刀杆 型号  
TOOLHOLDER Type

**B105**



孔径Ø 自 Bore Ø from 13.5 mm



配合刀片  
for use with Insert

型号 105.MD...  
Type

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	$l_1$	f	$D_{min}$	SW	规格 Size
R/LB105.MD12.2.13	12	42	6.4	13.5	10	MD
R/LB105.MD12.4.13		72				
R/LB105.MD12.6.13		90				
R/LB105.MD12.8.13		125				

注明R或L型  
State R or L version

要求的刀片  
Inserts upon request

尺寸单位 : mm  
Dimensions in mm

可根据要求订制更多尺寸和形式  
Further sizes and versions upon request

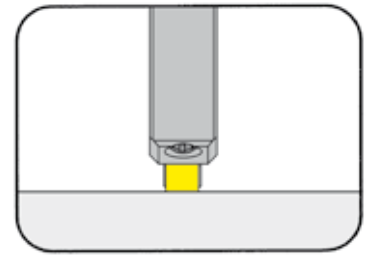
螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

附件  
Spare parts

刀杆 Toolholder	扳手 Wrench	螺纹锁紧销 Threaded pin
R/LB105.MD12....	SW2,5DIN911	DIN913-M5x5

刀夹 型号  
CASSETTE Type

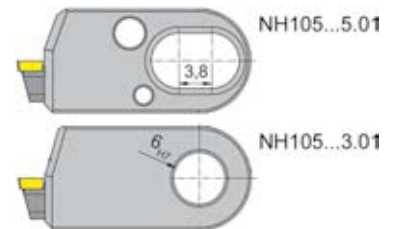
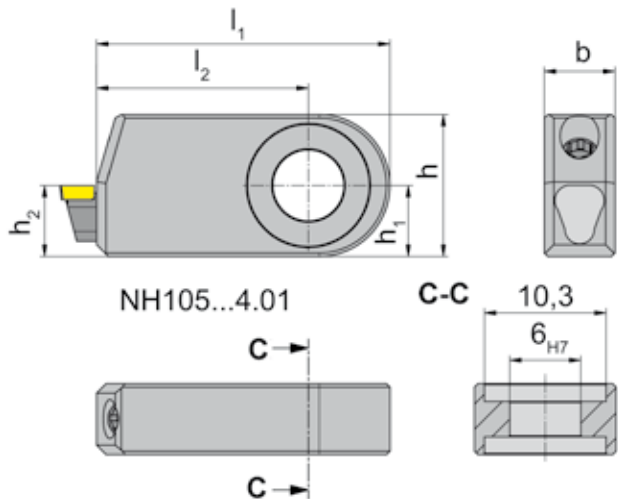
# NH105



高抛光车削/高抛光铣削  
High polish turning / High polish milling

配合刀片  
for use with Insert

型号 105...F.06  
Type 105...D.06



产品型号 Part number	$l_1$	$l_2$	$h$	$h_1$	$h_2$	$b$
NH105.MD.06.3.01	23.9	17.9	12	6	6	6
NH105.MD.06.4.01	24.8	17.9	12	6	6	6
NH105.MD.06.5.01	23.9	19.4	12	6	6	6

尺寸单位：mm  
Dimensions in mm

按需提供更多尺寸  
Further sizes upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

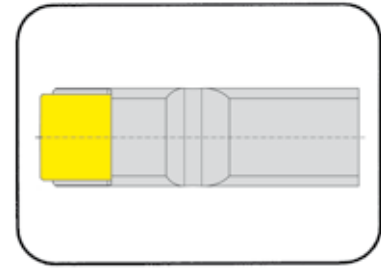
附件  
Spare parts

刀夹 Cassette	扳手 Wrench	螺纹锁紧销 Threaded pin
NH105.MD.06....	SW2,0DIN911	DIN913-M4x5

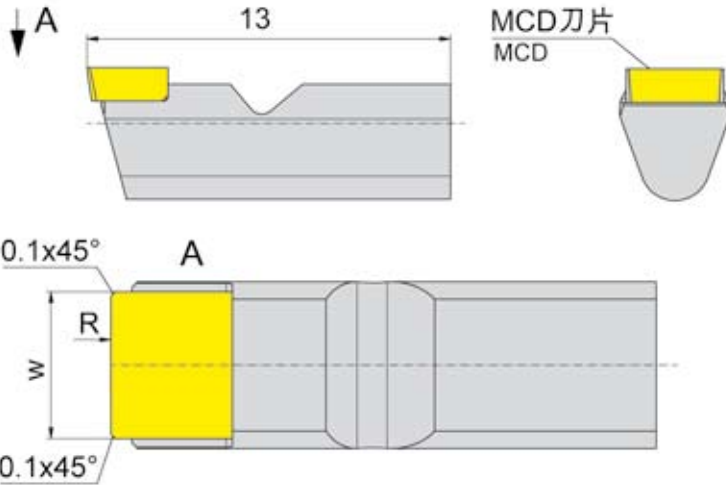
### 刀片型号

INSERT type

# 105



抛光铣削  
High polish milling



用于刀夹  
for use with Cassette

型号 NH105  
type

产品编号 Part number	w	R	硬质合金牌号 Carbide Grades	断屑槽用于 / Geometries for			
				铝 Aluminium	黄铜 Brass	塑料 (PMMA) Synthetics (PMMA)	
105.300.AF.06	3.5	300	▲	x			
105.300.KF.06	3.5	300	▲			x	
105.300.MF.06	3.5	300	▲		x		
▲ 库存品 / on stock    Δ 4周 / 4 weeks ● 主要应用 / main recommendation ○ 可替换推荐 / alternative recommendation ■ 无涂层牌号 / uncoated grades ■ 涂层牌号 / coated grades ■ 钎焊 MCD / brazed MCD				P			
				M			
				K			
				N	•	•	•
				S			
				H			

尺寸单位 : mm  
Dimensions in mm

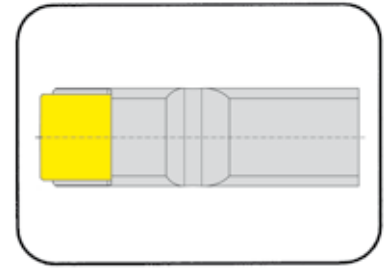
中心高需调整的正确位置。  
切削刃需光学测量  
Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

MCD-根据要求重磨  
MCD - Regrind upon request

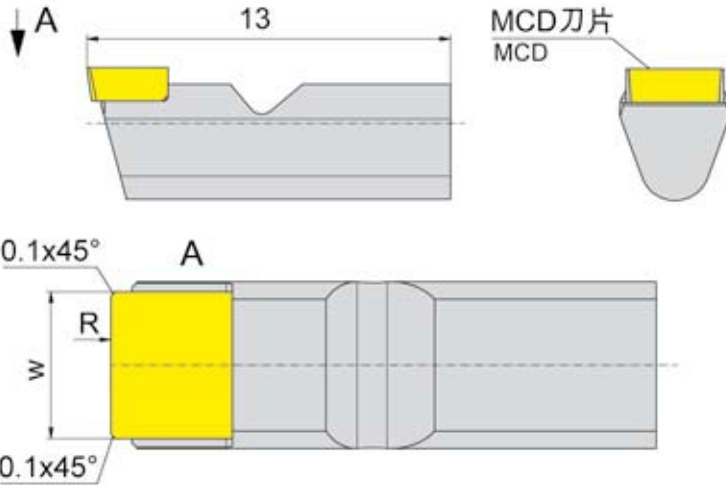
### 刀片型号

INSERT type

# 105



抛光车削  
High polish turning



用于刀夹  
for use with Cassette

型号 NH105  
type

S

产品编号 Part number	w	R	硬质合金牌号 Carbide Grades	断屑槽用于 / Geometries for		
				铝 Aluminium	黄铜 Brass	塑料 (PMMA) Synthetics (PMMA)
105.300.AD.06	3.5	300	▲	x		
105.300.KD.06	3.5	300	▲			x
105.300.MD.06	3.5	300	▲		x	
			P			
			M			
			K			
			S			
			N	•	•	•
			H			

尺寸单位 : mm  
Dimensions in mm

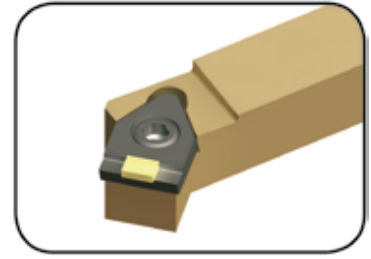
中心高需调整的正确位置。  
切削刃需光学测量

Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

MCD-根据要求重磨  
MCD - Regrind upon request

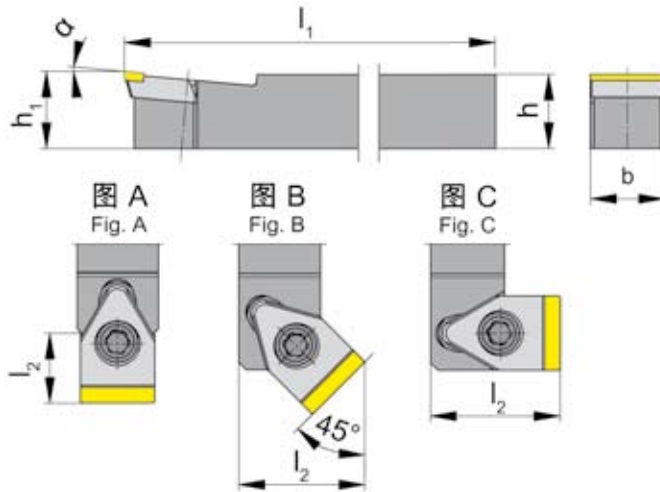
刀杆型号  
TOOLHOLDER Type

# H117



配合刀片  
for use with Insert

型号 S117...10  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	$\alpha$	图型 Figure	h	$h_1$	b	$l_1$	$l_2$
H117.1010.10	5°	A	10	10.0	10	100	-
H117.1212.10	5°	B	12	12.0	12	125	9.0
H117.1616.10	5°	B	16	16.0	16	125	9.0
H117.MD10.00.5.10	5°	A	10	10.4	10	100	-
R/LH117.MD10.45.5.10	5°	B	10	10.4	11	100	17.0
R/LH117.MD10.90.5.10	5°	C	10	10.4	10	100	17.5

注明R或L型  
State R or L version

尺寸单位：mm  
Dimensions in mm

可根据要求订制更多尺寸和形式  
Further sizes and versions upon request

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

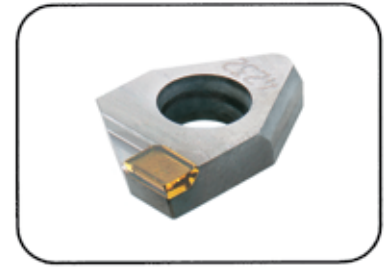
附件  
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
H117...10	030.400P.0227	T15PQ
H117.1212.10/...1616.10	4.09T15P	T15PQ

### 刀片型号

INSERT type

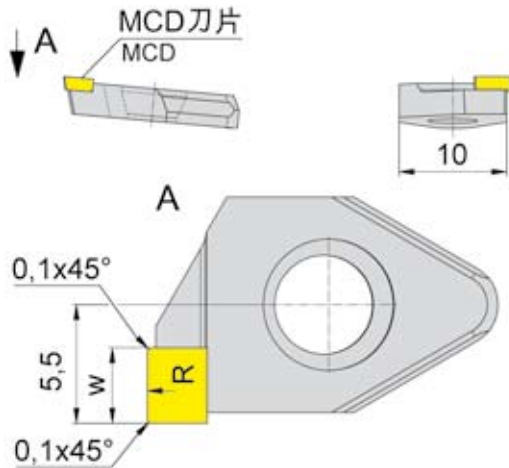
# S117



侧车削 / 仿形  
Side turning / Profiling

用于刀杆  
for use with Toolholder

型号 H117...10  
type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品编号 Part number	w	R	硬质合金牌号 Carbide Grades	断屑槽用于 / Geometries for		
				铝 Aluminium	黄铜 Brass	塑料 (PMMA) Synthetics (PMMA)
RS117.300.00.A0.10 LS117.300.00.A0.10	3.5	300	▲ △	x x		
RS117.300.00.K0.10 LS117.300.00.K0.10			▲ △			x x
RS117.300.00.M0.10 LS117.300.00.M0.10	3.5	300	▲ △		x x	
▲ 库存品 / on stock    △ 4周 / 4 weeks			P			
● 主要应用 / main recommendation			M			
○ 可替换推荐 / alternative recommendation			K			
■ 无涂层牌号 / uncoated grades			N	•	•	•
■ 涂层牌号 / coated grades			S			
■ 钎焊 MCD / brazed MCD			H			

