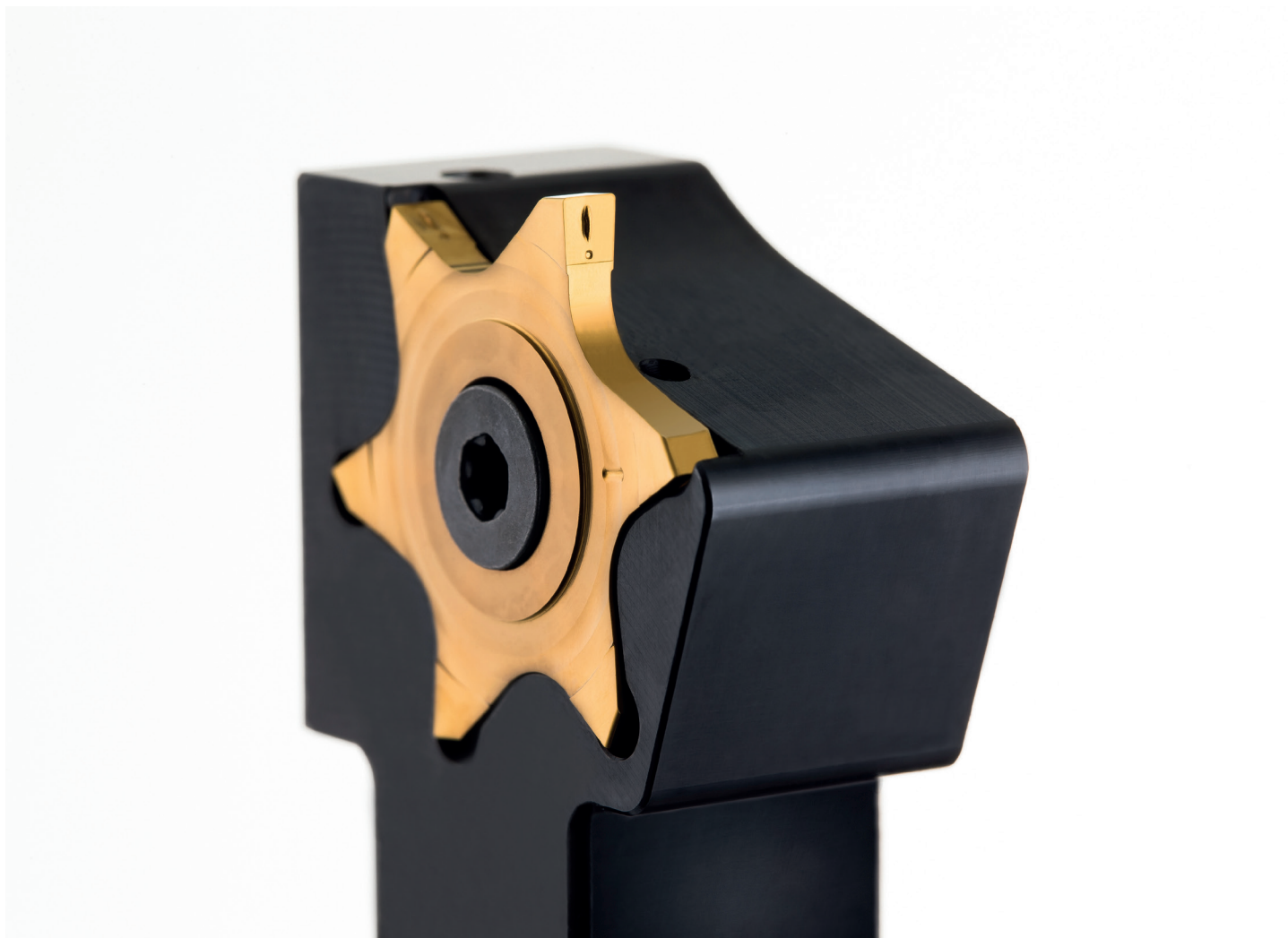


车槽 • 切断 • 铣槽 • 插削 • 仿形铣削 • 钻孔 • 铰削



槽加工 Grooving

2020



GROOVING • PARTING OFF • GROOVE MILLING • BROACHING • PROFILE MILLING • DRILLING • REAMING



HORN 全新样本 – 以高效作为标杆

我们的刀具为您提供,快速,经济高质量的解决方案. 从系列产品到单个零件,从标准到非标的应用.

- 槽加工
- Supermini 和 Mini 内孔加工
- 模块化系统
- 硬材料加工
- 铣削系统
- 钻孔/铰削
- 整体硬质合金立铣刀
- Boehlerit 铣削
- Boehlerit 车削

在每一个目录里,根据不同切削工艺区分,让您能快速的找到产品描述.
当您选定了特定的切削参数时,您会发现许多经验的数值表格.

Lothar Horn
首席执行官
Paul Horn GmbH

Markus Horn
首席执行官
Paul Horn GmbH

New catalogues from HORN - benchmarks for productivity

Our tools provide you with fast, economical, high quality solutions, from single part to series production, for standard or special applications.

Our complete range of standard tools is summarised in the new catalogues

- Grooving
- Supermini & Mini Internal Machining
- Modular Holder Systems
- Ultra Hard Cutting Materials
- Milling Systems
- Drilling / Reaming
- Solid Carbide Mills
- Milling Catalogue Boehlerit
- Turning Catalogue Boehlerit

In each catalogue, the breakdown into the type of cutting process makes it easier for you to quickly find the products described. When choosing the individual cutting parameters, you will find numerous tables with proven empirical values.

Lothar Horn, CEO
Paul Horn GmbH

Markus Horn, GmbH
Paul Horn GmbH

A	刀具系列 100 / 101
B	刀具系列 117
C	刀具系列 119 / 123 / 223
D	刀具系列 209
E	刀具系列 216
F	刀具系列 217
G	刀具系列 224
H	刀具系列 229 / 259
I	刀具系列 231
J	刀具系列 262
K	刀具系列 264
L	刀具系列 274
M	刀具系列 34T

A

B

C

D

E

F

G

H

I

J

K

L

M



N	刀具系列 312
O	刀具系列 315
P	刀具系列 316
Q	刀具系列 64T
R	适用于 SWISS 机床的刀具 Tools for Swiss Type Machines
S	端面切槽 Face Grooving
T	切断 Parting Off
U	技术说明 Technical Instructions
V	插削 Broaching
W	附加设备 Additional Equipment

N

O

P

Q

R

S

T

U

V

W

系统 System	15 25A	100	101	117	119	123	209	216	217	223	224
内孔槽 / Internal Grooving											
过孔-Ø Bore Ø	15 - 50				≥ 16	≥ 16	≥ 16	≥ 20	≥ 20	≥ 18	≥ 28
槽宽 Width of groove	2 - 4				2 - 3	2 - 3	2 - 3	2 - 6	0,5 - 5,3	1,2 - 3	2 - 6
切槽 Grooving					•	•	•	•	•	•	•
车削 Turning					•		•	•		•	•
螺纹 Thread											•
仿形加工 Profiling							•	•		•	•
端面槽 Facegrooving	•										
外圆槽 / External Grooving											
槽深 Depth of groove	≤ 25	≤ 55	≤ 13	≤ 10		≤ 25			≤ 4,7	≤ 11	≤ 32,5
槽宽 Width of groove	2 - 4	2 - 16	1,2-1,6	10 - 45		2 - 3			0,5 - 5,3	1,2 - 3	2 - 6
切槽 Grooving		•	•			•			•	•	•
车削 Turning		•								•	•
切断 Parting off		•	•							•	•
螺纹 Thread											•
仿形加工 Profiling				•					•		•
端面槽 Facegrooving	•										•
章节 Chapter	S	A	A	B	C	C	D	E	F	C	G

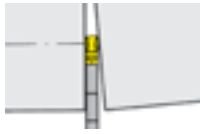
可应要求提供非标刀具
Special tools upon request

单位尺寸 mm
Dimensions in mm

系统 System	229 259	231	262	264	274	34T	312	315	316	64T
内孔槽 / Internal Grooving										
孔径-Ø Bore Ø	≥ 38	≥ 75					≥ 46	≥ 43		
槽宽 Width of groove	2,5 - 10	2,5 - 10					0,5 - 6,3	0,5 - 8		
切槽 Grooving	•	•					•	•		
车削 Turning	•							•		
螺纹 Thread	•	•						•		
仿形加工 Profiling	•							•		
断面槽 Facegrooving										
外圆槽 / External Grooving										
槽深 Depth of groove	≤ 25	≤ 11	≤ 7,5	≤ 16	≤ 6	≤ 6,5	≤ 8	≤ 6	≤ 8	≤ 5,5
槽宽 Width of groove	2,5 - 10	2,5 - 10	0,025 - 6	1,5 - 3	0,5 - 7	2 - 5	0,5 - 6,3	0,5 - 8	1,5 - 3	0,5 - 3,15
切槽 Grooving	•	•	•	•	•	•	•	•	•	•
车削 Turning	•		•	•	•	•	•	•	•	•
切断 Parting off	•		•	•	•	•	•	•	•	•
螺纹 Thread	•	•		•	•			•		
仿形加工 Profiling	•							•		
断面槽 Facegrooving	•	•					•	•		
章节 Chapter	H	I	J	K	L	M	N	O	P	Q

可应要求提供非标刀具
Special tools upon request

尺寸单位: mm
Dimensions in mm



刀具系统 100
 $t_{\max} = \leq 55 \text{ mm}$



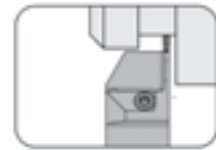
刀具系统 101
 $t_{\max} = \leq 13 \text{ mm}$

刀杆
 Toolholder
 H100

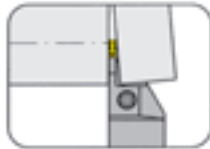


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 A3-A5

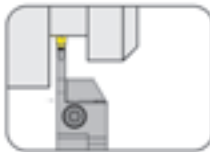
刀杆
 Toolholder
 H101



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 A28



页/Page
 A6-A12, A14, A24-A25



页/Page
 A13, A15-A16

刀夹
 Cassette
 NK100



页/Page
 A17

刀片
 Insert
 S100/S101



页/Page
 A18



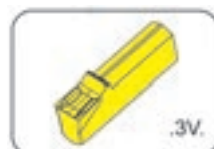
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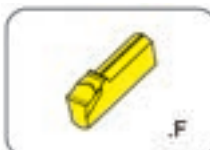
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页/Page
 A19, A26



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 A22, A27



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 A20

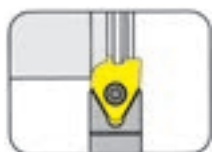


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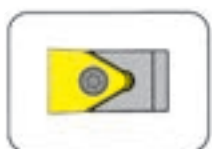


$t_{\max} = \leq 10 \text{ mm}$
 $w = 10 - 45 \text{ mm}$

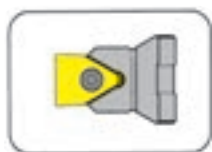
刀杆
 Toolholder
 H117



页/Page
 B3-B4, B6, B8

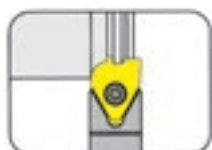


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 B10

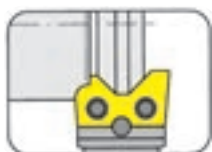


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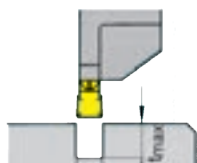
刀片
 Insert
 S117



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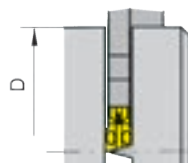
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 B9



$w = 1,1 - 3 \text{ mm}$
 $t_{\max} = 10 \text{ mm}$

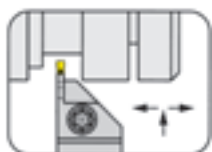


$w = 1,1 - 3 \text{ mm}$
 $t_{\max} = 6,3 \text{ mm}$
 $D \geq 16 \text{ mm}$



$w = 2 - 3 \text{ mm}$
 $D_{\max} \leq 50 \text{ mm}$

刀杆
Toolholder
H223/B119/B223



页/Page
C3

刀夹
Cassette
BK223

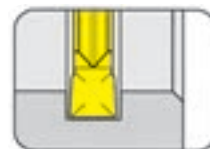


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C12

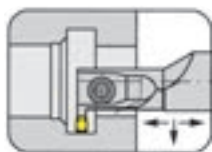


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C4

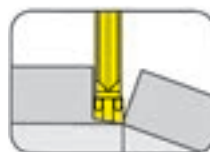
刀片
Insert
S119/S223/S123



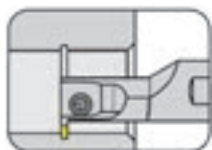
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C13, C16



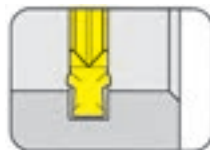
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C6-C8



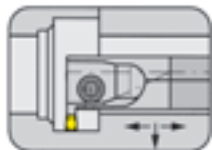
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C14-C15, C20-C21



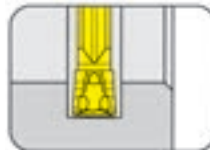
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C9



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C17

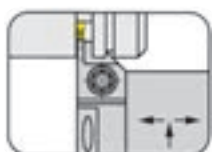


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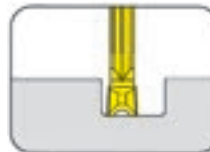


页/Page
C18

刀夹
Cartridge
E223

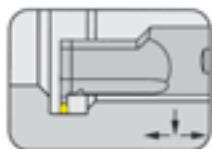


页/Page
C5



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C19

基础刀柄
Basic toolholder
B223



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C11

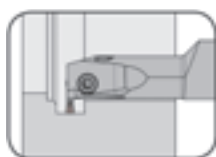


$w = 2 - 3 \text{ mm}$
 $a_{p \text{ max}} = 1 \text{ mm}$



$w = 2 - 3 \text{ mm}$
 $t_{\text{max}} = 5 \text{ mm}$
 $D \geq 16 \text{ mm}$

刀杆
 Toolholder
 B209

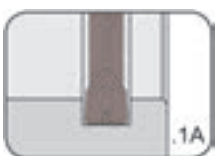


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 D3

可转位刀片
 Indexable insert
 S209



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 D4

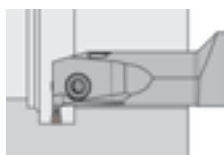


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 D5



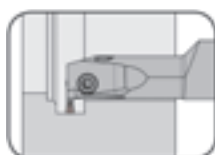
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 D6

D



$D_{\min} = 20 \text{ mm}$
 $t_{\max} = 7,5 \text{ mm}$

刀杆
 Toolholder
 B216



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 E3

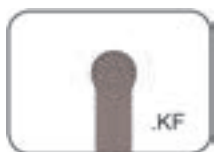
可转位刀片
 Indexable insert
 S216



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 E4

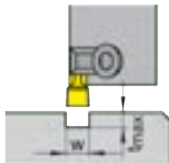


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 E5

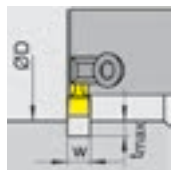


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 E6

E

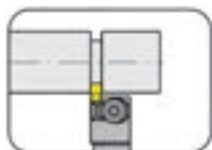


w = 0,5 - 5,3 mm
t_{max} = 4 mm

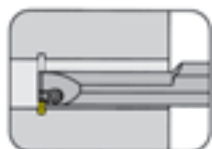


w = 0,5 - 5,3 mm
t_{max} = 4,7 mm
D ≥ 20 mm

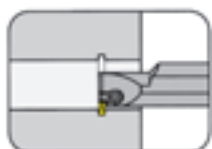
刀杆
Toolholder
240/248/230/233/
234/235/245



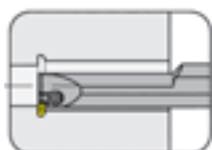
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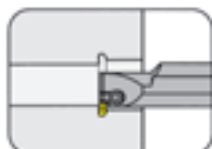
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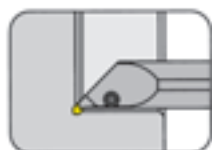
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F8

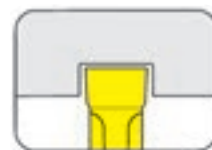


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F10

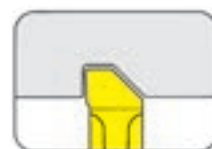
可转位刀片
Indexable insert
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F11



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F12



页/Page
F13

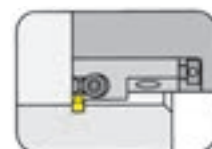


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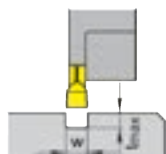
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F14

刀夹
Cartridge
232

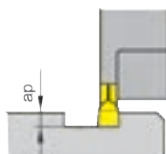


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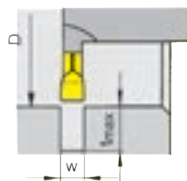
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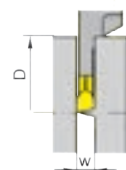
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 $t_{\text{max}} = 18 \text{ mm}$



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

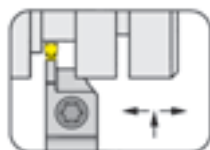


$w = 2 - 6 \text{ mm}$
 $t_{\text{max}} = 13 \text{ mm}$
 $D \geq 28 \text{ mm}$



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

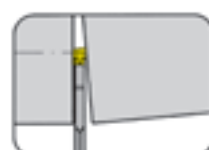
刀杆
Toolholder
H224/B224/224



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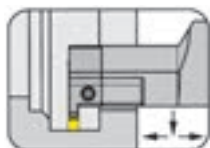
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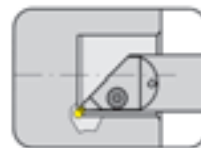
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G24-G28



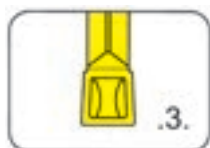
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G30-G31

刀夹
Cassette
BK224

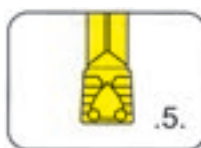


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G27

刀片
Inserts
S224/S124/224/NS224



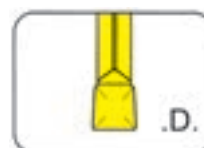
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G32-G33



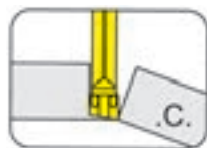
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G36-G37



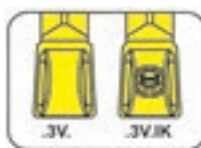
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G38-G39



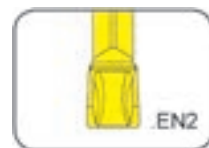
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G40-G41



页 / Page
G42



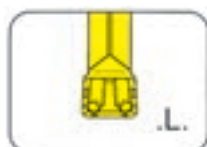
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G43, G55



页 / Page
G44



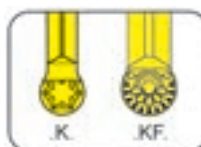
页 / Page
G45



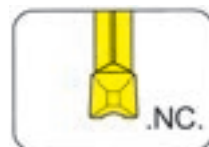
页 / Page
G46-G47



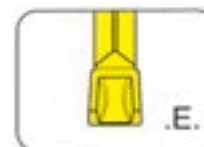
页 / Page
G48



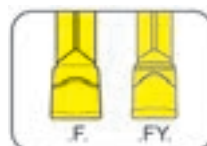
页 / Page
G49-G50



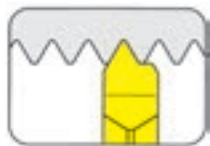
页 / Page
G51



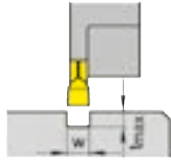
页 / Page
G52



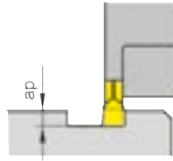
页 / Page
G53-G54



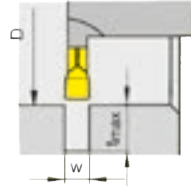
页 / Page
G56-G57



$w = 2,5 - 10 \text{ mm}$
 $t_{\max} = 25 \text{ mm}$



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

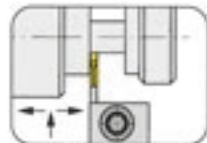


$w = 3 - 10 \text{ mm}$
 $t_{\max} = 15 \text{ mm}$
 $D \geq 38 \text{ mm}$



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

切槽(外圆) Grooving (external)



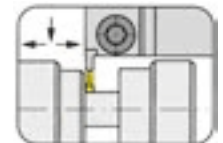
页 / Page H2-H14,H16



页 / Page H15,H17



页 / Page H18

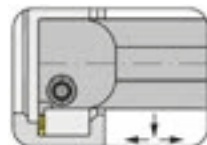


页 / Page H19-H20



页 / Page H21

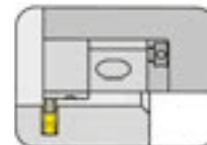
切槽(内孔) Grooving (internal)



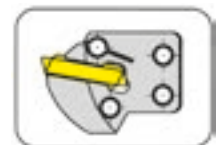
页 / Page H22-H29



页 / Page H30

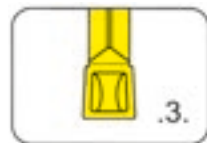


页 / Page H31

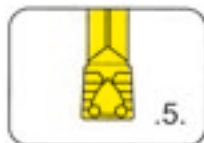


页 / Page H32

可转位刀片 Indexable inserts S229



页 / Page H34-H35



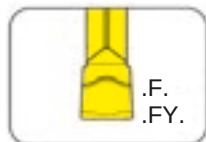
页 / Page H36-H37



页 / Page H38-H39



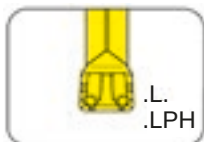
页 / Page H40



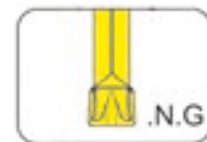
页 / Page H41-H42



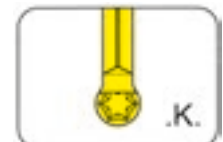
页 / Page H43-H44



页 / Page H45-H46

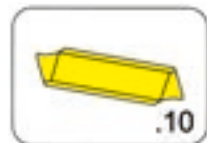


页 / Page H47

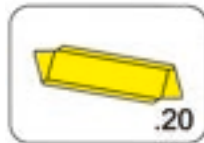


页 / Page H48-H49

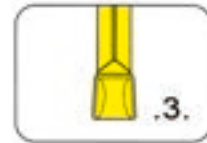
可转位刀片 Indexable inserts 229



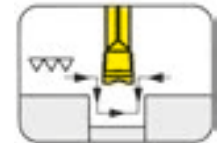
页 / Page H50-H51



页 / Page H52-H53



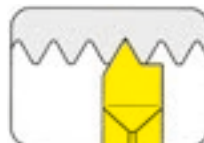
页 / Page H54-H55



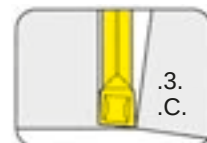
页 / Page H56-H57



页 / Page H58

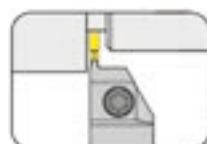


页 / Page H59-H61



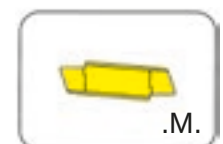
页 / Page H62-H64

刀杆 Toolholder H259

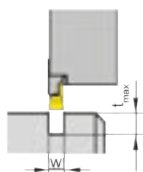


页 / Page H65

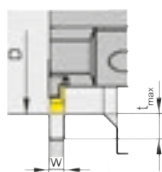
可转位刀片 Indexable inserts 259



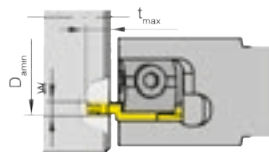
页 / Page H66



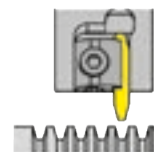
$w = 2,5 - 10 \text{ mm}$
 $t_{\max} = 11 \text{ mm}$



$w = 4 - 10 \text{ mm}$
 $t_{\max} = 5 - 9 \text{ mm}$
 $D = 75 - 200 \text{ mm}$



$w = 3 - 10 \text{ mm}$
 $t_{\max} = 8 \text{ mm}$
 $D_{\min} \geq 30 \text{ mm}$

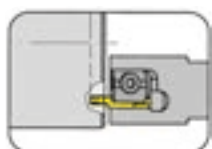


米制梯形螺纹
metric trapezoidal thread

刀杆
Toolholder
211/221/228

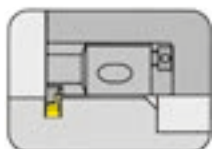


页/Page
I3-I4



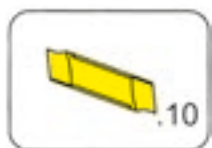
页/Page
I11-I12

刀夹
Cartridge
208

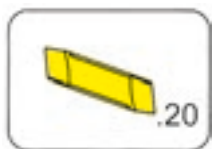


页/Page
I5

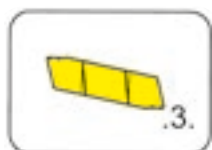
可转位刀片
Indexable insert
231



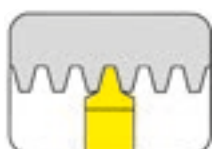
页/Page
I7-I8



页/Page
I9-I10



页/Page
I13



页/Page
I14



切槽/车削
Grooving and Side Turning



仿形车削(精加工)
Copy Turning (Finishing)



切断
Parting off

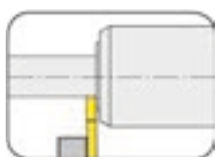


切槽/背车
Grooving and Back Turning



半精加工刀片
Semi-finished Insert

刀杆
Toolholder
262



页/Page
J3

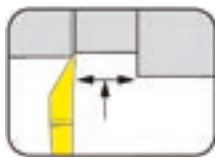
可转位刀片
Indexable insert
S262



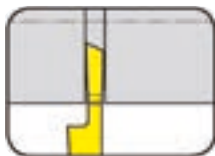
页/Page
J4



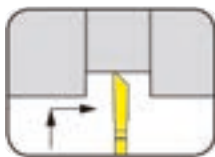
页/Page
J5



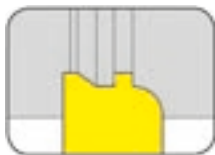
页/Page
J6



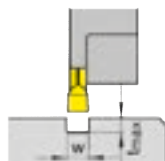
页/Page
J7



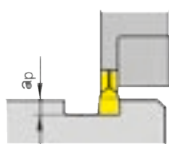
页/Page
J8-J9



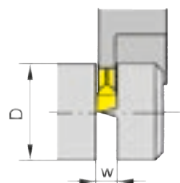
页/Page
J10



$w = 1,5 - 3 \text{ mm}$
 $t_{\text{max}} = 16 \text{ mm}$

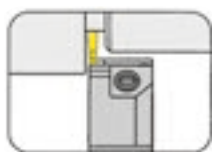


$w = 1,5 \text{ mm}$
 $a_p = 2,25 \text{ mm}$



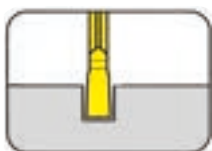
$w = 1,5 - 3 \text{ mm}$
 $D = 20 - 32 \text{ mm}$

刀杆
Toolholder
H264



页/Page
K3-K6

可转位刀片
Indexable insert
264



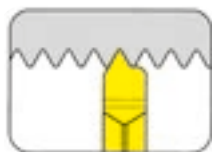
页/Page
K7, K9, K11



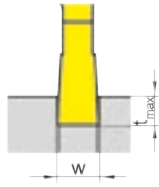
页/Page
K8, K10



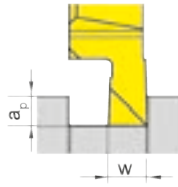
页/Page
K12-K13



页/Page
K14



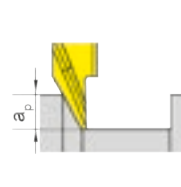
$w = 0,5 - 7,0 \text{ mm}$
 $t_{\max} = 6,0 \text{ mm}$



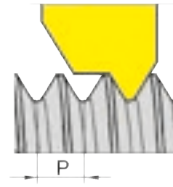
$w = 0,5 - 2,0 \text{ mm}$
 $a_p = 6,0 \text{ mm}$



$w = 0,8 - 2,0 \text{ mm}$



$a_p = 6,0 \text{ mm}$

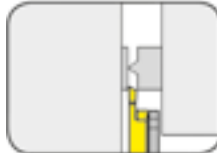


半牙型/Partial profile
 $P = 0,24 - 0,4 \text{ mm}$
全牙型/Full profile
 $P = 0,5 - 1,5 \text{ mm}$

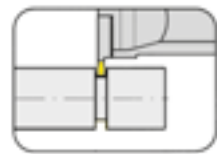
刀杆
Toolholder
H274/H274...E/
H274...SF/HC274



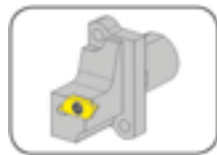
页/Page
L3, L6, L29, L46-L47



页/Page
L4-L5



页/Page
L8



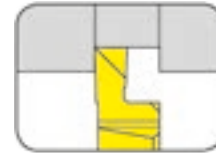
页/Page
L9

刀杆 Graf
Toolholder Graf
974

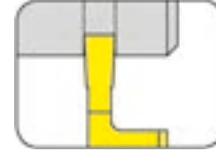


页/Page
L7

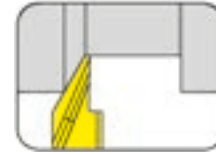
可转位刀片
Indexable insert
S274/S274...E/
S274...SF



页/Page
L13-L14, L30-L31



页/Page
L15-L17, L32-L34



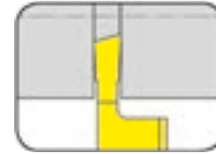
页/Page
L18, L35



页/Page
L19, L36



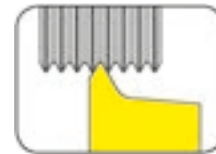
页/Page
L48



页/Page
L20-L25, L37-L42, L51-L52



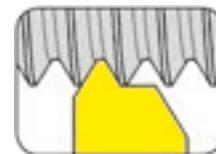
页/Page
L49-L50



页/Page
L26, L43



页/Page
L53-L54



页/Page
L27-L28, L44-L45

刀夹
Cartridge
KT274/KTC274



页/Page
L10-L11

刀夹 Graf
Cartridge Graf
64

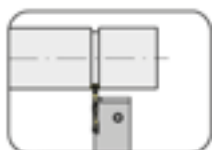


页/Page
L12



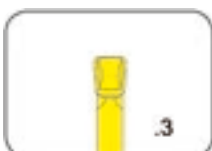
w = 2,0 - 5,0 mm
t_{max} = 6,50 mm

刀杆
Toolholder
H34T

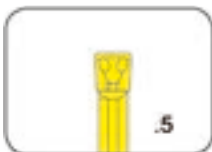


页/Page
M3

可转位刀片
Indexable insert
S34T



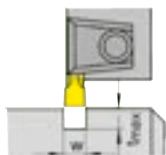
页/Page
M4



页/Page
M5



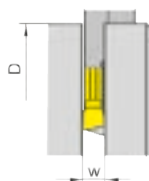
页/Page
M6



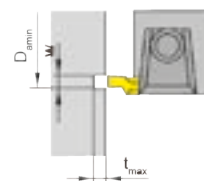
$w = 0,5 - 6,3 \text{ mm}$
 $t_{\max} = 8,0 \text{ mm}$



$w = 0,5 - 6,3 \text{ mm}$
 $t_{\max} = 5,5 \text{ mm}$
 $D \geq 46 \text{ mm}$



$w = 0,5 - 6,3 \text{ mm}$
 $D = 12 \text{ mm}$
 $t_{\max} = 8 \text{ mm}$

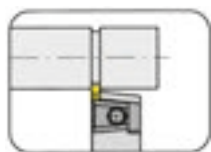


$w = 1,5 - 3 \text{ mm}$
 $t_{\max} = 3 \text{ mm}$
 $D_{\min} = 20 \text{ mm}$

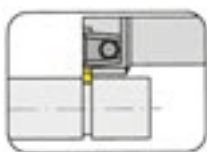
刀杆

Toolholder

360/361/369/390/391/
368/309/340



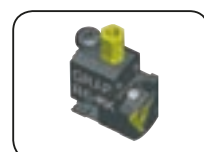
页 / Page
N4-N8, N18-N19



页 / Page
N13



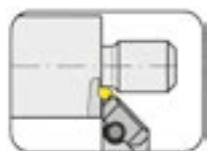
页 / Page
N14



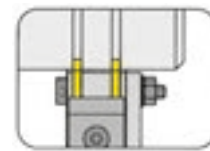
页 / Page
N15-N16



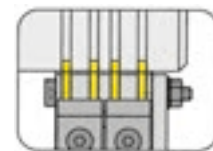
页 / Page
N17



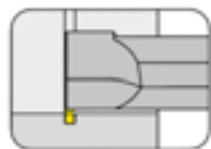
页 / Page
N20



页 / Page
N21



页 / Page
N22



页 / Page
N23



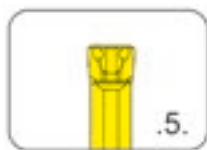
页 / Page
N9-N12

可转位刀片

Indexable insert
S312



页 / Page
N24



页 / Page
N25



页 / Page
N26



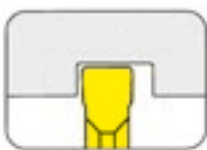
页 / Page
N27

可转位刀片

Indexable insert
312



页 / Page
N28-N32



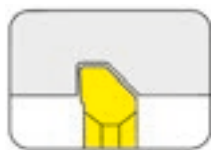
页 / Page
N33-N34



页 / Page
N35-N36



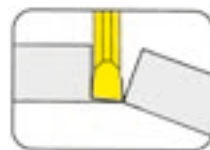
页 / Page
N37



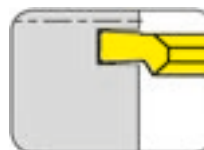
页 / Page
N38-N39



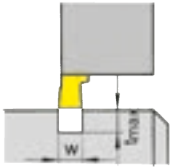
页 / Page
N40



页 / Page
N41-N44



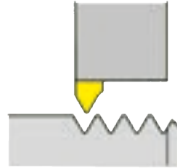
页 / Page
N45



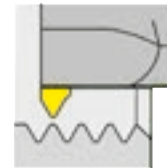
w = 0,5 - 7,5 mm
t_{max} = 5 mm



w = 0,5 - 3,5 mm
t_{max} = 5 mm
D ≥ 43 mm



米制梯形螺纹
metric trapezoidal thread



米制梯形螺纹
metric trapezoidal thread

刀杆
Toolholder
356/357/333



页/Page
O3-O6, O9



页/Page
O18



页/Page
O28



页/Page
O7-O8



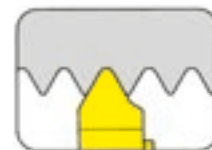
页/Page
O19-O20



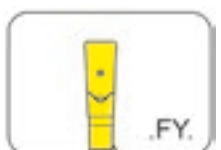
页/Page
O29



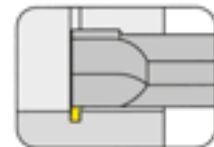
页/Page
O10



页/Page
O21



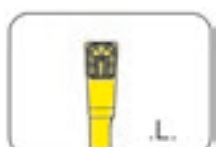
页/Page
O30



页/Page
O11

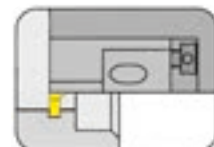


页/Page
O22, O25

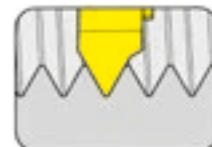


页/Page
O31

刀夹
Cartridge
357



页/Page
O12

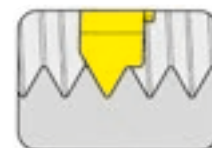


页/Page
O23

可转位刀片
Indexable insert
315/A315/S315



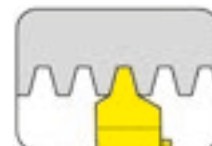
页/Page
O14-O16



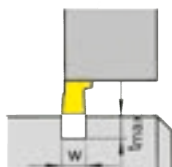
页/Page
O24



页/Page
O17



页/Page
O26

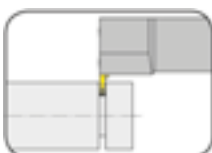


w = 1,5 - 3,0 mm
t_{max} = 8,0 mm

刀杆
Toolholder
H316/HC316



页/Page
P3-P4, P10



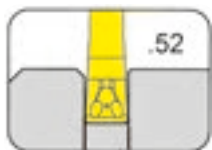
页/Page
P5, P11

刀夹
Cassette
NK316

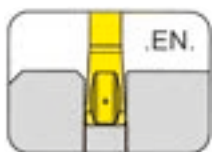


页/Page
P6, P12

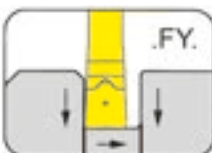
可转位刀片
Indexable insert
S316



页/Page
P7



页/Page
P8



页/Page
P9



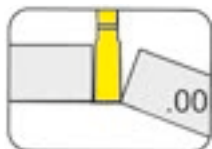
w = 0,5 - 3,0 mm
t_{max} = 5,5 mm

刀杆
Toolholder
H64T

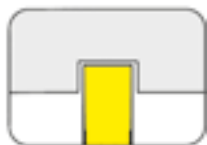


页/Page
Q3-Q4

可转位刀片
Indexable insert
S64T



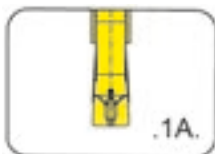
页/Page
Q5



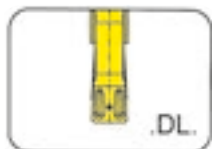
页/Page
Q6



页/Page
Q7



页/Page
Q8



页/Page
Q9

100/101



机夹式刀杆

槽宽 1.2 - 16 mm

槽深可达 55 mm

Cutter body with Inserts

Width of groove 1.2 - 16 mm

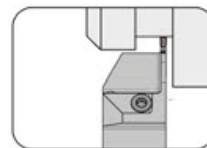
Depth of groove up to 55 mm

刀杆
Toolholder
H100

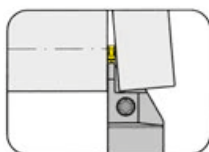


页/Page
A3-A5

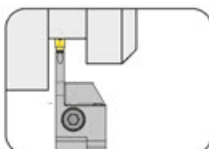
刀杆
Toolholder
H101



页/Page
A28



页/Page
A6-A12, A14, A24-A25



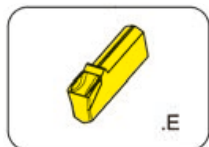
页/Page
A13, A15-A16

刀夹
Cassette
NK100

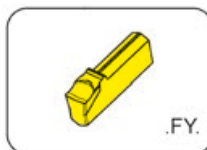


页/Page
A17

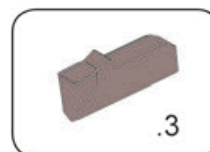
刀片
Insert
S100/S101



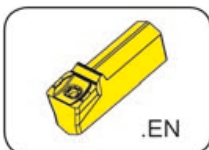
页/Page
A18



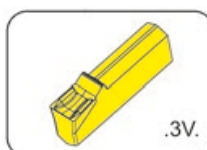
页/Page
A21



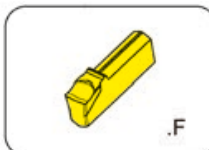
页/Page
A29



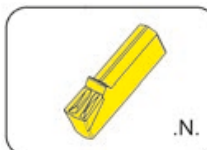
页/Page
A19, A26



页/Page
A22, A27



页/Page
A20



页/Page
A23

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

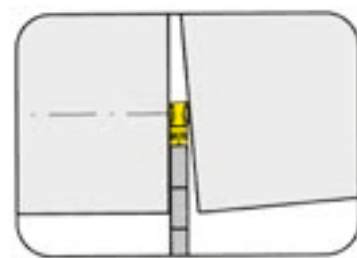
H100

自夹紧
with self clamping

槽深可达
槽宽

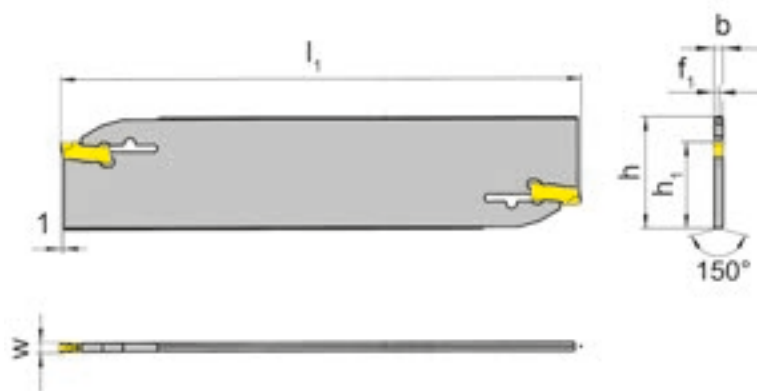
Depth of groove up to
Width of groove

55 mm
2-5 mm



配合刀片
for Insert

型号 S100
Type



产品型号 Part number	h	b	l_1	h_1	f_1	t_{max}	尺寸规格 Size
H100.2601.01	26	1.5	110	21.4	0.75	25.0	01
H100.3201.01	32	1.5	150	24.8	0.75	25.0	01
H100.2602.02	26	1.9	110	21.4	0.95	37.5	02
H100.3202.02	32	1.9	150	24.8	0.95	50.0	02
H100.2603.03	26	2.3	110	21.4	1.15	37.5	03
H100.3203.03	32	2.3	150	24.8	1.15	50.0	03
H100.2604.04	26	3.1	110	21.8	1.65	40.0	04
H100.3204.04	32	3.1	160	24.8	1.65	55.0	04
H100.3205.05	32	3.9	160	24.8	2.00	55.0	05

按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

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

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

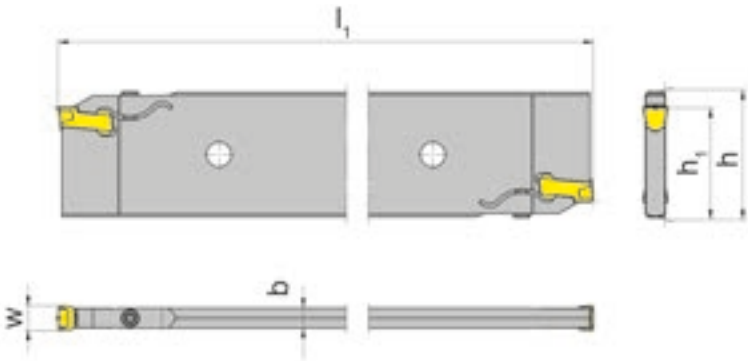
H100



槽宽	Width of groove	8-12 mm

配合刀片
for Insert

型号 S100
Type



产品型号 Part number	h	b	l ₁	h ₁	槽宽 Width of groove
H100.5208.26.08	52.6	7.4	260	45	8
H100.5210.26.10	52.6	8.2	260	45	10
H100.5212.26.12	52.6	10.4	260	45	12

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H100...	5.13 T20P	T20PQ

切槽和切断

Grooving and Parting Off



A

刀杆

Toolholder

H100

自夹紧
with self clamping

槽深可达
槽宽

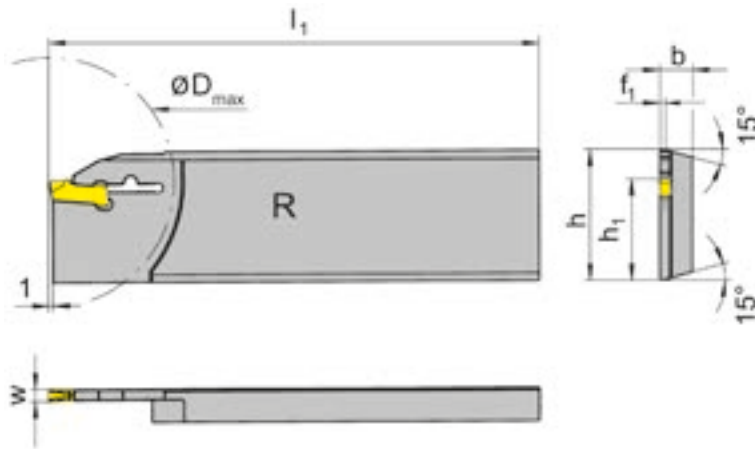
Depth of groove up to
Width of groove

34 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	f_1	t_{max}	D_{max}	尺寸规格 Size
R/LH100.2608.31	26	7.9	110	21.4	0.75	21	42	01
R/LH100.2608.32	26	7.9	110	21.4	0.95	25	50	02
R/LH100.2608.33	26	7.9	110	21.4	1.15	25	50	03
R/LH100.2608.34	26	7.9	110	21.4	1.55	25	50	04
R/LH100.3208.31	32	7.9	112	24.8	0.75	25	50	01
R/LH100.3208.32	32	7.9	112	24.8	0.95	34	68	02
R/LH100.3208.33	32	7.9	112	24.8	1.15	34	68	03
R/LH100.3208.34	32	7.9	112	24.8	1.55	34	68	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

注意事项：
扳手P39L不包含在刀板中，需单独订购！

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

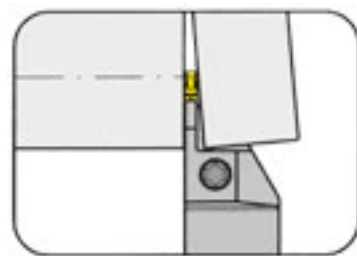
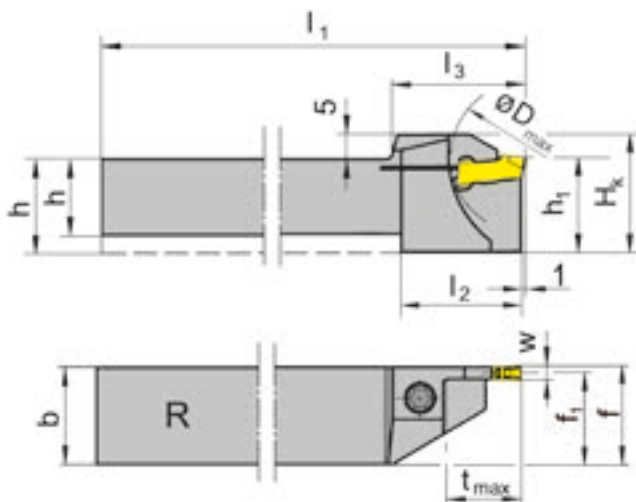
Traub机床推荐型号::
Recommended for Traub machines type:

R/L100.2608.31-34	R/LH100.3208.31-34
TNC 30	TNC 42/65
TNM 28	TNM 42/65
TNS 26	TNS 65
TNS 30/42	TNS 60
TNA 300	TNA 400
TNK 28/36	TNA 300
TNL 26	

刀杆

Toolholder

H100

螺钉夹紧
with screwed clamping槽深可达
槽宽Depth of groove up to
Width of groove21 mm
2 mm配合刀片
for Insert型号 S100
TypeR=右手型-如图
R = right hand version shownL=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH100.1010.01	10	10	125	19	21.0	13	9.25	f ₁ +w/2	10.5	21	18	01
R/LH100.1010.11	10	10	125	21	23.0	16	9.25	f ₁ +w/2	13.0	42	21	01
R/LH100.1212.01	12	12	125	21	23.0	16	11.25	f ₁ +w/2	13.0	26	21	01
R/LH100.1212.11	12	12	125	21	26.0	16	11.25	f ₁ +w/2	16.0	42	21	01
R/LH100.1616.11	16	16	125	24	26.0	20	15.25	f ₁ +w/2	16.0	42	25	01
R/LH100.1616.21	16	16	125	30	33.5	20	15.25	f ₁ +w/2	21.0	42	25	01
R/LH100.2020.11	20	20	125	-	33.5	20	19.25	f ₁ +w/2	16.0	42	25	01
R/LH100.2020.21	20	20	125	-	33.5	20	19.25	f ₁ +w/2	21.0	42	25	01
R/LH100.2525.21	25	25	150	-	33.5	25	24.30	f ₁ +w/2	21.0	42	30	01

注明R或L型
State R or L versionw见刀片
w see inserts尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	4.15T15P	T15PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

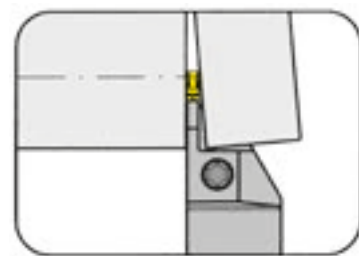
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

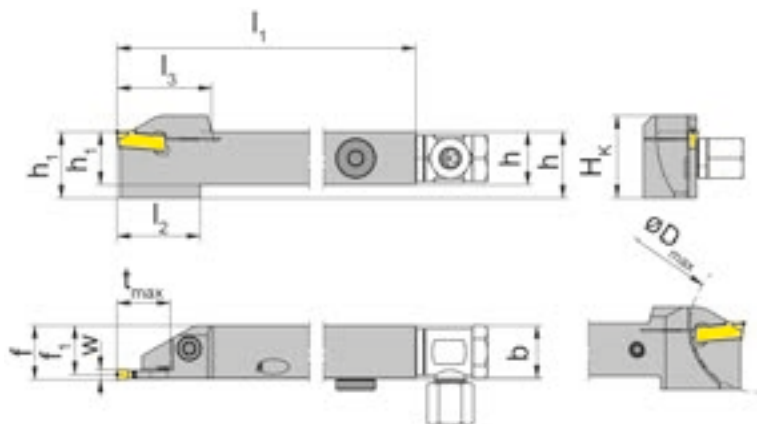
Depth of groove up to
Width of groove

21 mm
2 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	尺寸规格 Size
R/LH100.1212.01.IK	12	12	125	21	23.0	12	11.25	$f_1 + w/2$	13	26	21	01
R/LH100.1212.11.IK	12	12	125	21	26.0	12	11.25	$f_1 + w/2$	16	42	21	01
R/LH100.1616.11.IK	16	16	125	24	26.0	16	15.25	$f_1 + w/2$	16	42	25	01
R/LH100.1616.21.IK	16	16	125	30	33.5	16	15.25	$f_1 + w/2$	21	42	25	01
R/LH100.2020.11.IK	20	20	125	-	33.5	20	19.25	$f_1 + w/2$	16	42	25	01
R/LH100.2020.21.IK	20	20	125	-	33.5	20	19.25	$f_1 + w/2$	21	42	25	01
R/LH100.2525.21.IK	25	25	150	-	33.5	25	24.30	$f_1 + w/2$	21	42	30	01

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

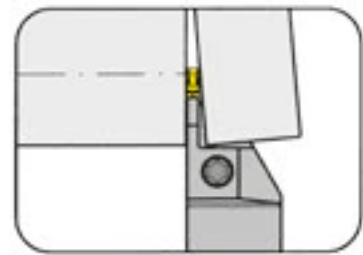
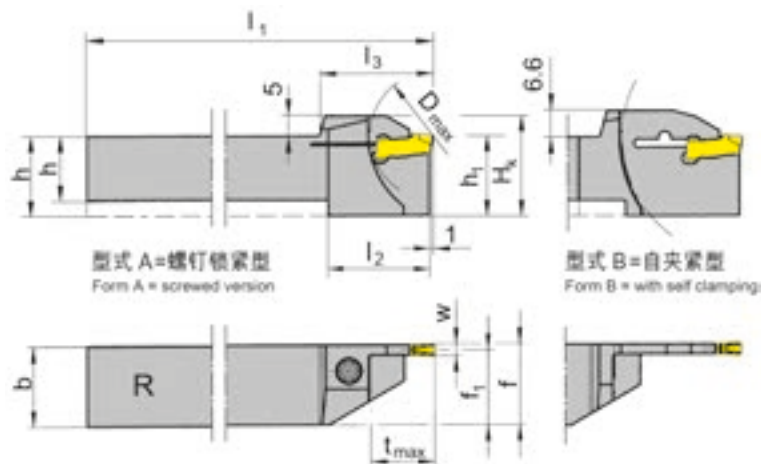
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH100.1212...	4.15T15P	004.00.61	T15PQ	-
R/LH100...	4.15T15P	SBD 6 LR - G1/8"	T15PQ	004.00.26

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove32.5 mm
2.5 mm配合刀片
for Insert型号 S100
TypeR=右手型-如图
R = right hand version shownL=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	形式 Form	尺寸规格 Size
R/LH100.1212.02	12	12	125	21	23.0	16	11.05	$f_1+w/2$	13.0	25	21.0	A	02
R/LH100.1616.02	16	16	125	19	21.0	20	15.05	$f_1+w/2$	10.5	42	25.0	A	02
R/LH100.1212.12	12	12	125	24	26.0	16	11.05	$f_1+w/2$	16.0	42	25.0	A	02
R/LH100.1616.12	16	16	125	24	26.0	20	15.05	$f_1+w/2$	16.0	42	25.0	A	02
R/LH100.2020.12	20	20	125	-	26.0	20	19.05	$f_1+w/2$	16.0	42	25.0	A	02
R/LH100.1616.22	16	16	125	30	33.5	20	15.05	$f_1+w/2$	21.0	42	25.0	A	02
R/LH100.2020.22	20	20	125	-	33.5	20	19.05	$f_1+w/2$	21.0	42	25.0	A	02
R/LH100.2525.22	25	25	150	-	33.5	25	24.05	$f_1+w/2$	21.0	42	30.0	A	02
R/LH100.2020.32	20	20	125	35	38.5	25	19.05	$f_1+w/2$	32.5	65	31.6	B	02

注明R或L型
State R or L versionw见刀片
w see inserts尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中 R/LH100.2020.32，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100.2020.32 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	4.15T15P	T15PQ

切槽和切断

Grooving and Parting Off

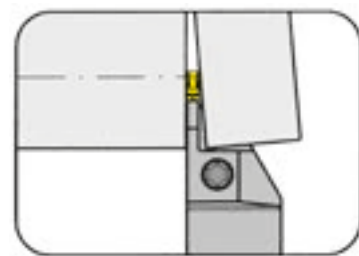


A

刀杆

Toolholder

H100



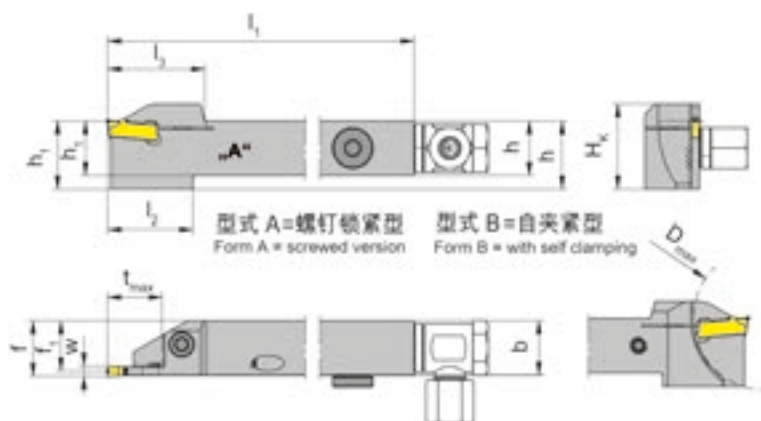
槽深可达
槽宽

Depth of groove up to
Width of groove

21 mm
2.5 mm

配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	形式 Form	尺寸规格 Size
R/LH100.1212.02.IK	12	12	125	21	23.0	16	11.05	f ₁ +w/2	13.0	25	21	A	02
R/LH100.1616.02.IK	16	16	125	19	21.0	20	15.05	f ₁ +w/2	10.5	42	25	A	02
R/LH100.1212.12.IK	12	12	125	24	26.0	16	11.05	f ₁ +w/2	16.0	42	25	A	02
R/LH100.1616.12.IK	16	16	125	24	28.5	20	15.05	f ₁ +w/2	16.0	42	25	A	02
R/LH100.2020.12.IK	20	20	125	-	26.0	20	19.05	f ₁ +w/2	16.0	42	25	A	02
R/LH100.1616.22.IK	16	16	125	30	33.5	20	15.05	f ₁ +w/2	21.0	42	25	A	02
R/LH100.2020.22.IK	20	20	125	-	33.5	20	19.05	f ₁ +w/2	21.0	42	25	A	02
R/LH100.2525.22.IK	25	25	150	-	33.5	25	24.05	f ₁ +w/2	21.0	42	30	A	02

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

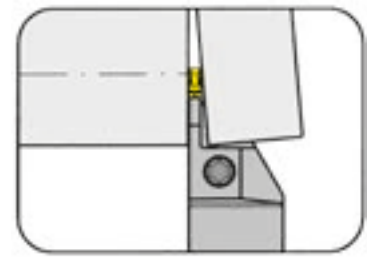
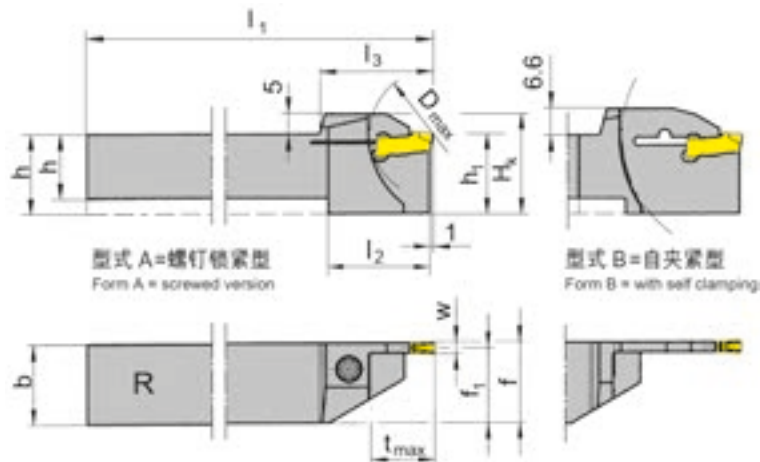
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH100.1212...	4.15T15P	004.00.61	T15PQ	-
R/LH100...	4.15T15P	004.00.61	T15PQ	004.00.26

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove32.5 mm
3 mm配合刀片
for Insert型号 S100
TypeR=右手型-如图
R = right hand version shownL=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	形式 Form	尺寸规格 Size
R/LH100.1212.03	12	12	125	21.0	23.0	16	10.85	$f_1+w/2$	13.0	26	25.0	A	03
R/LH100.1616.03	16	16	125	19.5	23.0	20	14.85	$f_1+w/2$	10.5	42	25.0	A	03
R/LH100.1616.13	16	16	125	25.0	28.5	20	14.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.2020.13	20	20	125	-	28.5	20	18.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.2525.13	25	25	150	-	28.5	25	23.85	$f_1+w/2$	16.0	42	30.0	A	03
R/LH100.1616.23	16	16	125	30.0	33.5	20	14.85	$f_1+w/2$	21.0	42	25.0	A	03
R/LH100.2020.23	20	20	125	-	33.5	20	18.85	$f_1+w/2$	21.0	42	25.0	A	03
R/LH100.2525.23	25	25	150	-	33.5	25	23.85	$f_1+w/2$	21.0	42	30.0	A	03
R/LH100.2020.33	20	20	125	35.0	38.5	25	18.85	$f_1+w/2$	32.5	65	31.6	B	03
R/LH100.2525.33	25	25	150	-	38.5	25	23.85	$f_1+w/2$	32.5	65	31.6	B	03

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	5.17T20P	T20PQ

切槽和切断

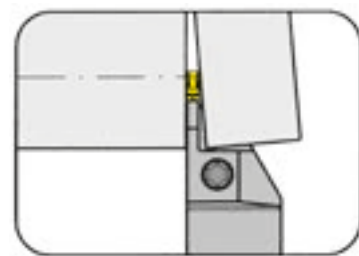
Grooving and Parting Off



刀杆

Toolholder

H100



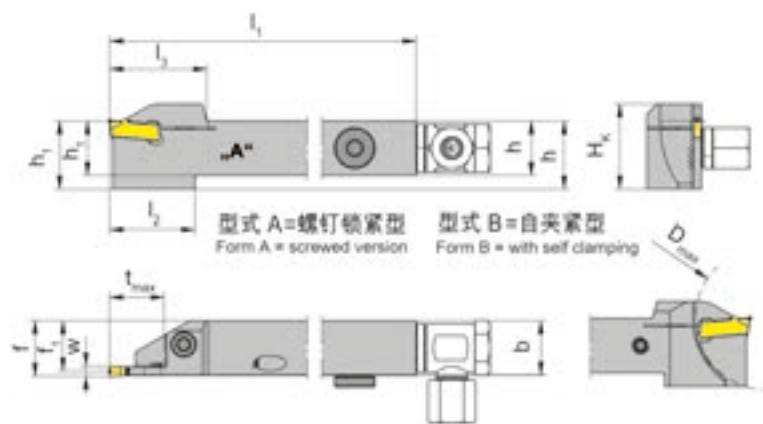
槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
3 mm

配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	形式 Form	尺寸规格 Size
R/LH100.1212.03.IK	12	12	125	21.0	23.0	16	10.85	f ₁ +w/2	13.0	26	25.0	A	03
R/LH100.1616.03.IK	16	16	125	19.5	23.0	20	14.85	f ₁ +w/2	10.5	42	25.0	A	03
R/LH100.1616.13.IK	16	16	125	25.0	28.5	20	14.85	f ₁ +w/2	16.0	42	25.0	A	03
R/LH100.2020.13.IK	20	20	125	-	28.5	20	18.85	f ₁ +w/2	16.0	42	25.0	A	03
R/LH100.2525.13.IK	25	25	150	-	28.5	25	23.85	f ₁ +w/2	16.0	42	30.0	A	03
R/LH100.1616.23.IK	16	16	125	30.0	33.5	20	14.85	f ₁ +w/2	21.0	42	25.0	A	03
R/LH100.2020.23.IK	20	20	125	-	33.5	20	18.85	f ₁ +w/2	21.0	42	25.0	A	03
R/LH100.2525.23.IK	25	25	150	-	33.5	25	23.85	f ₁ +w/2	21.0	42	30.0	A	03
R/LH100.2020.33.IK	20	20	125	35.0	38.5	25	18.85	f ₁ +w/2	32.5	65	31.6	B	03
R/LH100.2525.33.IK	25	25	150	-	38.5	25	23.85	f ₁ +w/2	32.5	65	31.6	B	03

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Note:

Wrench P39L is not combined with blade R/LH100...33 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

