

车 槽

切 断

铣 槽

插 削

仿 形 铣 削

铰 削

新 产 品

NEW

**S100 和 S224 系统全新的加工
铝合金几何槽型**

切槽和切断

**New geometry for Aluminium
in Systems S100 and S224**

for grooving and parting off

HORN-卓越于技术

HORN - EXCELLENCE IN TECHNOLOGY



GROOVING PARTING OFF GROOVE MILLING BROACHING PROFILE MILLING REAMING



S100 和 S224 系统全新 的加工铝合金几何槽型

S100 和 S224 车槽系统新开发的几何槽型，专门用于对铝进行车槽、切断，切削宽度为 2 mm 和 3 mm 两种规格。刀片专门针对铝加工而设计，拥有正前角几何槽型和锋利的刀刃。

抛光的切屑几何槽型有助于有效避免切屑瘤产生，同时还可确保出色的切屑控制和极佳的工件表面质量。

除了无涂层 K10 型号外，还提供带涂层的 DD26 刀片，用于加工硅含量较高的铝合金。

推荐采用夹爪式并带内部冷却功能的刀杆，便可实现最佳的加工条件。

New geometry for Aluminium in Systems S100 and S224

A newly developed geometry for grooving and parting off aluminium using the S100 and S224 grooving systems is available with cutting widths of 2 mm and 3 mm. Specially designed for aluminium machining, the inserts boast positive geometry and a sharp cutting edge. The polished chip shape geometry serves to prevent the formation of built-up edges whilst also ensuring excellent chip control and premium surface quality on the workpiece.

In addition to the uncoated K10 model, coated DD26 inserts are also available for aluminium alloys with a higher silicon content.

Toolholders with internal cooling - particularly via the clamping finger - are recommended for optimal machining conditions.



切槽和切断

GROOVING and PARTING OFF

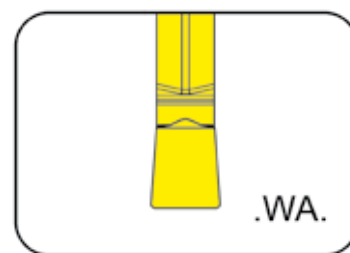


刀片 型号

INSERT Type

S100

带断屑槽
with chip forming



槽宽

Width of groove

2.0 - 3.0 mm

精密打磨和抛光

precision ground and polished

适合与刀杆/刀夹配合使用

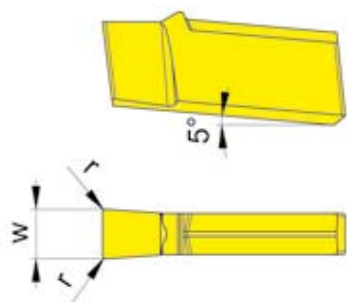
for use with Toolholder / Cassette

型号

H100

Type

NK100



产品型号 Part number	w	r	尺寸规格 Size	K10	DD26
S100.0200.WA2	2	0.2	01	▲	▲
S100.0300.WA2	3	0.2	03	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks				P	
● 主要应用 / main recommendation				M	
○ 可选推荐 / alternative recommendation				K	
■ 无涂层牌号 / uncoated grades				N	●
■ 涂层牌号 / coated grades				S	
■ 钎焊/金属陶瓷 / brazed/Cermet				H	

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

GROOVING and PARTING OFF

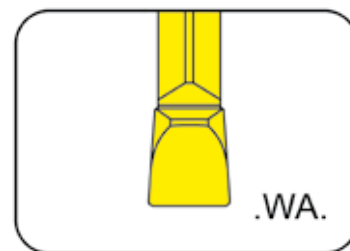


可转位刀片 型号

INDEXABLE INSERT Type

S224

带断屑槽
with chip forming



槽宽
槽深可达

Width of groove
Depth of groove up to

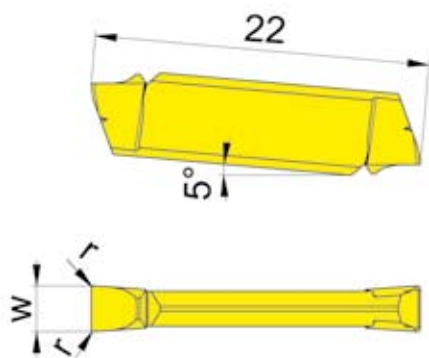
2.0 - 3.0 mm
18.0 mm

精密打磨和抛光

precision ground and polished

适合与刀杆/刀夹配合使用
for use with Toolholder / Cassette

型号 B224
Type BK224
H224



产品型号 Part number	w	r	尺寸规格 Size	K10	DD26
S224.0200.WA2	2	0.2	01	▲	▲
S224.0300.WA2	3	0.2	03	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks				P	
● 主要应用 / main recommendation				M	
○ 可选推荐 / alternative recommendation				K	
■ 无涂层牌号 / uncoated grades				N	●
■ 涂层牌号 / coated grades				S	
■ 钎焊/金属陶瓷 / brazed/Cermet				H	

尺寸单位 : mm
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

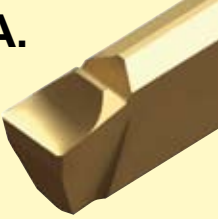
Indexable inserts can be used in **right and left hand** toolholders.