尺寸单位 : mm  
Dimensions in mm

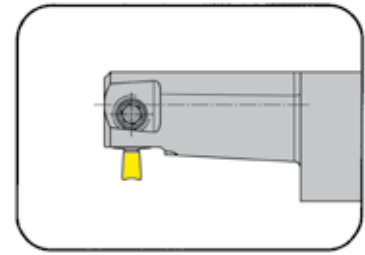
注明R或L型  
State R or L version

中心高需调整的正确位置。  
切削刃需光学测量  
Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

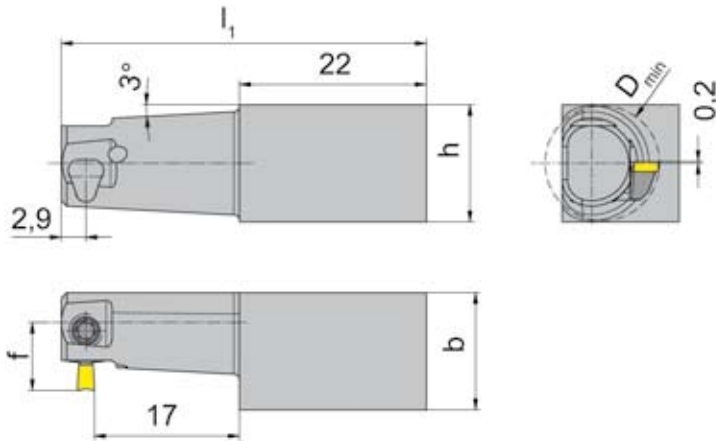
MCD-根据要求重磨  
MCD - Regrind upon request

刀杆 型号  
TOOLHOLDER Type

# HC105



孔径Ø 自 Bore Ø from 13.5 mm



配合 刀片  
for use with Insert

型号 105...MD...  
Type

产品型号 Part number	$l_1$	$h$	$f$	$D_{min}$	$b$	规格 Size
<b>RHC105.MD1414.2.10</b>	42	13.8	8	13.5	13.8	MD

按需提供更多尺寸  
Further sizes upon request

尺寸单位：mm  
Dimensions in mm

螺丝的扭矩规格，详见技术说明。  
For torque specifications of the screw, please see Technical Instructions.

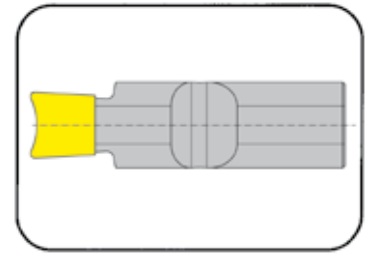
附件  
Spare parts

刀杆 Toolholder	扳手 Wrench	螺纹锁紧销 Threaded pin	扳手 Wrench	螺纹锁紧销 Threaded pin
RHC105.MD1414.2.10	<b>SW2,5DIN911</b>	<b>DIN913-M4x5</b>	<b>SW2,0DIN911</b>	<b>DIN913-M5x5</b>

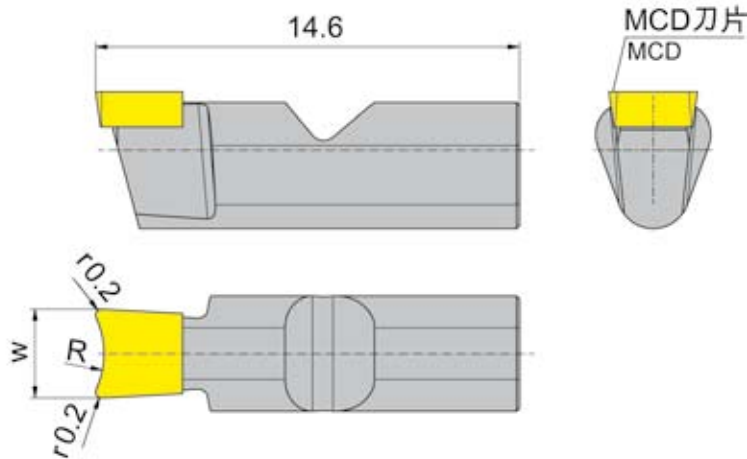


刀片 型号  
INSERT Type

# 105



高抛光车削  
High polish turning



配合 刀夹  
for use with Cassette

型号 NH105.MD...01  
Type

产品编号 Part number	w	R	硬质合金牌号 Carbide Grades MD10	断屑槽用于 / Geometries for		
				铝 Aluminium	黄铜/黄金 Brass/Gold	塑料 (PMMA) Synthetics (PMMA)
<b>105.3030.MD.06</b>	3.05	3	▲		x	
▲ 库存品 / on stock    Δ 4周 / 4 weeks			P			
● 主要应用 / main recommendation			M			
○ 可替换推荐 / alternative recommendation			K			
■ 无涂层硬质合金牌号 / uncoated grades			N		•	
■ 涂层牌号 / coated grades			S			
■ 钎焊 MCD / brazed MCD			H			

尺寸单位 : mm  
Dimensions in mm

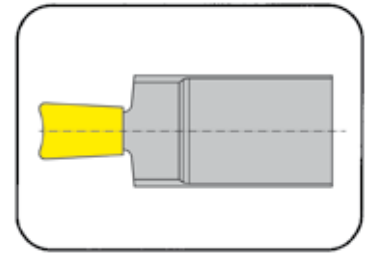
中心高需调整的正确位置。  
切削刃需光学测量  
Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

MCD-根据要求重磨  
MCD - Regrind upon request

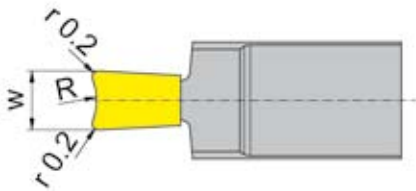
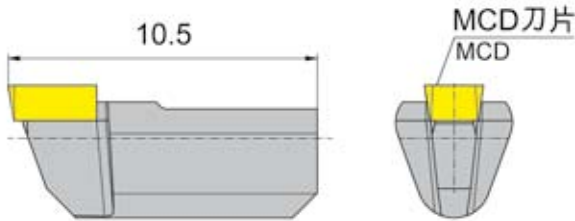
S

刀片 型号  
INSERT Type

# 105



高抛光车削  
High polish turning



配合 刀杆  
for use with Toolholder

型号 RHC105.MD1414.2.10  
Type

产品编号 Part number	w	R	硬质合金牌号 Carbide Grades	断屑槽用于 / Geometries for		
				铝 Aluminium	黄铜/黄金 Brass/Gold	塑料 (PMMA) Synthetics (PMMA)
<b>105.2020.MD.10</b>	2	2	MD10		x	
▲ 库存品 / on stock    Δ 4周 / 4 weeks			P			
● 主要应用 / main recommendation			M			
○ 可替换推荐 / alternative recommendation			K			
□ 无涂层硬质合金牌号 / uncoated grades			N		•	
■ 涂层牌号 / coated grades			S			
■ 钎焊 MCD / brazed MCD			H			

尺寸单位 : mm  
Dimensions in mm

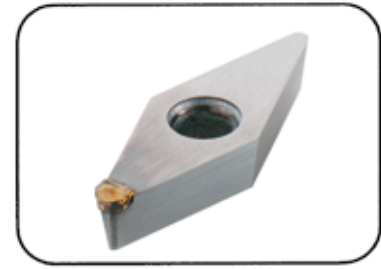
中心高需调整的正确位置。  
切削刃需光学测量  
Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

MCD-根据要求重磨  
MCD - Regrind upon request

### 刀片型号

INSERT type

# VCGW

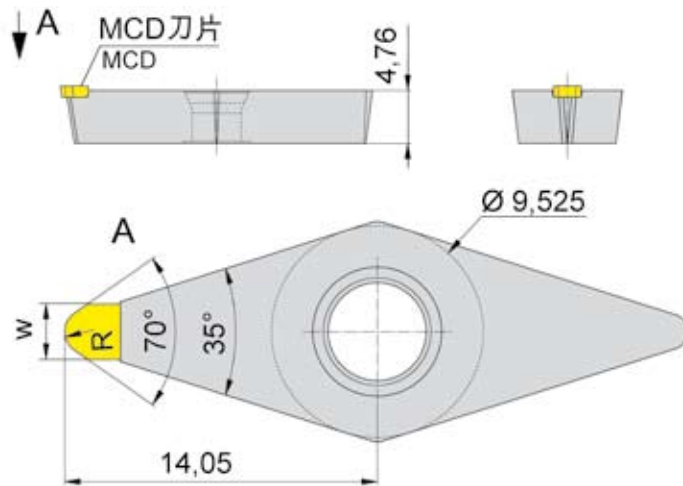


侧车削 / 仿形  
Side turning / Profiling

用于ISO刀杆  
for use with ISO-Toolholder

**S**

规格 .16  
Size .16



产品编号 Part number	w	R	硬质合金牌号 Carbide Grades	断屑槽用于 / Geometries for		
				铝 Aluminium	黄铜 Brass	塑料 (PMMA) Synthetics (PMMA)
VCGW160410.00.A0	2.5	1	▲	x		
VCGW160410.00.K0	2.5	1	▲			x
VCGW160410.00.M0	2.5	1	▲		x	
▲ 库存品 / on stock    Δ 4周 / 4 weeks				P		
● 主要应用 / main recommendation				M		
○ 可替换推荐 / alternative recommendation				K		
■ 无涂层牌号 / uncoated grades				N	•	•
■ 涂层牌号 / coated grades				S		
■ 钎焊 MCD / brazed MCD				H		

尺寸单位 : mm  
Dimensions in mm

中心高需调整的正确位置。  
切削刃需光学测量  
Centre height must be measured and adjusted to the correct position.  
Cutting edges must be measured optically!

MCD-根据要求重磨  
MCD - Regrind upon request

### 纳米级高抛光表面的加工

Machining of high polished surfaces in Nano quality



S

材料 Material	$v_c$ (m/min)	f (mm/转) f (mm/rev)	$a_p$ (mm)	冷却 cooling	
非铁金属 Non ferrous metals	Ag	200 - 250	0.05 - 0.06	0.02 - 0.05	•
	Al	200 - 400	0.02 - 0.10	0.02 - 0.05	•
	Au	200 - 250	0.05 - 0.06	0.02 - 0.05	•
	CuSn	150 - 250	0.05 - 0.10	0.02 - 0.05	•
	Cu	150 - 300	0.02 - 0.10	0.02 - 0.05	• / -
	CuZn	150 - 250	0.05 - 0.10	0.02 - 0.05	• / -
	Pt	150 - 125	0.02 - 0.04	0.01 - 0.03	•
塑料 Synthetics	PMMA	100 - 150	0.05 - 0.10	0.02 - 0.05	• / -
	PC	80 - 150	0.05 - 0.10	0.02 - 0.05	• / -
	PVC	150 - 250	0.05 - 0.10	0.02 - 0.05	• / -
	PE	150 - 300	0.05 - 0.10	0.02 - 0.05	• / -



如需详细技术信息请查阅最新样本。

For further technical information please ask for our current catalogues.

## CVD金刚石和PCD ISO刀片



CVD Diamond and  
PCD tipped ISO inserts



帶有HORN 3D斷屑槽  
with HORN 3D geometries

T

## 超硬切削材料的应用

该样本中的刀具和刀片为非铁材料以及各种塑料的加工提供经济，高效的解决方案。

我们的技术部门将帮助您选择合适的CVD和PCD金刚石刀具。

为了发挥金刚石刀具优势和潜力，正确的使用方法是必需的。

PCD，MCD，CVD-D，或天然钻石由于其致密性和构造形成的超硬性以及由此产生的锋利刃口决定了这类刀具与传统刀具不同的加方式。

不同的金刚石刀具根据加工任务的不同进行优化而得到。

因此选择正确的金刚石牌号和合适的几何槽型非常重要。

我们推荐的切削参数是实现良好的切屑控制及高效经济加工的关键，在每个案例中，都需要根据实际加工条件调整加工参数。

机床，加工线路，主轴和工件及刀具夹持系统的设计都对您想要的结果有决定性的影响。为了实现最好的稳定性以得到最佳的加工效果，应该将所有的加工条件都考虑到。

### Application of high-hard cutting materials

The tools and inserts presented in this catalogue are intended to represent solutions for economic and high productive machining of Non Ferrous materials as well as plastics with various fillers.

