

Supermini® & Mini

硬质合金刀具 - Carbide Tools



2013 / 2014





尊敬的客户：

非常荣幸向您介绍我们的Supermini® 和Mini硬质合金刀具样本。

该样本展示了我们所有槽加工产品中的一部分。

HORN在四十年的时间里，专注于刀具的设计与生产，特别在槽加工领域。

作为HORN刀具的使用者，您将获得丰富的槽加工经验，我们的工程师将给予您所需要的任何支持和帮助，以确保我们的产品在他的生产中展现出最佳的性能。

如需更详细的信息或支持，请联系我们。

期待与您的合作。

谨上

Lothar Horn, CEO

Dear customer,

we are pleased to introduce our new catalogue of **Supermini® and Mini Carbide Tools**.

This catalogue represents part of the most comprehensive range of grooving products available from any single manufacturer.

For more than 40 years, HORN has dedicated its resources to the design and manufacture of tooling specifically for grooving applications.

As a HORN user, you gain access to this wealth of experience in grooving. Our team of engineers will be pleased to give you the help and assistance necessary to ensure you get the very best performance from our products.

If you require any further assistance or information, please do not hesitate to contact us.

We look forward to our continued cooperation.

Yours sincerely

Lothar Horn, CEO



- A Supermini® 型号 / type 105**
镗孔, 切槽, 倒角, 螺纹切削, 端面切槽
Boring, Grooving, Chamfering, Threading, Face Grooving
- B Supermini® 型号 / type 110**
镗孔, 切槽, 端面切槽
Boring, Grooving, Face Grooving
- C Mini 型号 / type 107**
镗孔, 切槽, 倒角, 螺纹切削
Boring, Grooving, Chamfering, Threading
- D Mini 型号 / type 108**
镗孔, 切槽, 倒角, 螺纹切削
Boring, Grooving, Chamfering, Threading
- E Mini 型号 / type 10P**
切槽
Grooving
- F Mini 型号 / type 111**
镗孔, 切槽, 倒角, 螺纹切削
Boring, Grooving, Chamfering, Threading
- G Mini 型号 / type 11P**
切槽
Grooving
- H Mini 型号 / type 114**
镗孔, 切槽, 倒角, 螺纹切削, 端面切槽
Boring, Grooving, Chamfering, Threading, Face Grooving
- J Mini 型号 / type 116**
镗孔, 切槽, 倒角, 螺纹切削
Boring, Grooving, Chamfering, Threading
- K Mini 型号 / type 18P**
切槽
Grooving
- L 加工实例**
Examples for machining
- M 技术说明, 附加设备**
Technical Instructions, Additional equipment

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B

C

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M

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
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槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
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加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Supermini® 硬质合金切槽刀具
Supermini® CARBIDE GROOVING TOOLS

型号 105
type

刀杆系统
Toolholder system



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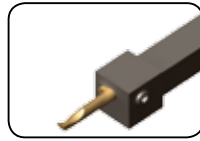
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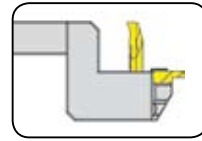
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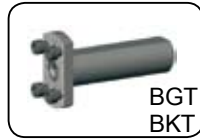
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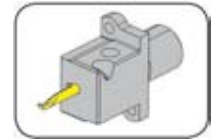
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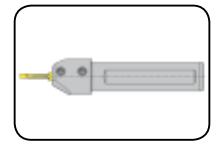
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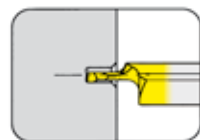


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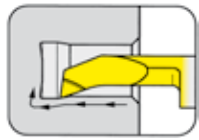


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A105
轴向 / axial

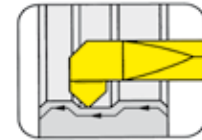
105
≥ Ø 0.2 mm
刀片
Inserts



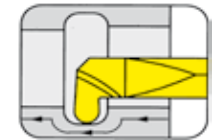
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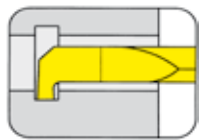
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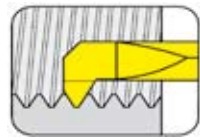
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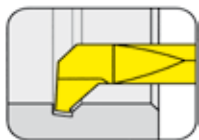
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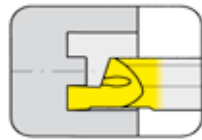
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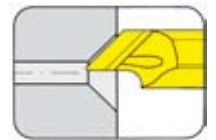
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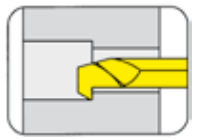
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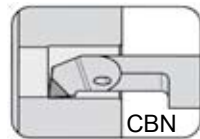
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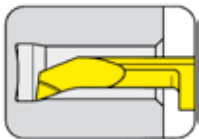
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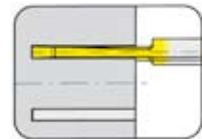
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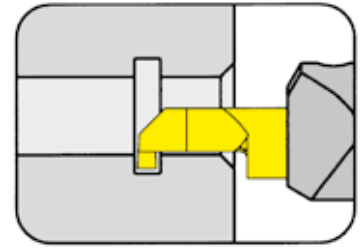
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(夹持部分增长)
(increased clamping shank)



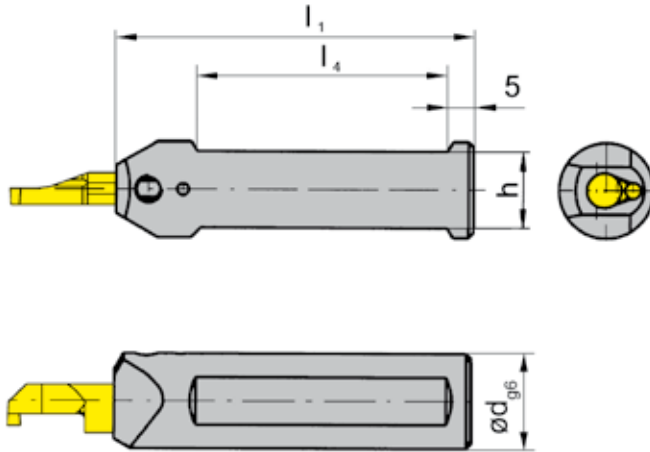
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A106
轴向
axial

刀杆 型号

TOOLHOLDER Type

B105带内冷
with through coolant supply

孔径最小至	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

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄
B105.0010.01	10	75	9	50
B105.0012.01	12	75	11	50
B105.0016.01	16	75	14	50
B105.0020.01	20	90	18	55
B105.0025.01	25	100	23	55

按需提供更多尺寸
Further sizes upon request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...	6.075T15P	T15PQ

切槽和镗孔

GROOVING and BORING



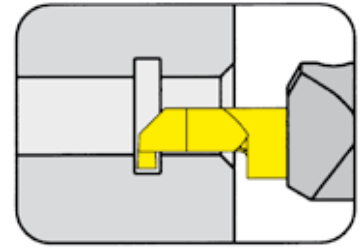
A

刀杆 型号

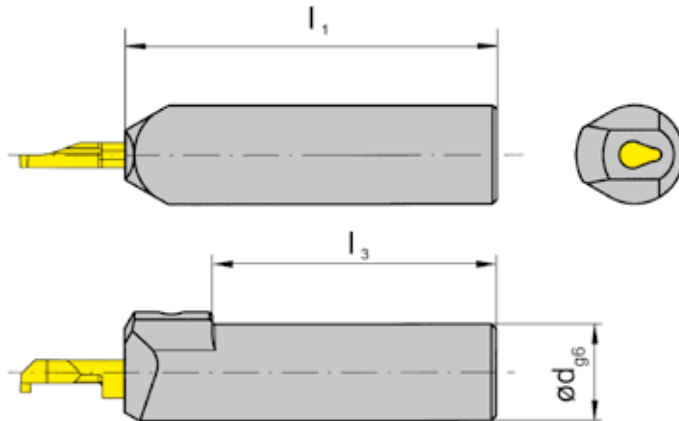
TOOLHOLDER Type

B105

带内冷
with through coolant supply



孔径最小至	Bore \varnothing 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

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_3
B105.0010.01A	10	75	57
B105.0012.01A	12	75	63
B105.0016.01A	16	75	63

按需提供更多尺寸
Further sizes upon request

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.

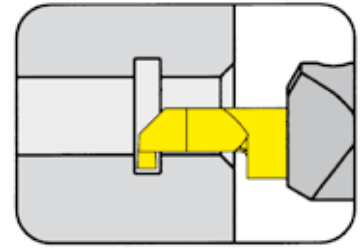
附件

Spare parts

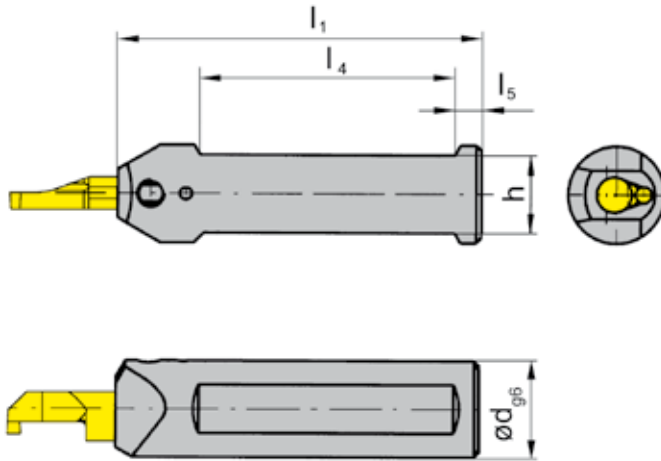
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.001...	6.075T15P	T15PQ

刀杆 型号

TOOLHOLDER Type

B105/BU105带内冷
with through coolant supply

孔径最小至	Bore \varnothing 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

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
B105.0022.01	22.00	90.0	20.00	55	5	-
B105.0028.01	28.00	120.0	26.00	72	12	**
BU105.0750.5.01	3/4"	90.0	17.04	70	5	**
BU105.0750.5.3.01	3/4"	152.5	17.05	70	5	**
BU105.1000.5.01	1"	90.0	23.40	65	5	**
BU105.1000.5.3.01	1"	152.5	23.40	70	5	**

按需提供更多尺寸

Further sizes upon request

单位：mm和inch

Dimensions in mm and inch

** 用于Traub机床带有M12×1.5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...	6.075T15P	T15PQ

切槽和镗孔

GROOVING and BORING



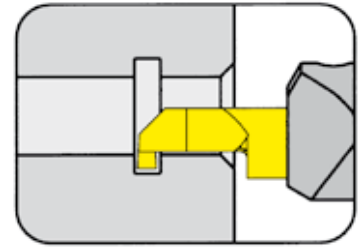
A

刀杆 型号

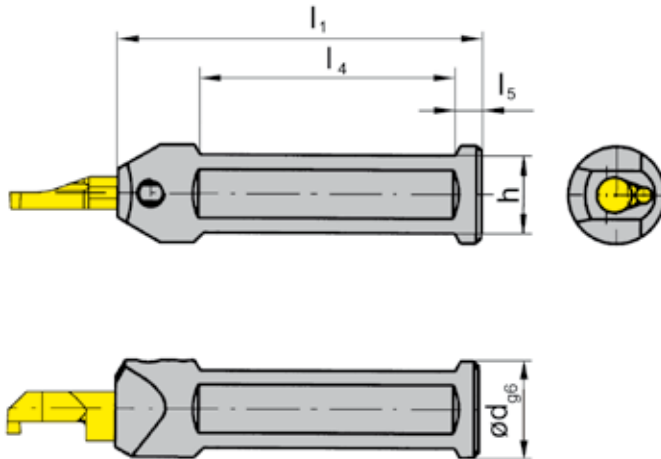
TOOLHOLDER Type

B105

带内冷
with through coolant supply



孔径最小至	Bore Ø from	0.2 mm
槽深	Depth of groove	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

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄	l ₅
B105.0022.1.2.01	22	120	20	72	5

按需提供更多尺寸
Further sizes upon request

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.

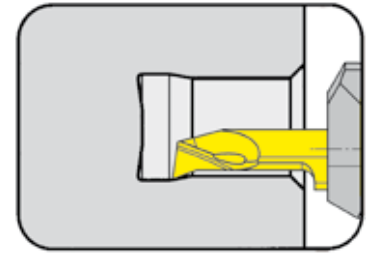
附件

Spare parts

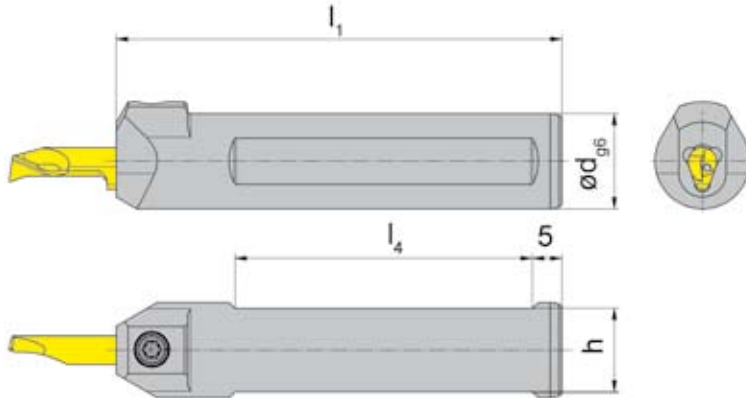
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.0022.1.2.01	6.075T15P	T15PQ

刀杆 型号

TOOLHOLDER Type

B105带内冷
with through coolant supply

孔径最小至	Bore \varnothing 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

带有多个冷却孔
with additional through coolant
bores

产品型号 Part number	d	l_1	h	l_4
B105.0012-K.01	12	75	11	50
B105.0016-K.01	16	75	14	50
B105.0020-K.01	20	90	18	50

按需提供更多尺寸

Further sizes upon request

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...	6.075T15P	T15PQ

切槽和镗孔

GROOVING and BORING

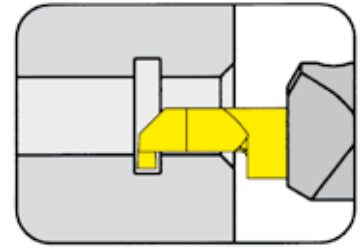


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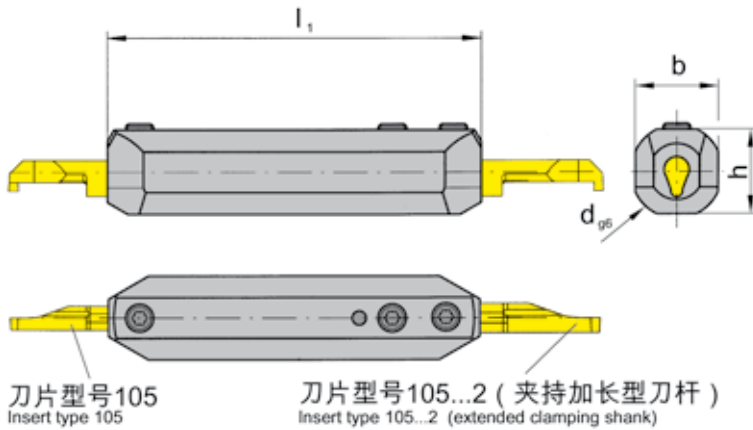
刀杆 型号
TOOLHOLDER Type

B105

无内冷
no coolant supply



孔径最小至	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 105...2

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	b
B105.0020.1.03	20	80	18	18

按需提供更多尺寸
Further sizes upon request

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.

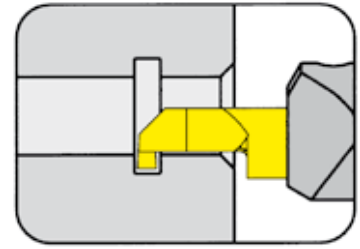
螺丝的扭矩规格，详见技术说明。
For torque specifications of the screw, please see Technical Instructions.

附件
Spare parts

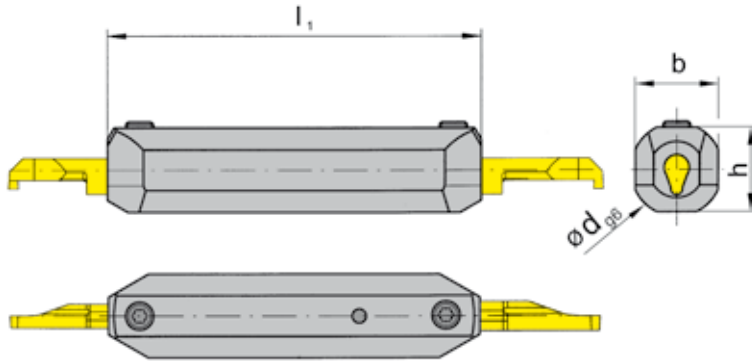
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.0020.1.03	6.075T15P	T15PQ

刀杆 型号

TOOLHOLDER Type

B105无内冷
no coolant supply

孔径最小至	Bore \varnothing 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

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	h	b
B105.0022.2.1.01	22	80	20	20
B105.0022.2.2.01	22	120	20	20

按需提供更多尺寸
Further sizes upon request

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
B105.0022.2....	6.075T15P	T15PQ

切槽和镗孔

GROOVING and BORING



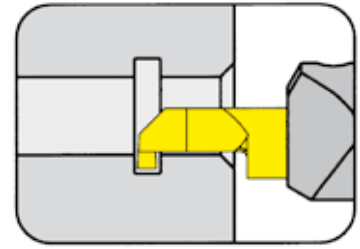
A

刀杆 型号

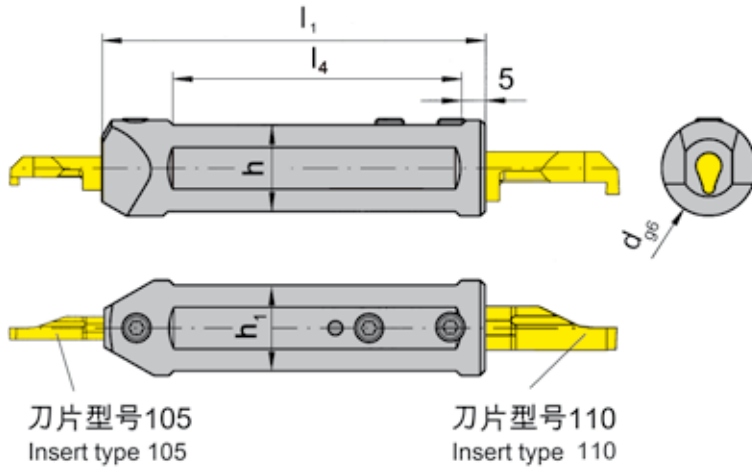
TOOLHOLDER Type

B105

带内冷
with through coolant supply



孔径最小至	Bore Ø from	0.2/6.0 mm
槽深	Depth of groove	2.5/4.0 mm
槽宽	Width of groove	2.0/3.0 mm



配合 刀片
for use with Insert

型号 105
Type 110

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	h ₁
B105.0020.1.10	20	80	60	18	18

按需提供更多尺寸
Further sizes upon request

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
B105.0020.1.10	6.075T15P	T15PQ

GRAF常规刀柄 型号

BASIC TOOLHOLDER GRAF Type

IR105

带内冷

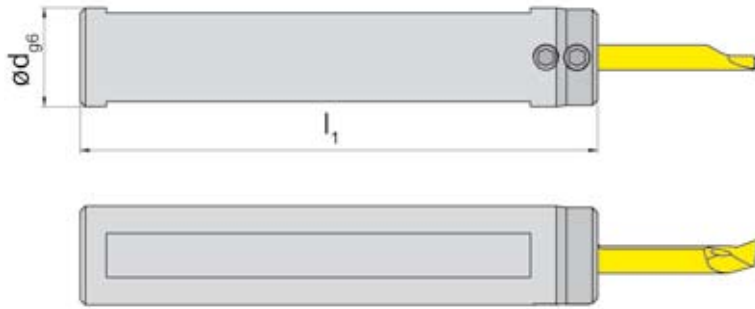
with through coolant supply



孔径最小至

Bore Ø from

0.2 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	机床型号 Type of machine
IR105.34.100	3/4"	100	CITIZEN
IR105.34.40	3/4"	40	
IR105.34.50	3/4"	50	
IR105.34.70	3/4"	70	
IR105.20.30	20.00	30	
IR105.20.50	20.00	50	
IR105.10.100	1"	100	
IR105.10.60	1"	60	STAR
IR105.16.30	16.00	30	
IR105.16.50	16.00	50	
IR105.16.70	16.00	70	
IR105.22.100	22.00	100	
IR105.22.120	22.00	120	
IR105.22.38	22.00	38	
IR105.22.50	22.00	50	TORNOS
IR105.22.70	22.00	70	
IR105.18.310	18.00	310	
IR105.20.170	20.00	170	
IR105.20.185	20.00	185	
IR105.25.100	25.00	100	
IR105.25.150	25.00	150	
IR105.28.80	28.00	80	

按需提供更多尺寸

Further sizes upon request

单位：mm和inch

Dimensions in mm and inch

附件

Spare parts

Graf常规刀柄 Basic toolholder GRAF	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
IR105....	6.075T15P	T15PQ

注意事项：

冷却液管需要单独订购！

Note:

Coolant supply must be ordered separately!

螺丝的扭矩规格，详见技术说明。

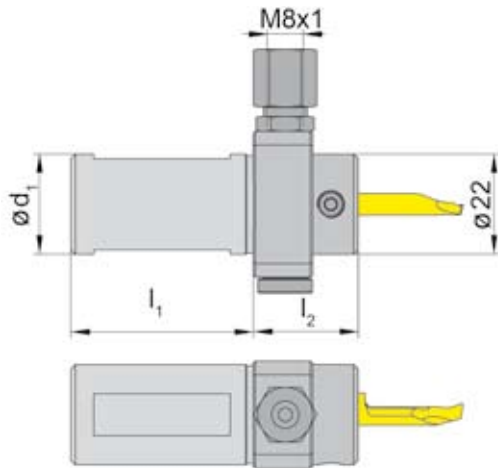
For torque specifications of the screw, please see Technical Instructions.

GRAF刀夹 型号
CARTRIDGE GRAF Type

IR105
带内冷
with through coolant supply



孔径最小至 Bore Ø from 0.2 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	l_1	l_2	d_1
IR105.1640.IKV	40	23	16.00
IR105.3440.IKV	40	23	3/4"
IR105.2040.IKV	40	23	20.00
IR105.2240.IKV	40	23	22.00
IR105.2560.IKV	60	23	25.00
IR105.1060.IKV	60	23	1"

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

螺丝的扭矩规格，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
IR105....	6.075T15P	T15PQ

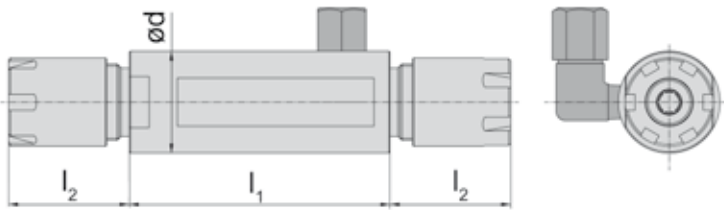
双头刀杆 型号

DOUBLE CHUCK HOLDERS Type

GZ79

带内冷
with through coolant supply

用于带ER16夹紧螺母的ER刀杆
for chuck holders ER with chucking nuts ER16



产品型号 Part number	d	l ₁	l ₂	备注 Remark
GZ79.3470.16	3/4"	70	32	ER16
GZ79.2065.16	20.00	65	32	ER16
GZ79.22100.16	22.00	100	32	ER16
GZ79.2262.16	22.00	62	32	ER16
GZ79.2580.16	25.00	80	32	ER16
GZ79.1065.16	1"	65	32	ER16

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

切槽和镗孔

GROOVING and BORING



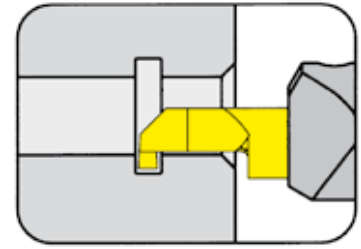
A

刀杆型号

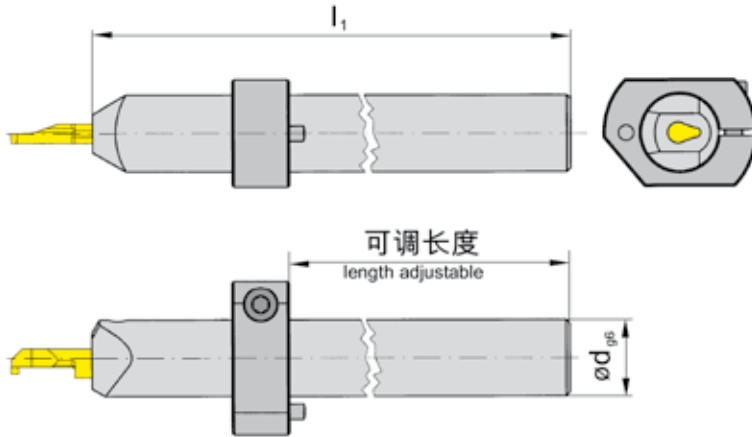
TOOLHOLDER Type

B105

带内冷
with through coolant supply



孔径最小至	Bore \varnothing 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_1
B105.0020.2.01	20	150
B105.0025.2.01	25	150

按需提供更多尺寸
Further sizes upon request

单位: mm
Dimensions in mm

订货须知:

刀杆可以安装左, 右手刀片

Ordering note:

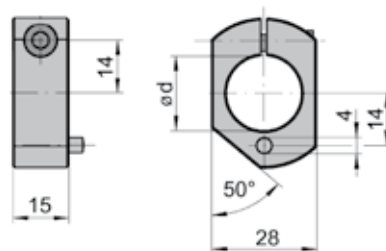
Toolholders can be used with right and left hand inserts.

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!

调整环

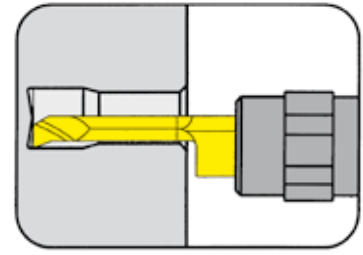
Adjusting ring



调整环型号 Part number "Adjusting ring"	d	机床类型 Type of machine
020.0020.1665	20	Tornos DECO
020.0025.2234	25	

刀杆 型号

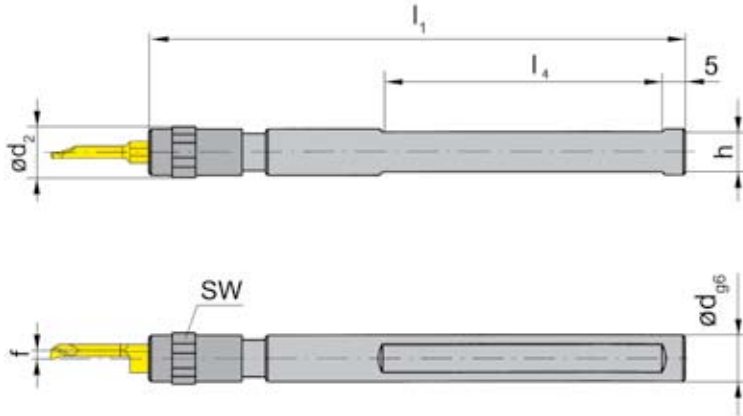
TOOLHOLDER Type

B105带内冷
with through coolant supply

孔径最小至

Bore \varnothing from

<3.0/>5.0 mm



配合 刀片

for use with Insert

型号 105 ($\varnothing \leq 3.0$)Type 105 ($\varnothing \geq 5.0$)

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	h	f	d_2	l_4	孔径范围 Bore Range	SW
B105.0010.9.01	10	100	9	1.6	11	50	* ≤ 3.0	10
B105.0012.11.01	12	100	11	1.2	16	50	* ≥ 5.0	13
B105.0016.11.01	16		15					

按需提供更多尺寸

Further sizes upon request

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	020.0010.1719
B105.001...01	020.0016.1999

A14

切槽和镗孔

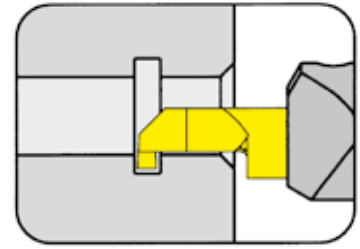
GROOVING and BORING



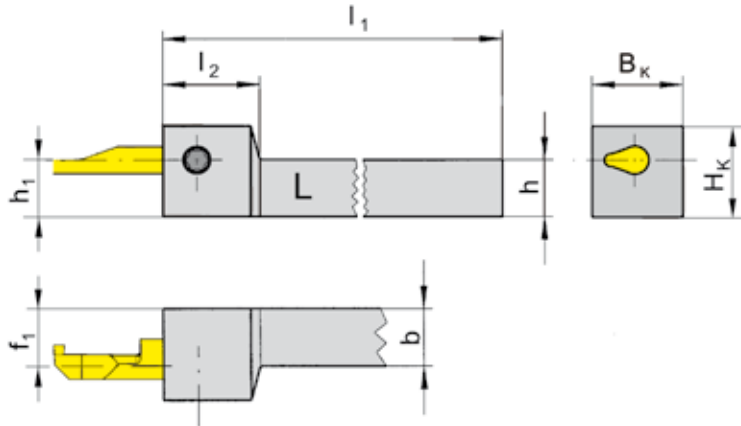
A

刀杆 型号
TOOLHOLDER Type

H105



孔径最小至 Bore Ø from 0.2 mm



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_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

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.

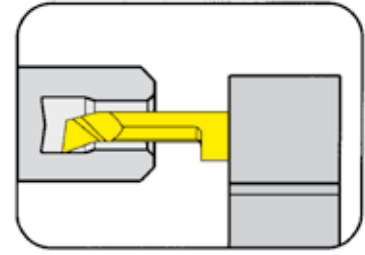
附件
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LH105....	6.075T15P	T15PQ

刀杆 型号

TOOLHOLDER Type

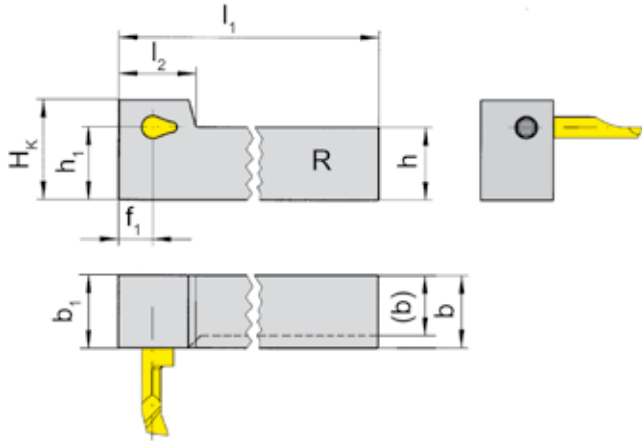
HC105



孔径最小至

Bore \varnothing 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
R/LHC105-1212-01	90	17	12	12	7.5	12	16	18
R/LHC105-1616-01	130	17	16	16	7.5	16	16	22

注明R或L型

State R or L version

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.

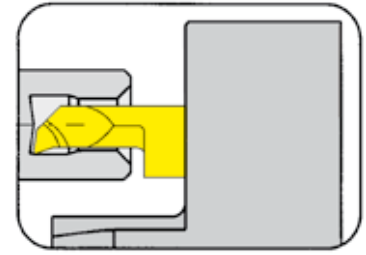
附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LHC105.1...	6.075T15P	T15PQ

刀杆 型号
TOOLHOLDER Type

HC105

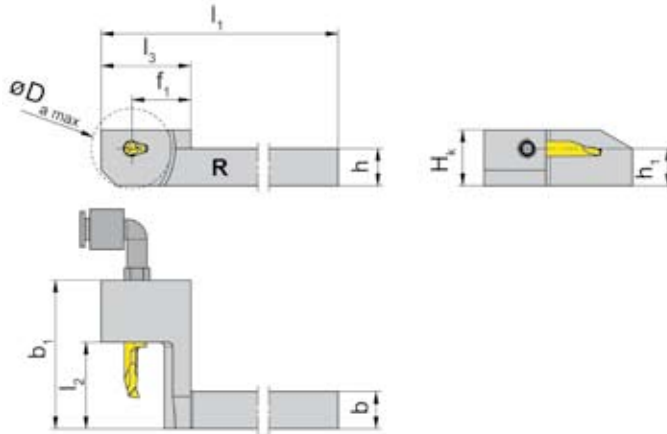


孔径最小至 Bore Ø from 0.2 mm

弯曲型冷却液接头
Coolant supply through cranked fitting

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	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 R/LHC105.0812.21	99	18	8	8	19	29	8 12	32.0	26	13	*
RHC105.1010.11	99	8	10	10	19	29	10	22.7	26	16	*
R/LHC105.1010.21 R/LHC105.1010.41	99	18 28	10	10	19	29	10	38.0 48.0	26	16	
R/LHC105.1212.21 R/LHC105.1212.41	99	18 28	12	12	19	29	12	38.0 48.0	26	18	
R/LHC105.1616.21 R/LHC105.1616.41	104	18 28	16	16	24	34	16	38.0 48.0	36	22	

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

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

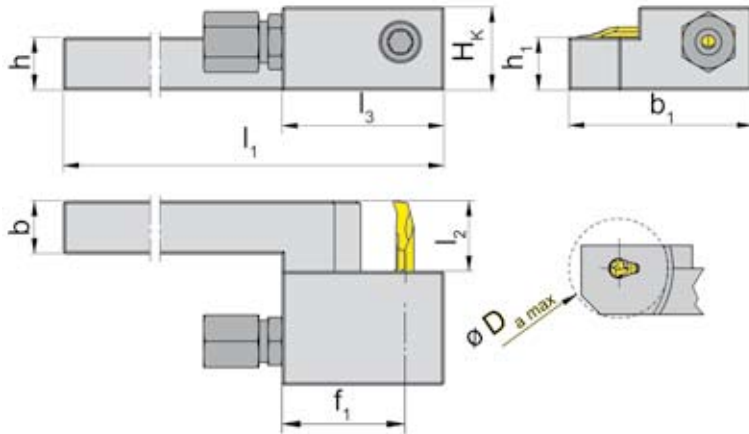
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	旋紧型角度接头 Screwed angle fitting
R/LHC105...07./08...	6.075T15P	T15PQ	-
RHC105...11	6.075T15P	T15PQ	-
R/LHC105.1...21/41	6.075T15P	T15PQ	KQ2L06-M5

刀杆 型号
TOOLHOLDER Type

962

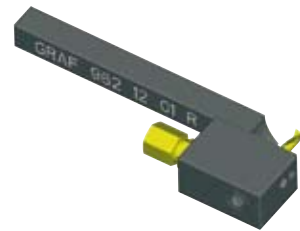
孔径最小至 Bore Ø from 0.2 mm

内冷装置
Coolant through fitting



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	l_3	b	b_1	$D_{a\ max}$	H_k
962.08.01R 962.08.02L	130	15	8	8	27	37	8	42	26	15
962.10.01R 962.10.02L	130	15	10	10	27	37	10	42	26	17
962.12.01R 962.12.02L	130	15	12	12	27	37	12	42	26	19
962.16.01R 962.16.02L	130	15	16	16	27	37	16	42	32	23
962.20.01R 962.20.02L	130	15	20	20	27	37	20	42	32	27

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

螺丝的扭矩规格，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
962....	6.075T15P	T15PQ	004.00.19

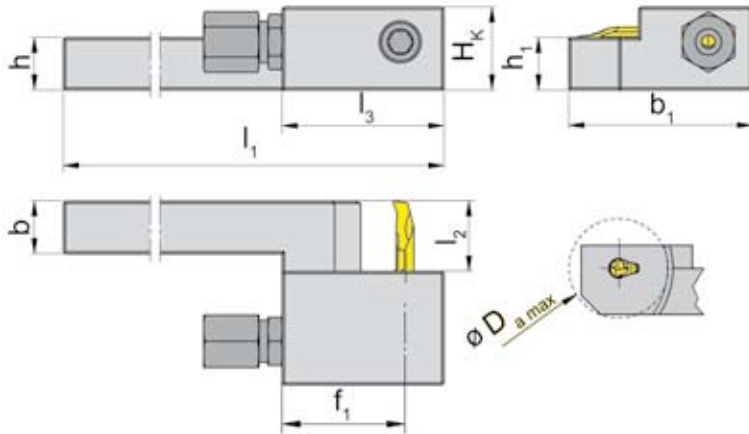
刀杆 型号
TOOLHOLDER Type

962



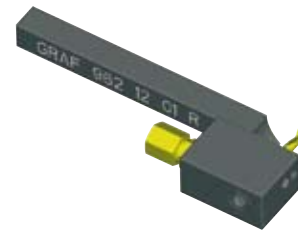
孔径最小至 Bore Ø from 0.2 mm

内冷装置
Coolant through fitting



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	l_3	b	b_1	$D_{a \max}$	H_k
962.08.03R 962.08.04L	130	30	8	8	27	37	8	57	26	15
962.10.03R 962.10.04L	130	30	10	10	27	37	10	57	26	17
962.12.03R 962.12.04L	130	30	12	12	27	37	12	57	26	19
962.16.03R 962.16.04L	130	30	16	16	27	37	16	57	32	23
962.20.03R 962.20.04L	130	30	20	20	27	37	20	57	32	27

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

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

附件
Spare parts

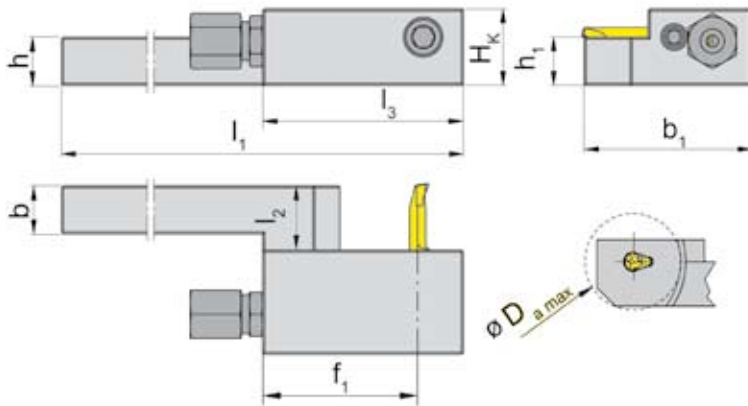
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
962....	6.075T15P	T15PQ	004.00.19

刀杆 型号
TOOLHOLDER Type

963

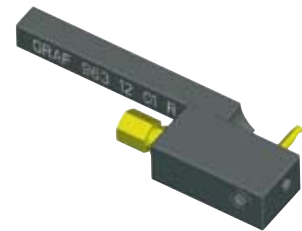
孔径最小至 Bore Ø from 0.2 mm

内冷装置
Coolant through fitting



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	l_3	b	b_1	$D_{a \max}$	H_k
963.08.01R 963.08.02L	130	15	8	8	40	50	8	42	26	15
963.10.01R 963.10.02L	130	15	10	10	40	50	10	42	26	17
963.12.01R 963.12.02L	130	15	12	12	40	50	12	42	26	19
963.16.01R 963.16.02L	130	15	16	16	45	50	16	42	32	23
963.20.01R 963.20.02L	130	15	20	20	45	50	20	42	32	27

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

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

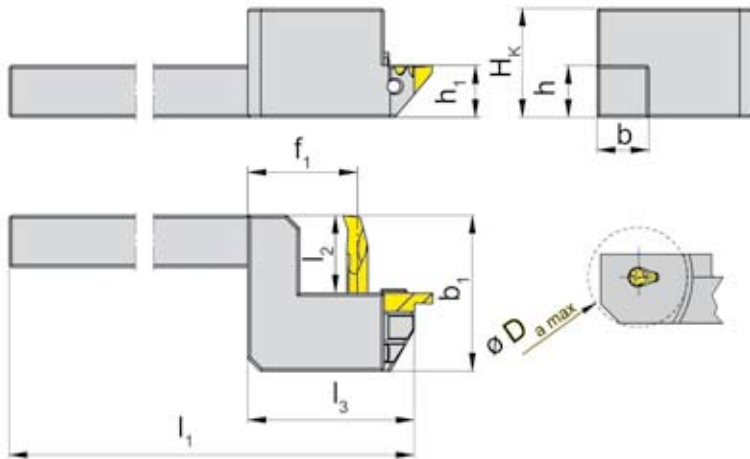
附件
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	冷却接头 Coolant supply
963....	6.075T15P	T15PQ	004.00.19

刀杆 型号
TOOLHOLDER Type

AIH

孔径最小至 Bore Ø from 0.2 mm



配合 刀片
for use with Insert

型号 105
Type S274

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
AIH.974.R/L1010.K04	130	15	10	10	23	35	10	30	20	17	*
AIH.974.R/L1212.K04			12	12	23	35	12		20	19	
AIH.974.R/L1616.K04			16	16	26	38	16		26	23	
AIH.974.R/L2020.K04			20	20	29	38	20		32	23	
AIH.R/L1010.K08	130	15	10	10	21	30	10	30	20	17	**
AIH.R/L1212.K08			12	12	21		12		20	19	
AIH.R/L1616.K08			16	16	24		16		26	23	
AIH.R/L2020.K08			20	20	27		20		32	23	

注明R或L型
State R or L version

单位 : mm
Dimensions in mm

注意事项 :

*该刀杆可配合HORN105和S274系列的刀片
**该刀杆可配合Horn105系列刀片和Graf刀片CS08。

Note:

* These toolholders can be equipped with HORN inserts type 105 and S274
** These toolholders can be equipped with HORN inserts type 105 and Graf inserts CS08

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	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
AIH....	030.3509.T15P	6.075T15P	T15PQ

常规刀杆 型号

BASIC TOOLHOLDER Type

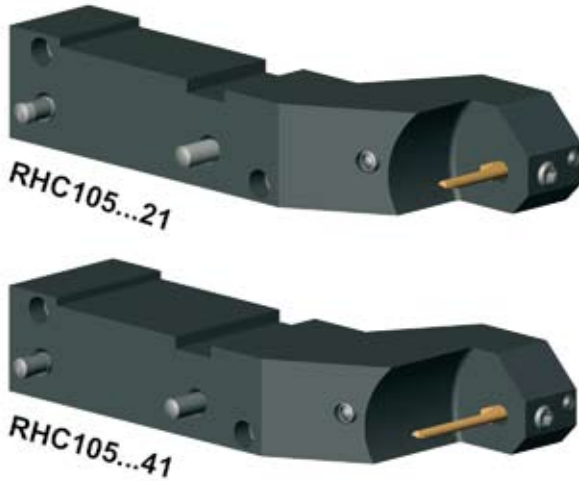
HC105

孔径最小至

Bore Ø from

0.2 mm

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

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

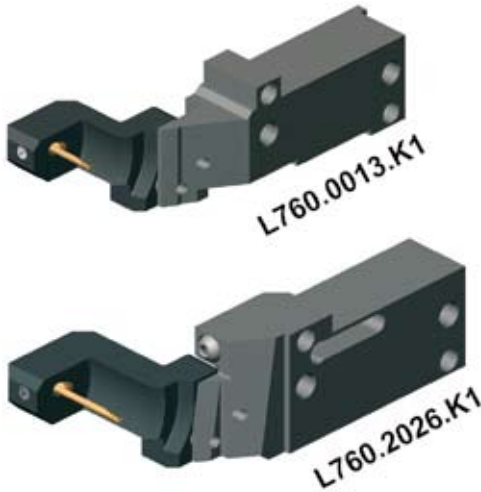
常规刀杆 Basic toolholder	螺钉 Screw	螺钉 Screw	圆柱螺钉 Cylindrical Screw	TORX PLUS® 扳手 TORX PLUS® Wrench	旋紧型角度接头 Screwed angle fitting	销 Pin
RHC105.0710....	020.0518.1610	6.075T15P	DIN912-M5x45	T15PQ	KQ2L06-M5	DIN6325-5H6x20

常规刀杆 型号
BASIC TOOLHOLDER Type

L760

孔径最小至 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_2 可达//up to 15 mm
L760.2026.K1	DECO20/26	RKC760.0105.41	105...41 l_2 可达//up to 25 mm

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

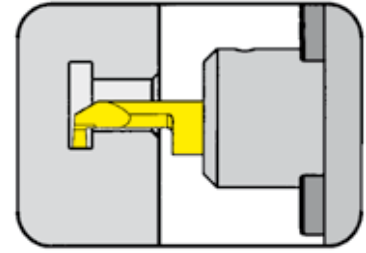
附件
Spare parts

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 L760.2026.K1	DIN7984-M16x35 DIN7984-M16x35	SW5.0DIN911 SW5.0DIN911	05.032.902

常规刀杆 型号

BASIC TOOLHOLDER Type

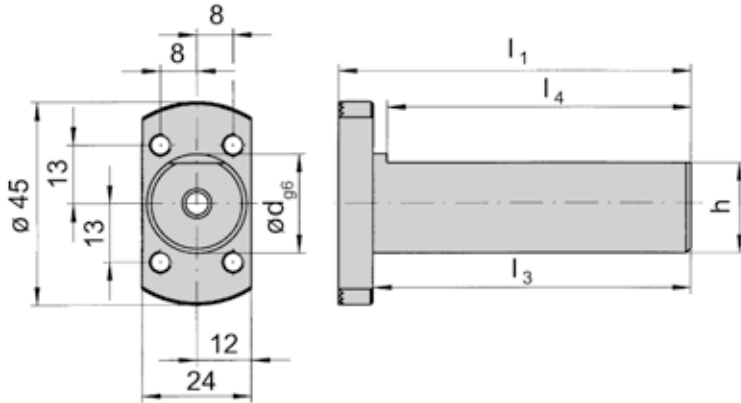
BGT

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 ₁	h	l ₃	l ₄	机床 Machine tool
BGT001.0010.50	10	57.50	9	50	47	
BGT001.0016.21 BGT001.0R16.21	16	28.50	14	21	18	Star
BGT001.0020.100	20	107.50	18	100	97	Tornos
BGT001.0022.30 BGT001.0022.70	22	36.35 77.50	20	30 70	27 67	Star
BGT001.0025.70	25	77.50	23	70	67	
BGT001.0028.80	28	87.50	26	81	77	Traub

按需提供更多尺寸

Further sizes upon request

单位：mm

Dimensions in mm

注意事项：

BGT001.0022.30无内冷

Note:

BGT001.0022.30 without 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

常规刀杆 Basic toolholder	螺钉 Screw	扳手 Wrench	O型圈 O-ring
BGT001.0...	DIN912-M5x10	SW4.0DIN911	DIN3770-7x3

切槽和镗孔

GROOVING and BORING



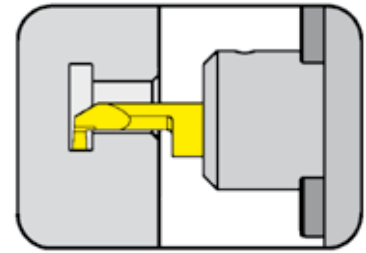
A

常规刀杆 型号

BASIC TOOLHOLDER Type

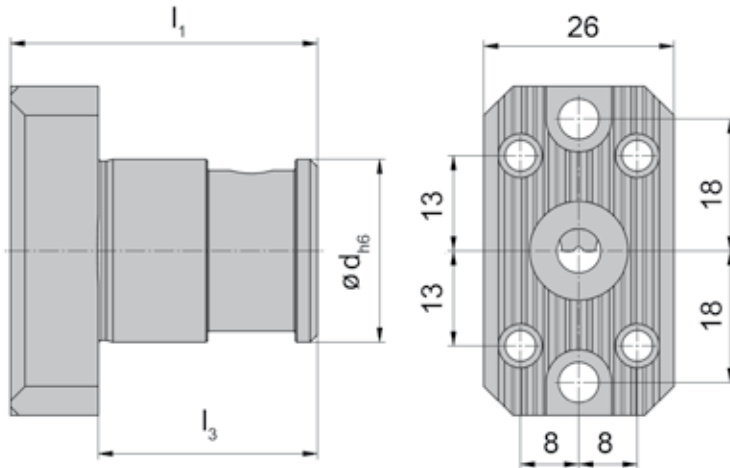
BGT

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 ₁	l ₃	机床 Machine tool
BGT001.C025.30IK	25	42	30	Citizen L20X

按需提供更多尺寸
Further sizes upon request

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

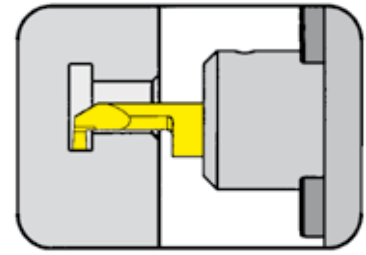
Spare parts

常规刀杆 Basic toolholder	圆柱螺钉 Cylindrical Screw	扳手 Wrench	O型圈 O-ring
BGT001.C025.30IK	DIN912-M5x14	SW4.0DIN911	DIN3770-7x3

可调刀杆 型号

ADJUSTABLE HOLDER Type

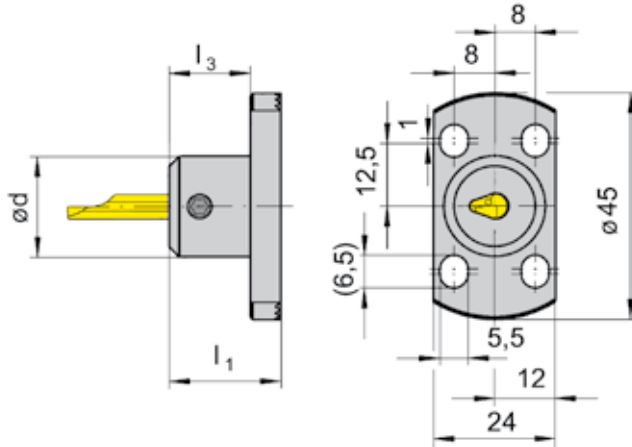
BKT



孔径最小至	Bore \varnothing 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

带内冷

with through coolant supply



配合 刀片

for use with Insert

型号 105

Type



产品型号 Part number	d	l_1	l_3
BKT105.2445.01	20	22	16
BKT105.2445.02		32	26

按需提供更多尺寸

Further sizes upon request

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
BKT105.2445.0...	6.075T15P	T15PQ

切槽和镗孔

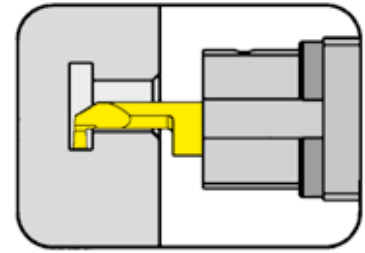
GROOVING and BORING

常规刀杆 型号

BASIC TOOLHOLDER Type

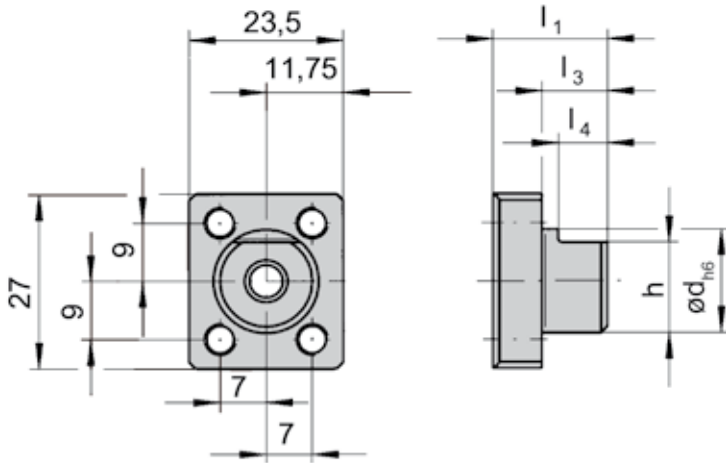
BGT

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 ₁	h	l ₃	l ₄	机床 Machine tool
BGT001.1627.10	16	17.5	14	10	7.5	Star

按需提供更多尺寸
Further sizes upon request

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

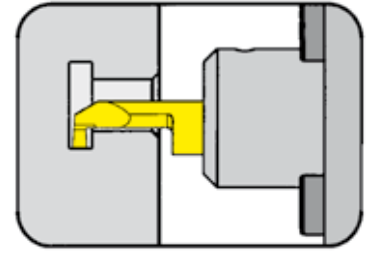
Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	扳手 Wrench	O型圈 O-ring
BGT001.1627.10	DIN912-M5x10	SW4.0DIN911	DIN3770-7x3

常规刀杆 型号

BASIC TOOLHOLDER Type

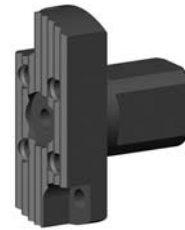
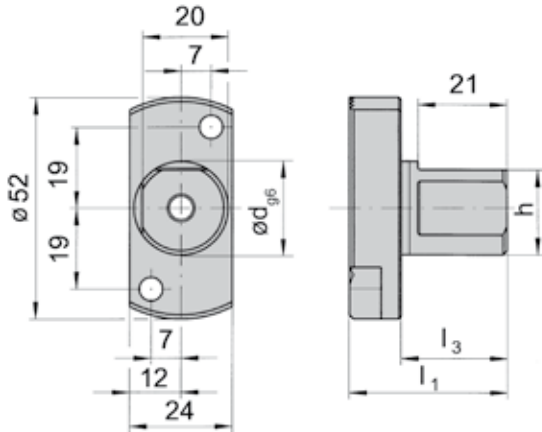
BGT

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 ₁	h	l ₃
BGT001.0R22.25	22	37	20	25

按需提供更多尺寸
Further sizes upon request

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	扳手 Wrench
BGT001.0R22.25	DIN912-M5x10	SW4.0DIN911

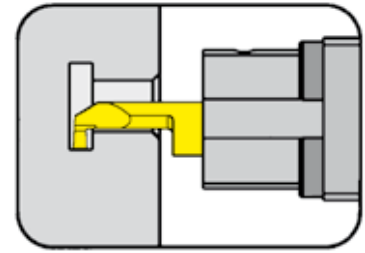
切槽和镗孔

GROOVING and BORING

可调刀杆 型号

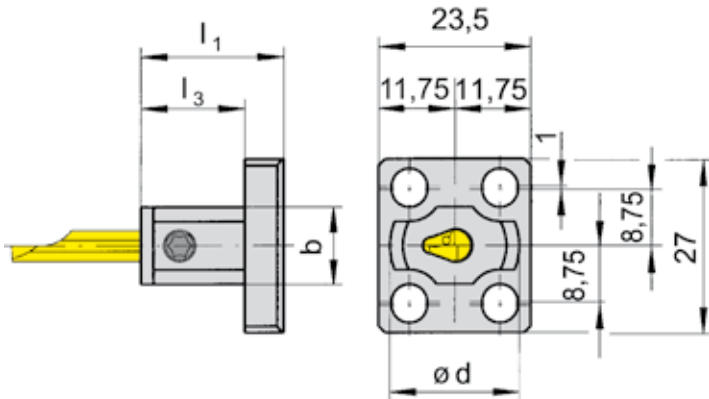
ADJUSTABLE HOLDER Type

BKT



孔径最小至	Bore \varnothing 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

带内冷
with through coolant supply



配合 刀片
for use with Insert

型号 105
Type



BKT105.2327.01

产品型号 Part number	d	l_1	l_3	b
BKT105.2327.01	20	22	16	12

按需提供更多尺寸
Further sizes upon request

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

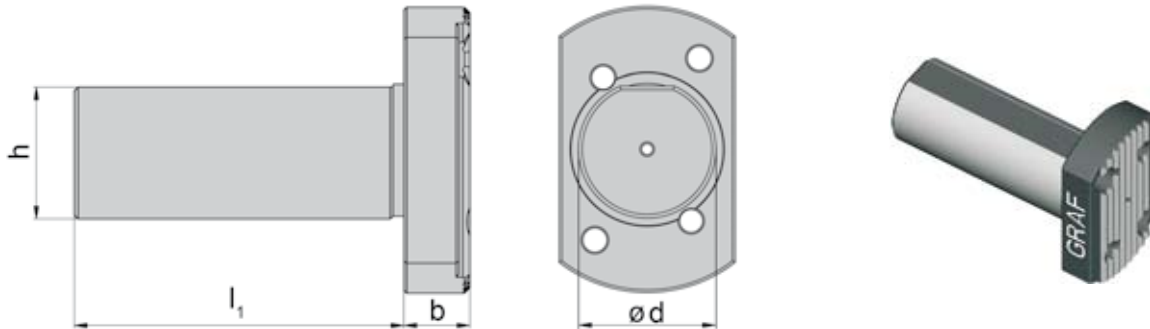
GRAF常规刀柄 型号

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 ₁	h	b	机床 Machine tool
G016021	16.00	21	14	6	Star Traub/Manurhin
G016040		40			
G034040	3/4"	40	18	6	Citizen
G034050		50			
G034120		120			
G020030	20.00	30	18	6	Citizen Hanwha Tornos Manurhin/Tornos
G020040		40			
G020100		100			
G020150		150			
G022023	22.00	23	20	6	Star
G022025SR16/20R		25		12	
G022030		30		6	
G022030SR32		30		12	
G022070		70		6	

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

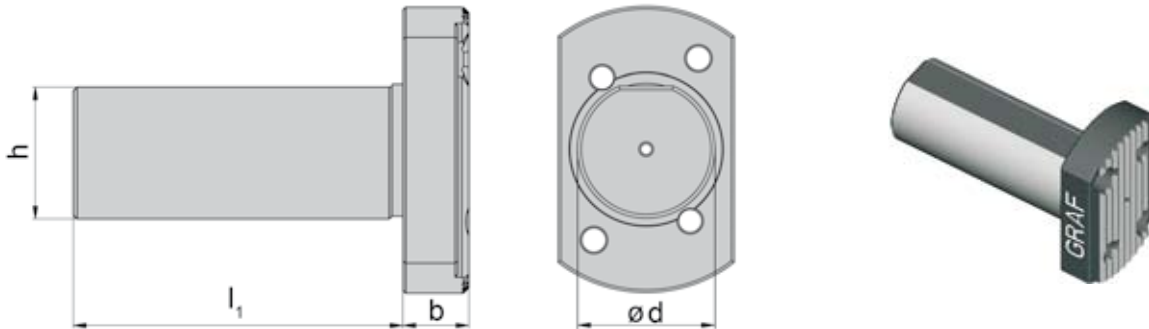
GROOVING and BORING

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 ₁	h	b	机床 Machine tool
G025060	25.0	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	28.0	6	26	12	Hanwha Traub
G028080		80			
G030045	30.0	45	27	12	Maier
G033040	33.0	40	31	12	Hanwha
G034020	34.0	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

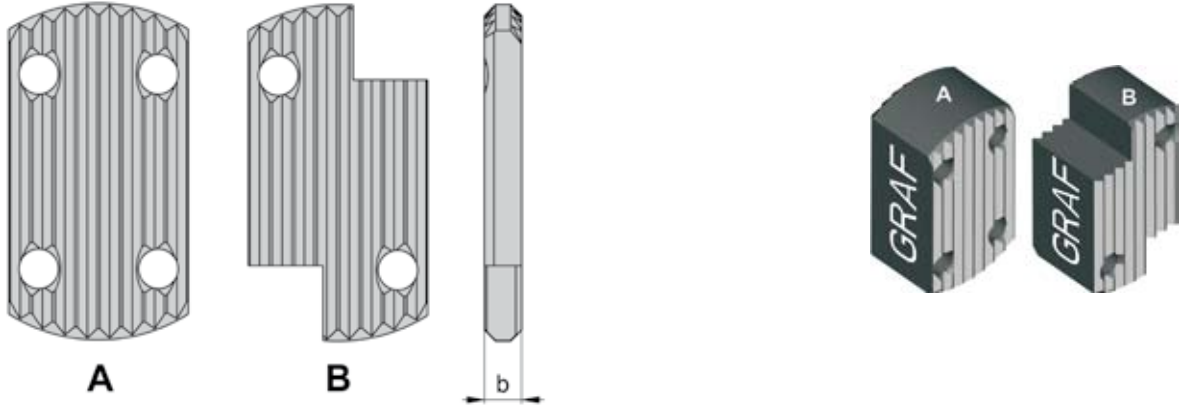
GRAF接头 型号

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

单位：mm
Dimensions in mm

切槽和镗孔

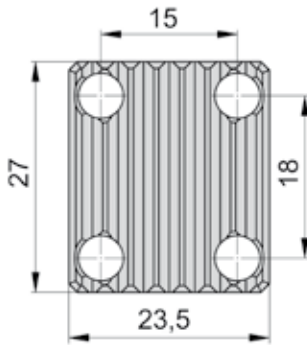
GROOVING and BORING

GRAF接头 型号
ADAPTOR GRAF Type

Z
无刀夹
without cartridge



配合HORN可调刀杆BKT105.2327.01
for adjustable holder HORN BKT.105.2327.01



产品型号 Part number	b
Z10SW7	10
Z15SW7	15
Z20SW7	20
Z25SW7	25
Z30SW7	30

按需提供更多尺寸
Further sizes upon request

单位：mm
Dimensions in mm

平面间 GRAF 型号

PLATE BETWEEN GRAF type

N

无刀夹
without cartridge

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

用于背面加工
for back working

产品编号 N11

Part number

适合两刃刀片

For alternatively 2 cartridges



产品编号 N12

Part number

适合三刃刀片

For alternatively 3 cartridges



产品编号 N93IK

Part number

内冷

with through coolant supply

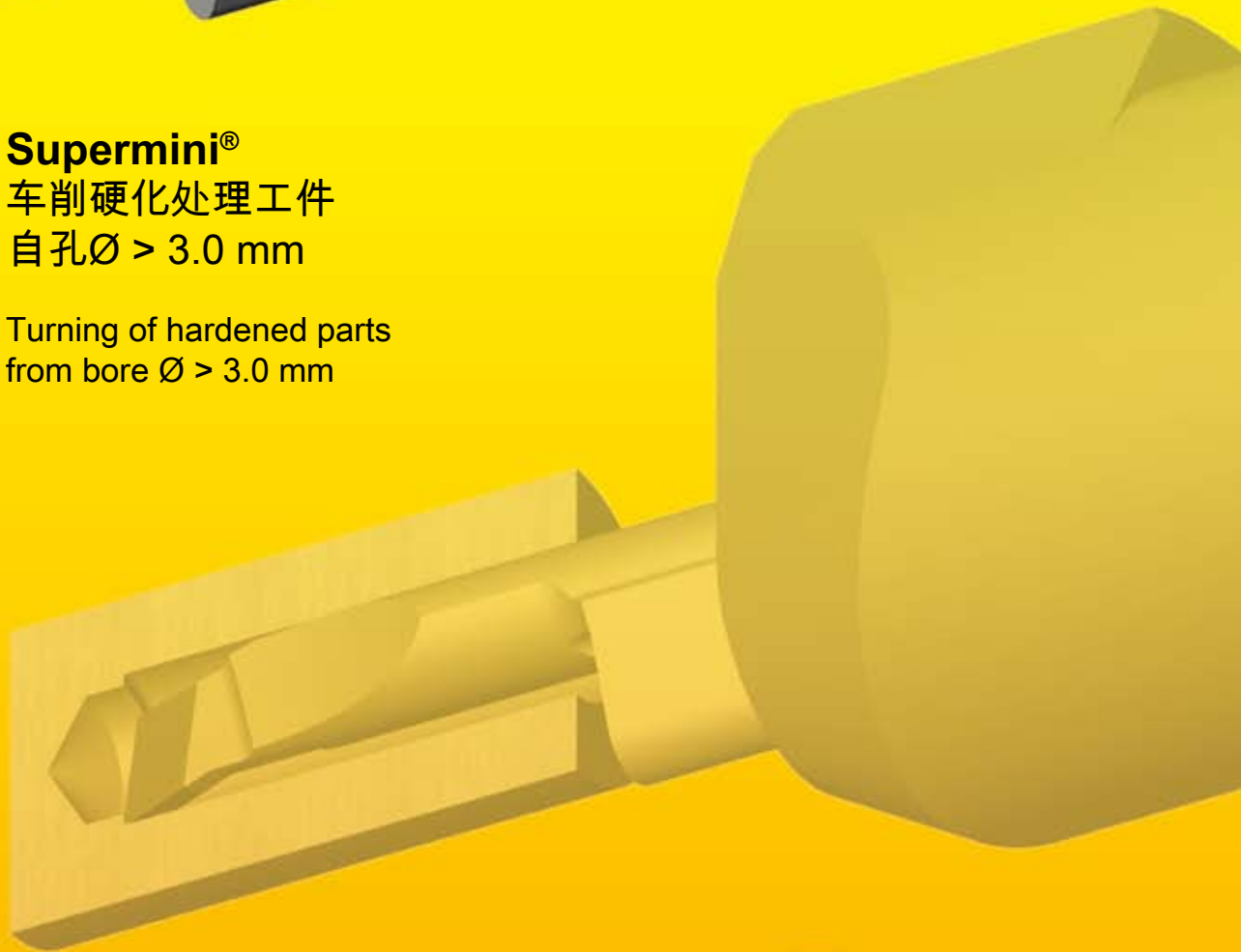


根据要求提供PCD或CBN刀片
PCD- or CBN-tipped inserts upon request.