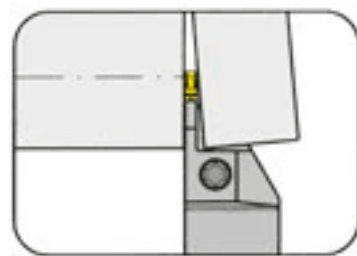
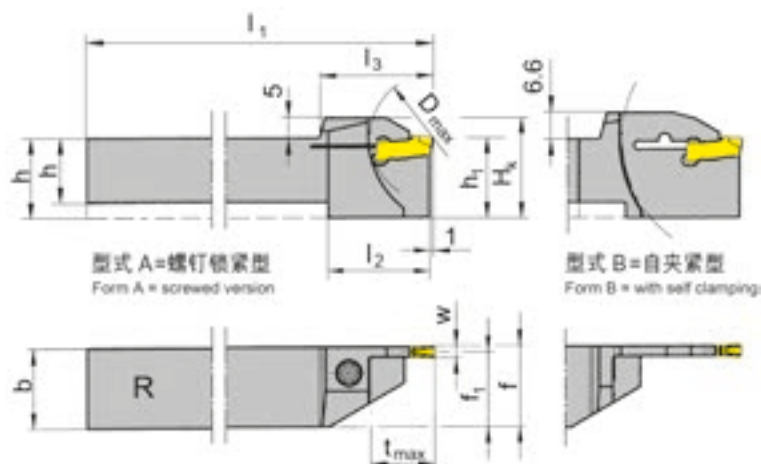
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH100.1212.../2525.23...	5.17T20P	004.00.61	T20PQ	-
R/LH100...	5.17T20P	004.00.16	T20PQ	004.00.26
R/LH100...33.IK	-	004.00.16	-	004.00.26

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove40.5 mm
4 mm配合刀片
for Insert型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1616.04	16	16	125	19.5	23.0	20	14.45	$f_1 + w/2$	10.5	42	25.0	A	04
R/LH100.1616.14	16	16	125	25.0	28.5	20	14.45	$f_1 + w/2$	16.0	42	25.0	A	04
R/LH100.2020.14	20	20	125	-	28.5	20	18.45	$f_1 + w/2$	16.0	42	25.0	A	04
R/LH100.2525.14	25	25	150	-	28.5	25	23.45	$f_1 + w/2$	16.0	42	30.0	A	04
R/LH100.1616.24	16	16	125	30.0	33.5	20	14.45	$f_1 + w/2$	21.0	42	25.0	A	04
R/LH100.2020.34	20	20	125	35.0	38.5	25	18.45	$f_1 + w/2$	32.5	65	31.6	B	04
R/LH100.2525.34	25	25	150	40.0	46.5	32	23.45	$f_1 + w/2$	40.5	81	31.6	B	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中R/LH100...34，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100...34 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	5.17T20P	T20PQ

切槽和切断

Grooving and Parting Off

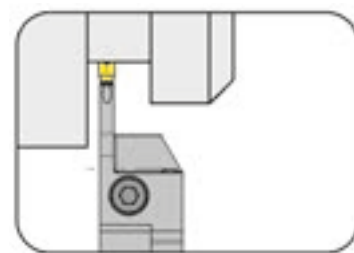


刀杆

Toolholder

H100

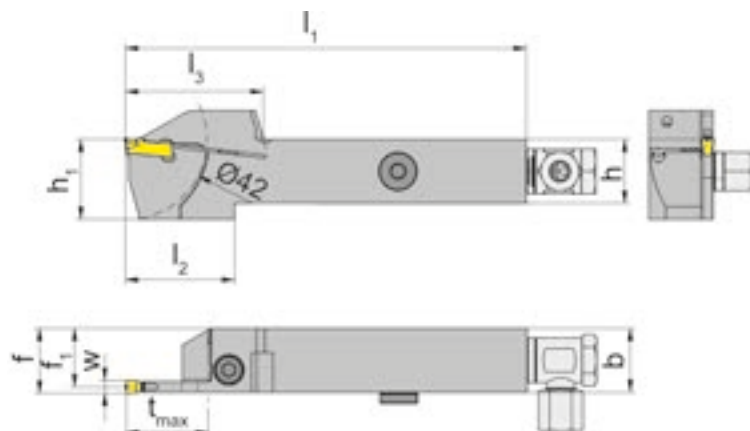
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

21.5 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.1616.0.23.IK	16	20	125	35	39	25	14.65	$f_1 + w/2$	21.5	03
R/LH100.1616.0.24.IK	16	20	125	35	39	25	14.30	$f_1 + w/2$	21.5	04
R/LH100.2020.0.23.IK	20	20	125	33	39	25	18.65	$f_1 + w/2$	21.5	03
R/LH100.2020.0.24.IK	20	20	125	33	39	25	18.30	$f_1 + w/2$	21.5	04
R/LH100.2525.0.23.IK	25	25	150	33	39	30	23.65	$f_1 + w/2$	21.5	03
R/LH100.2525.0.24.IK	25	25	150	33	39	30	23.30	$f_1 + w/2$	21.5	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

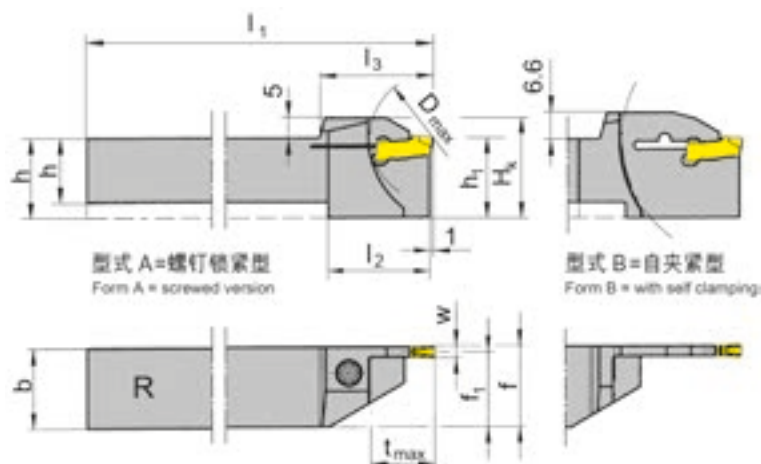
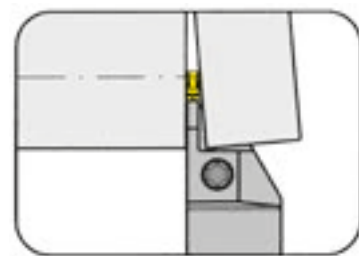
Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove40.5 mm
5 mm配合刀片
for Insert型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.2020.15	20	20	125	-	28.5	20	18.05	$f_1+w/2$	16.0	42	25.0	A	05
R/LH100.2525.15	25	25	150	-	28.5	25	23.05	$f_1+w/2$	16.0	42	30.0	A	05
R/LH100.2020.35	20	20	125	35	38.5	25	18.05	$f_1+w/2$	32.5	65	31.6	B	05
R/LH100.2525.35	25	25	150	40	46.5	32	23.05	$f_1+w/2$	40.5	81	38.6	B	05

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100....	5.17T20P	T20PQ

切槽和切断

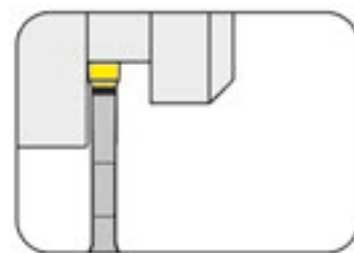
Grooving and Parting Off



刀杆

Toolholder

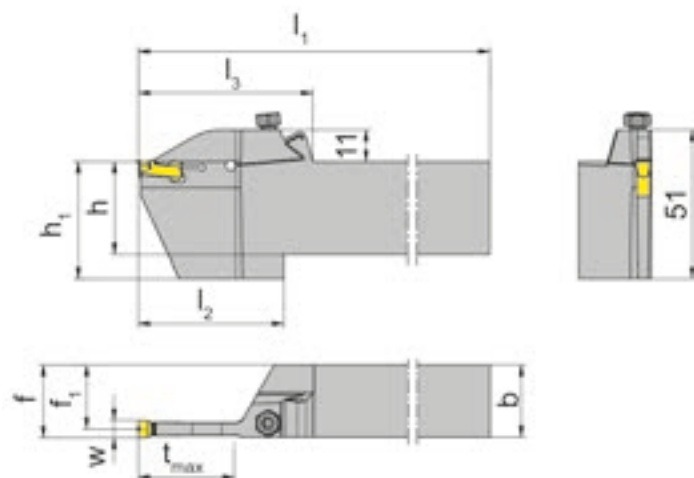
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

41 mm
4-12 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.2020.3.04	20	20	150	50	60	32	18.2	$f_1+w/2$	33	04
R/LH100.2020.3.05	20	20	150	50	60	32	17.7	$f_1+w/2$	33	05
R/LH100.2525.3.05	25	25	150	50	60	32	22.7	$f_1+w/2$	33	05
R/LH100.2525.3.06	25	25	150	50	60	40	22.2	$f_1+w/2$	33	06
R/LH100.3225.3.06	32	25	170	50	60	40	22.2	$f_1+w/2$	33	06
R/LH100.3225.3.08	32	25	170	50	60	40	21.2	$f_1+w/2$	33	08
R/LH100.3225.3.8	32	25	170	50	60	40	21.2	$f_1+w/2$	35	08
R/LH100.3225.4.08	32	25	170	55	65	40	21.2	$f_1+w/2$	41	08
R/LH100.3225.4.10	32	25	170	55	65	40	20.3	$f_1+w/2$	41	10
R/LH100.3225.4.12	32	25	170	55	65	40	19.3	$f_1+w/2$	41	12

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

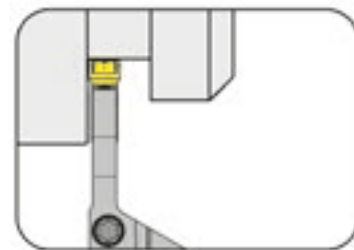
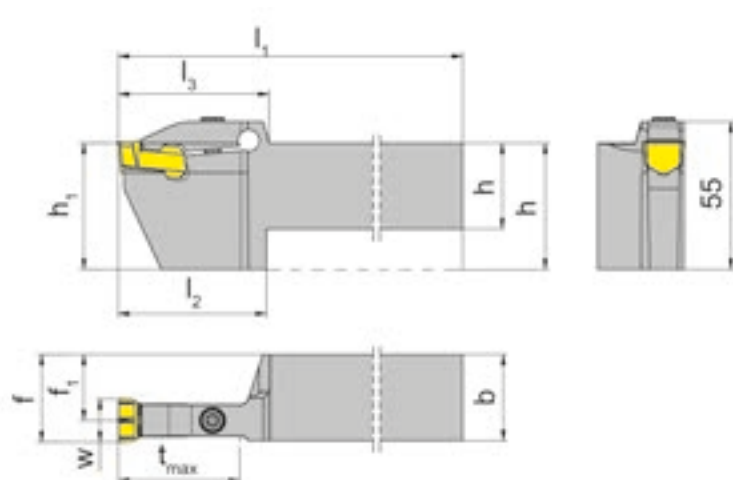
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	030.6075.T20P	T20PQ

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove45 mm
16 mm配合刀片
for Insert型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	l_3	尺寸规格 Size
R/LH100.3232.5.16	32	32	170	55	47	24.5	$f_1 + w/2$	45	56	16

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100.3232.5.16	030.0625.T25P	T25PQ

切槽和切断 (外圆)

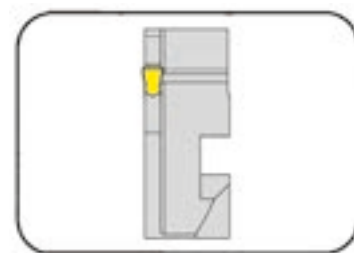
Grooving and Parting off (external)



刀夹

Cassette

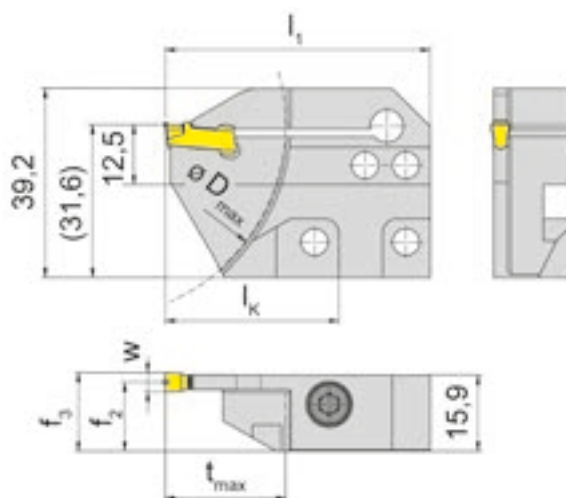
NK100



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type

L=左手型-如图
L = left hand version shown

产品型号 Part number	t _{max}	f ₂	f ₃	w	D _{max}	l ₁	l _K
R/LNK100.3215.21	25	15.4	f ₂ +w/2	2	80	55	36
R/LNK100.3215.23	25	14.9	f ₂ +w/2	3	80	55	36
R/LNK100.3215.24	25	14.4	f ₂ +w/2	4	80	55	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK100...	6.23T25P	T25PQ

刀片

Insert

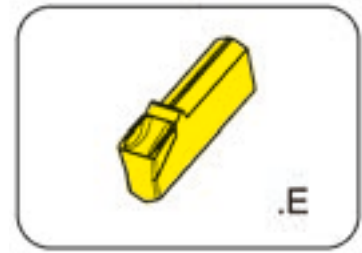
S100

带卷屑器
with chip former

槽宽

Width of groove

2-5 mm



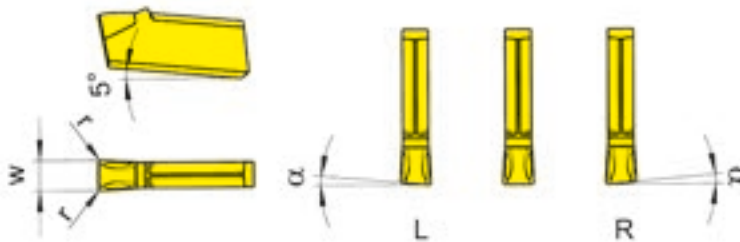
配合刀杆

for Toolholder

型号

H100

Type



R=右手型

R = right hand version

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	ALX2	ALX3	AS63	AS66	TC92	TC93	TF42	TF43	TF45	TF46	T122
S100.0200.E2	2.0	0.2	0°	01		▲			Δ	Δ		▲	▲	▲	▲
R/L/S100.0520.E2	2.0	0.2	5°	01					Δ/Δ	Δ/Δ		▲/Δ	▲/▲	Δ/Δ	Δ/Δ
S100.0250.E2	2.5	0.2	0°	02					Δ	Δ		▲	▲	▲	▲
R/LS100.0525.E2	2.5	0.2	5°	02					Δ/Δ	▲/Δ		▲/Δ	▲/Δ	Δ/Δ	Δ/Δ
S100.0300.E2	3.0	0.2	0°	03	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
R/LS100.0530.E2	3.0	0.2	5°	03		▲/▲			Δ/▲	Δ/Δ	▲/Δ	▲/▲	▲/▲	▲/▲	▲/Δ
S100.0400.E3	4.0	0.3	0°	04		▲			Δ	▲		▲	▲	▲	▲
R/LS100.0540.E2	4.0	0.2	5°	04		Δ/Δ			Δ/Δ	Δ/Δ		▲/▲	▲/▲	Δ/Δ	Δ/Δ
S100.0500.E3	5.0	0.3	0°	05				Δ	Δ	▲		▲	▲	▲	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request															
● 推荐 / recommended															
○ 次推荐 / alternative recommendation															
- 不合适 / not suitable															
非涂层 / uncoated grades															
涂层 / coated grades															
钎焊/金属陶瓷 / brazed/Cermet															

尺寸单位：mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



A

刀片

Insert

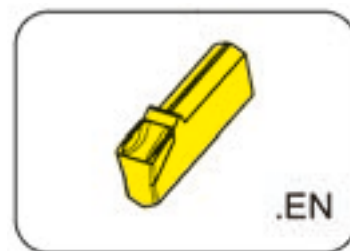
S100

带卷屑器
with chip former

槽宽

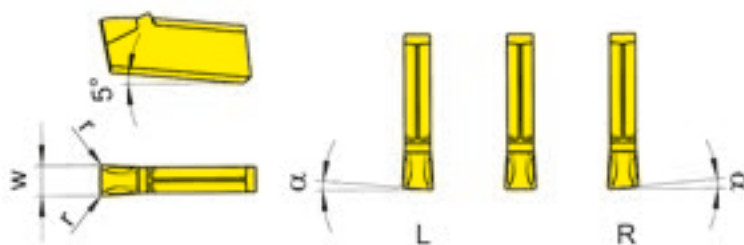
Width of groove

2-16 mm



配合刀杆
for Toolholder

型号 H100
Type



R=右手型
R = right hand version

L=左手型
L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	ALX3	ALX5	AS62	AS63	AS66	AS6G	TF45	TH35
S100.0200.EN2	2.0	0.2	0°	01	▲	Δ				▲		Δ
S100.0220.EN2	2.2	0.2	0°	01	▲					▲		
S100.0250.EN2	2.5	0.2	0°	02	▲					▲		
S100.0300.EN2	3.0	0.2	0°	03	▲	Δ		▲	▲	▲	Δ	
RS100.0530.EN2	3.0	0.2	5°	03			▲		▲			
S100.0400.EN3	4.0	0.3	0°	04	▲			▲		▲		
R/LS100.0540.EN2	4.0	0.2	5°	04	▲/▲							
S100.0500.EN3	5.0	0.3	0°	05	▲							
S100.0600.EN6	6.0	0.8	0°	06								
S100.0800.EN8	8.0	0.8	0°	08					▲	▲		
LS100.0480.EN8	8.0	0.8	4°	08					▲			
S100.1000.EN8	10.0	0.8	0°	10						▲		
S100.1200.EN8	12.0	0.8	0°	12						▲		
S100.1600.EN8	16.0	0.8	0°	16						▲		
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	•	•	•	•	•	•	•
● 推荐 / recommended					M	-	•	-	-	o	•	•
o 次推荐 / alternative recommendation					K	-	•	-	-	•	•	•
- 不合适 / not suitable					N	-	•	-	-	•	•	•
■ 非涂层 / uncoated grades					S	-	•	-	-	o	•	•
■ 涂层 / coated grades					H	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号
Carbide grades

刀片

Insert

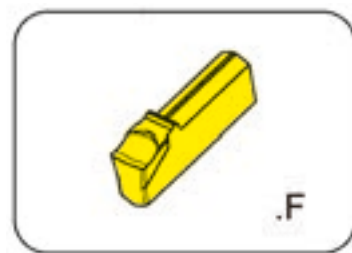
S100

带卷屑器
with chip forming

槽宽

Width of groove

2-5 mm

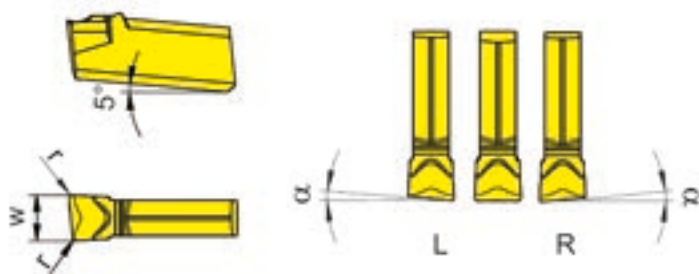


配合刀杆

for Toolholder

型号 H100

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	TC92	TC93	TF42	TF43	TF45	TF46	T122
S100.0200.F2	2.0	0.2	0°	01	▲	△		▲	▲	▲	▲
R/LS100.0520.F2	2.0	0.2	5°	01	△/△	△/△		△/△	▲/▲	▲/△	△/△
S100.0250.F2	2.5	0.2	0°	02	△	△		△	▲	△	▲
R/LS100.0525.F2	2.5	0.2	5°	02	△/△	△/△		△/△	▲/▲	△/△	△/△
S100.0300.F2	3.0	0.2	0°	03	△	▲	△	▲	▲	▲	▲
R/LS100.0530.F2	3.0	0.2	5°	03	△/△	△/△		▲/△	▲/▲	▲/▲	△/▲
S100.0400.F3	4.0	0.3	0°	04	△	▲		▲	▲	▲	▲
R/LS100.0540.F2	4.0	0.2	5°	04	△/△	△/△		△/△	▲/▲	△/△	△/△
S100.0500.F3	5.0	0.3	0°	05	△	△		△	▲	△	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

	P	M	K	N	S	H
TC92	●	-	-	-	-	-
TC93	●	-	-	-	-	-
TF42	●	-	-	-	-	-
TF43	●	-	-	-	-	-
TF45	●	o	●	●	o	-
TF46	●	-	●	●	-	-
T122	●	-	-	-	-	-

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



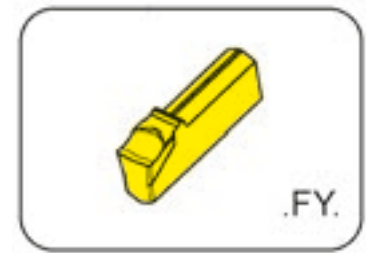
A

刀片

Insert

S100

带卷屑器
with chip forming



槽宽

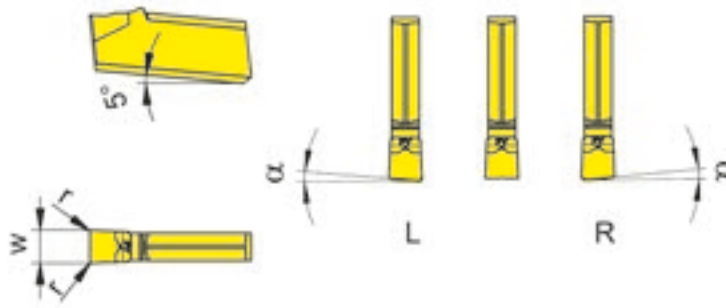
Width of groove

2-4 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H100
Type



R=右手型
R = right hand version

L=左手型
L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	AS45	HP65	IG35	PH35	TI25	
S100.0200.FY2	2.0	0.2	0°	01	△	▲	▲	▲	▲	
R/LS100.1520.FY0	2.0	-	15°	01	▲/▲		▲/▲			
S100.0220.FY2	2.2	0.2	0°	01			▲		▲	
S100.0250.FY2	2.5	0.2	0°	02	△	▲	▲		▲	
S100.0300.FY2	3.0	0.2	0°	03	△	▲	▲	▲	▲	
R/LS100.1530.FY0	3.0	-	15°	03	▲/▲		▲/▲			
S100.0400.FY3	4.0	0.3	0°	04		▲	▲		▲	
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	-	○	●
● 推荐 / recommended					M	●	●	●	○	●
○ 次推荐 / alternative recommendation					K	●	●	-	●	●
- 不合适 / not suitable					N	○	○	-	-	●
■ 非涂层 / uncoated grades					S	●	●	●	-	●
■ 涂层 / coated grades					H	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet										

硬质合金牌号
Carbide grades

尺寸单位 : mm
Dimensions in mm

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

刀片

Insert

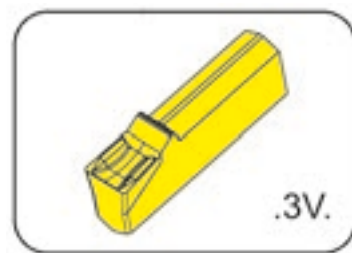
S100

带卷屑器
with chip forming

槽宽

Width of groove

2-4 mm



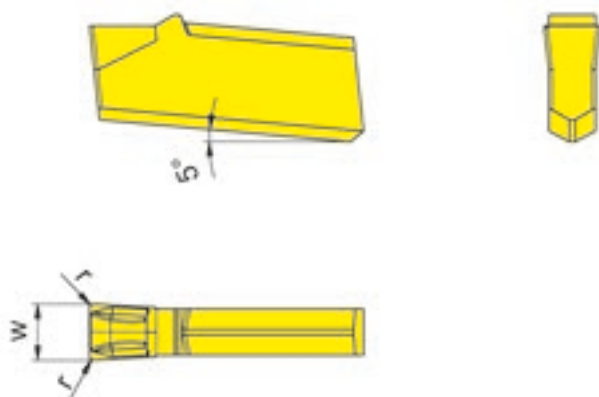
配合刀杆

for Toolholder

型号

H100

Type



产品型号 Part number	w	r	尺寸规格 Size		AS45	HP35	HP65	IG35	PH35
S100.0200.3V2	2.0	0.2	01		▲	△	▲	▲	▲
S100.0250.3V2	2.5	0.2	02		▲		▲	▲	
S100.0300.3V2	3.0	0.2	03		▲		▲	▲	▲
S100.0400.3V3	4.0	0.3	04		▲		▲	▲	
				P	●	○	●	-	○
				M	●	●	●	●	○
				K	●	○	●	-	●
				N	○	-	○	-	-
				S	●	○	●	●	-
				H	-	-	-	-	

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



刀片

Insert

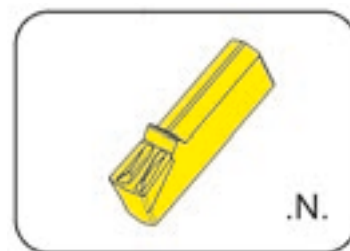
S100

带卷屑器
with chip forming

槽宽

Width of groove

3-4 mm

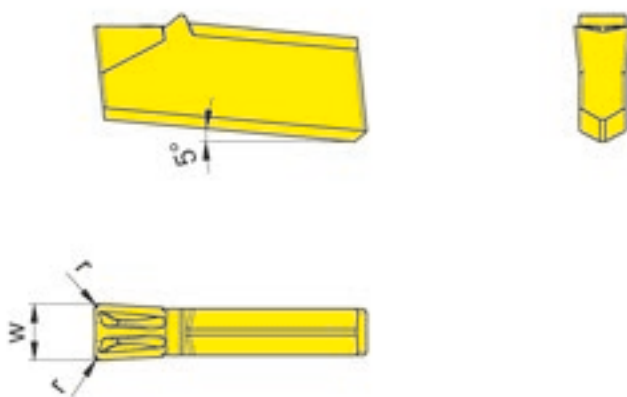


配合刀杆

for Toolholder

型号 H100

Type



产品型号 Part number	w	r	尺寸规格 Size		AS45	HP65
S100.0300.N2	3	0.2	03	▲	●	●
S100.0400.N3	4	0.3	04	▲	●	●
				P	●	●
				M	●	●
				K	●	●
				N	○	○
				S	●	●
				H	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

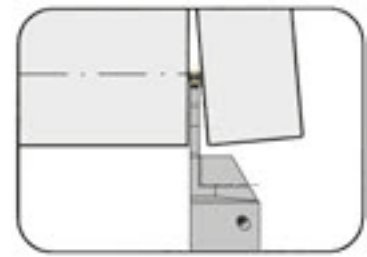
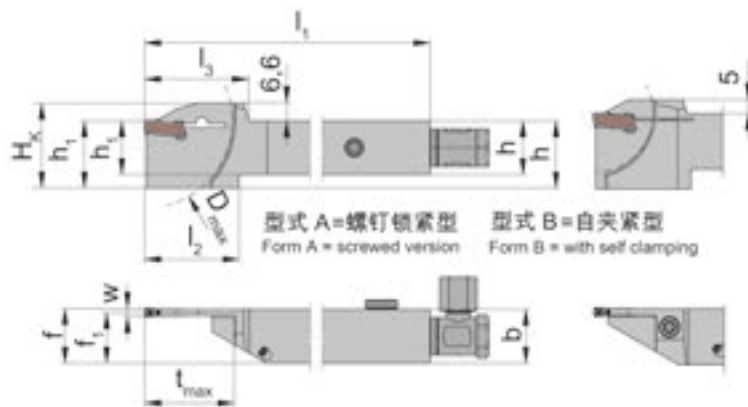
硬质合金牌号

Carbide grades

刀杆

Toolholder

H100

槽深可达
槽宽Depth of groove up to
Width of groove41 mm
3-4 mm配合刀片
for Insert型号 S100
Type冷却液供应通过刀片
Coolant supply through insert

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1616.1.23.IK	16	16	125	35	33.5	27	14.85	$f_1 + w/2$	21.5	42	32.0	A	03
R/LH100.2020.1.13.IK	20	20	125	30	28.5	27	18.85	$f_1 + w/2$	16.0	42	32.0	A	03
R/LH100.2020.1.23.IK	20	20	125	35	33.5	27	18.85	$f_1 + w/2$	21.5	42	32.0	A	03
R/LH100.2020.1.33.IK	20	20	125	35	38.5	27	18.85	$f_1 + w/2$	33.0	65	33.6	B	03
R/LH100.2525.1.33.IK	25	25	150	35	38.5	32	23.85	$f_1 + w/2$	33.0	65	38.6	B	03
R/LH100.2020.1.34.IK	20	20	125	35	38.5	27	18.45	$f_1 + w/2$	33.0	65	33.6	B	04
R/LH100.2525.1.34.IK	25	25	150	40	46.5	32	23.45	$f_1 + w/2$	41.0	81	38.6	B	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	Sealing plug Sealing plug	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100...13/23.IK	5.17T20P	004.00.26	SBD 6 LR - G1/8"	T20PQ	-
R/LH100....	-	004.00.26	SBD 6 LR - G1/8"	-	P39L

切槽和切断

Grooving and Parting Off



刀杆

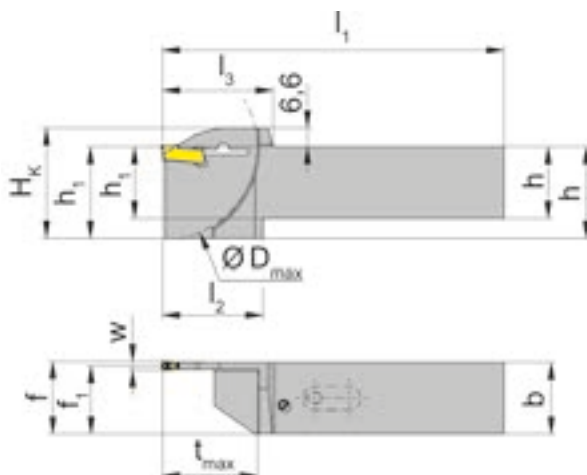
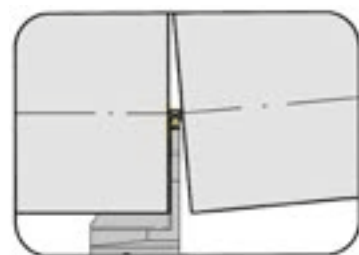
Toolholder

H100

槽深可达
槽宽

Depth of groove up to
Width of groove

33 mm
3 mm



配合刀片
for Insert

型号 S100
Type

带集成内冷
with integrated through
coolant supply

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH100.2020.3.33.IK	20	20	104	35	38.5	27	18.85	f ₁ +w/2	33	65	33.6	03
R/LH100.2525.3.33.IK	25	25	119	35	38.5	32	23.85	f ₁ +w/2	33	65	38.6	03

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中，需单独订购！

Ordering note:

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

刀片

Insert

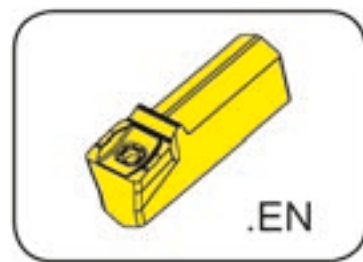
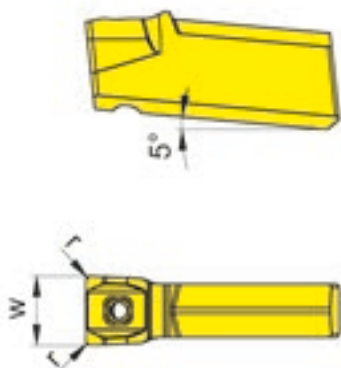
S100

带卷屑器
with chip former

槽宽

Width of groove

3-4 mm

配合刀杆
for Toolholder型号 H100...13/23/33/34IK
Type冷却液供应通过刀片
Coolant supply through insert

产品型号 Part number	w	r	尺寸规格 Size		AS45	EG55	HP65
S100.0300.EN2.IK	3	0.2	03		▲	▲	▲
S100.0400.EN3.IK	4	0.3	04		▲	▲	▲
				P	•	•	•
				M	•	○	•
				K	•	○	•
				N	○	-	○
				S	•	-	•
				H	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

切槽和切断

Grooving and Parting Off



刀片

Insert

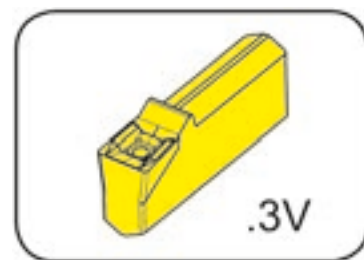
S100

带卷屑器
with chip former

槽宽

Width of groove

2.5-3 mm

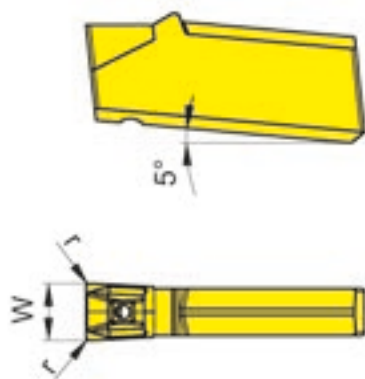


配合刀杆

for Toolholder

型号 H100...13/23/33/34IK

Type



冷却液供应通过刀片
Coolant supply through insert

产品型号 Part number	w	r	尺寸规格 Size		HP65	IG35
S100.0250.3V2.IK	2.5	0.2	02		▲	▲
S100.0300.3V2.IK	3.0	0.2	03		▲	▲
				P	●	-
				M	●	●
				K	●	-
				N	○	-
				S	●	●
				H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

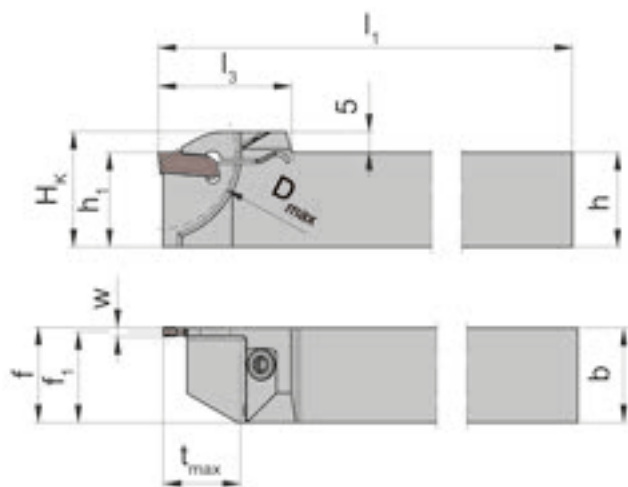
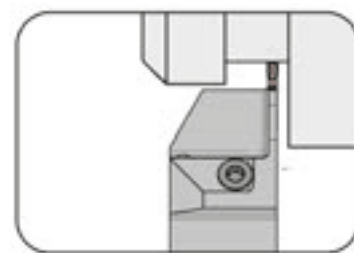
刀杆

Toolholder

H101

螺钉夹紧

with screwed clamping

槽深可达
槽宽Depth of groove up to
Width of groove13 mm
1.2-1.6 mm配合刀片
for Insert型号 S101
Type

产品型号 Part number	h	b	l_1	l_3	h_1	f_1	f	t_{max}	H_K	D_{max}	尺寸规格 Size
R/LH101.1010.1.16	10	10	125	22.5	10	9.35	$f_1 + w/2$	13	13.5	26	16
R/LH101.1212.1.16	12	12	125	22.5	12	11.35	$f_1 + w/2$	13	15.5	26	16
R/LH101.1616.1.16	16	16	125	22.5	16	15.35	$f_1 + w/2$	13	19.5	26	16

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH101...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

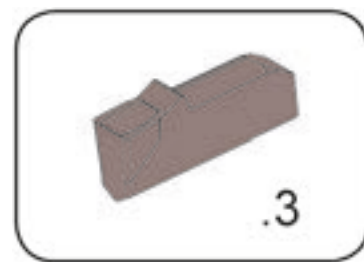


刀片

Insert

S101

带卷屑器
with chip forming



槽宽

Width of groove

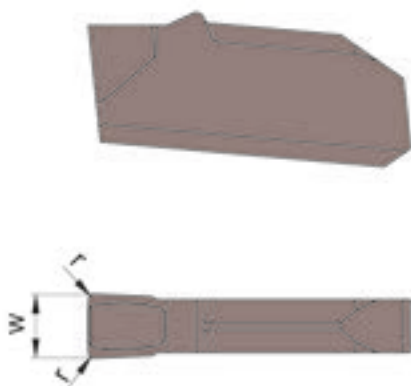
1.2-1.6 mm

配合刀杆

for Toolholder

型号 H101

Type



产品型号 Part number	w	r	尺寸规格 Size		AS45	IG35
S101.0120.315	1.2	0.15	12		▲	▲
S101.0160.315	1.6	0.15	16		▲	▲
				P	●	-
				M	●	●
				K	●	-
				N	○	-
				S	●	●
				H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

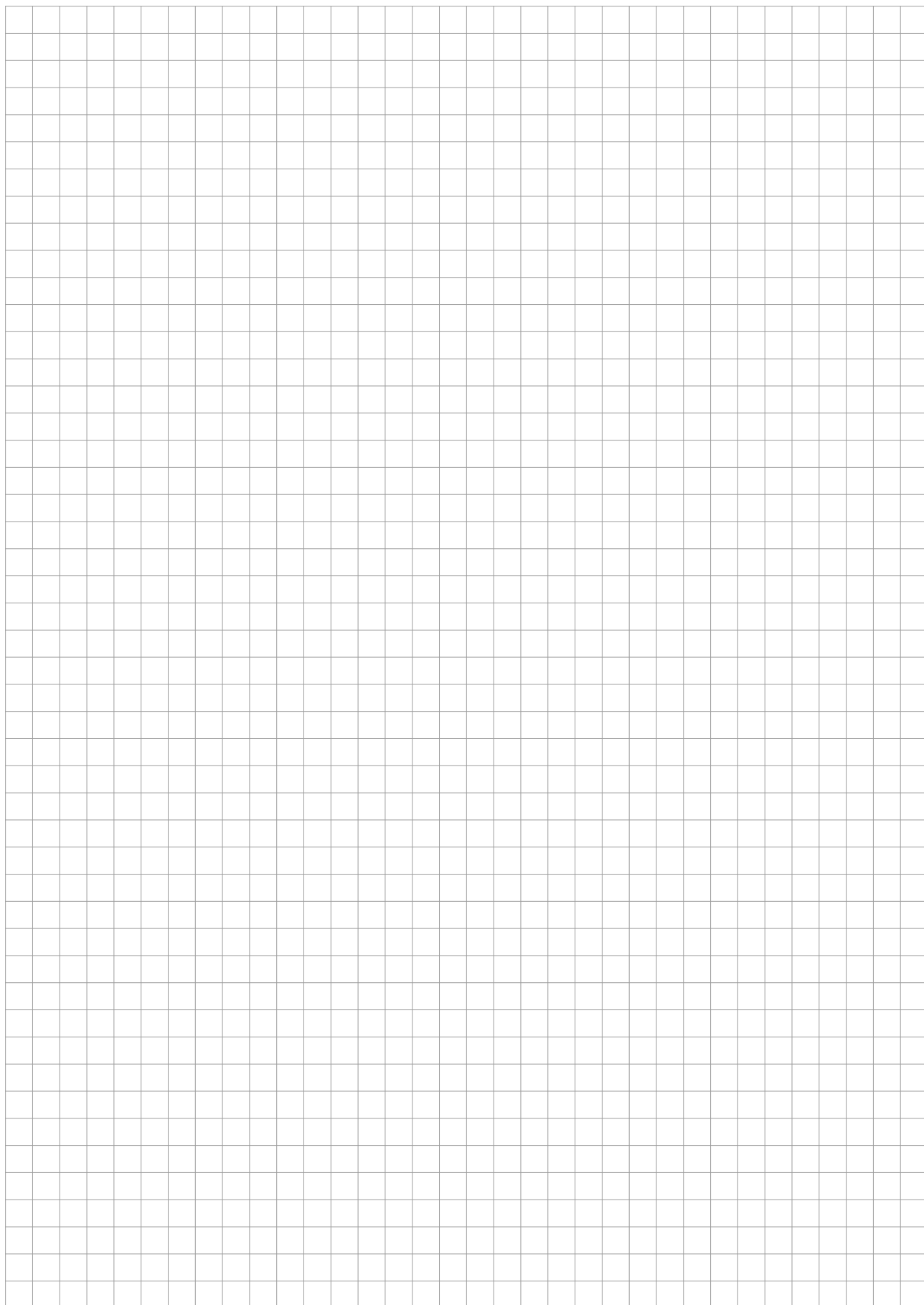
■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm





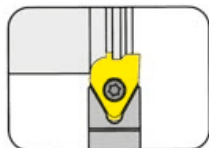
机夹式刀杆

轮廓宽度可达 10 - 45 mm

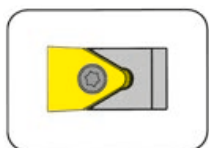
Toolholder with Inserts

Width of profile 10 - 45 mm

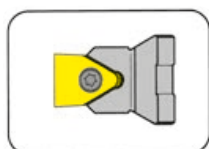
刀杆
Toolholder
H117



页/Page
B3-B4, B6, B8

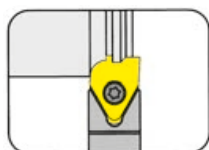


页/Page
B10



页/Page
B11

刀片
Insert
S117



页/Page
B5, B7, B9

仿形加工 (外圆)

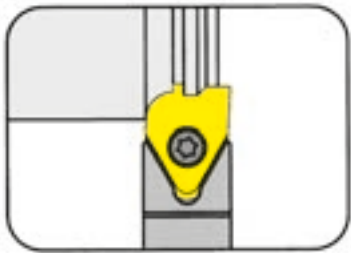
Profiling (external)



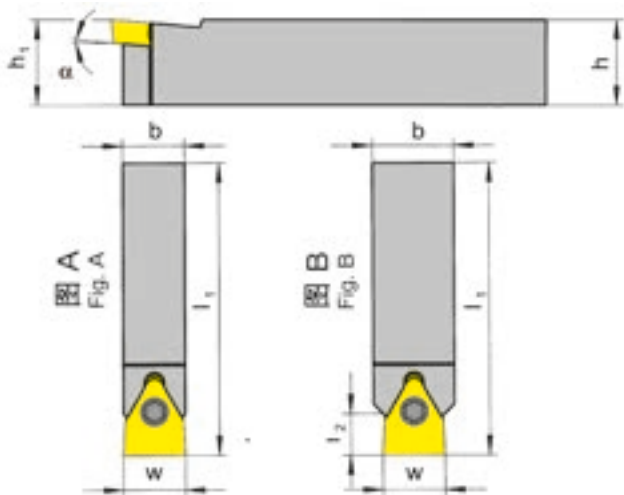
B

刀杆
Toolholder

H117



轮廓深度 轮廓宽度可达	Depth of form up to Width of form up to	4.5 mm 12 mm



配合刀片
for Insert

型号 S117
Type

产品型号 Part number	h	b	l ₁	h ₁	α	形式 Figur	l ₂	w	刀片 Insert
H117.1010.10	10	10	100	10	5°	A	-	10	S117.0010.00
H117.1212.10	12	12	125	12	5°	B	9	10	S117.0010.00
H117.1616.10	16	16	125	16	5°	B	9	10	S117.0010.00
H117.1212.12	12	12	125	12	5°	A	-	12	S117.0012.00
H117.1414.12	14	14	125	14	5°	B	8	12	S117.0012.00
H117.1612.12	16	12	125	16	5°	A	-	12	S117.0012.00
H117.1616.12	16	16	125	16	5°	B	8	12	S117.0012.00
H117.2020.12	20	20	150	20	5°	B	8	12	S117.0012.00

按需提供更多角度
 Further angles upon request
 螺丝的扭矩规格，详见技术说明。
 For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
 Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117.1010.10	030.400P.0227	T15PQ
H117...	4.09T15P	T15PQ

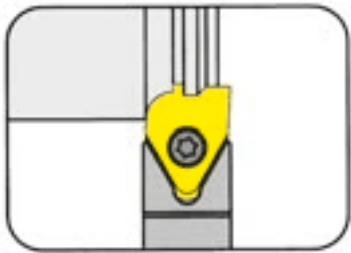
仿形加工 (外圆)
Profiling (external)



B

刀杆
Toolholder

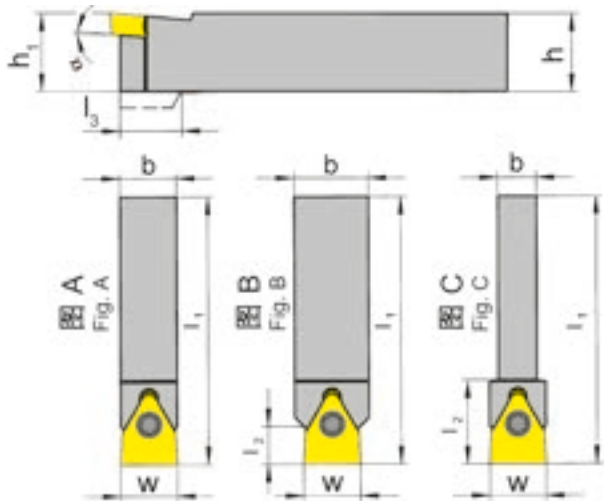
H117



轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

10 mm
26 mm



配合刀片
for Insert

型号 S117
Type

产品型号 Part number	h	b	l ₁	h ₁	l ₃	α	形式 Figur	l ₂	w	刀片 Insert
H117.1414.16	14	14	125	14	18	5°	C	22.0	16	S117.0014/16.00
H117.1616.16	16	16	125	16	-	5°	A / B	11.0	16	S117.0014/16.00
H117.2020.16	20	20	150	20	-	5°	B	11.0	16	S117.0014/16.00
H117.2525.16	25	25	150	25	-	5°	B	8.5	16	S117.0014/16.00
H117.1616.20	16	16	125	16	23	5°	C	30.0	20	S117.0018/20.00
H117.2020.20	20	20	150	20	-	5°	A / B	15.0	20	S117.0018/20.00
H117.2525.20	25	25	150	25	-	5°	B	15.0	20	S117.0018/20.00
H117.2020.26	20	20	150	20	-	5°	C	30.0	26	S117.0026.00
H117.2525.26	25	25	150	25	-	5°	A	-	26	S117.0026.00

按需提供更多角度

Further angles upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...16	5.12T20P	T20PQ
H117...	6.17 T20P	T20PQ

仿形加工 (外圆)

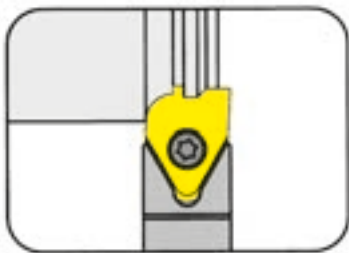
Profiling (external)



B

刀片
Insert

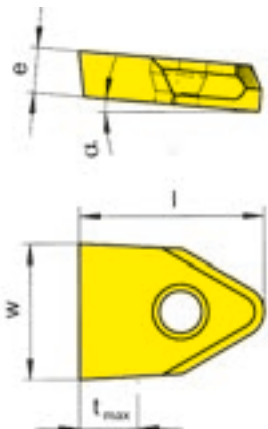
S117



轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

10 mm
26 mm



配合刀杆
for Toolholder

型号 H117
Type

产品型号 Part number	w	E	t _{max}	l	α	刀杆 Toolholder	MG12	H54
S117.0010.00	10	3.0	3.5	16	5°	H117...10	▲	
S117.0012.00	12	4.5	4.5	17	5°	H117...12	▲	Δ
S117.0014.00	14	6.0	6.0	21	5°	H117...16	▲	
S117.0016.00	16	6.0	6.0	21	5°	H117...16	▲	
S117.0018.00	18	7.0	9.0	29	5°	H117...20	▲	
S117.0020.00	20	7.0	9.0	29	5°	H117...20	▲	
S117.0026.00	26	7.0	10.0	32	5°	H117...26	▲	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

P	o	●
M	-	●
K	-	-
N	-	-
S	-	-
H	-	-

尺寸单位 : mm
Dimensions in mm



根据客户要求生产的各种仿形刀片
Profile inserts upon request.

仿形加工 (外圆)

Profiling (external)

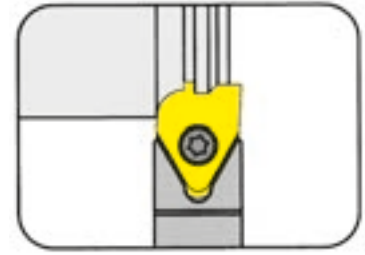


B

刀杆

Toolholder

H117



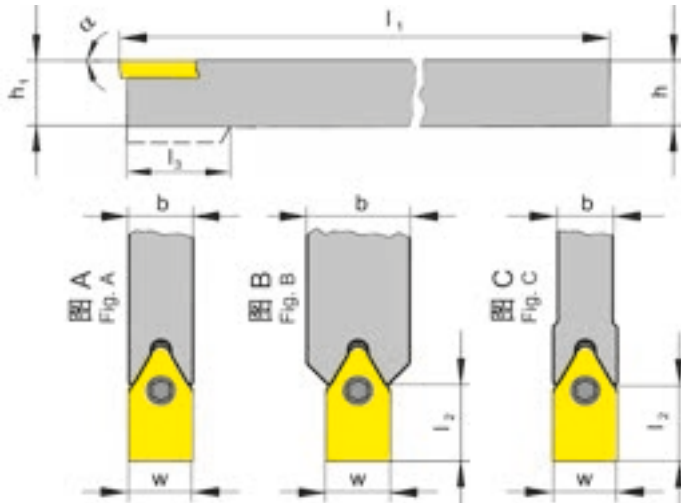
轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

13 mm
26 mm

配合刀片
for Insert

型号 S117
Type



产品型号 Part number	h	b	l_1	h_1	l_3	α	形式 Figur	l_2	w	刀片 Insert
H117.1010.02.10	10	10	100	10	-	0°	A	-	10	S117.0010.02.00
H117.1212.02.10	12	12	125	12	-	0°	B	12	10	S117.0010.02.00
H117.1616.02.10	16	16	125	16	-	0°	B	12	10	S117.0010.02.00
H117.1212.02.12	12	12	125	12	-	0°	A	-	12	S117.0012.02.00
H117.1616.02.12	16	16	125	16	-	0°	B	11	12	S117.0012.02.00
H117.2020.02.12	20	20	150	20	-	0°	B	11	12	S117.0012.02.00
H117.1616.02.16	16	16	125	16	-	0°	A	-	16	S117.0016.02.00
H117.2020.02.16	20	20	150	20	-	0°	B	14	16	S117.0016.02.00
H117.1616.02.20	16	16	125	16	26	0°	C	33	20	S117.0020.02.00
H117.2020.02.20	20	20	150	20	-	0°	A	-	20	S117.0020.02.00
H117.2525.02.20	25	25	150	25	-	0°	B	19	20	S117.0020.02.00
H117.2020.02.26	20	20	150	20	-	0°	C	33	26	S117.0026.02.00
H117.2525.02.26	25	25	150	25	-	0°	A	-	26	S117.0026.02.00

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...10/12	4.09T15P	T15PQ
H117...16	5.12T20P	T20PQ
H117...20/26	6.17 T20P	T20PQ

仿形加工 (外圆)

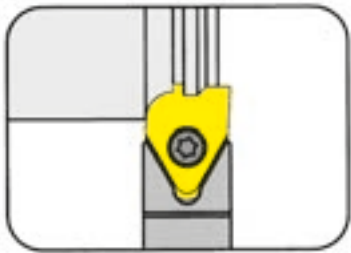
Profiling (external)



B

刀片
Insert

S117



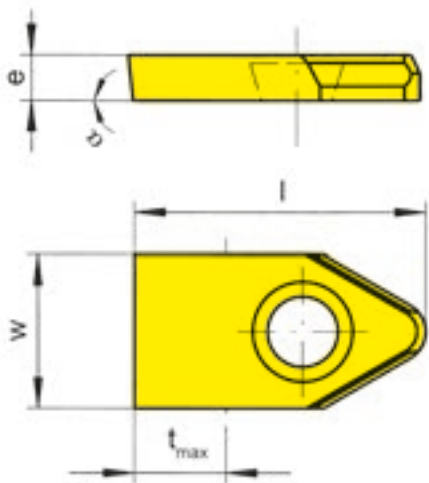
轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

13 mm
26 mm

配合刀杆
for Toolholder

型号 H117
Type SH117



产品型号 Part number	w	e	t _{max}	l	α	刀杆 Toolholder	MG12
S117.0010.02.00	10	3.0	6.5	19	0°	H117...02.10	▲
S117.0012.02.00	12	4.5	7.5	20	0°	H117...02.12	▲
S117.0016.02.00	16	6.0	9.0	24	0°	H117...02.16	▲
S117.0020.02.00	20	7.0	12.0	32	0°	H117...02.20	▲
S117.0026.02.00	26	7.0	13.0	35	0°	H117...02.26	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

按需提供更多尺寸

Further sizes upon request

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

尺寸单位 : mm
Dimensions in mm



根据客户要求生产的各种仿形刀片
Profile inserts upon request.

仿形加工 (外圆)

Profiling (external)



B

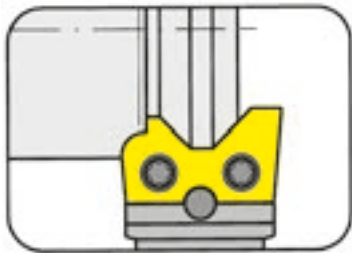
刀杆
Toolholder

H117

轮廓深度
轮廓宽度可达

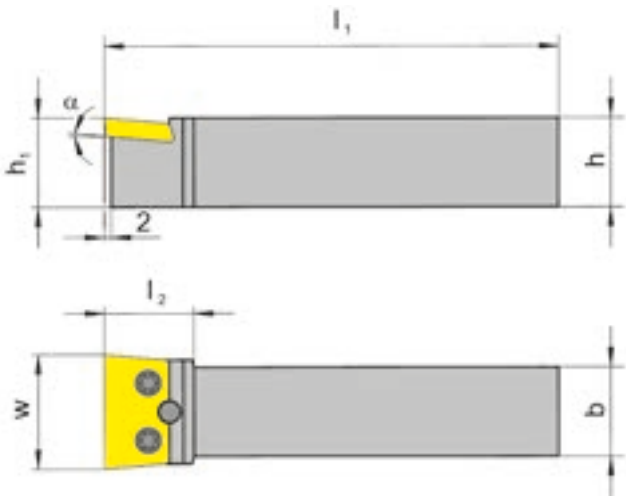
Depth of form up to
Width of form up to

6.5 mm
45 mm



配合刀片
for Insert

型号 S117
Type



产品型号 Part number	h	b	l_1	h_1	α	l_2	w	刀片 Insert
H117.2020.32	20	20	150	20	5°	25	32	S117.0032.00
H117.2525.32	25	25	150	25	5°	25	32	S117.0032.00
H117.2525.45	25	25	150	25	5°	27	45	S117.0045.00
H117.3232.45	32	32	170	32	5°	27	45	S117.0045.00

按需提供更多角度

Further angles upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117...	5.12T20P	T20PQ

仿形加工 (外圆)

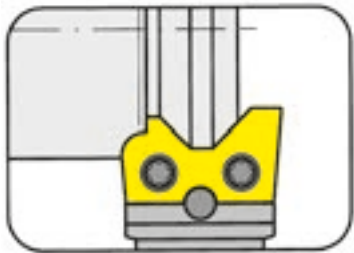
Profiling (external)



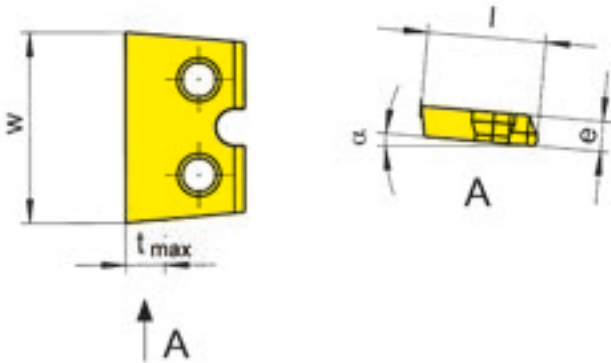
B

刀片
Insert

S117



轮廓深度 轮廓宽度可达	Depth of form up to Width of form up to	6.5 mm 45 mm



配合刀杆
for Toolholder

型号 H117
Type

产品型号 Part number	w	e	t _{max}	l	α	刀杆 Toolholder	MG12
S117.0032.00	32	5	6.5	19.7	5°	H117...32	▲
S117.0045.00	45	5	6.5	19.7	5°	H117...45	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

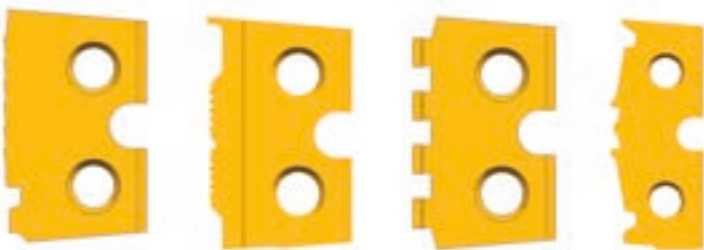
钎焊/金属陶瓷 / brazed/Cermet

按需提供更多尺寸

Further sizes upon request

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

尺寸单位 : mm
Dimensions in mm



根据客户要求生产的各种仿形刀片
Profile inserts upon request.

