

Supermini® & Mini

Hartmetall-Werkzeuge

Carbide tools

2014 / 2015





Sehr geehrter Kunde,

unser Ziel ist es, mit den in diesem Katalog vorgestellten Werkzeugen das höchste Maß an Wirtschaftlichkeit und Präzision bei Ihnen zu erreichen.

Der neue HORN-Katalog **Supermini® und Mini** beinhaltet das weltweit umfangreichste Standardprogramm im Bereich der Nutenbearbeitung und zielt darauf ab, Ihren Arbeitsalltag zu erleichtern und Ihnen schnell und übersichtlich die gewünschten Informationen zur Verfügung zu stellen.

Wir sind in der Lage, Standard- und Sonderwerkzeuge binnen kürzester Zeit zu liefern.

Mit unseren Werkzeuglösungen, unserem Know-how und unserer individuellen Beratung stehen wir Ihnen bei Ihren Aufgabenstellungen, Ihren Herausforderungen und Ihren Projekten zur Seite.

Auf gute Zusammenarbeit

Lothar Horn, Geschäftsführer

Dear Customer,

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

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

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

We look forward to working with you in the future.

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

Yours sincerely

Lothar Horn, CEO



phorn.de



phorn.com



youtube.com

- A Supermini® Typ / type 105**
Ausdrehen, Einstechen, Fasen, Gewindedrehen, Axialeinstechen
 Boring, Grooving, Chamfering, Threading, Face Grooving

- B Supermini® Typ / type 109**
Ausdrehen, Einstechen, Fasen, Gewindedrehen, Axialeinstechen
 Boring, Grooving, Chamfering, Threading, Face Grooving

- C Supermini® Typ / type 110**
Ausdrehen, Einstechen, Axialeinstechen
 Boring, Grooving, Face Grooving

- D Mini Typ / type 106**
Ausdrehen, Einstechen, Fasen
 Boring, Grooving, Chamfering

- E Mini Typ / type 107**
Ausdrehen, Einstechen, Fasen, Gewindedrehen
 Boring, Grooving, Chamfering, Threading

- F Mini Typ / type 108**
Ausdrehen, Einstechen, Fasen, Gewindedrehen
 Boring, Grooving, Chamfering, Threading

- G Mini Typ / type 10P**
Einstechen
 Grooving

- H Mini Typ / type 111**
Ausdrehen, Einstechen, Fasen, Gewindedrehen
 Boring, Grooving, Chamfering, Threading

- J Mini Typ / type 11P**
Einstechen
 Grooving

- K Mini Typ / type 114**
Ausdrehen, Einstechen, Fasen, Gewindedrehen, Axialeinstechen
 Boring, Grooving, Chamfering, Threading, Face Grooving

- L Mini Typ / type 116**
Ausdrehen, Einstechen, Fasen, Gewindedrehen
 Boring, Grooving, Chamfering, Threading

- M Mini Typ / type 18P**
Einstechen
 Grooving

- N Technische Hinweise, Anwendungsbeispiele, Zubehör**
 Technical Instructions, Examples for machining, Additional equipment

A

B

C

D

E

F

G

H

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K

L

M

N

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

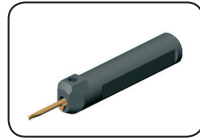
Abmessung in mm
Dimensions in mm

Supermini® HM-SCHNEIDWERKZEUGE

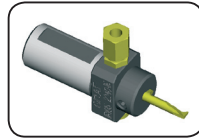
Supermini® CARBIDE GROOVING TOOLS

Typ
type **105**

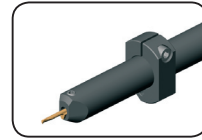
Haltersysteme Toolholder system



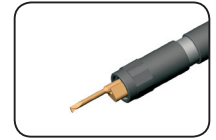
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A2-A10



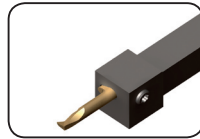
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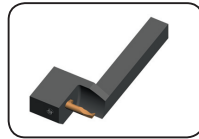
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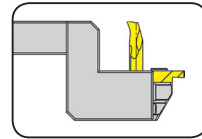
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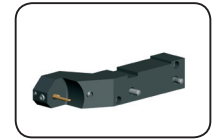
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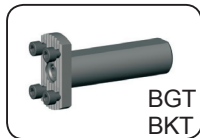
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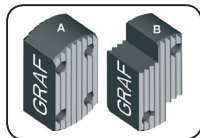
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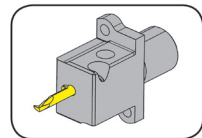
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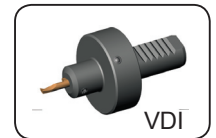
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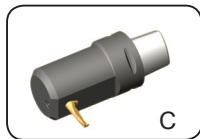
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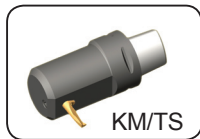
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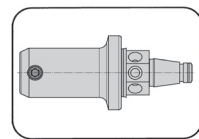
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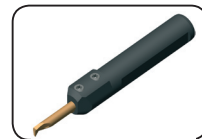
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A48-A50, A103



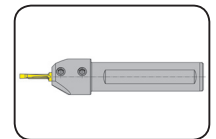
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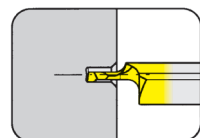


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A102

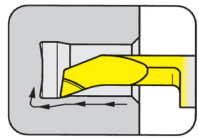


Seite/Page
A105
axial / axial

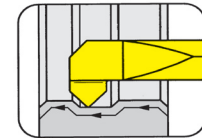
105 ≥ Ø 0,2 mm Schneidplatten Inserts



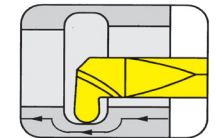
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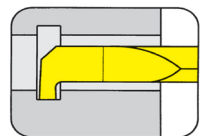
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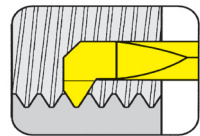
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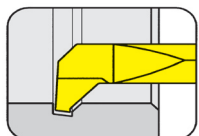
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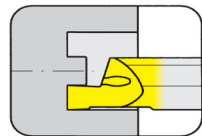
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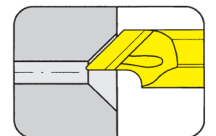
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A83-A92



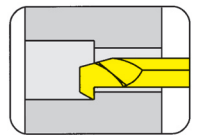
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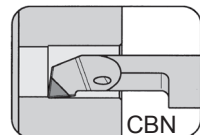
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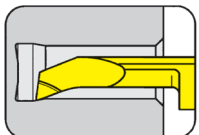
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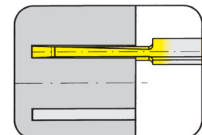
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A104
(verlängerter Spannschaft)
(increased clamping shank)



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A106
axial
axial

Technische Hinweise
Technical Instructions

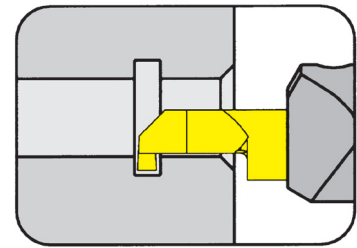
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Page **N2-N8**

KLEMMHALTER Typ

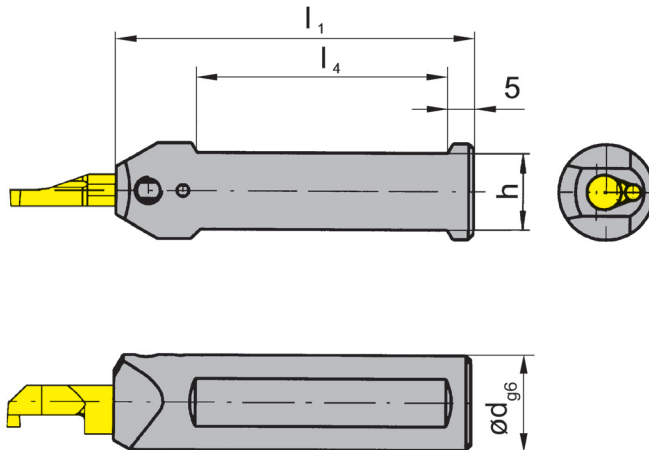
TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

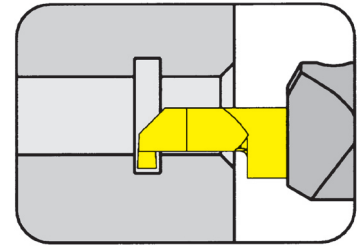
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.00... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

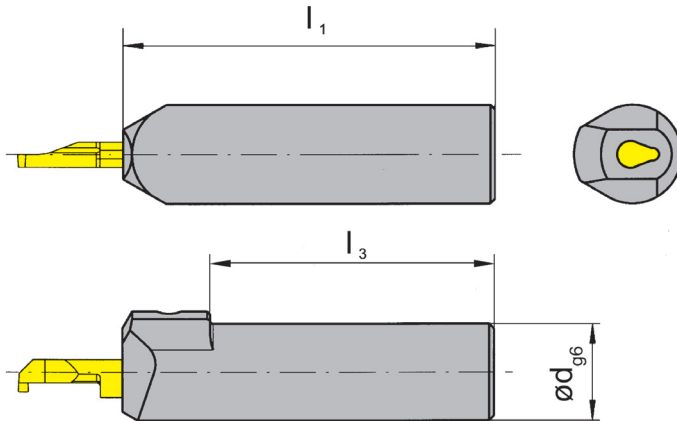
TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

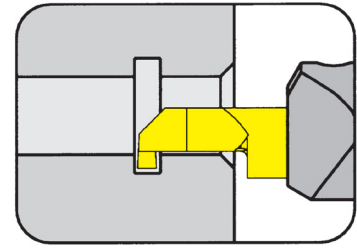
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.001... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

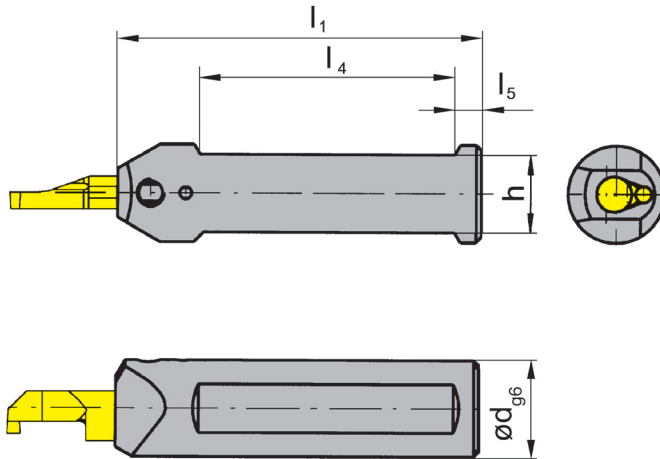
TOOLHOLDER Type

B105/BU105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | h | l ₄ | l ₅ | Bemerkung 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 | ** |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm und Zoll
Dimensions in mm and inch

** Kühlmittelanschluss M12x1,5 für TRAUB

** Adapter of cooling M12x1,5 for Traub

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

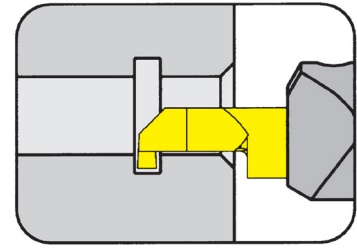
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

für Schneidplatte
for use with Insert

Typ 105
Type

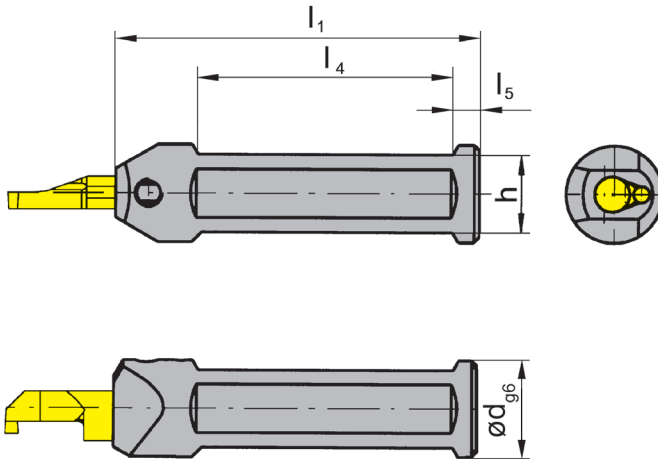


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | h | l ₄ | l ₅ |
|------------------------------|----|----------------|----|----------------|----------------|
| B105.0022.1.2.01 | 22 | 120 | 20 | 72 | 5 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.0022.1.2.01 | 6.075T15P | T15PQ |

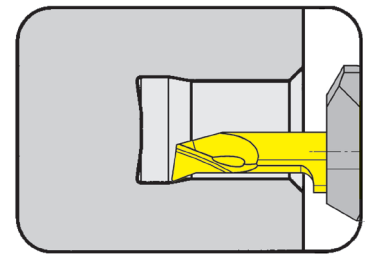
KLEMMHALTER Typ

TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply

| | | |
|---------------|-----------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite | Width of groove | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

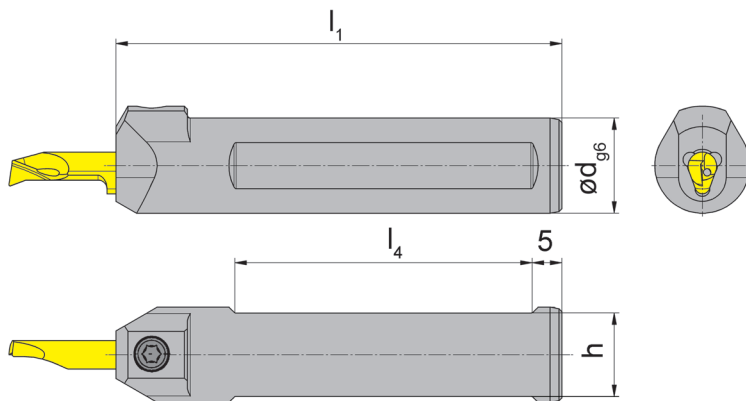


Abbildung = rechtsschneidend
Picture = right hand cutting version

mit zusätzlichen
Spülbohrungen
with additional through coolant
bores

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

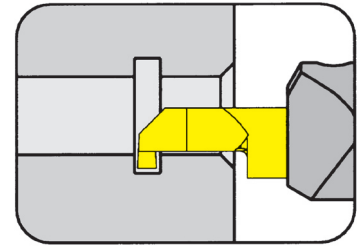
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.00... | 6.075T15P | T15PQ |

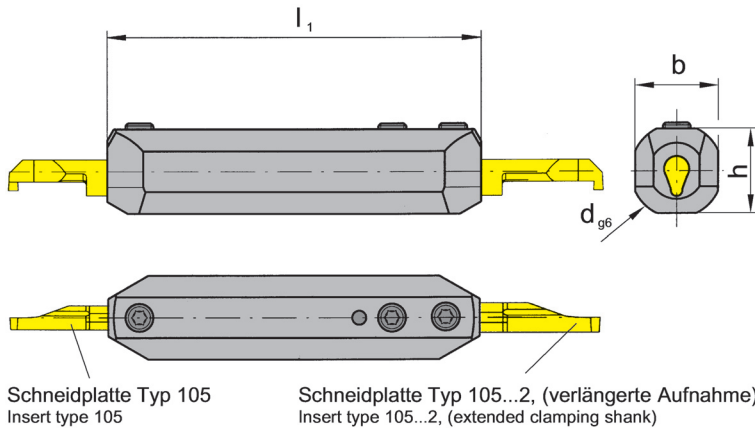
KLEMMHALTER Typ TOOLHOLDER Type

B105

ohne Kühlmittelzufuhr
no coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type 105...2

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | h | b |
|------------------------------|----|----------------|----|----|
| B105.0020.1.03 | 20 | 80 | 18 | 18 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

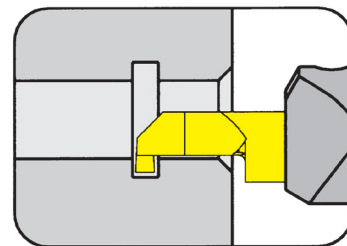
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.0020.1.03 | 6.075T15P | T15PQ |

KLEMMHALTER Typ

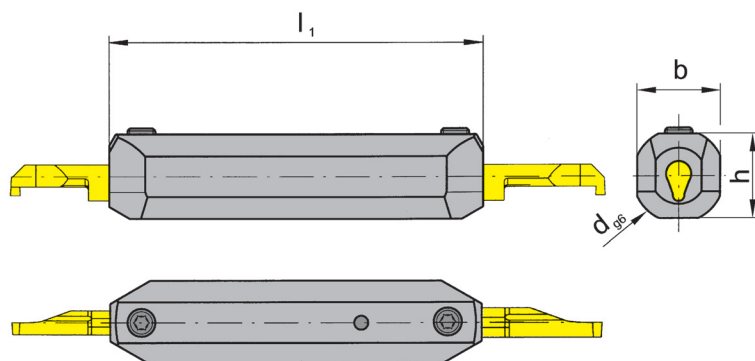
TOOLHOLDER Type

B105

ohne Kühlmittelzufuhr
no coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

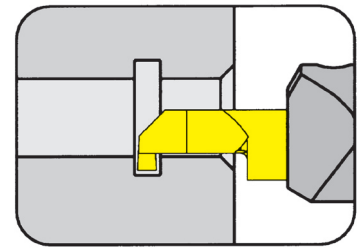
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.0022.2.... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|---------------|-----------------|------------|
| Bohrungs-Ø ab | Bore Ø from | 0,2/6,0 mm |
| Stechtiefe | Depth of groove | 2,5/4,0 mm |
| Stechbreite | Width of groove | 2,0/3,0 mm |

für Schneidplatte
for use with Insert

Typ 105
Type 110

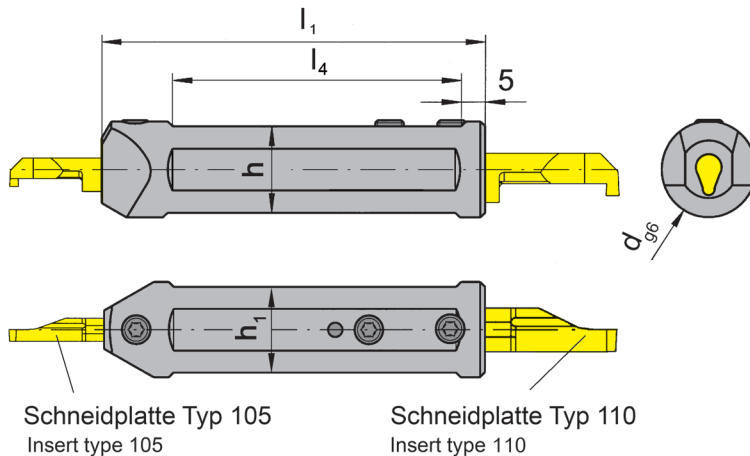


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | h | h ₁ | l ₄ |
|------------------------------|----|----------------|----|----------------|----------------|
| B105.0020.1.10 | 20 | 80 | 18 | 18 | 60 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.0020.1.10 | 6.075T15P | T15PQ |

GRUNDHALTER GRAF Typ

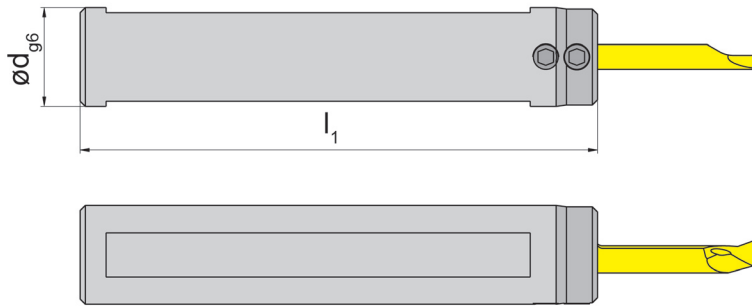
BASIC TOOLHOLDER GRAF Type

IR105

mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab Bore Ø from 0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type

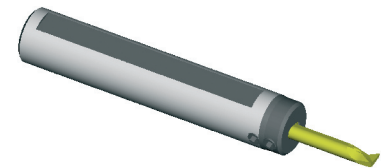


Abbildung = rechtsschneidend
Picture = right hand cutting version shown

| Bestellnummer Part number | d | l ₁ | Maschinentyp 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 | |
| IR105.16.30 | 16,00 | 30 | STAR |
| 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 | |
| IR105.22.70 | 22,00 | 70 | |
| IR105.18.310 | 18,00 | 310 | TORNOS |
| 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 | |

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

Coolant supply must be ordered separately!

Abmessungen in mm und Zoll

Dimensions in mm and inch

Weitere Abmessungen auf Anfrage

Further sizes upon request

Ersatzteile

Spare parts

| Grundhalter Graf Basic toolholder Graf | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---|------------------------|---|
| IR105.... | 6.075T15P | T15PQ |

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

For the locking torque of the screws please see the Technical Instructions.

EINBAUHALTER GRAF Typ

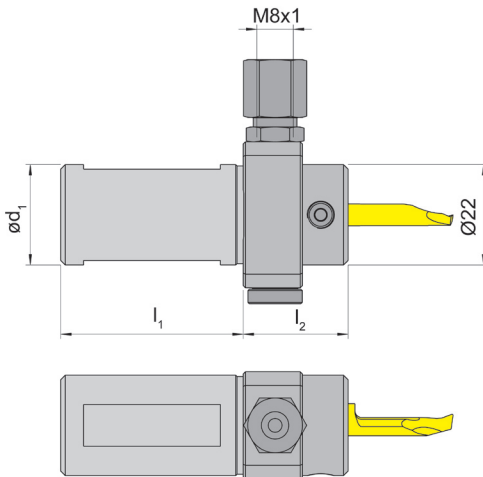
CARTRIDGE GRAF Type

IR105

mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab Bore Ø from 0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type

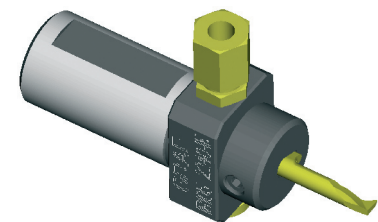


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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" |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm und Zoll
Dimensions in mm and inch

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

Coolant supply must be ordered separately!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Einbauhalter Graf Cartridge Graf | Kühlmittelanschluss Coolant supply | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|-------------------------------------|---------------------------------------|------------------------|---|
| IR105.... | 004.00.19 | 6.075T15P | T15PQ |

DOPPELSPANNZANGENHALTER Typ

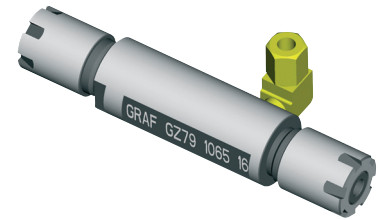
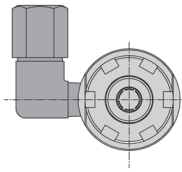
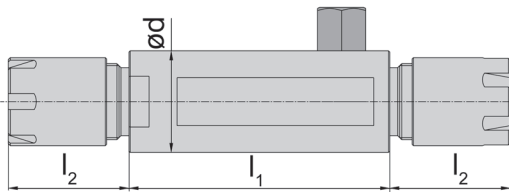
DOUBLE CHUCK HOLDERS Type

GZ79

mit innerer Kühlmittelzufuhr
with through coolant supply



für ER-Spannzangen mit Spannmutter ER16
for chuck holders ER with chucking nuts ER16



| Bestellnummer Part number | d | l ₁ | l ₂ | Bemerkung 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm und Zoll
Dimensions in mm and inch

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

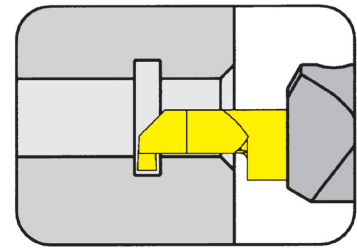
Coolant supply must be ordered separately!

KLEMMHALTER Typ

TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|---------------|-----------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite | Width of groove | 2,0 mm |

für Schneidplatte
for use with Insert

Typ 105
Type

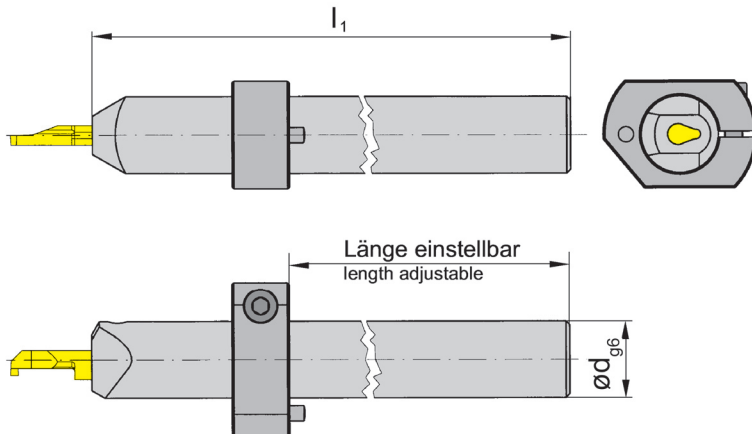


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ |
|------------------------------|----|----------------|
| B105.0020.2.01 | 20 | 150 |
| B105.0025.2.01 | 25 | 150 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

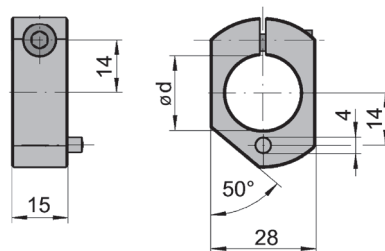
Toolholders can be used with right and left hand inserts.

Stelling ist nicht im Lieferumfang enthalten - bitte separat bestellen!

Adjusting ring is not included with toolholder - separate order required!

Stelling

Adjusting ring



| Bestellnummer "Stelling" Part number "Adjusting ring" | d | Maschinentyp Type of machine |
|--|----|---------------------------------|
| 020.0020.1665 | 20 | Tornos DECO |
| 020.0025.2234 | 25 | |

KLEMMHALTER Typ

TOOLHOLDER Type

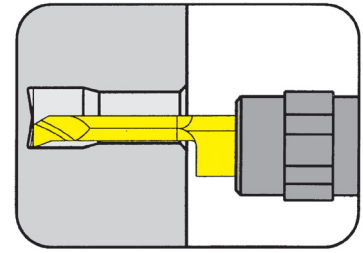
B105

mit innerer Kühlmittelzufuhr
with through coolant supply

Bohrungs-Ø ab

Bore Ø from

<3,0/>5,0 mm



für Schneidplatte
for use with Insert

Typ 105 ($\text{Ø} \leq 3,0$)

Type 105 ($\text{Ø} \geq 5,0$)

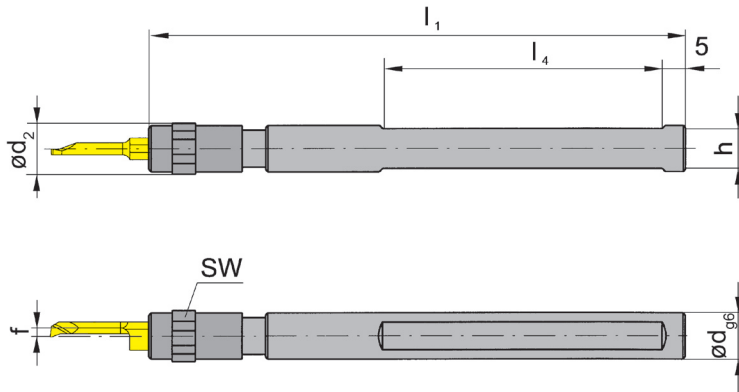


Abbildung = rechtsschneidend

Picture = right hand cutting version

| Bestellnummer Part number | d | l_1 | h | f | d_2 | l_4 | Bohrungsbereich Boring 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 | | | | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

* gilt nur für Standard-SP nach Katalog
* only valid for standard inserts

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Ersatzteile

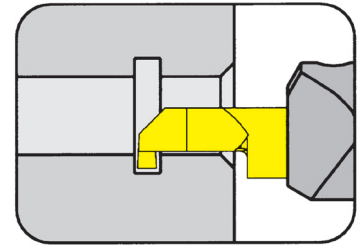
Spare parts

| Klemmhalter Toolholder | Spannmutter Chucking nut |
|---------------------------|-----------------------------|
| B105.0010.9.01 | 020.0010.1719 |
| B105.001...01 | 020.0016.1999 |

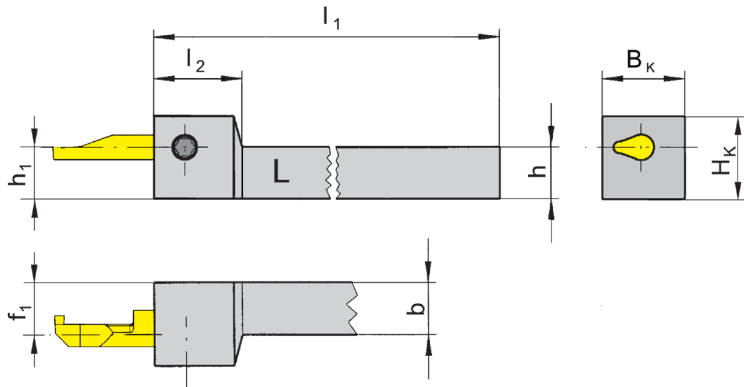
KLEMMHALTER Typ

TOOLHOLDER Type

H105



Bohrungs-Ø ab Bore Ø from 0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type

L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LH105.... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

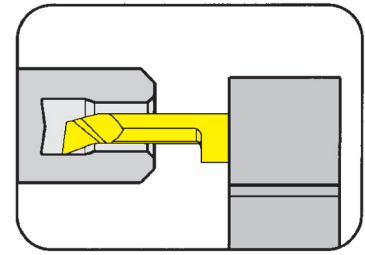
TOOLHOLDER Type

HC105

Bohrungs-Ø ab

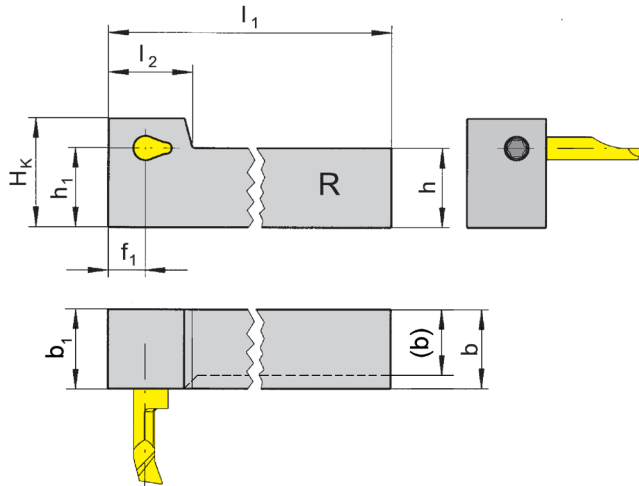
Bore Ø from

0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

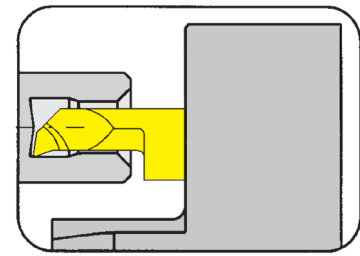
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LHC105.1... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

HC105

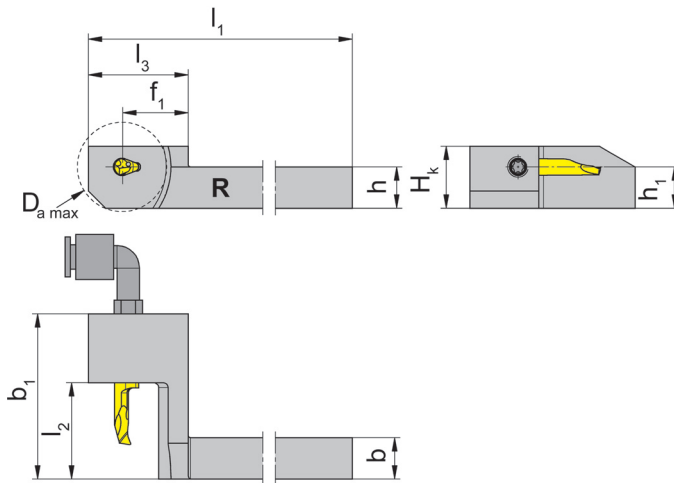


Bohrungs-Ø ab Bore Ø from 0,2 mm

Kühlmittelezufuhr über Winkelverschraubung
Coolant supply through cranked fitting

für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | l_1 | l_2 | h | h_1 | f_1 | l_3 | b | b_1 | $D_{a\ max}$ | H_k | Bemerkung 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 | |

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Hinweis:

* = ohne Kühlmittelzufuhr!

Note:

* = no through coolant supply!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench | SMC Winkelverschraubung 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 |

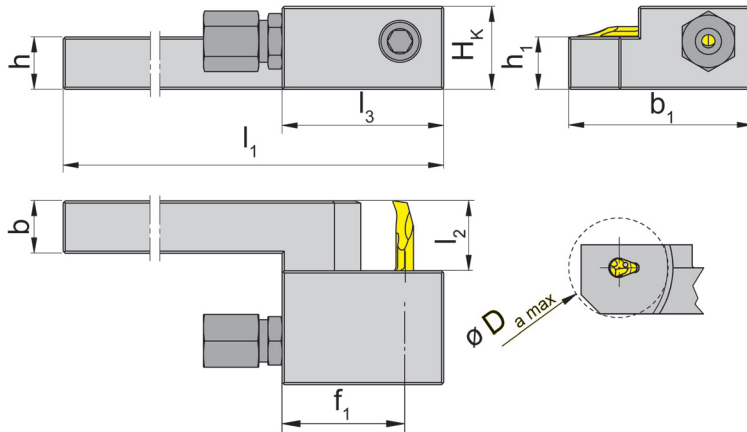
KLEMMHALTER Typ

TOOLHOLDER Type

962

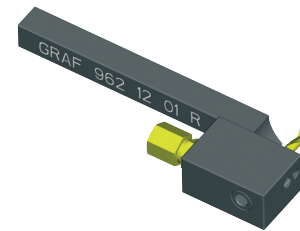
Bohrungs-Ø ab Bore Ø from 0,2 mm

Kühlmitteleinzufuhr über Verschraubung
Coolant through fitting



für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

Coolant supply must be ordered separately!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Kühlmittelanschluss Coolant supply | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|---------------------------------------|------------------------|---|
| 962.... | 004.00.14 (G1/8") | 6.075T15P | T15PQ |

KLEMMHALTER Typ

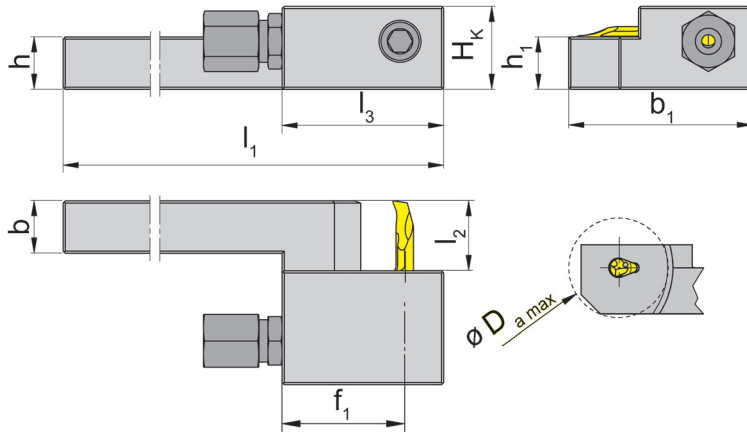
TOOLHOLDER Type

962



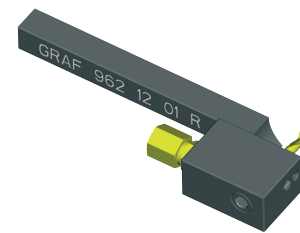
Bohrungs-Ø ab Bore Ø from 0,2 mm

Kühlmitteleinlass über Verschraubung
Coolant through fitting



für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

Coolant supply must be ordered separately!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Kühlmittelanschluss Coolant supply | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|---------------------------------------|------------------------|---|
| 962.... | 004.00.14 (G1/8") | 6.075T15P | T15PQ |

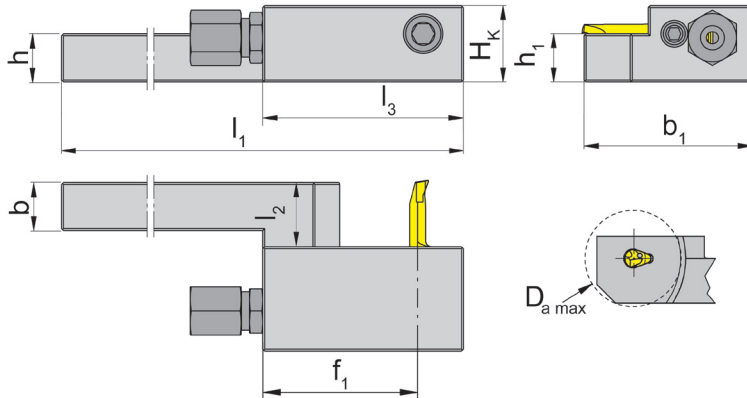
KLEMMHALTER Typ

TOOLHOLDER Type

963

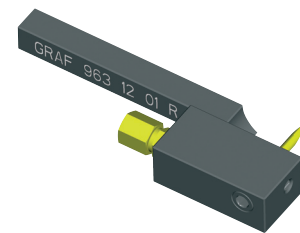
Bohrungs-Ø ab Bore Ø from 0,2 mm

Kühlmittelezufuhr über Verschraubung
Coolant through fitting



für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Hinweis:

Der Kühlmittelanschluss gehört nicht zum Lieferumfang. Bitte separat bestellen!

Note:

Coolant supply must be ordered separately!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

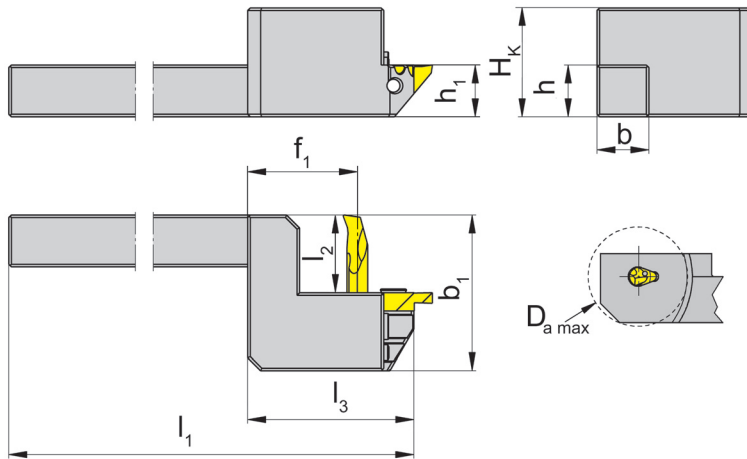
| Klemmhalter Toolholder | Kühlmittelanschluss Coolant supply | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|---------------------------------------|------------------------|---|
| 963.... | 004.00.14 (G1/8") | 6.075T15P | T15PQ |

KLEMMHALTER Typ TOOLHOLDER Type

AIH



Bohrungs-Ø ab Bore Ø from 0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type S274

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | l_1 | l_2 | h | h_1 | f_1 | l_3 | b | b_1 | $D_{a \max}$ | H_k | Bemerkung Remark |
|------------------------------|-------|-------|-----|-------|-------|-------|-----|-------|--------------|-------|---------------------|
| AIH.974.R/L1010.K04 | | | 10 | 10 | 23 | 35 | 10 | | 20 | 17 | |
| AIH.974.R/L1212.K04 | 130 | 15 | 12 | 12 | 23 | 35 | 12 | 30 | 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 | | | 10 | 10 | 21 | | 10 | | 20 | 17 | |
| AIH.R/L1212.K08 | 130 | 15 | 12 | 12 | 21 | 30 | 12 | 30 | 20 | 19 | ** |
| AIH.R/L1616.K08 | | | 16 | 16 | 24 | | 16 | | 23 | | |
| AIH.R/L2020.K08 | | | 20 | 20 | 27 | | 20 | | 23 | | |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Hinweis:

* Diese Halter sind bestückbar mit HORN-Platten Typ 105 und S274

** Diese Halter sind bestückbar mit HORN-Platten Typ 105 und Graf Wendeschneidplatten 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

Weitere Abmessungen auf Anfrage

Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

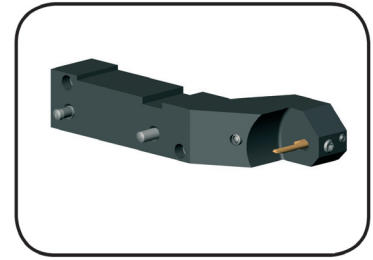
Spare parts

| Klemmhalter Toolholder | Schraube Screw | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|-------------------|------------------------|---|
| AIH.... | 030.3509.T15P | 6.075T15P | T15PQ |

GRUNDHALTER Typ

BASIC TOOLHOLDER Type

HC105

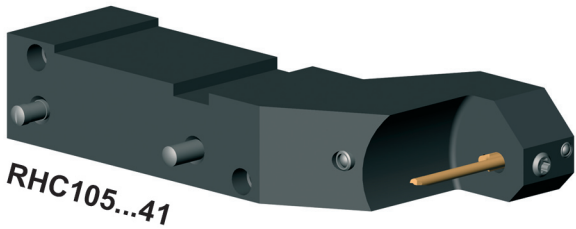
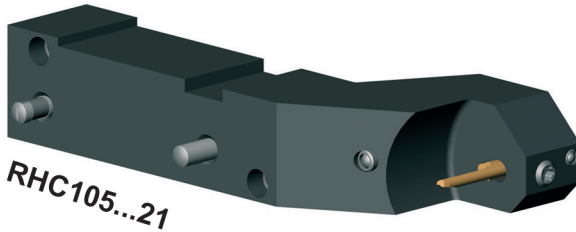


Bohrungs-Ø ab Bore Ø from 0,2 mm

Werkzeug für Tornos DECO2000
Tool for Tornos DECO2000

für Schneidplatte
for use with Insert

Typ 105
Type



| Bestellnummer Part number | Maschinentyp Type of machine | Schneidplatte Insert |
|------------------------------|---------------------------------|--|
| RHC105.0710.21 | DECO 7/10 | 105...21 $\frac{1}{2}$ bis/up to 15 mm |
| RHC105.0710.41 | | 105...41 $\frac{1}{2}$ bis/up to 25 mm |

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

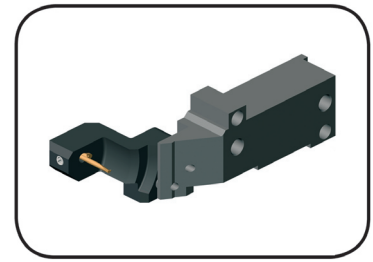
Spare parts

| Grundhalter Basic toolholder | Zylinderstift Pin | Spann- schraube Screw | Zylinder- schraube Cylindrical Screw | TORX PLUS®- Schlüssel TORX PLUS® Wrench | SMC Winkel- verschraubung Screwed angle fitting | Zylinderstift Pin |
|---------------------------------|----------------------|-----------------------------|---|--|--|----------------------|
| RHC105.0710.... | 020.0518.1610 | 6.075T15P | DIN912-M5x45 | T15PQ | KQ2L06-M5 | DIN6325-5H6x20 |

GRUNDHALTER Typ

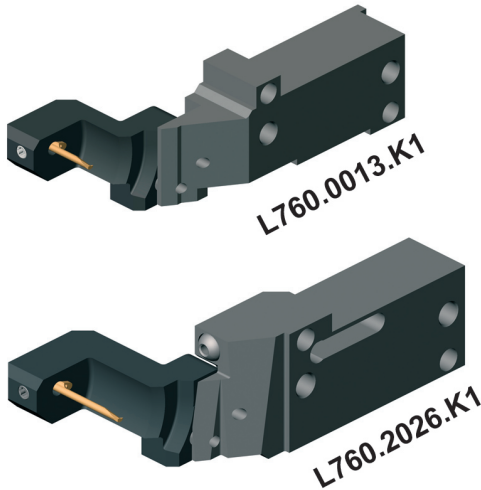
BASIC TOOLHOLDER Type

L760



| | | |
|---------------|-------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
|---------------|-------------|--------|

Werkzeug für Tornos DECO2000
Tool for Tornos DECO2000



für Kassette
for use with Cassette

Typ RKC760
Type

| Bestellnummer Part number | Maschinentyp Type of machine | Kassette Cassette | Schneidplatte Insert |
|------------------------------|---------------------------------|----------------------|--|
| L760.0013.K1 | DECO13 | RKC760.0105.21 | 105...21 l ₂ bis/up to 15 mm |
| L760.2026.K1 | DECO20/26 | RKC760.0105.41 | 105...41 l ₂ bis/up to 25 mm |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Ersatzteile

Spare parts

| Grundhalter Basic toolholder | Zylinderschraube Cylindrical Screw | Inbus-Schlüssel Wrench | Kugelspritzdüse Coolant spray nozzle |
|---------------------------------|--|--|---|
| L760.0013.K1 L760.2026.K1 | DIN7984-M16x35 DIN7984-M16x35 | SW5,0DIN911 SW5,0DIN911 | 05.032.902 |

GRUNDHALTER Typ

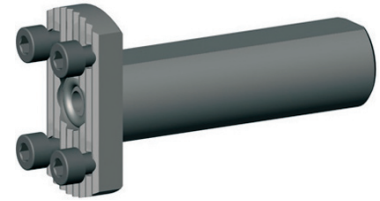
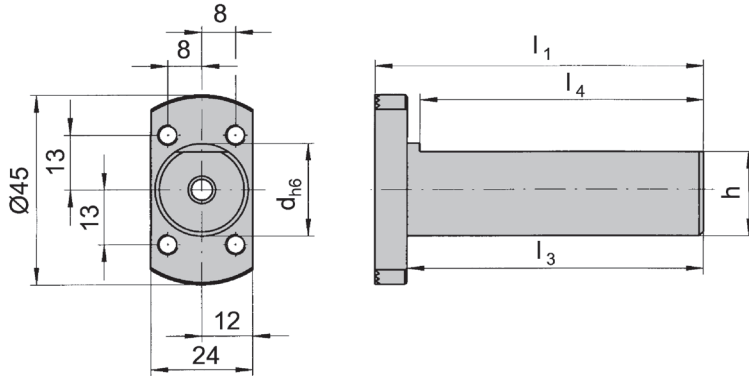
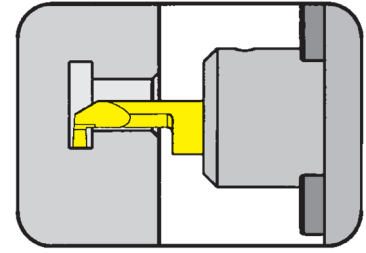
BASIC TOOLHOLDER Type

BGT

ohne Einbauhalter
without cartridge

Verstellbare Rundschäfte für Halter BKT105.2445.01/02
Adjustable round shanks for toolholder BKT105.2445.01/02

mit innerer Kühlmittelzufuhr
with through coolant supply



| Bestellnummer Part number | d | l ₁ | h | l ₃ | l ₄ | Hersteller Manufacturer |
|--|----|----------------|----|----------------|----------------|----------------------------|
| 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Hinweis:

BGT001.0022.30 ohne innere Kühlmittelzufuhr

Note:

BGT001.0022.30 without through coolant supply

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

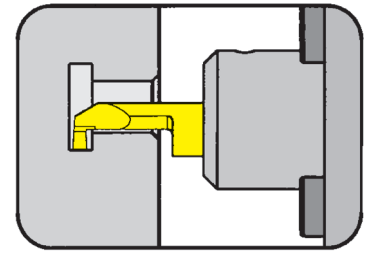
| Grundhalter Basic toolholder | Befestigungsschraube Fixing screw | Inbus-Schlüssel Wrench | O-Ring O-ring |
|---------------------------------|--------------------------------------|---------------------------|--------------------|
| BGT001.0... | DIN912-M5x10 | SW4,0DIN911 | DIN3770-7x3 |

GRUNDHALTER Typ

BASIC TOOLHOLDER Type

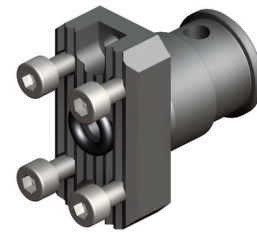
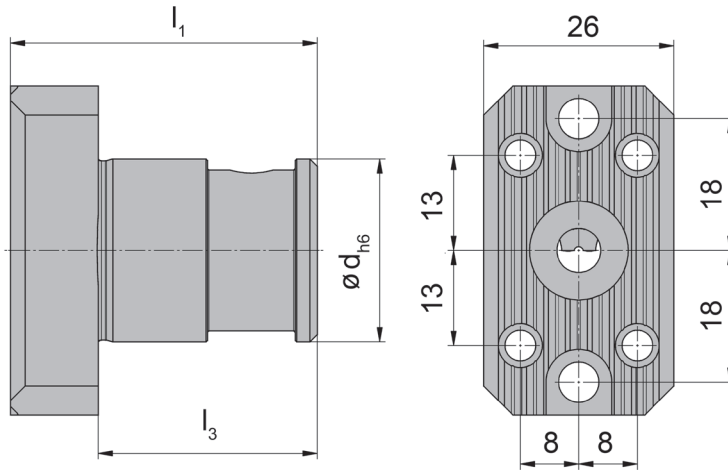
BGT

ohne Einbauhalter
without cartridge



Verstellbare Rundschäfte für Halter BKT105.2445.01/02
Adjustable round shanks for toolholder BKT105.2445.01/02

mit innerer Kühlmittelzufuhr
with through coolant supply



| Bestellnummer Part number | d | l ₁ | l ₃ | Hersteller Manufacturer |
|------------------------------|----|----------------|----------------|----------------------------|
| BGT001.C025.30IK | 25 | 42 | 30 | Citizen L20X |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

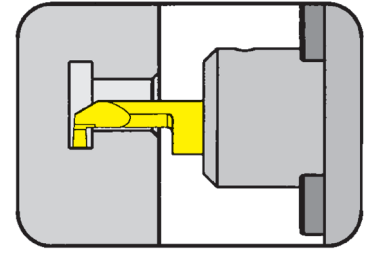
| Grundhalter Basic toolholder | Zylinderschraube Cylindrical Screw | Inbus-Schlüssel Wrench | O-Ring O-ring |
|---------------------------------|---------------------------------------|---------------------------|--------------------|
| BGT001.C025.30IK | DIN912-M5x14 | SW4,0DIN911 | DIN3770-7x3 |

EINSTELLBARE HALTER Typ BKT

ADJUSTABLE HOLDER Type

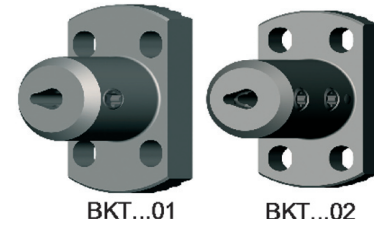
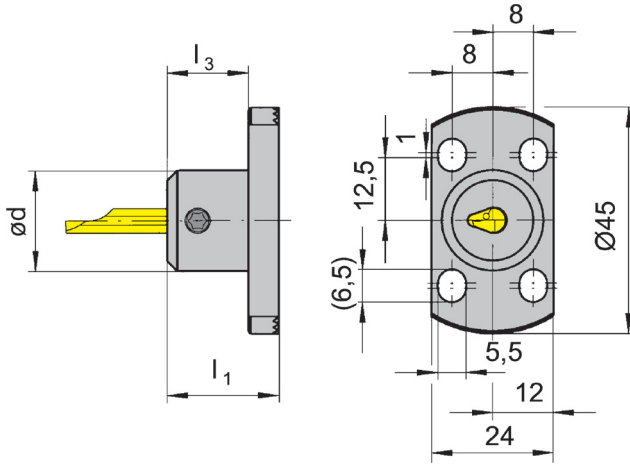
| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

mit innerer Kühlmittelzufuhr
with through coolant supply



für Schneidplatte
for use with Insert

Typ 105
Type



| Bestellnummer Part number | d | l ₁ | l ₃ |
|------------------------------|----|----------------|----------------|
| BKT105.2445.01 | 20 | 22 | 16 |
| BKT105.2445.02 | | 32 | 26 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

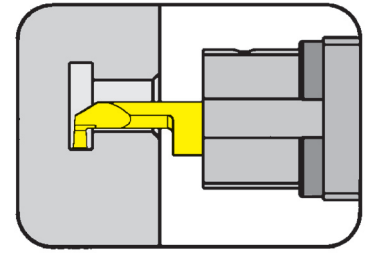
| | | |
|--|------------------------|---|
| Einstellbare Halter Adjustable holder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| BKT105.2445.0... | 6.075T15P | T15PQ |

GRUNDHALTER Typ

BASIC TOOLHOLDER Type

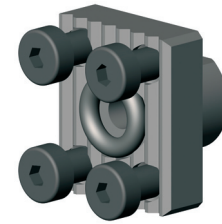
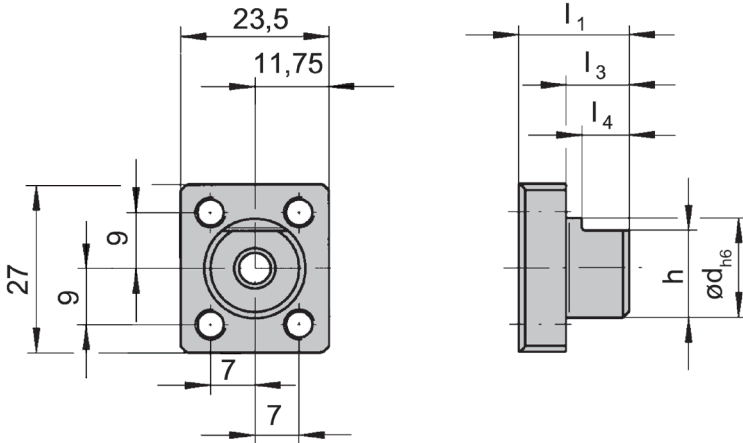
BGT

ohne Einbauhalter
without cartridge



Verstellbare Rundschäfte für Halter BKT105.2327.01
Adjustable round shanks for toolholder BKT105.2327.01

mit innerer Kühlmittelzufuhr
with through coolant supply



| Bestellnummer Part number | d | l ₁ | h | l ₃ | l ₄ | Hersteller Manufacturer |
|------------------------------|----|----------------|----|----------------|----------------|----------------------------|
| BGT001.1627.10 | 16 | 17,5 | 14 | 10 | 7,5 | Star |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Grundhalter Basic toolholder | Befestigungsschraube Fixing screw | Inbus-Schlüssel Wrench | O-Ring O-ring |
|---------------------------------|--------------------------------------|---------------------------|--------------------|
| BGT001.1627.10 | DIN912-M5x10 | SW4,0DIN911 | DIN3770-7x3 |

GRUNDHALTER Typ

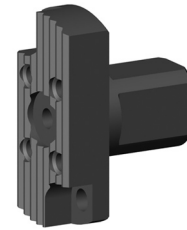
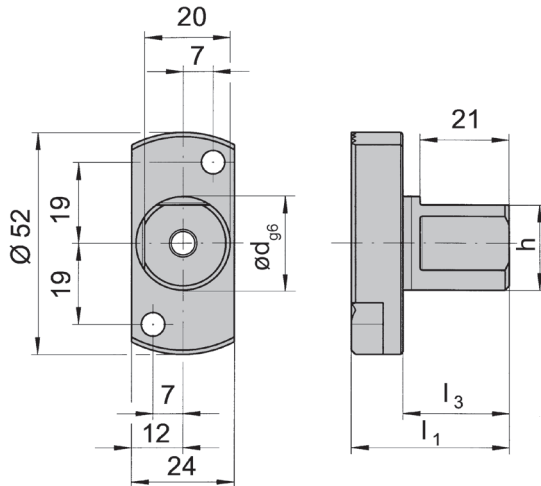
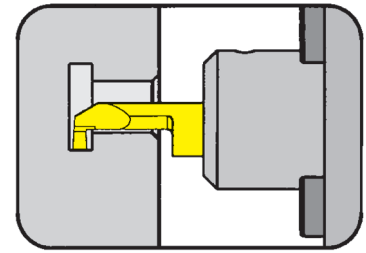
BASIC TOOLHOLDER Type

BGT

ohne Einbauhalter
without cartridge

Verstellbare Rundschäfte für Halter BKT105.2327.01
Adjustable round shanks for toolholder BKT105.2327.01

mit innerer Kühlmittelzufuhr
with through coolant supply



| Bestellnummer Part number | d | l_1 | h | l_3 |
|------------------------------|----|-------|----|-------|
| BGT001.0R22.25 | 22 | 37 | 20 | 25 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

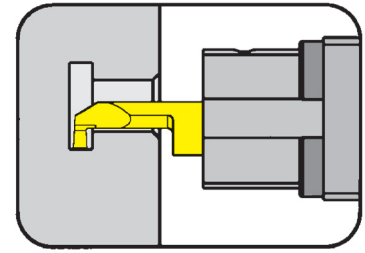
| Grundhalter Basic toolholder | Befestigungsschraube Fixing screw | Inbus-Schlüssel Wrench |
|---------------------------------|--------------------------------------|---------------------------|
| BGT001.0R22.25 | DIN912-M5x10 | SW4,0DIN911 |

EINSTELLBARE HALTER Typ **BKT**

ADJUSTABLE HOLDER Type

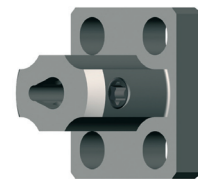
| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

mit innerer Kühlmittelzufuhr
with through coolant supply

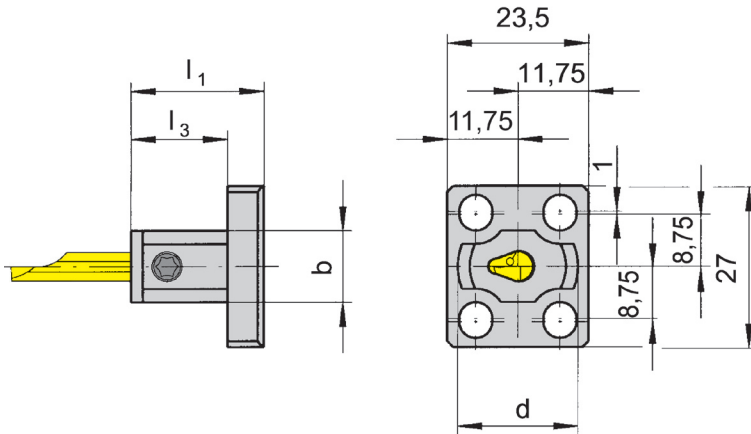


für Schneidplatte
for use with Insert

Typ 105
Type



BKT105.2327.01



| Bestellnummer Part number | d | l_1 | l_3 | b |
|------------------------------|----|-------|-------|----|
| BKT105.2327.01 | 20 | 22 | 16 | 12 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile Spare parts

| | | |
|--|------------------------|---|
| Einstellbare Halter Adjustable holder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| BKT105.2327.01 | 6.075T15P | T15PQ |

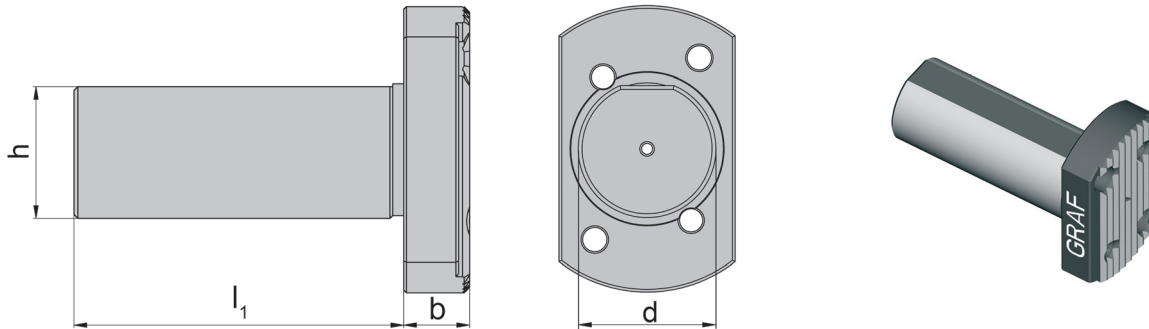
GRUNDHALTER GRAF Typ

BASIC TOOLHOLDER GRAF Type

G

ohne Einbauhalter
without cartridge

für einstellbare Halter Graf Typ N und HORN BKT105.2445.01/02
for adjustable holder Graf type N and HORN BKT105.2445.01/02



| Bestellnummer Part number | d | l ₁ | h | b | Hersteller Manufacturer |
|------------------------------|-------|----------------|----|----|--|
| 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 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm und Zoll
Dimensions in mm and inch

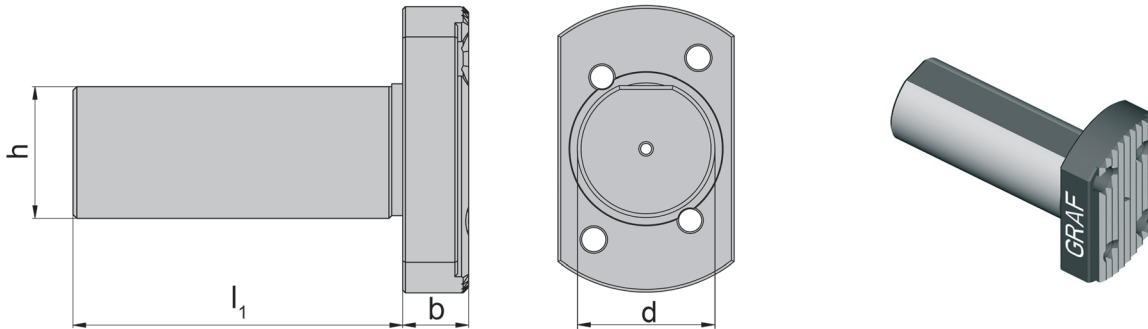
GRUNDHALTER GRAF Typ

BASIC TOOLHOLDER GRAF Type

G

ohne Einbauhalter
without cartridge

für einstellbare Halter Graf Typ N und HORN BKT105.2445.01/02
for adjustable holder Graf type N and HORN BKT105.2445.01/02



| Bestellnummer Part number | d | l ₁ | h | b | Hersteller Manufacturer |
|------------------------------|------|----------------|----|----|---|
| 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 | | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm und Zoll
Dimensions in mm and inch

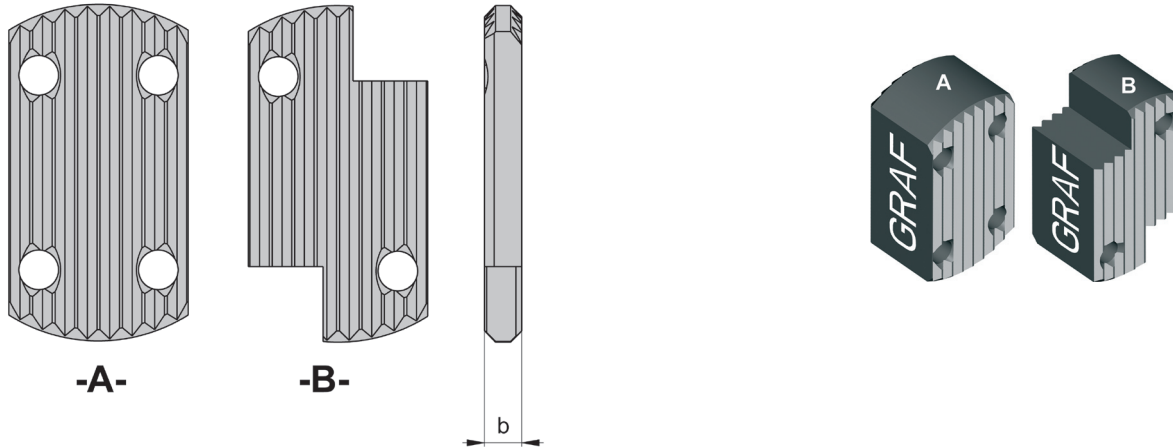
ZWISCHENSTÜCK GRAF Typ

ADAPTOR GRAF Type

Z

ohne Einbauhalter
without cartridge

für einstellbare Halter Graf Typ N und HORN BKT105.2445.01/02
for adjustable holder Graf type N and HORN BKT105.2445.01/02



| Bestellnummer Part number | b | Form 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 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

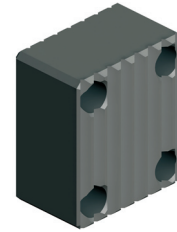
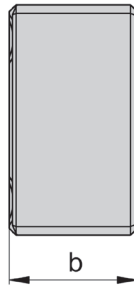
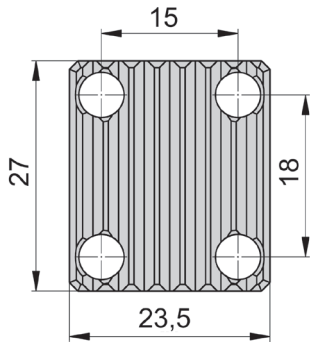
ZWISCHENSTÜCK GRAF Typ

ADAPTOR GRAF Type

Z

ohne Einbauhalter
without cartridge

für einstellbare Halter HORN BKT105.2327.01
for adjustable holder HORN BKT.105.2327.01



| Bestellnummer Part number | b |
|------------------------------|----|
| Z10SW7 | 10 |
| Z15SW7 | 15 |
| Z20SW7 | 20 |
| Z25SW7 | 25 |
| Z30SW7 | 30 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

ZWISCHENPLATTE GRAF Typ

PLATE BETWEEN GRAF type

N

ohne Einbauhalter
without cartridge



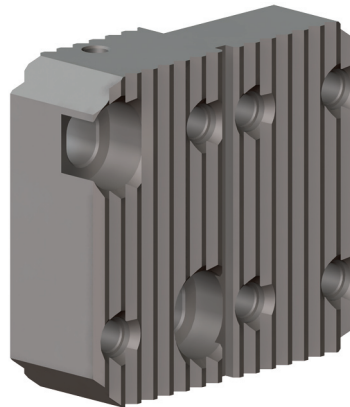
für einstellbare Halter Graf Typ N und HORN BKT105.2445.01/02
for adjustable holder Graf type N and HORN BKT105.2445.01/02

für Rückseitenbearbeitung
for back working

Bestellnummer N11

Part number

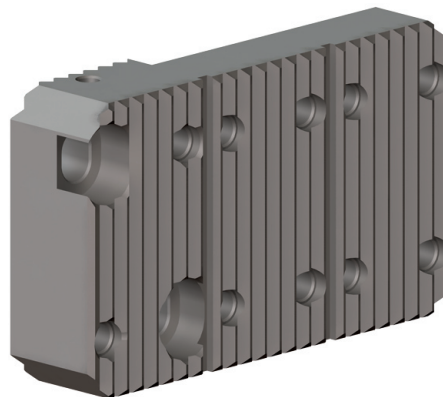
Für wahlweise 2 Einsätze
For alternatively 2 cartridges



Bestellnummer N12

Part number

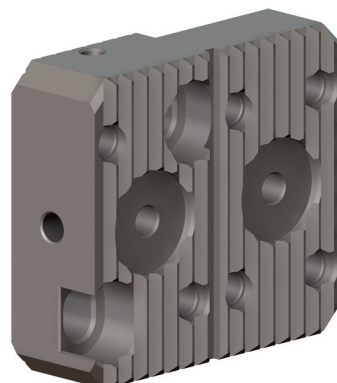
Für wahlweise 3 Einsätze
For alternatively 3 cartridges



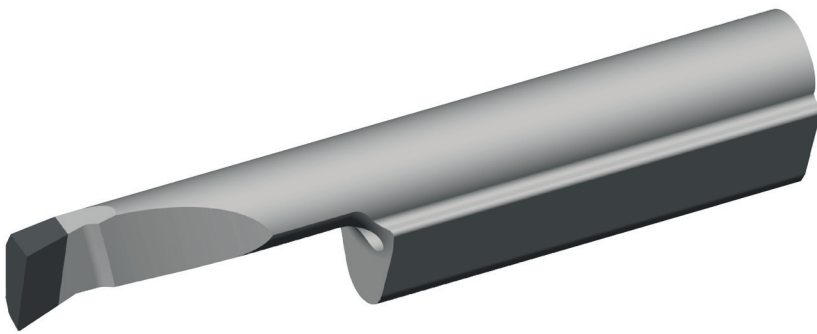
Bestellnummer N93IK

Part number

mit innerer Kühlmittelzufuhr
with through coolant supply



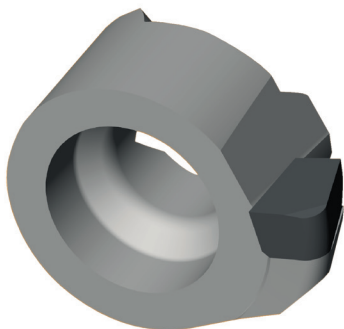
PKD- oder CBN-bestückte Schneidplatten auf Anfrage lieferbar.
PCD- or PCBN-tipped inserts upon request.



Supermini®

Ausdrehen gehärteter Teile
ab Bohrungs- $\varnothing > 3,0$ mm

Turning of hardened parts
from bore $\varnothing > 3,0$ mm



Mini

PKD-bestückte Ausdrehplatte
PCD-tipped insert

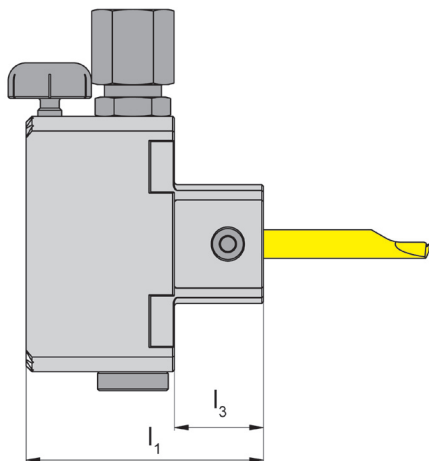
EINSTELLBARE HALTER Typ

N

ADJUSTABLE HOLDER Type

| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

mit innerer Kühlmittelzufuhr
with through coolant supply



für Schneidplatte
for use with Insert

Typ 105
Type

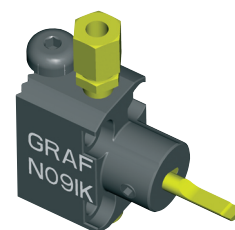


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | l_1 | l_3 |
|------------------------------|-------|-------|
| N09IK | 40 | 15 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Kühlmittelrohr ist nicht im Lieferumfang enthalten - bitte separat bestellen!
Coolant tube is not included - separate order required!

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Spannschraube Screw | Höhenverstellungsschraube Height adjustment screw | Kühlmittelanschluss Coolant supply |
|--|------------------------|--|---------------------------------------|
| N09IK | 6.075T15P | 002.00.69 | 004.00.19 |

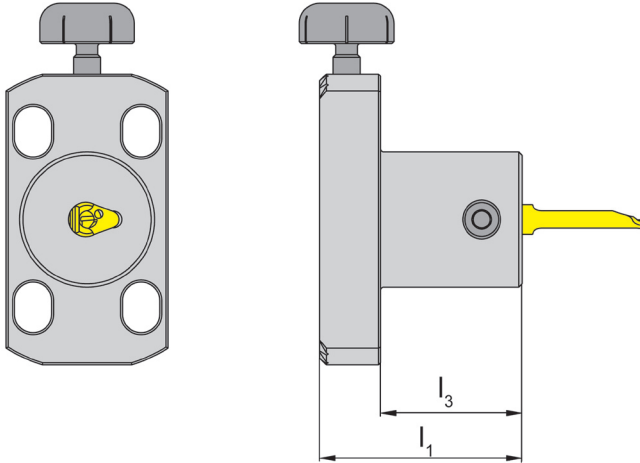
EINSTELLBARE HALTER Typ N

ADJUSTABLE HOLDER Type



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

ohne innere Kühlmittelzufuhr
no through coolant supply



für Schneidplatte
for use with Insert

Typ 105
Type

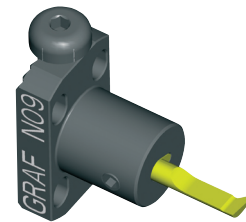


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | l_1 | l_3 |
|------------------------------|-------|-------|
| N09 | 30 | 20 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Spannschraube Screw | Höhenverstellungsschraube Height adjustment screw |
|--|------------------------|--|
| N09 | 6.075T15P | 002.00.69 |

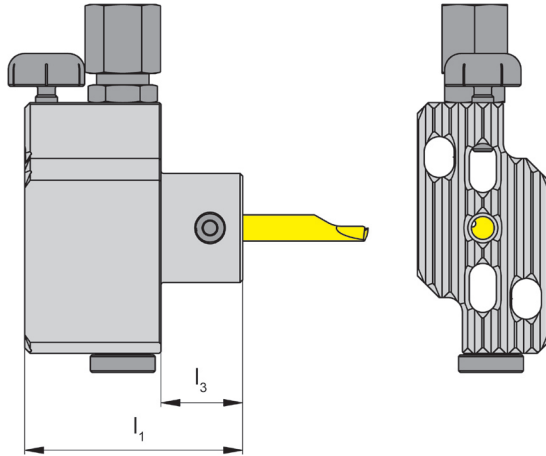
EINSTELLBARE HALTER Typ

N

ADJUSTABLE HOLDER Type

| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

mit innerer Kühlmittelzufuhr
with through coolant supply



für Schneidplatte
for use with Insert

Typ 105
Type

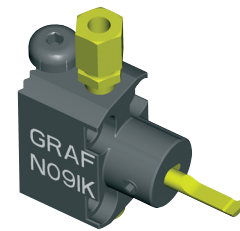


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | l_1 | l_3 |
|------------------------------|-------|-------|
| N73IK | 40 | 15 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Spannschraube Screw | Höhenverstellungsschraube Height adjustment screw | Kühlmittelanschluss Coolant supply |
|--|------------------------|--|---------------------------------------|
| N73IK | 6.075T15P | 002.00.69 | 004.00.19 |

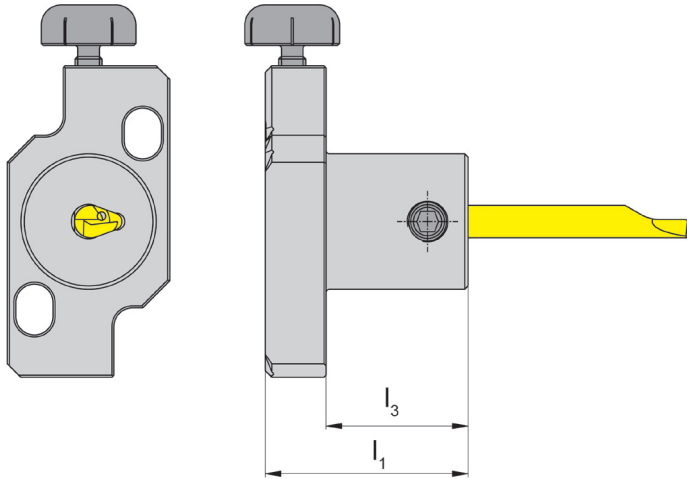
EINSTELLBARE HALTER Typ N

ADJUSTABLE HOLDER Type



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

ohne innere Kühlmittelzufuhr
no through coolant supply



für Schneidplatte
for use with Insert

Typ 105
Type

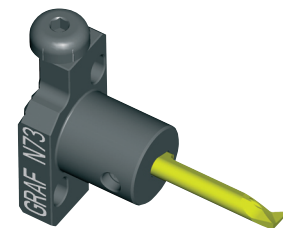


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | l_1 | l_3 |
|------------------------------|-------|-------|
| N73 | 30 | 20 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

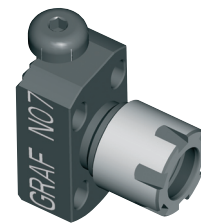
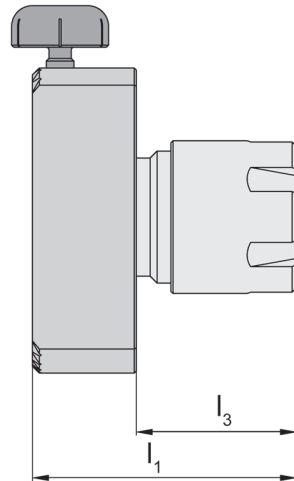
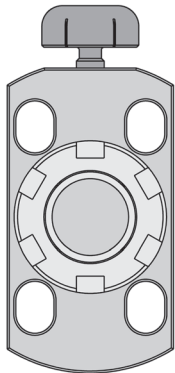
| Einstellbare Halter Adjustable holder | Spannschraube Screw | Höhenverstellungsschraube Height adjustment screw |
|--|------------------------|--|
| N73 | 6.075T15P | 002.00.69 |

EINSTELLBARE HALTER Typ

ADJUSTABLE HOLDER Type

N

mit Spannmutter ER16 System Graf
with chucking nut ER16 system Graf



| Bestellnummer Part number | l_1 | l_3 | Bemerkung Remark |
|------------------------------|-------|-------|---------------------|
| N07 | 37 | 18 | ER16 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Spannmutter Chucking nut | Höhenverstellungsschraube Height adjustment screw |
|--|-----------------------------|--|
| N07 | 62.000.16 | 002.00.69 |

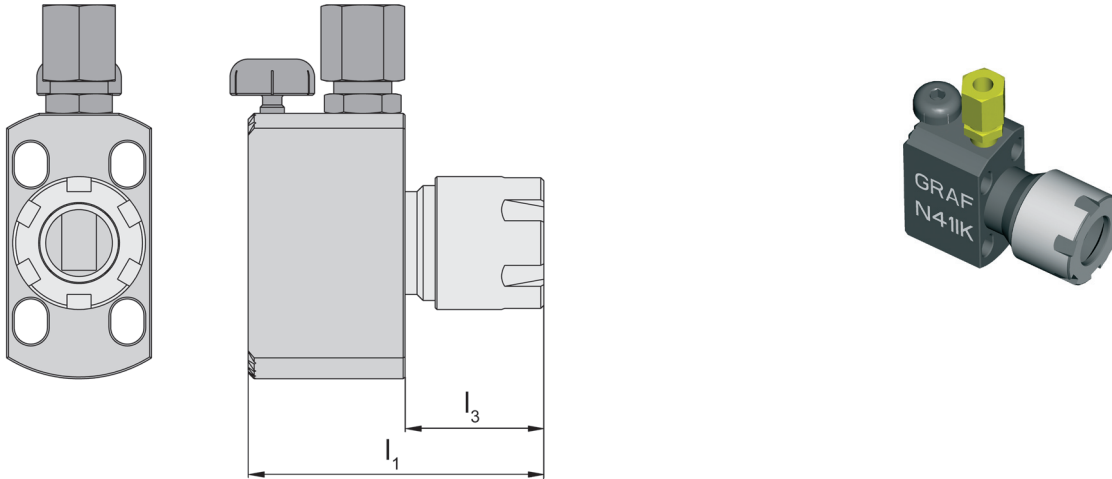
EINSTELLBARE HALTER Typ

ADJUSTABLE HOLDER Type

N

mit Spannmutter ER16 / ER20 System Graf
with chucking nut ER16 / E20 system Graf

mit innerer Kühlmittelzufuhr
with through coolant supply



| Bestellnummer Part number | l_1 | l_3 | Bemerkung Remark |
|------------------------------|-------|-------|---------------------|
| N07IK | 54 | 18 | ER16 |
| N41IK | 64 | 26 | ER20 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Ersatzteile

Spare parts

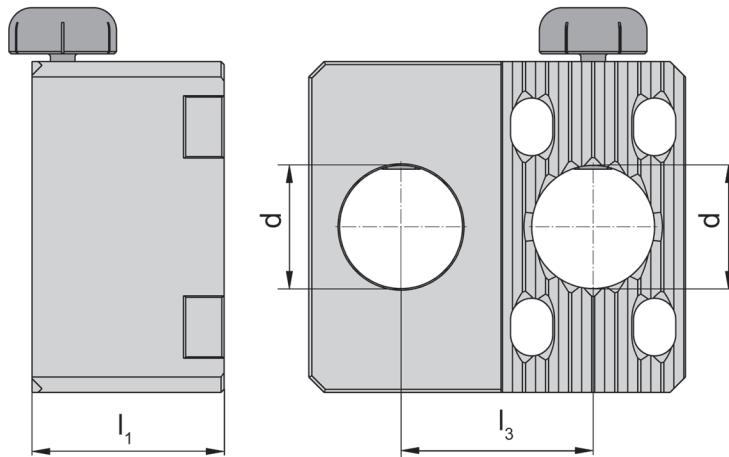
| Einstellbare Halter Adjustable holder | Spannmutter Chucking nut | Höhenverstellungsschraube Height adjustment screw | Kühlmittelanschluss Coolant supply | Dichtscheibensatz D3 Set of seals D3 |
|--|-----------------------------|--|---------------------------------------|---|
| N07IK | 62.000.16 | 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 |

EINSTELLBARE HALTER Typ

ADJUSTABLE HOLDER Type

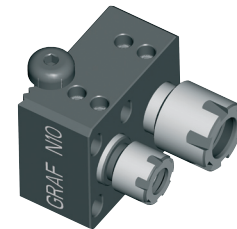
N

für Spannzangenaufnahmen ER11/ER16 System Graf
for collet adaptors ER11/ER16 System Graf



für Grundhalter
for use with Basic toolholder

Typ Horn BGT/
Type Graf G



| Bestellnummer Part number | l_1 | l_3 | Bemerkung Remark |
|------------------------------|-------|-------|---------------------|
| N10 | 25 | 25 | ER11 + ER16 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Die Spannzangenaufnahmen sind nicht im Lieferumfang enthalten - bitte separat bestellen!
The collet adaptors are not included - separate order required!