Supermini®
车削硬化处理工件
自孔 $\varnothing > 3.0$ mm

Turning of hardened parts
from bore $\varnothing > 3.0$ mm



Mini
PCD刀片
PCD-tipped insert



可调刀杆 型号

ADJUSTABLE HOLDER Type

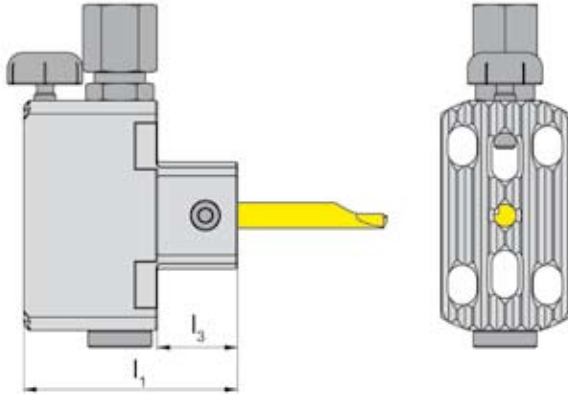
N

GRAF[®]
WERKZEUGSYSTEME

孔径最小至	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

带内冷

with through coolant supply



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	l_1	l_3
N09IK	40	15

按需提供更多尺寸

Further sizes upon request

单位 : mm

Dimensions in mm

不包含冷却液管-需要单独订购!

Coolant tube is not included - 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

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

可调刀杆 型号

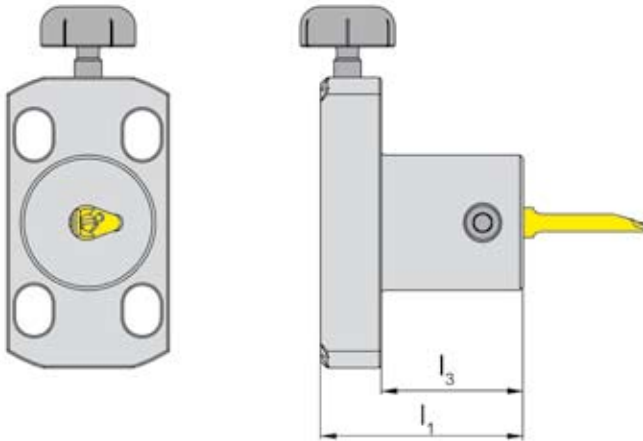
ADJUSTABLE HOLDER Type

N



孔径最小至	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

无内冷
no through coolant supply



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	l_1	l_3
N09	30	20

按需提供更多尺寸
Further sizes upon request

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	高度调节螺钉 Height adjustment screw
N09	6.075T15P	002.00.69

可调刀杆 型号

ADJUSTABLE HOLDER Type

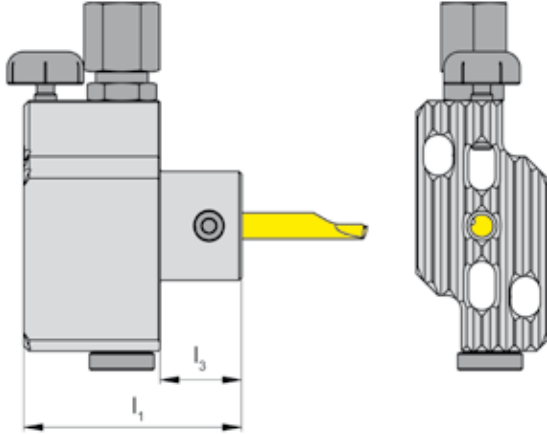
N

GRAF[®]
WERKZEUGSYSTEME

孔径最小至	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

带内冷

with through coolant supply



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	l_1	l_3
N73IK	40	15

按需提供更多尺寸

Further sizes upon request

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	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply
N73IK	6.075T15P	002.00.69	004.00.19

可调刀杆 型号

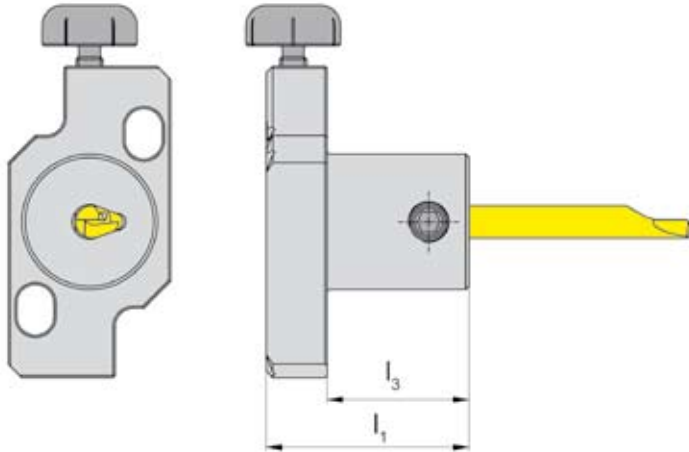
ADJUSTABLE HOLDER Type

N



孔径最小至	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

无内冷
no through coolant supply



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	l_1	l_3
N73	30	20

按需提供更多尺寸
Further sizes upon request

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	高度调节螺钉 Height adjustment screw
N73	6.075T15P	002.00.69

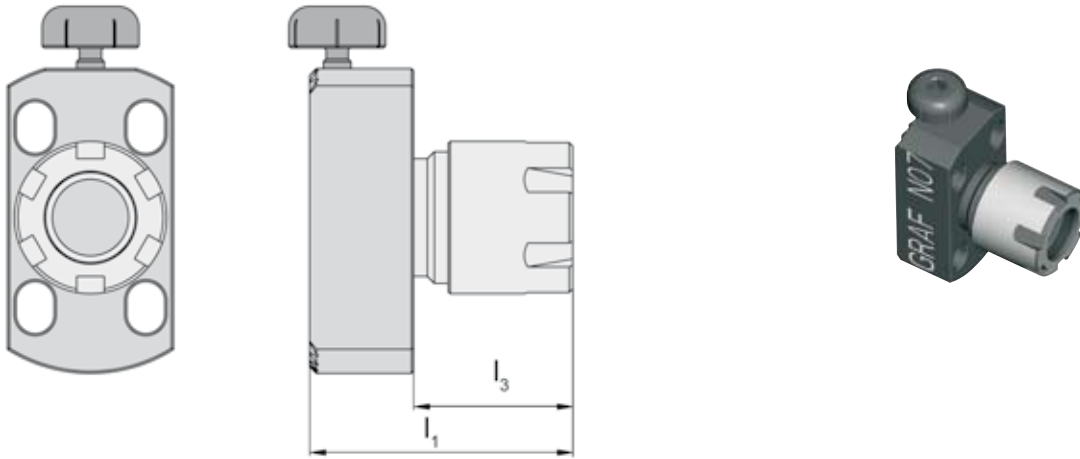
可调刀杆 型号

ADJUSTABLE HOLDER Type

N

GRAF®
WERKZEUGSYSTEME

配合Graf系统 ER16 筒夹
with chucking nut ER16 system Graf



产品型号 Part number	l_1	l_3	备注 Remark
N07	37	18	ER16

按需提供更多尺寸
Further sizes upon request

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
N07	62.000.16	002.00.69

可调刀杆 型号

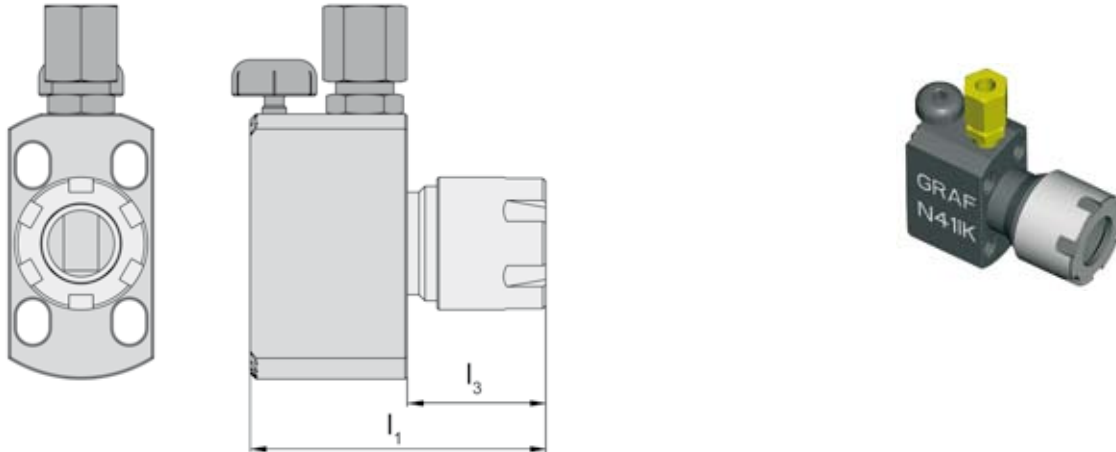
ADJUSTABLE HOLDER Type

N



配合Graf ER16/ER20筒夹
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

单位：mm
Dimensions in mm

附件

Spare parts

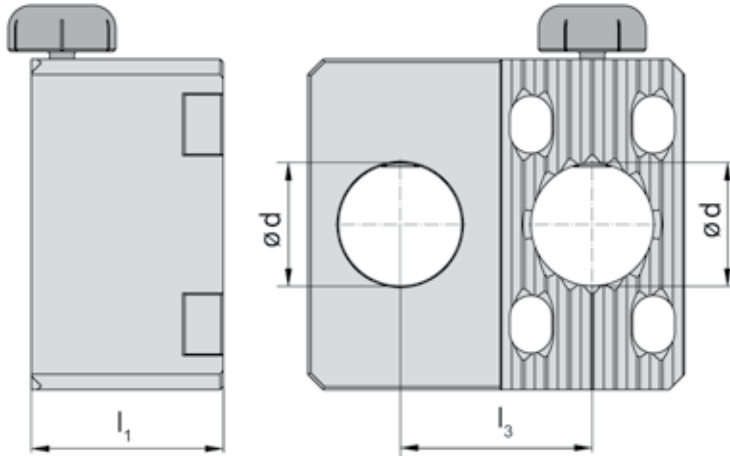
可调刀杆 Adjustable holder	锁紧螺母 Chucking nut	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply	垫圈组D3 Set of seals D3
N07IK	62.000.16	002.00.69	004.00.19	64.600.16.3-10
N41IK	62.000.20	002.00.69	004.00.19	64.600.20.3-13

可调刀杆 型号

ADJUSTABLE HOLDER Type

N

配合Graf ER11/ER16筒夹接头
for collet adaptors ER11/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
N10	25	25	ER11 + ER16

按需提供更多尺寸
Further sizes upon request

单位：mm
Dimensions in mm

不包含筒夹接头-需单独订购！
The collet adaptors are not included - separate order required!

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	筒夹刀柄 Collet holder
N10	002.00.11	002.00.69	GZ66.1620.11ER11/ GZ66.1626.16ER16



冷却系统标准连接头

Standard connection for through cooling

用于管子 Ø 6 mm
for pipe Ø 6 mm

冷却系统连接
Connection for through cooling
004.00.19

M8 x 1



用于管子 Ø 6 mm
for pipe Ø 6 mm



冷却系统连接
Connection for through cooling
004.00.22

M8 x 1

冷却系统连接快速接头

Clip connection for through cooling

M10 x 1

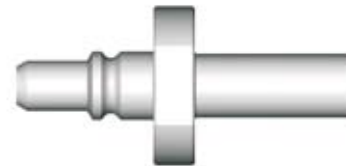


快速夹头
Clip connection
004.00.49



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

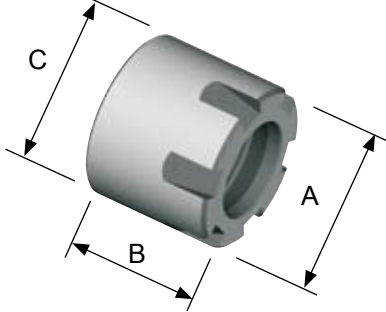
M8 x 1 - 004.00.61
G1/8" - 004.00.16

夹紧螺母

Chucking nut

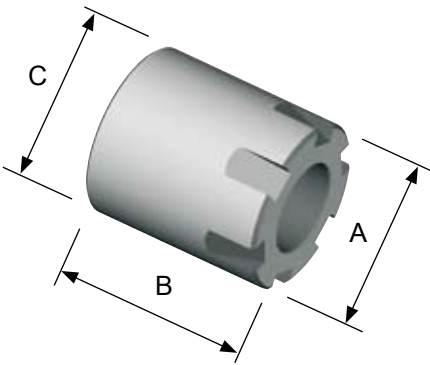


ER-M



ER-M	A	B	C
62 000 08-ER 8	12	10.8	M10x0.75
62 000 11-ER 11	16	12	M13x0.75
62 000 16-ER 16	22	18	M19x1
62 000 20-ER 20	28	19	M24x1
62 000 25-ER 25	35	20	M30x1

ER-MA 密封 sealed

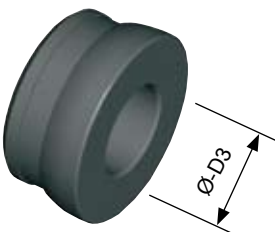


ER-MA	A	B	C
62 600 16-ER 16	22	24.5	M19x1
62 600 20-ER 20	28	26.5	M24x1
62 600 25-ER 25	35	27.5	M30x1

尺寸单位：mm
Dimensions in mm

密封圈 用于ER-MA密封螺母

Sealing rings
for chucking nuts ER-MA...



全组合：
completed set:

产品编号 Part number	Ø D3
64 600 16-ER 16	3.0-3.5...9.5-10.0 mm
64 600 20-ER 20	3.0-3.5...12.5-13.0 mm
64 600 25-ER 25	3.0-3.5...15.5-16.0 mm

尺寸单位：mm
Dimensions in mm

密封环可单独购买

例如：

The sealing rings can be ordered separately.

Example:

产品编号 Part number	直径范围 Diameter range	可能自-达 possible from-up to
ER 16 64 600 16 <u>30</u>	3.01 - 3.50	3 - 10
ER 20 64 600 20 <u>45</u>	4.51 - 5.00	3 - 13
ER 25 64 600 25 <u>80</u>	8.01 - 8.50	3 - 16

尺寸单位：mm
Dimensions in mm

高度调节装置

DEVICE FOR HEIGHT ADJUSTING



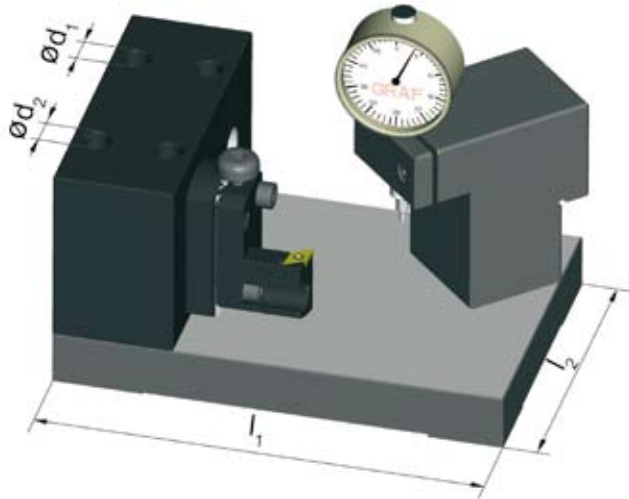
A

高度调节机构 型号
DEVICE FOR HEIGHT ADJUSTING Type

HVR40



用于背面加工的刀杆HVR40
for back working holder HVR40



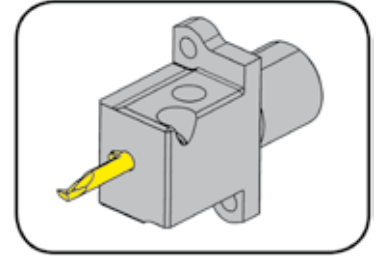
产品型号 Part number	l_1	l_2	d_1	d_2	系统 System
12.0506	250	180	16	22	STAR
12.0507			3/4"	1"	CITIZEN
12.0508			30	34	MAIER
12.0511			25	33	HANWHA
12.0523			20	28	HANWHA

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

刀杆 型号

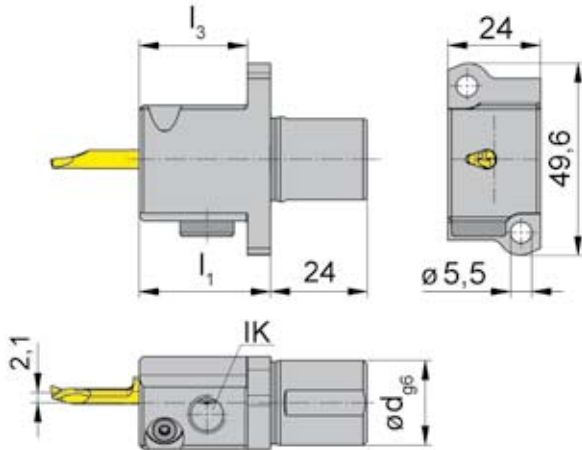
TOOLHOLDER Type

B105带内冷
with through coolant supply

孔径最小至	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

内冷管G1/8"

Through coolant supply G1/8"



配合 刀片

for use with Insert

型号 105

Type

Star SV12/20/32
SR10/20/32和SB16

Star SV 12/20/32
SR 10/20/32 and SB 16

L=左手型

L = left hand version

产品型号 Part number	d	l ₁	l ₃
LB105.A022.26.31	22	34	28

按需提供更多尺寸

Further sizes upon request

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	070.0010.0118	030.0422.T10P	DIN7984-M5x12	SW3.0DIN911	T10PL

切槽和镗孔

GROOVING and BORING



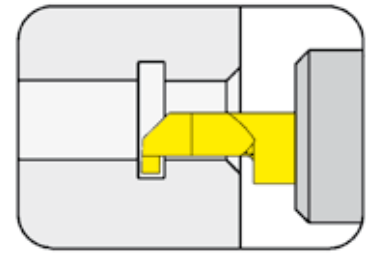
A

刀杆 型号

TOOLHOLDER Type

VDI

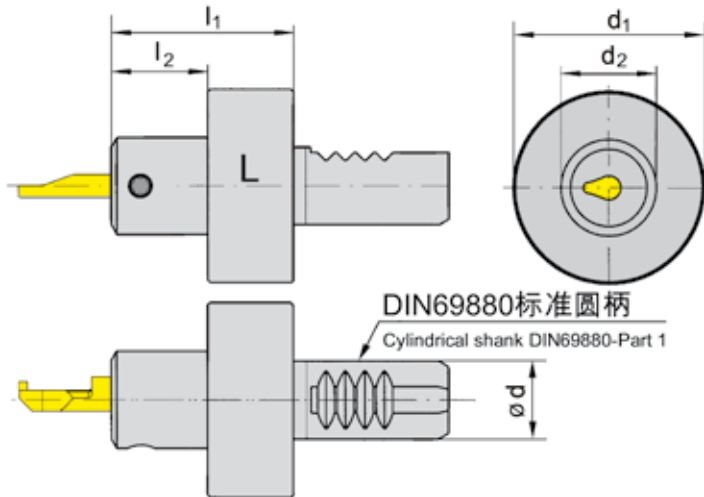
带内冷
with through coolant supply



孔径最小至	Bore \varnothing 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	3.0 mm

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	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

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

切槽 (内圆)

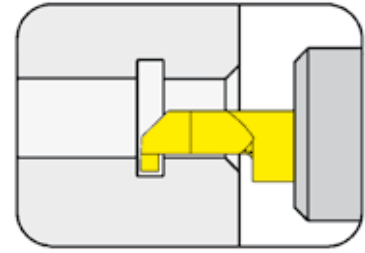
GROOVING (internal)

刀杆 型号

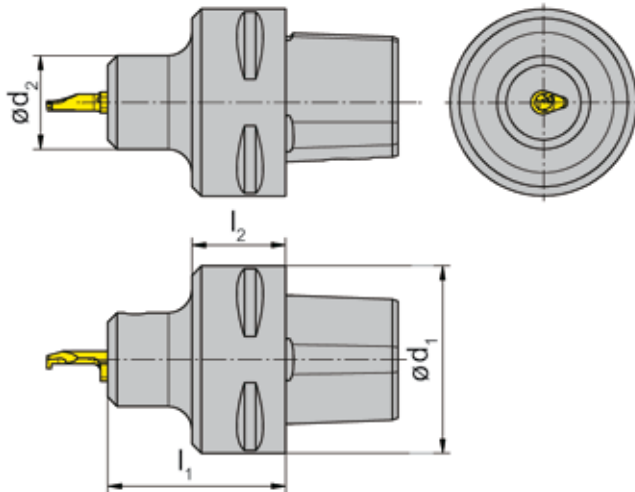
TOOLHOLDER Type

B105C

带内冷
with through coolant supply



HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623



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 105

Type

产品型号 Part number	l_1	l_2	d_2	d_1
R/LB105.00C3.20.1.01	30	15	20	32
R/LB105.00C4.20.1.01	38	20	20	40
R/LB105.00C5.20.1.01	38	20	20	50
R/LB105.00C6.20.1.01	42	22	20	63

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.

单位：mm

Dimensions in mm

附件

Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB105.00C...	6.075T15P	T15PQ

切槽 (内圆)

GROOVING (internal)



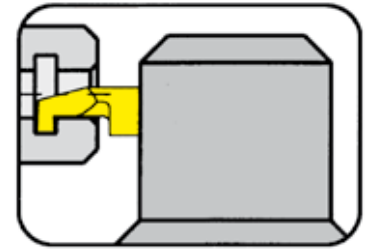
A

刀杆 型号

TOOLHOLDER Type

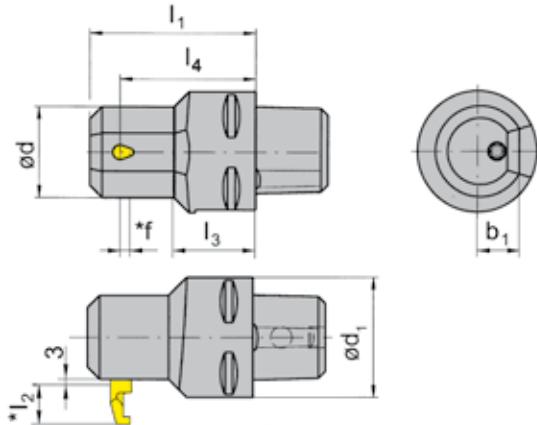
B105C

带内冷
with through coolant supply



HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于INDEX多主轴机床
for INDEX Multi spindle machines



配合刀片
for use with Insert

型号 105
Type

产品型号 Part number	d	l ₁	l ₃	b ₁	l ₄	d ₁	机床型号 Type of machine
RB105.00C3.2.2.01	30	55	17	14	45	32	MS32
RB105.00C3.2.2.02	36		15	18			
RB105.00C4.2.2.01	30	55	26	14	45	40	MS52
RB105.00C4.2.2.02	36		22	18			

按需提供更多尺寸
Further sizes upon request

f. l₂ 见 105 系列刀片
f. l₂ see inserts type 105

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
RB105.00C...	6.075T15P	T15PQ

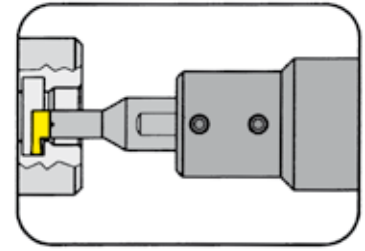
切槽 (内圆)

GROOVING (internal)

接头 型号

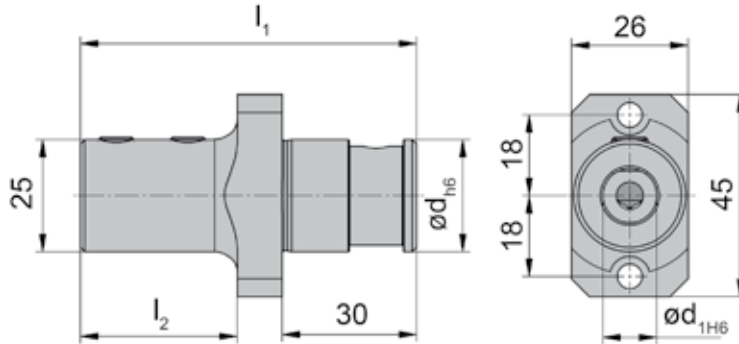
ADAPTOR Type

001



HORN 多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于带标准加持面的圆刀杆
for cylindrical shanks with standard clamping flat



产品型号 Part number	d	l ₁	l ₂	d ₁	机床 Machine tool
001.C025.12.30IK	25	75	35	12	Citizen L20X

按需提供更多尺寸
Further sizes upon request

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

接头 Adaptor	螺钉 Screw	扳手 Wrench
001.C025.12.30IK	DIN1835BM8x7.5	SW4.0DIN911



Supermini® 型号 105 自 Ø 0.2 mm
Mini 型号 108 自 Ø 8.0 mm
切槽刀具264系列

Supermini® type 105 from Ø 0.2 mm
Mini type 108 from Ø 8.0 mm
Grooving system 264



内圆和外圆加工
-不仅仅适用于Swiss机床-

External and internal machining
- not only for Swiss Type Machines -

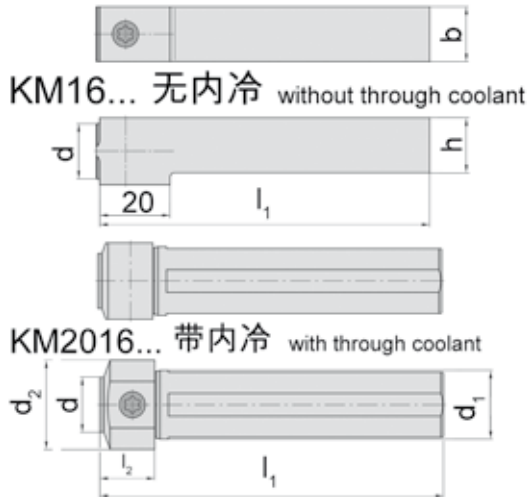
常规刀杆 型号

KM16

BASIC TOOLHOLDER Type

配合...KM16...刀柄的常规刀杆

Basic toolholder for use with toolholder ...KM16...



Kennametal KM16 Micro
系统
System Kennametal
KM16 Micro

产品型号 Part number	l_1	l_2	h	b	d_1	d_2
KM16 NCM 1616 100	100	-	16	16	-	-
KM2016 NCM SS20 16 KM2016 NCM SS22 16	100	16	-	-	20 22	26 28

按需提供更多尺寸
Further sizes upon request

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

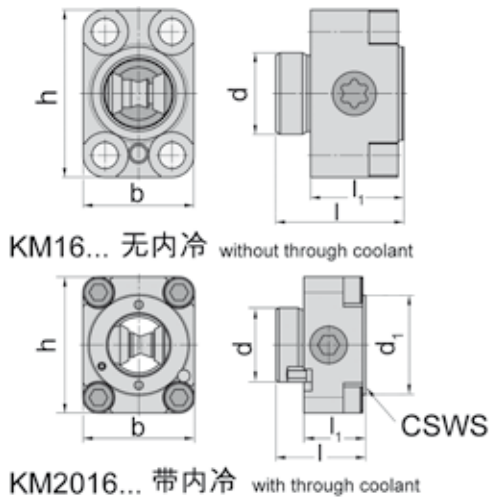
Spare parts

常规刀杆 Basic toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Blade
KM16 NCM 1616 100 KM2016 NCM SS2...	KM16-NSPKG KM16-NAPKG	DT27PQ DT27PQ

法兰 型号
FLANGE Type

KM16

配合...KM16...刀柄的常规刀杆
Basic toolholder for use with toolholder ...KM16...



Kennametal KM16 Micro
系统
System Kennametal
KM16 Micro

产品型号 Part number	l	d	l ₁	h	b	d ₁
KM16NCMSF1928	22	14	16	27.5	19	-
KM2016NCMSF2434	22	20	16	33.0	25	20

按需提供更多尺寸
Further sizes upon request

单位：mm
Dimensions in mm

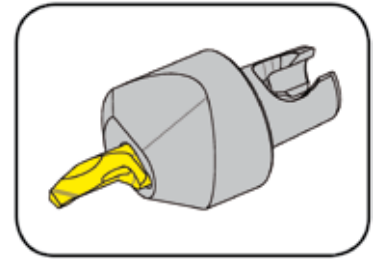
螺丝的扭矩规格，详见技术说明。
For torque specifications of the screw, please see Technical Instructions.

附件
Spare parts

法兰 Flange	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Blade
KM16NCMSF1928 KM2016NCMSF2434	KM16-NSPKG KM16-NAPKG	DT27PQ DT27PQ

刀杆 型号

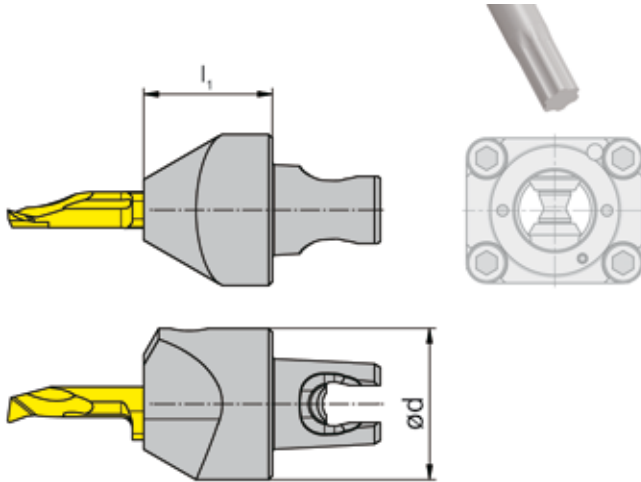
TOOLHOLDER Type

B105KM带内冷
with through coolant supply

孔径最小至

Bore Ø from

0.2 mm



配合 刀片

for use with Insert

型号 105

Type

Kennametal KM16 Micro
系统System Kennametal
KM16 Micro

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l ₁
B105.KM16.90.01	20	17

按需提供更多尺寸
Further sizes upon request

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
B105.KM16.90.01	6.075T15P	T15PQ

切槽和镗孔

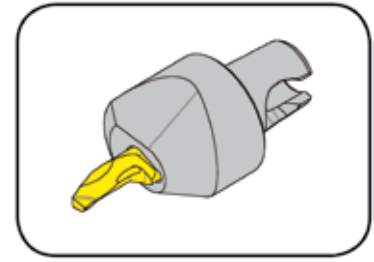
GROOVING and BORING



A

刀杆 型号
TOOLHOLDER Type

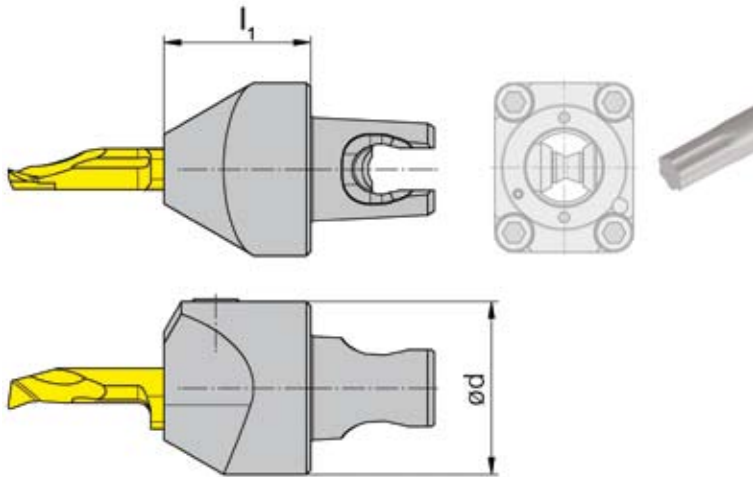
B105KM
带内冷
with through coolant supply



孔径最小至	Bore Ø from	0.2 mm
-------	-------------	--------

配合 刀片
for use with Insert

型号 105
Type



图示=右手型
Picture = right hand cutting version

Kennametal KM16 Micro
系统
System Kennametal
KM16 Micro

产品型号 Part number	d	l ₁
B105.KM16.01	20	17

按需提供更多尺寸
Further sizes upon request

单位 : mm
Dimensions in mm

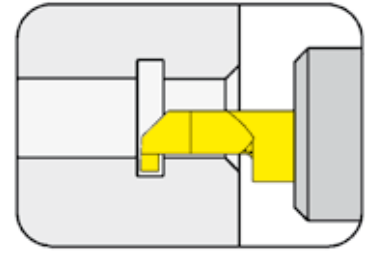
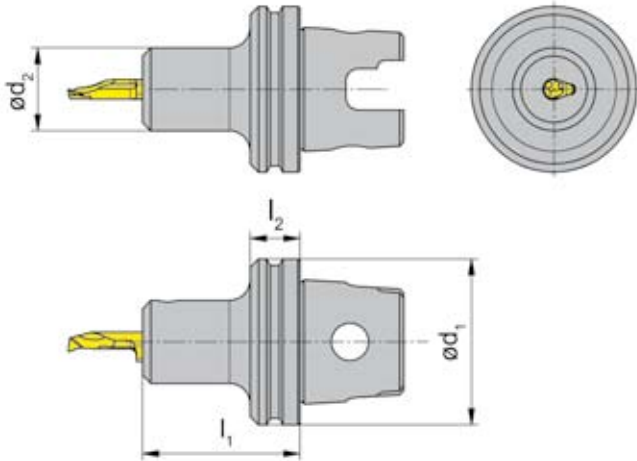
螺丝的扭矩规格，详见技术说明。
For torque specifications of the screw, please see Technical Instructions.

附件
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
B105.KM16.01	6.075T15P	T15PQ

刀杆 型号

TOOLHOLDER Type

B105KM带内冷
with through coolant supply用于105系列刀片Horn - KM的接头
Adapter for inserts type 105 System KM

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 105
TypeHORN刀杆TS (DIN
26622)HORN Toolholder TS
according to DIN 26622

产品型号 Part number	l_1	l_2	d_2	d_1	备注 Remark
R/LB105.KM40.20.1.01	38	12	20	40	KM40

注明R或L型

State R or L version

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.KM40.20.1.01	6.075T15P	T15PQ

切槽和镗孔

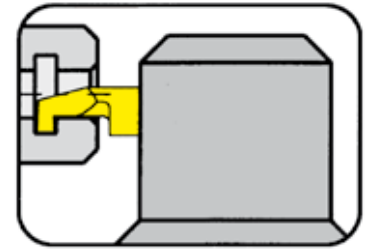
GROOVING and BORING



A

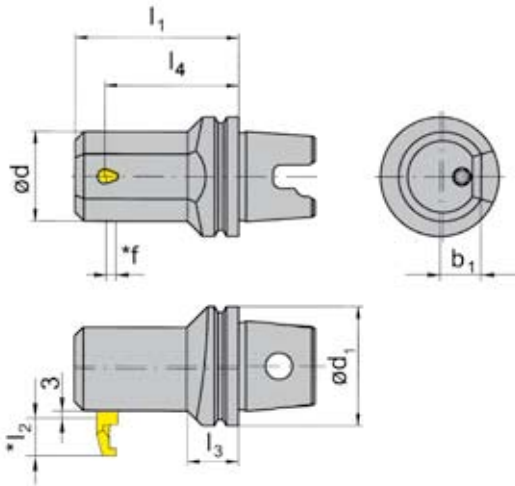
刀杆 型号
TOOLHOLDER Type

B105KM
带内冷
with through coolant supply



用于105系列刀片HORN - KM的接头
Adapter for inserts type 105 HORN-KM

用于INDEX多主轴机床
for INDEX Multi spindle machines



配合 刀片
for use with Insert

型号 105
Type

Kennametal授权
Licence Kennametal

R=右手型-如图
R = right hand version shown

产品型号 Part number	d	l ₁	l ₃	b ₁	l ₄	d ₁	机床型号 Type of machine
RB105.KM40.2.2.01	36	55	17	14	45	40	MS32
RB105.KM40.2.2.02			14	18			
RB105.KM50.2.2.01	36	55	26	14	45	50	MS52
RB105.KM50.2.2.02			22	18			

按需提供更多尺寸
Further sizes upon request

f.l₂见105系列刀片
f. l₂ see inserts type 105

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.

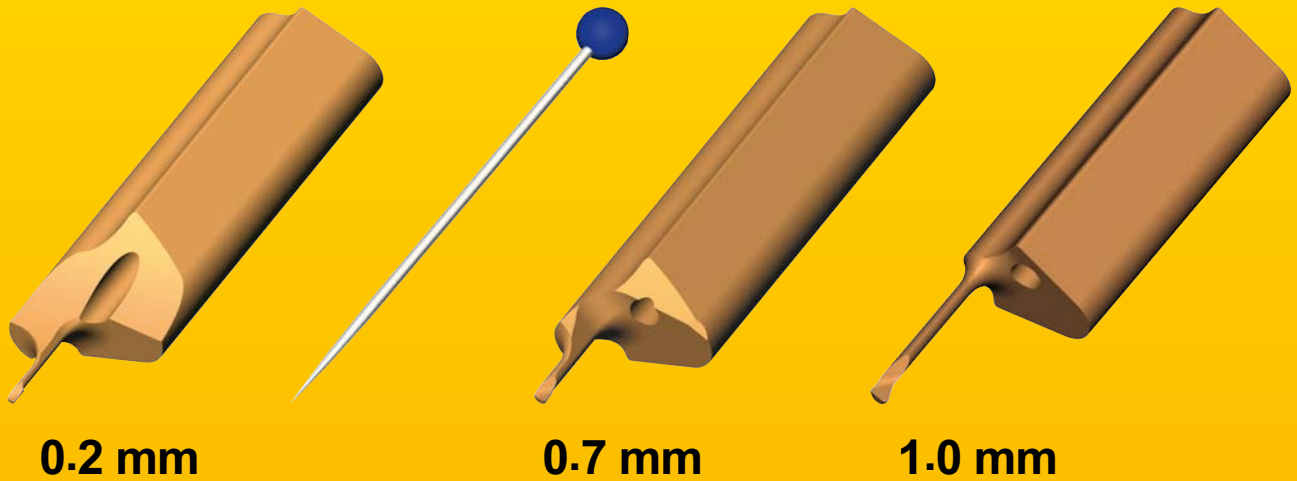
附件
Spare parts

刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
RB105.KM...	6.075T15P	T15PQ

孔径自

Boring from

0.2 mm



系列名称

Supermini[®]

- 最适于小孔径加工 -

Supermini[®]

- best in small bores -

镗孔和仿形加工 $\geq \text{Ø } 0.2 \text{ mm}$

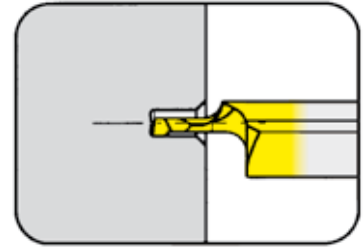
BORING and PROFILING



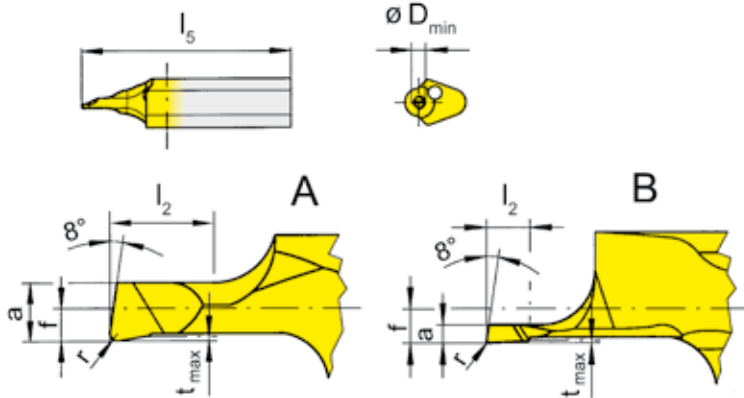
A

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 0.2 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	l_2	l_5	t_{max}	D_{min}	r	自 Form	MG12	TN35	TI25	TF45	TH35
R/L105.1802.0.02	1.0	0.17	1	23	0.02	0.2	0.02	B	▲/▲				
R/L105.1802.0.03	1.0	0.25	1	23	0.02	0.3	0.02	B	▲/▲				
R/L105.1802.0.05	1.0	0.40	2	23	0.05	0.5	0.05	B	▲/▲				
R/L105.1803.0.07	0.3	0.60	2	23	0.05	0.7	0.05	A	▲/▲				

- ▲ 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

单位 : mm

Dimensions in mm

注明R或L型

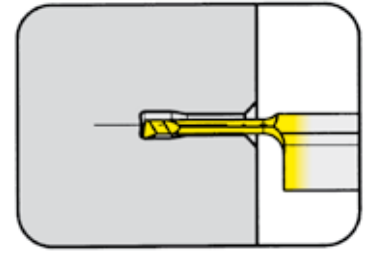
State R or L version

按需提供更多尺寸

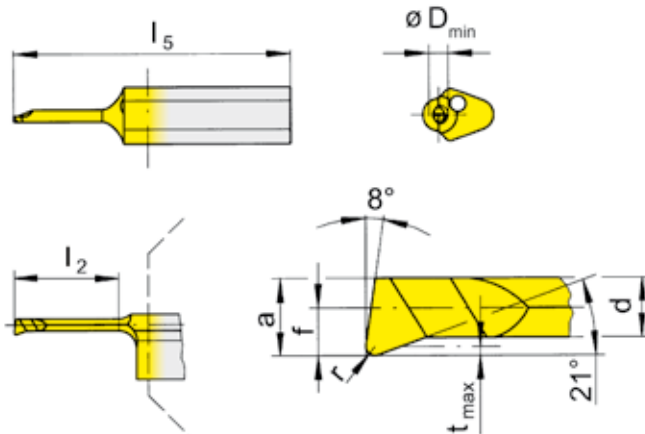
Further sizes upon request

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 1.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1805.005.0.1				4	25	0.10	1.0	0.05					▲/▲	
R/L105.1805.005.1.1	0.5	0.9	0.65	6	25	0.10	1.0	0.05					▲/▲	
R/L105.1805.005.2.1				8									▲/▲	
R/L105.1805.0.1				4	25	0.10	1.0	0.10		▲/▲	▲/▲	▲/▲		
R/L105.1805.1.1	0.5	0.9	0.65	6	25	0.10	1.0	0.10			▲/▲	▲/▲		
R/L105.1805.2.1				8							▲/▲	▲/▲		
R/L105.1813.005.0.15				6	25	0.15	1.5	0.05					▲/▲	
R/L105.1813.005.1.15	1.3	1.4	1.10	9	25	0.15	1.5	0.05					▲/▲	
R/L105.1813.005.2.15				12	30								▲/▲	
R/L105.1813.01.0.15				6	25	0.15	1.5	0.10					▲/▲	▲/▲
R/L105.1813.01.1.15	1.3	1.4	1.10	9	25	0.15	1.5	0.10					▲/▲	▲/▲
R/L105.1813.01.2.15				12	30								▲/▲	▲/▲

- ▲ 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

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

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

硬质合金牌号
Carbide grades

镗孔和仿形加工 $\geq \text{Ø} 2.0 \text{ mm}$

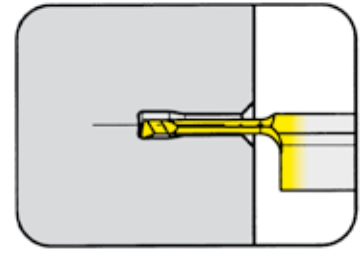
BORING and PROFILING



A

刀片型号
INSERT Type

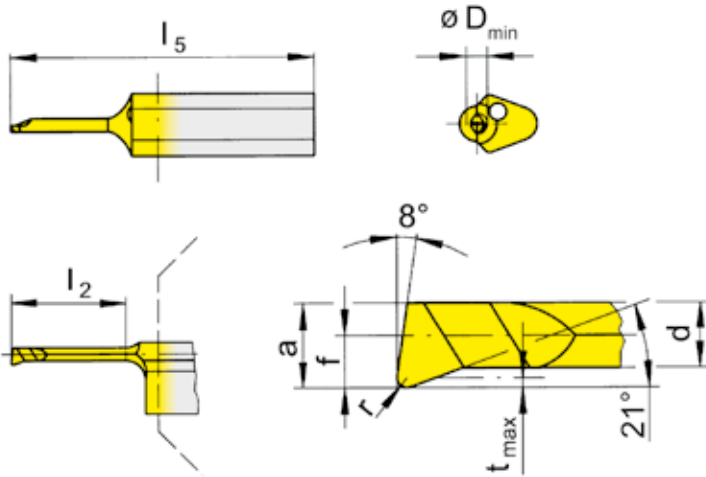
105



孔径最小至 Bore Ø from 2.0 mm

配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35	
R/L105.1809.005.0.2				6	25								▲/▲		
R/L105.1809.005.1.2	1.0	1.9	1.60	9	25	0.15	2.0	0.05					▲/▲		
R/L105.1809.005.2.2				12	30								▲/▲		
R/L105.1809.01.0.2				6	25								▲/▲	▲/▲	
R/L105.1809.01.1.2	1.0	1.9	1.60	9	25	0.15	2.0	0.10					▲/▲	▲/▲	
R/L105.1809.01.2.2				12	30								▲/▲	▲/▲	
R/L105.1809.0.2				6	25					▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1809.1.2	1.0	1.9	1.60	9	25	0.15	2.0	0.15		▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1809.2.2				12	30					▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1813.005.0.25				6	25									▲/▲	
R/L105.1813.005.1.25				9	25								▲/▲		
R/L105.1813.005.2.25	1.3	2.3	1.95	12	30	0.15	2.5	0.05					▲/▲	▲/	
R/L105.1813.005.3.25				16	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	●	●	●	●	●

硬质合金牌号
Carbide grades

单位 : mm

Dimensions in mm

注明R或L型

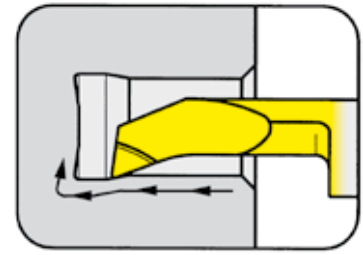
State R or L version

按需提供更多尺寸

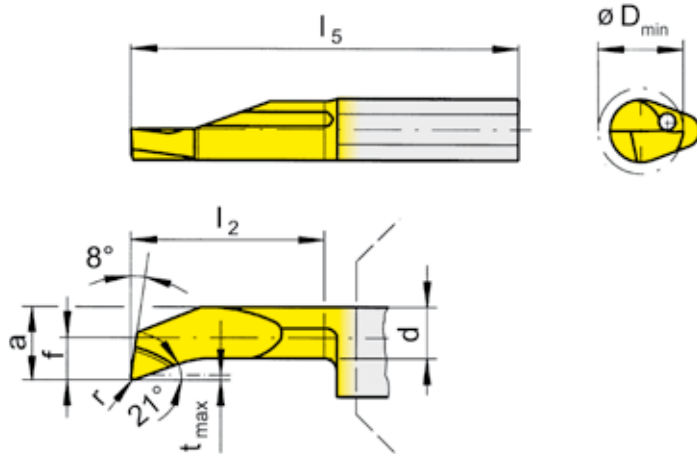
Further sizes upon request

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 3.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r	MG12	TN35	TI25	TF45	TH35
R/L105.1813.005.1.3				10	25							▲/▲	
R/L105.1813.005.2.3	1.3	2.6	2.3	15	30	0.15	3	0.05				▲/▲	
R/L105.1813.005.3.3				20	35							▲/▲	
R/L105.1813.01.1.3				10	25							▲/▲	▲/▲
R/L105.1813.01.2.3	1.3	2.6	2.3	15	30	0.15	3	0.10				▲/▲	▲/▲
R/L105.1813.01.3.3				20	35							▲/▲	▲/▲
R/L105.1813.1.3				10	25				▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1813.2.3	1.3	2.6	2.3	15	30	0.15	3	0.20	▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1813.3.3				20	35				▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1819.005.1.4				10	25							▲/▲	
R/L105.1819.005.2.4	1.9	3.7	2.9	15	30	0.30	4	0.05				▲/▲	
R/L105.1819.005.3.4				20	35							▲/▲	
R/L105.1819.1.4				10	25				▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1819.2.4	1.9	3.7	2.9	15	30	0.30	4	0.20	▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1819.3.4				20	35				▲/▲	▲/▲	▲/▲		▲/▲

- ▲ 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

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

镗孔和仿形加工 $\geq \text{Ø} 5.0 \text{ mm}$

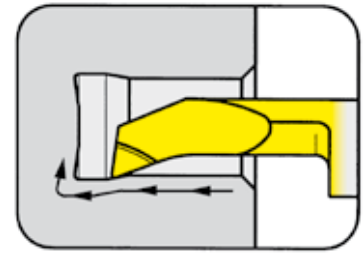
BORING and PROFILING



A

刀片型号
INSERT Type

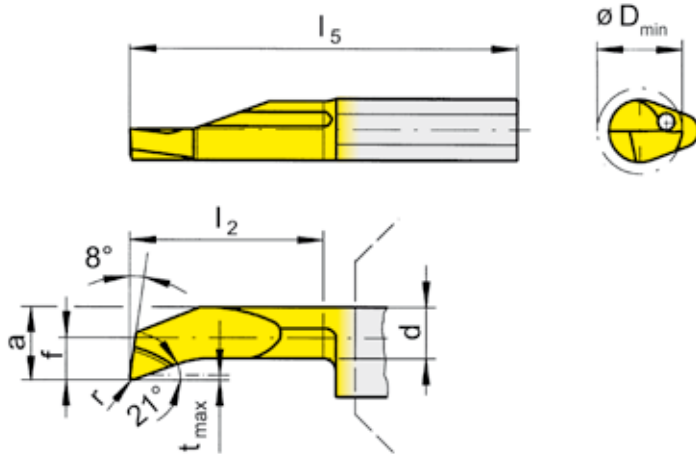
105



孔径最小至 Bore Ø from 5.0 mm

配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1823.005.1.5				10	25								▲/▲	
R/L105.1823.005.2.5				15	30								▲/▲	
R/L105.1823.005.3.5	2.3	4.7	4	20	35	0.5	5	0.05					▲/▲	
R/L105.1823.005.4.5				25	40								▲/▲	
R/L105.1823.005.5.5				30	45								▲/▲	
R/L105.1823.1.5				10	25					▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1823.2.5				15	30					▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1823.3.5	2.3	4.7	4	20	35	0.5	5	0.20		▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1823.4.5				25	40					▲/▲	▲/▲	▲/▲		▲/▲
R/L105.1823.5.5				30	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
MG12	○	●	●	●	●	●
TN35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TF45	●	●	●	●	●	●
TH35	●	●	●	●	●	●

硬质合金牌号
Carbide grades

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

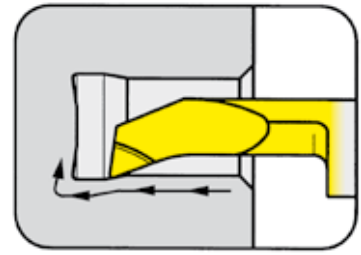
A 镗孔和仿形加工 $\geq \text{Ø} 6.0 \text{ mm}$

BORING and PROFILING

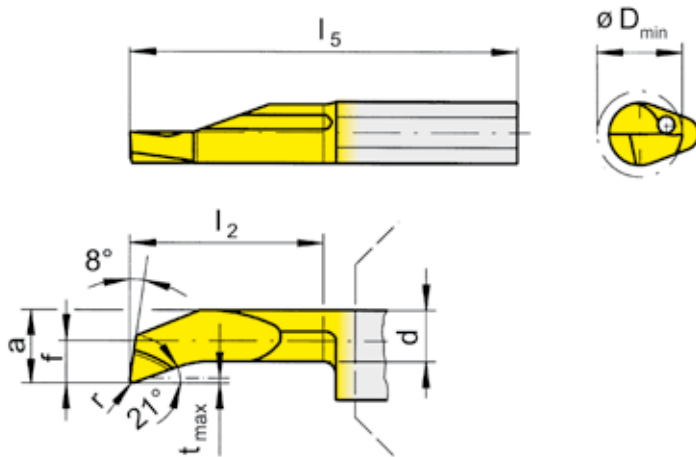


刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 6.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1833.005.2.6	3.3	5.7	4.7	15	30	0.5	6.0	0.05					▲/▲	
R/L105.1833.005.3.6				20	35							▲/▲		
R/L105.1833.005.4.6				25	40							▲/▲		
R/L105.1833.005.5.6				30	45							▲/▲		
R/L105.1833.2.6	3.3	5.7	4.7	15	30	0.5	6.0	0.20	▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1833.3.6				20	35				▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1833.4.6				25	40				▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1833.5.6				30	45				▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1840.005.3.7	4.0	6.4	5.2	20	35	0.5	6.8	0.05					▲/▲	
R/L105.1840.005.4.7				25	40							▲/▲		
R/L105.1840.005.5.7				30	45							▲/▲		
R/L105.1840.3.7	4.0	6.4	5.2	20	35	0.5	6.8	0.20	▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1840.4.7				25	40				▲/▲	▲/▲	▲/▲		▲/▲	
R/L105.1840.5.7				30	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					

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

按需提供更多尺寸
Further sizes upon request

镗孔和仿形加工 $\geq \text{Ø} 4.0 \text{ mm}$

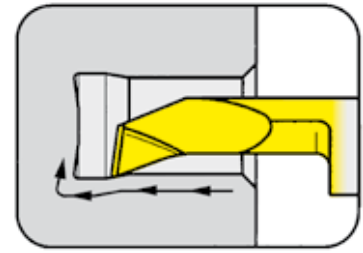
BORING and PROFILING



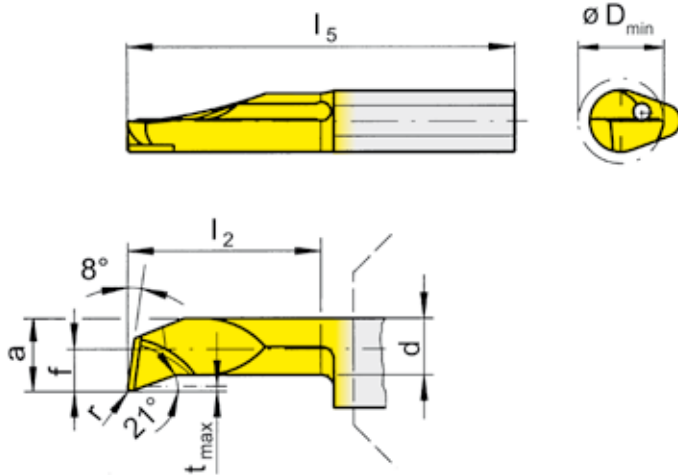
A

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 4.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带断屑槽
(槽型H)
with chip breaker
(geometry H)

产品型号 Part number	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1819.1.H4				10	25								▲/▲	▲/▲
R/L105.1819.2.H4	1.9	3.7	2.9	15	30	0.3	4.0	0.2					▲/▲	▲/▲
R/L105.1819.3.H4				20	35								▲/▲	▲/▲
R/L105.1823.1.H5				10	25								▲/▲	▲/▲
R/L105.1823.2.H5				15	30								▲/▲	▲/▲
R/L105.1823.3.H5	2.3	4.7	4.0	20	35	0.5	5.0	0.2					▲/▲	▲/▲
R/L105.1823.4.H5				25	40								▲/▲	▲/▲
R/L105.1823.5.H5				30	45								▲/▲	▲/▲
R/L105.1833.2.H6				15	30								▲/▲	▲/▲
R/L105.1833.3.H6	3.3	5.7	4.7	20	35	0.5	6.0	0.2					▲/▲	▲/▲
R/L105.1833.4.H6				25	40								▲/▲	▲/▲
R/L105.1833.5.H6				30	45								▲/▲	▲/▲
R/L105.1840.3.H7				20	35								▲/▲	▲/▲
R/L105.1840.4.H7	4.0	6.4	5.2	25	40	0.5	6.8	0.2					▲/▲	▲/▲
R/L105.1840.5.H7				30	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					

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

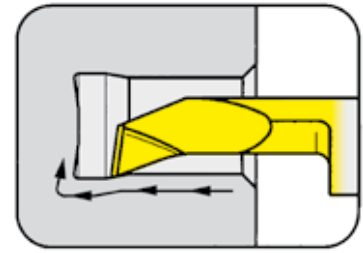
按需提供更多尺寸

Further sizes upon request

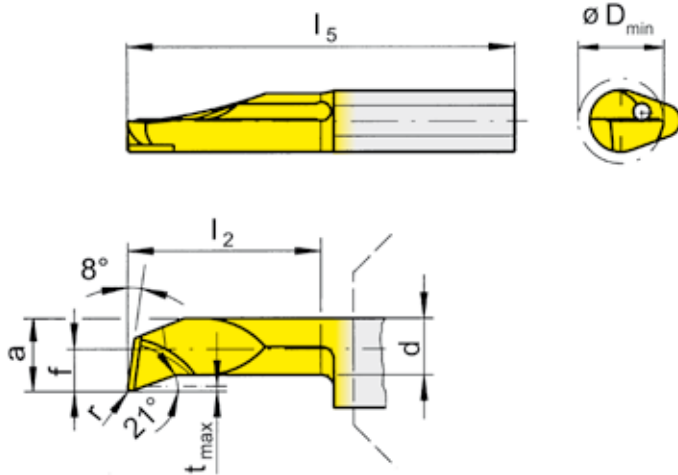
硬质合金牌号
Carbide grades

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 4.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

加长断屑槽
(HV槽型)
extended chip breaker
(geometry HV)

产品型号 Part number	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	Ti25	TF45	TH35
R/L105.1819.1.HV4				10	25									▲/△
R/L105.1819.2.HV4	1.9	3.7	2.9	15	30	0.3	4.0	0.2						▲/△
R/L105.1819.3.HV4				20	35									▲/△
R/L105.1823.1.HV5				10	25									▲/▲
R/L105.1823.2.HV5				15	30									▲/▲
R/L105.1823.3.HV5	2.3	4.7	4.0	20	35	0.5	5.0	0.2						▲/▲
R/L105.1823.4.HV5				25	40									▲/△
R/L105.1823.5.HV5				30	45									▲/△
R/L105.1833.2.HV6				15	30									▲/▲
R/L105.1833.3.HV6				20	35									▲/△
R/L105.1833.4.HV6	3.3	5.7	4.7	25	40	0.5	6.0	0.2						▲/△
R/L105.1833.5.HV6				30	45									▲/△
R/L105.1840.2.HV7				15	30									▲/▲
R/L105.1840.3.HV7				20	35									▲/△
R/L105.1840.4.HV7	4.0	6.4	5.2	25	40	0.5	6.8	0.2						▲/△
R/L105.1840.5.HV7				30	45									▲/△

- ▲ 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				

单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

注明R或L型
State R or L version

镗孔和仿形加工 $\geq \text{Ø} 4.0 \text{ mm}$

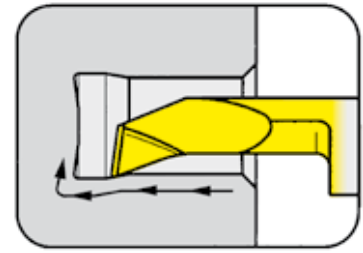
BORING and PROFILING



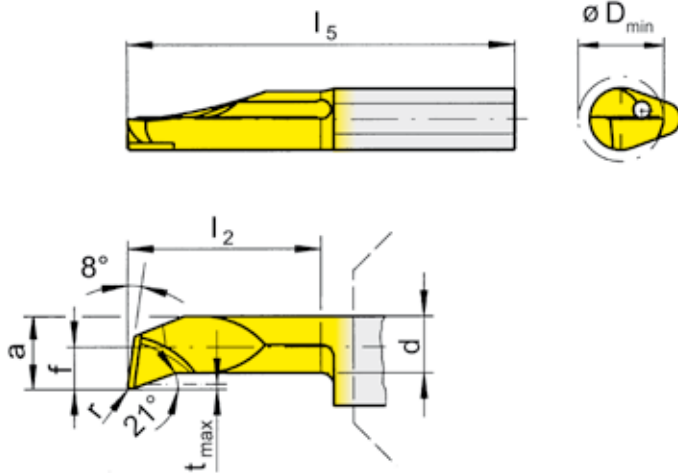
A

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 4.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

加长断屑槽
(HV槽型)
extended chip breaker
(geometry HV)

产品型号 Part number	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1819.04.1.HV4				10	25									▲/▲
R/L105.1819.04.2.HV4	1.9	3.7	2.9	15	30	0.3	4.0	0.4						▲/▲
R/L105.1819.04.3.HV4				20	35									▲/▲
R/L105.1823.04.1.HV5				10	25									▲/▲
R/L105.1823.04.2.HV5				15	30									▲/▲
R/L105.1823.04.3.HV5	2.3	4.7	4.0	20	35	0.5	5.0	0.4						▲/▲
R/L105.1823.04.4.HV5				25	40									▲/▲
R/L105.1823.04.5.HV5				30	45									▲/▲
R/L105.1833.04.2.HV6				15	30									▲/▲
R/L105.1833.04.3.HV6				20	35									▲/▲
R/L105.1833.04.4.HV6	3.3	5.7	4.7	25	40	0.5	6.0	0.4						▲/▲
R/L105.1833.04.5.HV6				30	45									▲/▲
R/L105.1840.04.2.HV7				15	30									▲/▲
R/L105.1840.04.3.HV7				20	35									▲/▲
R/L105.1840.04.4.HV7	4.0	6.4	5.2	25	40	0.5	6.8	0.4						▲/▲
R/L105.1840.04.5.HV7				30	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				

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

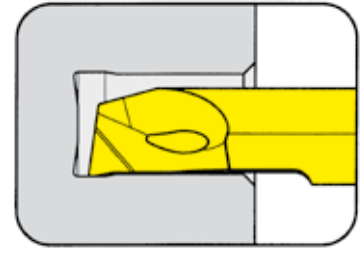
按需提供更多尺寸

Further sizes upon request

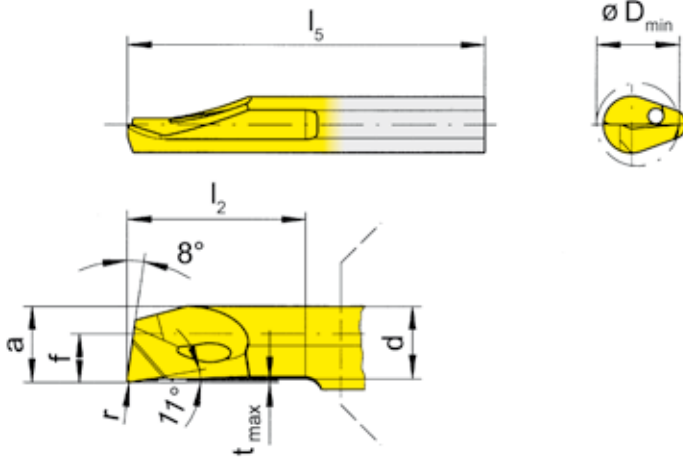
硬质合金牌号
Carbide grades

刀片型号
INSERT Type

105
加强型
reinforced version



孔径最小至 Bore Ø from 4.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1019.005.1.4	1.5	3.7	3.4	10	25	0.15	4	0.05						▲/▲
R/L105.1019.005.2.4				15	30								▲/▲	
R/L105.1019.005.3.4				20	35								▲/▲	
R/L105.1019.005.4.4				25	40								▲/▲	
R/L105.1019.1.4	1.5	3.7	3.4	10	25	0.15	4	0.20						▲/▲
R/L105.1019.2.4				15	30								▲/▲	
R/L105.1019.3.4				20	35								▲/▲	
R/L105.1019.4.4				25	40								▲/▲	