The technical section will help you to properly select and apply our CVD and PCD diamond tool assortment.

Correct use and application is essential to obtain the benefits and highest potential of the Diamond materials.

The superior hardness of Diamond in its various consistencies and structures like PCD, MCD, CVD-Diamond, or Natural Diamond and the resulting sharpness of the cutting edge, demands a different approach to machining than that of conventional tooling.

The different Diamond cutting materials are optimised according to the consistencies and structures for different challenges.

Therefore it is important to choose the right diamond grade in combination with the optimal cutting edge geometry.

Our recommended cutting parameters are the key to achieving a highly economical result combined with good chip control. In every case you need to adjust parameters per your overall machining conditions.

The design of the machine, ways, spindles, and clamping system of the workpiece and tools have a determining influence on your results. To achieve the best possible results, you should take all machining conditions into consideration in order to raise the stability to the highest possible level.

**CCGT...N.HS/HN**

带有HORN 3D断屑槽 / with 3D HORN chip breaker

T6

**CCGT...Wiper**

带HORN 3D断屑槽的修光槽型 /  
Wiper geometry with 3D HORN chip breaker

T7

**CCGT...R/LG.HN**

全切削刃带有HORN 3D断屑槽 /  
complete edge with 3D HORN chip breaker

T8

**CPGT...N.HS/HN**

带HORN 3D断屑槽 / with 3D HORN chip breaker

T9

**DCGT...N.HS/HN**

带有HORN 3D断屑槽 / with 3D HORN chip breaker

T10

**DCGT...Wiper**

带HORN 3D断屑槽的修光槽型 /  
Wiper geometry with 3D HORN chip breaker

T11

**VCGT...N.HS/HN**

带有HORN 3D断屑槽 / with 3D HORN chip breaker

T12

**CCGT...N.H6**

“正-中性”型 / Version "positive-neutral"

T13

**CCGW...N.H0**

“中性”型 / Version "neutral"

T14

**DCGT...N.H6**

“正-中性”型 / Version "positive-neutral"

T15

**DCGW...N.H0**

“中性”型 / Version "neutral"

T16

**VCGT...N.H6**

“正-中性”型 / Version "positive-neutral"

T17

**VCGW...N.H0**

“中性”型 / Version "neutral"

T18

**技术说明 / 附加设备**

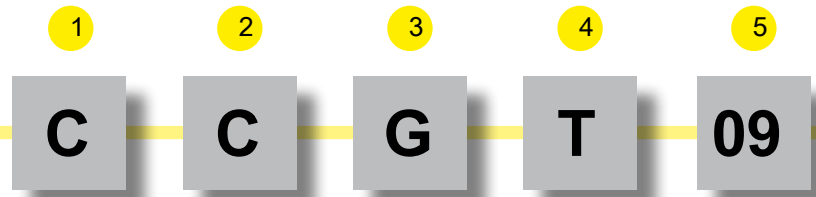
Technical Instructions / Additional equipment

T19 - T28

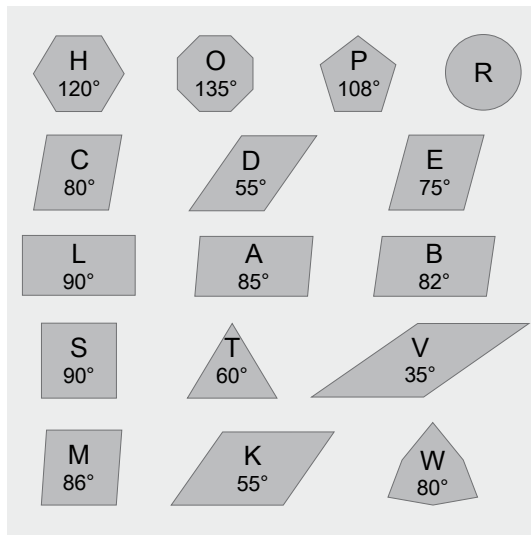
T3

T

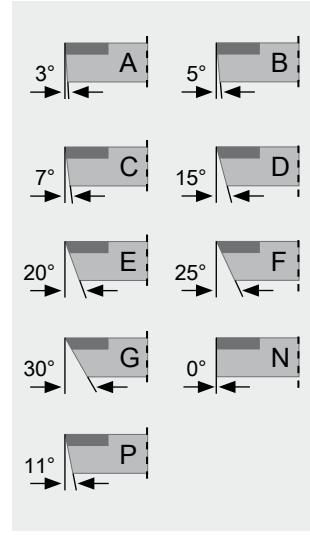
### ISO-数字-编码 ISO-Designation-Code



#### 1 外形 Shape



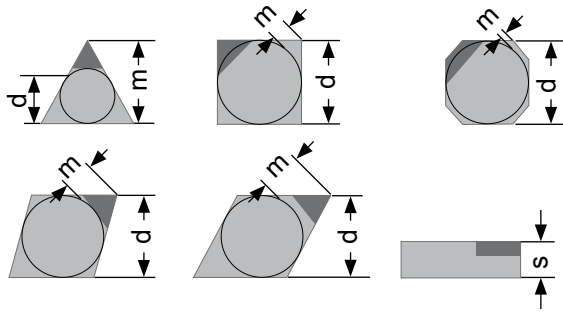
#### 2 后角 Clearance



#### 4 刀片 Insert type

A	
G	
M	
N	
P	
R	
T	
W	
X	非标 Special

#### 3 公差等级 Tolerance grade

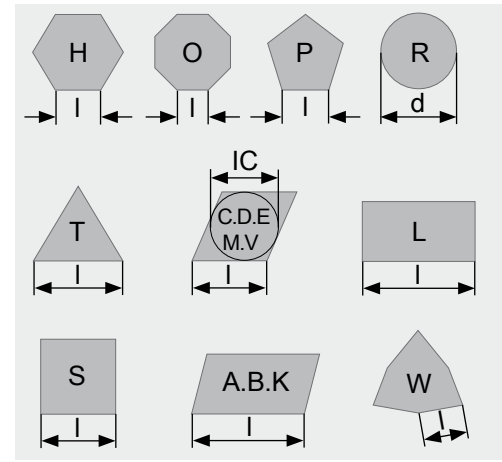


	m	s	d*
A	±0.005	±0.025	±0.025
E	±0.025	±0.025	±0.025
F	±0.005	±0.025	±0.013
G	±0.025	±0.013	±0.025
H	±0.013	±0.025	±0.013
J	±0.005	±0.025	±0.05-0.15
K	±0.013	±0.025	±0.05-0.15
L	±0.025	±0.025	±0.05-0.15
M	±0.08-0.20	±0.05-0.13	±0.05-0.15
N	±0.08-0.20	±0.025	±0.05-0.15
U	±0.13-0.38	±0.13	±0.08-0.25

公差 ( mm )  
Tolerance in mm

\* 精确的公差决定于刀片的尺寸  
\* Exact tolerance is determined by size of insert

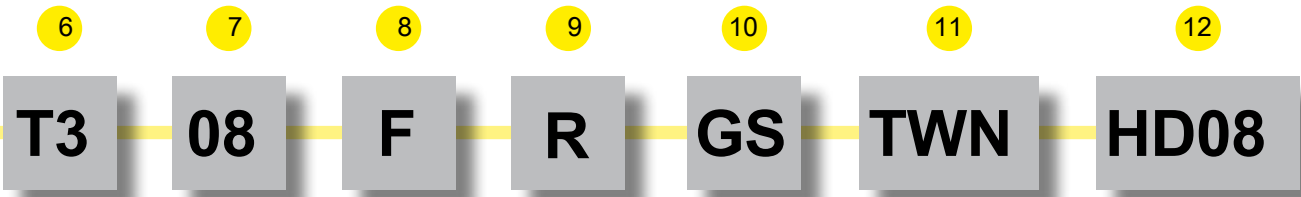
#### 5 切削刃长度/刀片规格 Length of cutting edge/insert size



IC "d" 见订单描述  
IC "d" see order description

如果小于10, 首位使用0 (例如: 9.525 mm = 09)  
If less than 10 use 0 in first place (Example: 9.525 mm = 09)





### 6 厚度 : mm Thickness in mm

	s
01	1.59
T1	1.98
02	2.38
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35



如果小于10, 首位使用0  
(例如: 3.18 mm = 03)  
If less than 10 use 0 in first place  
(Example: 3.18 mm = 03)

### 7 圆角结构 Corner configuration

圆角 Radius	
00	尖角 Sharp corner
01	0.1 mm
02	0.2 mm
04	0.4 mm
08	0.8 mm
12	1.2 mm
16	1.6 mm
00	圆刀片 (英寸) Round insert (inch)
M0	圆刀片 (米制) Round insert (metr.)



### 断屑槽 Geometry

Geometry

主切削刃和修光面间的主偏角  
Entering angle of the main cutting edge to the wiper flat

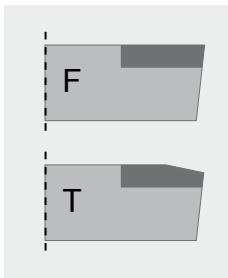
修光刃后角  
Wiper edge clearance

A - 45°	A - 3°
D - 60°	B - 5°
E - 75°	C - 7°
F - 85°	D - 15°
P - 90°	E - 20°

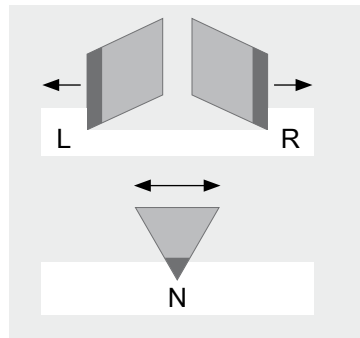
ZZ - 非标/Special  
(需要更准确的信息/  
detailed explanations are  
necessary)

F - 25°
G - 30°
N - 0°
P - 11°

### 8 切削刃设计 Cutting edge condition



### 9 切削方向 Cutting direction



### 10 钎焊类型 Tipping type

无 without	刀尖刃口 Edge tipped
FF	整个刀面 Full face
GS	整个切削刃 Whole cutting edge
W	修光槽型 Wiper Geometries

### 11 断屑 Chipbreaker

HN	HORN 3D断屑槽, 半精加工 HORN 3D Geometry, medium up to roughing
HS	HORN 3D断屑槽, 精加工, 如果工件较脆-低 $a_p$ HORN 3D Geometry, finishing, low $a_p$ for fragile parts
H0	中性型 Version neutral
H6	正-中性型 Version positive-neutral

### 12 切削材料 Cutting materials

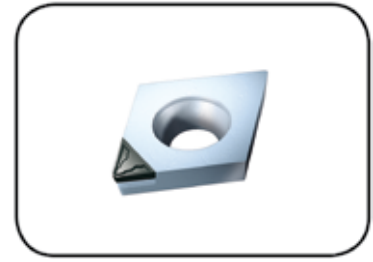
MD10	(MKD)
HD08	(CVD-D)
PD02	(PCD)
PD75	(PCD)