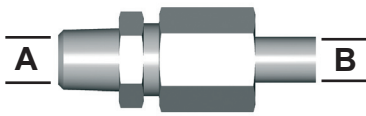
Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Gewindestift Threaded pin | Höhenverstellungsschraube Height adjustment screw | Spannzangen-Halter Collet holder |
|--|------------------------------|--|--|
| N10 | 002.00.11 | 002.00.69 | GZ66.1620.11ER11/GZ66.1626.16ER16 |

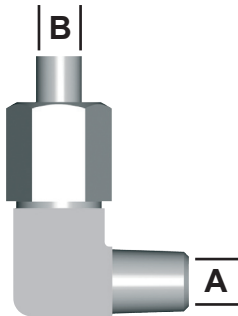


Kühlmittelanschluss Standard für Rohr Ø 6 mm
Standard connection for coolant supply for pipe Ø 6 mm



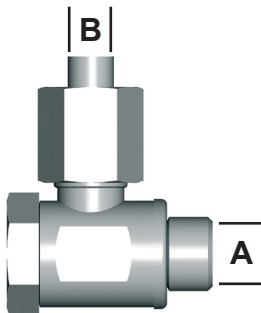
Kühlmittelanschluss
gerade
Connection for coolant supply
straight screwed

| A | B | Bestellnummer Part number |
|--------|--------|------------------------------|
| M8 x 1 | Ø 6 mm | 004.00.19 |
| G1/8" | Ø 6 mm | 004.00.14 |



Kühlmittelanschluss
winkelig fest
Connection for coolant supply
angled and fix

| A | B | Bestellnummer Part number |
|--------|--------|------------------------------|
| M8 x 1 | Ø 6 mm | 004.00.22 |
| G1/8" | Ø 6 mm | 004.00.33 |



Schwenkverschraubung
Swivelling screw-fitting

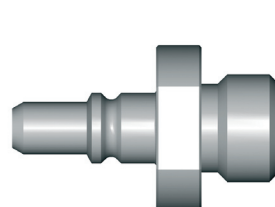
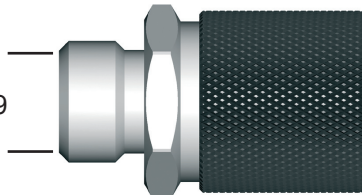
| A | B | Bestellnummer Part number |
|--------|--------|------------------------------|
| M8 x 1 | Ø 6 mm | 004.00.16 |

Kühlmittelanschluss Schnellkupplung

Clip connection for coolant supply

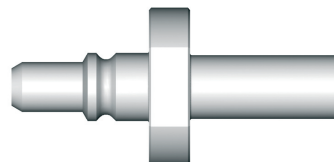
Schnellkupplung
Quick connector

M10 x 1 - 004.00.49



Stecker
Plug

M8 x 1 - 004.00.56
G1/8" - 004.00.57



Stecker
Plug

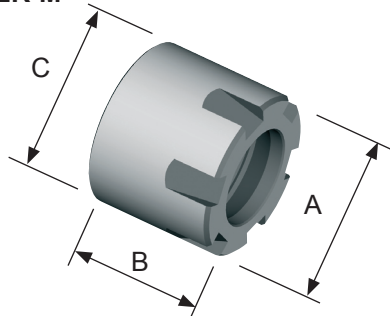
Ø 6 mm - 004.00.59

Spannmutter

Chucking nut

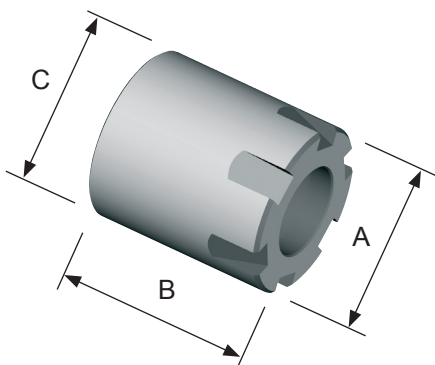


ER-M



| 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 abdichtbar sealed



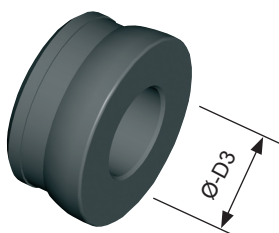
| ER-MA | A | B | C |
|-----------------|----|------|-------|
| 62 600 16-ER 16 | 22 | 24,5 | M19x1 |
| 62 600 20-ER 20 | 28 | 26,5 | M24x1 |
| 62 600 25-ER 25 | 35 | 27,5 | M30x1 |

Abmessungen in mm
Dimensions in mm

Dichtscheiben

für abdichtbare Spannmutter ER-MA...

Sealing rings
for chucking nuts ER-MA...



kompletter Satz:
completed set:

| Bestellnummer 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 |

Abmessungen in mm
Dimensions in mm

Die Dichtscheiben können auch einzeln bestellt werden.

Beispiel:

The sealing rings can be ordered separately.

Example:

| Bestellnummer Part number | Durchmesserbereich Diameter range | möglich von-bis 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 |

Abmessungen in mm
Dimensions in mm

HÖHENEINSTELL-VORRICHTUNG

DEVICE FOR HEIGHT ADJUSTING



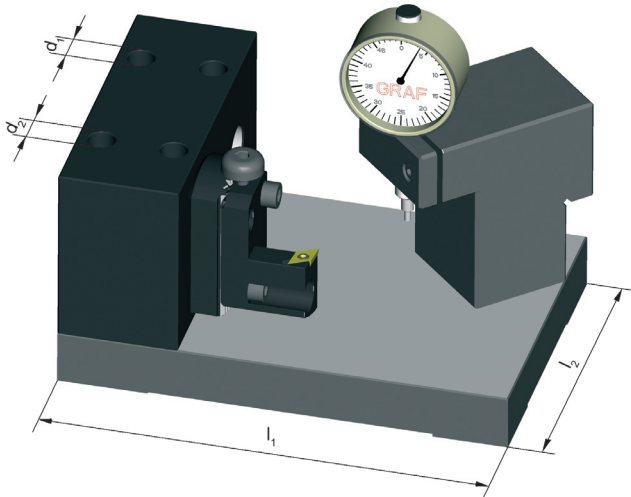
A

HÖHENEINSTELLVORRICHTUNG Typ **HVR40**

DEVICE FOR HEIGHT ADJUSTING Type



für Rückseitenbearbeitungs-Drehhalter HVR40
for back working holder HVR40



| Bestellnummer Part number | l_1 | l_2 | d_1 | d_2 | System 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

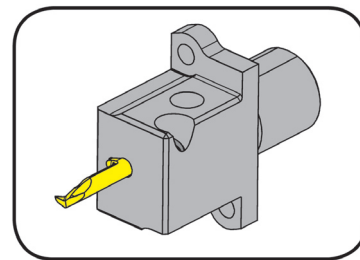
Abmessungen in mm und Zoll
Dimensions in mm and inch

KLEMMHALTER Typ

TOOLHOLDER Type

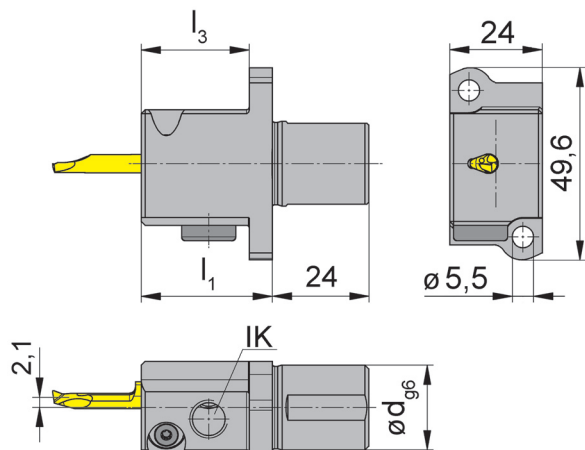
B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

Kühlmittelzufuhr G1/8" Lochbild 13,7 x 37,6 mm
Through coolant supply G1/8" Hole pattern 13,7 x 37,6 mm



für Schneidplatte
for use with Insert

Typ 105
Type

für Star
Langdrehautomaten
for Swiss type machines Star

L = Linksausführung
L = left hand version

| Bestellnummer Part number | d | l ₁ | l ₃ |
|------------------------------|----|----------------|----------------|
| LB105.A022.26.31 | 22 | 34 | 28 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Star Langdrehautomaten:

ECAS-12/20, SB16D/E, SR-20, SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RIII

Swiss Type Machines Star:

ECAS-12/20, SB16D/E, SR-20, SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RII

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Inbus-Schlüssel Wrench | Spannkeil Tensioning wedge | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench | Zylinder-schraube Cylindrical Screw |
|---------------------------|---------------------------|-------------------------------|------------------------|---|--|
| LB105.A022... | SW3,0DIN911 | 070.0010.0118 | 030.0422.T10P | T10PL | DIN7984-M5x12 |

EINSTECHEN und AUDREHEN

GROOVING and BORING



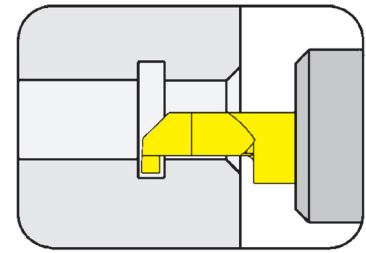
A

KLEMMHALTER Typ

TOOLHOLDER Type

VDI

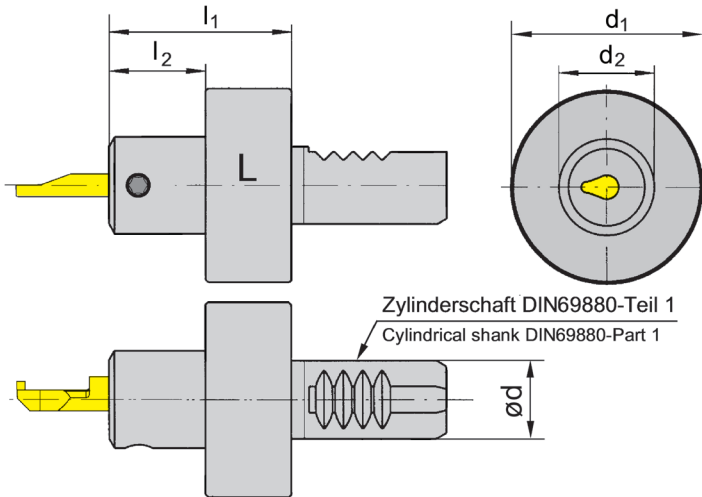
mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

für Schneidplatte
for use with Insert

Typ 105
Type



L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| VDI... | 6.075T15P | T15PQ |

EINSTECHEN (innen)

GROOVING (internal)

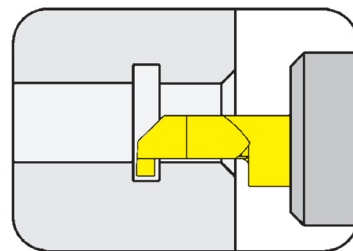


KLEMMHALTER Typ

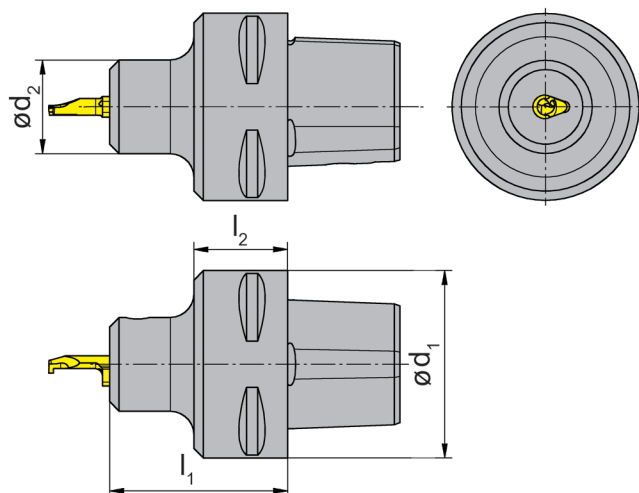
TOOLHOLDER Type

B105C

mit innerer Kühlmittelzufuhr
with through coolant supply



HORN-Polygonschaft nach ISO 26623
HORN Polygon shank according ISO 26623



für Schneidplatte
for use with Insert

Typ 105
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LB105.00C... | 6.075T15P | T15PQ |

EINSTECHEN (innen)

GROOVING (internal)

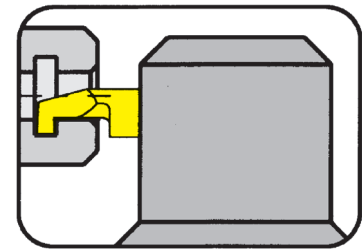


A

KLEMMHALTER Typ
TOOLHOLDER Type

B105C

mit innerer Kühlmittelzufuhr
with through coolant supply

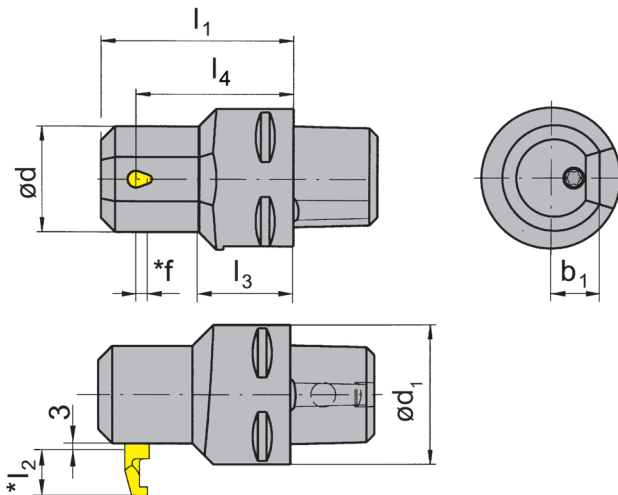


HORN-Polygonschaft nach ISO 26623
HORN Polygon shank according ISO 26623

für INDEX Mehrspindler
for INDEX Multi spindle machines

für Schneidplatte
for use with Insert

Typ 105
Type



| Bestellnummer Part number | d | l ₁ | l ₃ | b ₁ | l ₄ | d ₁ | Maschinentyp Machine type |
|------------------------------|----|----------------|----------------|----------------|----------------|----------------|------------------------------|
| 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 | | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

f, l₂ siehe SP Typ 105
f, l₂ see inserts type 105

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| RB105.00C... | 6.075T15P | T15PQ |

EINSTECHEN (innen)

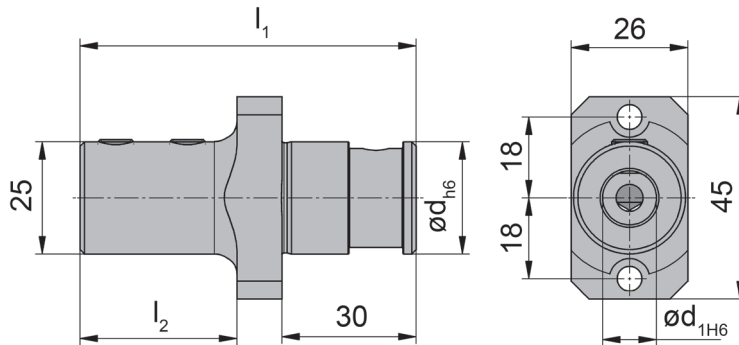
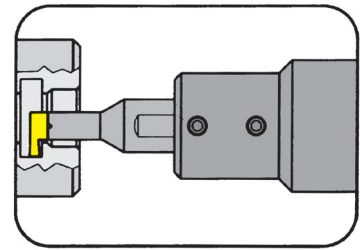
GROOVING (internal)



BOHRSTANGEN-AUFNAHME Typ 001

ADAPTOR Type

für zylindrische Schäfte mit durchgehender Spannfläche
for cylindrical shanks with standard clamping flat



| Bestellnummer Part number | d | l_1 | l_2 | d_1 | Hersteller Manufacturer |
|------------------------------|----|-------|-------|-------|----------------------------|
| 001.C025.12.30IK | 25 | 75 | 35 | 12 | Citizen L20X |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

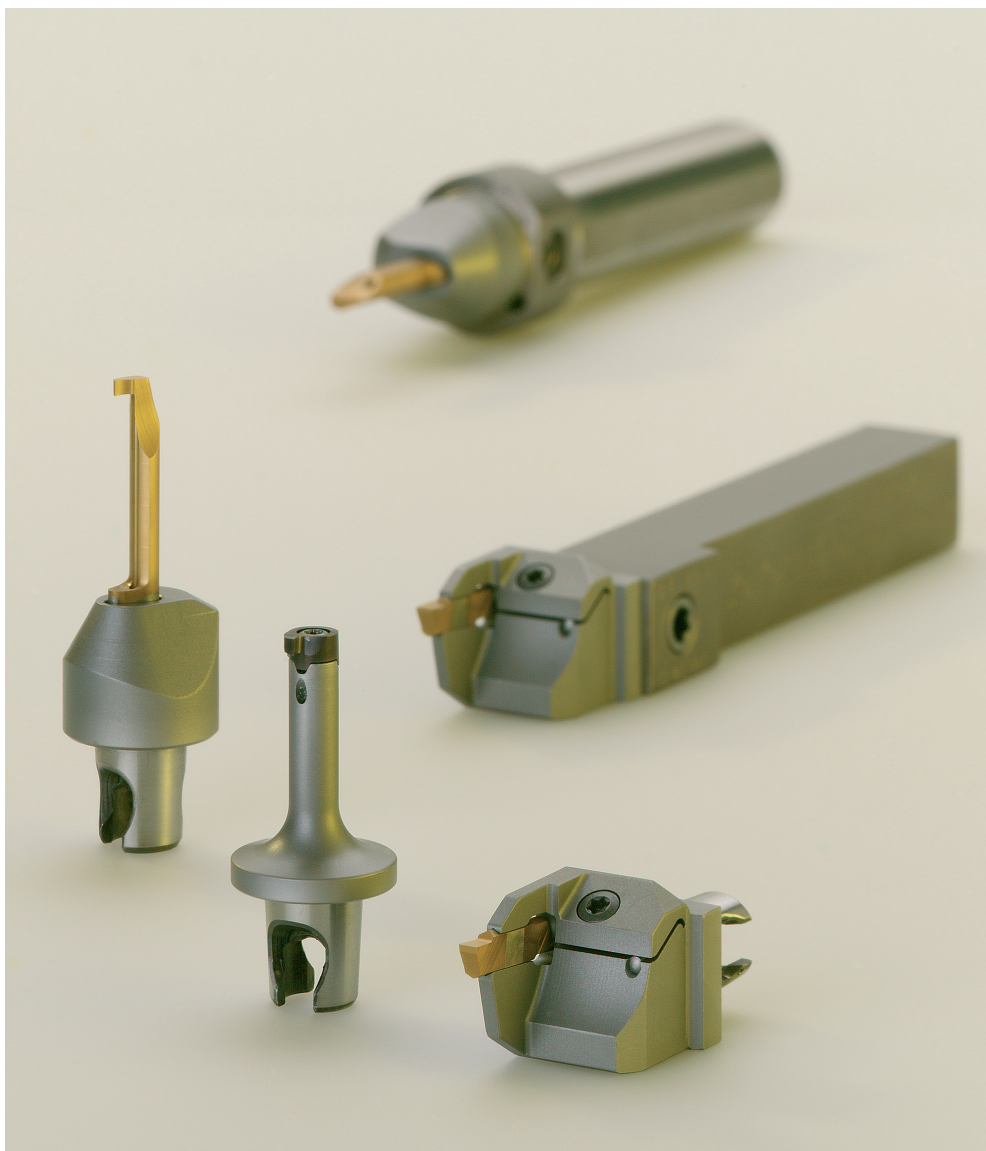
Ersatzteile

Spare parts

| Bohrstangen-Aufnahme Adaptor | Spannschraube Screw | Inbus-Schlüssel Wrench |
|---------------------------------|------------------------|---------------------------|
| 001.C025.12.30IK | DIN1835BM8x7,5 | SW4,0DIN911 |

**Supermini® Typ 105 ab Ø 0,2 mm
Mini Typ 108 ab Ø 8,0 mm
Einstecksystem 264**

**Supermini® type 105 from Ø 0,2 mm
Mini type 108 from Ø 8,0 mm
Grooving system 264**



**Außen- und Innebearbeitung
- nicht nur für Langdrehautomaten -**

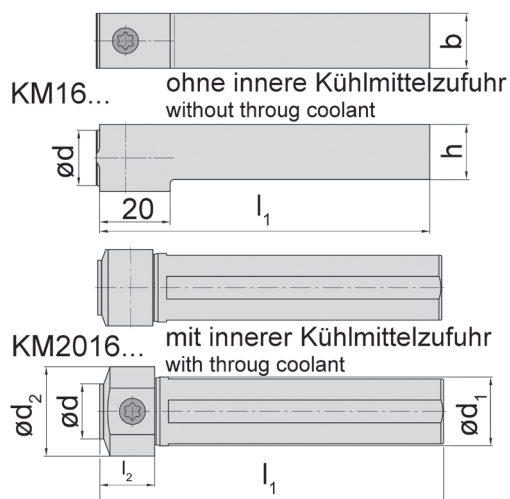
**External and internal machining
- not only for Swiss Type Machines -**

GRUNDHALTER Typ

BASIC TOOLHOLDER Type

KM16

Grundhalter für Klemmhalter ...KM16...
Basic toolholder for use with toolholder ...KM16...



System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

| Bestellnummer 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 |

Weitere Baugrößen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

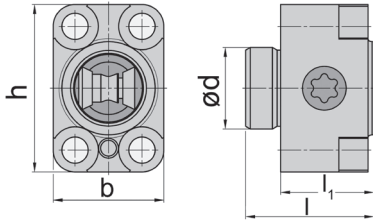
Spare parts

| Grundhalter Basic toolholder | Spannschraube Screw | TORX PLUS®-Klinge TORX PLUS® Blade |
|--|--|---------------------------------------|
| KM16 NCM 1616 100 KM2016 NCM SS2... | KM16-NSPKG KM16-NAPKG | DT27PQ DT27PQ |

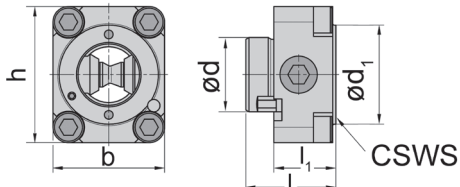
FLANSCH Typ
FLANGE Type

KM16

Grundhalter für Klemmhalter ...KM16...
Basic toolholder for use with toolholder ...KM16...



KM16... ohne innere Kühlmittelzufuhr
without through coolant



KM2016... mit innerer Kühlmittelzufuhr
with through coolant

System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

| Bestellnummer 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 |

Weitere Baugrößen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

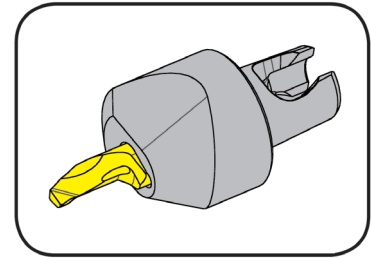
| Flansch Flange | Spannschraube Screw | TORX PLUS®-Klinge TORX PLUS® Blade |
|----------------------------------|--|---------------------------------------|
| KM16NCMSF1928 KM2016NCMSF2434 | KM16-NSPKG KM16-NAPKG | DT27PQ DT27PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

B105KM

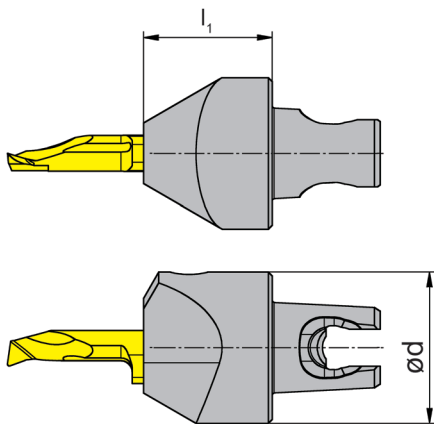
mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab

Bore Ø from

0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

| Bestellnummer Part number | d | l ₁ |
|------------------------------|----|----------------|
| B105.KM16.90.01 | 20 | 17 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

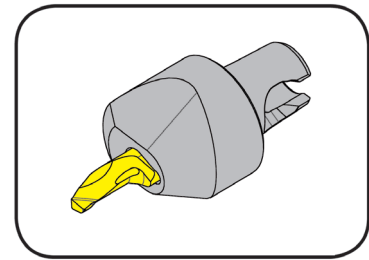
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.KM16.90.01 | 6.075T15P | T15PQ |

KLEMMHALTER Typ

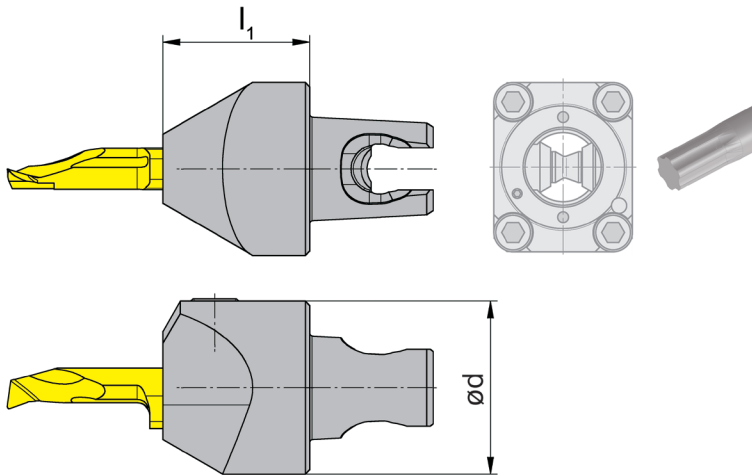
TOOLHOLDER Type

B105KM

mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab Bore Ø from 0,2 mm



für Schneidplatte
for use with Insert

Typ 105
Type

System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ |
|------------------------------|----|----------------|
| B105.KM16.01 | 20 | 17 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.KM16.01 | 6.075T15P | T15PQ |

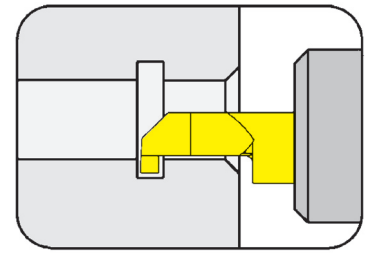
KLEMMHALTER Typ

TOOLHOLDER Type

B105TS

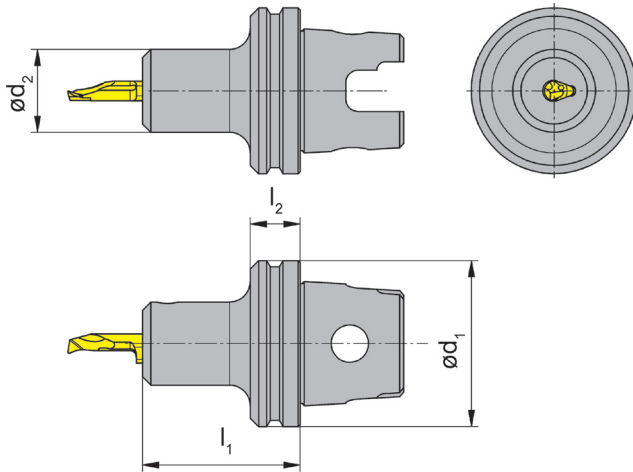
mit innerer Kühlmittelzufuhr
with through coolant supply

Direktaufnahme für Schneidplatte Typ 105 HORN-TS
Adapter for inserts type 105 HORN-TS



für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

HORN-Klemmhalter TS
nach ISO 26622
HORN Toolholder TS
according to DIN 26622

| Bestellnummer Part number | l_1 | l_2 | d_2 | d_1 | Bemerkung Remark |
|------------------------------|-------|-------|-------|-------|---------------------|
| R/LB105.TS40.20.1.01 | 38 | 12 | 20 | 40 | KM40 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

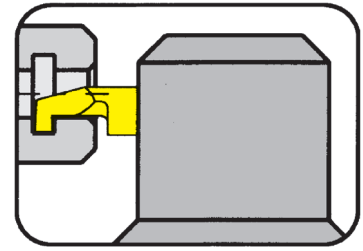
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LB105.TS40.20.1.01 | 6.075T15P | T15PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

B105TS

mit innerer Kühlmittelzufuhr
with through coolant supply

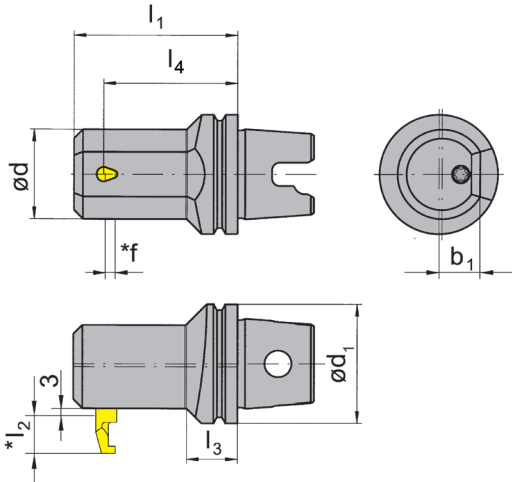


Direktaufnahme für Schneidplatte Typ 105 HORN-TS
Adapter for inserts type 105 HORN-TS

für INDEX Mehrspindler
for INDEX Multi spindle machines

für Schneidplatte
for use with Insert

Typ 105
Type



R = rechts wie gezeichnet
R = right hand version shown

HORN-Klemmhalter TS
nach ISO 26622
HORN Toolholder TS
according to DIN 26622

| Bestellnummer Part number | d | l ₁ | l ₃ | b ₁ | l ₄ | d ₁ | Maschinentyp Machine type |
|--|----|----------------|----------------|----------------|----------------|----------------|------------------------------|
| RB105.TS40.2.2.01 RB105.TS40.2.2.02 | 36 | 55 | 17 14 | 14 18 | 45 | 40 | MS32 |
| RB105.TS50.2.2.01 RB105.TS50.2.2.02 | 36 | 55 | 26 22 | 14 18 | 45 | 50 | MS52 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

f, l₂ siehe SP Typ 105
f, l₂ see inserts type 105

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

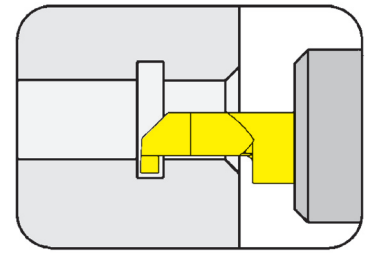
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| RB105.TS... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

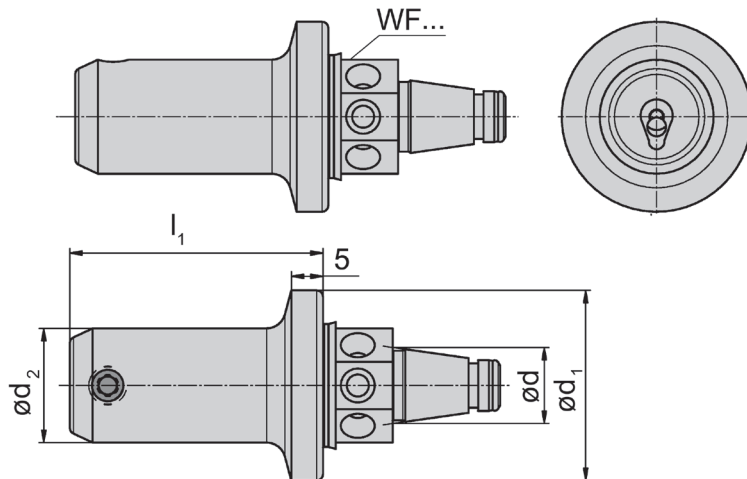
TOOLHOLDER Type

B105.WF

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 0,2 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Schneidplatte
for use with Insert

Typ 105
Type

| Bestellnummer Part number | Anbindung Coupling System | d | l ₁ | d ₂ | d ₁ |
|------------------------------|------------------------------|----|----------------|----------------|----------------|
| B105.WF20.2.01 | WF20-12 | 12 | 40 | 18 | 30 |
| B105.WF20.3.01 | | | 55 | | |
| B105.WF24.2.01 | WF24-16 | 16 | 40 | 18 | 37 |
| B105.WF32.2.01 | WF32-20 | 20 | 40 | 18 | 47 |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.WF... | 6.075T15P | T15PQ |

BOHRUNG-DREHEN $\geq \varnothing 0,2$ mm

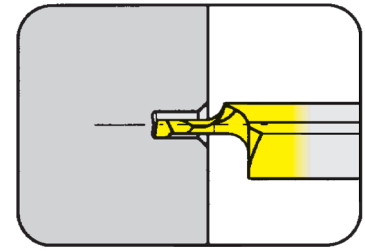
BORING and PROFILING



A

SCHNEIDPLATTE Typ INSERT Type

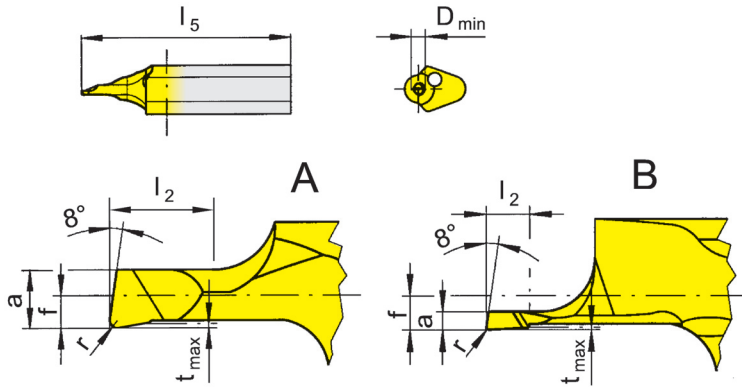
105



Bohrungs- \varnothing ab Bore \varnothing from 0,2 mm

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
 H105
 HC105
 VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | l_2 | l_5 | t_{max} | D_{min} | r | Form Form | MG12 | TN35 | TI25 | 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 | ▲/▲ | | | |
| | | | | | | | | | P | o | | |
| | | | | | | | | | M | • | | |
| | | | | | | | | | K | • | | |
| | | | | | | | | | N | • | | |
| | | | | | | | | | S | • | | |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

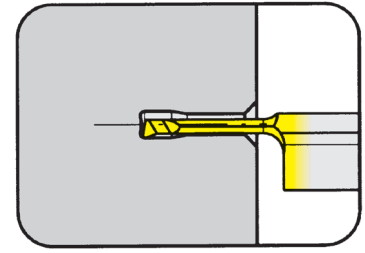
| | | | |
|---|---|--|--|
| P | o | | |
| M | • | | |
| K | • | | |
| N | • | | |
| S | • | | |
| H | | | |

HM-Sorten
Carbide grades

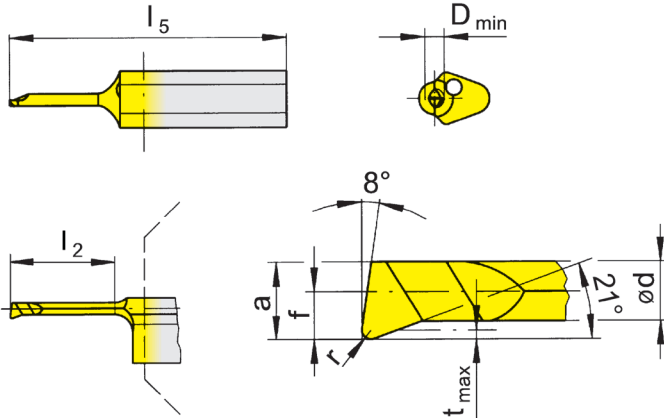
SCHNEIDPLATTE Typ

105

INSERT Type

Bohrungs- \varnothing abBore \varnothing from

1,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | ▲/▲ | |
| 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 | | | | | | | ▲/▲ | ▲/▲ |
| 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 | | | | | | | ▲/▲ | ▲/▲ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | | | | | |
|---|---|---|---|---|---|
| P | o | ● | ● | ● | ● |
| M | ● | ● | ● | ● | ● |
| K | ● | ● | ● | ● | ● |
| N | ● | ● | ● | ● | ● |
| S | ● | ● | ● | ● | ● |
| H | | | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 2,0$ mm

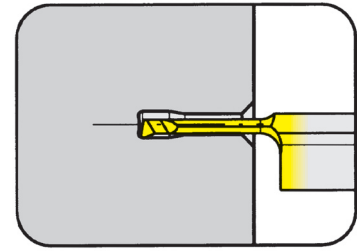
BORING and PROFILING



A

SCHNEIDPLATTE Typ INSERT Type

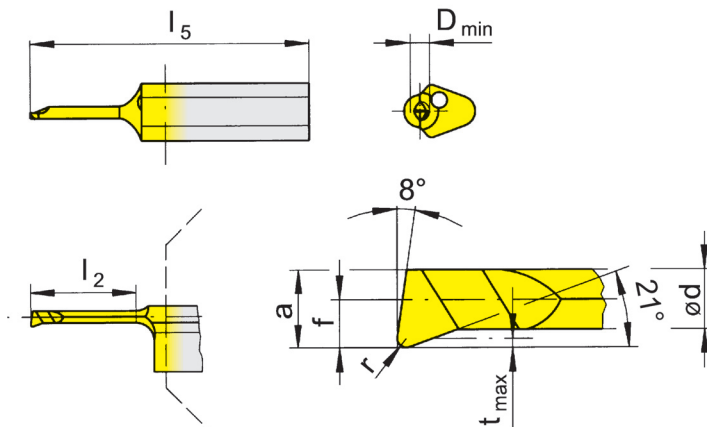
105



Bohrungs- \varnothing ab Bore \varnothing from 2,0 mm

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
 H105
 HC105
 VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | ▲/▲ | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | | |
|---|---|---|---|---|---|
| P | o | • | • | • | • |
| M | • | • | • | • | • |
| K | • | • | • | • | • |
| N | • | • | • | • | • |
| S | • | • | • | • | • |
| H | | | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

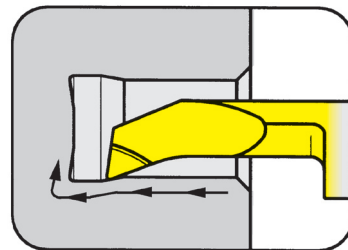
Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

SCHNEIDPLATTE Typ

105

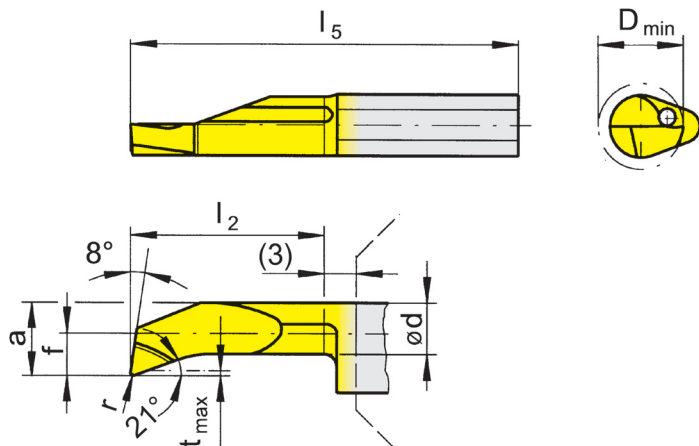
INSERT Type



Bohrungs- \varnothing ab

Bore \varnothing from

3,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | ▲/▲ | ▲/▲ | ▲/▲ | | ▲/▲ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | | | | | |
|---|---|---|---|---|---|
| P | o | • | • | • | • |
| M | • | • | • | • | • |
| K | • | • | • | • | • |
| N | • | • | • | • | • |
| S | • | • | • | • | • |
| H | | | | | |

HM-Sorten
Carbide grades

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 5,0$ mm

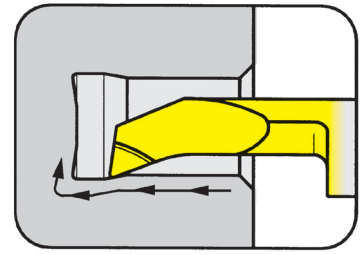
BORING and PROFILING



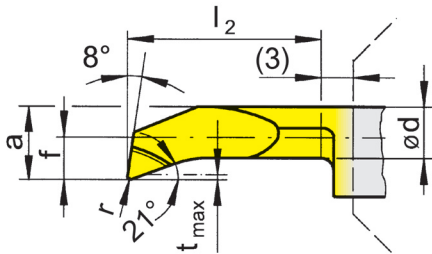
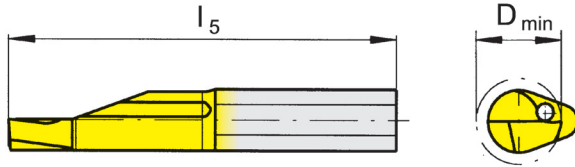
A

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs- \varnothing ab Bore \varnothing from 5,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | ▲/▲ | ▲/▲ | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

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

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

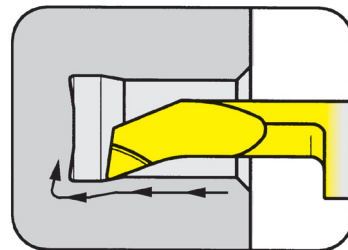
Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

SCHNEIDPLATTE Typ

105

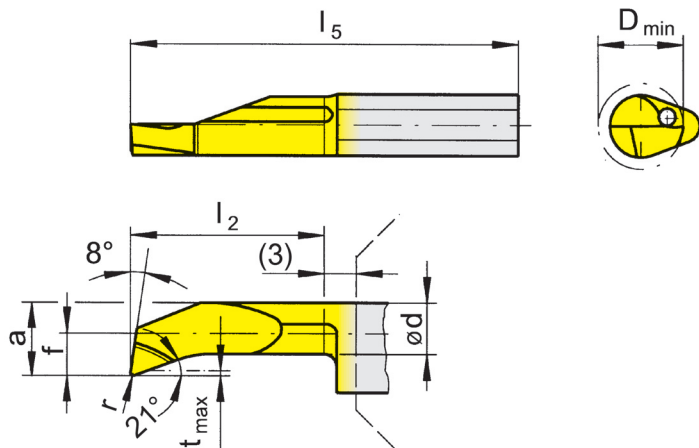
INSERT Type



Bohrungs- \varnothing ab

Bore \varnothing from

6,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | ▲/▲ | ▲/▲ | ▲/▲ | | ▲/▲ | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | | |
|---|---|---|---|---|---|
| P | o | • | • | • | • |
| M | • | • | • | • | • |
| K | • | • | • | • | • |
| N | • | • | • | • | • |
| S | • | • | • | • | • |
| H | | | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 4,0$ mm

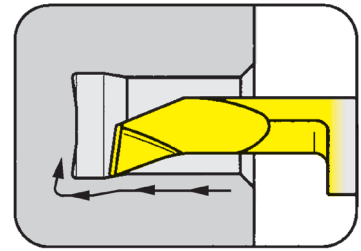
BORING and PROFILING



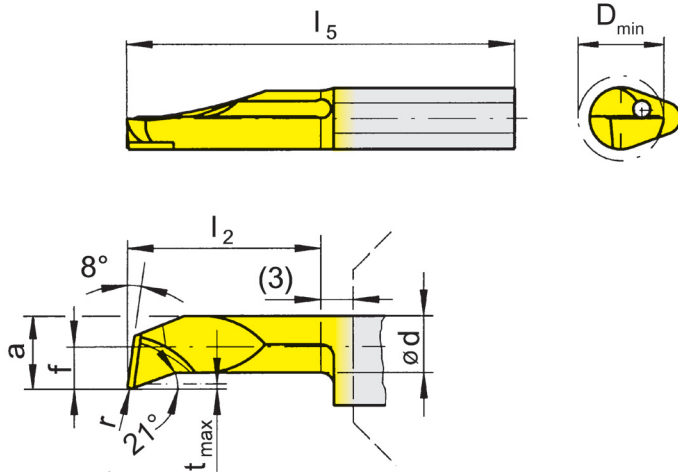
A

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs- \varnothing ab Bore \varnothing from 4,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

mit Spantreppe
(Geometrie H)
with chip breaker
(geometry H)

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | 20 | 35 | | | | | | | | ▲/▲ | ▲/▲ |
| R/L105.1833.4.H6 | 3,3 | 5,7 | 4,7 | 25 | 40 | 0,5 | 6,0 | 0,2 | | | | | ▲/▲ | ▲/▲ |
| 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 | | | | | | | | ▲/▲ | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|---|---|
| P | | | ● | ● |
| M | | | ● | ● |
| K | | | ● | ● |
| N | | | ● | ● |
| S | | | ● | ● |
| H | | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 4,0$ mm

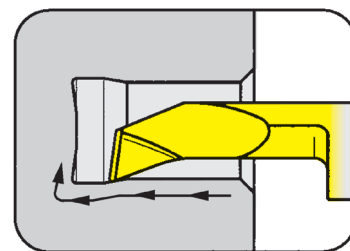
BORING and PROFILING



SCHNEIDPLATTE Typ

105

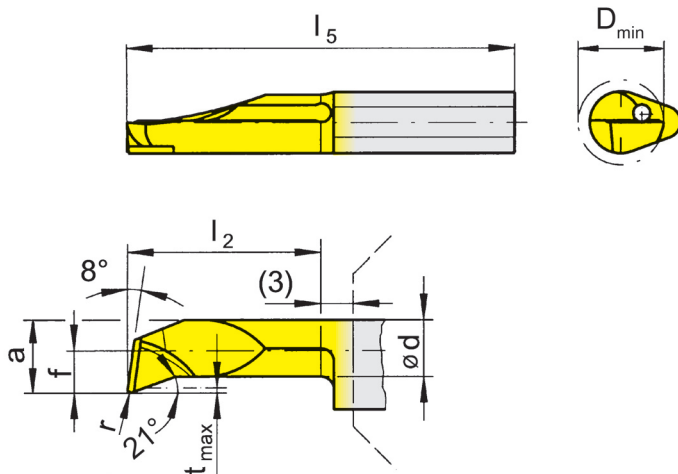
INSERT Type



Bohrungs- \varnothing ab

Bore \varnothing from

4,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

verlängerte Spantrenne
(Geometrie HV)
extended chip breaker
(geometry HV)

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-------|-------|-----------|-----------|-----|------|------|------|------|
| R/L105.1819.1.HV4 | | | | 10 | 25 | | | | | | | ▲/Δ |
| R/L105.1819.2.HV4 | 1,9 | 3,7 | 2,9 | 15 | 30 | 0,3 | 4,0 | 0,2 | | | | ▲/Δ |
| R/L105.1819.3.HV4 | | | | 20 | 35 | | | | | | | ▲/Δ |
| 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 | | | | | | | ▲/Δ |
| R/L105.1823.5.HV5 | | | | 30 | 45 | | | | | | | ▲/Δ |
| 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 | | | | ▲/Δ |
| R/L105.1833.5.HV6 | | | | 30 | 45 | | | | | | | ▲/Δ |
| R/L105.1840.2.HV7 | | | | 15 | 30 | | | | | | | ▲/▲ |
| R/L105.1840.3.HV7 | | | | 20 | 35 | | | | | | | ▲/Δ |
| R/L105.1840.4.HV7 | 4,0 | 6,4 | 5,2 | 25 | 40 | 0,5 | 6,8 | 0,2 | | | | ▲/Δ |
| R/L105.1840.5.HV7 | | | | 30 | 45 | | | | | | | ▲/Δ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | ● |
| M | | | ● |
| K | | | ● |
| N | | | ● |
| S | | | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

BOHRUNG-DREHEN $\geq \varnothing 4,0$ mm

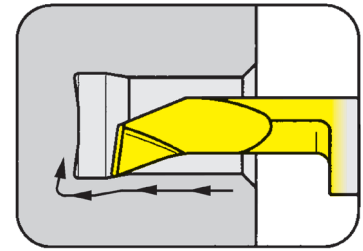
BORING and PROFILING



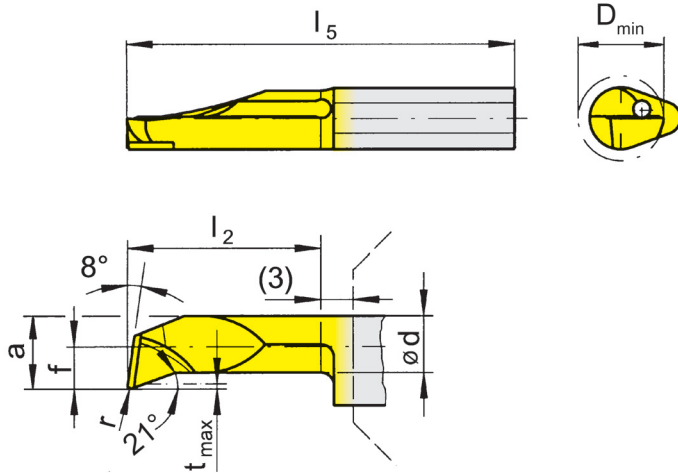
A

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs- \varnothing ab Bore \varnothing from 4,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

verlängerte Spantrenne
(Geometrie HV)
extended chip breaker
(geometry HV)

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | MG12 | TN35 | TI25 | 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 | | | | ▲/Δ |
| R/L105.1819.04.3.HV4 | | | | 20 | 35 | | | | | | | ▲/Δ |
| R/L105.1823.04.1.HV5 | | | | 10 | 25 | | | | | | | ▲/▲ |
| R/L105.1823.04.2.HV5 | | | | 15 | 30 | | | | | | | ▲/Δ |
| R/L105.1823.04.3.HV5 | 2,3 | 4,7 | 4,0 | 20 | 35 | 0,5 | 5,0 | 0,4 | | | | ▲/Δ |
| R/L105.1823.04.4.HV5 | | | | 25 | 40 | | | | | | | Δ/Δ |
| R/L105.1823.04.5.HV5 | | | | 30 | 45 | | | | | | | ▲/Δ |
| 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 | | | | ▲/Δ |
| R/L105.1833.04.5.HV6 | | | | 30 | 45 | | | | | | | Δ/Δ |
| R/L105.1840.04.2.HV7 | | | | 15 | 30 | | | | | | | ▲/Δ |
| R/L105.1840.04.3.HV7 | | | | 20 | 35 | | | | | | | ▲/Δ |
| R/L105.1840.04.4.HV7 | 4,0 | 6,4 | 5,2 | 25 | 40 | 0,5 | 6,8 | 0,4 | | | | ▲/Δ |
| R/L105.1840.04.5.HV7 | | | | 30 | 45 | | | | | | | ▲/Δ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | ● |
| M | | | ● |
| K | | | ● |
| N | | | ● |
| S | | | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 4,0$ mm

BORING and PROFILING

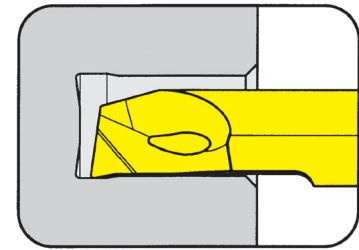


SCHNEIDPLATTE Typ

INSERT Type

105

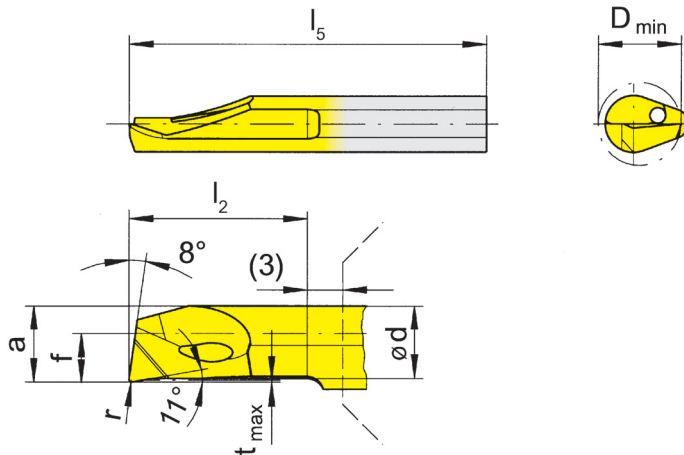
verstärkte Ausführung
reinforced version



Bohrungs- \varnothing ab

Bore \varnothing from

4,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-------|-------|-----------|-----------|------|--|------|------|------|------|
| R/L105.1019.005.1.4 | | | | 10 | 25 | | | | | | | | ▲/▲ |
| R/L105.1019.005.2.4 | 1,5 | 3,7 | 3,4 | 15 | 30 | 0,15 | 4 | 0,05 | | | | | ▲/Δ |
| R/L105.1019.005.3.4 | | | | 20 | 35 | | | | | | | | ▲/▲ |
| R/L105.1019.005.4.4 | | | | 25 | 40 | | | | | | | | ▲/▲ |
| R/L105.1019.1.4 | | | | 10 | 25 | | | | | | | | ▲/▲ |
| R/L105.1019.2.4 | 1,5 | 3,7 | 3,4 | 15 | 30 | 0,15 | 4 | 0,20 | | | | | ▲/▲ |
| R/L105.1019.3.4 | | | | 20 | 35 | | | | | | | | ▲/Δ |
| R/L105.1019.4.4 | | | | 25 | 40 | | | | | | | | ▲/▲ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

○ bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| MG12 | ● | ● | ● | ● | ● | ● |
| TN35 | ● | ● | ● | ● | ● | ● |
| TI25 | ● | ● | ● | ● | ● | ● |
| TH35 | ● | ● | ● | ● | ● | ● |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 5,0$ mm

BORING and PROFILING



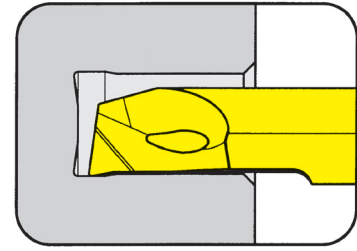
A

SCHNEIDPLATTE Typ

INSERT Type

105

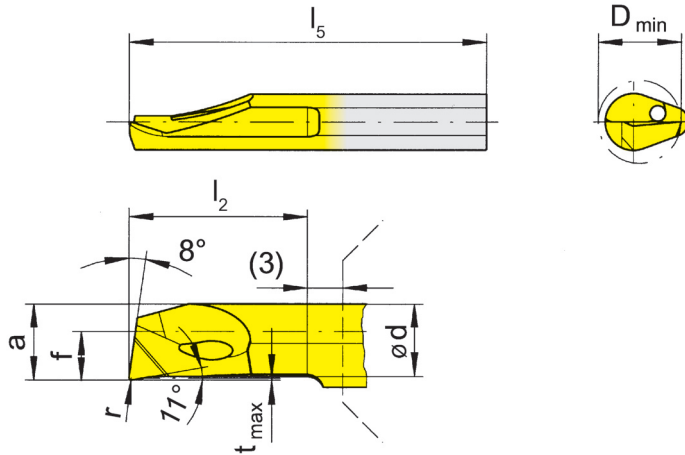
verstärkte Ausführung
reinforced version



Bohrungs- \varnothing ab

Bore \varnothing from

5,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | 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 | | | | | | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | ● |
| M | | | ● |
| K | | | ● |
| N | | | ● |
| S | | | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

BORING and PROFILING

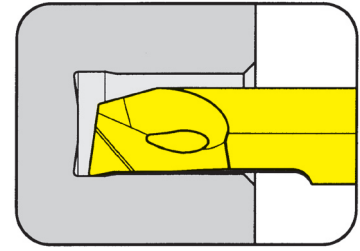


SCHNEIDPLATTE Typ

INSERT Type

105

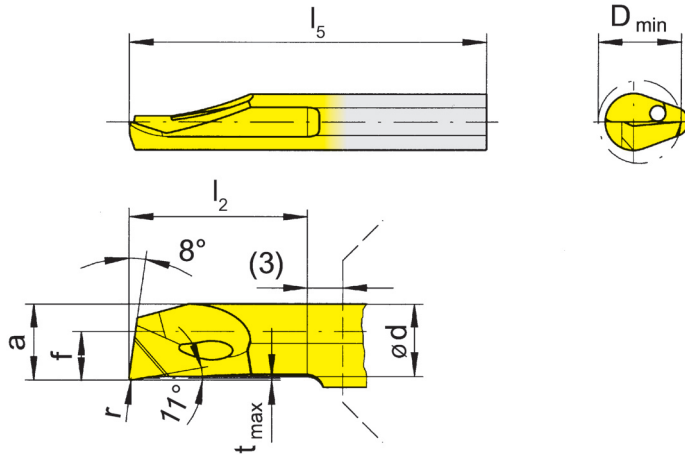
verstärkte Ausführung
reinforced version



Bohrungs- \varnothing ab

Bore \varnothing from

6,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | 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 | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | | | | • |
| | | | | | | | | | | | | | • |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 6,8$ mm

BORING and PROFILING



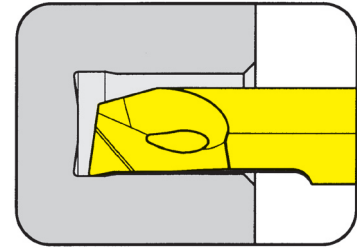
A

SCHNEIDPLATTE Typ

INSERT Type

105

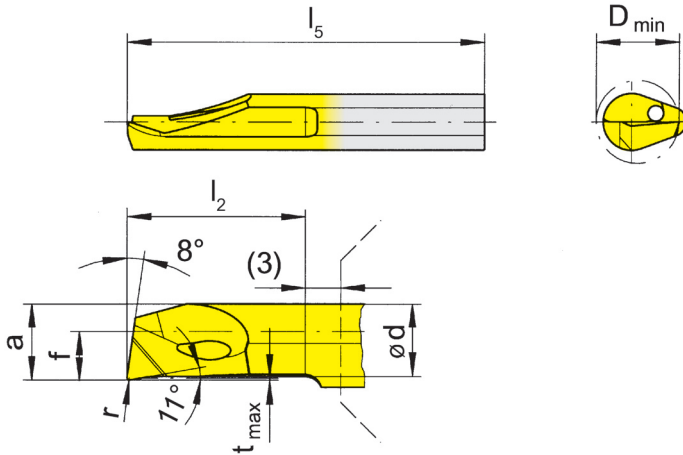
verstärkte Ausführung
reinforced version



Bohrungs- \varnothing ab

Bore \varnothing from

6,8 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | 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 | | | | | | | | ▲▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | | | • |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 4,0$ mm

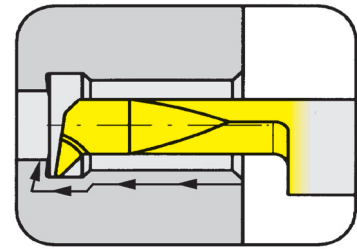
BORING and PROFILING



SCHNEIDPLATTE Typ

105

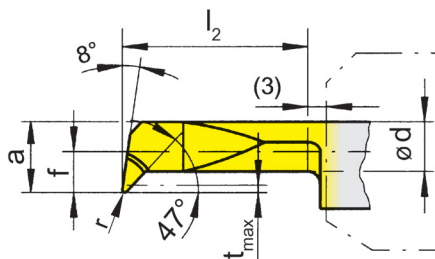
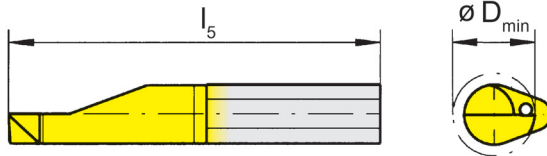
INSERT Type



Bohrungs- \varnothing ab

Bore \varnothing from

4,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | 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 | | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | • | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 3,0$ mm

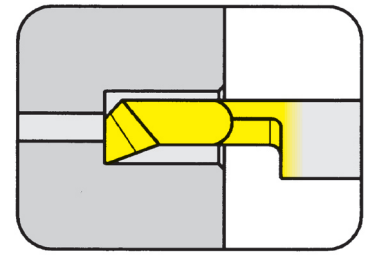
BORING and PROFILING



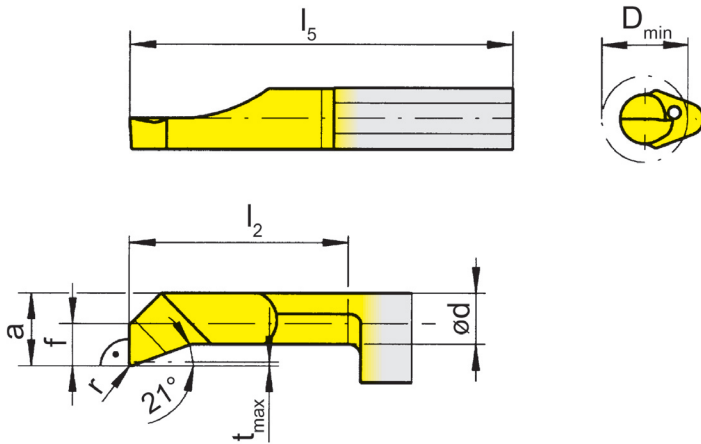
A

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs- \varnothing ab Bore \varnothing from 3,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | 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 | | | | | ▲/▲ | | |

- ▲ ab Lager / on stock △ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | ● | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 5,0$ mm

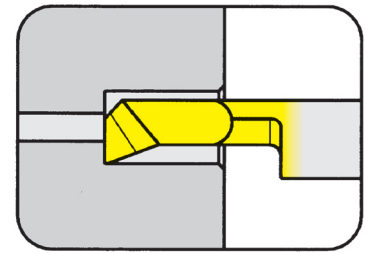
BORING and PROFILING



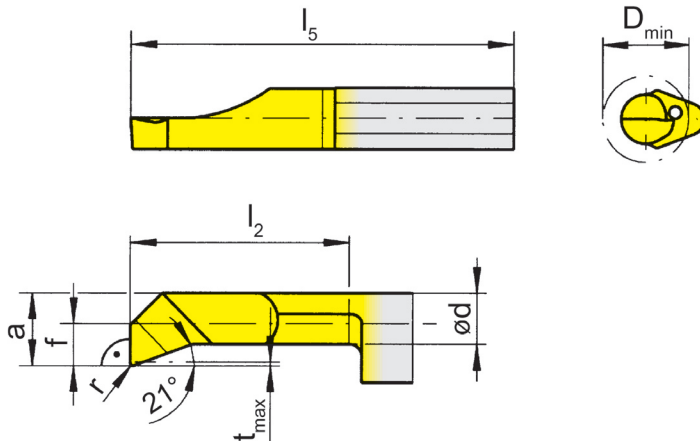
SCHNEIDPLATTE Typ

INSERT Type

105



Bohrungs- \varnothing ab Bore \varnothing from 5,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
 H105
 HC105
 VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | Material | | | |
|------------------------------|-----|-----|-----|----------------|----------------|------------------|------------------|-----|----------|------|------|------|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L105.9023.01.1.5 | 2,3 | 4,7 | 4,0 | 10 | 25 | 0,5 | 5 | 0,1 | | | | ▲/Δ |
| R/L105.9023.01.2.5 | | | | | | | | | | | | ▲/Δ |
| R/L105.9023.01.3.5 | | | | | | | | | | | | ▲/Δ |
| R/L105.9023.01.4.5 | | | | | | | | | | | | ▲/ |
| R/L105.9023.1.5 | 2,3 | 4,7 | 4,0 | 10 | 25 | 0,5 | 5 | 0,2 | | ▲/▲ | | ▲/ |
| R/L105.9023.2.5 | | | | | | | | | ▲/▲ | | | |
| R/L105.9023.3.5 | | | | | | | | | ▲/▲ | | | |
| R/L105.9033.1.6 | 3,3 | 5,7 | 4,7 | 10 | 25 | 0,5 | 6 | 0,2 | | | | Δ/ |
| R/L105.9033.2.6 | | | | | | | | | | | | ▲/Δ |
| R/L105.9033.3.6 | | | | | | | | | | | | ▲/Δ |
| R/L105.9033.4.6 | | | | | | | | | | | | ▲/Δ |
| R/L105.9033.5.6 | | | | | | | | | | | | ▲/Δ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| MG12 | ● | | | | | |
| TN35 | ● | | | | | |
| TI25 | ● | | | | | |
| TH35 | ● | | | | | |

Abmessungen in mm
Dimensions in mm

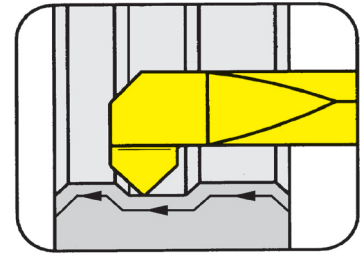
Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

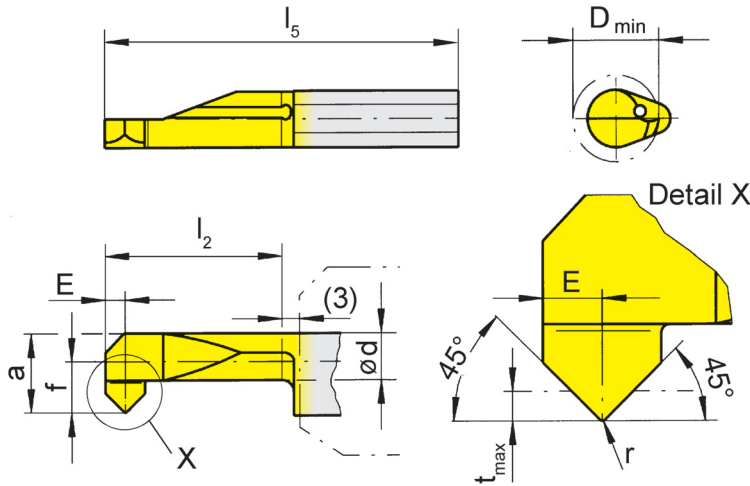
HM-Sorten
Carbide grades

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs-Ø ab Bore Ø from 5,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | E | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | MG12 | TN35 | TI25 | 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 | | ▲/▲ | | |
| | | | | | | | | | | P | • | | |
| | | | | | | | | | | M | • | | |
| | | | | | | | | | | K | • | | |
| | | | | | | | | | | N | • | | |
| | | | | | | | | | | S | • | | |
| | | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|--|--|
| P | • | | |
| M | • | | |
| K | • | | |
| N | • | | |
| S | • | | |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

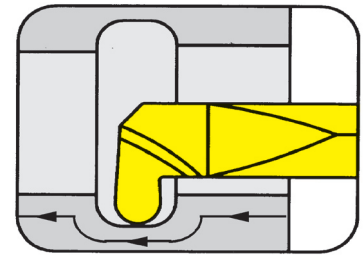
Weitere Abmessungen auf Anfrage
Further sizes upon request

EINSTECHEN (innen) $\geq \text{Ø } 4,0 \text{ mm}$ GROOVING (internal)

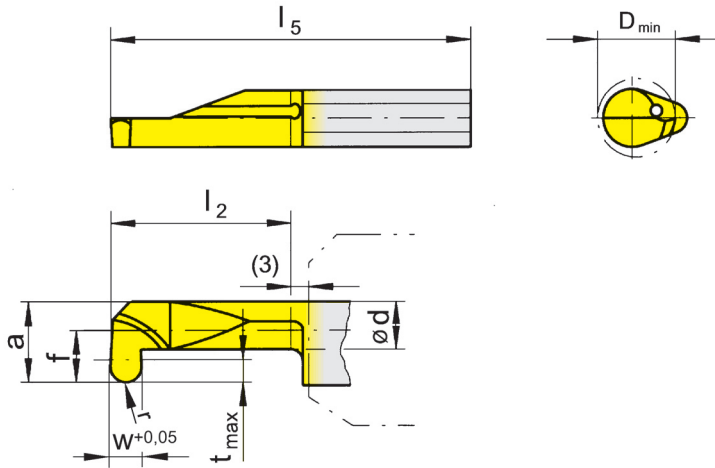


SCHNEIDPLATTE Typ
INSERT Type

105



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 4,0 mm |
| Vollradius | Full radius | r 0,5 - 1,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

Vollradius
Full radius

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | MG12 | TN35 | TH35 |
|------------------------------|-----|-----|-----|-----|----------------|----------------|------------------|------------------|------|------|------|------|
| R/L105.0005.1.4 | 1,0 | 1,9 | 3,7 | 2,7 | 10 | 25 | 0,8 | 4 | 0,50 | | | ▲/▲ |
| R/L105.0005.2.4 | 1,0 | 1,9 | 3,7 | 2,7 | 15 | 30 | 0,8 | 4 | 0,50 | | ▲/▲ | |
| R/L105.0007.1.5 | 1,5 | | | | | | | | 0,75 | | | ▲/▲ |
| R/L105.0010.1.5 | 2,0 | 2,3 | 4,7 | 3,5 | 10 | 25 | 1,0 | 5 | 1,00 | | | ▲/▲ |
| 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 | 0,75 | | ▲/▲ | |
| R/L105.0010.3.5 | 2,0 | | | | | | | | 1,00 | | ▲/▲ | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | |
|---|---|---|
| P | ● | ● |
| M | ● | ● |
| K | ● | ● |
| N | ● | ● |
| S | ● | ● |
| H | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

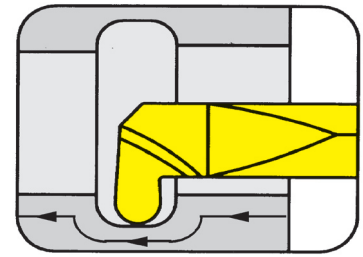
EINSTECHEN (innen) $\geq \text{Ø } 6,0 \text{ mm}$ GROOVING (internal)



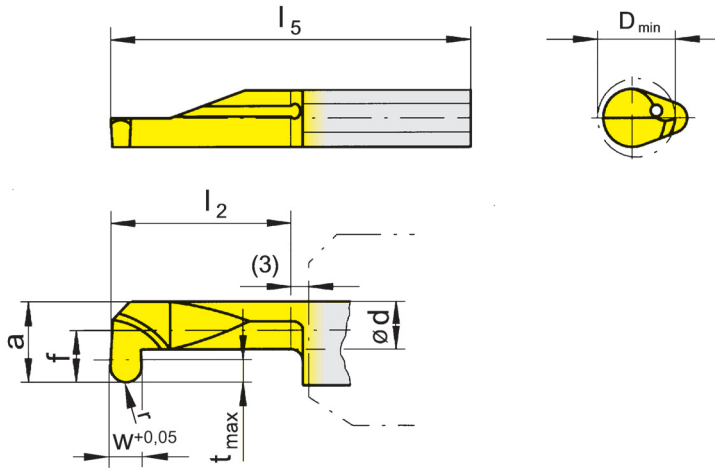
A

SCHNEIDPLATTE Typ INSERT Type

105



| | | |
|-----------------------------|----------------------------|--------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 6,0 mm r 0,5 - 1,0 mm |
|-----------------------------|----------------------------|--------------------------|



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

Vollradius
Full radius

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|-------|-------|-----------|-----------|------|------|------|------|------|
| R/L105.0005.2.6 | 1,0 | | | | | | | | 0,50 | | | | ▲/▲ |
| R/L105.0007.2.6 | 1,5 | 3,3 | 5,7 | 3,7 | 15 | 30 | 1,8 | 6 | 0,75 | | | | ▲/▲ |
| R/L105.0010.2.6 | 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 | 0,75 | | ▲/▲ | | |
| R/L105.0010.4.6 | 2,0 | | | | | | | | 1,00 | | ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | • | • | • |
| M | • | • | • |
| K | • | • | • |
| N | • | • | • |
| S | • | • | • |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

EINSTECHEN (innen) $\geq \text{Ø } 6,8 \text{ mm}$

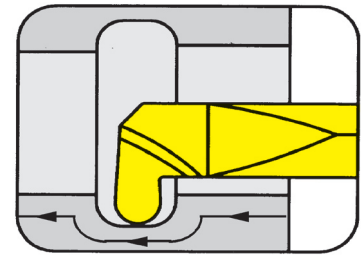
GROOVING (internal)



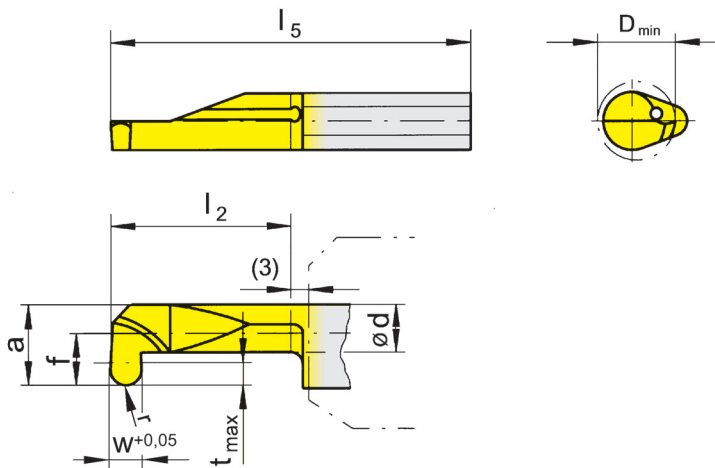
SCHNEIDPLATTE Typ

105

INSERT Type



Bohrungs-Ø ab Bore Ø from 6,8 mm
Vollradius Full radius r 0,5 - 1,0 mm



für Einbaualter Graf
for use with Cartridge Graf

Typ B105
Type BKT105
H105
HC105
VDI

Vollradius
Full radius

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 | |
|---|-----|---|-----|-----|-------|-------|-----------|------------|------|------|------|------|------|---|
| R/L105.0005.3.7 | 1,0 | | | | | | | | 0,50 | | | | ▲/▲ | |
| R/L105.0007.3.7 | 1,5 | 4 | 6,4 | 3,7 | 20 | 35 | 2,5 | 6,8 | 0,75 | | | | ▲/▲ | |
| R/L105.0010.3.7 | 2,0 | | | | | | | | 1,00 | | | | ▲/▲ | |
| R/L105.0005.5.7 | 1,0 | | | | | | | | 0,50 | | ▲/▲ | | | |
| R/L105.0007.5.7 | 1,5 | 4 | 6,4 | 3,7 | 30 | 45 | 2,5 | 6,8 | 0,75 | | ▲/▲ | | | |
| R/L105.0010.5.7 | 2,0 | | | | | | | | 1,00 | | ▲/▲ | | | |
| ▲ ab Lager / on stock | | | | | | | | | | | P | • | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