- ▲ 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

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

镗孔和仿形加工 $\geq \text{Ø} 5.0 \text{ mm}$

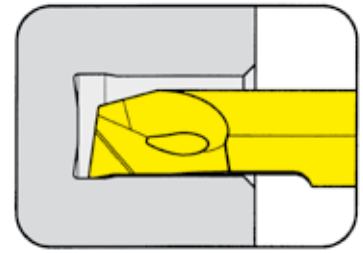
BORING and PROFILING



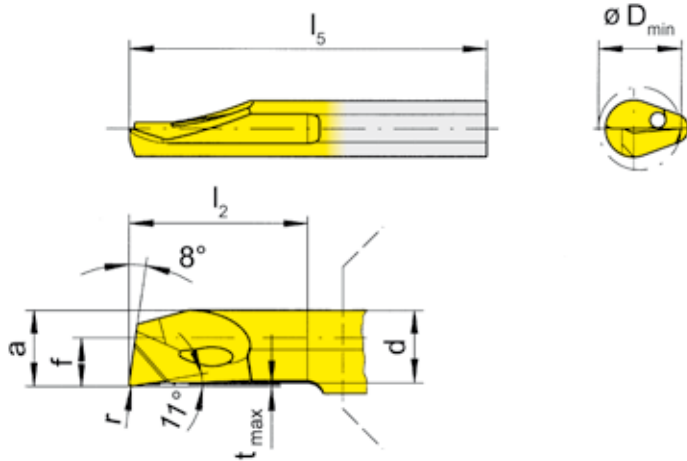
A

刀片型号
INSERT Type

105
加强型
reinforced version



孔径最小至 Bore Ø from 5.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1023.005.1.5				10	25									▲/▲
R/L105.1023.005.2.5				15	30									▲/▲
R/L105.1023.005.3.5	2.8	4.7	4.4	20	35	0.15	5	0.05						▲/▲
R/L105.1023.005.4.5				25	40									▲/▲
R/L105.1023.005.5.5				30	45									▲/▲
R/L105.1023.005.6.5				35	50									▲/▲
R/L105.1023.1.5				10	25									▲/▲
R/L105.1023.2.5				15	30									▲/▲
R/L105.1023.3.5	2.8	4.7	4.4	20	35	0.15	5	0.20						▲/▲
R/L105.1023.4.5				25	40									▲/▲
R/L105.1023.5.5				30	45									▲/▲
R/L105.1023.6.5				35	50									▲/▲
▲ 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														●
														●
														●
														●

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

硬质合金牌号
Carbide grades

镗孔和仿形加工 $\geq \text{Ø} 6.0 \text{ mm}$

BORING and PROFILING

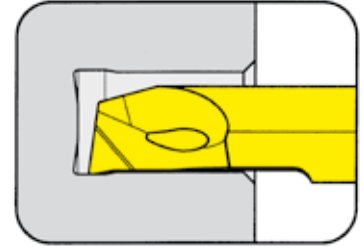


刀片型号

INSERT Type

105

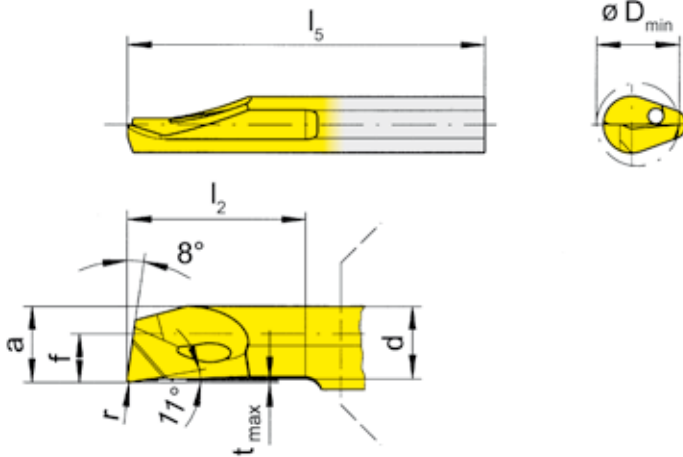
加强型
reinforced version



孔径最小至

Bore Ø from

6.0 mm



配合刀杆

for use with Toolholder

型号

B105

Type

BKT105

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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1033.005.1.6				10	25									▲/▲
R/L105.1033.005.2.6				15	30									▲/▲
R/L105.1033.005.3.6	3.3	5.7	5.4	20	35	0.15	6	0.05						▲/▲
R/L105.1033.005.4.6				25	40									▲/▲
R/L105.1033.005.5.6				30	45									▲/▲
R/L105.1033.005.6.6				35	50									▲/▲
R/L105.1033.1.6				10	25									▲/▲
R/L105.1033.2.6				15	30									▲/▲
R/L105.1033.3.6	3.3	5.7	5.4	20	35	0.15	6	0.20						▲/▲
R/L105.1033.4.6				25	40									▲/▲
R/L105.1033.5.6				30	45									▲/▲
R/L105.1033.6.6				35	50									▲/▲
▲ 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														●
														●
														●
														●
														●

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

硬质合金牌号

Carbide grades

镗孔和仿形加工 $\geq \text{Ø} 6.8 \text{ mm}$

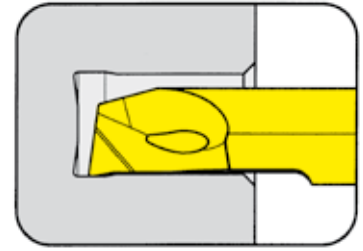
BORING and PROFILING



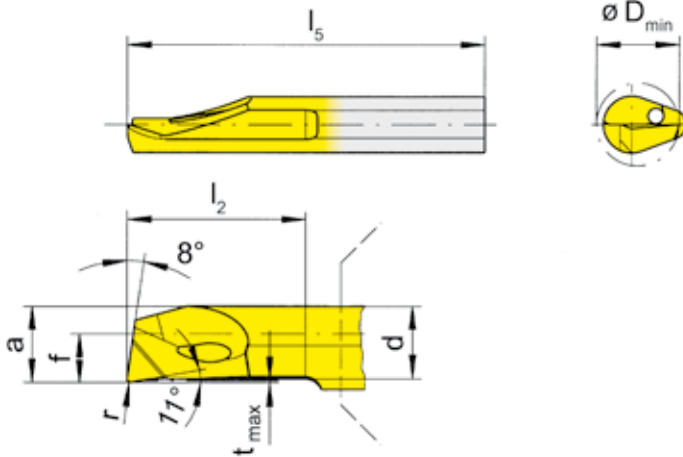
A

刀片型号
INSERT Type

105
加强型
reinforced version



孔径最小至 Bore Ø from 6.8 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.1040.1.7				10	25									▲/▲
R/L105.1040.2.7				15	30									▲/▲
R/L105.1040.3.7	4	6.4	6.1	20	35	0.15	6.8	0.2						▲/▲
R/L105.1040.4.7				25	40									▲/▲
R/L105.1040.5.7				30	45									▲/▲
R/L105.1040.6.7				35	50									▲/▲
▲ 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				•

单位 : mm
Dimensions in mm

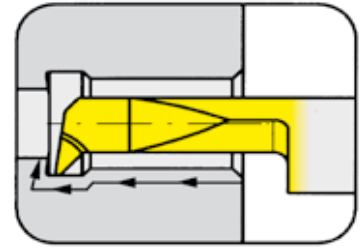
注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

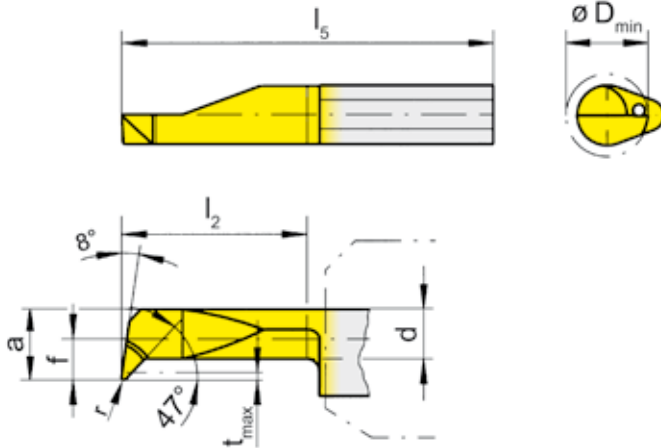
硬质合金牌号
Carbide grades

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 4.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.4719.1.4 R/L105.4719.3.4	1.9	3.7	2.9	10 20	25 35	0.6	4	0.15			▲/▲	▲/▲		▲/▲
R/L105.4723.2.5 R/L105.4723.4.5	2.3	4.7	3.7	15 25	30 40	0.8	5	0.15			▲/▲	▲/▲		▲/▲
R/L105.4733.3.6 R/L105.4733.5.6	3.3	5.7	3.7	20 30	35 45	1.8	6	0.15			▲/▲			▲/▲
▲ 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				

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

硬质合金牌号
Carbide grades

镗孔和仿形加工 $\geq \text{Ø} 3.0 \text{ mm}$

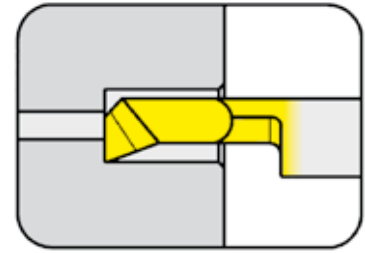
BORING and PROFILING



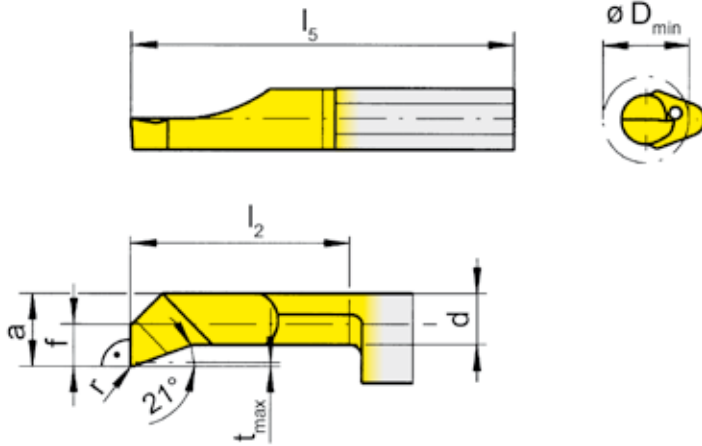
A

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 3.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l ₂	l ₅	t _{max}	D _{min}	r		MG12	TN35	TI25	TF45	TH35
R/L105.9013.01.1.3				10	25									▲/△
R/L105.9013.01.2.3	1.3	2.6	2.3	15	30	0.15	3	0.1						▲/△
R/L105.9013.01.3.3				20	35									
R/L105.9013.1.3	1.3	2.6	2.3	10	25	0.15	3	0.2		▲/▲				
R/L105.9013.2.3				15	30					▲/▲				
R/L105.9019.01.1.4				10	25									▲/△
R/L105.9019.01.2.4	1.9	3.7	2.9	15	30	0.30	4	0.1						▲/△
R/L105.9019.01.3.4				20	35									▲/△
R/L105.9019.1.4	1.9	3.7	2.9	10	25	0.30	4	0.2		▲/▲				
R/L105.9019.2.4				15	30					▲/▲				
▲ 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				

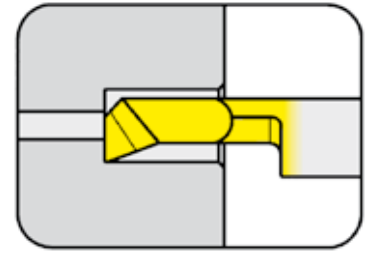
单位 : mm
Dimensions in mm

注明R或L型
State R or L version

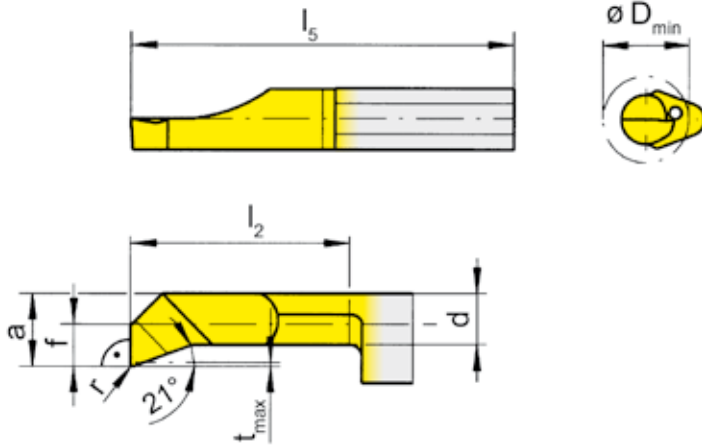
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

刀片型号 **105**
INSERT Type



孔径最小至 Bore Ø from **5.0 mm**



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l ₂	l ₅	t _{max}	D _{min}	r	MG12	TN35	TI25	TH35
R/L105.9023.01.1.5	2.3	4.7	4.0	10	25	0.5	5	0.1				▲/△
R/L105.9023.01.2.5				15	30							▲/△
R/L105.9023.01.3.5				20	35							▲/△
R/L105.9023.01.4.5				25	40							▲/
R/L105.9023.1.5	2.3	4.7	4.0	10	25	0.5	5	0.2				▲/
R/L105.9023.2.5				15	30							▲/▲
R/L105.9023.3.5				20	35							▲/▲
R/L105.9033.1.6	3.3	5.7	4.7	10	25	0.5	6	0.2				△/
R/L105.9033.2.6				15	30							△/△
R/L105.9033.3.6				20	35							▲/△
R/L105.9033.4.6				25	40							△/△
R/L105.9033.5.6				30	45							△/△

- ▲ 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			

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

按需提供更多尺寸
Further sizes upon request

镗孔，仿形加工和倒角

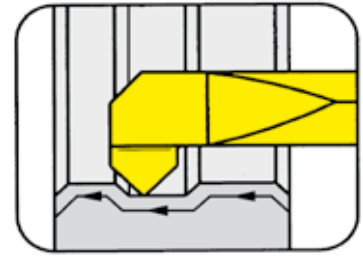
BORING, PROFILING and CHAMFERING



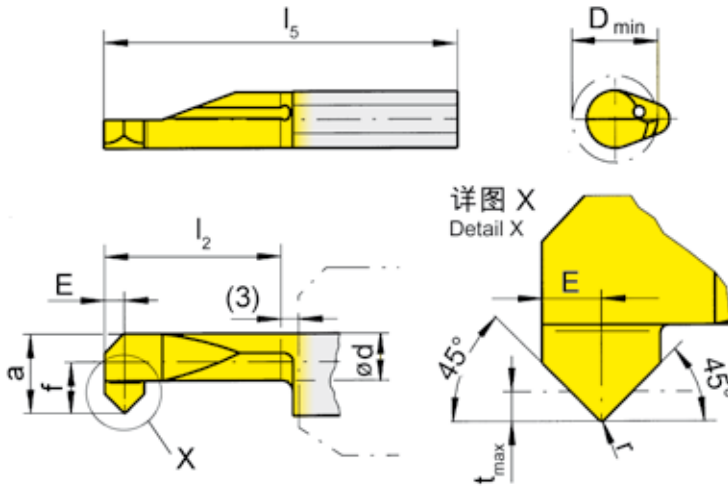
A

刀片型号
INSERT Type

105



孔径最小至 Bore Ø from 5.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	E	f	a	d	l_2	l_5	t_{max}	D_{min}	r	MG12	TN35	TI25	TF45	TH35
R/L105.4545.2.5	1	2.3	4.7	3.5	15	30	0.7	5	0.2		▲/▲			
R/L105.4545.3.7	1	4.0	6.4	4.7	20	35	0.7	7	0.2		▲/▲			
▲ 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				

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

硬质合金牌号
Carbide grades

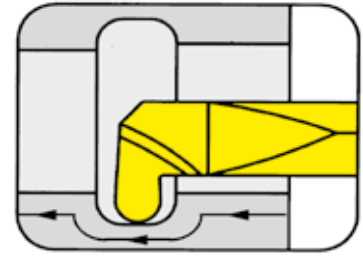
切槽 (内圆) $\geq \varnothing 4.0$ mm

GROOVING (internal)

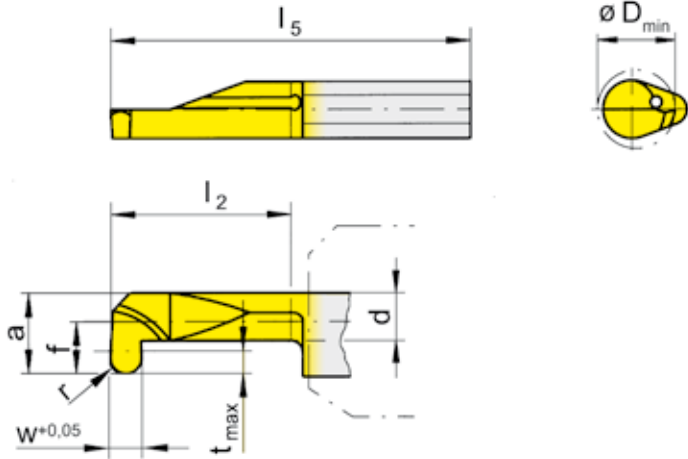


刀片型号
INSERT Type

105



孔径最小至
圆头 Bore \varnothing from 4.0 mm
Full radius r 0.5 - 1.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r	MG12	TN35	TI25	TF45	TH35
R/L105.0005.2.4	1.0	1.9	3.7	2.7	15	30	0.8	4.0	0.50		▲/▲			
R/L105.0005.3.5	1.0								0.50		▲/▲			
R/L105.0007.3.5	1.5	2.3	4.7	3.5	20	35	1.0	5.0	0.75		▲/▲			
R/L105.0010.3.5	2.0								1.00		▲/▲			
R/L105.0005.4.6	1.0								0.50		▲/▲			
R/L105.0007.4.6	1.5	3.3	5.7	3.7	25	40	1.8	6.0	0.75		▲/▲			
R/L105.0010.4.6	2.0								1.00		▲/▲			
R/L105.0005.5.7	1.0								0.50		▲/▲			
R/L105.0007.5.7	1.5	4.0	6.4	3.7	30	45	2.5	6.8	0.75		▲/▲			
R/L105.0010.5.7	2.0								1.00		▲/▲			
										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

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

硬质合金牌号
Carbide grades

切槽 (内圆) $\geq \varnothing 2.0 \text{ mm}$

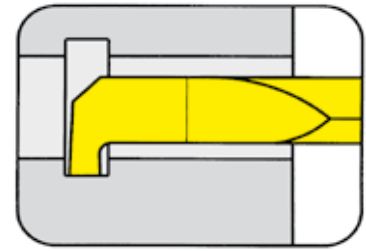
GROOVING (internal)



A

刀片型号
INSERT Type

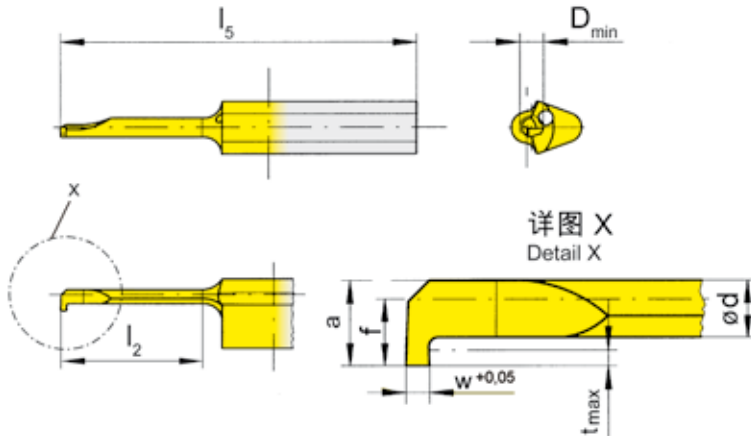
105



孔径最小至	Bore \varnothing from	2.0 mm
槽深可达	Depth of groove up to	0.4 mm

配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l ₂	l ₅	t _{max}	D _{min}		MG12	TN35	TI25	TF45	TH35
R/L105.0050.0.2					6	25						▲/▲		
R/L105.0050.1.2	0.5	1.4	1.8	1.2	9	25	0.4	2				▲/▲		
R/L105.0050.2.2					12	30						▲/▲		
▲ 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				

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

硬质合金牌号

Carbide grades

切槽 (内圆) $\geq \text{Ø} 3.0 \text{ mm}$

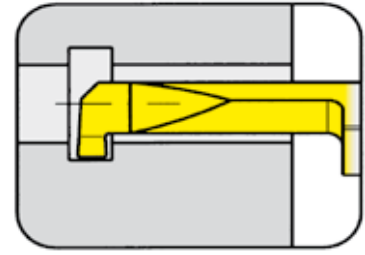
GROOVING (internal)



刀片型号

INSERT Type

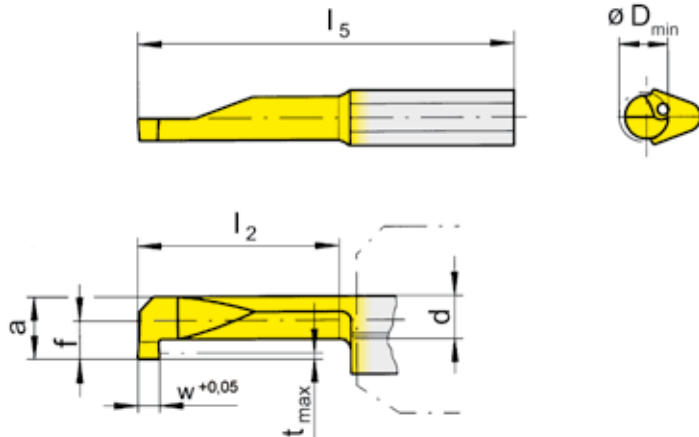
105



孔径最小至
槽深可达

Bore Ø from
Depth of groove up to

3.0 mm
0.6 mm



配合刀杆

for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{\max}	D_{\min}		MG12	TN35	TI25	TF45	TH35
R/L105.0070.1.3					8	25						▲/▲		
R/L105.0070.2.3	0.7	1.4	2.7	1.9	12	30	0.6	3				▲/▲		
R/L105.0070.3.3					16	35						▲/▲		
▲ 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				

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

硬质合金牌号

Carbide grades

切槽 (内圆) $\geq \varnothing 4.0 \text{ mm}$

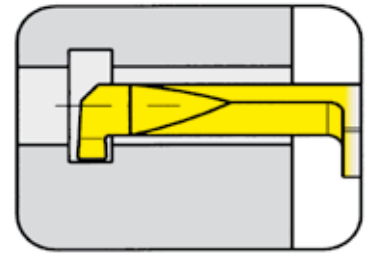
GROOVING (internal)



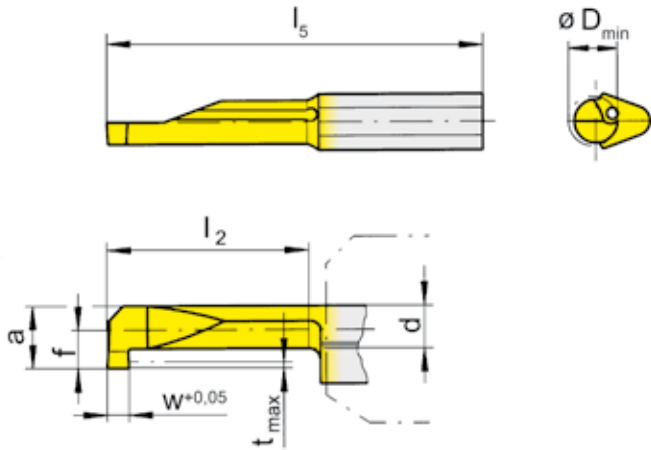
A

刀片型号
INSERT Type

105



孔径最小至 槽深可达	Bore \varnothing from Depth of groove up to	4.0 mm 0.8 mm
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	MG12	TN35	TI25	TF45	TH35	
R/L105.0100.1.4					10	25			▲/▲	▲/▲				
R/L105.0100.2.4	1	1.9	3.7	2.7	15	30	0.8	4	▲/▲	▲/▲				
R/L105.0100.3.4					20	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				

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

硬质合金牌号

Carbide grades

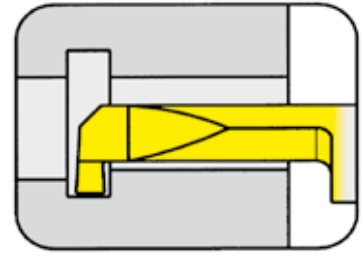
切槽 (内圆) $\geq \varnothing 5.0$ mm

GROOVING (internal)



刀片型号
INSERT Type

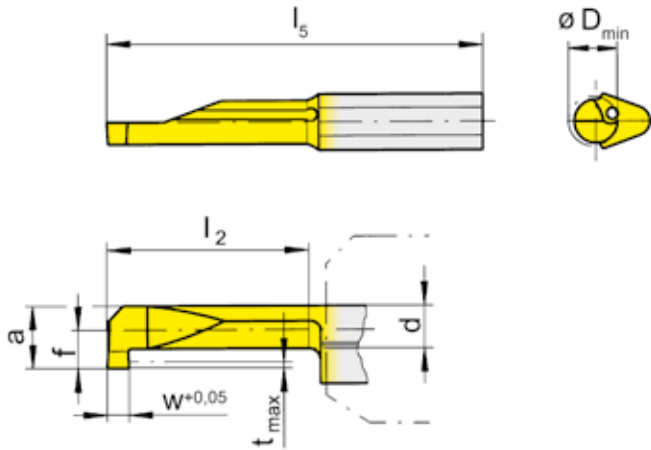
105



孔径最小至
槽深可达

Bore \varnothing from
Depth of groove up to

5.0 mm
1.0 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}		MG12	TN35	TI25	TF45	TH35
R/L105.0100.1.5	1.0									▲/▲	▲/▲			▲/▲
R/L105.0150.1.5	1.5	2.3	4.7	3.5	10	25	1	5		▲/	▲/▲			▲/▲
R/L105.0200.1.5	2.0									▲/▲	▲/▲			▲/▲
R/L105.0100.2.5	1.0									▲/▲	▲/▲			▲/▲
R/L105.0150.2.5	1.5	2.3	4.7	3.5	15	30	1	5		▲/▲	▲/▲			▲/▲
R/L105.0200.2.5	2.0									▲/▲	▲/▲			▲/▲
R/L105.0100.3.5	1.0									▲/▲	▲/▲			▲/▲
R/L105.0150.3.5	1.5	2.3	4.7	3.5	20	35	1	5		▲/▲	▲/▲			▲/▲
R/L105.0200.3.5	2.0									▲/	▲/▲			▲/▲
R/L105.0100.4.5	1.0										▲/▲			▲/▲
R/L105.0150.4.5	1.5	2.3	4.7	3.5	25	40	1	5			▲/▲			▲/▲
R/L105.0200.4.5	2.0										▲/▲			▲/▲
R/L105.0100.5.5	1.0										▲/▲			▲/▲
R/L105.0150.5.5	1.5	2.3	4.7	3.5	30	45	1	5			▲/▲			▲/▲
R/L105.0200.5.5	2.0										▲/▲			▲/▲
▲ 库存 / on stock ▲ 4周 / 4 weeks										P	o	•		•
• 主要应用 / main recommendation										M	•	•		•
o 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				

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

硬质合金牌号
Carbide grades

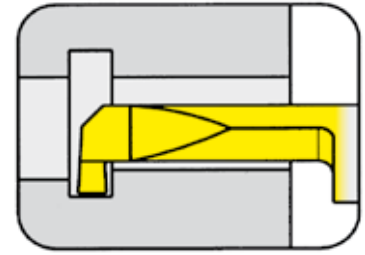
切槽 (内圆) $\geq \varnothing 6.0 \text{ mm}$ GROOVING (internal)



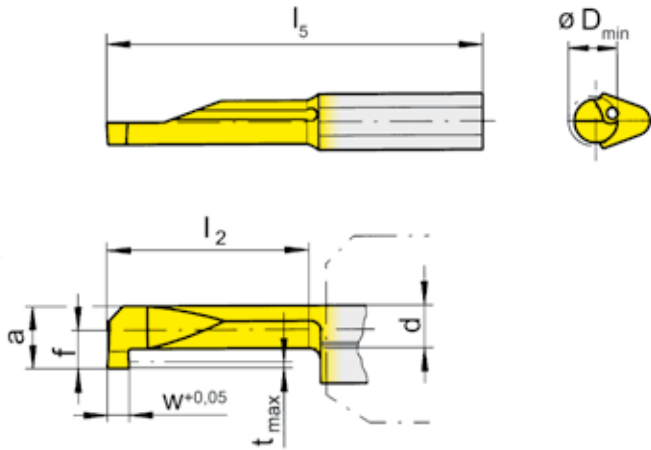
A

刀片 型号
INSERT Type

105



孔径最小至 槽深可达	Bore \varnothing from Depth of groove up to	6.0 mm 1.8 mm
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配合 刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	MG12	TN35	TI25	TF45	TH35
R/L105.0100.1.6	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.1.6	1.5	3.3	5.7	3.7	10	25	1.8	6	▲/▲	▲/▲			▲/▲
R/L105.0200.1.6	2.0								▲/▲	▲/▲			▲/▲
R/L105.0100.2.6	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.2.6	1.5	3.3	5.7	3.7	15	30	1.8	6	▲/▲	▲/▲			▲/▲
R/L105.0200.2.6	2.0								▲/▲	▲/▲			▲/▲
R/L105.0100.3.6	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.3.6	1.5	3.3	5.7	3.7	20	35	1.8	6	▲/▲	▲/▲			▲/▲
R/L105.0200.3.6	2.0								▲/	▲/▲			▲/▲
R/L105.0100.4.6	1.0									▲/▲			▲/▲
R/L105.0150.4.6	1.5	3.3	5.7	3.7	25	40	1.8	6		▲/▲			▲/▲
R/L105.0200.4.6	2.0									▲/▲			▲/▲
R/L105.0100.5.6	1.0									▲/▲			▲/▲
R/L105.0150.5.6	1.5	3.3	5.7	3.7	30	45	1.8	6		▲/▲			▲/▲
R/L105.0200.5.6	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

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

硬质合金牌号
Carbide grades

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

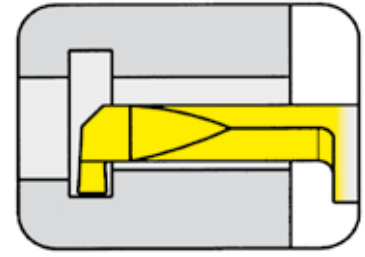
切槽 (内圆) $\geq \text{Ø} 6.8 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

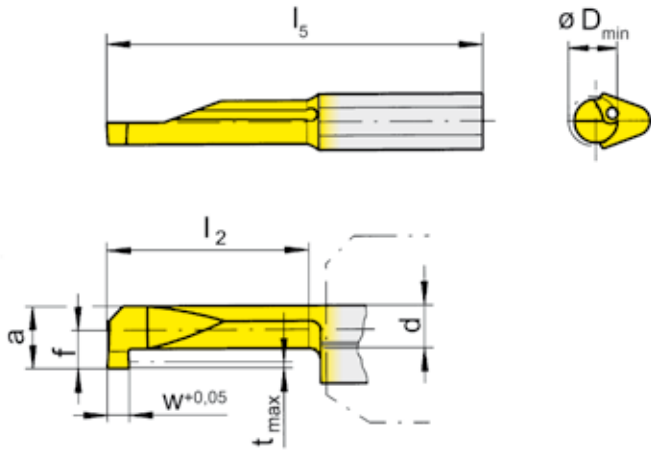
105



孔径最小至
槽深可达

Bore Ø from
Depth of groove up to

6.8 mm
2.5 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
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	f	a	d	l_2	l_5	t_{max}	D_{min}	MG12	TN35	Ti25	TF45	TH35
R/L105.0100.1.7	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.1.7	1.5	4	6.4	3.7	10	25	2.5	6.8	▲/▲	▲/▲			▲/▲
R/L105.0200.1.7	2.0								▲/▲	▲/▲			▲/▲
R/L105.0100.2.7	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.2.7	1.5	4	6.4	3.7	15	30	2.5	6.8	▲/▲	▲/▲			▲/▲
R/L105.0200.2.7	2.0								▲/▲	▲/▲			▲/▲
R/L105.0100.3.7	1.0								▲/▲	▲/▲			▲/▲
R/L105.0150.3.7	1.5	4	6.4	3.7	20	35	2.5	6.8	▲/▲	▲/▲			▲/▲
R/L105.0200.3.7	2.0								▲/▲	▲/▲			▲/▲
R/L105.0100.4.7	1.0									▲/▲			▲/▲
R/L105.0150.4.7	1.5	4	6.4	3.7	25	40	2.5	6.8		▲/▲			▲/▲
R/L105.0200.4.7	2.0									▲/▲			▲/▲
R/L105.0100.5.7	1.0									▲/▲			▲/▲
R/L105.0150.5.7	1.5	4	6.4	3.7	30	45	2.5	6.8		▲/▲			▲/▲
R/L105.0200.5.7	2.0									▲/▲			▲/▲
									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

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

硬质合金牌号
Carbide grades

螺纹切削-非全牙型 (内圆)

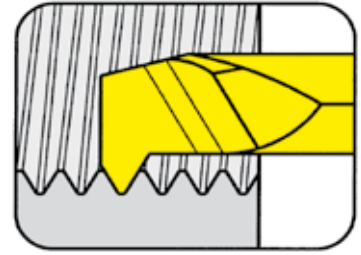
THREADING (internal) Partial profile



A

刀片型号
INSERT Type

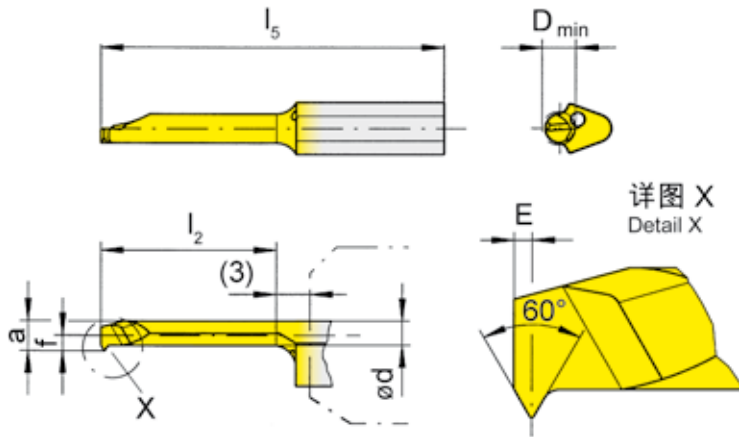
105



孔径最小至 螺距	Bore \varnothing from Pitch	3.00 mm P 0.25 mm
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	l_2	l_5	D_{min}		MG12	TN35	Ti25	TF45	TH35
R/L105.0102.2.3	0.25	0.3	1.4	2.7	2.2	15	30	3			▲/△			
▲ 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				

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

硬质合金牌号
Carbide grades

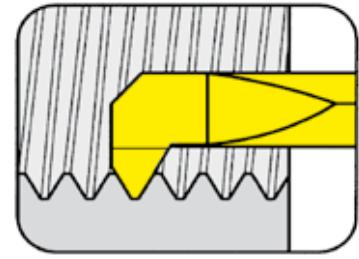
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

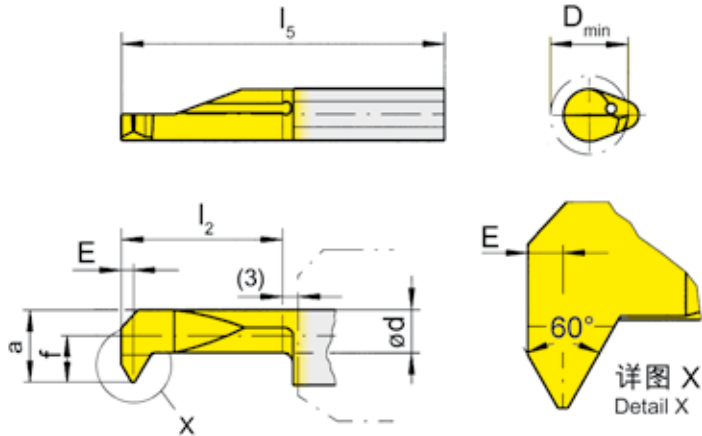
105



孔径最小至
螺距

Bore \varnothing from
Pitch

3.00 mm
P 0.35 mm



配合刀杆
for use with Toolholder

型号
Type

B105
BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	I_2	I_5	D_{min}	MG12	TN35	TI25	TF45	TH35
R/L105.0203.1.3	0.35	0.3	1.4	2.7	2.1	10	25	3		▲/△			
R/L105.0203.2.5	0.35	0.3	2.3	4.7	3.5	15	30	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				

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

硬质合金牌号
Carbide grades

螺纹切削-非全牙型 (内圆)

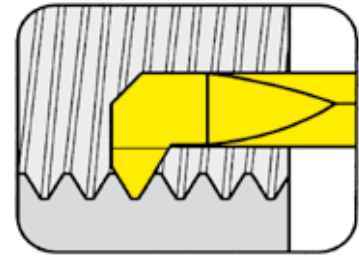
THREADING (internal) Partial profile



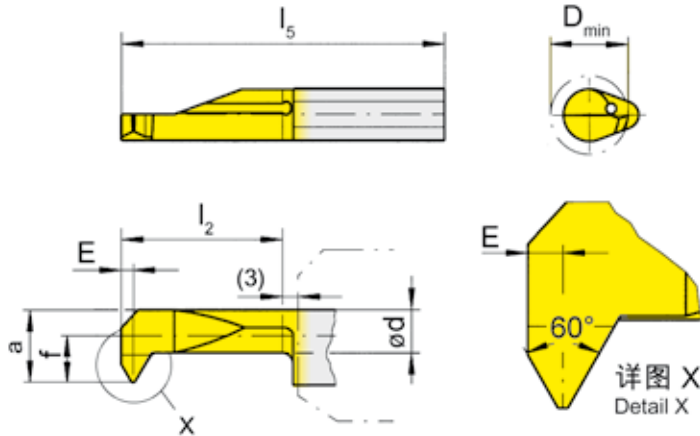
A

刀片型号
INSERT Type

105



孔径最小至 螺距	Bore Ø from Pitch	3.00 mm P 0.50 mm
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	l_2	l_5	D_{min}	MG12	TN35	TI25	TF45	TH35	
R/L105.0205.2.3	0.5	0.35	1.4	2.7	2.1	15	30	3		▲/▲				
R/L105.0205.2.4						15	30			▲/▲			▲/Δ	
R/L105.0205.3.4	0.5	0.35	1.9	3.7	2.7	20	35	4		▲/				
R/L105.0205.2.5						15	30		▲/Δ	▲/▲			▲/▲	
R/L105.0205.3.5	0.5	0.35	2.3	4.7	3.5	20	35	5		▲/Δ				
R/L105.0205.4.5						25	40			▲/				
R/L105.0205.3.6	0.5	0.35	3.3	5.7	4.8	20	35	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				

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

硬质合金牌号
Carbide grades

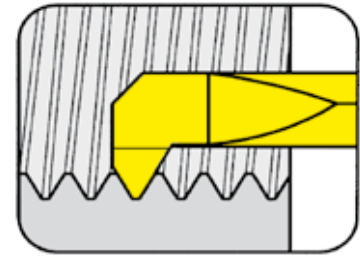
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile

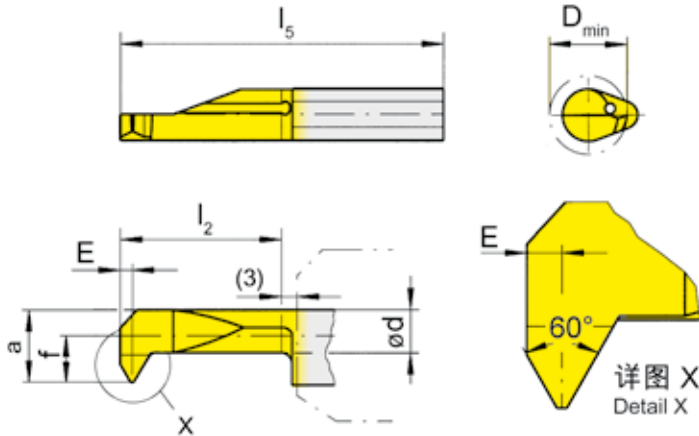


刀片型号
INSERT Type

105



孔径最小至
螺距 Bore Ø from Pitch 3.00 mm
P 0.50 - 0.75 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	l ₂	l ₅	D _{min}		MG12	TN35	TI25	TF45	TH35
R/L105.0407.2.3	0.5	0.75	0.45	1.4	2.7	2.0	15	30	3			▲/			
R/L105.0407.1.4							10	25				▲/▲			
R/L105.0407.2.4	0.5	0.75	0.45	1.9	3.7	2.7	15	30	4			▲/▲			
R/L105.0407.3.4							20	35				▲/▲			
R/L105.0407.2.5							15	30				▲/▲			▲/▲
R/L105.0407.3.5	0.5	0.75	0.45	2.3	4.7	3.5	20	35	5			▲/▲			
R/L105.0407.4.5							25	40				▲/▲			
R/L105.0407.3.6	0.5	0.75	0.45	3.3	5.7	4.7	20	35	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

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

硬质合金牌号
Carbide grades

螺纹切削-非全牙型 (内圆)

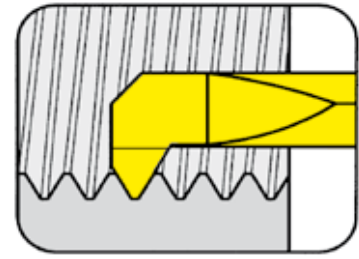
THREADING (internal) Partial profile



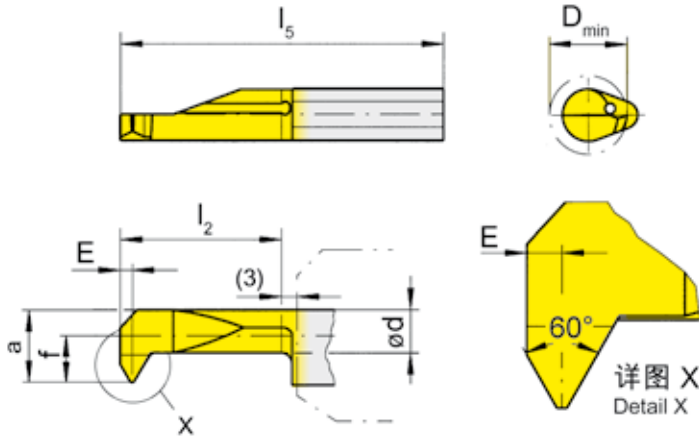
A

刀片型号
INSERT Type

105



孔径最小至 螺距	Bore Ø from Pitch	4.8 mm P 1.0 - 1.5 mm
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	l ₂	l ₅	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L105.0510.2.5	1.00	0.55	2.1	4.5	3.5	15	30	4.8	▲▲	▲/▲			▲/▲
R/L105.0510.3.5									▲/▲				
R/L105.0510.4.5									▲/▲				
R/L105.0510.2.6	1.00	0.55	3.3	5.7	3.7	15	30	6.0		▲/▲			▲/▲
R/L105.0612.2.6									▲/▲				
R/L105.0612.3.6									▲/▲				
R/L105.0612.4.6	1.25	0.65	3.3	5.7	3.7	20	35	6.0	▲/▲	▲/▲			▲/▲
R/L105.0815.2.7									▲/▲				
R/L105.0815.3.7									▲/▲				
R/L105.0815.4.7	1.50	0.75	4.0	6.4	3.7	25	40	7.0	▲/▲	▲/▲			▲/▲
									▲/▲				
									▲/▲				

- ▲ 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

	P	M	K	N	S	H
MG12	○	●	●	●	●	●
TN35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TF45	●	●	●	●	●	●
TH35	●	●	●	●	●	●

硬质合金牌号
Carbide grades

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

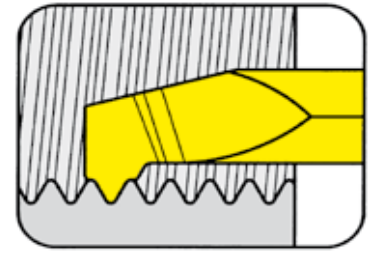
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile

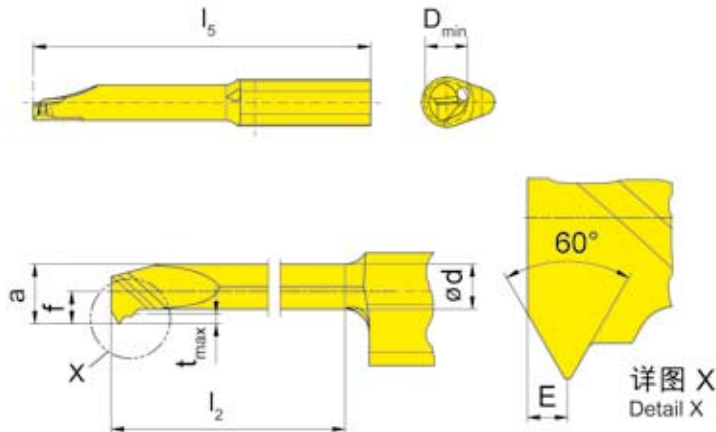


刀片型号
INSERT Type

105



孔径最小至
螺距 Bore Ø from Pitch 2.40 mm
P 0.50 - 1.25 mm



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	l ₂	l ₅	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L105.VPM3.2.3 R/L105.VPM3.4.3	0.50	0.3	1.4	2.2	1.65	9 12	25 35	2.4					▲/△
R/L105.VPM4.2.4 R/L105.VPM4.3.4	0.70	0.4	1.5	2.9	2.10	15 20	30 35	3.2					▲/△
R/L105.VPM5.2.5 R/L105.VPM5.4.5	0.80	0.5	2.0	3.7	2.80	15 25	30 40	4.1					▲/▲
R/L105.VPM6.3.6 R/L105.VPM6.4.6 R/L105.VPM6.5.6	1.00	0.5	2.4	4.5	3.40	20 25 30	35 40 45	4.9					▲/△
R/L105.VPM8.3.8 R/L105.VPM8.5.8	1.25	0.7	3.8	6.2	4.70	20 30	35 45	6.6					▲/▲
									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

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

硬质合金牌号
Carbide grades

螺纹切削-非全牙型 (内圆)

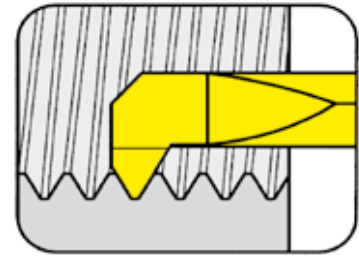
THREADING (internal) Partial profile



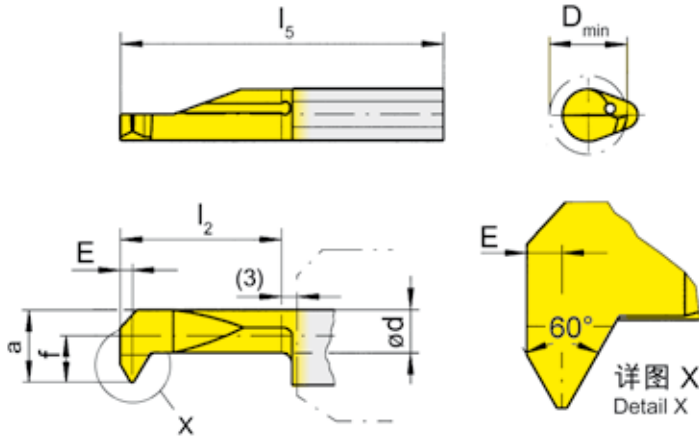
A

刀片型号
INSERT Type

105



孔径最小至 每英寸牙数	Bore Ø from Threads per inch	4.0 mm 16 - 40
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

UN螺纹
Thread UN

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	f	a	d	l ₂	l ₅	D _{min}	MG12	TN35	TI25	TF45	TH35	
R/L105.3240.2.4	32 - 40	0.45	1.9	3.7	2.7	15	30	4		▲/▲				
R/L105.1620.2.5 R/L105.1620.3.5	16 - 20	0.70	2.3	4.7	3.3	15 20	30 35	5					▲/Δ ▲/Δ	
R/L105.2428.2.5 R/L105.3240.2.5	24 - 28 32 - 40	0.55 0.45	2.3	4.7	3.5	15	30	5		▲/▲ ▲/▲				
R/L105.1620.2.6 R/L105.1620.3.6 R/L105.1620.4.6	16 - 20	0.70	3.3	5.7	3.7	15 20 25	30 35 40	6		▲/▲ ▲/ ▲/				
R/L105.2428.2.6 R/L105.2428.3.6 R/L105.2428.4.6	24 - 28	0.55	3.3	5.7	3.7	15 20 25	30 35 40	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				

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

硬质合金牌号
Carbide grades

螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile

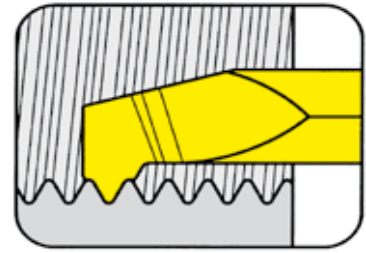


刀片型号

INSERT Type

105

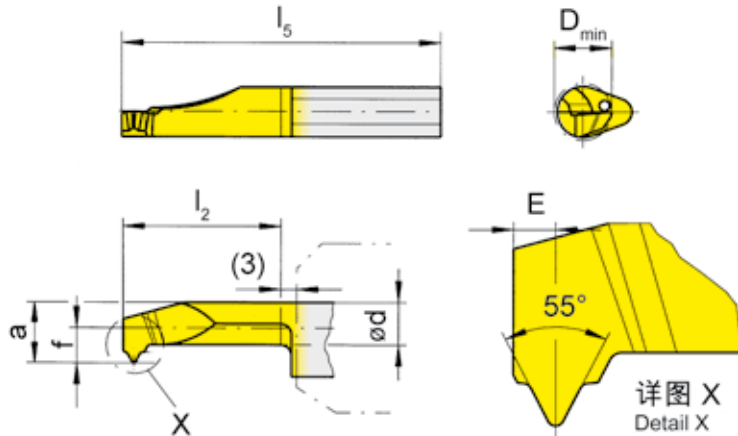
惠氏螺纹
Whitworth thread



孔径最小至
每英寸牙数

Bore \varnothing from
Threads per inch

4.0 mm
20 - 28



配合刀杆

for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图

R = right hand version shown

BSW/BSF螺纹

Thread BSW/BSF

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	f	a	d	l_2	l_5	D_{min}	MG12	TN35	TI25	TF45	TH35	
R105.5520.2.4	20	1.0	1.9	3.7	2.5	15	30	4		▲				
R/L105.5524.2.5	24									△/△				
R/L105.5526.2.5	26	0.8	2.3	4.7	3.5	15	30	5		▲/△				
R/L105.5528.2.5	28									▲/△				
▲ 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				

单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削-全牙型 (内圆)

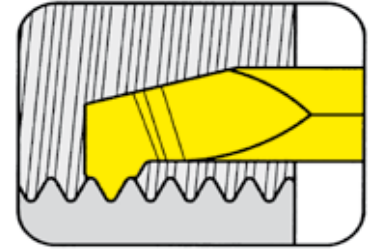
THREADING (internal) Full profile



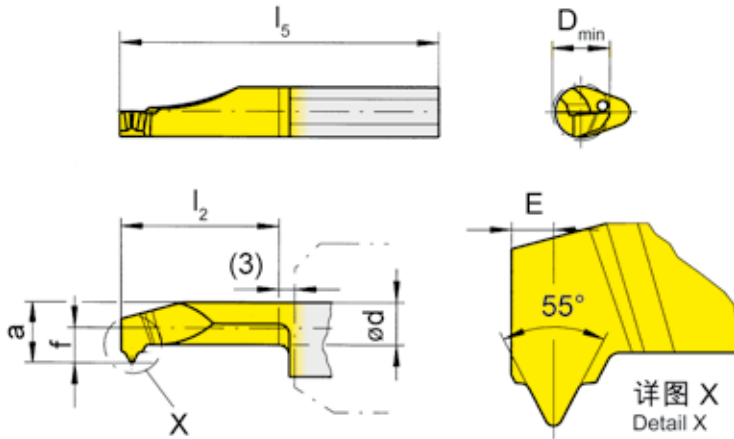
A

刀片型号
INSERT Type

105
惠氏螺纹
Whitworth thread



孔径最小至 每英寸牙数	Bore Ø from Threads per inch	6.0 mm 19 - 28
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配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

BSW/BSF螺纹
Thread BSW/BSF

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	f	a	d	l ₂	l ₅	D _{min}	MG12	TN35	Ti25	TF45	TH35
R/L105.5524.2.6	24	0.8								▲/			
R/L105.5526.2.6	26	0.8								▲/			
R/L105.5528.2.6	28	0.8								▲/▲			
R/L105.5519.2.6	19	1.0	3.3	5.7	3.7	15	30	6		▲/▲			
R/L105.5520.2.6	20	1.0								▲/▲			
R/L105.5522.2.6	22	1.0								▲/▲			
R/L105.5528.3.6	28	0.8								▲/▲			
R105.5524.3.6	24	0.8								▲			
R105.5526.3.6	26	0.8	3.3	5.7	3.7	20	35	6		▲			
R105.5519.3.6	19	1.0								▲			
R105.5522.3.6	22	1.0								▲			

- ▲ 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

P	●			
M	●			
K	●			
N	●			
S	●			
H				

硬质合金牌号
Carbide grades

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

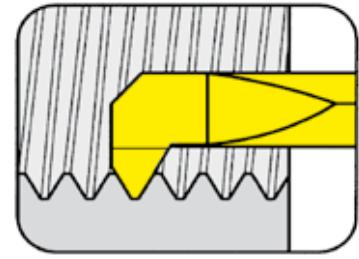
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

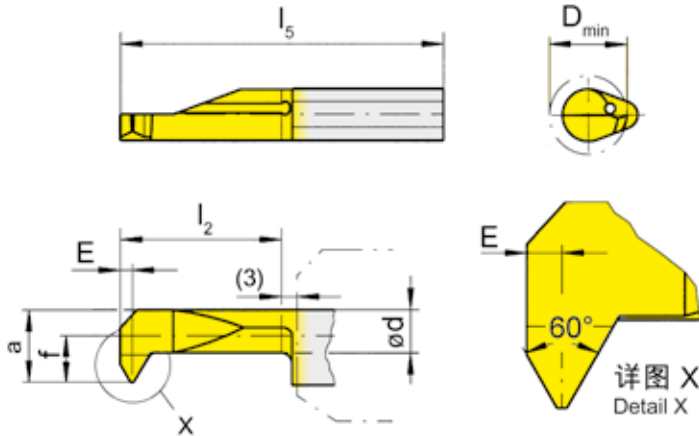
105



孔径最小至
每英寸牙数

Bore \varnothing from
Threads per inch

6.0 mm
18 - 27



配合刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

NPT螺纹
Thread NPT

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	f	a	d	l_2	l_5	D_{min}	MG12	TN35	TI25	TF45	TH35
R/L105.NP18.2.6	18	1.0				15	30	6	/Δ	▲/▲			
R/L105.NP18.3.6	18	1.0				20	35			Δ/Δ			Δ/Δ
R/L105.NP18.4.6	18	1.0				25	40			Δ/Δ			Δ/Δ
R/L105.NP27.2.6	27	0.8	3.3	5.7	3.7	15	30			▲/Δ	/Δ		
R/L105.NP27.3.6	27	0.8				20	35			Δ/Δ	Δ/		Δ/Δ
R/L105.NP27.4.6	27	0.8				25	40			Δ/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

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

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

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

PREGROOVING and CHAMFERING (internal)

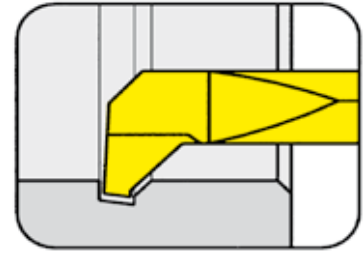


A

刀片型号

INSERT Type

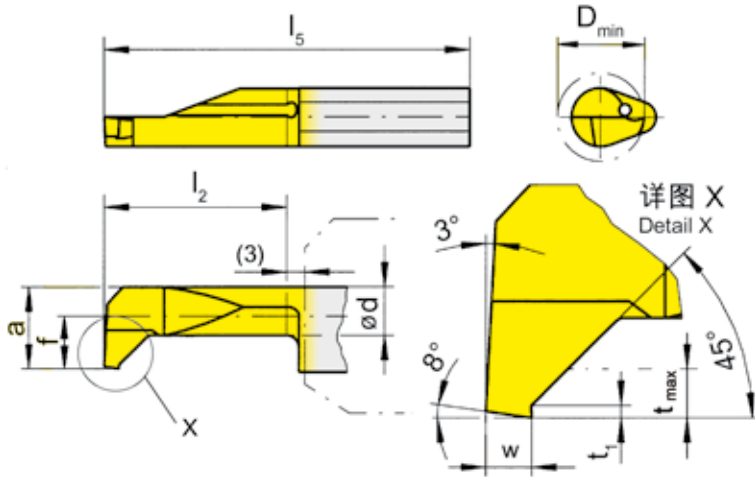
105



孔径最小至

Bore Ø from

3.0 mm



配合刀杆

for use with Toolholder

型号

Type B105
BKT105
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	f	a	d	l ₂	l ₅	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L105.0810.1.3 R/L105.0810.2.3	0.7	1.4	2.7	2.0	10 15	25 30	0.2	0.5	3		▲/▲			
R/L105.0810.1.4 R/L105.0810.2.4 R/L105.0810.3.4	1.0	1.9	3.7	2.7	10 15 20	25 30 35	0.2	0.7	4		▲/▲			
R/L105.0810.2.5 R/L105.0810.3.5 R/L105.0810.4.5 R/L105.0810.5.5	1.0	2.3	4.7	3.5	15 20 25 30	30 35 40 45	0.2	0.7	5	▲/▲	▲/▲	▲/▲		
R/L105.0810.5.6 R/L105.0810.7.6	1.0	3.1	5.5	4.2	30 40	45 55	0.2	1.0	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

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

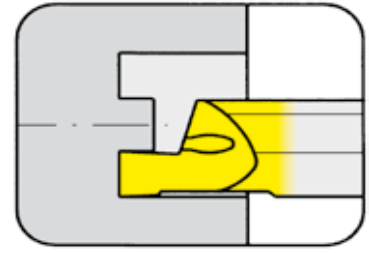
Further sizes upon request

端面切槽

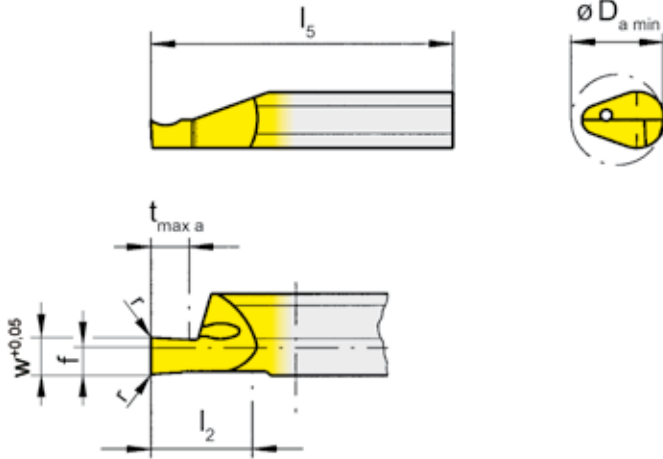
FACE GROOVING

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 BKT105
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}	硬质合金牌号					
								MG12	TN35	TI25	TF45	TH35	
R/L105.0510.1.8	1.0					2	5	▲/△		▲/▲			
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	5	△/△		▲/▲			
R/L105.0515.2.8	1.5	0.05	2	15	35	3	5	△/△		▲/▲			
R/L105.0520.2.8	2.0					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													

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

硬质合金牌号
Carbide grades

端面切槽

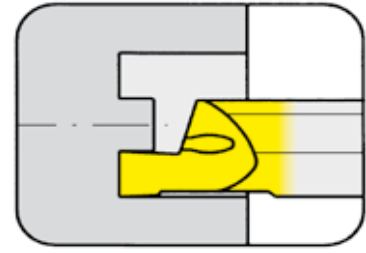
FACE GROOVING



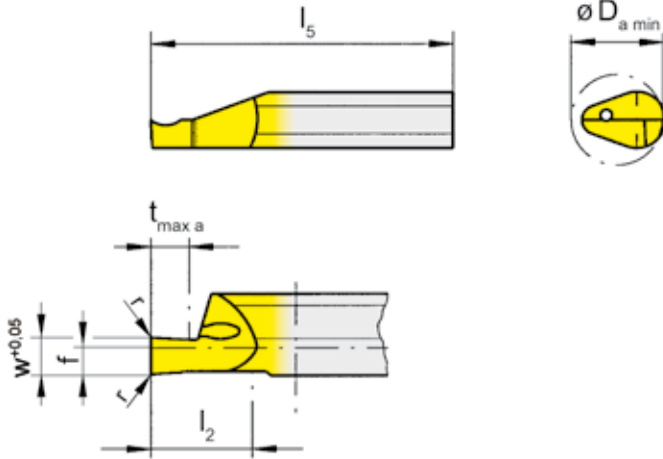
A

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 BKT105
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}	硬质合金牌号					
								MG12	TN35	TI25	TF45	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		▲/△		▲/▲			
								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

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

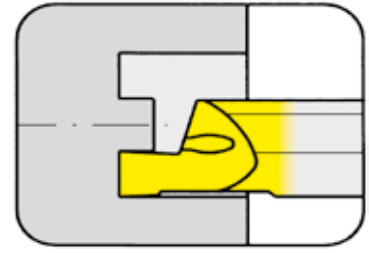
硬质合金牌号
Carbide grades

端面切槽

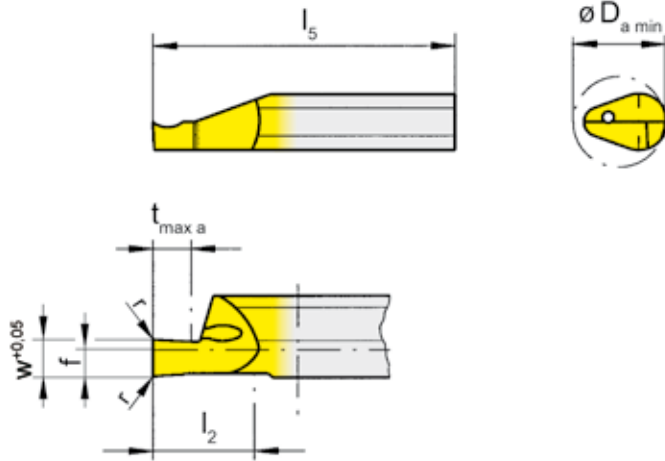
FACE GROOVING

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 BKT105
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	T125	TF45	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				

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

硬质合金牌号
Carbide grades

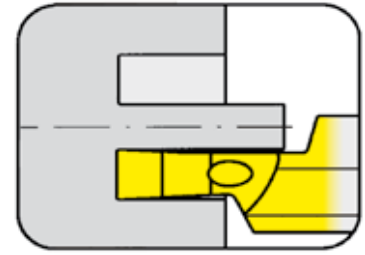
端面切槽 FACE GROOVING



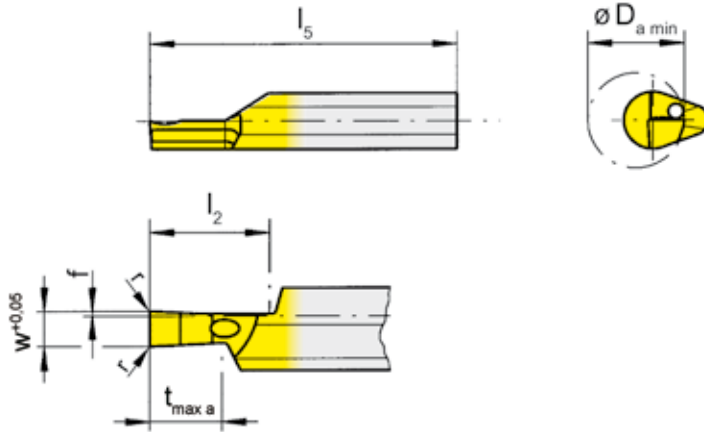
A

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 BKT105
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	TF45	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					▲/▲		
								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