仿形加工 (外圆)

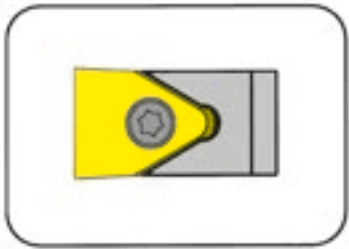
Profiling (external)



B

刀杆
Toolholder

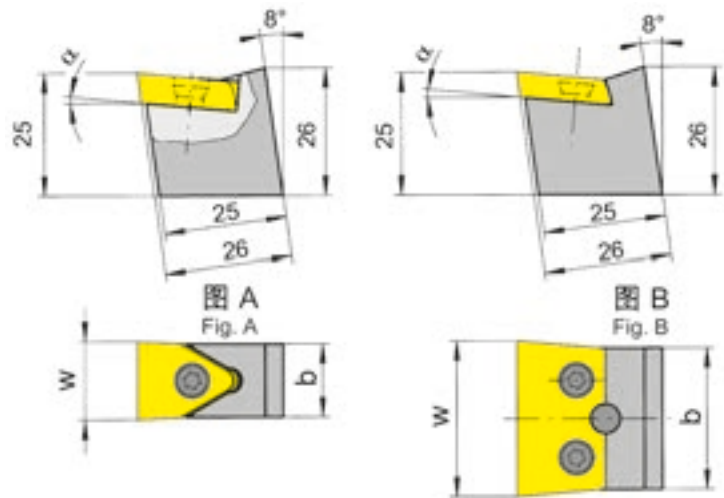
H117



轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

6.5 mm
45 mm



配合刀片
for Insert

型号 S117
Type

适用于PWP-系列
with PWP-System

产品型号 Part number	b	α	形式 Figur	w	刀片 Insert
H117.PWP.10	10	5°	A	10	S117.0010.00
H117.PWP.12	12	5°	A	12	S117.0012.00
H117.PWP.16	16	5°	A	16	S117.0014/16.00
H117.PWP.32	28	5°	B	32	S117.0032.00
H117.PWP.45	42	5°	B	45	S117.0045.00

按需提供更多角度

Further angles upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117.PWP.10	4.09T15P	T15PL
H117.PWP.12	4.09T15P	T15PQ
H117.PWP...	5.12T20P	T20PQ

仿形加工 (外圆)

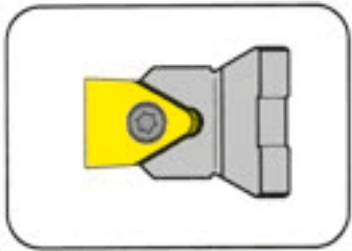
Profiling (external)



B

刀杆
Toolholder

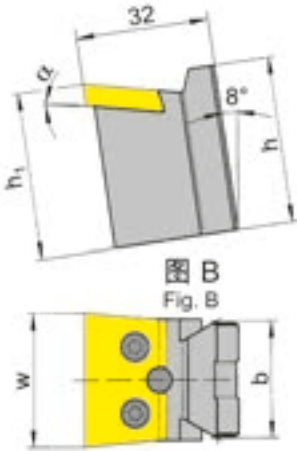
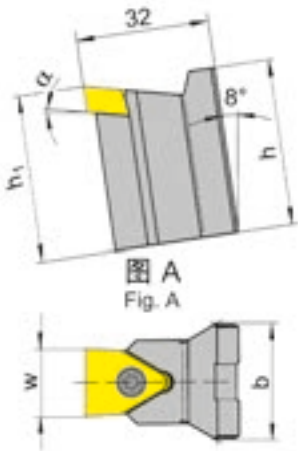
H117



轮廓深度
轮廓宽度可达

Depth of form up to
Width of form up to

10 mm
45 mm



配合刀片
for Insert

型号 S117
Type

适用于AWN-系列
with AWN-System

产品型号 Part number	h	b	l ₁	h ₁	t _{max}	α	形式 Figur	w	刀片 Insert
H117.AW20.10	36	20	32	40	3.5	5°	A	10	S117.0010.00
H117.AW28.10	36	28	32	40	3.5	5°	A	10	S117.0010.00
H117.AW20.12	36	20	32	40	4.5	5°	A	12	S117.0012.00
H117.AW28.12	36	28	32	40	4.5	5°	A	12	S117.0012.00
H117.AW20.16	36	20	32	40	6.5	5°	A	16	S117.0014/16.00
H117.AW28.16	36	28	32	40	6.5	5°	A	16	S117.0014/16.00
H117.AW28.20	36	28	32	40	9.0	5°	A	20	S117.0018/20.00
H117.AW28.26	36	28	35	40	10.0	5°	A	26	S117.0026.00
H117.AW28.32	36	28	32	40	6.5	5°	B	32	S117.0032.00
H117.AW40.45	50	40	32	50	6.5	5°	B	45	S117.0045.00

按需提供更多角度
Further angles upon request

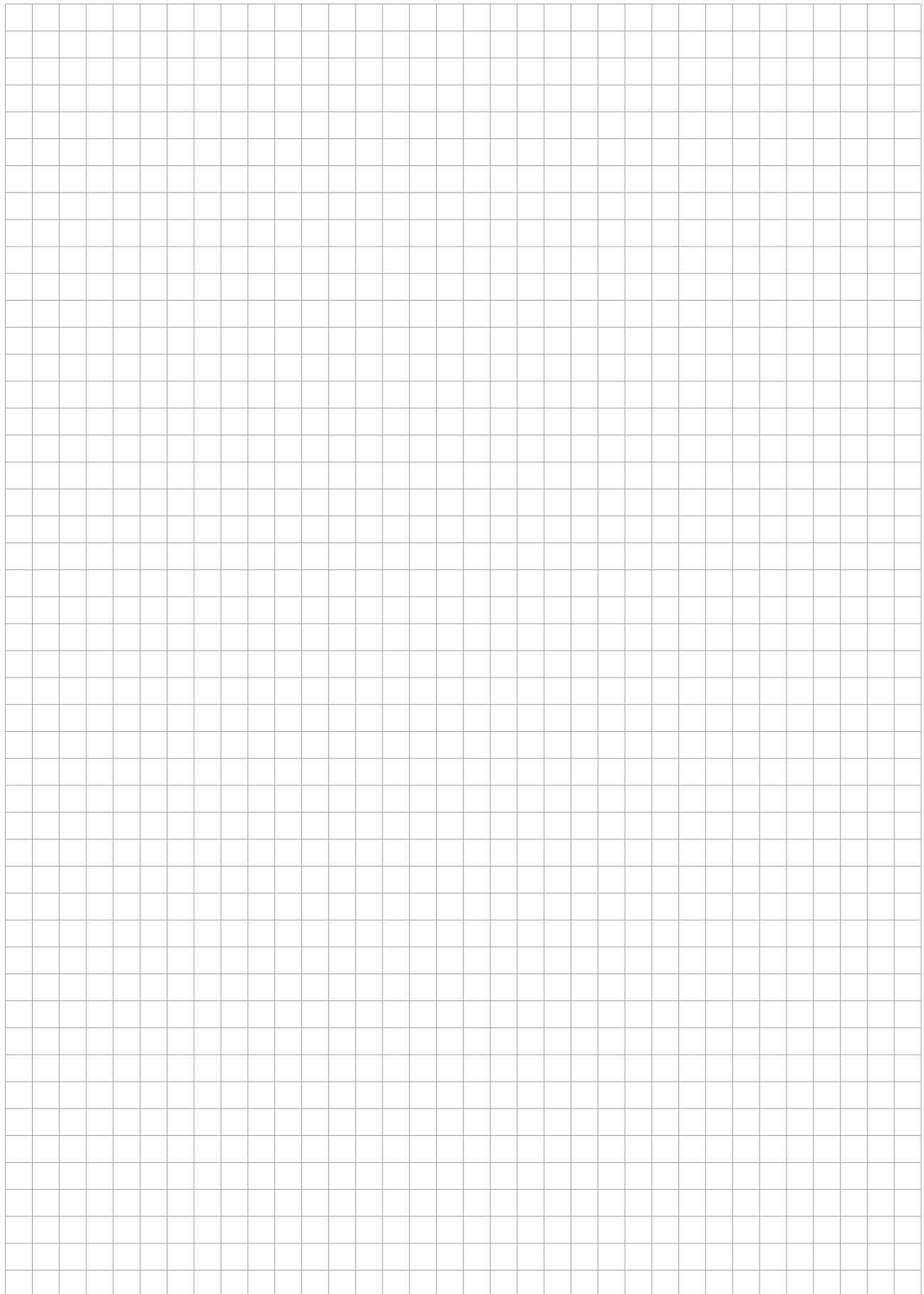
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H117.AW2...10/12	4.09T15P	T15PQ
H117.AW...16/32/45	5.12T20P	T20PQ
H117.AW28.20/26	6.17 T20P	T20PQ

B





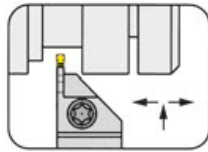
机夹式刀杆

槽宽 1.1 - 3 mm

Toolholder with Inserts

Width of groove 1.1 - 3 mm

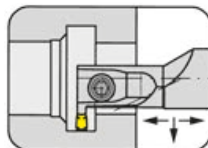
刀杆
Toolholder
H223/B119/B223



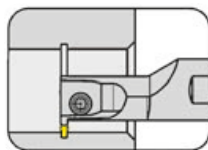
页/Page
C3



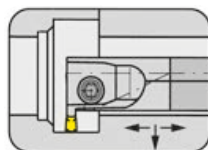
页/Page
C4



页/Page
C6-C8

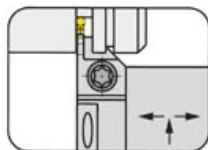


页/Page
C9



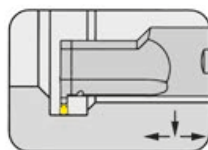
页/Page
C10

刀夹
Cartridge
E223



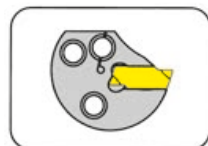
页/Page

常规刀柄
Basic toolholder
B223



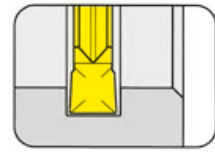
页/Page
C11

刀夹
Cassette
BK223

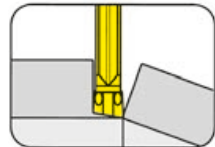


页/Page
C12

刀片
Insert
S119/S123

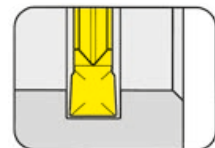


页/Page
C13

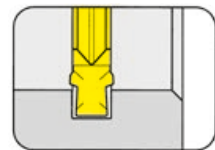


页/Page
C14-C15

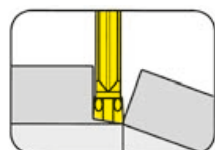
可转位刀片
Indexable insert
S223



页/Page
C16. C18-C19



页/Page
C17



页/Page
C20-C21

切槽和侧车削 (外圆)

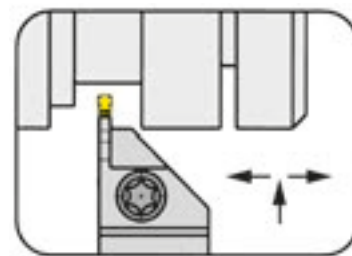
Grooving and Side Turning (external)



刀杆

Toolholder

H223

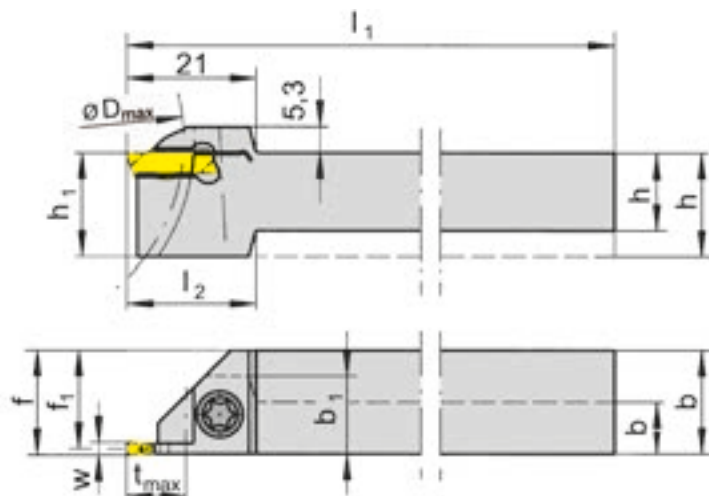


C

槽深可达
夹持范围

Depth of groove up to
Clamping range

10 mm
2-3 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合刀片
for Insert

型号 S123
Type S223

产品型号 Part number	h	b	l ₁	l ₂	h ₁	b ₁	f ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH223.1010.01	10	10	80	20	12	12	9.20	f ₁ +w/2	8	25	01	2.0
R/LH223.1212.01	12	12	100	21	16	-	11.20	f ₁ +w/2	10	50	01	2.0
R/LH223.1616.01	16	16	125	-	16	-	15.20	f ₁ +w/2	10	50	01	2.0
R/LH223.2020.01	20	20	125	-	20	-	19.20	f ₁ +w/2	10	50	01	2.0
R/LH223.2525.01	25	25	150	-	25	-	24.20	f ₁ +w/2	10	50	01	2.0
R/LH223.1010.02	10	10	80	20	12	12	9.05	f ₁ +w/2	8	25	02	2.5
R/LH223.1212.02	12	12	100	21	16	-	11.05	f ₁ +w/2	10	50	02	2.5
R/LH223.1616.02	16	16	125	-	16	-	15.05	f ₁ +w/2	10	50	02	2.5
R/LH223.2020.02	20	20	125	-	20	-	19.05	f ₁ +w/2	10	50	02	2.5
R/LH223.2525.02	25	25	150	-	25	-	24.05	f ₁ +w/2	10	50	02	2.5
R/LH223.1010.03	10	10	80	20	12	12	8.80	f ₁ +w/2	8	25	03	3.0
R/LH223.1212.03	12	12	100	21	16	-	10.80	f ₁ +w/2	10	50	03	3.0
R/LH223.1616.03	16	16	125	-	16	-	14.80	f ₁ +w/2	10	50	03	3.0
R/LH223.2020.03	20	20	125	-	20	-	18.80	f ₁ +w/2	10	50	03	3.0
R/LH223.2525.03	25	25	150	-	25	-	23.80	f ₁ +w/2	10	50	03	3.0

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H223
加强型
reinforced version



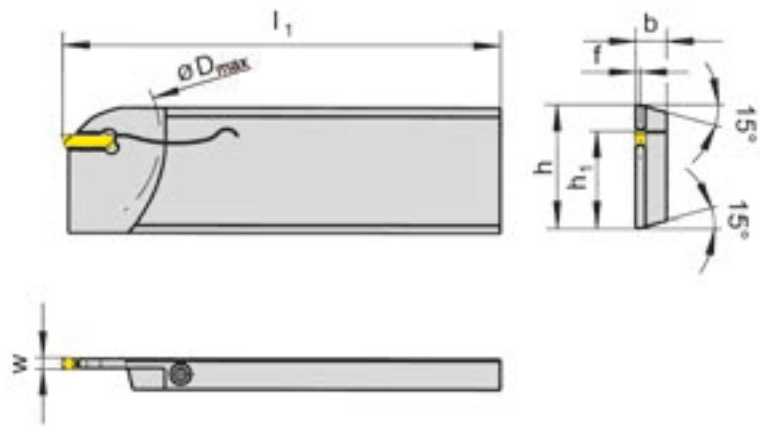
槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
2-3 mm

配合刀片
for Insert

型号 S123
Type S223



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH223.2608.01	26	7.9	110	21.4	0.80	50	01	2.0
R/LH223.3208.01	32	7.9	110	24.8	0.80	50	01	2.0
R/LH223.2608.02	26	7.9	110	21.4	0.95	50	02	2.5
R/LH223.3208.02	32	7.9	110	24.8	0.95	50	02	2.5
R/LH223.2608.03	26	7.9	110	21.4	1.20	50	03	3.0
R/LH223.3208.03	32	7.9	110	24.8	1.20	50	03	3.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

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

切槽和侧车削 (外圆)

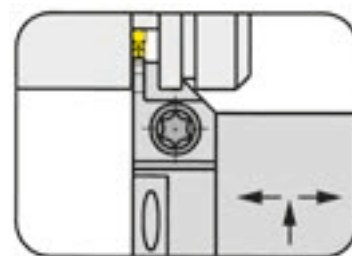
Grooving and Side Turning (external)



刀夹

Cartridge

E223

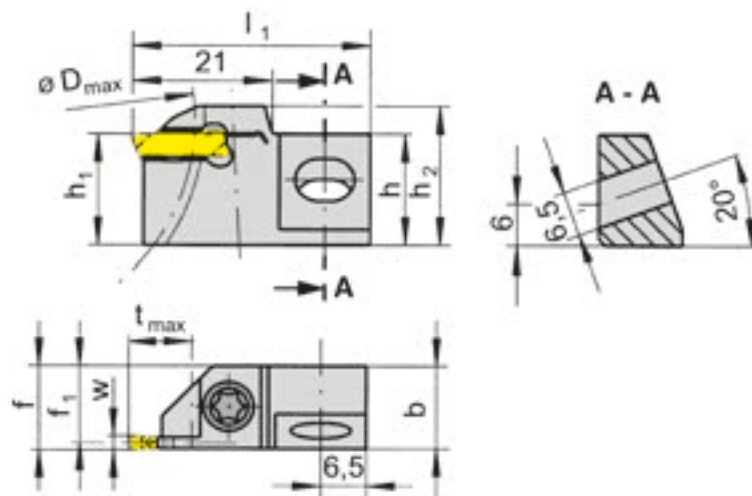


C

槽深可达
夹持范围

Depth of groove up to
Clamping range

10 mm
2-3 mm



配合刀片
for Insert

型号 S123
Type S223

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

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

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)

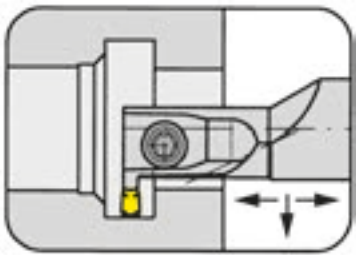


刀杆

Toolholder

B119

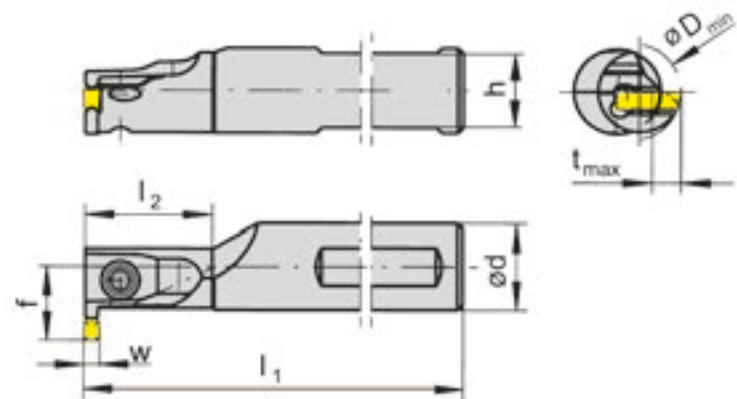
直接冷却液供应
with through coolant supply



孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

16 mm
3 mm
2-3 mm



配合刀片
for Insert

型号 S119
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB119.0016.1.32	16	110	25	14	11.8	3	16	02	2.00-2.99
R/LB119.0016.1.33	16	110	25	14	11.8	3	16	03	3.00-3.00

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位 : mm
Dimensions in mm

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

配件

Spare Parts

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

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)

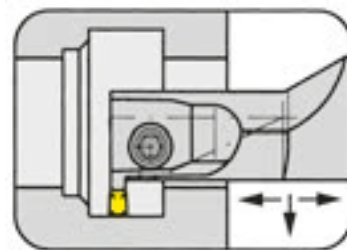


刀杆

Toolholder

B223

直接冷却液供应
with through coolant supply



C

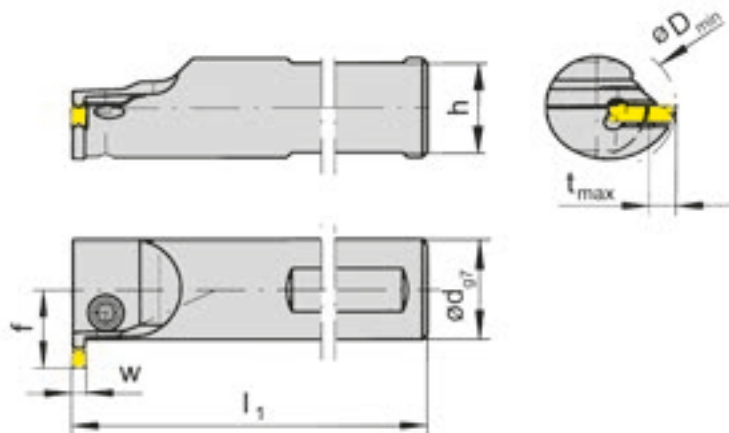
孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

22 mm
6.3 mm
2-3 mm

配合可转位刀片
for Indexable insert

型号 S223
Type S123



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB223.0016.0.42	16	110	14	13.0	4.5	22	02	2.00-2.99
R/LB223.0020.0.52	20	120	18	15.7	5.3	27	02	2.00-2.99
R/LB223.0025.0.62	25	150	23	19.3	6.3	33	02	2.00-2.99
R/LB223.0016.0.43	16	110	14	13.0	4.5	22	03	3.00-3.00
R/LB223.0020.0.53	20	120	18	15.7	5.3	27	03	3.00-3.00
R/LB223.0025.0.63	25	150	23	19.3	6.3	33	03	3.00-3.00

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB223.0...	5.11T15P	T15PL
R/LB223.0025.0.63	5.11T15P	T15PQ

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)

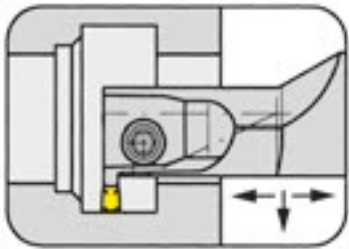


刀杆

Toolholder

B223

直接冷却液供应
with through coolant supply



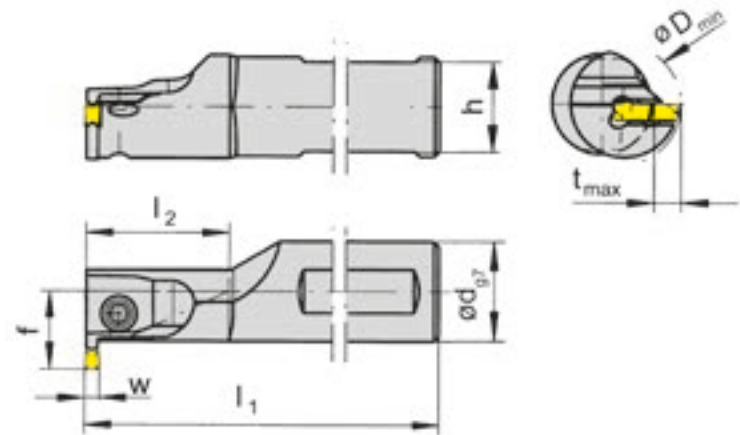
孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

18 mm
6.3 mm
2-3 mm

配合可转位刀片
for Indexable insert

型号 S223
Type S123



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB223.0016.1.42	16	110	25	14	13.0	4.5	18	02	2.00-2.99
R/LB223.0020.1.52	20	120	30	18	15.7	5.3	20	02	2.00-2.99
R/LB223.0025.1.62	25	150	50	23	18.8	6.3	25	02	2.00-2.99
R/LB223.0016.1.43	16	110	25	14	13.0	4.5	18	03	3.00-3.00
R/LB223.0020.1.53	20	120	30	18	15.7	5.3	20	03	3.00-3.00
R/LB223.0025.1.63	25	150	50	23	18.8	6.3	25	03	3.00-3.00

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

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

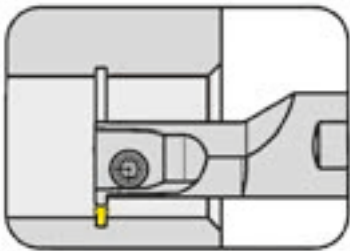
切槽 (内圆)
Grooving (internal)



刀杆
Toolholder

B223

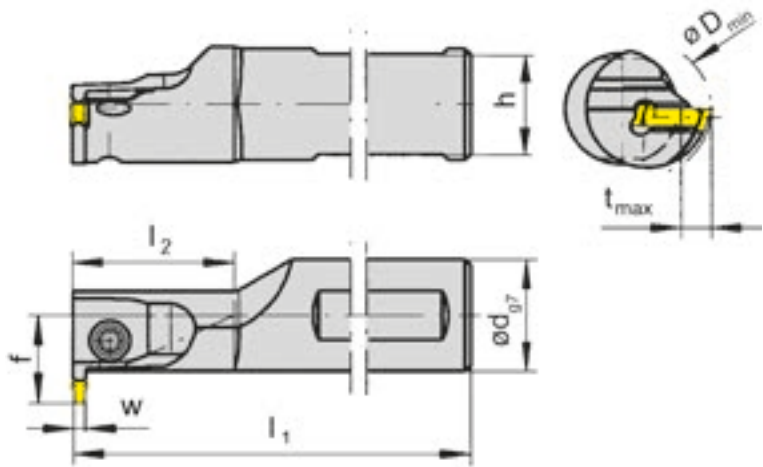
直接冷却液供应
with through coolant supply



孔径Ø 自 卡簧槽 夹持范围	Bore Ø from Circlip grooves Clamping range	18 mm DIN 471/472 2-2.9 mm

配合可转位刀片
for Indexable insert

型号 S223
Type S123



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB223.0016.1.22	16	110	25	14	13.0	1.65	18	02	2.00-2.99
R/LB223.0020.1.22	20	120	30	18	15.7	1.65	20	02	2.00-2.99

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

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

配件
Spare Parts

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

切槽和侧车削 (内圆)

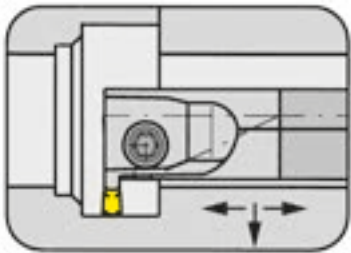
Grooving and Side Turning (internal)



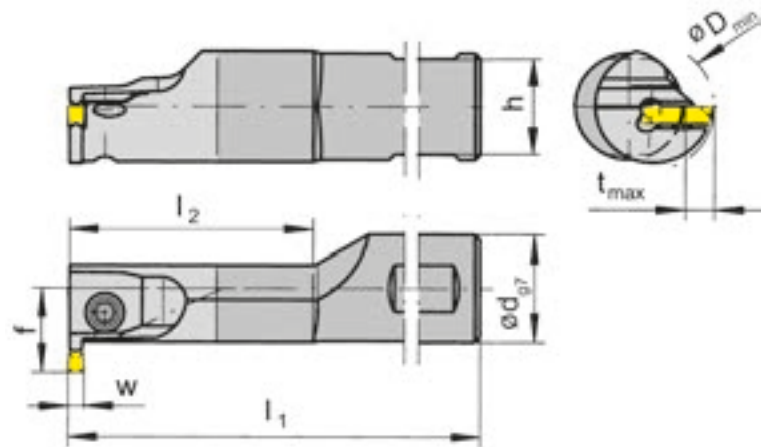
刀杆

Toolholder

B223
直接冷却液供应
with through coolant supply



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	18 mm 6.3 mm 2-3 mm



配合可转位刀片
for Indexable insert

型号 S223
Type S123

硬质合金刀杆
Carbide shank

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB223.HM16.2.42	16	130	50	14	13.0	4.5	18	02	2.00-2.99
R/LB223.HM20.2.52	20	150	60	18	15.7	5.3	20	02	2.00-2.99
R/LB223.HM25.2.62	25	160	70	23	18.8	6.3	25	02	2.00-2.99
R/LB223.HM16.2.43	16	130	50	14	13.0	4.5	18	03	3.00-3.00
R/LB223.HM20.2.53	20	150	60	18	15.7	5.3	20	03	3.00-3.00
R/LB223.HM25.2.63	25	160	70	23	18.8	6.3	25	03	3.00-3.00

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

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

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



常规刀柄

Basic toolholder

B223

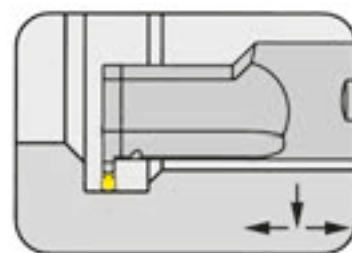
无刀夹
without cassette

孔径
槽深可达
槽宽

Bore Ø
Depth of groove up to
Width of groove

28,0 mm
6.3 mm
2-3 mm

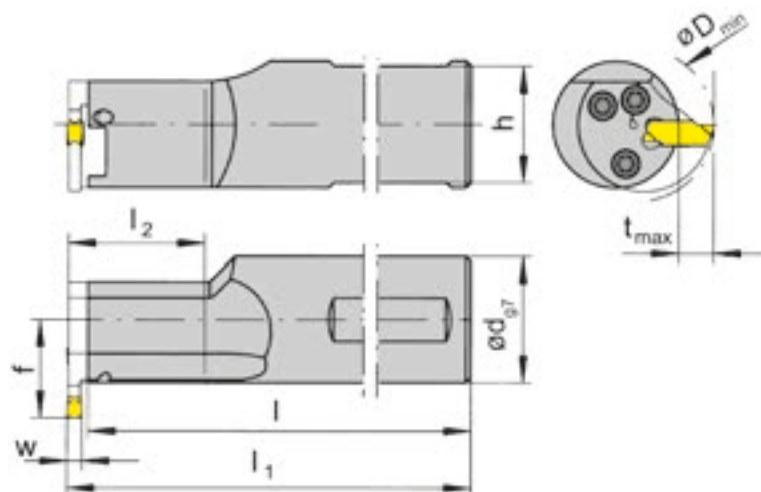
直接冷却液供应
with through coolant supply



C

配合刀夹
for Cassette

Typ BK223
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	d	l	l_2	h	f
R/LB223.0025.1.K2	$l+b_1+w/2$	25	116.1	30	23	19.5
R/LB223.0025.2.K2	$l+b_1+w/2$	25	146.1	60	23	19.5
R/LB223.0032.1.K2	$l+b_1+w/2$	32	146.1	30	30	23.0
R/LB223.0032.2.K2	$l+b_1+w/2$	32	176.1	60	30	23.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：

D_{min} , t_{max} , w和 b_1 尺寸，见刀夹

Note:

Dimensions for D_{min} , t_{max} and b_1 see cassettes

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB223...	4.09T15P	T15PL

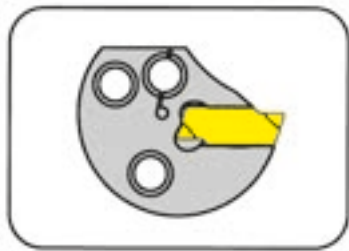
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀夹
Cassette

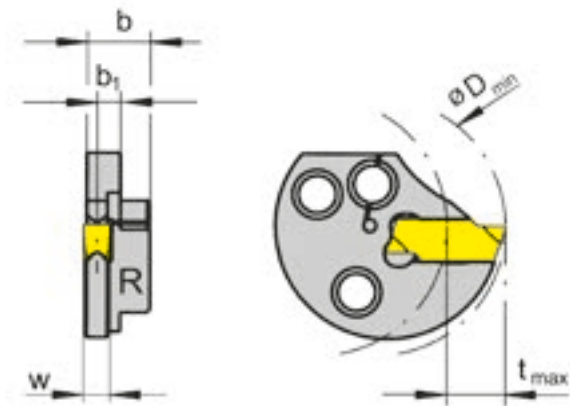
BK223



孔径
槽深可达
夹持范围

Bore $\varnothing$
Depth of groove up to
Clamping range

28 mm
6.3 mm
2-3 mm



配合可转位刀片
for Indexable insert

型号 S223
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	D_{min}	t_{max}	b	b_1	尺寸规格 Size	夹持范围 Clamping range
R/LBK223.0028.01	28	6.3	7.4	3.10	01	2.0-2.0
R/LBK223.0028.02	28	6.3	7.4	2.95	02	2.5-2.5
R/LBK223.0028.03	28	6.3	7.4	2.70	03	3.0-3.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

配件
锁紧螺钉包含在刀杆内,不需要单独订购

Spare Parts
The fastening screw is combined with the basic toolholder - no seperate order required.

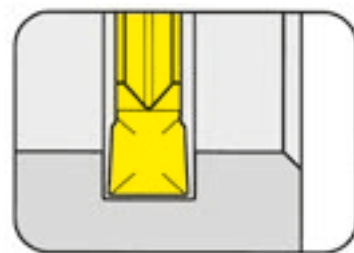
切槽和侧车削

Grooving and Side Turning

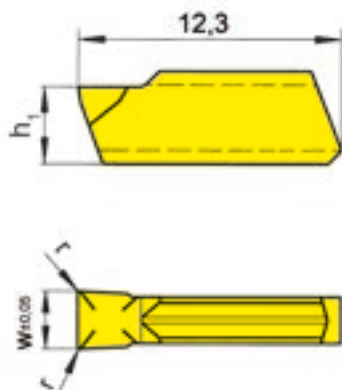


刀片
Insert

S119



槽深可达 槽宽	Depth of groove up to Width of groove	3 mm 2-3 mm



配合刀杆
for Toolholder

型号 B119
Type

产品型号 Part number	w	r	h ₁	尺寸规格 Size	TN35
S119.0200.32	2.0	0.2	3.65	02	▲
S119.0250.32	2.5	0.2	3.75	02	▲
S119.0300.32	3.0	0.2	3.95	03	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

切槽和切断

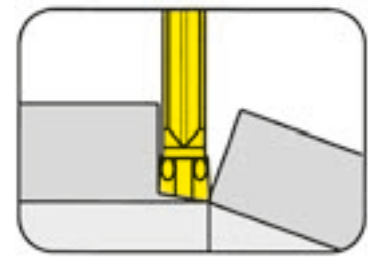
Grooving and Parting Off



刀片

Insert

S123



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2-3 mm

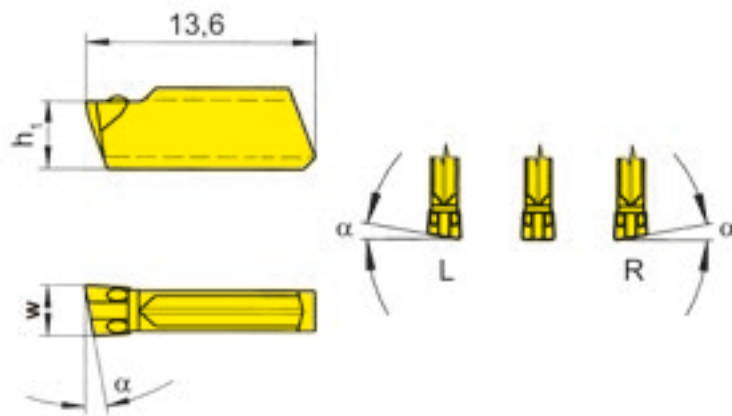
配合刀杆

for Toolholder

型号

H223

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	h_1	尺寸规格 Size	TF45	TI25	TN35
S123.0020.C0	2	0°	3.65	01	Δ	Δ	Δ
R/LS123.0420.C0	2	4°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0820.C0	2	8°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.1520.C0	2	15°	3.65	01	▲/Δ	Δ/Δ	Δ/Δ
S123.0030.C0	3	0°	3.95	03	Δ	Δ	Δ
R/LS123.0430.C0	3	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0830.C0	3	8°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



刀片

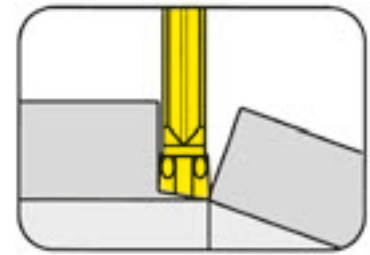
Insert

S123

槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2-3 mm



C

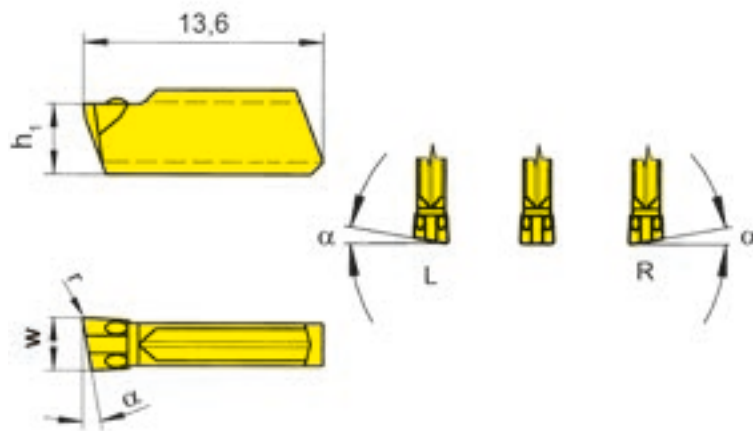
配合刀杆

for Toolholder

型号

H223

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	h ₁	尺寸规格 Size	TF45	T125	TN35
S123.0020.C1	2	0.15	0°	3.65	01	Δ	Δ	Δ
R/LS123.0420.C1	2	0.15	4°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0820.C1	2	0.15	8°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.1520.C1	2	0.15	15°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
S123.0030.C1	3	0.15	0°	3.95	03	Δ	Δ	Δ
R/LS123.0430.C1	3	0.15	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0830.C1	3	0.15	8°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

切槽和侧车削

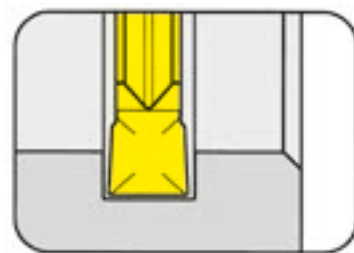
Grooving and Side Turning



可转位刀片

Indexable insert

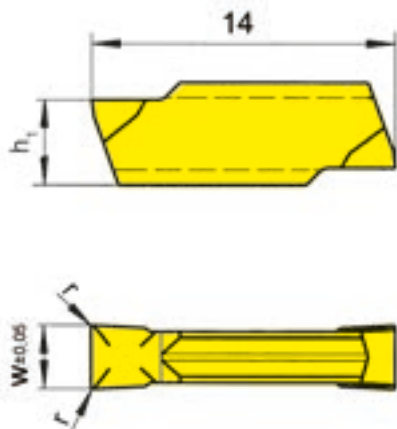
S223



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm



配合刀杆
for Toolholder

型号 H223
Type E223
B223
BK223

产品型号 Part number	w	r	h ₁	尺寸规格 Size		MG12	H54	TI25	TN35
S223.0200.32	2.0	0.2	3.65	01		▲	▲	▲	▲
S223.0250.32	2.5	0.2	3.75	02		▲	▲	▲	▲
S223.0300.32	3.0	0.2	3.95	03		▲	▲	▲	▲
					P	○	●	●	●
					M	-	●	●	●
					K	-	-	●	●
					N	-	-	●	●
					S	-	-	●	●
					H	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽

Grooving



可转位刀片

Indexable insert

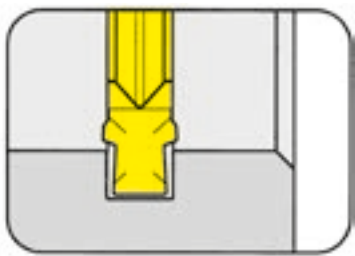
S223

切削深度受限
limited depth of cut

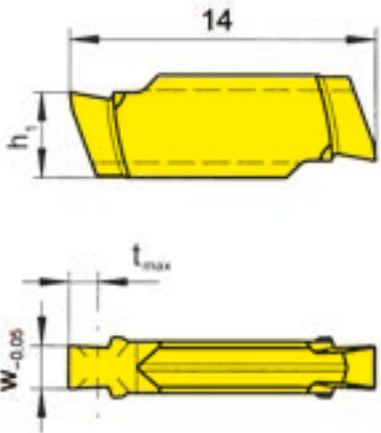
卡簧槽
卡簧宽度Nw

Circlip grooves
Width of circlip Nw

DIN 471/472
1.1-2.15 mm



C



配合刀杆
for Toolholder

型号 H223
Type E223
B223...1.22

产品型号 Part number	w	Nw	t _{max}	h ₁	尺寸规格 Size	TN35
S223.0110.32	1.24	1.10	0.60	3.75	02	▲
S223.0130.32	1.44	1.30	1.10	3.75	02	▲
S223.0160.32	1.74	1.60	1.15	3.75	02	▲
S223.0185.32	1.99	1.85	1.40	3.75	02	▲
S223.0215.32	2.29	2.15	1.65	3.75	02	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

切槽和侧车削

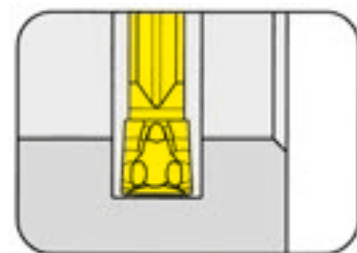
Grooving and Side Turning



可转位刀片

Indexable insert

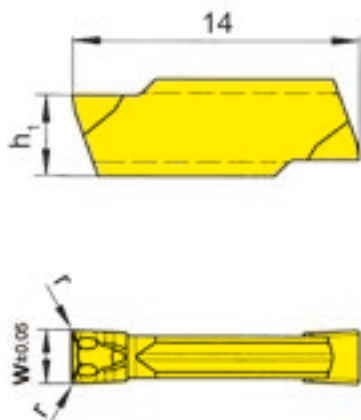
S223



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm



配合刀杆
for Toolholder

型号 H223
Type E223
B223
BK223

产品型号 Part number	w	r	h ₁	尺寸规格 Size	TH35	TI25
S223.0200.52	2.0	0.2	3.65	01	▲	
S223.0250.52	2.5	0.2	3.75	02		▲
S223.0300.52	3.0	0.2	3.95	03	▲	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	TH35	TI25
P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

切槽和侧车削

Grooving and Side Turning

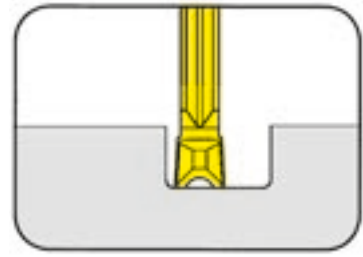


可转位刀片

Indexable insert

S223

帶卷屑器
with chip forming



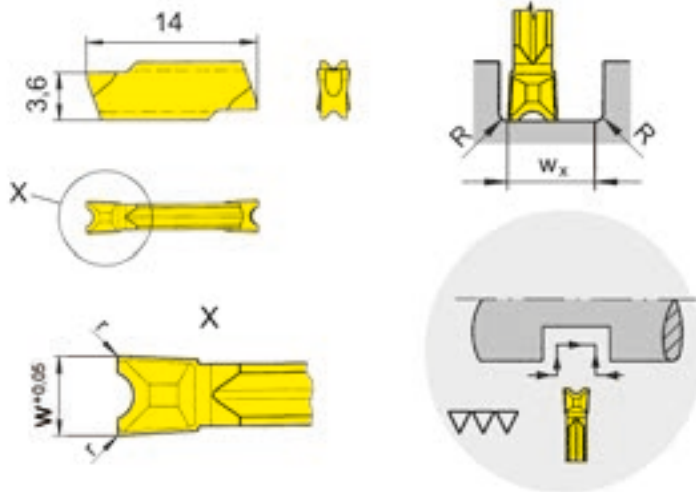
C

槽深可达
槽宽

Depth of groove up to
Width of groove

10 mm
2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号	H223
Type	E223
	B223
	BK223

产品型号 Part number	w	r	t _{max}	w _x	尺寸规格 Size	T125 ▲
S223.NC20.D2	2	0.2	10	2.7	01	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

- 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

$$w_x = \text{槽宽} - R_{(\text{右})} - R_{(\text{左})}$$

w_x = width of groove - $R_{(right)}$ - $R_{(left)}$

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

切槽和切断

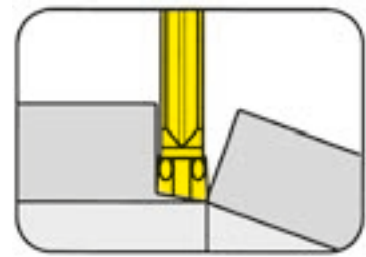
Grooving and Parting Off



可转位刀片

Indexable insert

S223



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm

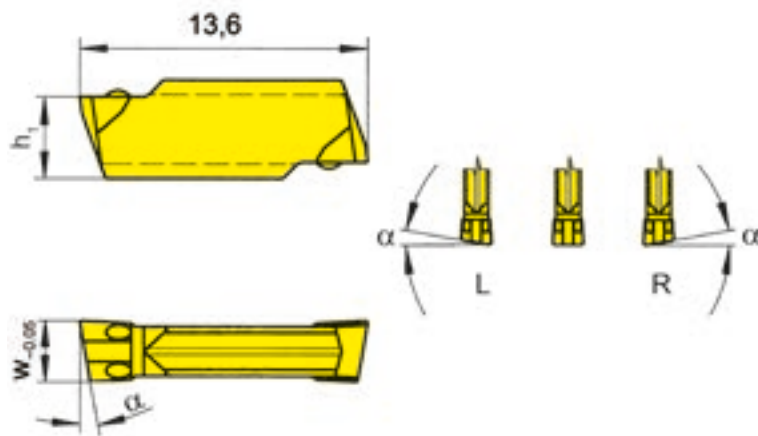
配合刀杆

for Toolholder

型号

H223

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	h ₁	尺寸规格 Size	TF45	T125	TN35
S223.0020.C0	2.0	0°	3.65	01	▲	▲	▲
R/LS223.0420.C0	2.0	4°	3.65	01	Δ/Δ	▲/Δ	▲/▲
R/LS223.0820.C0	2.0	8°	3.65	01	▲/Δ	▲/▲	▲/▲
R/LS223.1520.C0	2.0	15°	3.65	01	▲/Δ	▲/▲	▲/▲
S223.0025.C0	2.5	0°	3.75	02	Δ	▲	Δ
R/LS223.0425.C0	2.5	4°	3.75	02	Δ/Δ	▲/Δ	Δ/Δ
R/LS223.0825.C0	2.5	8°	3.75	02	▲/Δ	▲/Δ	▲/Δ
S223.0030.C0	3.0	0°	3.95	03	Δ	▲	▲
R/LS223.0430.C0	3.0	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS223.0830.C0	3.0	8°	3.95	03	▲/Δ	▲/Δ	▲/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

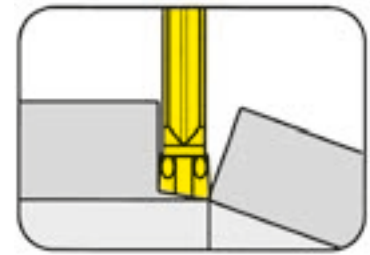
切槽和切断

Grooving and Parting Off



可转位刀片 Indexable insert

S223



C

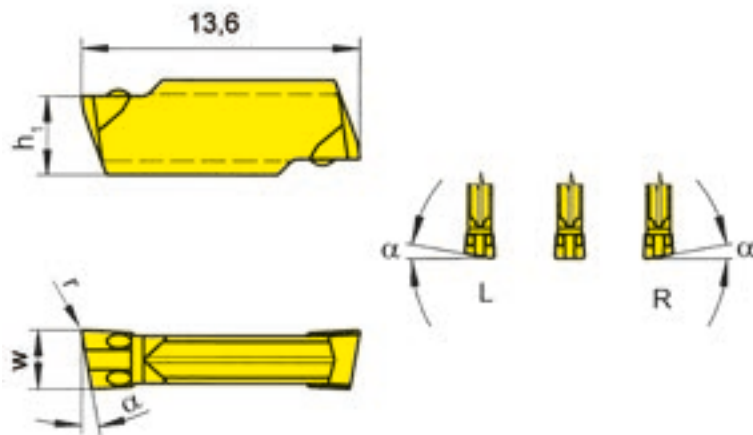
槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm

配合刀杆
for Toolholder

型号 H223
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	α	h ₁	尺寸规格 Size	TF45	Tl25	TN35
S223.0020.C1	2.0	0.15	0°	3.65	01	▲	▲	▲
R/LS223.0420.C1	2.0	0.15	4°	3.65	01	Δ/Δ	Δ/Δ	▲/▲
R/LS223.0820.C1	2.0	0.15	8°	3.65	01	▲/Δ	▲/Δ	▲/Δ
R/LS223.1520.C1	2.0	0.15	15°	3.65	01	▲/Δ	Δ/Δ	▲/Δ
S223.0025.C1	2.5	0.15	0°	3.75	02	Δ	▲	Δ
R/LS223.0425.C1	2.5	0.15	4°	3.75	02	Δ/Δ	Δ/Δ	Δ/Δ
R/LS223.0825.C1	2.5	0.15	8°	3.75	02	Δ/Δ	▲/Δ	Δ/Δ
S223.0030.C1	3.0	0.15	0°	3.95	03	▲	▲	▲
R/LS223.0430.C1	3.0	0.15	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS223.0830.C1	3.0	0.15	8°	3.95	03	▲/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

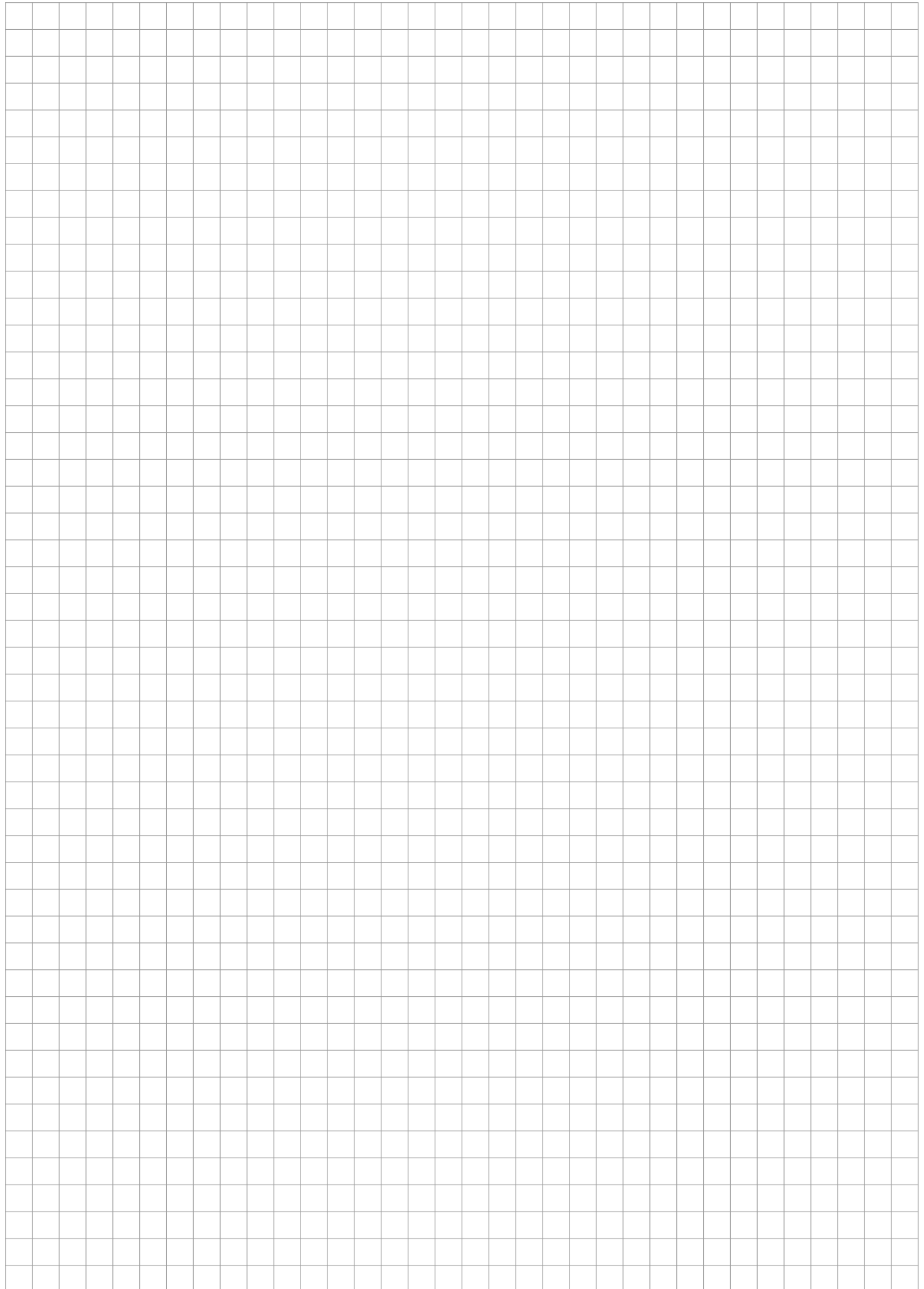
此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

C





D

机夹式刀杆

槽宽 2 - 3 mm

Toolholder with Inserts

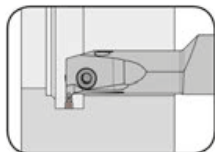
Width of groove 2 - 3 mm

切槽和侧车削

Grooving and Side Turning

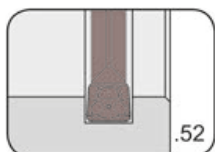


刀杆
Toolholder
B209



页/Page
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可转位刀片
Indexable insert
S209



页/Page
D4-D6

D

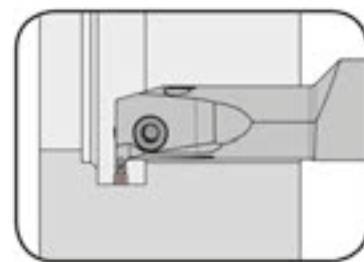
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

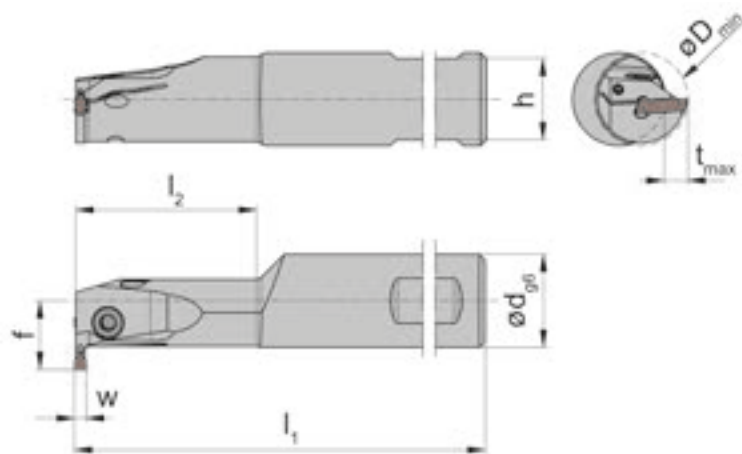
B209



孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

16 mm
5 mm
3 mm



配合可转位刀片
for Indexable insert

型号 S209
Type

D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB209.0016.1.02.IK	16	110	30	14	11.8	3.5	16	20	2.0-2.4
R/LB209.0020.1.12.IK	20	110	30	18	15.3	5.0	18	20	2.0-2.4
R/LB209.0016.1.025.IK	16	110	30	14	11.8	3.5	16	25	2.5-3.0
R/LB209.0020.1.125.IK	20	110	30	18	15.3	5.0	18	25	2.5-3.0
R/LB209.0016.1.03.IK	16	110	30	14	11.8	3.5	16	30	3.0-3.0
R/LB209.0020.1.13.IK	20	110	30	18	15.3	5.0	18	30	3.0-3.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB209...	3.5.12T10EP	T10PL

切槽和侧车削

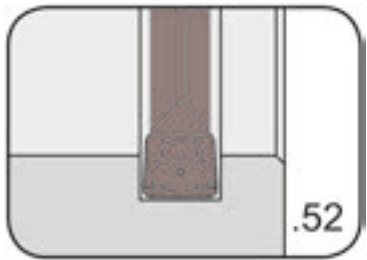
Grooving and Side Turning



可转位刀片

Indexable insert

S209
带卷屑器
with chip forming

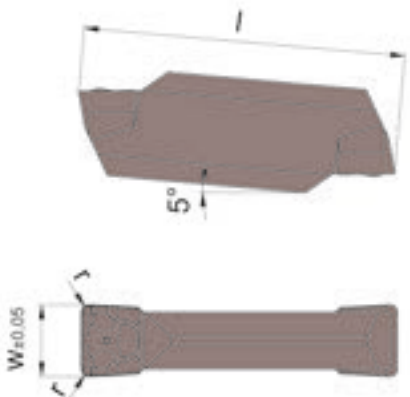


槽宽	Width of groove	2-3 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B209
Type



刀片长度重复定位精度
 $\pm 0.05 \text{ mm}$
Indexability length $\pm 0.05 \text{ mm}$

产品型号 Part number	w	r	l	尺寸规格 Size	AS45
S209.0200.52	2.0	0.2	9	20	▲
S209.0250.52	2.5	0.2	10	25	▲
S209.0300.52	3.0	0.2	10	30	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

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

硬质合金牌号
Carbide grades

切槽和侧车削

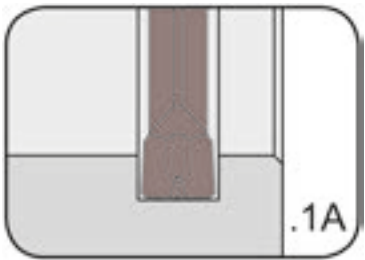
Grooving and Side Turning



可转位刀片

Indexable insert

S209
带卷屑器
with chip forming

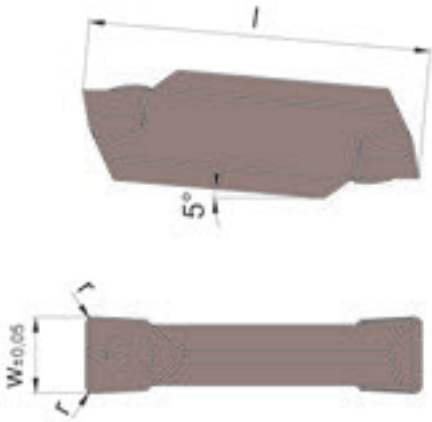


槽宽	Width of groove	2-3 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B209
Type



刀片长度重复定位精度
 $\pm 0.05 \text{ mm}$
Indexability length $\pm 0.05 \text{ mm}$

产品型号 Part number	w	r	l	尺寸规格 Size	AS45
S209.0200.1A2	2.0	0.2	9	20	▲
S209.0250.1A2	2.5	0.2	10	25	△
S209.0300.1A2	3.0	0.2	10	30	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

P	●
M	●
K	●
N	○
S	●
H	-

切槽和侧车削

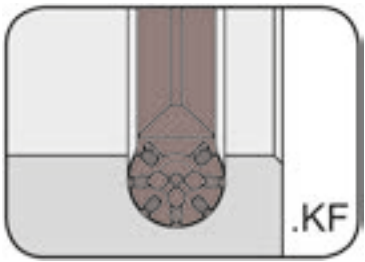
Grooving and Side Turning



可转位刀片

Indexable insert

S209
带卷屑器
with chip forming



槽宽
圆头

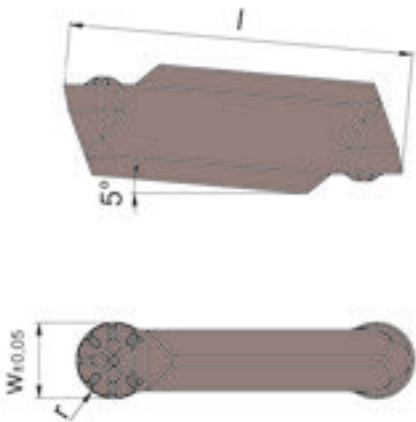
Width of groove
Full radius

2-3 mm
1-1.5 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B209
Type



刀片长度重复定位精度
 $\pm 0.05 \text{ mm}$
Indexability length $\pm 0.05 \text{ mm}$

产品型号 Part number	w	l	r	尺寸规格 Size	AS45
S209.0010.KF2	2	9	1.0	20	▲
S209.0015.KF3	3	10	1.5	30	▲
					P •
					M •
					K •
					N ○
					S •
					H -

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
○ 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

硬质合金牌号
Carbide grades



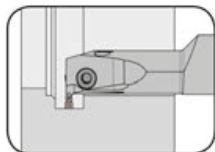
机夹式刀杆

槽宽2 - 6 mm

Toolholder with Inserts

Width of groove 2 - 6 mm

刀杆
Toolholder
B216

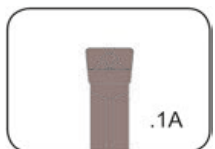


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可转位刀片
Indexable insert
S216



页/Page
E4-E6



页/Page
E5



页/Page
E6

E

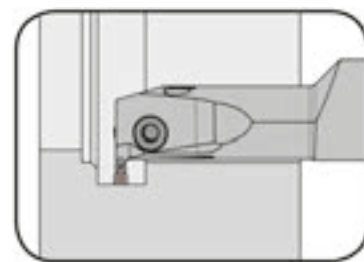
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

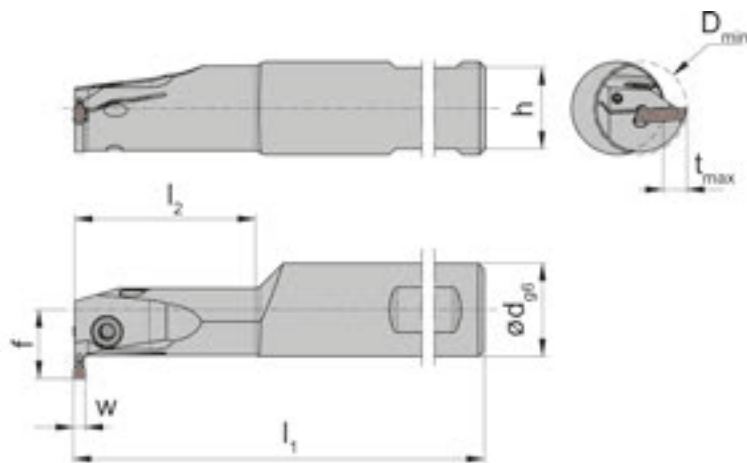
B216



孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

20 mm
7.5 mm
2-6,1 mm



配合可转位刀片
for Indexable insert

型号 S216
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	l ₂	h	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/LB216.0020.1.22.IK	20	110	30	18	16.3	6.0	20	20	2.0-2.4
R/LB216.0020.1.225.IK	20	110	30	18	16.3	6.0	20	25	2.4-2.8
R/LB216.0020.1.23.IK	20	110	30	18	16.3	6.0	20	30	2.8-3.7
R/LB216.0020.1.24.IK	20	110	30	18	16.3	6.0	20	40	3.7-4.4
R/LB216.0025.2.22.IK	25	150	50	23	20.3	7.5	25	20	2.0-2.4
R/LB216.0025.2.225.IK	25	150	50	23	20.3	7.5	25	25	2.4-2.8
R/LB216.0025.2.23.IK	25	150	50	23	20.3	7.5	25	30	2.8-3.7
R/LB216.0025.2.24.IK	25	150	50	23	20.3	7.5	25	40	3.7-4.4
R/LB216.0025.23.1.22.IK	25	150	30	23	19.8	7.0	23	20	2.0-2.4
R/LB216.0025.23.1.225.IK	25	150	30	23	19.8	7.0	23	25	2.4-2.8
R/LB216.0025.23.1.23.IK	25	150	30	23	19.8	7.0	23	30	2.8-3.7
R/LB216.0025.23.1.24.IK	25	150	30	23	19.8	7.0	23	40	3.7-4.4
R/LB216.0025.23.1.25.IK	25	150	30	23	19.8	7.0	23	50	4.4-5.1
R/LB216.0025.23.1.26.IK	25	150	30	23	19.8	7.0	23	60	5.1-6.1

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB216.0020.1.2...IK	3.5.12T10EP	T10PL
R/LB216...IK	5.13T20EP	T20PQ

切槽和侧车削

Grooving and Side Turning

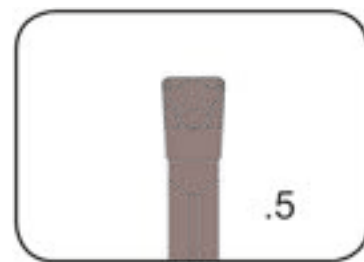


可转位刀片

Indexable insert

S216

带卷屑器
with chip forming

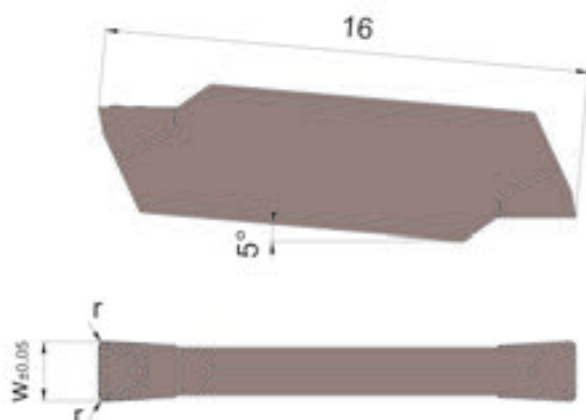


槽宽	Width of groove	2-6 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B216
Type



刀片长度重复定位精度
 $\pm 0,1 \text{ mm}$
Indexability length $\pm 0,1 \text{ mm}$

产品型号 Part number	w	r	尺寸规格 Size	AS45
S216.0200.52	2.0	0.2	20	▲
S216.0250.52	2.5	0.2	25	▲
S216.0300.52	3.0	0.2	30	▲
S216.0400.52	4.0	0.2	40	▲
S216.0500.54	5.0	0.4	50	△
S216.0600.54	6.0	0.4	60	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	•
K	•
N	o
S	•
H	-

硬质合金牌号
Carbide grades

切槽和侧车削

Grooving and Side Turning

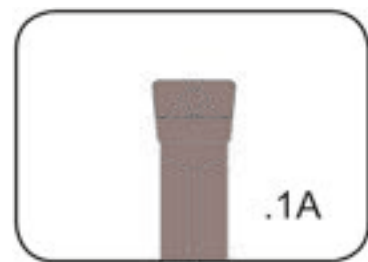


可转位刀片

Indexable insert

S216

带卷屑器
with chip forming



槽宽

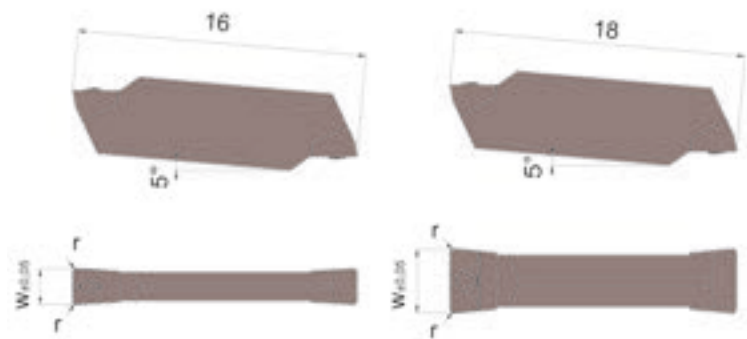
Width of groove

2-6 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B216
Type



槽宽 2 - 4 mm
Width of groove 2 - 4 mm

宽度 5 - 6 mm
Width 5 - 6 mm

刀片长度重复定位精度
 $\pm 0,1$ mm
Indexability length $\pm 0,1$ mm

产品型号 Part number	w	r	尺寸规格 Size	AS45
S216.0200.1A2	2.0	0.2	20	▲
S216.0250.1A2	2.5	0.2	25	△
S216.0300.1A2	3.0	0.2	30	▲
S216.0400.1A2	4.0	0.2	40	▲
S216.0500.1A4	5.0	0.4	50	△
S216.0600.1A4	6.0	0.4	60	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

P	●
M	●
K	●
N	○
S	●
H	-

E

切槽和侧车削

Grooving and Side Turning

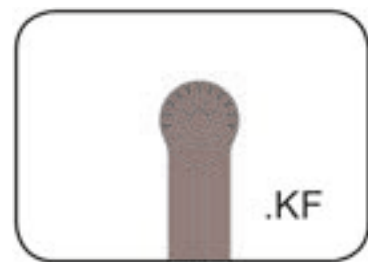


可转位刀片

Indexable insert

S216

带卷屑器
with chip forming



槽宽
圆头

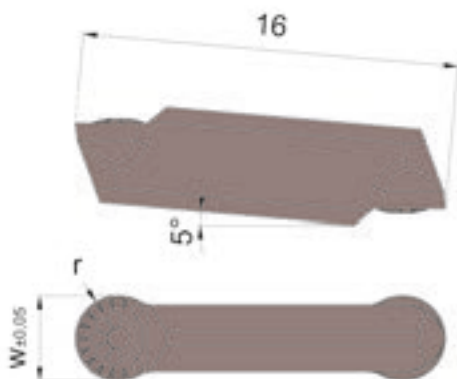
Width of groove
Full radius

2-4 mm
1-2 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 B216
Type



刀片长度重复定位精度
 $\pm 0,1 \text{ mm}$
Indexability length $\pm 0,1 \text{ mm}$

产品型号 Part number	w	r	尺寸规格 Size	AS45
S216.0010.KF2	2	1.0	20	▲
S216.0015.KF3	3	1.5	30	▲
S216.0020.KF4	4	2.0	40	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