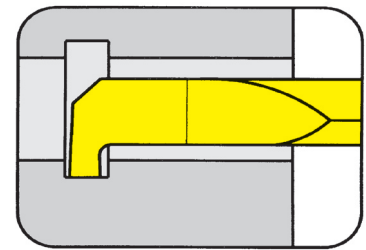
EINSTECHEN (innen) $\geq \text{Ø } 2,0 \text{ mm}$ GROOVING (internal)



A

SCHNEIDPLATTE Typ INSERT Type

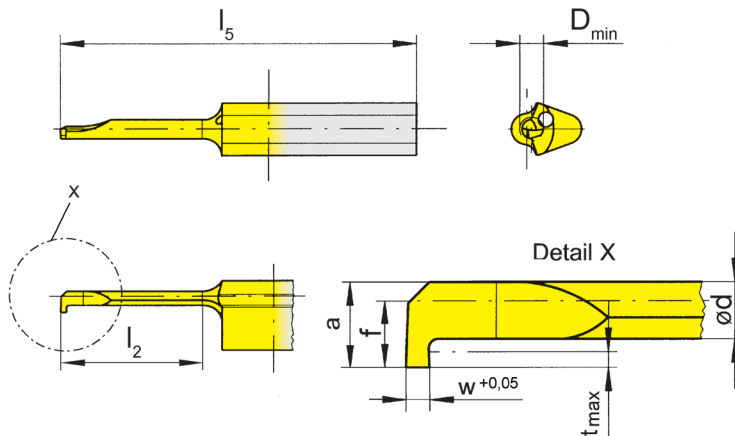
105



| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 2,0 mm |
| Stechtiefe bis | Depth of groove up to | 0,4 mm |

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | | | | | ▲/▲ | | |
| <ul style="list-style-type: none"> ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | P | | ● | |
| | | | | | | | | | | M | | ● | |
| | | | | | | | | | | K | | ● | |
| | | | | | | | | | | N | | ● | |
| | | | | | | | | | | S | | ● | |
| | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 3,0 \text{ mm}$

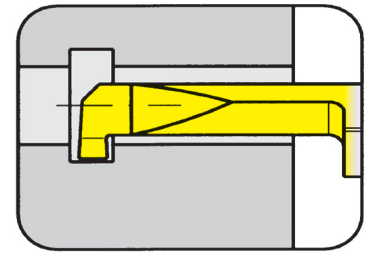
GROOVING (internal)



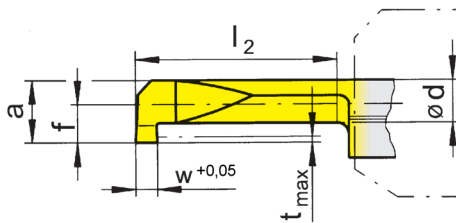
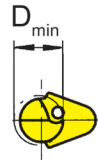
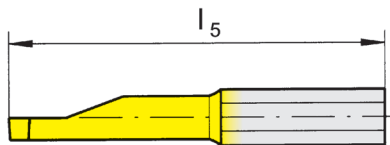
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 3,0 mm |
| Stechtiefe bis | Depth of groove up to | 0,6 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | | | | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | • | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | • | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | • | |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | • | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | | • | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

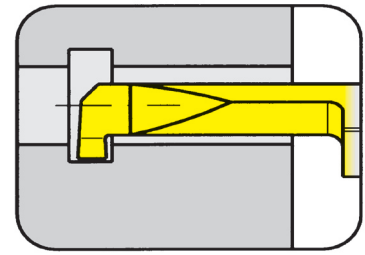
EINSTECHEN (innen) $\geq \text{Ø} 4,0 \text{ mm}$ GROOVING (internal)



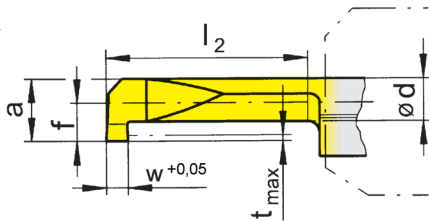
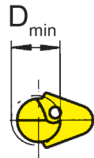
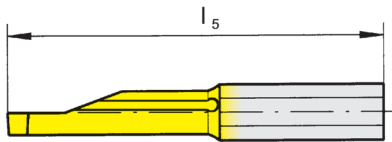
A

SCHNEIDPLATTE Typ INSERT Type

105



| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 4,0 mm |
| Stechtiefe bis | Depth of groove up to | 0,8 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | | | ▲/▲ | ▲/▲ | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation ○ bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | ○ | ● | |
| | | | | | | | | | M | ● | ● | |
| | | | | | | | | | K | ● | ● | |
| | | | | | | | | | N | ● | ● | |
| | | | | | | | | | S | ● | ● | |
| | | | | | | | | | H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

EINSTECHEN (innen) $\geq \text{Ø } 5,0 \text{ mm}$

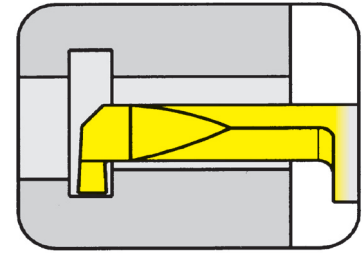
GROOVING (internal)



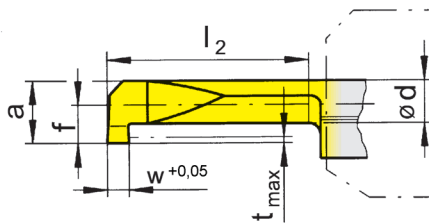
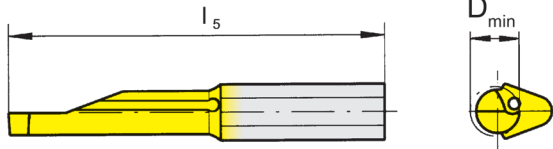
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 5,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | ▲/ | ▲/▲ | | ▲/Δ |
| R/L105.0200.1.5 | 2,0 | | | | | | | | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0100.2.5 | 1,0 | | | | | | | | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0150.2.5 | 1,5 | 2,3 | 4,7 | 3,5 | 15 | 30 | 1 | 5 | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0200.2.5 | 2,0 | | | | | | | | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0100.3.5 | 1,0 | | | | | | | | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0150.3.5 | 1,5 | 2,3 | 4,7 | 3,5 | 20 | 35 | 1 | 5 | ▲/Δ | ▲/▲ | | ▲/▲ |
| R/L105.0200.3.5 | 2,0 | | | | | | | | Δ/ | ▲/Δ | | ▲/Δ |
| R/L105.0100.4.5 | 1,0 | | | | | | | | | ▲/Δ | | Δ/Δ |
| R/L105.0150.4.5 | 1,5 | 2,3 | 4,7 | 3,5 | 25 | 40 | 1 | 5 | | ▲/Δ | | ▲/Δ |
| R/L105.0200.4.5 | 2,0 | | | | | | | | | ▲/Δ | | Δ/Δ |
| R/L105.0100.5.5 | 1,0 | | | | | | | | | ▲/Δ | | ▲/Δ |
| R/L105.0150.5.5 | 1,5 | 2,3 | 4,7 | 3,5 | 30 | 45 | 1 | 5 | | ▲/Δ | | ▲/Δ |
| R/L105.0200.5.5 | 2,0 | | | | | | | | | ▲/Δ | | Δ/Δ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | o | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \varnothing 6,0$ mm

GROOVING (internal)

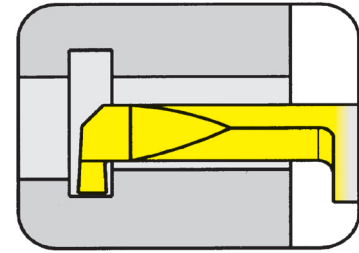


A

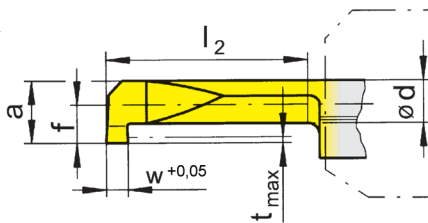
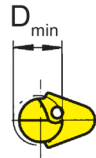
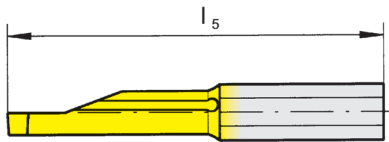
SCHNEIDPLATTE Typ

INSERT Type

105



| | | |
|----------------------------|-------------------------|--------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,8 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | HM-Sorten | | | |
|------------------------------|-----|-----|-----|-----|----------------|----------------|------------------|------------------|-----------|------|------|------|
| | | | | | | | | | MG12 | TN35 | Ti25 | 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 | | | | | | | | | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | o | • | • |
| M | • | • | • |
| K | • | • | • |
| N | • | • | • |
| S | • | • | • |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 6,8 \text{ mm}$

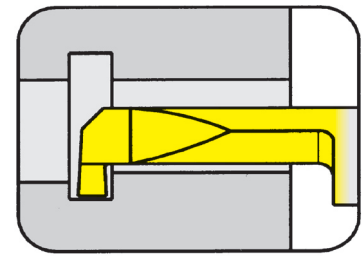
GROOVING (internal)



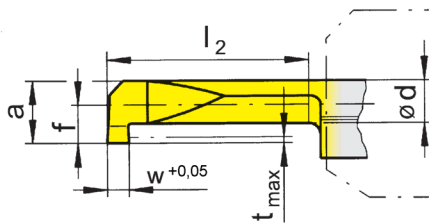
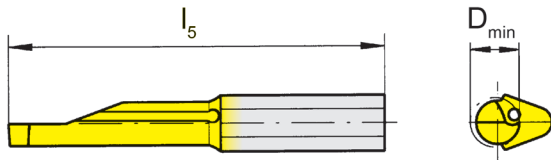
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,8 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | HM-Sorten | | | |
|------------------------------|-----|---|-----|-----|----------------|----------------|------------------|------------------|-----------|------|------|------|
| | | | | | | | | | MG12 | TN35 | TI25 | 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 | ▲/Δ | ▲/▲ | | ▲/▲ |
| 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 | ▲/Δ | ▲/▲ | | ▲/▲ |
| R/L105.0200.2.7 | 2,0 | | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |
| R/L105.0100.3.7 | 1,0 | | | | | | | | ▲/▲ | ▲/▲ | | ▲/Δ |
| R/L105.0150.3.7 | 1,5 | 4 | 6,4 | 3,7 | 20 | 35 | 2,5 | 6,8 | ▲/Δ | ▲/▲ | | ▲/Δ |
| R/L105.0200.3.7 | 2,0 | | | | | | | | ▲/Δ | ▲/▲ | | ▲/▲ |
| R/L105.0100.4.7 | 1,0 | | | | | | | | | ▲/Δ | | ▲/Δ |
| 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 | | ▲/▲ | | ▲/Δ |
| R/L105.0200.5.7 | 2,0 | | | | | | | | | ▲/▲ | | ▲/Δ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

○ bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

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

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

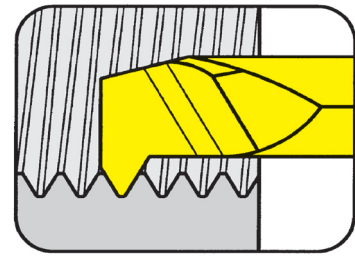


A

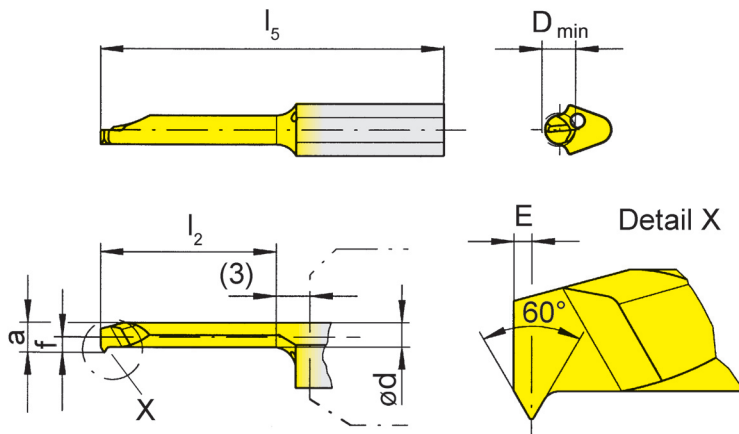
SCHNEIDPLATTE Typ

INSERT Type

105



| | | |
|---------------|-------------|-----------|
| Bohrungs-Ø ab | Bore Ø from | 3,00 mm |
| Steigung | Pitch | P 0,25 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|------|-----|-----|-----|-----|----------------|----------------|------------------|------|------|------|------|
| R/L105.0102.2.3 | 0,25 | 0,3 | 1,4 | 2,7 | 2,2 | 15 | 30 | 3 | | ▲/△ | | |
| ▲ ab Lager / on stock | | | | | | | | | P | • | | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

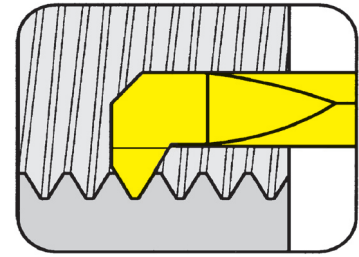


SCHNEIDPLATTE Typ

105

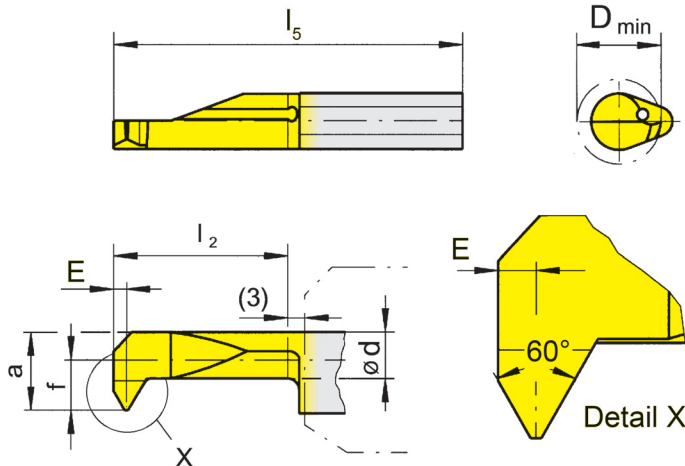
INSERT Type

| | | |
|---------------|-------------|-----------|
| Bohrungs-Ø ab | Bore Ø from | 3,00 mm |
| Steigung | Pitch | P 0,35 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|------|-----|-----|-----|-----|----------------|----------------|------------------|------|------|------|------|
| R/L105.0203.1.3 | 0,35 | 0,3 | 1,4 | 2,7 | 2,1 | 10 | 25 | 3 | | ▲/Δ | | |
| R/L105.0203.2.5 | 0,35 | 0,3 | 2,3 | 4,7 | 3,5 | 15 | 30 | 5 | | ▲/▲ | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | • | | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

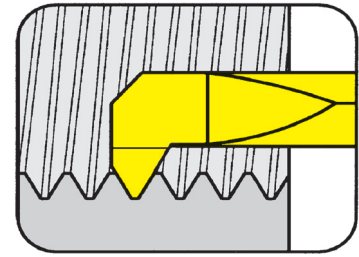


A

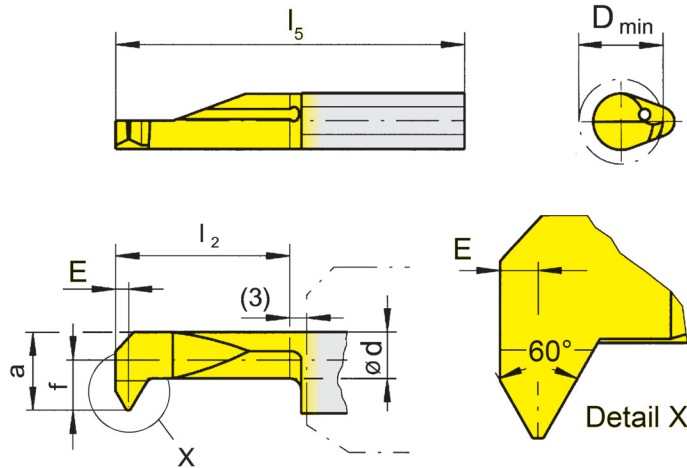
SCHNEIDPLATTE Typ

INSERT Type

105



| | | |
|---------------|-------------|-----------|
| Bohrungs-Ø ab | Bore Ø from | 3,00 mm |
| Steigung | Pitch | P 0,50 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | 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 | | ▲/ | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

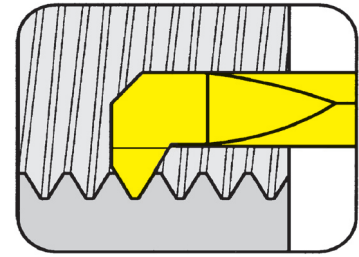


SCHNEIDPLATTE Typ

105

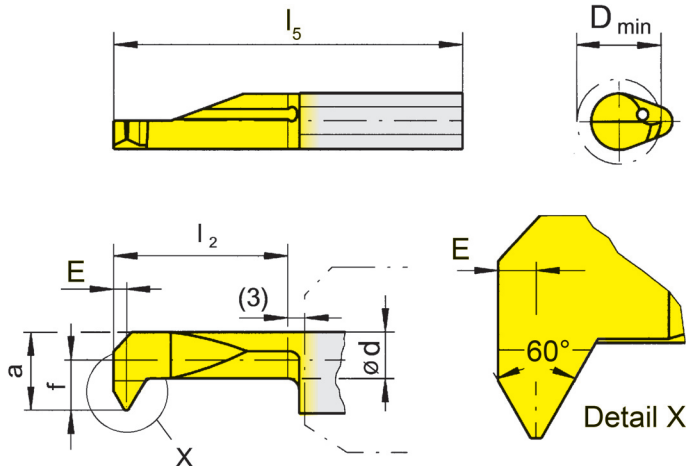
INSERT Type

Bohrungs-Ø ab Bore Ø from 3,00 mm
Steigung Pitch P 0,50 - 0,75 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | P _{max} | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | 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 | | | ▲/Δ | | |
| R/L105.0407.2.4 | 0,5 | 0,75 | 0,45 | 1,9 | 3,7 | 2,7 | 15 | 30 | 4 | | ▲/Δ | | |
| R/L105.0407.3.4 | | | | | | | 20 | 35 | | | ▲/Δ | | |
| R/L105.0407.2.5 | | | | | | | 15 | 30 | | | ▲/▲ | | ▲/Δ |
| R/L105.0407.3.5 | 0,5 | 0,75 | 0,45 | 2,3 | 4,7 | 3,5 | 20 | 35 | 5 | | ▲/Δ | | |
| R/L105.0407.4.5 | | | | | | | 25 | 40 | | | ▲/Δ | | |
| R/L105.0407.3.6 | 0,5 | 0,75 | 0,45 | 3,3 | 5,7 | 4,7 | 20 | 35 | 6 | | ▲/ | | |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

• Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | • | • | • |
| M | • | • | • |
| K | • | • | • |
| N | • | • | • |
| S | • | • | • |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

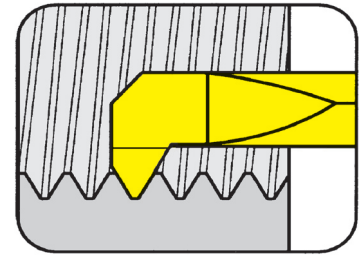


A

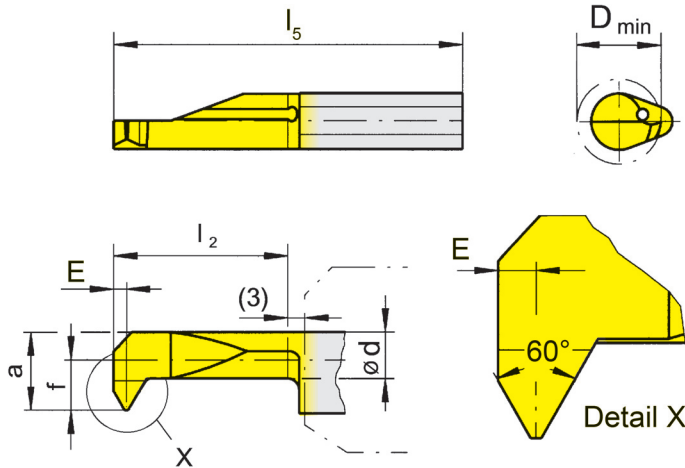
SCHNEIDPLATTE Typ

INSERT Type

105



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 4,8 mm |
| Steigung | Pitch | P 1,0 - 1,5 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | E | f | a | d | l ₂ | l ₅ | D _{min} | HM-Sorten / Carbide grades | | | |
|------------------------------|------|------|-----|-----|-----|----------------|----------------|------------------|----------------------------|------|------|------|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L105.0510.2.5 | | | | | | 15 | 30 | | ▲/▲ | ▲/▲ | | ▲/▲ |
| R/L105.0510.3.5 | 1,00 | 0,55 | 2,1 | 4,5 | 3,5 | 20 | 35 | 4,8 | ▲/▲ | ▲/▲ | | |
| R/L105.0510.4.5 | | | | | | 25 | 40 | | ▲/▲ | | | |
| R/L105.0510.2.6 | 1,00 | 0,55 | 3,3 | 5,7 | 3,7 | 15 | 30 | 6,0 | | ▲/▲ | | ▲/▲ |
| R/L105.0612.2.6 | | | | | | 15 | 30 | | ▲/▲ | ▲/▲ | | ▲/▲ |
| R/L105.0612.3.6 | 1,25 | 0,65 | 3,3 | 5,7 | 3,7 | 20 | 35 | 6,0 | | ▲/▲ | | |
| R/L105.0612.4.6 | | | | | | 25 | 40 | | ▲/▲ | | | |
| R/L105.0815.2.7 | | | | | | 15 | 30 | | | ▲/▲ | | ▲/▲ |
| R/L105.0815.3.7 | 1,50 | 0,75 | 4,0 | 6,4 | 3,7 | 20 | 35 | 7,0 | | ▲/▲ | | |
| R/L105.0815.4.7 | | | | | | 25 | 40 | | ▲/▲ | | | |

| | |
|---|----------------------|
| ▲ ab Lager / on stock | Δ 4 Wochen / 4 weeks |
| ● Haupteinsatzbereich / main recommendation | |
| ○ bedingt einsetzbar / alternative recommendation | |
| ■ unbeschichtete HM-Sorten / uncoated grades | |
| ■ beschichtete HM-Sorten / coated grades | |
| ■ bestückt/Cermet / brazed/Cermet | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Vollprofil

THREADING (internal) Full profile

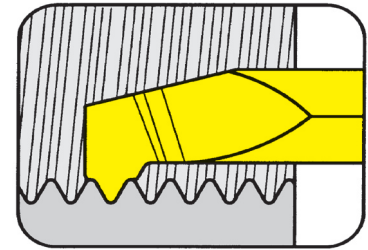


SCHNEIDPLATTE Typ

105

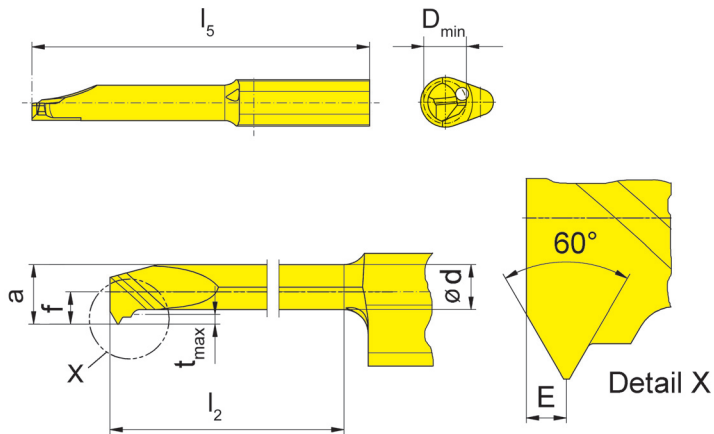
INSERT Type

Bohrungs-Ø ab Bore Ø from 2,40 mm
Steigung Pitch P 0,50 - 1,25 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | E | f | a | d | l ₂ | l ₅ | D _{min} | HM-Sorten / Carbide grades | | | | |
|--|------|-----|-----|-----|------|----------------|----------------|------------------|----------------------------|------|------|------|-----|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 | |
| R/L105.VPM3.2.3 R/L105.VPM3.4.3 | 0,50 | 0,3 | 1,4 | 2,2 | 1,65 | 9 16 | 25 35 | 2,4 | | | | ▲/Δ | ▲/Δ |
| 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 | | | | ▲/Δ | ▲/Δ |
| 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 | | | | ▲/▲ | ▲/Δ |
| 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 | | | | ▲/Δ | ▲/Δ |
| 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 | | | | ▲/▲ | ▲/Δ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation | | | | | | | | | P | | | • | |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | M | | | • | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | K | | | • | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | N | | | • | |
| | | | | | | | | | S | | | • | |
| | | | | | | | | | H | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

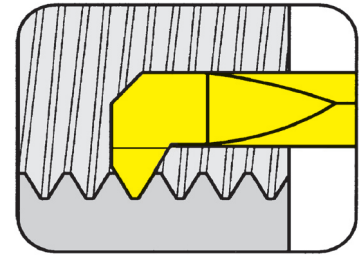


A

SCHNEIDPLATTE Typ

INSERT Type

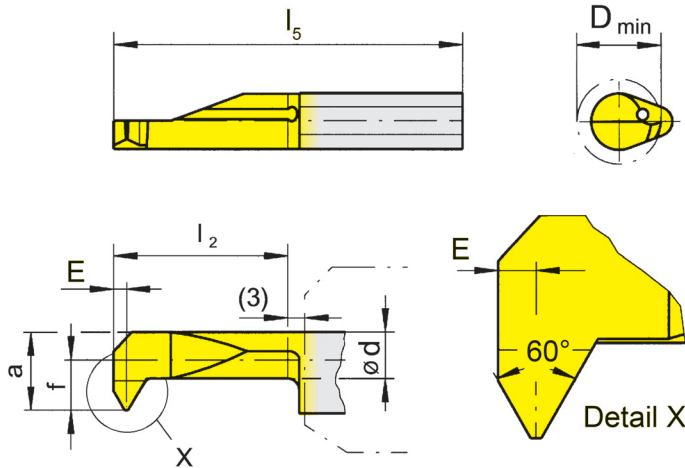
105



| | | |
|---------------|------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 4,0 mm |
| Gang pro Zoll | Threads per inch | 16 - 40 |

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Gewinde UN
Thread UN

| Bestellnummer Part number | Gang/Zoll Threads per Inch | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-------------------------------|------|-----|-----|-----|----------------|----------------|------------------|------|------|------|------|
| R/L105.3240.2.4 | 32 - 40 | 0,45 | 1,9 | 3,7 | 2,7 | 15 | 30 | 4 | | ▲/▲ | | |
| R/L105.1620.2.5 | 16 - 20 | 0,70 | 2,3 | 4,7 | 3,3 | 15 | 30 | 5 | | | | ▲/Δ |
| R/L105.1620.3.5 | | | | | | | | | | | | ▲/Δ |
| R/L105.2428.2.5 | 24 - 28 | 0,55 | 2,3 | 4,7 | 3,5 | 15 | 30 | 5 | | ▲/▲ | | |
| R/L105.3240.2.5 | 32 - 40 | 0,45 | | | | | | | ▲/Δ | | | |
| R/L105.1620.2.6 | 16 - 20 | 0,70 | 3,3 | 5,7 | 3,7 | 15 | 30 | 6 | | ▲/▲ | | |
| R/L105.1620.3.6 | | | | | | | | | 20 | 35 | ▲/ | |
| R/L105.1620.4.6 | | | | | | | | | 25 | 40 | ▲/ | |
| R/L105.2428.2.6 | 24 - 28 | 0,55 | 3,3 | 5,7 | 3,7 | 15 | 30 | 6 | | ▲/▲ | | |
| R/L105.2428.3.6 | | | | | | | | | 20 | 35 | ▲/ | |
| R/L105.2428.4.6 | | | | | | | | | 25 | 40 | ▲/▲ | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | ● | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

GEWINDEDREHEN (innen) Vollprofil

THREADING (internal) Full profile

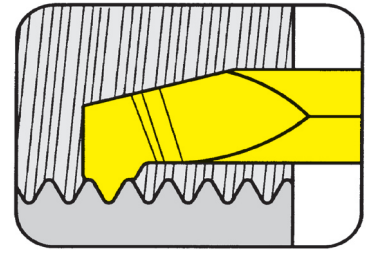


SCHNEIDPLATTE Typ

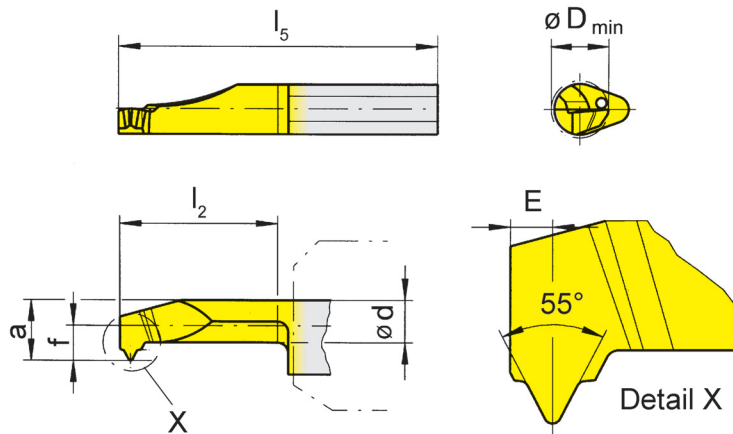
INSERT Type

105

Whitworth-Gewinde
Whitworth thread



| | | |
|---------------|------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 4,0 mm |
| Gang pro Zoll | Threads per inch | 20 - 28 |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Gewinde BSW/BSF
Thread BSW/BSF

| Bestellnummer Part number | Gang/Zoll Threads per Inch | E | f | a | d | l_2 | l_5 | D_{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-------------------------------|-----|-----|-----|-----|-------|-------|-----------|------|------|------|------|
| R105.5520.2.4 | 20 | 1,0 | 1,9 | 3,7 | 2,5 | 15 | 30 | 4 | | ▲ | | |
| R/L105.5524.2.5 | 24 | | | | | | | | | Δ/Δ | | |
| R/L105.5526.2.5 | 26 | 0,8 | 2,3 | 4,7 | 3,5 | 15 | 30 | 5 | | ▲/Δ | | |
| R/L105.5528.2.5 | 28 | | | | | | | | | ▲/Δ | | |
| | | | | | | | | | P | • | | |
| | | | | | | | | | M | • | | |
| | | | | | | | | | K | • | | |
| | | | | | | | | | N | • | | |
| | | | | | | | | | S | • | | |
| | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Vollprofil

THREADING (internal) Full profile



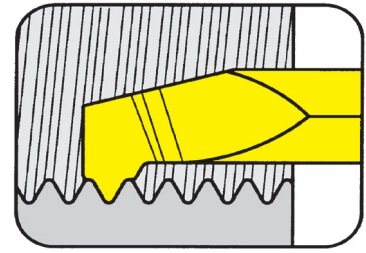
A

SCHNEIDPLATTE Typ

INSERT Type

105

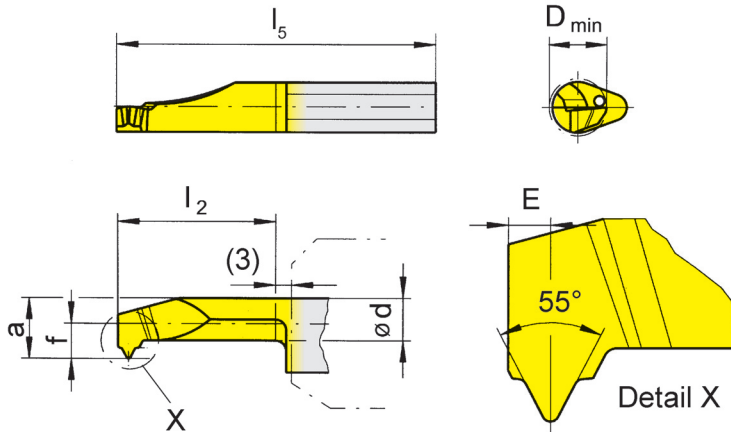
Whitworth-Gewinde
Whitworth thread



| | | |
|--------------------------------|---------------------------------|-------------------|
| Bohrungs-Ø ab Gang pro Zoll | Bore Ø from Threads per inch | 6,0 mm 19 - 28 |
|--------------------------------|---------------------------------|-------------------|

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Gewinde BSW/BSF
Thread BSW/BSF

| Bestellnummer Part number | Gang/Zoll Threads per Inch | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | TI25 | 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 | | | | | | | | ▲/Δ | | |
| 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 | | | | | | | | ▲/Δ | | |
| R/L105.5522.2.6 | 22 | 1,0 | | | | | | | | Δ/ | | |
| R/L105.5528.3.6 | 28 | 0,8 | 3,3 | 5,7 | 3,7 | 20 | 35 | 6 | | ▲/Δ | | |
| R105.5524.3.6 | 24 | 0,8 | | | | | | | | Δ | | |
| R105.5526.3.6 | 26 | 0,8 | | | | | | | | Δ | | |
| R105.5519.3.6 | 19 | 1,0 | 3,3 | 5,7 | 3,7 | 20 | 35 | 6 | | ▲ | | |
| R105.5522.3.6 | 22 | 1,0 | | | | | | | | Δ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|--|--|
| P | • | | |
| M | • | | |
| K | • | | |
| N | • | | |
| S | • | | |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

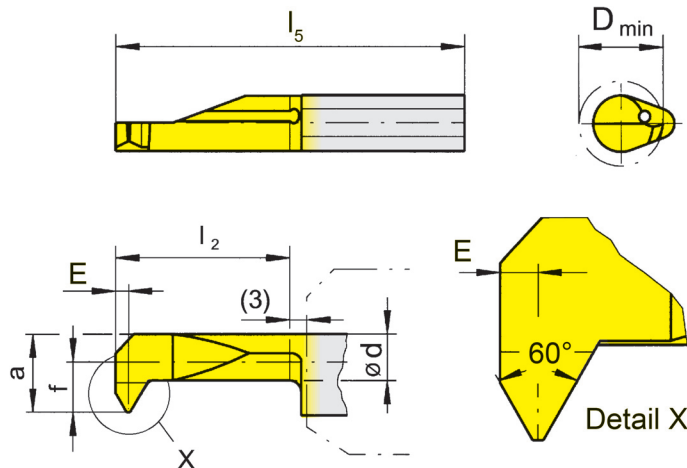
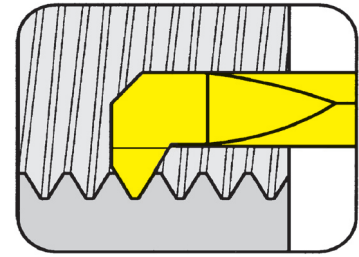


SCHNEIDPLATTE Typ

105

INSERT Type

| | | |
|---------------|------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Gang pro Zoll | Threads per inch | 18 - 27 |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Gewinde NPT / NPTF
Thread NPT / NPTF

| Bestellnummer Part number | E | f | a | d | l ₂ | l ₅ | D _{min} | HM-Sorten Carbide grades | | | |
|------------------------------|-----|-----|-----|-----|----------------|----------------|------------------|-----------------------------|------|------|------|
| | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L105.NP18.2.6 | 1,0 | | | | 15 | 30 | 6 | /Δ | ▲/▲ | | |
| R/L105.NP18.3.6 | 1,0 | | | | 20 | 35 | | | Δ/Δ | | Δ/Δ |
| R/L105.NP18.4.6 | 1,0 | | | | 25 | 40 | | | Δ/Δ | | Δ/Δ |
| R/L105.NP27.2.6 | 0,8 | 3,3 | 5,7 | 3,7 | 15 | 30 | | | ▲/Δ | /Δ | |
| R/L105.NP27.3.6 | 0,8 | | | | 20 | 35 | | | Δ/Δ | Δ/ | Δ/Δ |
| R/L105.NP27.4.6 | 0,8 | | | | 25 | 40 | | | Δ/Δ | | Δ/Δ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

| | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| MG12 | o | • | • | • | • | • |
| TN35 | • | • | • | • | • | • |
| TI25 | • | • | • | • | • | • |
| TH35 | • | • | • | • | • | • |

HM-Sorten
Carbide grades

VORSTECHEN und FASEN (innen)

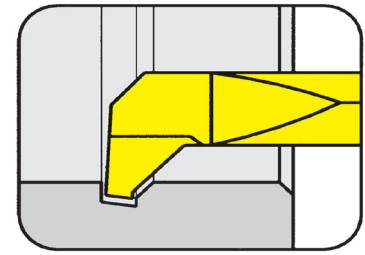
PREGROOVING and CHAMFERING (internal)



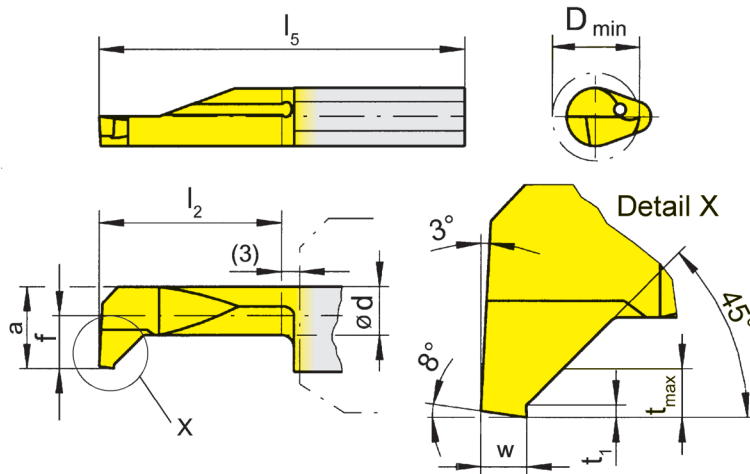
A

SCHNEIDPLATTE Typ INSERT Type

105



Bohrungs-Ø ab Bore Ø from 3,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
 H105
 HC105
 VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t ₁ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | | ▲/▲ ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

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

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

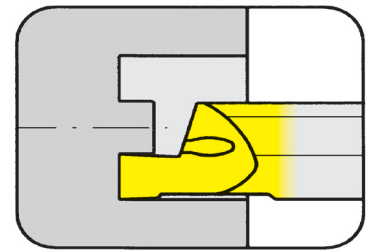
AXIALEINSTECHEN

FACE GROOVING

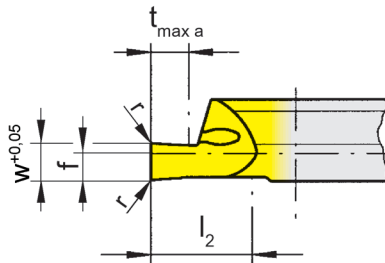
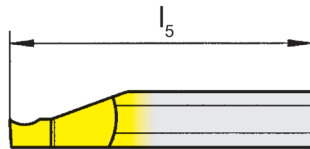
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|-----------------|-----------------------|--------|
| Nutaußen-Ø ab | from outer groove Ø | 5,0 mm |
| Stechtiefe | Depth of groove | 5,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | f | l ₂ | l ₅ | t _{max a} | D _{a min} | HM-Sorten / Carbide grades | | | |
|------------------------------|-----|------|---|----------------|----------------|--------------------|--------------------|----------------------------|------|------|------|
| | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L105.0510.1.8 | 1,0 | | | | | 2 | | ▲/▲ | | ▲/▲ | |
| R/L105.0515.1.8 | 1,5 | 0,05 | 2 | 10 | 25 | 3 | 5 | ▲/▲ | | ▲/▲ | |
| R/L105.0520.1.8 | 2,0 | | | | | 5 | | ▲/▲ | | ▲/▲ | |
| R/L105.0510.2.8 | 1,0 | | | | | 2 | | △/△ | | ▲/▲ | |
| R/L105.0515.2.8 | 1,5 | 0,05 | 2 | 15 | 35 | 3 | 5 | △/△ | | ▲/▲ | |
| R/L105.0520.2.8 | 2,0 | | | | | 5 | | △/△ | | ▲/▲ | |

▲ ab Lager / on stock △ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

○ bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

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

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

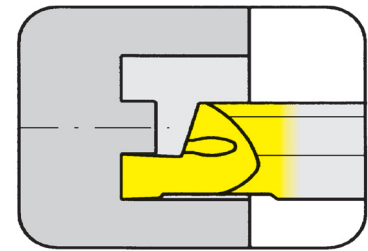
Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

AXIALEINSTECHEN FACE GROOVING

SCHNEIDPLATTE Typ INSERT Type

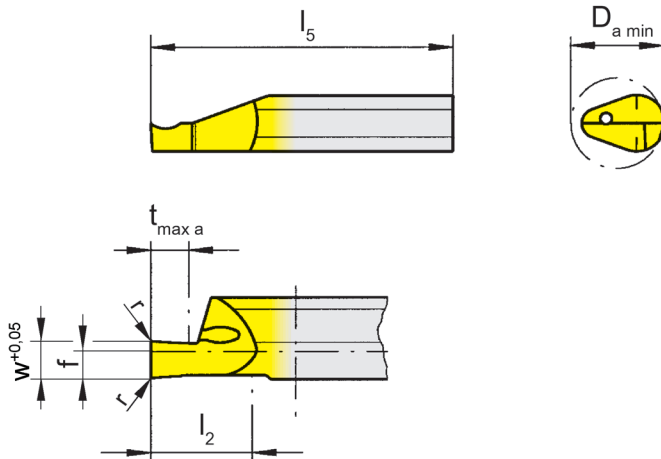
105



| | | |
|-----------------|-----------------------|--------|
| Nutaußen-Ø ab | from outer groove Ø | 6,0 mm |
| Stechtiefe | Depth of groove | 5,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | f | l ₂ | l ₅ | t _{max a} | D _{a min} | Material | | | |
|------------------------------|-----|------|---|----------------|----------------|--------------------|--------------------|----------|------|------|------|
| | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L105.0610.1.8 | 1,0 | | | | | 2 | | ▲/▲ | | ▲/▲ | |
| R/L105.0615.1.8 | 1,5 | 0,05 | 2 | 10 | 25 | 3 | 6 | ▲/▲ | | ▲/▲ | |
| R/L105.0620.1.8 | 2,0 | | | | | 5 | | ▲/▲ | | ▲/▲ | |
| R/L105.0610.2.8 | 1,0 | | | | | 2 | | △/△ | | ▲/△ | |
| R/L105.0615.2.8 | 1,5 | 0,05 | 2 | 15 | 35 | 3 | 6 | ▲/ | | ▲/△ | |
| R/L105.0620.2.8 | 2,0 | | | | | 5 | | ▲/△ | | ▲/▲ | |

- ▲ ab Lager / on stock △ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | o | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

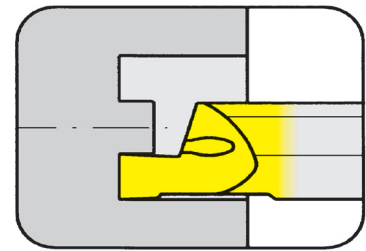
AXIALEINSTECHEN

FACE GROOVING

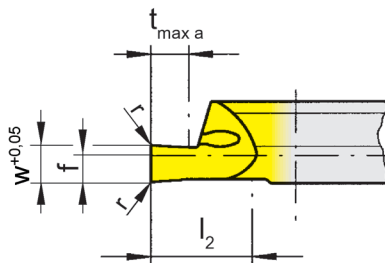
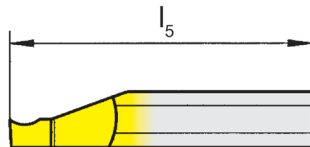
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|-----------------|-----------------------|--------|
| Nutaußen-Ø ab | from outer groove Ø | 8,0 mm |
| Stechtiefe | Depth of groove | 6,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Klemhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | f | l ₂ | l ₅ | t _{max a} | D _{a min} | | MG12 | TN35 | TI25 | TH35 |
|---|-----|------|---|----------------|----------------|--------------------|--------------------|--|------|------|------|------|
| R/L105.0810.1.8 | 1,0 | | | | | 2 | | | | | ▲/▲ | |
| R/L105.0815.1.8 | 1,5 | | | | | 3 | | | | | ▲/▲ | |
| R/L105.0820.1.8 | 2,0 | 0,15 | 2 | 10 | 25 | 4 | 8 | | | | ▲/▲ | |
| R/L105.0825.1.8 | 2,5 | | | | | 5 | | | | | ▲/▲ | |
| R/L105.0830.1.8 | 3,0 | | | | | 6 | | | | | ▲/▲ | |
| R/L105.0810.2.8 | 1,0 | | | | | 2 | | | | | ▲/▲ | |
| R/L105.0815.2.8 | 1,5 | | | | | 3 | | | | | ▲/▲ | |
| R/L105.0820.2.8 | 2,0 | 0,15 | 2 | 15 | 35 | 4 | 8 | | | | ▲/▲ | |
| R/L105.0825.2.8 | 2,5 | | | | | 5 | | | | | ▲/▲ | |
| R/L105.0830.2.8 | 3,0 | | | | | 6 | | | | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | • | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | • | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | • | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | • | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | • | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

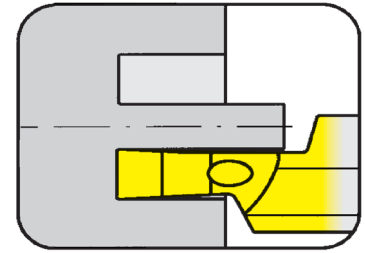
AXIALEINSTECHEN FACE GROOVING



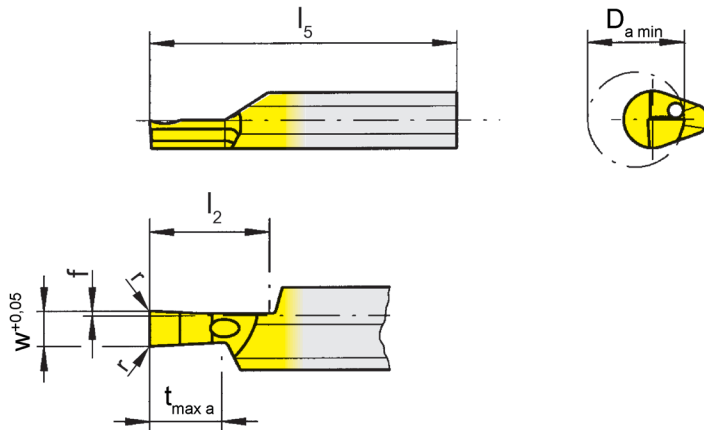
A

SCHNEIDPLATTE Typ INSERT Type

105



| | | |
|-----------------|-----------------------|--------|
| Nutaußen-Ø ab | from outer groove Ø | 8,0 mm |
| Stechtiefe | Depth of groove | 6,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | f | l ₂ | l ₅ | t _{max a} | D _{a min} | MG12 | TN35 | TI25 | TH35 |
|---|-----|------|-----|----------------|----------------|--------------------|--------------------|------|------|------|------|
| R/L105.0810.1.9 | 1,0 | | | | | 2 | | | | ▲/▲ | |
| R/L105.0815.1.9 | 1,5 | | | | | 3 | | | | ▲/▲ | |
| R/L105.0820.1.9 | 2,0 | 0,15 | 0,4 | 10 | 25 | 4 | 8 | | | ▲/▲ | |
| R/L105.0825.1.9 | 2,5 | | | | | 5 | | | | ▲/▲ | |
| R/L105.0830.1.9 | 3,0 | | | | | 6 | | | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | P | | • | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | | • | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | | • | |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | | • | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | S | | • | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

AXIALEINSTECHEN

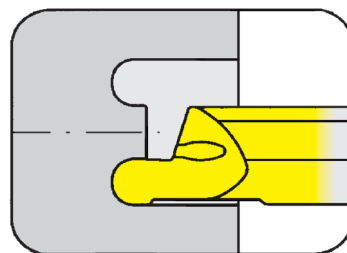
FACE GROOVING



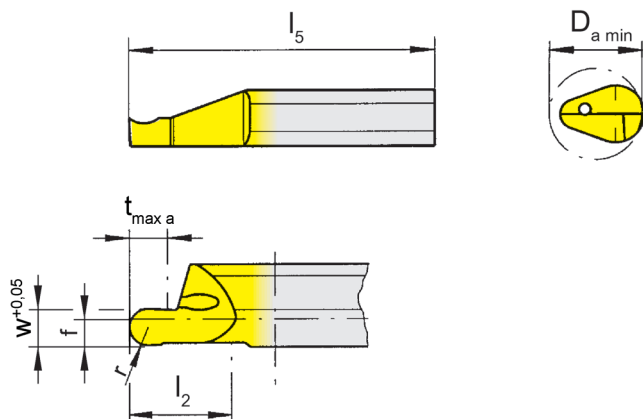
SCHNEIDPLATTE Typ

105

INSERT Type



| | | |
|-----------------|-----------------------|--------|
| Nutaußen-Ø ab | from outer groove Ø | 8,0 mm |
| Stechtiefe | Depth of groove | 6,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Vollradius
Full radius

| Bestellnummer Part number | w | r | f | l ₂ | l ₅ | t _{max a} | D _{a min} | | MG12 | TN35 | TI25 | TH35 |
|---|-----|------|---|----------------|----------------|--------------------|--------------------|--|------|------|------|------|
| R/L105.8V10.1.8 | 1,0 | 0,50 | | | | 2 | | | | | ▲/▲ | |
| R/L105.8V16.1.8 | 1,6 | 0,80 | | | | 3 | | | | | ▲/▲ | |
| R/L105.8V20.1.8 | 2,0 | 1,00 | 2 | 10 | 25 | 4 | 8 | | | | ▲/▲ | |
| R/L105.8V25.1.8 | 2,5 | 1,25 | | | | 5 | | | | | ▲/▲ | |
| R/L105.8V30.1.8 | 3,0 | 1,50 | | | | 6 | | | | | ▲/▲ | |
| R/L105.8V10.2.8 | 1,0 | 0,50 | | | | 2 | | | | | ▲/▲ | |
| R/L105.8V16.2.8 | 1,6 | 0,80 | | | | 3 | | | | | ▲/▲ | |
| R/L105.8V20.2.8 | 2,0 | 1,00 | 2 | 15 | 35 | 4 | 8 | | | | ▲/▲ | |
| R/L105.8V25.2.8 | 2,5 | 1,25 | | | | 5 | | | | | ▲/▲ | |
| R/L105.8V30.2.8 | 3,0 | 1,50 | | | | 6 | | | | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | • | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | • | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | • | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | • | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | • | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

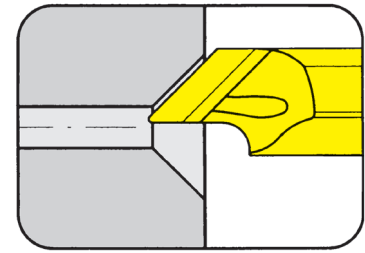
Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

SCHNEIDPLATTE Typ INSERT Type

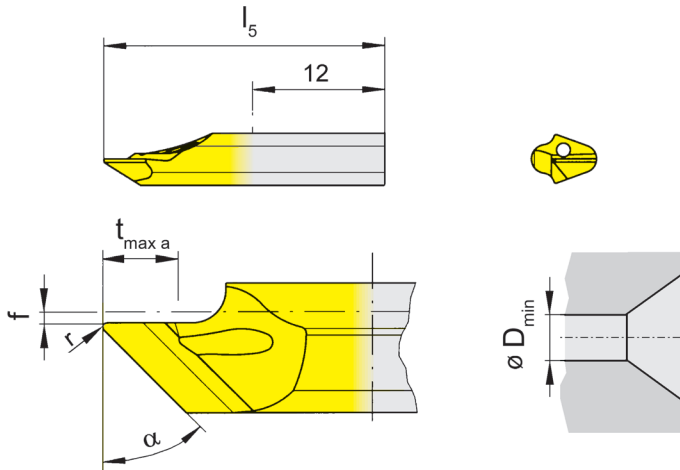
105



| | | |
|-----------------|------------------------|----------|
| Faswinkel | Angle of chamfer | 45°/ 60° |
| Fasenbreite bis | Width of chamfer up to | 4,0 mm |

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | ▲/▲ | ▲/▲ |
| | | | | | | | P | • | | • | |
| | | | | | | | M | • | | • | |
| | | | | | | | K | • | | • | |
| | | | | | | | N | • | | • | |
| | | | | | | | S | • | | • | |
| | | | | | | | H | | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

RÜCKWÄRTSDREHEN (innen)

BACKBORING (internal)



SCHNEIDPLATTE Typ

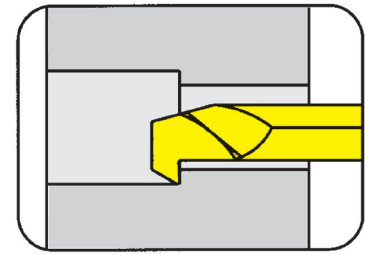
105

INSERT Type

Bohrungs-Ø ab

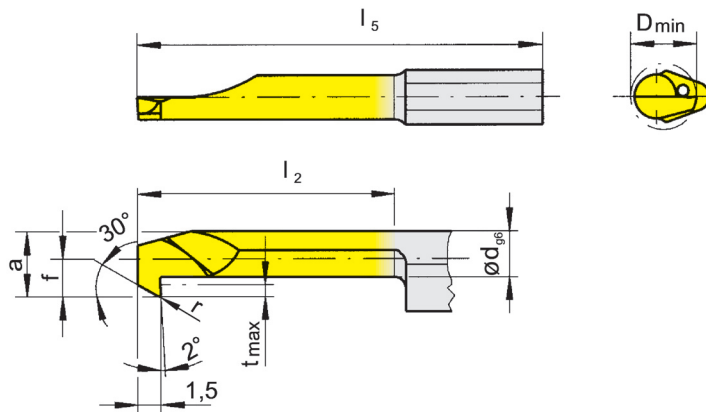
Bore Ø from

3,0 mm



für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
H105
HC105
VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | 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 | | | ▲/▲ ▲/▲ | |
| 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 | | | ▲/▲ ▲/▲ | |
| 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 | | | ▲/▲ ▲/▲ | |
| 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 | | | ▲/▲ ▲/▲ | |
| 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 | | | ▲/▲ ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | • | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | • | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | • | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | • | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | • | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

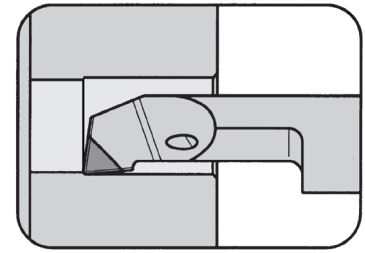
Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

SCHNEIDPLATTE Typ

INSERT Type

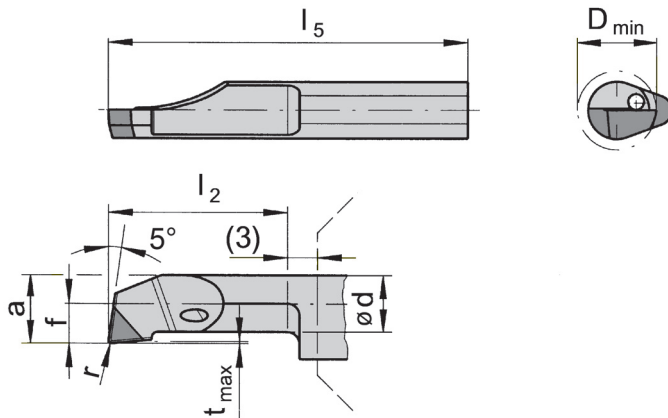
105



Bohrungs-Ø ab Bore Ø from 3,0 mm

für Klemmhalter
for use with Toolholder

Typ B105
Type BKT105
 H105
 HC105
 VDI



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

CBN-bestückt
PCBN tipped

| Bestellnummer 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 |
| R105.0540.2.7.B | 4,0 | 6,4 | 6,0 | 15 | 30 | 0,15 | 6,8 | 0,20 | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| |
|---|
| P |
| M |
| K |
| N |
| S |
| H |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

KLEMMHALTER Typ

TOOLHOLDER Type

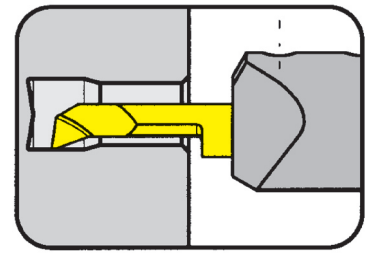
B105

mit innerer Kühlmittelzufuhr
with through coolant supply

Bohrungs-Ø ab

Bore Ø from

5,0 mm



für Schneidplatte
for use with Insert

Typ 105...2
Type

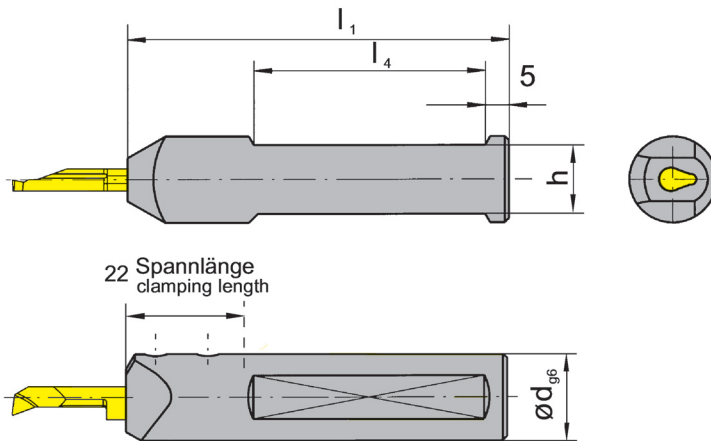


Abbildung = rechtsschneidend
Picture = right hand cutting version

nur für Schneidplatten mit
verlängertem Spannschaft
only usable for inserts with
extended clamping length

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.00... | 6.075T15P | T15PQ |

EINSTECHEN (innen)

GROOVING (internal)

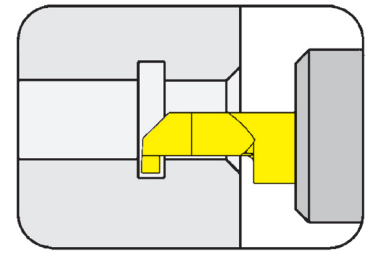


A

KLEMMHALTER Typ
TOOLHOLDER Type

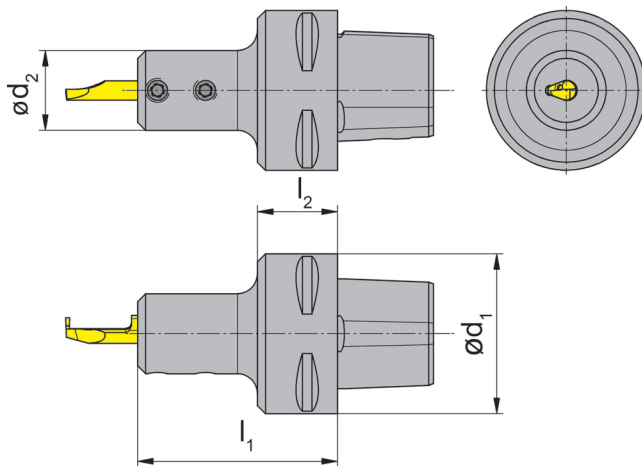
B105C

mit innerer Kühlmittelzufuhr
with through coolant supply



HORN-Polygonschaft nach ISO 26623
HORN Polygon shank according ISO 26623

Spannlänge 22 mm
Clamping length 22 mm



für Schneidplatte
for use with Insert

Typ 105...2
Type

L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

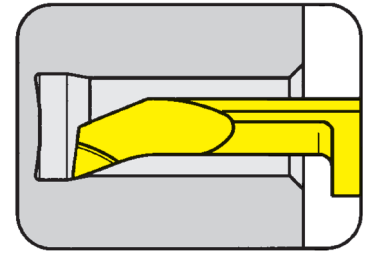
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LB105.00C... | 6.075T15P | T15PQ |

SCHNEIDPLATTE Typ

INSERT Type

105

mit verlängertem Spannschaft
with extended clamping shank

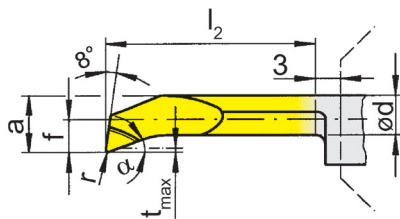
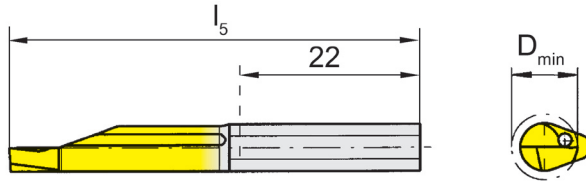


Bohrungs-Ø ab

Bore Ø from

5,0 mm

Spannlänge 22 mm
Clamping length 22 mm



für Klemmhalter
for use with Toolholder

Typ B105.0012.02
Type B105.0016.02
B105.0020.02
B105.0022.02

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|----------------|----------------|------------------|------------------|-----|------|------|------|------|
| R/L105.1823.4.5.2 | 2,3 | 4,7 | 4,2 | 25 | 50 | 0,3 | 5,0 | 0,1 | | | ▲/Δ | ▲/▲ |
| 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 | | | ▲/▲ | ▲/Δ |
| 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 | | | ▲/▲ | ▲/Δ |
| R/L105.1840.5.7.2 | | | | | | | | | | | ▲/▲ | ▲/Δ |
| 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 | | | ▲/Δ | ▲/Δ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|---|---|
| P | | | ● | ● |
| M | | | ● | ● |
| K | | | ● | ● |
| N | | | ● | ● |
| S | | | ● | ● |
| H | | | | |

Abmessungen in mm
Dimensions in mm

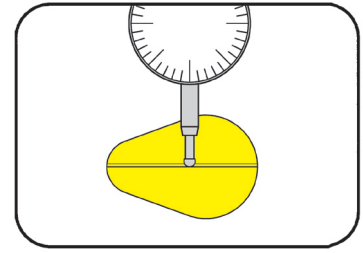
Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

PLATTE Typ
INSERT Type

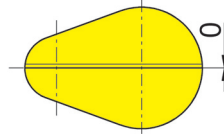
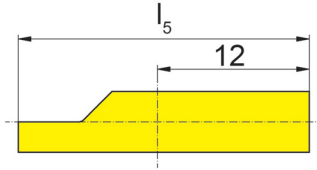
105



Platte zum Einrichten des Werkzeugs
Insert for tool set up

für Klemmhalter
for use with Toolholder

Typ B105
Type



R = rechts wie gezeichnet
R = right hand version shown

| Bestellnummer Part number | l_5 |
|------------------------------|-------|
| R105.LEHR.H.01 | 23 |

Abmessungen in mm
Dimensions in mm

AXIALEINSTECHEN

FACE GROOVING



KLEMMHALTER Typ

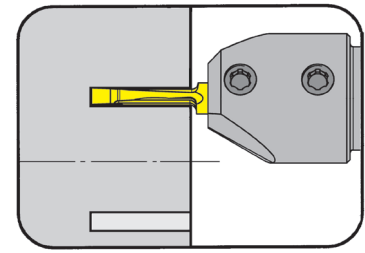
TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply

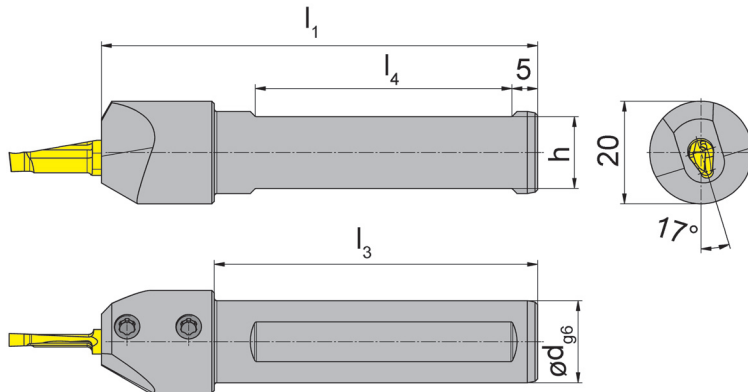
| | | |
|---------------|---------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 10,0 mm |
| Stechtiefe | Depth of groove | 15,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

Verlängerte Aufnahme der Platte
Extended depth of insert seat



für Schneidplatte
for use with Insert

Typ A105
Type



L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB105.00... | 6.075T15P | T15PQ |

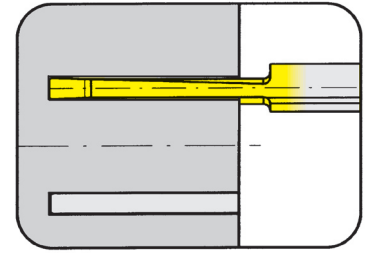
AXIALEINSTECHEN FACE GROOVING



A

SCHNEIDPLATTE Typ INSERT Type

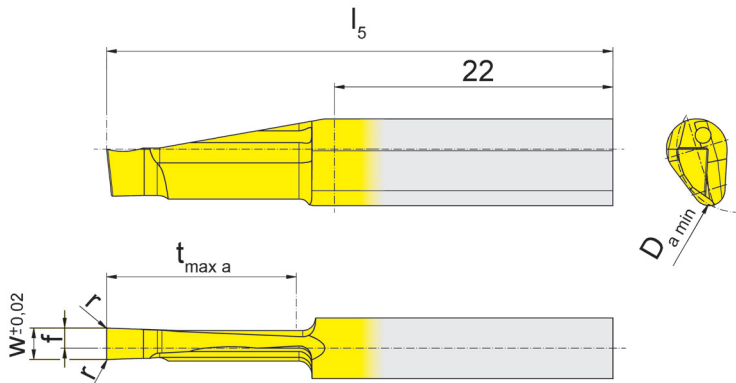
A105



| | | |
|---------------|---------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 10,0 mm |
| Stechtiefe | Depth of groove | 15,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B105...12.2
Type



L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer Part number | w | r | f | l ₅ | t _{max a} | D _{a min} | HM-Sorten | | | |
|------------------------------|-----|-----|-----|----------------|--------------------|--------------------|-----------|------|------|------|
| | | | | | | | 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 | | | | | ▲/▲ | | |
| | | | | | | | P | | • | |
| | | | | | | | M | | • | |
| | | | | | | | K | | • | |
| | | | | | | | N | | • | |
| | | | | | | | S | | • | |
| | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Schneidplatte RA105 in Klemmhalter RB105 und
Schneidplatte LA105 in Klemmhalter LB105 verwenden

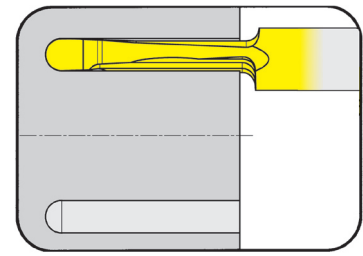
Note:
Use insert RA105 in toolholder RB105
Use insert LA105 in toolholder LB105

Axialstechen ins Volle bei voller Stechtiefe nur bei D_{amin} 10 - 40 mm möglich!
Face grooving with full width of the full depth only possible between D_{amin} 10 - 40 mm!

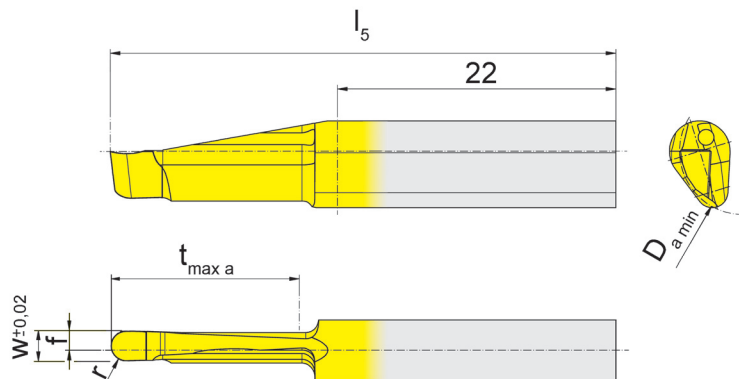
SCHNEIDPLATTE Typ

A105

INSERT Type



| | | |
|---------------|---------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 10,0 mm |
| Stechtiefe | Depth of groove | 15,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B105...12.2
Type

L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

Vollradius
Full radius

| Bestellnummer Part number | w | r | f | l ₅ | t _{max a} | D _{a min} | MG12 | TN35 | TI25 | TH35 |
|---|-----|------|-----|----------------|--------------------|--------------------|------|------|------|------|
| R/LA105.1020.10.2.2 | 2,0 | 1,00 | 1,4 | | | | | | ▲/▲ | |
| R/LA105.1025.12.2.2 | 2,5 | 1,25 | 1,6 | 40 | 15 | 10 | | | ▲/▲ | |
| R/LA105.1030.15.2.2 | 3,0 | 1,50 | 1,9 | | | | | | ▲/▲ | |
| ▲ ab Lager / on stock | | | | | | | | | ● | |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | ● | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | ● | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | ● | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | ● | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | ● | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Schneidplatte RA105 in Klemmhalter RB105 und
Schneidplatte LA105 in Klemmhalter LB105 verwenden

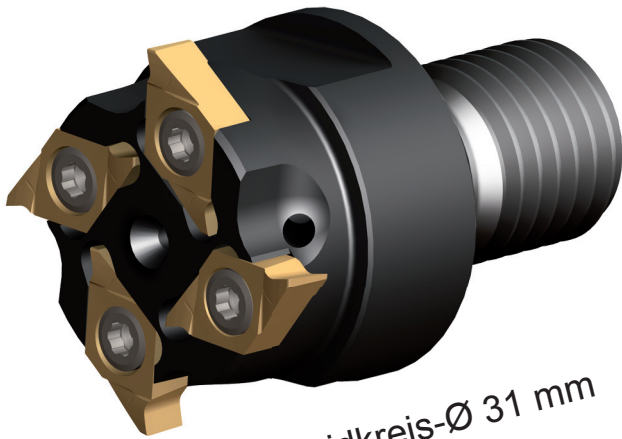
Note:

Use insert RA105 in toolholder RB105
Use insert LA105 in toolholder LB105

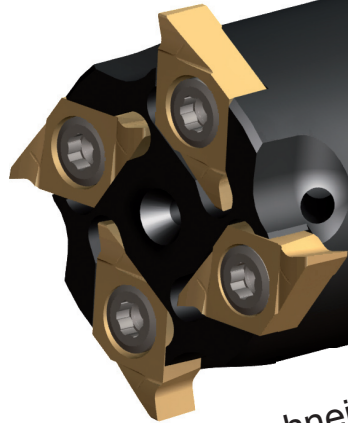
Axialstechen ins Volle bei voller Stechtiefe nur bei D_{amin} 10 - 40 mm möglich!
Face grooving with full width of the full depth only possible between D_{amin} 10 - 40 mm!