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

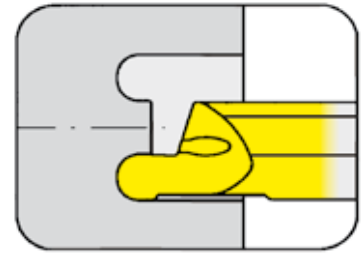
硬质合金牌号
Carbide grades

端面切槽

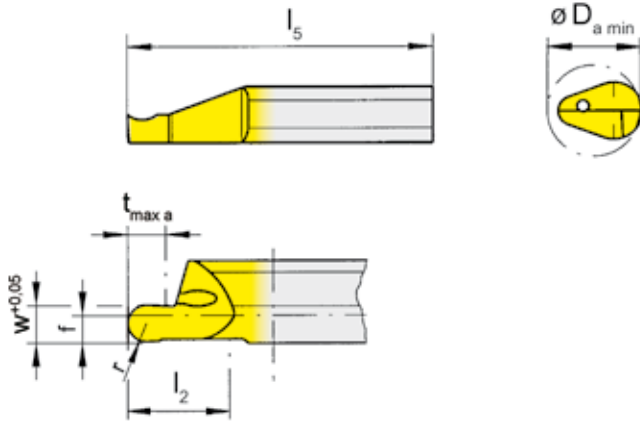
FACE GROOVING

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 BKT105
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	TF45	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									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				

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

硬质合金牌号
Carbide grades

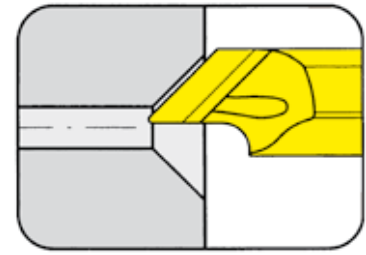
倒角 CHAMFERING



A

刀片型号
INSERT Type

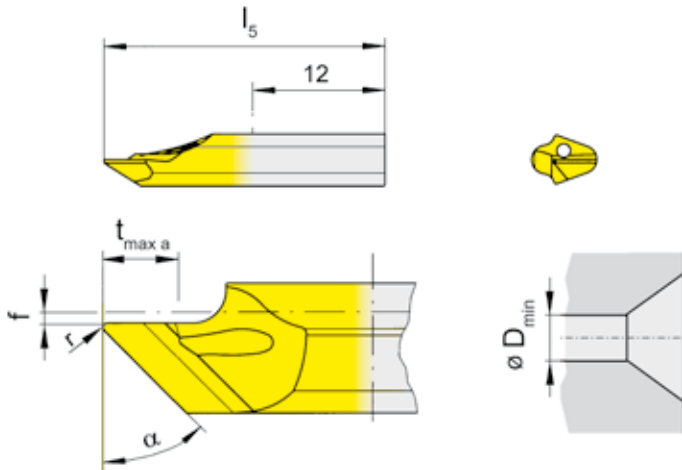
105



倒角角度	Angle of chamfer	45°/ 60°
倒角宽度可达	Width of chamfer up to	4.0 mm

配合 刀杆
for use with Toolholder

型号 B105
Type BKT105
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	r	α	f	l ₅	t _{max a}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L105.0045.0.1 R/L105.0045.1.1	0.2	45°	0.5	20 25	3.5	1		▲/▲		▲/▲	
R/L105.0060.0.1 R/L105.0060.1.1	0.2	60°	0.5	20 25	4.0	1				▲/▲	▲/▲
▲ 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				

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

硬质合金牌号
Carbide grades

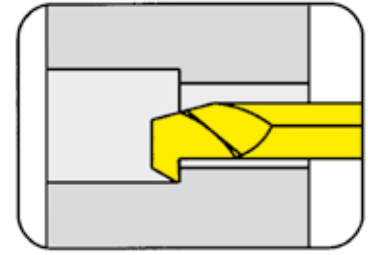
背镗 (内圆)

BACKBORING (internal)

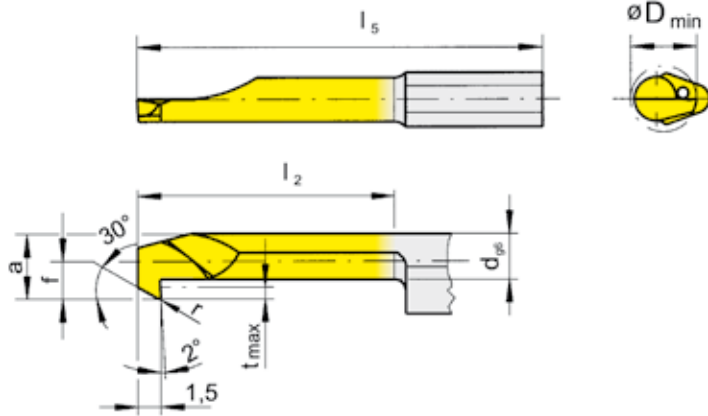


刀片 型号
INSERT Type

105



孔径最小至 Bore Ø from 3.0 mm



配合 刀杆
for use with Toolholder

型号 B105
Type BKT105
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	r	f	a	d	l ₂	l ₅	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L105.3013.2.3 R/L105.3013.3.3	0.10	1.3	2.6	1.9	15 20	30 35	0.5	3.0			▲/▲ ▲/Δ		
R/L105.3019.2.4 R/L105.3019.4.4	0.15	1.9	3.7	2.7	15 25	30 40	0.8	4.0			▲/Δ ▲/Δ		
R/L105.3023.3.5 R/L105.3023.5.5	0.20	2.3	4.7	3.5	20 30	35 45	1.0	5.0			▲/▲ ▲/Δ		
R/L105.3033.3.6 R/L105.3033.5.6	0.20	3.3	5.7	3.7	20 30	35 45	1.8	6.0			▲/▲ ▲/Δ		
R/L105.3040.3.7 R/L105.3040.5.7	0.20	4.0	6.4	3.7	20 30	35 45	2.5	6.8			▲/▲ ▲/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				

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

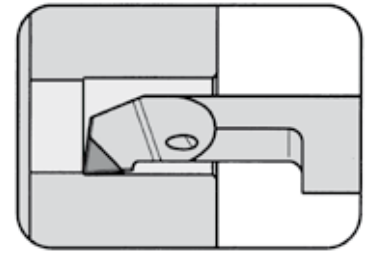
按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片型号
INSERT Type

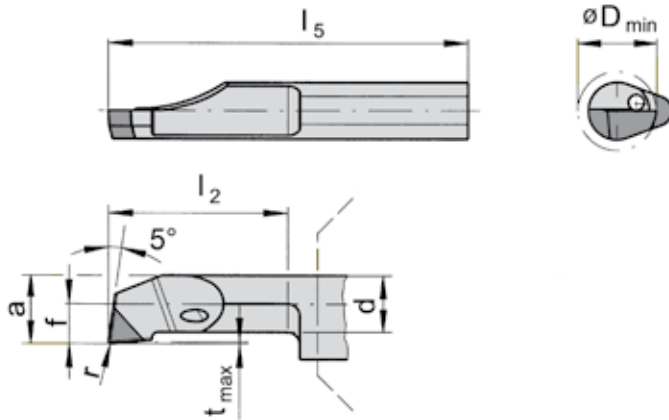
105



孔径最小至 Bore Ø from 3.0 mm

配合 刀杆
for use with Toolholder

型号 B105
Type BKT105
H105
HC105
VDI



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

CBN刀片
CBN tipped

产品型号 Part number	f	a	d	l ₂	l ₅	t _{max}	D _{min}	r	CB10
R105.0513.0.3.B	1.3	2.7	2.5	7	25	0.10	3.0	0.15	▲
R105.0519.1.4.B	1.5	3.7	3.4	10	25	0.10	4.0	0.20	▲
R105.0523.2.5.B	2.3	4.7	4.4	15	30	0.10	5.0	0.20	▲
R105.0533.2.6.B	3.3	5.7	5.3	15	30	0.15	6.0	0.20	▲
R/L105.0533.3.6.B				20	35				Δ/Δ
R105.0540.2.7.B	4.0	6.4	6.0	15	30	0.15	6.8	0.20	▲

- ▲ 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

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

P
M
K
N
S
H

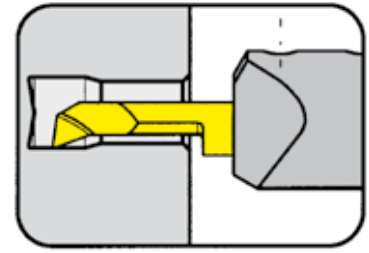
硬质合金牌号
Carbide grades

刀杆 型号

TOOLHOLDER Type

B105

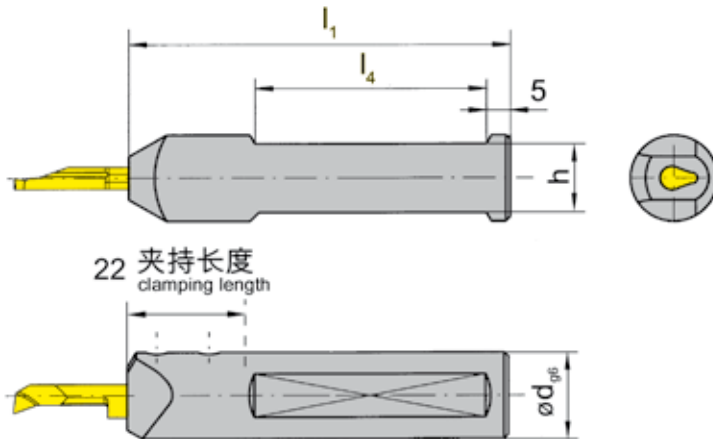
带内冷
with through coolant supply



孔径最小至

Bore Ø from

5.0 mm



配合 刀片

for use with Insert

型号 105...2

Type

图示=右手型

Picture = right hand cutting version

仅适用于夹持加长型刀片

only usable for inserts with
extended clamping length

产品型号 Part number	d	l ₁	h	l ₄
B105.0012.02	12	85	11	50
B105.0016.02	16	85	14	50
B105.0020.02	20	100	18	55
B105.0022.02	22	100	20	55

按需提供更多尺寸

Further sizes upon request

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...	6.075T15P	T15PQ

切槽 (内圆)

GROOVING (internal)



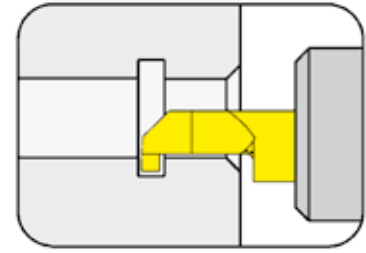
A

刀杆 型号

TOOLHOLDER Type

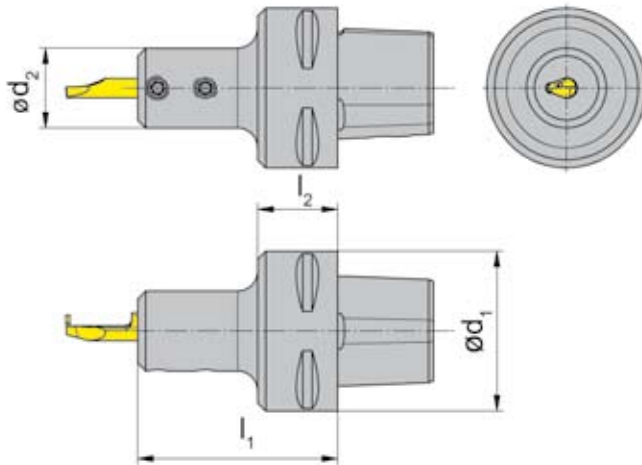
B105C

带内冷
with through coolant supply



HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

加持长度22mm
Clamping length 22 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 105...2
Type

产品型号 Part number	l_1	l_2	d_2	d_1
R/LB105.00C4.20.1.02	50	20	20	40
R/LB105.00C6.20.1.02	52	22	20	63

注明R或L型
State R or L version

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

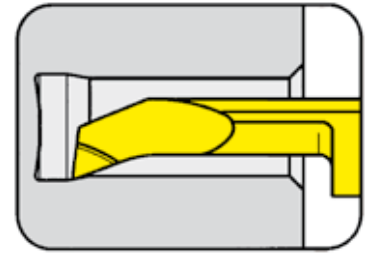
刀杆 Toolholder	螺钉 Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/LB105.00C...	6.075T15P	T15PQ

刀片型号

INSERT Type

105

配合加长型刀杆
with extended clamping shank



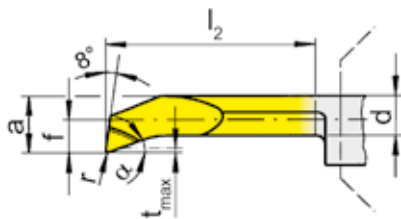
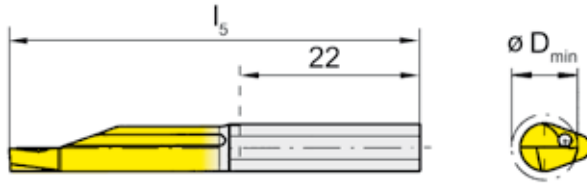
孔径最小至

Bore \varnothing from

5.0 mm

加持长度22mm

Clamping length 22 mm



配合 刀杆

for use with Toolholder

型号 B105.0012.02

Type B105.0016.02

B105.0020.02

B105.0022.02

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	f	a	d	l_2	l_5	t_{max}	D_{min}	r	α		MG12	TN35	TI25	TF45	TH35
R/L105.1823.4.5.2	2.3	4.7	4.2	25	50	0.3	5.0	0.1	20°				▲/△		▲/▲
R/L105.1823.5.5.2													▲/▲	▲/▲	
R/L105.1833.4.6.2	3.3	5.7	4.9	25	50	0.3	6.0	0.1	20°				▲/▲		▲/▲
R/L105.1833.5.6.2													▲/▲	▲/▲	
R/L105.1840.4.7.2	4.0	6.4	5.4	25	50	0.3	6.8	0.1	20°				▲/▲		▲/▲
R/L105.1840.5.7.2													▲/▲	▲/▲	
R/L105.1840.7.7.2													▲/	▲/▲	
R/L105.4733.5.6.2	3.3	5.7	3.7	30	55	1.8	6.0	0.1	47°			▲/▲		▲/▲	

▲ 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

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

硬质合金牌号

Carbide grades

端面切槽

FACE GROOVING



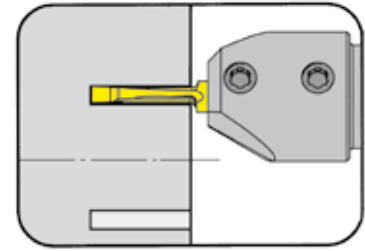
A

刀杆 型号

TOOLHOLDER Type

B105

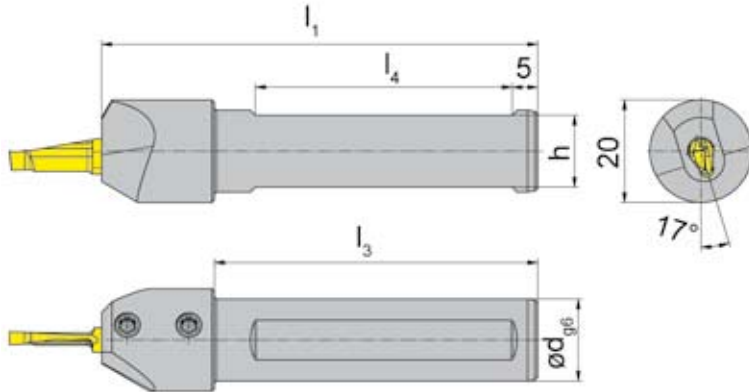
带内冷
with through coolant supply



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

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

A105

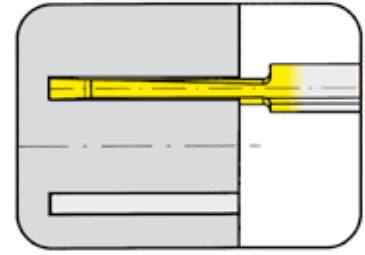
端面切槽

FACE GROOVING

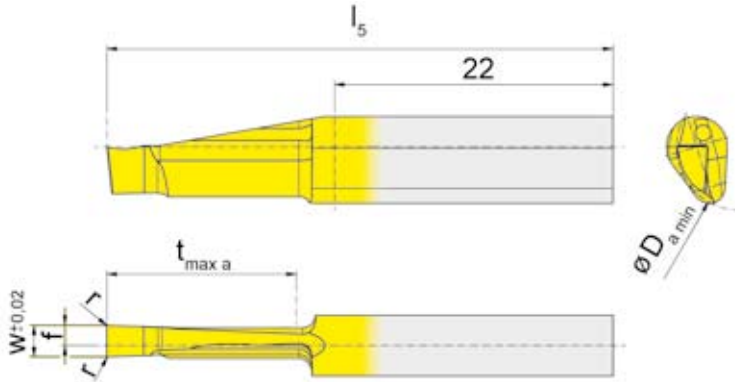
刀片型号

INSERT Type

A105



端面槽起始外径	from outer groove \emptyset	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_5	$t_{max a}$	$D_{a min}$	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			

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

在最大切深且满切情况下进行端面切槽， $D_{a min}$ 10-40 mm!

Face grooving with full width of the full depth only possible between $D_{a min}$ 10 - 40 mm!

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

铣槽 系列 275

GROOVE MILLING System 275



A



切削刃 \varnothing 31 mm
Cutting edge \varnothing 31 mm



切削刃 \varnothing 31 mm
Cutting edge \varnothing 31 mm



切削刃 \varnothing 38 mm
Cutting edge \varnothing 38 mm

需要更多信息请参阅HORN样本 "硬质合金铣削刀具"

For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Supermini® 硬质合金切槽刀具
Supermini® CARBIDE GROOVING TOOLS

型号 **110**
type

B110. VDI...110. N
刀柄
Toolholder



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B2-B3



页 / Page
B4



页 / Page
B5-B6

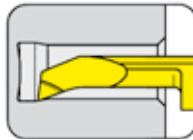


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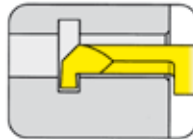


页 / Page
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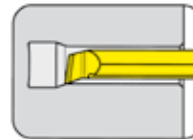
110
≥ Ø 6.0 mm
刀片
Inserts



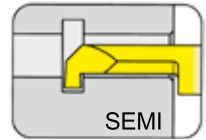
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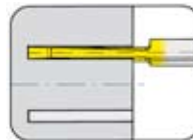
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B110
端面切槽
Face Grooving
刀柄
Toolholder

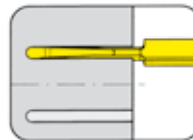


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A110
端面切槽
Face Grooving
刀片
Inserts



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技术说明
Technical Instructions

页
Page M1-M7

切槽和镗孔

GROOVING and BORING

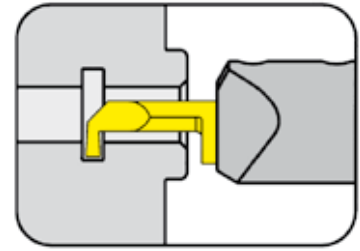


B

刀杆 型号
TOOLHOLDER Type

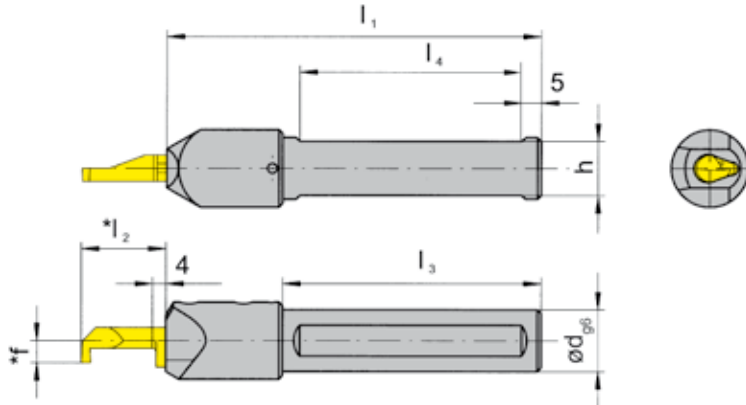
B110

带内冷
with through coolant supply



孔径最小至	Bore Ø from	6.0 mm
槽深可达	Depth of groove up to	4.0 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 110
Type

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₃	l ₄
B110.0016.02	16	100	14	70	55
B110.0020.02	20	100	18	-	55
B110.0022.02	22	100	20	-	55
B110.0025.02	25	100	23	-	55

按需提供更多尺寸
Further sizes upon request

f, l₂ 见 105 系列刀片
f, l₂ see inserts type 105

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
B110.00...	6.075T15P	T15PQ

B2

切槽和镗孔

GROOVING and BORING

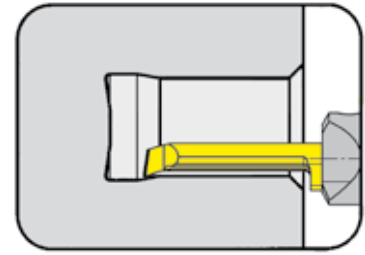


B

刀杆 型号
TOOLHOLDER Type

B110

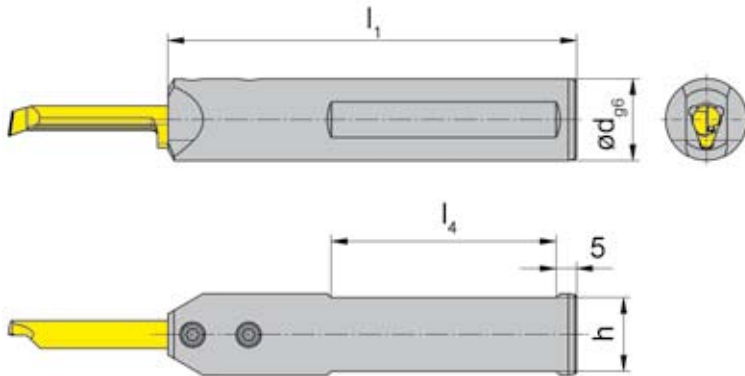
带内冷
with through coolant supply



孔径最小至	Bore Ø from	6.0 mm
槽深可达	Depth of groove up to	4.0 mm
槽宽可达	Width of groove up to	3.0 mm

配合 刀片
for use with Insert

型号 110
Type



带有多个冷却孔
with additional through coolant bores

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄
B110.0020.K.02	20	100	18	55

按需提供更多尺寸
Further sizes upon request

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
B110.0020.K.02	6.075T15P	T15PQ

切槽和镗孔

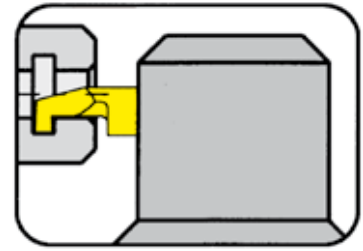
GROOVING and BORING



B

刀杆 型号
TOOLHOLDER Type

B110KM

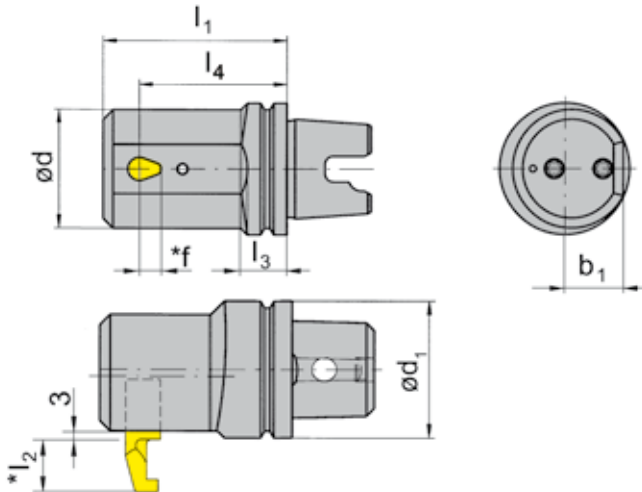


用于110系列刀片HORN - KM的接头
Adapter for inserts type 110 HORN-KM

用于INDEX多主轴机床
for INDEX Multi spindle machines

配合刀片
for use with Insert

型号 110
Type



R=右手型-如图
R = right hand version shown

Kennametal授权
Licence Kennametal

产品型号 Part number	d	l ₁	l ₃	b ₁	l ₄	d ₁	机床型号 Type of machine
RB110.KM40.2.2.02	36	56	14	18	45	40	MS32
RB110.KM50.2.2.02	36	56	22	18	45	50	MS52

按需提供更多尺寸
Further sizes upon request

f, l₂见110系列刀片
f, l₂ see inserts type 110

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
RB110.KM...	6.075T15P	T15PQ

切槽和镗孔

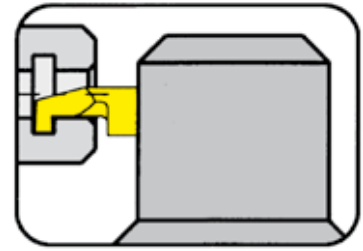
GROOVING and BORING



B

刀杆 型号
TOOLHOLDER Type

B110C

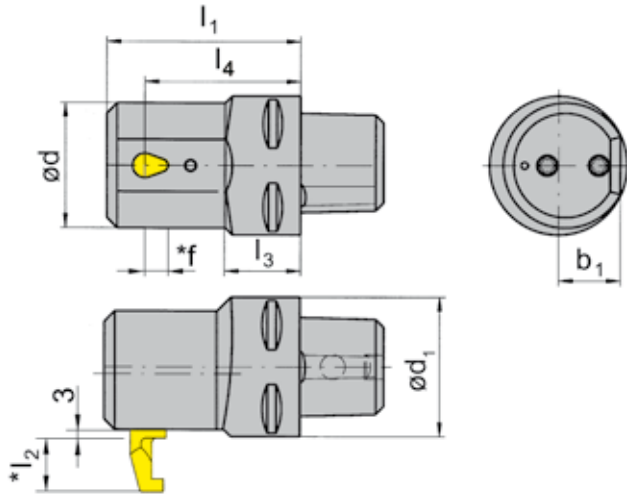


HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于INDEX多主轴机床
for INDEX Multi spindle machines

配合刀片
for use with Insert

型号 110
Type



R=右手型-如图
R = right hand version shown

产品型号 Part number	d	l ₁	l ₃	b ₁	l ₄	d ₁	机床型号 Type of machine
RB110.00C3.2.2.02	36	56	15	18	45	32	MS32
RB110.00C4.2.2.02	36	56	22	18	45	40	MS52

按需提供更多尺寸
Further sizes upon request

f, l₂见110系列刀片
f, l₂ see inserts type 110

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
RB110.00C...	6.075T15P	T15PQ

切槽和镗孔

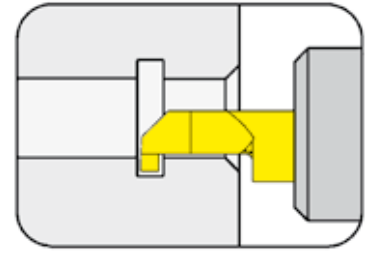
GROOVING and BORING



B

刀杆 型号
TOOLHOLDER Type

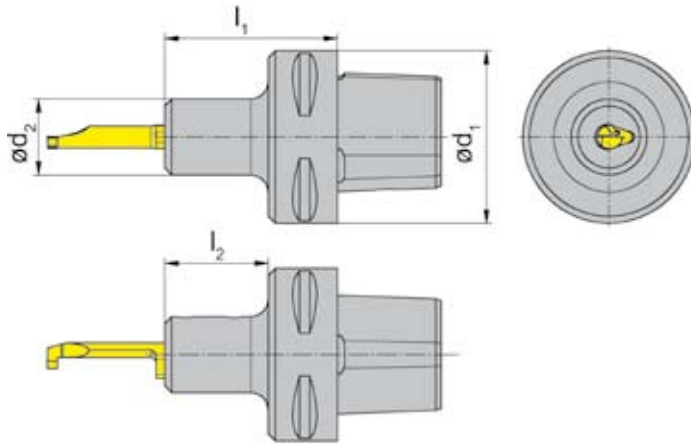
B110C



HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

配合 刀片
for use with Insert

型号 110
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	d_2	d_1
R/LB110.00C3.22.1.02	45	30	22	32
R/LB110.00C4.22.1.02	50	30	22	40
R/LB110.00C5.22.1.02	50	30	22	50
R/LB110.00C6.22.1.02	52	30	22	63

按需提供更多尺寸
Further sizes upon request

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/LB110.00C...	6.075T15P	T15PQ

B6

切槽和镗孔

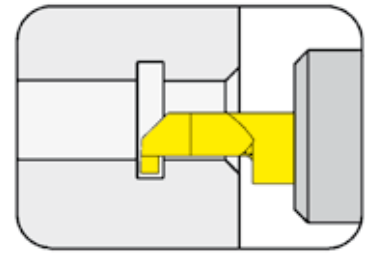
GROOVING and BORING



B

刀杆 型号
TOOLHOLDER Type

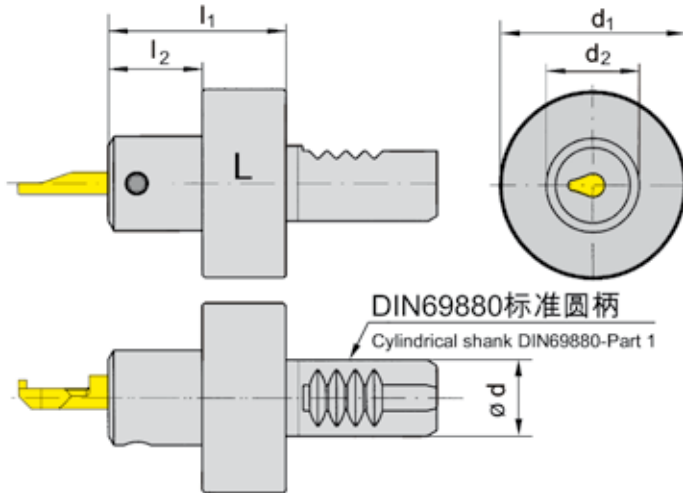
VDI
带内冷
with through coolant supply



孔径最小至 Bore Ø from 6.0 mm

配合 刀片
for use with Insert

型号 110
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	l ₂	d ₂	d ₁
VDI16-R/L110.30.02	16	48	30	22	40
VDI20-R/L110.30.02	20	48	30	22	50
VDI25-R/L110.30.02	25	48	30	22	58
VDI30-R/L110.30.02	30	48	30	22	68
VDI40-R/L110.30.02	40	48	30	22	83

注明R或L型
State R or L version

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

切槽和镗孔

GROOVING and BORING



B

可调刀杆 型号

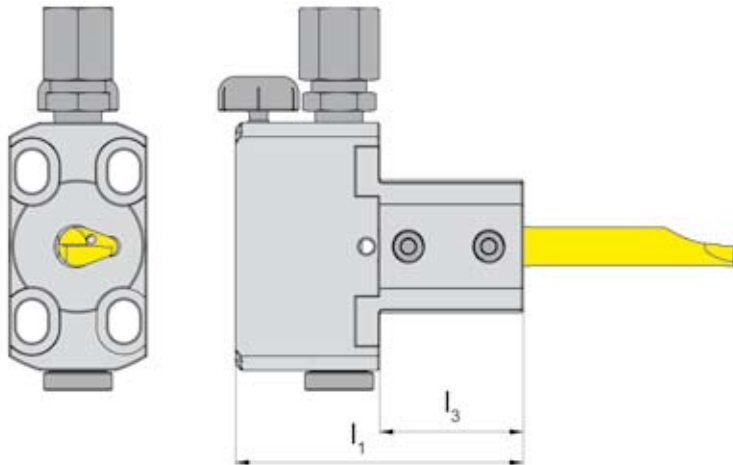
ADJUSTABLE HOLDER Type

N



孔径最小至	Bore Ø from	6.0 mm
槽深可达	Depth of groove up to	4.0 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 110
Type



图示=右手型
Picture = right hand cutting version

产品型号 Part number	l_1	l_3
N79IK	50	25

按需提供更多尺寸
Further sizes upon request

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	高度调节螺钉 Height adjustment screw	冷却接头 Coolant supply
N79IK	6.075T15P	002.00.69	004.00.19

B8

镗孔和仿形加工 $\geq \text{Ø} 6.0 \text{ mm}$

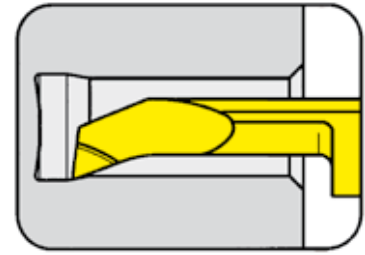
BORING and PROFILING



B

刀片型号
INSERT Type

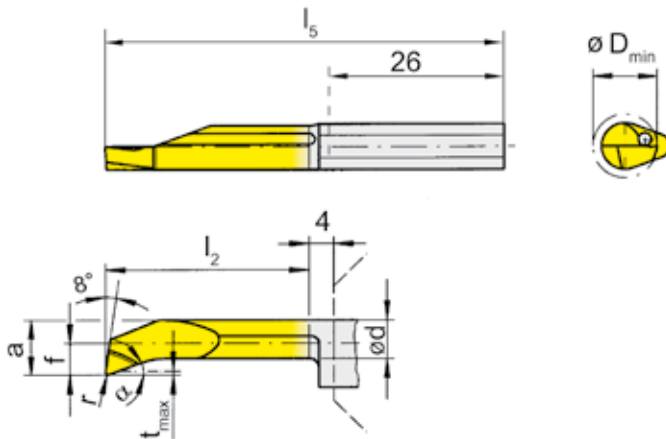
110



孔径最小至 Bore Ø from 6.0 mm

配合刀杆
for use with Toolholder

型号 B110
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	f	a	d	l_2	l_5	t_{max}	D_{min}	r	α	MG12	TN35	TI25	TH35
R/L110.1829.7.6	2.9	5.7	4.8	40	70	0.5	6	0.2	20°			▲/▲	▲/▲
R/L110.1829.9.6												▲/▲	▲/▲
R/L110.1829.9.8	4.0	7.4	6.0	50	80	0.5	8	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

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

切槽 (内圆) $\geq \text{Ø} 8.0 \text{ mm}$

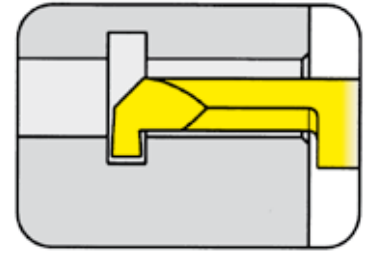
GROOVING (internal)



B

刀片型号
INSERT Type

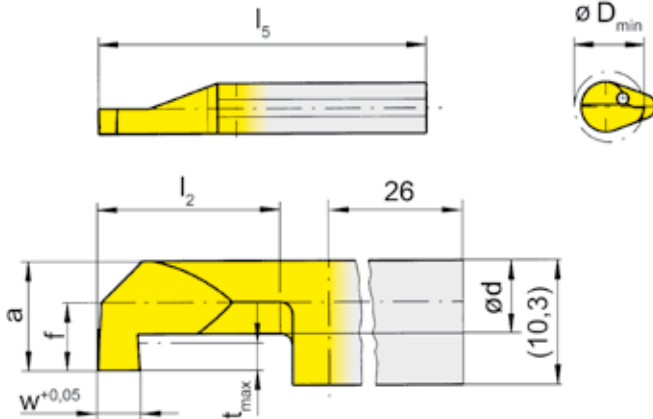
110



孔径最小至 Bore Ø from 8.0 mm

配合刀杆
for use with Toolholder

型号 B110
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	f	a	d	l_2	l_5	t_{max}	D_{min}	MG12	TN35	TI25	TH35
R/L110.0100.5.8	1.0				30	60				▲/▲		
R/L110.0200.5.8	2.0				30	60				▲/▲		
R/L110.0250.5.8	2.5				30	60				▲/▲		
R/L110.0100.7.8	1.0	4	7.4	4.2	40	70	2.8	8		▲/△		
R/L110.0200.7.8	2.0				40	70				▲/▲		
R/L110.0250.7.8	2.5				40	70				▲/△		
R/L110.0100.5.0	1.0				30	60				▲/△		
R/L110.0200.5.0	2.0				30	60				▲/▲		
R/L110.0300.5.0	3.0				30	60				▲/▲		
R/L110.0100.9.0	1.0	6	9.4	5.0	50	80	4.0	10		▲/△		
R/L110.0200.9.0	2.0				50	80				▲/▲		
R/L110.0300.9.0	3.0				50	80				▲/△		
▲ 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			

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

硬质合金牌号
Carbide grades

B10

切槽 (内圆) $\geq \text{Ø} 8.0 \text{ mm}$

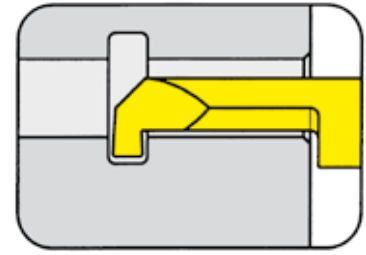
GROOVING (internal)



B

刀片型号
INSERT Type

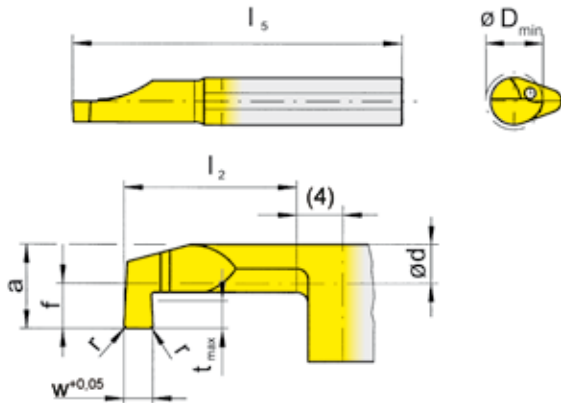
110



孔径最小至 Bore Ø from 8.0 mm

配合刀杆
for use with Toolholder

型号 B110
Type



带圆角
with corner radius

R=右手型-如图
R = right hand version shown

产品型号 Part number	w	f	a	d	l_2	l_s	t_{max}	D_{min}	r	MG12	TN35	TI25	TH35
R110.0200.02.3.8	2	4	7.4	4.2	20	50	2.8	8	0.2		▲		
										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

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

镗孔和仿形加工 $\geq \text{Ø} 6.0 \text{ mm}$

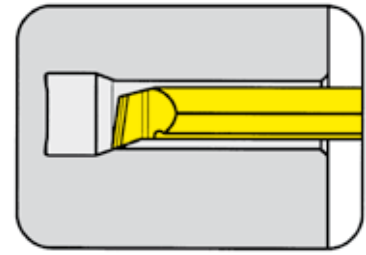
BORING and PROFILING



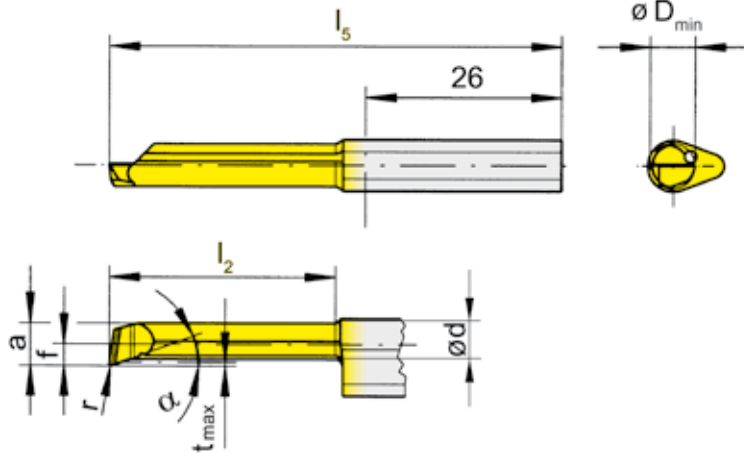
B

刀片型号
INSERT Type

110



孔径最小至 Bore Ø from 6.0 mm



配合 刀杆
for use with Toolholder

型号 B110
Type

带断屑槽
(槽型H)
with chip breaker
(geometry H)

R=右手型-如图
R = right hand version shown

产品型号 Part number	f	a	d	l ₂	l ₅	t _{max}	D _{min}	r	α	硬质合金牌号			
										MG12	TN35	TI25	TH35
R110.1829.9.H6	2.9	5.7	4.8	50	80	0.5	6	0.2	20°			▲	
R110.1829.9.H8	4.0	7.4	6.0	50	80	0.5	8	0.2	20°			▲	
											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

单位 : mm
 Dimensions in mm
 按需提供更多尺寸
 Further sizes upon request

硬质合金牌号
 Carbide grades

基本规格 型号 110

Basic sizes type 110

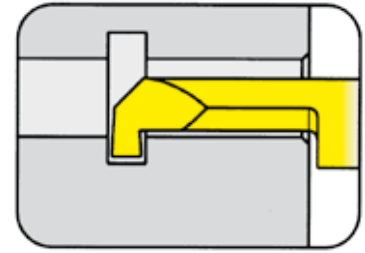


B

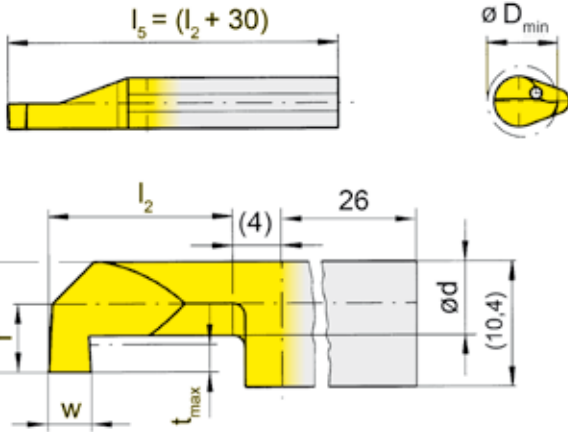
刀片 型号

110

INSERT type



基本规格 型号 110
Basic sizes type 110



用于 刀柄
for Toolholder

型号 B110
type

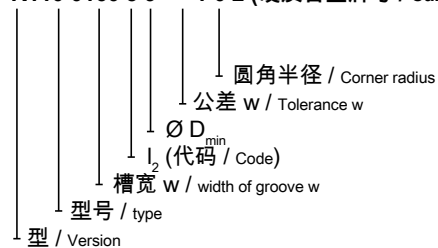
产品编号 Part number	D _{min}	f	a	d	t _{max}	w	代码 Code	l ₂	MG12	TN35	TI25	TH35
110...8	8	4	7.4	4.2	2.8	0.5-3.0	1	10	按照要求 UPON REQUEST			
110...9	9	5	8.4	4.8	3.5		2	15				
							3	20				
							4	25				
110...0	10	6	9.4	5.2	4.0		5	30				
							6	35				
							7	40				

尺寸单位 : mm
Dimensions in mm

如何订购:

Ordering example:

R110.0160.3.9^{+0.05}r 0.2 (硬质合金牌号 / Carbide grade)



端面切槽 FACE GROOVING

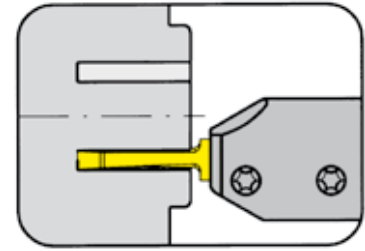


B

刀杆 型号
TOOLHOLDER Type

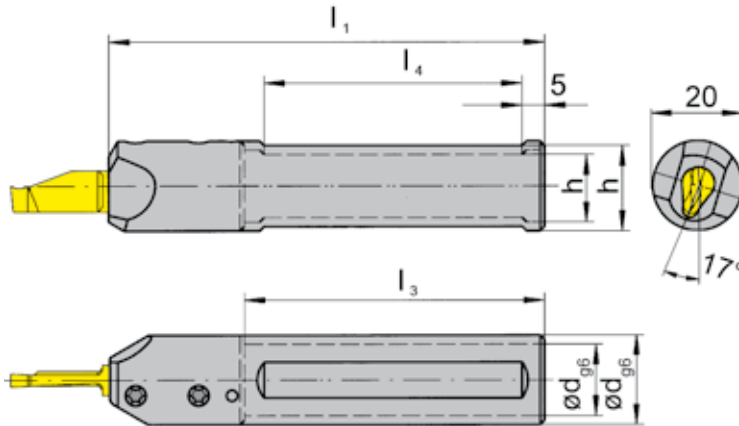
B110

带内冷
with through coolant supply



端面槽起始外径	from outer groove \varnothing	20.0 mm
槽深可达	Depth of groove up to	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

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

B14

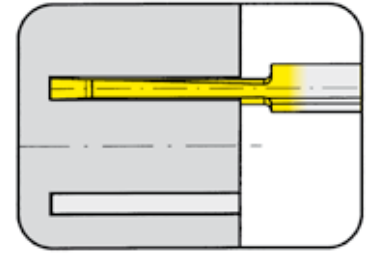
端面切槽 FACE GROOVING



B

刀片型号
INSERT Type

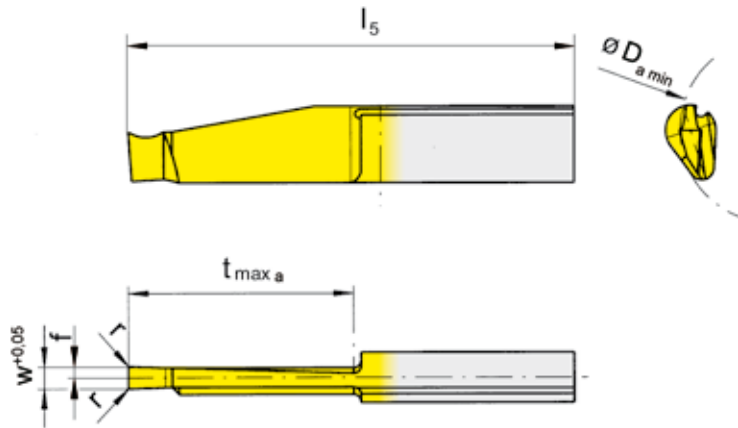
A110



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

单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

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

在最大切深且满切情况下进行端面切槽时 D_{amin} 20-50mm。
Face grooving with full width of the full depth only possible between D_{amin} 20 - 50 mm.

端面切槽

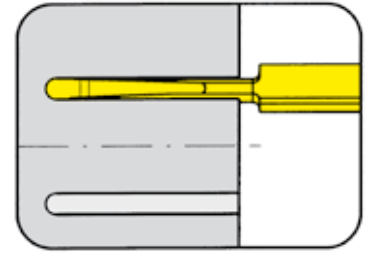
FACE GROOVING



B

刀片型号
INSERT Type

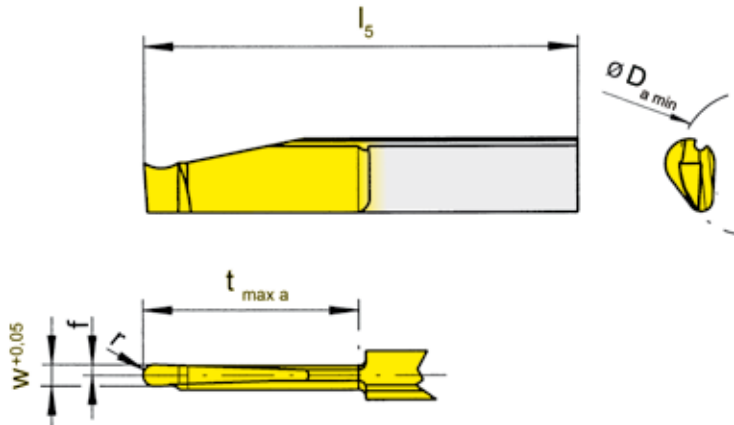
A110



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

圆头
Full radius

产品型号 Part number	w	r	f	l_5	$t_{max a}$	$D_{a min}$	MG12	TN35	TI25	TH35
R/LA110.2030.15.5.0	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			

单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

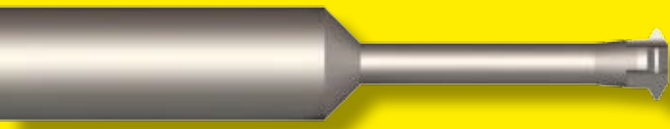
硬质合金牌号
Carbide grades

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

在最大切深且满切情况下进行端面切槽时 D_{amin} 20-50mm。
Face grooving with full width of the full depth only possible between D_{amin} 20 - 50 mm.

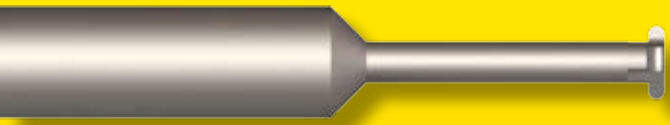


型号 DCG

螺纹铣削，全牙型和非全牙型
M3-M12

type DCG

Thread milling, Full and partial profile
M3 - M12



型号 DCR

全半径铣槽
Ø Ds 4.0 - 10.0 mm
半径 0.5 - 1.5 mm

type DCR

Groove milling Full Radius
Ø Ds 4.0 - 10.0 mm
Radius 0.5 - 1.5 mm

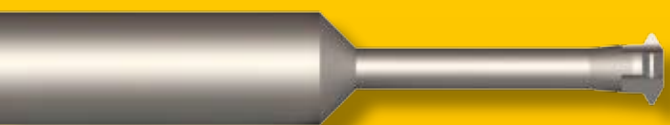


型号 DCN

铣槽
Ø Ds 4.0 - 10.0 mm

type DCN

Groove milling
Ø Ds 4.0 - 10.0 mm



型号 DCF

倒角铣削
Ø Ds 2.0 - 7.5 mm

type DCF

Chamfer milling
Ø Ds 2.0 - 7.5 mm

需要更多信息请参阅HORN样本 "硬质合金铣削刀具"

For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
-------------	---	---	---	---	---	---	---	---	---	---

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

型号 107
type

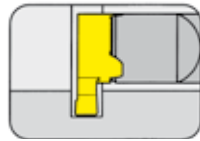
C

B107
刀柄
Toolholder

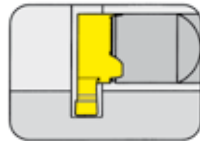


页 / Page
C2

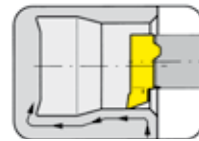
107
≥ Ø 7,0 mm
刀片
Inserts



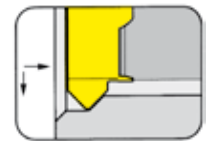
页 / Page
C3



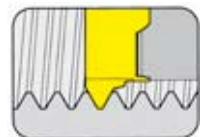
页 / Page
C4



页 / Page
C5



页 / Page
C6



页 / Page
C7

技术说明
Technical Instructions

页
Page M1-M7

切槽和镗孔

GROOVING and BORING

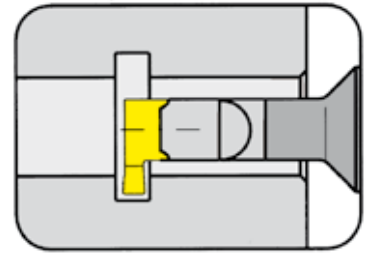


刀杆 型号

TOOLHOLDER Type

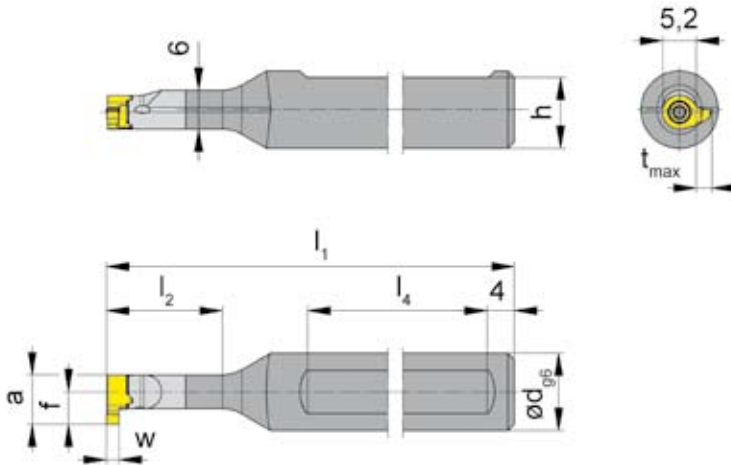
B107

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	7.0 mm
槽深可达	Depth of groove up to	2.0 mm
槽宽可达	Width of groove up to	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 107
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	l_2	h	l_4
R/LB107.0012.01	12	80	18	11	45
R/LB107.0012.02		90	26		
R/LB107.0012.03		100	36		

注明R或L型
State R or L version

w, a, t_{max} 和 f 见刀片
 w, a, t_{max} and f see inserts

单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
HORN可以返修损坏的刀杆基座。
Ordering note:
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
R/LB107.0012.0...	2.2.5T7EP	T7PL

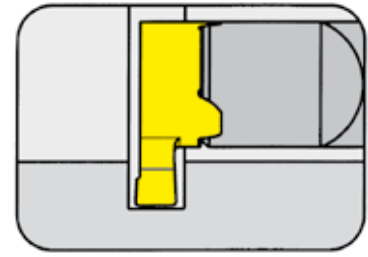
切槽 (内圆) $\geq \varnothing 7.0 \text{ mm}$

GROOVING (internal)



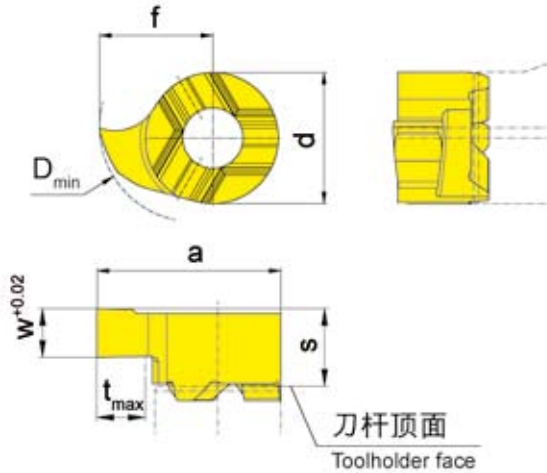
刀片型号
INSERT Type

107



C

孔径最小至	Bore \varnothing from	7.0 mm
槽深可达	Depth of groove up to	1.0 mm
槽宽可达	Width of groove up to	1.5 mm



配合 刀杆
for use with Toolholder

型号 B107
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L107.0100.1.00	1.0	3,3	4	6,6	5.2	1	7				▲/▲
R/L107.0150.1.00	1.5										▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

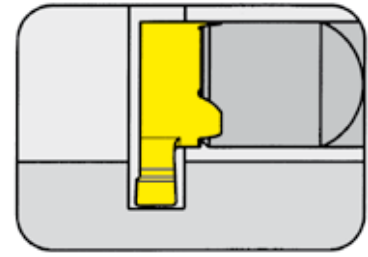
切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

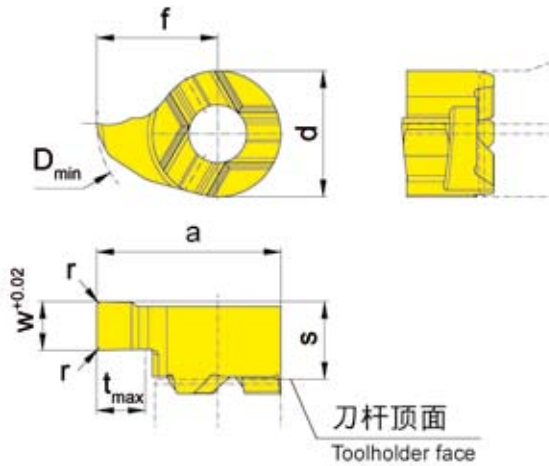
107



孔径最小至	Bore \varnothing from	8.0 mm
槽深可达	Depth of groove up to	2.0 mm
槽宽可达	Width of groove up to	2.0 mm

配合刀杆
for use with Toolholder

型号 B107
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L107.0100.2.00	1.0	-										▲/▲
R/L107.0150.2.01	1.5	0.1	3,3	5	7,6	5.2	2	8				▲/▲
R/L107.0200.2.02	2.0	0.2										▲/▲
▲ 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

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

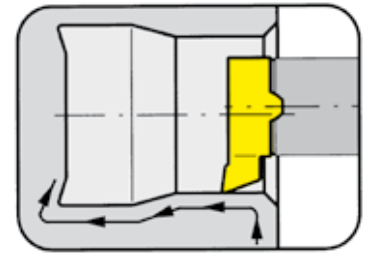
镗孔和仿形加工 $\geq \text{Ø} 6.8 \text{ mm}$

BORING and PROFILING



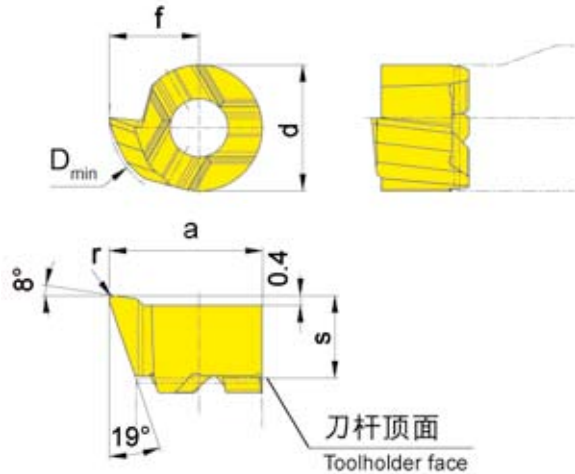
刀片型号
INSERT Type

107



C

孔径最小至 Bore Ø from 6.8 mm



配合刀杆
for use with Toolholder

型号 B107
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	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L107.1837.02	0.2	3,3	3,7	6,3	5.2	6.8				▲/▲
R/L107.1837.04	0.4									▲/▲
▲ 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			

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

改进后的几何槽形可镗 $\geq \text{Ø} 6.8 \text{ mm}$ 的孔和仿形加工DIN509E型和F型退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 6.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

倒角和背镗 (内圆)

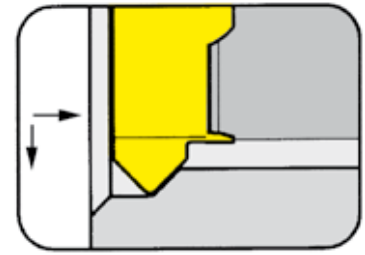
CHAMFERING and BACKBORING (internal)



刀片 型号

INSERT Type

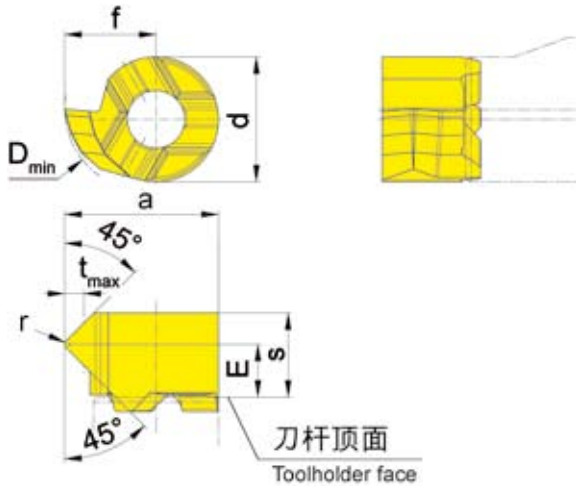
107



孔径最小至
切深可达

Bore \varnothing from
Depth of cut up to

6.8 mm
0.8 mm



配合 刀杆

for use with Toolholder

型号 B107

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	E	r	s	f	a	d	t _{max}	D _{min}		MG12	TN35	TI25	TA45	TH35
R/L107.4545.1.02	2.2	0.2	3.5	3.8	6.4	5.2	0.8	6.8						▲/▲
▲ 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				

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

硬质合金牌号

Carbide grades

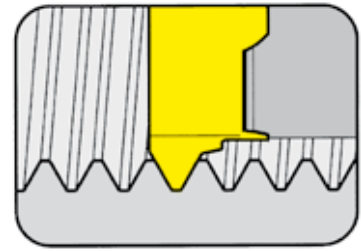
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



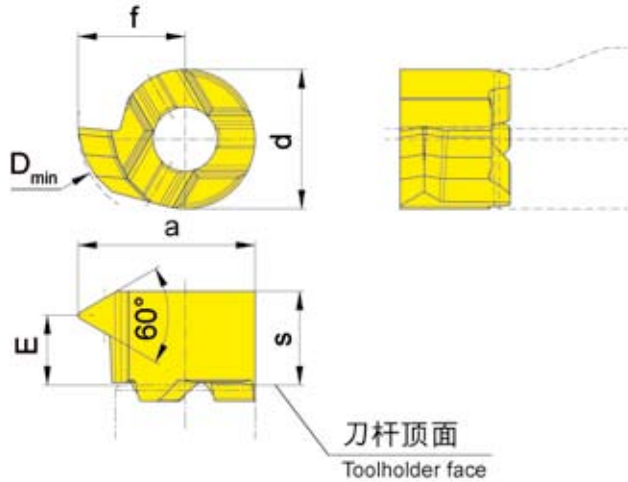
刀片型号
INSERT Type

107



C

孔径最小至 7.00 mm
螺距 Pitch 0.50 - 1.75 mm



配合刀杆
for use with Toolholder

型号 B107
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	涂层 / Coating			
								MG12	TN35	TI25	TH35
R/L107.0205.1.01	0.5 - 0.75	3.0									▲/▲
R/L107.0510.1.01	1.0 - 1.25	2.8	3.5	4	6,6	5.2	7				▲/▲
R/L107.0815.1.01	1.5 - 1.75	2.6									▲/▲
								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

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

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

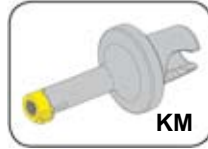
Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

型号 108
type

B108
刀柄
Toolholder

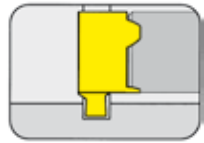


页 / Page
D2-D3

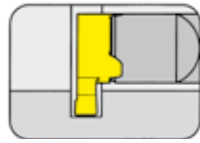


页 / Page
D4-D5

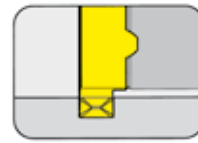
108 / S108
≥ Ø 8,0 mm
刀片
Inserts



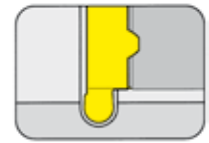
页 / Page
D6



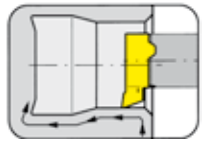
页 / Page
D7-D9



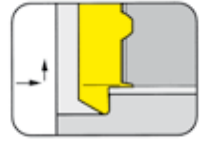
页 / Page
D10



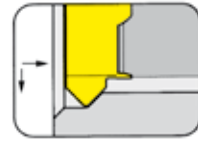
页 / Page
D11



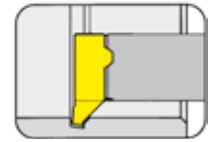
页 / Page
D12-D13, D16



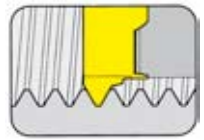
页 / Page
D14



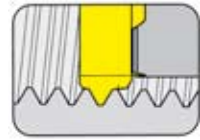
页 / Page
D17



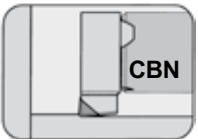
页 / Page
D18



页 / Page
D19-D20



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D21-D22



页 / Page
D23

技术说明
Technical Instructions

页
Page M1-M7

D

切槽和镗孔

GROOVING and BORING

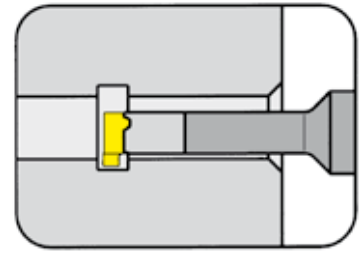


刀杆 型号

TOOLHOLDER Type

B108

带内冷
with through coolant supply

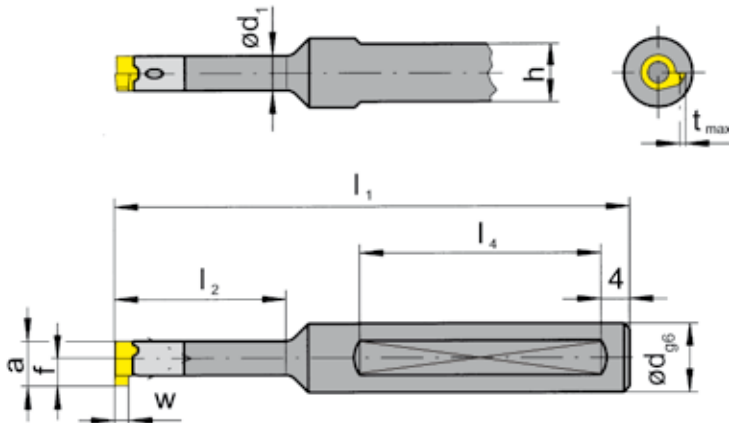


孔径最小至	Bore \varnothing from	8.0 mm
槽深可达	Depth of groove up to	1.0 mm
槽宽可达	Width of groove up to	2.0 mm