P	•
M	•
K	•
N	o
S	•
H	-



机夹式刀杆

槽宽0.5 - 5.3 mm

Toolholder with Inserts

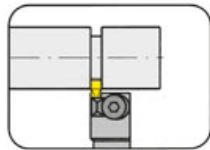
槽宽0.5 - 5.3 mm

切槽

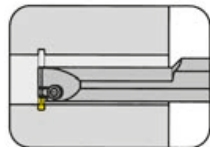
Grooving (external)



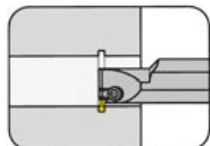
刀杆
Toolholder
240/248/230/233/
234/235/245



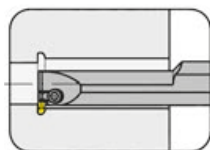
页/Page
F3-F5



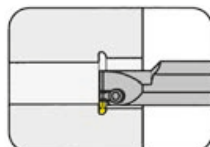
页/Page
F6



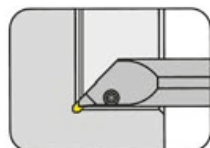
页/Page
F7



页/Page
F8

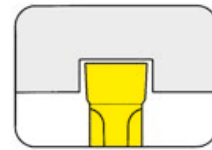


页/Page
F9

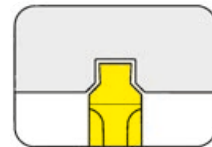


页/Page
F10

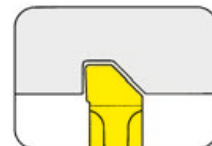
可转位刀片
Indexable insert
217



页/Page
F11



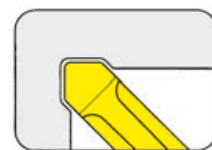
页/Page
F12



页/Page
F13

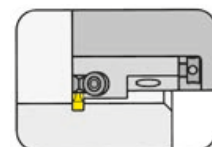


页/Page
F15



页/Page
F14

刀夹
Cartridge
232



页/Page
F16

F

切槽 (外圆)

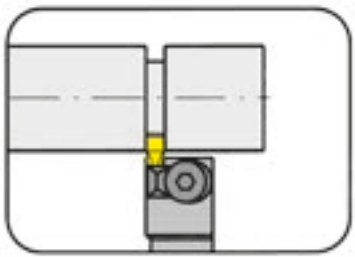
Grooving (external)



刀杆

Toolholder

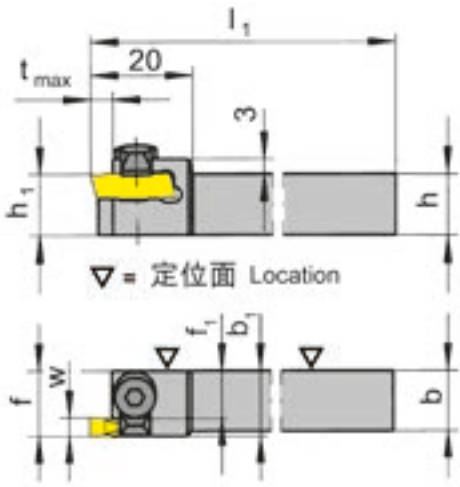
240



槽深可达
夹持范围

Depth of groove up to
Clamping range

4 mm
0.5 - 2.7 mm



配合可转位刀片
for Indexable insert

型号 217
Type

F

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L240.1010.01	10	10	80	10	13	11.5	f ₁ +w-a ₁	4	01	0.5-1.7
R/L240.1212.01	12	12	100	12	13	11.5	f ₁ +w-a ₁	4	01	0.5-1.7
R/L240.1414.01	14	14	100	14	14	12.5	f ₁ +w-a ₁	4	01	0.5-1.7
R/L240.1616.01	16	16	125	16	16	14.5	f ₁ +w-a ₁	4	01	0.5-1.7
R/L240.2020.01	20	20	125	20	20	18.5	f ₁ +w-a ₁	4	01	0.5-1.7
R/L240.1010.02	10	10	80	10	13	10.5	f ₁ +w-a ₁	4	02	1.7-2.7
R/L240.1212.02	12	12	100	12	13	10.5	f ₁ +w-a ₁	4	02	1.7-2.7
R/L240.1414.02	14	14	100	14	14	11.5	f ₁ +w-a ₁	4	02	1.7-2.7
R/L240.1616.02	16	16	125	16	16	13.5	f ₁ +w-a ₁	4	02	1.7-2.7
R/L240.2020.02	20	20	125	20	20	17.5	f ₁ +w-a ₁	4	02	1.7-2.7

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w, a₁ 见刀片
w, a₁ see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L240...	SW2,5 DIN911	8.3

切槽 (外圆)

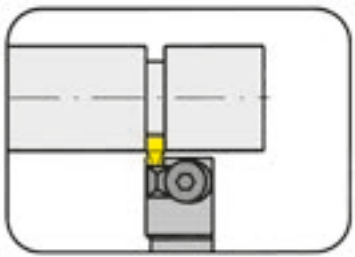
Grooving (external)



刀杆

Toolholder

240



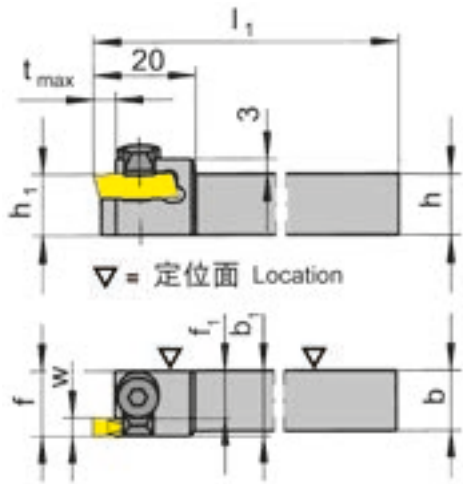
槽深可达
夹持范围

Depth of groove up to
Clamping range

4 mm
2.7 - 5.3 mm

配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L240.1010.03	10	10	80	10	13	9.5	f ₁ +w-a ₁	4	03	2.7-3.7
R/L240.1212.03	12	12	100	12	13	9.5	f ₁ +w-a ₁	4	03	2.7-3.7
R/L240.1414.03	14	14	100	14	14	10.5	f ₁ +w-a ₁	4	03	2.7-3.7
R/L240.1616.03	16	16	125	16	16	12.5	f ₁ +w-a ₁	4	03	2.7-3.7
R/L240.2020.03	20	20	125	20	20	16.5	f ₁ +w-a ₁	4	03	2.7-3.7
R/L240.1010.04	10	10	80	10	15	9.8	f ₁ +w-a ₁	4	04	3.7-5.3
R/L240.1212.04	12	12	100	12	15	9.8	f ₁ +w-a ₁	4	04	3.7-5.3
R/L240.1414.04	14	14	100	14	15	9.8	f ₁ +w-a ₁	4	04	3.7-5.3
R/L240.1616.04	16	16	125	16	16	10.8	f ₁ +w-a ₁	4	04	3.7-5.3
R/L240.2020.04	20	20	125	20	20	14.8	f ₁ +w-a ₁	4	04	3.7-5.3

注明R或L型
State R or L version

w, a₁ 见刀片
w, a₁ see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L240...03	SW2,5 DIN911	8.3
R/L240...04	SW2,5 DIN911	8.4

切槽 (外圆)

Grooving (external)



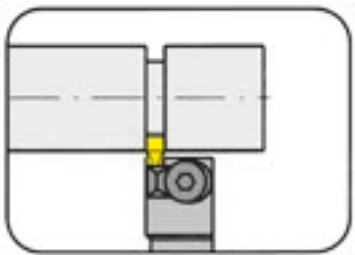
刀杆
Toolholder

248

槽深可达
夹持范围

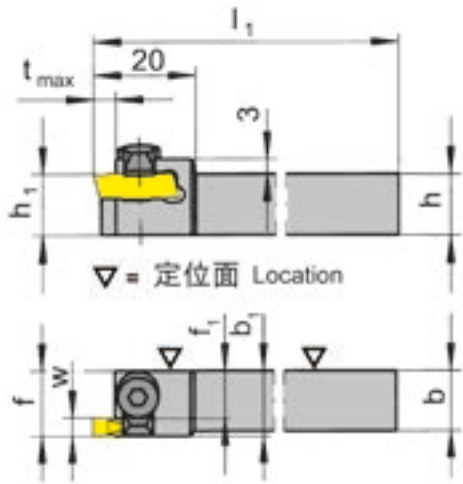
Depth of groove up to
Clamping range

4 mm
0.5 - 2.7 mm



配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L248.1212.01	12	12	95	12	13	1.5	f ₁ +a ₁	4	01	0.5-1.7
R/L248.1212.02	12	12	95	12	13	2.5	f ₁ +a ₁	4	02	1.7-2.7

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w,a₁见刀片
w, a₁ see indexable inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L248...	SW2,5 DIN911	8.3

切槽 (内圆)

Grooving (internal)



刀杆

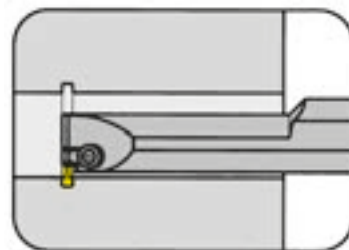
Toolholder

230

孔径Ø 自
槽深可达
夹持范围

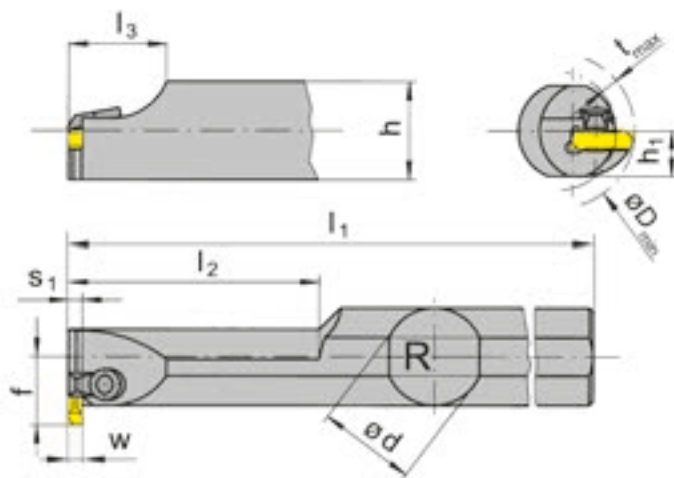
Bore Ø from
Depth of groove up to
Clamping range

20 mm
4.7 mm
0.9 - 5.3 mm



配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

长悬伸
long style

产品型号 Part number	d	l ₁	l ₂	l ₃	h	s ₁	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L230.0020.01	20	180	60	18	18	1.5	9.0	13.3	2.0	20	01	0.9-1.7
R/L250.0025.01	25	250	80	25	23	1.5	11.5	17.5	4.7	25	01	0.9-1.7
R/L250.0032.01	32	250	80	25	30	1.5	15.0	21.0	4.7	32	01	0.9-1.7
R/L230.0020.02	20	180	60	18	18	2.5	9.0	13.3	2.0	20	02	1.7-2.7
R/L250.0025.02	25	250	80	25	23	2.5	11.5	17.5	4.7	25	02	1.7-2.7
R/L250.0032.02	32	250	80	25	30	2.5	15.0	21.0	4.7	32	02	1.7-2.7
R/L230.0020.03	20	180	60	18	18	3.5	9.0	13.3	2.0	20	03	2.7-3.7
R/L250.0025.03	25	250	80	25	23	3.5	11.5	17.5	4.7	25	03	2.7-3.7
R/L250.0032.03	32	250	80	25	30	3.5	15.0	21.0	4.7	32	03	2.7-3.7
R/L230.0020.04	20	180	60	18	18	5.2	9.0	13.3	3.0	20	04	3.7-5.3
R/L250.0025.04	25	250	80	25	23	5.2	11.5	17.5	4.7	25	04	3.7-5.3
R/L250.0032.04	32	250	80	25	30	5.2	15.0	21.0	4.7	32	04	3.7-5.3

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L250...	SW2,5 DIN911	8.3
R/L250...04	SW2,5 DIN911	8.4

切槽 (内圆)

Grooving (internal)



刀杆

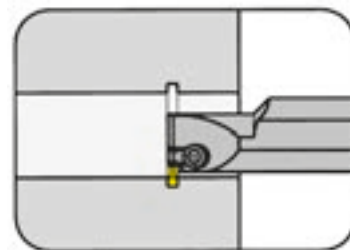
Toolholder

233

孔径Ø 自
槽深可达
夹持范围

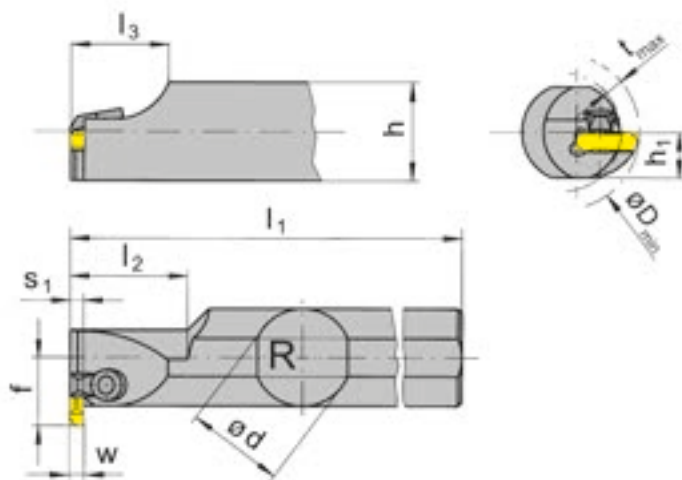
Bore Ø from
Depth of groove up to
Clamping range

20 mm
4.7 mm
0.9 - 5.3 mm



配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

短悬伸
short style

产品型号 Part number	d	l ₁	l ₂	l ₃	h	s ₁	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L233.0020.01	20	130	25	18	18	1.5	9.0	13.3	2.0	20	01	0.9-1.7
R/L253.0025.01	25	150	30	25	23	1.5	11.5	17.5	4.7	25	01	0.9-1.7
R/L253.0032.01	32	150	30	25	30	1.5	15.0	21.0	4.7	32	01	0.9-1.7
R/L233.0020.02	20	130	25	18	18	2.5	9.0	13.3	2.0	20	02	1.7-2.7
R/L253.0025.02	25	150	30	25	23	2.5	11.5	17.5	4.7	25	02	1.7-2.7
R/L253.0032.02	32	150	30	25	30	2.5	15.0	21.0	4.7	32	02	1.7-2.7
R/L233.0020.03	20	130	25	18	18	3.5	9.0	13.3	2.0	20	03	2.7-3.7
R/L253.0025.03	25	150	30	25	23	3.5	11.5	17.5	4.7	25	03	2.7-3.7
R/L253.0032.03	32	150	30	25	30	3.5	15.0	21.0	4.7	32	03	2.7-3.7
R/L233.0020.04	20	130	25	18	18	5.2	9.0	13.3	3.0	20	04	3.7-5.3
R/L253.0025.04	25	150	30	25	23	5.2	11.5	17.5	4.7	25	04	3.7-5.3
R/L253.0032.04	32	150	30	25	30	5.2	15.0	21.0	4.7	32	04	3.7-5.3

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L253...	SW2,5 DIN911	8.3
R/L253...04	SW2,5 DIN911	8.4

切槽 (内圆) Grooving (internal)



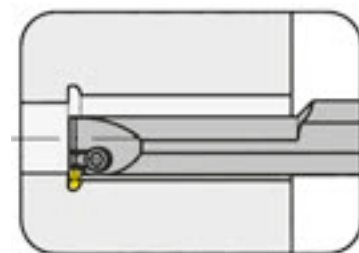
刀杆 Toolholder

234

孔径Ø 自
槽深可达
夹持范围

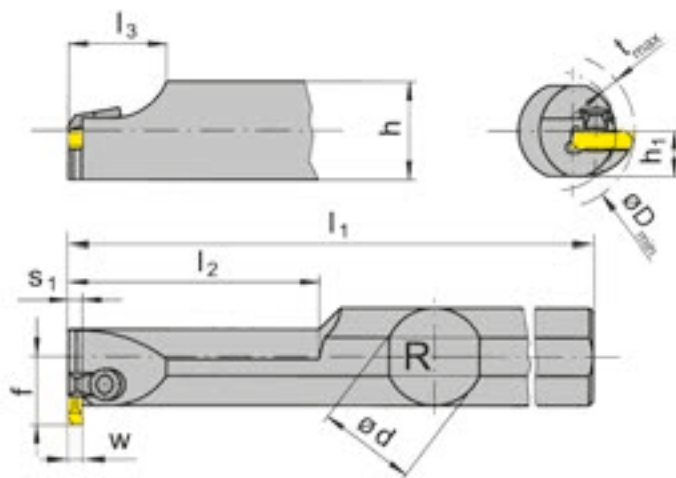
Bore Ø from
Depth of groove up to
Clamping range

20 mm
4.7 mm
0.9 - 5.3 mm



配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	d	l ₁	l ₂	l ₃	h	s ₁	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L234.0020.01	20	180	60	18	18	1.5	9.0	13.3	2.0	20	01	0.9-1.7
R/L254.0025.01	25	250	80	25	23	1.5	11.5	17.5	4.7	25	01	0.9-1.7
R/L254.0032.01	32	250	80	25	30	1.5	15.0	21.0	4.7	32	01	0.9-1.7
R/L234.0020.02	20	180	60	18	18	2.5	9.0	13.3	2.0	20	02	1.7-2.7
R/L254.0025.02	25	250	80	25	23	2.5	11.5	17.5	4.7	25	02	1.7-2.7
R/L254.0032.02	32	250	80	25	30	2.5	15.0	21.0	4.7	32	02	1.7-2.7
R/L234.0020.03	20	180	60	18	18	3.5	9.0	13.3	2.0	20	03	2.7-3.7
R/L254.0025.03	25	250	80	25	23	3.5	11.5	17.5	4.7	25	03	2.7-3.7
R/L254.0032.03	32	250	80	25	30	3.5	15.0	21.0	4.7	32	03	2.7-3.7
R/L234.0020.04	20	180	60	18	18	5.2	9.0	13.3	3.0	20	04	3.7-5.3
R/L254.0025.04	25	250	80	25	23	5.2	11.5	17.5	4.7	25	04	3.7-5.3
R/L254.0032.04	32	250	80	25	30	5.2	15.0	21.0	4.7	32	04	3.7-5.3

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

配件 Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L234...	SW2,5 DIN911	8.3
R/L234...04	SW2,5 DIN911	8.4

切槽 (内圆)

Grooving (internal)



刀杆

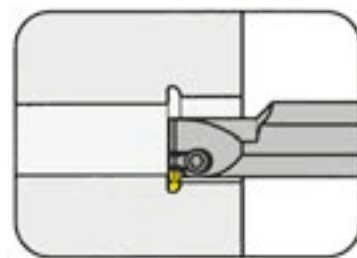
Toolholder

235

孔径Ø 自
槽深可达
夹持范围

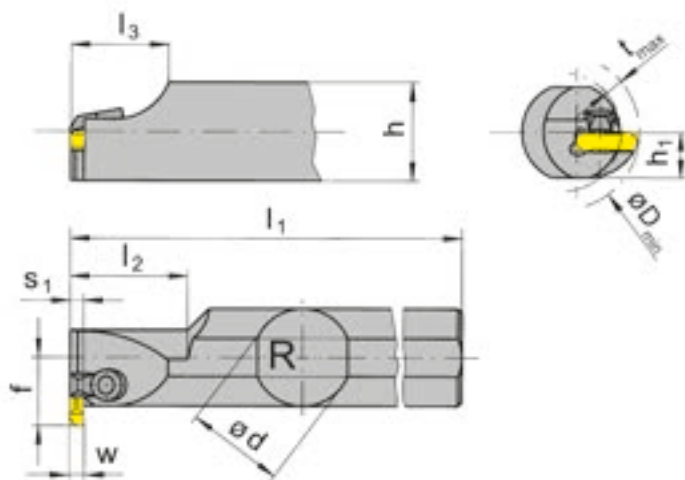
Bore Ø from
Depth of groove up to
Clamping range

20 mm
4.7 mm
0.9 - 5.3 mm



配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	d	l ₁	l ₂	l ₃	h	s ₁	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L235.0020.01	20	130	25	18	18	1.5	9.0	13.3	2.0	20	01	0.9-1.7
R/L255.0025.01	25	150	30	25	23	1.5	11.5	17.5	4.7	25	01	0.9-1.7
R/L255.0032.01	32	150	30	25	30	1.5	15.0	21.0	4.7	32	01	0.9-1.7
R/L235.0020.02	20	130	25	18	18	2.5	9.0	13.3	2.0	20	02	1.7-2.7
R/L255.0025.02	25	150	30	25	23	2.5	11.5	17.5	4.7	25	02	1.7-2.7
R/L255.0032.02	32	150	30	25	30	2.5	15.0	21.0	4.7	32	02	1.7-2.7
R/L235.0020.03	20	130	25	18	18	3.5	9.0	13.3	2.0	20	03	2.7-3.7
R/L255.0025.03	25	150	30	25	23	3.5	11.5	17.5	4.7	25	03	2.7-3.7
R/L255.0032.03	32	150	30	25	30	3.5	15.0	21.0	4.7	32	03	2.7-3.7
R/L235.0020.04	20	130	25	18	18	5.2	9.0	13.3	3.0	20	04	3.7-5.3
R/L255.0025.04	25	150	30	25	23	5.2	11.5	17.5	4.7	25	04	3.7-5.3
R/L255.0032.04	32	150	30	25	30	5.2	15.0	21.0	4.7	32	04	3.7-5.3

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位: mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L255...	SW2,5 DIN911	8.3
R/L255...04	SW2,5 DIN911	8.4

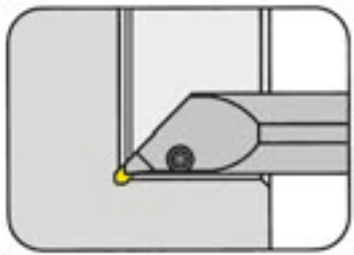
切退刀槽 (内圆)

Grooving Corner Reliefs (internal)



刀杆
Toolholder

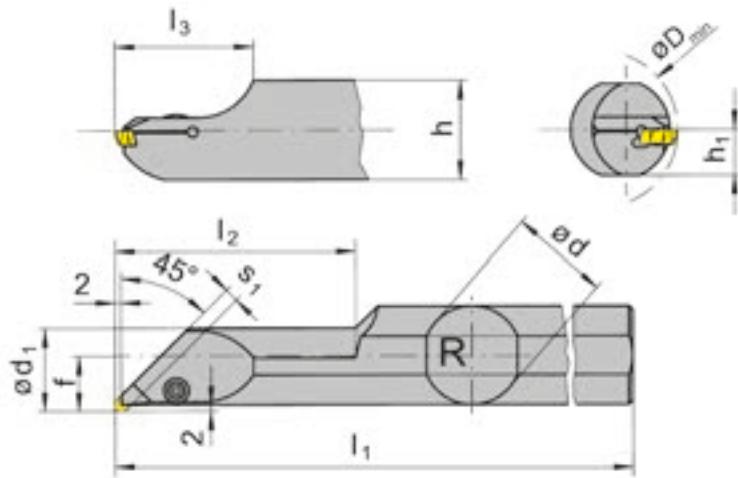
245



孔径Ø 自 Bore Ø from 20 mm

配合可转位刀片
for Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

类似于DIN509“F”型
similar to DIN 509 form „F“

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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L245...	51.27.984P	T15PQ

切槽 (内圆和外圆) Grooving (external and internal)



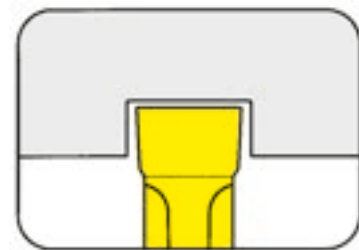
可转位刀片 Indexable insert

217

卡簧槽
卡簧宽度Nw

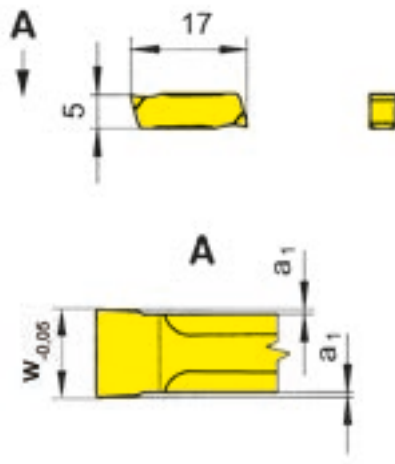
Circlip grooves
Width of circlip Nw

DIN 471/472
0.5-5.15 mm



配合刀杆
for Toolholder

型号 230
Type 232
233
240
248
250
253



刀片长度重复定位精度
±0.02 mm
Indexability length ± 0.02 mm

F

产品型号 Part number	w	Nw	a ₁	尺寸规格 Size		K10	MG12	H20	P20	TC92	TN32	TN35
217.0050.00	0.57	0.50	0.06	01		▲			▲		▲	
217.0060.00	0.67	0.60	0.06	01		▲			▲		▲	
217.0070.00	0.77	0.70	0.06	01		▲			▲		▲	
217.0080.00	0.87	0.80	0.06	01		▲			▲		▲	
217.0090.00	0.97	0.90	0.06	01		▲			▲		▲	
217.0100.00	1.07	1.00	0.06	01		▲			▲		▲	
217.0110.00	1.24	1.10	0.10	01		▲			▲		▲	
217.0130.00	1.44	1.30	0.10	01		▲			▲		▲	
217.0160.00	1.74	1.60	0.10	01		▲			▲		▲	
217.0185.00	1.99	1.85	0.10	02		▲	Δ	▲	▲	▲	▲	▲
217.0215.00	2.29	2.15	0.10	02		▲			▲	▲	▲	
217.0265.00	2.79	2.65	0.10	02		▲			▲	▲	▲	
217.0315.00	3.29	3.15	0.10	03		▲			▲	▲	▲	
217.0415.00	4.29	4.15	0.10	04		▲			▲	▲	▲	
217.0515.00	5.29	5.15	0.10	04		▲			▲	▲	▲	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

只有在切宽≥1.1mm时才能达到最大切深

较小宽度刀片的最大切深_{t_{max}} = 1 mm, 而且取决于工件的直径Ø。

Max. depth of groove can be reached only with width of cut ≥ 1,1 mm

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

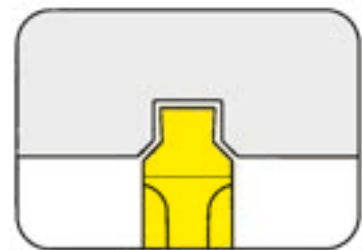
硬质合金牌号
Carbide grades

切槽 (内圆和外圆) Grooving (external and internal)



可转位刀片 Indexable insert

217



卡簧槽
卡簧宽度Nw

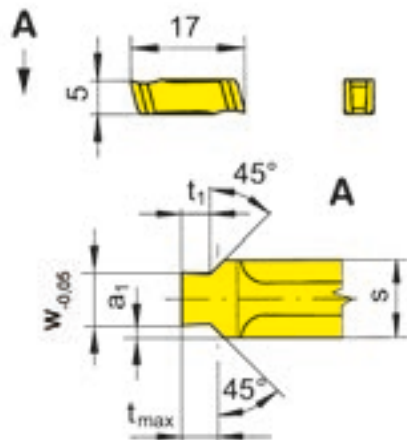
Circlip grooves
Width of circlip Nw

DIN 471/472
1.1-4.15 mm

带倒角
with chamfer

配合刀杆
for Toolholder

型号 234
Type 235
240
248
254
255



对于特殊尺寸, 请注明:
t1, tmax, w
for special dimensions please
state: w, t1, tmax

产品型号 Part number	w	Nw	t _{max}	a ₁	s	t ₁	尺寸规格 Size	MG12	P20	TN32
217.1101.25	1.24	1.10	0.20	0.64	2.5	0.19	02	Δ	Δ	
217.1102.25	1.24	1.10	0.25	0.64	2.5	0.24	02	Δ	Δ	
217.1103.25	1.24	1.10	0.30	0.64	2.5	0.29	02	Δ	Δ	
217.1104.25	1.24	1.10	0.35	0.64	2.5	0.33	02	Δ	Δ	
217.1105.25	1.24	1.10	0.40	0.64	2.5	0.36	02	Δ	Δ	
217.1306.25	1.44	1.30	0.55	0.54	2.5	0.45	02		Δ	▲
217.1607.33	1.74	1.60	0.70	0.79	3.3	0.60	03		Δ	▲
217.1608.33	1.74	1.60	0.85	0.79	3.3	0.75	03	Δ	Δ	
217.1609.33	1.74	1.60	1.00	0.79	3.3	0.85	03			▲
217.1810.33	1.99	1.85	1.00	0.67	3.3	0.85	03	Δ	Δ	
217.1812.33	1.99	1.85	1.25	0.67	3.3	1.10	03		Δ	▲
217.2115.43	2.29	2.15	1.50	1.02	4.3	1.35	04		Δ	▲
217.2616.43	2.79	2.65	1.50	0.77	4.3	1.35	04			Δ
217.2617.43	2.79	2.65	1.75	0.77	4.3	1.60	04			▲
217.3118.53	3.29	3.15	1.75	1.02	5.3	1.60	04			▲
217.4120.53	4.29	4.15	2.00	0.52	5.3	1.85	04			▲
217.4125.53	4.29	4.15	2.50	0.52	5.3	2.35	04	Δ	Δ	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切槽 (内圆和外圆)

Grooving (external and internal)

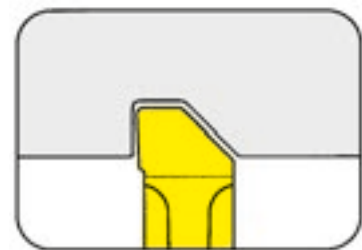


可转位刀片

Indexable insert

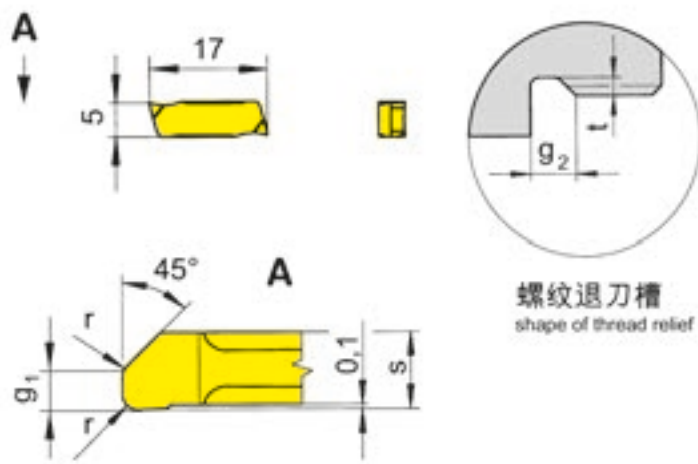
217

DIN76短型螺纹退刀槽
Thread relief DIN 76 „Short form“



配合刀杆
for Toolholder

型号 234
Type 235
240
248
254
255



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	r	t ₁	s	g ₁	g ₂	尺寸规格 Size	P20
R/L217.1050.17	0.50	0.2	0.50	1.7	1.25	1.75	01	△△
R/L217.1060.27	0.60	0.4	0.55	2.7	1.50	2.05	02	△△
R/L217.1070.27	0.70	0.4	0.60	2.7	1.75	2.35	02	△△
R/L217.1080.27	0.80	0.4	0.70	2.7	2.00	2.70	02	△△
R/L217.1100.37	1.00	0.6	0.90	3.7	2.50	3.40	03	▲/△
R/L217.1125.53	1.25	0.6	1.05	5.3	3.20	4.25	04	△△
R/L217.1150.53	1.50	0.8	1.20	5.3	3.80	5.00	04	△△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

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

内圆加工 :

右手型刀片配合左手型刀杆, 左手型刀片配合右手型刀杆

Internal machining:

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

P	•
M	-
K	-
N	-
S	-
H	-

F

切退刀槽 (内圆)

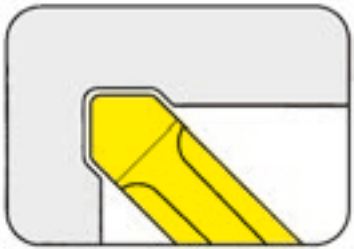
Grooving Corner Reliefs (internal)



可转位刀片
Indexable insert

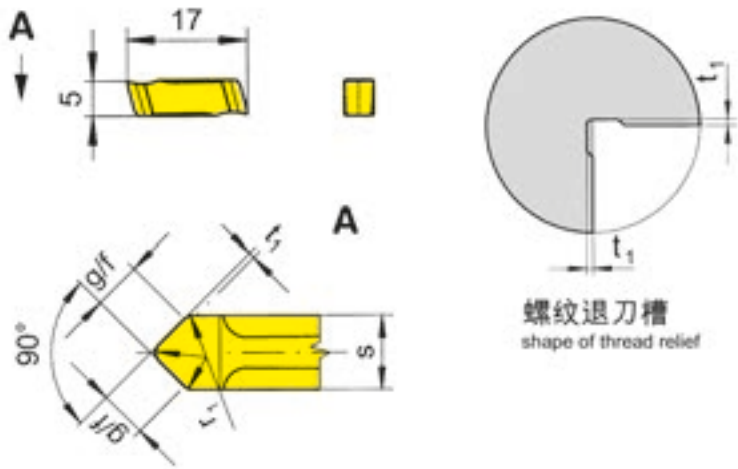
217

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



配合刀杆
for Toolholder

型号 245
Type



F

产品型号 Part number	r_1	D_{min}	t_1	s	g/f	尺寸规格 Size		P20	TN32
217.0602.24	0.6	20	0.2	2.4	1.7	02		▲	▲
217.0603.33	0.6	23	0.3	3.3	2.3	03		▲	
217.1002.30	1.0	22	0.2	3.0	2.1	03		△	
217.1004.50	1.0	27	0.4	5.0	3.6	04		△	
217.1603.50	1.6	27	0.3	5.0	3.6	04		△	
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request							P	•	•
● 推荐 / recommended							M	-	-
o 次推荐 / alternative recommendation							K	-	-
- 不合适 / not suitable							N	-	-
非涂层 / uncoated grades							S	-	-
涂层 / coated grades							H	-	-
钎焊/金属陶瓷 / brazed/Cermet									

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

硬质合金牌号
Carbide grades

切退刀槽 (内圆)

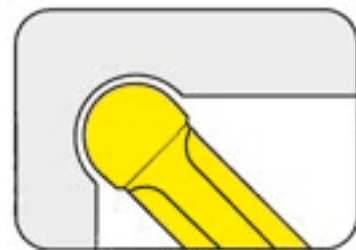
Grooving Corner Reliefs (internal)



可转位刀片

Indexable insert

217



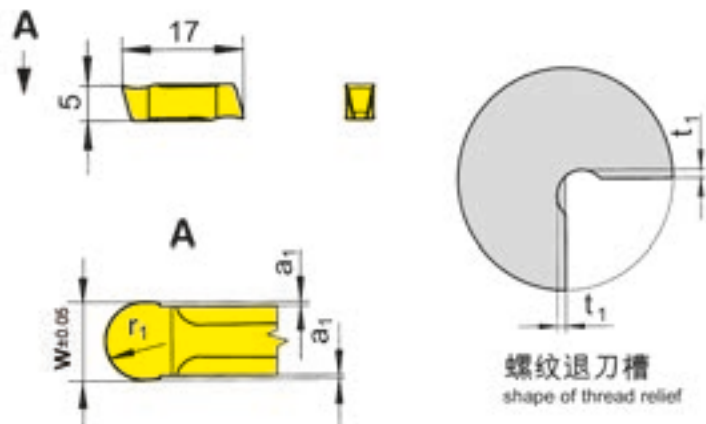
圆头

Full radius

1-2.5 mm

配合刀杆
for Toolholder

型号 245
Type



F

产品型号 Part number	w	a ₁	D _{min}	t ₁	r ₁	尺寸规格 Size		K10	P20	TC92	TF45	TI25	TN32	TN35
217.0010.20	2	0.1	20	0.75	1.0	02		▲	▲	Δ	Δ	Δ	▲	▲
217.0015.30	3	0.1	20	1.00	1.5	03		Δ	▲				▲	▲
217.0020.40	4	0.1	20	1.25	2.0	04			▲					▲
217.0025.50	5	0.1	20	1.50	2.5	04		▲	▲					
							P	●	●	●	●	●	●	●
							M	○	-	-	●	●	-	●
							K	●	-	-	●	●	-	●
							N	●	-	-	●	●	-	●
							S	○	-	-	●	●	-	●
							H	-	-	-	-	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

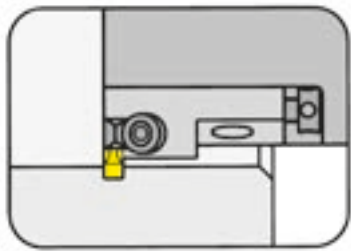
Carbide grades

切槽 (内圆)
Grooving (internal)

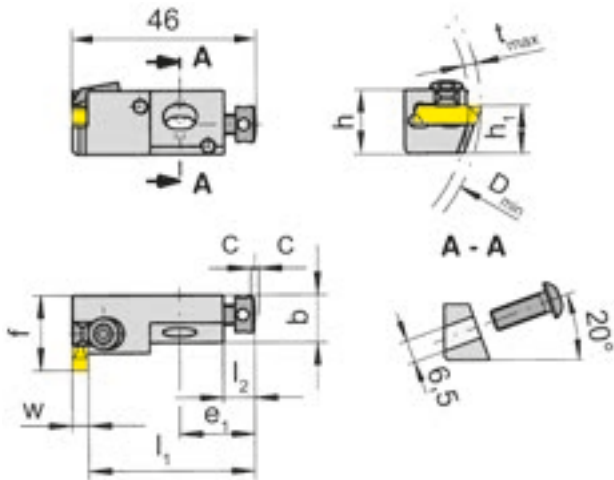


刀夹
Cartridge

232



孔径Ø 自	Bore Ø from	40 mm



可转位刀片
Indexable insert

型号 217
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	h ₁	f	l ₁	E ₁	l ₂	C	D _{min}	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R232.1212.01	16	12	12	19	44.4	19	8	1	40	3	01	0.9-1.7
R232.1212.02	16	12	12	19	43.4	19	8	1	40	3	02	1.7-2.7
R232.1212.03	16	12	12	19	42.4	19	8	1	40	3	03	2.7-3.7
R232.1212.04	16	12	12	19	40.7	19	8	1	40	3	04	3.7-5.3

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
底座尺寸见下一页
Dimensions of seating see following page

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	螺钉 Screw	压板 Clamping element
R232.1212....	4.08.913	SW2,5 DIN911	6.20.232	8.3
R232.1212.04	4.08.913	SW2,5 DIN911	6.20.232	8.4

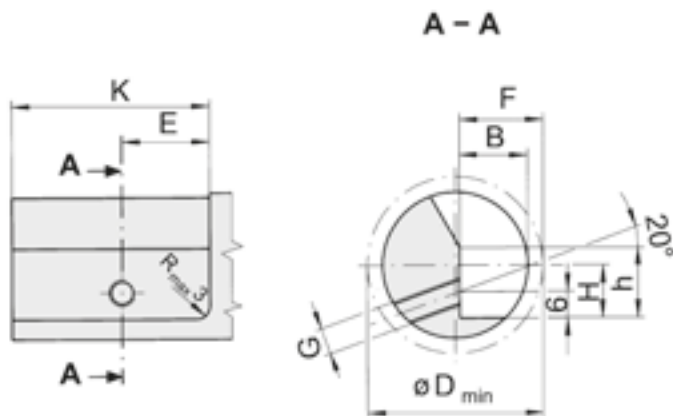
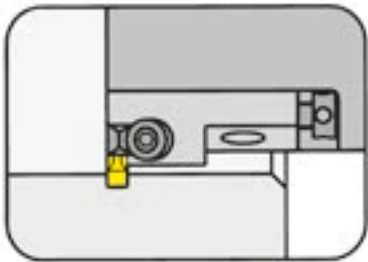
切槽 (内圆)

Grooving (internal)



外形尺寸 刀夹 型号
Seating Dimensions Cartridge

232

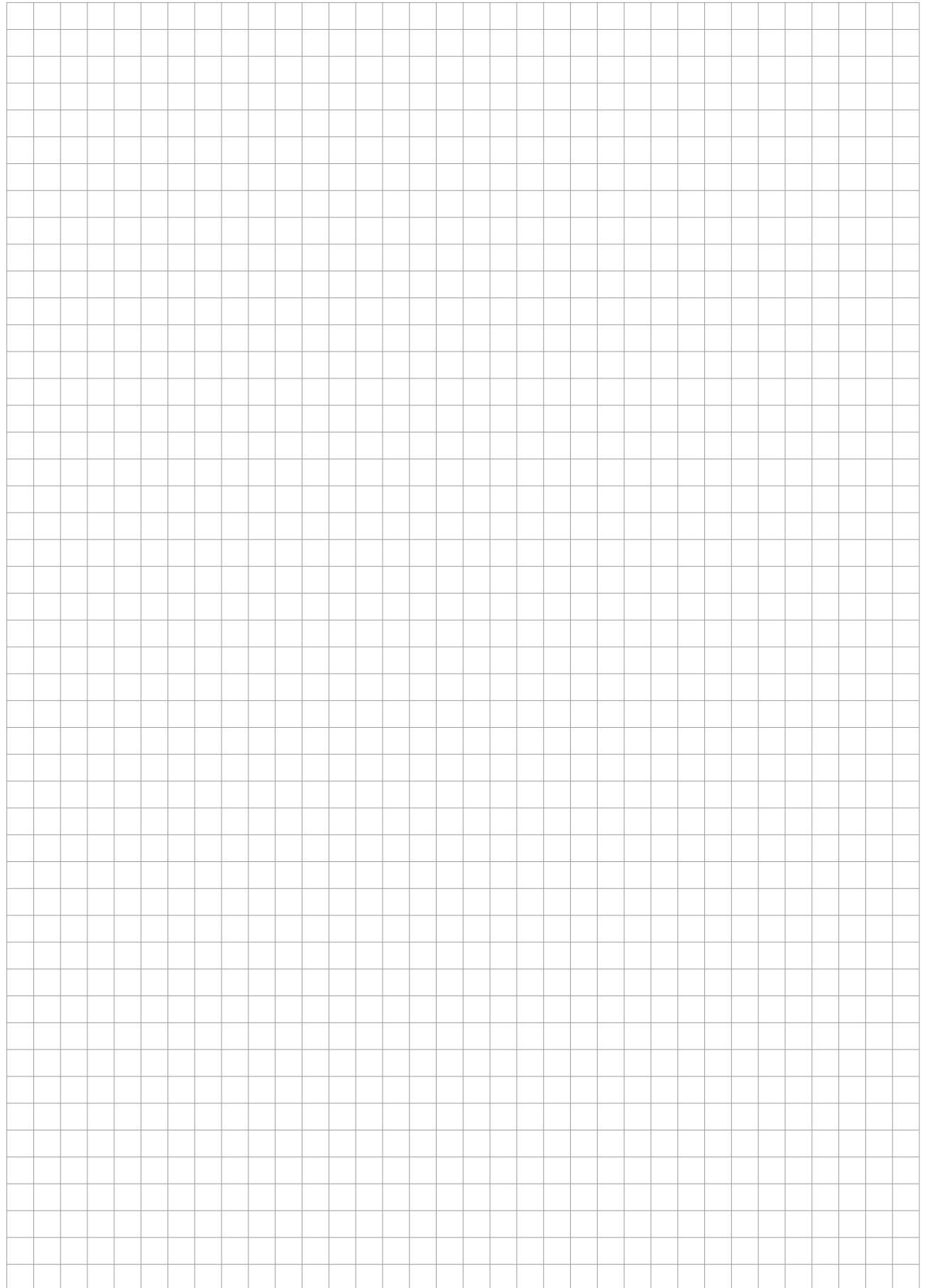


F

刀夹 Cartridge	F	G	H	K	E	B	h	D _{min}	紧固螺钉 Fastening screw
232.1212...	19	M6	12	45	20	15.5	16	40	6.20.232

尺寸单位 : mm
Dimensions in mm

F





G

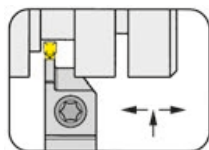
机夹式刀杆

槽宽2 - 6 mm

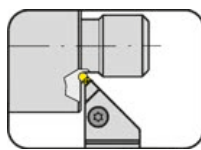
Toolholder with Inserts

Width of groove 2 - 6 mm

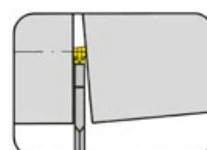
刀杆
Toolholder
H224/B224/224



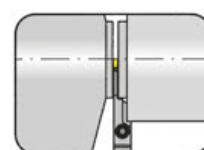
页 / Page
G3-G10.G12-G17



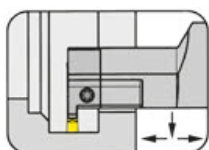
页 / Page
G18



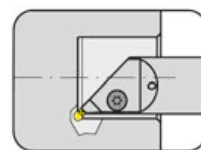
页 / Page
G19, G22-G23



页 / Page
G11, G20-G21

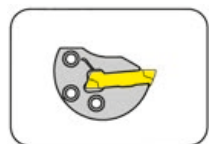


页 / Page
G24-G28



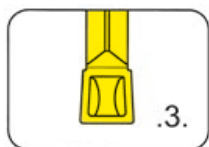
页 / Page
G30-G31

刀夹
Cassette
BK224

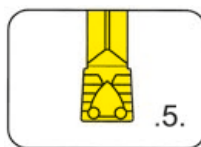


页 / Page
G27

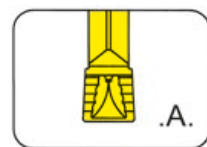
可转位刀片
Inserts
S224/S124/224/NS224



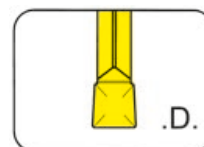
页 / Page
G32-G33



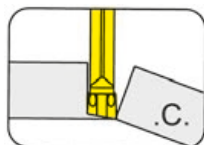
页 / Page
G34-G35



页 / Page
G36-G37



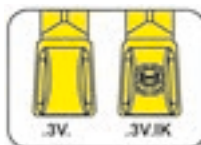
页 / Page
G38-G39



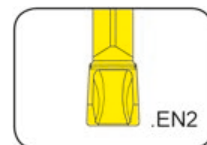
页 / Page
G40-G41



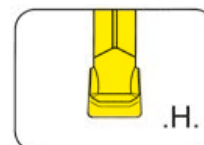
页 / Page
G42



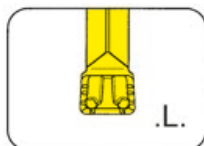
页 / Page
G43,G55



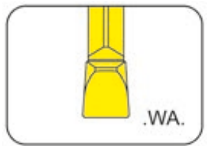
页 / Page
G44



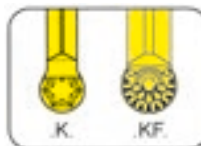
页 / Page
G45



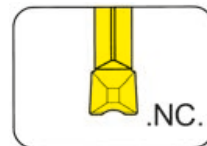
页 / Page
G46-G47



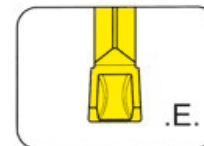
页 / Page
G48



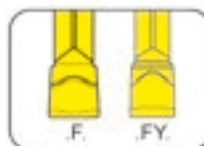
页 / Page
G49-G50



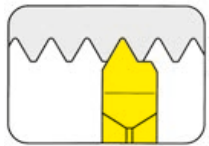
页 / Page
G51



页 / Page
G52



页 / Page
G53-G54



页 / Page
G56-G57

切槽和切断

Grooving and Parting Off

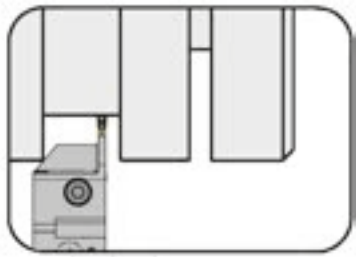


刀杆

Toolholder

H224

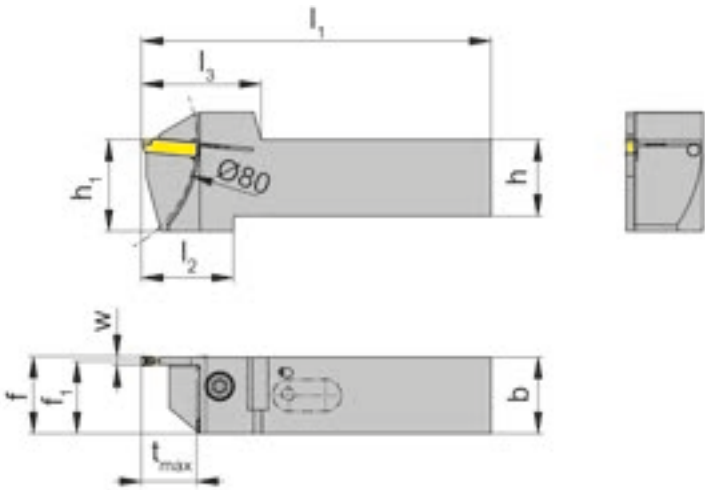
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3 mm



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

配合可转位刀片
for Indexable insert

型号 S224
Type NS224

冷却液供应通过刀片
Coolant supply through insert

G

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH224.1616.3.23.IK	16	16	87	33	39	25	14.75	$f_1 + w/2$	18	03
R/LH224.2020.3.23.IK	20	20	99	30	39	25	18.75	$f_1 + w/2$	18	03
R/LH224.2525.3.23.IK	25	25	114	30	39	30	23.75	$f_1 + w/2$	18	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

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

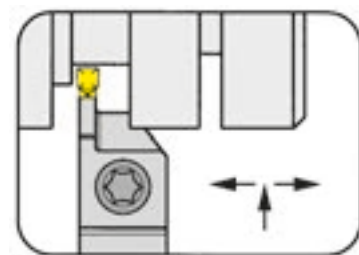
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆 Toolholder

H224



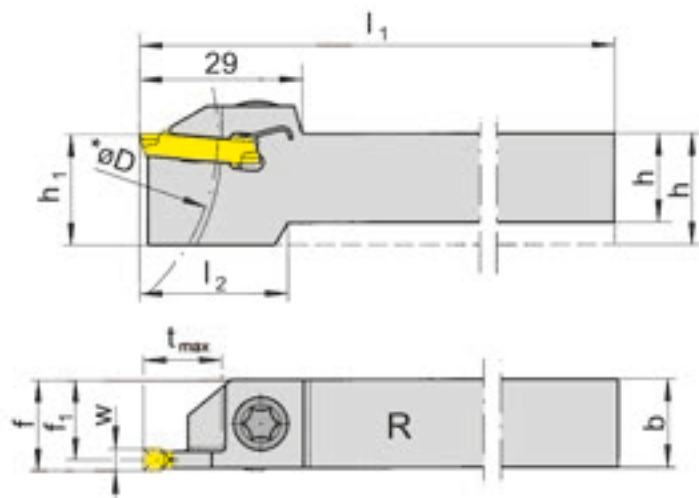
槽深可达
夹持范围

Depth of groove up to
Clamping range

14 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.01	16	16	125	25	20	15.3	$f_1+w/2$	14	80	01	2.0-2.4
R/LH224.2020.01	20	20	125	-	20	19.3	$f_1+w/2$	14	80	01	2.0-2.4
R/LH224.2525.01	25	25	150	-	25	24.3	$f_1+w/2$	14	80	01	2.0-2.4
R/LH224.1616.02	16	16	125	25	20	15.1	$f_1+w/2$	14	80	02	2.4-2.8
R/LH224.2020.02	20	20	125	-	20	19.1	$f_1+w/2$	14	80	02	2.4-2.8
R/LH224.2525.02	25	25	150	-	25	24.1	$f_1+w/2$	14	80	02	2.4-2.8
R/LH224.1616.03	16	16	125	25	20	14.9	$f_1+w/2$	14	80	03	2.8-3.7
R/LH224.2020.03	20	20	125	-	20	18.9	$f_1+w/2$	14	80	03	2.8-3.7
R/LH224.2525.03	25	25	150	-	25	23.9	$f_1+w/2$	14	80	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

*D=80mm以内可达 t_{max}

* t_{max} up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆

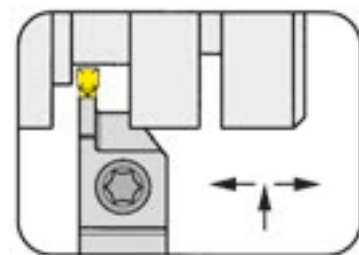
Toolholder

H224

槽深可达
夹持范围

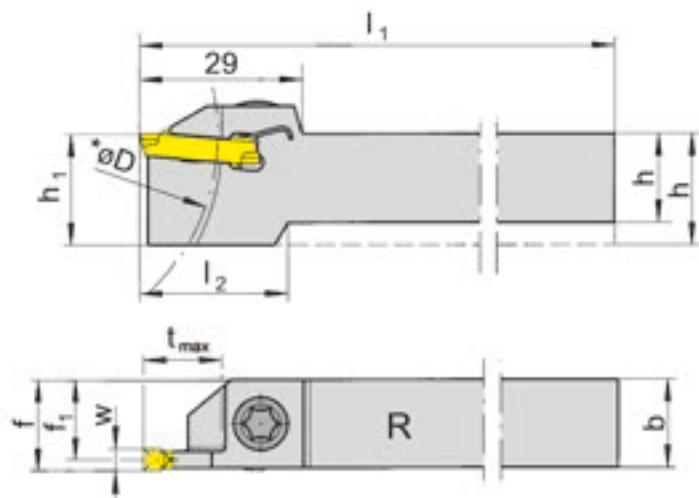
Depth of groove up to
Clamping range

14 mm
3.7-6.1 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.04	16	16	125	25	20	14.55	$f_1+w/2$	14	80	04	3.7-4.4
R/LH224.2020.04	20	20	125	-	20	18.55	$f_1+w/2$	14	80	04	3.7-4.4
R/LH224.2525.04	25	25	150	-	25	23.55	$f_1+w/2$	14	80	04	3.7-4.4
R/LH224.1616.05	16	16	125	-	20	18.15	$f_1+w/2$	14	80	05	4.4-5.1
R/LH224.2020.05	20	20	125	-	20	18.15	$f_1+w/2$	14	80	05	4.4-5.1
R/LH224.2525.05	25	25	150	-	25	23.15	$f_1+w/2$	14	80	05	4.4-5.1
R/LH224.2020.06	20	20	125	-	20	17.75	$f_1+w/2$	14	80	06	5.1-6.1
R/LH224.2525.06	25	25	150	-	25	22.75	$f_1+w/2$	14	80	06	5.1-6.1

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

*D=80mm以内可达 t_{max}

* t_{max} up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

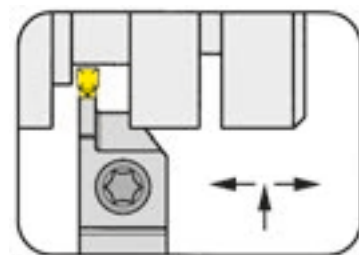
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆 Toolholder

H224



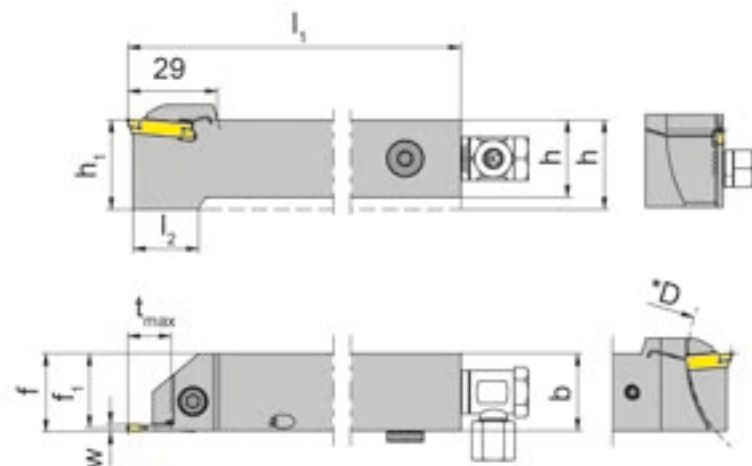
槽深可达
夹持范围

Depth of groove up to
Clamping range

14 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.01.IK	16	16	125	25	20	15.3	f ₁ +w/2	14	80	01	2.0-2.4
R/LH224.2020.01.IK	20	20	125	-	20	19.3	f ₁ +w/2	14	80	01	2.0-2.4
R/LH224.2525.01.IK	25	25	150	-	25	24.3	f ₁ +w/2	14	80	01	2.0-2.4
R/LH224.1616.02.IK	16	16	125	25	20	15.1	f ₁ +w/2	14	80	02	2.4-2.8
R/LH224.2020.02.IK	20	20	125	-	20	19.1	f ₁ +w/2	14	80	02	2.4-2.8
R/LH224.2525.02.IK	25	25	150	-	25	24.1	f ₁ +w/2	14	80	02	2.4-2.8
R/LH224.1616.03.IK	16	16	125	25	20	14.9	f ₁ +w/2	14	80	03	2.8-3.7
R/LH224.2020.03.IK	20	20	125	-	20	18.9	f ₁ +w/2	14	80	03	2.8-3.7
R/LH224.2525.03.IK	25	25	150	-	25	23.9	f ₁ +w/2	14	80	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

*D=80mm以内可达t_{max}

*t_{max} up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ

切槽和切断

Grooving and Parting Off

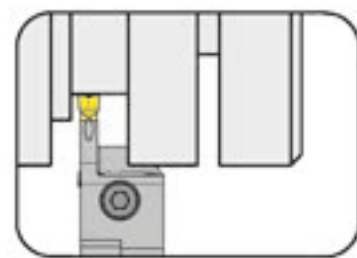


刀杆

Toolholder

H224

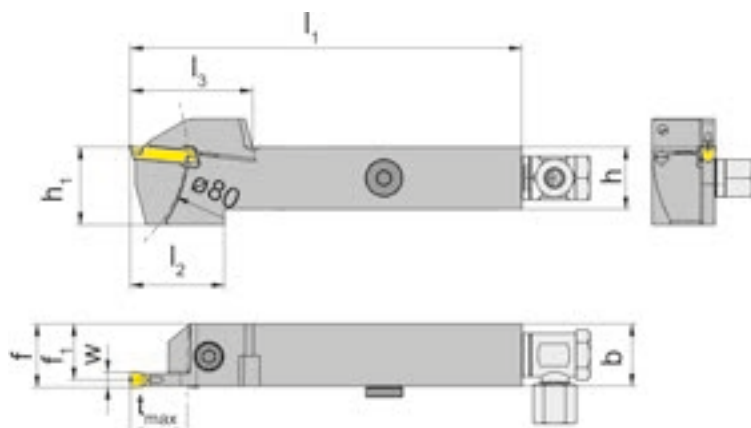
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH224.1616.0.03.IK	16	16	125	29	35	25	14.75	$f_1 + w/2$	14	03
R/LH224.2020.0.03.IK	20	20	125	26	35	25	18.75	$f_1 + w/2$	14	03
R/LH224.2525.0.03.IK	25	25	150	26	35	30	23.75	$f_1 + w/2$	14	03
R/LH224.1616.0.04.IK	16	16	125	29	35	25	14.30	$f_1 + w/2$	14	04
R/LH224.2020.0.04.IK	20	20	125	26	35	25	18.30	$f_1 + w/2$	14	04
R/LH224.2525.0.04.IK	25	25	150	26	35	30	23.30	$f_1 + w/2$	14	04
R/LH224.1616.0.05.IK	16	16	125	29	35	25	13.95	$f_1 + w/2$	14	05
R/LH224.2020.0.05.IK	20	20	125	26	35	25	17.95	$f_1 + w/2$	14	05
R/LH224.2525.0.05.IK	25	25	150	26	35	30	22.95	$f_1 + w/2$	14	05

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Allen Wrench
R/LH224...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ	-
R/LH224.1616.0.03.IK	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ	SW2,0 DIN911

切槽和切断

Grooving and Parting Off



刀杆

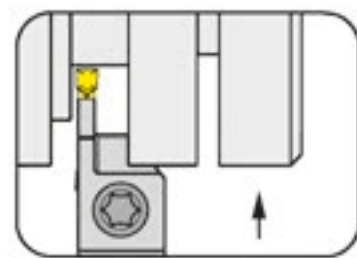
Toolholder

H224

槽深可达
夹持范围

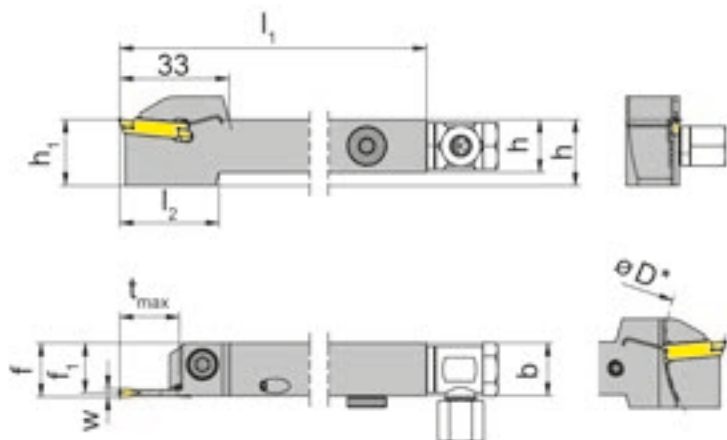
Depth of groove up to
Clamping range

18 mm
2-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1212.21.IK	12	12	125	33	20	11.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.1616.21.IK	16	16	125	30	20	15.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.2020.21.IK	20	20	125	-	20	19.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.2525.21.IK	25	25	150	-	25	24.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.1212.22.IK	12	12	125	33	20	11.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.1616.22.IK	16	16	125	30	20	15.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.2020.22.IK	20	20	125	-	20	19.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.2525.22.IK	25	25	150	-	25	24.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.1212.23.IK	12	12	125	33	20	10.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.1616.23.IK	16	16	125	30	20	14.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.2020.23.IK	20	20	125	-	20	18.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.2525.23.IK	25	25	150	-	25	23.9	$f_1+w/2$	18	80	03	2.8-3.7

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

*D=80mm以内可达 t_{max}

* t_{max} up to D = 80 mm

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	冷却液供应 Coolant supply	锁紧螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH224....	004.00.16	6.23T25P	T25PQ	004.00.26
R/LH224.1212.22.IK	004.00.61	6.23T25P	T25PQ	-
R/LH224.1212.23.IK	004.00.61	6.23T25P	T25PQ	-
R/LH224.2525.23.IK	004.00.61	6.23T25P	T25PQ	-