NUTFRÄSEN System 275

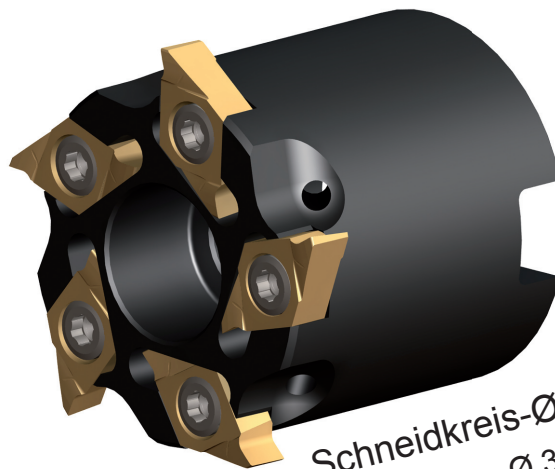
GROOVE MILLING System 275



Schneidkreis-Ø 31 mm
Cutting edge Ø 31 mm



Schneidkreis-Ø 31 mm
Cutting edge Ø 31 mm



Schneidkreis-Ø 38 mm
Cutting edge Ø 38 mm

Weitere Informationen finden Sie in unserem HORN-Katalog "ROTIERENDE WERKZEUGE"
For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

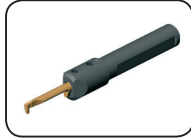
| | | | | | | | | | | | | |
|-------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|---|---|---|---|---|---|---|---|---|---|---|---|

Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

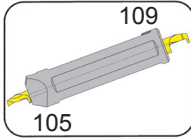
Supermini® HM-SCHNEIDWERKZEUGE **Typ 109**
Supermini® CARBIDE GROOVING TOOLS type

B109
Klemmhalter
Toolholder



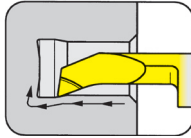
Seite/Page
B2-B3

B105
Klemmhalter
Toolholder

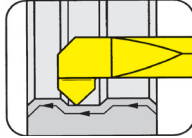


Seite/Page
B4

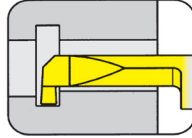
109
≥ Ø 6,0 mm
Schneidplatten
Inserts



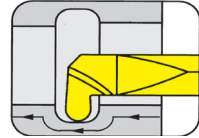
Seite/Page
B5-B8



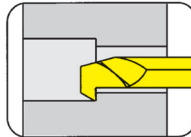
Seite/Page
B9



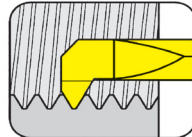
Seite/Page
B10-B11



Seite/Page
B12



Seite/Page
B13



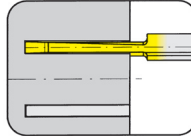
Seite/Page
B14-B15

B109
Axialeinstechen
Face Grooving
Klemmhalter
Toolholder



Seite/Page
B16

A109
Axialeinstechen
Face Grooving
Schneidplatten
Inserts



Seite/Page
B17

Technische Hinweise **Seite**
Technical Instructions Page **N2-N8**

EINSTECHEN und AUSDREHEN

GROOVING and BORING



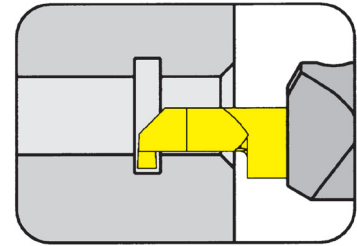
B

KLEMMHALTER Typ

TOOLHOLDER Type

B109

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

für Schneidplatte
for use with Insert

Typ 109
Type

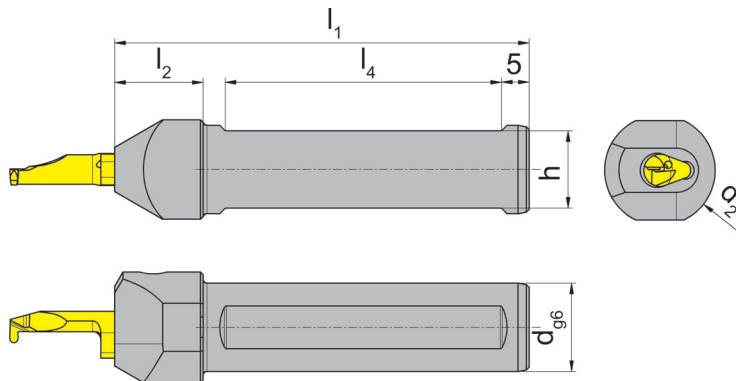


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | l ₂ | h | d ₂ | l ₄ |
|------------------------------|----|----------------|----------------|----|----------------|----------------|
| B109.0012.01 | 12 | 75 | 16 | 10 | 20 | 50 |
| B109.0016.01 | 16 | 75 | 16 | 14 | 20 | 50 |
| B109.0020.01 | 20 | 90 | - | 18 | 20 | 55 |
| B109.0025.01 | 25 | 100 | - | 23 | 25 | 55 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B109.00... | 6.075T15P | T15PQ |

EINSTECHEN und AUSDREHEN

GROOVING and BORING



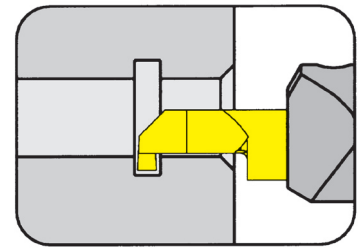
B

KLEMMHALTER Typ

TOOLHOLDER Type

B109

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

für Schneidplatte
for use with Insert

Typ 109
Type

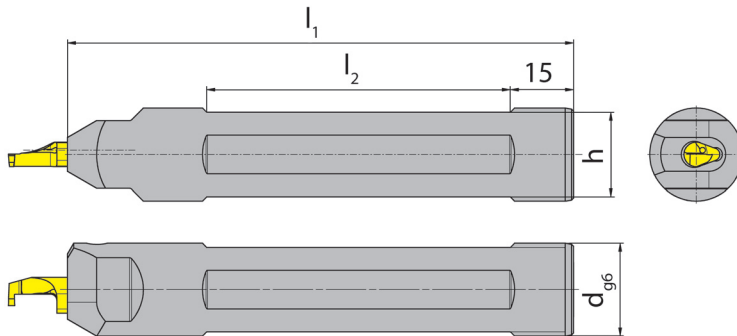


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | l ₂ | h |
|------------------------------|----|----------------|----------------|----|
| B109.0022.1.2.01 | 22 | 120 | 72 | 20 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B109.0022.1.2.01 | 6.075T15P | T15PQ |

EINSTECHEN und AUSDREHEN

GROOVING and BORING



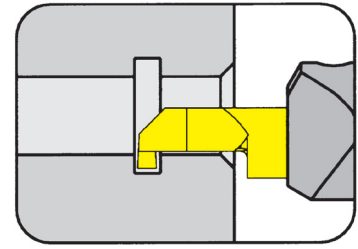
B

KLEMMHALTER Typ

TOOLHOLDER Type

B105

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|---------------|-----------------|------------|
| Bohrungs-Ø ab | Bore Ø from | 0,2/6,0 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite | Width of groove | 2,0 mm |

für Schneidplatte
for use with Insert

Typ 105
Type 109

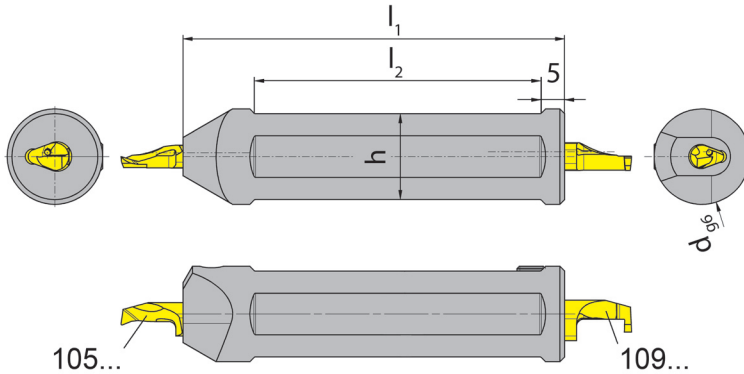


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | l ₂ | h |
|------------------------------|----|----------------|----------------|----|
| B105.0020.1.09 | 20 | 80 | 60 | 18 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B105.0020.1.09 | 6.075T15P | T15PQ |

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

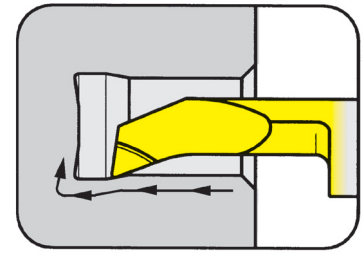
BORING and PROFILING



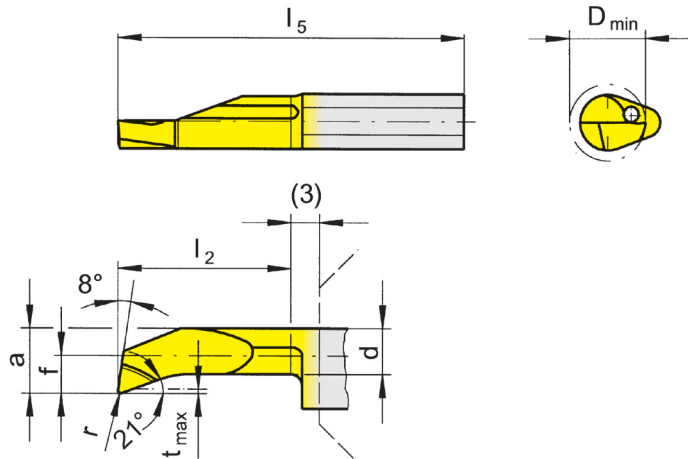
B

SCHNEIDPLATTE Typ INSERT Type

109



Bohrungs- \varnothing ab Bore \varnothing from 6,0 mm



für Klemmhalter
for use with Toolholder

Typ B109
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|---|-------|-------|-----------|-----------|-----|------|------|------|------|
| R/L109.1828.1.6 | | | | 10 | 28 | | | | | | | Δ/Δ |
| R/L109.1828.2.6 | | | | 15 | 33 | | | | | | | Δ/Δ |
| R/L109.1828.3.6 | | | | 20 | 38 | | | | | | | Δ/Δ |
| R/L109.1828.4.6 | 2,8 | 5,7 | 5 | 25 | 43 | 0,4 | 6 | 0,2 | | | | Δ/Δ |
| R/L109.1828.5.6 | | | | 30 | 48 | | | | | | | ▲/▲ |
| R/L109.1828.6.6 | | | | 35 | 53 | | | | | | | ▲/▲ |
| R/L109.1828.7.6 | | | | 40 | 58 | | | | | | | ▲/▲ |
| R/L109.1838.2.7 | | | | 15 | 33 | | | | | | | Δ/Δ |
| R/L109.1838.3.7 | | | | 20 | 38 | | | | | | | Δ/Δ |
| R/L109.1838.4.7 | | | | 25 | 43 | | | | | | | Δ/Δ |
| R/L109.1838.5.7 | 3,8 | 6,7 | 6 | 30 | 48 | 0,4 | 7 | 0,2 | | | | ▲/▲ |
| R/L109.1838.6.7 | | | | 35 | 53 | | | | | | | ▲/▲ |
| R/L109.1838.7.7 | | | | 40 | 58 | | | | | | | ▲/▲ |
| R/L109.1838.8.7 | | | | 45 | 63 | | | | | | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | ● |
| M | | | ● |
| K | | | ● |
| N | | | ● |
| S | | | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

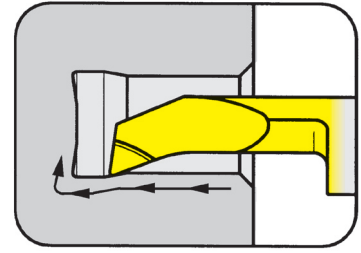
BORING and PROFILING



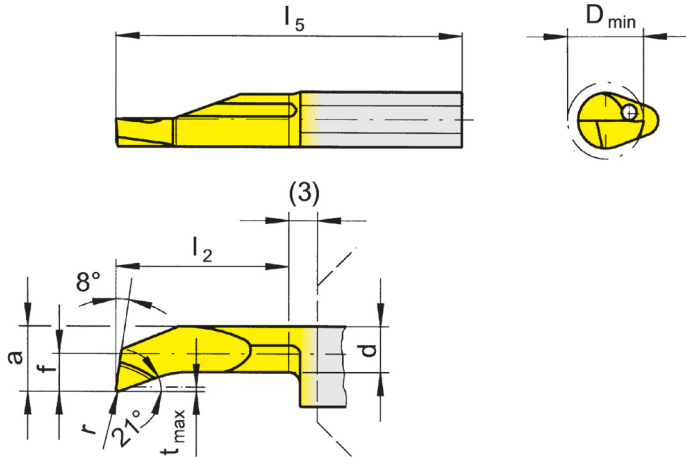
B

SCHNEIDPLATTE Typ
INSERT Type

109



| | | |
|----------------------------|-------------------------|--------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 6,0 mm |
|----------------------------|-------------------------|--------|



für Klemmhalter
for use with Toolholder

Typ B109
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|---|-------|-------|-----------|-----------|-----|------|------|------|------|
| R/L109.1828.04.1.6 | | | | 10 | 28 | | | | | | | Δ/Δ |
| R/L109.1828.04.2.6 | | | | 15 | 33 | | | | | | | Δ/Δ |
| R/L109.1828.04.3.6 | | | | 20 | 38 | | | | | | | Δ/Δ |
| R/L109.1828.04.4.6 | 2,8 | 5,7 | 5 | 25 | 43 | 0,4 | 6 | 0,4 | | | | Δ/Δ |
| R/L109.1828.04.5.6 | | | | 30 | 48 | | | | | | | ▲/▲ |
| R/L109.1828.04.6.6 | | | | 35 | 53 | | | | | | | ▲/▲ |
| R/L109.1828.04.7.6 | | | | 40 | 58 | | | | | | | ▲/▲ |
| R/L109.1838.04.2.7 | | | | 15 | 33 | | | | | | | Δ/Δ |
| R/L109.1838.04.3.7 | | | | 20 | 38 | | | | | | | Δ/Δ |
| R/L109.1838.04.4.7 | | | | 25 | 43 | | | | | | | Δ/Δ |
| R/L109.1838.04.5.7 | 3,8 | 6,7 | 6 | 30 | 48 | 0,4 | 7 | 0,4 | | | | ▲/▲ |
| R/L109.1838.04.6.7 | | | | 35 | 53 | | | | | | | ▲/▲ |
| R/L109.1838.04.7.7 | | | | 40 | 58 | | | | | | | ▲/▲ |
| R/L109.1838.04.8.7 | | | | 45 | 63 | | | | | | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | • |
| M | | | • |
| K | | | • |
| N | | | • |
| S | | | • |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

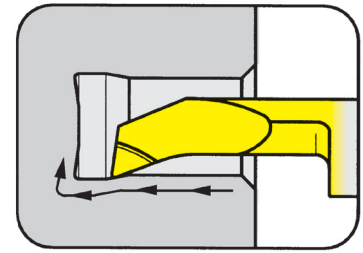
BORING and PROFILING



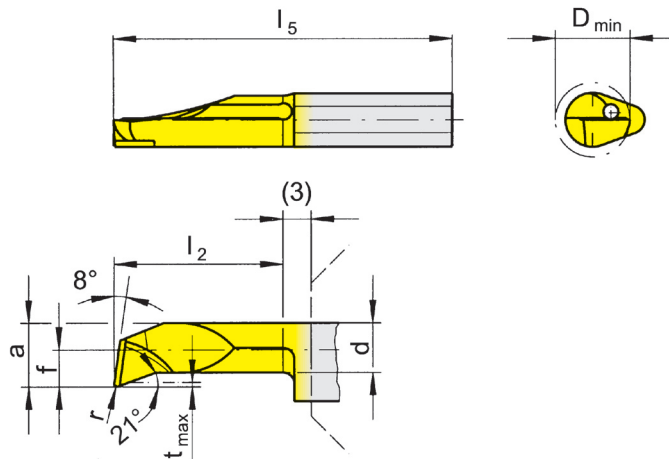
B

SCHNEIDPLATTE Typ INSERT Type

109



Bohrungs- \varnothing ab Bore \varnothing from 6,0 mm



für Klemmhalter
for use with Toolholder

Typ B109
Type

verlängerte Spantrenne
(Geometrie HV)
extended chip breaker
(geometry HV)

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|---|-------|-------|-----------|-----------|-----|--|------|------|------|------|
| R/L109.1828.1.HV6 | | | | 10 | 28 | | | | | | | | Δ/Δ |
| R/L109.1828.2.HV6 | | | | 15 | 33 | | | | | | | | Δ/Δ |
| R/L109.1828.3.HV6 | | | | 20 | 38 | | | | | | | | Δ/Δ |
| R/L109.1828.4.HV6 | 2,8 | 5,7 | 5 | 25 | 43 | 0,4 | 6 | 0,2 | | | | | Δ/Δ |
| R/L109.1828.5.HV6 | | | | 30 | 48 | | | | | | | | ▲/▲ |
| R/L109.1828.6.HV6 | | | | 35 | 53 | | | | | | | | ▲/▲ |
| R/L109.1828.7.HV6 | | | | 40 | 58 | | | | | | | | ▲/▲ |
| R/L109.1838.2.HV7 | | | | 15 | 33 | | | | | | | | Δ/Δ |
| R/L109.1838.3.HV7 | | | | 20 | 38 | | | | | | | | Δ/Δ |
| R/L109.1838.4.HV7 | | | | 25 | 43 | | | | | | | | Δ/Δ |
| R/L109.1838.5.HV7 | 3,8 | 6,7 | 6 | 30 | 48 | 0,4 | 7 | 0,2 | | | | | ▲/▲ |
| R/L109.1838.6.HV7 | | | | 35 | 53 | | | | | | | | ▲/▲ |
| R/L109.1838.7.HV7 | | | | 40 | 58 | | | | | | | | ▲/▲ |
| R/L109.1838.8.HV7 | | | | 45 | 63 | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

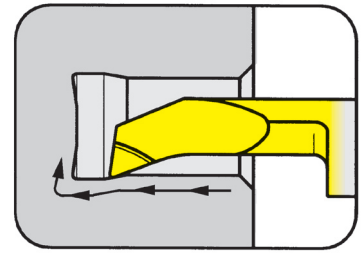
BORING and PROFILING



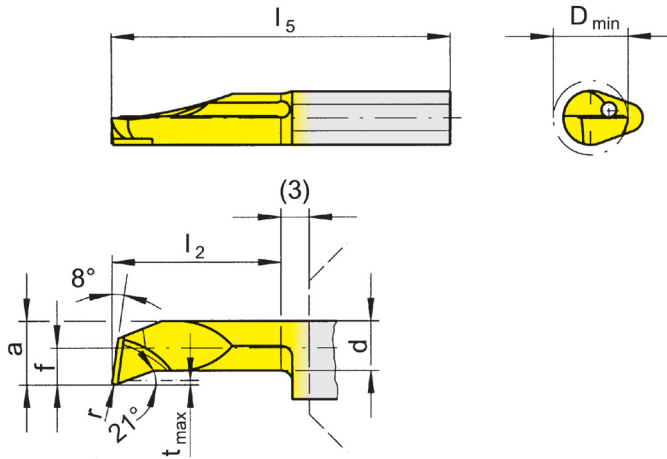
B

SCHNEIDPLATTE Typ
INSERT Type

109



| | | |
|----------------------------|-------------------------|--------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 6,0 mm |
|----------------------------|-------------------------|--------|



für Klemmhalter
for use with Toolholder

Typ B109
Type

verlängerte Spantrenne
(Geometrie HV)
extended chip breaker
(geometry HV)

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|---|-------|-------|-----------|-----------|-----|--|------|------|------|------|
| R/L109.1828.04.1.HV6 | | | | 10 | 28 | | | | | | | | Δ/Δ |
| R/L109.1828.04.2.HV6 | | | | 15 | 33 | | | | | | | | Δ/Δ |
| R/L109.1828.04.3.HV6 | | | | 20 | 38 | | | | | | | | Δ/Δ |
| R/L109.1828.04.4.HV6 | 2,8 | 5,7 | 5 | 25 | 43 | 0,4 | 6 | 0,4 | | | | | Δ/Δ |
| R/L109.1828.04.5.HV6 | | | | 30 | 48 | | | | | | | | ▲/▲ |
| R/L109.1828.04.6.HV6 | | | | 35 | 53 | | | | | | | | ▲/▲ |
| R/L109.1828.04.7.HV6 | | | | 40 | 58 | | | | | | | | ▲/▲ |
| R/L109.1838.04.2.HV7 | | | | 15 | 33 | | | | | | | | Δ/Δ |
| R/L109.1838.04.3.HV7 | | | | 20 | 38 | | | | | | | | Δ/Δ |
| R/L109.1838.04.4.HV7 | | | | 25 | 43 | | | | | | | | Δ/Δ |
| R/L109.1838.04.5.HV7 | 3,8 | 6,7 | 6 | 30 | 48 | 0,4 | 7 | 0,4 | | | | | ▲/▲ |
| R/L109.1838.04.6.HV7 | | | | 35 | 53 | | | | | | | | ▲/▲ |
| R/L109.1838.04.7.HV7 | | | | 40 | 58 | | | | | | | | ▲/▲ |
| R/L109.1838.04.8.HV7 | | | | 45 | 63 | | | | | | | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | • |
| M | | | • |
| K | | | • |
| N | | | • |
| S | | | • |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

BOHRUNG-DREHEN und FASEN

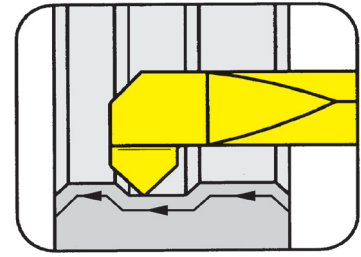
BORING, PROFILING and CHAMFERING



B

SCHNEIDPLATTE Typ INSERT Type

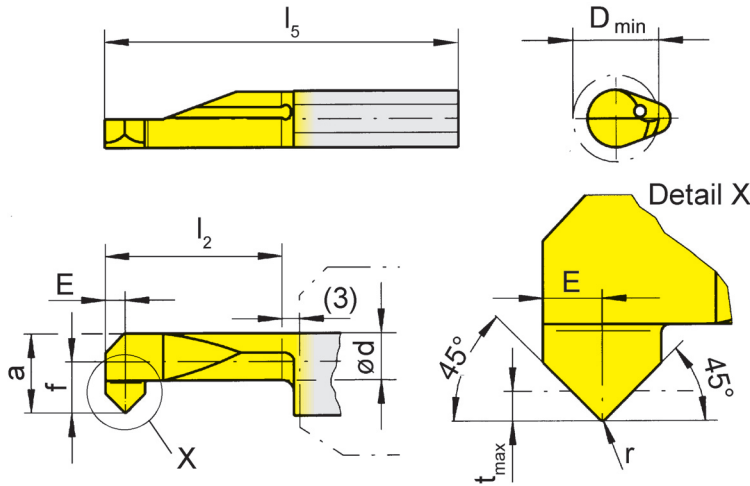
109



Bohrungs-Ø ab Bore Ø from 6,0 mm

für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | E | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | r | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|-----|-----|----------------|----------------|------------------|------------------|-----|------|------|------|------|
| R/L109.4545.3.6 | 1,2 | 2,8 | 5,7 | 4,3 | 20 | 38 | 0,9 | 6 | 0,2 | | | | Δ/Δ |
| R/L109.4545.5.7 | 1,2 | 3,8 | 6,7 | 5,3 | 30 | 48 | 0,9 | 7 | 0,2 | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \varnothing 6,0$ mm

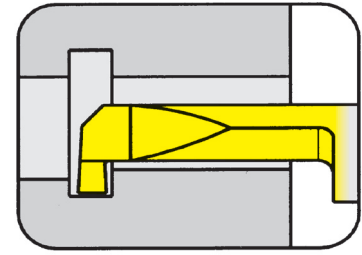
GROOVING (internal)



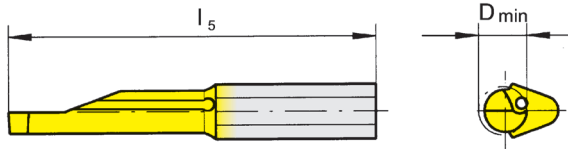
B

SCHNEIDPLATTE Typ
INSERT Type

109

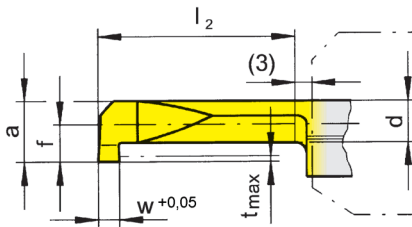


| | | |
|----------------------------|-------------------------|--------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,8 mm |



für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | | | | | | |
|---|-----|-----|-----|-----|----------------|----------------|------------------|------------------|------|------|------|------|--|-----|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 | | |
| R/L109.0100.1.6 | 1,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.1.6 | 1,5 | 2,8 | 5,7 | 3,7 | 10 | 28 | 1,8 | 6 | | | | | | Δ/Δ |
| R/L109.0200.1.6 | 2,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.2.6 | 1,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.2.6 | 1,5 | 2,8 | 5,7 | 3,7 | 15 | 33 | 1,8 | 6 | | | | | | Δ/Δ |
| R/L109.0200.2.6 | 2,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.3.6 | 1,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.3.6 | 1,5 | 2,8 | 5,7 | 3,7 | 20 | 38 | 1,8 | 6 | | | | | | Δ/Δ |
| R/L109.0200.3.6 | 2,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.4.6 | 1,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.4.6 | 1,5 | 2,8 | 5,7 | 3,7 | 25 | 43 | 1,8 | 6 | | | | | | Δ/Δ |
| R/L109.0200.4.6 | 2,0 | | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.5.6 | 1,0 | | | | | | | | | | | | | ▲/▲ |
| R/L109.0150.5.6 | 1,5 | 2,8 | 5,7 | 3,7 | 30 | 48 | 1,8 | 6 | | | | | | ▲/▲ |
| R/L109.0200.5.6 | 2,0 | | | | | | | | | | | | | ▲/▲ |
| R/L109.0100.6.6 | 1,0 | | | | | | | | | | | | | ▲/▲ |
| R/L109.0150.6.6 | 1,5 | 2,8 | 5,7 | 3,7 | 35 | 53 | 1,8 | 6 | | | | | | ▲/▲ |
| R/L109.0200.6.6 | 2,0 | | | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request

B10

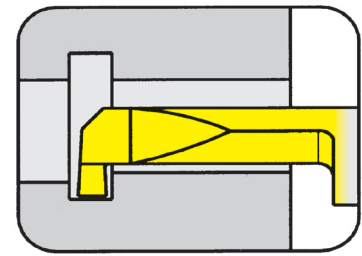
EINSTECHEN (innen) $\geq \text{Ø } 7,0 \text{ mm}$ GROOVING (internal)



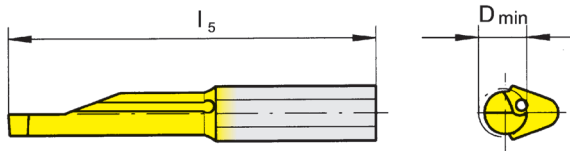
B

SCHNEIDPLATTE Typ INSERT Type

109

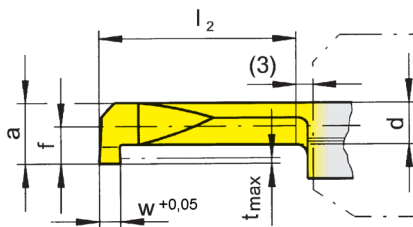


| | | |
|----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 7,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |



für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | | | | | |
|---|-----|-----|-----|---|----------------|----------------|------------------|------------------|------|------|------|------|-----|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 | |
| R/L109.0100.1.7 | 1,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.1.7 | 1,5 | 3,8 | 6,7 | 4 | 10 | 28 | 2,5 | 7 | | | | | Δ/Δ |
| R/L109.0200.1.7 | 2,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.2.7 | 1,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.2.7 | 1,5 | 3,8 | 6,7 | 4 | 15 | 33 | 2,5 | 7 | | | | | Δ/Δ |
| R/L109.0200.2.7 | 2,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.3.7 | 1,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0150.3.7 | 1,5 | 3,8 | 6,7 | 4 | 20 | 38 | 2,5 | 7 | | | | | Δ/Δ |
| R/L109.0200.3.7 | 2,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.4.7 | 1,0 | | | | | | | | | | | | Δ/Δ |
| R/L109.0200.4.7 | 1,0 | 3,8 | 6,7 | 4 | 25 | 43 | 2,5 | 7 | | | | | Δ/Δ |
| R/L109.0150.4.7 | 1,5 | | | | | | | | | | | | Δ/Δ |
| R/L109.0100.5.7 | 1,0 | | | | | | | | | | | | ▲/▲ |
| R/L109.0150.5.7 | 1,5 | 3,8 | 6,7 | 4 | 30 | 48 | 2,5 | 7 | | | | | ▲/▲ |
| R/L109.0200.5.7 | 2,0 | | | | | | | | | | | | ▲/▲ |
| R/L109.0100.6.7 | 1,0 | | | | | | | | | | | | ▲/▲ |
| R/L109.0150.6.7 | 1,5 | 3,8 | 6,7 | 4 | 35 | 53 | 2,5 | 7 | | | | | ▲/▲ |
| R/L109.0200.6.7 | 2,0 | | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request

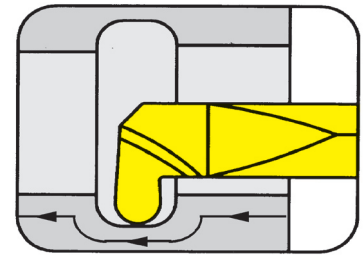
EINSTECHEN (innen) $\geq \text{Ø } 6,0 \text{ mm}$ GROOVING (internal)



B

SCHNEIDPLATTE Typ
INSERT Type

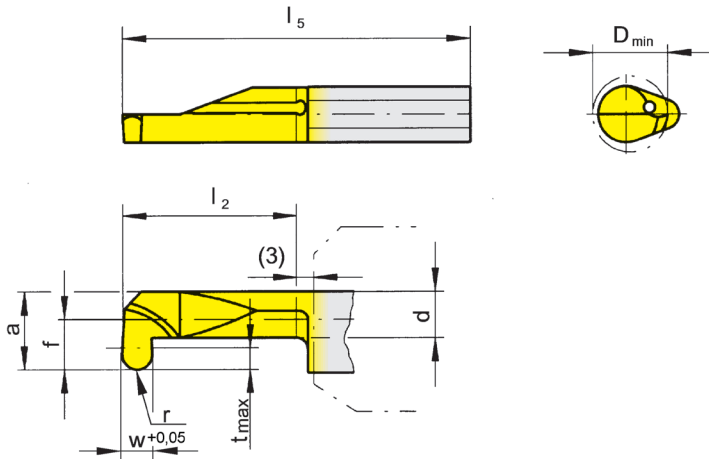
109



| | | |
|-----------------------------|----------------------------|--------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 6,0 mm r 0,5 - 1,0 mm |
|-----------------------------|----------------------------|--------------------------|

für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Vollradius
Full radius

| Bestellnummer Part number | w | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|-------|-------|-----------|-----------|------|------|------|------|------|
| R/L109.0005.4.6 | 1,0 | | | | | | | | 0,50 | | | | Δ/Δ |
| R/L109.0007.4.6 | 1,5 | 2,8 | 5,7 | 3,7 | 25 | 43 | 1,8 | 6 | 0,75 | | | | Δ/Δ |
| R/L109.0010.4.6 | 2,0 | | | | | | | | 1,00 | | | | Δ/Δ |
| R/L109.0005.6.7 | 1,0 | | | | | | | | 0,50 | | | | ▲/▲ |
| R/L109.0007.6.7 | 1,5 | 3,8 | 6,7 | 4,0 | 35 | 53 | 2,5 | 7 | 0,75 | | | | ▲/▲ |
| R/L109.0010.6.7 | 2,0 | | | | | | | | 1,00 | | | | ▲/▲ |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

● Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | • |
| M | | | • |
| K | | | • |
| N | | | • |
| S | | | • |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

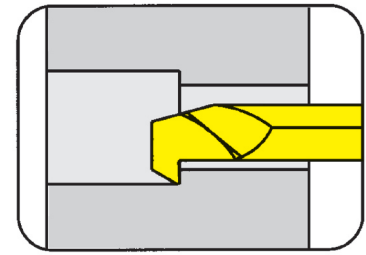
RÜCKWÄRTSDREHEN (innen) BACKBORING (internal)



B

SCHNEIDPLATTE Typ
INSERT Type

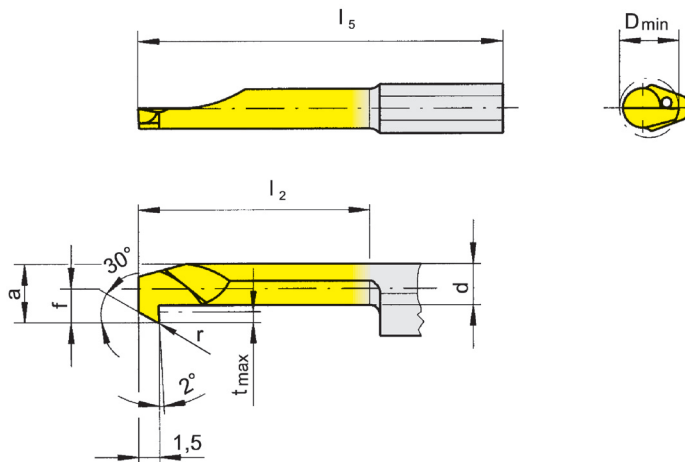
109



Bohrungs-Ø ab Bore Ø from 6,0 mm

für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | f | a | d | l ₂ | l ₅ | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|----------------|----------------|------------------|------------------|------|------|------|------|
| R/L109.3028.3.6 | 0,2 | 2,8 | 5,7 | 3,7 | 20 | 38 | 1,8 | 6 | ■ | ■ | ■ | Δ/Δ |
| R/L109.3028.5.6 | | | | | 30 | 48 | | | | | | ▲/▲ |
| R/L109.3038.3.7 | 0,2 | 3,8 | 6,7 | 4,0 | 20 | 38 | 2,5 | 7 | | | | ▲/▲ |
| R/L109.3038.5.7 | | | | | 30 | 48 | | | | | | ▲/▲ |
| | | | | | | | | | P | ■ | ■ | ● |
| | | | | | | | | | M | ■ | ■ | ● |
| | | | | | | | | | K | ■ | ■ | ● |
| | | | | | | | | | N | ■ | ■ | ● |
| | | | | | | | | | S | ■ | ■ | ● |
| | | | | | | | | | H | ■ | ■ | ■ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | ■ | ■ | ● |
| M | ■ | ■ | ● |
| K | ■ | ■ | ● |
| N | ■ | ■ | ● |
| S | ■ | ■ | ● |
| H | ■ | ■ | ■ |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile

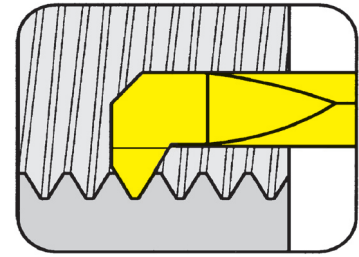


B

SCHNEIDPLATTE Typ
INSERT Type

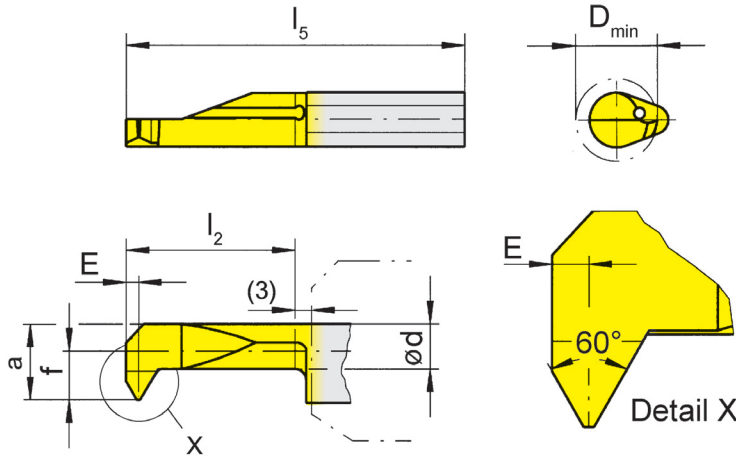
109

Bohrungs-Ø ab Steigung Bore Ø from Pitch 7,0 mm
P 1,50 - 1,75 mm



für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO-Gewinde
Metric ISO thread

| Bestellnummer Part number | P | P _{max} | E | f | a | d | l ₂ | l ₅ | D _{min} | MG12 | TN35 | Ti25 | TH35 |
|------------------------------|-----|------------------|-----|-----|-----|-----|----------------|----------------|------------------|------|------|------|------|
| R/L109.0815.1.7 | | | | | | | 10 | 28 | | | | | Δ/Δ |
| R/L109.0815.3.7 | 1,5 | 1,75 | 0,9 | 3,8 | 6,7 | 5,1 | 20 | 38 | 7 | | | | Δ/Δ |
| R/L109.0815.5.7 | | | | | | | 30 | 48 | | | | | ▲/▲ |
| | | | | | | | | | | P | | | • |
| | | | | | | | | | | M | | | • |
| | | | | | | | | | | K | | | • |
| | | | | | | | | | | N | | | • |
| | | | | | | | | | | S | | | • |
| | | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

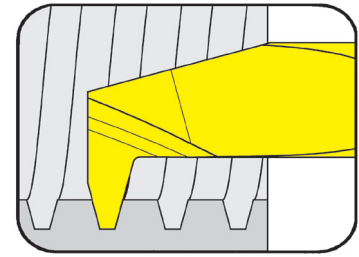
THREADING (internal) Partial profile



B

SCHNEIDPLATTE Typ
INSERT Type

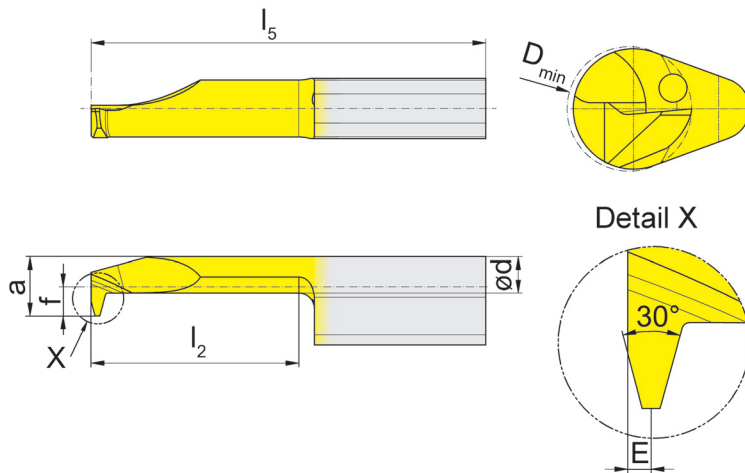
109



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Steigung | Pitch | P 1,5 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B109
Type



R = rechts wie gezeichnet
R = right hand version shown

Metrisches ISO
Trapezgewinde DIN 103
Metric ISO trapezoidal
thread DIN 103

| Bestellnummer Part number | P | E | f | a | d | l_2 | l_5 | D_{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|-----|-------|-------|-----------|------|------|------|------|
| R109.0915.3.6 | 1,5 | 0,6 | 2,8 | 5,7 | 3,5 | 20 | 38 | 6 | | | | ▲ |
| R109.1220.3.6 | 2,0 | 0,8 | | | | | | | | | | |
| R109.1220.3.7 | 2,0 | 0,8 | 3,8 | 6,7 | 4,8 | 20 | 38 | 7 | | | | ▲ |
| R109.1220.5.7 | 2,0 | 0,8 | | | | | | | | | | |
| R109.1730.3.7 | 3,0 | 1,2 | | | 4,3 | 20 | 38 | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | ● |
| M | | | ● |
| K | | | ● |
| N | | | ● |
| S | | | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request

AXIALEINSTECHEN FACE GROOVING



B

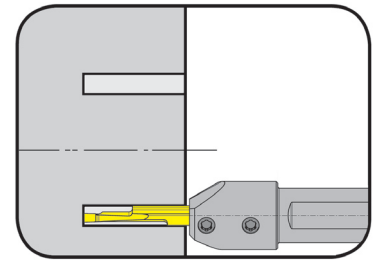
KLEMMHALTER Typ
TOOLHOLDER Type

B109

mit innerer Kühlmittelzufuhr
with through coolant supply

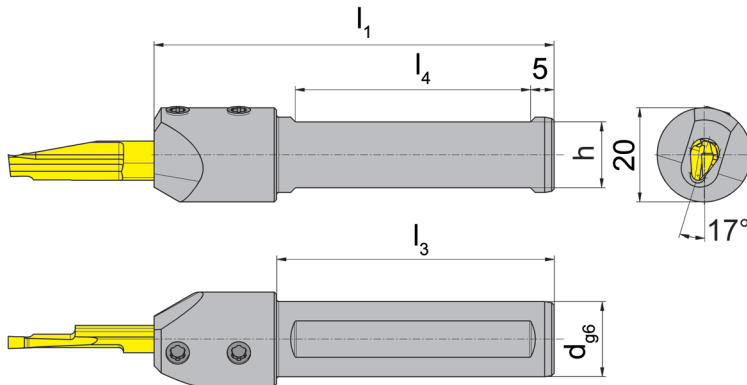
| | | |
|---------------|---------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 15,0 mm |
| Stechtiefe | Depth of groove | 20,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

Verlängerte Aufnahme der Platte
Extended depth of insert seat



für Schneidplatte
for use with Insert

Typ A109
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | d | l ₁ | h | l ₃ | l ₄ |
|------------------------------|----|----------------|----|----------------|----------------|
| R/LB109.0016.14.2 | 16 | 85 | 14 | 59 | 50 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schraube 6.075T15P beträgt 5 Nm.
Torque specification of the screw 6.075T25P = 5 Nm.

Ersatzteile
Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB109.0016.14.2 | 6.075T15P | T15PQ |

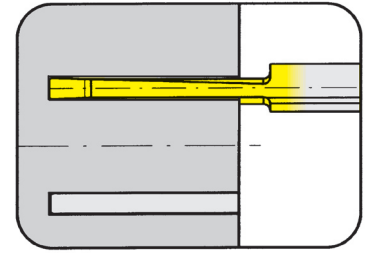
AXIALEINSTECHEN FACE GROOVING



B

SCHNEIDPLATTE Typ INSERT Type

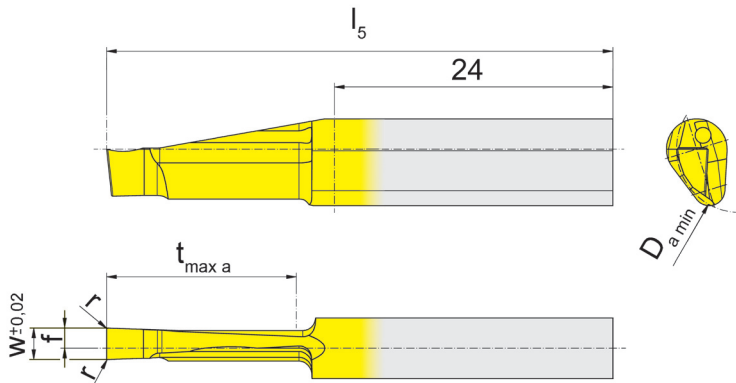
A109



| | | |
|---------------|---------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 15,0 mm |
| Stechtiefe | Depth of groove | 20,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B109...14.2
Type



L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer Part number | w | r | f | l ₅ | t _{max a} | D _{a min} | HM-Sorten | | | |
|------------------------------|-----|-----|-----|----------------|--------------------|--------------------|-----------|------|------|------|
| | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/LA109.1520.3.2 | 2,0 | | 1,0 | | | | | ▲ | | |
| R/LA109.1525.3.2 | 2,5 | 0,1 | 1,2 | 48 | 20 | 15 | | ▲ | | |
| R/LA109.1530.3.2 | 3,0 | | 1,5 | | | | | ▲ | | |
| | | | | | | | P | | ● | |
| | | | | | | | M | | ● | |
| | | | | | | | K | | ● | |
| | | | | | | | N | | ● | |
| | | | | | | | S | | ● | |
| | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Schneidplatte RA109 in Klemmhalter RB109 und
Schneidplatte LA109 in Klemmhalter LB109 verwenden

Note:
Use insert RA109 in toolholder RB109
Use insert LA109 in toolholder LB109

Axialstechen ins Volle bei voller Stechtiefe nur bei D_{amin} 15 - 40 mm möglich!
Face grooving with full width of the full depth only possible between D_{amin} 15 - 40 mm!

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

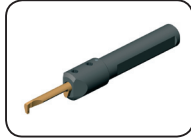
| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Supermini® HM-SCHNEIDWERKZEUGE **Typ 110**
Supermini® CARBIDE GROOVING TOOLS type

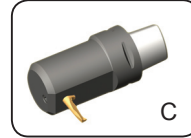
B110, VDI...110, N
Klemmhalter
Toolholder



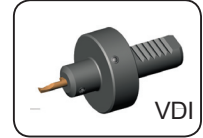
Seite/Page
C2-C3



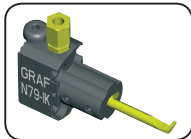
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C4



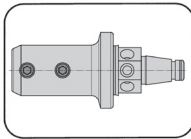
Seite/Page
C5-C6



Seite/Page
C7

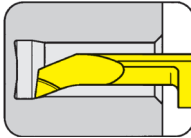


Seite/Page
C8

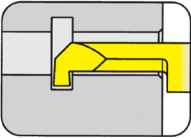


Seite/Page
C9

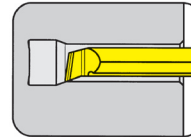
110
≥ Ø 6,0 mm
Schneidplatten
Inserts



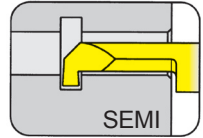
Seite/Page
C11



Seite/Page
C12-C13



Seite/Page
C14



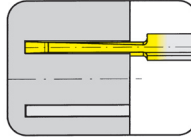
Seite/Page
C15

B110
Axialeinstechen
Face Grooving
Klemmhalter
Toolholder

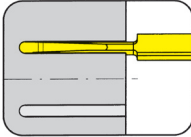


Seite/Page
C16

A110
Axialeinstechen
Face Grooving
Schneidplatten
Inserts



Seite/Page
C17



Seite/Page
C18

Technische Hinweise **Seite N2-N8**
Technical Instructions Page

EINSTECHEN und AUSDREHEN

GROOVING and BORING

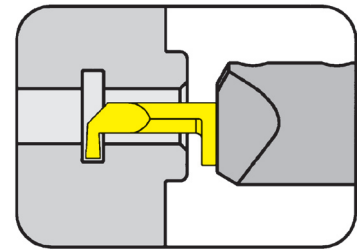


KLEMMHALTER Typ

TOOLHOLDER Type

B110

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 4,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Verlängerte Aufnahme der Platte
Extended depth of insert seat

für Schneidplatte
for use with Insert

Typ 110
Type

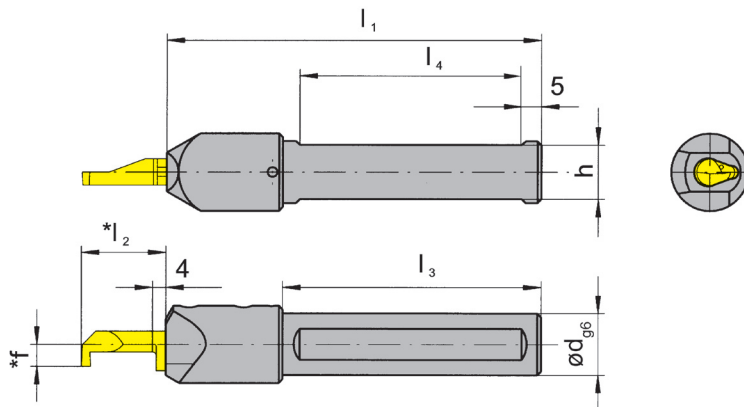


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

f, l₂ siehe SP Typ 110
f, l₂ see inserts type 110

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B110.00... | 6.075T15P | T15PQ |

EINSTECHEN und AUSDREHEN

GROOVING and BORING



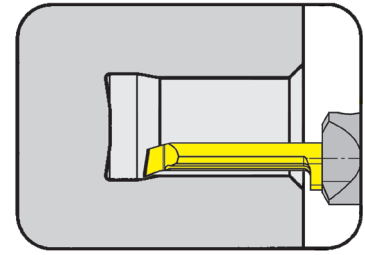
KLEMMHALTER Typ

TOOLHOLDER Type

B110

mit innerer Kühlmittelzufuhr
with through coolant supply

| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 4,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Schneidplatte
for use with Insert

Typ 110
Type

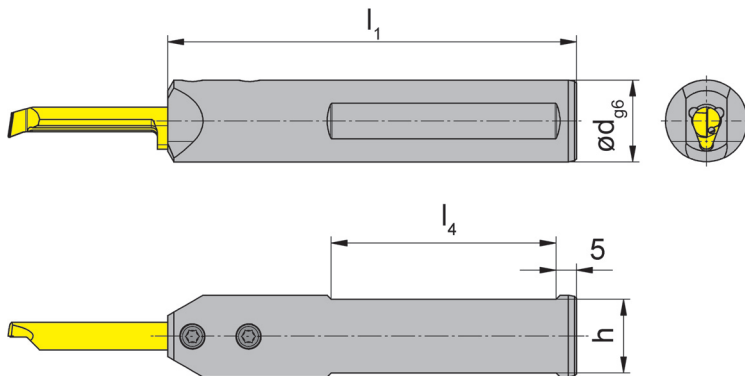


Abbildung = rechtsschneidend
Picture = right hand cutting version

mit zusätzlichen
Spülbohrungen
with additional through coolant
bores

| Bestellnummer Part number | d | l ₁ | h | l ₄ |
|------------------------------|----|----------------|----|----------------|
| B110.0020.K.02 | 20 | 100 | 18 | 55 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Ordering note:

Toolholders can be used with right and left hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B110.0020.K.02 | 6.075T15P | T15PQ |

EINSTECHEN und AUSDREHEN

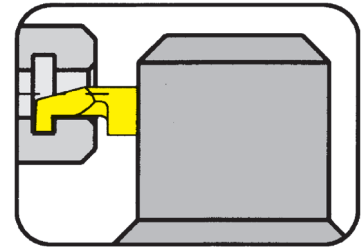
GROOVING and BORING



KLEMMHALTER Typ

TOOLHOLDER Type

B110TS

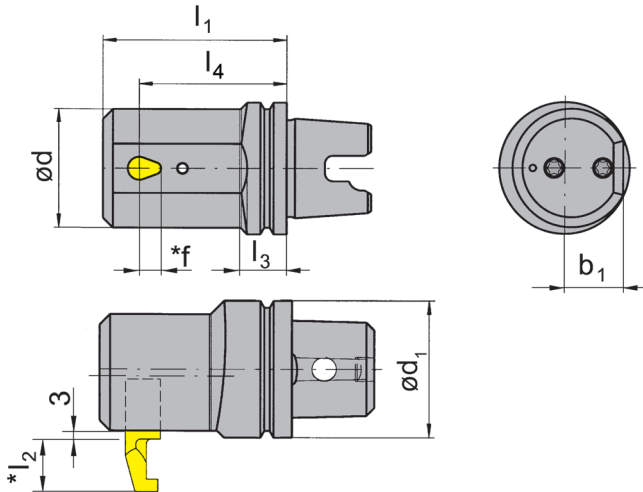


Direktaufnahme für Schneidplatte Typ 110 HORN-TS
Adapter for inserts type 110 HORN-TS

für INDEX Mehrspindler
for INDEX Multi spindle machines

für Schneidplatte
for use with Insert

Typ 110
Type



R = rechts wie gezeichnet
R = right hand version shown

HORN-Klemmhalter TS
nach ISO 26622
HORN Toolholder TS
according to DIN 26622

| Bestellnummer Part number | d | l ₁ | l ₃ | b ₁ | l ₄ | d ₁ | Maschinentyp Machine type |
|------------------------------|----|----------------|----------------|----------------|----------------|----------------|------------------------------|
| RB110.TS40.2.2.02 | 36 | 56 | 14 | 18 | 45 | 40 | MS32 |
| RB110.TS50.2.2.02 | | | 22 | | | 50 | MS52 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

f, l₂ siehe SP Typ 110
f, l₂ see inserts type 110

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

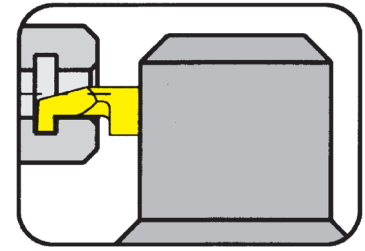
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| RB110.TS... | 6.075T15P | T15PQ |

KLEMMHALTER Typ

TOOLHOLDER Type

B110C

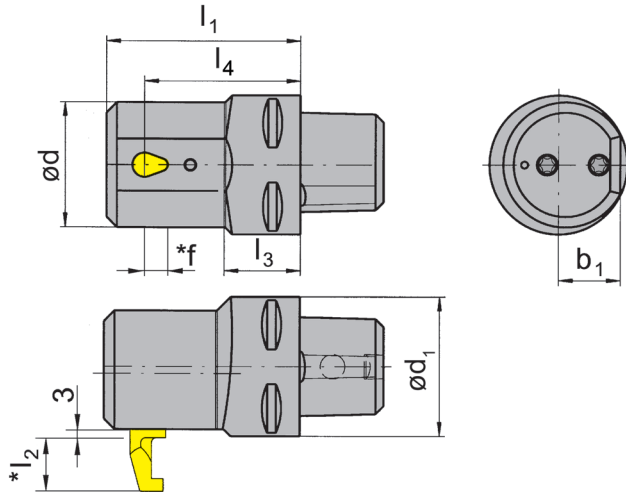


HORN-Polygonschaft nach ISO 26623
HORN Polygon shank according ISO 26623

für INDEX Mehrspindler
for INDEX Multi spindle machines

für Schneidplatte
for use with Insert

Typ 110
Type



R = rechts wie gezeichnet
R = right hand version shown

| Bestellnummer Part number | d | l ₁ | l ₃ | b ₁ | l ₄ | d ₁ | Maschinentyp Machine type |
|------------------------------|----|----------------|----------------|----------------|----------------|----------------|------------------------------|
| RB110.00C3.2.2.02 | 36 | 56 | 15 | 18 | 45 | 32 | MS32 |
| RB110.00C4.2.2.02 | 36 | 56 | 22 | 18 | 45 | 40 | MS52 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

f, l₂ siehe SP Typ 110
f, l₂ see inserts type 110

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| RB110.00C... | 6.075T15P | T15PQ |

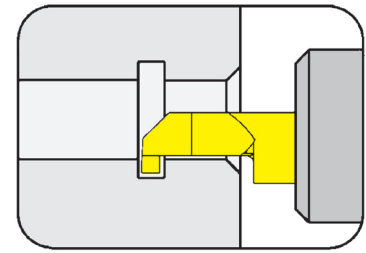
EINSTECHEN und AUSDREHEN

GROOVING and BORING



KLEMMHALTER Typ
TOOLHOLDER Type

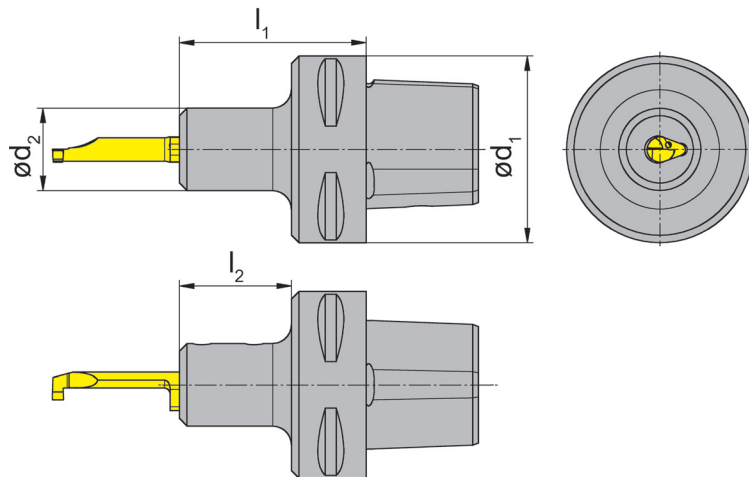
B110C



HORN-Polygonschaft nach ISO 26623
HORN Polygon shank according ISO 26623

für Schneidplatte
for use with Insert

Typ 110
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LB110.00C... | 6.075T15P | T15PQ |

EINSTECHEN und AUSDREHEN

GROOVING and BORING

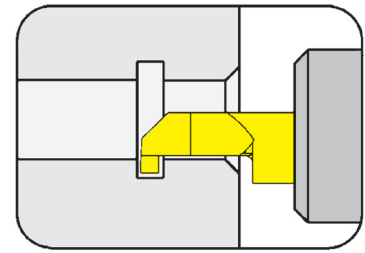


KLEMMHALTER Typ

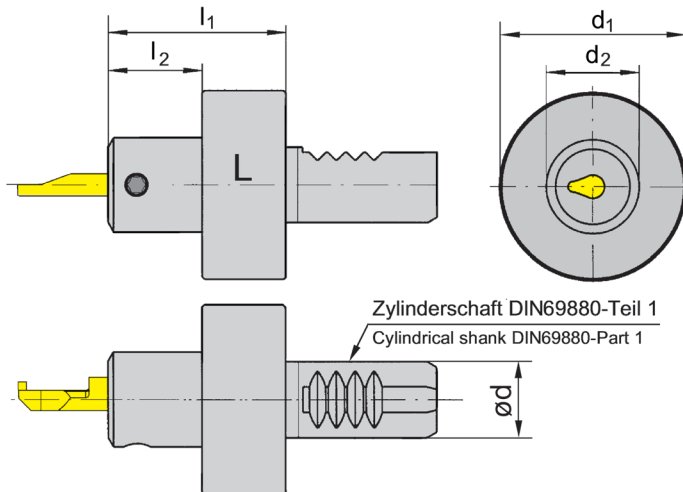
TOOLHOLDER Type

VDI

mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs-Ø ab Bore Ø from 6,0 mm



für Schneidplatte
for use with Insert

Typ 110
Type

L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| VDI... | 6.075T15P | T15PQ |

EINSTELLBARE HALTER Typ N

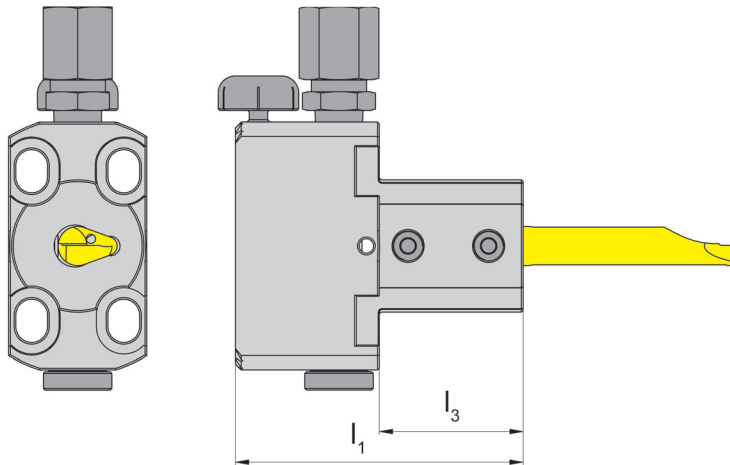
ADJUSTABLE HOLDER Type

N



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 4,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

mit innerer Kühlmittelzufuhr
with through coolant supply



für Schneidplatte
for use with Insert

Typ 110
Type

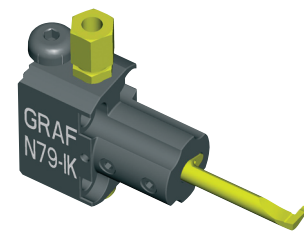


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | l_1 | l_3 |
|------------------------------|-------|-------|
| N79IK | 50 | 25 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Einstellbare Halter Adjustable holder | Spannschraube Screw | Höhenverstellungsschraube Height adjustment screw | Kühlmittelanschluss Coolant supply |
|--|------------------------|--|---------------------------------------|
| N79IK | 6.075T15P | 002.00.69 | 004.00.19 |

EINSTECHEN und AUSDREHEN

GROOVING and BORING

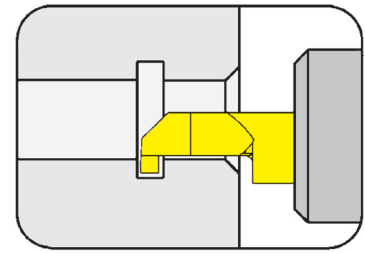


KLEMMHALTER Typ

TOOLHOLDER Type

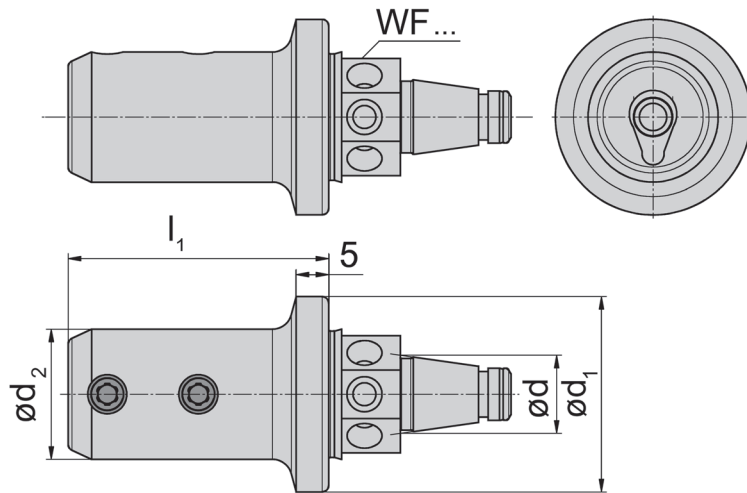
B110.WF

mit innerer Kühlmittelzufuhr
with through coolant supply



C

Bohrungs-Ø ab Bore Ø from 6,0 mm



für Schneidplatte
for use with Insert

Typ 110
Type

| Bestellnummer Part number | Anbindung Coupling System | d | l ₁ | d ₂ | d ₁ |
|------------------------------|------------------------------|----|----------------|----------------|----------------|
| B110.WF20.2.02 | WF20-12 | 12 | 40 | 20 | 30 |
| B110.WF24.2.02 | WF24-16 | 16 | 40 | 20 | 37 |
| B110.WF32.2.02 | WF32-20 | 20 | 40 | 20 | 50 |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

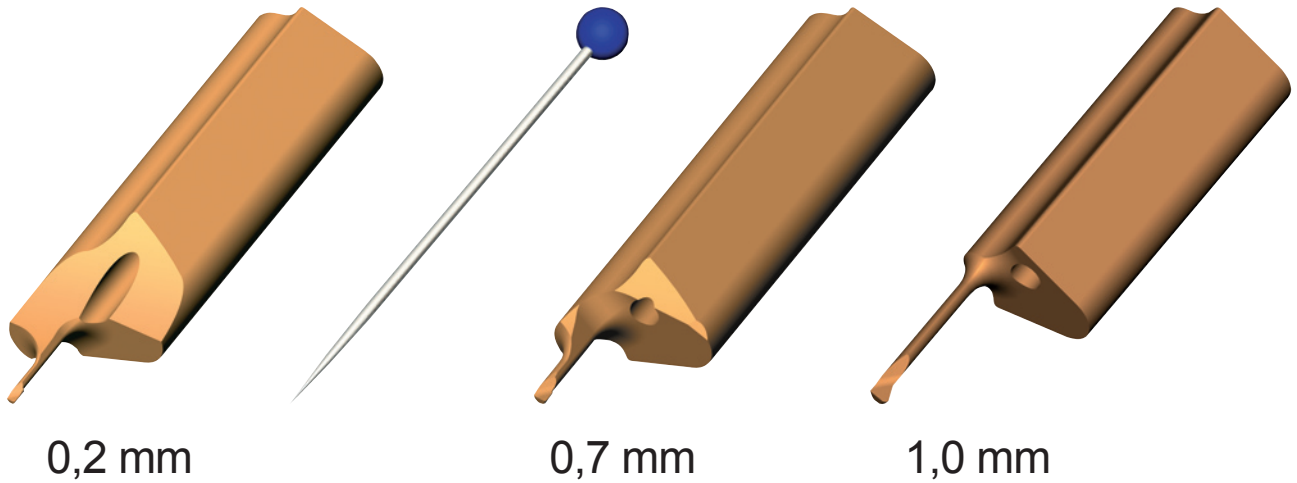
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B110.WF... | 6.075T15P | T15PQ |

C

Bohrung ausdrehen ab

Boring from

0,2 mm



0,2 mm

0,7 mm

1,0 mm

Ein Beweis für den Namen

Supermini[®]

- einfach bestechend gut -

Supermini[®]

- best in small bores -

BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

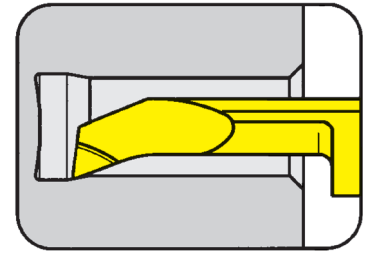
BORING and PROFILING



SCHNEIDPLATTE Typ

INSERT Type

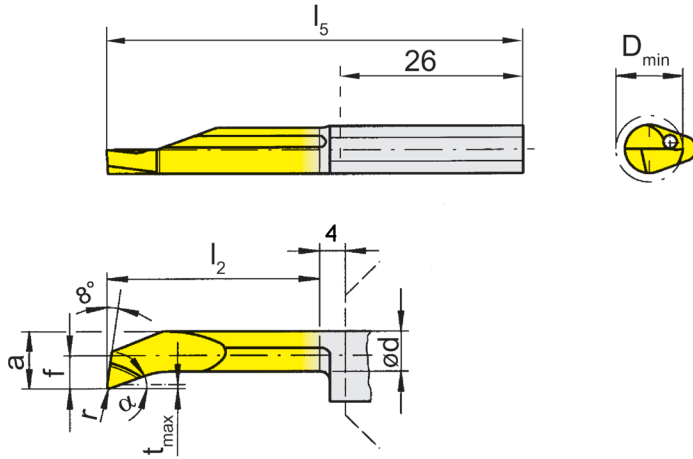
110



Bohrungs- \varnothing ab Bore \varnothing from 6,0 mm

für Klemmhalter
for use with Toolholder

Typ B110
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | α | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|-----|-------|-------|-----------|-----------|-----|----------|------|------|------|------|
| R/L110.1829.7.6 | | | | 40 | 70 | 0,5 | 6 | 0,2 | 20° | | | ▲/▲ | ▲/▲ |
| R/L110.1829.9.6 | 2,9 | 5,7 | 4,8 | 50 | 80 | 0,5 | 6 | 0,2 | 20° | | | ▲/▲ | ▲/▲ |
| R/L110.1829.9.8 | 4,0 | 7,4 | 6,0 | 50 | 80 | 0,5 | 8 | 0,2 | 20° | | | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

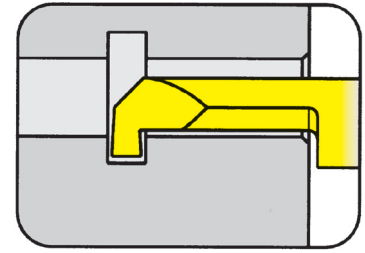
HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)

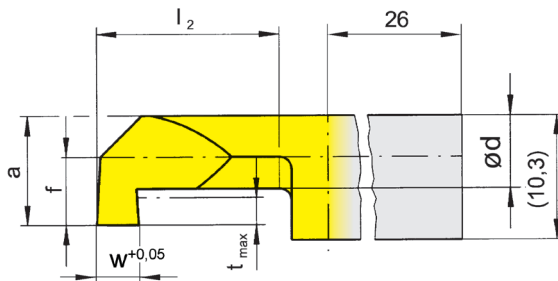
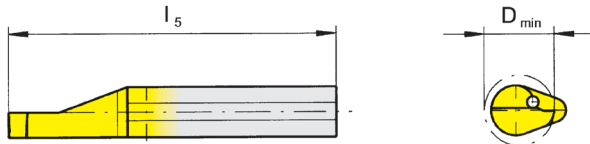


SCHNEIDPLATTE Typ
INSERT Type

110



Bohrungs-Ø ab Bore Ø from 8,0 mm



für Klemmhalter
for use with Toolholder

Typ B110
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | 4 | 7,4 | 4,2 | 30 | 60 | 2,8 | 8 | | ▲/▲ | | |
| R/L110.0100.7.8 | 1,0 | | | | 40 | 70 | | | | ▲/▲ | | |
| 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 | | | | ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|--|--|
| P | • | | |
| M | • | | |
| K | • | | |
| N | • | | |
| S | • | | |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

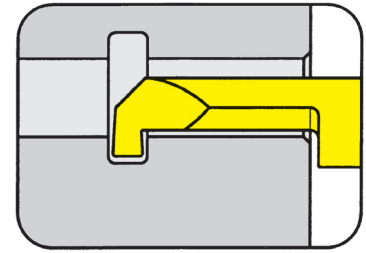
HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)

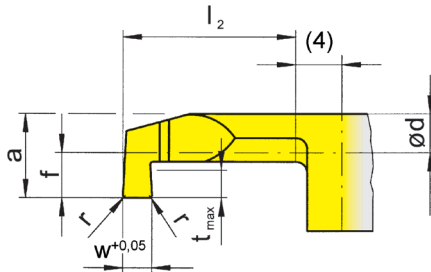
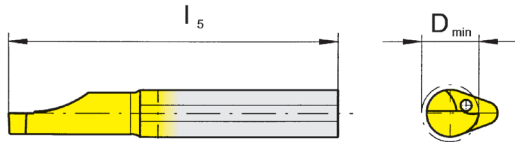


SCHNEIDPLATTE Typ
INSERT Type

110



Bohrungs-Ø ab Bore Ø from 8,0 mm



für Klemmhalter
for use with Toolholder

Typ B110
Type

mit Eckenradius
with corner radius

R = rechts wie gezeichnet
R = right hand version shown

| Bestellnummer Part number | w | f | a | d | l_2 | l_5 | 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 | | ▲ | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | • | | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | • | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | • | | |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | • | | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | S | • | | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

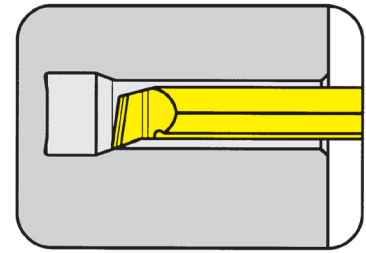
BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

BORING and PROFILING

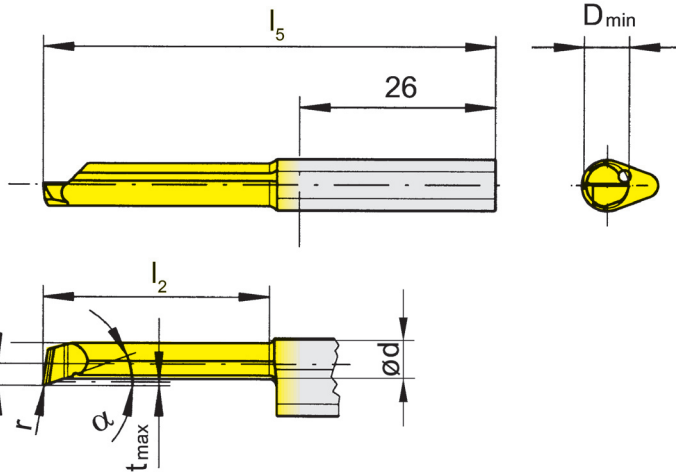


SCHNEIDPLATTE Typ INSERT Type

110



Bohrungs- \varnothing ab Bore \varnothing from 6,0 mm



für Klemmhalter
for use with Toolholder

Typ B110
Type

R = rechts wie gezeichnet
R = right hand version shown

mit Spantreppe
(Geometrie H)
with chip breaker
(geometry H)

| Bestellnummer Part number | f | a | d | l_2 | l_5 | t_{max} | D_{min} | r | α | 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 | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

| | | | |
|---|--|---|--|
| P | | • | |
| M | | • | |
| K | | • | |
| N | | • | |
| S | | • | |
| H | | | |

HM-Sorten
Carbide grades

Grundabmessungen Typ 110

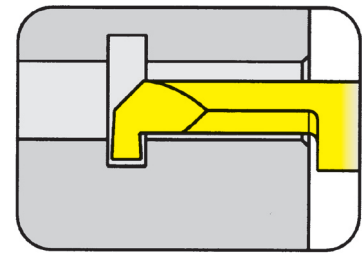
Basic sizes type 110



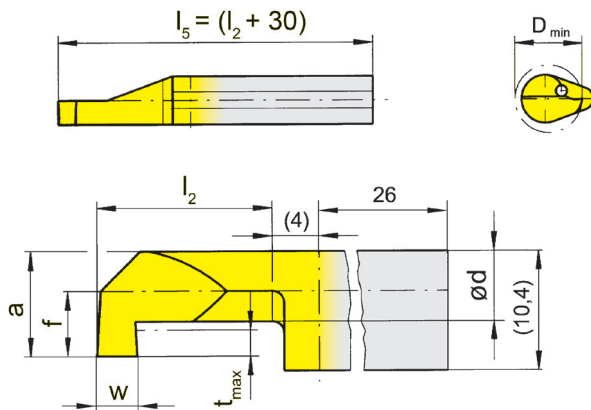
SCHNEIDPLATTE Typ 110

INSERT type

110



Grundabmessungen Typ 110
Basic sizes type 110



für Klemmhalter
for Toolholder

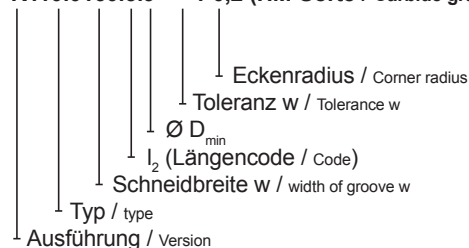
Typ B110
type

| Bestellnummer Part number | D_{min} | f | a | d | t_{max} | w | Längencode Code | l_2 | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----------|---|-----|-----|-----------|---------|--------------------|-------|-----------------------------|------|------|------|
| 110...8 | 8 | 4 | 7,4 | 4,2 | 2,8 | 0,5-3,0 | 1 | 10 | AUF ANFRAGE 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 | | | | |

Abmessungen in mm
Dimensions in mm

Bestellbeispiel:
Ordering example:

R110.0160.3.9^{+0,05} r 0,2 (HM-Sorte / Carbide grade)



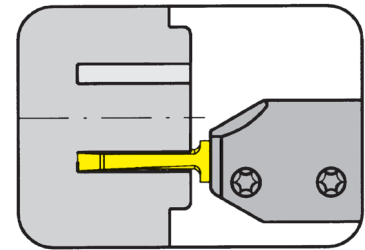
AXIALEINSTECHEN FACE GROOVING



KLEMMHALTER Typ TOOLHOLDER Type

B110

mit innerer Kühlmittelzufuhr
with through coolant supply

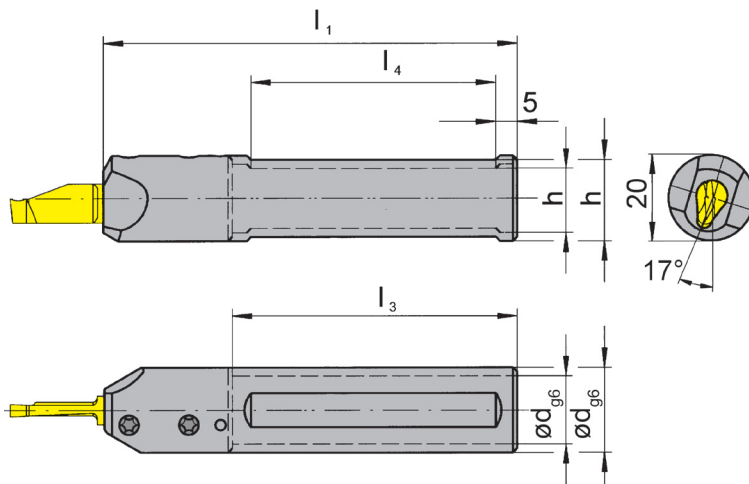


| | | |
|-----------------|-----------------------|---------|
| Nutaußen-Ø ab | from outer groove Ø | 20,0 mm |
| Stechtiefe bis | Depth of groove up to | 30,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Verlängerte Aufnahme der Platte
Extended depth of insert seat

für Schneidplatte
for use with Insert

Typ A110
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile Spare parts

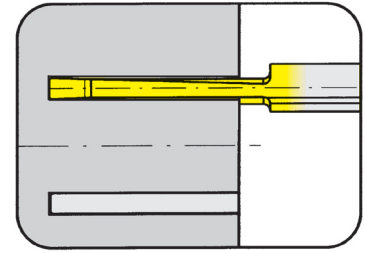
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB110.00... | 6.075T15P | T15PQ |

AXIALEINSTECHEN FACE GROOVING



SCHNEIDPLATTE Typ INSERT Type

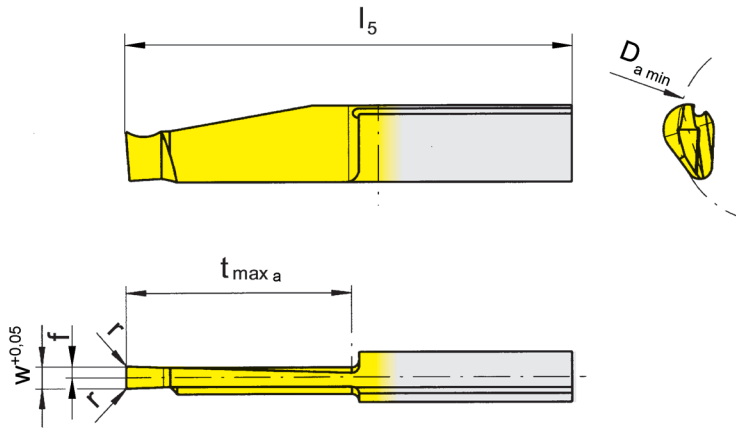
A110



| | | |
|---------------|---------------------|---------|
| Nutaußen-Ø ab | from outer groove Ø | 20,0 mm |
| Stechtiefe | Depth of groove | 30,0 mm |
| Stechbreite | Width of groove | 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B110
Type



L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

| Bestellnummer 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 | | ▲/▲ | | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | • | • | • |
| ● Haupteinsatzbereich / main recommendation | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Schneidplatte RA110 in Klemmhalter RB110 und
Schneidplatte LA110 in Klemmhalter LB110 verwenden

Note:

Use insert RA110 in toolholder RB110
Use insert LA110 in toolholder LB110

Hinweis für R/LA110.2030...:

Axialstechen ins Volle bei voller Stechtiefe nur bei D_{amin} 20 - 50 mm möglich!

Note for R/LA110.2030...:

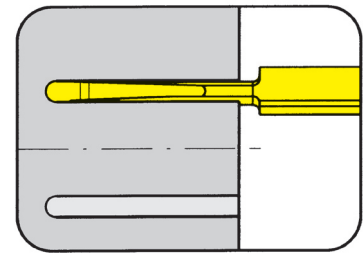
Face grooving with full width of the full depth only possible between D_{amin} 20 - 50 mm.

AXIALEINSTECHEN FACE GROOVING

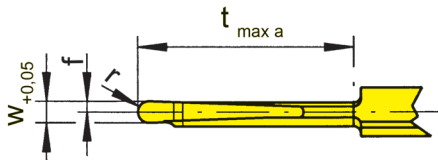
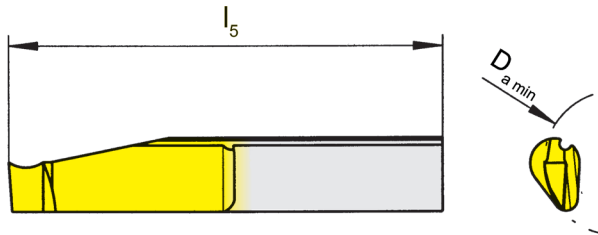


SCHNEIDPLATTE Typ INSERT Type

A110



| | | |
|---------------|---------------------|---------|
| Nutaußen-Ø ab | from outer groove Ø | 20,0 mm |
| Stechtiefe | Depth of groove | 30,0 mm |
| Stechbreite | Width of groove | 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B110
Type

L = links wie gezeichnet
L = left hand version shown

R = rechts spiegelbildlich
R = right hand version

Vollradius
Full radius

| Bestellnummer 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 | | ▲/▲ | | |
| ▲ ab Lager / on stock | | | | | | | P | • | | |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | • | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | • | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | • | | |
| beschichtete HM-Sorten / coated grades | | | | | | | S | • | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

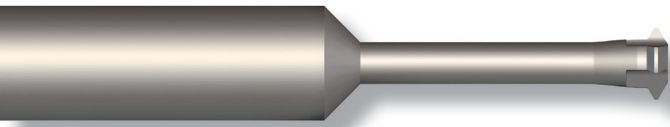
Hinweis:

Schneidplatte RA110 in Klemmhalter RB110 und
Schneidplatte LA110 in Klemmhalter LB110 verwenden

Note:

Use insert RA110 in toolholder RB110
Use insert LA110 in toolholder LB110

Axialstechen ins Volle bei voller Stechtiefe nur bei D_{amin} 20 - 50 mm möglich!
Face grooving with full width of the full depth only possible between D_{amin} 20 - 50 mm.