详细信息参阅T21页  
Details see page T21

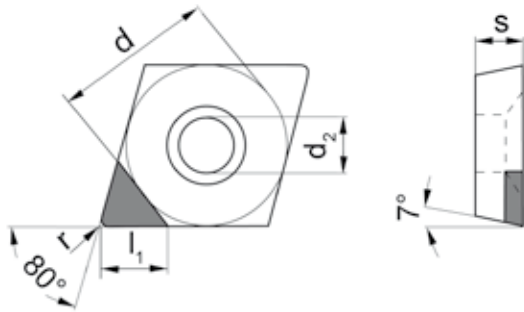
T

**CVD-D 刀片 型号**  
CVD-D INSERT Type

## CCGT



带HORN 3D断屑槽  
with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
CCGT060201N.HS	6.350	2.8	2.38	3.0	0.1	▲
CCGT060202N.HN	6.350	2.8	2.38	3.0	0.2	▲
CCGT060202N.HS	6.350	2.8	2.38	3.0	0.2	▲
CCGT060204N.HN	6.350	2.8	2.38	3.0	0.4	▲
CCGT060204N.HS	6.350	2.8	2.38	3.0	0.4	▲
CCGT060208N.HN	6.350	2.8	2.38	3.0	0.8	▲
CCGT060208N.HS	6.350	2.8	2.38	3.0	0.8	▲
CCGT09T301N.HS	9.525	4.4	3.97	4.5	0.1	▲
CCGT09T302N.HN	9.525	4.4	3.97	4.5	0.2	▲
CCGT09T302N.HS	9.525	4.4	3.97	4.5	0.2	▲
CCGT09T304N.HN	9.525	4.4	3.97	4.5	0.4	▲
CCGT09T304N.HS	9.525	4.4	3.97	4.5	0.4	▲
CCGT09T308N.HN	9.525	4.4	3.97	4.5	0.8	▲
CCGT09T308N.HS	9.525	4.4	3.97	4.5	0.8	▲
CCGT120402N.HN	12.700	5.5	4.76	4.5	0.2	▲
CCGT120402N.HS	12.700	5.5	4.76	4.5	0.2	▲
CCGT120404N.HN	12.700	5.5	4.76	4.5	0.4	▲
CCGT120404N.HS	12.700	5.5	4.76	4.5	0.4	▲
CCGT120408N.HN	12.700	5.5	4.76	4.5	0.8	▲
CCGT120408N.HS	12.700	5.5	4.76	4.5	0.8	▲
CCGT120412N.HN	12.700	5.5	4.76	4.5	1.2	▲
CCGT120412N.HS	12.700	5.5	4.76	4.5	1.2	▲

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

□ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

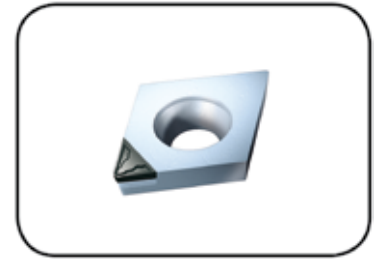
切削刃必须测量  
Cutting edges must be measured optically!

硬质合金牌号  
Carbide grades

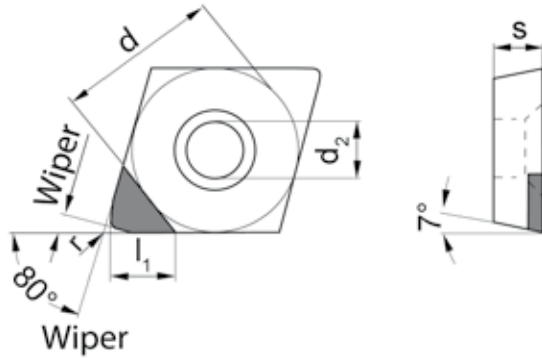
P
M
K
N •
S
H

## CVD-D 刀片 型号 CVD-D INSERT Type

## CCGT



带HORN 3D断屑槽的修光几何槽形  
Wiper geometry with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

请注意接近角！  
见T19页  
Please note the approach angle!  
See page T19

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
CCGT060202N.W.HN	6.350	2.8	2.38	2.9	0.2	▲
CCGT060202N.W.HS	6.350	2.8	2.38	2.9	0.2	▲
CCGT060204N.W.HN	6.350	2.8	2.38	2.9	0.4	▲
CCGT060204N.W.HS	6.350	2.8	2.38	2.9	0.4	▲
CCGT09T302N.W.HN	9.525	4.4	3.97	4.4	0.2	▲
CCGT09T302N.W.HS	9.525	4.4	3.97	4.4	0.2	▲
CCGT09T304N.W.HN	9.525	4.4	3.97	4.4	0.4	▲
CCGT09T304N.W.HS	9.525	4.4	3.97	4.4	0.4	▲
CCGT120402N.W.HN	12.700	5.5	4.76	4.4	0.2	▲
CCGT120402N.W.HS	12.700	5.5	4.76	4.4	0.2	▲
CCGT120404N.W.HN	12.700	5.5	4.76	4.4	0.4	▲
CCGT120404N.W.HS	12.700	5.5	4.76	4.4	0.4	▲

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P
M
K
N •
S
H

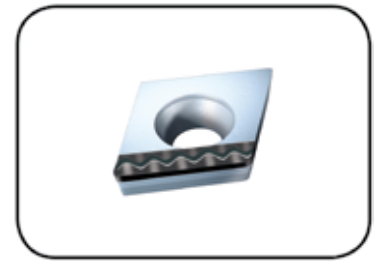
尺寸单位 : mm  
Dimensions in mm

硬质合金牌号  
Carbide grades

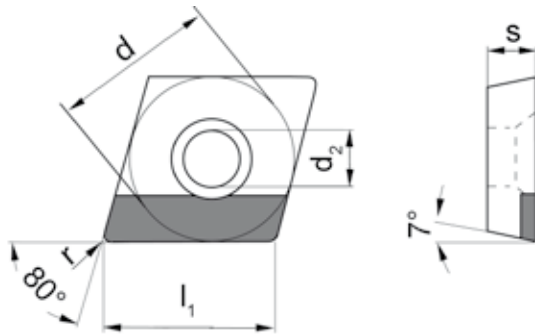
切削刃需测量！  
Cutting edges must be measured optically!

## PCD刀片 型号 PCD INSERT Type

# CCGT



整个切削刃都有HORN 3D断屑槽  
complete edge with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	PD02
CCGT060204L.G.HN	6.350	2.8	2.38	6.4	0.4	▲
CCGT060204R.G.HN	6.350	2.8	2.38	6.4	0.4	▲
CCGT060208L.G.HN	6.350	2.8	2.38	6.3	0.8	▲
CCGT060208R.G.HN	6.350	2.8	2.38	6.3	0.8	▲
CCGT09T304L.G.HN	9.525	4.4	3.97	9.6	0.4	▲
CCGT09T304R.G.HN	9.525	4.4	3.97	9.6	0.4	▲
CCGT09T308L.G.HN	9.525	4.4	3.97	9.5	0.8	▲
CCGT09T308R.G.HN	9.525	4.4	3.97	9.5	0.8	▲
CCGT120404L.G.HN	12.700	5.5	4.76	12.8	0.4	△
CCGT120404R.G.HN	12.700	5.5	4.76	12.8	0.4	△
CCGT120408L.G.HN	12.700	5.5	4.76	12.7	0.8	△
CCGT120408R.G.HN	12.700	5.5	4.76	12.7	0.8	△

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量 !

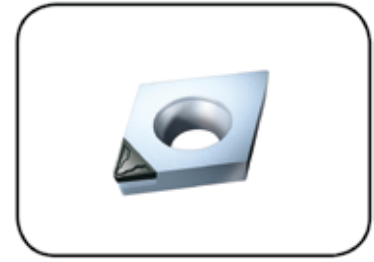
Cutting edges must be measured optically!

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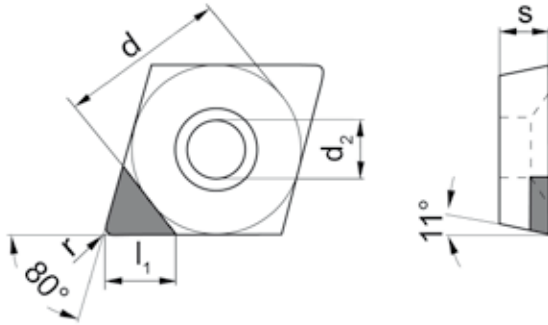
硬质合金牌号  
Carbide grades

## CVD-D 刀片 型号 CVD-D INSERT Type

# CPGT



带HORN 3D断屑槽  
with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
CPGT060201N.HS	6.350	2.8	2.38	3.0	0.1	△
CPGT060202N.HN	6.350	2.8	2.38	3.0	0.2	▲
CPGT060202N.HS	6.350	2.8	2.38	3.0	0.2	▲
CPGT060204N.HN	6.350	2.8	2.38	3.0	0.4	▲
CPGT060204N.HS	6.350	2.8	2.38	3.0	0.4	▲
CPGT060208N.HN	6.350	2.8	2.38	3.0	0.8	▲
CPGT09T301N.HS	9.525	4.4	3.97	4.5	0.1	△
CPGT09T302N.HN	9.525	4.4	3.97	4.5	0.2	▲
CPGT09T302N.HS	9.525	4.4	3.97	4.5	0.2	▲
CPGT09T304N.HN	9.525	4.4	3.97	4.5	0.4	▲
CPGT09T304N.HS	9.525	4.4	3.97	4.5	0.4	▲
CPGT09T308N.HN	9.525	4.4	3.97	4.5	0.8	▲
CPGT09T312N.HN	9.525	4.4	3.97	4.5	1.2	△

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量 !

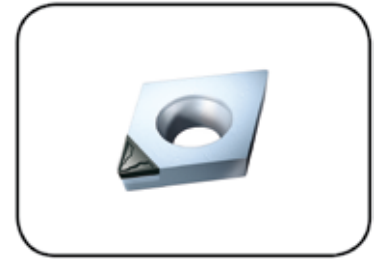
Cutting edges must be measured optically!

硬质合金牌号  
Carbide grades

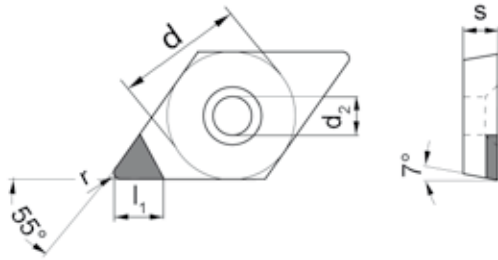
P	■
M	■
K	■
N	●
S	■
H	■

CVD-D 刀片 型号  
CVD-D INSERT Type

## DCGT



带HORN 3D断屑槽  
with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
DCGT070201N.HS	6.350	2.8	2.38		0.1	▲
DCGT070202N.HN	6.350	2.8	2.38		0.2	▲
DCGT070202N.HS	6.350	2.8	2.38		0.2	▲
DCGT070204N.HN	6.350	2.8	2.38		0.4	▲
DCGT070204N.HS	6.350	2.8	2.38		0.4	▲
DCGT070208N.HN	6.350	2.8	2.38		0.8	▲
DCGT070208N.HS	6.350	2.8	2.38		0.8	▲
DCGT11T302N.HN	9.525	4.4	3.97	3	0.2	▲
DCGT11T302N.HS	9.525	4.4	3.97		0.2	▲
DCGT11T304N.HN	9.525	4.4	3.97		0.4	▲
DCGT11T304N.HS	9.525	4.4	3.97		0.4	▲
DCGT11T308N.HN	9.525	4.4	3.97		0.8	▲
DCGT11T308N.HS	9.525	4.4	3.97		0.8	▲
DCGT11T312N.HN	9.525	4.4	3.97		1.2	▲
DCGT11T312N.HS	9.525	4.4	3.97		1.2	▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

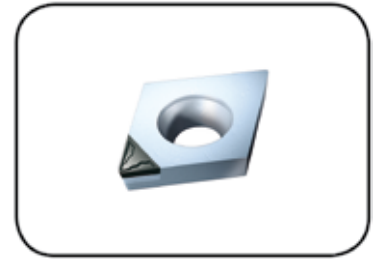
切削刃需测量!  
Cutting edges must be measured optically!