切槽和切断

Grooving and Parting Off

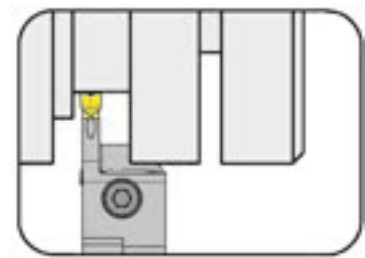


刀杆

Toolholder

H224

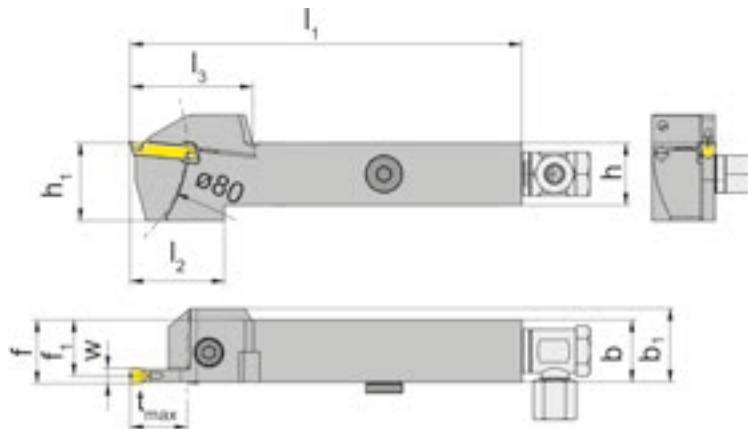
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	b_1	f_1	f	t_{max}	尺寸规格 Size
R/LH224.1616.0.23.IK	16	16	125	33	39	25	20	14.75	$f_1 + w/2$	18	03
R/LH224.2020.0.23.IK	20	20	125	30	39	25	-	18.75	$f_1 + w/2$	18	03
R/LH224.2525.0.23.IK	25	25	150	30	39	30	-	23.75	$f_1 + w/2$	18	03
R/LH224.1616.0.24.IK	16	16	125	33	39	25	20	14.30	$f_1 + w/2$	18	04
R/LH224.2020.0.24.IK	20	20	125	30	39	25	-	18.30	$f_1 + w/2$	18	04
R/LH224.2525.0.24.IK	25	25	150	30	39	30	-	23.30	$f_1 + w/2$	18	04
R/LH224.1616.0.25.IK	16	16	125	33	39	25	20	13.95	$f_1 + w/2$	18	05
R/LH224.2020.0.25.IK	20	20	125	30	39	25	-	17.95	$f_1 + w/2$	18	05
R/LH224.2525.0.25.IK	25	25	150	30	39	30	-	23.95	$f_1 + w/2$	18	05

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug	冷却液供应 Coolant supply	扳手 Allen Wrench
R/LH224...	6.23T25P	T25PQ	004.00.26	SBD 6 LR - G1/8"	-
R/LH224.2020.0.24.IK	6.23T25P	T25PQ	004.00.26	SBD 6 LR - G1/8"	SW4,0 DIN911

切槽和切断

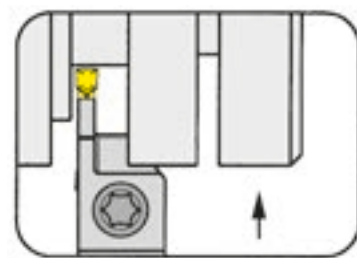
Grooving and Parting Off



刀杆

Toolholder

H224



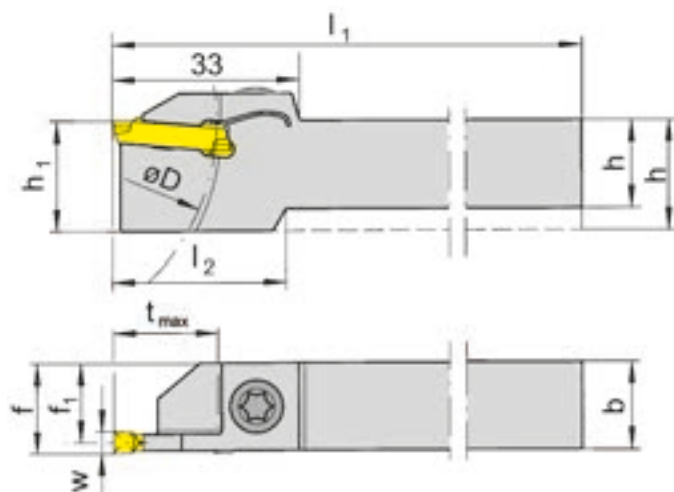
槽深可达
夹持范围

Depth of groove up to
Clamping range

18 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1212.21	12	12	125	33	20	11.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.1616.21	16	16	125	30	20	15.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.2020.21	20	20	125	-	20	19.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.2525.21	25	25	150	-	25	24.3	$f_1+w/2$	18	80	01	2.0-2.4
R/LH224.1608.02	16	8	100	30	20	7.1	$f_1+w/2$	14	80	02	2.4-2.8
R/LH224.1212.22	12	12	125	33	20	11.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.1616.22	16	16	125	30	20	15.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.2020.22	20	20	125	-	20	19.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.2525.22	25	25	150	-	25	24.1	$f_1+w/2$	18	80	02	2.4-2.8
R/LH224.1212.23	12	12	125	33	20	10.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.1608.23	16	8	100	-	20	6.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.1616.23	16	16	125	30	20	14.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.2020.23	20	20	125	-	20	18.9	$f_1+w/2$	18	80	03	2.8-3.7
R/LH224.2525.23	25	25	150	-	25	23.9	$f_1+w/2$	18	80	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	6.23T25P	T25PQ
R/LH224.1608.02	4.15T15P	T15PL
R/LH224.1608.23	4.15T15P	T15PQ

切槽和切断

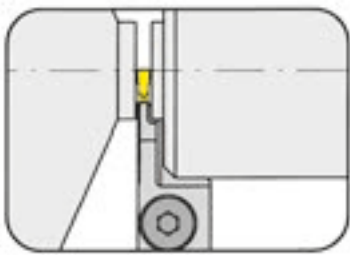
Grooving and Parting Off



刀杆

Toolholder

H224



槽深可达
夹持范围

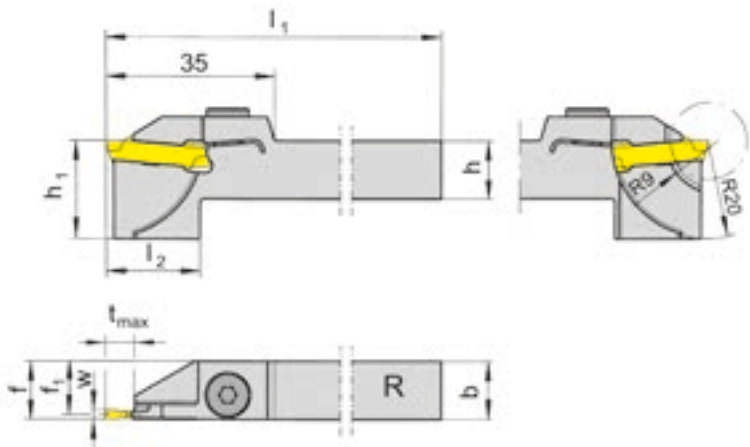
Depth of groove up to
Clamping range

8.2 mm
2-2.4 mm

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

配合可转位刀片
for Indexable insert

型号 S224
Type N224



R=右手型-如图
R = right hand version shown

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

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RH224.1212.81	6.17T25P	T25PQ

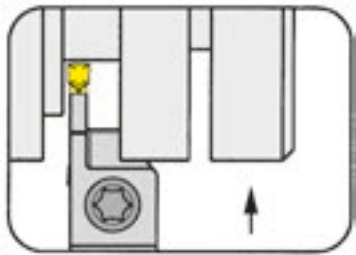
切槽 (外圆)

Grooving (external)



刀杆 Toolholder

H224



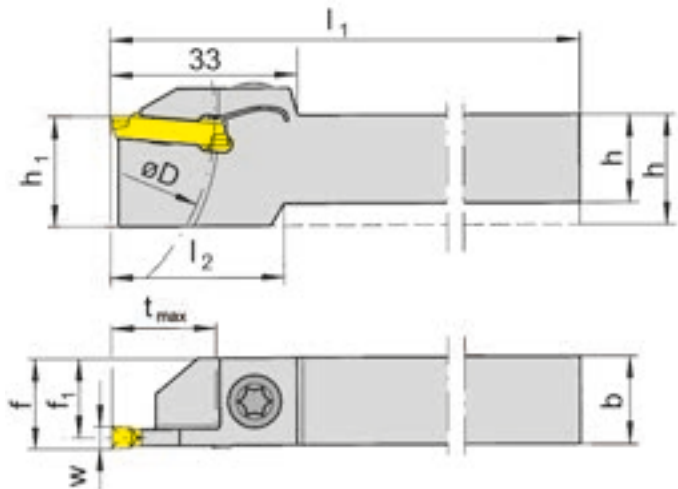
槽深可达
夹持范围

Depth of groove up to
Clamping range

18 mm
3.7-6.1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1608.24	16	8	100	-	16	6.55	f ₁ +w/2	18	80	04	3.7-4.4
R/LH224.1616.24	16	16	125	30	20	14.55	f ₁ +w/2	18	80	04	3.7-4.4
R/LH224.2020.24	20	20	125	-	20	18.55	f ₁ +w/2	18	80	04	3.7-4.4
R/LH224.2525.24	25	25	150	-	25	23.55	f ₁ +w/2	18	80	04	3.7-4.4
R/LH224.1616.25	16	16	125	30	20	14.15	f ₁ +w/2	18	80	05	4.4-5.1
R/LH224.2020.25	20	20	125	-	20	18.15	f ₁ +w/2	18	80	05	4.4-5.1
R/LH224.2525.25	25	25	150	-	25	23.15	f ₁ +w/2	18	80	05	4.4-5.1
R/LH224.1616.26	16	16	125	30	20	13.75	f ₁ +w/2	18	80	06	5.1-6.1
R/LH224.2020.26	20	20	125	-	20	17.75	f ₁ +w/2	18	80	06	5.1-6.1
R/LH224.2525.26	25	25	150	-	25	22.75	f ₁ +w/2	18	80	06	5.1-6.1

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
*D=80mm以内可达t_{max}
*t_{max} up to D = 80 mm
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224.1608.24	4.15T15P	T15PQ
R/LH224...	6.23T25P	T25PQ

切槽和侧车削 (外圆)

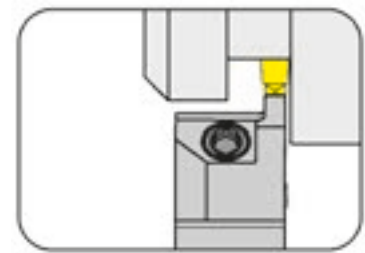
Grooving and Side Turning (external)



刀杆 Toolholder

H224

螺钉夹紧
with screwed clamping



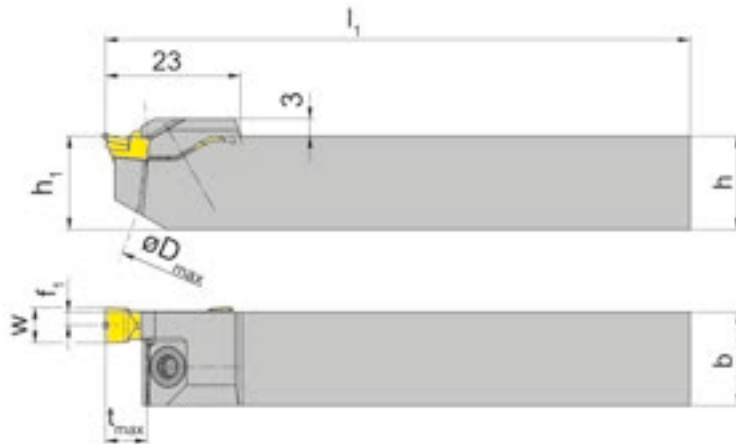
槽深可达
夹持范围

Depth of groove up to
Clamping range

7 mm
2-4,4 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1212.61	12	12	100	12	0.70	7	100	01	2.0-2.4
R/LH224.1616.61	16	16	100	16	0.70	7	100	01	2.0-2.4
R/LH224.2020.61	20	20	100	20	0.70	7	100	01	2.0-2.4
R/LH224.1212.62	12	12	100	12	0.90	7	100	02	2.4-2.8
R/LH224.1616.62	16	16	100	16	0.90	7	100	02	2.4-2.8
R/LH224.2020.62	20	20	100	20	0.90	7	100	02	2.4-2.8
R/LH224.1212.63	12	12	100	12	1.10	7	100	03	2.8-3.7
R/LH224.1616.63	16	16	100	16	1.10	7	100	03	2.8-3.7
R/LH224.2020.63	20	20	100	20	1.10	7	100	03	2.8-3.7
R/LH224.1212.64	12	12	100	12	1.45	7	100	04	3.7-4.4
R/LH224.1616.64	16	16	100	16	1.45	7	100	04	3.7-4.4
R/LH224.2020.64	20	20	100	20	1.45	7	100	04	3.7-4.4

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件 Spare Parts

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

切槽和侧车削 (外圆)

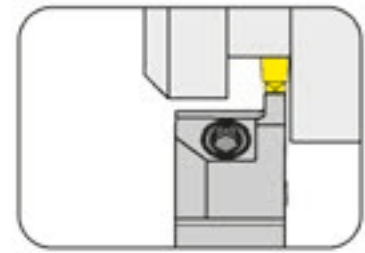
Grooving and Side Turning (external)



刀杆 Toolholder

H224

螺钉夹紧
with screwed clamping



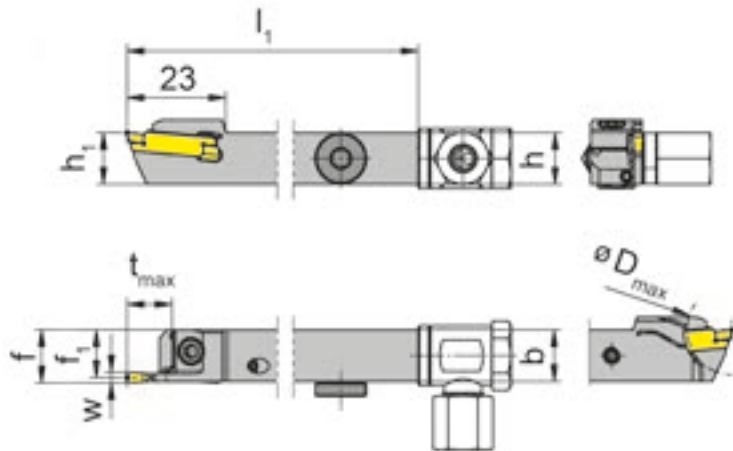
槽深可达
夹持范围

Depth of groove up to
Clamping range

7 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH224.1212...	4.12T15EP	004.00.61	T15PL	-
R/LH224...	4.12T15EP	004.00.16	T15PL	004.00.26

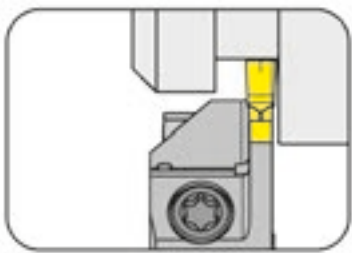
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆
Toolholder

H224



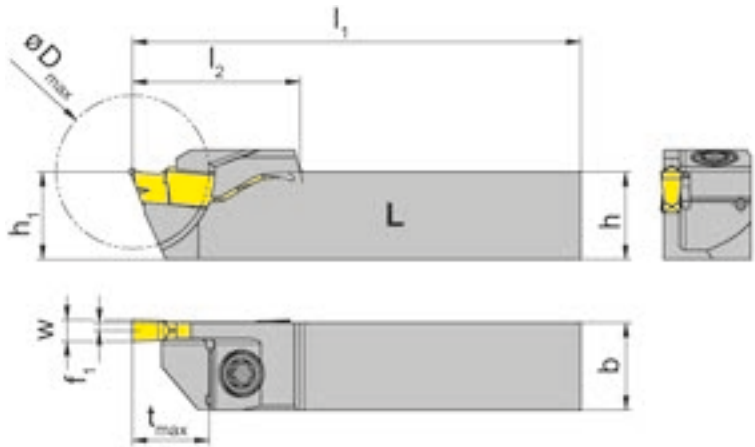
槽深可达
夹持范围

Depth of groove up to
Clamping range

10.5 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

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

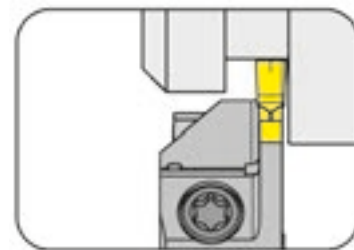
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆 Toolholder

H224



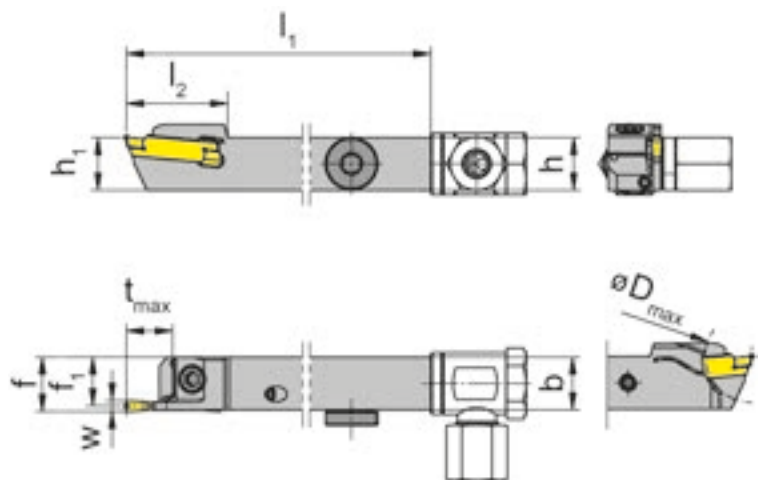
槽深可达
夹持范围

Depth of groove up to
Clamping range

10.5 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1212.20.61.IK	12	12	100	23	12	0.7	$f_1 + w/2$	10.5	21	01	2.0-2.4
R/LH224.1212.20.62.IK	12	12	100	23	12	0.9	$f_1 + w/2$	10.5	21	02	2.4-2.8
R/LH224.1212.20.63.IK	12	12	100	23	12	1.1	$f_1 + w/2$	10.5	21	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	TORX PLUS®扳手 TORX PLUS® Wrench	冷却液供应 Coolant supply
R/LH224...	4.12T15EP	SW2,0 DIN911	T15PQ	004.00.61

切槽和侧车削 (外圆)

Grooving and Side Turning (external)

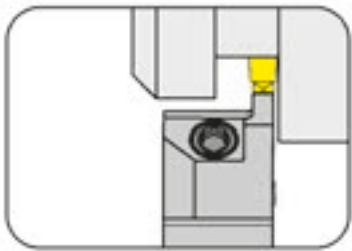


刀杆

Toolholder

H224

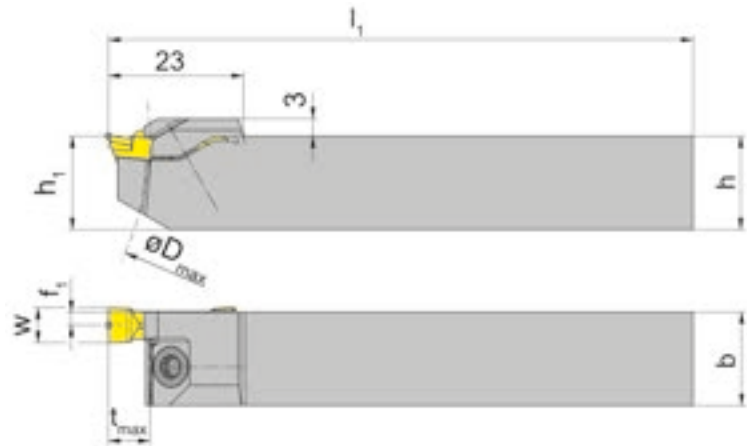
螺钉锁紧
with screwed clamping



槽深可达
夹持范围

Depth of groove up to
Clamping range

7 mm
4,4-6.1 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.65	16	16	100	16	1.85	7	100	05	4.4-5.1
R/LH224.2020.65	20	20	100	20	1.85	7	100	05	4.4-5.1
R/LH224.1616.66	16	16	100	16	2.25	7	100	06	5.1-6.1
R/LH224.2020.66	20	20	100	20	2.25	7	100	06	5.1-6.1

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

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

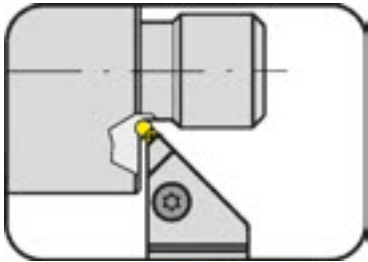
切退刀槽 (外圆)

Grooving Corner Reliefs (external)

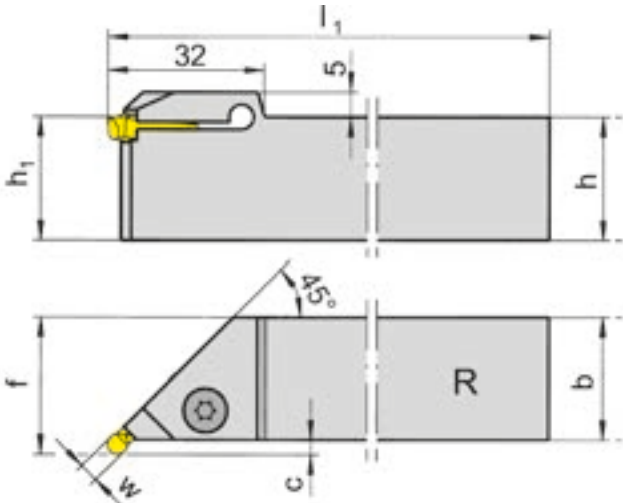


刀杆
Toolholder

H224



槽宽	Width of groove	2-6.1 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 S224...K
Type NS224

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

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

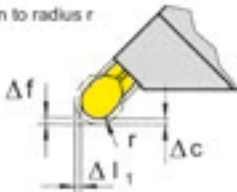
注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w和Dmin见可转位刀片
w and Dmin see indexable inserts

尺寸单位：mm
Dimensions in mm

半径r的相关修正因素 Δl_1 、 Δc 和 Δf
Revision factor Δl_1 , Δc and Δf in relation to radius r

r	Δl_1	Δc	Δf
3,0	0	0	0
2,5	-0,146	-0,146	-0,146
2,0	0	0	0
1,5	-0,146	-0,146	-0,146
1,0	0	0	0



配件
Spare Parts

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

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

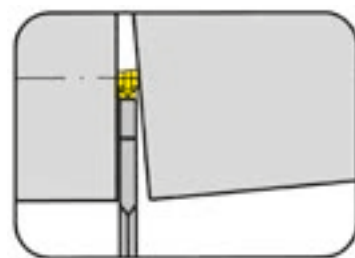
H224

自夹紧
with self clamping

槽深可达
夹持范围

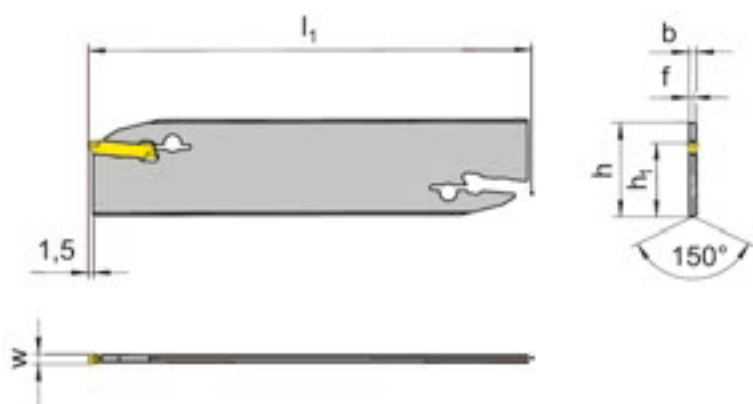
Depth of groove up to
Clamping range

18 mm
2.4-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224



产品型号 Part number	h	b	l ₁	h ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
H224.2602.02	26	1.9	110	21.4	0.95	18	02	2.4-2.8
H224.2603.03	26	2.3	110	21.4	1.15	18	03	2.8-3.7
H224.3203.03	32	2.3	150	24.8	1.15	18	03	2.8-3.7

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

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

切槽和切断

Grooving and Parting Off

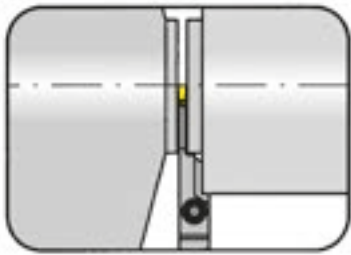


刀杆

Toolholder

H224

加强型
reinforced version



槽深可达
夹持范围

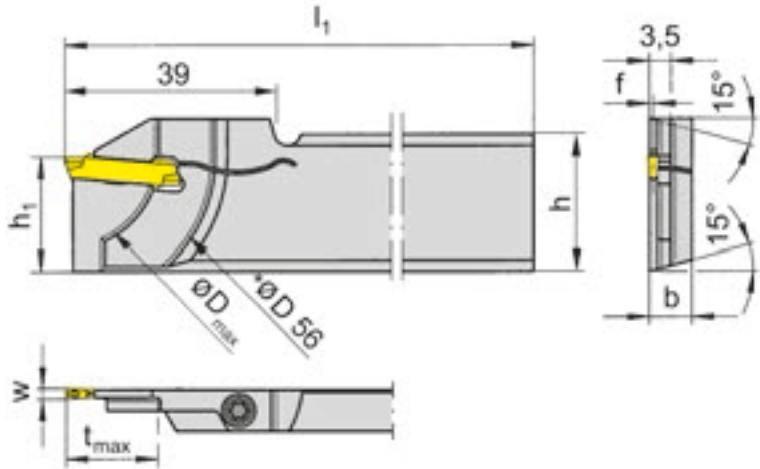
Depth of groove up to
Clamping range

18 mm
2.4-3.7 mm

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

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

*副主轴D_{max}=D56
*D 56 = D_{max} of the subspindle
按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224.2608....	4.15T15P	T15PL
R/LH224.2608.83	4.15T15P	T15PQ

切槽和切断

Grooving and Parting Off

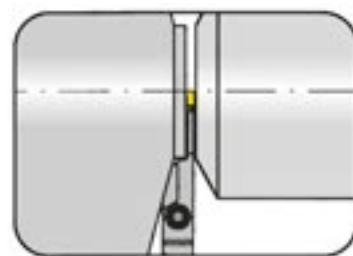


刀杆

Toolholder

H224

加强型
reinforced version



槽深可达
夹持范围

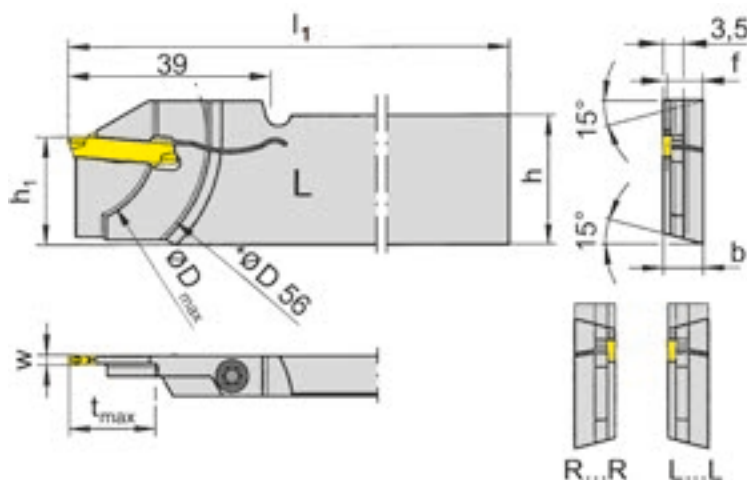
Depth of groove up to
Clamping range

21 mm
2-3.7 mm

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

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

*副主轴D_{max}=D56

*D 56 = D_{max} of the subspindle

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

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

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	4.15T15P	T15PL
R/LH224.3208.83R/L	5.13 T20P	T20PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H224

加强型
reinforced version



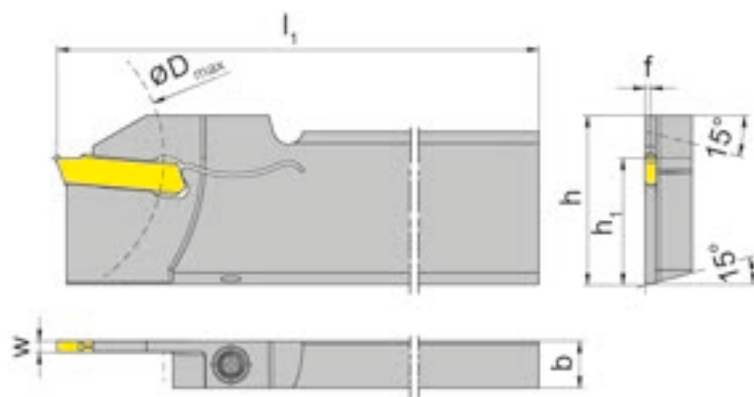
槽深可达
夹持范围

Depth of groove up to
Clamping range

18 mm
2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

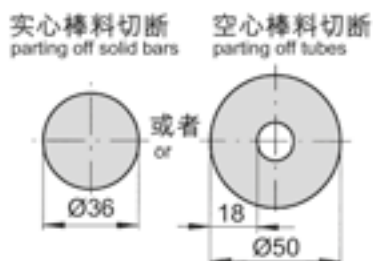
尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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



配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	4.20T15P	T15PL
R/LH224.2608.03	4.20T15P	T15PQ

切槽和切断

Grooving and Parting Off

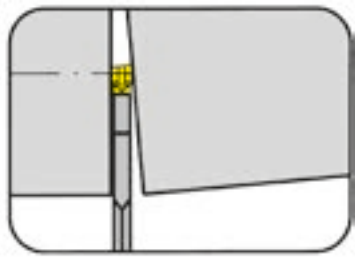


刀杆

Toolholder

H224

螺钉夹紧
with screwed clamping



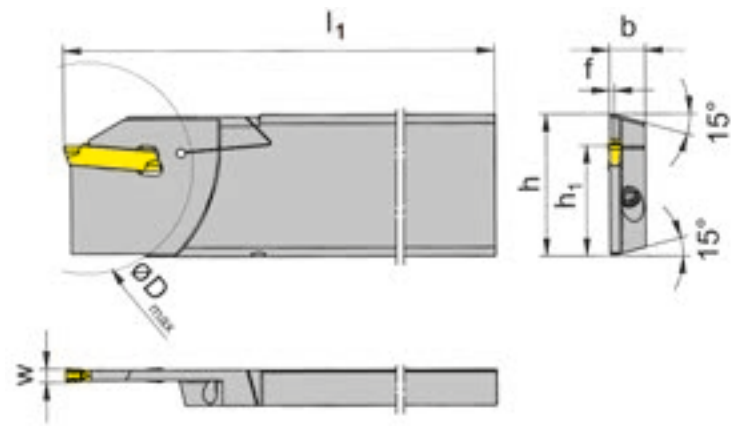
槽深可达
夹持范围

Depth of groove up to
Clamping range

32.5 mm
3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.3208.93	32	8	112	24.8	1.15	32.5	65	03	2.8-3.7

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	紧固螺钉 Pin
R/LH224.3208.93	030.0413.T15P	T15PQ	020.0040.0999

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

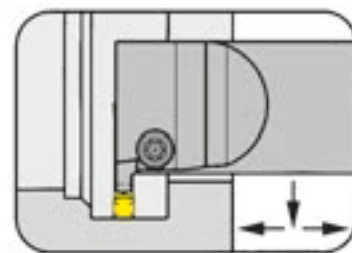
B224

短悬伸
Short style

孔径Ø 自
槽深可达
夹持范围

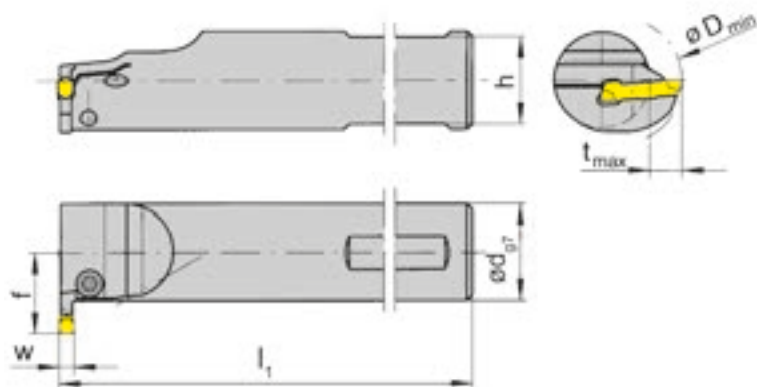
Bore Ø from
Depth of groove up to
Clamping range

30 mm
8 mm
2-6.1 mm



配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

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

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

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

切槽和侧车削 (内圆)

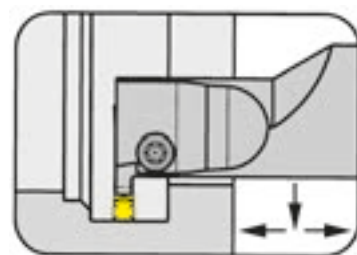
Grooving and Side Turning (internal)



刀杆

Toolholder

B224



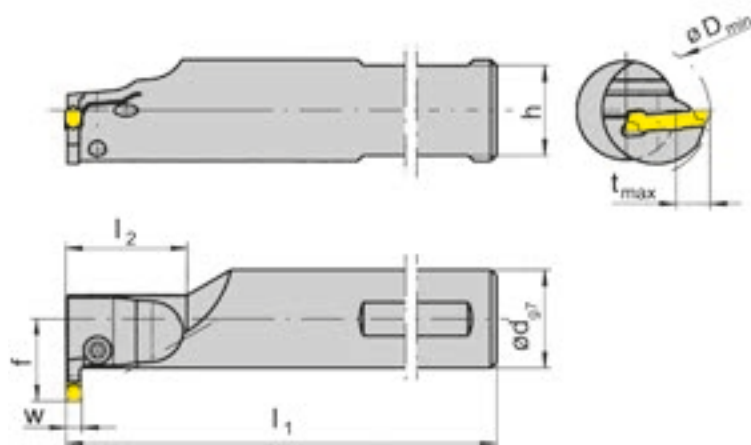
孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

28 mm
8 mm
2-6.1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

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

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

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

配件

Spare Parts

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

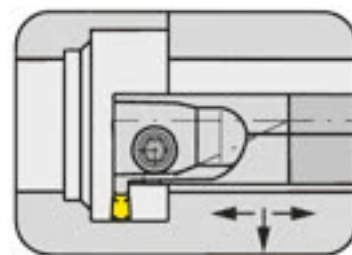
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

B224



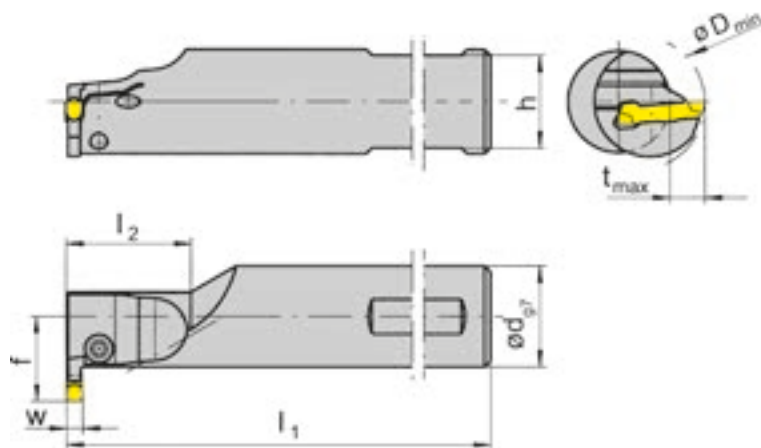
孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

32 mm
13 mm
2,8-6.1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

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

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

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

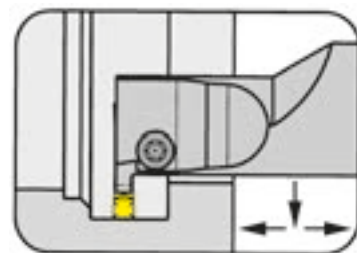
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

B224



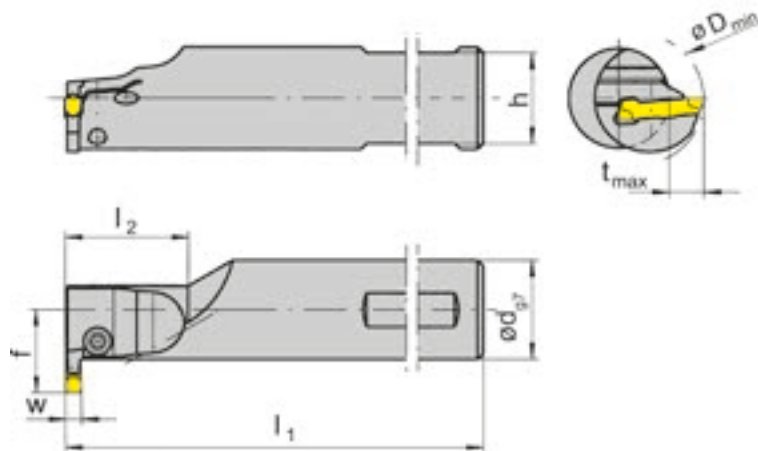
孔径Ø 自
槽深可达
夹持范围

Bore Ø from
Depth of groove up to
Clamping range

28 mm
11 mm
2-4,4 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

配件 Spare Parts

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

切槽和侧车削 (内圆)

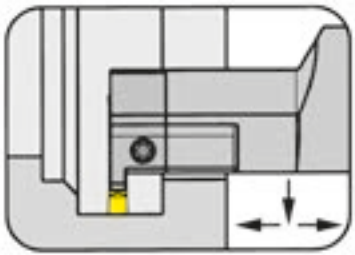
Grooving and Side Turning (internal)



常规刀柄

Basic toolholder

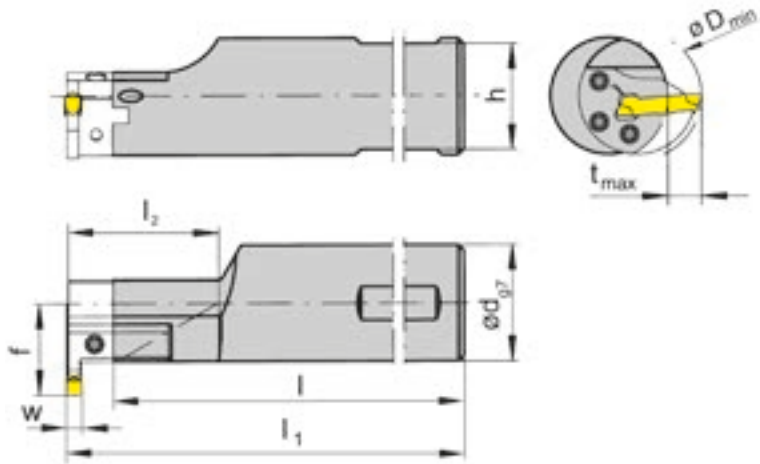
B224
无刀夹
without cassette



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	40 mm 11 mm 2-6.1 mm

配合刀夹
for Cassette

型号 BK224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	l_1	d	l	l_2	h	f
R/LB224.0032.1.K2	$l+b_1+w/2$	32	136.3	30	30	28
R/LB224.0032.2.K2	$l+b_1+w/2$	32	166.3	60	30	28
R/LB224.0040.1.K2	$l+b_1+w/2$	40	166.3	30	38	32
R/LB224.0040.2.K2	$l+b_1+w/2$	40	186.3	60	38	32

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：
D_{min}, t_{max}, w和b₁尺寸，见刀夹
Note:
Dimensions for D_{min}, t_{max} and b₁ see cassettes

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB224...	030.0518T20P	T20PQ

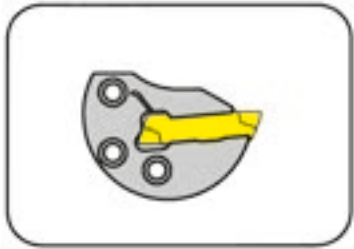
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀夹
Cassette

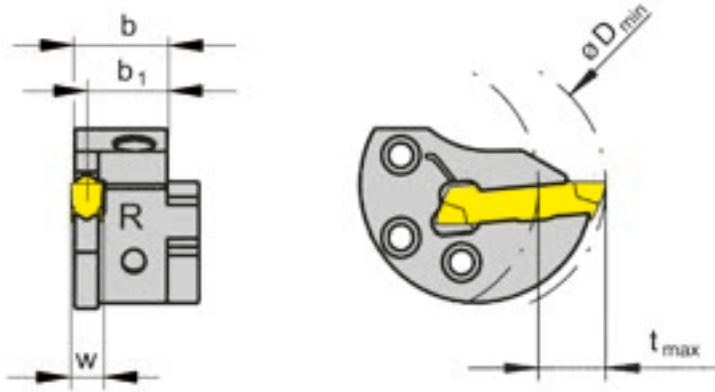
BK224



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	40 mm 11 mm 2-6.1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type NS224



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购
Ordering note:
The fastening screw is combined with the basic toolholder - no sepearte order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

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



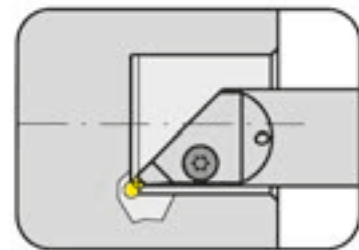
切退刀槽 (内圆)

Grooving Corner Reliefs (internal)



刀杆
Toolholder

224



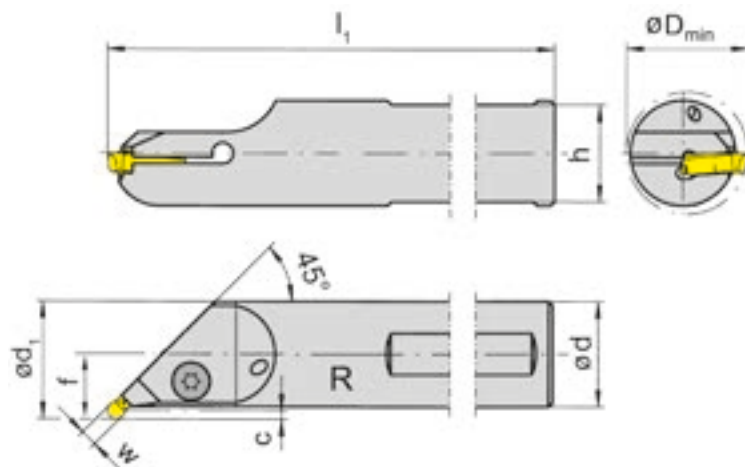
槽宽

Width of groove

2,0 - 6,1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	d	h	l_1	f	C	D_{min}	d_1	槽宽 Width of groove
R/LB224.4520.0.02	20	18	130	13.0	2.5	25.0	23.0	2.0-2.8
R/LB224.4525.0.02	25	23	150	15.5	2.5	29.0	28.0	2.0-2.8
R/LB224.4532.0.02	32	30	150	19.0	2.5	36.0	35.0	2.0-2.8
R/LB224.4540.1.02	40	38	200	23.0	2.5	44.0	43.0	2.0-2.8
R/LB224.4520.0.04	20	18	130	13.0	2.5	25.0	23.0	2.8-4.4
R/LB224.4525.0.04	25	23	150	15.5	2.5	29.0	28.0	2.8-4.4
R/LB224.4532.0.04	32	30	150	19.0	2.5	36.0	35.0	2.8-4.4
R/LB224.4540.1.04	40	38	200	23.0	2.5	44.0	43.0	2.8-4.4
R/LB224.4520.0.06	20	18	130	13.5	3.0	25.0	23.5	4.4-6.1
R/LB224.4525.0.06	25	23	150	16.0	3.0	29.5	28.5	4.4-6.1
R/LB224.4532.0.06	32	30	150	19.0	3.0	36.5	35.5	4.4-6.1

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

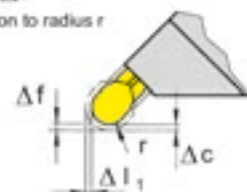
螺丝的扭矩规格, 详见技术说明。

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

半径r的相关修正因素 Δl_1 , Δc 和 Δf

Revision factor Δl_1 , Δc and Δf in relation to radius r

r	Δl_1	Δc	Δf
3,0	0	0	0
2,5	-0,146	-0,146	-0,146
2,0	0	0	0
1,5	-0,146	-0,146	-0,146
1,0	0	0	0



配件

Spare Parts

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

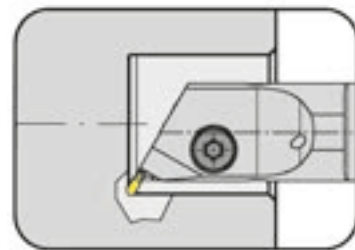
切退刀槽 (内圆)

Grooving Corner Reliefs (internal)



刀杆
Toolholder

224



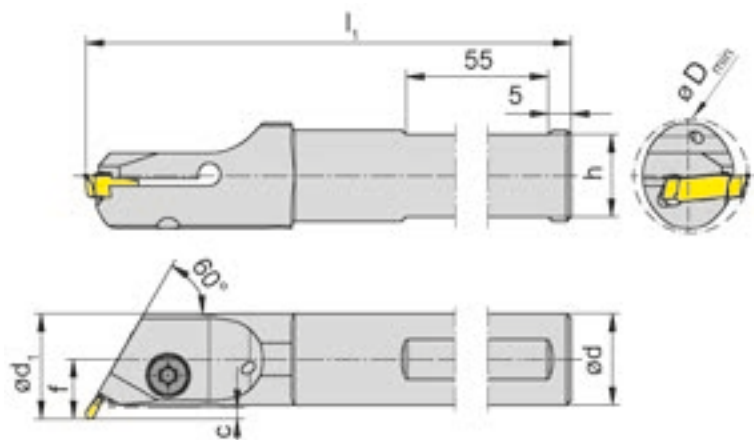
槽宽

Width of groove

2,0 - 6,1 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	d	h	l_1	f	C	D_{min}	d_1	槽宽 Width of groove
R/LB224.6020.0.02	20	18	150	13.0	2.5	25.0	23.0	2.0-2.8
R/LB224.6025.0.02	25	23	150	15.5	2.5	29.0	28.0	2.0-2.8
R/LB224.6032.0.02	32	30	150	19.0	2.5	36.0	35.0	2.0-2.8
R/LB224.6020.0.04	20	18	150	13.0	2.5	25.0	23.0	2.8-4.4
R/LB224.6025.0.04	25	23	150	15.5	2.5	29.0	28.0	2.8-4.4
R/LB224.6032.0.04	32	30	150	19.0	2.5	36.0	35.0	2.8-4.4
R/LB224.6020.0.06	20	18	150	13.5	3.0	25.0	23.5	4.4-6.1
R/LB224.6025.0.06	25	23	150	16.0	3.0	29.5	28.5	4.4-6.1
R/LB224.6032.0.06	32	30	150	19.5	3.0	36.5	35.5	4.4-6.1

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

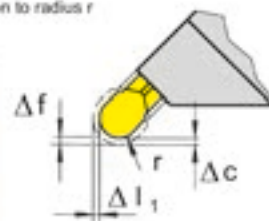
尺寸单位：mm

Dimensions in mm

半径r的相关修正因素 Δl_1 、 Δc 和 Δf

Revision factor Δl_1 , Δc and Δf in relation to radius r

r	Δl_1	Δc	Δf
3,0	0	0	0
2,5	-0,25	-0,067	-0,067
2,0	0	0	0
1,5	-0,25	-0,067	-0,067
1,0	0	0	0



配件

Spare Parts

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

可转位刀片

Indexable insert

S224...3.

精密烧结

precision sintered

断屑槽 Geometry

.3.

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

特点

Characteristics

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

应用

Applications

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

进给率 f

Feed rate f

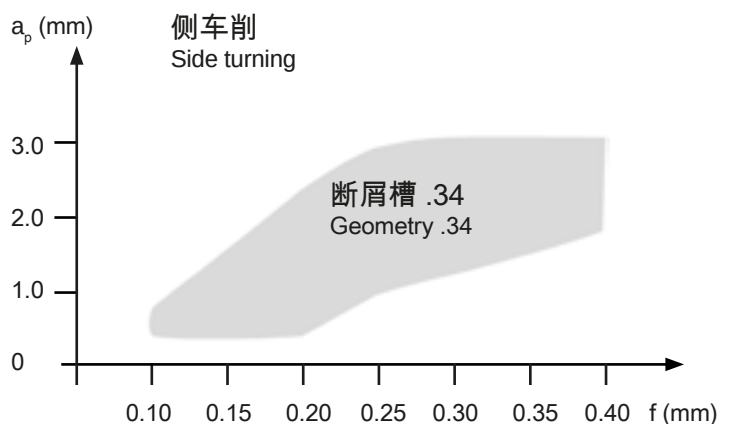
- 切槽: 0.15 可达 0.25 mm/转*
- 侧车削: 可达 0.4 mm/转*
- Grooving: 0.15 up to 0.25 mm/rev*
- Side turning: up to 0.4 mm/rev*

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

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

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

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



229.0500.34加工16MnCr5时切屑控制图表

Chip control graph S224.0500.34 material 16MnCr5

切槽和侧车削

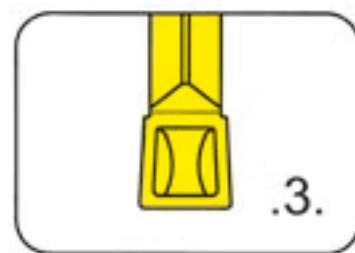
Grooving and Side Turning



可转位刀片

Indexable insert

S224
带卷屑器
with chip former

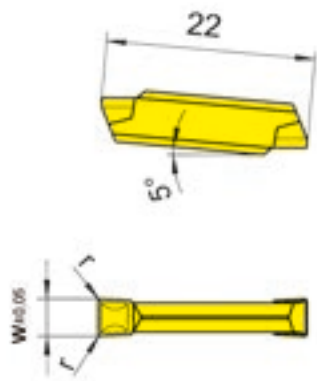


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	H54	TC92	TF45	TI22	TI25	TN32	TN35
S224.0300.32	3	0.2	03	▲	▲	▲	△	▲	▲	△	▲	▲	▲
S224.0300.34	3	0.4	03	▲	▲	▲	△	▲	▲	△	▲	▲	▲
S224.0400.32	4	0.2	04	△	▲	▲	△	△	▲	△	▲	▲	▲
S224.0400.34	4	0.4	04	▲	▲	▲	△	▲	▲	△	▲	▲	▲
S224.0500.34	5	0.4	05	▲	▲	▲	△	△	▲	△	▲	▲	▲
S224.0500.38	5	0.8	05	△	▲	▲	△	△	▲		▲	△	△
S224.0600.34	6	0.4	06	△	▲	▲	△	△	▲		▲	▲	▲
S224.0600.38	6	0.8	06	△	▲	▲	△	△	▲		△	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●	●	●	●	●
● 推荐 / recommended				M	-	-	o	●	-	●	-	-	●
o 次推荐 / alternative recommendation				K	●	-	●	-	-	●	-	-	●
- 不合适 / not suitable				N	●	-	●	-	-	●	-	-	●
非涂层 / uncoated grades				S	-	-	o	-	-	●	-	-	●
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

可转位刀片

Indexable insert

S224...5.

精密烧结

precision sintered



断屑槽 Geometry

.5.

适用于中等强度材料的易切削断屑槽。

Easy cutting geometry for materials with medium strength.

特点

Characteristics

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

应用

Applications

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



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

进给率 f

Feed rate f

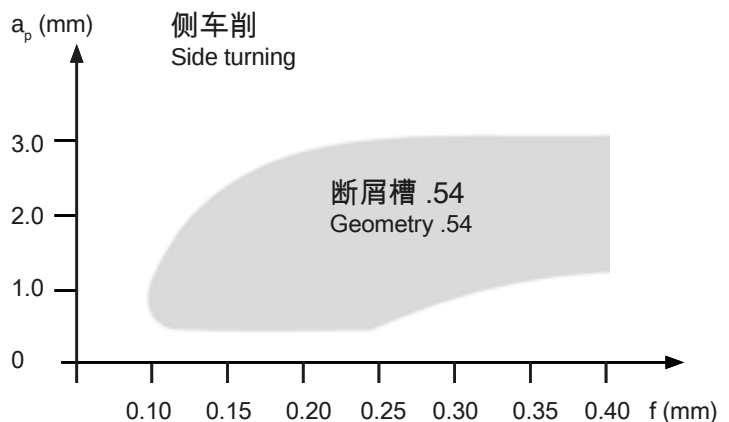
- 切槽: 可达 0.45 mm/转*
- 侧车削: 可达 0.6 mm/转*
- Grooving: up to 0.45 mm/rev*
- Side turning: up to 0.6 mm/rev*

* 取决于刀片宽度

* dependent upon width of insert

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

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



S224.0400.54加工16MnCr5时切屑控制图表

Chip control graph S224.0500.54 material 16MnCr5

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S224

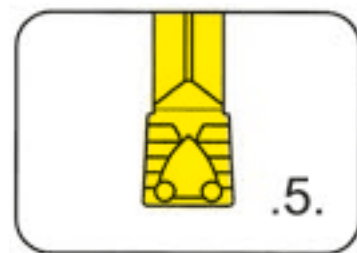
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

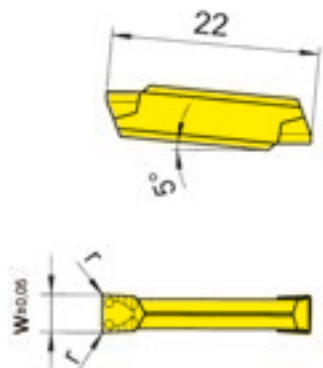
18 mm
2-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224



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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	EG56	H54	TC92	TF45	TI25	TN32	TN35
S224.0200.52	2.0	0.2	01		▲	▲	▲						
S224.0250.52	2.5	0.2	02		▲	▲	▲						
S224.0300.52	3.0	0.2	03	△	▲	▲	▲	△	▲	▲	▲	▲	▲
S224.0300.54	3.0	0.4	03	▲	▲	▲	▲	△	▲	▲	▲	▲	▲
S224.0400.52	4.0	0.2	04	▲	▲	▲	▲	△	△	▲	▲	▲	▲
S224.0400.54	4.0	0.4	04	▲	▲	▲	▲	△	▲	▲	▲	▲	▲
S224.0500.54	5.0	0.4	05	△	▲	▲	▲	△	▲	▲	▲	▲	▲
S224.0500.58	5.0	0.8	05	△	▲	▲	△	△	△	△	▲	△	△
S224.0600.54	6.0	0.4	06	△	▲	▲	▲	△	△	▲	▲	△	▲
S224.0600.58	6.0	0.8	06	△	▲	▲	△	△	△	△	△	△	△
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●	●	●	●	●
● 推荐 / recommended				M	-	-	○	○	●	-	●	-	●
○ 次推荐 / alternative recommendation				K	●	-	●	○	-	●	●	-	●
- 不合适 / not suitable				N	●	-	●	-	-	●	●	-	●
非涂层 / uncoated grades				S	-	-	○	-	-	●	●	-	●
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

可转位刀片

Indexable insert

S224...A.

精密烧结

precision sintered



断屑槽 Geometry

.A.

适用于中等强度材料具有优异断屑效果的断屑槽

Geometry with excellent chip breaking for materials with medium strength

特点

Characteristics

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

应用

Applications

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



进给率 f

Feed rate f

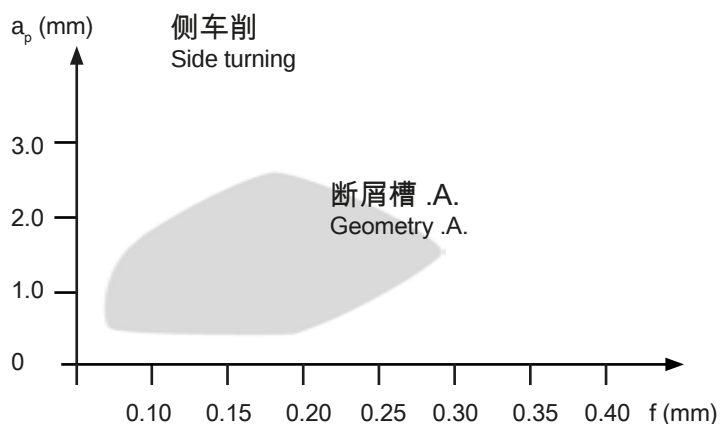
- excellent swarf on a wide feed range
- excellent swarf control, also by partial cutting
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

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

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

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

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



S224.0500.A4加工16MnCr5时切屑控制图表

Chip control graph S224.0500.A4 material 16MnCr5

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

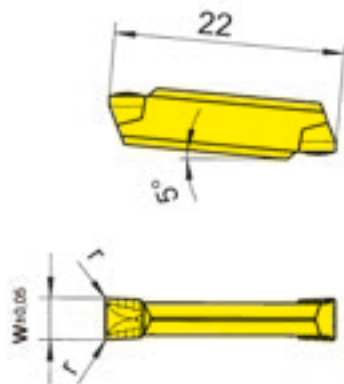


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS65	TC92	TF45	TI22	TI25	TN32	TN35
S224.0300.A2	3	0.2	03	▲	▲		△	▲	△	▲	△	▲
S224.0300.A4	3	0.4	03	△	▲		△	▲	△	▲	▲	▲
S224.0400.A2	4	0.2	04	△	▲		△	△	△	▲	△	▲
S224.0400.A4	4	0.4	04	△	▲	▲	△	▲	△	▲	△	▲
S224.0500.A4	5	0.4	05	△	▲		△	▲	△	▲	▲	▲
S224.0500.A8	5	0.8	05	△	▲		△	△		△	▲	△
S224.0600.A4	6	0.4	06	△	▲		△	△		▲	△	▲
S224.0600.A8	6	0.8	06	△	▲		△	△		△	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●	●	●	●
● 推荐 / recommended				M	-	-	o	-	●	-	-	●
o 次推荐 / alternative recommendation				K	●	-	o	-	●	●	-	●
- 不合适 / not suitable				N	●	-	-	-	●	●	-	●
■ 非涂层 / uncoated grades				S	-	-	-	-	●	-	-	●
■ 涂层 / coated grades				H	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

可转位刀片

Indexable insert

S224...D.

精密烧结

precision sintered

断屑槽 Geometry

.D.

适用于所有材料有切屑成型的断屑槽。

Easy cutting geometry with chip former.

特点

Characteristics

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

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

应用

Applications

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

进给率 f

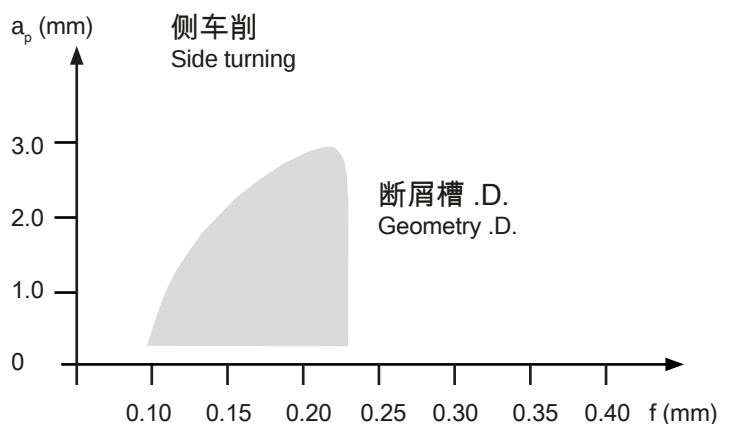
Feed rate f

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

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

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

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



S224.0400.D2加工16MnCr5时切屑控制图表

Chip control graph S224.0300.D2 material 16MnCr5

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

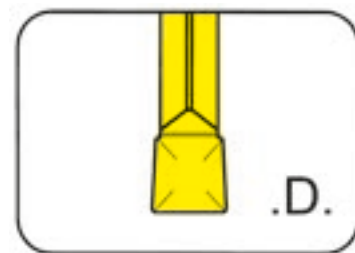
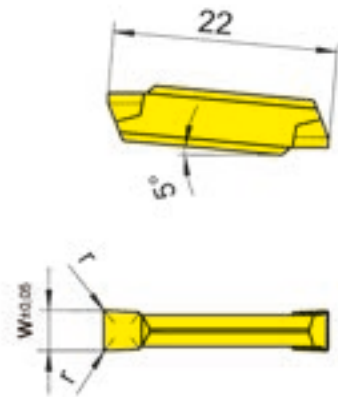
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-4 mm

D2精密烧结/*D2.G精密磨削

D2 precision sintered / *D2.G precision ground



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

*刀片长度重复定位精度
±0.06 mm

*Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size		H54	TF45	TF46	T122	T125	TN32	TN35
S224.0200.D2.G	2,0	0.2	01			x					
S224.0200.D2	2,0	0.2	01		▲	▲	▲		▲	▲	▲
S224.0250.D2.G	2,5	0.2	02				▲	▲			
S224.0250.D2	2,5	0.2	02		Δ	▲	▲		▲	▲	▲
S224.0300.D2.G	3,0	0.2	03			▲	▲	▲			
S224.0300.D2	3,0	0.2	03		▲	▲	▲		▲	▲	▲
S224.0400.D2.G	4,0	0.2	04				▲	▲			
S224.0400.D2	4,0	0.2	04		Δ	▲	▲		▲	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

可转位刀片
Indexable insert

S224...C.

精密烧结
precision sintered

断屑槽
Geometry .C.

切断用断屑槽.
Geometry for parting off.

特点 Characteristics

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

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

应用 Applications

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

进给率 f Feed rate f

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

请注意:

对于左手和右手刀片, 进给率都需在推荐进给率上降低20%到50%。
使用标准的直刀片可以得到最佳的刀具寿命和表面质量。切断实心棒料前需降低进给率。

Please note:

The recommended feedrate has to be reduced by 20-50% with right or left hand inserts.
Best toollife and surfaces will be obtained with neutral inserts. Reduce the feed rate before parting off when machining solid bars.