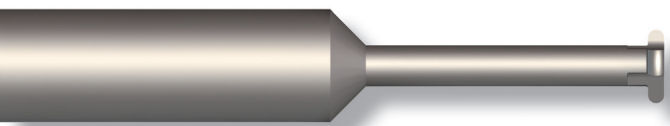


Typ DCG

Gewindefräsen Voll- und Teilprofil
M3 - M12

type DCG

Thread milling, Full and partial profile
M3 - M12

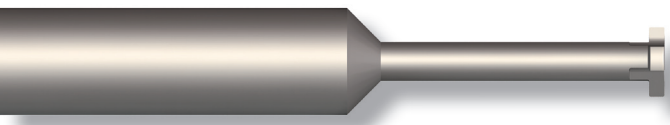


Typ DCR

Nutfräsen Vollradius
Ø Ds 4,0 - 10,0 mm
Radius 0,5 - 1,5 mm

type DCR

Groove milling Full Radius
Ø Ds 4,0 - 10,0 mm
Radius 0,5 - 1,5 mm

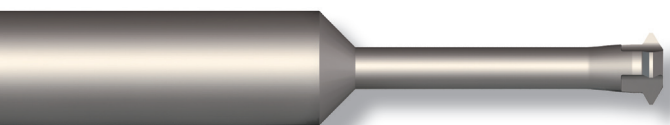


Typ DCN

Nutfräsen
Ø Ds 4,0 - 10,0 mm

type DCN

Groove milling
Ø Ds 4,0 - 10,0 mm



Typ DCF

Fasfräsen
Ø Ds 2,0 - 7,5 mm

type DCF

Chamfer milling
Ø Ds 2,0 - 7,5 mm

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

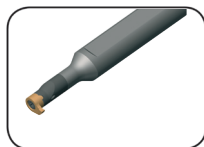
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

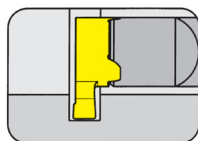
Typ 106
type

B106
Klemmhalter
Toolholder

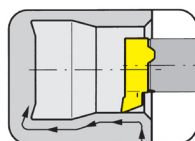


Seite/Page
D2

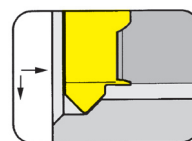
106
≥ Ø 6,0 mm
Schneidplatten
Inserts



Seite/Page
D3



Seite/Page
D4



Seite/Page
D5

D

Technische Hinweise
Technical Instructions

Seite N2-N8
Page

EINSTECHEN und AUSDREHEN

GROOVING and BORING

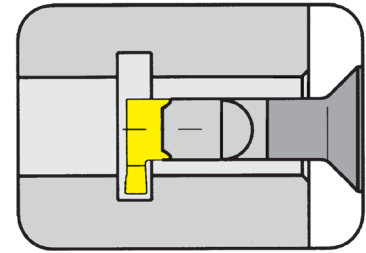


KLEMMHALTER Typ

TOOLHOLDER Type

B106

mit innerer Kühlmittelzufuhr
with through coolant supply

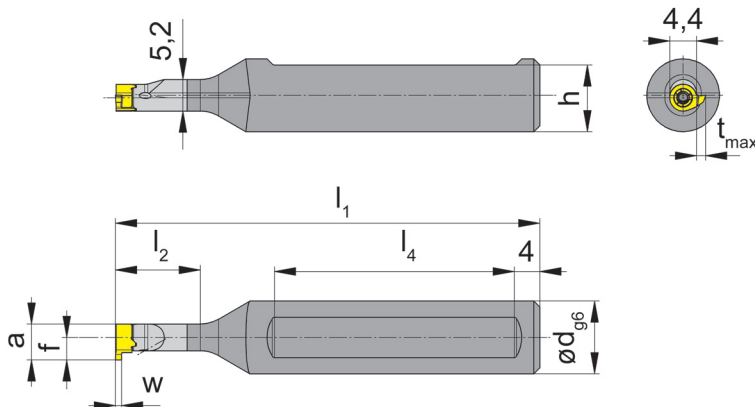


| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,0 mm |
| Stechtiefe bis | Depth of groove up to | 0,8 mm |
| Stechbreite bis | Width of groove up to | 1,5 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 106
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | d | l ₁ | l ₂ | h | l ₄ |
|------------------------------|----|----------------|----------------|----|----------------|
| LB106.0012.01 | 12 | 70 | 14 | 11 | 40 |
| LB106.0012.02 | | 80 | 20 | | 40 |
| LB106.0012.03 | | 90 | 26 | | 45 |
| RB106.0012.01 | 12 | 70 | 14 | 11 | 40 |
| RB106.0012.02 | | 80 | 20 | | 40 |
| RB106.0012.03 | | 90 | 26 | | 45 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

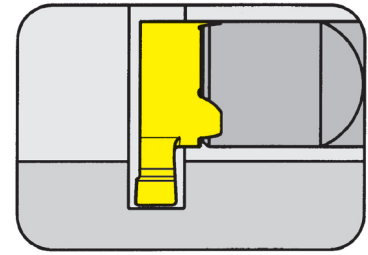
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB106.0012.0... | 1.8.4T6EP | T6PL |

EINSTECHEN (innen) $\geq \text{Ø } 6,5 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ
INSERT Type

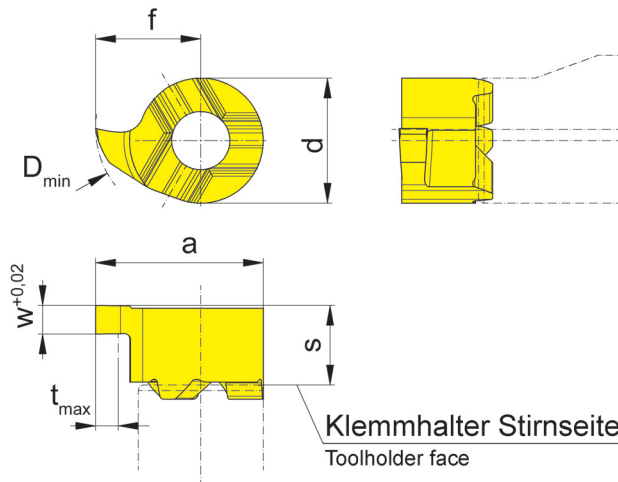
106



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 6,5 mm |
| Stechtiefe bis | Depth of groove up to | 0,8 mm |
| Stechbreite bis | Width of groove up to | 1,5 mm |

für Klemmhalter
for use with Toolholder

Typ B106
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|------|-----|-----|-----|-----|------------------|------------------|------|------|------|------|
| R/L106.0070.2.00 | 0,74 | | | | | | | | | | ▲/▲ |
| R/L106.0100.2.00 | 1,00 | 2,8 | 3,7 | 5,9 | 4,4 | 0,8 | 6,5 | | | | ▲/▲ |
| R/L106.0150.2.00 | 1,50 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

Rechte SP in rechten, linke SP in linken Klemmhaltern verwenden.
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders.

HM-Sorten
Carbide grades



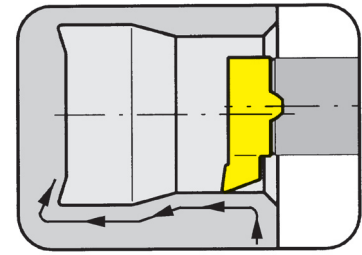
BOHRUNG-DREHEN $\geq \varnothing 6,0$ mm

BORING and PROFILING

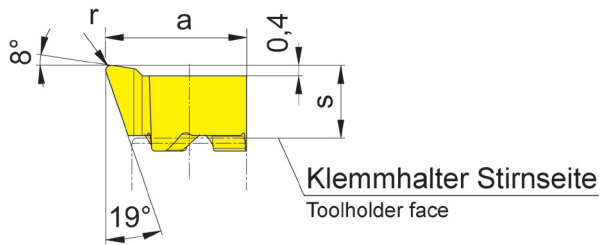
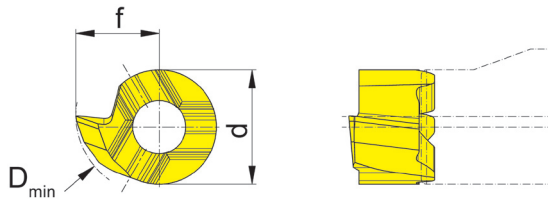


SCHNEIDPLATTE Typ INSERT Type

106



Bohrungs- \varnothing ab Bore \varnothing from 6,0 mm



für Klemmhalter
for use with Toolholder

Typ B106
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|------|-----|-----|-----|-----|------------------|------|------|------|------|
| R/L106.1831.1.005 | 0,05 | | | | | | | | | ▲/▲ |
| R/L106.1831.1.02 | 0,20 | 2,8 | 3,2 | 5,4 | 4,4 | 6 | | | | ▲/▲ |
| R/L106.1831.1.04 | 0,40 | | | | | | | | | ▲/▲ |
| | | | | | | | P | | | • |
| | | | | | | | M | | | • |
| | | | | | | | K | | | • |
| | | | | | | | N | | | • |
| | | | | | | | S | | | • |
| | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

Rechte SP in rechten, linke SP in linken Klemmhaltern verwenden.
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders.

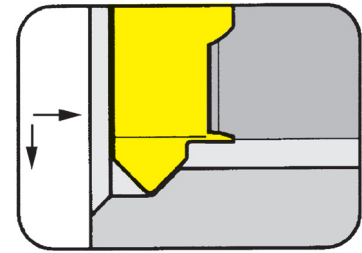
D

FASEN und RÜCKWÄRTSDREHEN (innen) CHAMFERING and BACKBORING (internal)

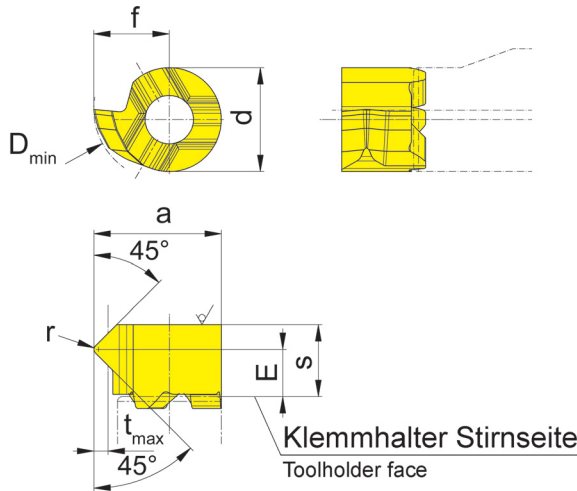


SCHNEIDPLATTE Typ
INSERT Type

106



| | | |
|-----------------------------------|-----------------------------------|------------------|
| Bohrungs-Ø ab Schnitttiefe bis | Bore Ø from Depth of cut up to | 6,0 mm 0,6 mm |
|-----------------------------------|-----------------------------------|------------------|



für Klemmhalter
for use with Toolholder

Typ B106
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | E | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|---|-----|------|-----|-----|-----|------------------|------------------|------|------|------|------|
| R/L106.4545.1.02 | 2 | 0,2 | 3,05 | 3,2 | 5,4 | 4,4 | 0,6 | 6 | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

Rechte SP in rechten, linke SP in linken Klemmhaltern verwenden.
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders.

HM-Sorten
Carbide grades



HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

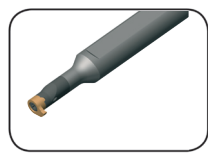
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

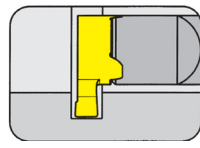
Typ 107
type

B107
Klemmhalter
Toolholder

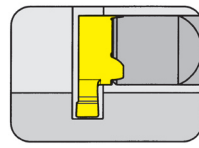


Seite/Page
E2

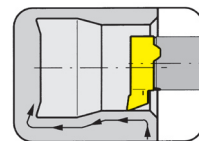
107
≥ Ø 7,0 mm
Schneidplatten
Inserts



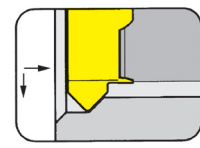
Seite/Page
E3



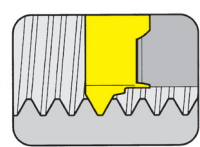
Seite/Page
E4



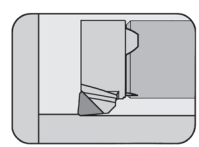
Seite/Page
E5



Seite/Page
E6



Seite/Page
E7



Seite/Page
E8

E

Technische Hinweise
Technical Instructions

Seite N2-N8
Page

EINSTECHEN und AUSDREHEN

GROOVING and BORING

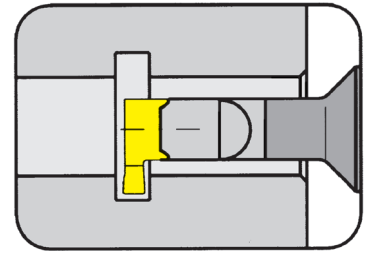


KLEMMHALTER Typ

TOOLHOLDER Type

B107

mit innerer Kühlmittelzufuhr
with through coolant supply

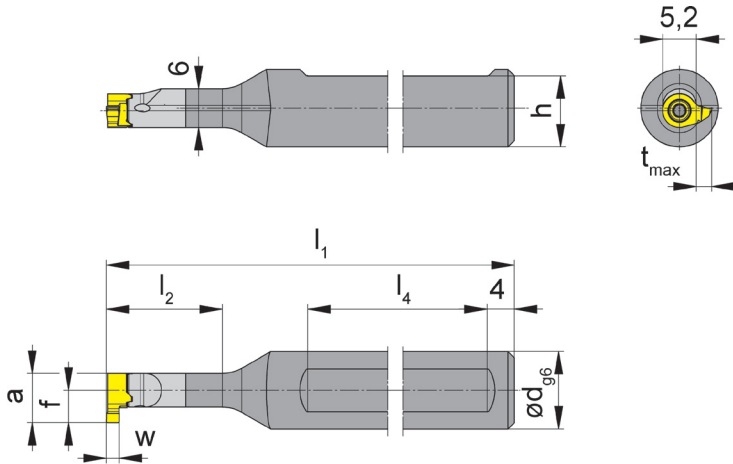


| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 7,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 107
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | d | l ₁ | l ₂ | h | l ₄ |
|------------------------------|----|----------------|----------------|----|----------------|
| R/LB107.0012.01 | | 80 | 18 | | |
| R/LB107.0012.02 | 12 | 90 | 26 | 11 | 45 |
| R/LB107.0012.03 | | 100 | 36 | | |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

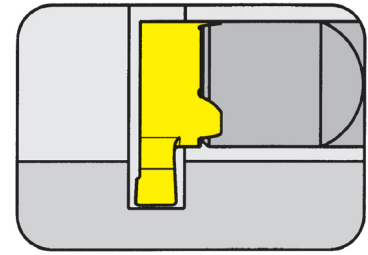
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB107.0012.0... | 2.2.5T7EP | T7PL |

EINSTECHEN (innen) $\geq \text{Ø } 7,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

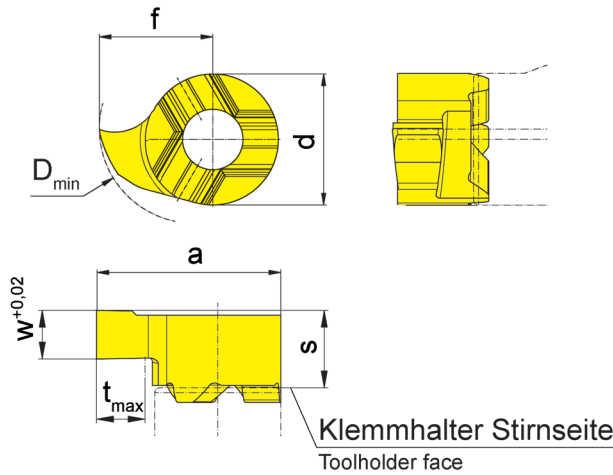
107



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 7,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,0 mm |
| Stechbreite bis | Width of groove up to | 1,5 mm |

für Klemmhalter
for use with Toolholder

Typ B107
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock | Δ 4 Wochen / 4 weeks | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

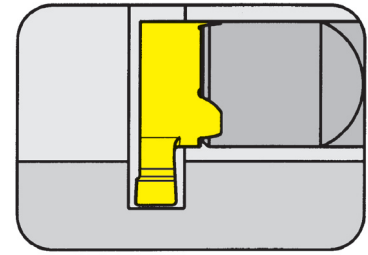


EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ
INSERT Type

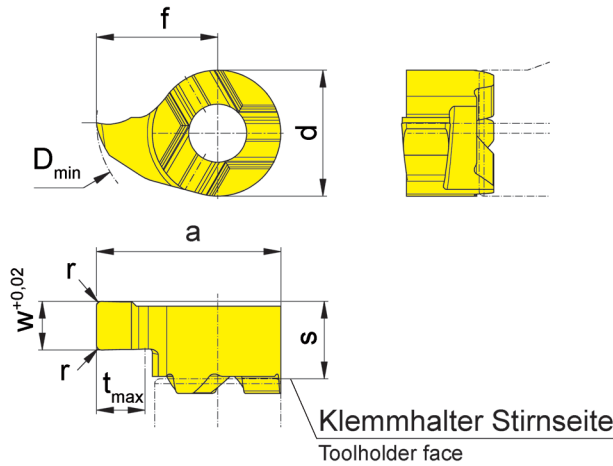
107



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 8,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B107
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock | | | | | | | | | | P | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | S | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

E

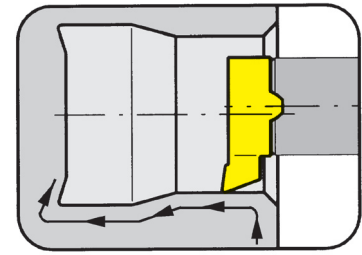
BOHRUNG-DREHEN $\geq \varnothing 6,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

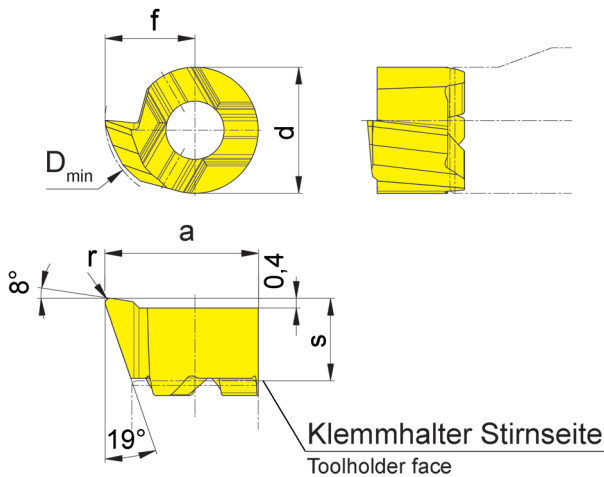
107



Bohrungs- \varnothing ab Bore \varnothing from 6,8 mm

für Klemmhalter
for use with Toolholder

Typ B107
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | 3,3 | 3,7 | 6,3 | 5,2 | 6,8 | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 6,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 6,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

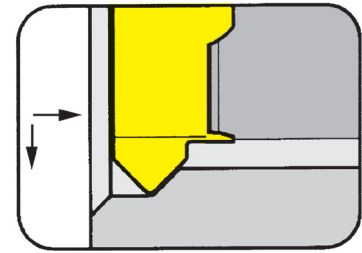


FASEN und RÜCKWÄRTSDREHEN (innen) CHAMFERING and BACKBORING (internal)

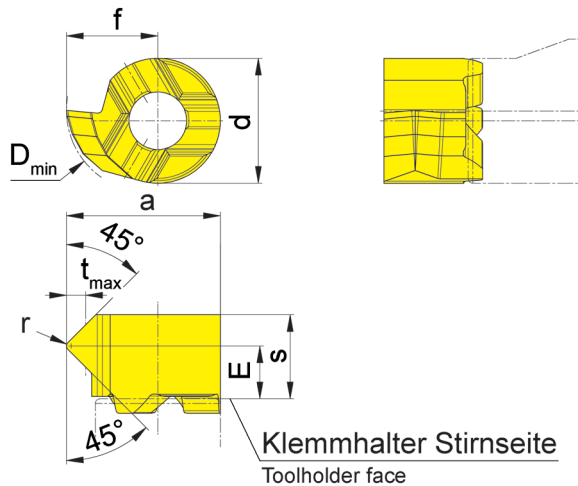


SCHNEIDPLATTE Typ
INSERT Type

107



| | | |
|-----------------------------------|-----------------------------------|------------------|
| Bohrungs-Ø ab Schnitttiefe bis | Bore Ø from Depth of cut up to | 6,8 mm 0,8 mm |
|-----------------------------------|-----------------------------------|------------------|



für Klemmhalter
for use with Toolholder

Typ B107
Type

E

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | E | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|-----|-----|-----|-----|------------------|------------------|------|------|------|------|
| R/L107.4545.1.02 | 2,2 | 0,2 | 3,5 | 3,8 | 6,4 | 5,2 | 0,8 | 6,8 | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

GEWINDEDREHEN (innen) Teilprofil

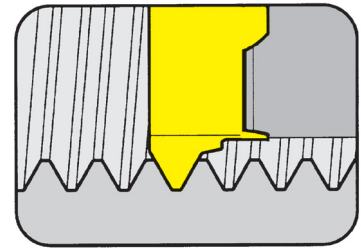
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

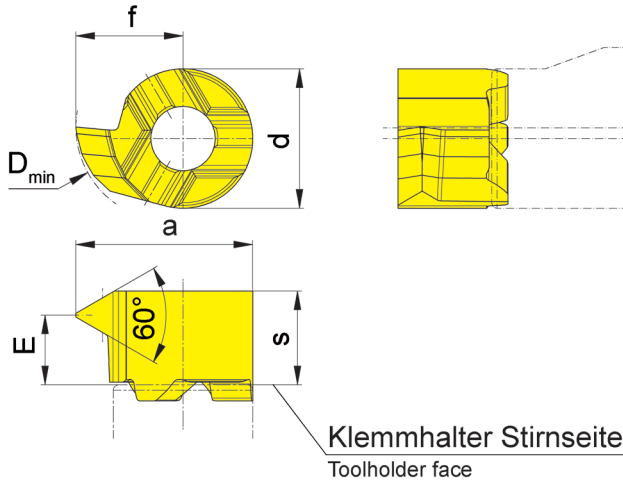
107



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 7,00 mm |
| Steigung | Pitch | 0,50 - 1,75 mm |

für Klemmhalter
for use with Toolholder

Typ B107
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | HM-Sorten / Carbide grades | | | |
|--|------------|-----|-----|---|-----|-----|------------------|----------------------------|------|------|------|
| | | | | | | | | 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 | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | P | | | ● |
| | | | | | | | | M | | | ● |
| | | | | | | | | K | | | ● |
| | | | | | | | | N | | | ● |
| | | | | | | | | S | | | ● |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



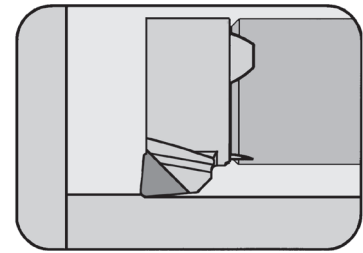
BOHRUNGEN HART AUSDREHEN

HARD BORING



SCHNEIDPLATTE Typ
INSERT Type

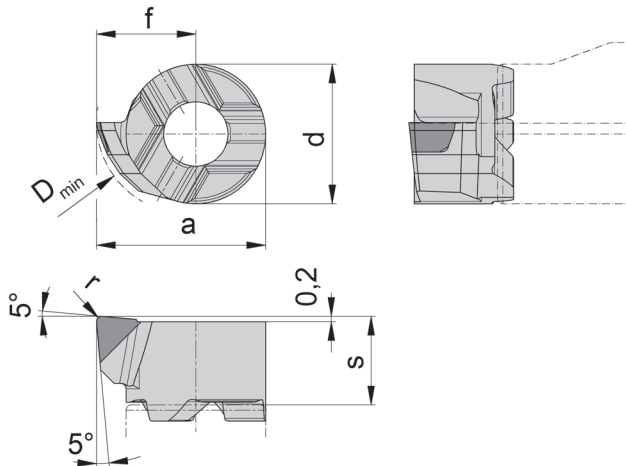
107



Bohrungs-Ø ab Bore Ø from 6,8 mm

für Klemmhalter
for use with Toolholder

Typ B107
Type



R = rechts wie gezeichnet
R = right hand version shown

CBN-bestückt
PCBN tipped

| Bestellnummer Part number | r | s | f | a | d | D _{min} | CB10 |
|---|-----|-----|-----|-----|-----|------------------|------|
| R107.0537.02.B | 0,2 | 3,3 | 3,7 | 6,3 | 5,2 | 6,8 | ▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P |
| ● Haupteinsatzbereich / main recommendation | | | | | | | M |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | N |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | S |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | H • |

Abmessungen in mm
Dimensions in mm
Weitere Abmessungen auf Anfrage
Further sizes upon request

E

Die Schnittstellen der Größen WFB 20 - 12 und WFB 24 - 16 sind für den Einsatz "Drehen" und "Fräsen" geeignet

Vorteile:

- flexibel
- präzise
- kompakt
- orientierte Schneidenlage

The interface sizes WFB 20 - 12 and WFB 24 - 16 are suitable for "turning" and "milling"

Advantages:

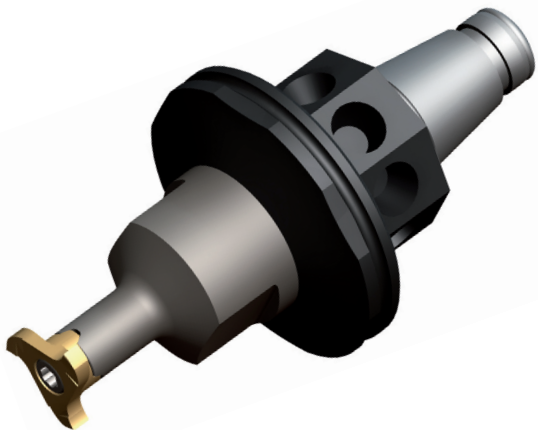
- flexible
- accurate
- compact
- orientated cutting position



Drehbearbeitung mit Supermini® Typ 105 und Typ 110

Turning with Supermini® type 105 - type 110

E



Fräsbearbeitung mit Einschraubfräser für Typ 306 - Typ 328

Milling with screw-in cutter for type 306 - 328



Drehbearbeitung mit Mini Typ 108 - Typ 114

Turning with Mini type 108 - type 114

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

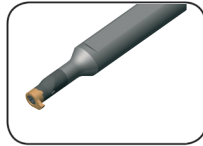
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

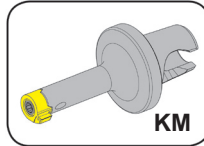
Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

Typ 108
type

B108
Klemmhalter
Toolholder

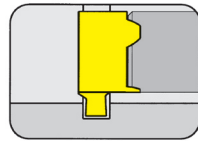


Seite/Page
F2-F3

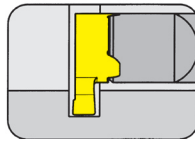


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F4-F5

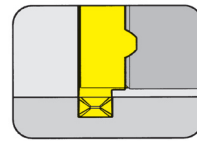
108 / S108
≥ Ø 8,0 mm
Schneidplatten
Inserts



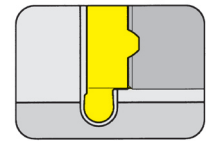
Seite/Page
F6



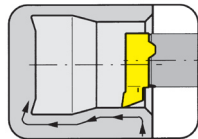
Seite/Page
F7-F9



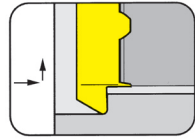
Seite/Page
F10



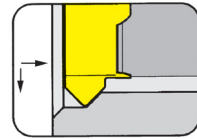
Seite/Page
F11



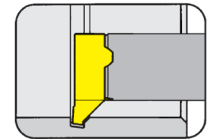
Seite/Page
F12-F13, F16



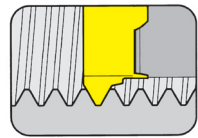
Seite/Page
F15



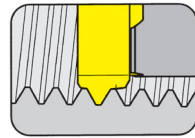
Seite/Page
F17



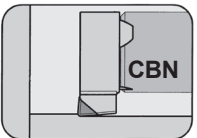
Seite/Page
F18



Seite/Page
F19-F20



Seite/Page
F21-F22



Seite/Page
F23

F

Technische Hinweise
Technical Instructions

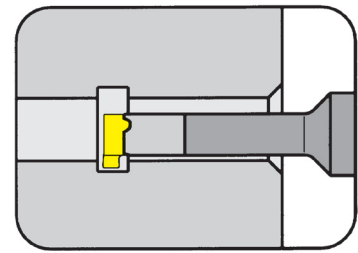
Seite N2-N8
Page

KLEMMHALTER Typ

TOOLHOLDER Type

B108

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 8,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 108
Type S108

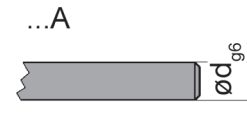
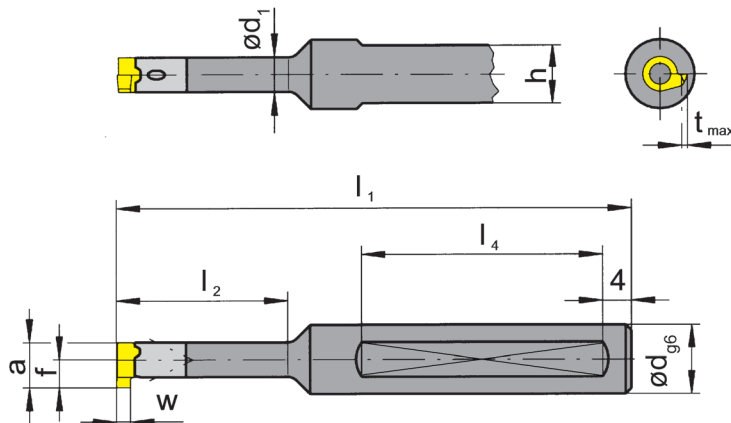


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B108.00... | 2.6.5T8EP | T8PL |

EINSTECHEN und AUSDREHEN

GROOVING and BORING

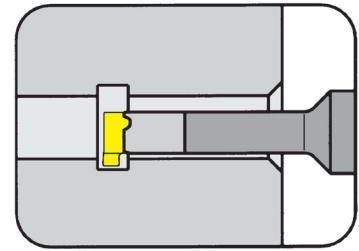


KLEMMHALTER Typ

TOOLHOLDER Type

B108

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 8,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,0 mm |
| Stechbreite bis | Width of groove up to | 2,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 108
Type S108

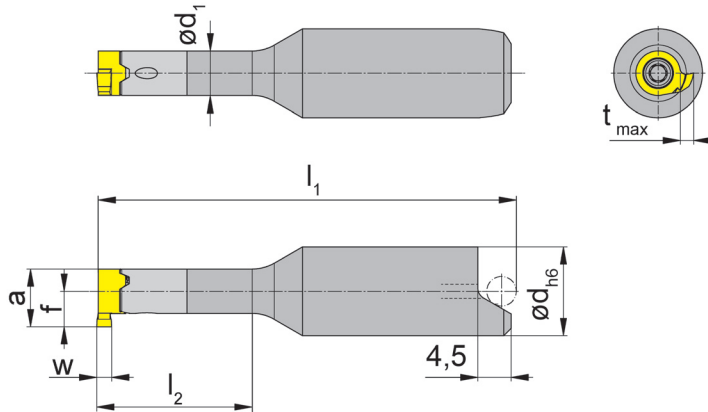


Abbildung = rechtsschneidend
Picture = right hand cutting version

zum lageorientierten
Schrumpfen
S = Lageorientierung
for shrinkage location
S = orientation

| Bestellnummer 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 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

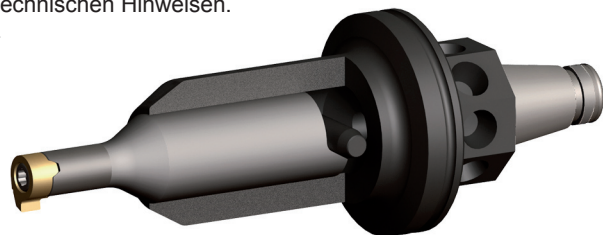
Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.



Einbaubeispiel System "W&F"
Example of assembly System "W&F"

Ersatzteile Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B108.0012.0... | 2.6.5T8EP | T8PL |



EINSTECHEN (innen) $\geq \varnothing 8,0$ mm

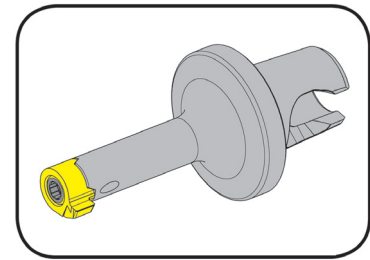
GROOVING (internal)



KLEMMHALTER Typ
TOOLHOLDER Type

B108KM

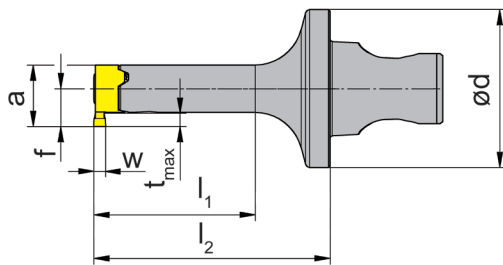
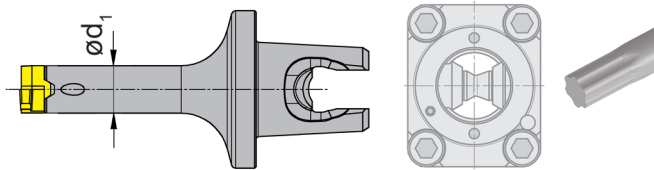
mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs- \varnothing ab Bore \varnothing from 8,0 mm

für Schneidplatte
for use with Insert

Typ 108
Type S108



System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

| Bestellnummer Part number | d | l ₁ | l ₂ | d ₁ |
|------------------------------|----|----------------|----------------|----------------|
| B108.KM16.01 | 20 | 21 | 30 | 6 |
| B108.KM16.02 | | 26 | 35 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B108.KM16.0... | 2.6.5T8EP | T8PL |

EINSTECHEN (innen) $\geq \varnothing 8,0$ mm

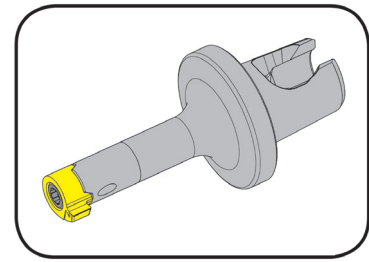
GROOVING (internal)



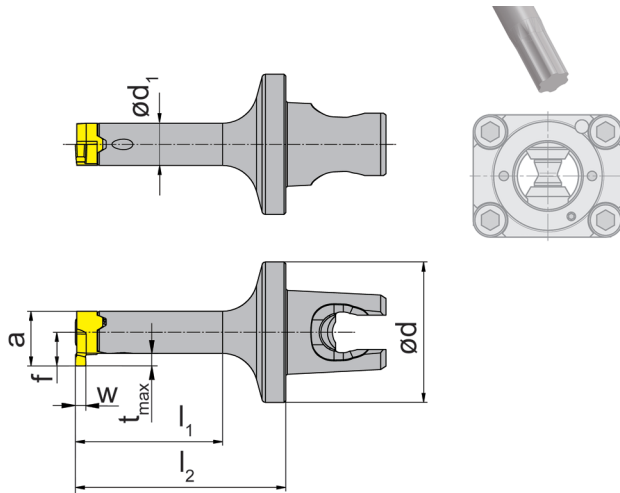
KLEMMHALTER Typ
TOOLHOLDER Type

B108KM

mit innerer Kühlmittelzufuhr
with through coolant supply



Bohrungs- \varnothing ab Bore \varnothing from 8,0 mm



für Schneidplatte
for use with Insert

Typ 108
Type S108

F

System Kennametal
KM16 Micro
System Kennametal
KM16 Micro

| Bestellnummer Part number | d | l_1 | l_2 | d_1 |
|------------------------------|----|-------|-------|-------|
| B108.KM16.90.01 | 20 | 21 | 30 | 6 |
| B108.KM16.90.02 | | 26 | 35 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile
Spare parts

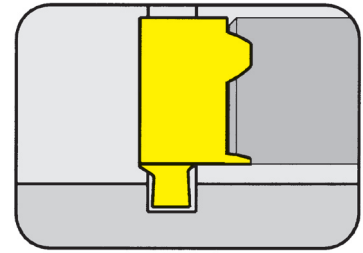
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B108.KM16.90.0... | 2.6.5T8EP | T8PL |

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)



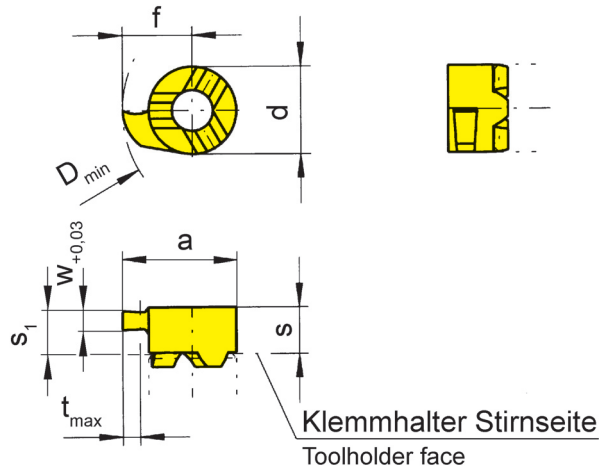
SCHNEIDPLATTE Typ INSERT Type

108



| | | |
|------------------|---------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 8,0 mm |
| Nutnennbreite Nw | Width of circlip Nw | 0,7 - 0,9 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



für Klemmhalter
for use with Toolholder

Typ B108
Type

F

Zapfenausführung
not face cutting,
limited depth of cut

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

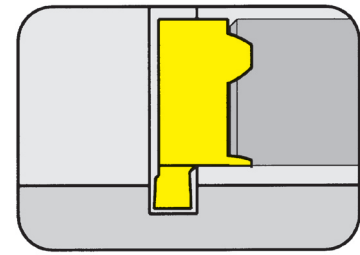
HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)



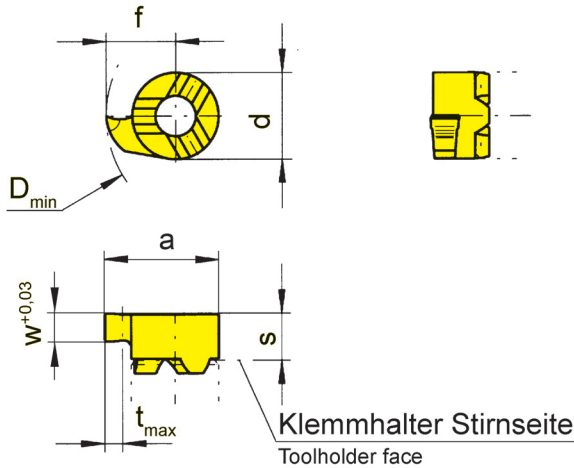
SCHNEIDPLATTE Typ INSERT Type

108



| | | |
|-----------------------------------|------------------------------------|------------------------|
| Bohrungs-Ø ab Nutnennbreite Nw | Bore Ø from Width of circlip Nw | 8,0 mm 1,1 - 1,6 mm |
|-----------------------------------|------------------------------------|------------------------|

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | o | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

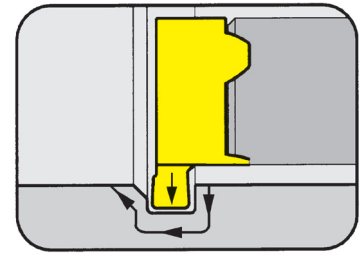
HM-Sorten
Carbide grades

NC-FEINDREHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ NC-PROFILING (internal)



SCHNEIDPLATTE Typ INSERT Type

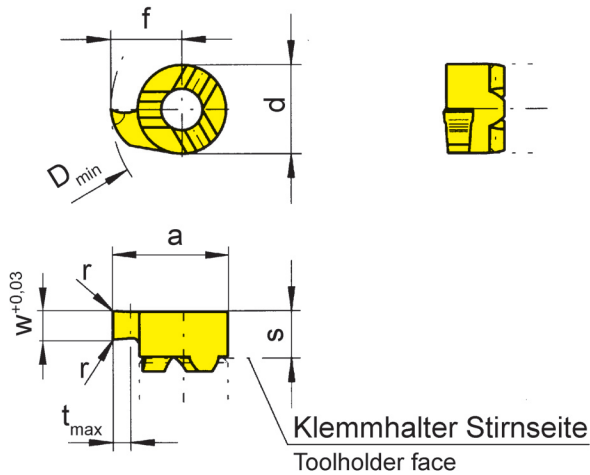
108



| | | |
|-----------------------------|--------------------------------|------------------|
| Bohrungs-Ø ab Stechtiefe | Bore Ø from Depth of groove | 8,0 mm 1,0 mm |
|-----------------------------|--------------------------------|------------------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

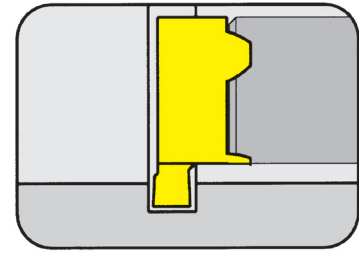
F

EINSTECHEN (innen) $\geq \varnothing 8,0$ mm GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

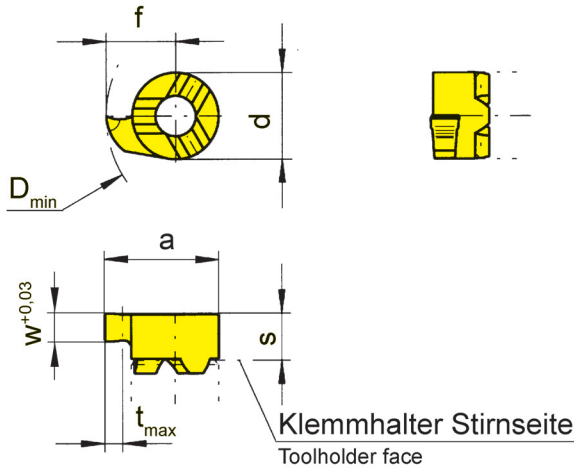
108



| | | |
|---|--|------------------------|
| Bohrungs- \varnothing ab Stechbreite | Bore \varnothing from Width of groove | 8,0 mm 1,5 - 2,0 mm |
|---|--|------------------------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | |
| | | | | | | | | P | o | • |
| | | | | | | | | M | • | • |
| | | | | | | | | K | • | • |
| | | | | | | | | N | • | • |
| | | | | | | | | S | • | • |
| | | | | | | | | H | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

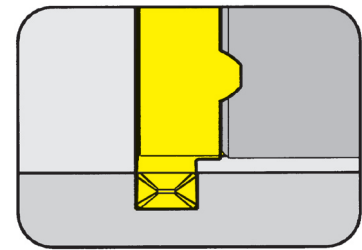
F

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

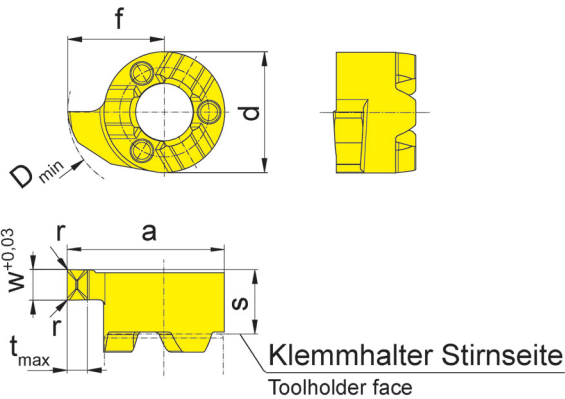
S108



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 8,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,0 mm |
| Stechbreite | Width of groove | 1,0 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B108
Type



F

Geometrie .D
Geometry .D

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | | | ● |
| | | | | | | | | | M | | | ● |
| | | | | | | | | | K | | | ● |
| | | | | | | | | | N | | | ● |
| | | | | | | | | | S | | | ● |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

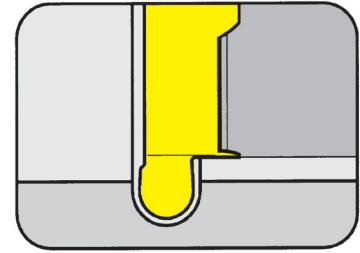
HM-Sorten
Carbide grades

EINSTECHEN (innen) $\geq \text{Ø } 8,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

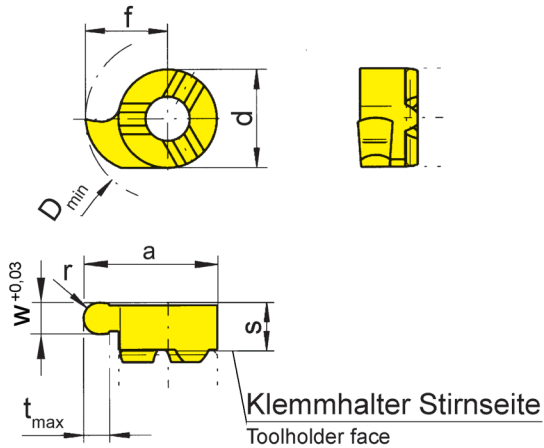
108



| | | |
|-----------------------------|----------------------------|--------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 8,0 mm r 0,4 - 0,9 mm |
|-----------------------------|----------------------------|--------------------------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Vollradius
Full radius

| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| | | | | | | | | | P | o | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



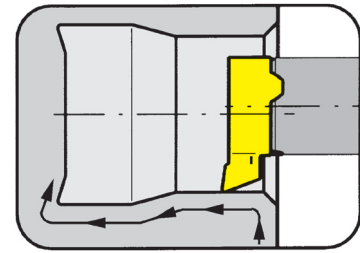
BOHRUNG-DREHEN $\geq \varnothing 7,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

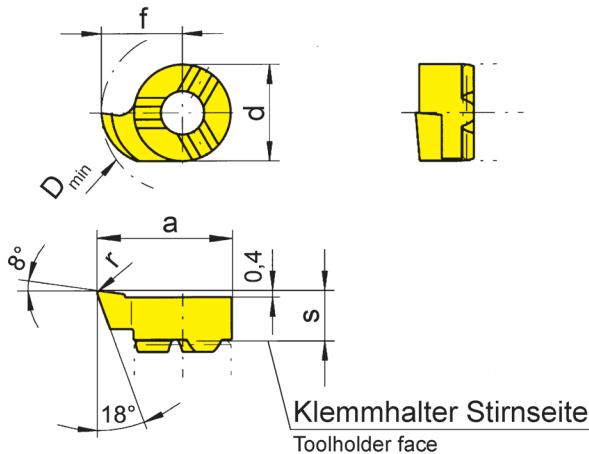
108



| | | |
|----------------------------|-------------------------|--------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 7,8 mm |
|----------------------------|-------------------------|--------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 7,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 7,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

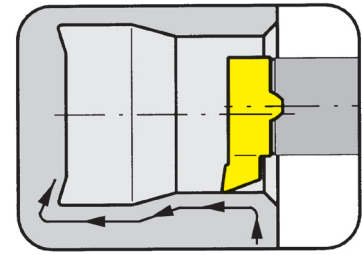
BOHRUNG-DREHEN $\geq \varnothing 7,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

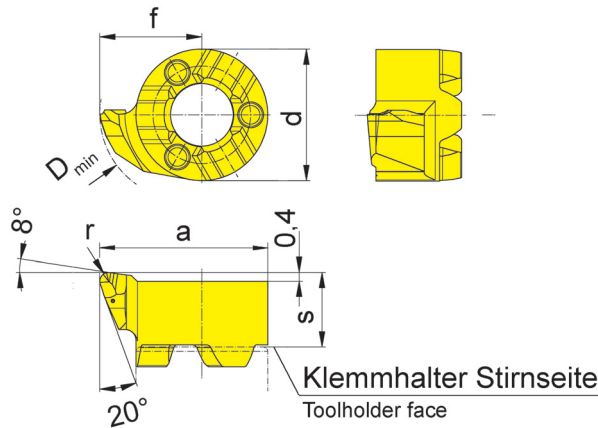
S108



Bohrungs- \varnothing ab Bore \varnothing from 7,8 mm

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .R
Geometry .R

| Bestellnummer 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 | | | | | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|--|---|
| P | | | | ● |
| M | | | | ● |
| K | | | | ● |
| N | | | | ● |
| S | | | | ● |
| H | | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 7,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 7,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request



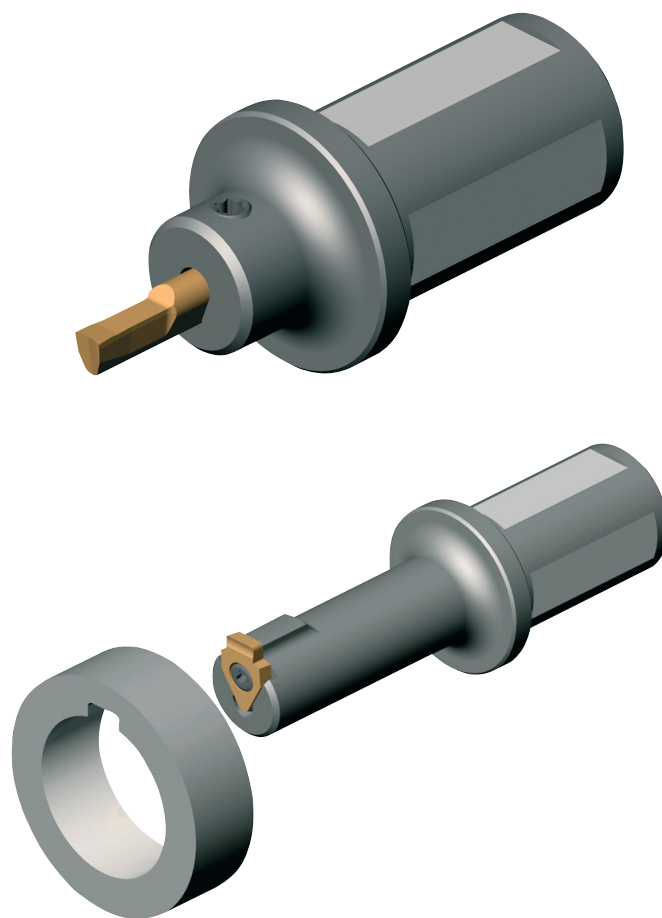
NUTSTOSSEN auf CNC-Drehmaschinen

BROACHING
on CNC lathes

STOSSWERKZEUGE TYP SB105/SB110 und SH117

BROACHING TOOLS TYPE SB105/SB110 and SH117

F



LÄNGSNUTEN NACH DIN138 und DIN6885

KEYWAYS ACCORDING DIN138 and DIN6885

Weitere Informationen finden Sie in unserem HORN-Katalog
"HARTMETALL-EINSTECHWERKZEUGE"

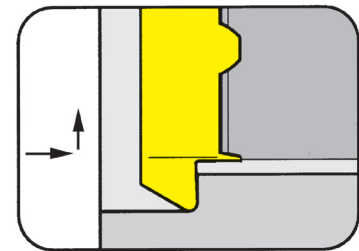
For further information please see the HORN catalogue "CARBIDE GROOVING TOOLS"

RÜCKWÄRTSDREHEN (innen) $\geq \varnothing 7,8$ mm BACKBORING (internal)

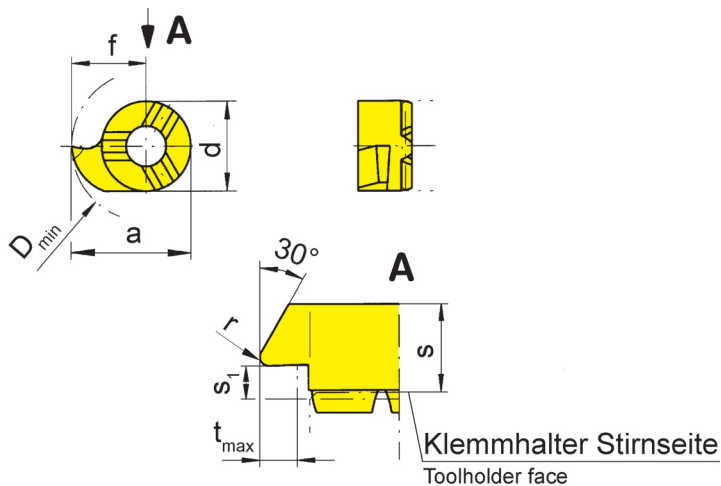


SCHNEIDPLATTE Typ INSERT Type

108



| | | |
|---|--|------------------|
| Bohrungs- \varnothing ab Profiltiefe bis | Bore \varnothing from Depth of undercut up to | 7,8 mm 1,3 mm |
|---|--|------------------|



für Klemmhalter
for use with Toolholder

Typ B108
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | • | | • |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | | • |
| ○ bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



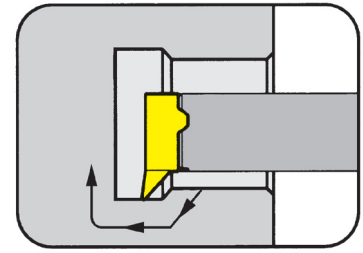
BOHRUNG-DREHEN $\geq \varnothing 7,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

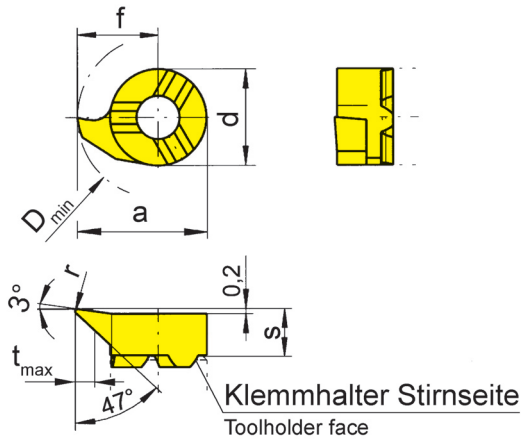
108



| | | |
|---|--|------------------|
| Bohrungs- \varnothing ab Profiltiefe bis | Bore \varnothing from Depth of undercut up to | 7,8 mm 1,2 mm |
|---|--|------------------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock | | | | | | | | | | | ● |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | | | ● |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | | o |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 7,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E.
The modified geometry allows boring of bores $\geq \varnothing 7,8$ mm and profiling of reliefs as per DIN 509 form E.

Weitere Abmessungen auf Anfrage
Further sizes upon request

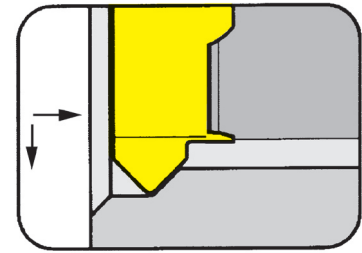
HM-Sorten
Carbide grades

FASEN und RÜCKWÄRTSDREHEN (innen) CHAMFERING and BACKBORING (internal)

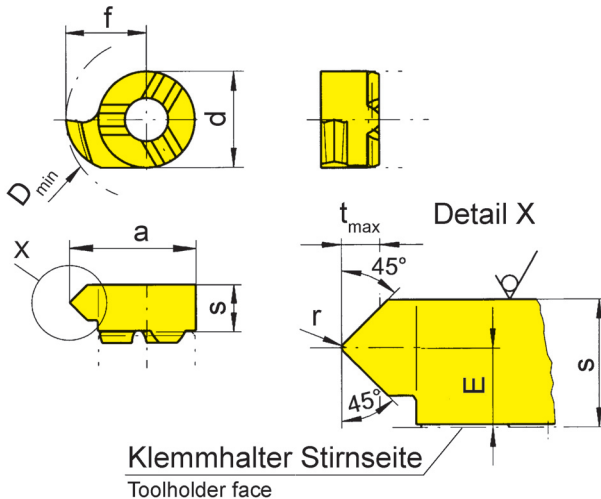


SCHNEIDPLATTE Typ
INSERT Type

108



| | | |
|-----------------------------------|-----------------------------------|------------------|
| Bohrungs-Ø ab Schnitttiefe bis | Bore Ø from Depth of cut up to | 7,8 mm 1,4 mm |
|-----------------------------------|-----------------------------------|------------------|



für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | ▲/▲ | ▲/▲ | ▲/▲ | |
| | | | | | | | | | | P | • | • | • | |
| | | | | | | | | | | M | • | • | • | |
| | | | | | | | | | | K | • | • | • | |
| | | | | | | | | | | N | • | • | • | |
| | | | | | | | | | | S | • | • | • | |
| | | | | | | | | | | H | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

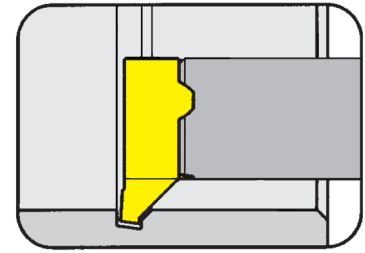
VORSTECHEN und FASEN (innen)

PREGROOVING and CHAMFERING (internal)



SCHNEIDPLATTE Typ
INSERT Type

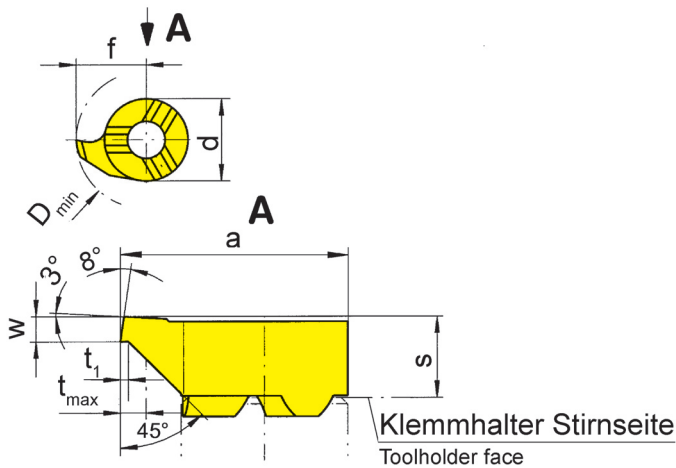
108



Bohrungs-Ø ab Bore Ø from 8,0 mm

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

F

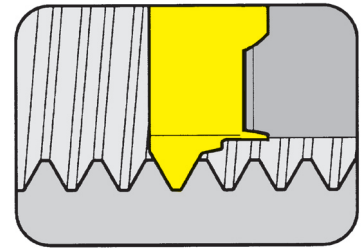
GEWINDEDREHEN (innen) Teilprofil

THREADING (internal) Partial profile



SCHNEIDPLATTE Typ
INSERT Type

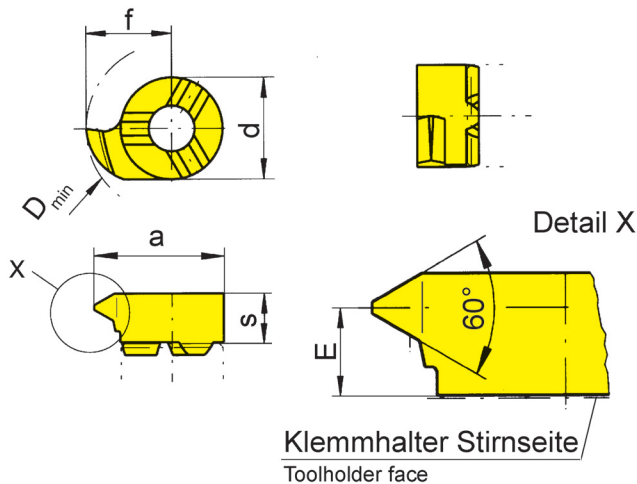
108



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 8,00 mm |
| Steigung | Pitch | 1,50 - 1,75 mm |

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Teilprofil

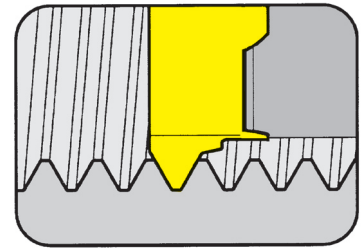
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

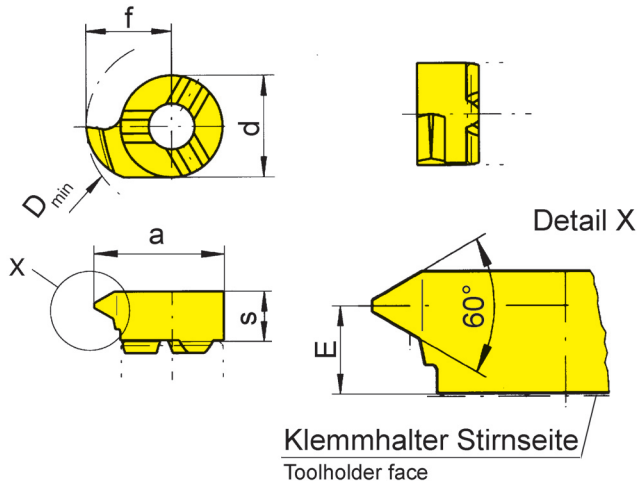
108



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 8,00 mm |
| Steigung | Pitch | 0,50 - 1,25 mm |

für Klemmhalter
for use with Toolholder

Typ B108
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO Feingewinde
Metric ISO fine thread

| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| | | | | | | | | | P | o | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

F

GEWINDEDREHEN (innen) Vollprofil

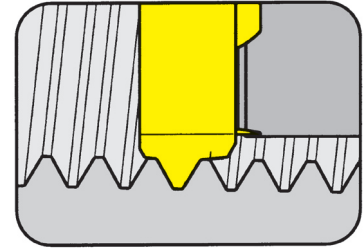
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

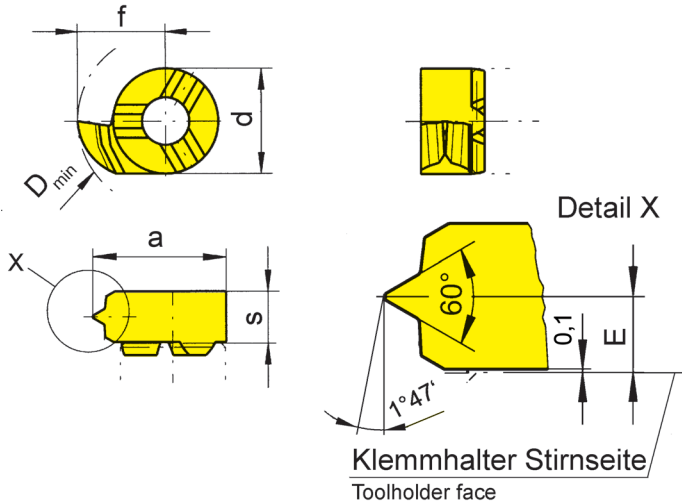
108



| | | |
|---------------|------------------|--------------|
| Gang pro Zoll | Threads per inch | 14 / 18 / 27 |
|---------------|------------------|--------------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

Gewinde NPT
Thread NPT



| Bestellnummer Part number | Gang/Zoll 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 | | | | | | | | ▲ | | |
| | | | | | | | | P | • | | |
| | | | | | | | | M | • | | |
| | | | | | | | | K | • | | |
| | | | | | | | | N | • | | |
| | | | | | | | | S | • | | |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

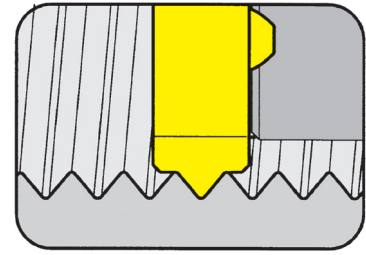
GEWINDEDREHEN (innen) Vollprofil

THREADING (internal) Full profile



SCHNEIDPLATTE Typ
INSERT Type

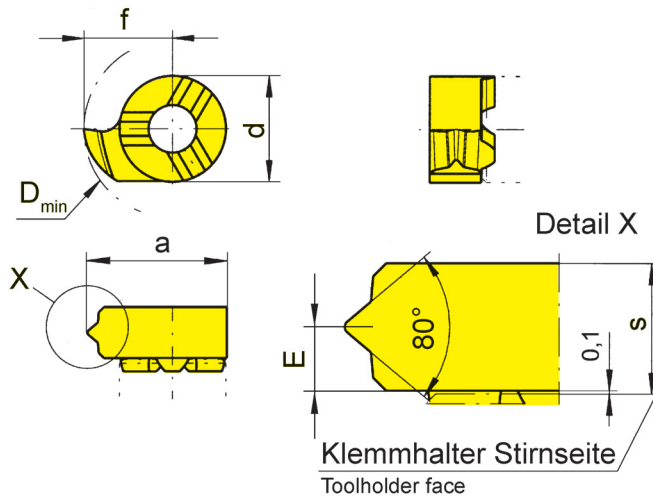
108



| | | |
|---------------|------------------|---------|
| Gang pro Zoll | Threads per inch | 18 / 20 |
|---------------|------------------|---------|

für Klemmhalter
for use with Toolholder

Typ B108
Type



R = rechts wie gezeichnet
R = right hand version shown

Stahlpanzerrohrgewinde
Thread profile PG

| Bestellnummer Part number | Gang/Zoll Threads per Inch | E | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|-------------------------------|-----|-----|-----|-----|---|------------------|------|------|------|------|
| R108.PG18.02 | 18 | | | | | | | | ▲ | | |
| R108.PG20.02 | 20 | 1,9 | 3,6 | 4,8 | 7,8 | 6 | 8 | | ▲ | | |
| ▲ ab Lager / on stock | Δ 4 Wochen / 4 weeks | | | | | | | P | • | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

F

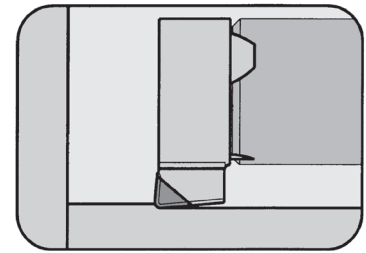
BOHRUNGEN HART AUSDREHEN

HARD BORING

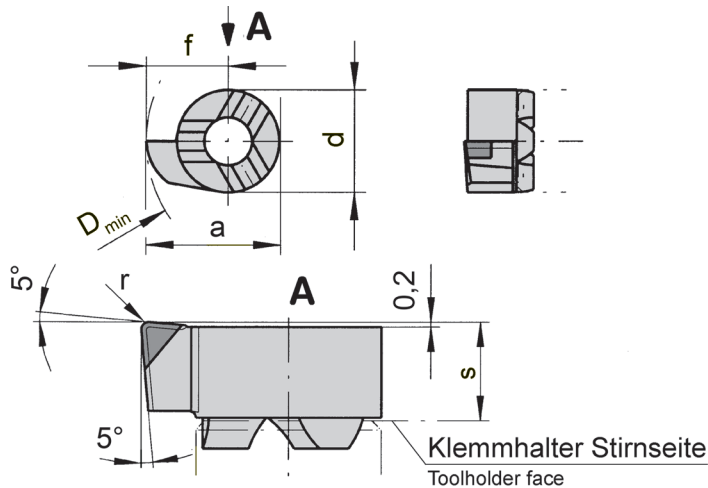


SCHNEIDPLATTE Typ
INSERT Type

108



Bohrungs-Ø ab Bore Ø from 7,8 mm



für Klemmhalter
for use with Toolholder

Typ B108
Type



CBN-bestückt
PCBN tipped

R = rechts wie gezeichnet
R = right hand version shown

| Bestellnummer 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 | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| |
|---|
| P |
| M |
| K |
| N |
| S |
| H |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

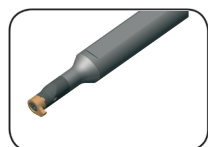
Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE

Mini CARBIDE GROOVING TOOLS

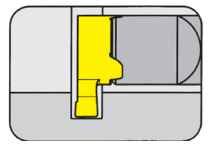
Typ 10P
type

B10P
Klemmhalter
Toolholder

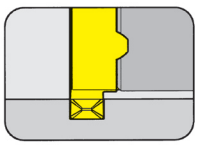


Seite/Page
G2-G4

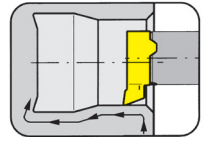
10P / S10P
≥ Ø 9,0 mm
Schneidplatten
Inserts



Seite/Page
G5, G7



Seite/Page
G6, G8



Seite/Page
G9



Technische Hinweise

Technical Instructions

Seite
Page

N2-N8

EINSTECHEN und AUSDREHEN

GROOVING and BORING

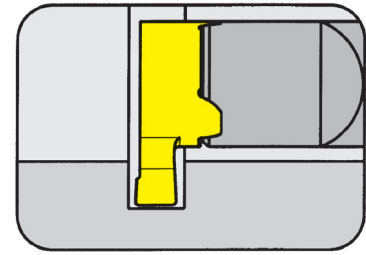


KLEMMHALTER Typ

TOOLHOLDER Type

B10P

mit innerer Kühlmittelzufuhr
with through coolant supply

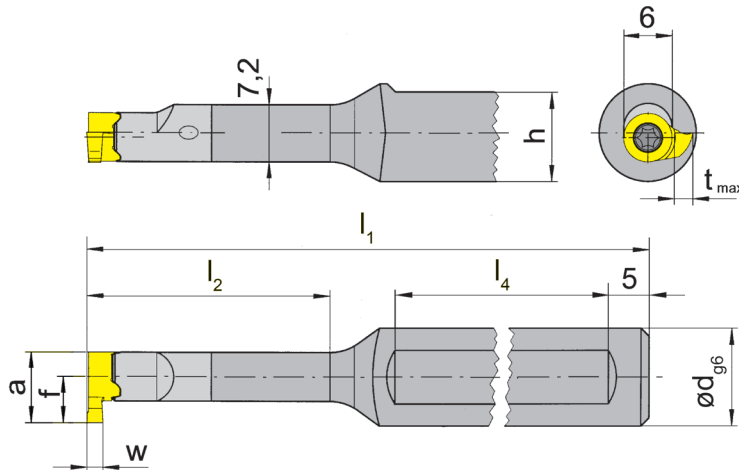


| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 9,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 10P
Type S10P



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB10P.0012.0... | 2.6.5T8EP | T8PL |

EINSTECHEN und AUSDREHEN

GROOVING and BORING

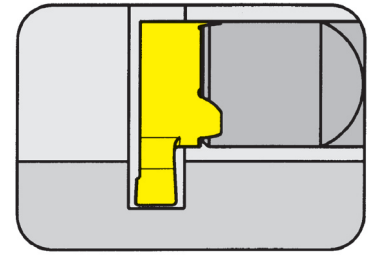


KLEMMHALTER Typ

TOOLHOLDER Type

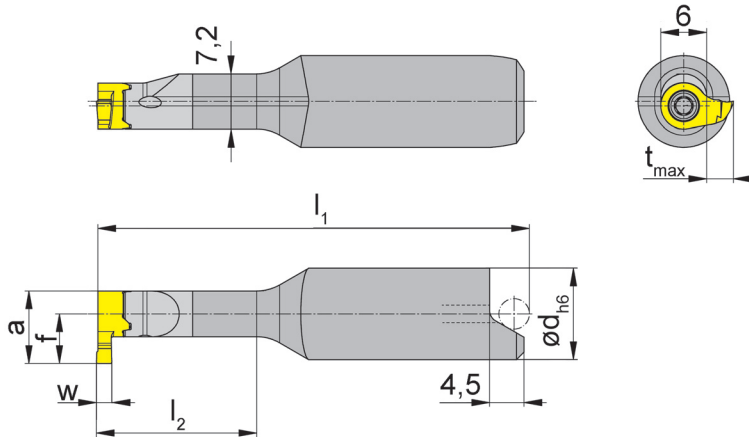
B10P

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 9,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance



für Schneidplatte
for use with Insert

Typ 10P
Type S10P

zum lageorientierten
Schrumpfen
S = Lageorientierung
for shrinkage location
S = orientation

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

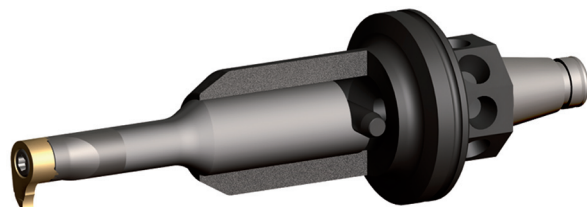
Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.