P
M
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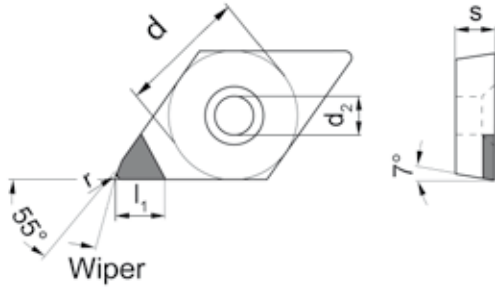
硬质合金牌号  
Carbide grades

## CVD-D 刀片 型号 CVD-D INSERT Type

## DCGT



带HORN 3D断屑槽的修光几何槽形  
Wiper geometry with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type



R=右手型-如图  
R = right hand version shown

L=左手型  
L = left hand version

请注意接近角！  
见T19页  
Please note the approach angle!  
See page T19

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
DCGT070202L.W.HN	6.350	2.8	2.38		0.2	▲
DCGT070202L.W.HS	6.350	2.8	2.38		0.2	▲
DCGT070202R.W.HN	6.350	2.8	2.38		0.2	▲
DCGT070202R.W.HS	6.350	2.8	2.38		0.2	▲
DCGT070204L.W.HN	6.350	2.8	2.38		0.4	▲
DCGT070204L.W.HS	6.350	2.8	2.38		0.4	▲
DCGT070204R.W.HN	6.350	2.8	2.38		0.4	▲
DCGT070204R.W.HS	6.350	2.8	2.38		0.4	▲
DCGT11T302L.W.HN	9.525	4.4	3.97	2.9	0.2	▲
DCGT11T302L.W.HS	9.525	4.4	3.97		0.2	▲
DCGT11T302R.W.HN	9.525	4.4	3.97		0.2	▲
DCGT11T302R.W.HS	9.525	4.4	3.97		0.2	▲
DCGT11T304L.W.HN	9.525	4.4	3.97		0.4	▲
DCGT11T304L.W.HS	9.525	4.4	3.97		0.4	▲
DCGT11T304R.W.HN	9.525	4.4	3.97		0.4	▲
DCGT11T304R.W.HS	9.525	4.4	3.97		0.4	▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

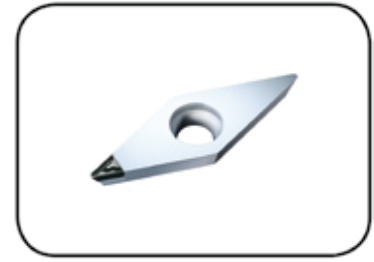
切削刃需测量！  
Cutting edges must be measured optically!

P	■
M	■
K	■
N	●
S	■
H	■

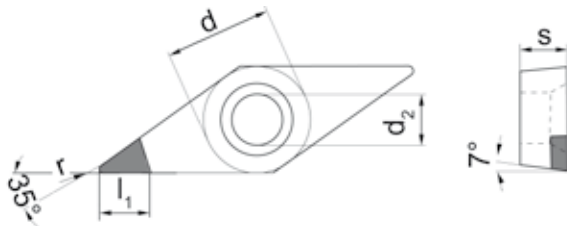
硬质合金牌号  
Carbide grades

## CVD-D 刀片 型号 CVD-D INSERT Type

## VCGT



带HORN 3D断屑槽  
with HORN 3D chip breaker



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
VCGT070201N.HS	3.970	2.25	2.38		0.1	▲
VCGT070202N.HN	3.970	2.25	2.38		0.2	▲
VCGT070202N.HS	3.970	2.25	2.38		0.2	▲
VCGT070204N.HN	3.970	2.25	2.38		0.4	▲
VCGT070204N.HS	3.970	2.25	2.38		0.4	▲
VCGT070208N.HN	3.970	2.25	2.38		0.8	▲
VCGT070208N.HS	3.970	2.25	2.38		0.8	▲
VCGT110301N.HS	6.350	2.80	3.18		0.1	▲
VCGT110302N.HN	6.350	2.80	3.18		0.2	▲
VCGT110302N.HS	6.350	2.80	3.18		0.2	▲
VCGT110304N.HN	6.350	2.80	3.18		0.4	▲
VCGT110304N.HS	6.350	2.80	3.18	3	0.4	▲
VCGT110308N.HN	6.350	2.80	3.18		0.8	▲
VCGT110308N.HS	6.350	2.80	3.18		0.8	▲
VCGT160401N.HS	9.525	4.40	4.76		0.1	▲
VCGT160402N.HN	9.525	4.40	4.76		0.2	▲
VCGT160402N.HS	9.525	4.40	4.76		0.2	▲
VCGT160404N.HN	9.525	4.40	4.76		0.4	▲
VCGT160404N.HS	9.525	4.40	4.76		0.4	▲
VCGT160408N.HN	9.525	4.40	4.76		0.8	▲
VCGT160408N.HS	9.525	4.40	4.76		0.8	▲
VCGT160412N.HN	9.525	4.40	4.76		1.2	▲
VCGT160412N.HS	9.525	4.40	4.76		1.2	▲

- ▲ 库存 / on stock    Δ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

P
M
K
N
S
H

尺寸单位 : mm  
Dimensions in mm

切削刃必须测量  
Cutting edges must be measured optically!

硬质合金牌号  
Carbide grades

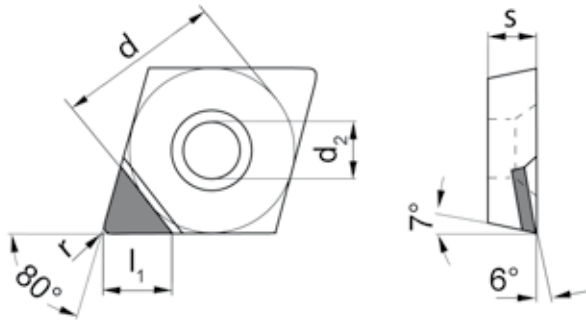


## CVD-D 刀片 型号 CVD-D INSERT Type

## CCGT



“正-中性”型  
Version "positive-neutral"



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
CCGT060201N.H6	6.350	2.8	2.38	3.0	0.1	▲
CCGT060202N.H6	6.350	2.8	2.38	3.0	0.2	▲
CCGT060204N.H6	6.350	2.8	2.38	3.0	0.4	▲
CCGT060208N.H6	6.350	2.8	2.38	3.0	0.8	▲
CCGT09T301N.H6	9.525	4.4	3.97	4.5	0.1	▲
CCGT09T302N.H6	9.525	4.4	3.97	4.5	0.2	▲
CCGT09T304N.H6	9.525	4.4	3.97	4.5	0.4	▲
CCGT09T308N.H6	9.525	4.4	3.97	4.5	0.8	▲
CCGT09T312N.H6	9.525	4.4	3.97	4.5	1.2	▲
CCGT120402N.H6	12.700	5.5	4.76	4.5	0.2	▲
CCGT120404N.H6	12.700	5.5	4.76	4.5	0.4	▲
CCGT120408N.H6	12.700	5.5	4.76	4.5	0.8	▲
CCGT120412N.H6	12.700	5.5	4.76	4.5	1.2	▲

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

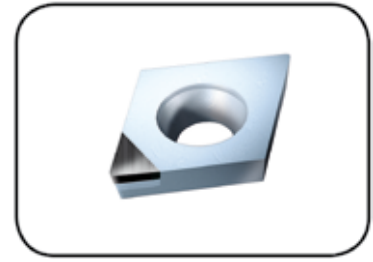
切削刃需测量 !  
Cutting edges must be measured optically!

P
M
K
N •
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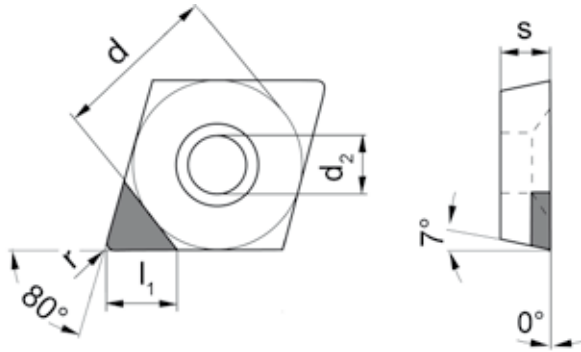
硬质合金牌号  
Carbide grades

## CVD-D 刀片 型号 CVD-D INSERT Type

# CCGW



“中性”型  
Version "neutral"



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
CCGW060201N.H0	6.350	2.8	2.38	3.0	0.1	▲
CCGW060202N.H0	6.350	2.8	2.38	3.0	0.2	▲▲
CCGW060204N.H0	6.350	2.8	2.38	3.0	0.4	▲▲▲
CCGW060208N.H0	6.350	2.8	2.38	3.0	0.8	▲▲▲▲
CCGW09T301N.H0	9.525	4.4	3.97	4.5	0.1	▲
CCGW09T302N.H0	9.525	4.4	3.97	4.5	0.2	▲▲
CCGW09T304N.H0	9.525	4.4	3.97	4.5	0.4	▲▲▲
CCGW09T308N.H0	9.525	4.4	3.97	4.5	0.8	▲▲▲▲
CCGW09T312N.H0	9.525	4.4	3.97	4.5	1.2	▲▲▲▲▲
CCGW120402N.H0	12.700	5.5	4.76	4.5	0.2	▲▲
CCGW120404N.H0	12.700	5.5	4.76	4.5	0.4	▲▲▲
CCGW120408N.H0	12.700	5.5	4.76	4.5	0.8	▲▲▲▲
CCGW120412N.H0	12.700	5.5	4.76	4.5	1.2	▲▲▲▲▲

- ▲ 库存 / on stock    △ 4周 / 4 weeks
- 主要应用 / main recommendation
- 可选推荐 / alternative recommendation
- 无涂层牌号 / uncoated grades
- 涂层牌号 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm  
Dimensions in mm

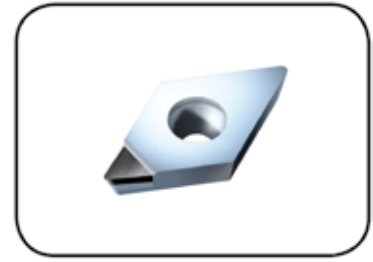
切削刃需测量 !  
Cutting edges must be measured optically!

P	▲
M	▲
K	▲
N	●
S	▲
H	▲

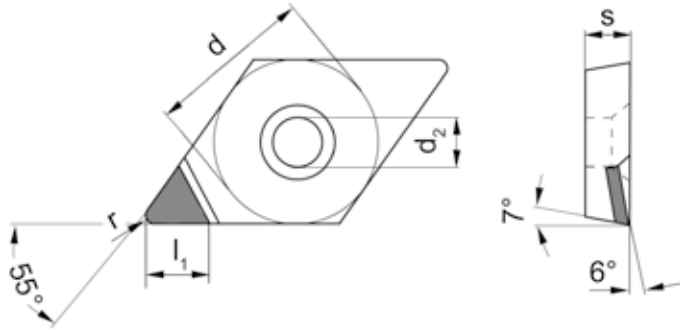
硬质合金牌号  
Carbide grades

CVD-D 刀片 型号  
CVD-D INSERT Type

DCGT



“正-中性”型  
Version "positive-neutral"



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
DCGT070201N.H6	6.350	2.8	2.38		0.1	▲
DCGT070202N.H6	6.350	2.8	2.38		0.2	▲
DCGT070204N.H6	6.350	2.8	2.38		0.4	▲
DCGT070208N.H6	6.350	2.8	2.38		0.8	▲
DCGT11T301N.H6	9.525	4.4	3.97	3	0.1	▲
DCGT11T302N.H6	9.525	4.4	3.97		0.2	▲
DCGT11T304N.H6	9.525	4.4	3.97		0.4	▲
DCGT11T308N.H6	9.525	4.4	3.97		0.8	▲
DCGT11T312N.H6	9.525	4.4	3.97		1.2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

□ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量 !

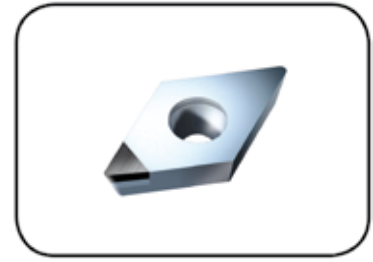
Cutting edges must be measured optically!