切槽和切断

Grooving and Parting Off

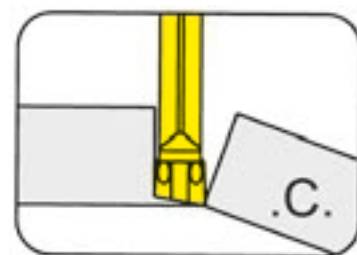


可转位刀片

Indexable insert

S224

带卷屑器
with chip forming



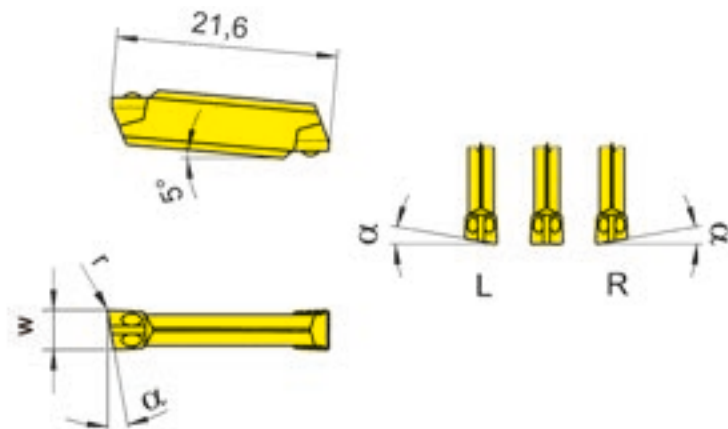
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号

H224

Type

B224

BK224

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	α	尺寸规格 Size	TC92	TF45	TI25	TN35
S224.0020.C1	2.0	0.15	0°	01	▲	▲	▲	▲
R/LS224.0520.C1	2.0	0.15	5°	01	△△	▲/▲		▲/▲
R/LS224.0820.C1	2.0	0.15	8°	01	△△	▲/▲		△△
R/LS224.1520.C1	2.0	0.15	15°	01	△△	▲/▲		▲/▲
S224.0025.C1	2.5	0.15	0°	02	△	▲	▲	▲
R/LS224.0525.C1	2.5	0.15	5°	02	△△	▲/▲		△△
R/LS224.0825.C1	2.5	0.15	8°	02	△△	▲/▲		△△
S224.0030.C1	3.0	0.15	0°	03	△	▲	▲	▲
R/LS224.0530.C1	3.0	0.15	5°	03	△△	▲/▲		▲/▲
R/LS224.0830.C1	3.0	0.15	8°	03	△△	▲/▲		▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S224
带卷屑器
with chip forming

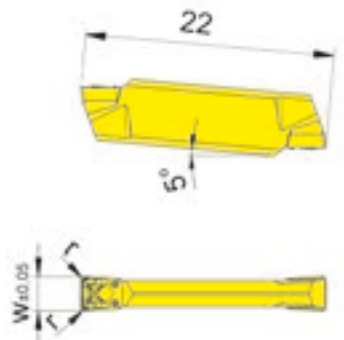


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3 mm

ZG精密磨削
ZG precision ground



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	ALXT
S224.0300.ZG2	3	0.2	03	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

P	●
M	o
K	-
N	-
S	-
H	-

切槽和侧车削

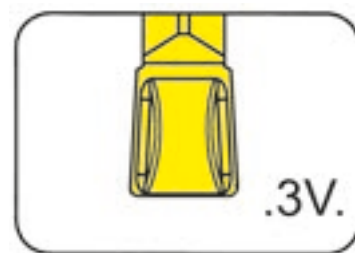
Grooving and Side Turning



可转位刀片

Indexable insert

S224
带卷屑器
with chip former



槽深可达
槽宽

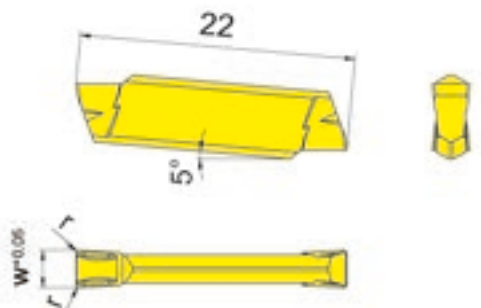
Depth of groove up to
Width of groove

18 mm
2-4 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H224
Type B224
BK224



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

产品型号 Part number	w	r	尺寸规格 Size	AS45	HP65	IG35
S224.0200.3V2	2.0	0.2	01	▲	▲	▲
S224.0250.3V2	2.5	0.2	02	▲	▲	▲
S224.0300.3V2	3.0	0.2	03	▲	▲	▲
S224.0400.3V3	4.0	0.3	04	▲	▲	▲
				P	•	•
				M	•	•
				K	•	•
				N	o	o
				S	•	•
				H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip former

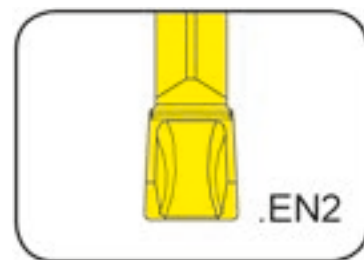
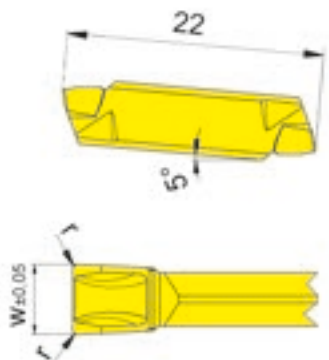
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 H224
Type B224
BK224

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size	AS62	AS65
S224.0200.EN2	2.0	0.2	01	▲	
S224.0250.EN2	2.5	0.2	02	▲	
S224.0300.EN2	3.0	0.2	03	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

P	●	●
M	-	o
K	-	o
N	-	-
S	-	-
H	-	-

硬质合金牌号
Carbide grades

切槽和侧车削

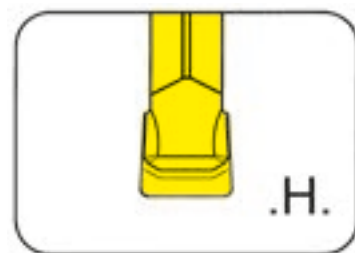
Grooving and Side Turning



可转位刀片

Indexable insert

S224
带断屑槽
with chip breaker

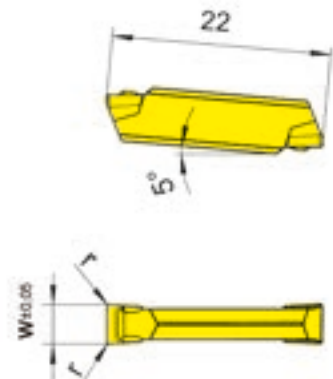


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	TF42
S224.0300.H4	3	0.4	03	▲	▲
S224.0400.H4	4	0.4	04	△	▲
S224.0500.H6	5	0.6	05	▲	▲
S224.0500.H8	5	0.8	05	△	△
S224.0600.H6	6	0.6	06	△	△
S224.0600.H8	6	0.8	06	▲	△
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	•
● 推荐 / recommended				M	-
o 次推荐 / alternative recommendation				K	•
- 不合适 / not suitable				N	•
■ 非涂层 / uncoated grades				S	-
■ 涂层 / coated grades				H	-
■ 钎焊/金属陶瓷 / brazed/Cermet					

尺寸单位 : mm
Dimensions in mm

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

硬质合金牌号
Carbide grades

G

切槽和侧车削

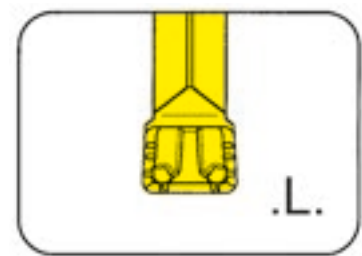
Grooving and Side Turning



可转位刀片

Indexable insert

S224
带卷屑器
with chip forming

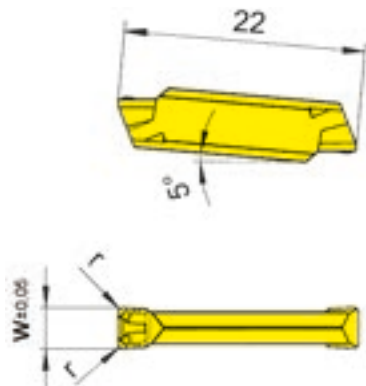


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size		AL96	AS62	AS65	AS66	ASG6	TF42	T122
S224.0300.L4	3	0.4	03			▲	▲	▲	▲		
S224.0400.L4	4	0.4	04		▲	▲		▲		▲	▲
S224.0500.L4	5	0.4	05		▲	▲		▲	△	▲	▲
S224.0500.L6	5	0.6	05		△	▲		▲	△	▲	△
S224.0600.L4	6	0.4	06		△	▲				▲	▲
S224.0600.L6	6	0.6	06		▲	▲			△	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●	●	●
● 推荐 / recommended				M	-	-	○	○	○	-	-
○ 次推荐 / alternative recommendation				K	●	-	○	●	○	-	-
- 不合适 / not suitable				N	●	-	-	●	-	-	-
■ 非涂层 / uncoated grades				S	-	-	-	○	-	-	-
■ 涂层 / coated grades				H	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和侧车削

Grooving and Side Turning



刀片

Insert

S124

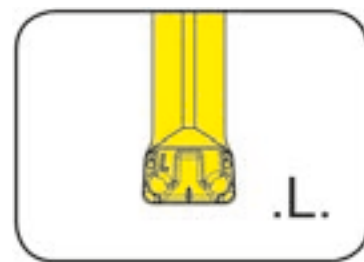
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

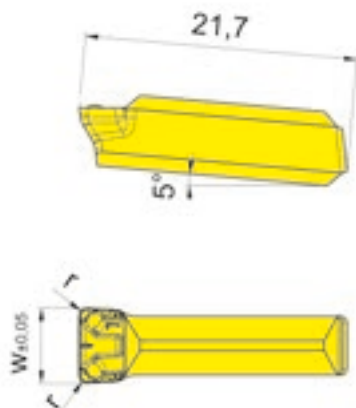
18 mm
6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224



产品型号 Part number	w	r	尺寸规格 Size	AS42	AS46
S124.0600.L6	6	0.6	06	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	AS42	AS46
P	●	○
M	●	○
K	●	●
N	●	○
S	●	○
H	-	-

硬质合金牌号
Carbide grades

G

切槽和切断

Grooving and Parting Off

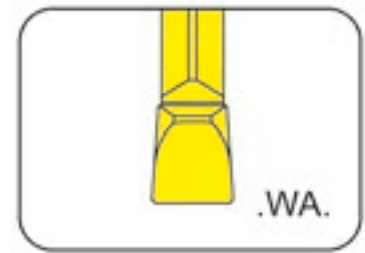


可转位刀片

Indexable insert

S224

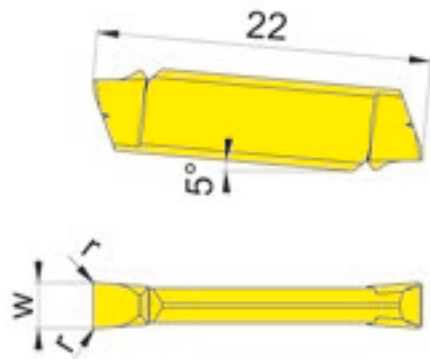
带卷屑器
with chip forming



槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm



配合刀杆
for Toolholder

型号 H224
Type B224
LNK760

G

产品型号 Part number	w	r	尺寸规格 Size		K10	DD26
S224.0200.WA2	2	0.2	01	▲	▲	▲
S224.0300.WA2	3	0.2	03	▲	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
 ● 推荐 / recommended
 ○ 次推荐 / alternative recommendation
 - 不合适 / not suitable

■ 非涂层 / uncoated grades
 ■ 涂层 / coated grades
 ■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
 Dimensions in mm

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

P	●	-
M	○	-
K	●	-
N	●	●
S	○	○
H	-	-

硬质合金牌号
 Carbide grades

切槽和侧车削

Grooving and Side Turning

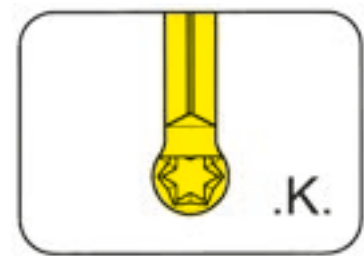


可转位刀片

Indexable insert

S224

带卷屑器
with chip forming



槽深可达
槽宽
圆头

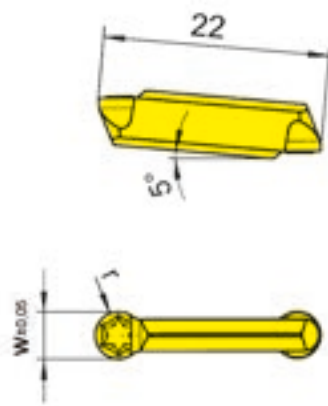
Depth of groove up to
Width of groove
Full radius

18 mm
2-6 mm
1-3 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H224
Type B224
LNK760



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

产品型号 Part number	w	r	尺寸规格 Size
S224.0010.K2	2	1.0	01
S224.0015.K3	3	1.5	03
S224.0020.K4	4	2.0	04
S224.0025.K5	5	2.5	05
S224.0030.K6	6	3.0	06

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	AL96	AS62	AS66	P20	TC92	TF42	TN32	TN35
P	●	●	●	●	●	●	●	●
M	-	-	o	-	-	-	-	●
K	●	-	●	-	-	-	-	●
N	●	-	●	-	-	-	-	●
S	-	-	o	-	-	-	-	●
H	-	-	-	-	-	-	-	-

硬质合金牌号
Carbide grades

使用45° 刀杆加工退刀槽时各尺寸刀片要求的Dmin

D_{min} for corner reliefs with toolholder 45°

t _{max}	S224.0010.K2	S224.0015.K3	S224.0020.K4	S224.0025.K5	S224.0030.K6
0.5	Ø 34	Ø 26	Ø 22	Ø 21	Ø 14
1.0	Ø 54	Ø 36	Ø 26	Ø 22	Ø 18
1.5	Ø 54	Ø 36	Ø 26	Ø 22	Ø 18
2.0	Ø 55	Ø 36	Ø 26	Ø 22	Ø 18
2.5	Ø 56	Ø 36	Ø 26	Ø 22	Ø 18
3.0	-	-	-	Ø 22	Ø 18

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S224
带卷屑器
with chip forming

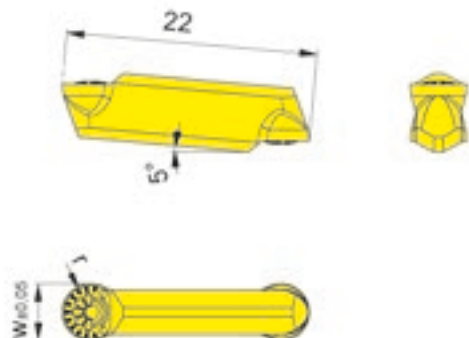


槽深可达
槽宽
圆头

Depth of groove up to
Width of groove
Full radius

18 mm
3-6 mm
1,5-3 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	AS62	AS66	TA42
S224.0015.KF3	3	1,5	03		▲	x
S224.0020.KF4	4	2,0	04		▲	Δ
S224.0025.KF5	5	2,5	05	Δ	▲	x
S224.0030.KF6	6	3,0	06	x	▲	
				P	●	●
				M	-	o
				K	-	●
				N	-	●
				S	-	o
				H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

使用45° 刀杆加工退刀槽时各尺寸刀片要求的Dmin

D_{min} for corner reliefs with toolholder 45°

t _{max}	S224.0010.K2	S224.0015.K3	S224.0020.K4	S224.0025.K5	S224.0030.K6
0.5	Ø 26	Ø 22	Ø 21	Ø 14	Ø 14
1.0	Ø 36	Ø 26	Ø 22	Ø 18	Ø 18
1.5	Ø 36	Ø 26	Ø 22	Ø 18	Ø 18
2.0	Ø 36	Ø 26	Ø 22	Ø 18	Ø 18
2.5	Ø 36	Ø 26	Ø 22	Ø 18	Ø 18
3.0	-	-	Ø 22	Ø 18	Ø 18

切槽和侧车削

Grooving and Side Turning

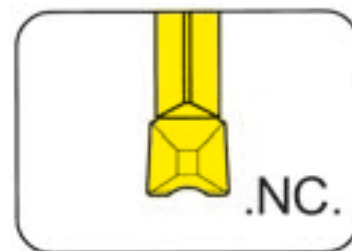


可转位刀片

Indexable insert

S224

带卷屑器
with chip forming



槽深可达
槽宽

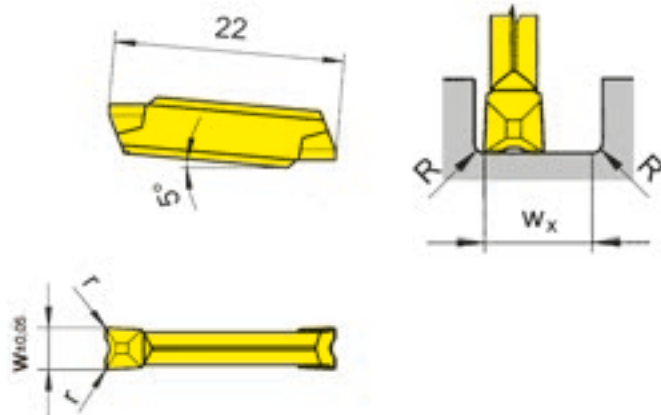
Depth of groove up to
Width of groove

18 mm
2.5-3 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H224
Type B224
BK224



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

产品型号 Part number	w	r	w _x	尺寸规格 Size		TF46	TI22	TI25	TI26
S224.NC25.D2	2.5	0.2	3.6	02		Δ	▲	▲	▲
S224.NC30.D2	3.0	0.2	4.5	03		Δ	▲	▲	▲
						P	•	•	•
						M	o	-	o
						K	•	-	•
						N	•	-	•
						S	o	-	o
						H	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

• 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

w_x = 槽宽 - R_(右) - R_(左)

w_x = width of groove - R_(right) - R_(left)

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip former

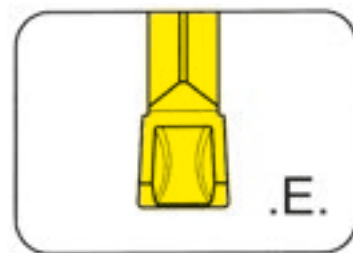
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

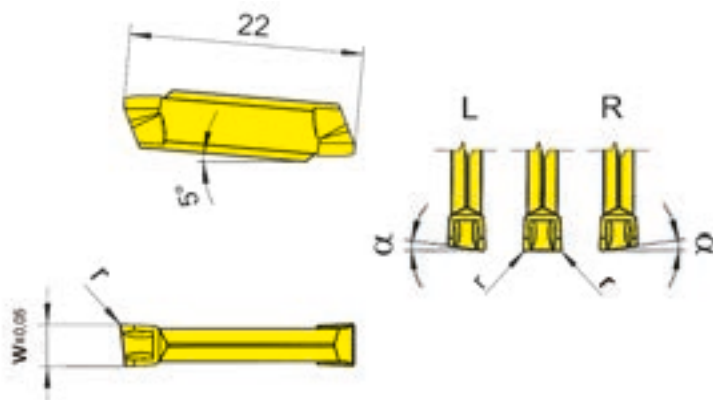
型号

H224

Type

B224

BK224



刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	AL96	AS62	TA43	TC92	TC93	TF43	TF45	TI22	TI25	TN32	TN35
S224.0200.E2	2.0	0.2	0°	01		▲		Δ	Δ	▲	▲				
R/LS224.0520.E2	2.0	0.2	5°	01		▲/▲		Δ/Δ	Δ/Δ	Δ/Δ	x/Δ				
S224.0250.E2	2.5	0.2	0°	02		▲		Δ	Δ	▲	▲				
R/LS224.0525.E2	2.5	0.2	5°	02		▲/Δ		Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ				
S224.0300.E2	3.0	0.2	0°	03	Δ	▲	Δ	Δ	Δ	▲	▲	▲	▲	Δ	Δ
S224.0300.E4	3.0	0.4	-	03	Δ	▲		Δ	Δ	Δ	▲		Δ	Δ	Δ
R/LS224.0530.E2	3.0	0.2	5°	03		▲/▲		Δ/Δ	Δ/Δ	Δ/Δ	▲/▲				
S224.0400.E2	4.0	0.2	0°	04	Δ	▲		Δ	Δ	Δ	▲		Δ	Δ	Δ
S224.0400.E4	4.0	0.4	-	04	Δ	▲		Δ	Δ	Δ	▲		Δ	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	•	•	•	•	•	•	•	•	•	•
● 推荐 / recommended					M	-	-	-	-	-	•	-	•	-	•
○ 次推荐 / alternative recommendation					K	•	-	-	-	-	•	-	•	-	•
- 不合适 / not suitable					N	•	-	-	-	-	•	-	•	-	•
非涂层 / uncoated grades					S	-	-	-	-	-	•	-	•	-	•
涂层 / coated grades					H	-	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet															

尺寸单位：mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

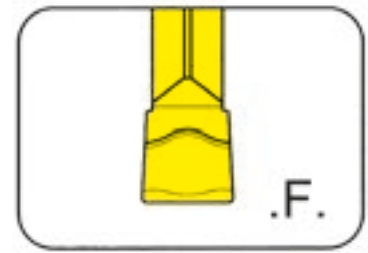
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

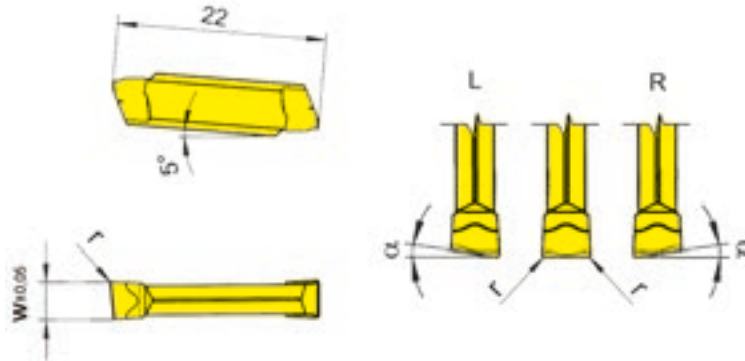
型号

H224

Type

B224

BK224



刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

G

产品型号 Part number	w	r	α	尺寸规格 Size	AL96	TA43	TF42	TF43	TF45	TF46	T122	T125	TN32
S224.0200.F2	2.0	0.2	0°	01	Δ		Δ	▲	▲	▲	▲	▲	Δ
R/LS224.0520.F2	2.0	0.2	5°	01					▲/▲	▲/Δ			
S224.0250.F2	2.5	0.2	0°	02	Δ		Δ	Δ	▲	▲	Δ	Δ	Δ
R/LS224.0525.F2	2.5	0.2	5°	02				▲/Δ	▲/▲				
S224.0300.F2	3.0	0.2	0°	03	Δ	Δ		▲	▲	▲	Δ	▲	Δ
R/LS224.0530.F2	3.0	0.2	5°	03				▲/Δ	▲/▲		Δ/Δ		
S224.0400.F2	4.0	0.2	0°	04	Δ		Δ		▲		▲	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	-	-	○	-	●	-
○ 次推荐 / alternative recommendation					K	●	-	-	-	●	-	●	-
- 不合适 / not suitable					N	●	-	-	-	●	-	●	-
非涂层 / uncoated grades					S	-	-	-	●	○	-	●	-
涂层 / coated grades					H	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

切槽和切断

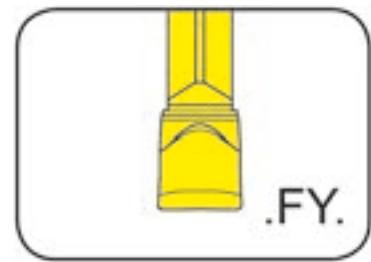
Grooving and Parting Off



可转位刀片 Indexable insert

S224

带卷屑器
with chip forming

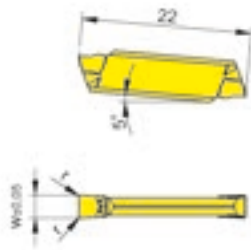


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	w	r	尺寸规格 Size	IG35	TI25
S224.0200.FY2	2.0	0.2	01	▲	▲
S224.0250.FY2	2.5	0.2	02	▲	▲
S224.0300.FY2	3.0	0.2	03	▲	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

切槽和切断

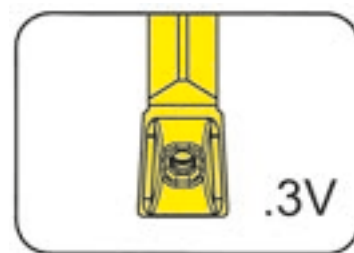
Grooving and Parting Off



可转位刀片

Indexable insert

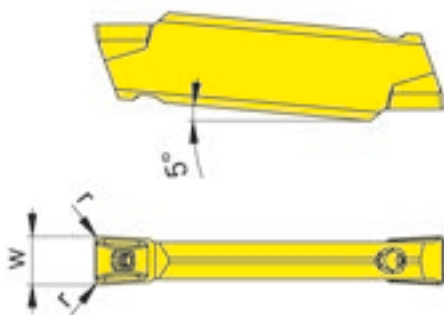
S224
带卷屑器
with chip former



槽宽

Width of groove

3 mm



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

冷却液供应通过刀片
Coolant supply through insert

产品型号 Part number	w	r	尺寸规格 Size	HP65	IG35
S224.0300.3V2.IK	3	0.2	03	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•
● 推荐 / recommended				M	•
o 次推荐 / alternative recommendation				K	•
- 不合适 / not suitable				N	o
■ 非涂层 / uncoated grades				S	•
■ 涂层 / coated grades				H	-
■ 钎焊/金属陶瓷 / brazed/Cermet					

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

G

螺纹切削 (外圆) -全牙型
Threading (external) Full profile

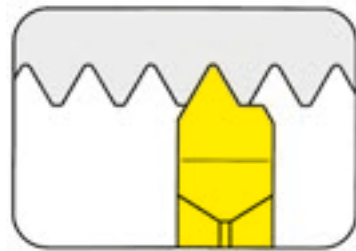


可转位刀片

Indexable insert

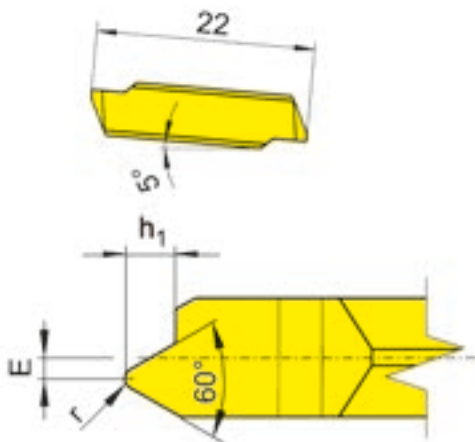
224

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号	H224
Type	B224
	BK224

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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	E	r	h_1	尺寸规格 Size		EG55	TF45
R/LS224.0305.02	0.50	1.0	0.07	0.31	03		▲/△	▲/▲
R/LS224.0407.02	0.75	0.9	0.11	0.46	03		▲/▲	▲/▲
R/LS224.0610.02	1.00	0.8	0.14	0.61	03		▲/▲	▲/▲
R/LS224.0712.02	1.25	0.7	0.15	0.77	03		▲/▲	▲/▲
R/LS224.0915.02	1.50	0.5	0.20	0.92	03		▲/▲	▲/▲
R/LS224.1017.02	1.75	0.4	0.25	1.07	03		▲/△	▲/△
R/LS224.1220.02	2.00	0.3	0.25	1.23	03		▲/△	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

- 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

注明R或L型

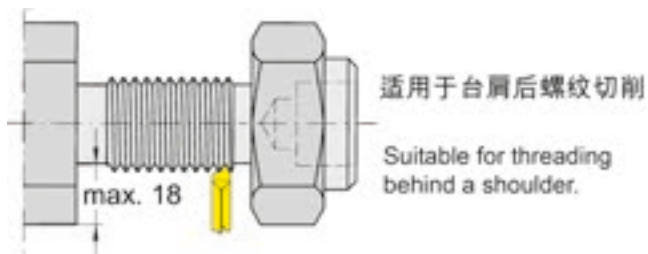
State R or L version

硬质合金牌号

Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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



螺纹切削 (外圆) -全牙型

Threading (external) Full profile

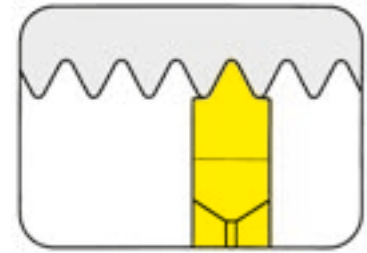


可转位刀片

Indexable insert

NS224

惠氏管螺纹
Whitworth pipe thread

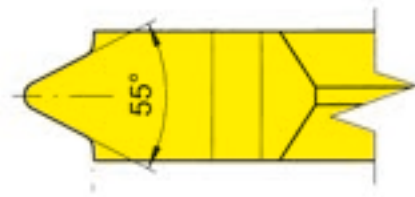
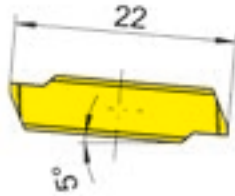


每英寸牙数

Threads per inch

11-28

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H224
Type B224
BK224

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

产品型号 Part number	TPI	尺寸规格 Size	EG55	TA45
NS224.5511.02	11	03	▲	▲
NS224.5514.02	14	03	▲	▲
NS224.5519.02	19	03	▲	▲
NS224.5528.02	28	03	▲	▲
			P	•
			M	○
			K	○
			N	-
			S	-
			H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

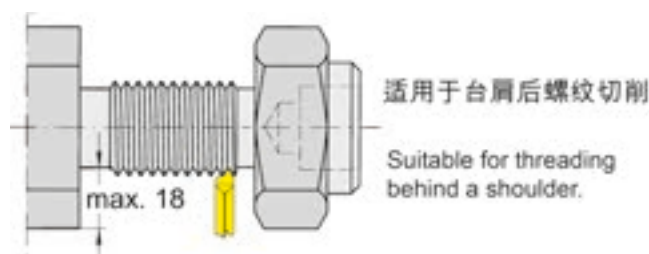
尺寸单位 : mm

Dimensions in mm

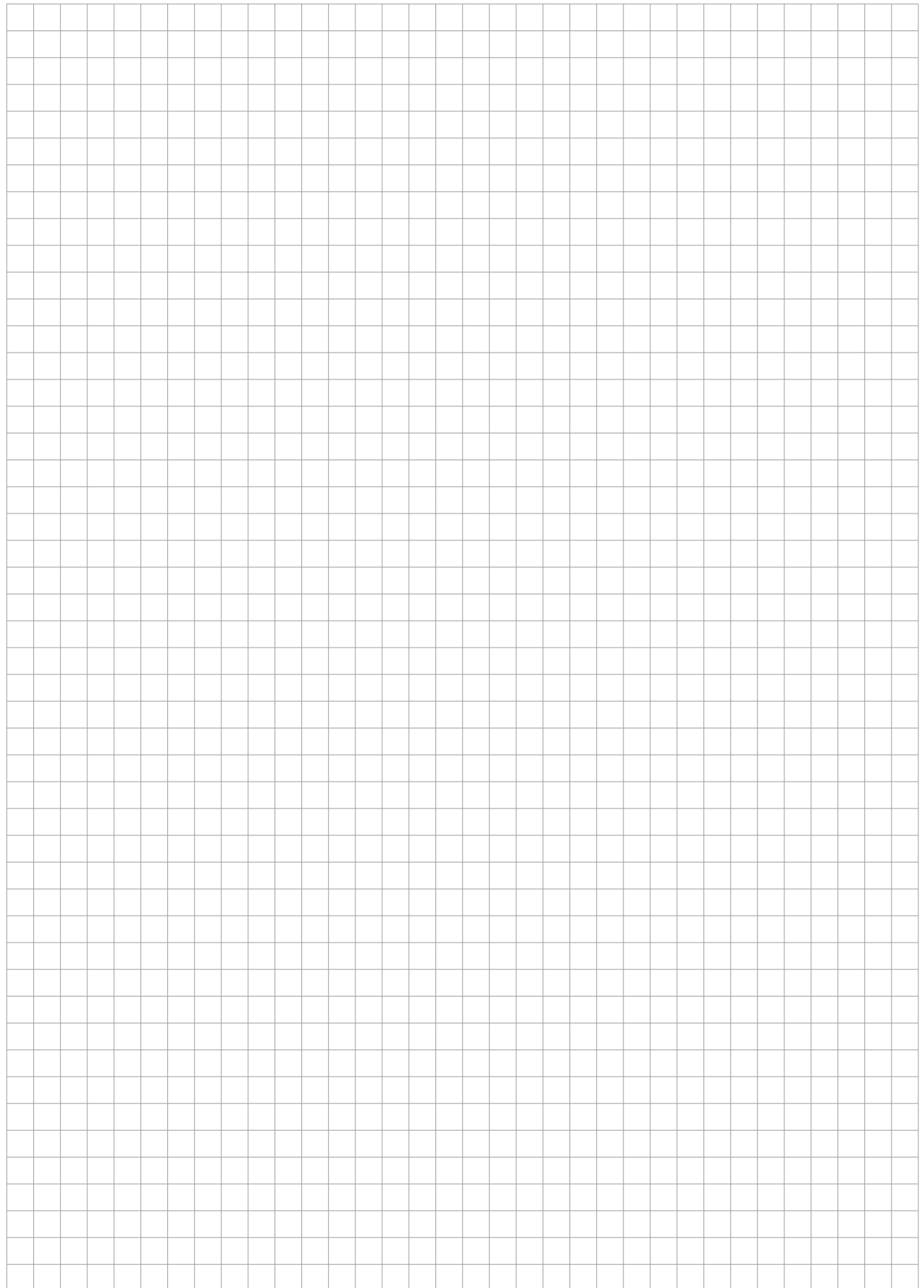
无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

硬质合金牌号
Carbide grades



G





机夹式刀杆

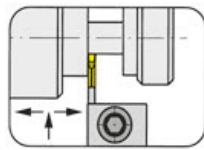
槽宽2.5 - 10 mm

Toolholder with Inserts

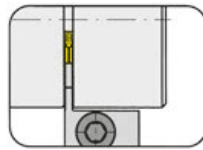
Width of groove 2.5 - 10 mm

H

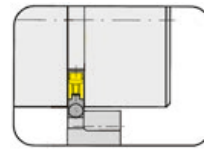
切槽 (外圆) Grooving (external)



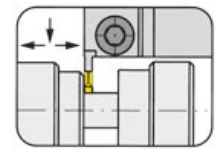
页 / Page H2-H14,H16



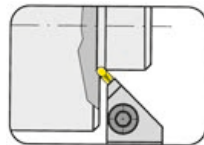
页 / Page H15,H17



页 / Page H18

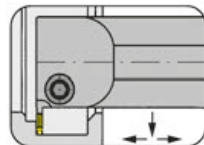


页 / Page H19-H20

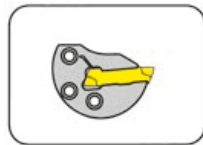


页 / Page H21

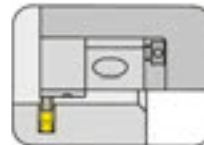
切槽 (内圆) Grooving (internal)



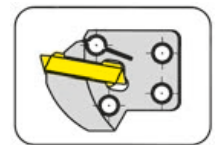
页 / Page H22-H29



页 / Page H30

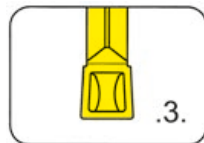


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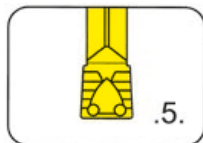


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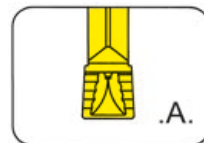
可转位刀片 Indexable inserts S229



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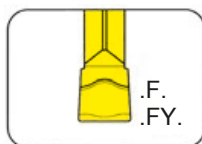
页 / Page H36-H37



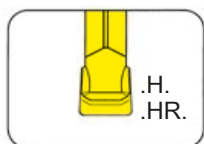
页 / Page H38-H39



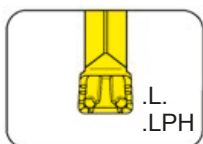
页 / Page H40



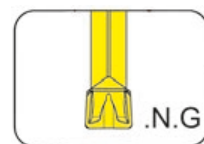
页 / Page H41-H42



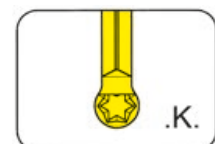
页 / Page H43-H44



页 / Page H45-H46

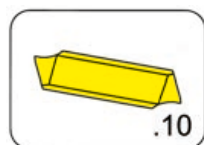


页 / Page H47

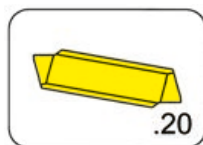


页 / Page H48-H49

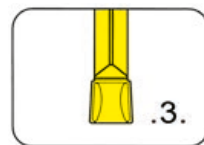
可转位刀片 Indexable inserts 229



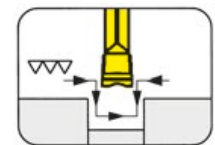
页 / Page H50-H51



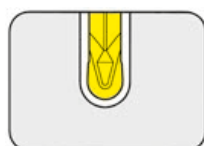
页 / Page H52-H53



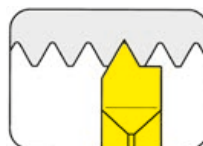
页 / Page H54-H55



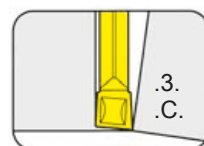
页 / Page H56-H57



页 / Page H58

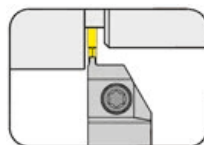


页 / Page H59-H61



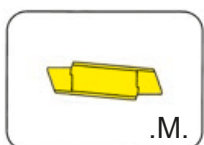
页 / Page H62-H64

刀杆 Toolholder H259



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可转位刀片 Indexable inserts 259



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切槽和侧车削 (外圆)

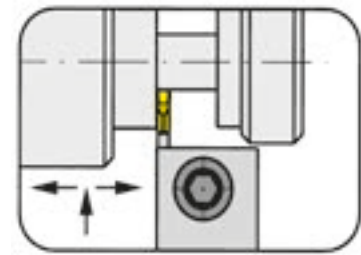
Grooving and Side Turning (external)



常规刀柄

Basic toolholder

210
带可换刀夹
with changeable cassette



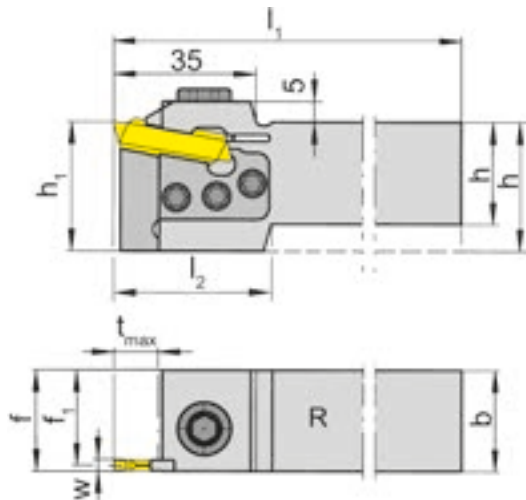
槽深可达
夹持范围

Depth of groove up to
Clamping range

11-11 mm
3-8 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L210.2525.K3	25	25	150	35	32	23.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.3225.K3	32	25	170	-	32	23.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.2525.K4	25	25	150	35	32	22.70	$f_1 + w/2$	11	04	4.0-5.0
R/L210.3225.K4	32	25	150	-	32	22.70	$f_1 + w/2$	11	04	4.0-5.0
R/L210.2525.K5	25	25	150	35	32	22.20	$f_1 + w/2$	11	05	5.1-6.0
R/L210.3225.K5	32	25	170	-	32	22.20	$f_1 + w/2$	11	05	5.1-6.0
R/L210.2525.K7	25	25	150	35	32	21.20	$f_1 + w/2$	11	07	6.1-8.0
R/L210.3225.K7	32	25	170	-	32	21.20	$f_1 + w/2$	11	07	6.1-8.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench	刀夹 Cassette	TORX PLUS®扳手 TORX PLUS® Wrench
R/L210...K3	030.0518T20P	SW6,0 DIN911	NK210.32.03	T20PQ
R/L210...K4	030.0518T20P	SW6,0 DIN911	NK210.32.04	T20PQ
R/L210...K5	030.0518T20P	SW6,0 DIN911	NK210.32.05	T20PQ
R/L210...K7	030.0518T20P	SW6,0 DIN911	NK210.32.07	T20PQ

切槽和侧车削 (外圆)

Grooving and Side Turning (external)

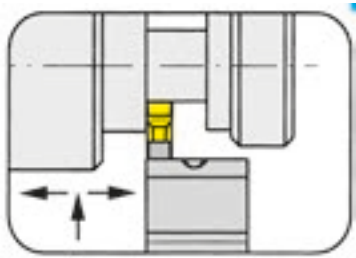


常规刀柄

Basic toolholder

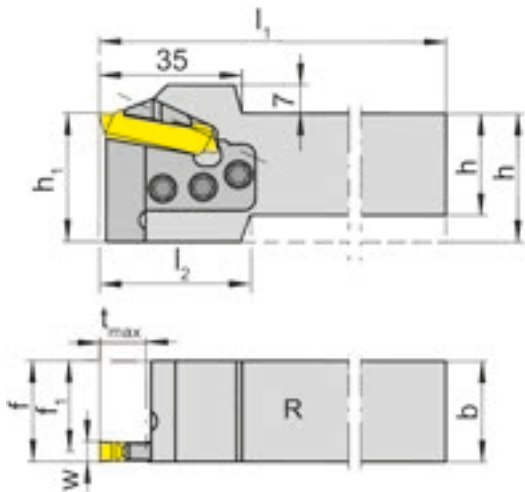
210
带可换刀夹
with changeable cassette

槽深可达 夹持范围	Depth of groove up to Clamping range	11 mm 8.1-10.4 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown
L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L210.2525.K9	25	25	150	35	32	20.2	f ₁ +w/2	11	09	8.1-10.4
R/L210.3225.K9	32	25	170	-	32	20.2	f ₁ +w/2	11	09	8.1-10.4

注明R或L型
State R or L version
w见刀片
w see indexable inserts
尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

注意事项 :
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	刀夹 Cassette	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L210...	030.0518T20P	NK210.32.09	L218.9	T20PQ
R210...	030.0518T20P	NK210.32.09	R218.9	T20PQ

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆

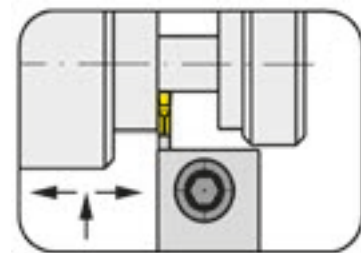
Toolholder

210

槽深可达
夹持范围

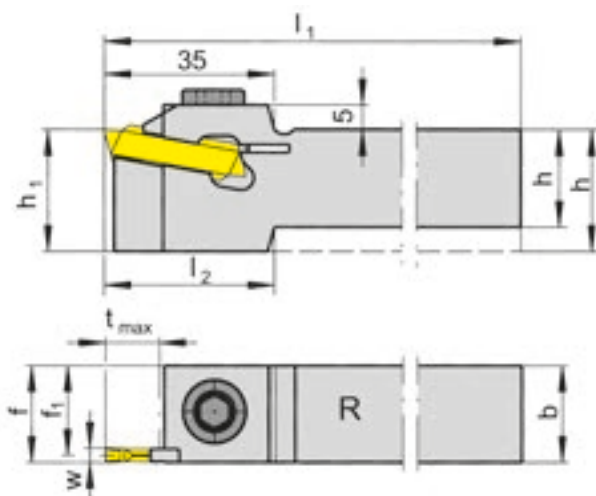
Depth of groove up to
Clamping range

11 mm
2.5-6 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L210.2020.02	20	20	150	35	25	18.55	$f_1 + w/2$	11	02	2.5-3.0
R/L210.2525.02	25	25	150	-	25	23.55	$f_1 + w/2$	11	02	2.5-3.0
R/L210.1616.03	16	16	150	45	25	14.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.2020.03	20	20	150	35	25	18.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.2525.03	25	25	150	-	25	23.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.3225.03	32	25	170	-	32	23.55	$f_1 + w/2$	11	03	3.0-4.0
R/L210.2020.04	20	20	150	35	25	17.70	$f_1 + w/2$	11	04	4.0-5.0
R/L210.2525.04	25	25	150	-	25	22.70	$f_1 + w/2$	11	04	4.0-5.0
R/L210.3225.04	32	25	170	-	32	22.70	$f_1 + w/2$	11	04	4.0-5.0
R/L210.2020.05	20	20	150	35	25	17.20	$f_1 + w/2$	11	05	5.1-6.0
R/L210.2525.05	25	25	150	-	25	22.20	$f_1 + w/2$	11	05	5.1-6.0
R/L210.3225.05	32	25	170	-	32	22.20	$f_1 + w/2$	11	05	5.1-6.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

R/L 210...02在工件直径150mm以下可达最大切深

R/L 210...02 max. depth of groove up to $\varnothing$ 150 mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

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

切槽和侧车削 (外圆)

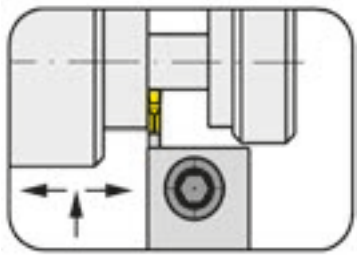
Grooving and Side Turning (external)



刀杆
Toolholder

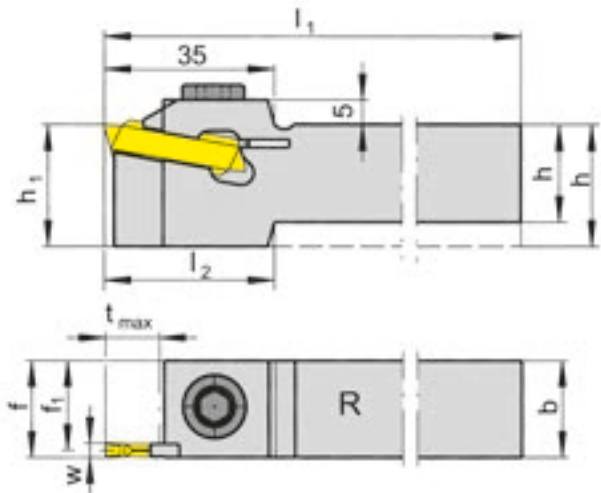
210

槽深可达 夹持范围	Depth of groove up to Clamping range	11 mm 6.1-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

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

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



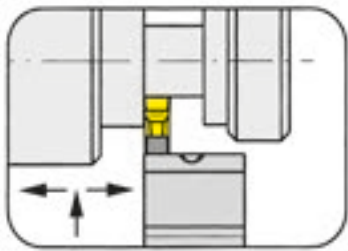
刀杆
Toolholder

210

槽深可达
夹持范围

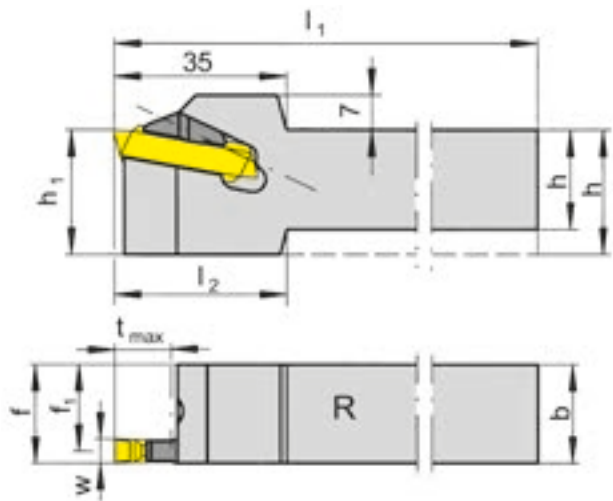
Depth of groove up to
Clamping range

11 mm
8.1-10.4 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L210.2020.09	20	20	150	35	25	15.2	f ₁ +w/2	11	09	8.1-10.4
R/L210.2525.09	25	25	150	-	25	20.2	f ₁ +w/2	11	09	8.1-10.4
R/L210.3225.09	32	25	170	-	32	20.2	f ₁ +w/2	11	09	8.1-10.4

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L210...	L218.9	T15PQ
R210...	R218.9	T15PQ

H

切槽和侧车削 (外圆)

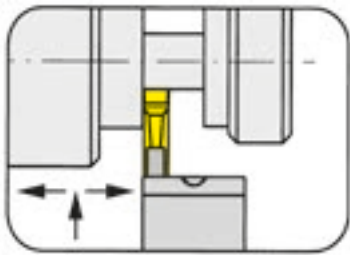
Grooving and Side Turning (external)



常规刀柄

Basic toolholder

218
带可换刀夹
with changeable cassette

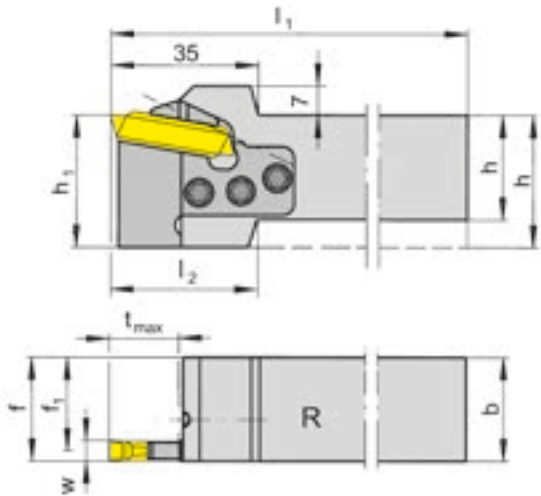


槽深可达 18 mm
夹持范围 8.1-10.4 mm

Depth of groove up to
Clamping range

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2525.K9	25	25	150	48	32	20.2	f ₁ +w/2	18	09	8.1-10.4
R/L218.3225.K9	32	25	170	-	32	20.2	f ₁ +w/2	18	09	8.1-10.4

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

注意事项 :
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	刀夹 Cassette	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L218...	030.0518T20P	NK218.32.09	L218.9	T20PQ
R218...	030.0518T20P	NK218.32.09	R218.9	T20PQ

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



常规刀柄

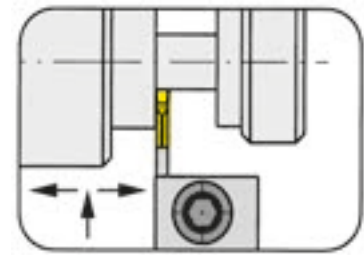
Basic toolholder

218
带可换刀夹
with changeable cassette

槽深可达
夹持范围

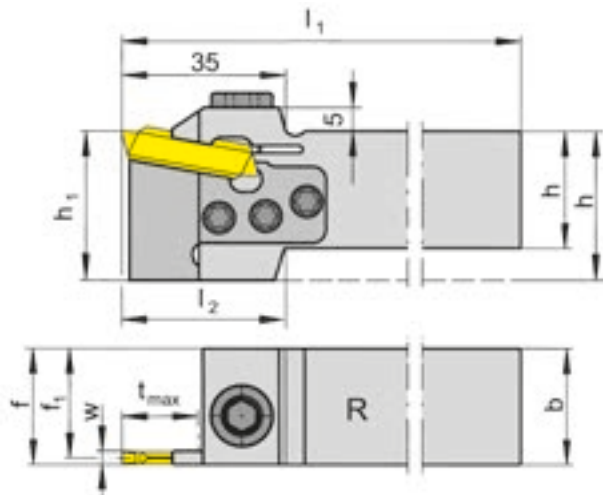
Depth of groove up to
Clamping range

18 mm
3-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2525.K3	25	25	150	35	32	23.55	f ₁ +w/2	18	03	3.0-4.0
R/L218.3225.K3	32	25	170	-	32	23.55	f ₁ +w/2	18	03	3.0-4.0
R/L218.2525.K4	25	25	150	35	32	22.70	f ₁ +w/2	18	04	4.0-5.0
R/L218.3225.K4	32	25	170	-	32	22.70	f ₁ +w/2	18	04	4.0-5.0
R/L218.2525.K5	25	25	150	35	32	22.20	f ₁ +w/2	18	05	5.1-6.0
R/L218.3225.K5	32	25	170	-	32	22.20	f ₁ +w/2	18	05	5.1-6.0
R/L218.2525.K7	25	25	150	35	32	21.20	f ₁ +w/2	18	07	6.1-8.0
R/L218.3225.K7	32	25	170	-	32	21.20	f ₁ +w/2	18	07	6.1-8.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

常规刀柄 Basic toolholder	螺钉 Screw	锁紧螺钉 Screw	扳手 Wrench	刀夹 Cassette	TORX PLUS®扳手 TORX PLUS® Wrench
R/L218...K3	218.3	030.0518T20P	SW6,0 DIN911	NK218.32.03	T20PQ
R/L218...K4	218.3	030.0518T20P	SW6,0 DIN911	NK218.32.04	T20PQ
R/L218...K5	218.3	030.0518T20P	SW6,0 DIN911	NK218.32.05	T20PQ
R/L218...K7	218.3	030.0518T20P	SW6,0 DIN911	NK218.32.07	T20PQ

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆

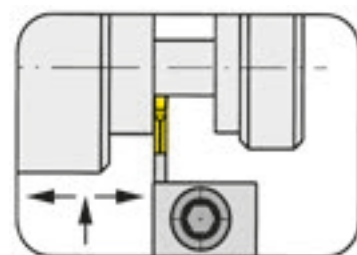
Toolholder

218

槽深可达
夹持范围

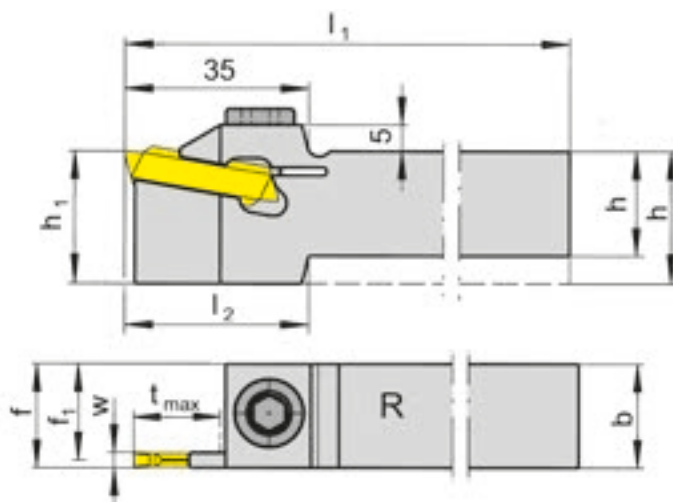
Depth of groove up to
Clamping range

18 mm
2.5-6 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2020.02	20	20	150	35	25	18.55	$f_1 + w/2$	18	02	2.5-3.0
R/L218.2525.02	25	25	150	-	25	23.55	$f_1 + w/2$	18	02	2.5-3.0
R/L218.1616.03	16	16	150	45	25	14.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.2020.03	20	20	150	35	25	18.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.2525.03	25	25	150	-	25	23.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.3225.03	32	25	170	-	32	23.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.2020.04	20	20	150	35	25	17.70	$f_1 + w/2$	18	04	4.0-5.0
R/L218.2525.04	25	25	150	-	25	22.70	$f_1 + w/2$	18	04	4.0-5.0
R/L218.3225.04	32	25	170	-	32	22.70	$f_1 + w/2$	18	04	4.0-5.0
R/L218.2020.05	20	20	150	35	25	17.20	$f_1 + w/2$	18	05	5.1-6.0
R/L218.2525.05	25	25	150	-	25	22.20	$f_1 + w/2$	18	05	5.1-6.0
R/L218.3225.05	32	25	170	-	32	22.20	$f_1 + w/2$	18	05	5.1-6.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

R/L 218...02在小于Ø 80mm可达最大切槽深度

R/L 218...02 max. depth of groove up to Ø 80 mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L218...	218.3	SW6,0 DIN911

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆

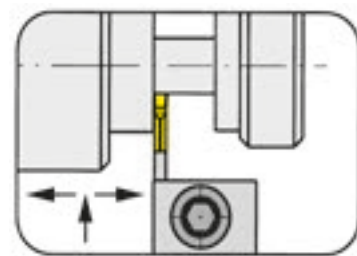
Toolholder

218

槽深可达
夹持范围

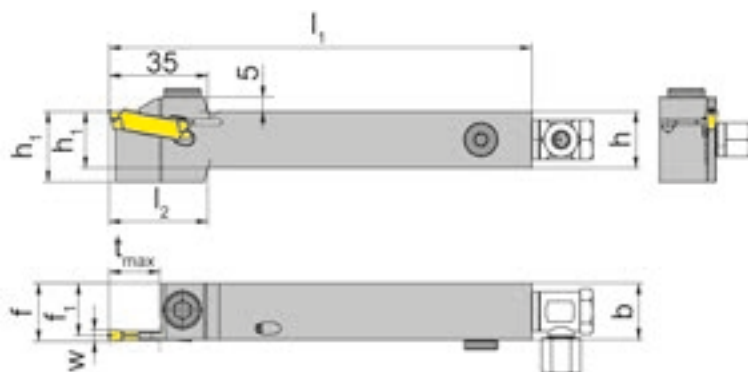
Depth of groove up to
Clamping range

18 mm
2.5-4 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2020.02.IK	20	20	150	35	25	18.55	$f_1 + w/2$	18	02	2.5-3.0
R/L218.2525.02.IK	25	25	150	-	25	23.55	$f_1 + w/2$	18	02	2.5-3.0
R/L218.1616.03.IK	16	16	150	45	25	14.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.2020.03.IK	20	20	150	35	25	18.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.2525.03.IK	25	25	150	-	25	23.55	$f_1 + w/2$	18	03	3.0-4.0
R/L218.3225.03.IK	32	25	170	-	32	23.55	$f_1 + w/2$	18	03	3.0-4.0

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

R/L 218...02在小于Ø 80mm可达最大切槽深度

R/L 218...02 max. depth of groove up to Ø 80 mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	密封塞 Sealing plug	扳手 Wrench	冷却液供应 Coolant supply
R/L218...	218.3	004.00.26	SW6,0 DIN911	SBD 6 LR - G1/8"

切槽和切断

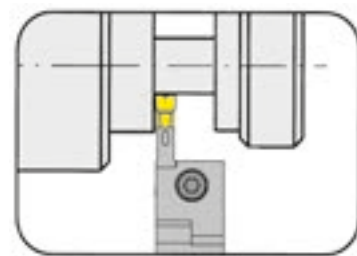
Grooving and Parting Off



刀杆

Toolholder

218
螺钉夹紧
with screwed clamping



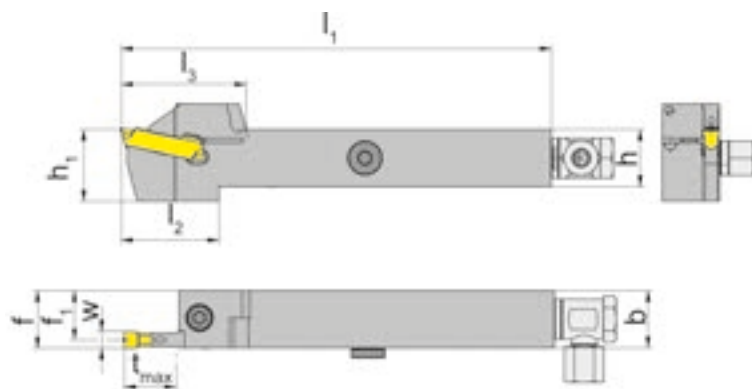
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-6 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/L218.1616.0.03.IK	16	16	150	37	43.5	25	14.55	$f_1 + w/2$	18	03
R/L218.2020.0.03.IK	20	20	150	34	43.5	25	18.55	$f_1 + w/2$	18	03
R/L218.2525.0.03.IK	25	25	150	32	43.5	32	23.55	$f_1 + w/2$	18	03
R/L218.2020.0.04.IK	20	20	150	34	43.5	25	17.70	$f_1 + w/2$	18	04
R/L218.2020.0.05.IK	20	20	150	34	43.5	25	17.20	$f_1 + w/2$	18	05
R/L218.2525.0.04.IK	25	25	150	32	43.5	32	22.70	$f_1 + w/2$	18	04
R/L218.2525.0.05.IK	25	25	150	32	43.5	32	22.20	$f_1 + w/2$	18	05

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R218...	004.00.26	004.00.61	6.23T25P	T25PQ

切槽和侧车削 (外圆)

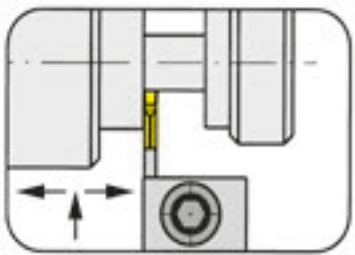
Grooving and Side Turning (external)



刀杆
Toolholder

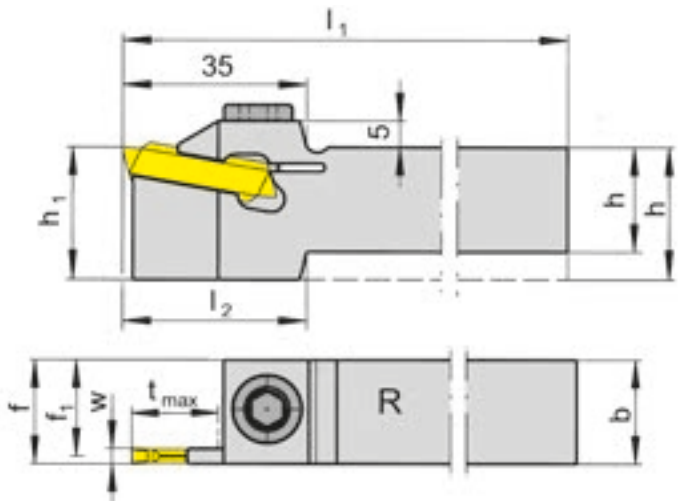
218

槽深可达 夹持范围	Depth of groove up to Clamping range	18 mm 6.1-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2020.07	20	20	150	35	25	16.2	f ₁ +w/2	18	07	6.1-8.0
R/L218.2525.07	25	25	150	-	25	21.2	f ₁ +w/2	18	07	6.1-8.0
R/L218.3225.07	32	25	170	-	32	21.2	f ₁ +w/2	18	07	6.1-8.0
R/L218.2525.08	25	25	150	-	25	21.2	f ₁ +w/2	18	08	7.6-8.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L218...	218.3	SW6,0 DIN911



切槽和侧车削 (外圆)

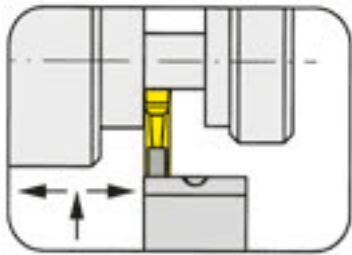
Grooving and Side Turning (external)



刀杆
Toolholder

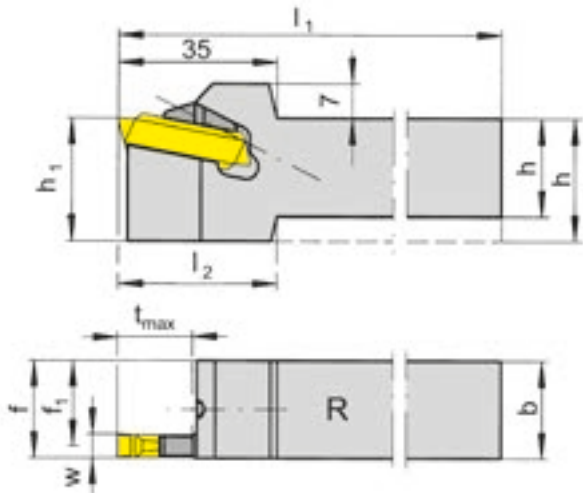
218

槽深可达 夹持范围	Depth of groove up to Clamping range	18 mm 8.1-10.4 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2020.09	20	20	150	35	25	15.2	f ₁ +w/2	18	09	8.1-10.4
R/L218.2525.09	25	25	150	-	25	20.2	f ₁ +w/2	18	09	8.1-10.4
R/L218.3225.09	32	25	170	-	32	20.2	f ₁ +w/2	18	09	8.1-10.4