Einbaubeispiel System "W&F"
Example of assembly System "W&F"

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB10P.0012.0... | 2.6.5T8EP | T8PL |

EINSTECHEN und AUSDREHEN

GROOVING and BORING

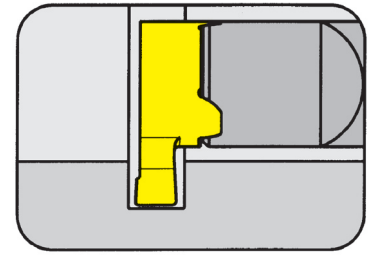


KLEMMHALTER Typ

TOOLHOLDER Type

B10P

mit innerer Kühlmittelzufuhr
with through coolant supply

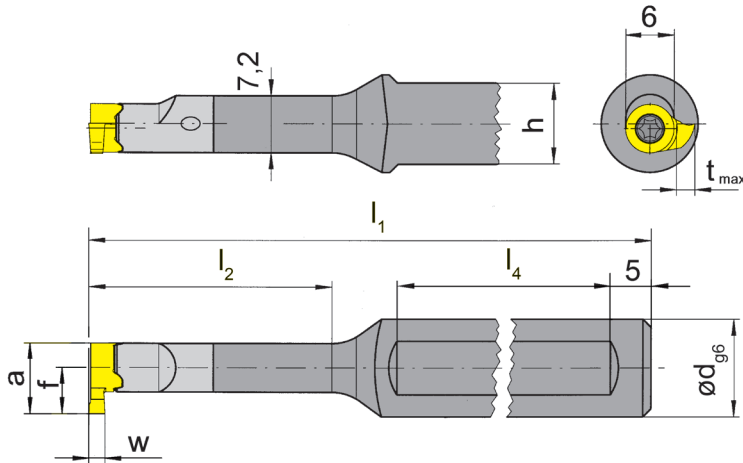


| | | |
|-----------------|-----------------------|--------|
| Bohrungs-Ø ab | Bore Ø from | 9,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 10P
Type S10P



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

mit 2 Spannflächen
with 2 clamping flats

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

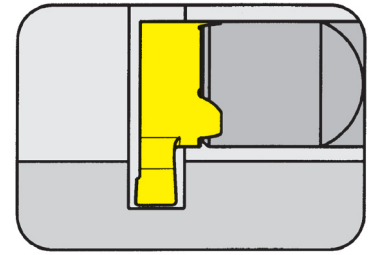
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB10P.0012.2.0... | 2.6.5T8EP | T8PL |

EINSTECHEN (innen) $\geq \text{Ø } 9,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

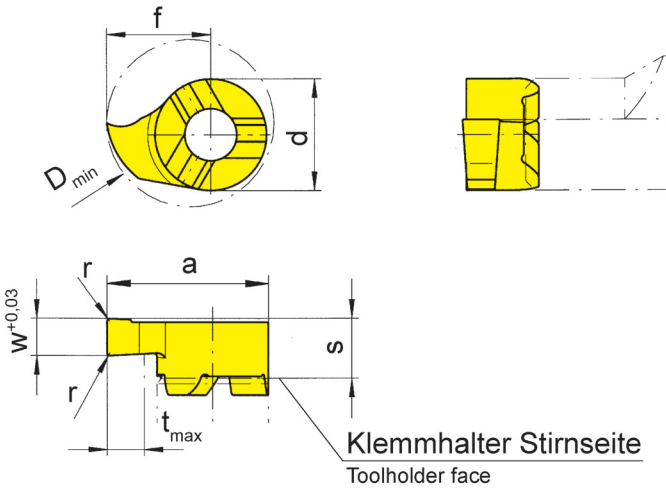
10P



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 9,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,0 mm |
| Stechbreite | Width of groove | 1,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B10P
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

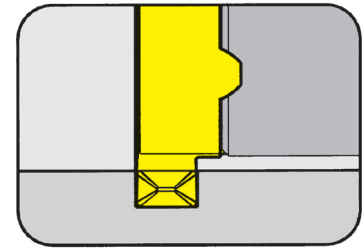


EINSTECHEN (innen) $\geq \text{Ø } 9,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

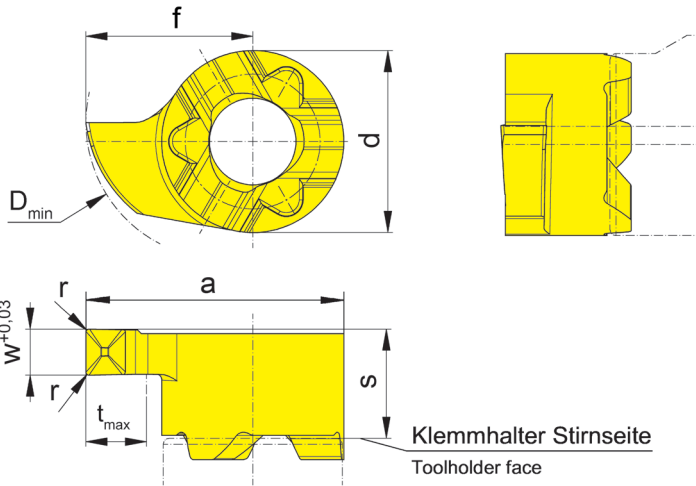
S10P



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 9,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,0 mm |
| Stechbreite | Width of groove | 1,0 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B10P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | | | | | | | ▲/Δ |
| R/LS10P.0150.1.D1 | 1,5 | 0,1 | 3,6 | 5,5 | 8,5 | 6 | 2 | 9 | | | | ▲/Δ |
| R/LS10P.0200.1.D2 | 2,0 | 0,2 | | | | | | | | | | ▲/Δ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | | | ● |
| | | | | | | | | | M | | | ● |
| | | | | | | | | | K | | | ● |
| | | | | | | | | | N | | | ● |
| | | | | | | | | | S | | | ● |
| | | | | | | | | | H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

G

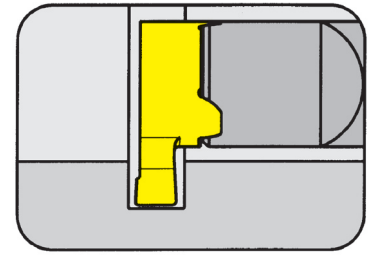
EINSTECHEN (innen) $\geq \text{Ø } 10,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ

10P

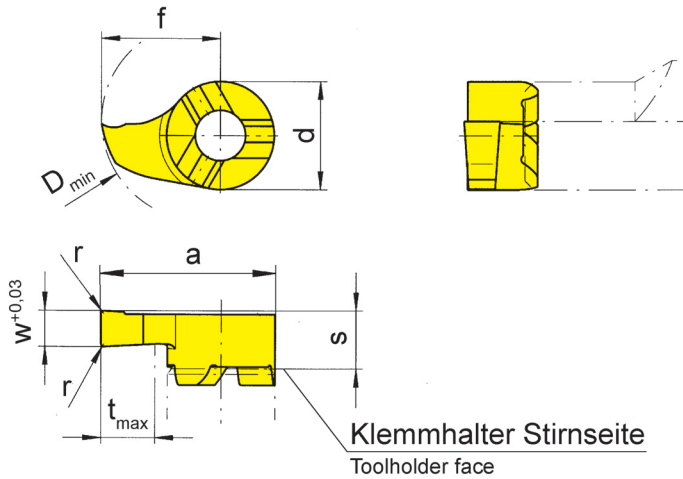
INSERT Type



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 10,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite | Width of groove | 1,0 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B10P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|--|-----|-----|-----|-----|-----|---|------------------|------------------|------|------|------|------|
| R/L10P.0100.2.00 | 1,0 | - | | | | | | | | | | ▲/Δ |
| 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation ○ bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | | | • |
| | | | | | | | | | M | | | • |
| | | | | | | | | | K | | | • |
| | | | | | | | | | N | | | • |
| | | | | | | | | | S | | | • |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

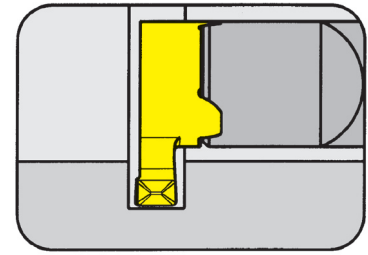


EINSTECHEN (innen) $\geq \text{Ø } 10,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

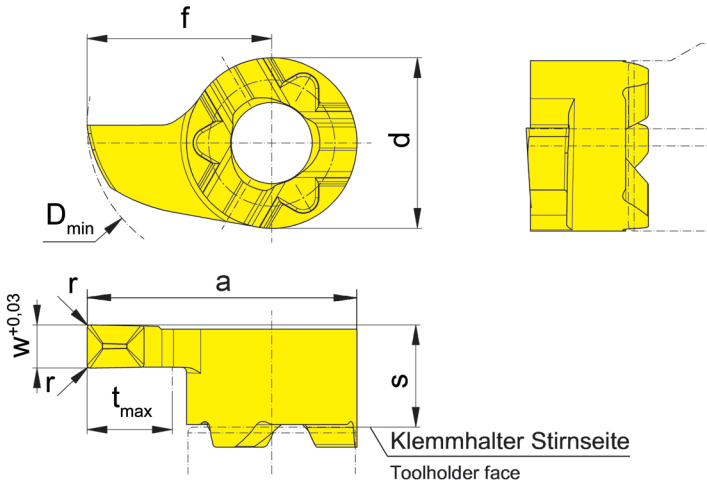
S10P



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 10,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite | Width of groove | 1,5 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B10P
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | ▲/Δ |
| R/LS10P.0200.2.D2 | 2,0 | 0,2 | | | | | | | ▲/▲ | | | |
| ▲ ab Lager / on stock | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

G

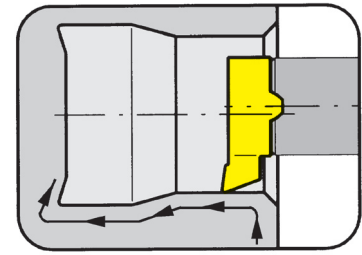
BOHRUNG-DREHEN $\geq \varnothing 8,8$ mm

BORING and PROFILING

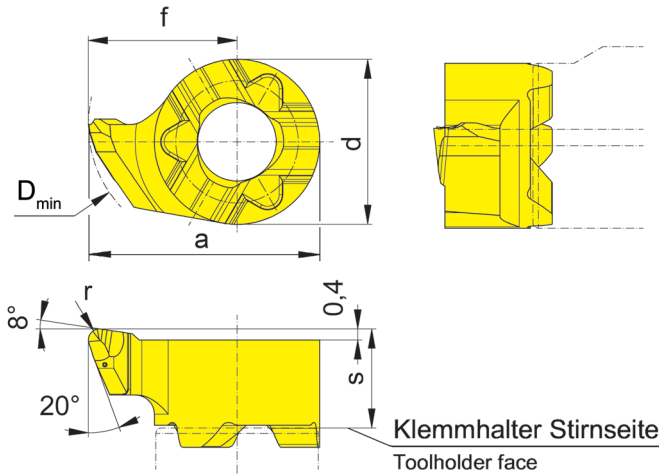


SCHNEIDPLATTE Typ INSERT Type

S10P



Bohrungs- \varnothing ab Bore \varnothing from 8,8 mm



für Klemmhalter
for use with Toolholder

Typ B10P
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .R
Geometry .R



| Bestellnummer Part number | r | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|---|------------------|------|------|------|------|
| LS10P.1854.R2 | 0,2 | | | | | | | | | ▲ |
| RS10P.1854.R2 | 0,2 | | | | | | | | | ▲ |
| LS10P.1854.R4 | 0,4 | 3,6 | 5,4 | 8,4 | 6 | 8,8 | | | | △ |
| RS10P.1854.R4 | 0,4 | | | | | | | | | ▲ |
| | | | | | | | P | | | • |
| | | | | | | | M | | | • |
| | | | | | | | K | | | • |
| | | | | | | | N | | | • |
| | | | | | | | S | | | • |
| | | | | | | | H | | | |

- ▲ ab Lager / on stock △ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | • |
| M | | | • |
| K | | | • |
| N | | | • |
| S | | | • |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 8,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 8,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

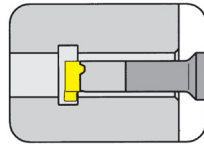
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

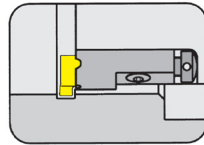
Typ 111
type

B111
Klemmhalter
Toolholder



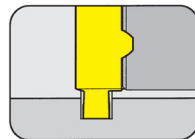
Seite/Page
H2-H4

125
Klemmhalter
Toolholder

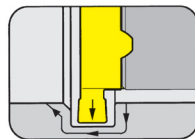


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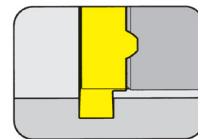
111 / S111
≥ Ø 10,0 mm
Schneidplatten
Inserts



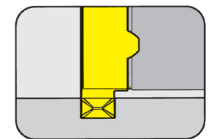
Seite/Page
H6



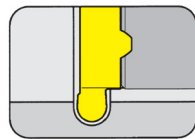
Seite/Page
H8



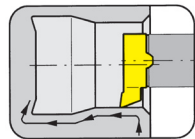
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H7, H9



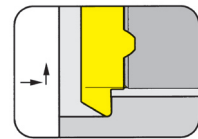
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H10



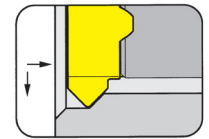
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H11



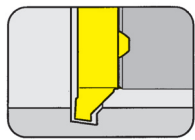
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H12-H13, H15



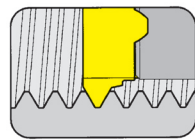
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H14



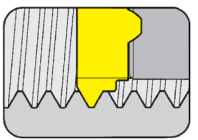
Seite/Page
H16



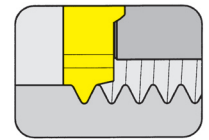
Seite/Page
H17



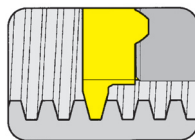
Seite/Page
H18-H19



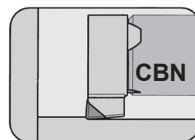
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H20-H21



Seite/Page
H22



Seite/Page
H23



Seite/Page
H24



Technische Hinweise
Technical Instructions

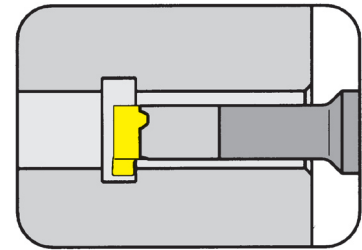
Seite N2-N8
Page

KLEMMHALTER Typ

TOOLHOLDER Type

B111

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 111
Type S111

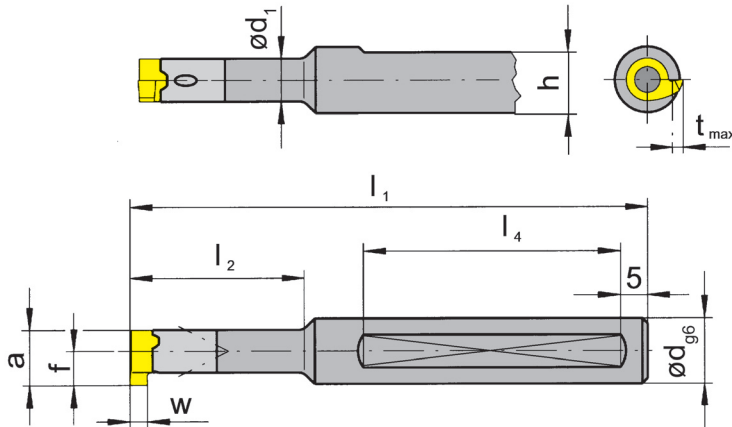


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

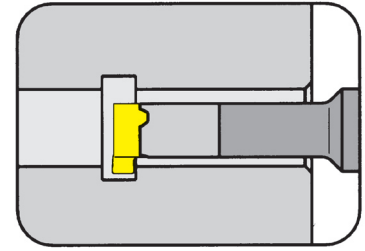
| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B111.00... | 3.5.12T10EP | T10PL |

KLEMMHALTER Typ

TOOLHOLDER Type

B111

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 111
Type S111

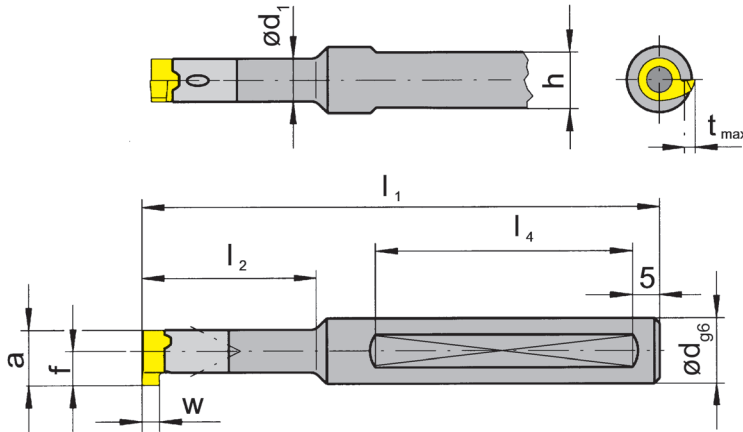


Abbildung = rechtsschneidend
Picture = right hand cutting version

mit 2 Spannflächen
with 2 clamping flats

| Bestellnummer 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 | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B111.0012.2.0... | 3.5.12T10EP | T10PL |



EINSTECHEN und AUSDREHEN

GROOVING and BORING

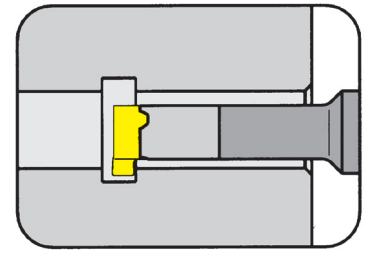


KLEMMHALTER Typ

TOOLHOLDER Type

B111

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 111
Type S111

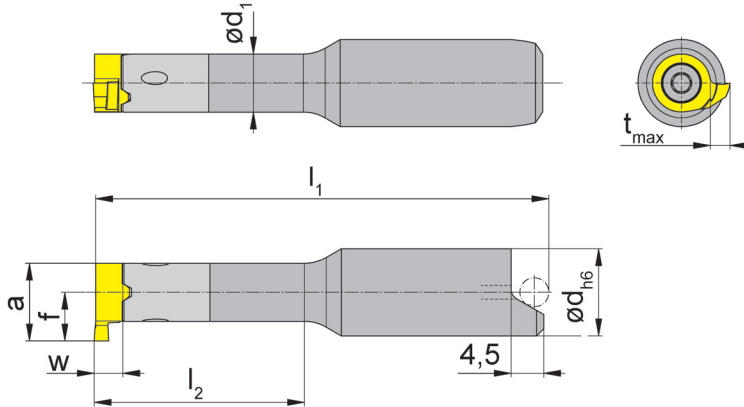


Abbildung = rechtsschneidend
Picture = right hand cutting version

zum lageorientierten
Schrumpfen
S = Lageorientierung
for shrinkage location
S = orientation

| Bestellnummer Part number | d | l ₁ | l ₂ | f | d ₁ |
|------------------------------|----|----------------|----------------|-----|----------------|
| B111.0012.00S | | 50,7 | 16,5 | | |
| B111.0012.01S | 12 | 62,7 | 29,0 | 6,7 | 8 |
| B111.0012.02S | | 75,7 | 42,0 | | |
| B111.0012.03S | | 89,7 | 56,0 | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

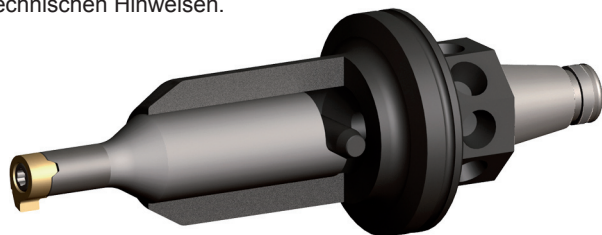
Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.



Einbaubeispiel System "W&F"
Example of assembly System "W&F"

Ersatzteile Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B111.0012.0... | 3.5.12T10EP | T10PL |

EINSTECHEN (innen) $\geq \text{Ø } 20,0 \text{ mm}$ GROOVING (internal)

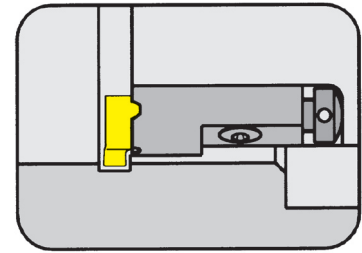


KURZKLEMMHALTER Typ

CARTRIDGE Type

125

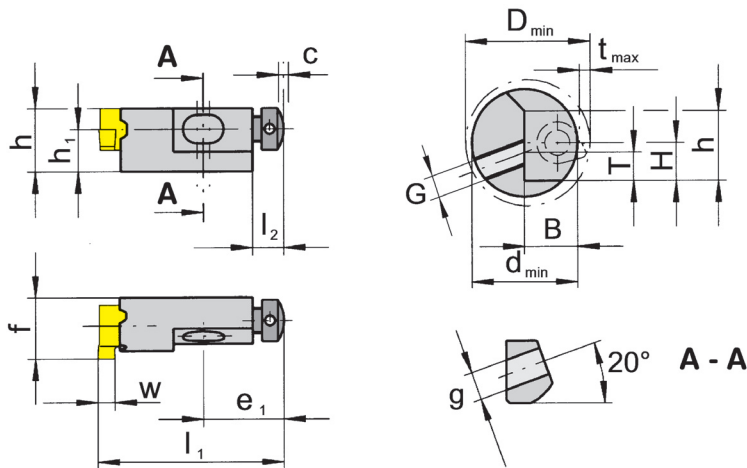
für Einbauzwecke
for customized tools



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 20,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

für Schneidplatte
for use with Insert

Typ 111
Type S111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | h_1 | f | h | l_1 | D_{min} | t_{max} | e_1 | l_2 | c | g | Spannbereich Clamping range |
|------------------------------|-------|------|----|-------|-----------|-----------|-------|-------|---|-----|--------------------------------|
| R/L125.0608.00 | 6 | 11,2 | 10 | 30 | 20 | 2,3 | 12,8 | 5 | 2 | 4,5 | 0,5 - 3,0 |

Ausführung R oder L angeben
State R or L version

w siehe Schneidplatten
w see inserts

Abmessungen in mm
Dimensions in mm

Schneidkantenhöhe h_1

Sonderhöhe $h_1 = 5 \text{ mm}$ auf Anfrage möglich

Height of cutting edge h_1

Special height $h_1 = 5 \text{ mm}$ available upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

| Einbaumaße Seating sizes | H | T | B | G | d_{min} | h |
|-----------------------------|---|-----|-----|----|-----------|----|
| R/L125.0608.00 | 6 | 4,5 | 8,5 | M4 | 16 | 10 |

Ersatzteile

Spare parts

| Kurzklemmhalter Cartridge | Befestigungsschraube Fixing screw | Spannschraube Screw | Stellschraube Adjusting screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|------------------------------|--------------------------------------|------------------------|----------------------------------|---|
| R/L125.0608.00 | 4.12.125 | 3.5.12T10EP | 4.06.020 | T10PL |



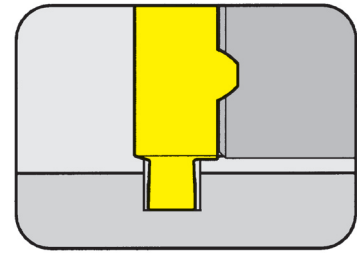
EINSTECHEN (innen) $\geq \text{Ø } 11,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ

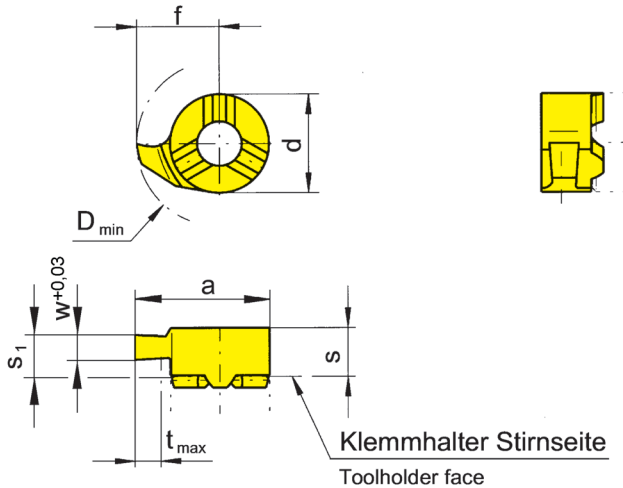
111

INSERT Type



| | | |
|------------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 1,5 mm |
| Nutnennbreite Nw | Width of circlip Nw | 0,7 - 0,9 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



Klemmhalter Stirnseite
Toolholder face

für Klemmhalter
for use with Toolholder

Typ 125
Type B111

Zapfenausführung
not face cutting,
limited depth of cut

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | ▲/▲ | | ▲/Δ |
| 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 | | ▲/Δ | ▲/▲ | | ▲/Δ |
| | | | | | | | | | | P | o | • | • |
| | | | | | | | | | | M | • | • | • |
| | | | | | | | | | | K | • | • | • |
| | | | | | | | | | | N | • | • | • |
| | | | | | | | | | | S | • | • | • |
| | | | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

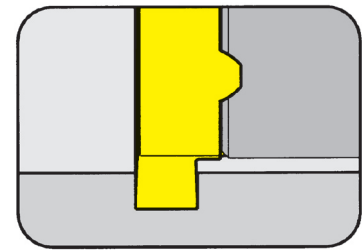
EINSTECHEN (innen) $\geq \text{Ø } 11,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ

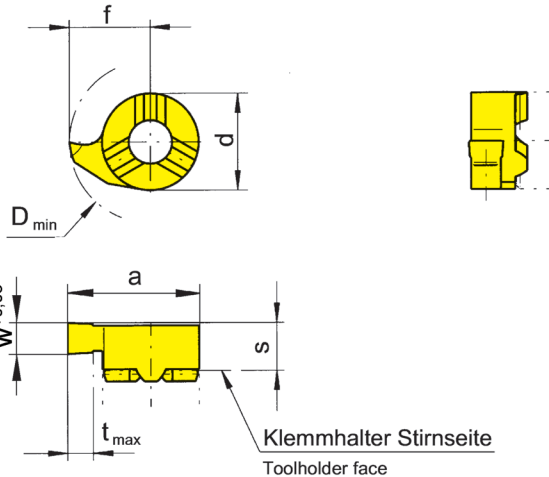
111

INSERT Type



| | | |
|------------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Nutnennbreite Nw | Width of circlip Nw | 1,1 - 1,6 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



für Klemmhalter
for use with Toolholder

Typ 125
Type B111

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | Nw | w | s | f | a | d | t _{max} | D _{min} | 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 | o | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



NC-FEINDREHEN (innen) $\geq \varnothing 11,0$ mm

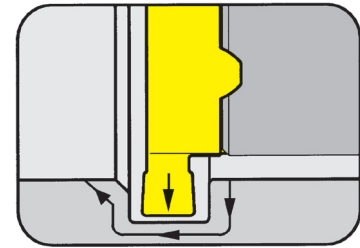
NC-PROFILING (internal)



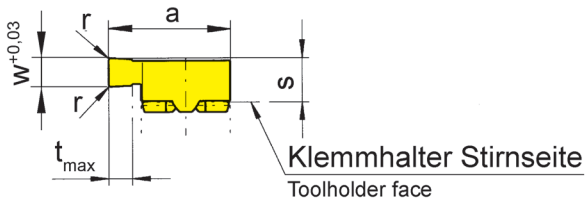
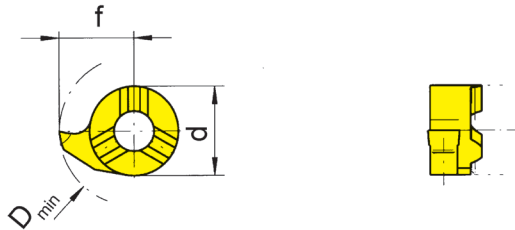
SCHNEIDPLATTE Typ

111

INSERT Type



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite | Width of groove | 2,0 mm |



für Klemmhalter
for use with Toolholder

Typ 125
Type B111

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

HM-Sorten
Carbide grades

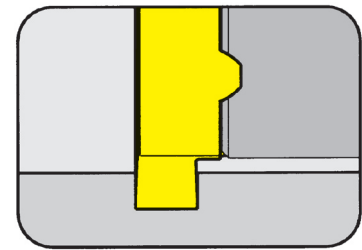
H

EINSTECHEN (innen) $\geq \text{Ø } 11,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

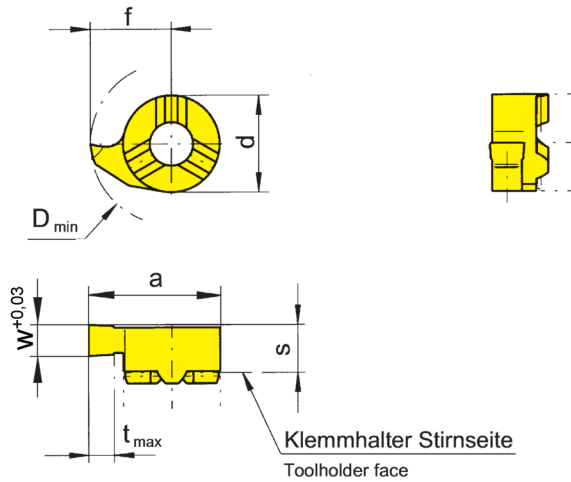
111



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite | Width of groove | 1,5 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | s | f | a | d | t _{max} | D _{min} | HM-Sorten | | | | |
|--|-----|------|-----|------|---|------------------|------------------|-----------|------|------|------|---|
| | | | | | | | | 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | P | o | ● | ● | |
| | | | | | | | | M | ● | ● | ● | ● |
| | | | | | | | | K | ● | ● | ● | ● |
| | | | | | | | | N | ● | ● | ● | ● |
| | | | | | | | | S | ● | ● | ● | ● |
| | | | | | | | | H | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

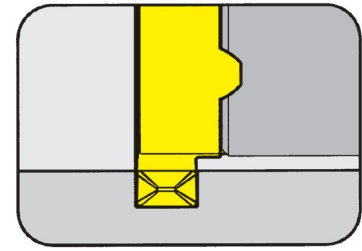


EINSTECHEN (innen) $\geq \text{Ø } 11,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

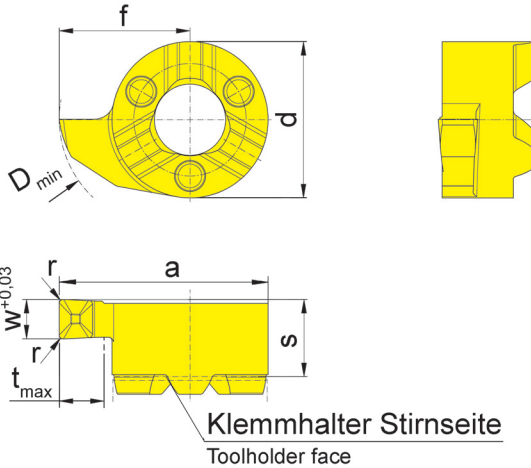
S111



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Stechbreite | Width of groove | 1,5 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer Part number | w | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|--|-----|-----|------|-----|------|---|------------------|------------------|------|------|------|------|
| R/LS111.0150.D1 | 1,5 | 0,1 | | | | | | | | | | ▲/Δ |
| 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 | | | | | | | | | | ▲/Δ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | | | ● |
| | | | | | | | | | M | | | ● |
| | | | | | | | | | K | | | ● |
| | | | | | | | | | N | | | ● |
| | | | | | | | | | S | | | ● |
| | | | | | | | | | H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

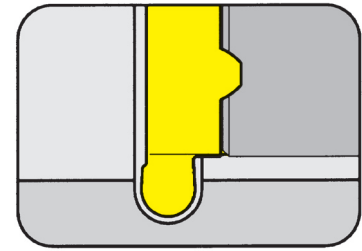
H

EINSTECHEN (innen) $\geq \varnothing 11,0$ mm GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

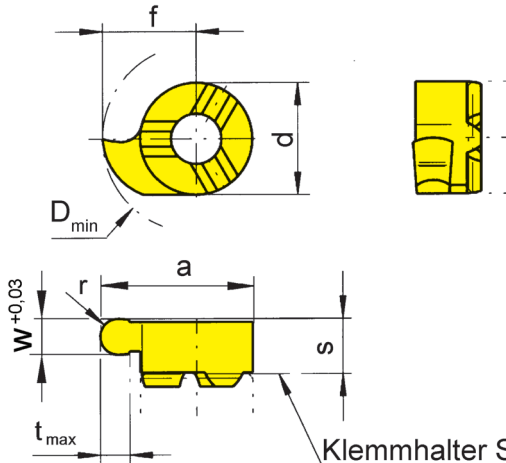
111



| | | |
|----------------------------|-------------------------|----------------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 11,0 mm |
| Stechtiefe bis | Depth of groove up to | 2,3 mm |
| Vollradius | Full radius | r 0,4 - 1,5 mm |

für Klemmhalter
for use with Toolholder

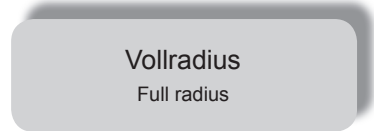
Typ 125
Type B111



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version



| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| MG12 | o | ● | ● | ● | ● | ● |
| TN35 | ● | ● | ● | ● | ● | ● |
| TI25 | ● | ● | ● | ● | ● | ● |
| TH35 | ● | ● | ● | ● | ● | ● |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request



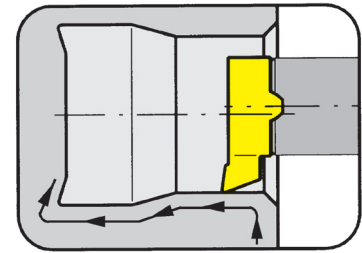
BOHRUNG-DREHEN $\geq \varnothing 9,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

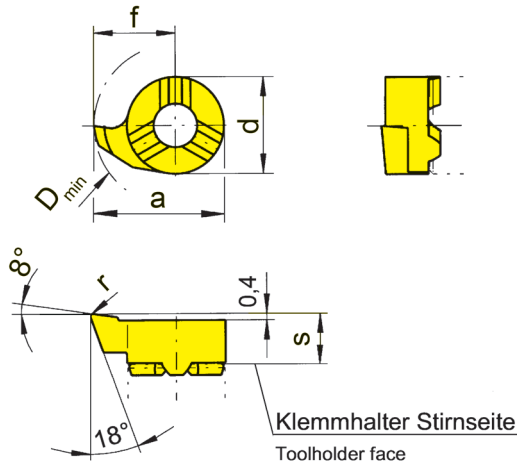
111



Bohrungs- \varnothing ab Bore \varnothing from 9,8 mm

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | D _{min} | HM-Sorten 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"> ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | P | o | • | • | • |
| | | | | | | | M | • | • | • | • |
| | | | | | | | K | • | • | • | • |
| | | | | | | | N | • | • | • | • |
| | | | | | | | S | • | • | • | • |
| | | | | | | | H | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 9,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 9,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

H

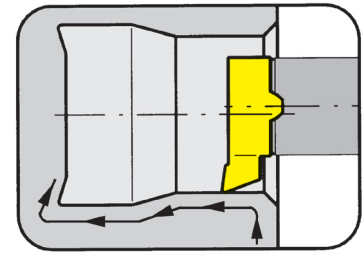
BOHRUNG-DREHEN $\geq \varnothing 11,0$ mm

BORING and PROFILING

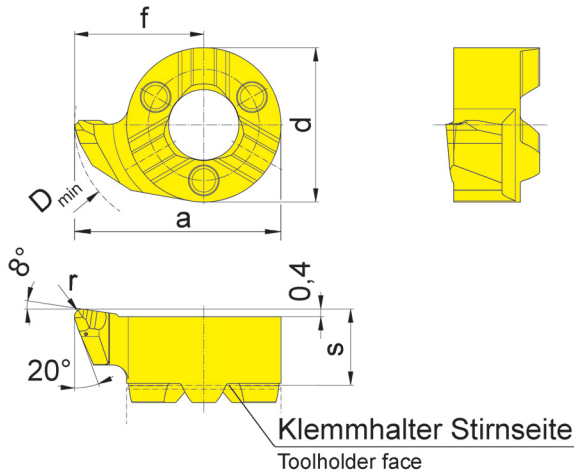


SCHNEIDPLATTE Typ INSERT Type

S111



Bohrungs- \varnothing ab Bore \varnothing from 11,0 mm



für Klemmhalter
for use with Toolholder

Typ 125
Type B111

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .R
Geometry .R

| Bestellnummer 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 | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 11,0$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 11,0$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

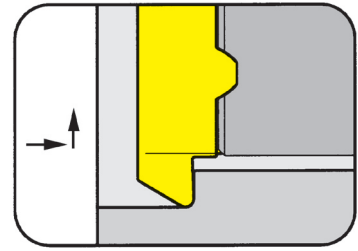


RÜCKWÄRTSDREHEN (innen) $\geq \varnothing 11,0$ mm BACKBORING (internal)

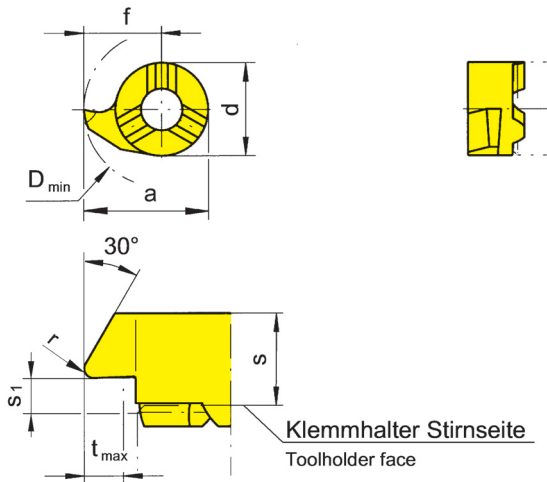


SCHNEIDPLATTE Typ INSERT Type

111



| | | |
|---|--|-------------------|
| Bohrungs- \varnothing ab Profiltiefe bis | Bore \varnothing from Depth of undercut up to | 11,0 mm 2,3 mm |
|---|--|-------------------|



für Klemmhalter
for use with Toolholder

Typ 125
Type B111

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | 1,4 | 4,15 | 6,7 | 10,7 | 8 | 2,3 | 11 | | /▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | • | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

BOHRUNG-DREHEN $\geq \varnothing 11,0$ mm

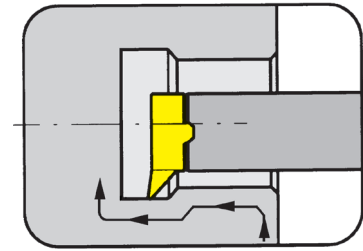
BORING and PROFILING



SCHNEIDPLATTE Typ 111

INSERT Type

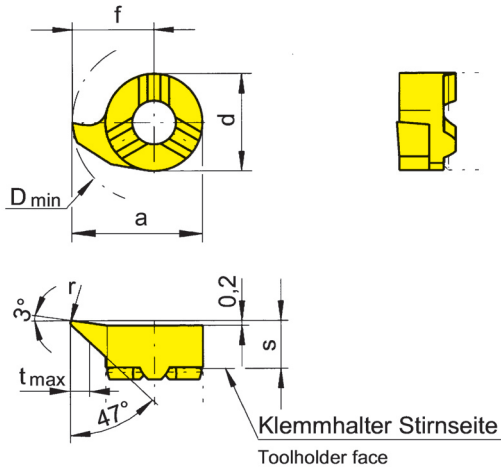
111



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 11,0 mm |
| Profiltiefe bis | Depth of undercut up to | 2,3 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ |
| | | | | | | | | P | • | • | • |
| | | | | | | | | M | • | • | • |
| | | | | | | | | K | • | • | • |
| | | | | | | | | N | • | • | • |
| | | | | | | | | S | • | • | • |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 11,0$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E.
The modified geometry allows boring of bores $\geq \varnothing 11,0$ mm and profiling of reliefs as per DIN 509 form E.

Weitere Abmessungen auf Anfrage
Further sizes upon request



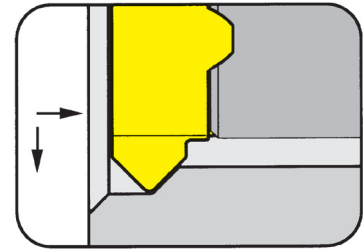
FASEN und RÜCKWÄRTSDREHEN (innen)

CHAMFERING and BACKBORING (internal)



SCHNEIDPLATTE Typ
INSERT Type

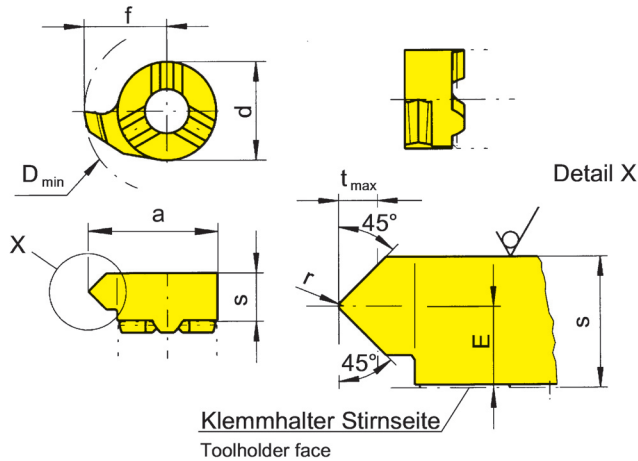
111



| | | |
|-----------------------------------|-----------------------------------|-------------------|
| Bohrungs-Ø ab Schnitttiefe bis | Bore Ø from Depth of cut up to | 11,0 mm 1,5 mm |
|-----------------------------------|-----------------------------------|-------------------|

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

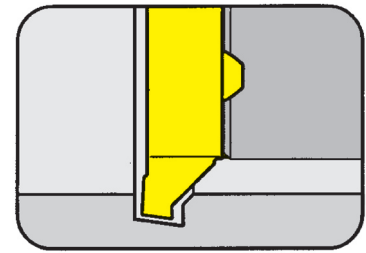
VORSTECHEN und FASEN (innen)

PREGROOVING and CHAMFERING (internal)

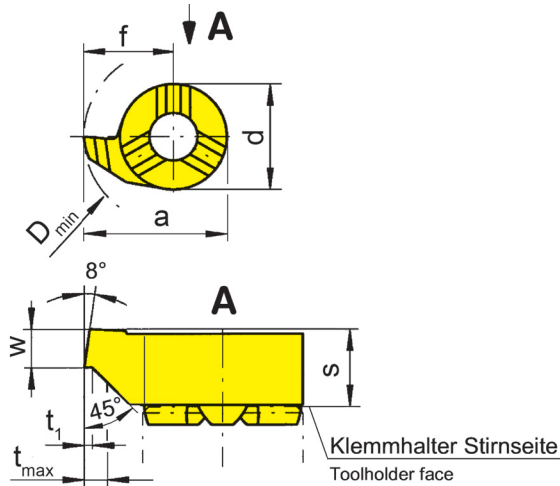


SCHNEIDPLATTE Typ
INSERT Type

111



Bohrungs-Ø ab Bore Ø from 11,0 mm



für Klemmhalter
for use with Toolholder

Typ 125
Type B111

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/△ | | ▲/▲ | |
| P | ○ | | | | | | | | | | ● | |
| M | ● | | | | | | | | | | ● | |
| K | ● | | | | | | | | | | ● | |
| N | ● | | | | | | | | | | ● | |
| S | ● | | | | | | | | | | ● | |
| H | | | | | | | | | | | | |

- ▲ ab Lager / on stock △ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Teilprofil

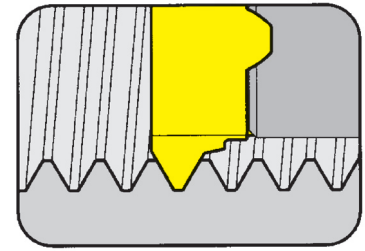
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

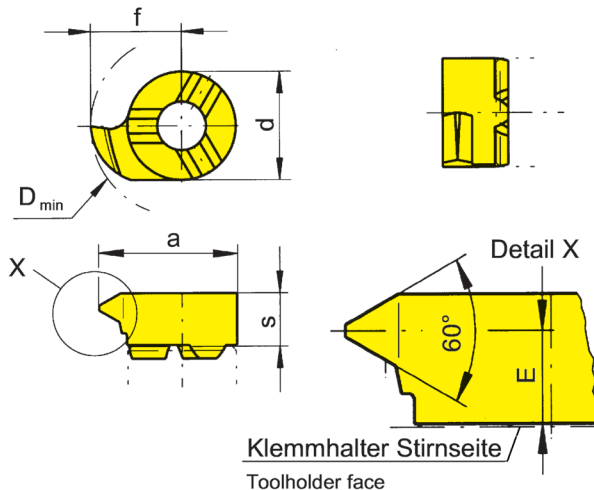
111



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Steigung | Pitch | 2,0 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer 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 | Δ/Δ | ▲/▲ | | ▲/ |
| ▲ ab Lager / on stock | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

GEWINDEDREHEN (innen) Teilprofil

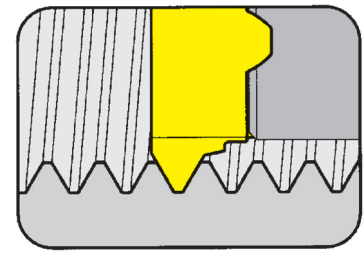
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

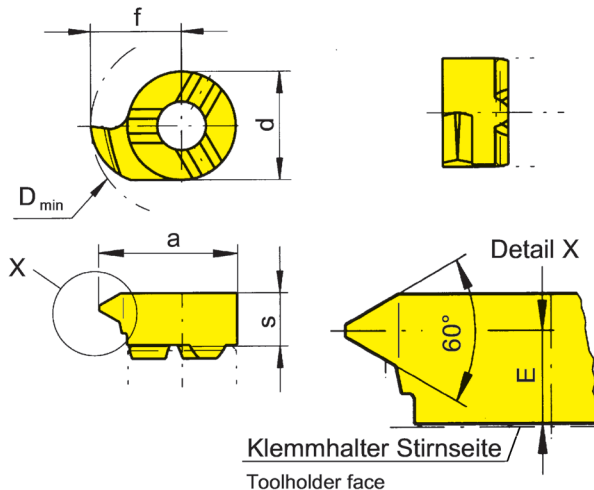
111



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 11,00 mm |
| Steigung | Pitch | 0,50 - 1,75 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Feingewinde
Metric ISO fine thread

| Bestellnummer 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 | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Vollprofil

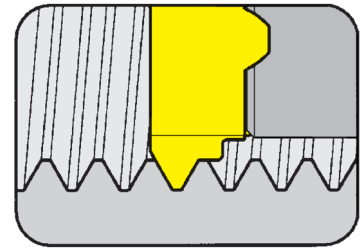
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

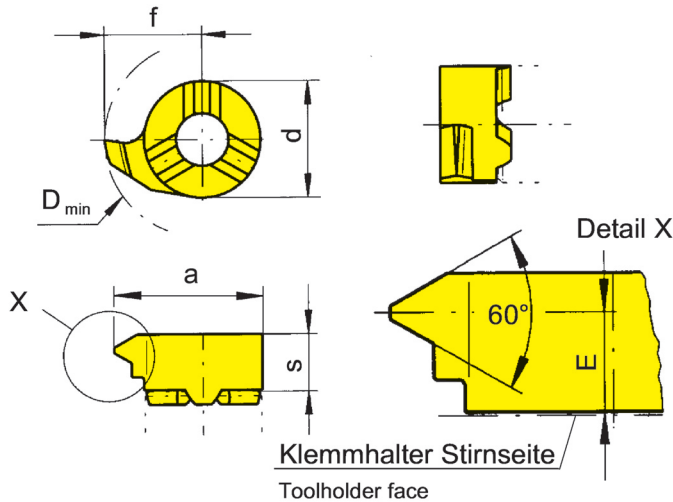
111



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Steigung | Pitch | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer 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 | | | | | | ▲/Δ | | | |
| | | | | | | | | P | • | | |
| | | | | | | | | M | • | | |
| | | | | | | | | K | • | | |
| | | | | | | | | N | • | | |
| | | | | | | | | S | • | | |
| | | | | | | | | H | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

GEWINDEDREHEN (innen) Vollprofil

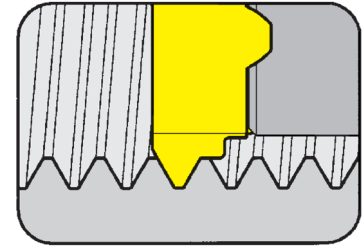
THREADING (internal) Full profile



SCHNEIDPLATTE Typ 111

INSERT Type

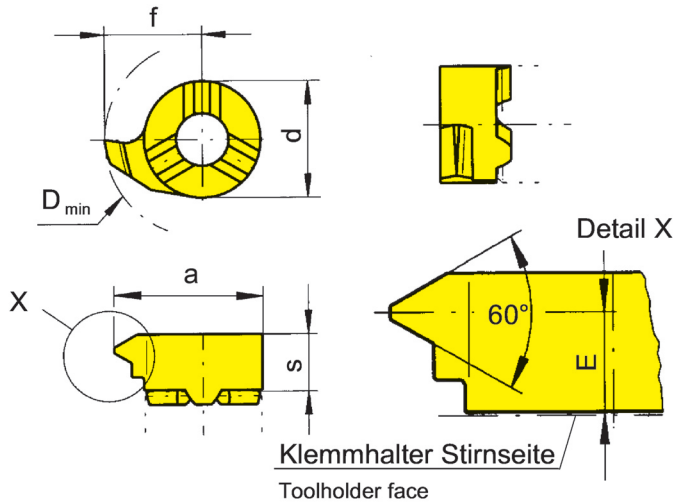
111



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Steigung | Pitch | 1,0 - 1,5 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO Feingewinde
Metric ISO fine thread

| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | | |
| | | | | | | | | P | o | • | • |
| | | | | | | | | M | • | • | • |
| | | | | | | | | K | • | • | • |
| | | | | | | | | N | • | • | • |
| | | | | | | | | S | • | • | • |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Vollprofil

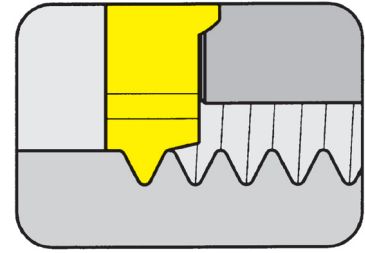
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

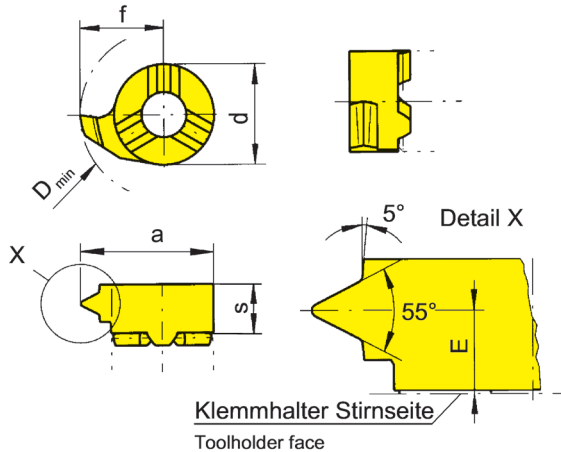
111



| | | |
|---------------|------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Gang pro Zoll | Threads per inch | 14/19 |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



Whitworth-Rohrgewinde
nach DIN ISO 228; (259)
und 2999

Whitworth pipe thread as per
DIN ISO 228; (259) and 2999

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | Gang/Zoll 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 | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

H

GEWINDEDREHEN (innen) Teilprofil

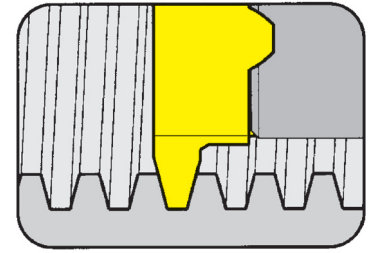
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ 111

INSERT Type

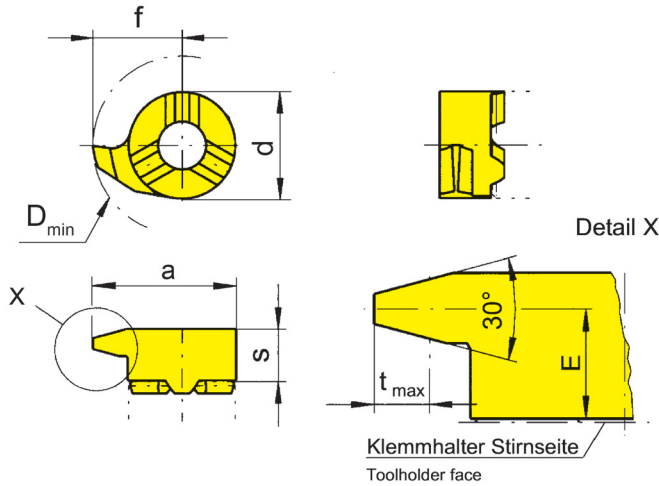
111



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,0 mm |
| Steigung | Pitch | 1,5 - 4,0 mm |

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Trapezgewinde DIN 103
Metric ISO trapezoidal
thread DIN 103

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | HM-Sorten / Carbide grades | | | |
|------------------------------|-----|-----|------|-----|------|---|------------------|----------------------------|------|------|------|
| | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L111.1015.01 | 1,5 | 3,5 | | | | | | ▲/Δ | | | |
| R/L111.1220.01 | 2,0 | 3,3 | | | | | | ▲/▲ | | | |
| R/L111.1730.01 | 3,0 | 3,0 | 4,15 | 6,7 | 10,7 | 8 | 11 | ▲/Δ | ▲/▲ | | |
| R/L111.2240.01 | 4,0 | 2,5 | | | | | | ▲/▲ | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



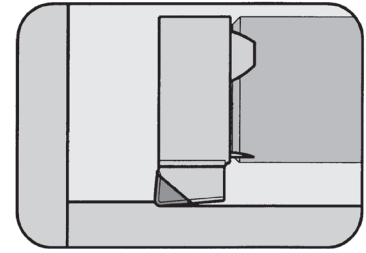
BOHRUNGEN HART AUSDREHEN

HARD BORING



SCHNEIDPLATTE Typ
INSERT Type

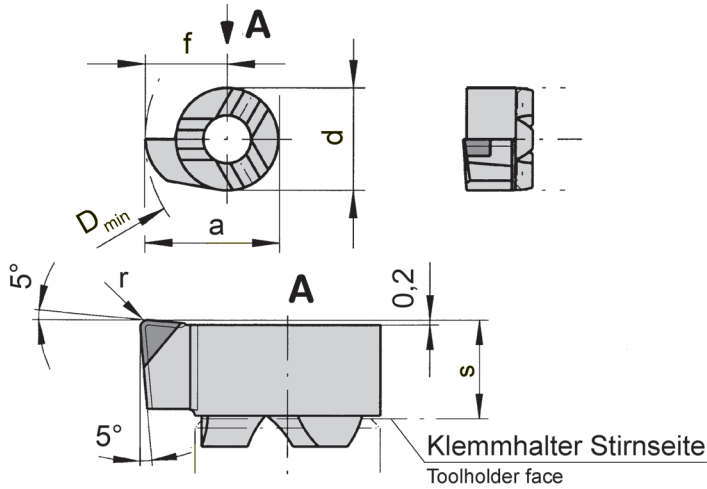
111



Bohrungs-Ø ab Bore Ø from 10,0 mm

für Klemmhalter
for use with Toolholder

Typ 125
Type B111



R = rechts wie gezeichnet
R = right hand version shown

CBN-bestückt
CBN tipped

H

| Bestellnummer 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 | △ |

- ▲ ab Lager / on stock △ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| |
|---|
| P |
| M |
| K |
| N |
| S |
| H |

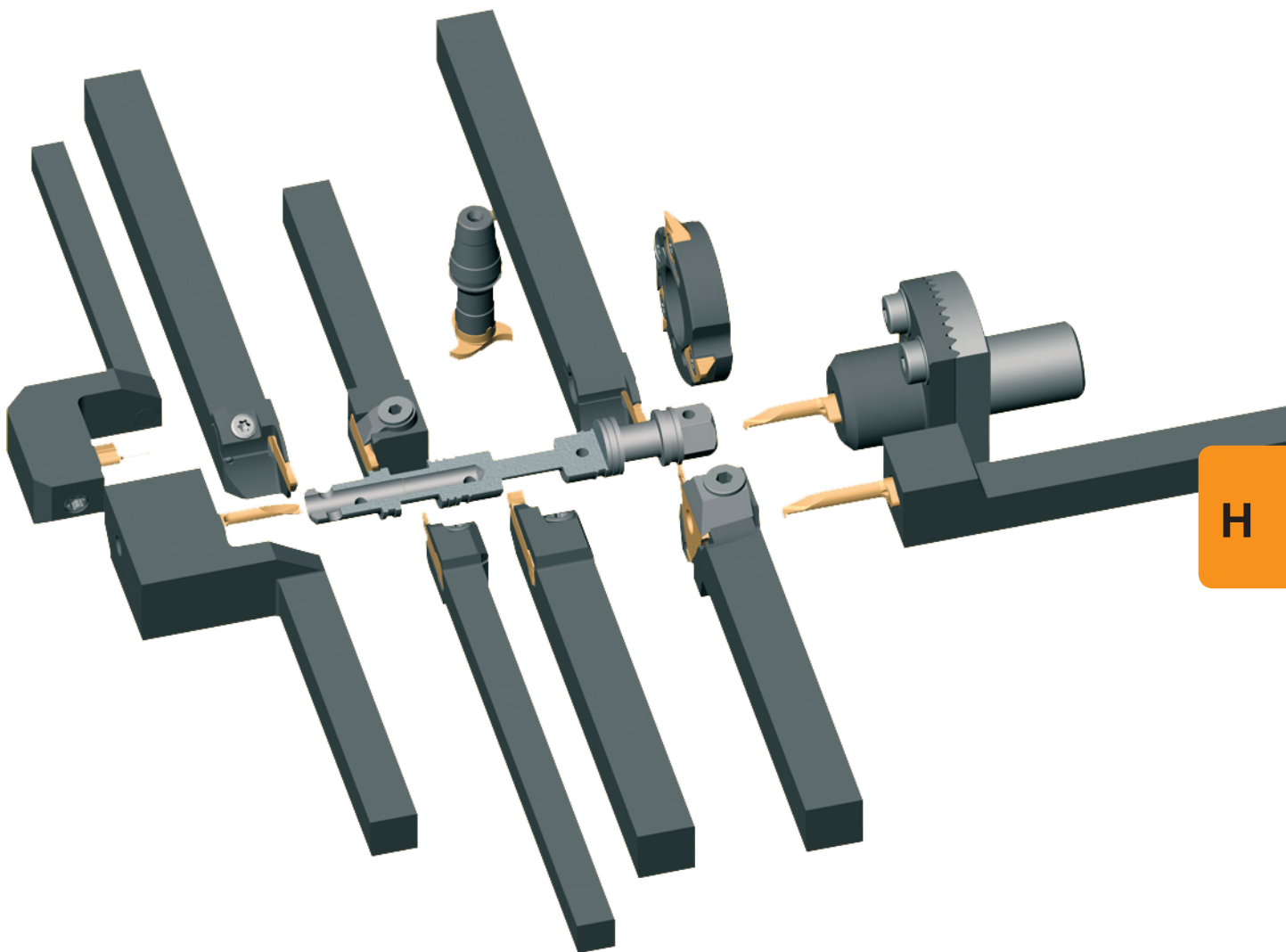
Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request

Die komplette Lösung für Sie!

The complete solution!



Weitere technische Informationen finden Sie in unseren aktuellen Katalogen.
For further technical information please ask for our current catalogues.

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

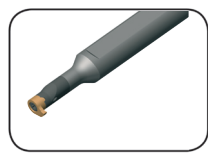
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

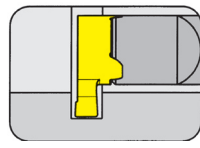
Typ **11P**
type

B11P
Klemmhalter
Toolholder

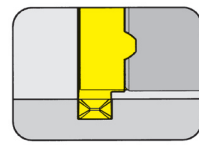


Seite/Page
J2-J4

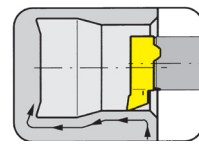
11P / S11P
≥ Ø 10 mm
Schneidplatten
Inserts



Seite/Page
J5, J7



Seite/Page
J6, J8



Seite/Page
J9-J10

Technische Hinweise
Technical Instructions

Seite
Page **N2-N8**



EINSTECHEN (innen) $\geq \text{Ø } 10,5 \text{ mm}$ GROOVING (internal)

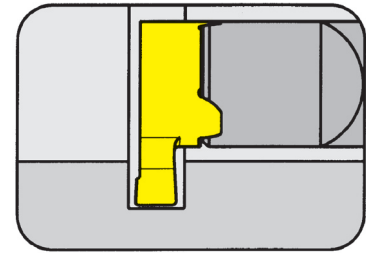


KLEMMHALTER Typ

TOOLHOLDER Type

B11P

mit innerer Kühlmittelzufuhr
with through coolant supply

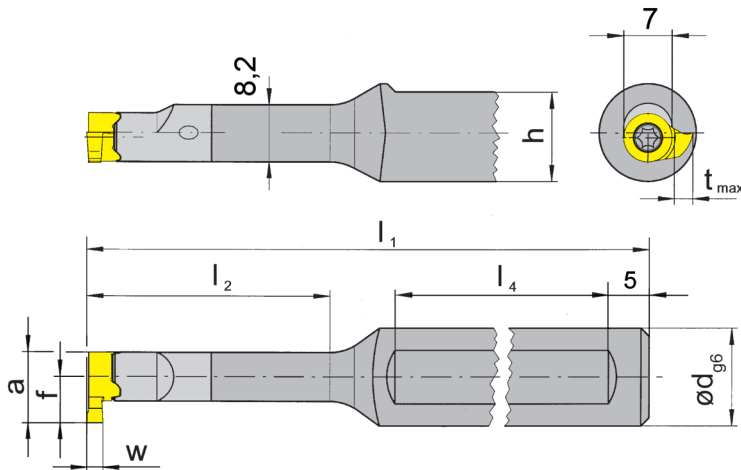


| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 10,5 mm |
| Stechtiefe bis | Depth of groove up to | 3,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 11P
Type S11P



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB11P.0012.0... | 3.10T9P | T9PL |

EINSTECHEN (innen) $\geq \text{Ø } 10,5 \text{ mm}$ GROOVING (internal)

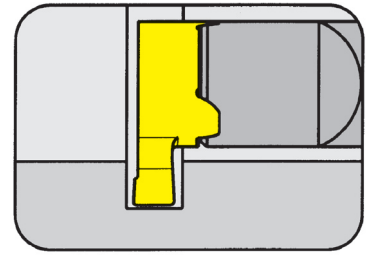


KLEMMHALTER Typ

TOOLHOLDER Type

B11P

mit innerer Kühlmittelzufuhr
with through coolant supply

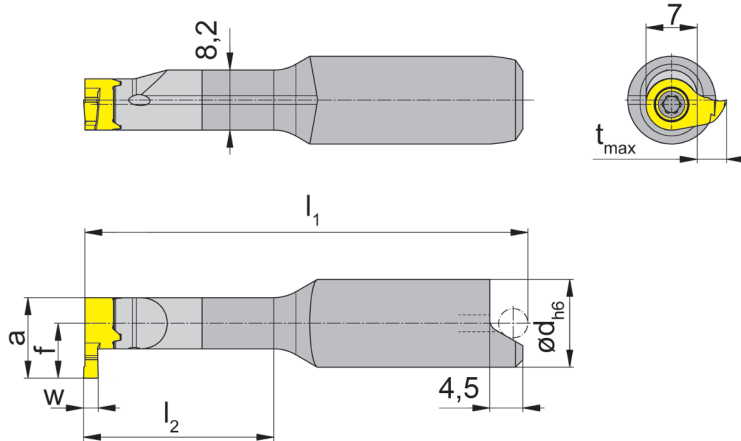


| | | |
|-----------------|-----------------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 10,5 / 11,5 mm |
| Stechtiefe bis | Depth of groove up to | 3,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 11P
Type S11P



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

zum lageorientierten
Schrumpfen
S = Lageorientierung
for shrinkage location
S = orientation

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

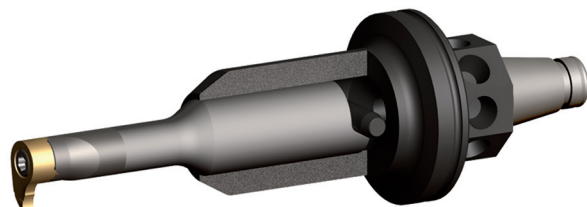
Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.



Einbaubeispiel System "W&F"
Example of assembly System "W&F"

Ersatzteile Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB11P.0012.0... | 3.10T9P | T9PL |

EINSTECHEN (innen) $\geq \text{Ø } 10,5 \text{ mm}$ GROOVING (internal)

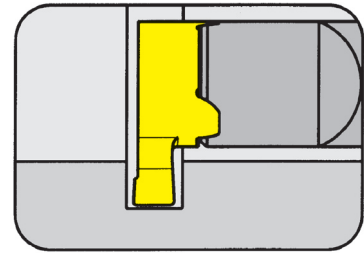


KLEMMHALTER Typ

TOOLHOLDER Type

B11P

mit innerer Kühlmittelzufuhr
with through coolant supply

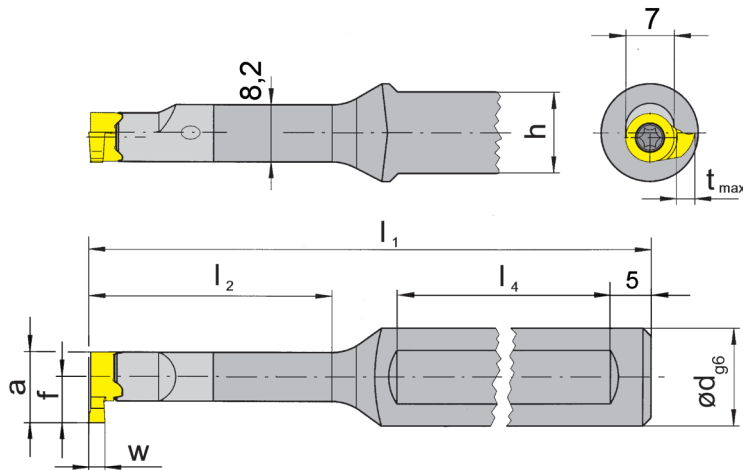


| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 10,5 mm |
| Stechtiefe bis | Depth of groove up to | 3,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 11P
Type S11P



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

mit 2 Spannflächen
with 2 clamping flats

| Bestellnummer 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 |

Ausführung R oder L angeben
State R or L version

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB11P.0012.2.0... | 3.10T9P | T9PL |

EINSTECHEN (innen) $\geq \varnothing 10,5$ mm

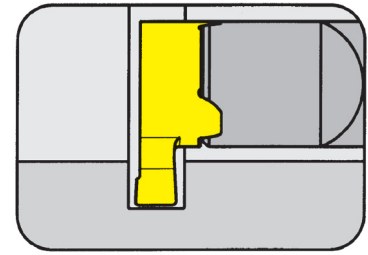
GROOVING (internal)



SCHNEIDPLATTE Typ

11P

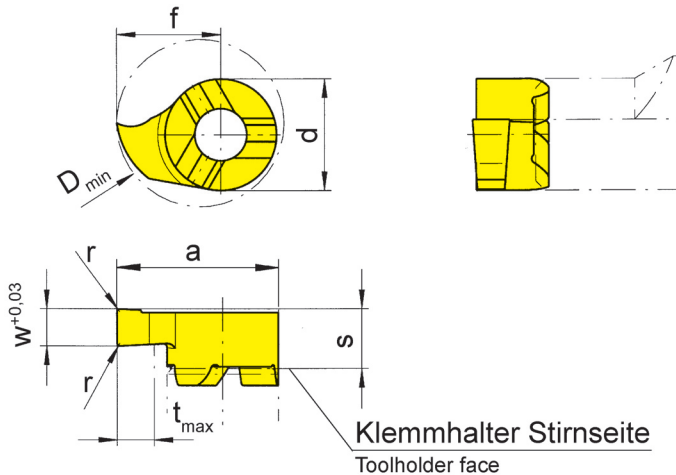
INSERT Type



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 10,5 mm |
| Stechtiefe | Depth of groove | 2,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B11P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

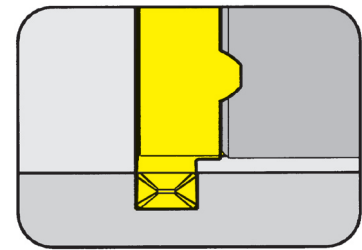


EINSTECHEN (innen) $\geq \text{Ø } 10,5 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

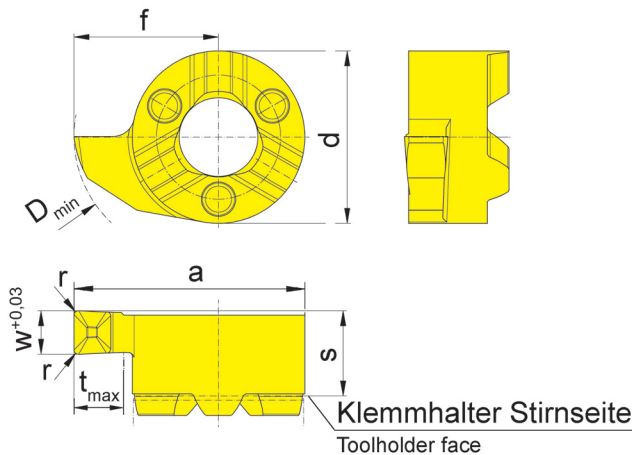
S11P



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 10,5 mm |
| Stechtiefe bis | Depth of groove up to | 2,5 mm |
| Stechbreite | Width of groove | 1,5 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ B11P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | | | | | | | ▲/Δ |
| R/LS11P.0200.1.D2 | 2,0 | 0,2 | 4,2 | 6,5 | 10 | 7 | 2,5 | 10,5 | | | | ▲/Δ |
| R/LS11P.0250.1.D2 | 2,5 | 0,2 | | | | | | | | | | ▲/▲ |
| | | | | | | | | | P | | | • |
| | | | | | | | | | M | | | • |
| | | | | | | | | | K | | | • |
| | | | | | | | | | N | | | • |
| | | | | | | | | | S | | | • |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

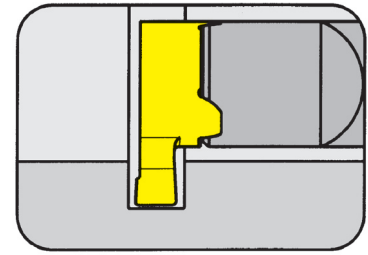


EINSTECHEN (innen) $\geq \text{Ø } 11,5 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

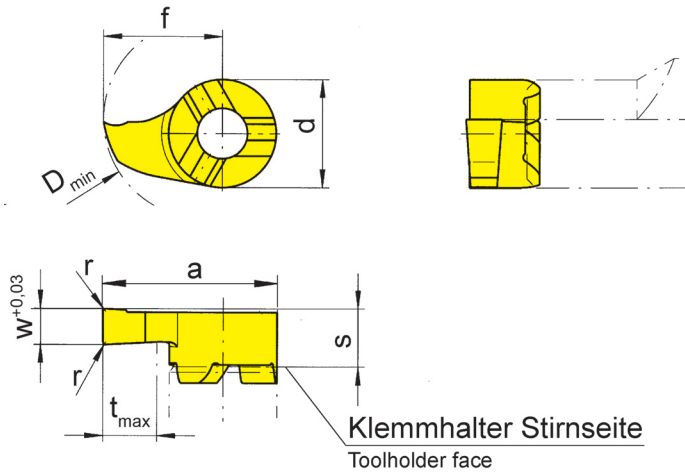
11P



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 11,5 mm |
| Stechtiefe | Depth of groove | 3,5 mm |
| Stechbreite | Width of groove | 1,0 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ B11P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|----|---|------------------|------------------|------|------|------|------|
| R/L11P.0100.2.00 | 1,0 | - | | | | | | | | | | ▲/Δ |
| 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 | | | | | | | | | | ▲/▲ |
| | | | | | | | | | | P | | • |
| | | | | | | | | | | M | | • |
| | | | | | | | | | | K | | • |
| | | | | | | | | | | N | | • |
| | | | | | | | | | | S | | • |
| | | | | | | | | | | H | | |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

• Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

| | | | |
|---|--|--|---|
| P | | | • |
| M | | | • |
| K | | | • |
| N | | | • |
| S | | | • |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request



EINSTECHEN (innen) $\geq \varnothing 11,5$ mm

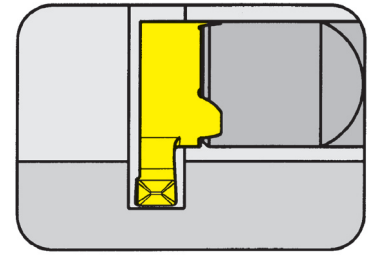
GROOVING (internal)



SCHNEIDPLATTE Typ

INSERT Type

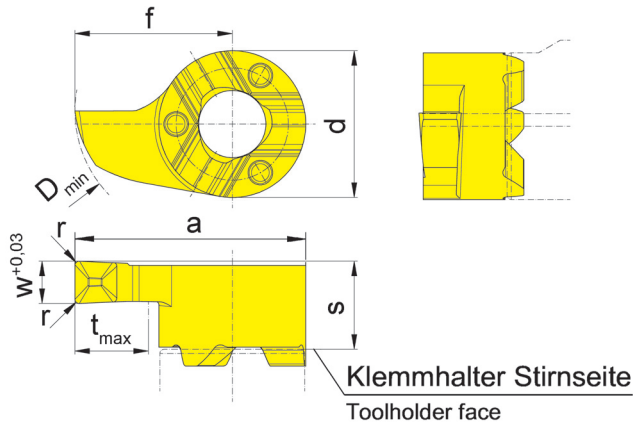
S11P



| | | |
|----------------------------|-------------------------|--------------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 11,5 mm |
| Stechtiefe bis | Depth of groove up to | 3,5 mm |
| Stechbreite | Width of groove | 1,5 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ B11P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | | | | | | | ▲/▲ |
| | | | | | | | | | | P | | • |
| | | | | | | | | | | M | | • |
| | | | | | | | | | | K | | • |
| | | | | | | | | | | N | | • |
| | | | | | | | | | | S | | • |
| | | | | | | | | | | H | | |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

• Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

HM-Sorten
Carbide grades

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

BOHRUNG-DREHEN $\geq \varnothing 10,5$ mm

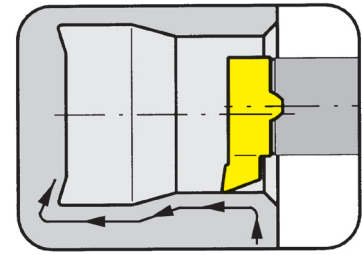
BORING and PROFILING



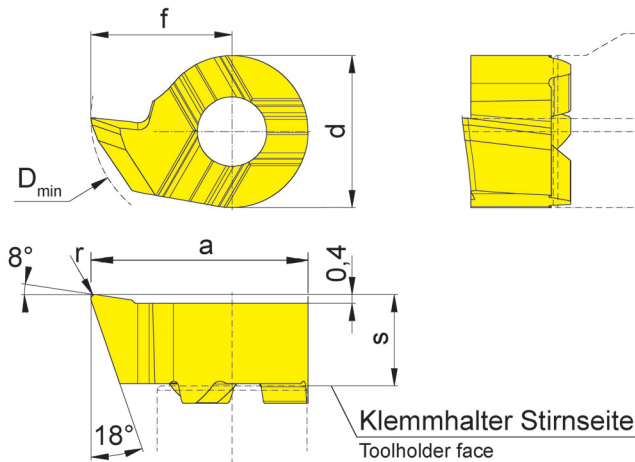
SCHNEIDPLATTE Typ 11P

INSERT Type

11P



Bohrungs- \varnothing ab Bore \varnothing from 10,5 mm



für Klemmhalter
for use with Toolholder

Typ B11P
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | ▲/Δ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | H | | | • |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 10,3$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 10,3$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request



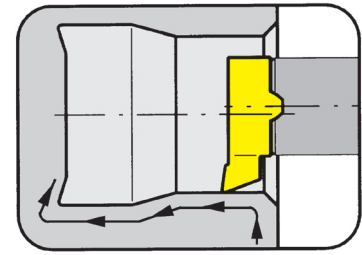
BOHRUNG-DREHEN $\geq \varnothing 9,8$ mm

BORING and PROFILING

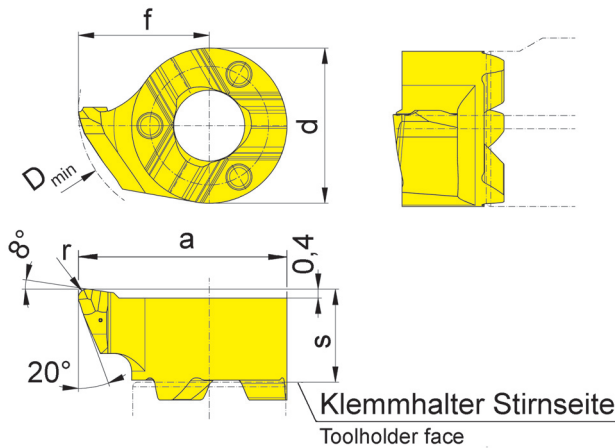


SCHNEIDPLATTE Typ INSERT Type

S11P



Bohrungs- \varnothing ab Bore \varnothing from 9,8 mm



für Klemmhalter
for use with Toolholder

Typ B11P
Type

Geometrie .R
Geometry .R

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|-----|-----|---|------------------|------|------|------|------|
| LS11P.1859.R2 | 0,2 | | | | | | | | | ▲ |
| RS11P.1859.R2 | 0,2 | | | | | | | | | ▲ |
| LS11P.1859.R4 | 0,4 | 4,2 | 5,9 | 9,4 | 7 | 9,8 | | | | ▲ |
| RS11P.1859.R4 | 0,4 | | | | | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|--|---|
| P | | | | ● |
| M | | | | ● |
| K | | | | ● |
| N | | | | ● |
| S | | | | ● |
| H | | | | |

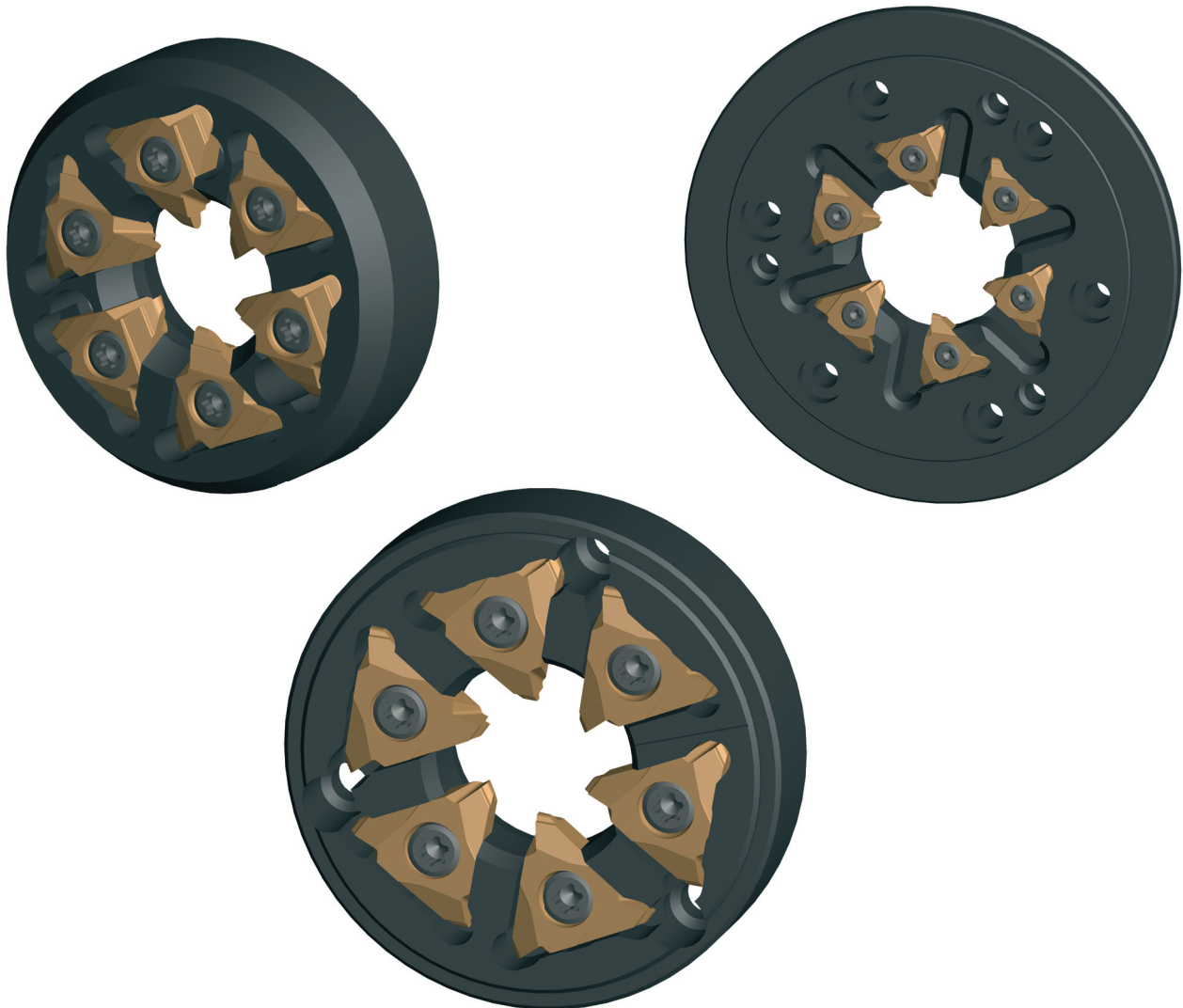
HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 9,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 9,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request



- **kurze Werkzeugwechselzeiten**
 - **höchste Präzision gewährleistet ruhigen Lauf**
 - **dadurch sehr gute Oberflächenqualität der Gewinde**
 - **hohe Standmengen durch gleichmäßige Schnittaufteilung**
-
- **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**

Weitere Informationen finden Sie in unserem HORN-Katalog "ROTIERENDE WERKZEUGE"
For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

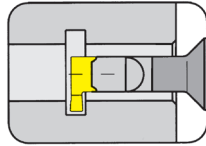
Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE

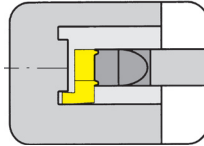
Mini CARBIDE GROOVING TOOLS

Typ **114**
type

B114
Klemmhalter
Toolholder

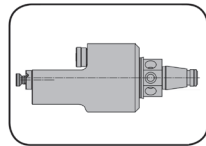


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K2-K4

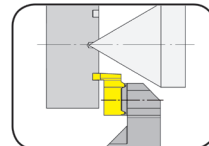


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K6

H114 / HC114
Klemmhalter
Toolholder

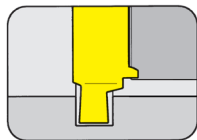


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K5

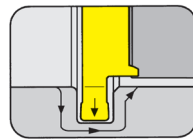


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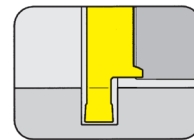
114 / S114
≥ Ø 14,0 mm
Schneidplatten
Inserts



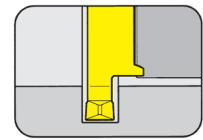
Seite/Page
K8



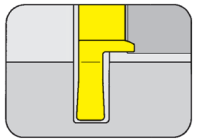
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K10



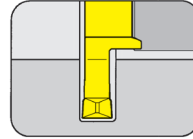
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K9,K11



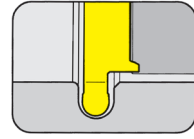
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K12



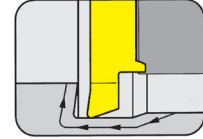
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K13



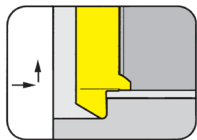
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K14



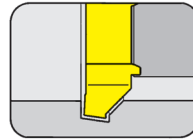
Seite/Page
K15



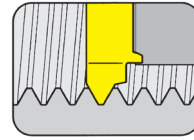
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K16-K17,K19



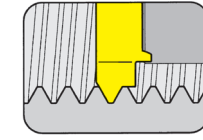
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K18



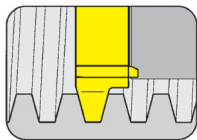
Seite/Page
K20



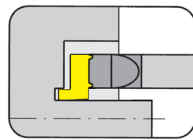
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K21-K22



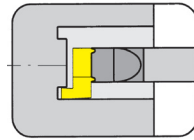
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K23-K24



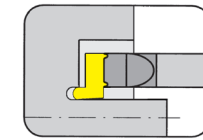
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K25



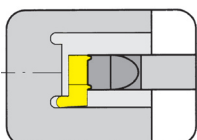
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K26



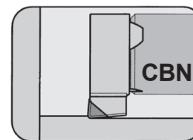
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K27



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K28



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K29



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K30

CBN

Technische Hinweise
Technical Instructions

Seite
Page **N2-N8**

K

EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)

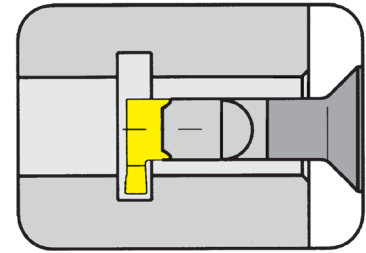


KLEMMHALTER Typ

TOOLHOLDER Type

B114

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 6,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 114
Type S114

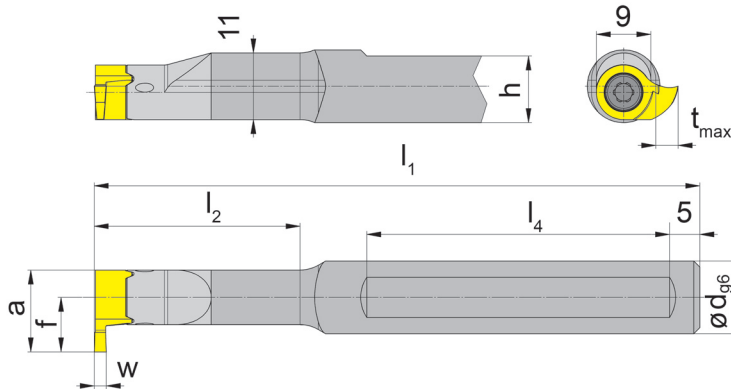


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B114.001... | 4.12T15EP | T15PQ |

EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)

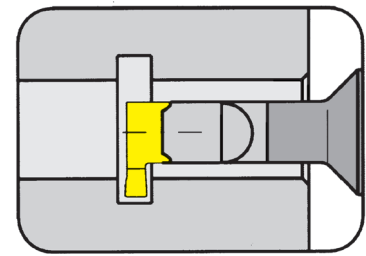


KLEMMHALTER Typ

TOOLHOLDER Type

B114

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 6,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 114
Type S114

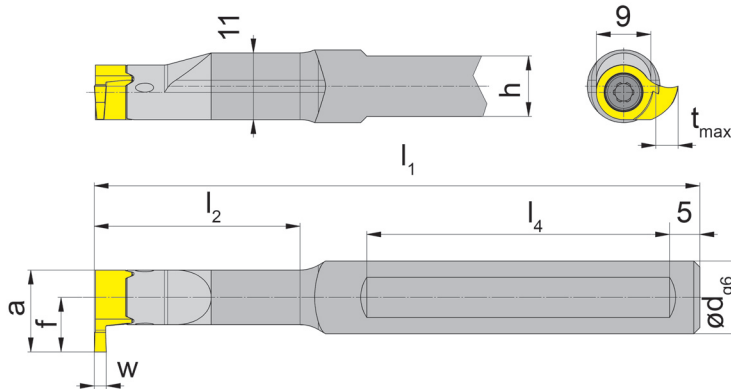


Abbildung = rechtsschneidend
Picture = right hand cutting version

mit 2 Spannflächen
with 2 clamping flats

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:
Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B114.001... | 4.12T15EP | T15PQ |



EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)

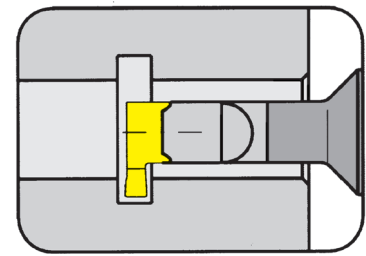


KLEMMHALTER Typ

TOOLHOLDER Type

B114

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 6,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 114
Type S114

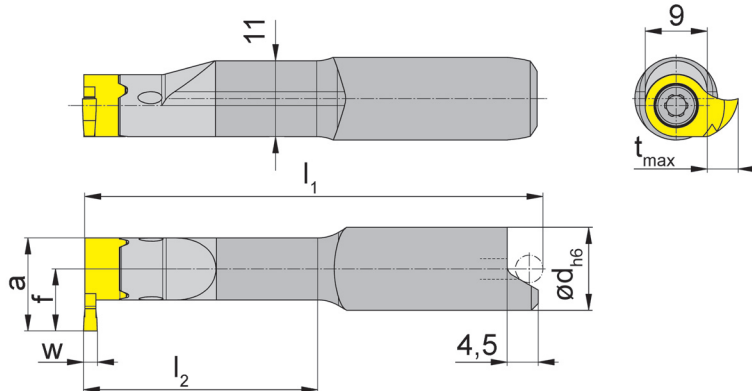


Abbildung = rechtsschneidend
Picture = right hand cutting version

zum lageorientierten
Schrumpfen
S = Lageorientierung
for shrinkage location
S = orientation

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

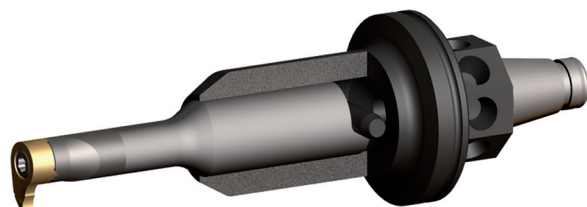
Ordering note:

Toolholders can be used with right and left hand inserts.