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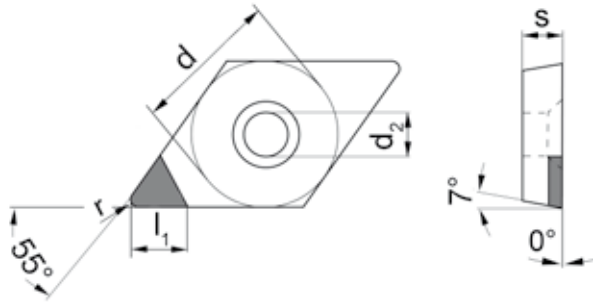
硬质合金牌号  
Carbide grades

CVD-D 刀片 型号  
CVD-D INSERT Type

DCGW



“中性”型  
Version "neutral"



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
DCGW070201N.H0	6.350	2.8	2.38	3	0.1	▲
DCGW070202N.H0	6.350	2.8	2.38		▲	
DCGW070204N.H0	6.350	2.8	2.38		▲	
DCGW070208N.H0	6.350	2.8	2.38		▲	
DCGW11T301N.H0	9.525	4.4	3.97		▲	
DCGW11T302N.H0	9.525	4.4	3.97		▲	
DCGW11T304N.H0	9.525	4.4	3.97		▲	
DCGW11T308N.H0	9.525	4.4	3.97		▲	

▲ 库存 / on stock    Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量!

Cutting edges must be measured optically!

P
M
K
N •
S
H

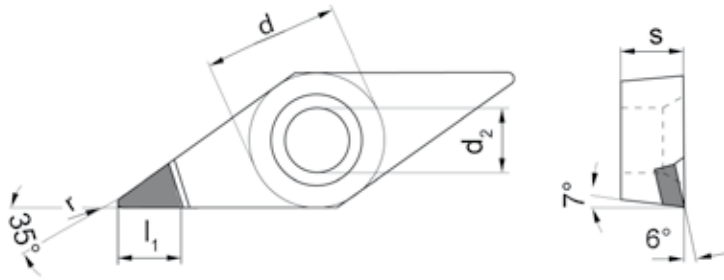
硬质合金牌号  
Carbide grades

CVD-D 刀片 型号  
CVD-D INSERT Type

VCGT



“正-中性”型  
Version "positive-neutral"



配合刀杆  
for use with Toolholder

型号 ISO  
Type

T

产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
VCGT110301N.H6	6.350	2.8	3.18		0.1	▲
VCGT110302N.H6	6.350	2.8	3.18		0.2	▲
VCGT110304N.H6	6.350	2.8	3.18		0.4	▲
VCGT110308N.H6	6.350	2.8	3.18		0.8	▲
VCGT160401N.H6	9.525	4.4	4.76	3	0.1	▲
VCGT160402N.H6	9.525	4.4	4.76		0.2	▲
VCGT160404N.H6	9.525	4.4	4.76		0.4	▲
VCGT160408N.H6	9.525	4.4	4.76		0.8	▲
VCGT160412N.H6	9.525	4.4	4.76		1.2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

■ 无涂层牌号 / uncoated grades

■ 涂层牌号 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量 !

Cutting edges must be measured optically!

P
M
K
N •
S
H

硬质合金牌号  
Carbide grades

CVD-D 刀片 型号  
CVD-D INSERT Type

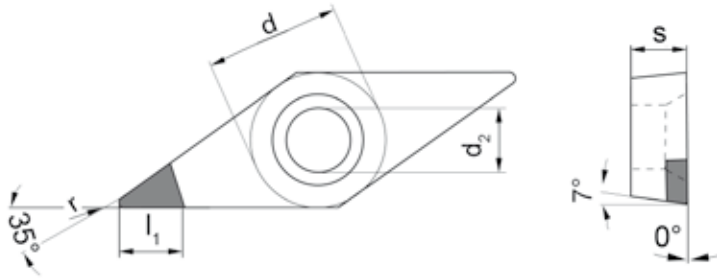
VCGW



“中性”型  
Version "neutral"

配合刀杆  
for use with Toolholder

型号 ISO  
Type



产品型号 Part number	d	d <sub>2</sub>	s	l <sub>1</sub>	r	HD08
VCGW110301N.H0	6.350	2.8	3.18	3	0.1	△
VCGW110302N.H0	6.350	2.8	3.18		0.2	▲
VCGW110304N.H0	6.350	2.8	3.18		0.4	▲
VCGW110308N.H0	6.350	2.8	3.18		0.8	▲
VCGW160401N.H0	9.525	4.4	4.76		0.1	△
VCGW160402N.H0	9.525	4.4	4.76		0.2	▲
VCGW160404N.H0	9.525	4.4	4.76		0.4	▲
VCGW160408N.H0	9.525	4.4	4.76		0.8	▲

▲ 库存 / on stock △ 4周 / 4 weeks

● 主要应用 / main recommendation

○ 可选推荐 / alternative recommendation

无涂层牌号 / uncoated grades

涂层牌号 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

切削刃需测量!

Cutting edges must be measured optically!

P	▲
M	▲
K	▲
N	●
S	▲
H	▲

硬质合金牌号  
Carbide grades

为了满足车削和铣削加工中要求的更佳表面质量，我们开发了很多种带有修光几何槽型的刀片。该类槽型在刀尖圆角和横向切削刃之间有一个后缘，其类似于切削角 $0^\circ$ 的切削刃。即使在2-4倍大的进给率下也能得到同样的表面质量。通过降低循环周期，更高进给率下最佳的切削控制和刀具寿命的增加，您能逐步提高产能同时降低成本。

### 使用修光槽型时请注意：

接近角 需要准确应用，以便得到最好的修光效果，使表面质量最佳。

CCGW / T $95^\circ$	DCGW / T $93^\circ$
------------------------	------------------------

注意切削方向。修光槽型被设计作用于切削刃之后，以得到良好的切屑流和表面质量。端面加工方向应从大径到小径。

由于后缘，失真可能出现在圆角，倒角和锥形面上。

### 修光槽型的优点:

- 同样的切削参数下更佳表面质量
- 更高的进给率-可使用同一刀片进行粗加工和精加工
- 通过更高进给实现更佳的切屑控制
- 更高的进给率降低了每个工件的切削时间，并提高了耐磨性和刀具寿命。

For the purpose of high performance cutting in the fields turning and milling, we developed a large number of inserts with WIPER geometry. Those geometries are designed with a trailing edge between edge radius and lateral cutting edge, which works like a cutting edge with  $0^\circ$  approach angle. Even with 2 - 4 times higher feed rates you can achieve the same surface qualities. Through reduction of cycle time, the optimal chip control with higher feed rates and the increase of tool life, you can escalate your productivity while reducing costs at the same time.

### Please keep in mind when using Wiper Geometries:

The **approach angle** needs to be applied accurately, in order to achieve the desired wiper effect to get best surface qualities:

CCGW / T $95^\circ$	DCGW / T $93^\circ$
------------------------	------------------------

**Be aware of the cutting direction.** Wiper geometries are designed to trail behind the cutting edge for proper chip flow and surface quality.

Facing operations should always be performed from the larger to smaller diameter.

Because of the trailing edge, **distortion** can occur on radii, chamfers and tapers.

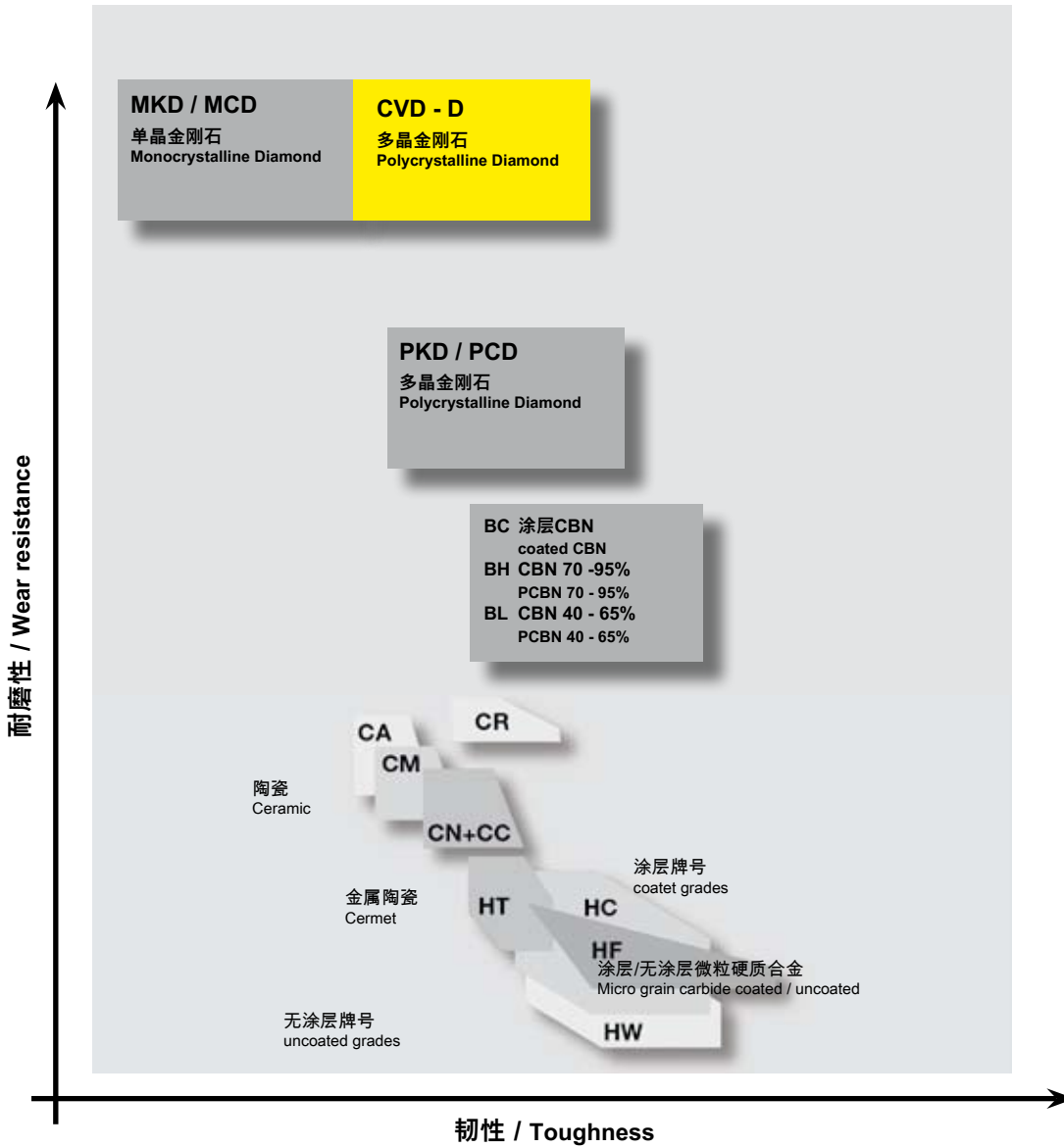
### Advantages of Wiper Geometries:

- Better surface qualities at the same cutting parameters
- Higher feed rates - Roughing and finishing with one insert is possible
- Better chip control through higher feed rates
- Higher feed rates reduces the cutting time per workpiece and therefore the wear characteristic and this leads to significantly longer tool life



根据DIN ISO 513 (2001)的切削材质说明

Description of cutting materials according DIN ISO 513 (2001)





HORN- 牌号	切削材料	性能	推荐应用
<b>MD10</b>	MKD	<b>固体单晶金刚石</b> 无粒状组织，极高硬度，无微型裂口的极其锋利的切削刃，低韧性。	超精加工所有非铁金属，无增强型填充物或硅胶的塑料，贵金属合金
<b>HD08</b>	CVD-D	<b>CVD金刚石</b> (多晶金刚石基材) 无整体硬质合金材质并无金属粘结剂。99.9%金刚石，非常高的硬度和耐磨性，无微型裂口使切削刃更锋利，韧性也得到提高。	自粗加工到超精加工，加工所有非铁金属，高含硅量的铝合金，纤维增强型塑料，贵金属合金，硬质合金，陶瓷坯件
<b>PD75</b> <b>PD02</b>	PKD	<b>多晶金刚石</b> 硬质合金增强型，粒度细，锋利的切削刃，提高了耐磨性和韧性	适用于所有非铁金属，低含硅量铝合金，含少量耐腐蚀增强物的塑料

HORN- Grades	Cutting material	Properties	Recommended applications
<b>MD10</b>	MCD	<b>Solid Monocrystalline Diamond</b> without grain structure, highest hardness, absolutely sharp cutting edge without micro fractures, low toughness	Ultra Fine Finishing of all nonferrous metals and plastics without reinforced fillers or silicon, precious alloys
<b>HD08</b>	CVD-D	<b>CVD Diamond</b> (Polycrystalline Diamond substrate) without solid carbide material and without metallic binder. 99.9% Diamond, Highest hardness and wear resistance, sharp cutting edge without micro fractures, improved toughness	From roughing to super finish of all nonferrous metals, Aluminium alloys with high silicon content, Plastics with abrasive reinforcements, precious alloys, Solid Carbide, Ceramic green parts
<b>PD75</b> <b>PD02</b>	PCD	<b>Polycrystalline Diamond</b> solid carbide reinforced, fine grit size, very good cutting edge sharpness, improved wear resistance and toughness	All purpose for all nonferrous metals, Aluminium alloys with low silicon content, plastics with low content of abrasive reinforcements

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加工铝镁合金，所有非铁材料，增强型塑料和无耐磨性填料型材料的首选。

出色的刀具寿命和HORN金刚石断屑槽型实现的切屑控制紧密相关。

这种创新为PCD，特别是CVD-D打开了新的应用领域，革新了铝合金加工的精度、速度及生产能力。

在大多数外圆和内圆的车削、切槽和切断加工中，断屑槽在整个加工过程中至关重要。当铣削铝合金时，HORN的断屑槽能够显著的降低加工成本。

如果允许毛刺存在的话，HORN金刚石断屑槽将使刀具寿命增加2.5-4倍。显著降低换刀时间和加工成本。

通常：  
    产能增加35%  
    加工成本降低80%  
    动力消耗降低30%

您的生产加工最终将受益于HORN的CVD-D刀具及其断屑槽型。

**The first choice** in machining of Aluminium and Magnesium alloys, all nonferrous materials, reinforced plastics and materials with abrasive fillers.