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

注意事项：
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

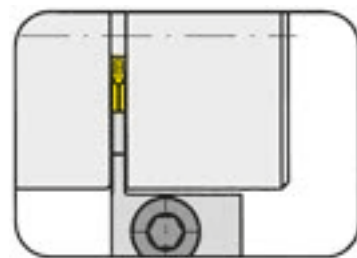
刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L218...	L218.9	T15PQ
R218...	R218.9	T15PQ

切槽 (外圆) Grooving (external)



刀杆 Toolholder

226



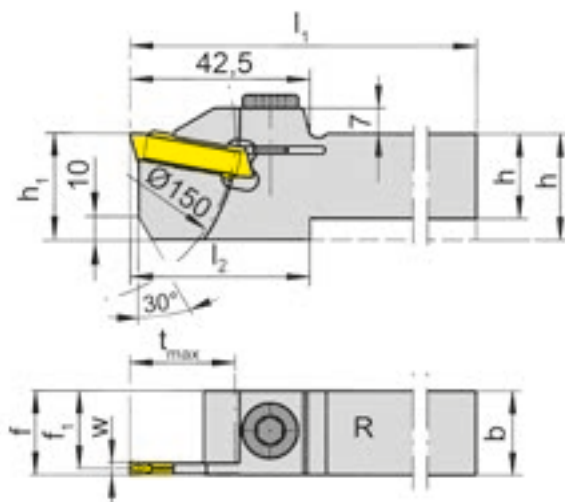
槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
3-6 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L226.1616.03	16	16	150	52.5	32	18.55	f ₁ +w/2	25	03	3.0-4.0
R/L226.2020.03	20	20	150	42.5	32	18.55	f ₁ +w/2	25	03	3.0-4.0
R/L226.2525.03	25	25	150	-	32	23.55	f ₁ +w/2	25	03	3.0-4.0
R/L226.3225.03	32	25	170	-	32	23.55	f ₁ +w/2	25	03	3.0-4.0
R/L226.1616.04	16	16	150	52.5	32	13.70	f ₁ +w/2	25	04	4.0-5.0
R/L226.2020.04	20	20	150	42.5	32	17.70	f ₁ +w/2	25	04	4.0-5.0
R/L226.2525.04	25	25	150	-	32	22.70	f ₁ +w/2	25	04	4.0-5.0
R/L226.3225.04	32	25	170	-	32	22.70	f ₁ +w/2	25	04	4.0-5.0
R/L226.2020.05	20	20	150	42.5	32	17.20	f ₁ +w/2	25	05	5.1-6.0
R/L226.2525.05	25	25	150	42.5	32	22.20	f ₁ +w/2	25	05	5.1-6.0
R/L226.3225.05	32	25	170	-	32	22.20	f ₁ +w/2	25	05	5.1-6.0

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L226...	218.3	SW6,0 DIN911

切槽和切断

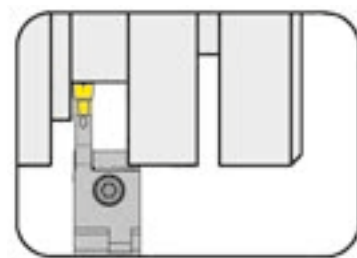
Grooving and Parting Off



刀杆

Toolholder

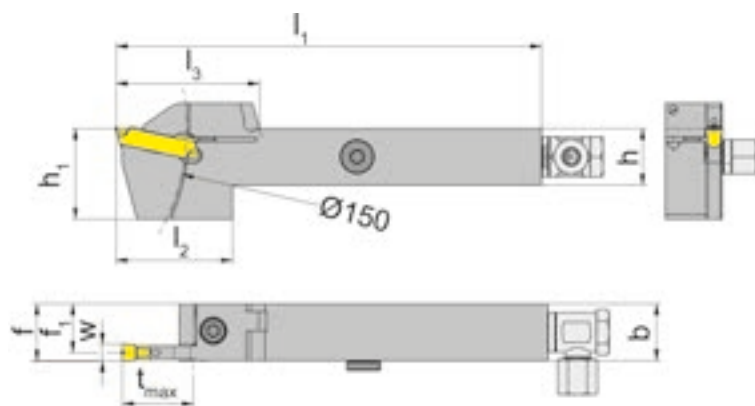
226
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/L226.2020.0.03.IK	20	20	150	41	50.5	32	18.55	$f_1 + w/2$	25	03
R/L226.2525.0.03.IK	25	25	150	39	50.5	32	23.55	$f_1 + w/2$	25	03
R/L226.2020.0.04.IK	20	20	150	41	50.5	32	17.70	$f_1 + w/2$	25	04
R/L226.2525.0.04.IK	25	25	150	39	50.5	32	22.70	$f_1 + w/2$	25	04
R/L226.2020.0.05.IK	20	20	150	41	50.5	32	17.20	$f_1 + w/2$	25	05
R/L226.2525.0.05.IK	25	25	150	39	50.5	32	22.20	$f_1 + w/2$	25	05

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

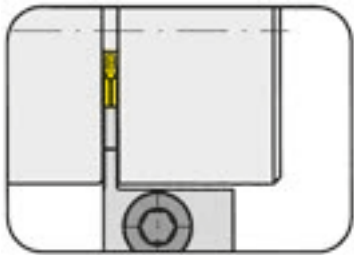
刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L226...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

226



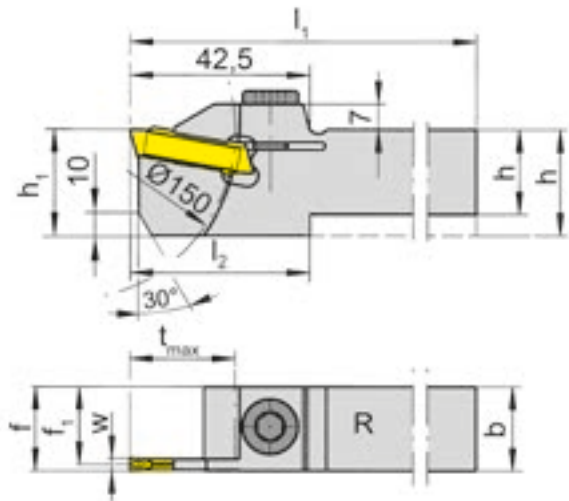
槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
6.1-8 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L226.2525.07	25	25	150	42.5	32	21.2	f ₁ +w/2	25	07	6.1-8.0
R/L226.3225.07	32	25	170	-	32	21.2	f ₁ +w/2	25	07	6.1-8.0
R/L226.2525.08	25	25	150	42.5	32	20.2	f ₁ +w/2	25	08	7.6-8.0
R/L226.3225.08	32	25	170	-	32	21.2	f ₁ +w/2	25	08	7.6-8.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L226...	218.3	SW6,0 DIN911

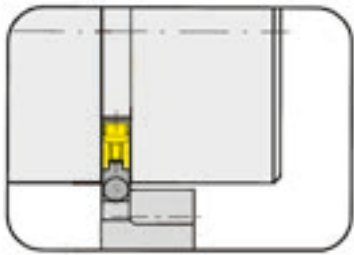
H

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

226



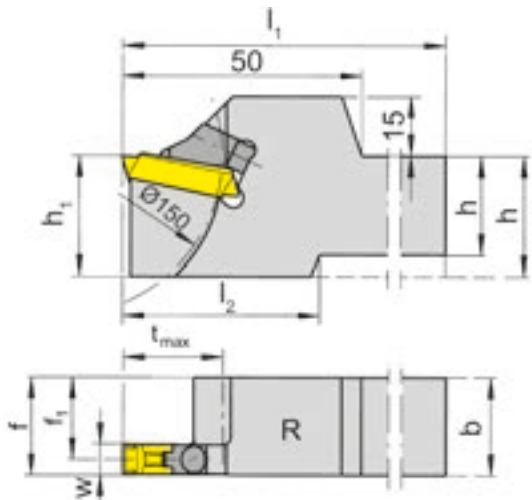
槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
8.1-10.4 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L226.2525.09	25	25	150	42.5	32	20.2	$f_1 + w/2$	25	09	8.1-10.4
R/L226.3225.09	32	25	170	-	32	20.2	$f_1 + w/2$	25	09	8.1-10.4

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L226...	020.1008.0041	T15PQ

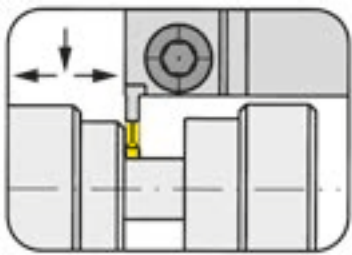
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆
Toolholder

219



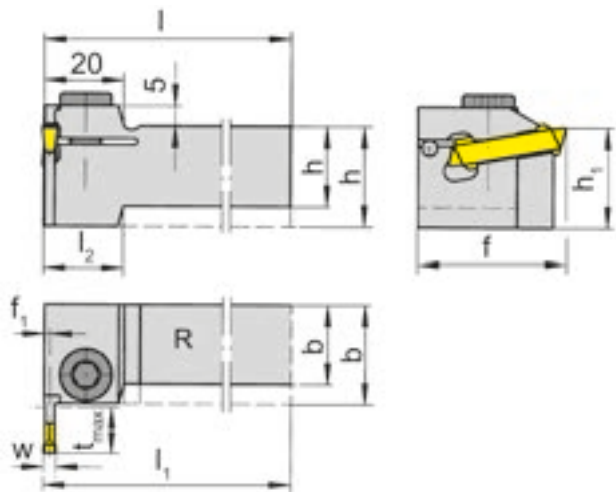
槽深可达
夹持范围

Depth of groove up to
Clamping range

15 mm
3-8 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l	l_1	l_2	h_1	f	f_1	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L219.2020.03	20	20	150	$l-f_1+w/2$	20	25	37	1.45	11	03	3.0-4.0
R/L219.2525.03	25	25	150	$l-f_1+w/2$	-	25	37	1.45	11	03	3.0-4.0
R/L219.2020.04	20	20	150	$l-f_1+w/2$	20	25	37	2.30	11	04	4.0-5.0
R/L219.2525.04	25	25	150	$l-f_1+w/2$	-	25	37	2.30	11	04	4.0-5.0
R/L219.2020.05	20	20	150	$l-f_1+w/2$	23	25	45	2.80	15	05	5.1-6.0
R/L219.2525.05	25	25	150	$l-f_1+w/2$	-	25	45	2.80	15	05	5.1-6.0
R/L219.2020.07	20	20	150	$l-f_1+w/2$	23	25	45	3.80	15	07	6.1-8.0
R/L219.2525.07	25	25	150	$l-f_1+w/2$	-	25	45	3.80	15	07	6.1-8.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L219...	218.3	SW6,0 DIN911

H

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆
Toolholder

219



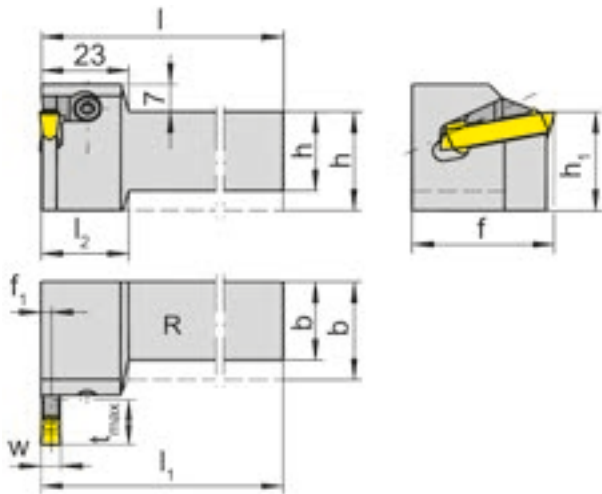
槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
8.1-10.4 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l	l_1	l_2	h_1	f	f_1	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L219.2020.09	20	20	150	$l-f_1+w/2$	23	25	45	4.8	15	09	8.1-10.4
R/L219.2525.09	25	25	150	$l-f_1+w/2$	-	25	45	4.8	15	09	8.1-10.4

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

注意事项 :
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L219....	R218.9.32	T15PQ
R219....	L218.9.32	T15PQ

切退刀槽 (外圆)

Grooving Corner Reliefs (external)

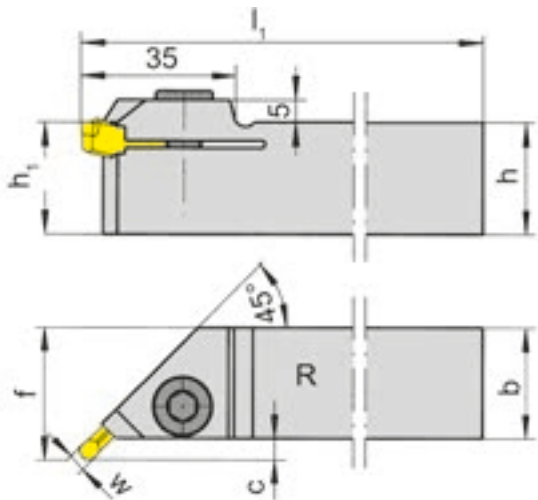


刀杆
Toolholder

225



槽宽 Width of groove 3-6 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229

产品型号 Part number	h	b	l_1	h_1	f	C	D_{min}	槽宽 Width of groove
R/L225.2525.04	25	25	150	25	30.0	5.0	50	3.0-5.0
R/L225.2525.05	25	25	150	25	30.5	5.5	50	5.1-6.0

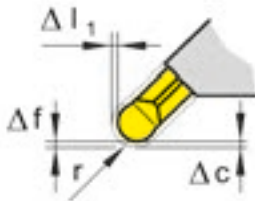
注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

半径r的相关修正因素 Δl_1 Δc 和 Δf
Revision factor Δl_1 , Δc and Δf in relation to radius r

r	Δl_1	Δc	Δf
2,5 - 3,0	0,000	0,000	0,000
2,0	-0,147	-0,147	-0,147
1,5	-0,293	-0,293	-0,293



配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L225...	218.3	SW6,0 DIN911

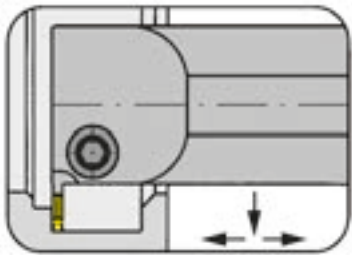
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆
Toolholder

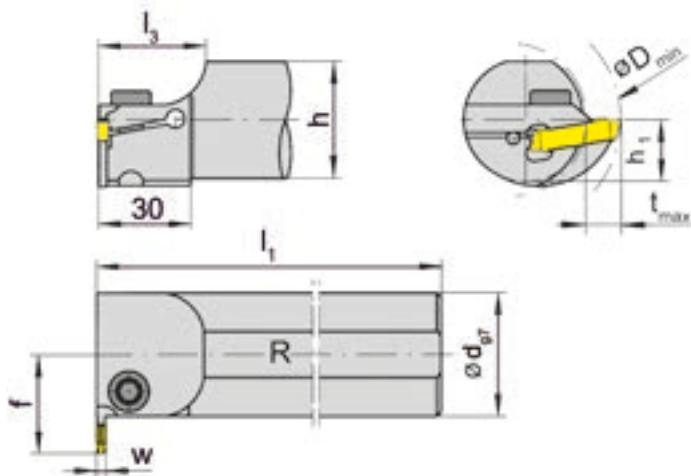
213
短悬伸
Short style



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	46 mm 11.5 mm 3-6 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₃	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L213.0032.0.03	32	150	35.0	30	15	28	11.5	46	03	3.0-4.0
R/L213.0040.0.03	40	180	39.4	38	19	32	11.5	54	03	3.0-4.0
R/L213.0032.0.04	32	150	35.0	30	15	28	11.5	46	04	4.0-5.0
R/L213.0040.0.04	40	180	39.4	38	19	32	11.5	54	04	4.0-5.0
R/L213.0032.0.05	32	150	35.0	30	15	28	11.5	46	05	5.1-6.0
R/L213.0040.0.05	40	180	39.4	38	19	32	11.5	54	05	5.1-6.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L213...	218.3	SW6,0 DIN911

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆 Toolholder

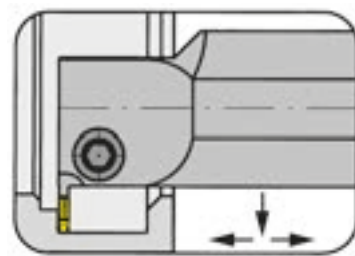
213

短悬伸
Short style

孔径Ø 自
槽深可达
夹持范围

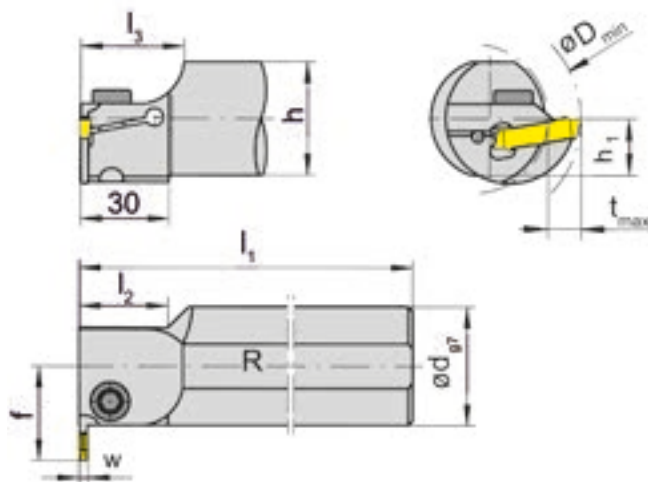
Bore Ø from
Depth of groove up to
Clamping range

38 mm
15 mm
3-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	l ₃	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L213.0025.03	25	150	-	31.8	23	11.5	24.5	7.5	38	03	3.0-4.0
R/L213.0032.03	32	150	30	35.0	30	15.0	28.0	7.5	38	03	3.0-4.0
R/L213.0040.03	40	180	30	37.4	38	19.0	32.0	11.5	50	03	3.0-4.0
R/L213.0050.03	50	200	30	39.1	47	23.5	40.5	15.0	60	03	3.0-4.0
R/L213.0025.04	25	150	-	31.8	23	11.5	24.5	7.5	38	04	4.0-5.0
R/L213.0032.04	32	150	30	35.0	30	15.0	28.0	7.5	38	04	4.0-5.0
R/L213.0040.04	40	180	30	37.4	38	19.0	32.0	11.5	50	04	4.0-5.0
R/L213.0050.04	50	200	30	39.1	47	23.5	40.5	15.0	60	04	4.0-5.0
R/L213.0032.05	32	150	-	35.0	30	15.0	28.0	11.5	46	05	5.1-6.0
R/L213.0040.05	40	180	30	35.0	38	19.0	32.0	11.5	50	05	5.1-6.0
R/L213.0050.05	50	200	30	40.0	47	23.5	40.5	15.0	60	05	5.1-6.0
R/L213.0040.07	40	180	30	35.0	38	19.0	32.0	11.5	50	07	6.1-8.0
R/L213.0050.07	50	200	30	40.0	47	23.5	40.5	15.0	60	07	6.1-8.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

请注意刀杆柄径为Ø 25或32mm

当孔径大于D_{min} 46 mm时可以达到最大切深t_{max} = 11.5 mm

Note toolholder with shank-Ø 25 or 32 mm

The full depth of cut t_{max} = 11.5 mm will be reached from D_{min} 46 mm

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L213...	218.3	SW6,0 DIN911

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



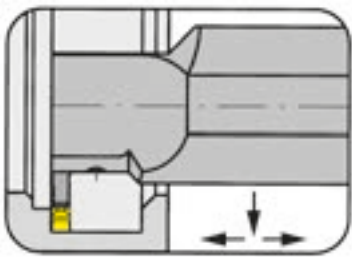
刀杆
Toolholder

213
短悬伸
Short style

孔径Ø 自
槽深可达
夹持范围

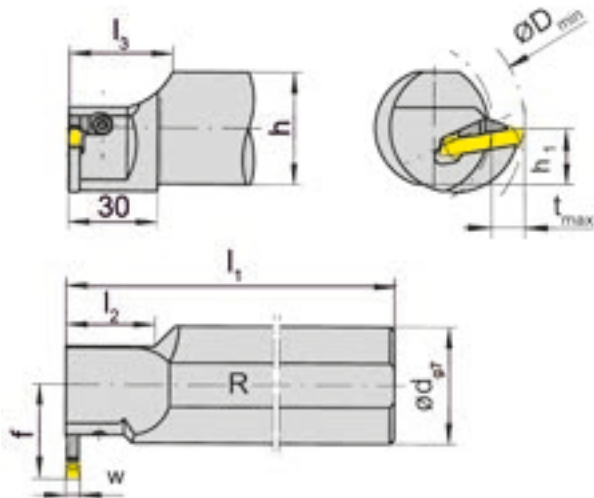
Bore Ø from
Depth of groove up to
Clamping range

50 mm
15 mm
8.1-10.4 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	l ₃	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L213.0040.09	40	180	30	35	38	19.0	32.0	11.5	50	09	8.1-10.4
R/L213.0050.09	50	200	30	40	47	23.5	40.5	15.0	60	09	8.1-10.4

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

注意事项 :
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

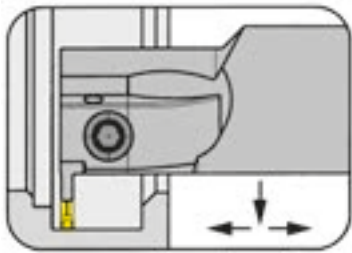
刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L213.0...	R218.9	T15PQ
R213.0...	L218.9	T15PQ

切槽和侧车削 (内圆)
Grooving and Side Turning (internal)

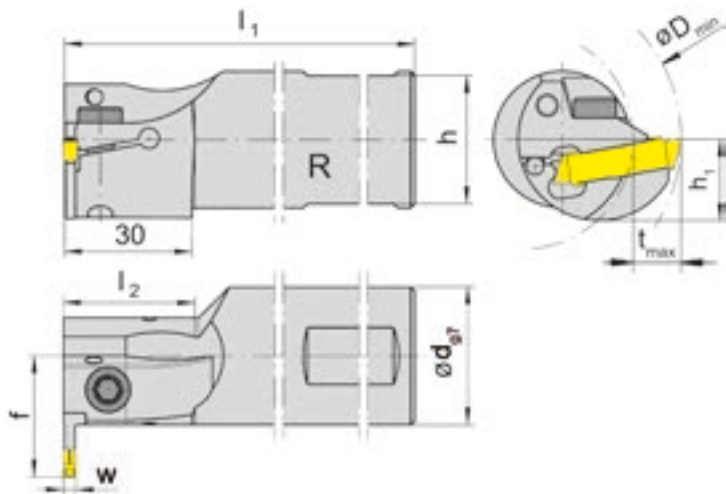


刀杆
Toolholder

213
短悬伸
Short style



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	38 mm 11.5 mm 3-5 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229

直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	l ₂	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L213.0025.03IK	25	150	-	23	11.5	24.5	7.5	38	03	3-4
R/L213.0025.04IK	25	150	-	23	11.5	24.5	7.5	38	04	4-5
R/L213.0032.03IK	32	150	30	30	15.0	28.0	7.5	38	03	3-4
R/L213.0032.04IK	32	150	30	30	15.0	28.0	7.5	38	04	4-5
R/L213.0040.03IK	40	180	30	38	19.0	32.0	11.5	50	03	3-4
R/L213.0040.04IK	40	180	30	38	19.0	32.0	11.5	50	04	4-5

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

请注意刀杆柄径为Ø 25或32mm
当孔径大于D_{min} 46 mm时可以达到最大切深t_{max}=11.5 mm
Note toolholder with shank-Ø 25 or 32 mm
The full depth of cut t_{max} = 11.5 mm will be reached from D_{min} 46 mm
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	扳手 Wrench
R/L213.0...	SW5,0 DIN911

H

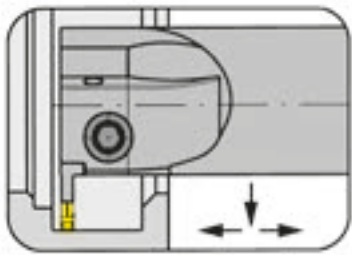
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆
Toolholder

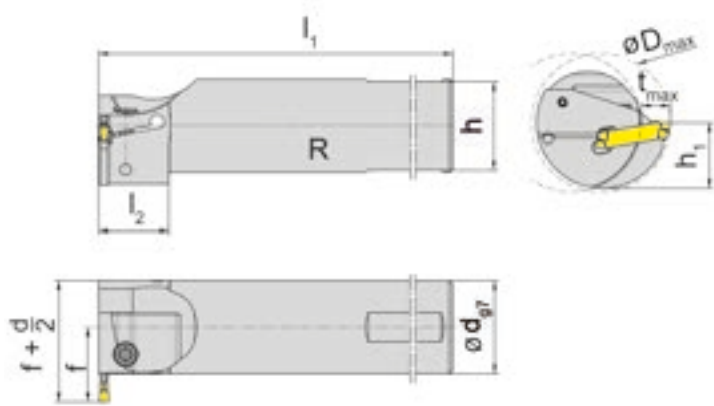
213
短悬伸
Short style



孔径Ø 自 槽深可达 夹持范围	Bore Ø from Depth of groove up to Clamping range	46 mm 11.5 mm 3-6 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	l ₂	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L213.0032.0.03IK	32	150	30	30	15	28	11.5	46	03	3.0-4.0
R/L213.0032.0.04IK	32	150	30	30	15	28	11.5	46	04	4.0-5.0
R/L213.0040.0.04IK	40	180	30	38	19	32	11.5	54	04	4.0-5.0
R/L213.0040.0.05IK	40	180	30	38	19	32	11.5	54	05	5.1-6.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	扳手 Wrench
R/L213...	SW5,0 DIN911

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



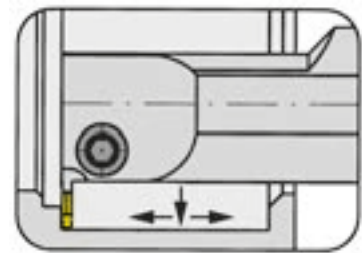
刀杆 Toolholder

214

孔径Ø 自
槽深可达
夹持范围

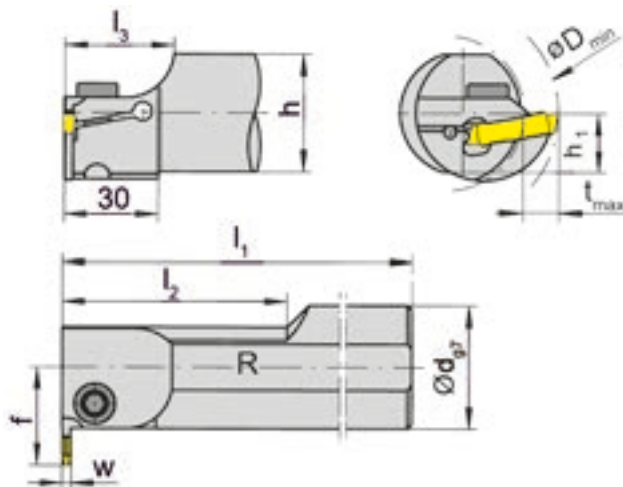
Bore Ø from
Depth of groove up to
Clamping range

38 mm
15 mm
3-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	l ₃	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L214.0032.03	32	200	70	35	30	15.0	28.0	7.5	38	03	3.0-4.0
R/L214.0040.03	40	250	80	35	38	19.0	32.0	11.5	50	03	3.0-4.0
R/L214.0050.03	50	250	100	40	47	23.5	40.5	15.0	60	03	3.0-4.0
R/L214.0032.04	32	200	70	35	30	15.0	28.0	7.5	38	04	4.0-5.0
R/L214.0040.04	40	250	80	35	38	19.0	32.0	11.5	50	04	4.0-5.0
R/L214.0050.04	50	250	100	40	47	23.5	40.5	15.0	60	04	4.0-5.0
R/L214.0032.05	32	200	-	35	30	15.0	28.0	11.5	46	05	5.1-6.0
R/L214.0040.05	40	250	80	35	38	19.0	32.0	11.5	50	05	5.1-6.0
R/L214.0050.05	50	250	100	40	47	23.5	40.5	15.0	60	05	5.1-6.0
R/L214.0040.07	40	250	80	35	38	19.0	32.0	11.5	50	07	6.1-8.0
R/L214.0050.07	50	250	100	40	47	23.5	40.5	15.0	60	07	6.1-8.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

请注意刀杆柄径为Ø 25或32mm

当孔径大于D_{min} 46 mm时可以达到最大切深t_{max} =11.5 mm

Note toolholder with shank-Ø 25 or 32 mm

The full depth of cut t_{max} = 11.5 mm will be reached from D_{min} 46 mm

可根据需要提供其他尺寸刀杆或内冷型刀杆

Further shank sizes or with through coolant supply upon request.

螺丝的扭矩规格，详见技术说明。

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Wrench
R/L214...	218.3	SW6,0 DIN911

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



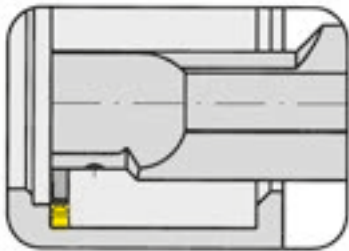
刀杆
Toolholder

214

孔径Ø 自
槽深可达
夹持范围

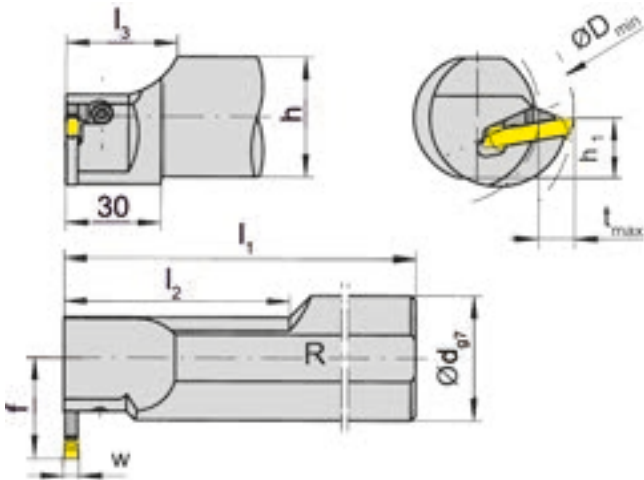
Bore Ø from
Depth of groove up to
Clamping range

50 mm
15 mm
8.1-10.4 mm



配合可转位刀片
for Indexable insert

型号 S229
Type 229
N229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	l ₃	h	h ₁	f	t _{max}	D _{min}	尺寸规格 Size	夹持范围 Clamping range
R/L214.0040.09	40	250	80	35	38	19.0	32.0	11.5	50	09	8.1-10.4
R/L214.0050.09	50	250	100	40	47	23.5	40.5	15.0	60	09	8.1-10.4

注明R或L型
State R or L version

w见刀片
w see indexable inserts

可根据需要提供其他尺寸刀杆或内冷型刀杆
Further shank sizes or with through coolant supply upon request.

注意事项：
请注意夹持方式

Note:
Please note type of clamp.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
L214.0...	R218.9	T15PQ
R214.0...	L218.9	T15PQ

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



常规刀柄

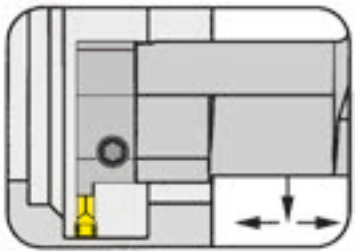
Basic toolholder

B229
无刀夹
without cassette

孔径
槽深可达
槽宽

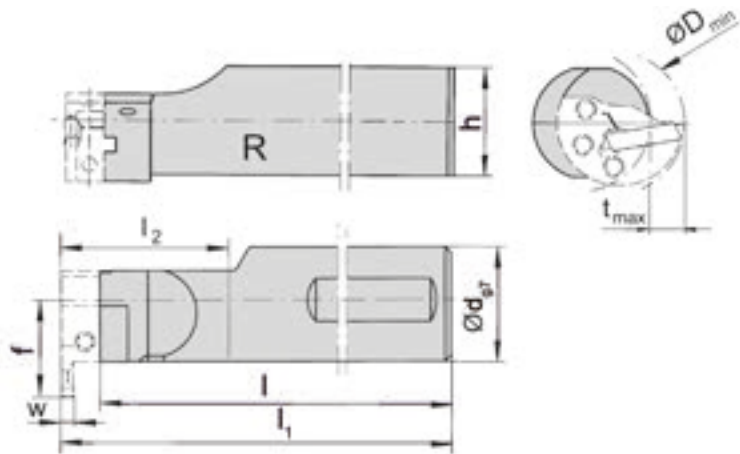
Bore Ø
Depth of groove up to
Width of groove

50 / 60 mm
12 / 15 mm
3-6 mm



配合刀夹
for Cassette

型号 BK229
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	d	l	l ₁	l ₂	h	f
R/LB229.0040.1.K2	40	172.5	187	30	38	35.5
R/LB229.0040.2.K2	40	185.5	200	60	38	35.5

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：
尺寸D_{min}、t_{max}和w见刀夹部分
Note:
Dimensions for D_{min}、t_{max} see cassettes

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB229...	030.0518T20P	T20PQ

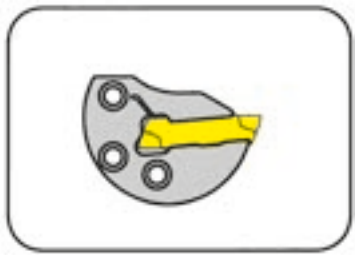
切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀夹
Cassette

BK229



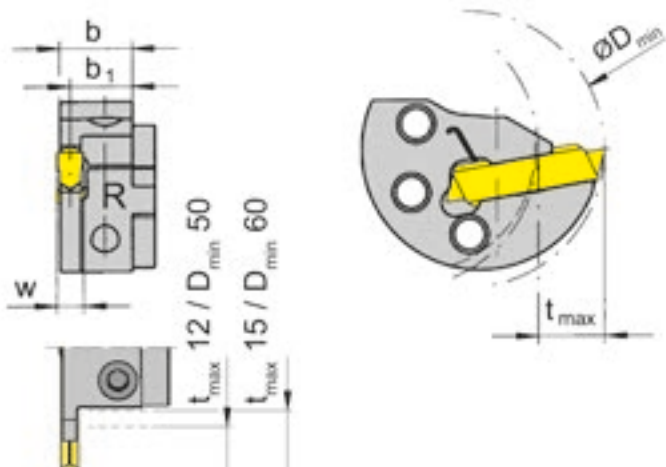
孔径Ø 自 槽深 夹持范围	Bore Ø from Depth of groove Clamping range	50 / 60 mm 12 / 15 mm 3-6 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229

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

D _{min}	t _{max}
50	12
60	15



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	D _{min}	D _{max}	t _{max}	b	b ₁	尺寸规格 Size	夹持范围 Clamping range
R/LBK229.0050.03	50	60	12-15	14.25	13.0	03	3.00-4.00
R/LBK229.0050.04	50	60	12-15	14.20	12.5	04	4.00-5.09
R/LBK229.0050.05	50	60	12-15	13.85	11.5	05	5.10-6.00

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购
Ordering note:
The fastening screw is combined with the basic toolholder - no seperate order required.

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LBK229...	5.13T20EP	T20PQ

切槽 (内圆)

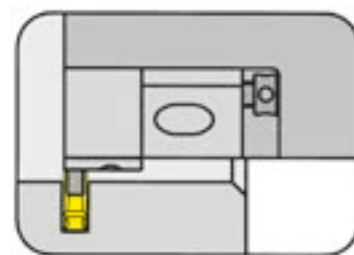
Grooving (internal)



刀夹

Cartridge

257



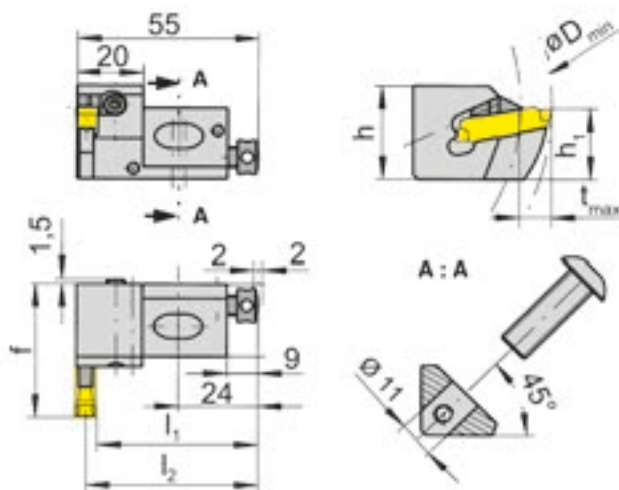
孔径Ø 自
槽深
夹持范围

Bore Ø from
Depth of groove
Clamping range

80/120 mm
10/15 mm
5.1-10.4 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

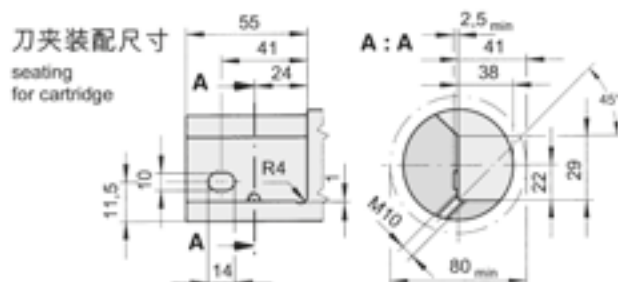
产品型号 Part number	h	h ₁	f	l ₂	l ₁	尺寸规格 Size	夹持范围 Clamping range
R/L257.2222.05	29	22	42	52.2	l ₂ -w/2	05	5.1-6.0
R/L257.2222.07	29	22	42	51.2	l ₂ -w/2	07	6.1-8.0
R/L257.2222.09	29	22	42	50.2	l ₂ -w/2	09	8.1-10.4

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

订货须知：
请注意夹持方式
Ordering note:
Please note type of clamp.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.



配件

Spare Parts

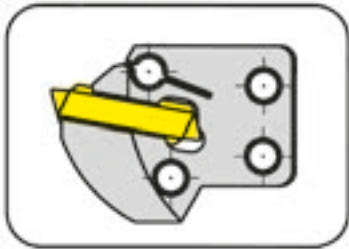
刀夹 Cartridge	锁紧螺钉 Clamping Screw	Inbus-Schlüssel Wrench	螺钉 Screw	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L257.2222.05	218.3	SW2,0 DIN911	6.12.020	-	-
L257.2222.07	4.08.913	-	6.12.020	R218.5.7.32	T15PQ
R257.2222.07	4.08.913	-	6.12.020	L218.5.7.32	T15PQ
L257.2222.09	4.08.913	-	6.12.020	R218.9.32	T15PQ
R257.2222.09	4.08.913	-	6.12.020	L218.9.32	T15PQ

切槽 (内圆)
Grooving (internal)



刀夹
Cassette

050

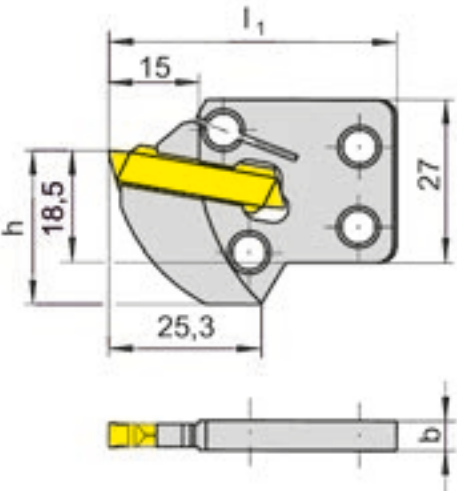


孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

62 mm
14 mm
3-5 mm

用于210系列安装刀夹的常规刀杆上
for basic toolholder type 210 with cassette



配合可转位刀片
for Indexable insert

型号 229
Type S229
N229

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

D _{min}	l _{max}
62	10
65	11
70	13
≥ 80	14

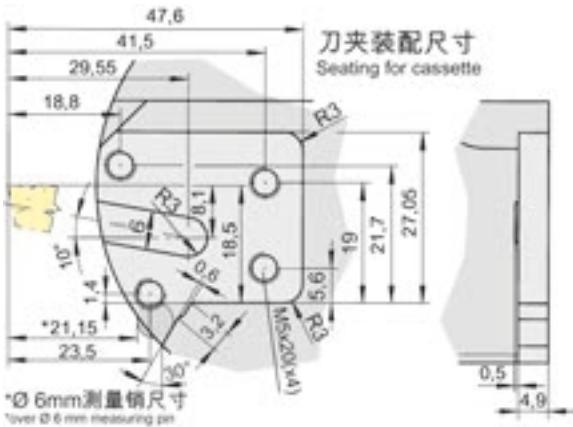
产品型号 Part number	b	l ₁	h	尺寸规格 Size	夹持范围 Clamping range
050.1827.0071	4.9	47	25.5	03	3.00-4.00
050.1827.0009	4.9	47	25.5	04	4.00-5.09

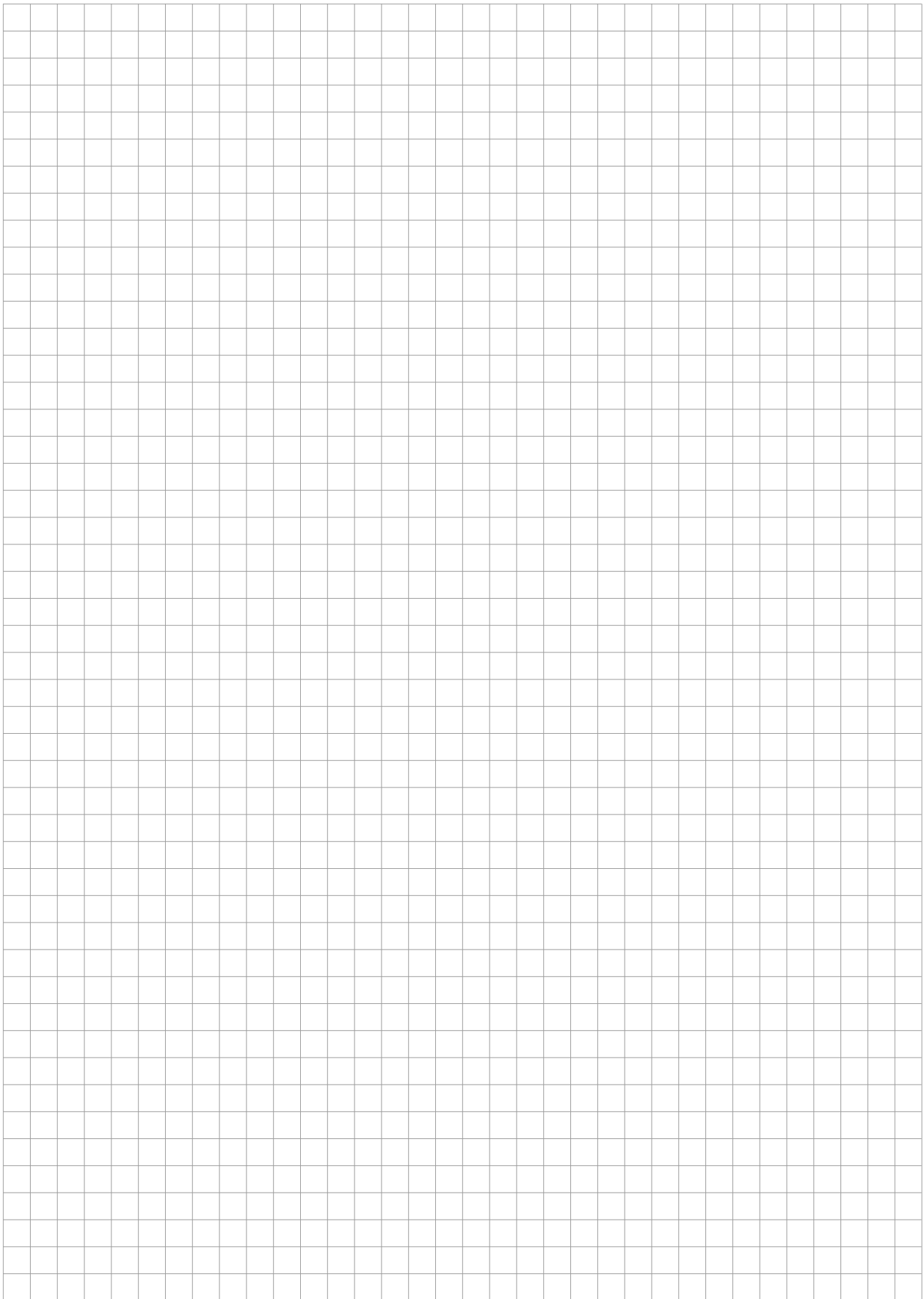
按需提供更多尺寸
Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm





可转位刀片

Indexable insert

S229...3.

精密烧结

precision sintered

断屑槽 Geometry

.3.

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

特点

Characteristics

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

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

应用

Applications

- 切槽:
槽深 可达 25 mm
- 侧车削:
切深 a_p 可达 4 mm*

- Grooving:
Depth of groove up to 25 mm
- Side turning:
Depth of cut a_p up to 4 mm*

进给率 f

Feed rate f

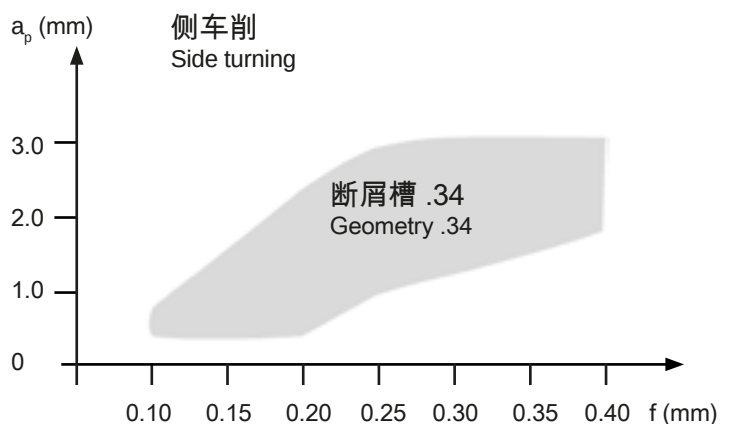
- 切槽: 0.15 可达 0.25 mm/转*
- 侧车削: 可达 0.4 mm/转*

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

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

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

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



S229.0500.34加工16MnCr5时切屑控制图表

Chip control graph S229.0500.34 material 16MnCr5

切槽和侧车削

Grooving and Side Turning

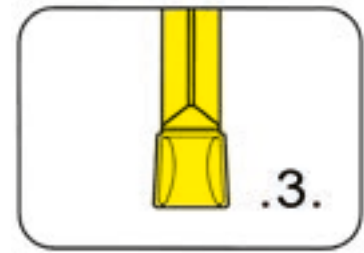


可转位刀片

Indexable insert

S229

带卷屑器
with chip former

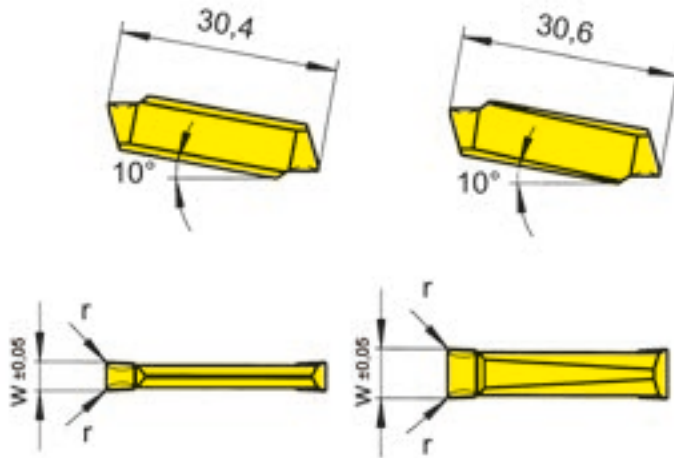


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-10 mm

精密烧结
precision sintered



宽度 3 - 5 mm
Width 3 - 5 mm

宽度 6 - 10 mm
Width 6 - 10 mm

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	MG12	AL96	AS62	AS66	H54	P20	TA45	TC92	TF42	TF45	TI22	TI25	TN32	TN35
S229.0300.32	3	0.2	03	▲	▲	▲	▲	▲	△	△	▲		▲	▲	▲	▲	▲
S229.0300.34	3	0.4	03	△	▲	▲	▲	▲	△		▲		▲	△	▲	▲	▲
S229.0400.32	4	0.2	03/04	△	▲	▲	▲	▲	△	△	▲		▲	△	▲	▲	▲
S229.0400.34	4	0.4	03/04	△	▲	▲	▲	▲	△		▲	▲	▲	△	▲	▲	▲
S229.0500.34	5	0.4	04	△	▲	▲	▲	△	△	△	▲		▲	▲	▲	▲	▲
S229.0500.36	5	0.6	04					△	△		△			△	△	△	△
S229.0600.34	6	0.4	05	△	▲	▲	▲	△	△	△	△		▲	△	▲	▲	▲
S229.0600.38	6	0.8	05		▲	▲	▲				▲			△			
S229.0700.36	7	0.6	07	△	△	▲			△		△				▲	△	▲
S229.0800.36	8	0.6	07/08	△		▲			△		▲			▲	▲	▲	▲
S229.0800.38	8	0.8	07/08								△				x	△	x
S229.0800.3K	8	1.2	07/08								△			△			
S229.1000.36	10	0.6	09	△		▲			△		△				▲	▲	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	o	•	•	•	•	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	o	•	-	•	-	•	-	•	-	•
o 次推荐 / alternative recommendation				K	-	•	-	•	-	-	•	-	•	-	•	-	•
- 不合适 / not suitable				N	-	•	-	•	-	-	•	-	•	-	•	-	•
非涂层 / uncoated grades				S	-	-	-	o	-	-	•	-	•	-	•	-	•
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet																	

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

可转位刀片
Indexable insert

S229...5.

精密烧结
precision sintered



断屑槽
Geometry .5.

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

特点 Characteristics

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

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

应用 Applications

- 切槽:
槽深 可达 25 mm
- 侧车削:
切深 a_p 可达 4 mm*

- Grooving:
Depth of groove up to 25 mm
- Side turning:
Depth of cut a_p up to 4 mm*

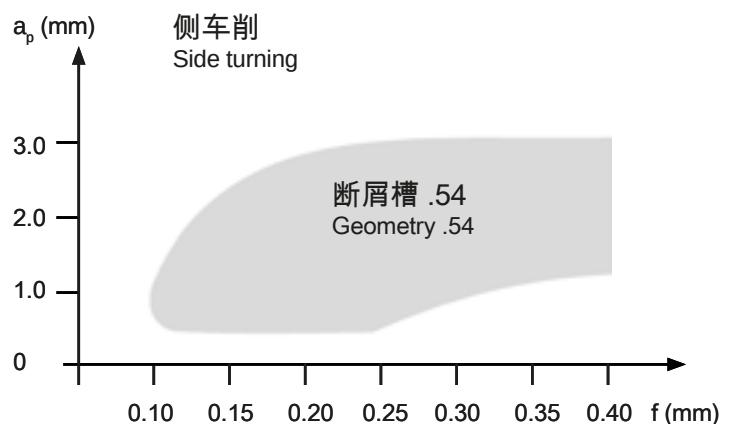
进给率 f Feed rate f

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

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

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

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



S229.0500.54加工16MnCr5时切屑控制图表

Chip control graph S229.0500.54 material 16MnCr5

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

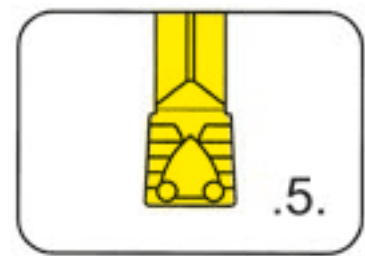
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

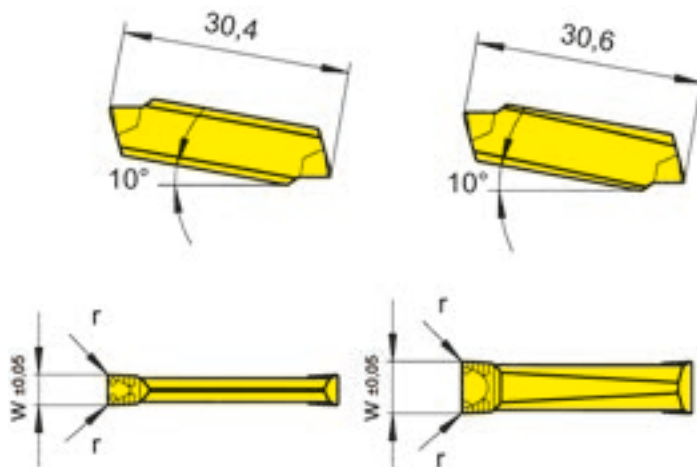
25 mm
3-10 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



宽度 3 - 5 mm
Width 3 - 5 mm

宽度 6 - 10 mm
Width 6 - 10 mm

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	P20	TC92	TF42	TF45	TI22	TI25	TN32	TN35
S229.0300.52	3	0.2	03	Δ	▲	Δ	Δ		▲	▲	▲	▲	▲
S229.0300.54	3	0.4	03	Δ	▲		Δ		▲	▲	▲	▲	
S229.0400.52	4	0.2	03/04	Δ	▲	Δ	Δ		▲	▲	▲	▲	▲
S229.0400.54	4	0.4	03/04	Δ	▲				▲	▲	▲	▲	▲
S229.0500.54	5	0.4	04	Δ	▲	Δ	▲		▲	▲	▲	▲	▲
S229.0500.56	5	0.6	06				Δ				Δ	Δ	Δ
S229.0600.54	6	0.4	05	Δ	▲	Δ	▲	▲			▲	▲	▲
S229.0600.56	6	0.6	05	Δ			Δ				Δ	Δ	Δ
S229.0600.58	6	0.8	05		▲								
S229.0700.56	7	0.6	07		▲	Δ	Δ			▲		Δ	
S229.0800.56	8	0.6	07/08	Δ	▲	Δ	Δ			▲		▲	
S229.0800.58	8	0.8	07/08	Δ		Δ	Δ	Δ		Δ		Δ	
S229.0800.5K	8	1.2	07/08	Δ			Δ			Δ			
S229.1000.56	10	0.6	09	Δ		Δ	Δ			Δ		▲	
▲ 库存 / on stock	Δ 4周 / 4 weeks	x 根据要求 / upon request		P	•	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	-	•	-	•	-	•
○ 次推荐 / alternative recommendation				K	•	-	-	-	•	-	•	-	•
- 不合适 / not suitable				N	•	-	-	-	•	-	•	-	•
非涂层 / uncoated grades				S	-	-	-	-	•	-	•	-	•
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

H

可转位刀片

Indexable insert

S229...A.

精密烧结

precision sintered



断屑槽 Geometry

.A.

适用于中等强度材料具有优异断屑效果的断屑槽

Geometry with excellent chip breaking for materials with medium strength

特点

Characteristics

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

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

应用

Applications

- 切槽:
槽深 可达 25 mm
- 侧车削:
切深 a_p 可达 2.5 mm*

- Grooving:
Depth of groove up to 18 mm
- Side turning:
Depth of cut a_p up to 2.5 mm*

进给率 f

Feed rate f

- 切槽: 可达 0.3 mm/转*
- 侧车削: 可达 0.3 mm/转*

- Grooving: up to 0.3 mm/rev*
- Side turning: up to 0.3 mm/rev*

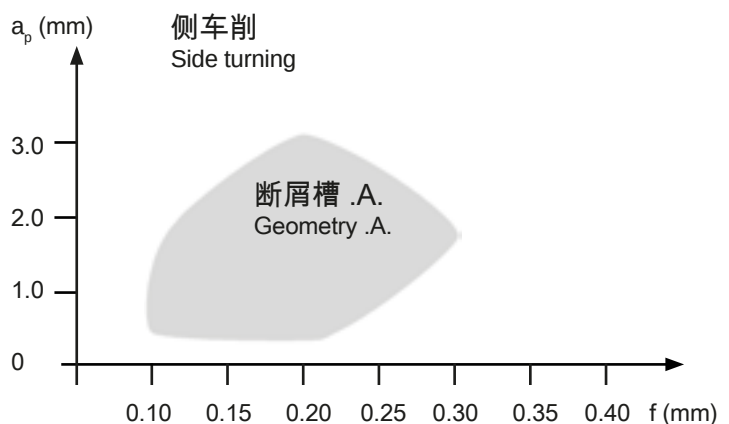
* 取决于刀片宽度

* dependent upon width of insert

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

Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.