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 S108



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2	h	l_4	d_1
B108.0006.01A	6	65	-	-	-	-
B108.0008.00 B108.0008.01	8	60 70	12.5 21.0	7	35 40	6
B108.0012.00 B108.0012.01 B108.0012.02 B108.0012.03	12	70 80 90 100	12.5 21.0 30.0 42.0	11	40 45 45 45	6

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

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
B108.00...	2.6.5T8EP	T8PL

切槽和镗孔

GROOVING and BORING

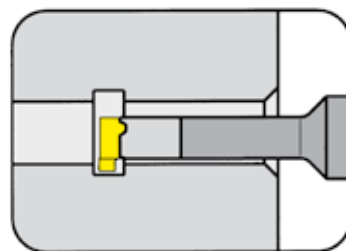


刀杆 型号

TOOLHOLDER Type

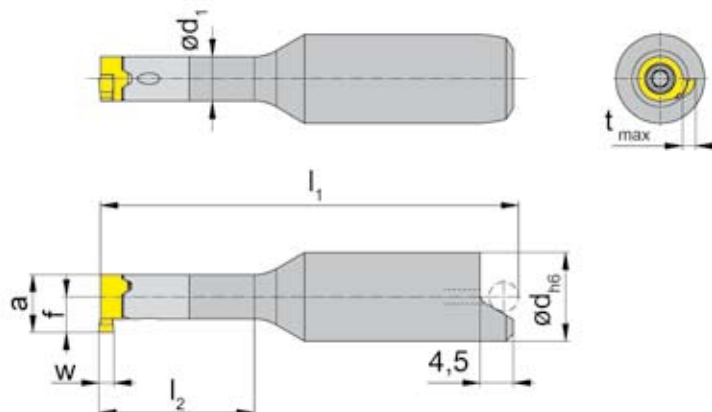
B108

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	8.0 mm
槽深可达	Depth of groove up to	1.0 mm
槽宽可达	Width of groove up to	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 S108

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_1	l_2	d_1
B108.0012.00S	12	48.7	12.5	6
B108.0012.01S		56.7	21.0	
B108.0012.02S		65.7	30.0	
B108.0012.03S		77.7	42.0	

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

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
B108.0012.0...	2.6.5T8EP	T8PL

切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

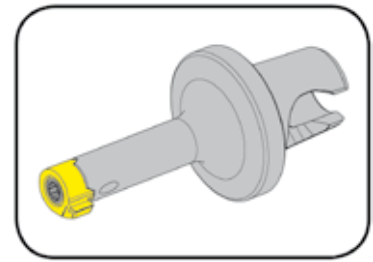
GROOVING (internal)



刀杆 型号
TOOLHOLDER Type

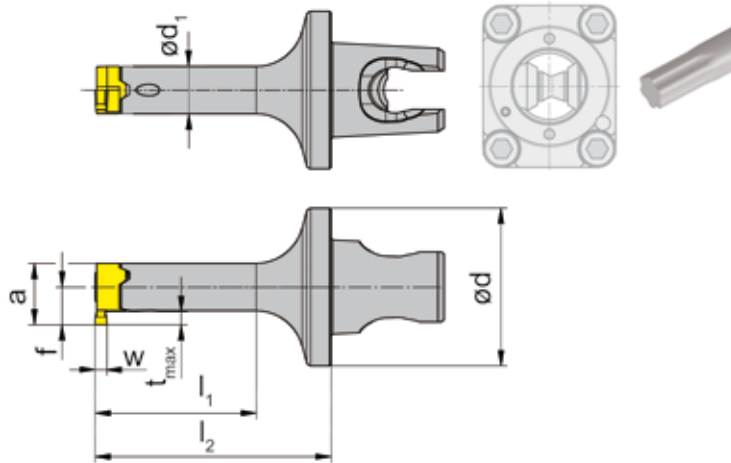
B108KM

带内冷
with through coolant supply



孔径最小至 Bore \varnothing from 8.0 mm

D



配合 刀片
for use with Insert

型号 108
Type S108

Kennametal KM16 Micro
系统
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

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
B108.KM16.0...	2.6.5T8EP	T8PL

D4

切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

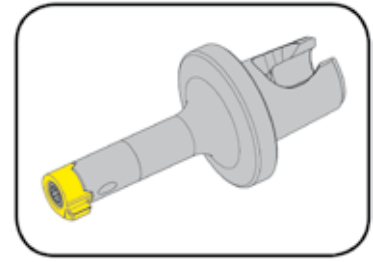
GROOVING (internal)



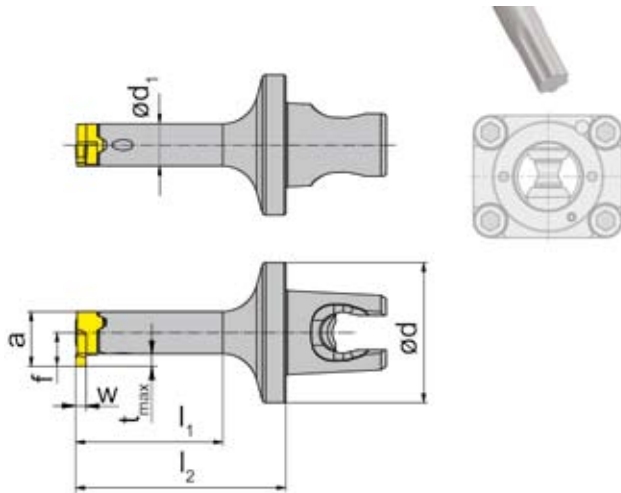
刀杆 型号
TOOLHOLDER Type

B108KM

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	8.0 mm
-------	-------------------------	--------



配合 刀片
for use with Insert

型号 108
Type S108

Kennametal KM16 Micro
系统
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

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
B108.KM16.90.0...	2.6.5T8EP	T8PL

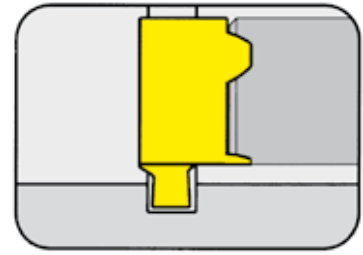
切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

GROOVING (internal)



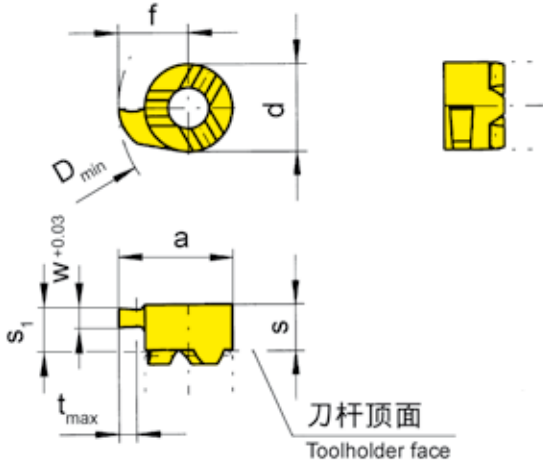
刀片型号
INSERT Type

108



孔径最小至 卡簧槽Nw	Bore \varnothing from Width of circlip Nw	8.0 mm 0.7 - 0.9 mm
----------------	--	------------------------

卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



配合 刀杆
for use with Toolholder

型号 B108
Type

不能端面切削，
受切深限制，
not face cutting,
limited depth of cut

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	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.0070.00	0.7	0.74									▲/▲		▲/▲
R/L108.0080.00	0.8	0.84	3.2	3.6	4.8	7.8	6	1	8		▲/▲		▲/▲
R/L108.0090.00	0.9	0.94									▲/▲		▲/▲
										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

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

硬质合金牌号
Carbide grades

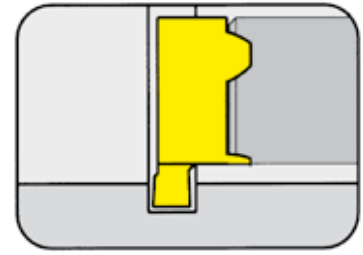
切槽 (内圆) $\geq \text{Ø} 8.0 \text{ mm}$

GROOVING (internal)



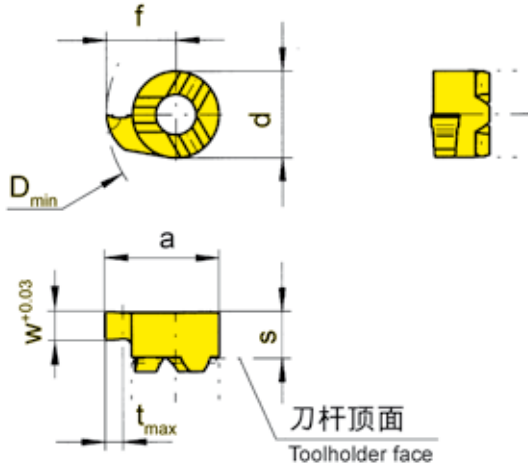
刀片型号
INSERT Type

108



孔径最小至 卡簧槽Nw	Bore Ø from Width of circlip Nw	8.0 mm 1.1 - 1.6 mm
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卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



配合刀杆
for use with Toolholder

型号 B108
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	Ti25	TH35
R/L108.0110.00	1.1	1.19							▲/▲	▲/▲		▲/▲
R/L108.0130.00	1.3	1.39	3.2	4.8	7.8	6	1	8	▲/▲	▲/▲		▲/▲
R/L108.0160.00	1.6	1.69							▲/▲	▲/▲		▲/▲
									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

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

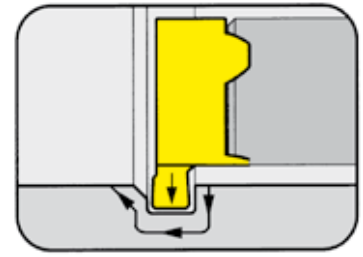
NC-仿形加工 (内圆) $\geq \varnothing 8.0 \text{ mm}$

NC-PROFILING (internal)

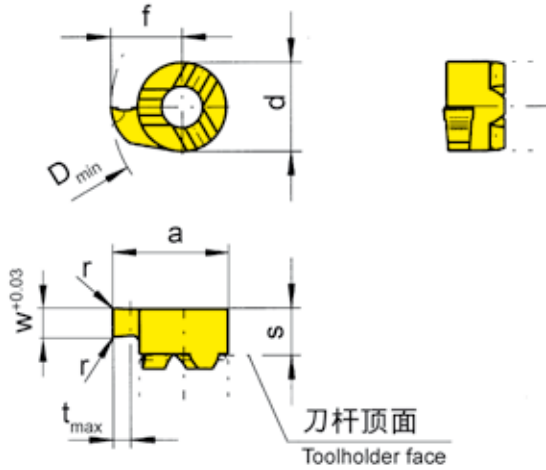


刀片型号
INSERT Type

108



孔径最小至 槽深	Bore \varnothing from Depth of groove	8.0 mm 1.0 mm
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配合刀杆
for use with Toolholder

型号 B108
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.0150.02	1.5	0.2	3.2	4.8	7.8	6	1	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			

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

硬质合金牌号
Carbide grades

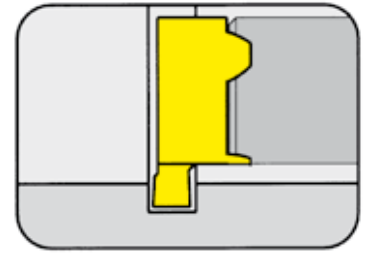
切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

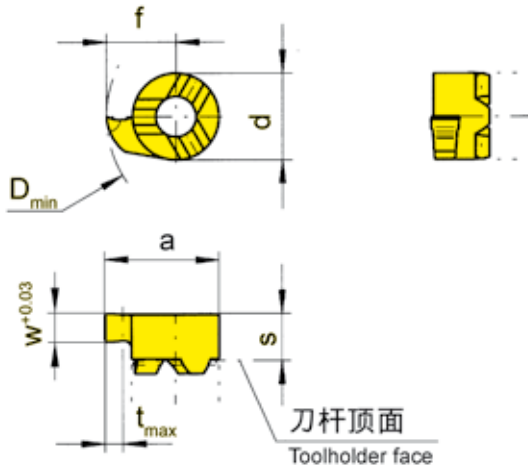
108



孔径最小至	Bore \varnothing from	8.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

配合刀杆
for use with Toolholder

型号 B108
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25
R/L108.0150.00	1.5	3.2	4.8	7.8	6	1	8	▲/▲	▲/▲	
R/L108.0200.00	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

	MG12	TN35	TI25
P	○	●	■
M	●	●	■
K	●	●	■
N	●	●	■
S	●	●	■
H	●	●	■

硬质合金牌号
Carbide grades

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

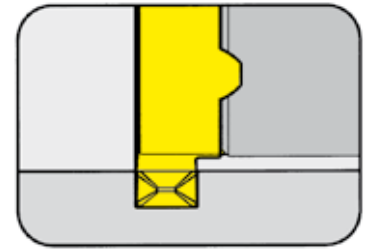
切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

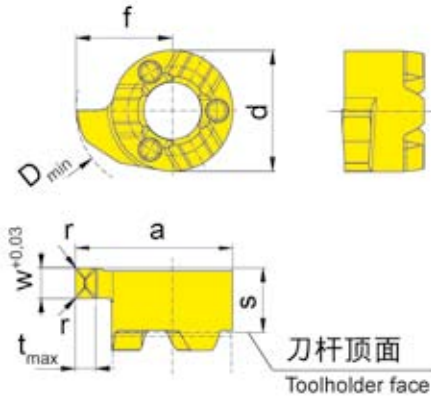
S108



孔径最小至	Bore \varnothing from	8.0 mm
槽深可达	Depth of groove up to	1.0 mm
槽宽	Width of groove	1.0 - 2.0 mm

配合刀杆
for use with Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}		MG12	TN35	TI25	TH35
R/LS108.0100.D1	1.0	0.1											▲/▲
R/LS108.0150.D1	1.5	0.1	3.2	4.8	7.8	6	1	8					▲/▲
R/LS108.0200.D2	2.0	0.2											▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

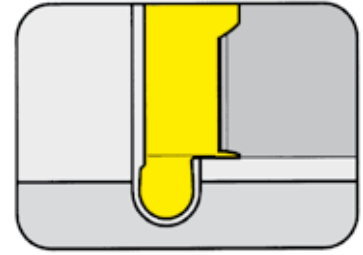
切槽 (内圆) $\geq \varnothing 8.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

108

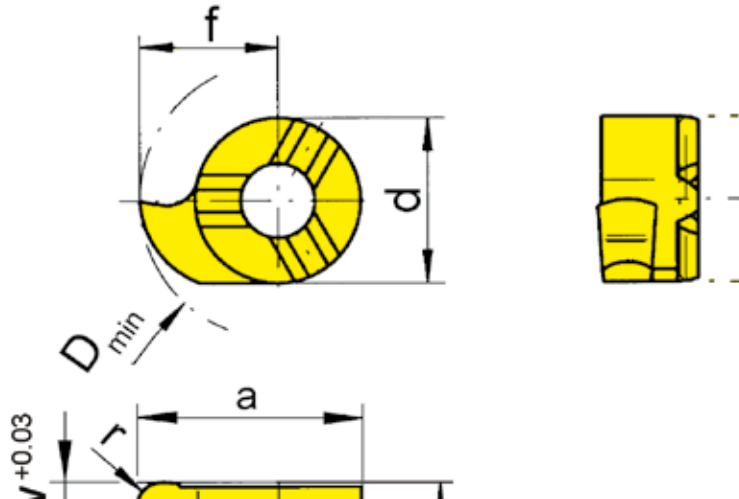


孔径最小至 圆头	Bore \varnothing from Full radius	8.0 mm r 0.4 - 0.9 mm
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配合 刀杆
for use with Toolholder

型号 B108
Type

D



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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.0004.08	0.8	0.4							▲/▲	▲/▲		▲/▲
R/L108.0006.12	1.2	0.6	3.2	4.8	7.8	6	1	8	▲/▲	▲/▲		▲/▲
R/L108.0009.18	1.8	0.9							▲/▲	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock ▲ 4周 / 4 weeks									P	o	•	•
● 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			

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

硬质合金牌号
Carbide grades

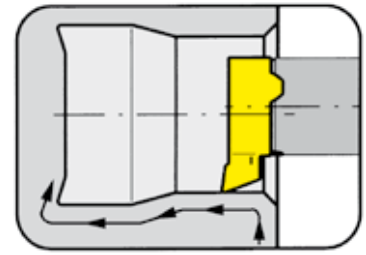
镗孔和仿形加工 $\geq \text{Ø} 7.8 \text{ mm}$

BORING and PROFILING

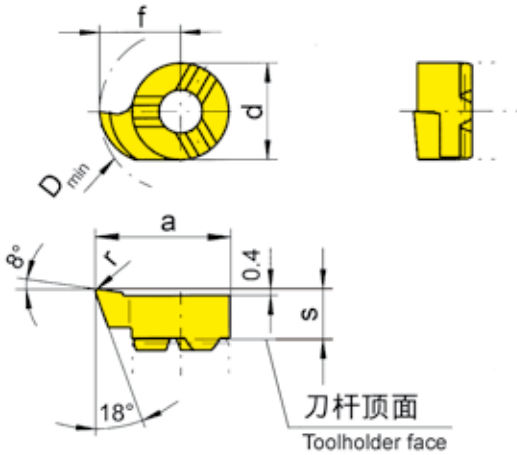


刀片型号
INSERT Type

108



孔径最小至 Bore Ø from 7.8 mm



配合刀杆
for use with Toolholder

型号 B108
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	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L108.1846.02	0.2	3.4	4.65	7.65	6	7.8	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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			

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

改进过的几何结构可以镗 $\geq \text{Ø} 7.8 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 7.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

D

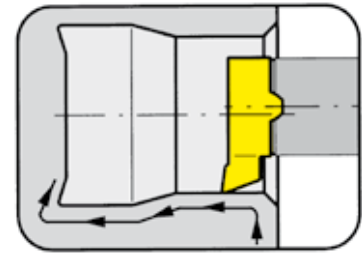
镗孔和仿形加工 $\geq \varnothing 7.8 \text{ mm}$

BORING and PROFILING

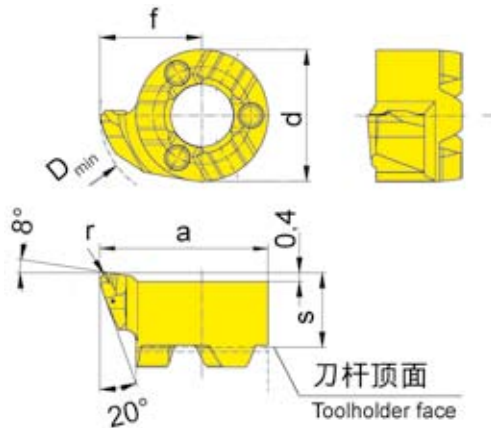


刀片型号
INSERT Type

S108



孔径最小至 Bore \varnothing from 7.8 mm



配合刀杆
for use with Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D_{min}	MG12	TN35	TI25	TH35
LS108.1846.R2	0.2									▲
RS108.1846.R2	0.2									▲
LS108.1846.R4	0.4	3.4	4.65	7.65	6	7.8				▲
RS108.1846.R4	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				

硬质合金牌号
Carbide grades

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

改进过的几何结构可以镗 $\geq \varnothing 7.8 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores $\geq \varnothing 7.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

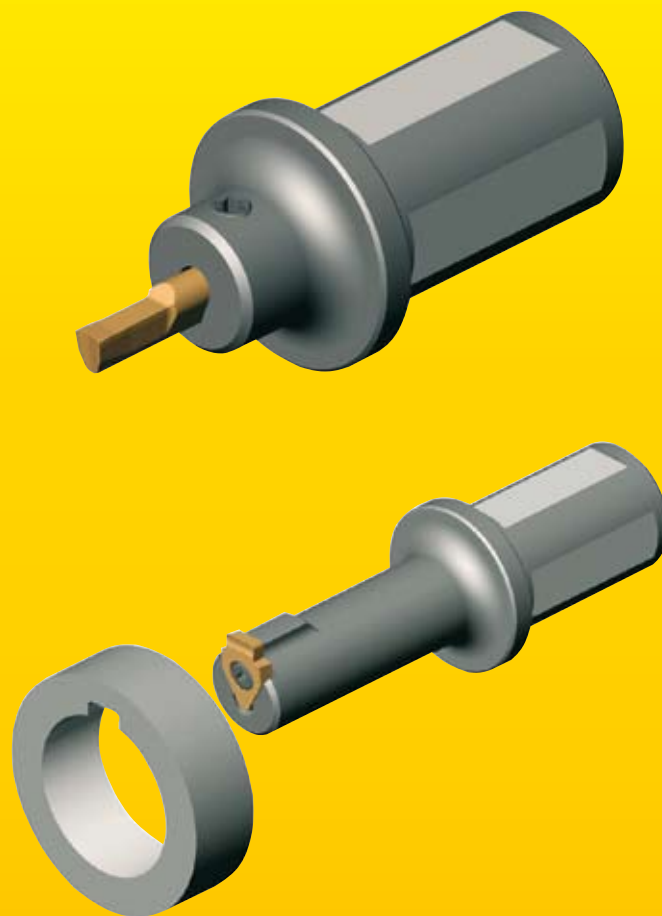
Further sizes upon request

插削
适用于CNC车床

BROACHING
on CNC lathes

D

插削刀具 型号 SB105/SB110 和 SH117
BROACHING TOOLS TYPE SB105/SB110 and SH117



DIN138和DIN6885标准键槽

KEYWAYS ACCORDING DIN138 and DIN6885

更多信息见HORN样本“硬质合金切槽刀具”

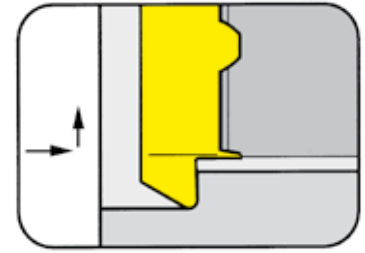
For further information please see the HORN catalogue "CARBIDE GROOVING TOOLS"

背镗 (内圆) $\geq \varnothing 7.8 \text{ mm}$ BACKBORING (internal)



刀片型号
INSERT Type

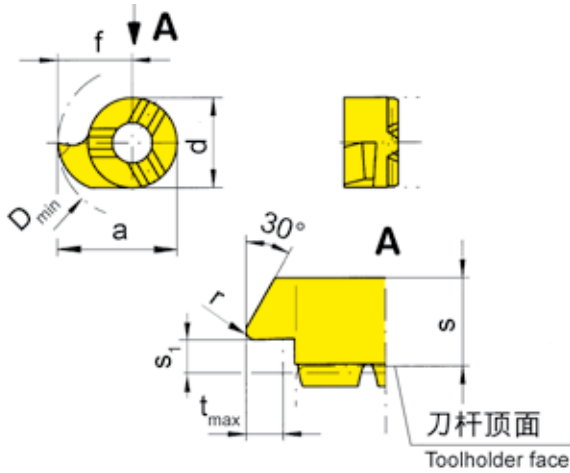
108



孔径最小至 向下切深可达	Bore \varnothing from Depth of undercut up to	7.8 mm 1.3 mm
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配合 刀杆
for use with Toolholder

型号 B108
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	r	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.3046.02	0.2	0.8	3.6	4.65	7.65	6	1.3	7.8		▲/▲		▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

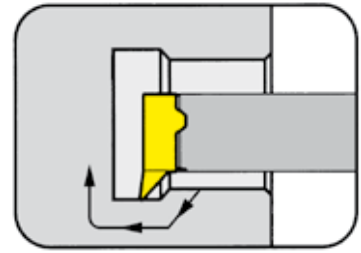
镗孔和仿形加工 $\geq \varnothing 7.8 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

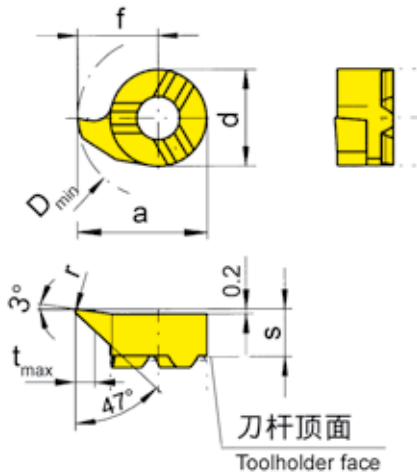
108



孔径最小至	Bore \varnothing from	7.8 mm
向下切深可达	Depth of undercut up to	1.2 mm

配合 刀杆
for use with Toolholder

型号 B108
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	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.4748.01	0.1										▲/▲
R/L108.4748.02	0.2	3.2	4.65	7.65	6	1.2	7.8		▲/▲		▲/▲
R/L108.4748.04	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

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

改进后的几何结构可以镗 $\geq \varnothing 7.8 \text{ mm}$ 孔和加工DIN509E型退刀槽

The modified geometry allows boring of bores $\geq \varnothing 7.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E.

按需提供更多尺寸

Further sizes upon request

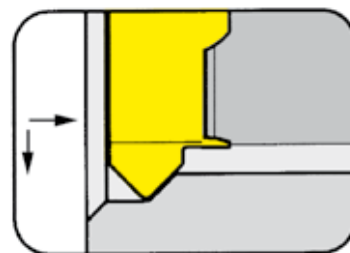
倒角和背镗 (内圆)

CHAMFERING and BACKBORING (internal)



刀片 型号
INSERT Type

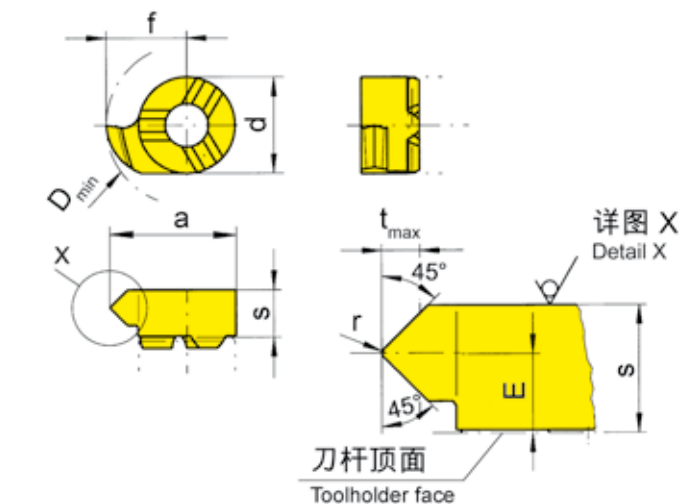
108



孔径最小至 切深可达	Bore \varnothing from Depth of cut up to	7.8 mm 1.4 mm
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配合 刀杆
for use with Toolholder

型号 B108
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	E	r	s	f	a	d	t _{max}	D _{min}		MG12	TN35	TI25	TA45	TH35
R/L108.4545.02	1.8	0.2	3.6	4.65	7.65	6	1.4	7.8			▲/▲	▲/▲	▲/	
▲ 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				

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

硬质合金牌号
Carbide grades



预切槽和倒角 (内圆)

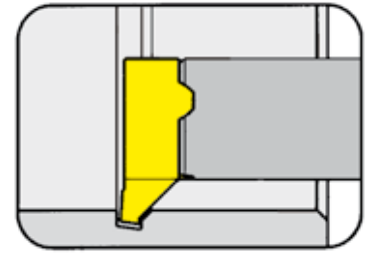
PREGROOVING and CHAMFERING (internal)



刀片型号

INSERT Type

108

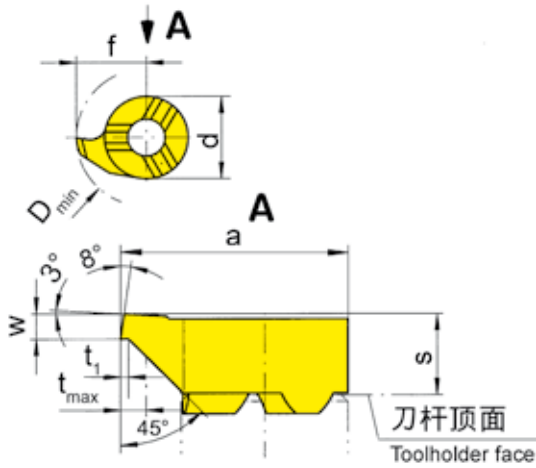


孔径最小至 Bore Ø from 8.0 mm

D

配合刀杆
for use with Toolholder

型号 B108
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	s	f	a	d	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L108.0810.45	1	3.2	4.8	7.8	6	0.2	1.5	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			

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

硬质合金牌号
Carbide grades

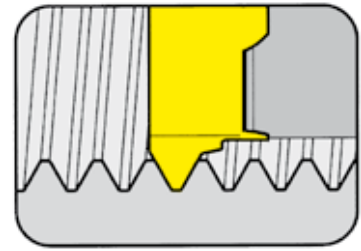
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

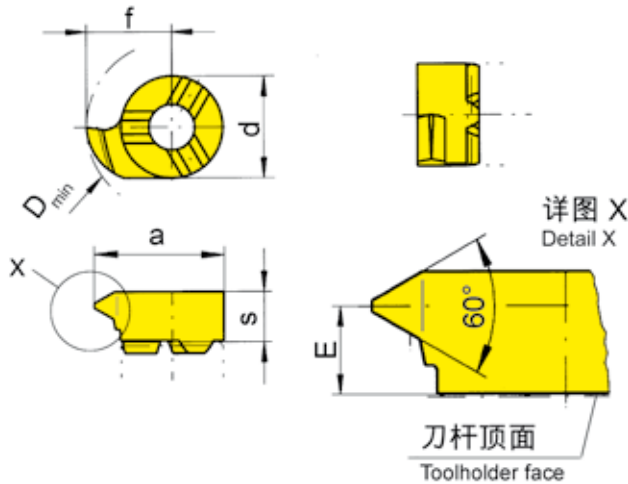
108



孔径最小至 螺距	Bore \varnothing from Pitch	8.00 mm 1.50 - 1.75 mm
-------------	----------------------------------	---------------------------

配合刀杆
for use with Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L108.0815.01	1.5	1.75	2.6	3.6	4.8	7.8	6	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			

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

硬质合金牌号
Carbide grades

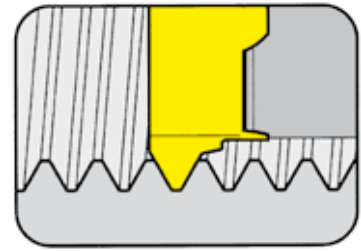
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

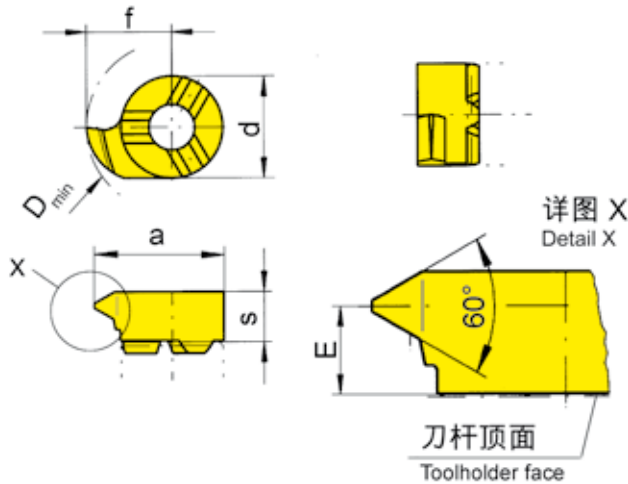
108



孔径最小至 螺距	Bore \varnothing from Pitch	8.00 mm 0.50 - 1.25 mm
-------------	----------------------------------	---------------------------

配合 刀杆
for use with Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L108.0205.01	0.5	0.75	2.8	3.6	4.8	7.8	6	8	▲/△	▲/▲	●	●
R/L108.0510.01	1.0	1.25	2.8	3.6	4.8	7.8	6	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
MG12	○	●	●	●	●	●
TN35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TH35	●	●	●	●	●	●

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

硬质合金牌号
Carbide grades

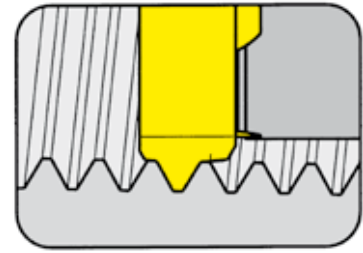
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片 型号
INSERT Type

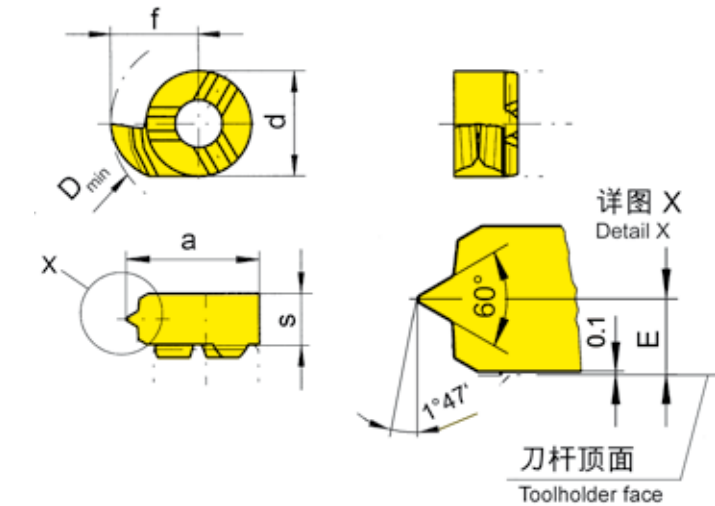
108



每英寸牙数	Threads per inch	14 / 18 / 27
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配合 刀杆
for use with Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

NPT螺纹
Thread NPT

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R108.NP14.02	14								▲		
R108.NP18.02	18	1.9	3.6	4.8	7.8	6	8		▲		
R108.NP27.02	27								△		
▲ 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			

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades



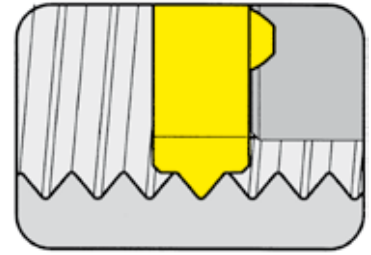
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片 型号
INSERT Type

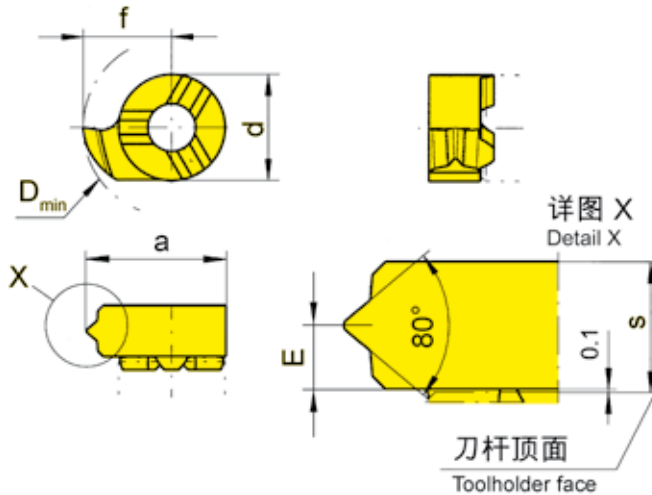
108



每英寸牙数	Threads per inch	18 / 20
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配合 刀杆
for use with Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

螺纹轮廓PG
Thread profile PG

产品型号 Part number	每英寸螺牙数 Threads per Inch	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R108.PG18.02	18	1.9	3.6	4.8	7.8	6	8		▲		
R108.PG20.02	20							▲			
<ul style="list-style-type: none"> ▲ 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			

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

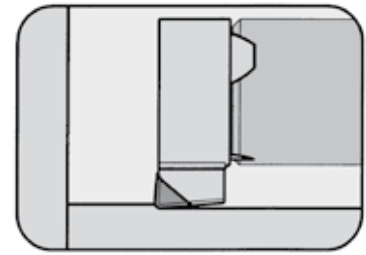
硬质合金牌号
Carbide grades

硬镗削 HARD BORING

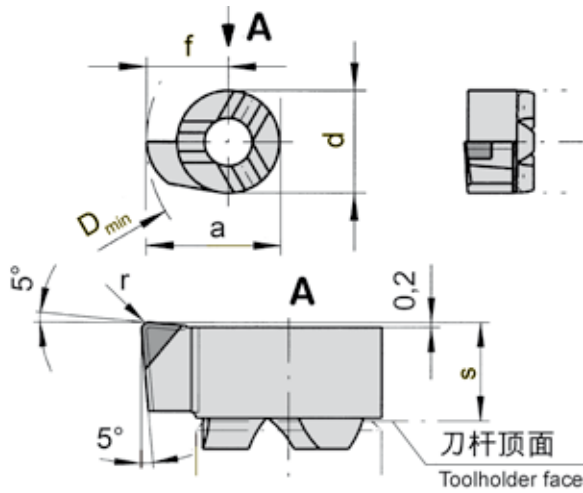


刀片 型号
INSERT Type

108



孔径最小至 Bore Ø from 7.8 mm



配合 刀杆
for use with Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

CBN刀片
CBN tipped

产品型号 Part number	r	s	f	a	d	D _{min}	CB10
R108.0547.03.B	0.3	3.5	4.65	7.65	6	7.8	▲
▲ 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 •

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

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									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•	•	•	•	•	•	
螺纹切削 / Threading	•		•	•	•	•		•	•	
倒角 / Chamfering	•		•	•	•	•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•	•	•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

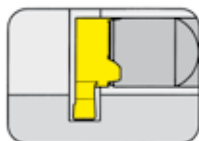
型号 10P
type

B10P
刀柄
Toolholder

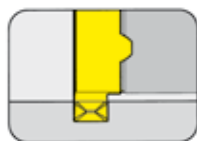


页 / Page
E2-E4

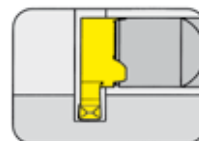
10P / S10P
≥ Ø 9,0 mm
刀片
Inserts



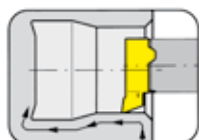
页 / Page
E5, E7



页 / Page
E6



页 / Page
E8



页 / Page
E9



技术说明
Technical Instructions

页
Page M1-M7

切槽和镗孔

GROOVING and BORING

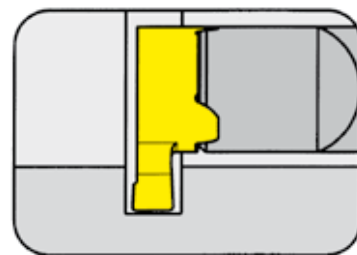


刀杆 型号

TOOLHOLDER Type

B10P

带内冷
with through coolant supply

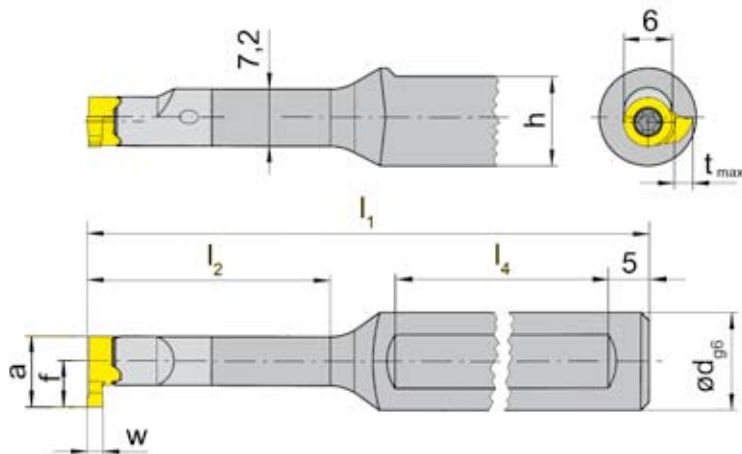


孔径最小至	Bore \varnothing from	9.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽可达	Width of groove up to	3.0 mm

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 10P
Type S10P



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	l_2	h	l_4
R/LB10P.0012.00	12	70	12.5	11	40
R/LB10P.0012.01		80	21.0		45
R/LB10P.0012.02		90	30.0		45
R/LB10P.0012.03		100	42.0		45

注明R或L型
State R or L version

w, a, t_{max} 和 f 见刀片
w, a, t_{max} and f see inserts

单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB10P.0012.0...	2.6.5T8EP	T8PL

切槽和镗孔

GROOVING and BORING

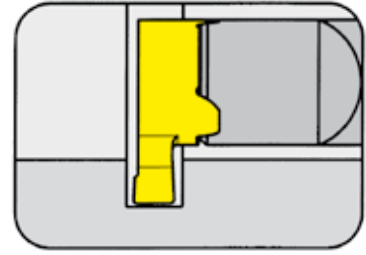


刀杆 型号

TOOLHOLDER Type

B10P

带内冷
with through coolant supply

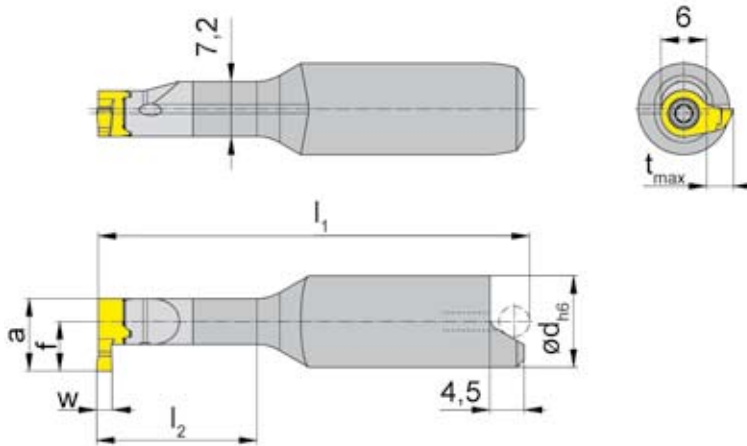


孔径最小至	Bore \varnothing from	9.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽可达	Width of groove up to	3.0 mm

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 10P
Type S10P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

用于收缩型定位
S=方向
for shrinkage location
S = orientation

产品型号 Part number	d	l_1	l_2
R/LB10P.0012.00S	12	48.7	12.5
R/LB10P.0012.01S		56.7	21.0
R/LB10P.0012.02S		65.7	30.0

注明R或L型
State R or L version

w, a, t_{max} 和 f 见刀片
 w, a, t_{max} and f see inserts

单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB10P.0012.0...	2.6.5T8EP	T8PL

切槽和镗孔

GROOVING and BORING

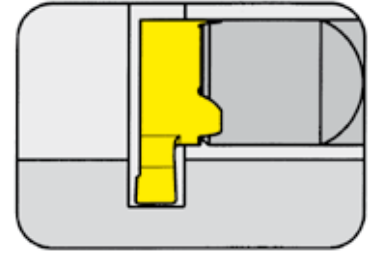


刀杆 型号

TOOLHOLDER Type

B10P

带内冷
with through coolant supply

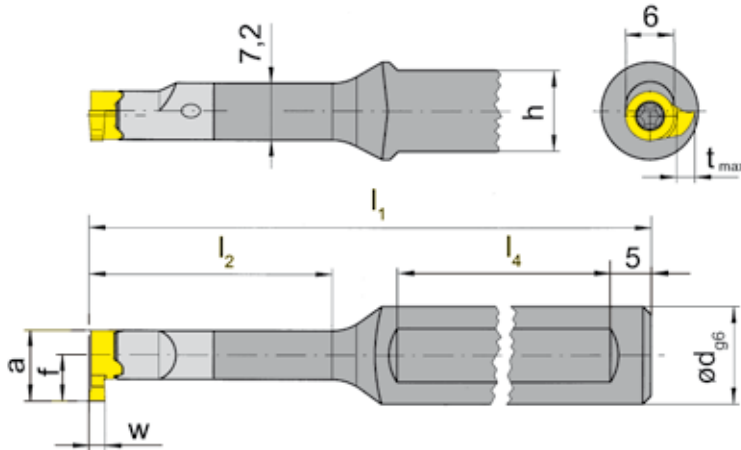


孔径最小至	Bore \varnothing from	9.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽可达	Width of groove up to	3.0 mm

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 10P
Type S10P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带2个夹持面
with 2 clamping flats

产品型号 Part number	d	l_1	l_2	h	l_4
R/LB10P.0012.2.00	12	70	12.5	11	40
R/LB10P.0012.2.01		80	21.0		45
R/LB10P.0012.2.02		90	30.0		45
R/LB10P.0012.2.03		100	42.0		45

注明R或L型
State R or L version

w, a, t_{max} 和 f 见刀片
w, a, t_{max} and f see inserts

单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:
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
R/LB10P.0012.2.0...	2.6-5T8EP	T8PL

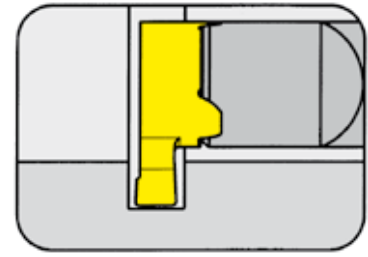
切槽 (内圆) $\geq \text{Ø} 9.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

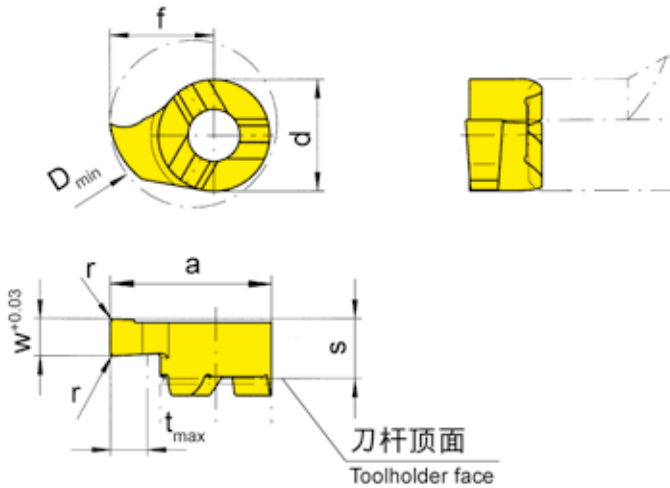
10P



孔径最小至	Bore Ø from	9.0 mm
槽深可达	Depth of groove up to	2.0 mm
槽宽	Width of groove	1.0 - 3.0 mm

配合刀杆
for use with Toolholder

型号 B10P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L10P.0100.1.00	1.0	-										▲/▲
R/L10P.0150.1.00	1.5	-										▲/▲
R/L10P.0200.1.02	2.0	0.2	3.6	5.5	8.5	6	2	9				▲/▲
R/L10P.0250.1.02	2.5	0.2										▲/▲
R/L10P.0300.1.02	3.0	0.2										▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

E

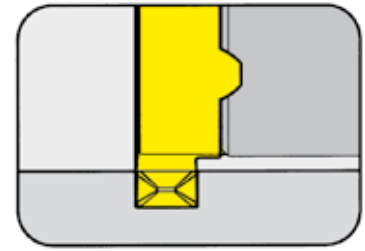
切槽 (内圆) $\geq \text{Ø} 9.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

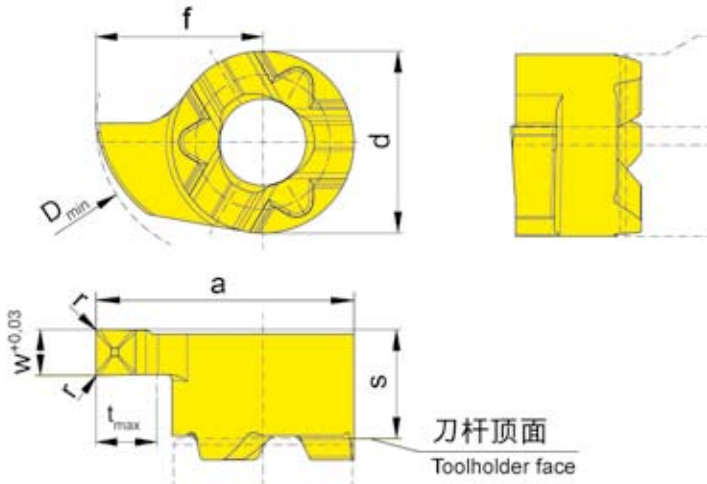
S10P



孔径最小至	Bore Ø from	9.0 mm
槽深可达	Depth of groove up to	2.0 mm
槽宽	Width of groove	1.0 - 2.0 mm

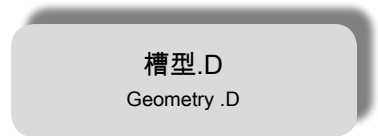
配合刀杆
for use with Toolholder

型号 B10P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/LS10P.0100.1.D1	1.0	0.1										▲/△	
R/LS10P.0150.1.D1	1.5	0.1	3.6	5.5	8.5	6	2	9				▲/△	
R/LS10P.0200.1.D2	2.0	0.2										▲/△	
▲ 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			

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

硬质合金牌号
Carbide grades

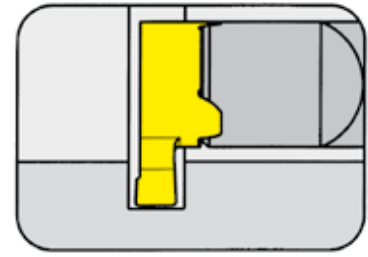
切槽 (内圆) $\geq \varnothing 10.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

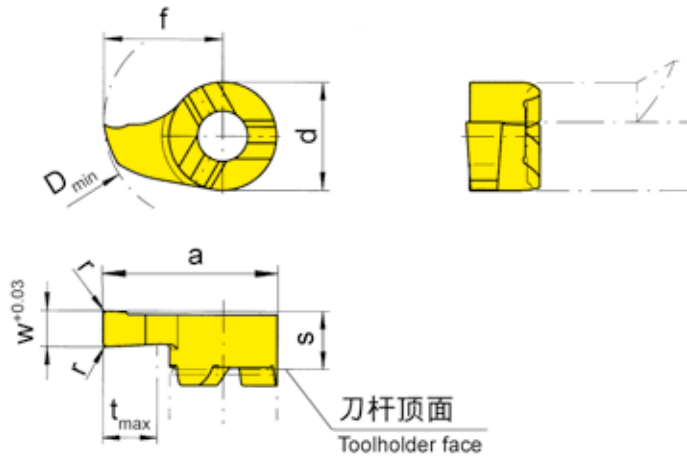
10P



孔径最小至	Bore \varnothing from	10.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.0 - 2.0 mm

配合 刀杆
for use with Toolholder

型号 B10P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L10P.0100.2.00	1.0	-	-	-	-	-	-	-				▲/△
R/L10P.0150.2.00	1.5	-	3.6	6.5	9.5	6	3	10				▲/▲
R/L10P.0200.2.02	2.0	0.2	-	-	-	-	-	-				▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades



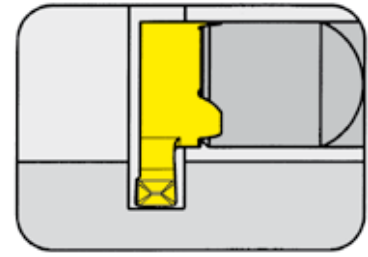
切槽 (内圆) $\geq \varnothing 10.0$ mm

GROOVING (internal)



刀片型号
INSERT Type

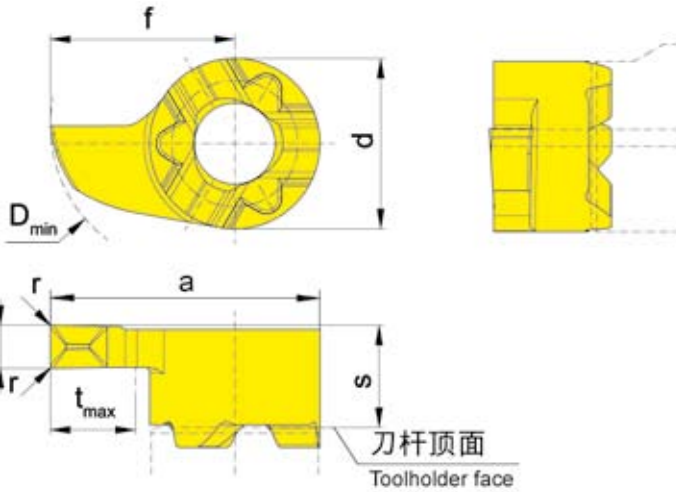
S10P



孔径最小至	Bore \varnothing from	10.0 mm
槽深可达	Depth of groove up to	3.0 mm
槽宽	Width of groove	1.5 - 2.0 mm

配合刀杆
for use with Toolholder

型号 B10P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/LS10P.0150.2-D1	1.5	0.1	3.6	6.5	9.5	6	3	10				▲/△
R/LS10P.0200.2-D2	2.0	0.2	3.6	6.5	9.5	6	3	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			

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

硬质合金牌号
Carbide grades

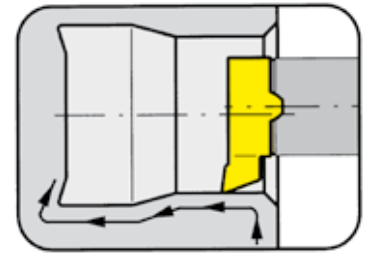
镗孔和仿形加工 $\geq \text{Ø} 8.8 \text{ mm}$

BORING and PROFILING

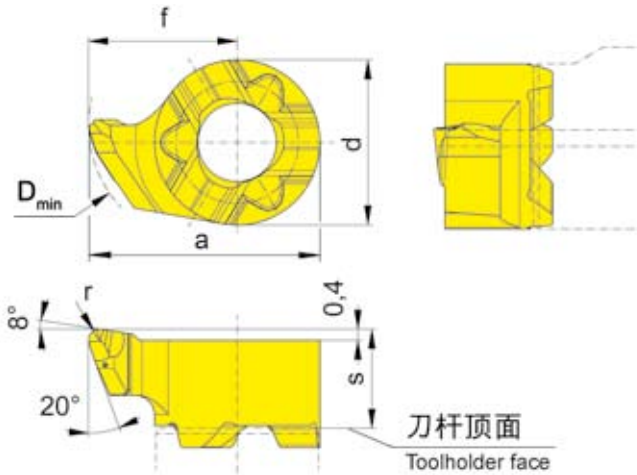


刀片型号
INSERT Type

S10P



孔径最小至 Bore Ø from 8.8 mm



配合刀杆
for use with Toolholder

型号 B10P
Type

E

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35	
LS10P.1854.R2	0.2									▲	
RS10P.1854.R2	0.2					8.8				▲	
LS10P.1854.R4	0.4	3.6	5.4	8.4	6					▲	
RS10P.1854.R4	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				

硬质合金牌号
Carbide grades

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

改进后的几何结构可以镗 $\geq \text{Ø} 8.8 \text{ mm}$ 的孔和仿形加工DIN509E型和F型的退刀槽。

The modified geometry allows boring of bores $\geq \text{Ø} 8.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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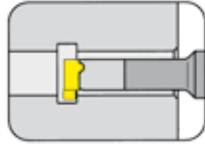
可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

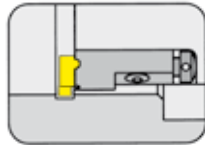
型号 111
type

B111
刀柄
Toolholder



页 / Page
F2-F4

R/L125
刀柄
Toolholder

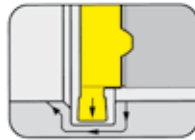


页 / Page F5

111 / S111
 $\geq \varnothing 11,0 \text{ mm}$
刀片
Inserts



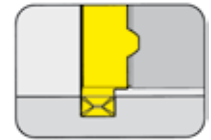
页 / Page
F6



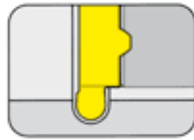
页 / Page
F8



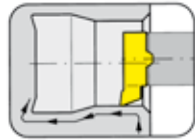
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F7, F9



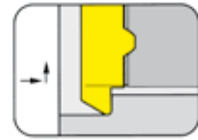
页 / Page
F10



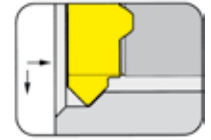
页 / Page
F11



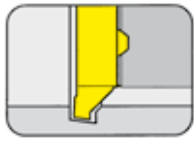
页 / Page
F12-F13, F15



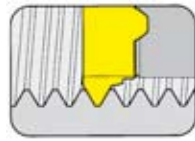
页 / Page
F14



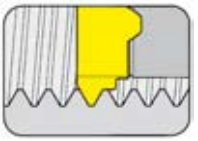
页 / Page
F16



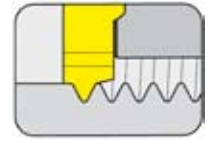
页 / Page
F17



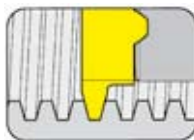
页 / Page
F18-F19



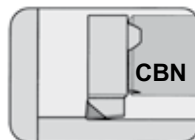
页 / Page
F20-F21



页 / Page
F22



页 / Page
F23



页 / Page
F24

F

切槽和镗孔

GROOVING and BORING

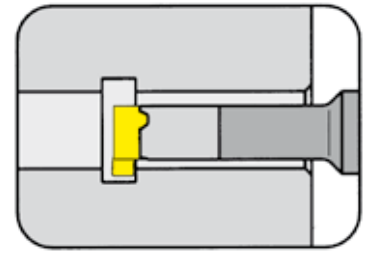


刀杆 型号

TOOLHOLDER Type

B111

带内冷
with through coolant supply

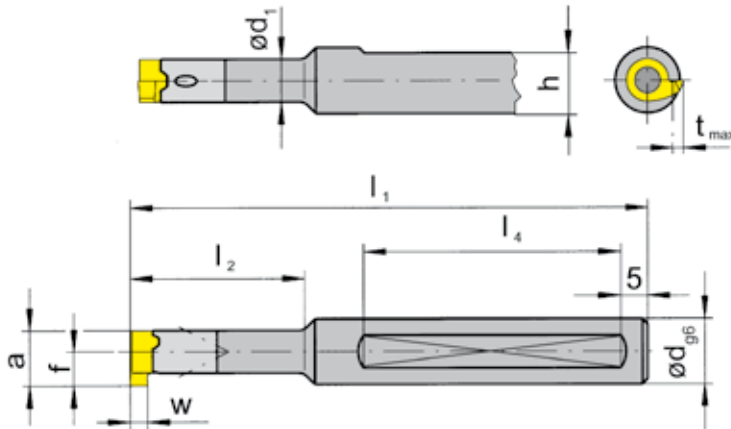


孔径最小至	Bore Ø from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽可达	Width of groove up to	3.0 mm

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 S111



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	l ₄	d ₁
B111.0008.01A	8	80	-	-	-	-
B111.0012.00	12	75	16.5	11	40	8
B111.0012.01		95	29.0		50	
B111.0012.02		110	42.0		50	
B111.0012.03		120	56.0		50	

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

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
B111.00...	3.5.12T10EP	T10PL

切槽和镗孔

GROOVING and BORING

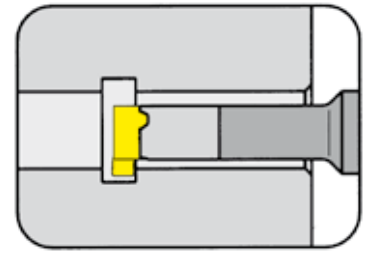


刀杆 型号

TOOLHOLDER Type

B111

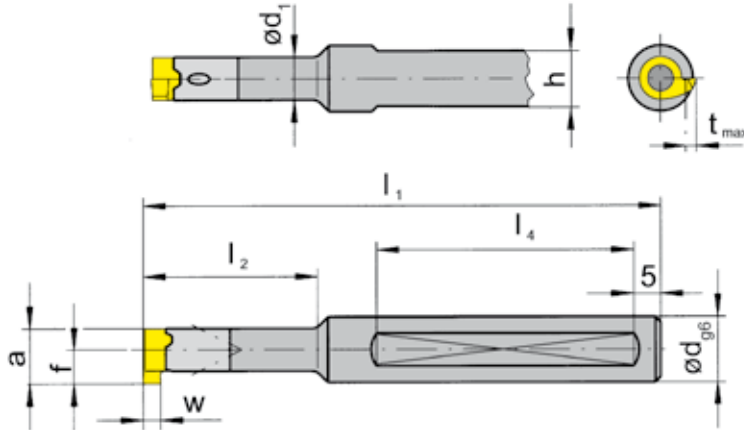
带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	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 S111

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_1	l_2	h	l_4	d_1
B111.0012.2.00	12	75	16.5	11	40	8
B111.0012.2.01		95	29.0		50	
B111.0012.2.02		110	42.0		50	
B111.0012.2.03		120	56.0		50	

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

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
B111.0012.2.0...	3.5.12T10EP	T10PL

切槽和镗孔

GROOVING and BORING

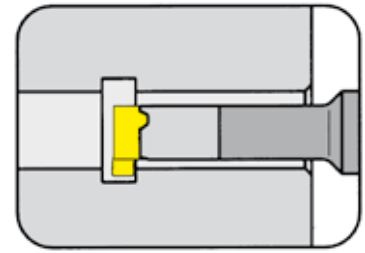


刀杆 型号

TOOLHOLDER Type

B111

带内冷
with through coolant supply

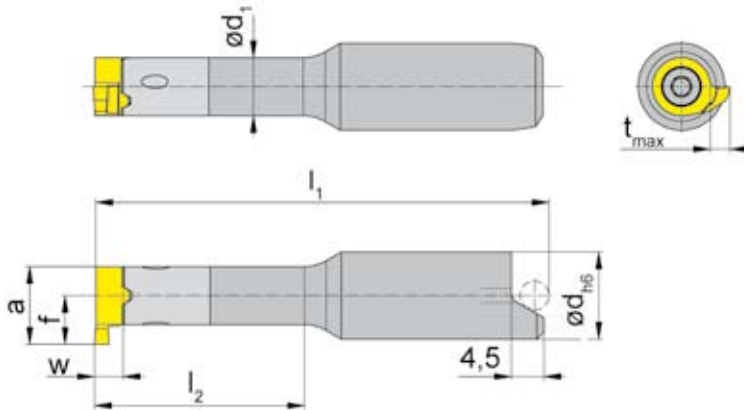


孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽可达	Width of groove up to	3.0 mm

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 S111



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_1	l_2	f	d_1
B111.0012.00S	12	50.7	16.5	6.7	8
B111.0012.01S		62.7	29.0		
B111.0012.02S		75.7	42.0		
B111.0012.03S		89.7	56.0		

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

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
B111.0012.0...	3.5.12T10EP	T10PL

切槽 (内圆) $\geq \varnothing 20.0$ mm

GROOVING (internal)

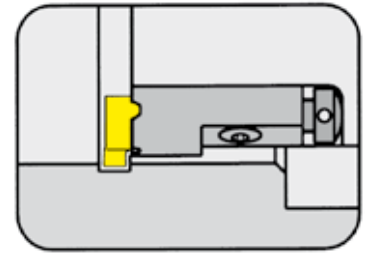


刀夹 型号

CARTRIDGE Type

125

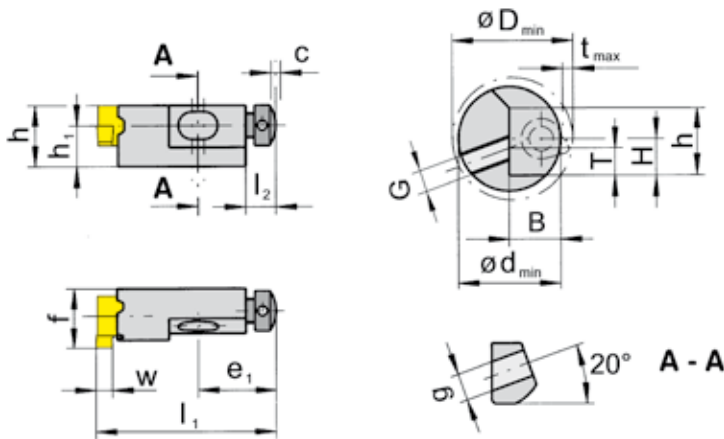
for customized tools
for customized tools



孔径最小至	Bore \varnothing from	20.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽可达	Width of groove up to	3.0 mm

配合 刀片
for use with Insert

型号 111
Type S111



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	l_1	D_{min}	t_{max}	e_1	l_2	c	g	夹持范围 Clamping range
R/L125.0608.00	6	11.2	10	30	20	2.3	12.8	5	2	4.5	0.5 - 3.0

注明R或L型
State R or L version

w见刀片
w see inserts

单位: mm
Dimensions in mm

切削刃高度 h_1
根据客户需要也可以使高度 $h_1=5$ mm
Height of cutting edge h_1
Special height $h_1 = 5$ mm available 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.