The outstanding tool life of a Diamond is combined with highly effective chip control through the HORN Diamond geometry.

This innovative development opens new application fields for PCD and in particular for CVD-D and revolutionizes the machining of Aluminium alloys regarding precision, speed and productivity.

In most external and internal turning, grooving and parting off operations the chip control and chip breaker plays a crucial role in the productivity of a whole manufacturing line. When milling Aluminium alloys one can achieve high cost saving potentials through another positive effect of HORN chip breaking geometry:

If the burr build up is criteria, you can multiply the tool life by factor 2.5 - 4 with the HORN diamond geometry , due to the soft and peeling cut. The reduced number in tool changes and the reduced efforts in the tooling room minimises machining costs dramatically.

**In General:**  
    Increase of productivity up to 35%  
    Minimise machining costs up to 80%  
    30% less energy consumption

**You will benefit with the HORN diamond geometry on our CVD diamond inserts for ultimate machining results!**

产品优点 Product advantages		客户利益 Customer benefit
3D断屑槽 仅仅在金刚石区域有切屑成型  3D form of chip breaker Chip forming only in Diamond area	➔	控制断屑，短屑，无积屑瘤 连续加工，确保无障碍生产  controlled chip break, short chips, no built up edges continual process, process sure manufacturing
正前角，高硬切削材质PCD和CVD-D  Positive chip angle on high-hard cutting materials PCD and CVD - D	➔	软切，非常小的毛刺， 粗加工与精加工一次完成  soft cut, very low burr build up, roughing and finishing in one operation
斜切削刃产生非常低的切削力  Very low cutting pressure trough lean cutting edge	➔	最小的热胀性，极好的表面质量精巧且脆性高的工件上， 减少机床维修，高尺寸精度，出色的镗削公差，干加工， 极小的润滑  Minimal heat expansion, Best surface quality on delicate and fragile components, reduced machine maintenance, high dimensional accuracy, precise boring tolerances, dry machining, minimal lubrication

## HORN金刚石刀具槽型优点

与整体硬质合金材料相比：

- 降低成本**
  - 减少换刀
  - 降低功耗
- 提高生产率**
  - 更长的刀具寿命
  - 显著增加的切削速度和进给率
- 提高工件质量**
  - 更好的表面质量
  - 稳定的公差
  - 无毛刺
  - 无积屑瘤
  - 减少加工时间

与标准PCD相比

- 降低成本**
  - 增加刀具寿命
  - 更少的换刀
  - 降低功耗
- 提高生产率**
  - 控制断屑实现连续生产
  - 无需二次加工
- 提高工件质量**
  - 加工脆性工件可保证稳定公差
  - 无毛刺，增加刀具寿命

## Advantages with HORN Diamond Geometry

Versus Solid carbide:

- Reduces Operating costs**
  - Less tool changes
  - Reduced power consumption
- Increases productivity**
  - Longer tool life
  - Significant increase of cutting speed and/or feed rate
- Improves work piece quality**
  - Better surface finish
  - Maintain tolerances
  - No burr build up
  - No edge build up
  - Reduction of machining time

Versus Standard PCD:

- Reduces Operating costs**
  - Increased tool life through softer cut
  - Less tool changes
  - Reduced power consumption
- Increases productivity**
  - Controlled chip breaking leads to continuous production
  - No expensive secondary operation
- Improved work piece quality**
  - Maintain tolerances on fragile components
  - No burr build up increases tool life

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# HORN 3D断屑槽

## HORN 3D chip breaker



规格	HORN 3D断屑槽	前角	性能	推荐应用
HS	S... 锋利	25 - 30°	正倒棱0.06mm	中小型精加工，非常锋利的切削刃，正切削角，对于脆性零件的最小切削力，较低的表面质量
HN	N... 负	15 - 25°	负倒棱0.08mm	通用中小型加工，强壮的切削刃，大切深和大进给，负倒棱实现最佳表面质量
G.HS	整个硬质合金刀片附有PCD刀尖	25 - 30°	正倒棱0.06mm	中小型精加工，非常锋利的切削刃，正切削角，对于脆性零件的最小切削力，较低的表面质量
G.HN		15 - 25°	负倒棱0.08mm	通用中小型加工，强壮的切削刃，大切深和大进给，负倒棱实现最佳表面质量

Specification	HORN 3D chip breaker	Chip angle	Properties	Recommended applications
HS	S... Sharp	25 - 30°	Positiv chamfer 0,06 mm	Fine to medium machining, absolute sharp cutting edge, positive cut, lowest cutting force on most fragile components, lower surface quality
HN	N... Negativ	15 - 25°	Negativ chamfer 0,08 mm	Medium machining for all purpose, strongest cutting edge, for high depth of cut and feed rates, best surface quality through negative chamfer
G.HS	PCD along the whole cutting edge of the solid carbide insert	25 - 30°	Positiv chamfer 0,06 mm	Fine to medium machining, absolute sharp cutting edge, positive cut, lowest cutting force on most fragile components, lower surface quality
G.HN		15 - 25°	Negativ chamfer 0,08 mm	Medium machining for all purpose, strongest cutting edge, for high depth of cut and feed rates, best surface quality through negative chamfer

当使用带有HORN 3D断屑槽的刀片时，请注意下述：

- 找到合适的切削深度和进给率，以获得良好的切屑控制。
- 当车削内孔时，仅可使用中性刀杆，特别使用断屑槽HS时，由于断屑槽的设计，在某些加工方案中可能会引起切削刃的加工应力过载。
- 对于越程槽和退刀槽，两个切削刃同时切削，不可以选择HS,主要是对于最小切削深度的断屑槽槽型的设计，切屑如果积聚的话，会引起加工过应力造成崩刃。

When using inserts with HORN 3D chip breaker please observe the following:

- Find the right combination of depth of cut and feed rate in order to obtain perfect chip control.
- When turning internal, you should use only neutral tool holder (radial angle of the insert 0°). In particular with the chip breaker HS in some cases it can come to a mechanical overstress of the cutting edge because of the design of the chip breaker.
- For relief grooves and undercuts, where both of the cutting edges are in cut at the same time, you should not use HS. The reason is in the geometrical design of the chip breaker for lowest depth of cuts. Chips may build up, this can lead to mechanical overstress and breakage of the cutting edge.

# 切削参数

## Cutting data



材料 Material	HORN 3D断屑槽 HORN 3D chip breaker	切削速度 $v_c$ Cutting speed $v_c$	
		$v_c$ min [m/min]	$v_c$ max [m/min]
铝-锻造合金 Al-wrought alloys	.HS	400	5000
含硅量12%的铝合金 Aluminium alloys up to 12% Si content	.HS / .HN	400	3500
含硅量12-20%的铝合金 Aluminium alloys with 12-20% Si content	.HN	400	1800
非铁金属 Non ferrous metals	.HN	300	2200
塑料, 增强型塑料 Synthetics, Reinforced plastics	.HN	300	1800
碳纤维和玻璃纤维增强型塑料 Carbon fibre and Glass reinforced plastics	.HN	400	900

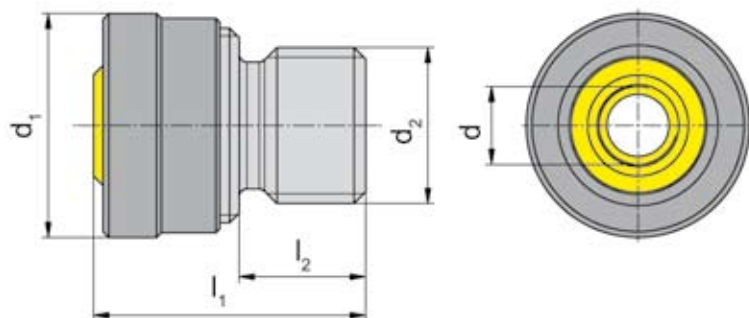
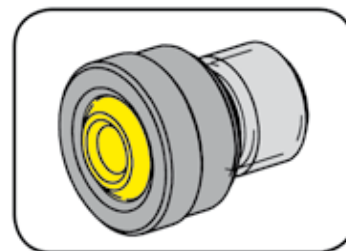
圆角半径 Corner radius [mm]	HORN 3D断屑槽 HORN 3D chip breaker .HS				HORN 3D断屑槽 HORN 3D chip breaker .HN			
	切深 Depth of cut		进给率 Feed rate		切深 Depth of cut		进给率 Feed rate	
	$a_p$ [mm]		$f$ [mm/转] [mm/rev]		$a_p$ [mm]		$f$ [mm/转] [mm/rev]	
	min	max	min	max	min	max	min	max
0.1	0.07	0.4	0.01	0.05				
0.2	0.08	0.9	0.02	0.1	0.2	2.2	0.05	0.15
0.4	0.12	1.4	0.04	0.2	0.4	2.7	0.1	0.3
0.8	0.18	1.9	0.08	0.4	0.7	3.2	0.2	0.6
1.2	0.25	2.4	0.12	0.6	0.9	3.7	0.25	0.9

涉及到刀杆的接近角时需考虑 $a_p$ 。  
Please consider the  $a_p$  in relation to the approach angle of the toolholder.

冷却液喷嘴 型号

COOLANT SPRAY NOZZLE type

020



T

产品编号 Part number	l <sub>1</sub>	l <sub>2</sub>	d	d <sub>1</sub>	d <sub>2</sub>
020.0806.3116	11,5	6,0	3	9,5	M6
020.1008.2977	14,0	6,5	4	11,5	M8x1
020.1008.2976	14,0	6,5	M4	11,5	M8x1
020.1210.2967	15,7	6,5	5	13,5	M10x1
020.1210.2966	15,7	6,5	M6	13,5	M10x1

尺寸单位 : mm  
Dimensions in mm

冷却系统标准接头  
Standard connection for through cooling



冷却系统接头  
Connection for through cooling  
004.00.19



用于管子 Ø 6 mm  
for pipe Ø 6 mm



冷却系统快速接头  
Clip connection for through cooling

M10 x 1



快速夹头  
Clip connection  
004.00.49



栓塞  
Plug

M8 x 1 - 004.00.56  
G1/8" - 004.00.57



栓塞  
Plug

Ø 6 mm - 004.00.59

用于管子 Ø 6 mm  
for pipe Ø 6 mm



接头  
Coupling

M8 x 1 - 004.00.61  
G1/8" - 004.00.16



使用GRAF上的可动高压系统，能够非常好的冷却刀具。

明显的优点：寿命长！



With the mobile high-pressure systems from **GRAF** you can employ the through cooled tools optimally.

The advantages are obvious: longer tool life!