硬质合金牌号
Carbide grades

断屑槽和进给率

Geometries and feed rates



断屑槽 Geometry	应用 Applications	进给率f (mm/转) Feed rate f (mm/rev)
.WA. 	车槽和切断，槽精加工 切削轻快 Grooving and parting off, finishing of grooves, easy cut	↓ 0,07 - 0,25

切削参数

Cutting data

材料 Material			硬度 Hardness Brinell (HB)	切削速度 v_c (m/min) Cutting speed v_c (m/min)	
				K10	DD26
N	铝合金 Al-alloys	非热处理 not heat treatable	30-80	1000-600	1000-600
		热处理 heat treatable	80-120	400-220	400-220
	铸铝合金 Al-cast-alloy	非热处理 not heat treatable	80	1000-600	1000-600
		热处理 heat treatable	100	600-300	600-300

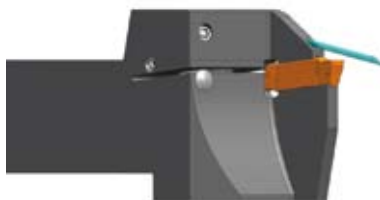
可能供应冷却液。
Possible coolant supply.



冷却液出口喷嘴位于刀片侧面。
Coolant outlet through spray nozzle at the side of the insert.

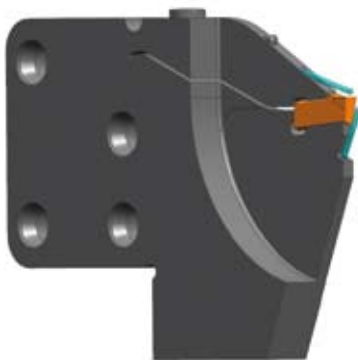


冷却液出口喷嘴位于刀片的侧面和下方。
Coolant outlet through spray nozzle at the side of the insert.



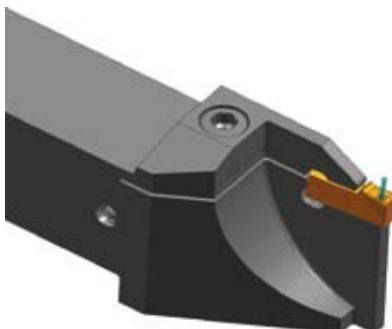
S100
S224
S229

冷却液出口通过刀片的上夹爪。
Coolant outlet through clamping finger.



S100
S224
S229

冷却液出口通过刀片的上夹爪和刀片底部支撑部分。
Coolant outlet through clamping finger and insert support.



S100
S224

冷却液出口通过刀片。
Coolant outlet through insert.



**Hartmetall Werkzeugfabrik
Paul HORN GmbH**

Unter dem Holz 33-35, D-72072 Tübingen
Tel +49 (0)7071/70040, Fax +49 (0)7071/72893
E-Mail info@phorn.de, www.phorn.de

HORN USA, Inc.

320 Premier Court, Suite 205, Franklin,
TN 37067
Tel +1 (888)818-HORN, Fax +1(615)771-4101
E-Mail sales@hornusa.com, www.hornusa.com

HORN CUTTING TOOLS Ltd.

32 New Street, Ringwood, Hampshire,
BH24 3AD, Tel +44 (0)1425/481 800
Fax +44 (0)1425/481 888
E-Mail info@phorn.co.uk, www.phorn.co.uk

HORN Magyarország Kft.

H-9027 Győr, Gesztenyefa u. 4
Tel +36 96 55 05 31, Fax +36 96 55 05 32
E-Mail technik@phorn.hu, www.phorn.hu

HORN S.A.S

665, av. Blaise Pascal, Zone Industrielle,
77127 Lieusaint
Tel +33 (0)1648859-58, Fax +33 (0)1648860-49
E-Mail infos@horn.fr, www.horn.fr

HORN (Shanghai) Trading Co. Ltd.

Room 905, No. 518 Anyuan Road, P.R. of China
Putuo District, Shanghai 200060
上海市安远路518号905室 邮编：200060
Tel：+86 21 52833505；52833205
Fax：+86 21 52832562
E-Mail: info@phorn.cn, www.phorn.cn



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