刀夹型号 Seating sizes	H	T	B	G	d_{min}	h
R/L125.0608.00	6	4.5	8.5	M4	16	10

附件
Spare parts

刀夹 Cartridge	螺钉 Screw	螺钉 Screw	轴向调节螺钉 Adjust screw axial	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L125.0608.00	4.12.125	3.5.12T10EP	4.06.020	T10PL

F

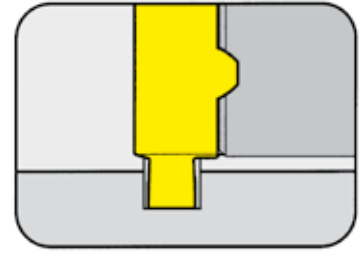
切槽 (内圆) $\geq \varnothing 11.0$ mm

GROOVING (internal)



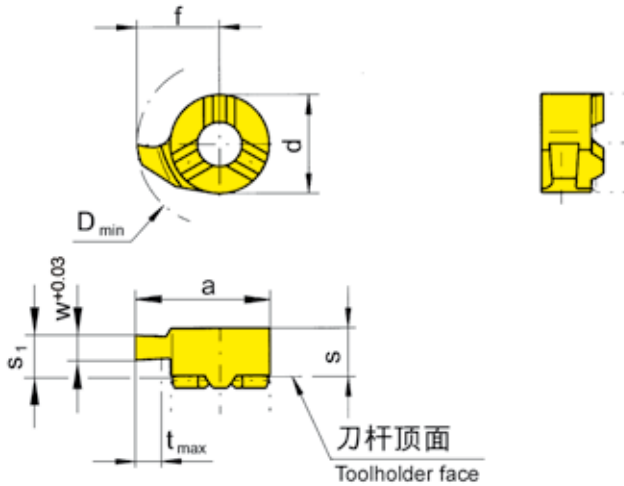
刀片型号
INSERT Type

111



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	1.5 mm
卡簧槽Nw	Width of circlip Nw	0.7 - 0.9 mm

卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



配合刀杆
for use with Toolholder

型号 125
Type B111

F

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

不能端面切削，
受切深限制，
not face cutting,
limited depth of cut

产品型号 Part number	Nw	w	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.0070.00	0.7	0.74						1.2			▲/▲		▲/▲
R/L111.0080.00	0.8	0.84	3.95	4.15	6.7	10.7	8	1.3	11		▲/▲		▲/▲
R/L111.0090.00	0.9	0.94						1.5		▲/▲	▲/▲		▲/▲
										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

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

硬质合金牌号
Carbide grades

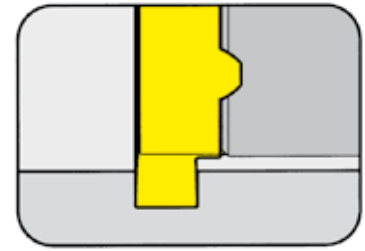
切槽 (内圆) $\geq \varnothing 11.0 \text{ mm}$ GROOVING (internal)



刀片 型号

INSERT Type

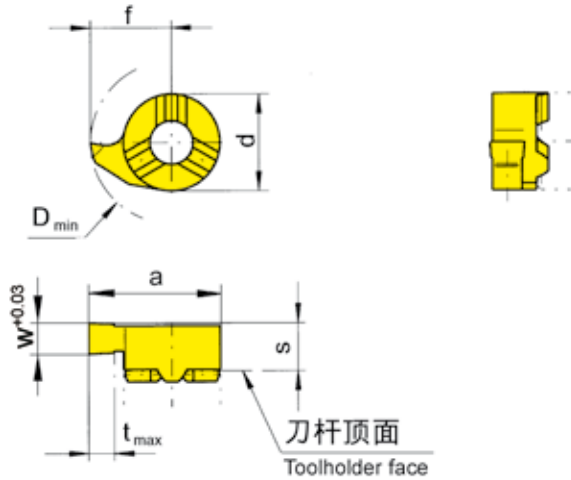
111



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
卡簧槽Nw	Width of circlip Nw	1.1 - 1.6 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合 刀杆

for use with Toolholder

型号 125

Type B111

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	Nw	w	s	f	a	d	t _{max}	D _{min}	硬质合金牌号			
									MG12	TN35	TI25	TH35
R/L111.0110.00	1.1	1.19							▲/▲	▲/▲		▲/▲
R/L111.0130.00	1.3	1.39	3.95	6.7	10.7	8	2.3	11	▲/▲	▲/▲		▲/▲
R/L111.0160.00	1.6	1.69							▲/▲	▲/▲		▲/▲
									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

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

硬质合金牌号

Carbide grades

NC-仿形加工 (内圆) $\geq \varnothing 11.0$ mm

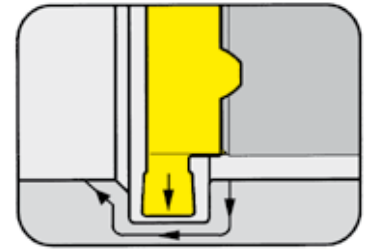
NC-PROFILING (internal)



刀片型号

INSERT Type

111



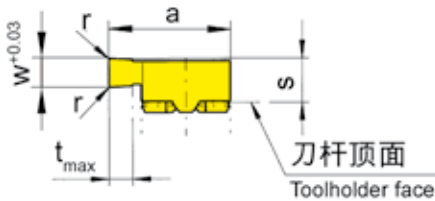
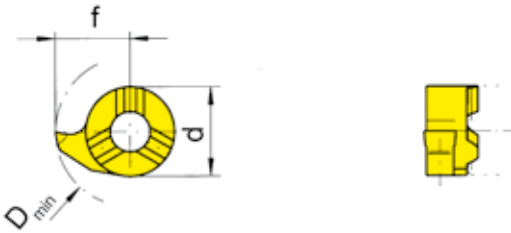
孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽	Width of groove	2.0 mm

配合刀杆

for use with Toolholder

型号 125

Type B111



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	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.0200.02	2	0.2	3.95	6.7	10.7	8	2.3	11	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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												

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

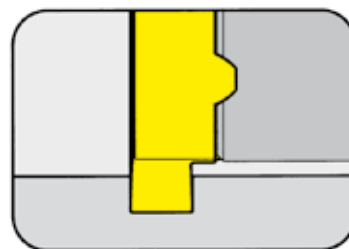
切槽 (内圆) $\geq \varnothing 11.0$ mm GROOVING (internal)



刀片型号

INSERT Type

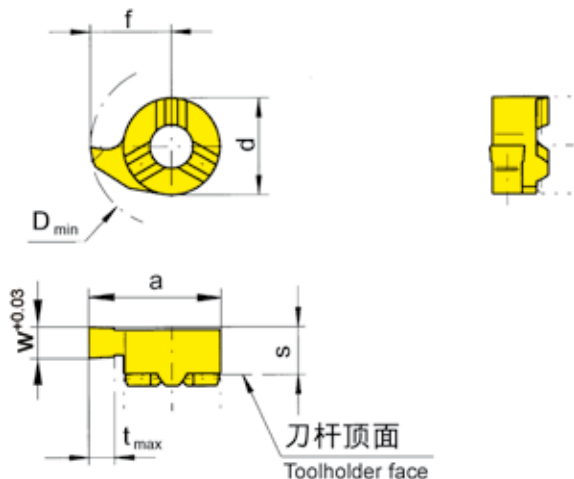
111



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽	Width of groove	1.5 - 3.0 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



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	f	a	d	t_{max}	D_{min}	硬质合金牌号			
								MG12	TN35	TI25	TH35
R/L111.0150.00	1.5							▲/▲	▲/▲		▲/▲
R/L111.0200.00	2.0							▲/▲	▲/▲		▲/▲
R/L111.0250.00	2.5	3.95	6.7	10.7	8	2.3	11	▲/▲	▲/▲		▲/▲
R/L111.0300.00	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

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

硬质合金牌号
Carbide grades



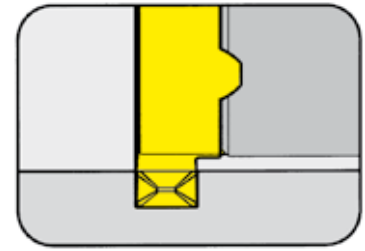
切槽 (内圆) $\geq \varnothing 11.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

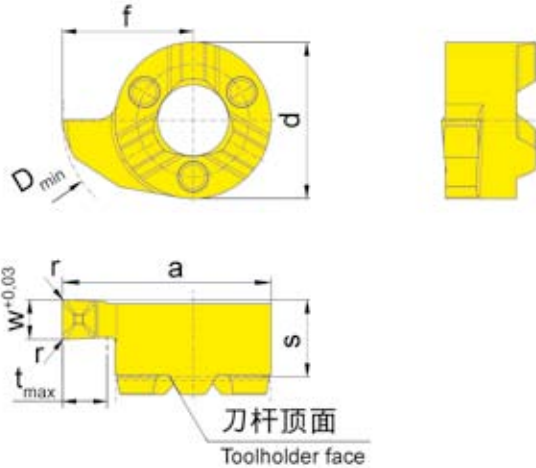
S111



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
槽宽	Width of groove	1.5 - 2.5 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/LS111.0150.D1	1.5	0.1										▲/△	
R/LS111.0200.D2	2.0	0.2	3.95	6.7	10.7	8	2.3	11				▲/▲	
R/LS111.0250.D2	2.5	0.2										▲/△	
▲ 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			

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

硬质合金牌号
Carbide grades

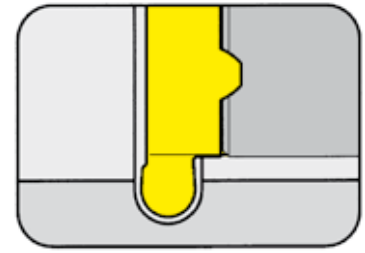
切槽 (内圆) $\geq \varnothing 11.0$ mm

GROOVING (internal)



刀片型号
INSERT Type

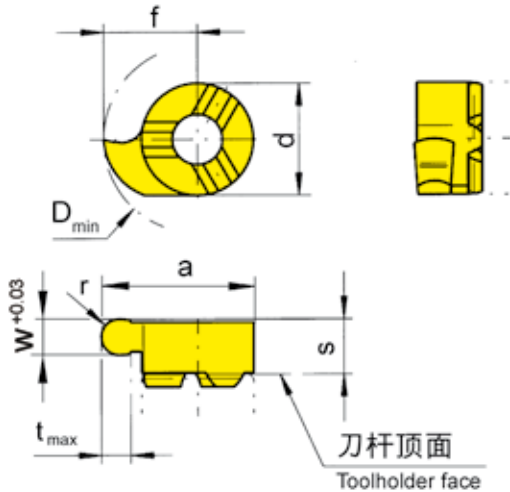
111



孔径最小至	Bore \varnothing from	11.0 mm
槽深可达	Depth of groove up to	2.3 mm
圆头	Full radius	r 0.4 - 1.5 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



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	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.0004.08	0.8	0.4								▲/▲		▲/▲
R/L111.0006.12	1.2	0.6							▲/▲	▲/▲		▲/▲
R/L111.0009.18	1.8	0.9	3.95	6.7	10.7	8	2.3	11	▲/▲	▲/▲		▲/▲
R/L111.0010.20	2.0	1.0							▲/▲	▲/▲		▲/▲
R/L111.0015.30	3.0	1.5							▲/▲	▲/▲		▲/▲
									P	o	•	•
									M	•	•	•
									K	•	•	•
									N	•	•	•
									S	•	•	•
									H			

▲ 库存 / on stock Δ 4周 / 4 weeks
 • 主要应用 / main recommendation
 o 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

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

硬质合金牌号
Carbide grades



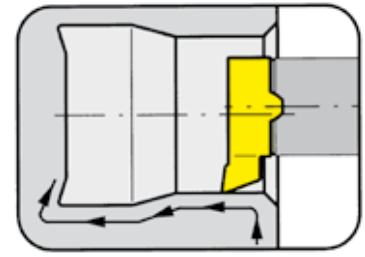
镗孔和仿形加工 $\geq \text{Ø} 9.8 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

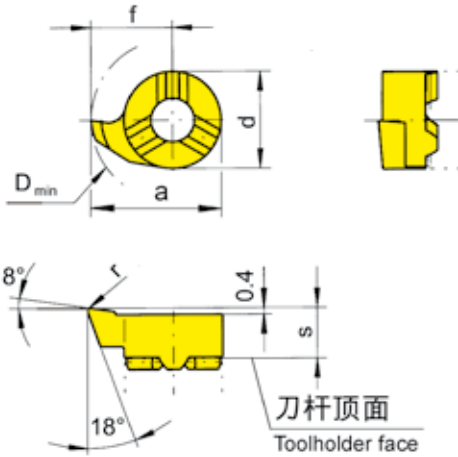
111



孔径最小至 Bore Ø from 9.8 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



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	r	s	f	a	d	D _{min}	硬质合金牌号 Carbide grades				
							MG12	TN35	TI25	TH35	
R/L111.1855.02	0.2	3.95	5.5	9.5	8	9.8	▲/▲	▲/▲	▲/▲	▲/▲	
R/L111.1867.02	0.2	3.95	6.7	10.7	8	11.0	▲/▲	▲/▲	▲/▲	▲/▲	
<ul style="list-style-type: none"> ▲ 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				

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

改进过的几何结构可以镗 $\geq \text{Ø} 9.8 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 9.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

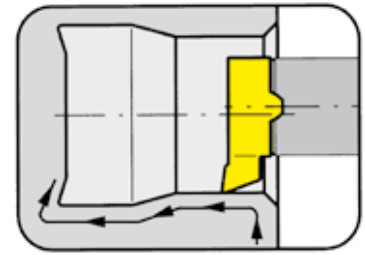
镗孔和仿形加工 $\geq \varnothing 11.0$ mm

BORING and PROFILING



刀片型号
INSERT Type

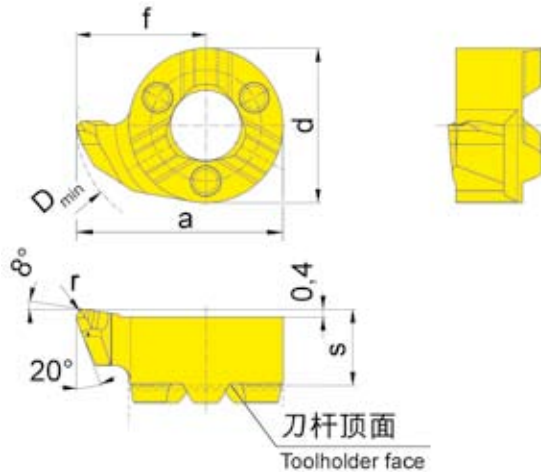
S111



孔径最小至 Bore \varnothing from 11.0 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
LS111.1867.R2	0.2									▲
RS111.1867.R2	0.2									▲
LS111.1867.R4	0.4	3.95	6.7	10.7	8	11				▲
RS111.1867.R4	0.4									▲
							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

P			•
M			•
K			•
N			•
S			•
H			

硬质合金牌号
Carbide grades

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

改进过的几何结构可以镗 $\geq \varnothing 11.0$ mm的孔，也可以仿形车DIN509标准E和F形式的退刀槽。
The modified geometry allows boring of bores $\geq \varnothing 11.0$ mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request



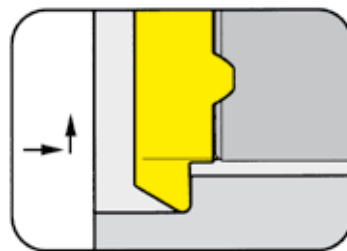
背镗 (内圆) $\geq \varnothing 11.0 \text{ mm}$ BACKBORING (internal)



刀片 型号

111

INSERT Type



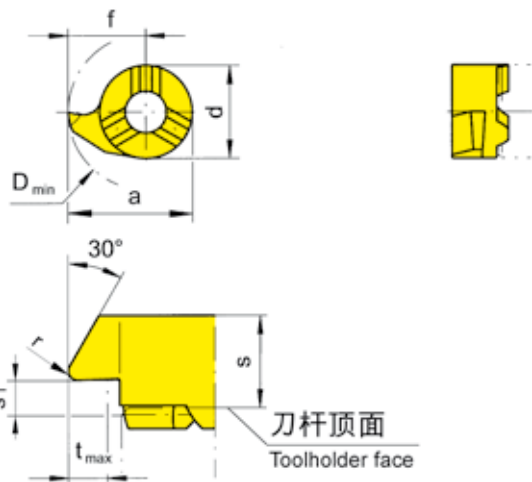
孔径最小至
向下切深可达

Bore \varnothing from
Depth of undercut up to

11.0 mm
2.3 mm

配合 刀杆
for use with Toolholder

型号 125
Type B111



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	r	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.3067.02	0.2	1.4	4.15	6.7	10.7	8	2.3	11		▲/▲		▲/▲
R/L111.3067.04	0.4									/▲		▲/▲
▲ 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			

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

硬质合金牌号

Carbide grades

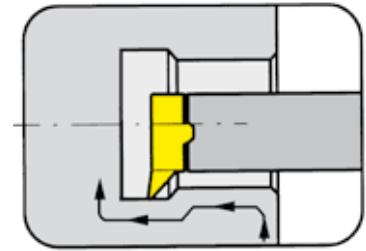
镗孔和仿形加工 $\geq \varnothing 11.0$ mm

BORING and PROFILING



刀片型号
INSERT Type

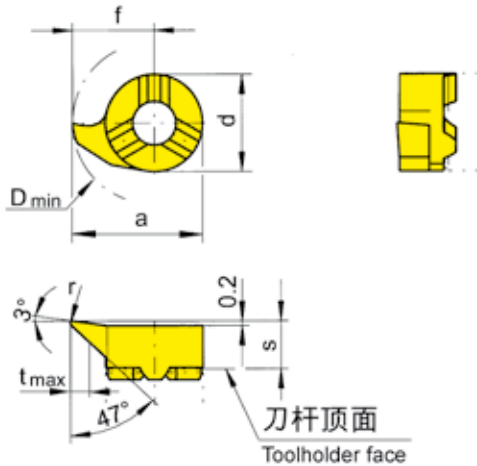
111



孔径最小至 向下切深可达	Bore \varnothing from Depth of undercut up to	11.0 mm 2.3 mm
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配合 刀杆
for use with Toolholder

型号 125
Type B111



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	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.4767.02	0.2	3.95	6.7	10.7	8	2.3	11		▲/▲	▲/▲	▲/▲
R/L111.4767.04	0.4							/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			

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

改进后的几何结构可以镗 $\geq \varnothing 11.0$ mm孔和加工DIN509E型退刀槽
The modified geometry allows boring of bores $\geq \varnothing 11.0$ mm and profiling of reliefs as per DIN 509 form E.

按需提供更多尺寸
Further sizes upon request



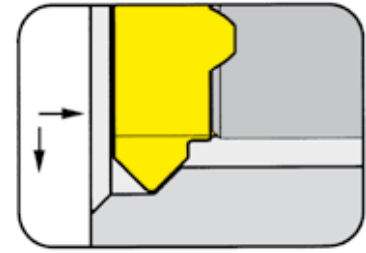
倒角和背镗 (内圆)

CHAMFERING and BACKBORING (internal)



刀片型号
INSERT Type

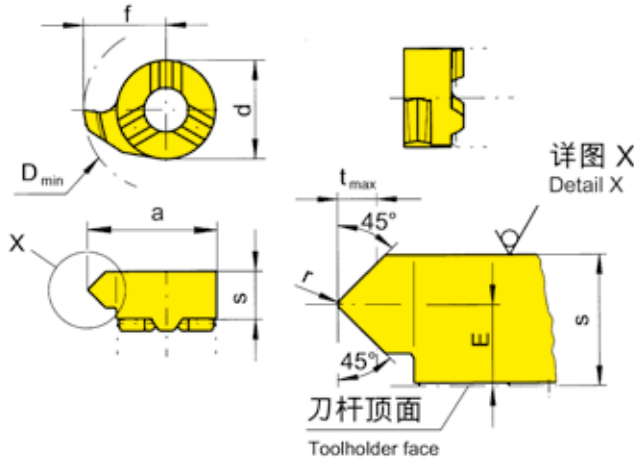
111



孔径最小至 切深可达	Bore \varnothing from Depth of cut up to	11.0 mm 1.5 mm
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配合 刀杆
for use with Toolholder

型号 125
Type B111



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	E	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.4545.02	2.4	0.2	4.15	6.7	10.7	8	1.5	11		▲/▲		
									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

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

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

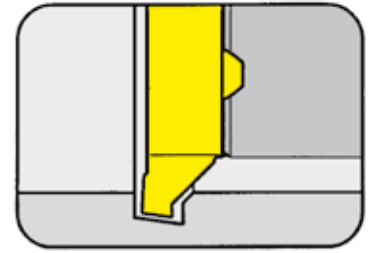
PREGROOVING and CHAMFERING (internal)



刀片型号

INSERT Type

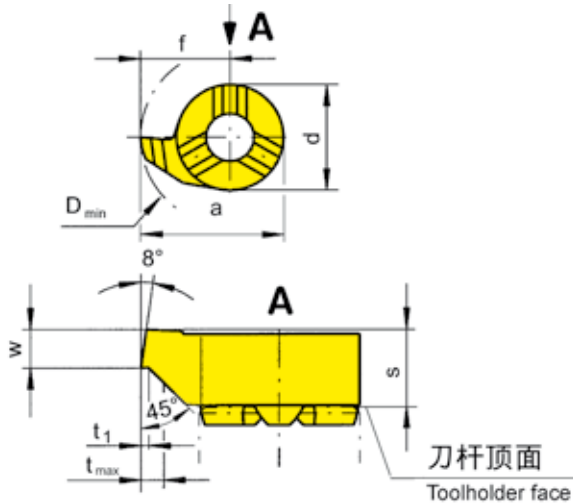
111



孔径最小至

Bore Ø from

11.0 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 125

Type B111

F

产品型号 Part number	w	s	f	a	d	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L111.0810.45	1	3.95	6.7	10.7	8	0.2	1.5	11	▲/△		▲/▲	
▲ 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			

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

硬质合金牌号
Carbide grades

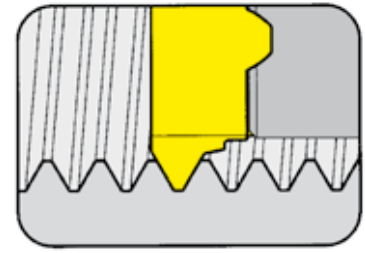
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

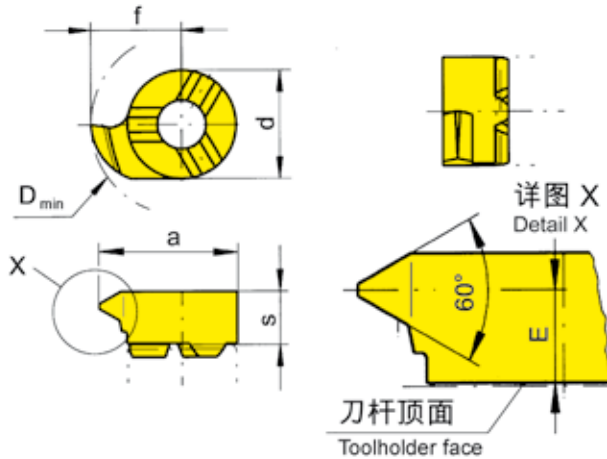
111



孔径最小至 螺距	Bore Ø from Pitch	11.0 mm 2.0 - 2.5 mm
-------------	----------------------	-------------------------

配合刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L111.1020.01	2.0	3.0	4.15	6.7	10.7	8	11	▲/▲	▲/▲	▲/▲	▲/▲
R/L111.1325.01	2.5	2.8	4.15	6.7	10.7	8	11	▲/▲	▲/▲	▲/▲	▲/▲

- ▲ 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
MG12	○	●	●	●	●	●
TN35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TH35	●	●	●	●	●	●

硬质合金牌号
Carbide grades

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

F

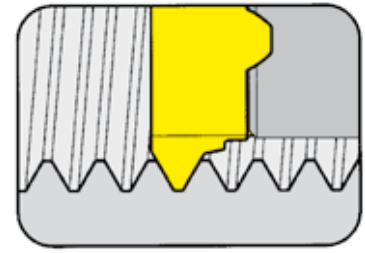
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

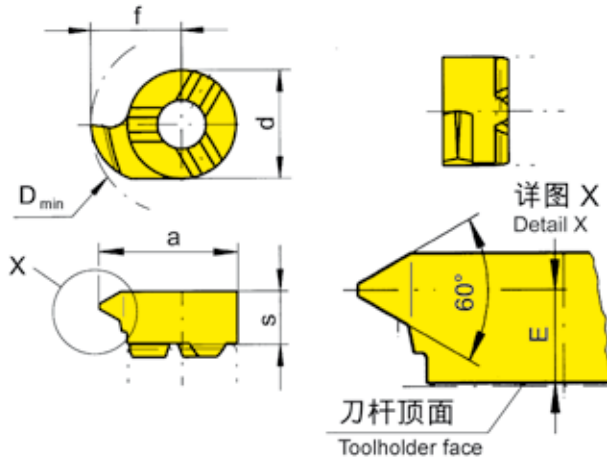
111



孔径最小至 螺距	Bore Ø from Pitch	11.00 mm 0.50 - 1.75 mm
-------------	----------------------	----------------------------

配合 刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L111.0205.01	0.5	0.75	3.5	4.15	6.7	10.7	8	11		▲/▲		▲/▲
R/L111.0510.01	1.0	1.25	3.3	4.15	6.7	10.7	8	11		▲/▲		▲/▲
R/L111.0815.01	1.5	1.75	3.3	4.15	6.7	10.7	8	11		▲/▲		▲/▲
									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

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

硬质合金牌号
Carbide grades



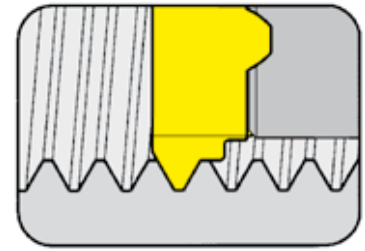
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

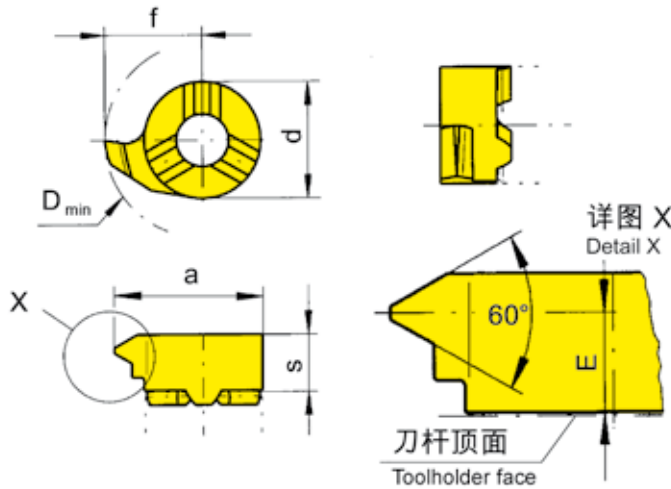
111



孔径最小至 螺距	Bore Ø from Pitch	11.0 mm 2.0 - 3.0 mm
-------------	----------------------	-------------------------

配合 刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L111.1020.02	2.0	3.0							▲/▲		
R/L111.1325.02	2.5	2.8	4.15	6.7	10.7	8	11	▲/▲			
R/L111.1630.02	3.0	2.8						▲/▲			

- ▲ 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

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

F

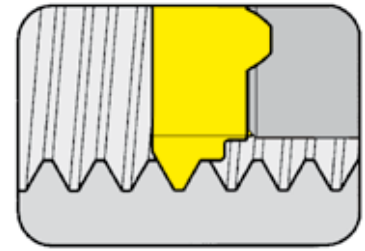
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

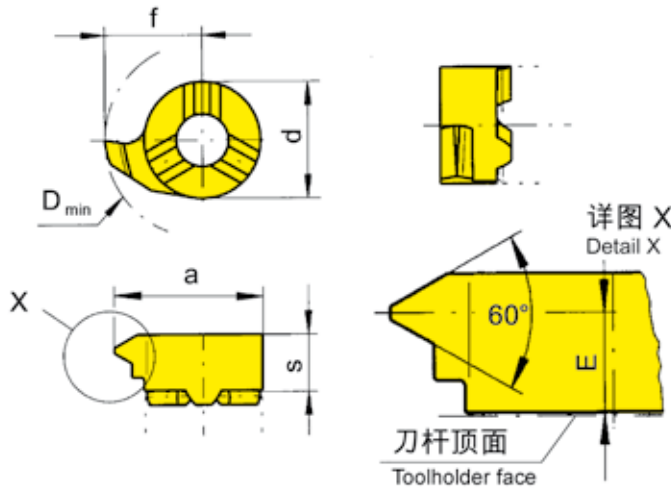
111



孔径最小至 螺距	Bore \varnothing from Pitch	11.0 mm 1.0 - 1.5 mm
-------------	----------------------------------	-------------------------

配合 刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L111.0510.02	1.0	3.3	4.15	6.7	10.7	8	11	▲/▲	▲/▲		
R/L111.0815.02	1.5							▲/▲	▲/▲		

- ▲ 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

	P	M	K	N	S	H
硬质合金牌号 Carbide grades	○	●	●	●	●	●

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



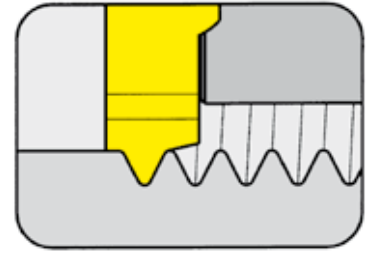
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

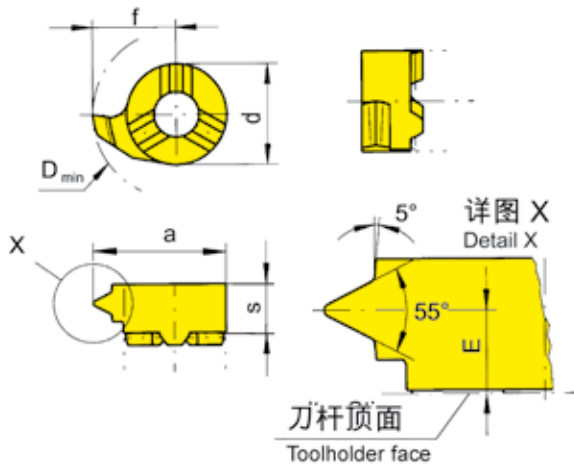
111



孔径最小至 每英寸牙数	Bore Ø from Threads per inch	11.0 mm 14/19
----------------	---------------------------------	------------------

配合 刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

惠氏管螺纹
DIN ISO228;(259)和2999
Whitworth pipe thread as per
DIN ISO 228; (259) and 2999

产品型号 Part number	每英寸螺牙数 Threads per Inch	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L111.5514.02	14	1.814	2.5	4.15	6.7	10.7	8	11		▲/▲		
R/L111.5519.02	19	1.337	2.9	4.15	6.7	10.7	8	11		▲/▲		
									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

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

F

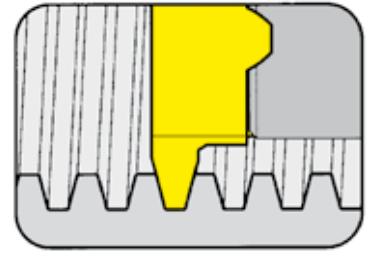
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

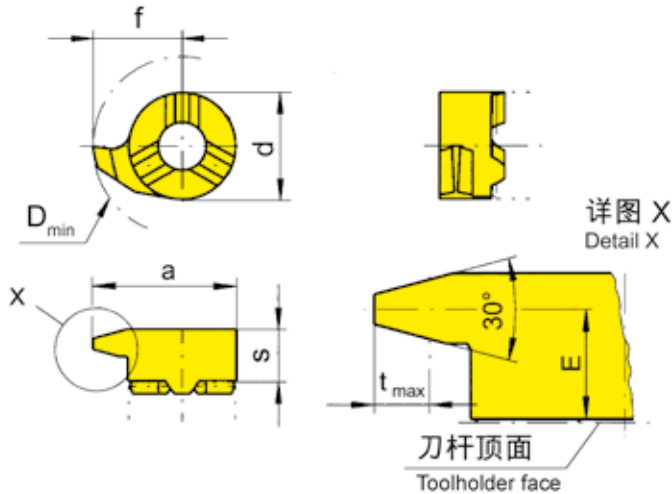
111



孔径最小至 螺距	Bore Ø from Pitch	11.0 mm 1.5 - 4.0 mm
-------------	----------------------	-------------------------

配合 刀杆
for use with Toolholder

型号 125
Type B111



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	s	f	a	d	D _{min}	硬质合金牌号			
								MG12	TN35	TI25	TH35
R/L111.1015.01	1.5	3.5						▲/△			
R/L111.1220.01	2.0	3.3						▲/▲			
R/L111.1730.01	3.0	3.0	4.15	6.7	10.7	8	11	▲/△	▲/▲		
R/L111.2240.01	4.0	2.5						▲/▲			
								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

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

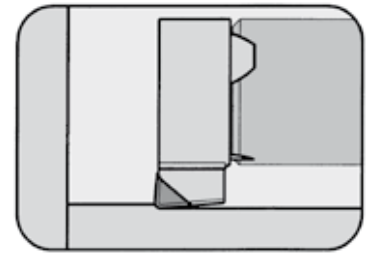
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades



刀片型号
INSERT Type

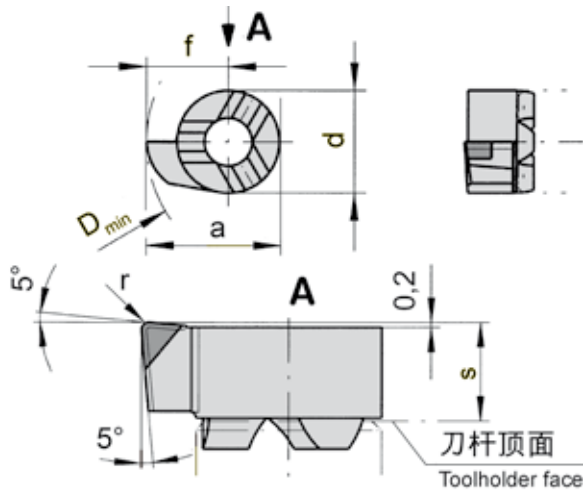
111



孔径最小至 Bore Ø from 10.0 mm

配合刀杆
for use with Toolholder

型号 125
Type B111



R=右手型-如图
R = right hand version shown

CBN刀片
CBN tipped

产品型号 Part number	r	s	f	a	d	D _{min}	CB10
R111.0557.03.B	0.3	3.95	5.7	9.7	8	10	▲
R111.0567.03.B	0.3	3.95	6.7	10.7	8	11	△

- ▲ 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

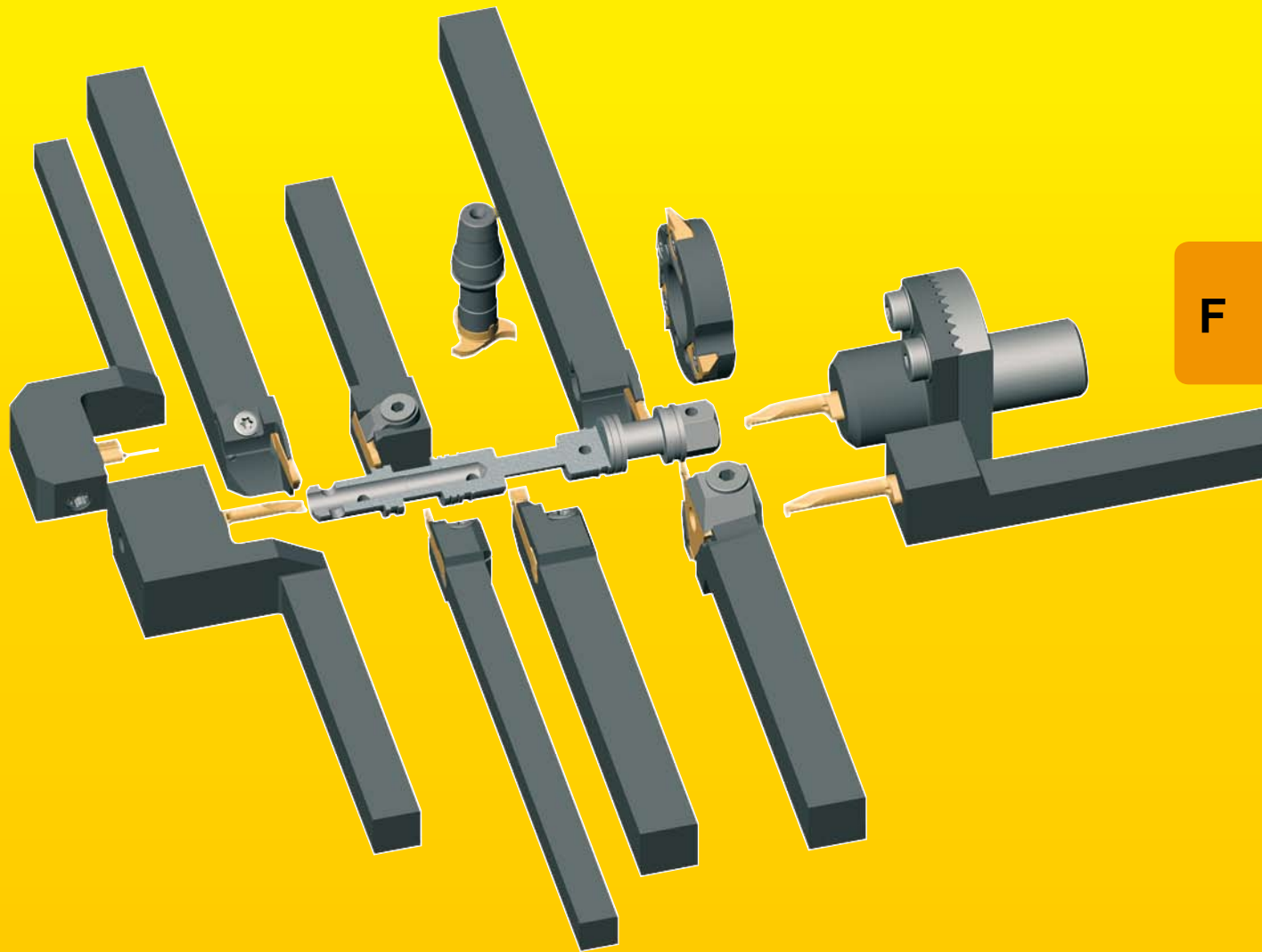
单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

P
M
K
N
S
H

完整的解决方案! The complete solution!



F

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.



HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

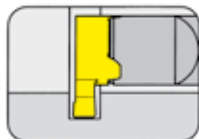
型号 11P
type

B11P
刀柄
Toolholder

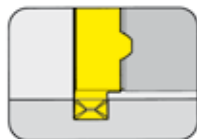


页 / Page
G2-G4

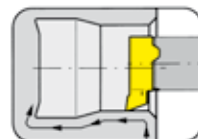
11P / S11P
≥ Ø 10,5 mm
刀片
Inserts



页 / Page
G5, G7



页 / Page
G6, G8



页 / Page
G9-G10

G

技术说明
Technical Instructions

页
Page M1-M7

切槽 (内圆) $\geq \varnothing 10.5 \text{ mm}$ GROOVING (internal)

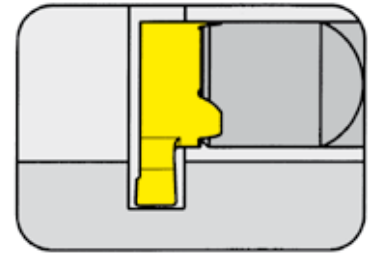


刀杆型号

TOOLHOLDER Type

B11P

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	10.5 mm
槽深可达	Depth of groove up to	3.5 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

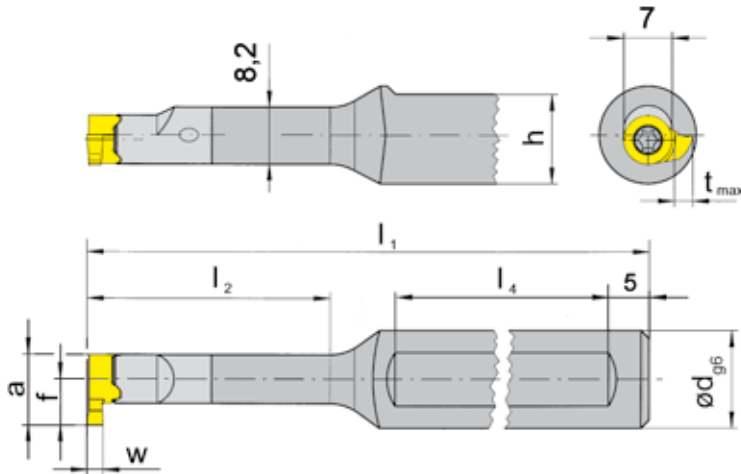
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片

for use with Insert

型号 11P

Type S11P



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	l_2	h	l_4
R/LB11P.0012.00	12	75	15	11	40
R/LB11P.0012.01		95	26		50
R/LB11P.0012.02		110	37		50
R/LB11P.0012.03		120	50		50

注明R或L型

State R or L version

w, a, t_{max} 和 f 见刀片

w, a, t_{max} and f see inserts

单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB11P.0012.0...	3.10T9P	T9PL

切槽 (内圆) $\geq \varnothing 10.5 \text{ mm}$ GROOVING (internal)

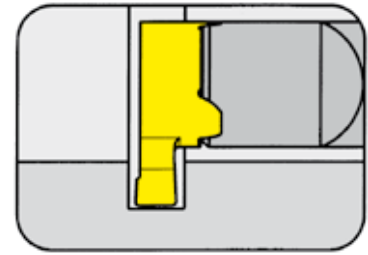


刀杆 型号

TOOLHOLDER Type

B11P

带内冷
with through coolant supply

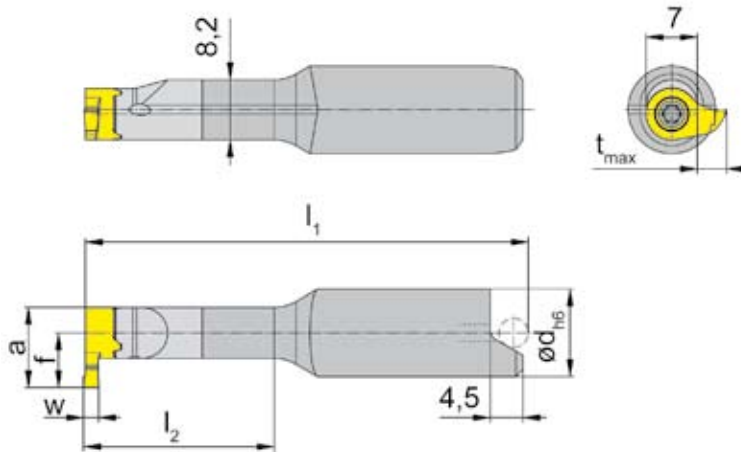


孔径最小至	Bore \varnothing from	10.5 / 11.5 mm
槽深可达	Depth of groove up to	3.5 mm
槽宽可达	Width of groove up to	3.0 mm

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 11P
Type S11P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

用于收缩型定位
S=方向
for shrinkage location
S = orientation

G

产品型号 Part number	d	l_1	l_2
R/LB11P.0012.00S	12	49.7	15
R/LB11P.0012.01S		60.7	26
R/LB11P.0012.02S		71.7	37

注明R或L型
State R or L version

w, a, t_{max} 和 f 见刀片
w, a, t_{max} and f see inserts

单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB11P.0012.0...	3.10T9P	T9PL

切槽 (内圆) $\geq \varnothing 10.5 \text{ mm}$ GROOVING (internal)

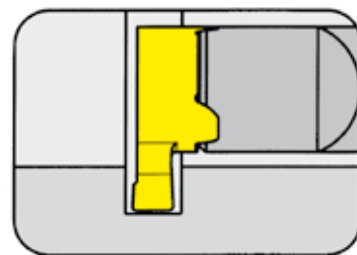


刀杆型号

TOOLHOLDER Type

B11P

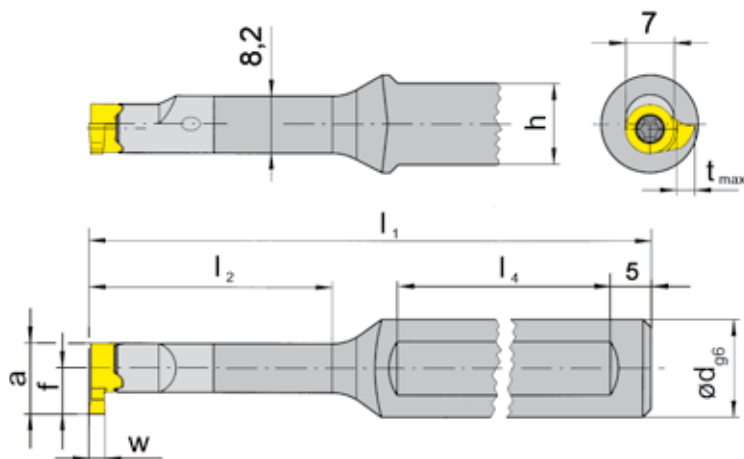
带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	10.5 mm
槽深可达	Depth of groove up to	3.5 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 11P

Type S11P

G

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

带2个夹持面

with 2 clamping flats

产品型号 Part number	d	l_1	l_2	h	l_4
R/LB11P.0012.2.00	12	75	15	11	40
R/LB11P.0012.2.01		95	26		50
R/LB11P.0012.2.02		110	37		50
R/LB11P.0012.2.03		120	50		50

注明R或L型

State R or L version

w, a, t_{max} 和 f 见刀片

w, a, t_{max} and f see inserts

单位: mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知:

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB11P.0012.2.0...	3.10T9P	T9PL

G4

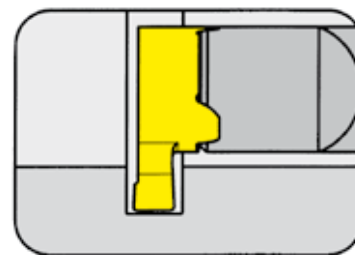
切槽 (内圆) $\geq \varnothing 10.5$ mm

GROOVING (internal)



刀片型号
INSERT Type

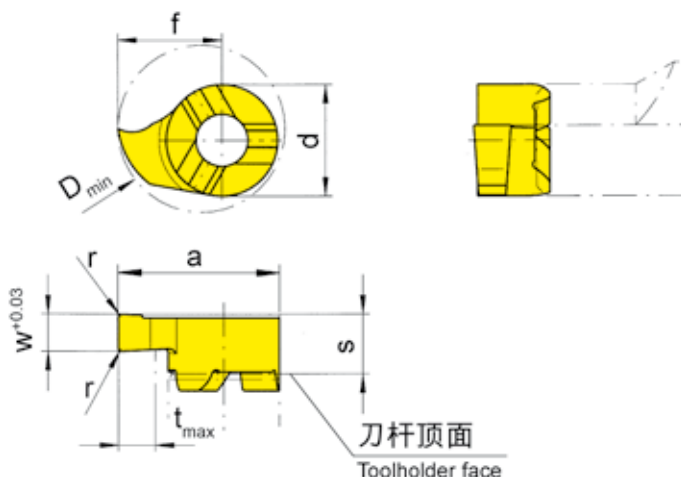
11P



孔径最小至	Bore \varnothing from	10.5 mm
槽深	Depth of groove	2.5 mm
槽宽可达	Width of groove up to	3.0 mm

配合刀杆
for use with Toolholder

型号 B11P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L11P.0100.1.00	1.0	-										▲/▲
R/L11P.0150.1.00	1.5	-										▲/▲
R/L11P.0200.1.02	2.0	0.2	4.2	6.5	10	7	2.5	10.5				▲/▲
R/L11P.0250.1.02	2.5	0.2										▲/▲
R/L11P.0300.1.02	3.0	0.2										▲/▲
									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

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

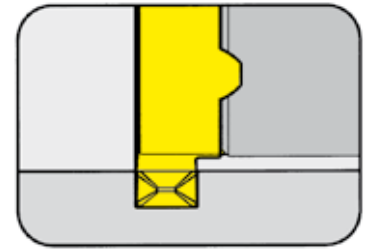


切槽 (内圆) $\geq \varnothing 10.5 \text{ mm}$ GROOVING (internal)



刀片型号
INSERT Type

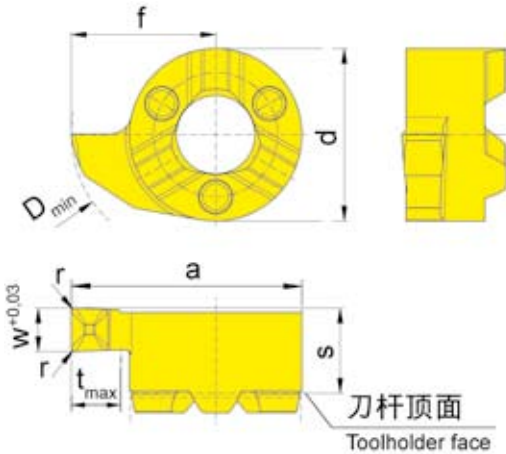
S11P



孔径最小至	Bore \varnothing from	10.5 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽	Width of groove	1.5 - 2.5 mm

配合刀杆
for use with Toolholder

型号 B11P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/LS11P.0150.1.D1	1.5	0.1										▲/△	
R/LS11P.0200.1.D2	2.0	0.2	4.2	6.5	10	7	2.5	10.5				▲/△	
R/LS11P.0250.1.D2	2.5	0.2										▲/△	
▲ 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										P			●
										M			●
										K			●
										N			●
										S			●
										H			

硬质合金牌号
Carbide grades

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

G

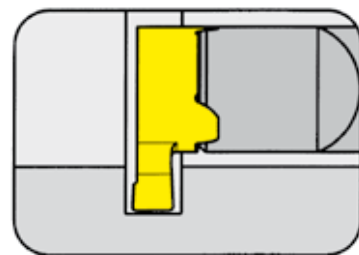
切槽 (内圆) $\geq \varnothing 11.5 \text{ mm}$ GROOVING (internal)



刀片型号

INSERT Type

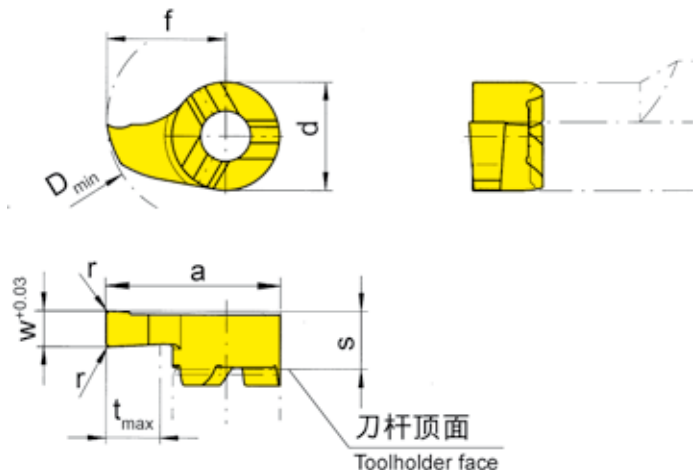
11P



孔径最小至	Bore \varnothing from	11.5 mm
槽深	Depth of groove	3.5 mm
槽宽可达	Width of groove up to	2.0 mm

配合 刀杆
for use with Toolholder

型号 B11P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L11P.0100.2.00	1.0	-	-	-	-	-	-	-				▲/△
R/L11P.0150.2.00	1.5	-	4.2	7.5	11	7	3.5	11.5				▲/▲
R/L11P.0200.2.02	2.0	0.2	-	-	-	-	-	-				▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades



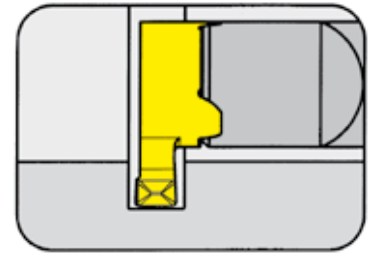
切槽 (内圆) $\geq \varnothing 11.5 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

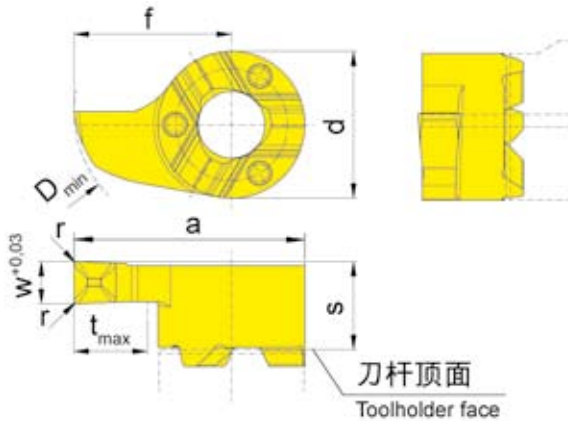
S11P



孔径最小至	Bore \varnothing from	11.5 mm
槽深可达	Depth of groove up to	3.5 mm
槽宽	Width of groove	1.5 - 2.5 mm

配合刀杆
for use with Toolholder

型号 B11P
Type



G

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/LS11P.0150.2.D1	1.5	0.1										▲/▲	
R/LS11P.0200.2.D2	2.0	0.2	4.2	7.5	11	7	3.5	11.5				▲/▲	
R/LS11P.0250.2.D2	2.5	0.2										▲/▲	
▲ 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			

硬质合金牌号
Carbide grades

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

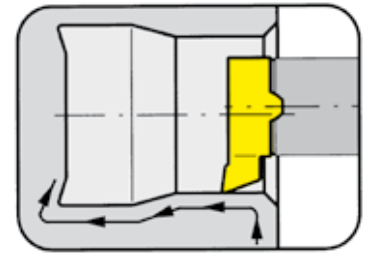
镗孔和仿形加工 $\geq \text{Ø} 10.5 \text{ mm}$

BORING and PROFILING

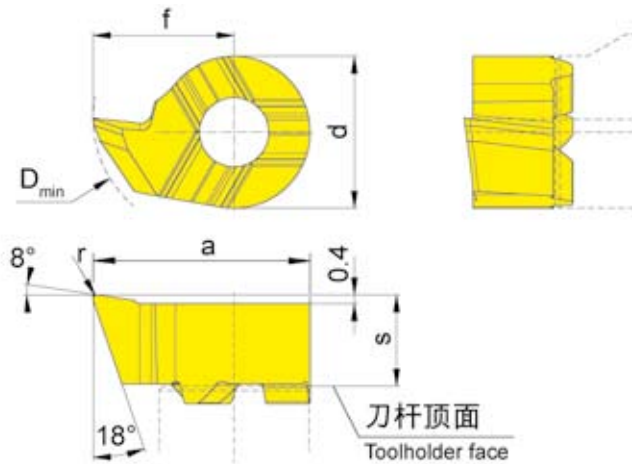


刀片型号
INSERT Type

11P



孔径最小至 Bore Ø from 10.5 mm



配合刀杆
for use with Toolholder

型号 B11P
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	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L11P.1865.1.02	0.2	4.2	6.5	10	7	10.5				▲/△
▲ 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			

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

改进后的几何结构可镗孔径 $\geq \text{Ø} 10.3 \text{ mm}$ 和仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 10.3 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

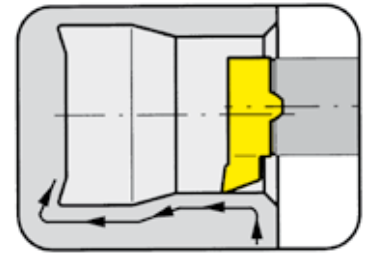


镗孔和仿形加工 $\geq \text{Ø} 9.8 \text{ mm}$ BORING and PROFILING

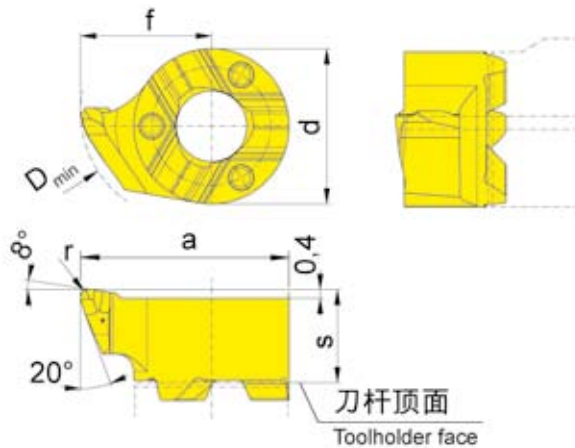


刀片型号
INSERT Type

S11P



孔径最小至 Bore Ø from 9.8 mm



配合刀杆
for use with Toolholder

型号 B11P
Type

G

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
LS11P.1859.R2	0.2									△
RS11P.1859.R2	0.2					9.8				▲
LS11P.1859.R4	0.4	4.2	5.9	9.4	7					▲
RS11P.1859.R4	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				

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

改进过的几何结构可以镗 $\geq \text{Ø} 9.8 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 9.8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request



G

- 缩短换刀时间
 - 高精度
 - 良好的表面质量
 - 出色的刀具寿命
-
- short tool changing times
 - high precision guaranteed for smooth cutting
 - very good surface finish on the threads
 - high tool life per edge due to even cutting action

需要更多信息请参阅HORN样本 "硬质合金铣削刀具"
For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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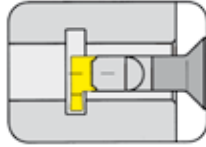
可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

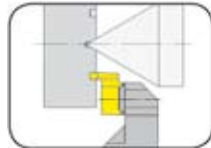
型号 114
type

B114
刀柄
Toolholder



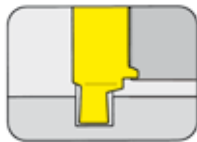
页 / Page
H2-H4

HC114
刀柄
Toolholder

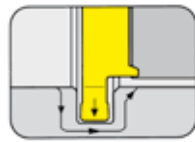


页 / Page
H5

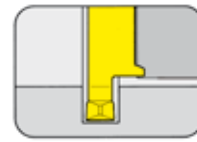
114 / S114
≥ Ø 14,0 mm
刀片
Inserts



页 / Page
H6-H7,H9



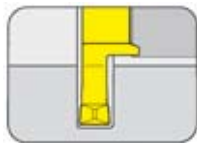
页 / Page
H8



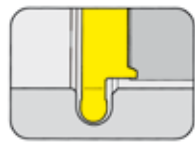
页 / Page
H10



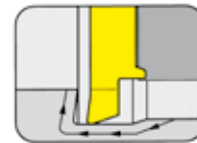
页 / Page
H11



页 / Page
H12



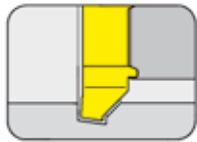
页 / Page
H13



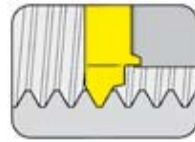
页 / Page
H14-H15,H17



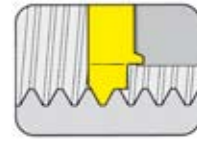
页 / Page
H16



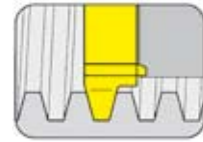
页 / Page
H18



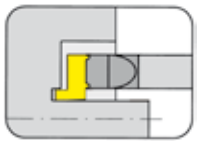
页 / Page
H19-H20



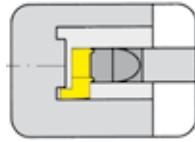
页 / Page
H21-H22



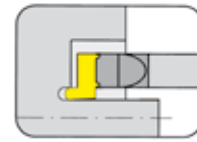
页 / Page
H23



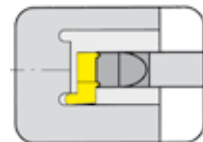
页 / Page
H24



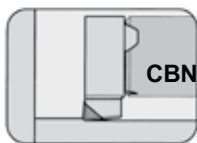
页 / Page
H25



页 / Page
H26



页 / Page
H27



页 / Page
H28

H

技术说明
Technical Instructions

页
Page M1-M7

切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$

GROOVING (internal)

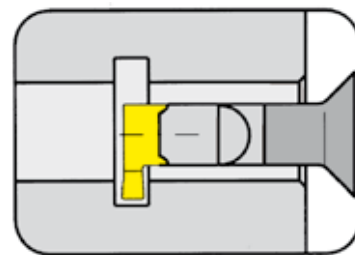


刀杆 型号

TOOLHOLDER Type

B114

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	6,5 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

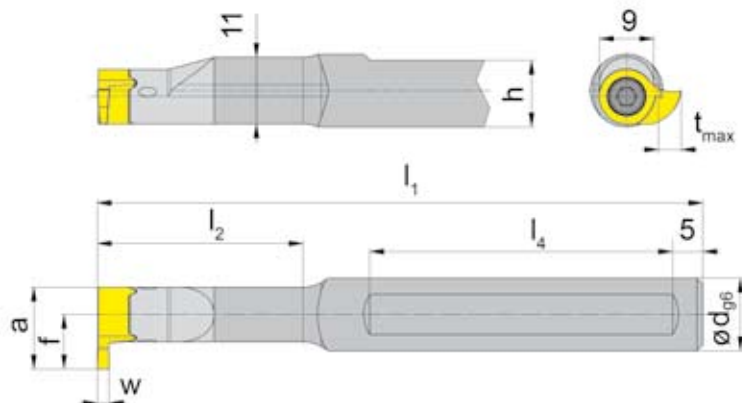
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片

for use with Insert

型号 114

Type S114



图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2	h	l_4
B114.0012.00	12	75	19,5	11	40
B114.0012.01		100	34,0		50
B114.0012.02		110	45,0		50
B114.0012.03		130	64,0		50
B114.0016.00	16	80	19,5	15	40
B114.0016.01		100	34,0		50
B114.0016.02		110	45,0		50
B114.0016.03		130	64,0		50

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

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

H2

切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$

GROOVING (internal)

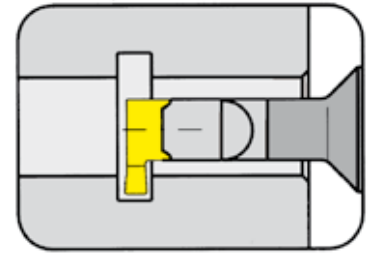


刀杆 型号

TOOLHOLDER Type

B114

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	6,5 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

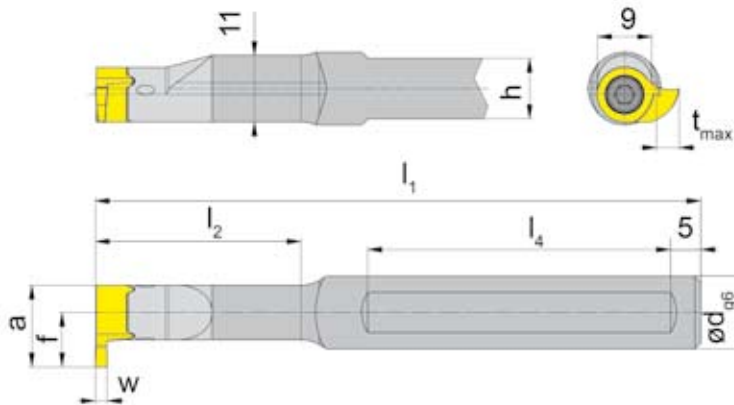
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片

for use with Insert

型号 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_1	l_2	h	l_4
B114.0012.2.00	12	75	19,5	11	40
B114.0012.2.01		100	34,0		50
B114.0012.2.02		110	45,0		50
B114.0012.2.03		130	64,0		50
B114.0016.2.00	16	80	19,5	14	40
B114.0016.2.01		100	34,0		50
B114.0016.2.02		110	45,0		50
B114.0016.2.03		130	64,0		50

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

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

切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$ GROOVING (internal)