附加设备  
Additional equipment

加工实例  
Examples for machining



**D 041 VL**  
型号 0,4-1 Nm  
Model

带刻度的扭矩扳手  
-扭矩可调  
-屏幕显示调整扭矩

扭矩无极调节，符合人体工程学的多组件手柄，轻而紧凑的设计，当达到设定扭矩时单击信号按钮。  
(标准: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)  
(精度:  $\pm 6\%$ )



**D 15 VL**  
型号 1-5 Nm  
Model

**Torque screw driver with scale**  
- variable torque setting  
- adjusted torque is shown on display

The Torque can be adjusted with a special torque setter (included). Ergonomical form gives perfect handling abilities. Audible signal when set torque is reached.  
(Standard: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)  
(Precision:  $\pm 6\%$ )



**D 28 VL**  
型号 2-8 Nm  
Model



**D515QL**  
型号 5-15 Nm  
Model



**ED 28 VL**

设定扭矩的设备

柄部： 醋酸纤维材质，表面为细微结构  
刃部： 八角形，硬化处理，镀锌



**ED 515 QL**

Device for setting the required torque.

Handle: Celluloseacetat with micro structured surface  
Blade: Octogonal (8 flats) blade, hardened galvanized



**DT6PK  
DT7PK  
DT8PK  
DT9PK  
DT10PK  
DT15PK  
DT20PK  
DT25PK**

刀头-Torx螺钉

刀头： 高品质铬钒钢，硬化处理，镀铬  
Wiha镀铬刀头保证了最好的精密密度。  
颜色代码为绿色

用途： 拧紧螺钉到指定扭矩，和Wiha扭矩扳手刀柄组合。

**Blade for TORX-Plus® screws**

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Wiha Chrome Blade guarantees maximum precision.  
Colored code dark green

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle.



**DT15PQ  
DT20PQ  
DT25PQ  
DT27PQ  
DT30PQ**



**DT6K**  
**DT8K**  
**DT15K**

**刀头-Torx螺钉**

刀头： 高品质铬钒钢，硬化处理，镀铬  
Wiha镀铬刀头保证了最好的精密度。  
颜色代码为绿色

用途： 拧紧螺钉到指定扭矩，和Wiha扭矩扳手刀柄组合。

**Blade for Torx screws**

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Wiha Chrome Blade guarantees maximum precision.  
Colored code dark green

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle.

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**DSW15K**  
**DSW20K**  
**DSW25K**  
**DSW30K**  
**DSW40K**  
**DSW50K**  
**DSW60K**

**扳手刀头-内六角螺钉**

刀头： 高品质的铬钒钢，硬化处理，镀铬。  
Wiha镀铬刀片保证了最好的精密度。  
使用红色代码

应用： 使用给定的扭紧扭矩，结合一个Wiha扭矩扳手。

**Blade for allen screws**

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Wiha Chrome Blade guarantees maximum precision.  
Colored code red

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle



## D14ZBK

**通用钻套**  
适用于S-DM08、S-DM10及S-DM12，也用于所有的C6.3和E6.3(1/4")钻头

刀头： 高品质铬钒钢，经过硬化处理，镀铬。  
刀颈： 不锈钢  
应用： 用于固定扭矩，扭矩标与柄部。



## D14ZBQ

**Universal Bitholder**  
For S-DM08, S-DM10 and S-DM12 also  
for all C6.3 and E6.3 (1/4") Bits

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.  
Collar: Stainless steel  
Utilization: For controlled screw setting with definite torque in combination with torque screw driver handle.



## 14ZQK

**通用T型刀柄的钻套**  
适用于S-DM08、S-DM10及S-DM12，也用于所有的C6.3和E6.3(1/4")钻头

刀头： 高品质铬钒钢，经硬化处理，镀铬  
刀颈： 不锈钢  
应用： 开关控制

**Universal Bitholder with T-handle**  
For S-DM08, S-DM10 and S-DM12  
also for all C6.3 and E6.3 (1/4") Bits

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.  
Collar: Stainless steel  
Utilization: For controlled opening

## 多槽“汽油机活塞”

使用312系列的PCD刀片加工此类槽，刀杆为340多槽专用刀杆。槽间宽度公差为0.005mm。

工序：

- 粗开槽
- 第二组刀片精加工

材料: **GD-AISI12**

切削参数

预割槽:

$$v_c = 350 \text{ m/min}$$

$$v_f = 0.07 \text{ mm}$$

精加工:

$$v_c = 350 \text{ m/min}$$

$$v_f = 0.03 \text{ mm}$$



### **Multigrooving "Petrol Piston"**

The grooves are machined with PCD-tipped inserts type 312 which are clamped in a multi-grooving toolholder of type 340. Closest tolerance of width is 0.005 mm.

Process:

- Pregrooving
- Finishing with a second set of inserts

**Material: GD-AISI12**

Cutting data

Pregrooving:

$$v_c = 350 \text{ m/min}$$

$$v_f = 0.07 \text{ mm}$$

Finishing:

$$v_c = 350 \text{ m/min}$$

$$v_f = 0.03 \text{ mm}$$

### 齿轮端面切槽

使用Horn 360系列Capto刀柄和非标312系列可转位刀片。  
齿上的毛刺决定了刀具的寿命，并对刀具本身提出了很高的技术要求。

切削参数:

$$v_c = 200 \text{ m/min}$$

$$v_f = 0.06 \text{ mm}$$



#### Face grooving on Gear wheel

with HORN Polygon shank type 360 and special indexable insert type 312.

The size of the burrs along the teeth defines the tool life and creates a high technical demand on the tool itself.

Cutting data:

$$v_c = 200 \text{ m/min}$$

$$v_f = 0.06 \text{ mm}$$

### 硬车齿轮

非标S117系列CBN刀片被用来精车槽宽。切削余量约为0.15-0.2mm (.006" - .008")。

刀片宽度按照槽宽进行精磨。

两个侧面同时加工( $R_z=2.3\mu\text{m}$ )。为了得到很高的表面光洁度，刀片的两个侧刃都有修光刃。

加工状况必须稳定。干切。

**材料: 20MnCr5 - 表面渗碳硬化 58-62 HRC**

切削参数:

$v_c = 140 \text{ m/min}$

$v_f = 0.08 \text{ mm}$



#### Hardturning on Gear wheel

Special **CBN-tipped** insert type S117 is used to finish the width of the groove. The stock removal is approximately 0.15 - 0.2 mm (.006" - .008"). The insert is ground to width of groove.

Both flanks are machined at the same time ( $R_z=2.3\mu\text{m}$ ). To obtain high surface finish, the insert has a wiper flat on both side cutting edges.

Stable machining conditions are imperative. **No coolant.**

**Material: 20MnCr5 - case hardened 58-62 HRC**

Cutting data:

$v_c = 140 \text{ m/min}$

$v_f = 0.08 \text{ mm}$



型号 Type	页 Page
001C	M12
001TS	M20
020	T26
050	G30
105	N7-N11,S6-S7,S11-S12
114	N24-N27
208	F4-F5
210	G2-G6
211	F2-F3
213	G20-G24
214	G25-G26
217	A10-A14
218	G7,G9-G13,P59-P60
219	G17-G18
220	N38-N39,P94
220C	M4-M5
220TS	M14-M15
221	F11,N34
225	G19
226	G14-G16,P61-P62
228	F12,N35
229	G49,G51,G53-G58,G60,G63,P65
230	A5
231	F7-F10,F13-F14,N36
232	A15-A16
233	A6
234	A7
235	A8
240	A2-A3
245	A9
248	A4,L33
250	A5
253	A6
254	A7
255	A8
257	G29
259	G65
264	B6-B11,B13,P20-P21
309	H17
312	H25-H41,N32,P26-P30
315	J10-J12,J15-J21
330	H20
333	J7
340	H18-H19
356	J2-J4
357	J5-J6,J8-J9
360	H2-H5,N30,P22
360C	M8-M9
360TS	M16-M17
361	H6,L42
368	H7-H9,L43,P23-P24
369	H10-H11,L44,N31
390	H15
391	H16,P25
64	H12-H13
65	H12-H13
849	M94,M96-M99,M101-M105
849C	M95
974	C5
99	H13
A105	N13
A110	N17-N18
A315	J13-J14
B105	L8-L9,L11,N2-N3,N12,R6,S4
B105KM	M82-M83
B108	L28
B108KM	M84-M85
B110	N16
B111	L27

型号 Type	页 Page
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B119	D5
B223	D6-D10
B224	E20-E24,E26-E27,N40
B224C	M10
B224TS	M18
B229	G27
B229C	M11
B229TS	M19
BGT	L12,L14,L16
BK223	D11
BK224	E25,M43
BK229	G28,M44
BKT	L13,L15
BU105	N3
C5	M6
C8	M6-M7
CCGT	T6-T8,T13
CCGW	T14
CPGT	T9
DCGT	T10-T11,T15
DCGW	T16
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G	L17-L18
H100	P69-P82,P84-P93
H105	L2,N4
H117	O2-O6,O8-O9,O11-O16,O18,O20-O21,R22,S8
H223	D2-D3,P37-P38
H224	E2-E19,L37-L38,P45-P52
H259	G64
H264	B2-B5,L29-L32,P16-P19
H264KM	M86-M87
H274	C3-C4,C6,L36,P2
H274...E	C26,P9
H274KM	M89
H316	K2,K8,P34
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HC114	N23
HC274KM	M88
HC316	K3,K9
HSK-220	M22-M23
HSK224	M24
HSK229	M25
HSKT100	M30-M31
HSKT40	M71
HSKT63	M28-M29,M32-M35
KM16	M80-M81
KT274	C7,L34
KTC274	C8,L35
L368	L39
L760	L6,L40
LA210	N54
LA226	N52
LAK220	M58-M59,M66-M67,N60-N61,N68-N69
LAK224	M46-M47,N41-N42
LIK220	M54-M55,M62-M63,N56-N57,N64-N65
LIK224	M50-M51,N45-N46
LNK368	L41
LNK760	L41
N	L20-L26
N105	R11-R16
N110	R11-R15
N229	G59
N231	F13,N36
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N68	H14
N849	M100
N98	H14
NH105	S5

型号 Type	页 Page
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NK220	M41-M42
NK224	M40,M74
NK264	M73
NK274	M72
NK356	M39,M77
NK360	M38,M75
NK368	M76
NS224	E49
R76	C9
RA210	N55
RA226	N53
RAK220	M60-M61,M68-M69,N62-N63,N70-N71
RAK224	M48-M49,N43-N44
RIK220	M56-M57,M64-M65,N58-N59,N66-N67
RIK224	M52-M53,N47-N48
S100	P97-P101
S117	O10,O17,O19,R26-R29,S9
S119	D12
S123	D13-D14,P39-P40

型号 Type	页 Page
S223	D15-D20,P41-P43
S224	E29,E31,E33,E35,E37-E48,N49-N51,P53-P57
S229	G33,G35,G37-G43,G45-G47,G60-G62,N72-N75,P63-P67
S264	B12
S274	C10-C25,P3-P8
S274...E	C27-C42,P10-P15
S312	H21-H24,P31-P33
S316	K4-K6,P35
SB105	R4-R5,R7-R8
SB110	R7-R10
SH117	R18,R20-R24
SHM117	R19
VCGT	T12,T17
VCGW	S13,T18
VDI	L7,N6
Z	L19





## 刀具材质-DIN ISO 513

Cutting Material Group per DIN ISO 513

主组 Main Group	缩写 Symbol	子组 Subgroups
硬质合金 Carbide	HW	WC基材非涂层硬质合金 uncoated carbides based upon WC
	HT	TIC/TIN基材非涂层硬质合金 (金属陶瓷) uncoated carbides based upon TIC/TIN (cermets)
	HC	涂层硬质合金 coated carbides
陶瓷 Ceramic cutting material	CA	氧化物陶瓷 $Al_2O_3$ Oxide ceramics based upon $Al_2O_3$
	CM	混合陶瓷 $Al_2O_3$ + 硬质合金 Mixed ceramics $Al_2O_3$ + metal carbide
	CN	氮化物陶瓷 $Si_3N_4$ Nitride ceramics based upon $Si_3N_4$
	CC	涂层陶瓷 coated ceramics
氮化硼 Boron nitride	BN	多晶立方氮化硼 (CBN) Polycrystalline cubic boron nitride (CBN)
金刚石 Diamond	DP	多晶金刚石 (PCD) Polycrystalline diamond (PCD)

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