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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



Einbaubeispiel System "W&F"
Example of assembly System "W&F"

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| B114.0012.0... | 4.12T15EP | T15PQ |

EINSTECHEN (außen)

GROOVING (external)

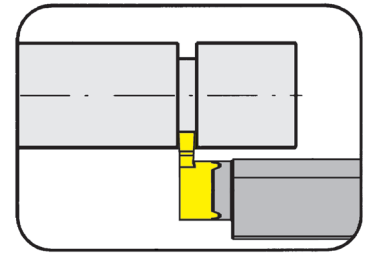


KLEMMHALTER Typ

TOOLHOLDER Type

H114.WF

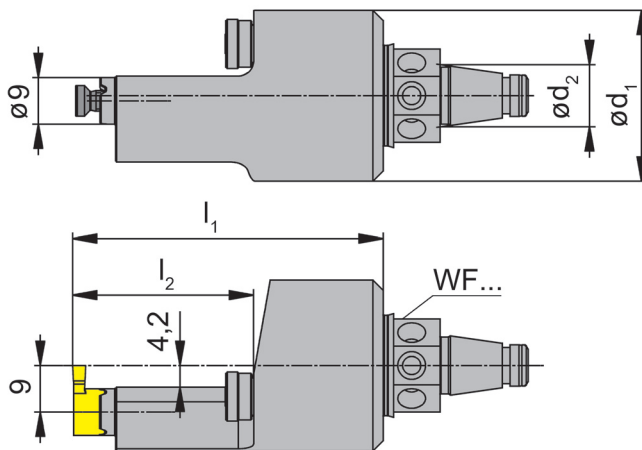
mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|--------|
| Stechtiefe | Depth of groove | 4,2 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

für Schneidplatte
for use with Insert

Typ 114
Type S114



| Bestellnummer Part number | Anbindung Coupling System | l_1 | l_2 | d_2 | d_1 |
|------------------------------|------------------------------|-------|-------|-------|-------|
| RH114.WF20.02 | WF20-12 | 60 | 35 | 12 | 33 |
| RH114.WF24.02 | WF24-16 | 80 | 55 | 16 | 40 |
| RH114.WF32.02 | WF32-20 | 80 | 32 | 20 | 50 |

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench | Kugelspritzdüse Coolant spray nozzle |
|---------------------------|------------------------|---|---|
| RH114.WF... | 4.12T15EP | T15PQ | 020.0806.3116 |

K

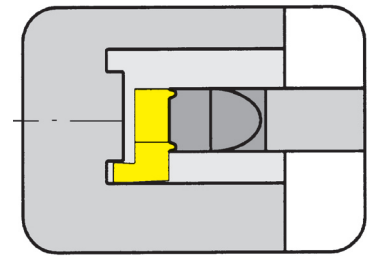
AXIALEINSTECHEN FACE GROOVING



KLEMMHALTER Typ TOOLHOLDER Type

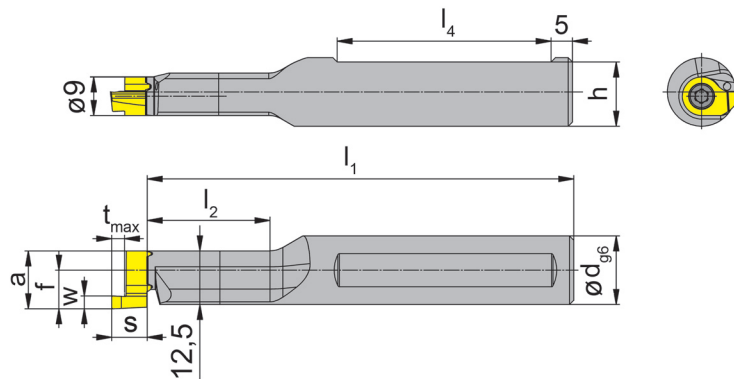
RBA114

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø | Bore Ø | 14,0 mm |
| Stechtiefe | Depth of groove | 6,0 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance



für Schneidplatte
for use with Insert

Typ R114 (axial)
Type

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer Part number | d | l ₁ | l ₂ | h | l ₄ |
|------------------------------|----|----------------|----------------|----|----------------|
| RBA114.0016.01 | 16 | 99,7 | 28,7 | 15 | 50 |
| RBA114.0016.02 | | 109,7 | 39,7 | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, s, t_{max} und f siehe Schneidplatten
w, a, s, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

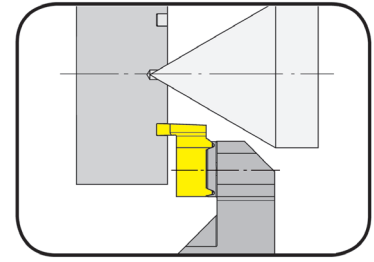
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| RBA114.0016.0... | 4.12T15EP | T15PQ |

EINSTECHEN und AXIALEINSTECHEN GROOVING and FACE GROOVING

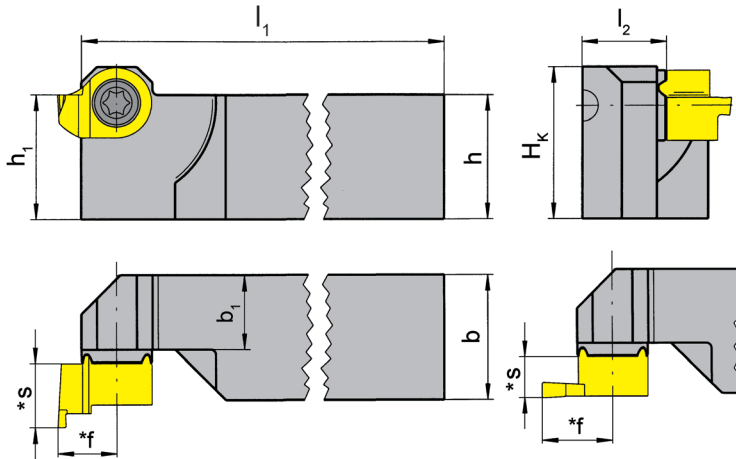


KLEMMHALTER Typ TOOLHOLDER Type

HC114



| | | |
|-----------------|-----------------------|--------|
| Stechtiefe bis | Depth of groove up to | 6,5 mm |
| Stechbreite bis | Width of groove up to | 3,0 mm |



für Schneidplatte
for use with Insert

Typ 114
Type S114

axial und radial
axial and radial

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 |

Weitere Abmessungen auf Anfrage
Further sizes upon request

* siehe Schneidplatten
* see inserts

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Bestellhinweis:

Rechte Klemmhalter verwendbar für linke Schneidplatten.
Linke Klemmhalter verwendbar für rechte Schneidplatten.

Ordering note:

Right hand toolholders use left hand inserts.
Left hand toolholders use right hand inserts.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|---------------------------|------------------------|---|
| R/LHC114.... | 4.12T15EP | T15PQ |

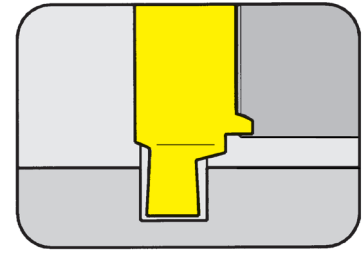


EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)



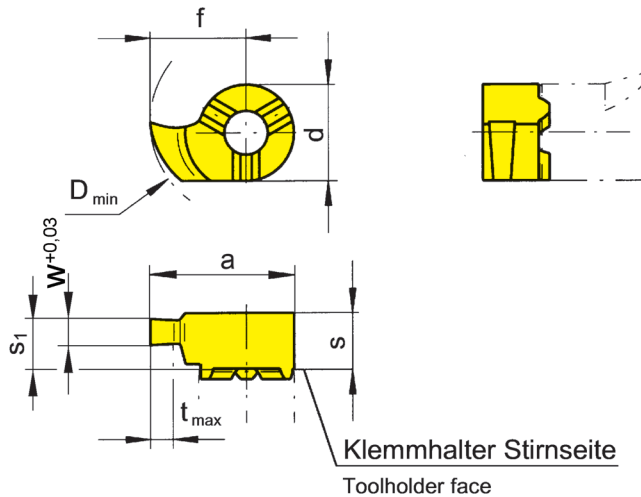
SCHNEIDPLATTE Typ INSERT Type

114



| | | |
|------------------|---------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 1,2 - 1,5 mm |
| Nutnennbreite Nw | Width of circlip Nw | 0,7 - 0,9 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114

Zapfenausführung
not face cutting,
limited depth of cut

| Bestellnummer 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 | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

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

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

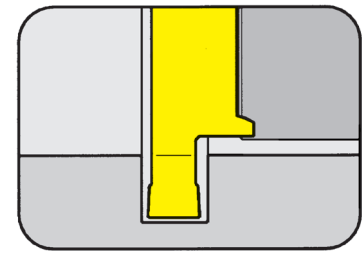
K

EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)



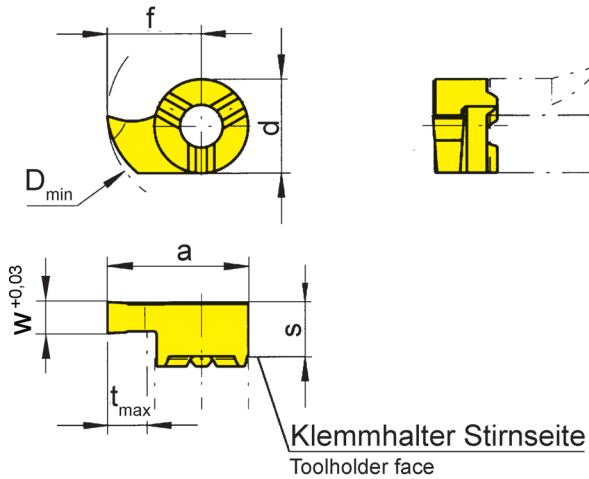
SCHNEIDPLATTE Typ INSERT Type

114



| | | |
|------------------|---------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 4,0 mm |
| Nutnennbreite Nw | Width of circlip Nw | 1,1 - 1,6 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



für Klemmhalter
for use with Toolholder

Typ B114
Type HC114

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | ▲/▲ | | ▲/▲ | |
| <ul style="list-style-type: none"> ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | P | • | | • |
| | | | | | | | | | | M | • | | • |
| | | | | | | | | | | K | • | | • |
| | | | | | | | | | | N | • | | • |
| | | | | | | | | | | S | • | | • |
| | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



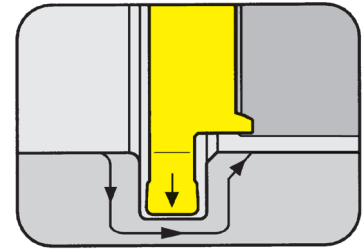
NC-FEINDREHEN (innen) $\geq \varnothing 14,0$ mm

NC-PROFILING (internal)



SCHNEIDPLATTE Typ INSERT Type

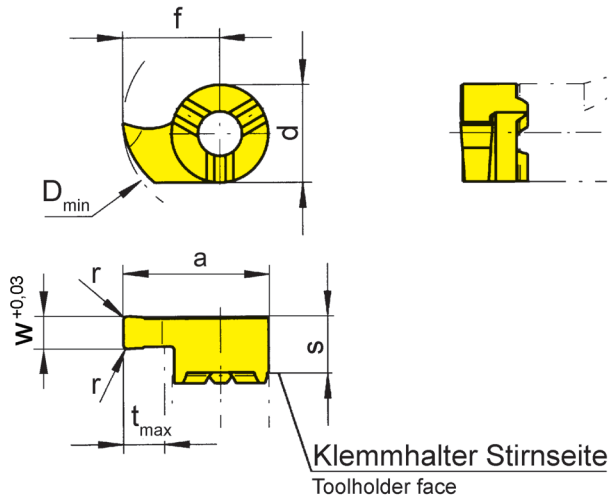
114



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 14,0 mm |
| Stechtiefe | Depth of groove | 4,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

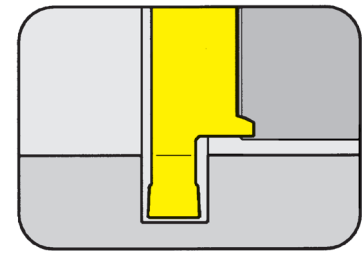
K

EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

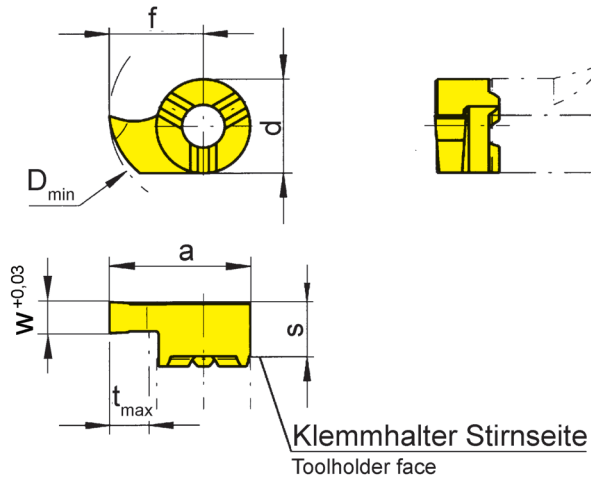
114



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 4,0 mm |
| Stechbreite | Width of groove | 1,5 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | s | f | a | d | t _{max} | D _{min} | 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | o | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

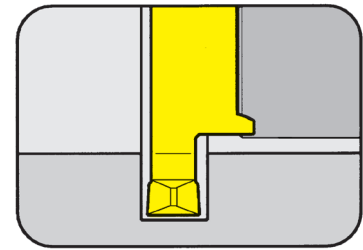


EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

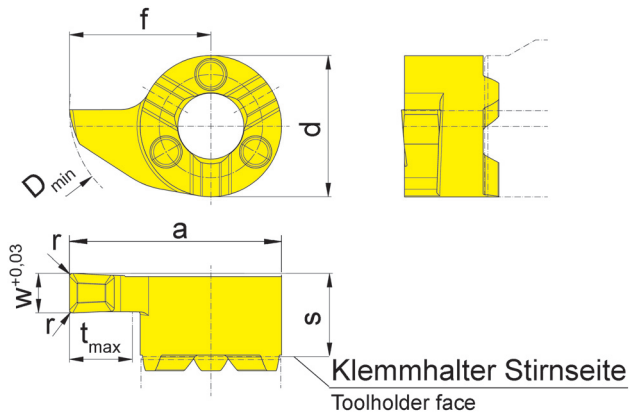
S114



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Stechtiefe | Depth of groove | 4,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer Part number | w | r | s | f | a | d | t _{max} | D _{min} | Geometrie .D | | | | |
|--|-----|-----|-----|---|------|---|------------------|------------------|--------------|------|------|------|---|
| | | | | | | | | | 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 | | | | | | | | | ▲/▲ | | ▲/▲ | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | P | • | | • |
| | | | | | | | | | | M | • | | • |
| | | | | | | | | | | K | • | | • |
| | | | | | | | | | | N | • | | • |
| | | | | | | | | | | S | • | | • |
| | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

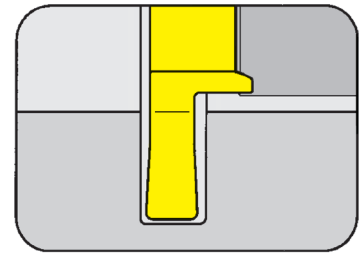
K

EINSTECHEN (innen) $\geq \text{Ø } 16,5 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

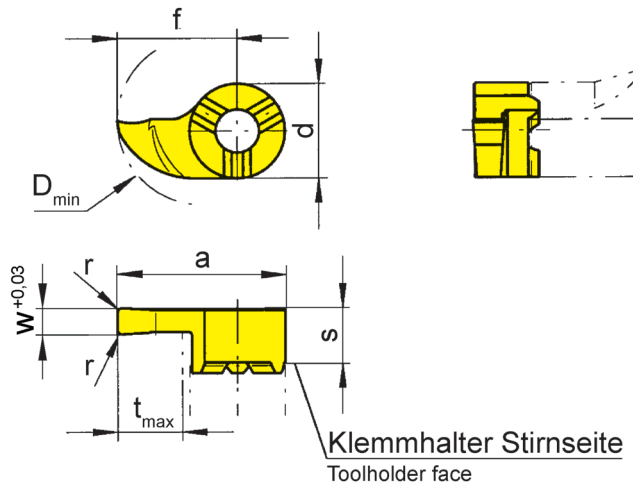
114



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,5 mm |
| Stechtiefe | Depth of groove | 6,5 mm |
| Stechbreite | Width of groove | 1,5 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | ▲/▲ | | ▲/▲ |
| <p>▲ ab Lager / on stock Δ 4 Wochen / 4 weeks</p> <p>● Haupteinsatzbereich / main recommendation</p> <p>o bedingt einsetzbar / alternative recommendation</p> <p>■ unbeschichtete HM-Sorten / uncoated grades</p> <p>■ beschichtete HM-Sorten / coated grades</p> <p>■ bestückt/Cermet / brazed/Cermet</p> | | | | | | | | | P | • | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

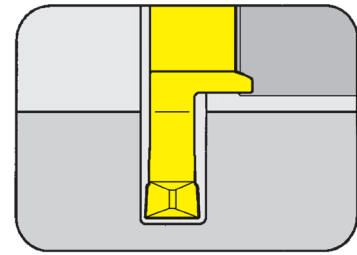


EINSTECHEN (innen) $\geq \text{Ø } 16,5 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

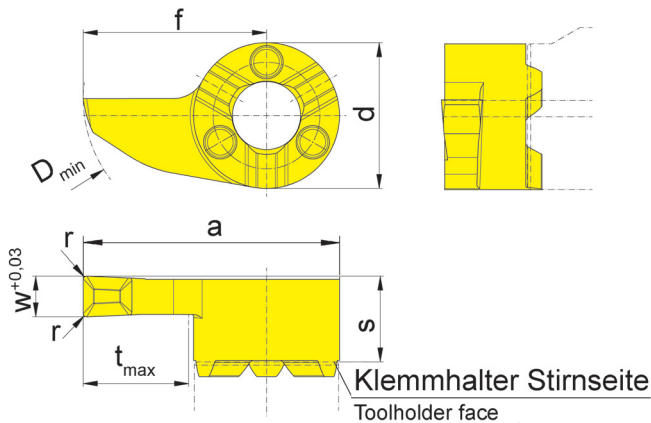
S114



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,5 mm |
| Stechtiefe | Depth of groove | 6,5 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | | | ● |
| | | | | | | | | | M | | | ● |
| | | | | | | | | | K | | | ● |
| | | | | | | | | | N | | | ● |
| | | | | | | | | | S | | | ● |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

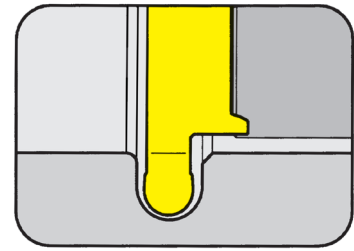
K

EINSTECHEN (innen) $\geq \text{Ø } 14,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

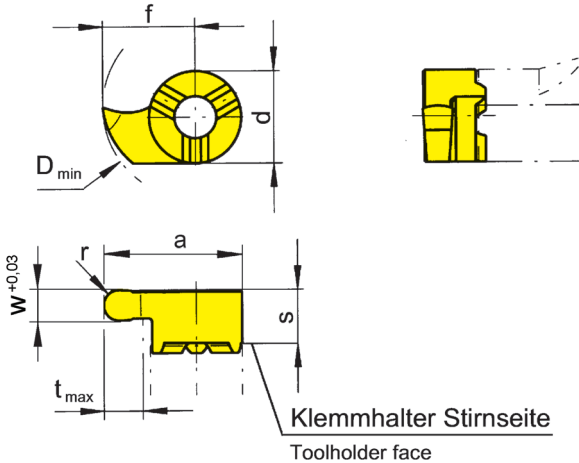
114



| | | |
|-----------------------------|----------------------------|---------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 14,0 mm r 0,6 - 2,0 mm |
|-----------------------------|----------------------------|---------------------------|

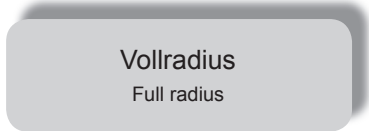
für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version



| Bestellnummer Part number | w | r | s | f | a | d | t _{max} | D _{min} | 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 | 5,3 | 9 | 13,5 | 9 | 4 | 14 | ▲/▲ | ● | | ▲/▲ |
| R/L114.0011.22 | 2,2 | 1,1 | | | | | | | ▲/▲ | ● | | ▲/▲ |
| R/L114.0015.30 | 3,0 | 1,5 | | | | | | | ▲/▲ | ● | | ▲/▲ |
| R/L114.0020.40 | 4,0 | 2,0 | | | | | | | ▲/▲ | ● | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | ● | ● | ● |
| | | | | | | | | | M | ● | ● | ● |
| | | | | | | | | | K | ● | ● | ● |
| | | | | | | | | | N | ● | ● | ● |
| | | | | | | | | | S | ● | ● | ● |
| | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



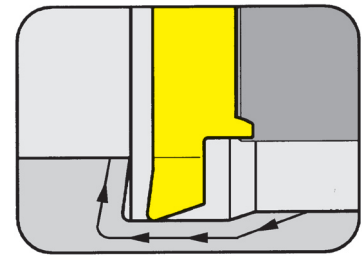
BOHRUNG-DREHEN $\geq \varnothing 13,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

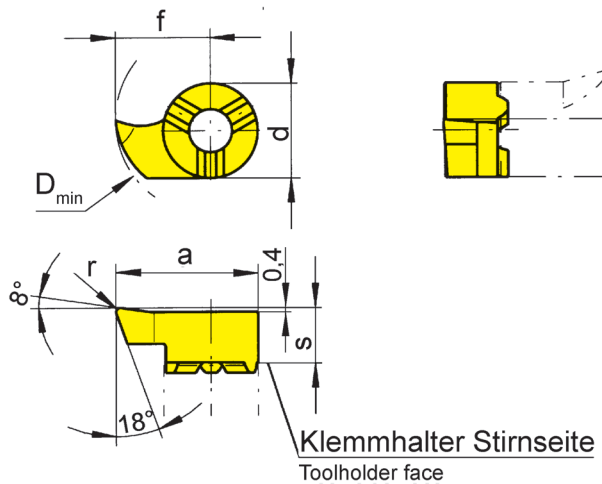
114



Bohrungs- \varnothing ab Bore \varnothing from 13,8 mm

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/▲ | ▲/▲ | ▲/▲ | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | • | • | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | • | • | • |
| beschichtete HM-Sorten / coated grades | | | | | | | S | • | • | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 13,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 13,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

K

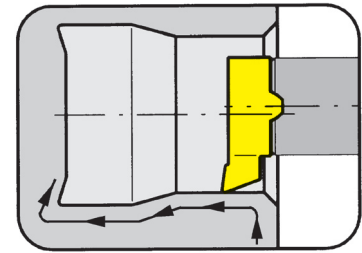
BOHRUNG-DREHEN $\geq \varnothing 13,8$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

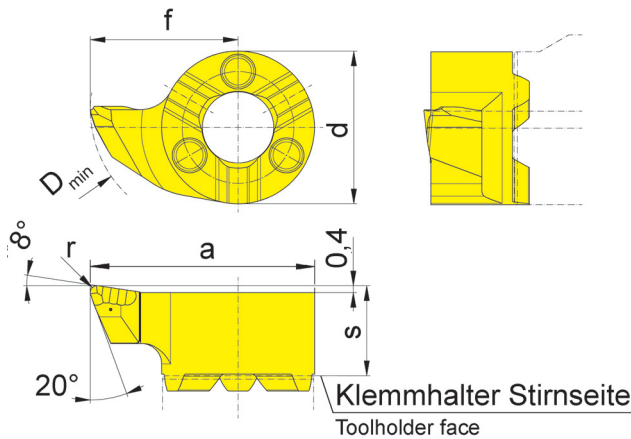
S114



Bohrungs- \varnothing ab Bore \varnothing from 13,8 mm

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .R
Geometry .R

| Bestellnummer 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 | | | | | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|--|---|
| P | | | | ● |
| M | | | | ● |
| K | | | | ● |
| N | | | | ● |
| S | | | | ● |
| H | | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 13,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 13,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

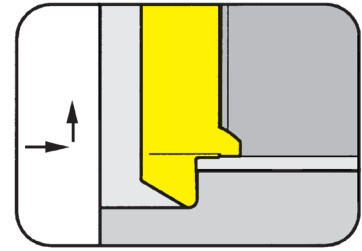


RÜCKWÄRTSDREHEN (innen) $\geq \varnothing 13,8$ mm BACKBORING (internal)



SCHNEIDPLATTE Typ INSERT Type

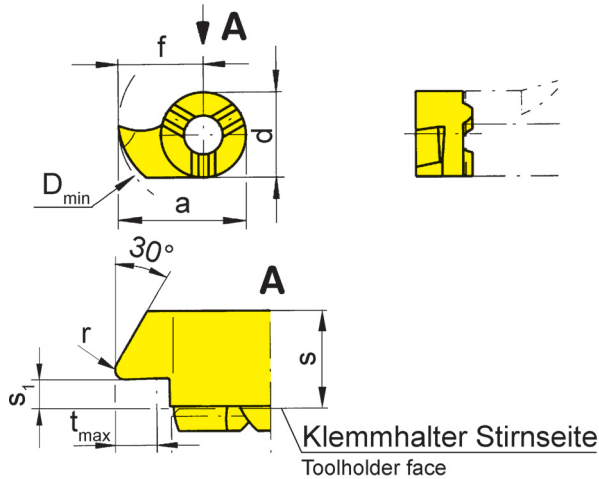
114



| | | |
|---|--|-------------------|
| Bohrungs- \varnothing ab Profiltiefe bis | Bore \varnothing from Depth of undercut up to | 13,8 mm 3,5 mm |
|---|--|-------------------|

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | | P | • | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | • | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | • | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | • | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | S | • | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

K

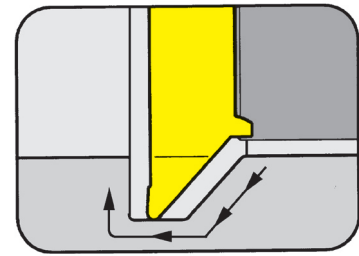
BOHRUNG-DREHEN $\geq \varnothing 13,8$ mm

BORING and PROFILING

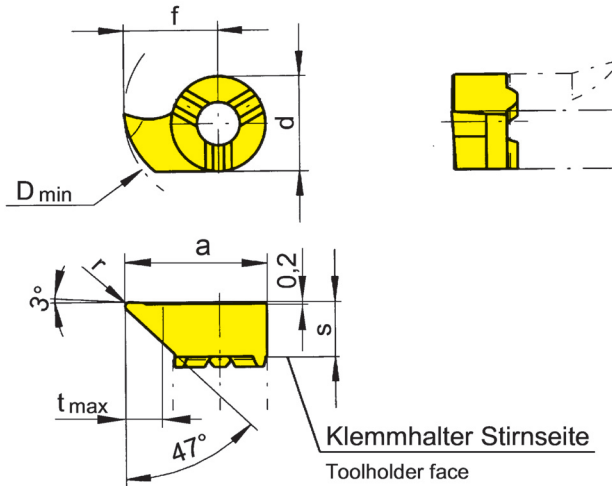


SCHNEIDPLATTE Typ INSERT Type

114



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 13,8 mm |
| Profiltiefe bis | Depth of undercut up to | 5,0 mm |



für Klemmhalter
for use with Toolholder

Typ B114
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | t _{max} | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|------|------|---|------------------|------------------|------|------|------|------|
| R/L114.4787.02 | 0,2 | | | | | | | | ▲/▲ | | ▲/▲ |
| R/L114.4787.04 | 0,4 | 5,3 | 8,7 | 13,2 | 9 | 3 | 13,8 | | ▲/▲ | | ▲/▲ |
| R/L114.4710.02 | 0,2 | 5,3 | 11,0 | 15,5 | 9 | 5 | 16,0 | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock | | | | | | | | | ● | | ● |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | ● | | ● |
| ○ bedingt einsetzbar / alternative recommendation | | | | | | | | | ○ | | ○ |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 13,8$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 13,8$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



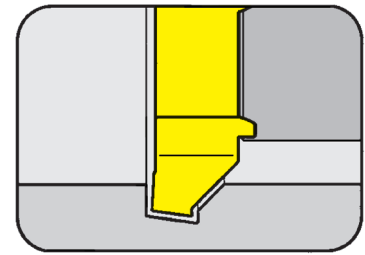
VORSTECHEN und FASEN (innen)

PREGROOVING and CHAMFERING (internal)

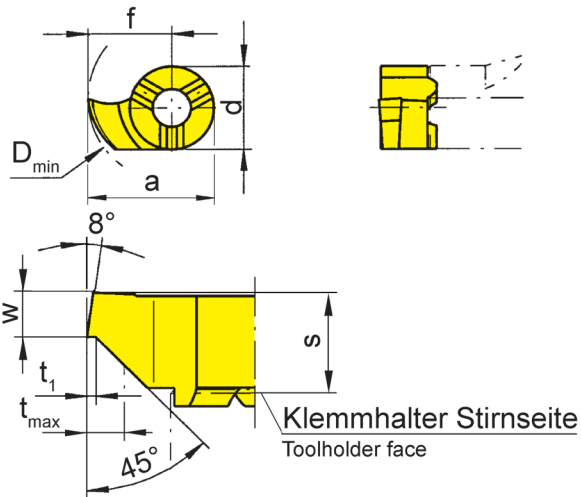


SCHNEIDPLATTE Typ
INSERT Type

114



Bohrungs-Ø ab Bore Ø from 14,0 mm



für Klemmhalter
for use with Toolholder

Typ B114
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/△ | | ▲/▲ | |
| ▲ ab Lager / on stock △ 4 Wochen / 4 weeks | | | | | | | | | P | o | • | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | • | • | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | • | • | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | • | • | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | • | • | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

K

GEWINDEDREHEN (innen) Teilprofil

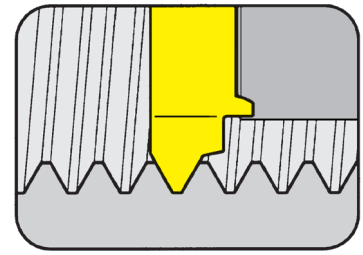
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

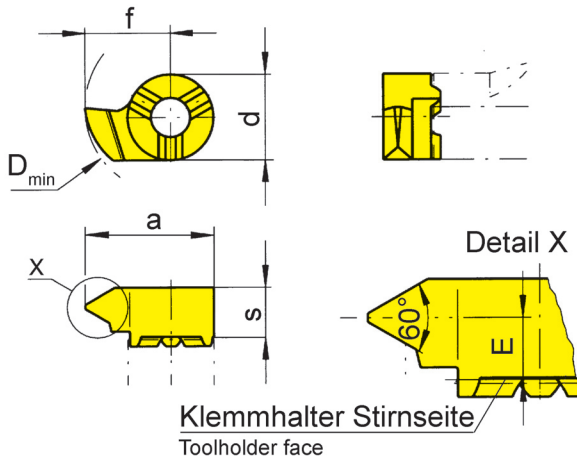
114



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Steigung | Pitch | 2,0 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | 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 | | | | | | | ▲/▲ | ● | ● | ● |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

| | | | |
|---|---|---|---|
| P | ● | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | ● | ● | ● |

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Teilprofil

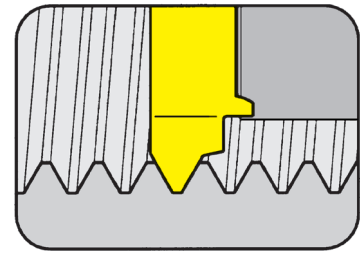
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

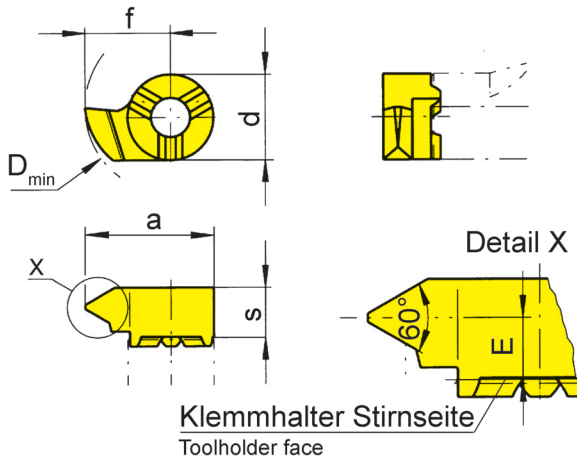
114



| | | |
|---------------|-------------|----------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Steigung | Pitch | 0,50 - 1,75 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Feingewinde
Metric ISO fine thread

| Bestellnummer Part number | P | P _{max} | E | s | f | a | d | D _{min} | HM-Sorten Carbide grades | | | |
|------------------------------|-----|------------------|-----|-----|---|------|---|------------------|-----------------------------|------|------|------|
| | | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L114.0205.01 | 0,5 | 0,75 | 4,8 | | | | | | | ▲/Δ | | Δ/Δ |
| R/L114.0510.01 | 1,0 | 1,25 | 4,7 | 5,5 | 9 | 13,5 | 9 | 14 | | ▲/▲ | | ▲/Δ |
| R/L114.0815.01 | 1,5 | 1,75 | 4,5 | | | | | | | ▲/▲ | | ▲/▲ |
| | | | | | | | | | P | • | • | • |
| | | | | | | | | | M | • | • | • |
| | | | | | | | | | K | • | • | • |
| | | | | | | | | | N | • | • | • |
| | | | | | | | | | S | • | • | • |
| | | | | | | | | | H | | | |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks

• Haupteinsatzbereich / main recommendation

o bedingt einsetzbar / alternative recommendation

■ unbeschichtete HM-Sorten / uncoated grades

■ beschichtete HM-Sorten / coated grades

■ bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Weitere Abmessungen auf Anfrage

Further sizes upon request

K

GEWINDEDREHEN (innen) Vollprofil

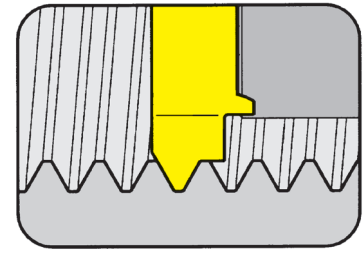
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

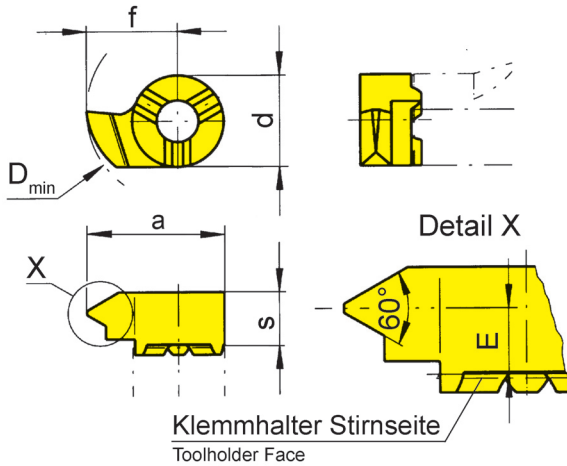
114



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Steigung | Pitch | 2,0 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer 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 | | | | | | | ▲/▲ | ● | | |
| ▲ ab Lager / on stock | Δ 4 Wochen / 4 weeks | | | | | | | P | ● | | |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | M | ● | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | ● | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | ● | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | ● | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Vollprofil

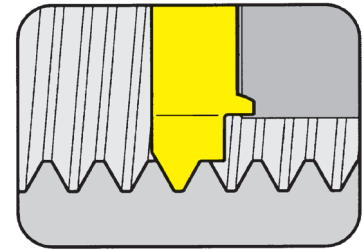
THREADING (internal) Full profile



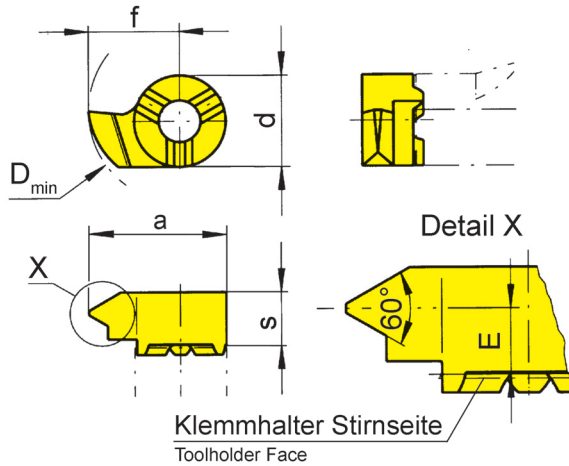
SCHNEIDPLATTE Typ

INSERT Type

114



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Steigung | Pitch | 1,0 - 1,5 mm |



für Klemmhalter
for use with Toolholder

Typ B114
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Feingewinde
Metric ISO fine thread

| Bestellnummer 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 | 5,5 | 9 | 13,5 | 9 | 14 | ▲/▲ | ● | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | P | ● | | |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | M | ● | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | ● | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | ● | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | ● | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

K

GEWINDEDREHEN (innen) Teilprofil

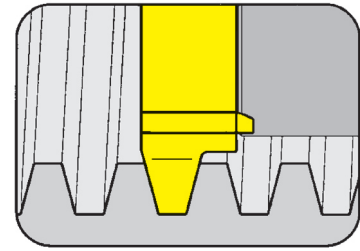
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

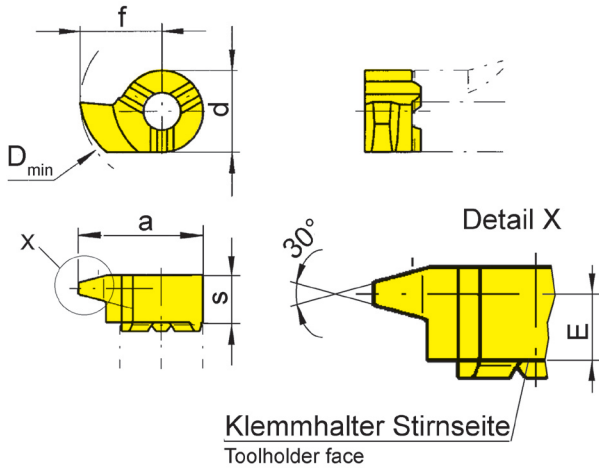
114



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 14,0 mm |
| Steigung | Pitch | 4,0 - 5,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Trapezgewinde DIN 103
Metric ISO trapezoidal
thread DIN 103

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | HM-Sorten / Carbide grades | | | |
|------------------------------|---|------|-----|---|------|---|------------------|----------------------------|------|------|------|
| | | | | | | | | 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 | 5,5 | 9 | 13,5 | 9 | 14 | • | • | • | • |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

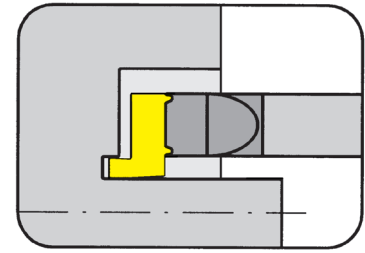
K

AXIALEINSTECHEN FACE GROOVING



SCHNEIDPLATTE Typ INSERT Type

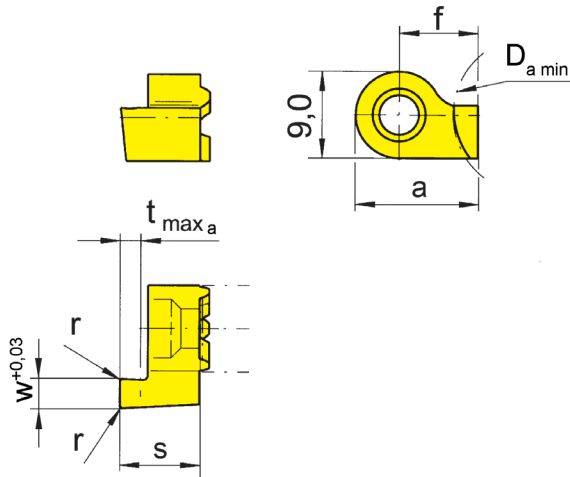
114



| | | |
|----------------|-----------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 12,0 mm |
| Stechtiefe bis | Depth of groove up to | 6,0 mm |
| Stechbreite | Width of groove | 1,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bearbeitung **HINTER** der
Drehmitte!
Machining **BEHIND** centre line

| Bestellnummer 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 | | ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|--|--|
| P | ● | | |
| M | ● | | |
| K | ● | | |
| N | ● | | |
| S | ● | | |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Ausführung R = Spindel linksdrehend!
Bei Verwendung der Axialstechplatte Typ 114 mit Klemmhalter Typ B114 verlängern sich die Haltermaße I₁ und I₂ um 3,0 / 5,5 oder 6,5 mm.

Note:

R = rotation anti-clockwise!
Using the face grooving insert type 114 on toolholder type B114 the size I₁ and I₂ will be enlarged by 3,0 / 5,5 or 6,5 mm.

Weitere Abmessungen auf Anfrage
Further sizes upon request

K26

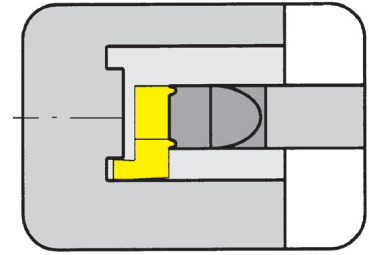
K

AXIALEINSTECHEN FACE GROOVING

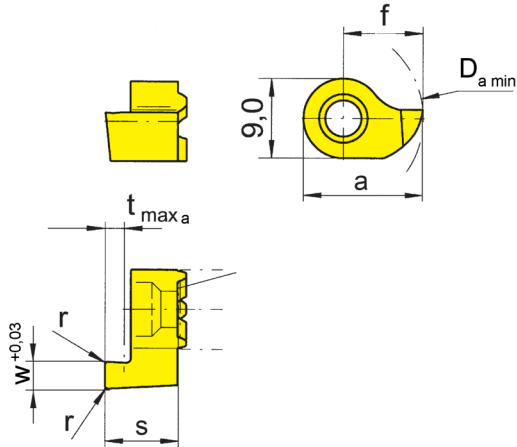


SCHNEIDPLATTE Typ INSERT Type

114



| | | |
|----------------|-----------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 14,0 mm |
| Stechtiefe bis | Depth of groove up to | 6,0 mm |
| Stechbreite | Width of groove | 1,0 - 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B114
Type HC114

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bearbeitung **VOR** der
Drehmitte!
Machining **IN-FRONT** of centre line

| Bestellnummer Part number | w | r | s | f | a | t _{max a} | D _{a min} | 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 | | ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|---|---|--|--|
| P | o | ● | | |
| M | ● | ● | | |
| K | ● | ● | | |
| N | ● | ● | | |
| S | ● | ● | | |
| H | | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Ausführung R = Spindel rechtsdrehend!
Bei Verwendung der Axialstechplatte Typ 114 mit Klemmhalter Typ B114 verlängern sich die Haltermaße I₁ und I₂ um 3,0 / 5,5 oder 6,5 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 / 5,5 or 6,5 mm.

Weitere Abmessungen auf Anfrage
Further sizes upon request

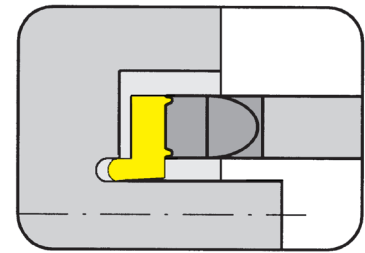


AXIALEINSTECHEN FACE GROOVING



SCHNEIDPLATTE Typ INSERT Type

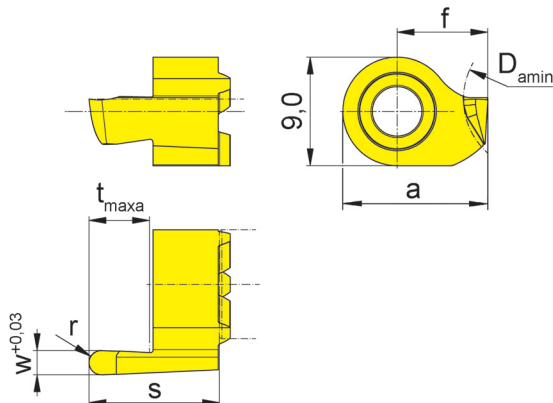
114



| | | |
|----------------|-----------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 12,0 mm |
| Stechtiefe bis | Depth of groove up to | 6,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Vollradius
Bearbeitung **HINTER** der
Drehmitte!
Full radius
Machining **BEHIND** centre line

| Bestellnummer 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 | | | ▲/▲ | | |
| <p>▲ ab Lager / on stock Δ 4 Wochen / 4 weeks</p> <p>● Haupteinsatzbereich / main recommendation</p> <p>o bedingt einsetzbar / alternative recommendation</p> <p>■ unbeschichtete HM-Sorten / uncoated grades</p> <p>■ beschichtete HM-Sorten / coated grades</p> <p>■ bestückt/Cermet / brazed/Cermet</p> | | | | | | | | P | • | | |
| | | | | | | | | M | • | | |
| | | | | | | | | K | • | | |
| | | | | | | | | N | • | | |
| | | | | | | | | S | • | | |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Hinweis:

Ausführung R = Spindel linksdrehend!
Bei Verwendung der Axialstechplatte Typ 114 mit Klemhalter Typ B114 verlängern sich die Haltermaße I₁ und I₂ um 5,5 oder 6,5 mm.

Note:

R = rotation anti-clockwise!
Using the face grooving insert type 114 on toolholder type B114 the size I₁ and I₂ will be enlarged by 5,5 mm or 6,5 mm.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

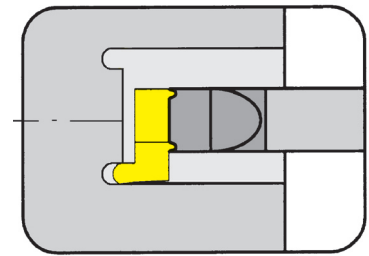
K

AXIALEINSTECHEN FACE GROOVING



SCHNEIDPLATTE Typ INSERT Type

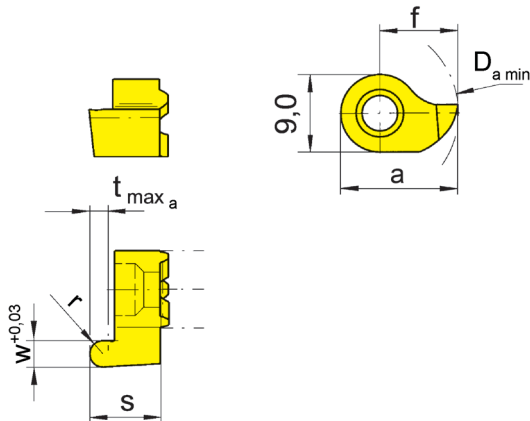
114



| | | |
|----------------|-----------------------|--------------|
| Nutaußen-Ø ab | from outer groove Ø | 14,0 mm |
| Stechtiefe bis | Depth of groove up to | 3,0 mm |
| Stechbreite | Width of groove | 1,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B114
Type HC114



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Vollradius
Bearbeitung **VOR** der
Drehmitte!
Full radius
Machining **IN-FRONT** of centre line

| Bestellnummer 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 | | | ▲/▲ | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|--|--|
| P | ● | | |
| M | ● | | |
| K | ● | | |
| N | ● | | |
| S | ● | | |
| H | | | |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Ausführung R oder L angeben
State R or L version

Hinweis:

Ausführung R = Spindel rechtsdrehend!

Bei Verwendung der Axialstechplatte Typ 114 mit Klemmhalter Typ B114 verlängern sich die Haltermaße I₁ und I₂ um 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.

Weitere Abmessungen auf Anfrage

Further sizes upon request



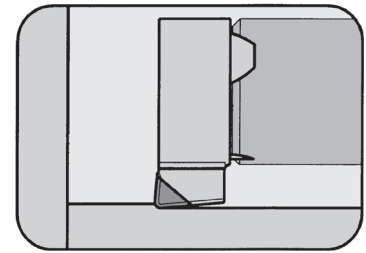
BOHRUNGEN HART AUSDREHEN

HARD BORING



SCHNEIDPLATTE Typ
INSERT Type

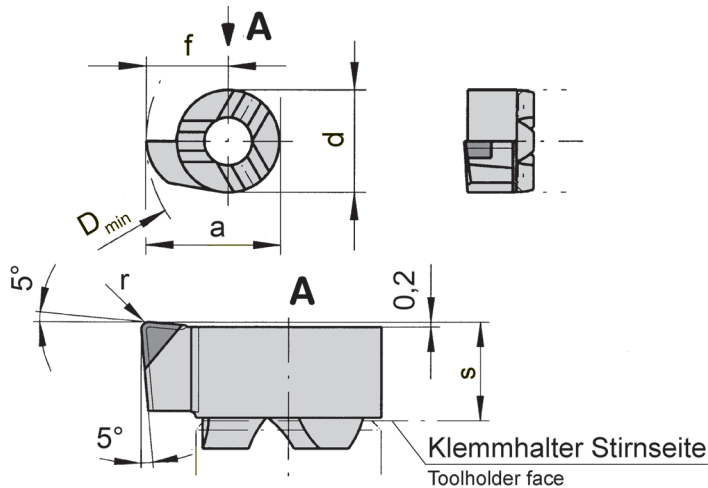
114



Bohrungs-Ø ab Bore Ø from 12,5 mm

für Klemmhalter
for use with Toolholder

Typ B114
Type



R = rechts wie gezeichnet
R = right hand version shown

CBN-bestückt
PCBN tipped

| Bestellnummer 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 | ▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P |
| ● Haupteinsatzbereich / main recommendation | | | | | | | M |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | N |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | S |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | H • |

Abmessungen in mm
Dimensions in mm

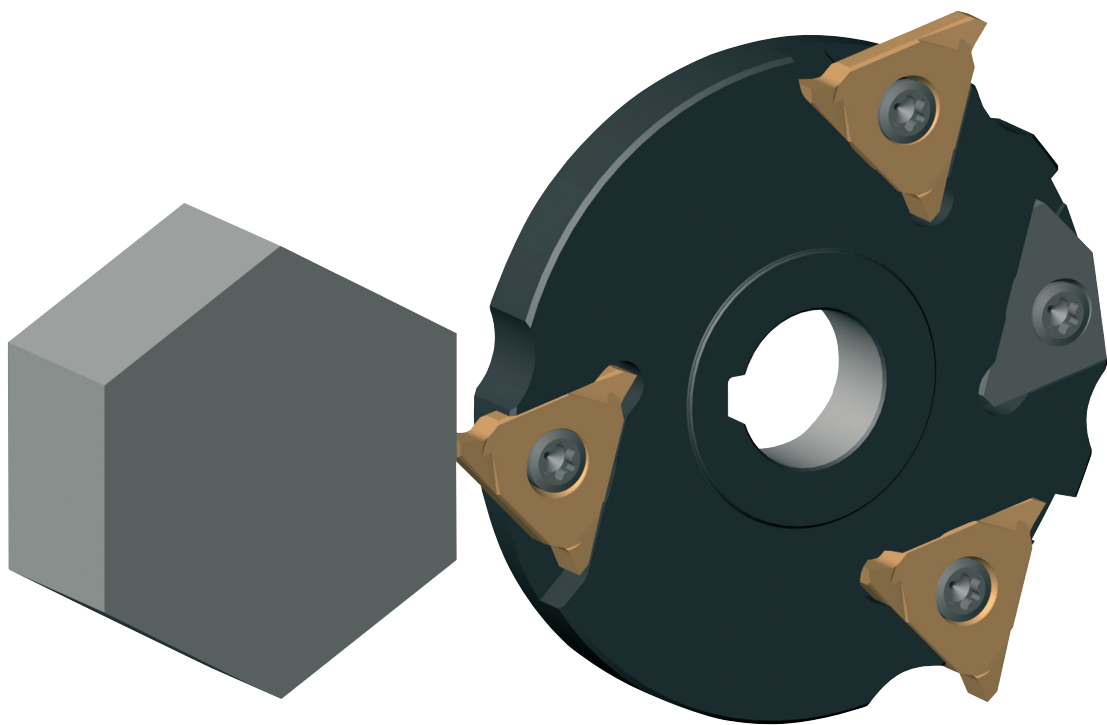
Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



Schlagmesser

Einsetzbar auf Drehmaschinen mit angetriebenen Werkzeugen zum Schlagen von Mehrkantflächen im Einstech- oder Längsdrehverfahren.
Weitere Informationen finden Sie in unserem Katalog "ROTIERENDE WERKZEUGE".



Cutter

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

K

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

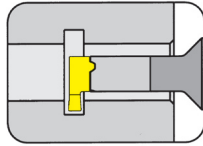
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

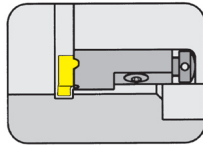
Typ 116
type

B116
Klemmhalter
Toolholder



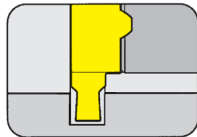
Seite / Page
L2-L3

R/L145
Klemmhalter
Toolholder

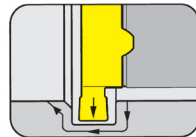


Seite / Page
L4

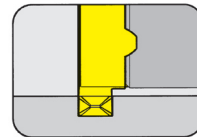
116 / S116
≥ Ø 14,0 mm
Schneidplatten
Inserts



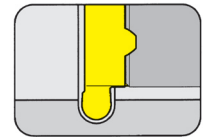
Seite / Page
L5-L6, L8



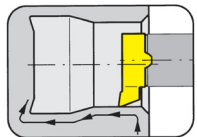
Seite / Page
L7



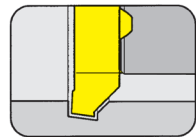
Seite / Page
L9



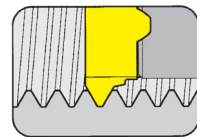
Seite / Page
L11



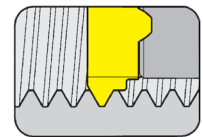
Seite / Page
L12-L14



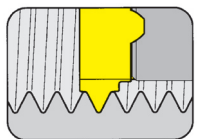
Seite / Page
L15



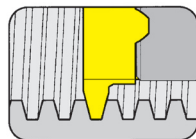
Seite / Page
L16-L17



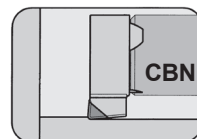
Seite / Page
L18-L19



Seite / Page
L20



Seite / Page
L21



Seite / Page
L22

Technische Hinweise
Technical Instructions

Seite N2-N8
Page

L

EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)

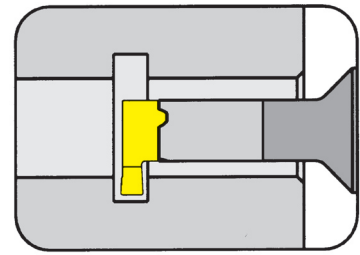


KLEMMHALTER Typ

TOOLHOLDER Type

B116

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Stechtiefe | Depth of groove | 4,3 mm |
| Stechbreite bis | Width of groove up to | 4,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance

für Schneidplatte
for use with Insert

Typ 116
Type S116

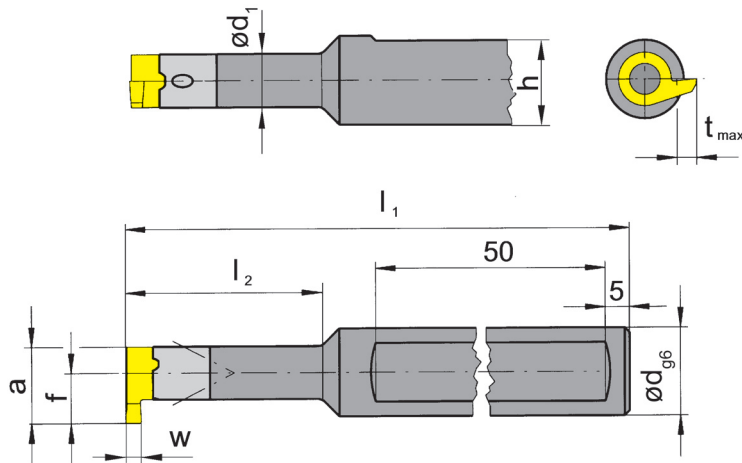


Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w, a, t_{max} und f siehe Schneidplatten
w, a, t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B116.001... | 5.13T20EP | T20PQ |

EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)

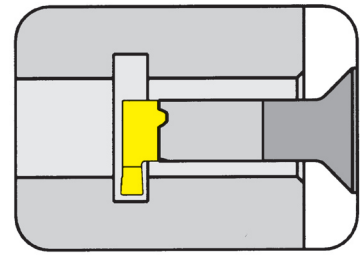


KLEMMHALTER Typ

TOOLHOLDER Type

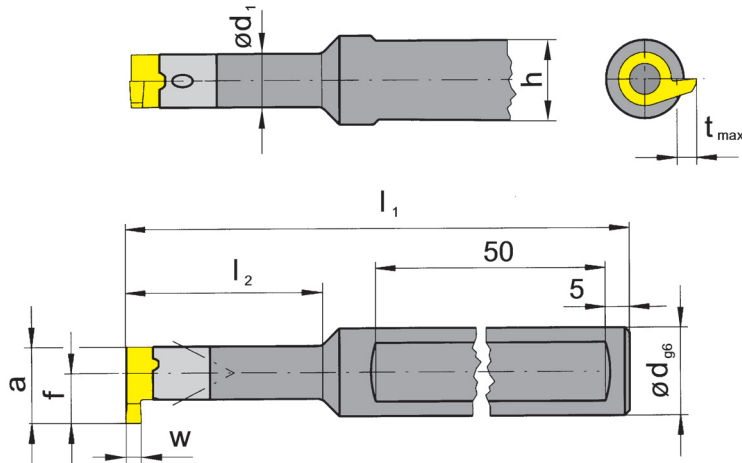
B116

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Stechtiefe | Depth of groove | 4,3 mm |
| Stechbreite bis | Width of groove up to | 4,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance



für Schneidplatte
for use with Insert

Typ 116
Type S116

mit 2 Spannflächen
with 2 clamping flats

Abbildung = rechtsschneidend
Picture = right hand cutting version

| Bestellnummer 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 | | |

Weitere Abmessungen auf Anfrage
Further sizes upon request

w , a , t_{max} und f siehe Schneidplatten
 w , a , t_{max} and f see inserts

Abmessungen in mm
Dimensions in mm

Bestellhinweis:

Klemmhalter sind jeweils für rechte und linke Schneidplatten verwendbar.
Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders can be used with right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| B116.001... | 5.13T20EP | T20PQ |



EINSTECHEN (innen) $\geq \text{Ø } 32,0 \text{ mm}$ GROOVING (internal)

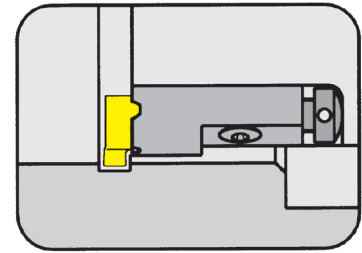


KURZKLEMMHALTER Typ

CARTRIDGE Type

145

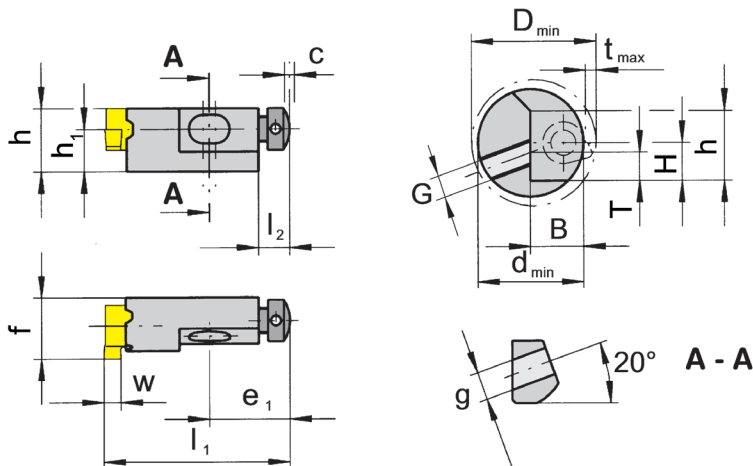
für Einbauzwecke
for customized tools



| | | |
|-----------------|-----------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 32,0 mm |
| Stechtiefe bis | Depth of groove up to | 4,3 mm |
| Stechbreite bis | Width of groove up to | 4,0 mm |

für Schneidplatte
for use with Insert

Typ 116
Type S116



| Bestellnummer Part number | h_1 | f | h | l_1 | D_{min} | t_{max} | e_1 | l_2 | c | g | Spannbereich Clamping range |
|------------------------------|-------|------|----|-------|-----------|-----------|-------|-------|---|-----|--------------------------------|
| R/L145.1012.00 | 10 | 16,7 | 17 | 36 | 32 | 4,3 | 13,8 | 5 | 1 | 6,6 | 0,5 - 4,0 |

Ausführung R oder L angeben
State R or L version

w siehe Schneidplatten
w see inserts

Abmessungen in mm
Dimensions in mm

Schneidkantenhöhe h_1

Sonderhöhe $h_1 = 6$ oder 7 mm auf Anfrage möglich.

Height of cutting edge h_1

Special height $h_1 = 6$ or 7 mm available upon request.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

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

| Einbaumaße seating sizes | H | T | B | G | d_{min} | h |
|-----------------------------|----|-----|------|----|-----------|----|
| R/L145.1012.00 | 10 | 9,0 | 12,0 | M6 | 26 | 17 |

Ersatzteile

Spare parts

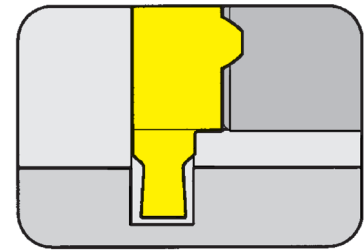
| Kurzklemmhalter Cartridge | Bef.schraube Fixing screw | Spannschraube Screw | Stellschraube Adjusting screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
|------------------------------|------------------------------|------------------------|----------------------------------|---|
| R/L145.1012.00 | 6.20.232 | 5.13T20EP | 4.06.020 | T20PQ |

EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)



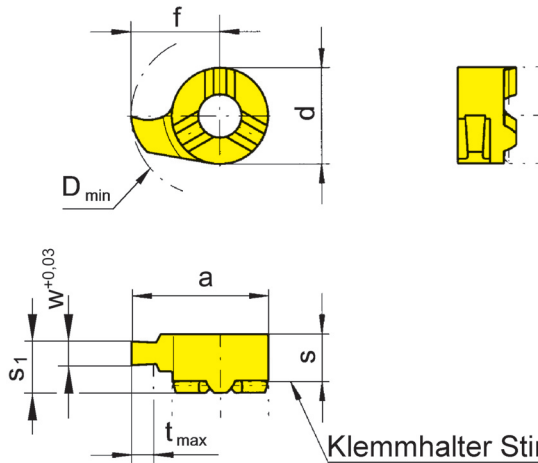
SCHNEIDPLATTE Typ INSERT Type

116



| | | |
|------------------|---------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Stechtiefe | Depth of groove | 1,2 - 1,5 mm |
| Nutnennbreite Nw | Width of circlip Nw | 0,7 - 0,9 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

für Klemmhalter
for use with Toolholder

Typ 145
Type B116

Zapfenausführung
not face cutting,
limited depth of cut

| Bestellnummer 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 | | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

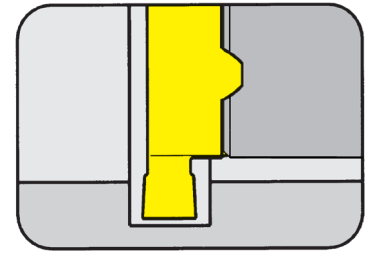


EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)



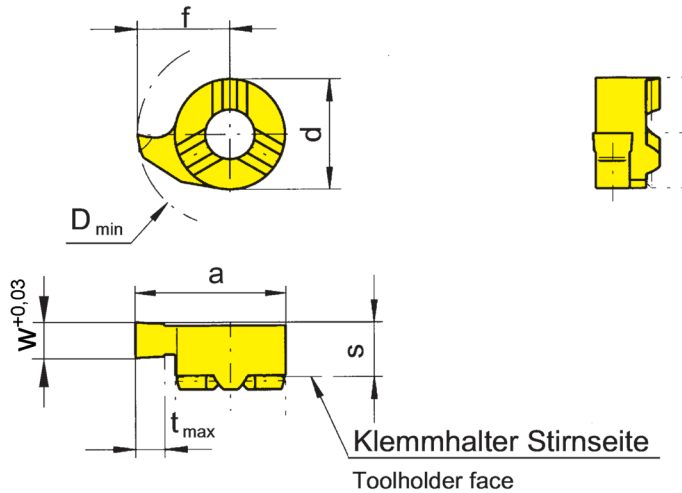
SCHNEIDPLATTE Typ INSERT Type

116



| | | |
|------------------|---------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Nutnennbreite Nw | Width of circlip Nw | 1,1 - 1,6 mm |

Abmessungen für Seegerringnuten DIN 471/472
Widths for circlip grooves DIN 471/472



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation ○ bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | P | ○ | ● | ● |
| | | | | | | | | | M | ● | ● | ● |
| | | | | | | | | | K | ● | ● | ● |
| | | | | | | | | | N | ● | ● | ● |
| | | | | | | | | | S | ● | ● | ● |
| | | | | | | | | | H | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request



NC-FEINDREHEN (innen) $\geq \varnothing 16,0$ mm

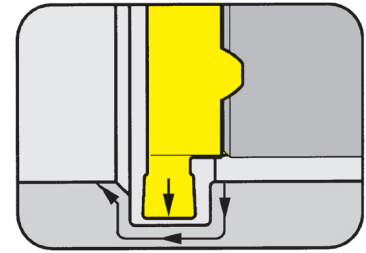
NC-PROFILING (internal)



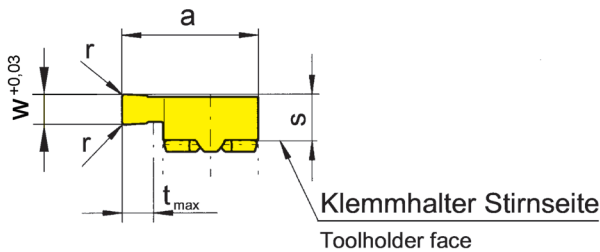
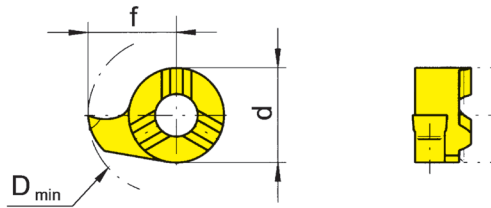
SCHNEIDPLATTE Typ 116

INSERT Type

116



| | | |
|----------------------------|-------------------------|---------|
| Bohrungs- \varnothing ab | Bore \varnothing from | 16,0 mm |
| Stechtiefe | Depth of groove | 4,3 mm |



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock | | | | | | | | | | P | • | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | | M | • | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | | K | • | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | N | • | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | | S | • | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



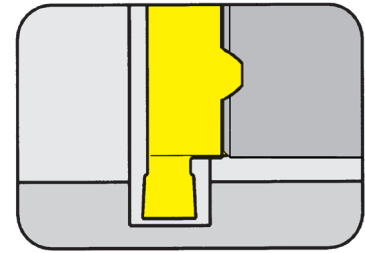
EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ

116

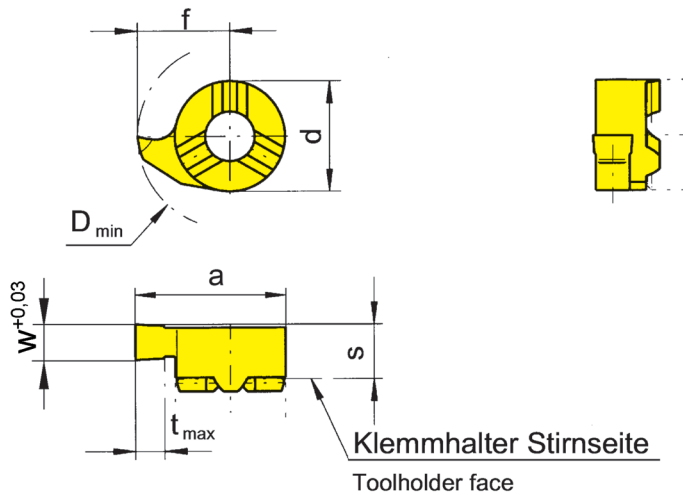
INSERT Type



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Stechtiefe | Depth of groove | 4,3 mm |
| Stechbreite | Width of groove | 2,0 - 4,0 mm |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | w | s | f | a | d | t _{max} | D _{min} | 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| MG12 | o | • | • | • | • | • |
| TN35 | • | • | • | • | • | • |
| TI25 | • | • | • | • | • | • |
| TH35 | • | • | • | • | • | • |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

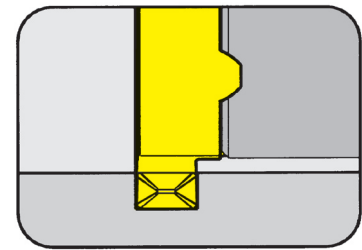
Weitere Abmessungen auf Anfrage
Further sizes upon request

EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)

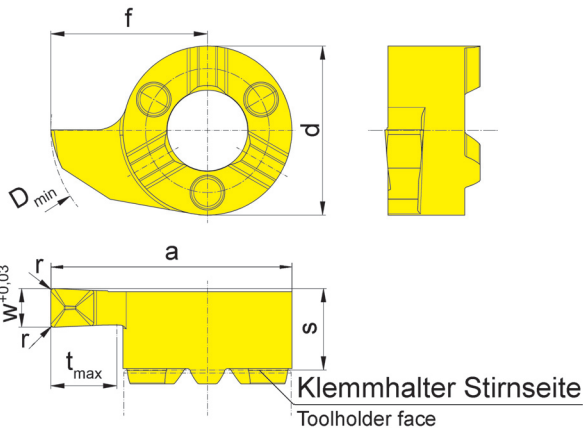


SCHNEIDPLATTE Typ INSERT Type

S116



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Stechtiefe bis | Depth of groove up to | 4,3 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Geometrie .D
Geometry .D

| Bestellnummer 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 | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

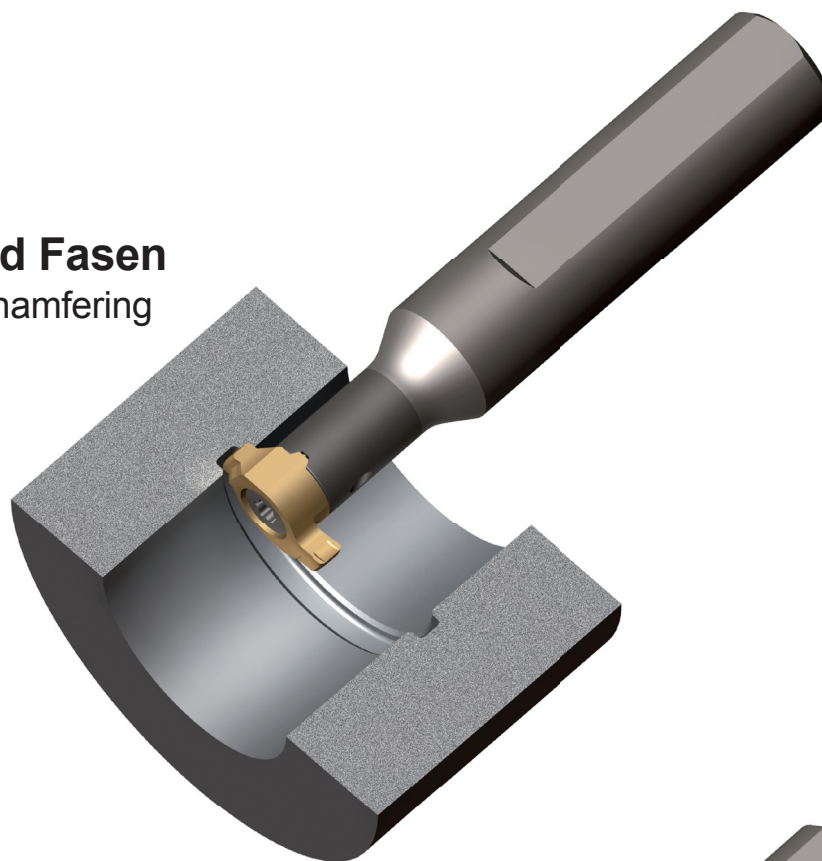


Einsparen von Werkzeugwechsel ab \varnothing 18 mm

Reducing of tool change
from \varnothing 18 mm

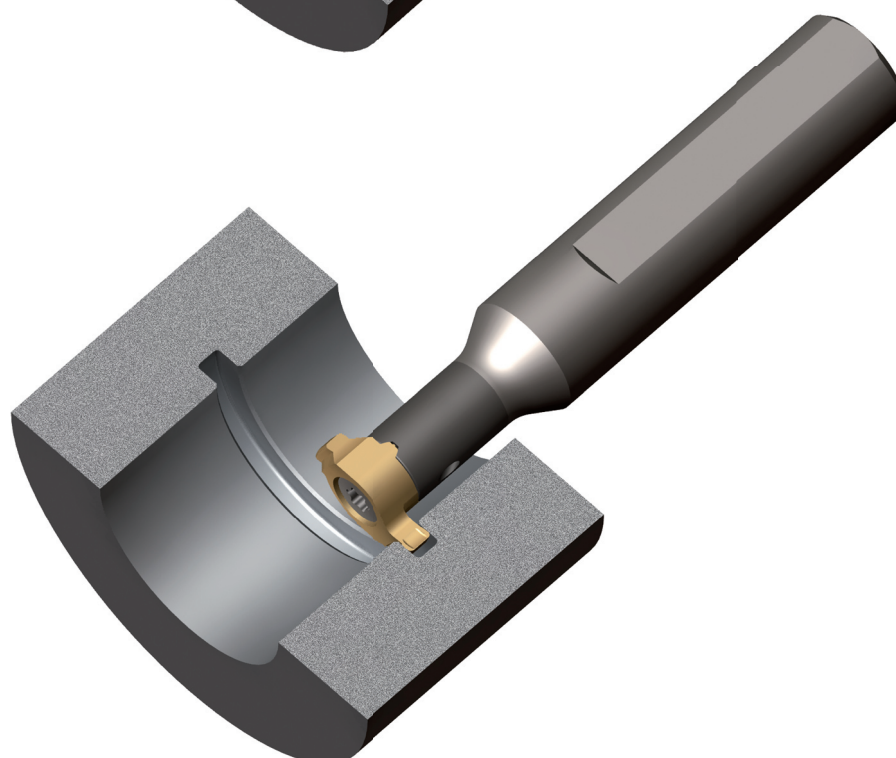
Vorstechen und Fasen

Pregrooving and chamfering



Fertigstechen

Finishing



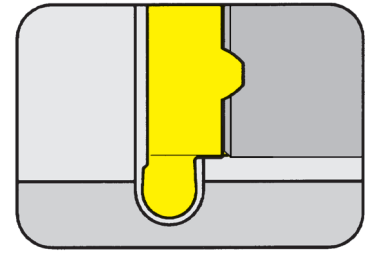
L

EINSTECHEN (innen) $\geq \text{Ø } 16,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