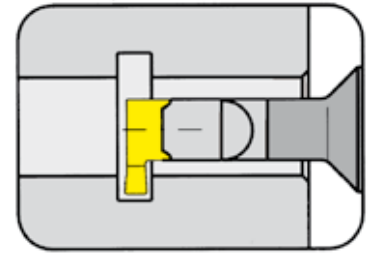


刀杆 型号

TOOLHOLDER Type

B114

带内冷
with through coolant supply

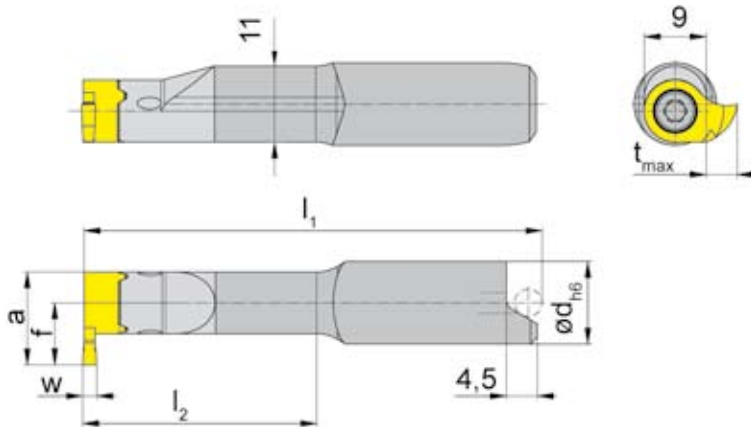


孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	6,5 mm
槽宽可达	Width of groove up to	3,0 mm

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 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_1	l_2
B114.0012.00S	12	52,7	19,5
B114.0012.01S		66,7	34,0
B114.0012.02S		77,7	45,0
B114.0012.03S		96,7	64,0

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

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

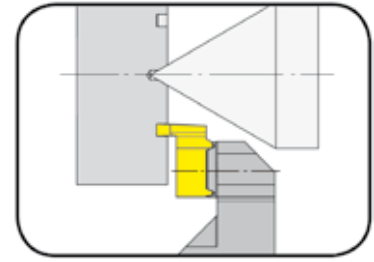
切槽和端面切槽

GROOVING and FACE GROOVING

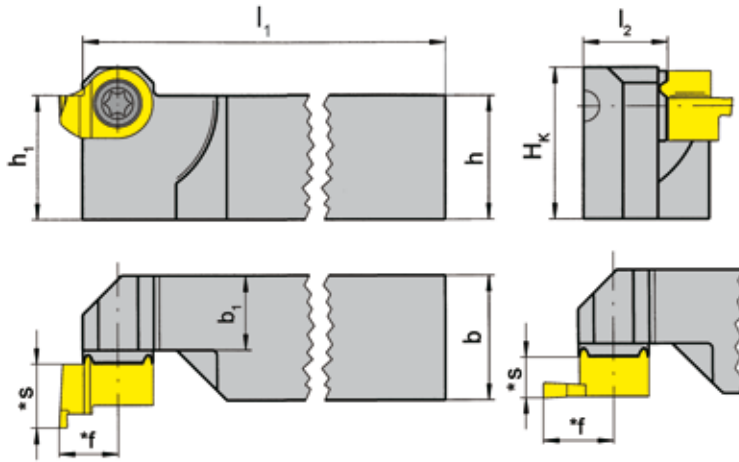


刀杆 型号
TOOLHOLDER Type

HC114



槽深可达 Depth of groove up to 6,5 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

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 ₁	l ₁	l ₂	b	b ₁	H _k
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

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

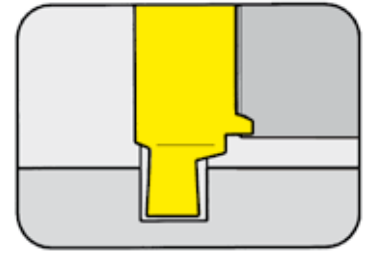
切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$

GROOVING (internal)



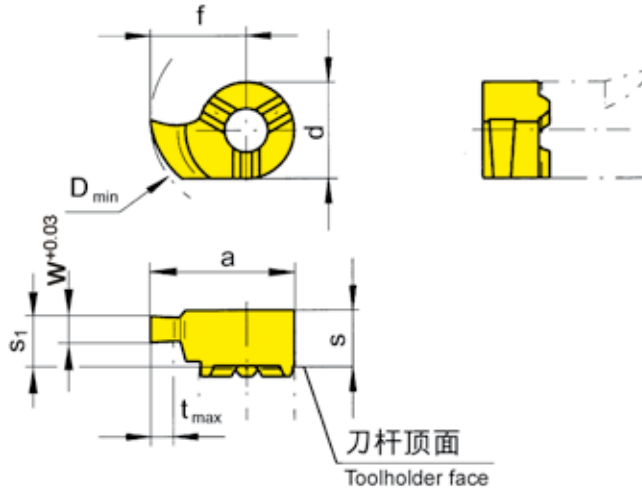
刀片型号
INSERT Type

114



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	1,2 - 1,5 mm
卡簧槽Nw	Width of circlip Nw	0,7 - 0,9 mm

卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



配合刀杆
for use with Toolholder

型号 B114
Type HC114

不能端面切削，
受切深限制，
not face cutting,
limited depth of cut

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	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L114.0070.00	0,7	0,74						1,2			▲/▲		
R/L114.0080.00	0,8	0,84	5,3	5,5	9	13,5	9	1,3	14		▲/▲		
R/L114.0090.00	0,9	0,94						1,5			▲/▲		
										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

切槽深度 t_{max} = 1.5 x w

Depth of groove t_{max} = 1,5 x w

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

H

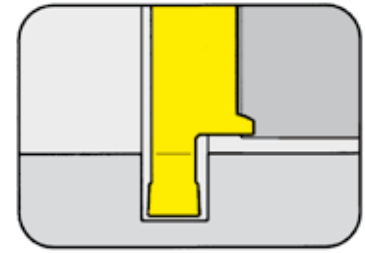
切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$

GROOVING (internal)



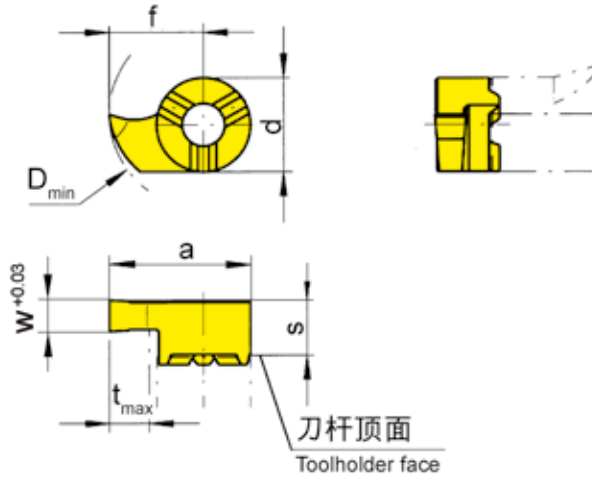
刀片型号
INSERT Type

114



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	4,0 mm
卡簧槽Nw	Width of circlip Nw	1,1 - 1,6 mm

卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



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

产品型号 Part number	Nw	w	s	f	a	d	t _{max}	D _{min}		MG12	TN35	TI25	TH35
R/L114.0110.00	1,1	1,19									▲/▲		▲/▲
R/L114.0130.00	1,3	1,39	5,3	9	13,5	9	4	14		▲/▲			▲/▲
R/L114.0160.00	1,6	1,69								▲/▲			▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

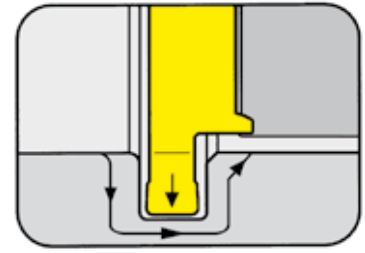


NC-仿形加工 (内圆) $\geq \varnothing 14,0 \text{ mm}$ NC-PROFILING (internal)



刀片 型号
INSERT Type

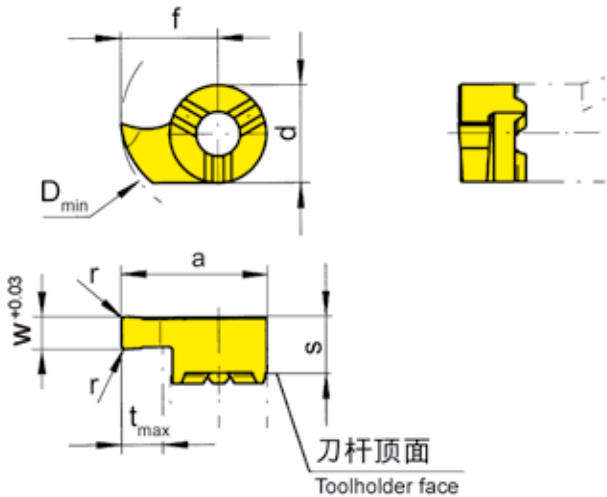
114



孔径最小至 槽深	Bore \varnothing from Depth of groove	14,0 mm 4,0 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

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L114.0200.02	2	0,2	5,3	9	13,5	9	4	14	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

H

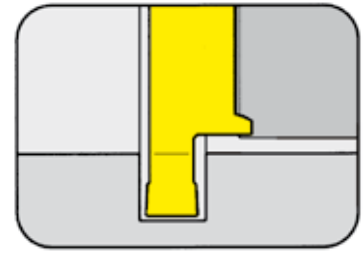
切槽 (内圆) $\geq \varnothing 14,0$ mm

GROOVING (internal)



刀片型号
INSERT Type

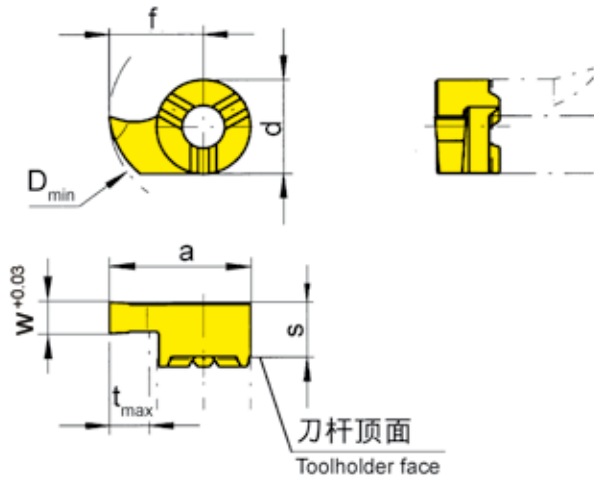
114



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	4,0 mm
槽宽	Width of groove	1,5 - 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

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}	硬质合金牌号			
								MG12	TN35	TI25	TH35
R/L114.0150.00	1,5							▲/▲	▲/▲		▲/▲
R/L114.0200.00	2,0							▲/▲	▲/▲		▲/▲
R/L114.0250.00	2,5	5,3	9	13,5	9	4	14	▲/▲	▲/▲		▲/▲
R/L114.0300.00	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			

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

硬质合金牌号
Carbide grades



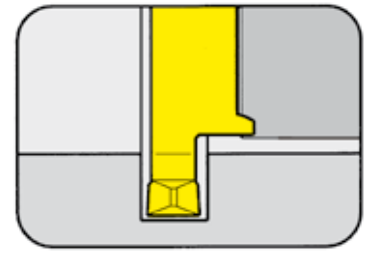
切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$

GROOVING (internal)



刀片 型号
INSERT Type

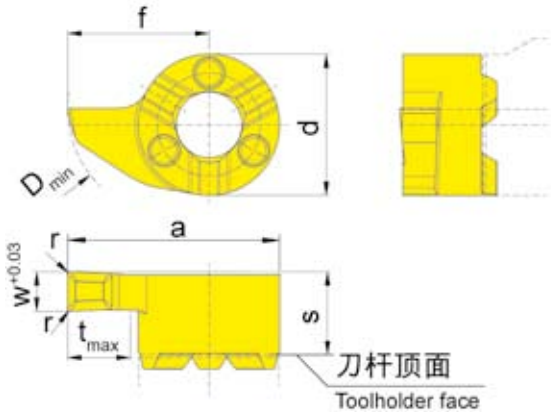
S114



孔径最小至	Bore \varnothing from	14,0 mm
槽深	Depth of groove	4,0 mm
槽宽	Width of groove	2,0 - 3,0 mm

配合 刀杆
for use with Toolholder

型号 B114
Type HC114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/LS114.0200.D2	2,0									▲/▲		▲/▲	
R/LS114.0250.D2	2,5	0,2	5,3	9	13,5	9	4	14		▲/▲		▲/▲	
R/LS114.0300.D2	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			

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

硬质合金牌号
Carbide grades

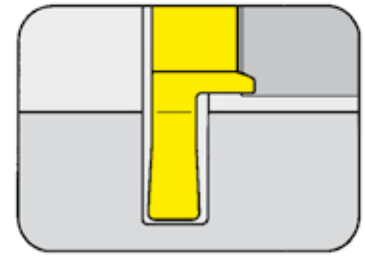
H

切槽 (内圆) $\geq \varnothing 16,5 \text{ mm}$ GROOVING (internal)



刀片型号
INSERT Type

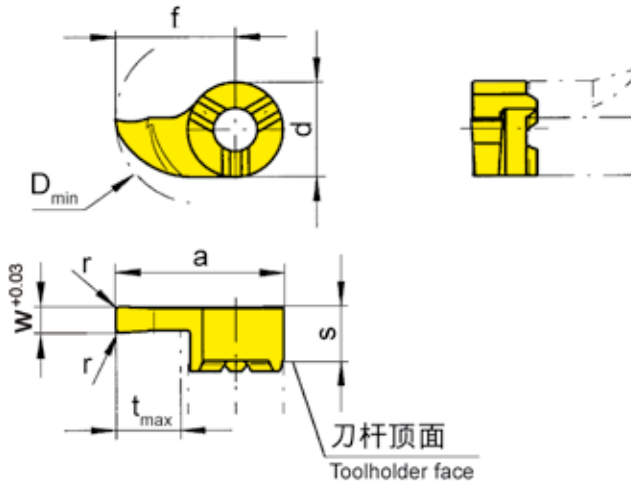
114



孔径最小至	Bore \varnothing from	16,5 mm
槽深	Depth of groove	6,5 mm
槽宽	Width of groove	1,5 - 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

产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35	
R/L114.0150.1.02	1,5									▲/▲		▲/▲	
R/L114.0200.1.02	2,0									▲/▲	▲/▲	▲/▲	
R/L114.0250.1.02	2,5	0,2	5,3	11,3	15,8	9	6,5	16,5		▲/▲		▲/▲	
R/L114.0300.1.02	3,0									▲/▲		▲/▲	
▲ 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										P	●	●	●
										M	●	●	●
										K	●	●	●
										N	●	●	●
										S	●	●	●
										H			

硬质合金牌号
Carbide grades

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



切槽 (内圆) $\geq \varnothing 16,5 \text{ mm}$

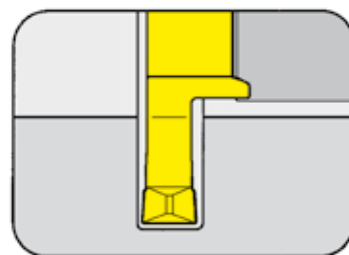
GROOVING (internal)



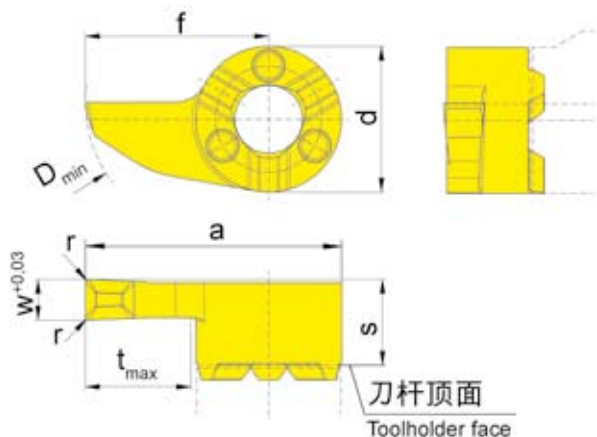
刀片 型号

INSERT Type

S114



孔径最小至	Bore \varnothing from	16,5 mm
槽深	Depth of groove	6,5 mm
槽宽	Width of groove	2,0 - 3,0 mm



配合 刀杆
for use with Toolholder

型号 B114
Type HC114

槽型.D
Geometry .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	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/LS114.0200.1.D2	2,0											▲/▲
R/LS114.0250.1.D2	2,5	0,2	5,3	11,3	15,8	9	6,5	16,5				▲/▲
R/LS114.0300.1.D2	3,0											▲/▲
▲ 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									P			●
									M			●
									K			●
									N			●
									S			●
									H			

硬质合金牌号
Carbide grades

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

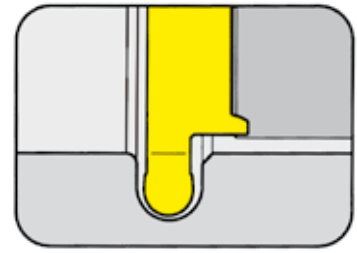
H

切槽 (内圆) $\geq \varnothing 14,0 \text{ mm}$ GROOVING (internal)



刀片型号
INSERT Type

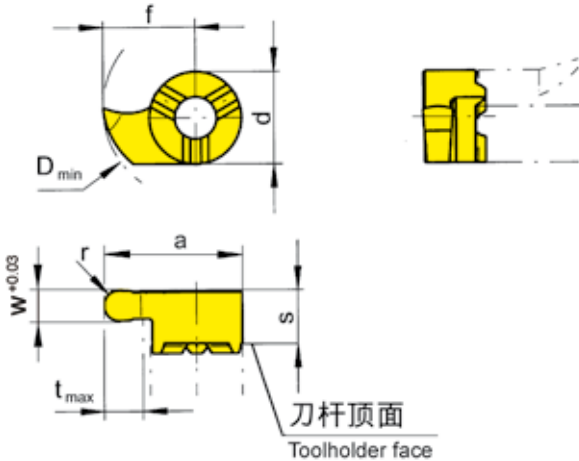
114



孔径最小至 圆头	Bore \varnothing from Full radius	14,0 mm r 0,6 - 2,0 mm
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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



产品型号 Part number	w	r	s	f	a	d	t _{max}	D _{min}	硬质合金牌号				
									MG12	TN35	TI25	TH35	
R/L114.0006.12	1,2	0,6								▲/▲		▲/▲	
R/L114.0009.18	1,8	0,9								▲/▲		▲/▲	
R/L114.0010.20	2,0	1,0								▲/▲		▲/▲	
R/L114.0011.22	2,2	1,1	5,3	9	13,5	9	4	14		▲/▲		▲/▲	
R/L114.0015.30	3,0	1,5								▲/▲		▲/▲	
R/L114.0020.40	4,0	2,0								▲/▲		▲/▲	
▲ 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			

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

硬质合金牌号
Carbide grades



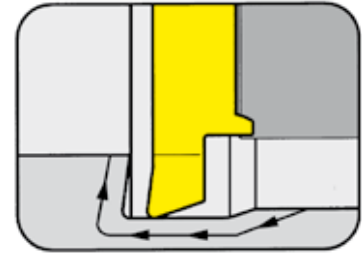
镗孔和仿形加工 $\geq \text{Ø } 13,8 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

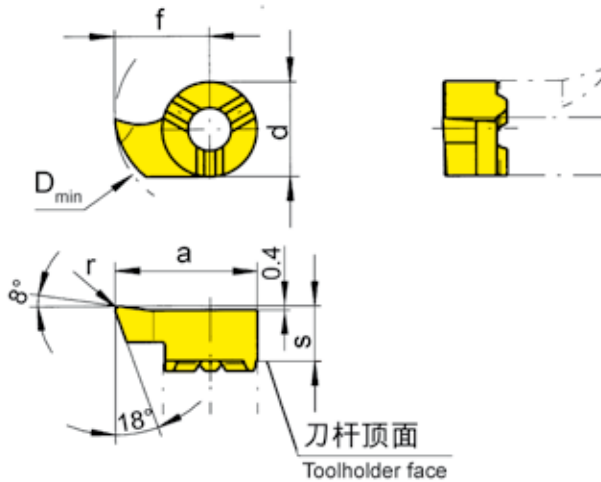
114



孔径最小至 Bore Ø from 13,8 mm

配合刀杆
for use with Toolholder

型号 B114
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	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L114.1890.02	0,2	5,3	8,7	13,2	9	13,8	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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			

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

改进过的几何结构可以镗 $\geq \text{Ø } 13,8 \text{ mm}$ 的孔，也可以仿形车DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø } 13,8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

H

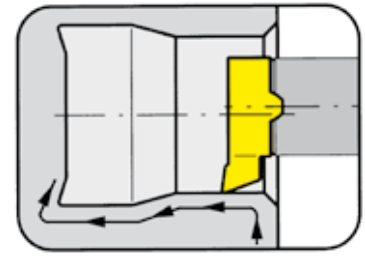
镗孔和仿形加工 $\geq \varnothing 13,8$ mm

BORING and PROFILING



刀片型号
INSERT Type

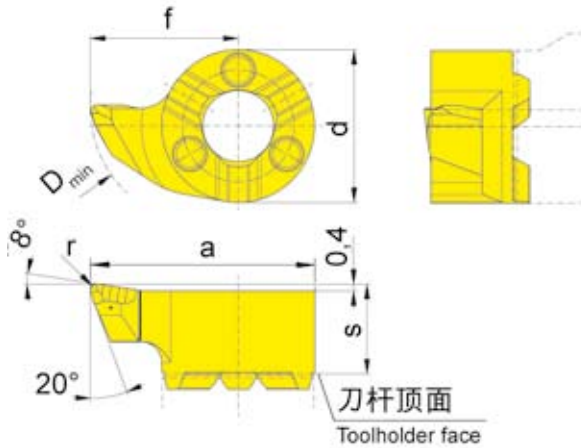
S114



孔径最小至 Bore \varnothing from 13,8 mm

配合刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
LS114.1890.R2	0,2									▲
RS114.1890.R2	0,2					13,8				▲
LS114.1890.R4	0,4	5,3	8,7	13,2	9					▲
RS114.1890.R4	0,4									▲

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

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

改进过的几何结构可以镗 $\geq \varnothing 13.8$ mm的孔，也可以仿形车DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \varnothing 13,8$ mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

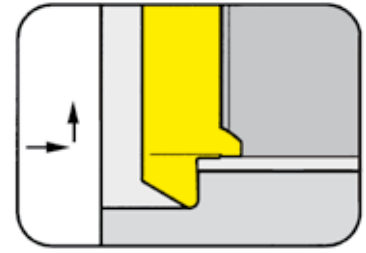


背镗 (内圆) $\geq \varnothing 13,8 \text{ mm}$ BACKBORING (internal)



刀片 型号
INSERT Type

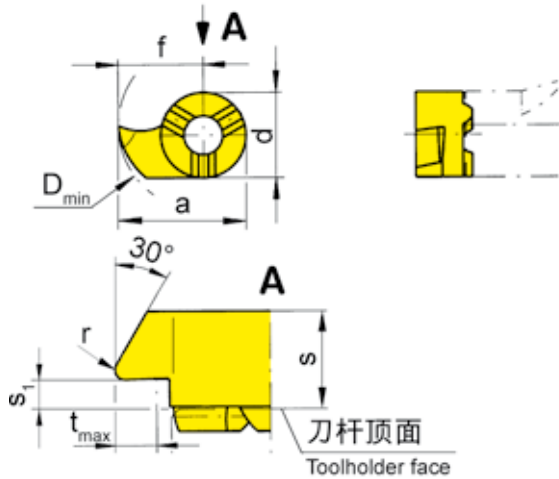
114



孔径最小至	Bore \varnothing from	13,8 mm
向下切深可达	Depth of undercut up to	3,5 mm

配合 刀杆
for use with Toolholder

型号 B114
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	r	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L114.3090.02	0,2	2,4	5,5	8,7	13,2	9	3,5	13,8		▲/▲		▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

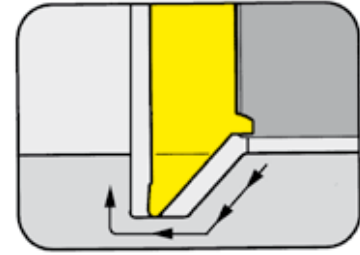
H

镗孔和仿形加工 $\geq \varnothing 13,8 \text{ mm}$ BORING and PROFILING

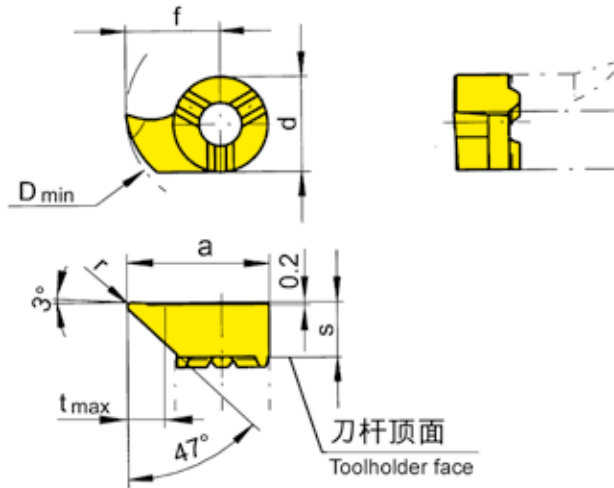


刀片型号
INSERT Type

114



孔径最小至 向下切深可达	Bore \varnothing from Depth of undercut up to	13,8 mm 5,0 mm
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配合刀杆
for use with Toolholder

型号 B114
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	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L114.4787.02	0,2	5,3	8,7	13,2	9	3	13,8		▲/▲		▲/▲
R/L114.4787.04	0,4								▲/▲		
R/L114.4710.02	0,2	5,3	11,0	15,5	9	5	16,0		▲/▲		▲/▲
								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

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

改进过的几何结构可以镗 $\geq \varnothing 13.8\text{mm}$ 的孔，也可以仿形车DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \varnothing 13,8 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades



预切槽和倒角 (内圆)

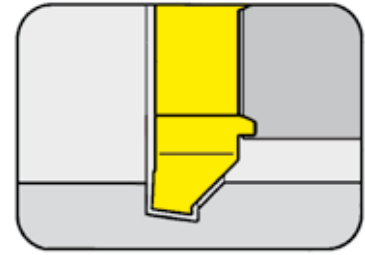
PREGROOVING and CHAMFERING (internal)



刀片型号

INSERT Type

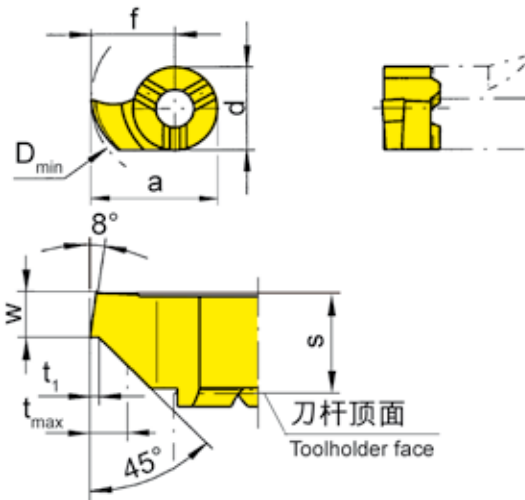
114



孔径最小至 Bore Ø from 14,0 mm

配合刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

H

产品型号 Part number	w	s	f	a	d	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L114.0815.45	1,5	5,3	9	13,5	9	0,2	1,5	14	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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	●	●	●

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

硬质合金牌号
Carbide grades

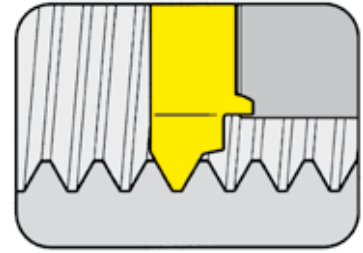
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

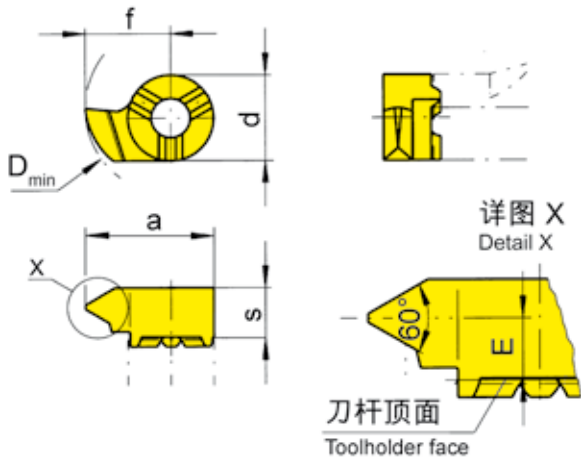
114



孔径最小至 螺距	Bore Ø from Pitch	14,0 mm 2,0 - 2,5 mm
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配合 刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	硬质合金牌号 Carbide grades			
								MG12	TN35	TI25	TH35
R/L114.1020.01	2,0	4,2	5,5	9	13,5	9	14	▲/▲	●	●	●
R/L114.1325.01	2,5							▲/▲	●	●	●
▲ 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	●	●	●

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



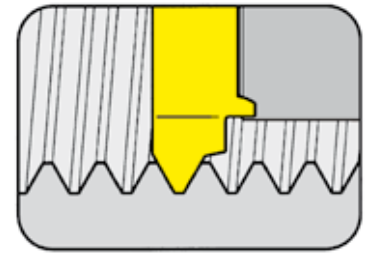
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

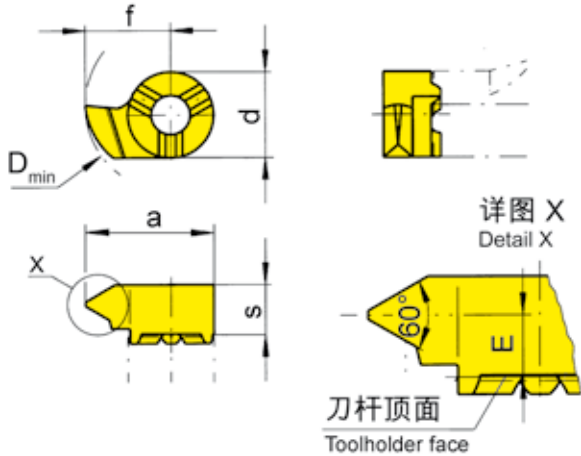
114



孔径最小至 螺距	Bore Ø from Pitch	14,0 mm 0,50 - 1,75 mm
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配合 刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L114.0205.01	0,5	0,75	4,8							▲/△		△/△
R/L114.0510.01	1,0	1,25	4,7	5,5	9	13,5	9	14	▲/▲	▲/▲		▲/△
R/L114.0815.01	1,5	1,75	4,5						▲/▲	▲/▲		▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades

H

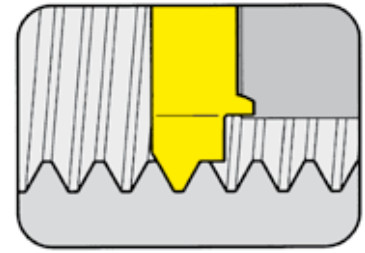
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

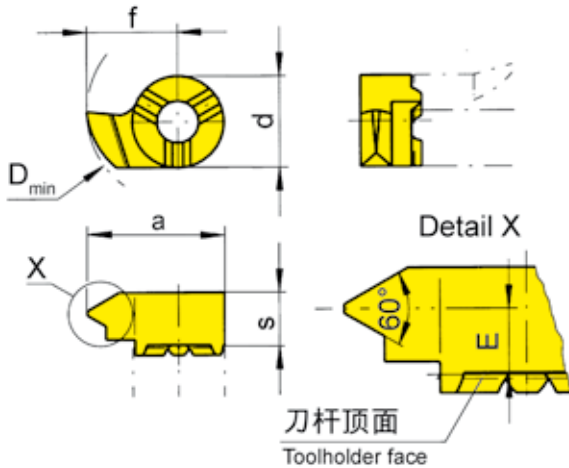
114



孔径最小至 螺距	Bore Ø from Pitch	14,0 mm 2,0 - 2,5 mm
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配合 刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L114.1020.02	2,0	4,2	5,5	9	13,5	9	14		▲/▲		
R/L114.1325.02	2,5								▲/▲		
▲ 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			

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

硬质合金牌号
Carbide grades



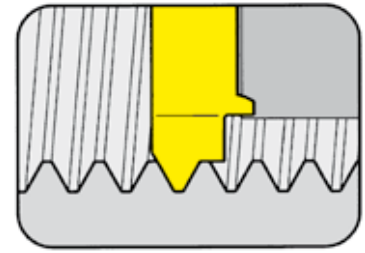
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

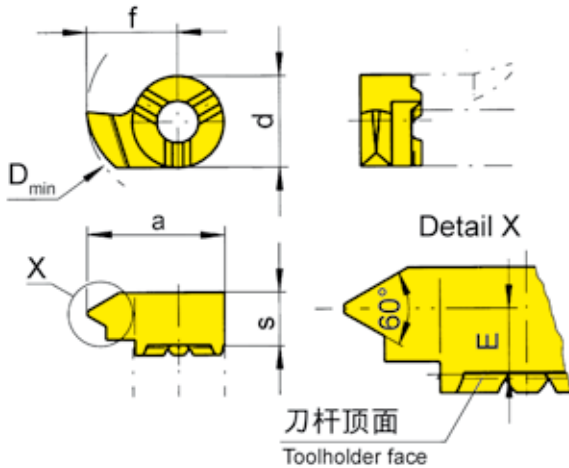
114



孔径最小至 螺距	Bore Ø from Pitch	14,0 mm 1,0 - 1,5 mm
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配合 刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L114.0510.02	1,0	4,7	5,5	9	13,5	9	14	▲/▲	●		
R/L114.0815.02	1,5	4,5						▲/▲	●		
▲ 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											

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

硬质合金牌号
Carbide grades

H

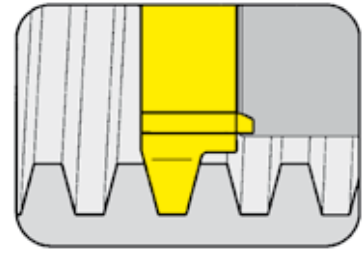
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

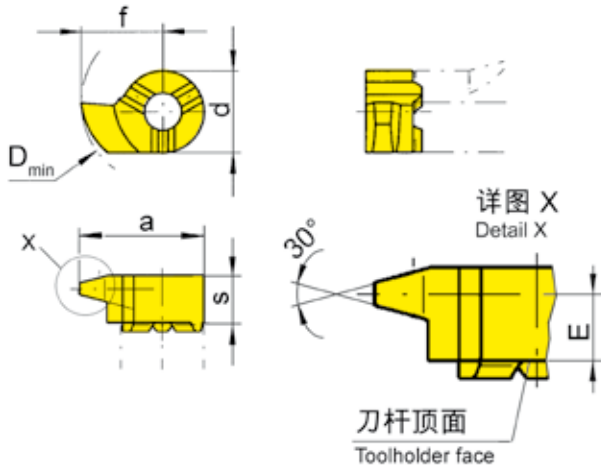
114



孔径最小至 螺距	Bore Ø from Pitch	14,0 mm 4,0 - 5,0 mm
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配合 刀杆
for use with Toolholder

型号 B114
Type



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	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L114.2240.01	4	4,00	5,5	9	13,5	9	14		▲/▲		
R/L114.2750.01	5	3,55							▲/▲		
								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

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



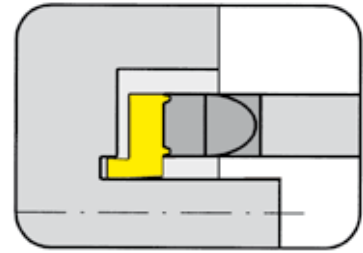
端面切槽 FACE GROOVING



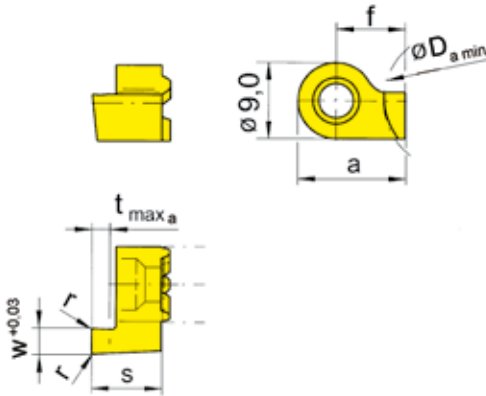
刀片型号

114

INSERT Type



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	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 _{max a}	D _{a min}	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							▲/▲		
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

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, l_1 和 l_2 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 l_1 and l_2 will be enlarged by 3,0 / 5,5 or 6,5 mm.

按需提供更多尺寸

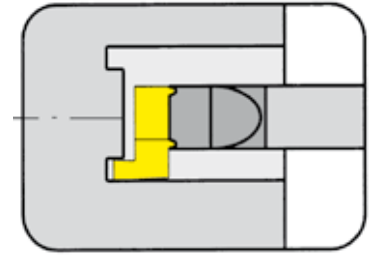
Further sizes upon request

端面切槽 FACE GROOVING



刀片型号
INSERT Type

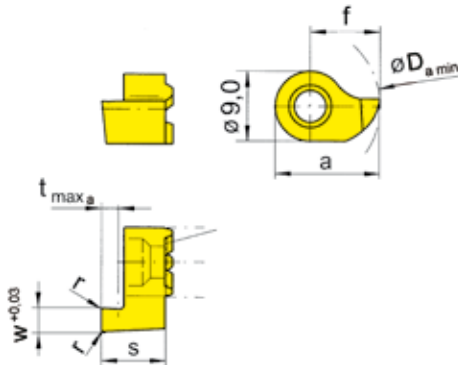
114



端面槽起始外径	from outer groove \varnothing	14,0 mm
槽深可达	Depth of groove up to	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 _{max a}	D _{a min}	Machining			
								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				5,0			▲/▲		
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
MG12	○	●	●	●	●	●
TN35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TH35	●	●	●	●	●	●

硬质合金牌号
Carbide grades

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, l₁和l₂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 l₁ and l₂ will be enlarged by 3,0 / 5,5 or 6,5 mm.

按需提供更多尺寸
Further sizes upon request



端面切槽

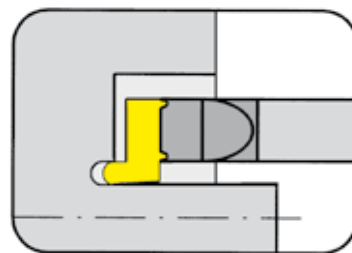
FACE GROOVING



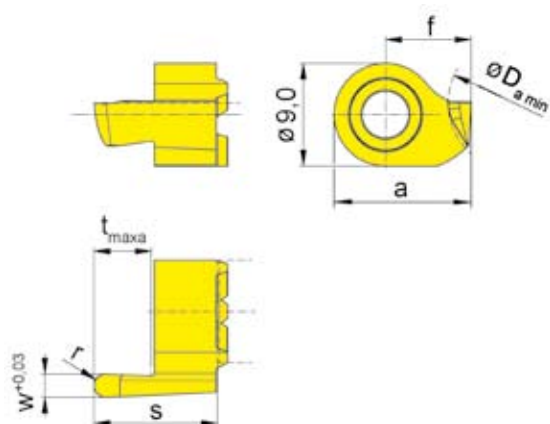
刀片型号

114

INSERT Type



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

圆弧刀片
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 _{max a}	D _{a min}	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

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.

按需提供更多尺寸

Further sizes upon request

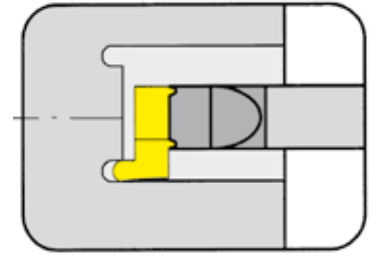
H

端面切槽 FACE GROOVING

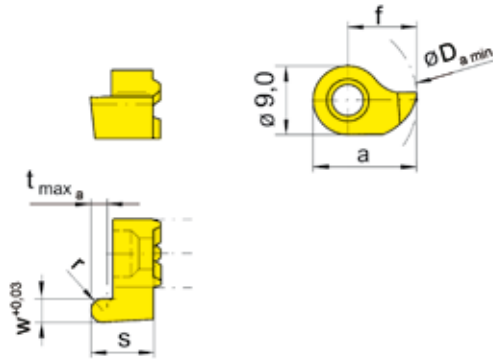


刀片型号
INSERT Type

114



端面槽起始外径	from outer groove \emptyset	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

圆弧刀片
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 _{max a}	D _{a min}	MG12	TN35	TI25	TH35
R/L114.1410.05	1,0	0,50				1,5			▲/▲		
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	14		▲/▲		
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

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系列端面槽刀片和B114刀杆时, I₁和I₂会增大3.0 mm。

Note:
R = rotation clockwise!
Using the face grooving insert type 114 on toolholder type B114 the size I₁ and I₂ will be enlarged by 3,0 mm.

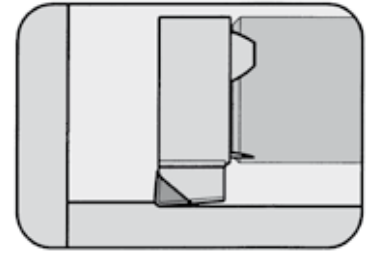
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

H

刀片型号
INSERT Type

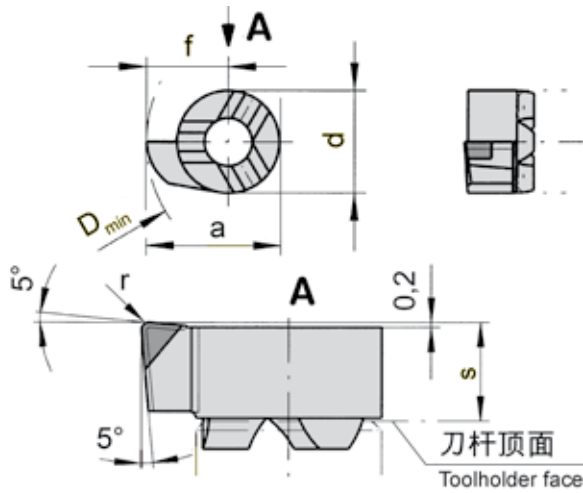
114



孔径最小至 Bore Ø from 12,5 mm

配合 刀杆
for use with Toolholder

型号 B114
Type



R=右手型-如图
R = right hand version shown

CBN刀片
CBN tipped

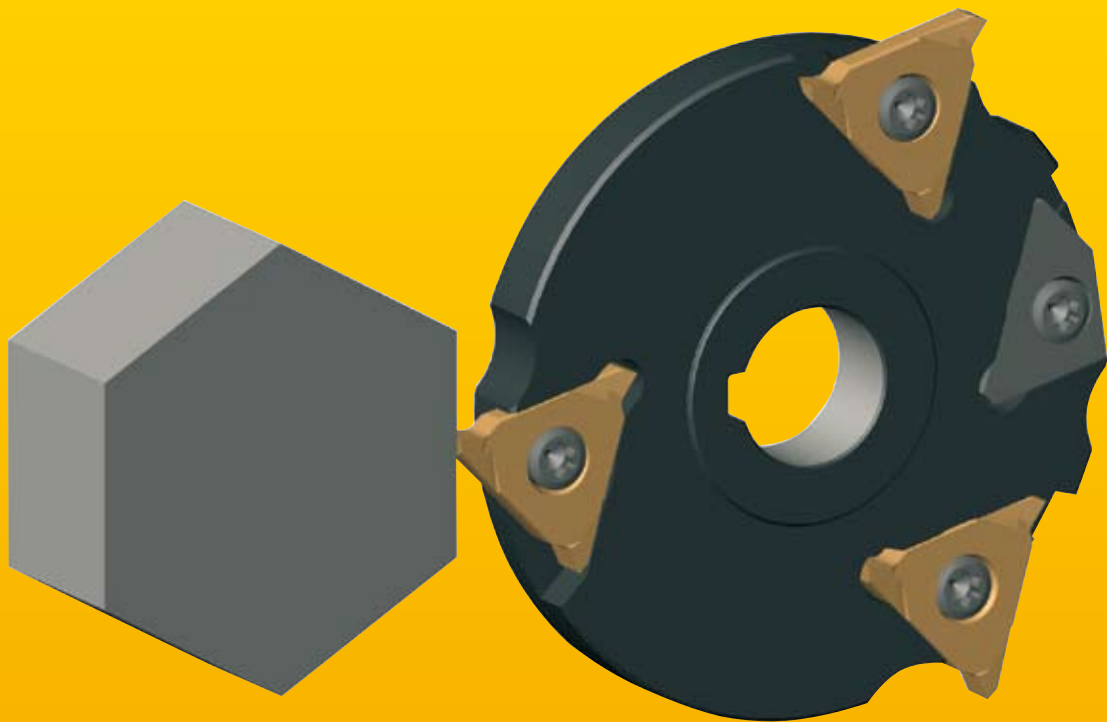
产品型号 Part number	r	s	f	a	d	D _{min}	CB10
R114.0572.04.B	0,4	5,3	7,25	11,75	9	12,5	▲
▲ 库存 / on stock Δ 4周 / 4 weeks							P
● 主要应用 / main recommendation							M
○ 可选推荐 / alternative recommendation							K
■ 无涂层牌号 / uncoated grades							N
■ 涂层牌号 / coated grades							S
■ 钎焊/金属陶瓷 / brazed/Cermet							H •

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

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“硬质合金铣削刀具”)



Cutter

For use on lathes with ability to machine polygon profiles.
For further information please see the HORN catalogue
"ROTATING TOOLS".

需要更多信息请参阅HORN样本“硬质合金铣削刀具”
For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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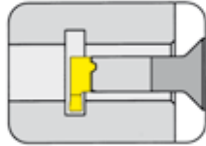
可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

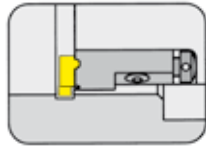
型号 116
type

B116
刀柄
Toolholder



页 / Page
J2-J3

R/L145
刀柄
Toolholder

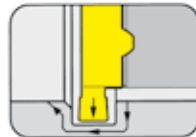


页 / Page
J4

114 / S114
≥ Ø 14,0 mm
刀片
Inserts



页 / Page
J5-J6, J8



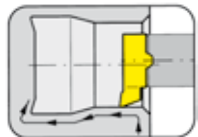
页 / Page
J7



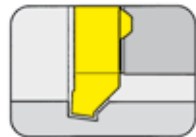
页 / Page
J9



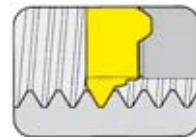
页 / Page
J11



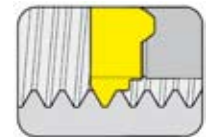
页 / Page
J12-J14



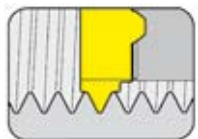
页 / Page
J15



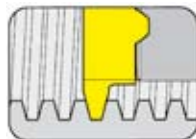
页 / Page
J16-J17



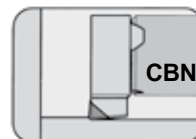
页 / Page
J18-J19



页 / Page
J20



页 / Page
J21



页 / Page
J22

技术说明
Technical Instructions

页
Page M1-M7

J

切槽 (内圆) $\geq \varnothing 16.0$ mm

GROOVING (internal)

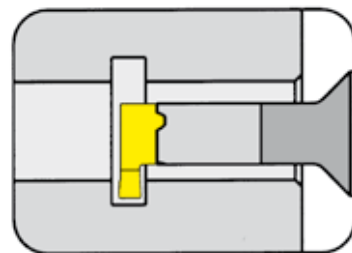


刀杆 型号

TOOLHOLDER Type

B116

带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	16.0 mm
槽深	Depth of groove	4.3 mm
槽宽可达	Width of groove up to	4.0 mm

刀杆材质：整体硬质合金 - 良好的抗振性能

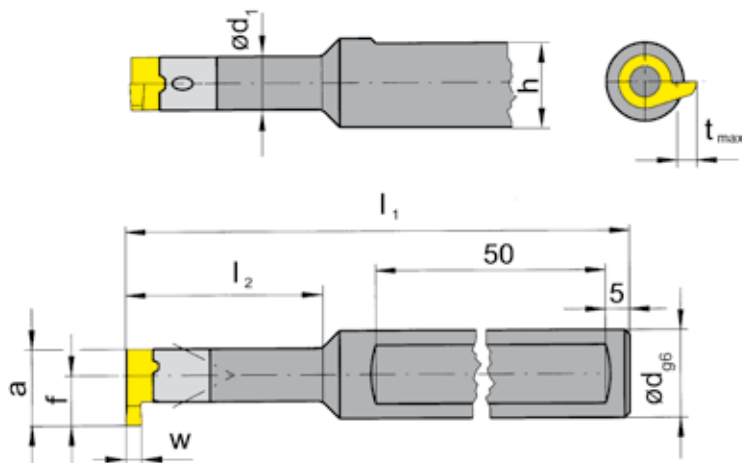
Material of shank: Carbide - Giving a good vibration resistance

配合 刀片

for use with Insert

型号 116

Type S116



图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2	h	d_1
B116.0012.01	12	130	40	11	11
B116.0012.02		130	56		
B116.0012.03		150	80		
B116.0016.01	16	130	40	15	11
B116.0016.02		130	56		
B116.0016.03		150	80		

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

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
B116.001...	5.13T20EP	T20PQ

切槽 (内圆) $\geq \varnothing 16.0$ mm

GROOVING (internal)

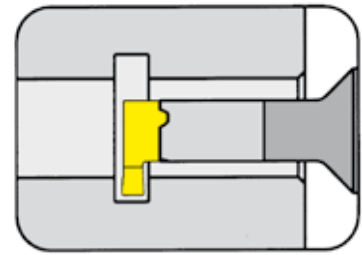


刀杆型号

TOOLHOLDER Type

B116

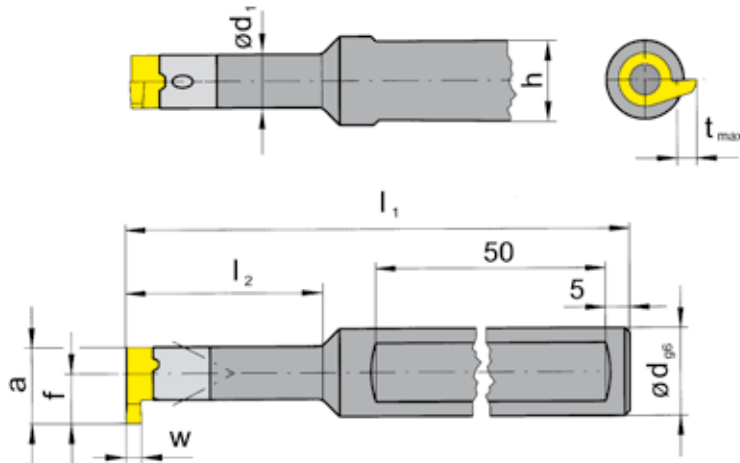
带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	16.0 mm
槽深	Depth of groove	4.3 mm
槽宽可达	Width of groove up to	4.0 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 116

Type S116

带2个夹持面

with 2 clamping flats

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2	h	d_1
B116.0012.2.01	12	130	40	11	11
B116.0012.2.02		130	56		
B116.0012.2.03		150	80		
B116.0016.2.01	16	130	40	14	11
B116.0016.2.02		130	56		
B116.0016.2.03		150	80		

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

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
B116.001...	5.13T20EP	T20PQ

切槽 (内圆) $\geq \varnothing 32.0$ mm

GROOVING (internal)

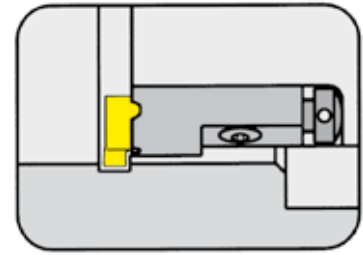


刀夹 型号

CARTRIDGE Type

145

for customized tools
for customized tools

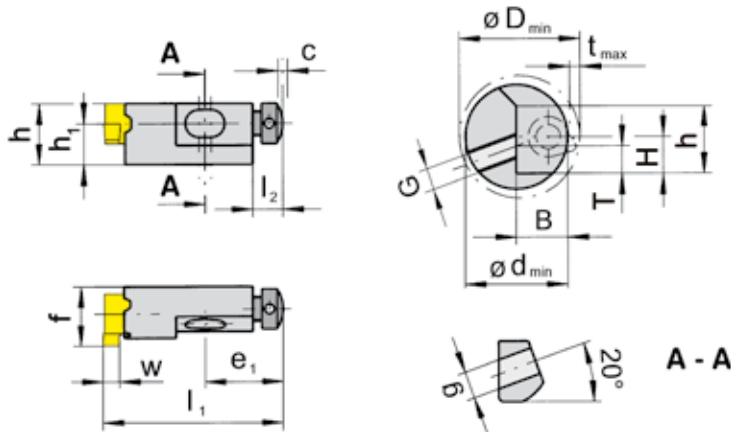


孔径最小至	Bore \varnothing from	32.0 mm
槽深可达	Depth of groove up to	4.3 mm
槽宽可达	Width of groove up to	4.0 mm

配合 刀片

for use with Insert

型号 116
Type S116



产品型号 Part number	h_1	f	h	l_1	D_{min}	t_{max}	e_1	l_2	c	g	夹持范围 Clamping range
R/L145.1012.00	10	16.7	17	36	32	4.3	13.8	5	1	6.6	0.5 - 4.0

注明R或L型
State R or L version

w见刀片
w see inserts

单位: mm
Dimensions in mm

切削刃高度 h_1

可以非标定制特殊高度 $h_1=6$ 或 7 mm。

Height of cutting edge h_1

Special height $h_1 = 6$ or 7 mm available 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	轴向调节螺钉 Adjust screw axial	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L145.1012.00	6.20-232	5.13T20EP	4.06-020	T20PQ

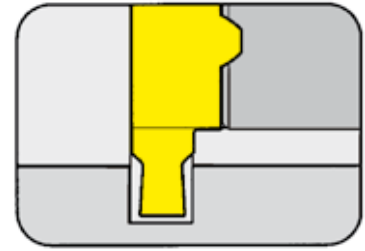
切槽 (内圆) $\geq \varnothing 16.0$ mm

GROOVING (internal)



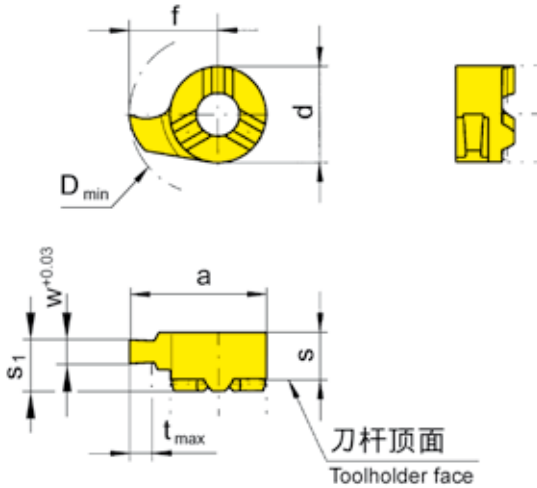
刀片型号
INSERT Type

116



孔径最小至	Bore \varnothing from	16.0 mm
槽深	Depth of groove	1.2 - 1.5 mm
卡簧槽Nw	Width of circlip Nw	0.7 - 0.9 mm

卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



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 145
Type B116

不能端面切削，
受切深限制，
not face cutting,
limited depth of cut

产品型号 Part number	Nw	w	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L116.0070.00	0.7	0.74						1.2			▲/▲		
R/L116.0080.00	0.8	0.84	5.3	5.5	10.2	15.7	11	1.3	16		▲/▲		
R/L116.0090.00	0.9	0.94						1.5			▲/▲		
										P	•		
										M	•		
										K	•		
										N	•		
										S	•		
										H			

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

硬质合金牌号
Carbide grades

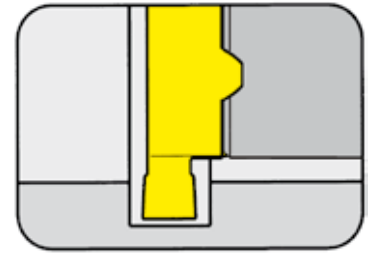


切槽 (内圆) $\geq \varnothing 16.0 \text{ mm}$ GROOVING (internal)



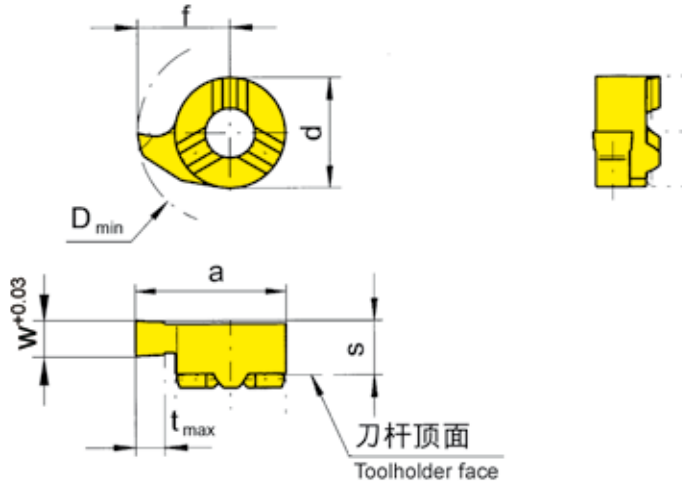
刀片 型号
INSERT Type

116



孔径最小至 卡簧槽Nw	Bore \varnothing from Width of circlip Nw	16.0 mm 1.1 - 1.6 mm
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卡簧槽宽度DIN471/472
Widths for circlip grooves DIN 471/472



配合 刀杆
for use with Toolholder

型号 145
Type B116

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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L116.0110.00	1.1	1.19							▲/▲	▲/▲		▲/▲
R/L116.0130.00	1.3	1.39	5.3	10.2	15.7	11	4.3	16	▲/▲	▲/▲		▲/▲
R/L116.0160.00	1.6	1.69							▲/▲	▲/▲		▲/▲
									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

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

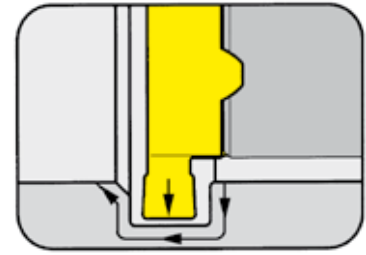
NC-仿形加工 (内圆) $\geq \varnothing 16.0$ mm

NC-PROFILING (internal)



刀片 型号
INSERT Type

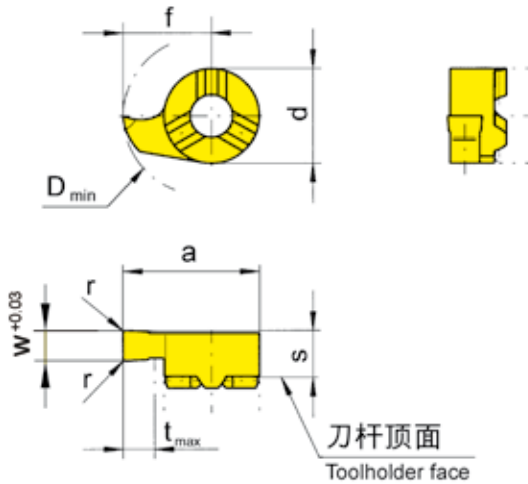
116



孔径最小至 槽深	Bore \varnothing from Depth of groove	16.0 mm 4.3 mm
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配合 刀杆
for use with Toolholder

型号 145
Type B116



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	d	t _{max}	D _{min}		MG12	TN35	TI25	TH35
R/L116.0200.02	2	0.2	5.3	10.2	15.7	11	4.3	16			▲/▲		▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades



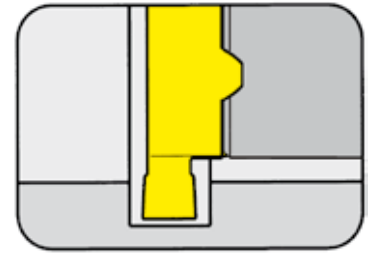
切槽 (内圆) $\geq \text{Ø} 16.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

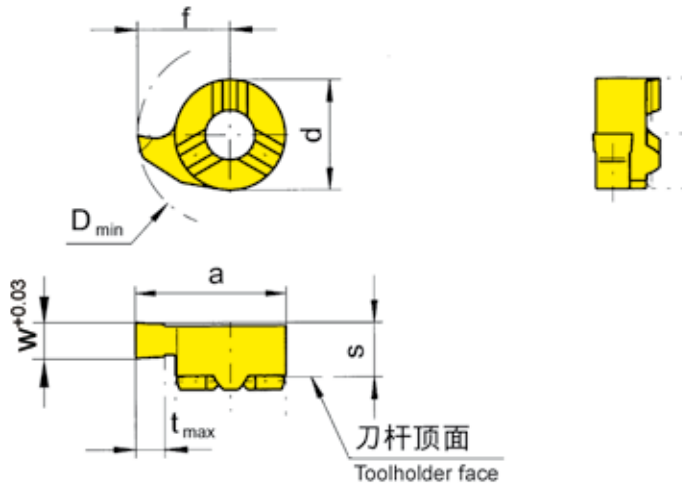
116



孔径最小至	Bore Ø from	16.0 mm
槽深	Depth of groove	4.3 mm
槽宽可达	Width of groove up to	4.0 mm

配合刀杆
for use with Toolholder

型号 145
Type B116



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	f	a	d	t_{\max}	D_{\min}	硬质合金牌号			
								MG12	TN35	TI25	TH35
R/L116.0200.00	2.0							▲/▲	▲/▲		▲/▲
R/L116.0250.00	2.5							▲/▲	▲/▲		▲/▲
R/L116.0300.00	3.0	5.3	10.2	15.7	11	4.3	16	▲/▲	▲/▲		▲/▲
R/L116.0350.00	3.5							▲/▲	▲/▲		▲/▲
R/L116.0400.00	4.0							▲/▲	▲/▲		▲/▲
								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

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

硬质合金牌号
Carbide grades

切槽 (内圆) $\geq \text{Ø} 16.0 \text{ mm}$

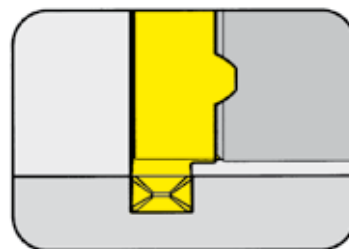
GROOVING (internal)



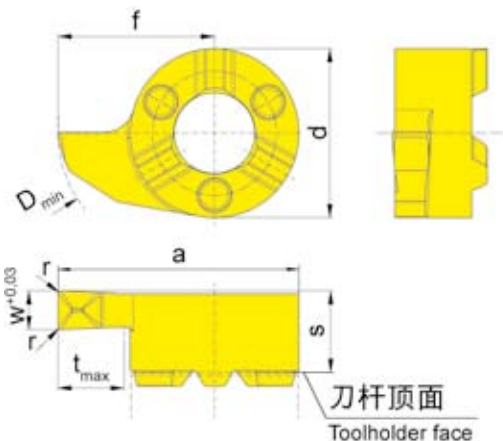
刀片型号

INSERT Type

S116



孔径最小至	Bore Ø from	16.0 mm
槽深可达	Depth of groove up to	4.3 mm
槽宽	Width of groove	2.0 - 3.0 mm



配合刀杆
for use with Toolholder

型号 145
Type B116

槽型.D
Geometry .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	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/LS116.0200.D2	2.0											▲/▲
R/LS116.0250.D2	2.5	0.2	5.3	10.2	15.7	11	4.3	16				▲/▲
R/LS116.0300.D2	3.0											▲/▲
▲ 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									P			●
									M			●
									K			●
									N			●
									S			●
									H			

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

硬质合金牌号
Carbide grades



减少换刀
自 $\varnothing 18$ mm

Reducing of tool change
from $\varnothing 18$ mm

预切槽和倒角
Pregrooving and chamfering



J

精加工
Finishing



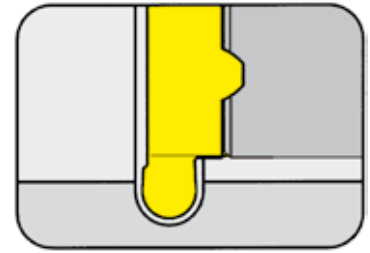
切槽 (内圆) $\geq \varnothing 16.0$ mm

GROOVING (internal)



刀片型号
INSERT Type

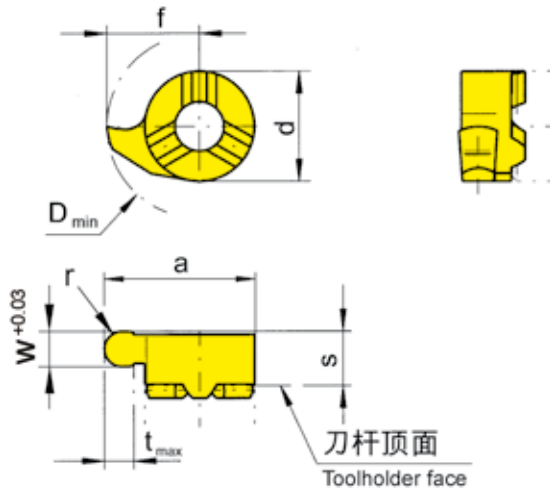
116



孔径最小至 圆头	Bore \varnothing from Full radius	16.0 mm r 0.9 - 2.0 mm
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配合 刀杆
for use with Toolholder

型号 145
Type B116



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	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L116.0009.18	1.8	0.9							▲/▲	▲/▲		▲/▲
R/L116.0011.22	2.2	1.1							▲/▲	▲/▲		▲/▲
R/L116.0015.30	3.0	1.5	5.3	10.2	15.7	11	4.3	16	▲/▲	▲/▲		▲/▲
R/L116.0020.40	4.0	2.0							▲/▲	▲/▲		▲/▲
									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

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

硬质合金牌号
Carbide grades



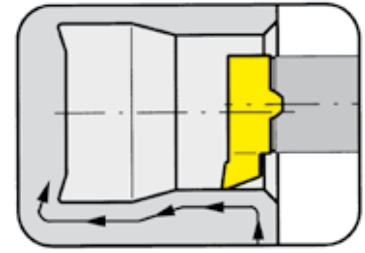
镗孔和仿形加工 $\geq \text{Ø} 15.5 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

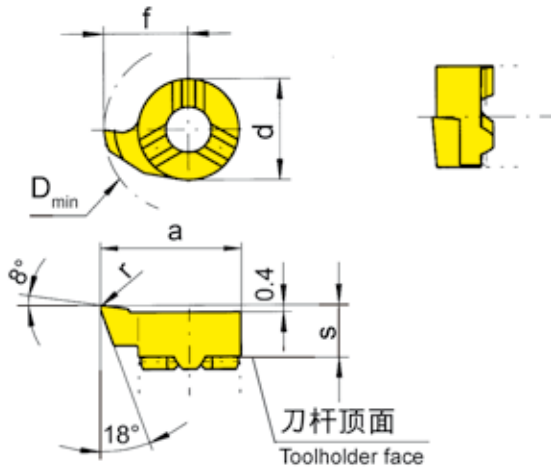
116



孔径最小至 Bore Ø from 15.5 mm

配合 刀杆
for use with Toolholder

型号 145
Type B116



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	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L116.1897.02	0.2	5.3	9.7	15.2	11	15.5		▲/▲		▲/▲
▲ 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			

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

改进过的几何结构可以镗 $\geq \text{Ø} 15.5 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 15.5 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

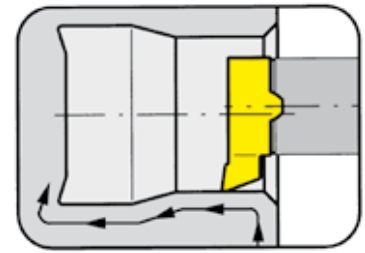
镗孔和仿形加工 $\geq \varnothing 15.5 \text{ mm}$

BORING and PROFILING

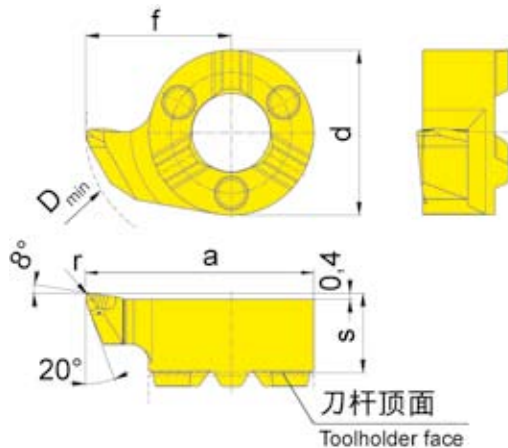


刀片型号
INSERT Type

S116



孔径最小至 Bore \varnothing from 15.5 mm



配合刀杆
for use with Toolholder

型号 145
Type B116

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	r	s	f	a	d	D_{min}	MG12	TN35	TI25	TH35
LS116.1897.R2	0.2									▲
RS116.1897.R2	0.2									▲
LS116.1897.R4	0.4	5.3	9.7	15.2	11	15.5				▲
RS116.1897.R4	0.4									▲
							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	MG12	TN35	TI25	TH35
P				•
M				•
K				•
N				•
S				•
H				

单位: mm
Dimensions in mm

注明R或L型
State R or L version

改进过的几何结构可以镗 $\geq \varnothing 15.5 \text{ mm}$ 的孔，也可以仿形加工DIN509E和F型的退刀槽。
The modified geometry allows boring of bores $\geq \varnothing 15.5 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request



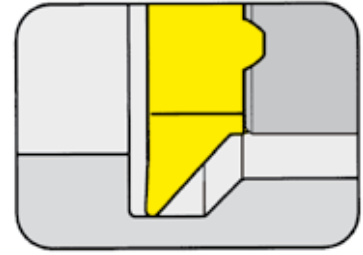
镗孔和仿形加工 $\geq \text{Ø} 16.0 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

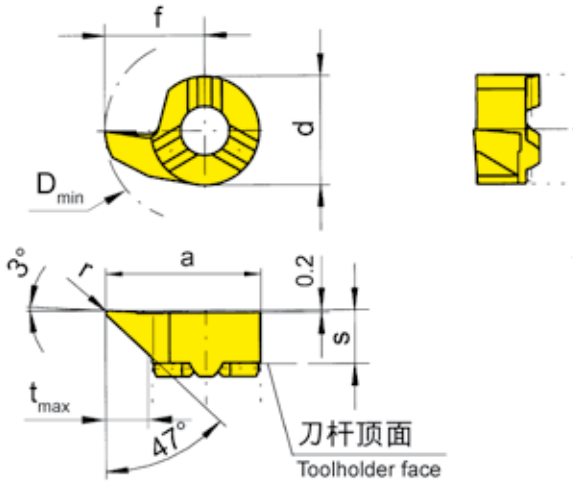
116



孔径最小至 向下切深可达	Bore Ø from Depth of undercut up to	16.0 mm 4.3 mm
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配合 刀杆
for use with Toolholder

型号 145
Type B116



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	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L116.4702.02	0.2	5.3	10.2	15.7	11	4.3	16		▲/▲		▲/▲
R/L116.4702.04	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										

硬质合金牌号
Carbide grades

单位 : mm

Dimensions in mm

注明R或L型

State R or L version

改进后的几何结构可以镗 $\geq \text{Ø} 16.0 \text{ mm}$ 的孔和仿形加工DIN509E型和F型的退刀槽。
The modified geometry allows boring of bores $\geq \text{Ø} 16.0 \text{ mm}$ and profiling of reliefs as per DIN 509 form E.

按需提供更多尺寸

Further sizes upon request

J

预切槽和倒角 (内圆)

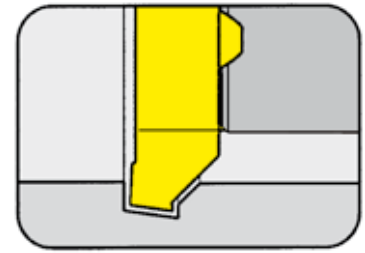
PREGROOVING and CHAMFERING (internal)



刀片型号

INSERT Type

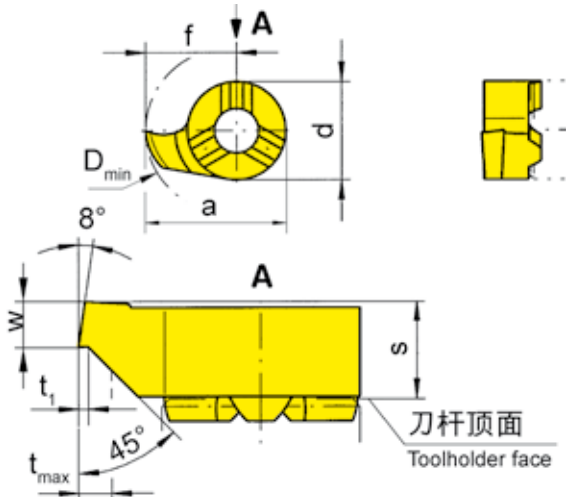
116



孔径最小至 Bore Ø from 16.0 mm

配合刀杆
for use with Toolholder

型号 145
Type B116



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	f	a	d	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L116.0815.45	1.5	5.3	10.2	15.7	11	0.2	1.5	16	▲/△	▲/▲	▲/▲	▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades



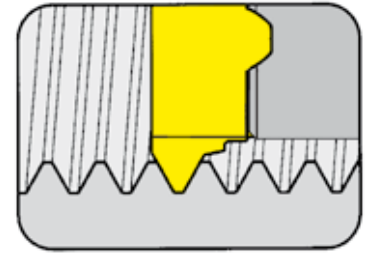
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

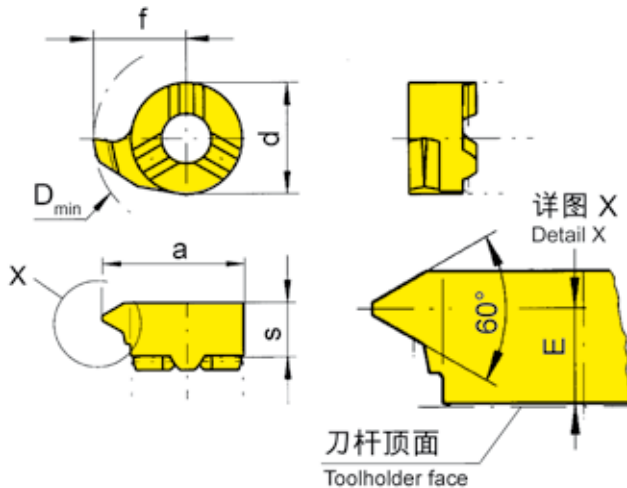
116



孔径最小至 螺距	Bore Ø from Pitch	16.0 mm 2.0 - 2.5 mm
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配合 刀杆
for use with Toolholder

型号 145
Type B116



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L116.1020.01	2.0	4.3	5.5	10.2	15.7	11	16		▲/△		▲/△
R/L116.1325.01	2.5	4.2	5.5	10.2	15.7	11	16		▲/▲		▲/▲
▲ 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											

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

	MG12	TN35	TI25	TH35
P	•	•	•	•
M	•	•	•	•
K	•	•	•	•
N	•	•	•	•
S	•	•	•	•
H				

硬质合金牌号
Carbide grades

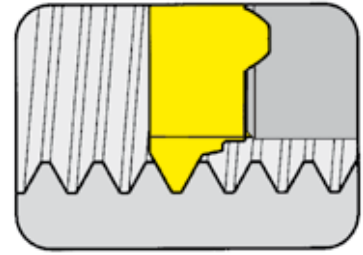
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

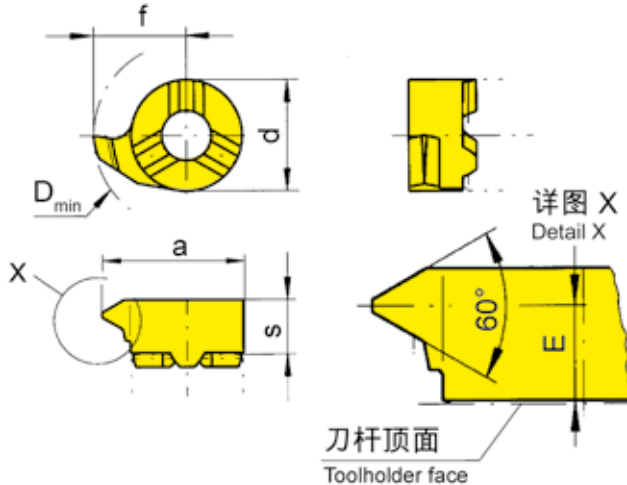
116



孔径最小至 螺距	Bore \varnothing from Pitch	16.0 mm 1.0 - 1.5 mm
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配合 刀杆
for use with Toolholder

型号 145
Type B116



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	ISO米制细螺纹			
									MG12	TN35	TI25	TH35
R/L116.0510.01	1.0	1.25	4.7	5.5	10.2	15.7	11	16	▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0815.01	1.5	1.75	4.5	5.5	10.2	15.7	11	16	▲/▲	▲/▲	▲/▲	▲/▲
									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

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

硬质合金牌号
Carbide grades



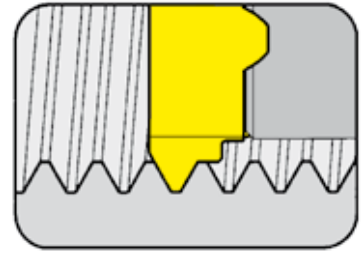
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

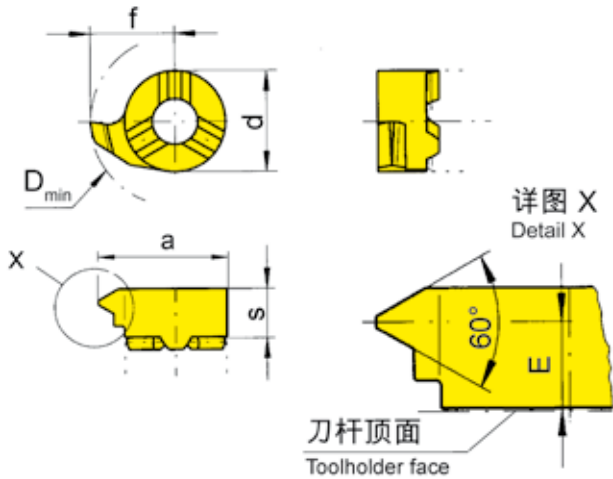
116



孔径最小至 螺距	Bore \varnothing from Pitch	16.0 mm 2.5 - 4.0 mm
-------------	----------------------------------	-------------------------

配合刀杆
for use with Toolholder

型号 145
Type B116



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

米制标准螺纹
Metric ISO standard thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	硬质合金牌号				
								MG12	TN35	TI25	TH35	
R/L116.1325.02	2.5	4.2							▲/△			
R/L116.1630.02	3.0	4.0							▲/▲			
R/L116.1835.02	3.5	3.8	5.5	10.2	15.7	11	16		▲/▲			
R/L116.2140.02	4.0	3.6							▲/△			
									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

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

硬质合金牌号
Carbide grades

J

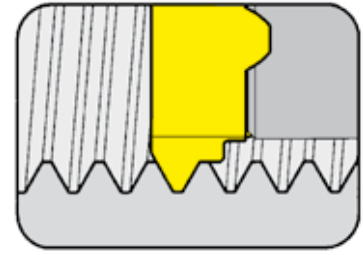
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

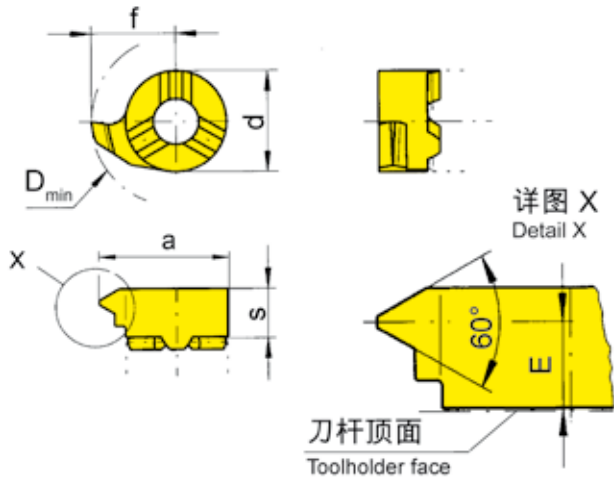
116



孔径最小至 螺距	Bore \varnothing from Pitch	16.0 mm 1.0 - 2.0 mm
-------------	----------------------------------	-------------------------

配合 刀杆
for use with Toolholder

型号 145
Type B116



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制细螺纹
Metric ISO fine thread

产品型号 Part number	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L116.0510.02	1.0	4.7							▲/△		
R/L116.0815.02	1.5	4.5	5.5	10.2	15.7	11	16		▲/▲		
R/L116.1020.02	2.0	4.3							▲/△		
<ul style="list-style-type: none"> ▲ 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			

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

硬质合金牌号
Carbide grades



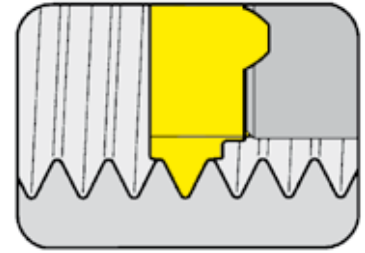
螺纹切削-全牙型 (内圆)

THREADING (internal) Full profile



刀片型号
INSERT Type

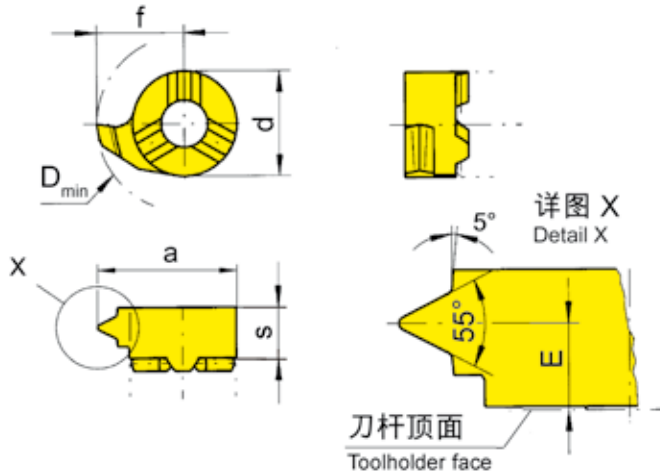
116



孔径最小至 每英寸牙数	Bore Ø from Threads per inch	16.0 mm 11/14
----------------	---------------------------------	------------------

配合 刀杆
for use with Toolholder

型号 145
Type B116



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

惠氏管螺纹
DIN ISO228;(259)和2999
Whitworth pipe thread as per
DIN ISO 228; (259) and 2999

产品型号 Part number	每英寸螺牙数 Threads per Inch	P	E	s	f	a	d	D _{min}	MG12	TN35	TI25	TH35
R/L116.5511.02	11	2.309	3.5	5.5	10.2	15.7	11	16		▲/▲		
R/L116.5514.02	14	1.814	3.9	5.5	10.2	15.7	11	16		▲/▲		
									P	•		
									M	•		
									K	•		
									N	•		
									S	•		
									H			

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

硬质合金牌号
Carbide grades

J

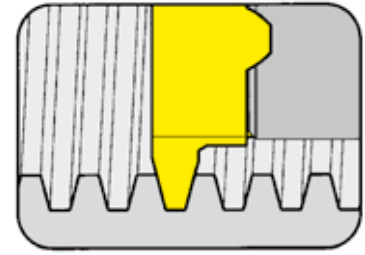
螺纹切削-非全牙型 (内圆)

THREADING (internal) Partial profile



刀片型号
INSERT Type

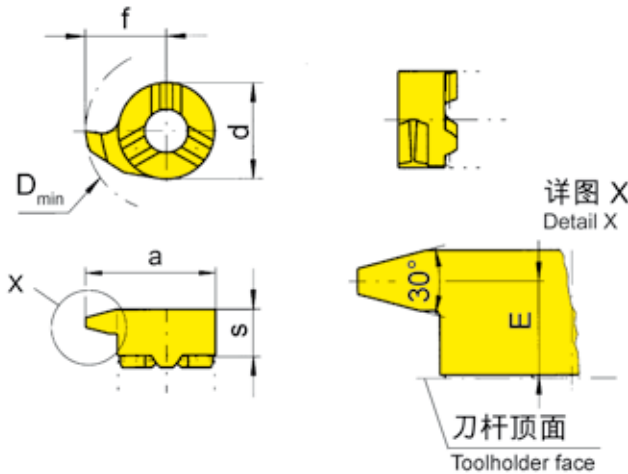
116



孔径最小至 螺距	Bore Ø from Pitch	16.0 mm 2.0 - 6.0 mm
-------------	----------------------	-------------------------

配合 刀杆
for use with Toolholder

型号 145
Type B116



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	s	f	a	d	D _{min}	梯形螺纹 Trapezoidal thread	MG12	TN35	TI25	TH35
R/L116.1220.01	2	4.50		9.7	15.2			Tr 20x2		▲/▲		
R/L116.1730.01	3	4.30		9.7	15.2			Tr 22x3		▲/▲		
R/L116.2240.01	4	4.00	5.5	9.7	15.2	11	16	Tr 22x4		▲/▲		
R/L116.2750.01	5	3.55		10.2	15.7			Tr 24x5		▲/▲		
R/L116.3560.01	6	3.30		10.2	15.7			Tr 30x6			▲/▲	

▲ 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

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

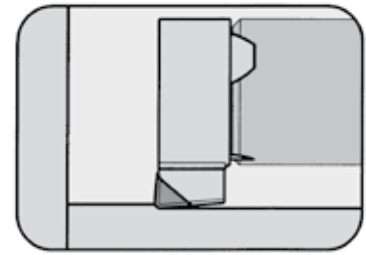
P	●	●	
M	●	●	
K	●	●	
N	●	●	
S	●	●	
H			

硬质合金牌号
Carbide grades

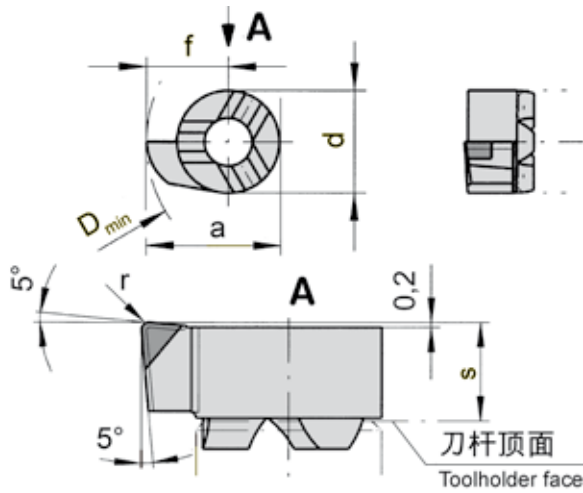


刀片型号
INSERT Type

116



孔径最小至 Bore Ø from 14.0 mm



配合刀杆
for use with Toolholder

型号 145
Type B116

CBN刀片
CBN tipped

R=右手型-如图
R = right hand version shown

产品型号 Part number	r	s	f	a	d	D _{min}	CB10
R116.0582.04.B	0.4	5.3	8.2	13.7	11	14	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 •

单位 : mm
Dimensions in mm
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

J

高性能铰削 HORN DR系列

HIGH-PERFORMANCE REAMING
HORN System DR

Ø 11.9 - 100.6 mm



许可证 / Licence



- 协同效应优势 -
- Benefits of Synergy -

需要更多信息请参阅HORN样本 "硬质合金铰削刀具"

For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line									
	105	110	107	108	10P	111	11P	114	116	18P
≥ 0.2	•									
≥ 0.5	•									
≥ 0.7	•									
≥ 1.0	•									
≥ 1.5	•									
≥ 2.0	•									
≥ 3.0	•									
≥ 4.0	•									
≥ 5.0	•									
≥ 6.0	•	•								
≥ 6.8		•								
≥ 7.0			•							
≥ 7.8		•	•	•						
≥ 8.0		•	•	•						
≥ 9.0		•	•	•	•		•			
≥ 10.0		•			•	•				
≥ 10.5							•			
≥ 11.0						•	•			
≥ 11.5							•			
≥ 13.8								•		
≥ 14.0								•	•	
≥ 16.0									•	
≥ 16.5								(•)		
≥ 18.0										•

槽深 Depth of groove	2.5	4.0	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-3.0	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

加工 / Machining										
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•		•		•	•	
螺纹切削 / Threading	•		•	•		•		•	•	
倒角 / Chamfering	•		•	•		•		•	•	
端面切槽 / Face Grooving	•	•						•		
硬车削 / Hard turning	•			•		•		•	•	

章 / Chapter	A	B	C	D	E	F	G	H	J	K
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可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

Mini 硬质合金切槽刀具
Mini CARBIDE GROOVING TOOLS

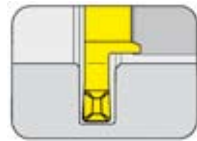
型号 18P
type

B18P
刀柄
Toolholder

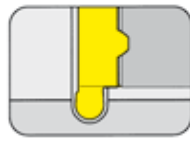


页 / Page
K2

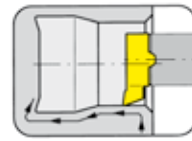
18P / S18P
≥ Ø 18 mm
刀片
Inserts



页 / Page
K3, K5



页 / Page
K4



页 / Page
K6

技术说明
Technical Instructions

页
Page M1-M7

K

切槽 (内圆) $\geq \varnothing 18.0 \text{ mm}$ GROOVING (internal)

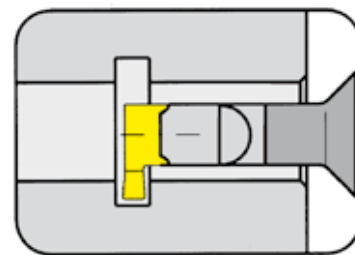


刀杆 型号

TOOLHOLDER Type

B18P

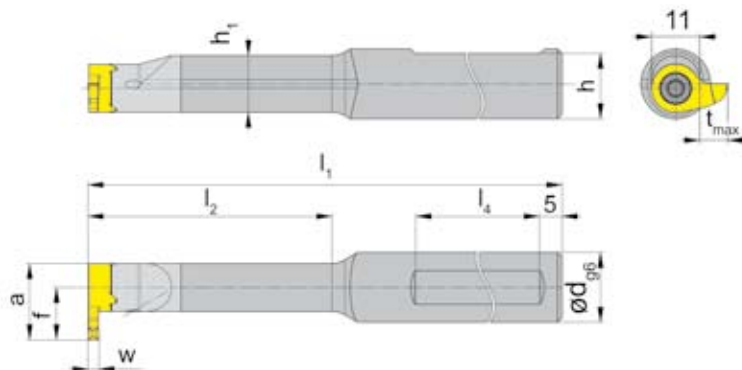
带内冷
with through coolant supply



孔径最小至	Bore \varnothing from	18.0 mm
槽深可达	Depth of groove up to	8.0 mm
槽宽	Width of groove	2.0 - 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 18P

Type S18P

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	l_2	h	h_1	l_4
R/LB18P.0012.00	12	100	25	11	12.5	50
R/LB18P.0012.01		120	40			
R/LB18P.0016.00	16	100	25	15	13.0	50
R/LB18P.0016.01		120	40			
R/LB18P.0016.02		130	56			
R/LB18P.0016.03		150	80			

注明R或L型

State R or L version

w, a, t_{max} 和 f 见刀片

w, a, t_{max} and f see inserts

单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

HORN可以返修损坏的刀杆基座。

Ordering note:

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
R/LB18P.001...	5.13T20EP	T20PQ

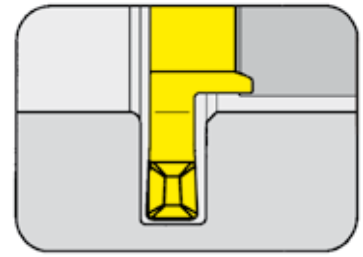
切槽 (内圆) $\geq \varnothing 18.0 \text{ mm}$

GROOVING (internal)



刀片型号
INSERT Type

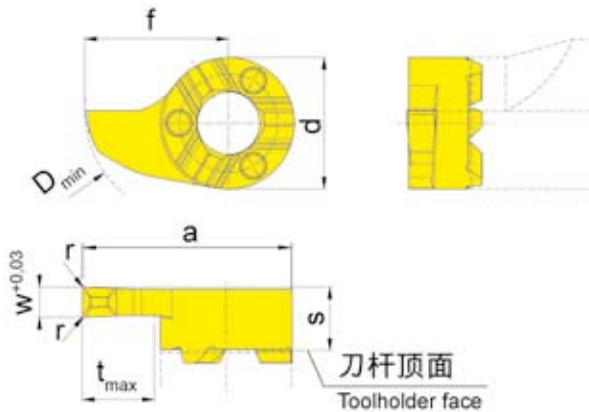
S18P



孔径最小至	Bore \varnothing from	18.0 mm
槽深	Depth of groove	6.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

配合 刀杆
for use with Toolholder

型号 B18P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/LS18P.0200.1.D2	2.0											▲/▲
R/LS18P.0250.1.D2	2.5	0.2	5.3	12	17.5	11	6	18				▲/▲
R/LS18P.0300.1.D2	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			

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

硬质合金牌号
Carbide grades

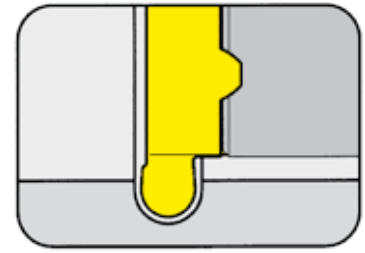


切槽 (内圆) $\geq \varnothing 18.0 \text{ mm}$ GROOVING (internal)



刀片型号
INSERT Type

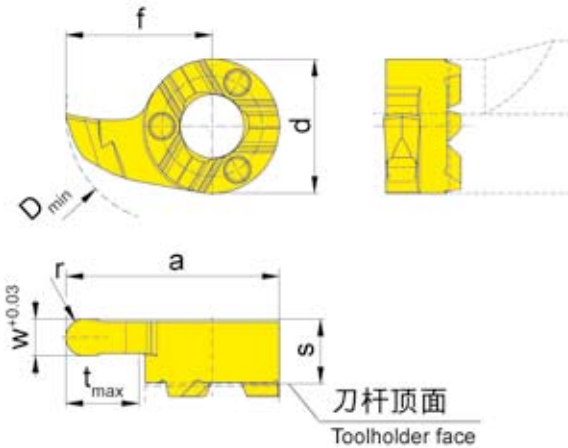
18P



孔径最小至 圆头	Bore \varnothing from Full radius	18.0 mm r 0.9 - 1.5 mm
-------------	--	---------------------------

配合 刀杆
for use with Toolholder

型号 B18P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/L18P.0009.1.18	1.8	0.9										▲/△
R/L18P.0011.1.22	2.2	1.1	5.3	12	17.5	11	6	18				△/△
R/L18P.0015.1.30	3.0	1.5										▲/△
▲ 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			

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

硬质合金牌号
Carbide grades

K

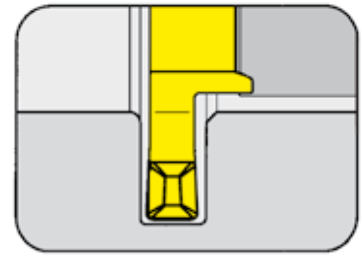
切槽 (内圆) $\geq \varnothing 20.0$ mm

GROOVING (internal)



刀片型号
INSERT Type

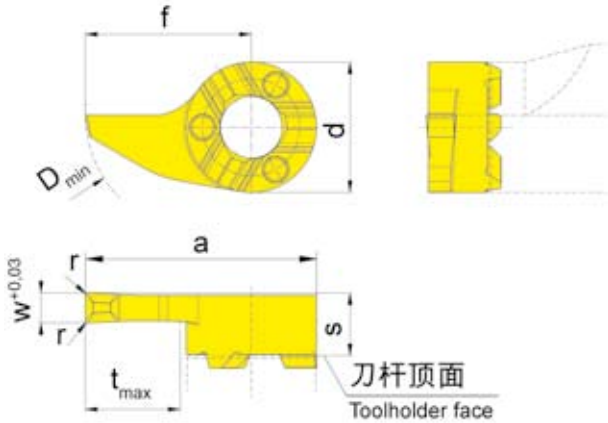
S18P



孔径最小至	Bore \varnothing from	20.0 mm
槽深	Depth of groove	8.0 mm
槽宽	Width of groove	2.0 - 3.0 mm

配合 刀杆
for use with Toolholder

型号 B18P
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	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TH35
R/LS18P.0200.2.D2	2.0											▲/▲
R/LS18P.0250.2.D2	2.5	0.2	5.3	14	19.5	11	8	20				▲/▲
R/LS18P.0300.2.D2	3.0											▲/▲
▲ 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			

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

硬质合金牌号
Carbide grades



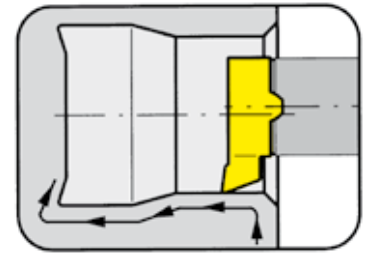
镗孔和仿形加工 $\geq \varnothing 17.5 \text{ mm}$

BORING and PROFILING



刀片型号
INSERT Type

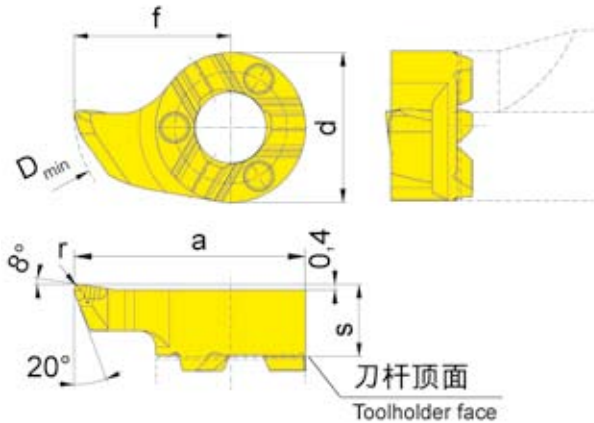
S18P



孔径最小至 Bore \varnothing from 17.5 mm

配合刀杆
for use with Toolholder

型号 B18P
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	r	s	f	a	d	D _{min}	硬质合金牌号			
							MG12	TN35	TI25	TH35
LS18P.1815.R2	0.2									△
RS18P.1815.R2	0.2					17.5				▲
LS18P.1815.R4	0.4	5.3	11.5	17	11					△
RS18P.1815.R4	0.4									▲
<ul style="list-style-type: none"> ▲ 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			

单位 : mm
Dimensions in mm

注明R或L型
State R or L version

改进型的几何结构可以镗 $\geq \varnothing 17.5 \text{ mm}$ 的孔和仿形加工DIN509E型和F型的退刀槽。
The modified geometry allows boring of bores $\geq \varnothing 17.5 \text{ mm}$ and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

K

Supermini®

Mini

加工实例
Examples for machining

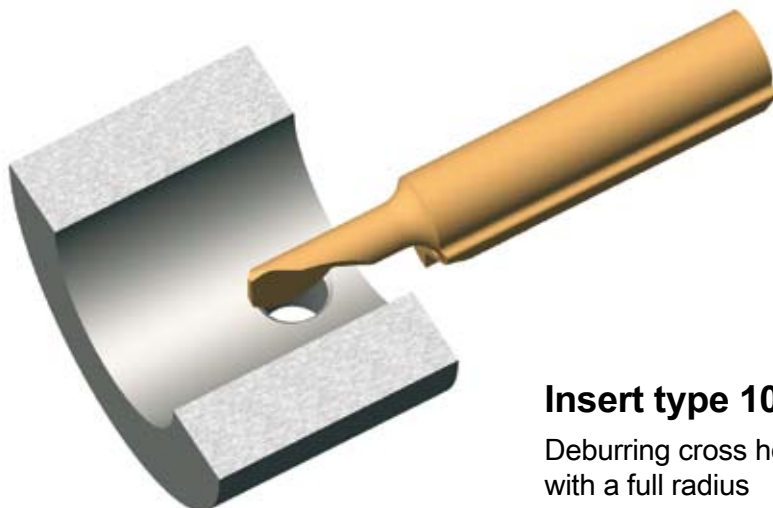
技术说明, 附加设备
Technical Instructions, Additional equipment

L

M

刀片 型号 105

使用旋转刀片去除交叉孔毛刺

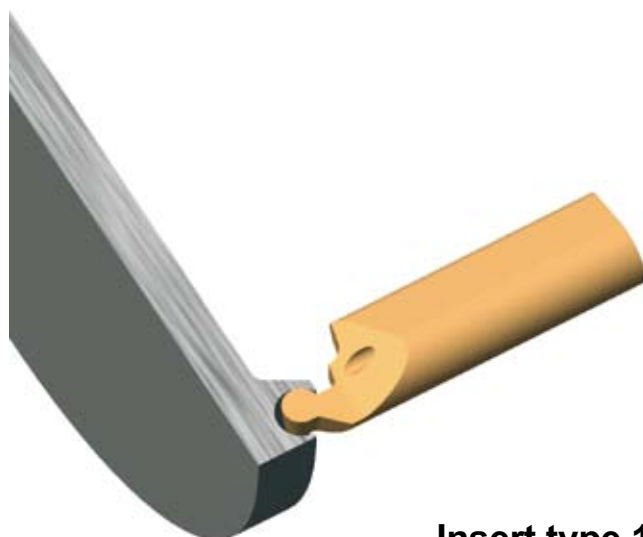


Insert type 105

Deburring cross holes using a rotating insert with a full radius

刀片 型号 105

端面成型槽 (圆头刀片)

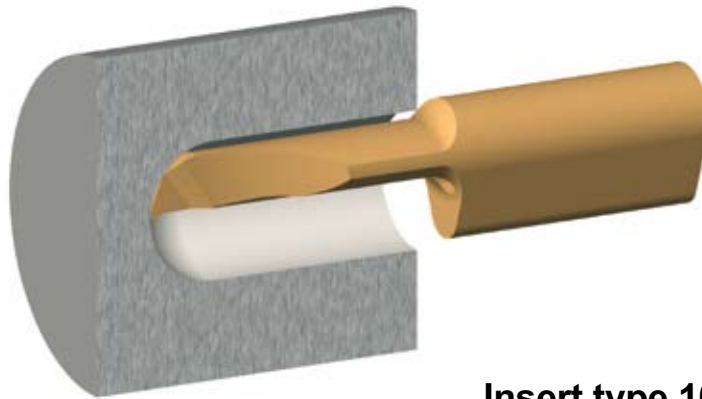


Insert type 105

Profiling a face groove (full radius insert)

刀片 型号 105

半球形加工



Insert type 105

Machining a hemisphere

刀片 型号 105

带倒角的端面开槽

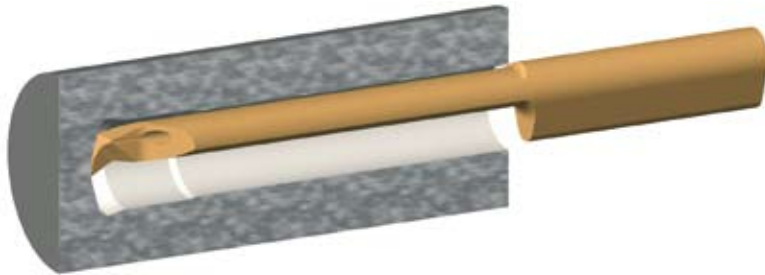


Insert type 105

Face grooving with chamfers

刀片 型号 105

加工孔底退刀槽

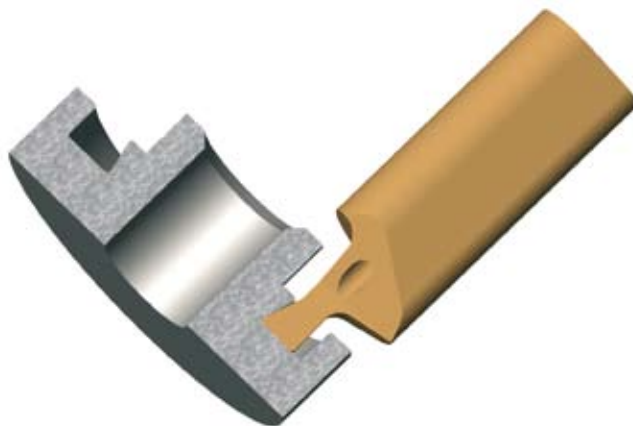


Insert type 105

Machining a flat bottom hole with an undercut

刀片 型号 105

加工端面燕尾槽

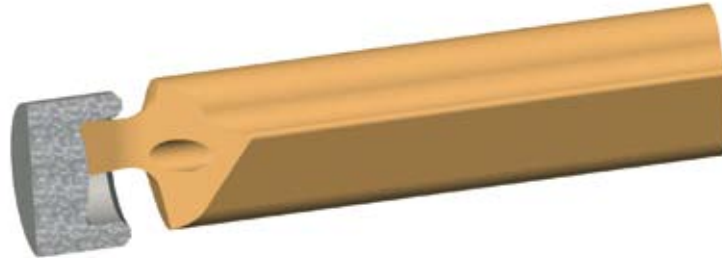


Insert type 105

Machining of a dovetail face groove

刀片 型号 105

车削孔底凸面

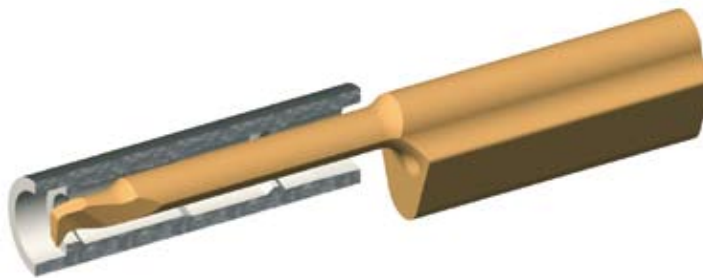


Insert type 105

Plunge machining of a convexed face
in a bore

刀片 型号 105

加工孔内轮廓

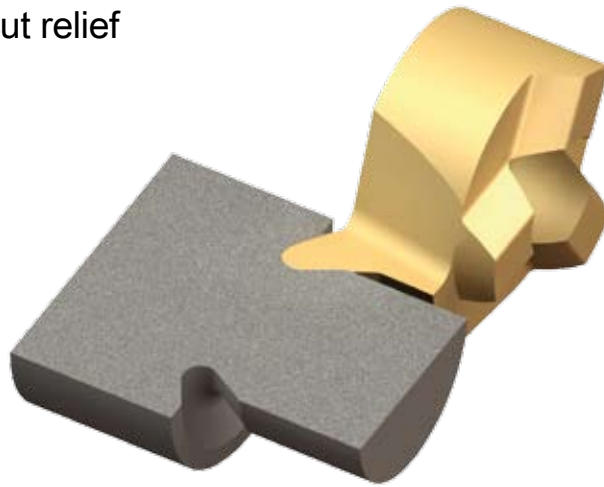


Insert type 105

Profiling of deep bores

刀片 型号 108

Special angled under-cut relief

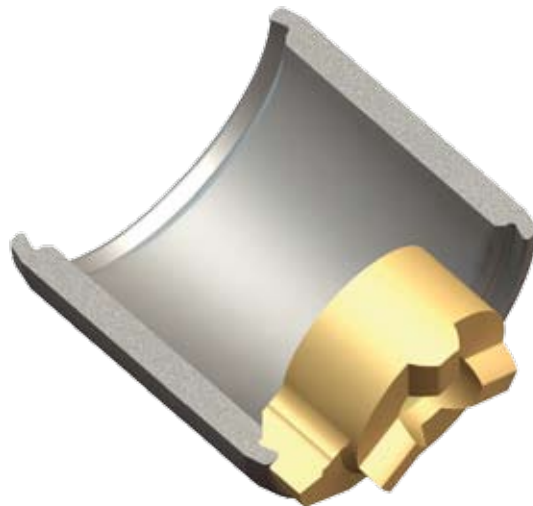


Insert type 108

Special angled under-cut relief

刀片 型号 111

特殊槽轮廓和端面轮廓



Insert type 111

Special ID form groove and facing

刀片型号 11P

非标多头大升角内螺纹

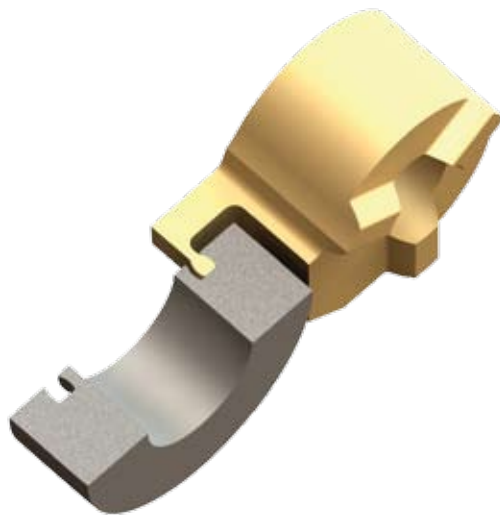


Insert type 11P

Special internal multi-start
high helix thread

刀片型号 114

特殊背面槽和O型圈槽轮廓



Insert type 114

Special back face groove and
form of captive o-ring groove



插削“内六角”
Broaching "Hexagon socket"



插削“Torx”
Broaching "Torx"



更多信息见HORN样本“硬质合金槽刀”

For further information please see the HORN catalogue "CARBIDE GROOVING TOOLS"

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。

涂层牌号

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

TF45 - 一种TiAlN涂层，具有非常好的热稳定性和高硬度，应用于特殊加工。
TA45

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

COATED GRADES

TN35 - a very popular grade TiN coated used to low or medium cutting speeds. Also recommended for machining stainless steel or exotic alloyed materials

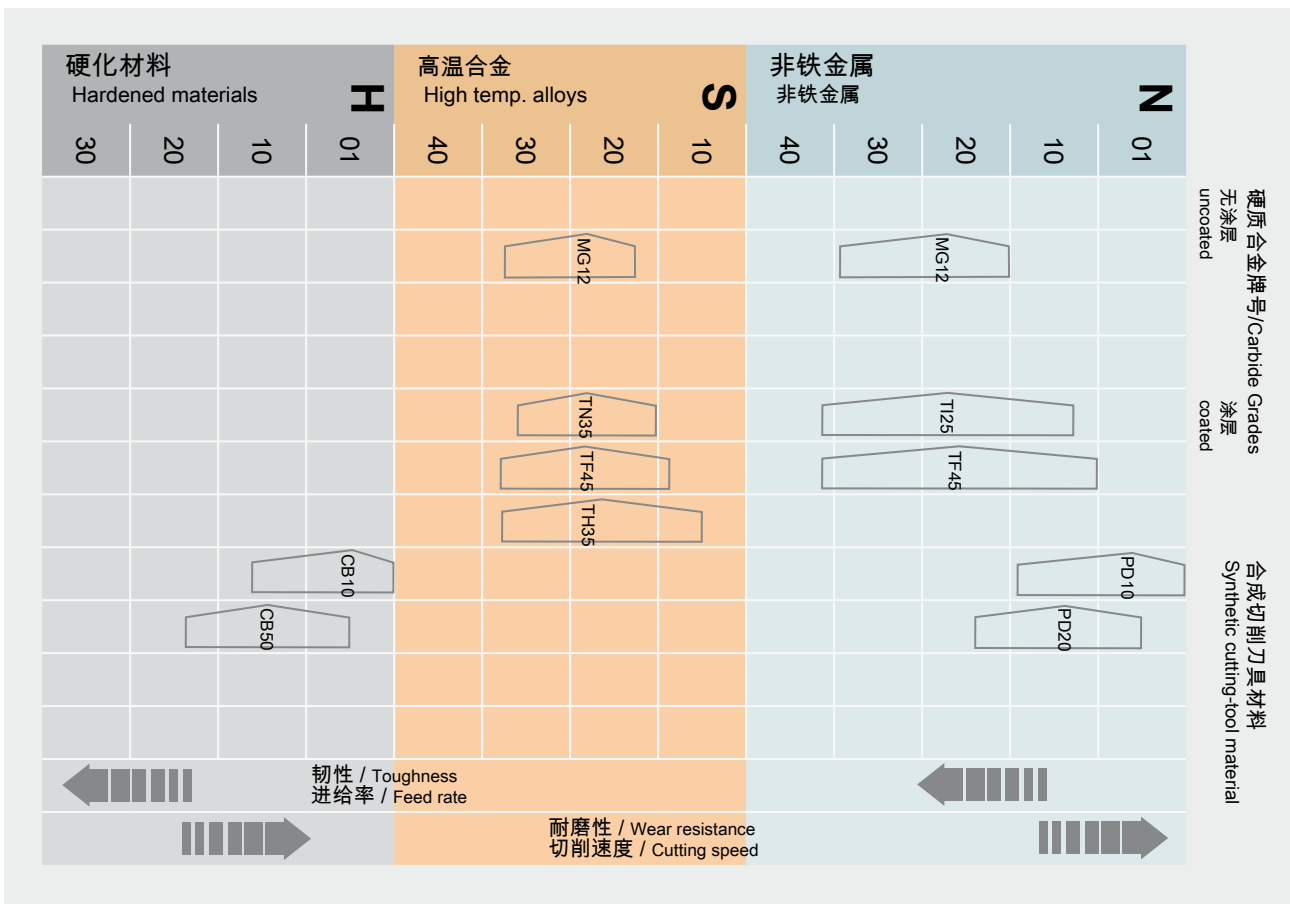
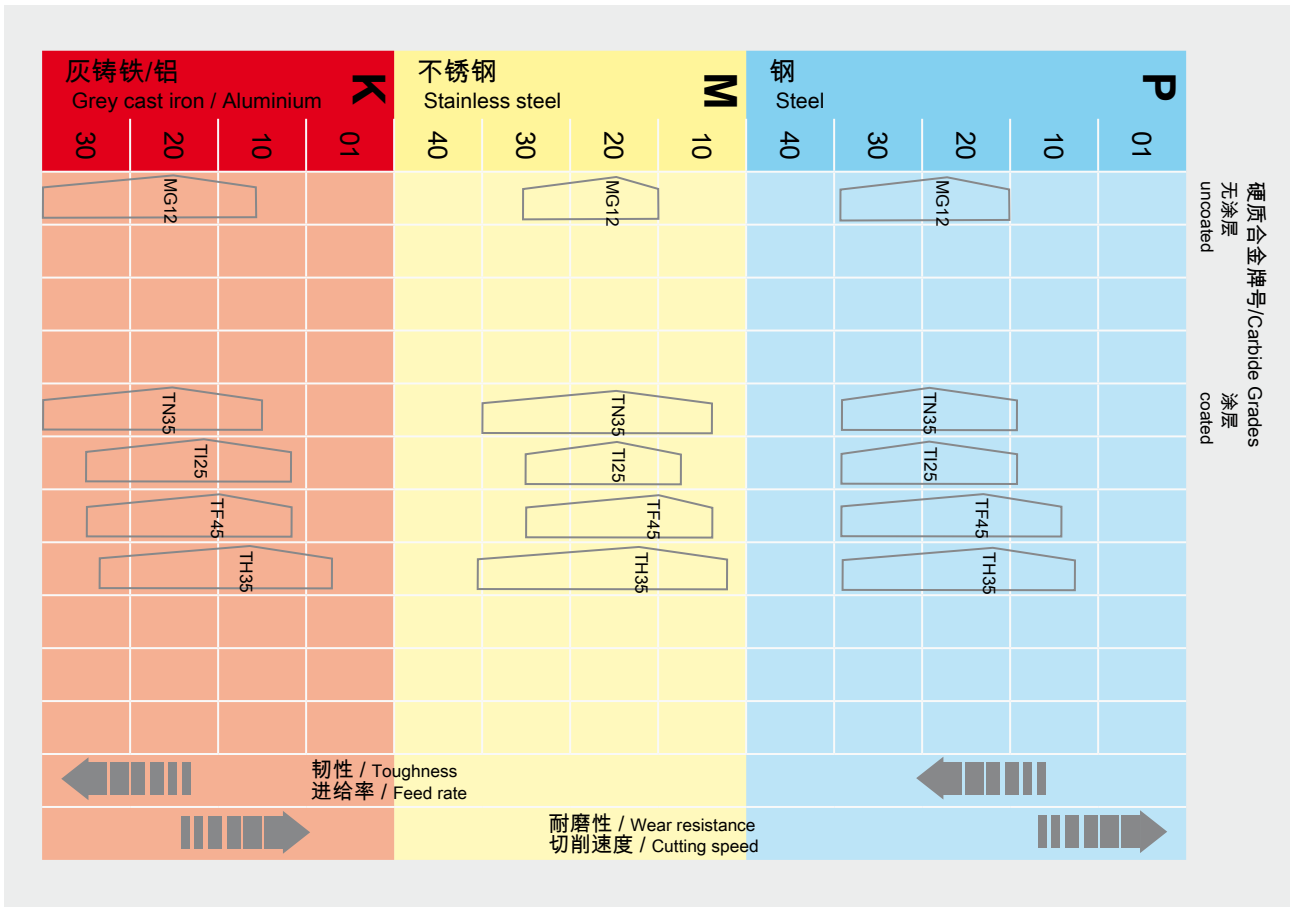
TI25 - a TiCN coated grade with high abrasion resistance. Recommended for machining steel and non ferrous materials at medium cutting speeds

TF45 - a TiAlN coated grade. This coating has a very high temperature stability and high hardness and is only used for special applications.
TA45

TH35 - new standard grade - extreme Oxidation resistance with high hardness and very good coefficient of friction.

硬质合金牌号的选择

CHOICE OF CARBIDE GRADES



M

HORN各种刀具材质的推荐切削速度 Nominal cutting speeds with HORN grades

ISO	材料 Material	硬度 Brinell Hardness Brinell HB	进给率 / Feed rate f mm/U		切削速度 / Cutting speed * v_c m/min				
			Supermini®		Mini				
			MG12	TN35	TI25	TF45	TH35	CB10/50	
P	碳钢 Carbon steel	C < 0.4%							
		C > 0.4% < 0.6 %	150	14-110	14-180	14-180	14-180	14-180	
		C > 0.4% < 0.6 %	200						
	低合金钢 low alloyed steel	退火 annealed	180						
		淬火 quenched	275	16-90	16-150	16-150		16-180	
		淬火 quenched	300						
	高合金钢 high alloyed steel	退火 annealed	200		19-90	19-90		19-120	
		淬火 quenched	325						
	铸钢 Cast steel	非合金 unalloyed	180						
		低合金 low alloyed	220	19-110	19-180	19-180		19-180	
高合金 high alloyed		225							
M	不锈钢 Stainless steel	马氏体, 铁素体 martensitic, ferritic	200		19-90	19-90		19-90	
		奥氏体 austenitic	180		16-80			16-80	
K	灰铸铁 Grey cast iron		180-260	16-90	16-150	16-150	16-150	16-150	
	球墨铸铁 Spheroidal graphite cast iron		180-260	16-90	16-130	16-130	16-150	16-150	
	可锻铸铁 Malleable cast iron		130-230		16-130	16-130	16-150	16-150	
S	耐热合金 Heat resistant alloy	NiFe				18-75	18-75	18-75	
		NiCo				18-40	18-40	18-40	
N	铝合金 Al-alloys			14-220	16-600	16-600		16-600	
	铜和黄铜合金类 Copper and brass alloys			14-220	14-700	14-700		14-700	
H	硬化材料 hardened material	> 54 HRC							20-140

v_c 决定于刀具直径和机床的最大转速。

V_c is depending on the tool diameter and therefore of the maximum numbers of revolutions of the machine.



螺钉扭矩

TORQUE OF SCREWS



以下是允许使用的螺钉的扭矩，不建议使用额外的润滑剂，如铜膏或其他。关于扭矩扳手，见章节辅助装置

Following torques are allowed for screws of MINI inserts. We recommend to use no additional gliding means (such as copper paste) for screws. For torque screw drivers please see chapter additional equipment.

型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
AIH	030.3509.T15P	2.5	T10PL	DT10PK
	6.075T15P	5.0	T15PQ	DT15PK
B105	6.075T15P	5.0	T15PQ	DT15PK
B105C	6.075T15P	5.0	T15PQ	DT15PK
B105KM	6.075T15P	5.0	T15PQ	DT15PK
B107	2.2.5T7EP	1.1	T7PL	DT7PK
B108	2.2.5T8EP	1.2	T8PL	DT8PK
B108KM	2.2.5T8EP	1.2	T8PL	DT8PK
B10P	2.2.5T8EP	1.2	T8PL	DT8PK
B110	6.075T15P	5.0	T15PQ	DT15PK
B110C	6.075T15P	5.0	T15PQ	DT15PK
B110KM	6.075T15P	5.0	T15PQ	DT15PK
B111	3.512T10EP	3.0	T10PL	DT10PK
B114	4.12T15EP	5.0	T15PQ	DT15PK
B116	5.13T20EP	6.5	T20PQ	DT20PK / DT20PQ
B11P	3.10T9P	1.8	T9PL	DT9PK
B18P	5.13T20EP	6.5	T20PQ	DT20PK / DT20PQ
BGT001...	DIN912M5x10	5.0	SW4DIN911	DSW40K
BGT001.C...	DIN912M5x14	5.0	SW4DIN911	DSW40K
BKT	6.075T15P	5.0	T15PQ	DT15PK
BU105	6.075T15P	5.0	T15PQ	DT15PK
H105	6.075T15P	5.0	T15PQ	DT15PK
HC105	6.075T15P	5.0	T15PQ	DT15PK
HC114	4.12T15EP	5.0	T15PQ	DT15PK
IR105	6.075T15P	5.0	T15PQ	DT15PK
LB105.A022.26.31	030.0422.T10P	3.0	T10PL	DT10PK
KM16NC...	KM16-NSPKG	10.0	D515QL	DT27PQ
KM2016NC...	KM16-NAPKG	10.0	D515QL	DT27PK
N...	6.075T15P	5.0	T15PQ	DT15PK
VDI	6.075T15P	5.0	T15PQ	DT15PK
001	DIN1835B-M8x7,5	5.0	SW4DIN911	DSW40K
125	3.512T10EP	3.0	T10PL	DT10PK
145	5.13T20EP	6.5	T20PQ	DT20PK / DT20PQ
962	6.075T15P	5.0	T15PQ	DT15PK
963	6.075T15P	5.0	T15PQ	DT15PK

M

螺纹

无特殊牙顶要求，螺旋角达4.5 °的螺纹都可使用HORN的标准螺纹刀片加工出来。

基座

Mini和Supmini®系列都可保证精确的中心高，但也请加工前检查中心高，因为任何小的误差都可能引起问题，特别是在加工小直径零件时。

切屑排出

请选择小切宽的刀片，这样有助于切屑的疏导和排出，防止切槽的过程中切屑阻塞。

冷却

使用过滤的冷却液带走切屑并冷却刀片，冷却液的最小压力5 bar。

THREADING

All threads up to 4,5 ° helix angle can be manufactured with HORN standard threading inserts. No special anvils will be necessary.

SEATINGS

of Mini as well as of Supermini® garantie the accurate centre height of these tools. In spite of this please always check centre height beacuse a difference may cause problems especially when machining small diameters.

REMOVAL OF CHIPS

Please choose inserts with small cutting widths, which helps chips evacuation and chip flow out of the bore beside the tool. To avoid jam of chips use the technique to groove by steps.

COOLANT

Use a filtered coolant for transporting the chips out and for cooling the insert itself. A coolant pressure of 5 bar min. is recommended.

推荐切削参数

RECOMMENDED NUMBER OF PASSES

硬质合金牌号 / Carbide grade	钢 (拉伸强度 N/mm ²) Steel (Tensile strength N/mm ²)					不锈钢 Stainless steel	灰铸铁 Grey cast iron	铝 Aluminium	
	400-500	500-700	700-850	850-1150	> 1150				
TN35	400-500	500-700	700-850	850-1150	> 1150	90	100	300	
V _{max} m/min	160	140	120	90	70	90	100	300	
螺距 / Pitch P		程数 / Number of passes							
mm	每英寸 齿数 / tpi								
0.8	32	5	5	5	5	8	8	5	5
1.0	24	6	6	6	6	8	8	6	6
1.25	20 - 19	7	7	7	7	8	8	7	7
1.5	16	8	8	8	8	10	10	8	8
1.75	14	10	10	10	10	12	12	10	10
2.0	12 - 11	12	12	12	12	14	14	12	12
2.5	10	13	13	13	13	15	15	13	13
3.0 - 3.5	8	15	15	16	16	18	18	16	15

表中的推荐切削行程数为近似值

请注意：

- 为了避免切削刃的损坏，首行程切深不宜过大
- 最后零切深的精修在表内未考虑

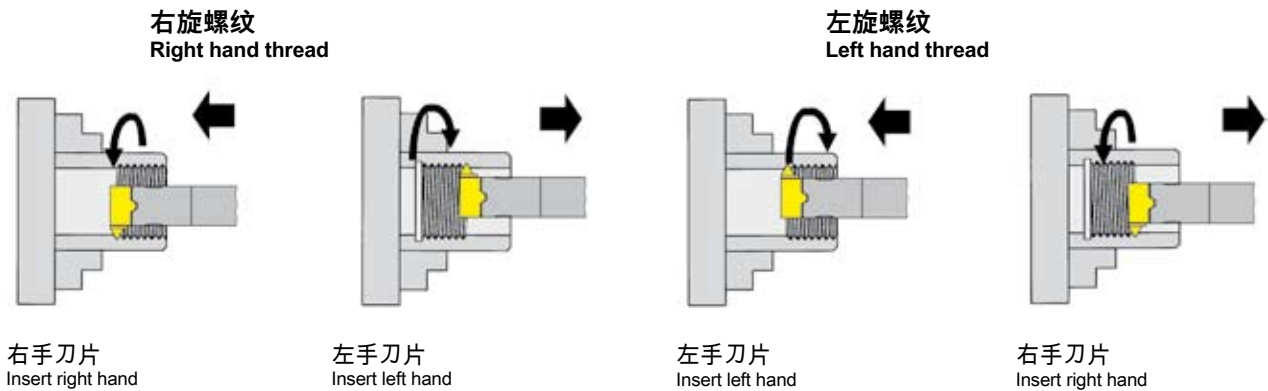
The recommended number of passes in the above table are approxiamte figures.

Please note:

- to avoid breakages at the cutting edge, the depth of cut at the first pass should not be to deep
- finishing passes (with zero depth of cut) are not considered in the table

进给率 内螺纹加工

FEED RATE internal threading

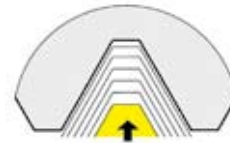


进给

IN-FEED

径向进给

同时切削刀片两边的材料，这是加工螺纹时最普通的方法。



RADIAL IN-FEED

Metal removed on both sides of the insert simultaneously. The most commonly used method for thread production.

改进的侧刃进给

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。



MODIFIED FLANK IN-FEED

Less wear of the trailing edge and better surface finish on corresponding flank.

变化的后刀面进给

两个刃都被充分利用，意味着刀片寿命更长。



ALTERNATING FLANK IN-FEED

Both edges are being fully utilised which means longer insert life.

后刀面进给

更好的断屑和散热



FLANK IN-FEED

More easily formed chip and better heat dissipation.





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



ED 28 VL

扭矩设定器

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

Torque setter

Device for setting the required torque.
Handle: Celluloseacetat with micro structured surface
Blade: Octogonal (8 flats) blade, hardened galvanized



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



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.



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。

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.



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: $\pm 6\%$)



ED515QL

扭矩设定器

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

Torque setter

Device for setting the required torque.
Handle: Celluloseacetat with micro structured surface
Blade: Octogonal (8 flats) blade, hardened galvanized



D14ZBQ

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。

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.



DT15Q
DT20Q
DT25Q
DT30Q

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-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.



DSW15K
DSW20K
DSW25K
DSW30K
DSW40K

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



T6PW
T7PW
T8PW
T9PW
T10PW
T15PW
T20PW
T25PW
T30PW

扳手-TORX PLUS® 螺钉

用途：适用于所有TORX PLUS®螺钉

注意：TORX PLUS®-扳手不适用于Torx-螺钉

Wrench for TORX PLUS® Screws

Utilization: For all kind of using TORX PLUS® Screws

Attention: TORX PLUS®-Wrench does NOT fit for Torx-Screws

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 (Cermets) 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)

DIN ISO 513不能代替制造商的牌号描述和命名。

DIN ISO 513作为各制造商牌号的对比参照

DIN ISO 513 does not replace the manufacturers grade discription or designation.

DIN ISO 513 gives a comparison for grades from various manufacturers.

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