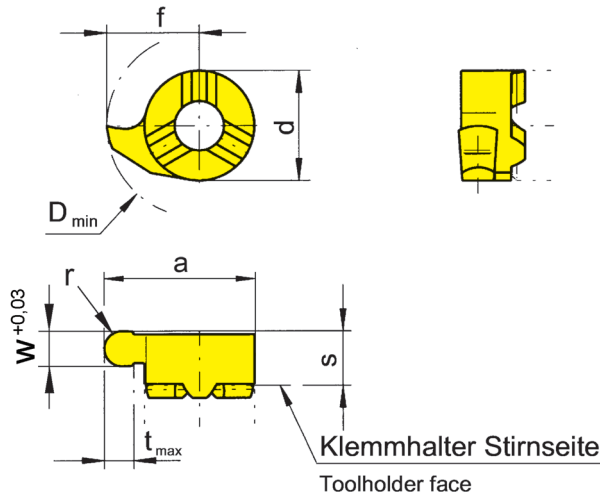
116



| | | |
|-----------------------------|----------------------------|---------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 16,0 mm r 0,9 - 2,0 mm |
|-----------------------------|----------------------------|---------------------------|

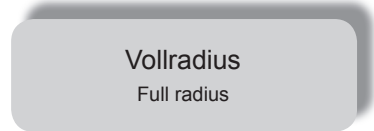
für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version



| Bestellnummer 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 | | | | | | | ▲/▲ | ▲/▲ | | ▲/▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|---|
| P | o | ● | ● |
| M | ● | ● | ● |
| K | ● | ● | ● |
| N | ● | ● | ● |
| S | ● | ● | ● |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



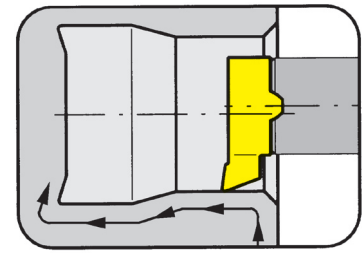
BOHRUNG-DREHEN $\geq \varnothing 15,5$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

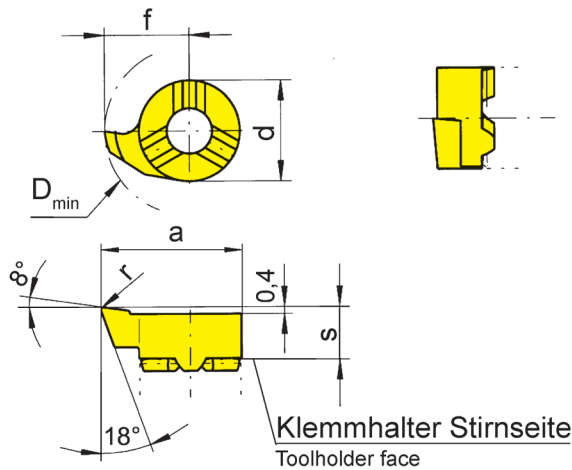
116



Bohrungs- \varnothing ab Bore \varnothing from 15,5 mm

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | P | • | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | M | • | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | K | • | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | N | • | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | S | • | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 15,5$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 15,5$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

L

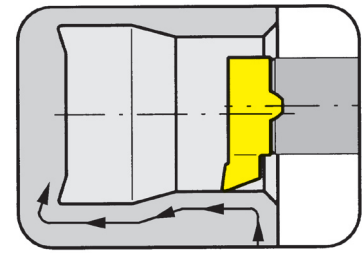
BOHRUNG-DREHEN $\geq \varnothing 15,5$ mm

BORING and PROFILING

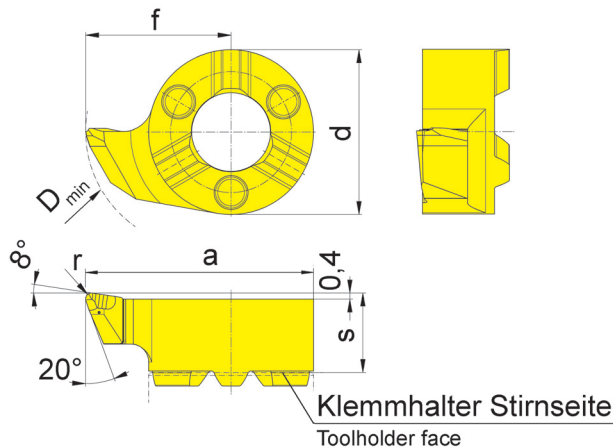


SCHNEIDPLATTE Typ INSERT Type

S116



Bohrungs- \varnothing ab Bore \varnothing from 15,5 mm



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

Geometrie .R
Geometry .R

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | D _{min} | MG12 | TN35 | Ti25 | TH35 |
|------------------------------|-----|-----|-----|------|----|------------------|------|------|------|------|
| LS116.1897.R2 | 0,2 | | | | | | | | | ▲ |
| RS116.1897.R2 | 0,2 | | | | | 15,5 | | | | ▲ |
| LS116.1897.R4 | 0,4 | 5,3 | 9,7 | 15,2 | 11 | | | | | ▲ |
| RS116.1897.R4 | 0,4 | | | | | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | | |
|---|--|--|--|---|
| P | | | | ● |
| M | | | | ● |
| K | | | | ● |
| N | | | | ● |
| S | | | | ● |
| H | | | | |

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 15,5$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 15,5$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request



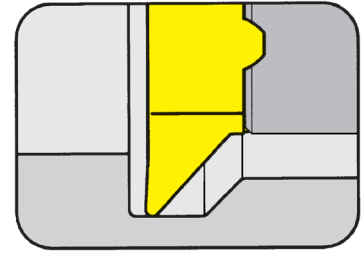
BOHRUNG-DREHEN $\geq \varnothing 16,0$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ INSERT Type

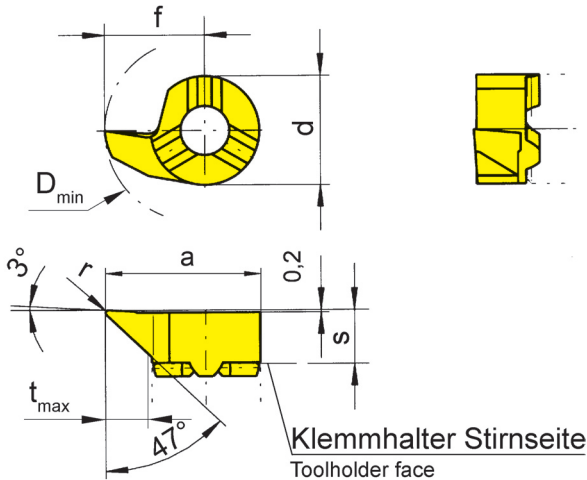
116



| | | |
|---|--|-------------------|
| Bohrungs- \varnothing ab Profiltiefe bis | Bore \varnothing from Depth of undercut up to | 16,0 mm 4,3 mm |
|---|--|-------------------|

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | 5,3 | 10,2 | 15,7 | 11 | 4,3 | 16 | | ▲/▲ | | ▲/▲ |
| ▲ ab Lager / on stock | | | | | | | | | | | |
| Δ 4 Wochen / 4 weeks | | | | | | | | | | | |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | | | |
| ○ bedingt einsetzbar / alternative recommendation | | | | | | | | | | | |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | | | |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | | | |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 16,0$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E.
The modified geometry allows boring of bores $\geq \varnothing 16,0$ mm and profiling of reliefs as per DIN 509 form E.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

L

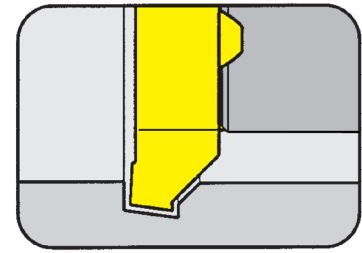
VORSTECHEN und FASEN (innen)

PREGROOVING and CHAMFERING (internal)

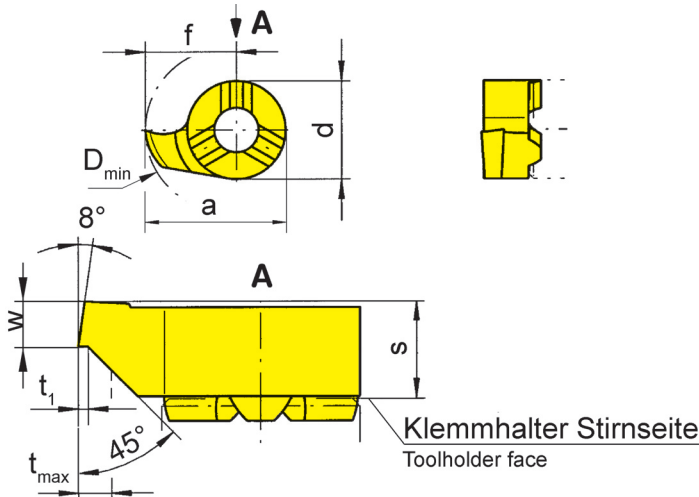


SCHNEIDPLATTE Typ
INSERT Type

116



Bohrungs-Ø ab Bore Ø from 16,0 mm



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | ▲/△ | | ▲/▲ | |
| ▲ ab Lager / on stock △ 4 Wochen / 4 weeks | | | | | | | | | P | ○ | ● | ● |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | | M | ● | ● | ● |
| ○ bedingt einsetzbar / alternative recommendation | | | | | | | | | K | ● | ● | ● |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | ● | ● | ● |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | ● | ● | ● |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Teilprofil

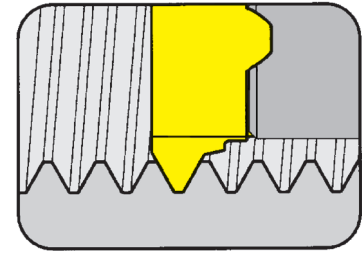
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

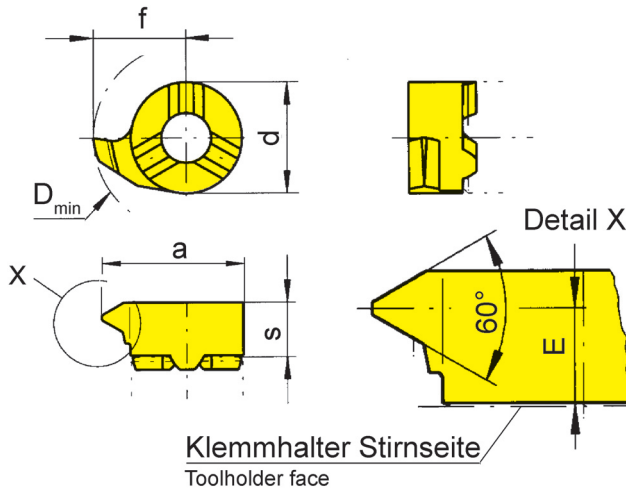
116



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Steigung | Pitch | 2,0 - 2,5 mm |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer 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 | ▲/▲ | ● | ● | ● |
| ▲ ab Lager / on stock △ 4 Wochen / 4 weeks | | | | | | | | P | ● | ● | ● |
| ● Haupteinsatzbereich / main recommendation | | | | | | | | M | ● | ● | ● |
| ○ bedingt einsetzbar / alternative recommendation | | | | | | | | K | ● | ● | ● |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | ● | ● | ● |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | S | ● | ● | ● |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | H | ● | ● | ● |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

L

GEWINDEDREHEN (innen) Teilprofil

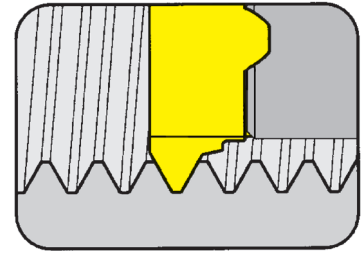
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

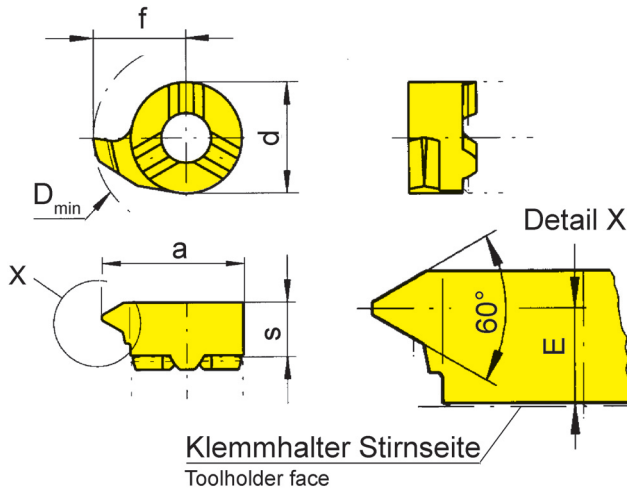
116



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Steigung | Pitch | 1,0 - 1,5 mm |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Feingewinde
Metric ISO fine thread

| Bestellnummer Part number | P | P _{max} | E | s | f | a | d | D _{min} | | 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 | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

| | | | |
|---|---|--|---|
| P | • | | • |
| M | • | | • |
| K | • | | • |
| N | • | | • |
| S | • | | • |
| H | | | |

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Vollprofil

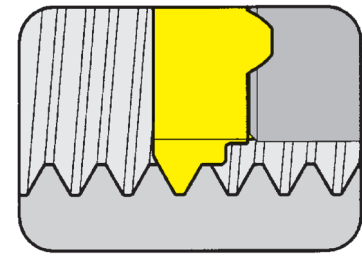
THREADING (internal) Full profile



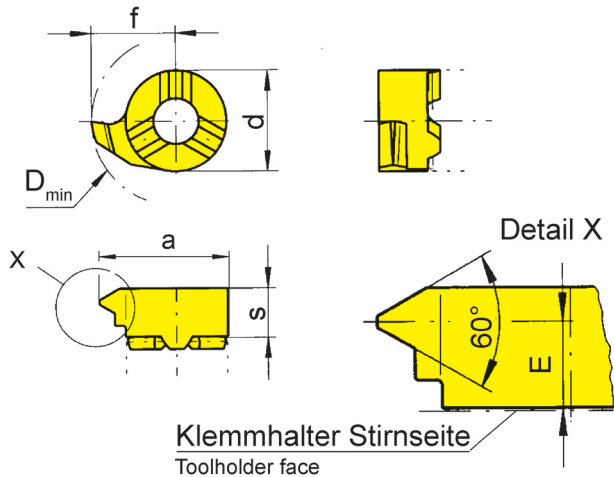
SCHNEIDPLATTE Typ

INSERT Type

116



Bohrungs-Ø ab Bore Ø from 16,0 mm
Steigung Pitch 2,5 - 4,0 mm



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Regelgewinde
Metric ISO standard thread

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | HM-Sorten / Carbide grades | | | |
|--|-----|-----|-----|------|------|----|------------------|----------------------------|------|------|------|
| | | | | | | | | MG12 | TN35 | TI25 | TH35 |
| R/L116.1325.02 | 2,5 | 4,2 | | | | | | ▲/Δ | | | |
| 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 | | | | | | ▲/Δ | | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks ● Haupteinsatzbereich / main recommendation o bedingt einsetzbar / alternative recommendation ■ unbeschichtete HM-Sorten / uncoated grades ■ beschichtete HM-Sorten / coated grades ■ bestückt/Cermet / brazed/Cermet | | | | | | | | P | • | | |
| | | | | | | | | M | • | | |
| | | | | | | | | K | • | | |
| | | | | | | | | N | • | | |
| | | | | | | | | S | • | | |
| | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

L

GEWINDEDREHEN (innen) Vollprofil

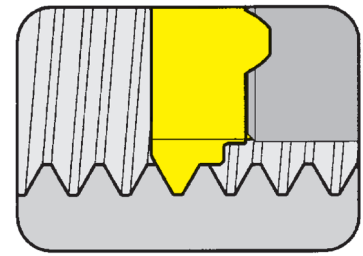
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

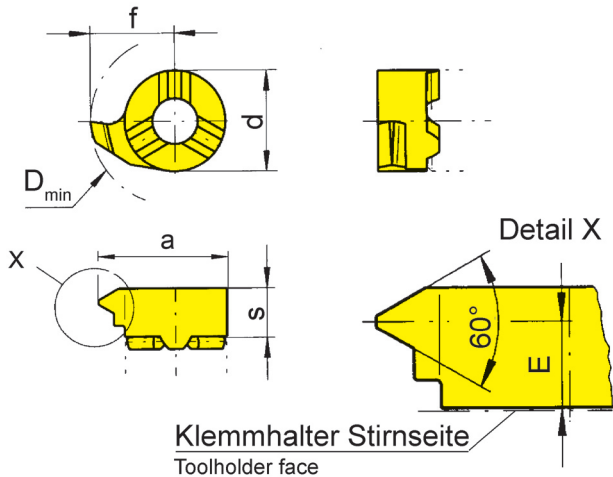
116



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Steigung | Pitch | 1,0 - 2,0 mm |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Feingewinde
Metric ISO fine thread

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|---|-----|-----|-----|------|------|----|------------------|------|------|------|------|
| R/L116.0510.02 | 1,0 | 4,7 | | | | | | | ▲/Δ | | |
| R/L116.0815.02 | 1,5 | 4,5 | 5,5 | 10,2 | 15,7 | 11 | 16 | ▲/▲ | | | |
| R/L116.1020.02 | 2,0 | 4,3 | | | | | | ▲/Δ | | | |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | P | • | | |
| • Haupteinsatzbereich / main recommendation | | | | | | | | M | • | | |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | K | • | | |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | N | • | | |
| beschichtete HM-Sorten / coated grades | | | | | | | | S | • | | |
| bestückt/Cermet / brazed/Cermet | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Vollprofil

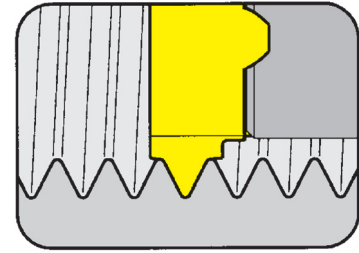
THREADING (internal) Full profile



SCHNEIDPLATTE Typ

INSERT Type

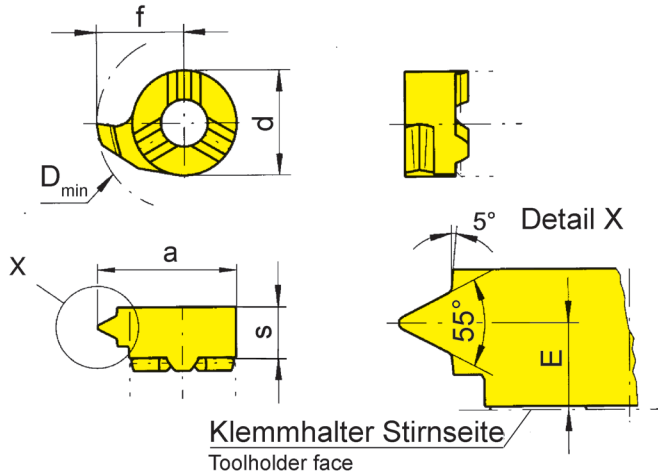
116



| | | |
|---------------|------------------|---------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Gang pro Zoll | Threads per inch | 11/14 |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



Whitworth-Rohrgewinde
nach DIN ISO 228; (259)
und 2999

Whitworth pipe thread as per
DIN ISO 228; (259) and 2999

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | Gang/Zoll 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 | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



GEWINDEDREHEN (innen) Teilprofil

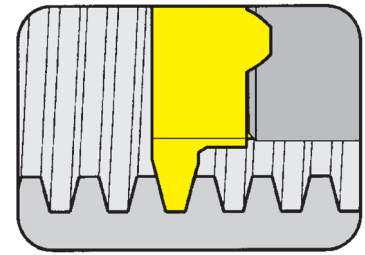
THREADING (internal) Partial profile



SCHNEIDPLATTE Typ

INSERT Type

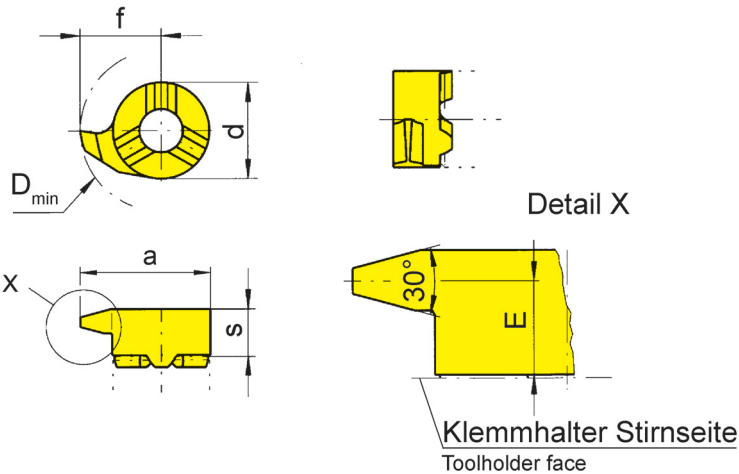
116



| | | |
|---------------|-------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 16,0 mm |
| Steigung | Pitch | 2,0 - 6,0 mm |

für Klemmhalter
for use with Toolholder

Typ 145
Type B116



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Metrisches ISO
Trapezgewinde DIN 103
Metric ISO trapezoidal
thread DIN 103

| Bestellnummer Part number | P | E | s | f | a | d | D _{min} | Trapezgewinde 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 | | | ▲/▲ | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | | | |
|---|---|---|--|
| P | ● | ● | |
| M | ● | ● | |
| K | ● | ● | |
| N | ● | ● | |
| S | ● | ● | |
| H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades



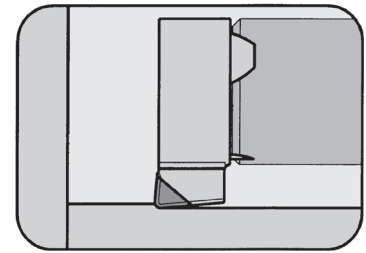
BOHRUNGEN HART AUSDREHEN

HARD BORING

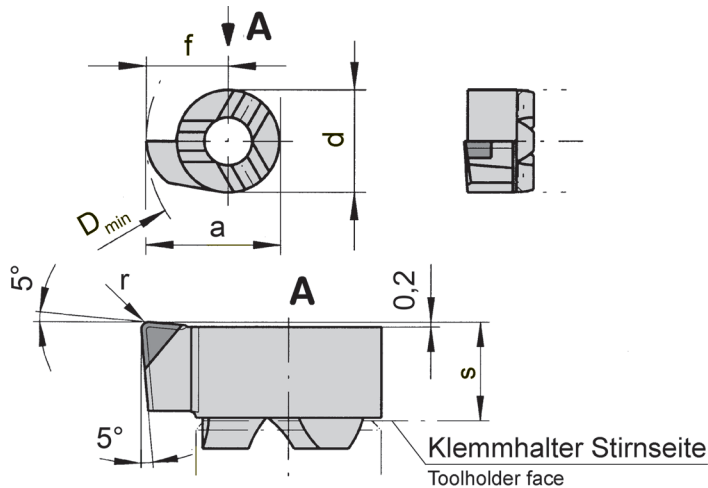


SCHNEIDPLATTE Typ
INSERT Type

116



Bohrungs-Ø ab Bore Ø from 14,0 mm



für Klemmhalter
for use with Toolholder

Typ 145
Type B116

CBN-bestückt
PCBN tipped

R = rechts wie gezeichnet
R = right hand version shown

| Bestellnummer 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 |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| |
|---|
| P |
| M |
| K |
| N |
| S |
| H |

Abmessungen in mm
Dimensions in mm

HM-Sorten
Carbide grades

Weitere Abmessungen auf Anfrage
Further sizes upon request



**HOCHLEISTUNGSREIBEN
HORN System DR**

**HIGH-PERFORMANCE REAMING
HORN System DR**

Ø 11,9 - 100,6 mm



Lizenz / Licence 

**- Synergieeffekte nutzen -
- Benefits of Synergy -**



Weitere Informationen finden Sie in unserem HORN-Katalog "ROTIERENDE WERKZEUGE"
For further information please ask for the HORN catalogue "ROTATING TOOLS"

HCG - HORN Catalogue Guide

INNENBEARBEITUNG / INTERNAL GROOVING

| Bohrungs-Ø Bore Ø | Artikelgruppen / Product line | | | | | | | | | | | | |
|----------------------|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|---|
| | 105 | 109 | 110 | 106 | 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 | | | | | | | | | | | | | • |

| | | | | | | | | | | | | |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|
| Stechtiefe Depth of groove | 2,5 | 2,5 | 4,0 | 0,8 | 2,0 | 1,0 | 3,0 | 2,3 | 3,5 | 4,0 (6,5) | 4,3 | 8,0 |
|-------------------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|--------------|-----|-----|

| | | | | | | | | | | | | |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Stechbreite Width of groove | 0,5-2,0 | 1,0-2,0 | 1,0-3,0 | 0,7-1,5 | 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 |
|--------------------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|

| Bearbeitung / Machining | | | | | | | | | | | | |
|---------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Einstechen / Grooving | • | • | • | • | • | • | • | • | • | • | • | • |
| Ausdrehen / Boring | • | • | • | • | • | • | | • | | • | • | |
| Gewindedrehen / Threading | • | • | | | • | • | | • | | • | • | |
| Fasen / Chamfering | • | • | | • | • | • | | • | | • | • | |
| Axialeinstechen / Face Grooving | • | • | • | | | | | | | • | | |
| Hartdrehen / Hard turning | • | | | | | • | | • | | • | • | |

| | | | | | | | | | | | | |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Kapitel / Chapter | A | B | C | D | E | F | G | H | J | K | L | M |
|-------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|

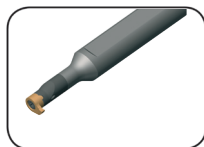
Sonderwerkzeuge sind auf Anfrage erhältlich
Special tools upon request

Abmessung in mm
Dimensions in mm

Mini HM-SCHNEIDWERKZEUGE
Mini CARBIDE GROOVING TOOLS

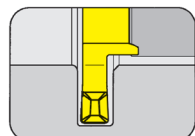
Typ **18P**
type

B18P
Klemmhalter
Toolholder

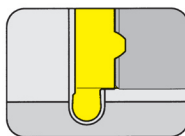


Seite/Page
M2

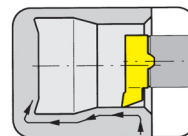
18P / S18P
≥ Ø 18 mm
Schneidplatten
Inserts



Seite/Page
M3, M5



Seite/Page
M4



Seite/Page
M6

Technische Hinweise
Technical Instructions

Seite
Page **N2-N8**

EINSTECHEN (innen) $\geq \text{Ø } 18,0 \text{ mm}$ GROOVING (internal)

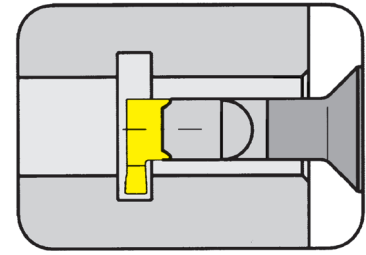


KLEMMHALTER Typ

TOOLHOLDER Type

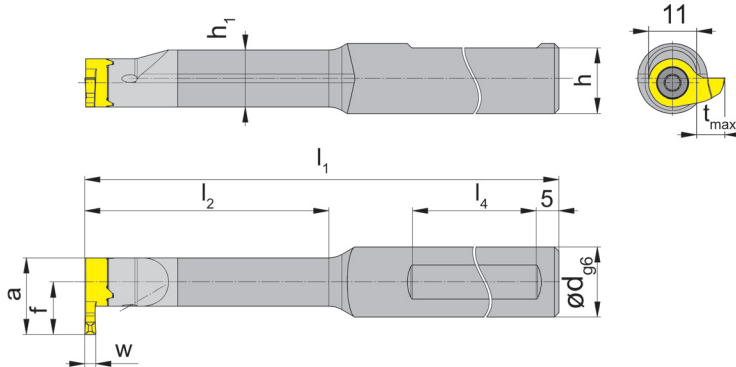
B18P

mit innerer Kühlmittelzufuhr
with through coolant supply



| | | |
|----------------|-----------------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 18,0 mm |
| Stechtiefe bis | Depth of groove up to | 8,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

Schaftmaterial: Hartmetall (schwingungsarm)
Material of shank: Carbide - Giving a good vibration resistance



für Schneidplatte
for use with Insert

Typ 18P
Type S18P

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | |

Ausführung R oder L angeben
State R or L version

w, a, t_{\max} und f siehe Schneidplatten
w, a, t_{\max} and f see inserts

Abmessungen in mm
Dimensions in mm

Weitere Abmessungen auf Anfrage
Further sizes upon request

Bestellhinweis:

Klemmhalter mit beschädigter Schneidplattenaufnahme können durch unseren Reparaturservice instand gesetzt werden.

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.
For torque specifications of the screw, please see Technical Instructions.

M

Ersatzteile

Spare parts

| | | |
|---------------------------|------------------------|---|
| Klemmhalter Toolholder | Spannschraube Screw | TORX PLUS®-Schlüssel TORX PLUS® Wrench |
| R/LB18P.001... | 5.13T20EP | T20PQ |

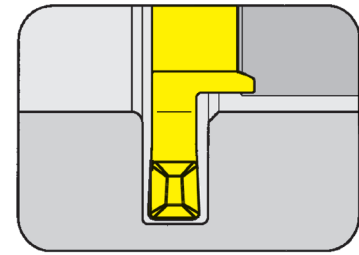
M2

EINSTECHEN (innen) $\geq \text{Ø } 18,0 \text{ mm}$ GROOVING (internal)

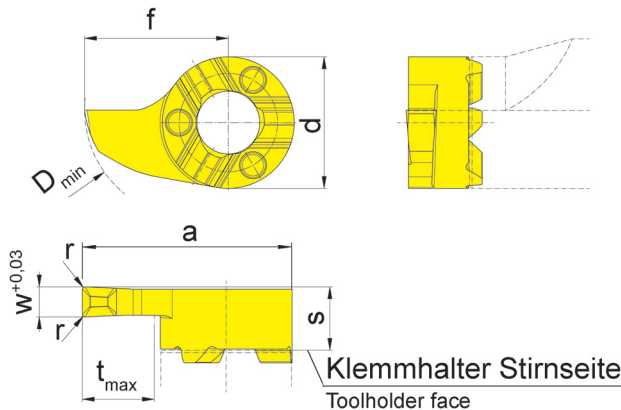


SCHNEIDPLATTE Typ INSERT Type

S18P



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 18,0 mm |
| Stechtiefe | Depth of groove | 6,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |



für Klemmhalter
for use with Toolholder

Typ B18P
Type

Klemmhalter Stirnseite
Toolholder face

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

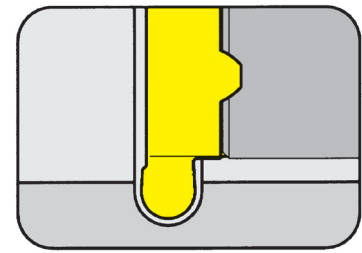
M

EINSTECHEN (innen) $\geq \text{Ø } 18,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

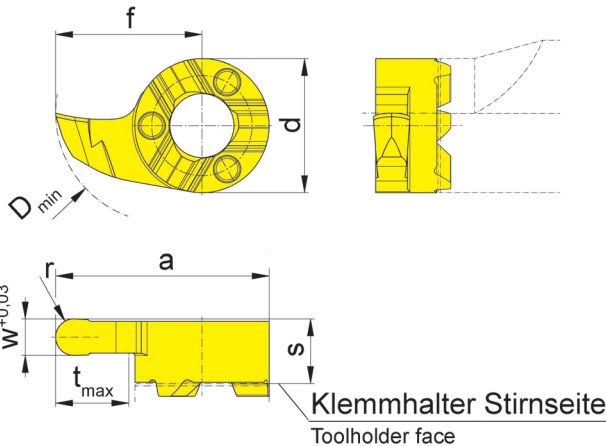
18P



| | | |
|-----------------------------|----------------------------|---------------------------|
| Bohrungs-Ø ab Vollradius | Bore Ø from Full radius | 18,0 mm r 0,9 - 1,5 mm |
|-----------------------------|----------------------------|---------------------------|

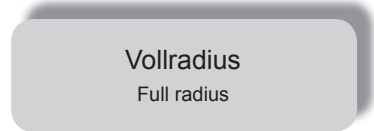
für Klemmhalter
for use with Toolholder

Typ B18P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version



| Bestellnummer 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 | | | | | | | | | | ▲/Δ |
| R/L18P.0011.1.22 | 2,2 | 1,1 | 5,3 | 12 | 17,5 | 11 | 6 | 18 | | | | Δ/Δ |
| R/L18P.0015.1.30 | 3,0 | 1,5 | | | | | | | | | | ▲/Δ |
| | | | | | | | | | | P | | • |
| | | | | | | | | | | M | | • |
| | | | | | | | | | | K | | • |
| | | | | | | | | | | N | | • |
| | | | | | | | | | | S | | • |
| | | | | | | | | | | H | | |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

HM-Sorten
Carbide grades

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

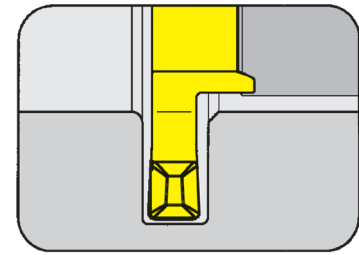
M

EINSTECHEN (innen) $\geq \text{Ø } 20,0 \text{ mm}$ GROOVING (internal)



SCHNEIDPLATTE Typ INSERT Type

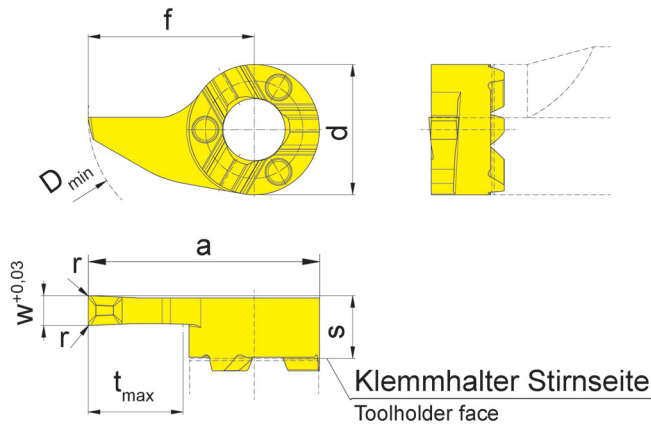
S18P



| | | |
|---------------|-----------------|--------------|
| Bohrungs-Ø ab | Bore Ø from | 20,0 mm |
| Stechtiefe | Depth of groove | 8,0 mm |
| Stechbreite | Width of groove | 2,0 - 3,0 mm |

für Klemmhalter
for use with Toolholder

Typ B18P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer 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 | | | | | | | | | | | ▲/▲ |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks | | | | | | | | | P | | | • |
| • Haupteinsatzbereich / main recommendation | | | | | | | | | M | | | • |
| o bedingt einsetzbar / alternative recommendation | | | | | | | | | K | | | • |
| ■ unbeschichtete HM-Sorten / uncoated grades | | | | | | | | | N | | | • |
| ■ beschichtete HM-Sorten / coated grades | | | | | | | | | S | | | • |
| ■ bestückt/Cermet / brazed/Cermet | | | | | | | | | H | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

M

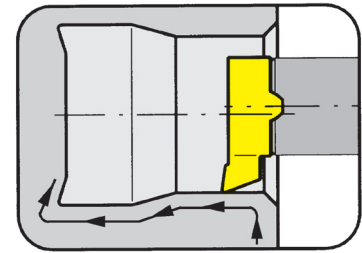
BOHRUNG-DREHEN $\geq \varnothing 17,5$ mm

BORING and PROFILING



SCHNEIDPLATTE Typ
INSERT Type

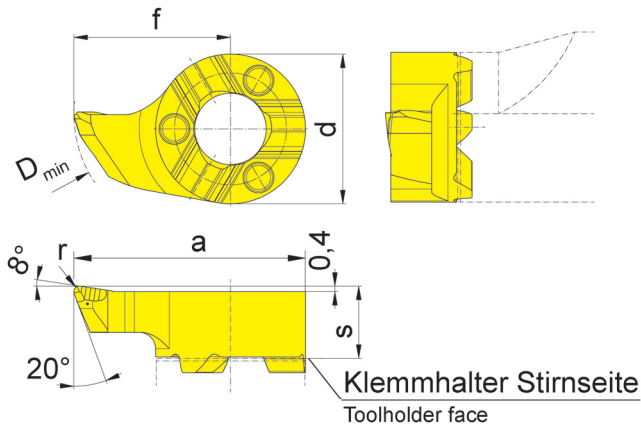
S18P



Bohrungs- \varnothing ab Bore \varnothing from 17,5 mm

für Klemmhalter
for use with Toolholder

Typ B18P
Type



R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

| Bestellnummer Part number | r | s | f | a | d | D _{min} | MG12 | TN35 | TI25 | TH35 |
|------------------------------|-----|-----|------|----|----|------------------|------|------|------|------|
| LS18P.1815.R2 | 0,2 | | | | | | | | | Δ |
| RS18P.1815.R2 | 0,2 | | | | | | | | | ▲ |
| LS18P.1815.R4 | 0,4 | 5,3 | 11,5 | 17 | 11 | 17,5 | | | | Δ |
| RS18P.1815.R4 | 0,4 | | | | | | | | | ▲ |

- ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks
- Haupteinsatzbereich / main recommendation
- o bedingt einsetzbar / alternative recommendation
- unbeschichtete HM-Sorten / uncoated grades
- beschichtete HM-Sorten / coated grades
- bestückt/Cermet / brazed/Cermet

| | P | M | K | N | S | H |
|--|---|---|---|---|---|---|
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Abmessungen in mm
Dimensions in mm

Ausführung R oder L angeben
State R or L version

Die besondere Schneidengeometrie erlaubt das Ausdrehen von Bohrungen $\geq \varnothing 17,5$ mm und das Kopieren von Freistichen gemäß DIN 509 Form E und F.
The modified geometry allows boring of bores $\geq \varnothing 17,5$ mm and profiling of reliefs as per DIN 509 form E and F.

Weitere Abmessungen auf Anfrage
Further sizes upon request

HM-Sorten
Carbide grades

M

| | |
|--|----------------|
| Technische Hinweise Technical Instructions | N2-N8 |
| Anwendungsbeispiele Examples for machining | N10-N16 |
| Zubehör Additional equipment | N18-N21 |

UNBESCHICHTETES HARTMETALL

MG12 - eine universell einsetzbare Sorte mit guter Verschleißfestigkeit. Anwendung bei niedrigen und mittleren Schnittgeschwindigkeiten für die Bearbeitung von Stahl, Guß und Nichteisenmetallen.

BESCHICHTETES HARTMETALL

TN35 - eine TiN-beschichtete Sorte, als Allround-Sorte einsetzbar bei niedrigen und mittleren Schnittgeschwindigkeiten. Auch einsetzbar für die Bearbeitung nichtrostender Stähle oder exotischer Materialien.

TI25 - eine TiCN-beschichtete Sorte mit höherer Verschleißfestigkeit. Empfohlen für die Bearbeitung von Stählen und Nichteisenmetallen bei mittleren Schnittgeschwindigkeiten.

TF45 - eine TiAlN-beschichtete Sorte. Diese Beschichtung zeichnet sich durch höhere Temperaturbeständigkeit bei hoher Härte aus, bleibt aber aufgrund der Einsatzbedingungen nur Sonderanwendungen vorbehalten.

TH35 - eine TiAlN-beschichtete Sorte. Diese Beschichtung zeichnet sich durch extreme Oxydationsbeständigkeit bei höherer Härte und sehr gutem Reibungskoeffizienten aus.

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.

TH35 - a TiAlN coated grade. This coating has an extreme Oxidation resistance with high hardness and very good coefficient of friction.

Nominale Schnittgeschwindigkeiten mit HORN-Sorten

Nominal cutting speeds with HORN grades

| ISO | Material Material | Härte Brinell Hardness Brinell | Vorschub f (mm/U) / Feed rate f (mm/rev) | | | | |
|------------------------------|---|--|--|--------|--------|--------|---------|
| | | | Supermini® | | Mini | | |
| | | | MG12 | TN35 | TI25 | TH35 | CB10/50 |
| P | Kohlenstoffstahl Carbon steel | C < 0,4% | | | | | |
| | | C > 0,4% < 0,6 % | 125 | 14-110 | 14-180 | 14-180 | 14-180 |
| | | C > 0,4% < 0,6 % | 150 | | | | |
| | niedrig legierter Stahl low alloyed steel | gegült annealed | 180 | | | | |
| | | vergütet quenched | 275 | 16-90 | 16-150 | 16-150 | 16-180 |
| | | vergütet quenched | 300 | | | | |
| | hochlegierter Stahl high alloyed steel | gegült annealed | 200 | | 19-90 | 19-90 | 19-120 |
| | | vergütet quenched | 325 | | | | |
| | Stahlguss Cast steel | unlegiert unalloyed | 180 | | | | |
| | | niedrig legiert low alloyed | 220 | 19-110 | 19-180 | 19-180 | 19-180 |
| hoch legiert high alloyed | | 225 | | | | | |
| M | Rostfreier Stahl Stainless steel | martensitisch ferritisch martensitic, ferritic | 200 | | 19-90 | 19-90 | 19-90 |
| | | austenitisch austenitic | 180 | | 16-80 | | 16-80 |
| K | Grauguss Grey cast iron | | 180-260 | 16-90 | 16-150 | 16-150 | 16-150 |
| | Kugelgraphitguss Spheroidal graphite cast iron | | 180-260 | 16-90 | 16-130 | 16-130 | 16-150 |
| | Temperguss Malleable cast iron | | 130-230 | | 16-130 | 16-130 | 16-150 |
| S | Warmfeste Legierung Heat resistant alloy | NiFe | | | | 18-75 | 18-75 |
| | | NiCo | | | | 18-40 | 18-40 |
| N | Al-Legierungen Al-alloys | | | 14-220 | 16-600 | 16-600 | 16-600 |
| | Kupfer- und Messinglegierung Copper and brass alloys | | | 14-220 | 14-700 | 14-700 | 14-700 |
| H | gehärtetes Material hardened material | > 54 HRC | | | | | 20-140 |

v_c ist abhängig vom Werkzeug- \varnothing und damit eingeschränkt durch die Höchstdrehzahl der Maschine.
 v_c is depending on the tool diameter and therefore of the maximum numbers of revolutions of the machine.

GEWINDEDREHEN

Alle Gewinde bis Steigungswinkel 4,5° können mit HORN Standard-Gewindeschneidplatten gefertigt werden. Es sind keine besonderen Unterlagen oder Anstellwinkel erforderlich.

PLATTENSITZE

Die Plattensitze der Mini- und Supermini®-Werkzeuge garantieren eine exakte Positionierung auf Spitzenhöhe. Trotzdem ist immer auf die Spitzenhöhe zu achten, denn Abweichungen können besonders bei Bearbeitung kleinster Durchmesser Probleme bereiten.

SPÄNEABFUHR

Bitte wählen Sie schmale Schneidbreiten, damit der Span geschmeidig bleibt und am Werkzeug vorbei aus der Bohrung fließen kann. Um Spänestau zu vermeiden, ist stufenförmig oder mit Schnittunterbrechung zu stechen.

KÜHLMITTEL

Verwenden Sie gefiltertes Kühlmittel, um die Späne auszuspülen und die Schneide zu kühlen. Ein Kühlmitteldruck von min. 5 bar wird empfohlen.

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® guarantee the accurate centre height of these tools. In spite of this please always check centre height because 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.

EMPFOHLENE ANZAHL DER SCHNITTE
RECOMMENDED NUMBER OF PASSES

| HM-Sorte / Carbide grade | Stahl (Festigkeit Nmm ²) Steel (N/mm ² Tensile strength) | | | | | rostfr. Stahl Stainless steel | Grauguss Grey cast iron | Aluminium 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 | |
| Steigung / Pitch P mm | Anzahl der Schnitte / Number of passes | | | | | | | | |
| Gg ^m / 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 |

Die Anzahl der Durchgänge für das Gewindedrehen in o.g. Tabelle sind nur Richtwerte.

Folgendes ist zu beachten:

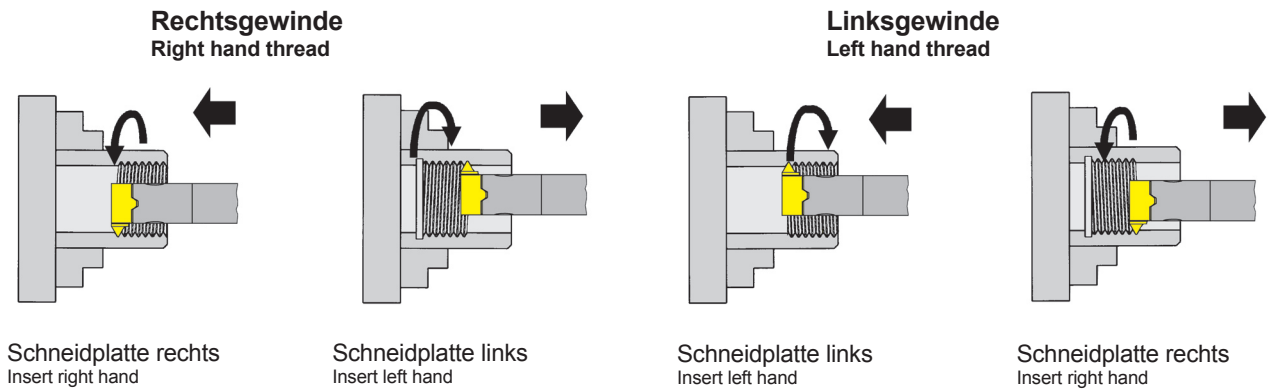
- Beim 1. Durchgang darf die Zustellung nicht zu groß sein, um Ausbrüche an der Schneide zu vermeiden.
- Leerschnitte (ohne Zustellung) sind in der Tabelle nicht berücksichtigt.

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

VORSCHUBSRICHTUNG Innengewindedrehen
 FEED DIRECTION internal threading



ZUSTELLUNG
 IN-FEED

RADIALE ZUSTELLUNG

Die gebräuchlichste Methode Gewinde herzustellen. Beide Schneiden sind gleichzeitig im Eingriff.



RADIAL IN-FEED

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

MODIFIZIERTE FLANKENZUSTELLUNG

Weniger Verschleiß der Schleppe und eine bessere Oberflächengüte der entsprechenden Gewideflanke.



MODIFIED FLANK IN-FEED

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

WECHSELNDE FLANKENZUSTELLUNG

Beide Schneidflanken werden gleichmäßig benutzt, ergibt höhere Standzeiten.



ALTERNATING FLANK IN-FEED

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

EINSEITIGE FLANKENZUSTELLUNG

Geringerer Schnittdruck und bessere Wärmeabfuhr.



FLANK IN-FEED

More easily formed chip and better heat dissipation.



Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden. Die passenden Drehmomentschlüssel finden Sie im Kapitel Zubehör.

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.

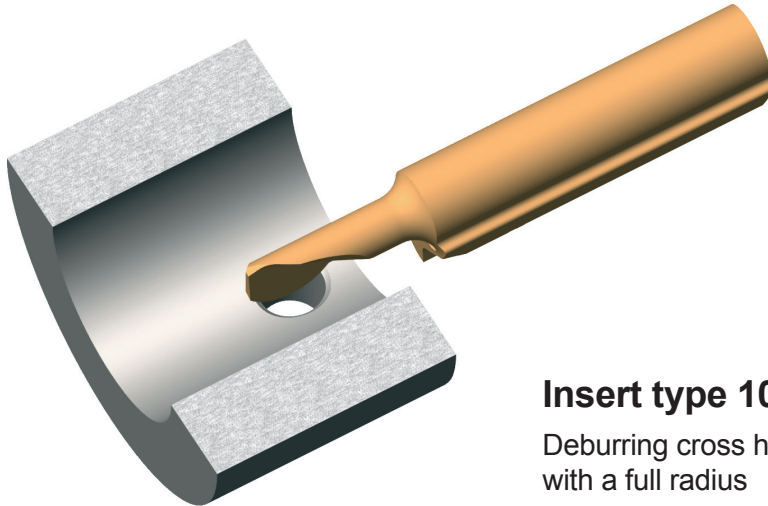
| Typ type | Schraube Screw | M _d Nm | Schlüssel Clamping wrench | Klinge Blade |
|------------------|-------------------|-------------------|------------------------------|-----------------|
| AIH | 030.3509.T15P | 2,5 | T10PL | DT10PK |
| | 6.075T15P | 5,0 | T15PQ | DT15PK |
| B105 | 6.075T15P | 5,0 | T15PQ | DT15PK |
| B106 | 1.8.4T6EP | 0,9 | T6PL | DT6PK |
| B107 | 2.2.5T7EP | 1,1 | T7PL | DT7PK |
| B108 | 2.6.5T8EP | 1,2 | T8PL | DT8PK |
| B109 | 6.075T15P | 5,0 | T15PQ | DT15PK |
| B10P | 2.6.5T8EP | 1,2 | T8PL | DT8PK |
| B110 | 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 | 2,0 | T10PL | DT10PK |
| KM16NC... | KM16-NSPKG | 10,0 | D515QL | DT27PQ |
| KM2016NC... | KM16-NAPKG | 10,0 | D515QL | DT27PK |
| N... | 6.075T15P | 5,0 | T15PQ | DT15PK |
| RBA114 | 4.12.T15P | 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 |

Anwendungsbeispiele
Examples for machining

N10-N16

Schneidplatte Typ 105

Rotierender Einsatz einer Vollradiusplatte
zum Entgraten von Querbohrungen

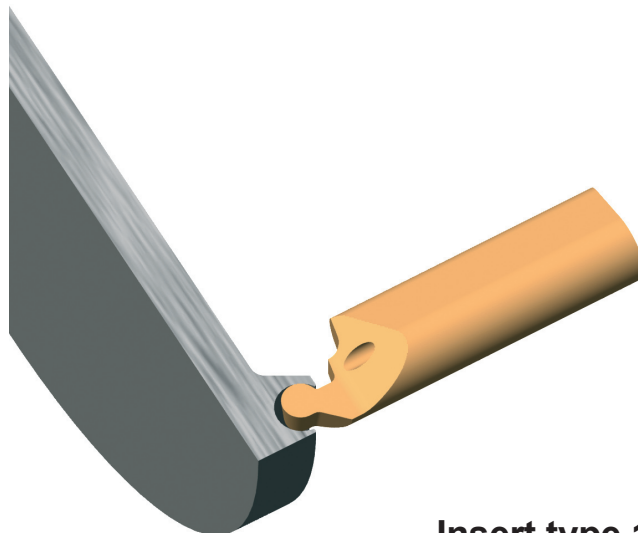


Insert type 105

Deburring cross holes using a rotating insert
with a full radius

Schneidplatte Typ 105

Einstecken einer axialen Formnut
(Vollradius)

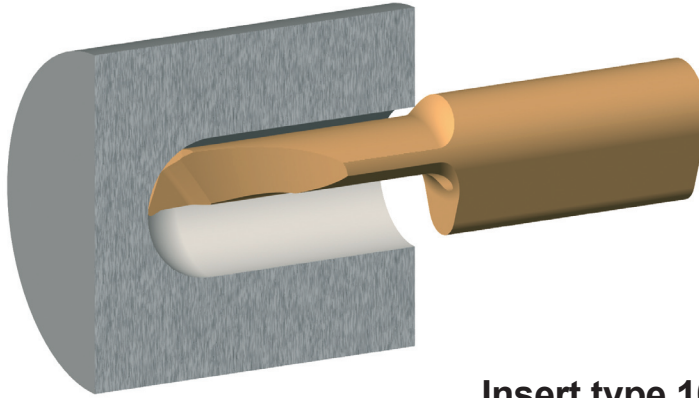


Insert type 105

Profiling a face groove
(full radius insert)

Schneidplatte Typ 105

Drehen des Bodens einer Sackbohrung
zur Halbkugel

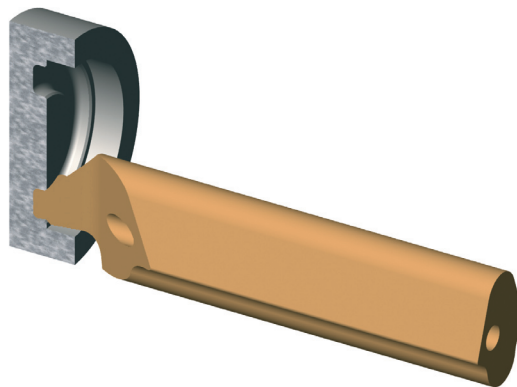


Insert type 105

Machining a hemisphere

Schneidplatte Typ 105

Planstechen einer Nut mit
Nutaußenkantenfasung

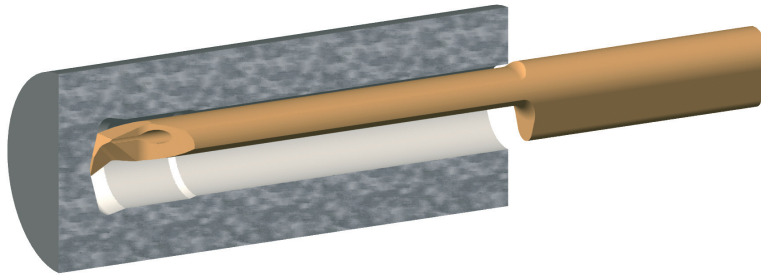


Insert type 105

Face grooving with chamfers

Schneidplatte Typ 105

Kopieren des Bohrungsbodens und
des Freistichs

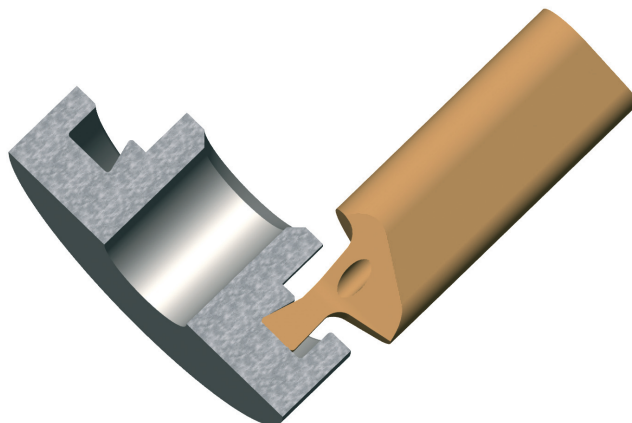


Insert type 105

Machining a flat bottom hole with
an undercut

Schneidplatte Typ 105

Fertigen einer axialen
Schwalbenschwanznut

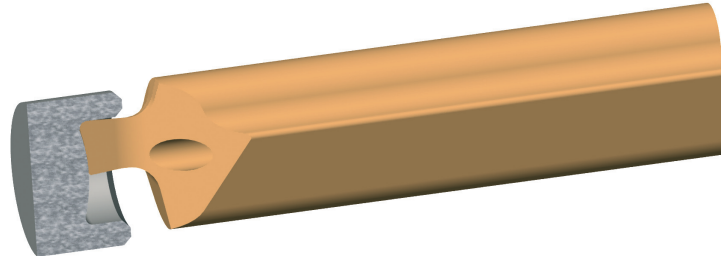


Insert type 105

Machining of a dovetail face groove

Schneidplatte Typ 105

Stechen eines konvexen
Bohrungsbodens

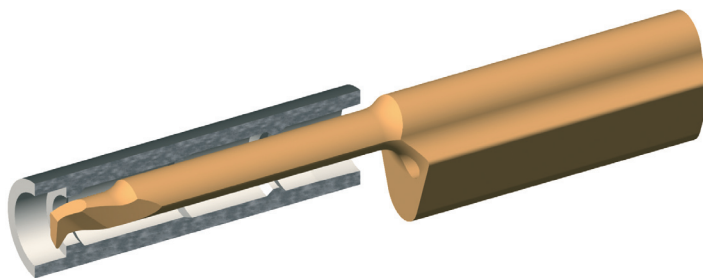


Insert type 105

Plunge machining of a convexed face
in a bore

Schneidplatte Typ 105

Kopieren einer langen Innenkontur

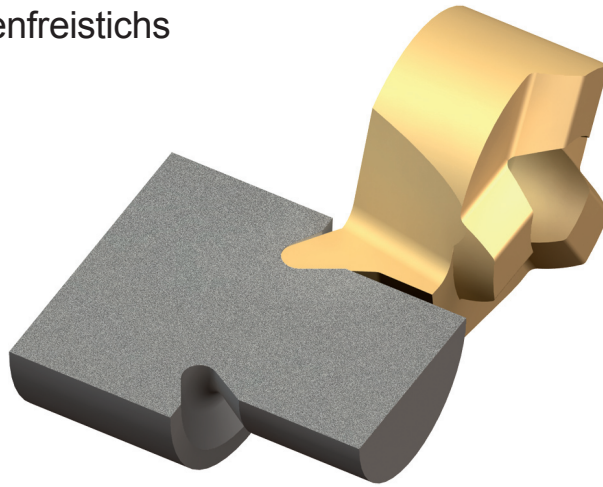


Insert type 105

Profiling of deep bores

Schneidplatte Typ 108

Sonderform eines Eckenfreistichs

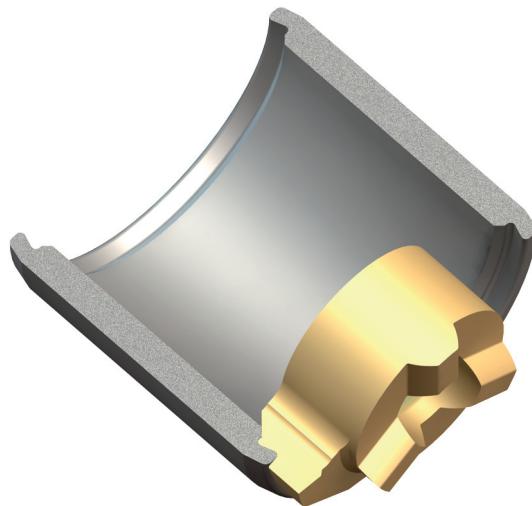


Insert type 108

Special angled under-cut relief

Schneidplatte Typ 111

Formstechen mit Endenbearbeitung
einer Hülse

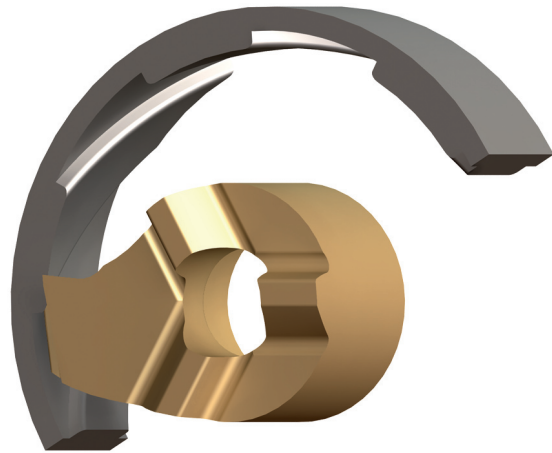


Insert type 111

Special ID form groove and facing

Schneidplatte Typ 11P

Drehen eines mehrgängigen
Flachgewindes

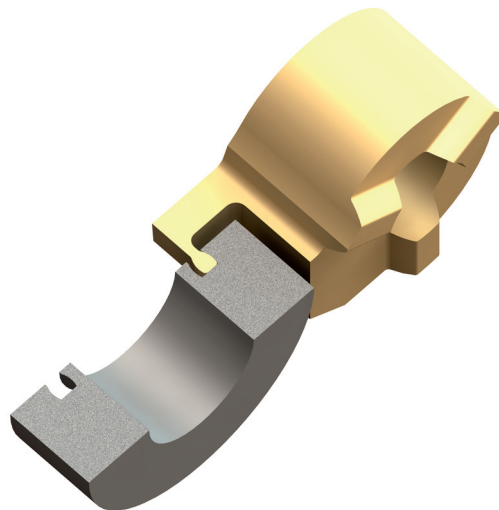


Insert type 11P

Special internal multi-start
high helix thread

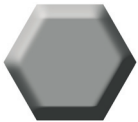
Schneidplatte Typ 114

Rückseitiges Stechen einer
Axialnut mit Unterschneidung

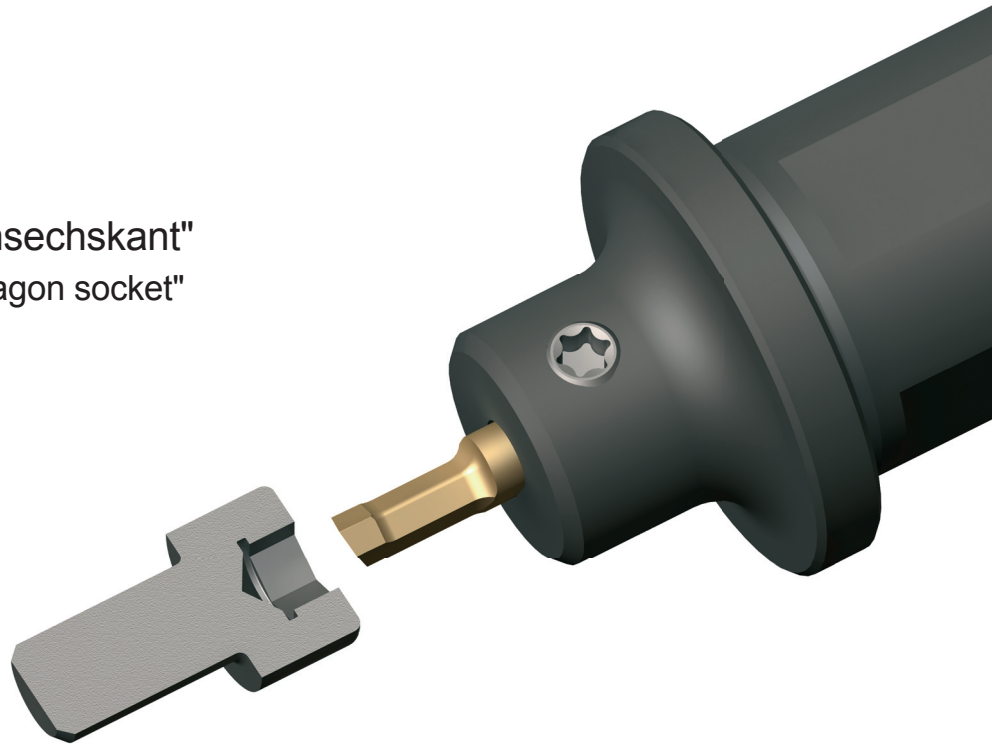


Insert type 114

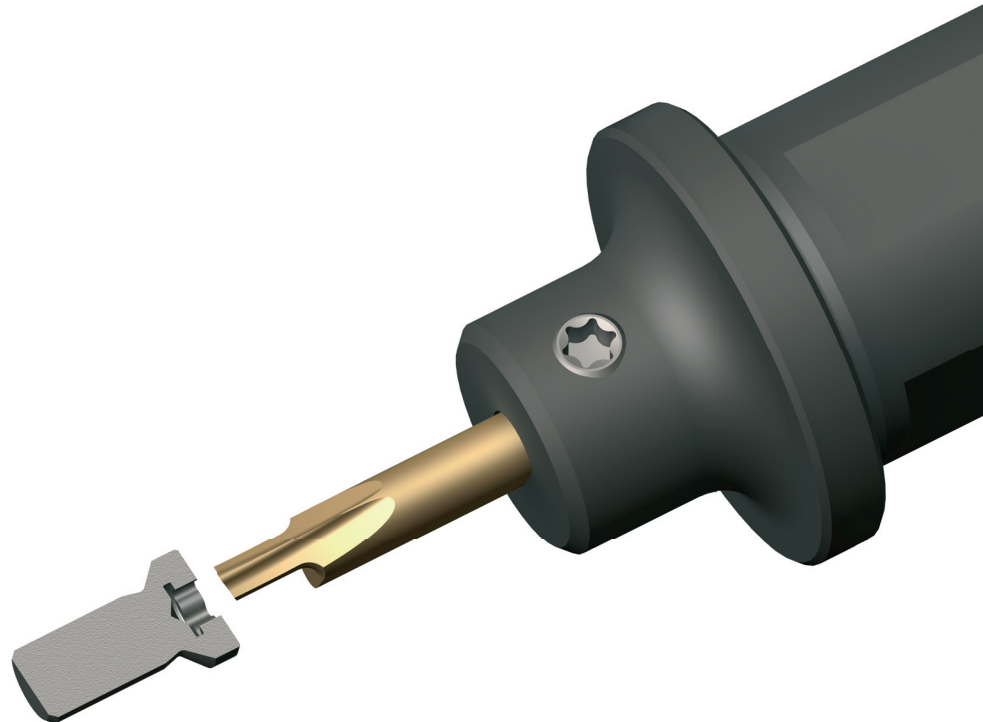
Special back face groove and
form of captive o-ring groove



Stoßen "Innensechskant"
Broaching "Hexagon socket"



Stoßen "Torx"
Broaching "Torx"



Weitere Informationen finden Sie in unserem HORN-Katalog
"HARTMETALL-EINSTECHWERKZEUGE"

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

Zubehör
Additional equipment

N18-N21



D 041 VL
0,4-1 Nm

Drehmoment-Schraubendreher mit Skala
- mit variabler Einstellmöglichkeit
- numerische Drehmoment-Anzeige in Fensterskala
Drehmoment stufenlos einstellbar mit Einstellwerkzeug
Torque-Setter (im Lieferumfang enthalten).
Ergonomischer Mehrkomponentengriff, extrem handlich
durch leichte und kompakte Bauweise. Klicksignal beim
Erreichen des eingestellten Drehmomentwertes.
(Normen: EN ISO 6798, BS EN 26789, ASME B107.14.M.)
(Genauigkeit: $\pm 6\%$, rückführbar auf nationale Normale)



D 15 VL
1-5 Nm

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
2-8 Nm



ED 28 VL
für / for
D041VL / D15VL / D28VL

Einstellwerkzeug für Drehmoment-Schraubendreher
Griff: Celluloseacetat mit microfeiner Oberflächenstruktur
Klinge: Achtkantklinge, durchgehend gehärtet, verzinkt
Device for setting the required torque.
Handle: Celluloseacetat with micro structured surface
Blade: Octogonal (8 flats) blade, hardened galvanized



DT6PK
DT7PK
DT8PK
DT9PK
DT10PK
DT15PK
DT20PK
DT25PK
DT27PK

für / for
D041VL / D15VL / D28VL



Plus

Wechselklinge für TORX PLUS® Schrauben

Klinge: Hochwertiger Chrom-Vanadium-Molybdän Stahl, durchgehend gehärtet, mattverchromt
Wiha Chrom Top-Klingenspitze garantiert höchste Maßhaltigkeit.

Farbcodierung dunkelgrün

Anwendung: Zum kontrollierten Verschrauben bei vorgegebenem Drehmoment, in Kombination mit einem Wiha Drehmomentgriff.

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.



T6PW
T7PW
T8PW
T9PW
T10PW
T15PW
T20PW

für / for
D041VL / D15VL / D28VL



Plus

Stiftschlüssel für TORX PLUS® Schrauben

Anwendung: Für alle TORX PLUS® Schraubaufgaben
Achtung: TORX PLUS®-Schlüssel passen NICHT in Torx-Schrauben

Wrench for TORX PLUS® Screws

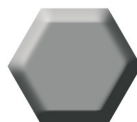
Utilization: For all kind of using TORX PLUS® Screws

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



DSW15K
DSW20K
DSW25K
DSW30K
DSW40K

für / for
D041VL / D15VL / D28VL



Wechselklinge für Innensechskant-Schrauben

Klinge: Hochwertiger Chrom-Vanadium-Molybdän-Stahl, durchgehend gehärtet, mattverchromt
Wiha Chrom Top-Klingenspitze garantiert höchste Maßhaltigkeit.

Farbcodierung rot

Anwendung: Kontrolliertes Verschrauben bei vorgegebenem Drehmoment, in Kombination mit einem Wiha Drehmomentgriff.

Blade for allen screws

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Wiha Chrome Blade guarantees maximum precision. Colored code red

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle





D14ZBK

für / for
D041VL / D15VL / D28VL

Universal-Bithalter für C6,3 und E6,3 (1/4") Bits

Klinge: Hochwertiger Chrom-Vanadium-Molybdän Stahl, durchgehend gehärtet, mattverchromt.

Hülse: Aus rostfreiem Stahl

Anwendung: Zum kontrollierten Verschrauben bei vorgegebenem Drehmoment, in Kombination mit einem Drehmomentgriff.

Universal Bitholder for 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

5-15 Nm

Drehmoment-Schraubendreher mit Skala

- mit variabler Einstellmöglichkeit

- numerische Drehmoment-Anzeige in Fensterskala

Drehmoment stufenlos einstellbar mit Einstellwerkzeug Torque-Setter (im Lieferumfang enthalten).

Ergonomischer Mehrkomponentengriff, extrem handlich durch leichte und kompakte Bauweise. Klicksignal beim Erreichen des eingestellten Drehmomentwertes.

(Normen: EN ISO 6798, BS EN 26789, ASME B107.14.M.)

(Genauigkeit: $\pm 6\%$, rückführbar auf nationale Normale)

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

für / for
D515QL

Einstellwerkzeug für Drehmoment-Schraubendreher

Griff: Celluloseacetat mit microfeiner Oberflächenstruktur

Klinge: Achteckklinge, durchgehend gehärtet, verzinkt

Device for setting the required torque.

Handle: Celluloseacetat with micro structured surface

Blade: Octagonal (8 flats) blade, hardened galvanized



DT15PQ
DT20PQ
DT25PQ
DT27PQ
DT30PQ

für / for
D515QL



Plus

Wechselklinge für TORX PLUS® Schrauben

Klinge: Hochwertiger Chrom-Vanadium-Molybdän Stahl, durchgehend gehärtet, mattverchromt
Wiha Chrom Top-Klingenspitze garantiert höchste Maßhaltigkeit.

Farbcodierung dunkelgrün

Anwendung: Zum kontrollierten Verschrauben bei vorgegebenem Drehmoment, in Kombination mit einem Wiha Drehmomentgriff.

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.



D14ZBQ

für / for
D515QL

Universal-Bithalter für C6,3 und E6,3 (1/4") Bits

Klinge: Hochwertiger Chrom-Vanadium-Molybdän Stahl, durchgehend gehärtet, mattverchromt.

Hülse: Aus rostfreiem Stahl

Anwendung: Zum kontrollierten Verschrauben bei vorgegebenem Drehmoment, in Kombination mit einem Drehmomentgriff.

Universal Bitholder for C6,3 and E6,3 (1/4") Bits

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Collar: Stainless steel

Utilization: For controlled screw setting with definite torque in combination with torque screw driver handle.



14ZQK

Bithalter mit Quergriff für C6,3 und E6,3(1/4") Bits

Klinge: Hochwertiger Chrom-Vanadium-Molybdän Stahl, durchgehend gehärtet, mattverchromt.

Hülse: Aus rostfreiem Stahl.

Anwendung: Zum kontrollierten Öffnen.

Universal Bitholder with T-handle for 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

| Typ Type | Seite Page |
|-------------|--------------------------------|
| 001 | A50 |
| 105 | A59-A77,A79-A103,A106-A107 |
| 106 | D3-D5 |
| 107 | E3-E8 |
| 108 | F6-F9,F11-F12,F15-F23 |
| 109 | B5-B15 |
| 10P | G5,G7 |
| 110 | C11-C15 |
| 111 | H6-H9,H11-H12,H14-H24 |
| 114 | K8-K11,K13,K15-K16,K18-K30 |
| 116 | L5-L8,L11-L12,L14-L22 |
| 11P | J5,J7,J9 |
| 125 | H5 |
| 145 | L4 |
| 18P | M4 |
| 962 | A18-A19 |
| 963 | A20 |
| A105 | A109-A110 |
| A110 | C17-C18 |
| AIH | A21 |
| B105 | A2-A9,A13-A14,A46,A104,A108,B4 |
| B105.WF | A58 |
| B105C | A48-A49,A105 |
| B105KM | A54-A55 |
| B105TS | A56-A57 |
| B106 | D2 |
| B107 | E2 |
| B108 | F2-F3 |
| B108KM | F4-F5 |
| B109 | B2-B3,B16 |
| B10P | G2-G4 |
| B110 | C2-C3,C16 |

| Typ Type | Seite Page |
|-------------|-----------------|
| B110.WF | C9 |
| B110C | C5-C6 |
| B110TS | C4 |
| B111 | H2-H4 |
| B114 | K2-K4 |
| B116 | L2-L3 |
| B11P | J2-J4 |
| B18P | M2 |
| BGT | A24-A25,A27-A28 |
| BKT | A26,A29 |
| BU105 | A4 |
| G | A30-A31 |
| GZ79 | A12 |
| H105 | A15 |
| H114.WF | K5 |
| HC105 | A16-A17,A22 |
| HC114 | K7 |
| HVR40 | A45 |
| IR105 | A10-A11 |
| KM16 | A52-A53 |
| L760 | A23 |
| N | A34,A36-A42,C8 |
| RBA114 | K6 |
| S108 | F10,F13 |
| S10P | G6,G8-G9 |
| S111 | H10,H13 |
| S114 | K12,K14,K17 |
| S116 | L9,L13 |
| S11P | J6,J8,J10 |
| S18P | M3,M5-M6 |
| VDI | A47,C7 |
| Z | A32-A33 |

Schneidstoffgruppen nach DIN ISO 513

Cutting Material Groups per DIN ISO 513

| Gruppen Main group | Symbol | Untergruppen Subgroups |
|--|--------|--|
| Hartmetall Carbide | HW | unbeschichtetes Hartmetall auf WC-Basis uncoated carbides based upon WC |
| | HT | unbeschichtetes Hartmetall auf TiC/TiN-Basis (Cermets) uncoated carbides based upon TiC/TiN (Cermets) |
| | HF | Feinkornhartmetall micro grane carbides |
| | HC | beschichtetes Hartmetall / Cermets coated carbides / cermets |
| Schneidkeramik Ceramic cutting material | CA | Oxidkeramik auf Al_2O_3 -Basis Oxide ceramics based upon Al_2O_3 |
| | CM | Mischkeramik auf Al_2O_3 + Metallcarbid Mixed ceramics based upon Al_2O_3 + metal carbide |
| | CN | Nitridkeramik auf Si_3N_4 -Basis Nitride ceramics based upon Si_3N_4 |
| | CC | beschichtete Schneidkeramik Coated ceramics |
| Diamant Diamond | DM | Monokristalliner Diamant (MKD) Monocrystalline diamond (MCD) |
| | DP | Polykristalliner Diamant (PKD) Polycrystalline diamond (PCD) |
| Bornitrid Boron nitride | BN | Polykristallines, kubisches Bornitrid (CBN) Polycrystalline, cubic boron nitride (PCBN) |

Technische Änderungen aufgrund von Weiterentwicklungen
behalten wir uns vor.

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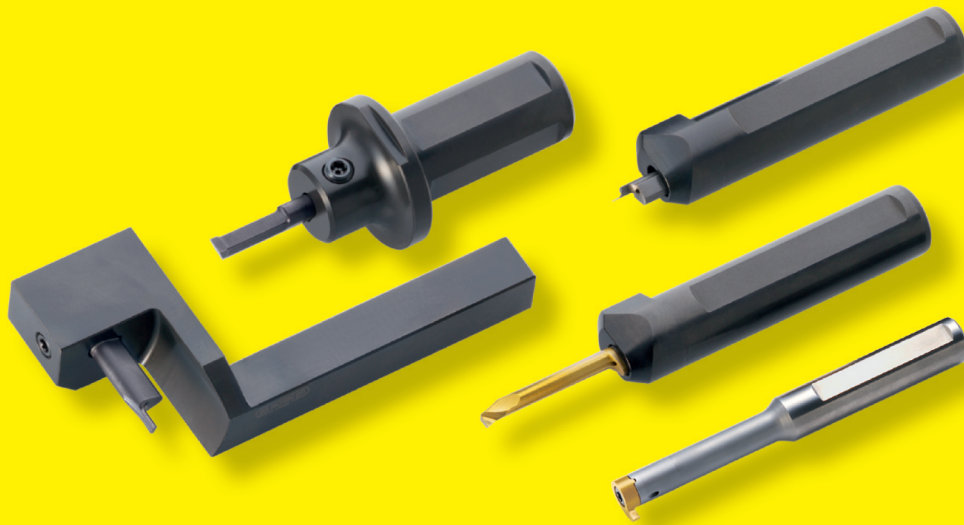
Stand: September 2014

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