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



S229.0500.A4加工16MnCr5时切屑控制图表

Chip control graph S229.0500.A4 material 16MnCr5

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

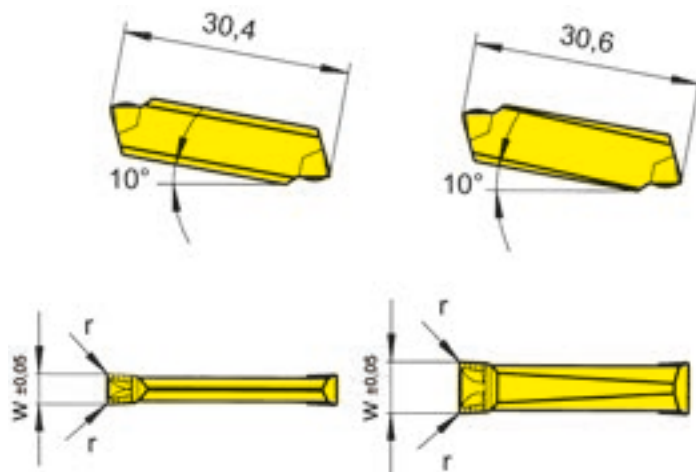
25 mm
3-10 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



宽度 3 - 5 mm
Width 3 - 5 mm

宽度 6 - 10 mm
Width 6 - 10 mm

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	P20	TC92	TF42	TF45	TI22	TI25	TN32	TN35
S229.0300.A2	3	0.2	03	Δ	▲	Δ	Δ		▲	▲	▲	▲	▲
S229.0300.A4	3	0.4	03	Δ	▲				▲	Δ	▲	▲	▲
S229.0400.A2	4	0.2	03/04	Δ	▲	Δ	Δ		▲	Δ	▲	▲	▲
S229.0400.A4	4	0.4	03/04	Δ	▲		Δ	▲	Δ	▲	▲	▲	▲
S229.0500.A4	5	0.4	04		▲		Δ		Δ	▲	Δ	▲	▲
S229.0500.A6	5	0.6	04	Δ	▲		Δ				▲		
S229.0600.A4	6	0.4	05	Δ	▲	Δ	Δ	Δ	▲	▲	Δ	▲	▲
S229.0600.A8	6	0.8	05		▲			Δ					
S229.0700.A6	7	0.6	07				Δ	▲				Δ	
S229.0800.A6	8	0.6	07/08					Δ		▲		▲	
S229.0800.A8	8	0.8	07/08					Δ		Δ			
S229.0800.AK	8	1.2	07/08							Δ			
S229.1000.A6	10	0.6	09			Δ	x			Δ		Δ	
S229.1000.A8	10	0.8	09				x			Δ			
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	-	•	-	•	-	•
○ 次推荐 / alternative recommendation				K	•	-	-	-	•	-	•	-	•
- 不合适 / not suitable				N	•	-	-	-	•	-	•	-	•
非涂层 / uncoated grades				S	-	-	-	-	•	-	•	-	•
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

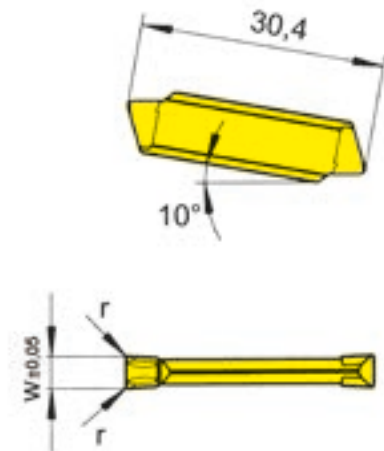
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 210
Type 213

214

218

219

225

226

257

R/LA210

R/LA226

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size
S229.0300.E2	3	0.2	03
S229.0300.E4	3	0.4	03
S229.0400.E2	4	0.2	03/04
S229.0400.E4	4	0.4	03/04

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	AS62	TC92	TF45	TF46	TI25
▲	▲	Δ	▲	▲	▲
▲	▲	Δ	▲	Δ	▲
▲	▲	Δ	▲	Δ	▲
▲	▲	Δ	▲	Δ	▲
P	●	●	●	●	●
M	-	-	●	o	●
K	-	-	●	●	●
N	-	-	●	●	●
S	-	-	●	o	●
H	-	-	-	-	-

硬质合金牌号

Carbide grades

H

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

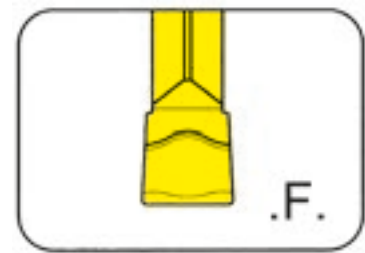
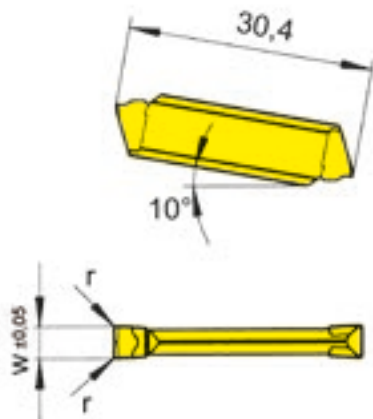
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 210
Type 213

214

218

219

225

226

257

R/LA210

R/LA226

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size
S229.0300.F2	3	0.2	03
S229.0300.F4	3	0.4	03
S229.0400.F2	4	0.2	03/04
S229.0400.F4	4	0.4	03/04

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	TC92	TF43	TF45	TF46	TI22	TI25
▲	▲	▲	▲	▲	▲	▲
Δ	Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ	Δ
P	●	●	●	●	●	●
M	-	-	●	o	-	●
K	-	-	●	●	-	●
N	-	-	●	●	-	●
S	-	-	●	o	-	●
H	-	-	-	-	-	-

硬质合金牌号

Carbide grades

H

切槽和切断

Grooving and Parting Off

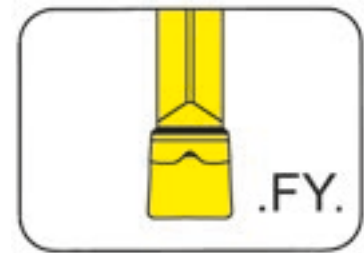


可转位刀片

Indexable insert

S229

带卷屑器
with chip forming



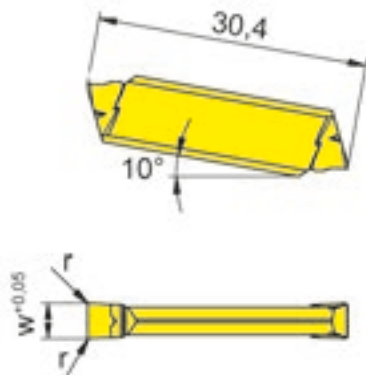
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size		HP65	IG35	PH35	TI25
S229.0300.FY2	3	0.2	03		▲	▲	▲	▲
S229.0400.FY3	4	0.3	03/04			▲	▲	▲
				P	●	-	○	●
				M	●	●	○	●
				K	●	-	●	●
				N	○	-	-	●
				S	●	●	-	●
				H	-	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

H

切槽和侧车削

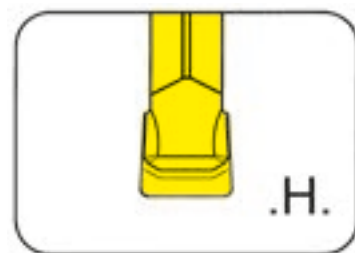
Grooving and Side Turning



可转位刀片

Indexable insert

S229
带断屑槽
with chip breaker

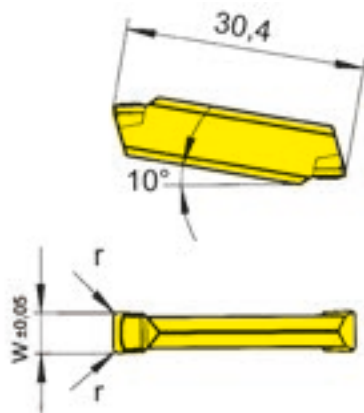


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	TF42	TF46
S229.0300.H4	3	0.4	03	▲	Δ	
S229.0300.H6	3	0.6	03	▲	▲	
S229.0400.H4	4	0.4	03/04	Δ	▲	
S229.0400.H6	4	0.6	03/04	Δ	Δ	
S229.0400.H8	4	0.8	03/04	▲	▲	Δ
S229.0500.H4	5	0.4	04	Δ	Δ	
S229.0500.H6	5	0.6	04	Δ	Δ	
S229.0500.H8	5	0.8	04	Δ	Δ	
S229.0600.H4	6	0.4	05	Δ	▲	
S229.0600.H6	6	0.6	05	Δ	Δ	
S229.0600.H8	6	0.8	05	Δ	Δ	
S229.0600.HK	6	1.2	05	Δ	Δ	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•
● 推荐 / recommended				M	-	-
○ 次推荐 / alternative recommendation				K	•	•
- 不合适 / not suitable				N	•	-
■ 非涂层 / uncoated grades				S	-	-
■ 涂层 / coated grades				H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

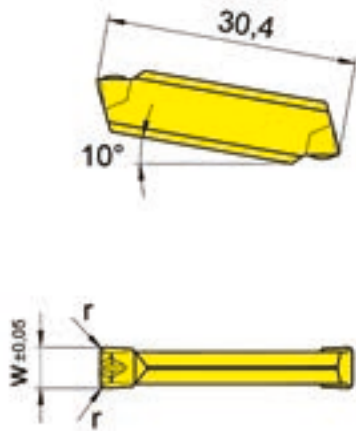
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-8 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	AS62	AS66
S229.0300.HR4	3	0.4	03	▲	△
S229.0400.HR4	4	0.4	03	▲	▲
S229.0500.HR4	5	0.4	04	▲	▲
S229.0500.HR6	5	0.6	04	▲	▲
S229.0500.HR8	5	0.8	04	▲	△
S229.0600.HR4	6	0.4	05	▲	▲
S229.0600.HR6	6	0.6	05	▲	▲
S229.0600.HR8	6	0.8	05	▲	△
S229.0800.HR8.PG	8	0.8	08	▲	
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	•
● 推荐 / recommended				M	-
○ 次推荐 / alternative recommendation				K	•
- 不合适 / not suitable				N	-
■ 非涂层 / uncoated grades				S	-
■ 涂层 / coated grades				H	-
■ 钎焊/金属陶瓷 / brazed/Cermet					

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

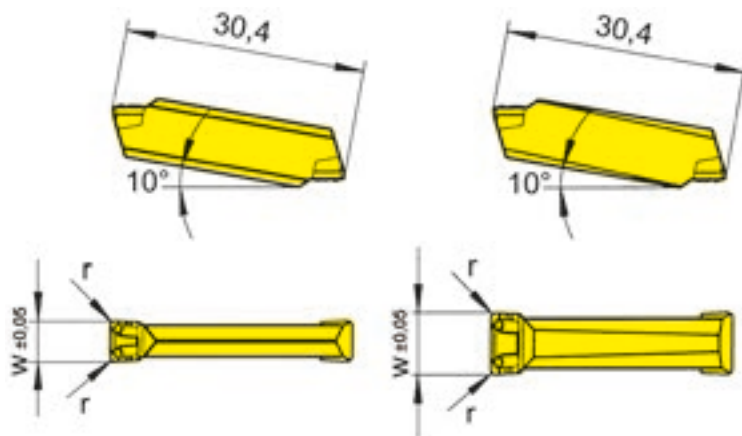
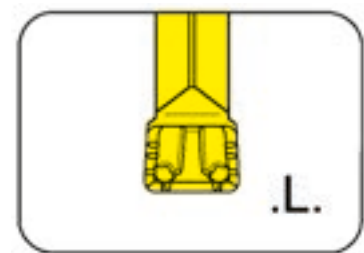
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-8 mm

精密烧结
precision sintered



宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 - 8 mm
Width 6 - 8 mm

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	TF42	TI22
S229.0400.L4	4	0.4	04	▲	▲	▲	▲	▲
S229.0400.L6	4	0.6	04	▲	▲	▲	▲	▲
S229.0500.L4	5	0.4	04	▲	▲	▲	▲	▲
S229.0500.L6	5	0.6	04	▲	▲	▲	▲	▲
S229.0500.L8	5	0.8	04	▲	▲	▲	▲	▲
S229.0600.L4	6	0.4	05	▲	▲	▲	▲	▲
S229.0600.L6	6	0.6	05	▲	▲	▲	▲	▲
S229.0800.L6	8	0.6	07	▲	▲	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•	•
● 推荐 / recommended				M	-	-	o	-
o 次推荐 / alternative recommendation				K	•	•	•	•
- 不合适 / not suitable				N	•	-	•	-
■ 非涂层 / uncoated grades				S	-	-	o	-
■ 涂层 / coated grades				H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

切槽和侧车削

Grooving and Side Turning

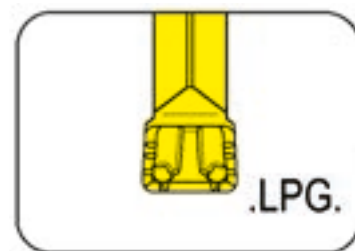


可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

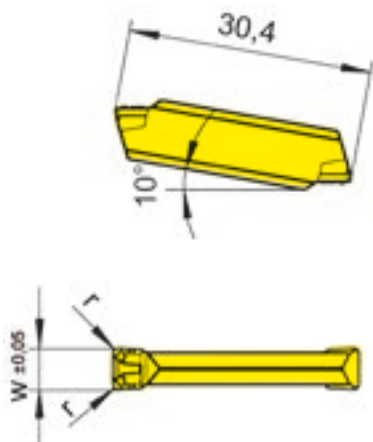


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
6-8 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

PG=磨削外边缘
PG = inserts with ground periphery

产品型号 Part number	w	r	尺寸规格 Size	AS62
S229.0600.L4.PG	6	0.4	05	▲
S229.0800.L8.PG	8	0.8	07	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	-
K	-
N	-
S	-
H	-

硬质合金牌号
Carbide grades

H

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

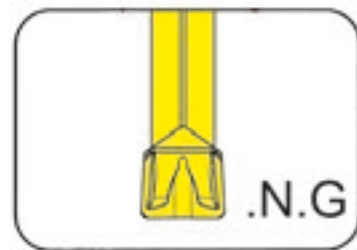
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

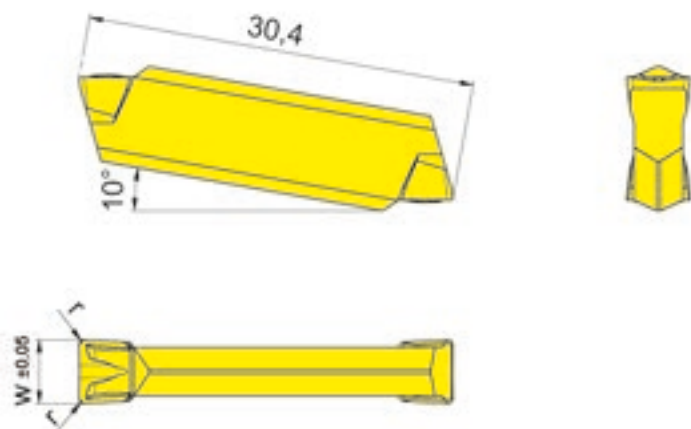
25 mm
3-6 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



刀片长度重复定位精度
 ± 0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size	AS45	AS62	DD25	TI25
S229.0300.N2.G	3	0.2	03	▲			
S229.0300.N4.G	3	0.4	03	▲			
S229.0400.N2.G	4	0.2	04	▲			
S229.0400.N4.G	4	0.4	04	▲			
S229.0500.N2.G	5	0.2	04			△	▲
S229.0500.N4.G	5	0.4	04	▲	▲	△	△
S229.0500.N6.G	5	0.6	04	△	▲		△
S229.0500.N8.G	5	0.8	04		▲		
S229.0600.N4.G	6	0.4	05	▲			△
S229.0600.N6.G	6	0.6	05	▲			△
				P	●	-	●
				M	●	-	●
				K	●	-	●
				N	○	-	●
				S	●	-	○
				H	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

H

切槽和侧车削

Grooving and Side Turning

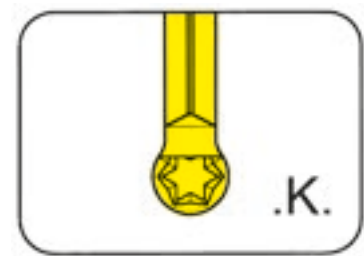


可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

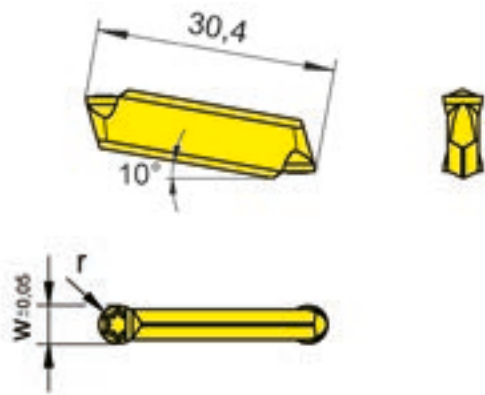


槽深可达
槽宽
圆头

Depth of groove up to
Width of groove
Full radius

25 mm
3-8 mm
1.5-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	AS62	AS66
S229.0015.K3	3	1.5	03	▲	▲
S229.0020.K4	4	2.0	04	▲	▲
S229.0025.K5	5	2.5	04	▲	▲
S229.0030.K6	6	3.0	05	▲	▲
S229.0040.K8	8	4.0	08	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	●	●
M	-	o
K	-	●
N	-	●
S	-	o
H	-	-

硬质合金牌号
Carbide grades

使用45° 刀杆加工退刀槽时各尺寸刀片要求的Dmin
D_{min} for corner reliefs with toolholder 45°

t _{max}	S229.0015.K3	S229.0020.K4	S229.0025.K5	S229.0030.K6
0.5	Ø 26	Ø 26	Ø 32	Ø 32
1.0	Ø 76	Ø 55	Ø 42	Ø 37
1.5	Ø 78	Ø 58	Ø 45	Ø 41
2.0	Ø 80	Ø 59	Ø 46	Ø 42
2.5	Ø 82	Ø 60	Ø 47	Ø 43
3.0	Ø 84	Ø 62	Ø 48	Ø 44
3.5	Ø 87	Ø 63	Ø 49	Ø 46
4.0	Ø 89	Ø 65	Ø 50	Ø 47

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

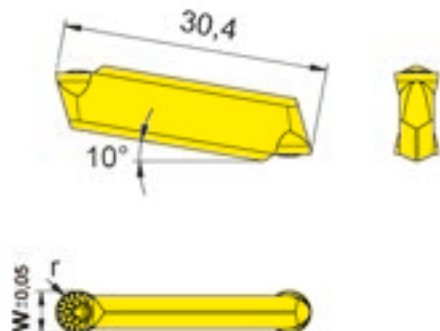


槽深可达
槽宽
圆头

Depth of groove up to
Width of groove
Full radius

25 mm
3-8 mm
1.5-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	AS66
S229.0015.KF3	3	1.5	03	▲
S229.0020.KF4	4	2.0	04	▲
S229.0025.KF5	5	2.5	04	▲
S229.0030.KF6	6	3.0	05	▲
S229.0040.KF8	8	4.0	07	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

使用45° 刀杆加工退刀槽时各尺寸刀片要求的Dmin
D_{min} for corner reliefs with toolholder 45°

t _{max}	S229.0015.KF3	S229.0020.KF4	S229.0025.KF5	S229.0030.KF6
0.5	Ø 26	Ø 26	Ø 32	Ø 32
1.0	Ø 76	Ø 55	Ø 42	Ø 37
1.5	Ø 78	Ø 58	Ø 45	Ø 41
2.0	Ø 80	Ø 59	Ø 46	Ø 42
2.5	Ø 82	Ø 60	Ø 47	Ø 43
3.0	Ø 84	Ø 62	Ø 48	Ø 44
3.5	Ø 87	Ø 63	Ø 49	Ø 46
4.0	Ø 89	Ø 65	Ø 50	Ø 47

可转位刀片
Indexable insert

229...10

精密研磨
precision ground



断屑槽 Geometry .10

易切削无切屑成型的断屑槽
Easy cutting geometry without chip former

特点 Characteristics

- 易切削-低功率要求
- 适用于不稳定零件
- 限制孔内圆切槽
- 适用于低进给
- easy cutting - low power requirement
- suitable for unstable parts
- for internal grooving in restricted bores
- suitable for low feeds

应用 Applications

- 切槽:
槽深 可达 25 mm
- Grooving:
Depth of groove up to 18 mm

进给率 f Feed rate f

- 切槽: 可达 0.3 mm/转
- Grooving: up to 0.3 mm/rev



以切削刃圆角为切深进行仿形加工
根据要求可提供可转位仿形刀片，中间 尺寸及不同切削刃圆角。
此可转位刀片可用于右手和左手刀杆。

Profiling with a cutting depth of the edge radius is possible.
Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.
Indexable inserts can be used in **right and left hand** toolholders.

切槽和侧车削

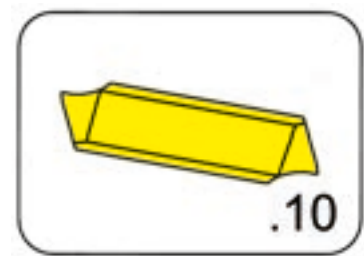
Grooving and Side Turning



可转位刀片

Indexable insert

229

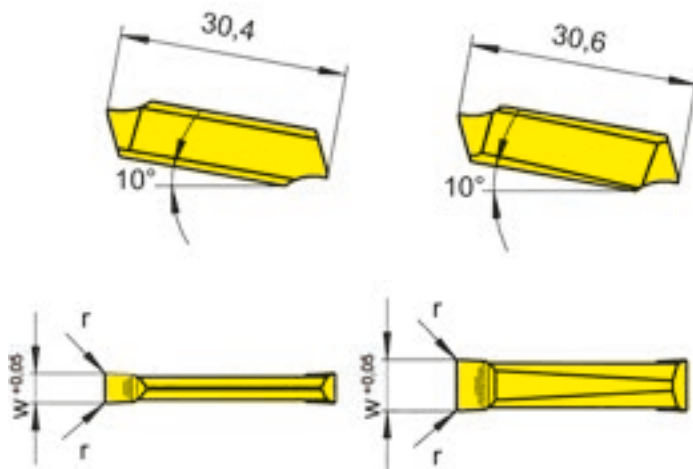


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2.5-10 mm

精密磨削
precision ground



槽宽2.5-5.0 mm
Width of groove 2.5 - 5,0 mm

宽度5.1-10.4mm
Width 5.1 - 10.4 mm

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	K10	MG12	AS62	H20	P20	TC92	TN32	TN35
229.0250.10	2.5	0.2	02								
229.0300.10	3.0	0.2	03	▲	▲	▲	▲	▲	▲	▲	▲
229.0400.10	4.0	0.2	03	▲		▲		▲	▲	▲	▲
229.0500.10	5.0	0.2	04	▲		▲		▲	▲	▲	▲
229.0600.10	6.0	0.4	05	▲				▲	▲	▲	▲
229.0700.10	7.0	0.4	07	▲				▲	▲	▲	▲
229.0800.10	8.0	0.4	07	▲				▲	▲	▲	▲
229.0900.10	9.0	0.4	09	▲				▲	▲	▲	▲
229.1000.10	10.0	0.4	09	▲				▲	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	●	○	●	●	●	●	●
● 推荐 / recommended				M	○	-	-	○	-	-	●
○ 次推荐 / alternative recommendation				K	●	-	-	-	-	-	●
- 不合适 / not suitable				N	●	-	-	-	-	-	●
■ 非涂层 / uncoated grades				S	○	-	-	-	-	-	●
■ 涂层 / coated grades				H	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

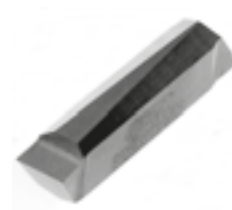
硬质合金牌号
Carbide grades

H

可转位刀片
Indexable insert

229...20

精密研磨
precision ground



断屑槽 Geometry

适用于灰铸铁和高拉伸强度材料无切屑成型的断屑槽
Geometry without chip forming for grey cast iron and materials with higher tensile strength

特点 Characteristics

- 稳定的楔角
- 适合大深度的成型刀片
- 适用于断续切削
- 适用于低进给切削

- strong wedge angle
- for inserts with larger depth of profile
- recommended for interrupted cut
- suitable for low feeds

应用 Applications

- 切槽:
槽深 可达 25 mm
- Grooving:
Depth of groove up to 25 mm

进给率 f Feed rate f

- 切槽: 0.07 可达 0.25 mm/转
- Grooving: 0.07 up to 0.25 mm/rev

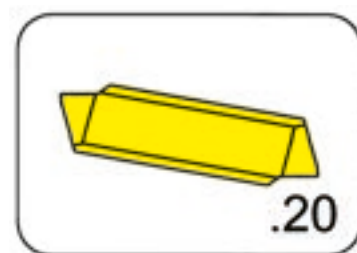


以切削刃圆角为切深进行仿形加工
根据要求可提供可转位仿形刀片，中间 尺寸及不同切削刃圆角。
此可转位刀片可用于右手和左手刀杆。

Profiling with a cutting depth of the edge radius is possible.
Indexable inserts with profiles, intermediate sizes or other edge radii are available upon request.
Indexable inserts can be used in **right and left hand** toolholders.

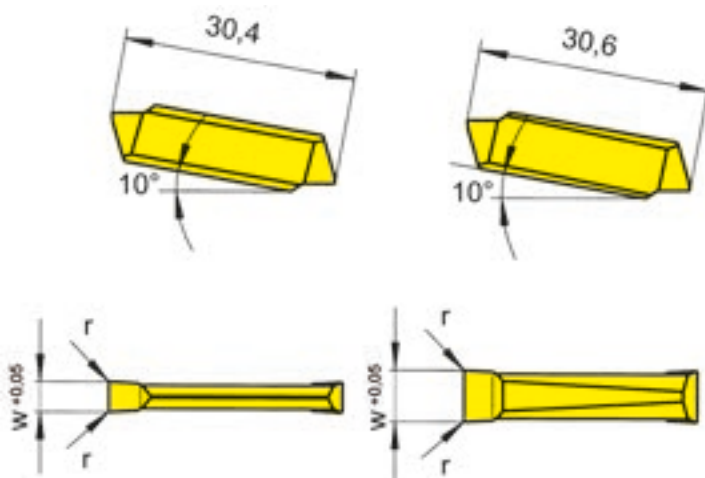
ph HORN ph

229



25 mm
3-10 mm

型号	210
Type	213
	214
	218
	219
	225
	226
	257
	R/LA210
	R/LA226



宽度5.1-10.4mm
Width 5.1 - 10.4 mm

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

产品型号 Part number	w	r	尺寸规格 Size		K10	AS62	H20	TC92	TN32
229.0300.20	3	0.2	03		▲	▲	▲	▲	
229.0400.20	4	0.2	03		▲	▲		△	▲
229.0500.20	5	0.2	04		▲	▲		▲	
229.0600.20	6	0.4	05		▲	▲		△	
229.0700.20	7	0.4	07		▲				
229.0800.20	8	0.4	07		▲				
229.0900.20	9	0.4	09		△				
229.1000.20	10	0.4	09		△				
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●
● 推荐 / recommended				M	○	-	○	-	-
○ 次推荐 / alternative recommendation				K	●	-	-	-	-
- 不合适 / not suitable				N	●	-	-	-	-
■ 非涂层 / uncoated grades				S	○	-	-	-	-
■ 涂层 / coated grades				H	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet									

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

硬质合金牌号
Carbide grades

H53

可转位刀片
Indexable insert

229...3.

精密研磨
precision ground

断屑槽 Geometry

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

特点 Characteristics

- 出色的切屑控制
- 适用于高强度的高合金钢
- 降低切屑宽度并可得到很好的侧面表面粗糙度
- 出色的切屑控制保证了生产的安全性
- excellent swarf control
- suitable for high alloy- high strength steels
- reduced swarf width gives high flank surface finish
- excellent swarf control allows production security

应用 Applications

- 切槽:
槽深 可达 25 mm
- 侧车削:
切深 a_p 可达 4 mm*
- Grooving:
Depth of groove up to 25 mm
- Side turning:
Depth of cut a_p up to 4 mm*

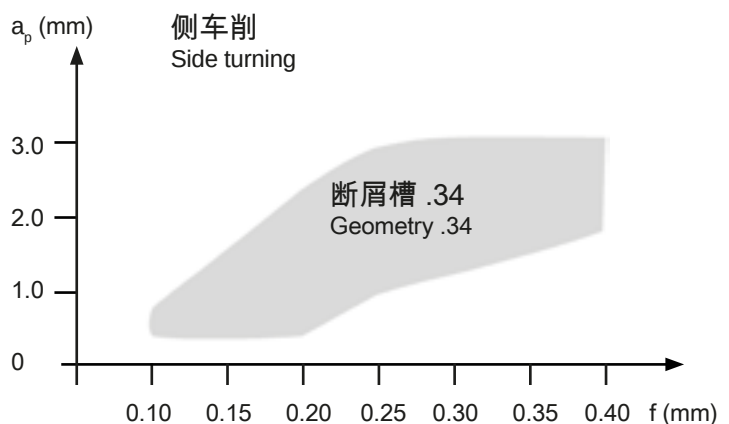
进给率 f Feed rate f

- 切槽: 0.15 可达 0.25 mm/转*
- 侧车削: 可达 0.4 mm/转*
- Grooving: 0.15 up to 0.25 mm/rev*
- Side turning: up to 0.4 mm/rev*

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

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

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



229.0500.34加工16MnCr5时切屑控制图表
Chip control graph 229.0500.34 material 16MnCr5

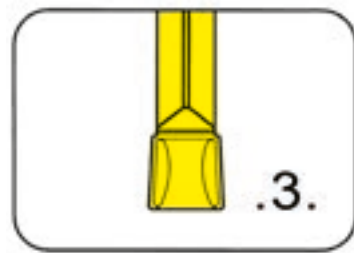
Grooving and Side Turning



Indexable insert

229

帶卷屑器
with chip former

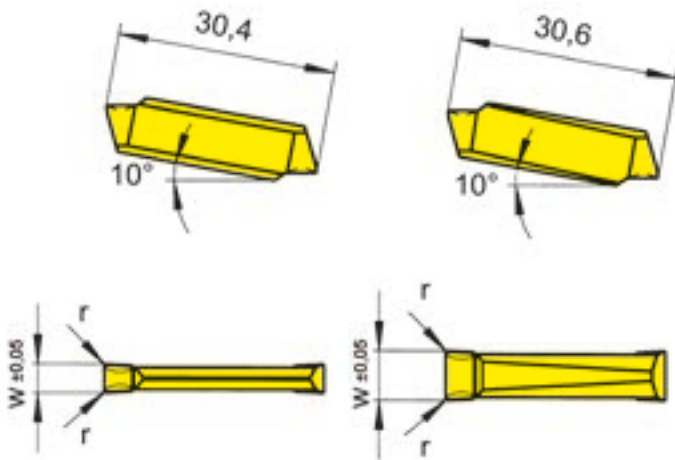


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-10 mm

精密磨削
precision ground



宽度 3 - 5 mm
Width 3 - 5 mm

宽度5.1-10.4mm
Width 5.1 - 10.4 mm

配合刀杆
for Toolholder

型号	210
Type	213
	214
	218
	219
	225
	226
	257
	R/LA210
	R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size
229.0300.31	3.0	0.2	03
229.0300.34	3.0	0.4	04
229.0350.31	3.5	0.2	03
229.0400.31	4.0	0.2	03
229.0400.34	4.0	0.4	04
229.0500.31	5.0	0.2	04
229.0500.34	5.0	0.4	04
229.0500.36	5.0	0.6	04
229.0600.31	6.0	0.4	05
229.0600.38	6.0	0.8	05
229.0700.31	7.0	0.4	07
229.0800.31	8.0	0.4	07
229.0900.31	9.0	0.4	09
229.1000.31	10.0	0.4	09

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

	K10	MG12	AS62	P20	TC92	T122	T125	TN32	TN35
	▲	▲	▲ ▲	▲ △	▲ △ △		▲	▲ ▲ ▲ ▲ ▲ △	▲ ▲
	▲		▲ ▲ ▲ ▲ △	▲ ▲ ▲ △	▲ △ △ △ △ △ △ △ △ △			▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲	▲
	▲		△	△	△	▲		▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲ ▲	▲
P	●	○	●	●	●	●	●	●	●
M	○	-	-	-	-	-	●	-	●
K	●	-	-	-	-	-	●	-	●
N	●	-	-	-	-	-	●	-	●
S	○	-	-	-	-	-	●	-	●
H	-	-	-	-	-	-	-	-	-

硬质合金牌号
Carbide grades

可转位刀片

Indexable insert

229

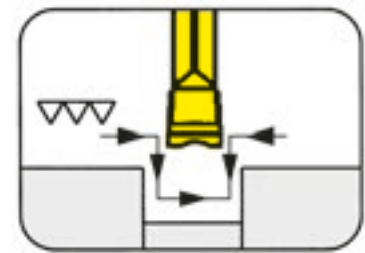
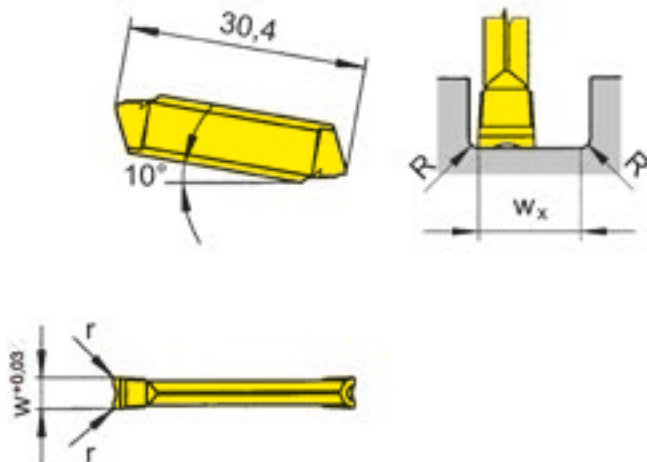
带断屑槽
with chip breaker

槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	w _x	尺寸规格 Size	H20
229.NC30.02	3	0.2	4.5	04	▲
229.NC40.02	4	0.2	6.4	04	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

w_x = 槽宽 - R_(右) - R_(左)

w_x = width of groove - R_(right) - R_(left)

此可转位刀片可用于右手和左手型刀杆

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

P	•
M	o
K	-
N	-
S	-
H	-

硬质合金牌号
Carbide grades

切槽和侧车削

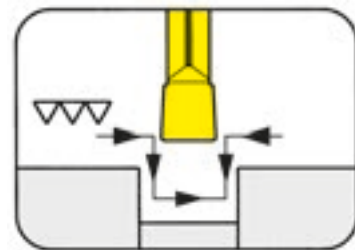
Grooving and Side Turning



可转位刀片

Indexable insert

229

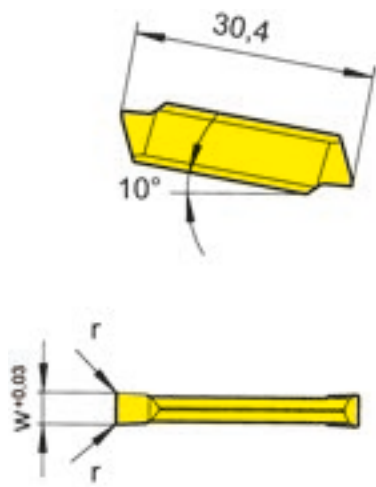


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size		H20	TN32
229.0300.02	3	0.2	04		▲	▲
229.0400.02	4	0.2	04		▲	▲
				P	●	●
				M	○	-
				K	-	-
				N	-	-
				S	-	-
				H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

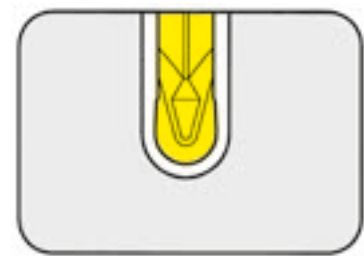
H

切槽 (内圆和外圆) Grooving (external and internal)



可转位刀片 Indexable insert

229
带环形断屑槽
with surrounding chip breaker

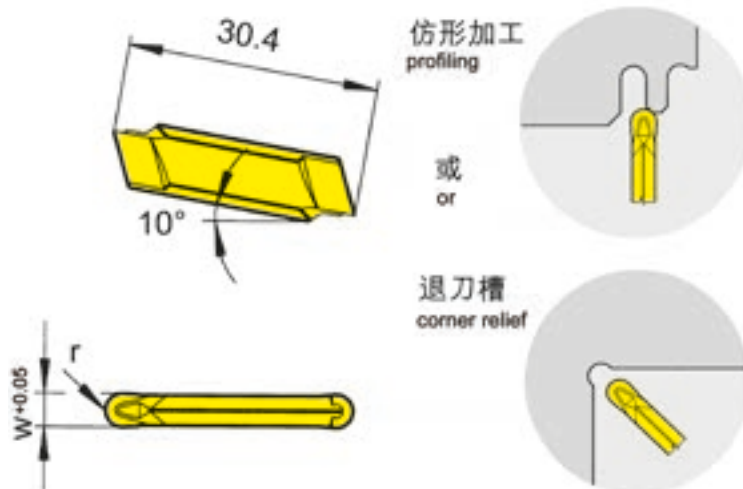


槽深可达
圆头

Depth of groove up to
Full radius

25 mm
1.5-3 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	w	r	尺寸规格 Size	夹持范围 Clamping range	MG12	AS62	AS66	H20	P20	TN32
229.0015.30	3	1.5	225...04 ...03	3,0 - 5,0 3,0 - 4,0	▲	▲		▲	▲	▲
229.0020.40	4	2,0	225...04 ...03 ...04	3,0 - 5,0 3,0 - 4,0 4,0 - 5,0	▲	▲			▲	▲
229.0025.50	5	2.5	225...04 ...04	3,0 - 5,0 3,0 - 4,0	▲	△	△		▲	▲
229.0030.60	6	3,0	...05	5.1 - 6,0		△			▲	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

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

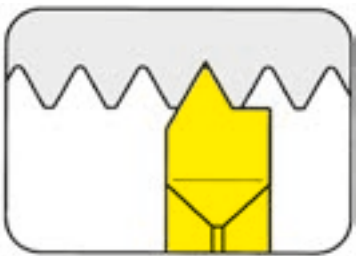
硬质合金牌号
Carbide grades

螺纹切削 (外圆) -全牙型
Threading (external) Full profile



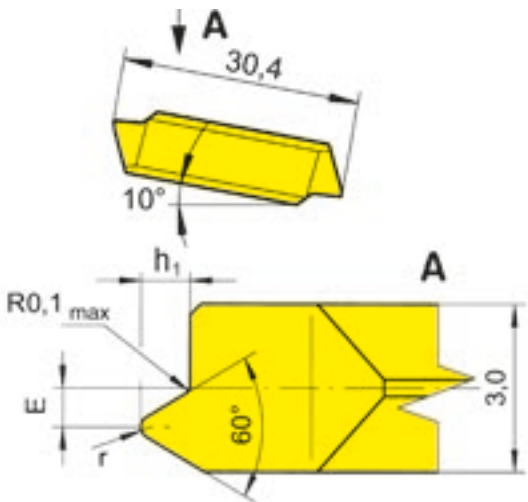
可转位刀片
Indexable insert

229
ISO米制螺纹
Metric ISO thread



螺距	Pitch	1-2.5 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号	210
Type	213
	214
	218
	219
	225
	226
	257
	R/LA210
	R/LA226

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

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	TN35
R/L229.0610.02	1.00	0.8	0.140	0.62	03	▲/▲
R/L229.0712.02	1.25	0.8	0.175	0.78	03	▲/▲
R/L229.0915.02	1.50	0.7	0.210	0.93	03	▲/▲
R/L229.1017.02	1.75	0.5	0.250	1.08	03	▲/▲
R/L229.1220.02	2.00	0.5	0.280	1.24	03	▲/▲
R/L229.1525.02	2.50	0.3	0.360	1.54	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

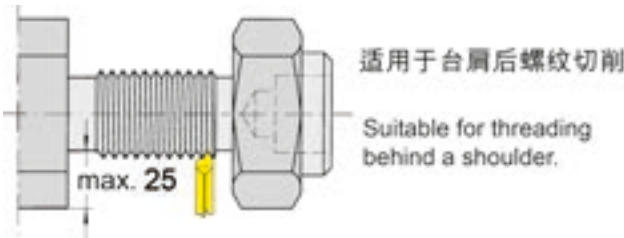
State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades



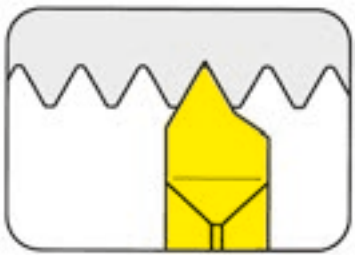
H

螺纹切削 (外圆) -非全牙型
Threading (external) Partial profile



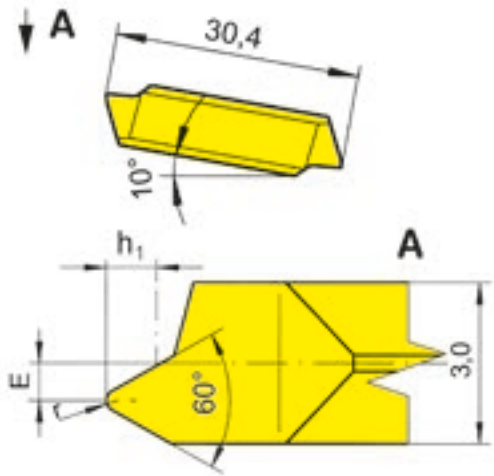
可转位刀片
Indexable insert

229
ISO米制螺纹
Metric ISO thread



螺距	Pitch	1-2.5 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号	210
Type	213
	214
	218
	219
	225
	226
	257
	R/LA210
	R/LA226

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

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	TN35
R/L229.0610.01	1.00	0.8	0.12	0.61	03	▲/▲
R/L229.0712.01	1.25	0.8	0.15	0.77	03	▲/▲
R/L229.0915.01	1.50	0.7	0.20	0.92	03	▲/▲
R/L229.1017.01	1.75	0.5	0.25	1.07	03	▲/▲
R/L229.1220.01	2.00	0.5	0.25	1.23	03	▲/▲
R/L229.1525.01	2.50	0.3	0.35	1.53	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

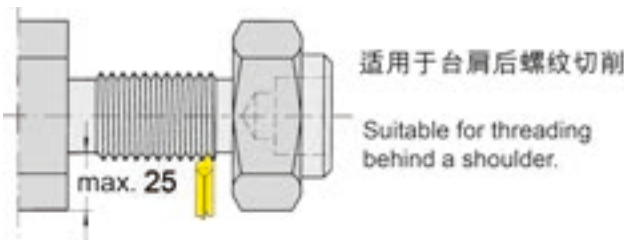
State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades



螺纹切削 (外圆) -全牙型

Threading (external) Full profile

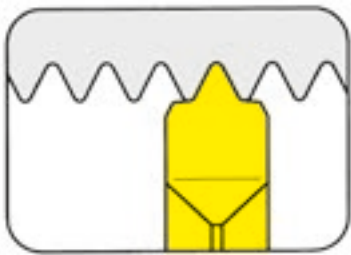


可转位刀片

Indexable insert

N229

惠氏管螺纹
Whitworth pipe thread

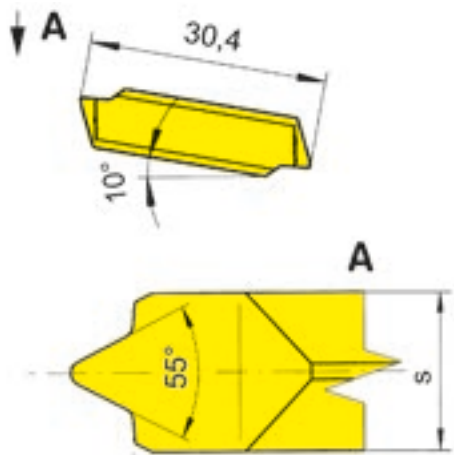


每英寸牙数

Threads per inch

11-28

精密磨削
precision ground



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226

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

产品型号 Part number	TPI	s	尺寸规格 Size		K10	MG12	TA45	TN35
N229.5511.02	11	3.5	03			Δ	Δ	▲
N229.5514.02	14	3.0	03		Δ	Δ	▲	▲
N229.5519.02	19	3.0	03			Δ	Δ	▲
N229.5528.02	28	3.0	03			Δ		Δ
				P	●	○	●	●
				M	○	-	●	●
				K	●	-	●	●
				N	●	-	●	●
				S	○	-	●	●
				H	-	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

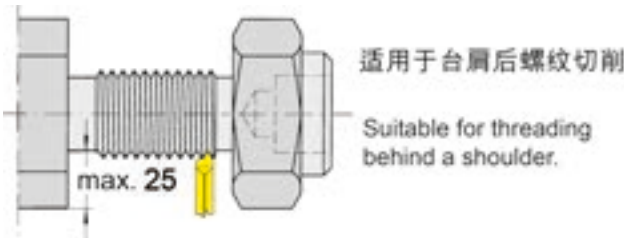
无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades



H

切断

Parting Off



可转位刀片

Indexable insert

229

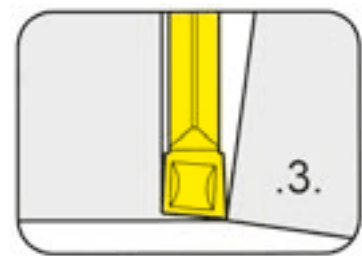
带卷屑器
with chip former

槽深可达
槽宽

Depth of groove up to
Width of groove

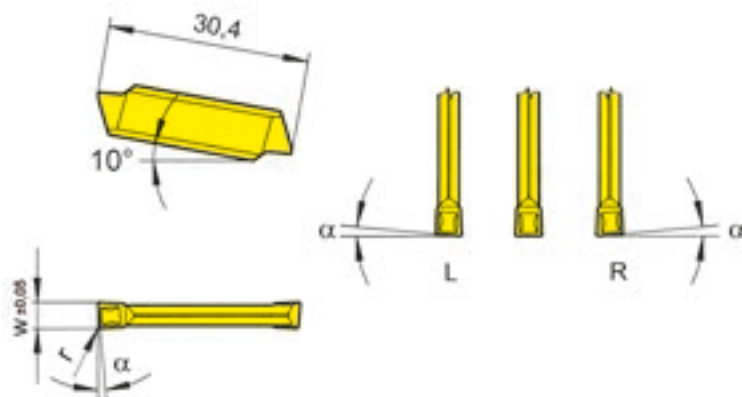
25 mm
3-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

长度重复定位精度
±0.04 mm
Indexability length ± 0.04 mm

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	AL96	AS62	AS66	H54	P20	TA45	TC92	TF45	TI22	TI25	TN32	TN35
R/L229.5300.31	3	0.2	5°	03	▲/▲		▲/▲					▲/▲			▲/▲	▲/▲	▲/▲
R/LS229.0530.32	3	0.2	5°	03			▲/▲				▲/▲	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
S229.0300.32	3	0.2	-	03	▲	▲	▲	▲	▲	Δ	Δ	▲	▲	▲	▲	▲	▲
R/LS229.0540.32	4	0.2	5°	04			▲/Δ				Δ/Δ	Δ/Δ	▲/▲		▲/▲	▲/▲	Δ/Δ
S229.0400.32	4	0.2	-	04	Δ	▲	▲	▲	▲	Δ	Δ	▲	▲	Δ	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	o	•	•	•	•	•	•	•	•	•	•	•
● 推荐 / recommended					M	-	-	-	o	•	-	•	-	-	•	-	•
o 次推荐 / alternative recommendation					K	-	•	-	•	-	•	-	•	-	•	-	•
- 不合适 / not suitable					N	-	•	-	•	-	•	-	•	-	•	-	•
■ 非涂层 / uncoated grades					S	-	-	-	o	-	•	-	•	-	•	-	•
■ 涂层 / coated grades					H	-	-	-	-	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet																	

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R/L229.5300.31精密磨削, 长度30.0mm

Note:

R/L229.5300.31 precision ground, length 30.0 mm

此可转位刀片可用于右手和左手型刀杆

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

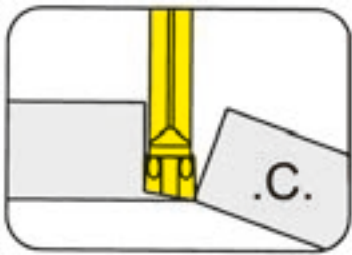
硬质合金牌号
Carbide grades

切断
Parting Off



可转位刀片
Indexable insert

S229
带卷屑器
with chip forming



槽深可达
槽宽

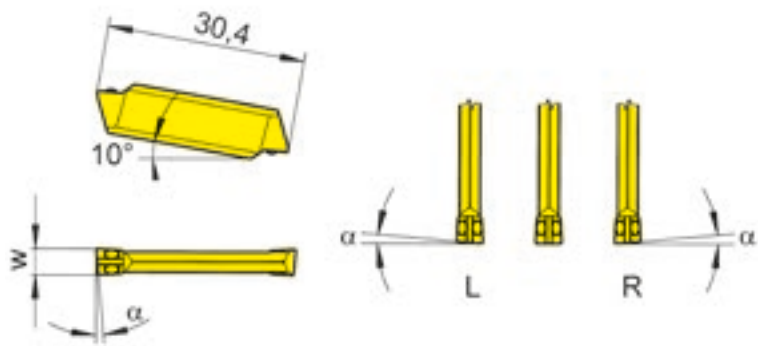
Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	α	尺寸规格 Size	TC92	TF45	TI25	TN35
R/LS229.0530.C0	3	5°	03	Δ/Δ	▲/▲	▲/▲	▲/▲
R/LS229.0830.C0	3	8°	03	▲/▲	▲/▲	▲/▲	▲/▲
S229.0030.C0	3	0°	03	Δ	▲	▲	▲
R/LS229.0540.C0	4	5°	03	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ
R/LS229.0840.C0	4	8°	03	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ
S229.0040.C0	4	0°	03	Δ	Δ	Δ	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•
● 推荐 / recommended				M	-	•	•
○ 次推荐 / alternative recommendation				K	-	•	•
- 不合适 / not suitable				N	-	•	•
■ 非涂层 / uncoated grades				S	-	•	•
■ 涂层 / coated grades				H	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet							

尺寸单位 : mm
Dimensions in mm
注明R或L型
State R or L version
此可转位刀片可用于右手和左手型刀杆
Indexable inserts can be used in right and left hand toolholders.

硬质合金牌号
Carbide grades



切断

Parting Off

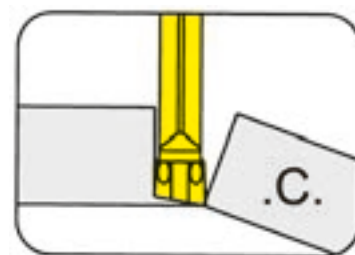


可转位刀片

Indexable insert

S229

带卷屑器
with chip forming



槽深可达
槽宽

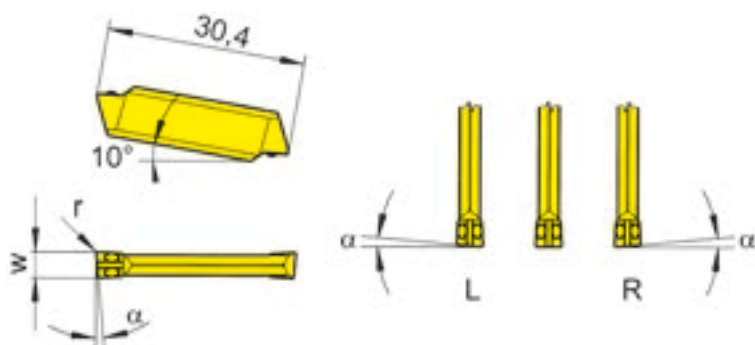
Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257
R/LA210
R/LA226



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	α	尺寸规格 Size	TC92	TF45	T125	TN35
R/LS229.0530.C1	3	0.15	5°	03	Δ/Δ	Δ/Δ	▲/▲	▲/▲
R/LS229.0830.C1	3	0.15	8°	03	Δ/Δ	▲/▲	▲/Δ	▲/▲
S229.0030.C1	3	0.15	0°	03	Δ	Δ	▲	▲
R/LS229.0540.C1	4	0.15	5°	04	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0540.C1	4	0.15	5°	04	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0840.C1	4	0.15	8°	04	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ
S229.0040.C1	4	0.15	0°	04	Δ	Δ	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



刀杆

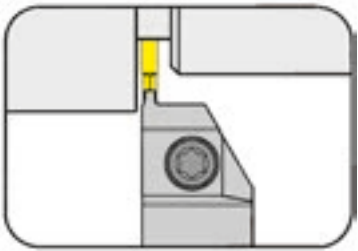
Toolholder

H259
加工铜
Messing brass

槽深可达
槽宽

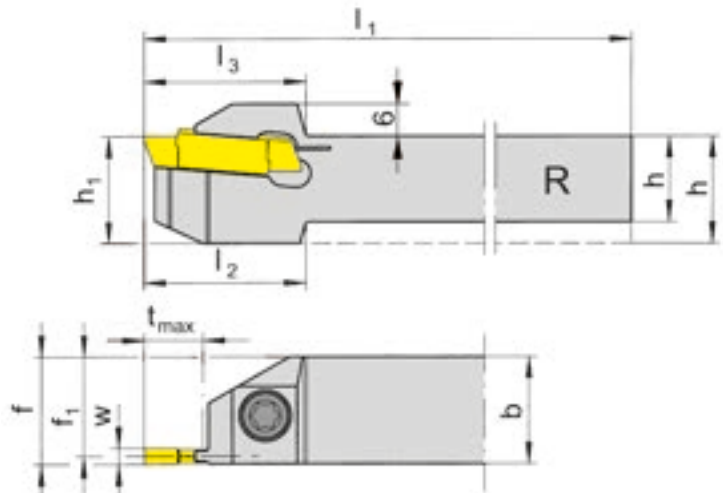
Depth of groove up to
Width of groove

18 mm
3 - 4 mm



配合可转位刀片
for Indexable insert

型号 259
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f	f_1	t_{max}	尺寸规格 Size
R/LH259.1616.03	16	16	135	30	30	20	$f_1+w/2$	14.55	11	03
R/LH259.2020.03	20	20	135	-	30	20	$f_1+w/2$	18.55	11	03
R/LH259.2525.03	25	25	135	-	30	25	$f_1+w/2$	23.55	11	03
R/LH259.1616.13	16	16	135	33	33	20	$f_1+w/2$	14.55	18	03
R/LH259.2020.13	20	20	135	-	33	20	$f_1+w/2$	18.55	18	03
R/LH259.2525.13	25	25	135	-	33	25	$f_1+w/2$	23.55	18	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH259...	6.23T25P	T25PQ

切槽和切断

Grooving and Parting Off

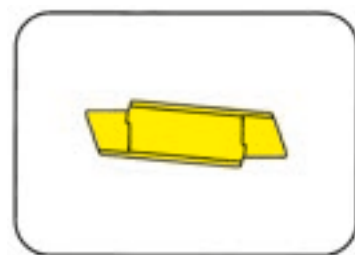


可转位刀片

Indexable insert

259

加工铜
Messing brass

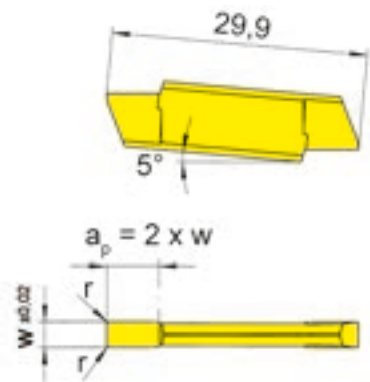


槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-4 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H259
Type

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

较小切削刃的可用长度 a_p
Usable length of minor cutting edge a_p

2 x w用于加工黄铜(Ms58)
2 x w for machining brass (Ms58)

产品型号 Part number	w	r	尺寸规格 Size	MG12
259.0300.M1	3	0.15	03	▲
259.0300.M2	3	0.20	03	▲
259.0400.M1	4	0.15	03	▲
259.0400.M2	4	0.20	03	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

P	○
M	-
K	-
N	-
S	-
H	-

H



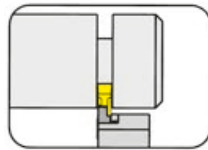
机夹式刀杆

槽宽2,5 - 10 mm

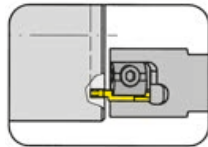
Toolholder with Inserts

Width of groove 2,5 - 10 mm

刀杆
Toolholder
211/221/228

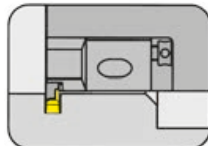


页/Page
I3-I4



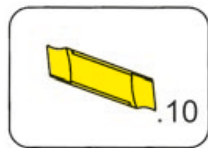
页/Page
I11-I12

刀夹
Cartridge
208

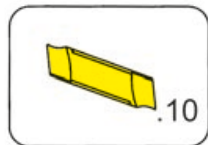


页/Page
I5

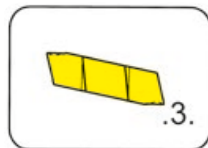
可转位刀片
Indexable insert
231



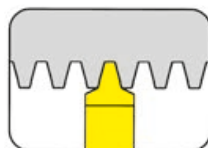
页/Page
I7, I9



页/Page
I8, I10



页/Page
I13



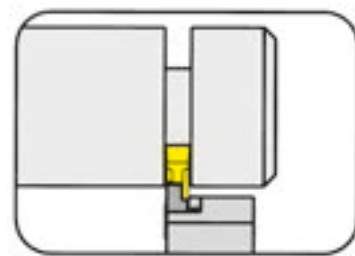
页/Page
I14

切槽 (外圆) Grooving (external)



刀杆 Toolholder

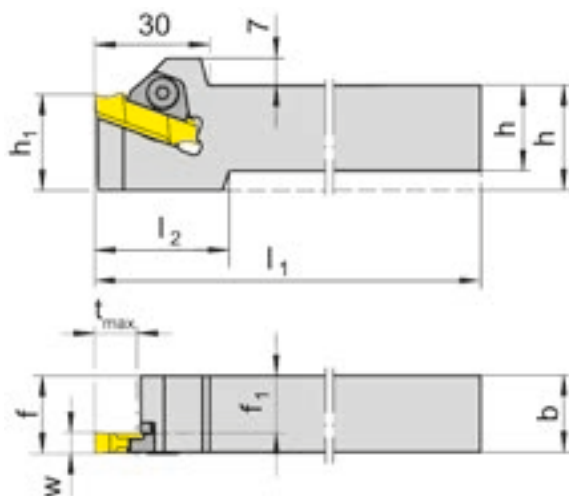
211



槽深可达
夹持范围

Depth of groove up to
Clamping range

11 mm
2,5-5 mm



配合可转位刀片
for Indexable insert

型号 231
Type N231

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w, a₁ 见刀片
w, a₁ see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格, 详见技术说明。

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

配件 Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L211...02	SW3,0 DIN911	2.16.2
R/L211...03	SW3,0 DIN911	2.16.3
R/L211...04	SW3,0 DIN911	2.16.7

切槽 (外圆)

Grooving (external)



刀杆

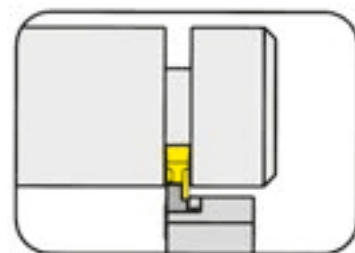
Toolholder

211

槽深可达
夹持范围

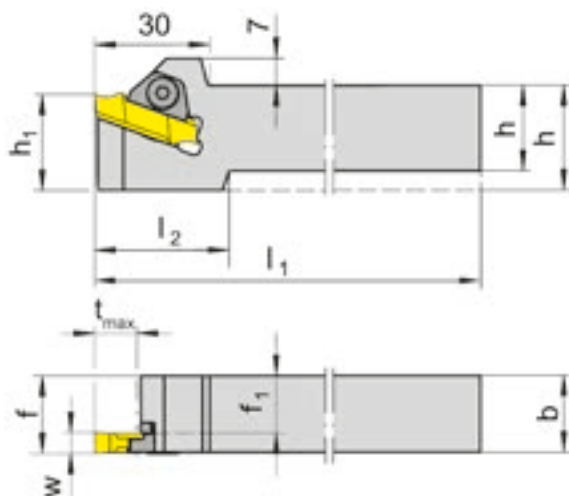
Depth of groove up to
Clamping range

11 mm
5-10 mm



配合可转位刀片
for Indexable insert

型号 231
Type N231



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L211.2020.05	20	20	125	35	25	15	f_1+w-a_1	11	05	5.0-6.5
R/L211.2525.05	25	25	150	-	25	20	f_1+w-a_1	11	05	5.0-6.5
R/L211.3232.05	32	32	170	-	32	27	f_1+w-a_1	11	05	5.0-6.5
R/L211.2020.07	20	20	125	35	25	13	f_1+w-a_1	11	07	6.5-8.5
R/L211.2525.07	25	25	150	-	25	18	f_1+w-a_1	11	07	6.5-8.5
R/L211.3232.07	32	32	170	-	32	25	f_1+w-a_1	11	07	6.5-8.5
R/L211.2020.09	20	20	125	35	25	11	f_1+w-a_1	11	09	8.5-10.0
R/L211.2525.09	25	25	150	-	25	16	f_1+w-a_1	11	09	8.5-10.0
R/L211.3232.09	32	32	170	-	32	23	f_1+w-a_1	11	09	8.5-10.0

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L211...	SW3,0 DIN911	2.16.7

切槽 (内圆)

Grooving (internal)



刀夹

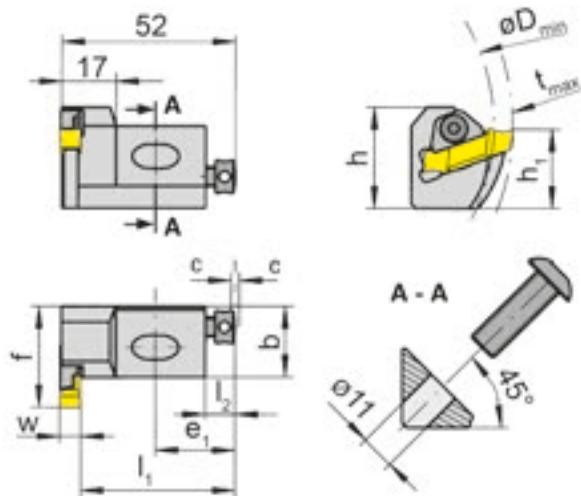
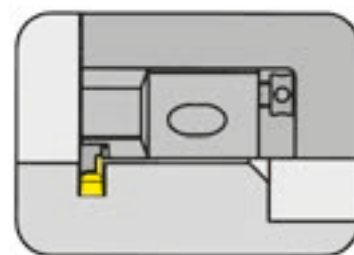
Cartridge

208

孔径Ø 自
夹持范围

Bore Ø from
Clamping range

75 mm
4-10 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 231
Type N231

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

D _{min}	t _{max}
75	5,0
85	6,0
95	6,5
110	7,0
140	8,0
200	9,0

产品型号 Part number	h	b	h ₁	f	l ₁	E ₁	l ₂	C	D _{min}	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L208.2520.04	32	20	25	32	47.8	25	9	2	75	5	04	4.0-5.0
R/L208.2520.05	32	20	25	32	46.8	25	9	2	75	5	05	5.0-6.5
R/L208.2520.07	32	20	25	32	44.8	25	9	2	75	5	07	6.5-8.5
R/L208.2520.09	32	20	25	32	42.8	25	9	2	75	5	09	8.5-10.0

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

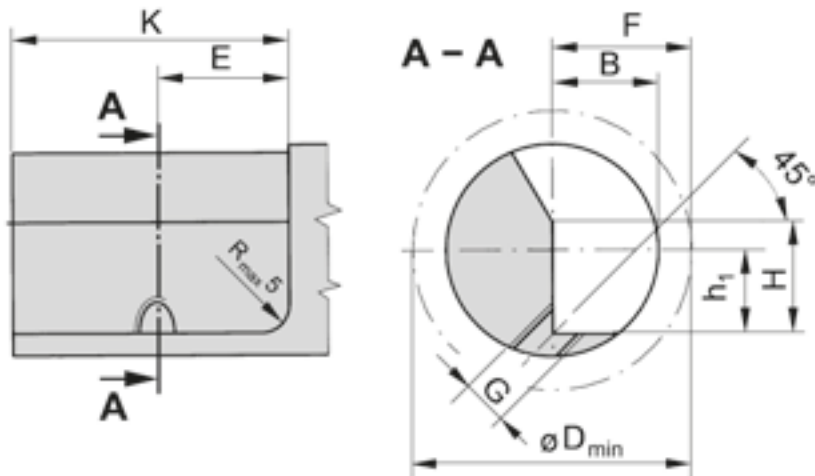
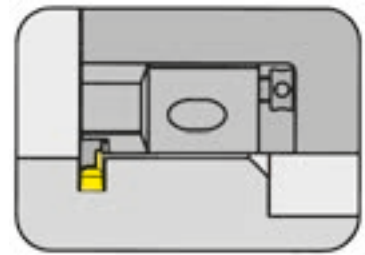
刀夹 Cartridge	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	螺钉 Screw	压板 Clamping element
R/L208...	4.08.913	SW3,0 DIN911	6.12.020	2.16.7 K

切槽 (外圆) Grooving (external)



外形尺寸 刀夹 型号
Seating Dimensions Cartridge

208



Kurzklemmhalter Cartridge	F	G	H	K	E	B	h ₁	D _{min}	紧固螺钉 Fastening Screw
R/L208.2520...	32	M10	32	50	25	20	25	75	0.30.208

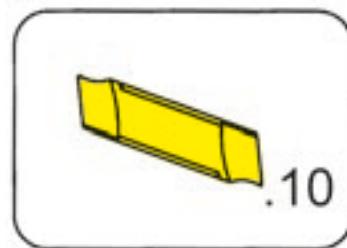
Abmessungen in mm
Dimensions in mm

切槽 (外圆) Grooving (external)



可转位刀片 Indexable insert

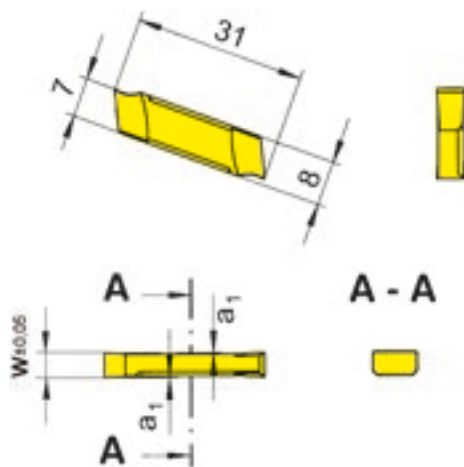
231
带圆形断屑槽
with round chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2.5-3.5 mm



配合刀杆
for Toolholder

型号 208
Type 211

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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	a ₁	尺寸规格 Size		K10	P20	TN32
R/L231.0250.10	2.5	0.2	02		Δ/Δ	▲/▲	▲/▲
R/L231.0300.10	3.0	0.2	03			Δ/▲	
R/L231.0350.10	3.5	0.2	03		Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

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

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

硬质合金牌号
Carbide grades

切槽 (内圆和外圆)

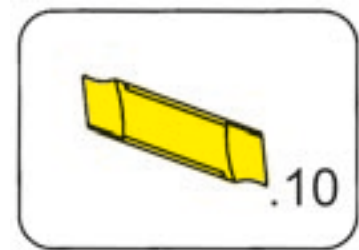
Grooving (external and internal)



可转位刀片

Indexable insert

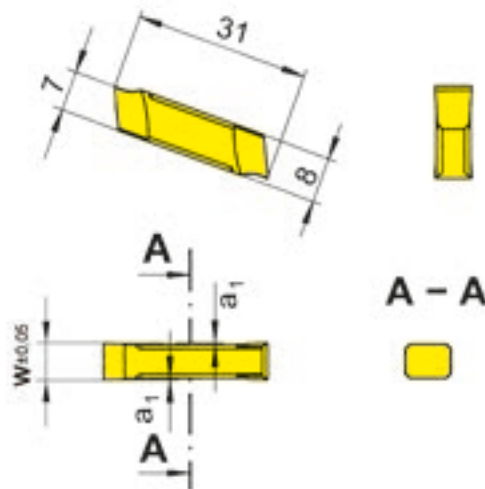
231
带圆形断屑槽
with round chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
4-10 mm



配合刀杆
for Toolholder

型号 208
Type 211

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

产品型号 Part number	w	a ₁	尺寸规格 Size		K10	P20	TC92	TN32
231.0400.10	4	0.2	04		▲	▲	▲	Δ
231.0500.10	5	0.2	05			▲	▲	
231.0600.10	6	0.2	05		Δ	▲	Δ	
231.0700.10	7	0.2	07			Δ	▲	Δ
231.0800.10	8	0.2	07		Δ	Δ		▲
231.0900.10	9	0.2	09		Δ	Δ		
231.1000.10	10	0.2	09		Δ	Δ	Δ	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●
● 推荐 / recommended				M	○	-	-	-
○ 次推荐 / alternative recommendation				K	●	-	-	-
- 不合适 / not suitable				N	●	-	-	-
■ 非涂层 / uncoated grades				S	○	-	-	-
■ 涂层 / coated grades				H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切槽 (外圆)

Grooving (external)

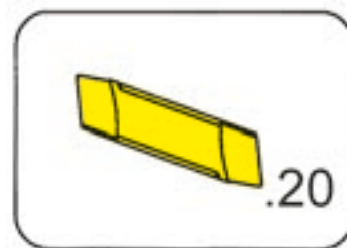


可转位刀片

Indexable insert

231

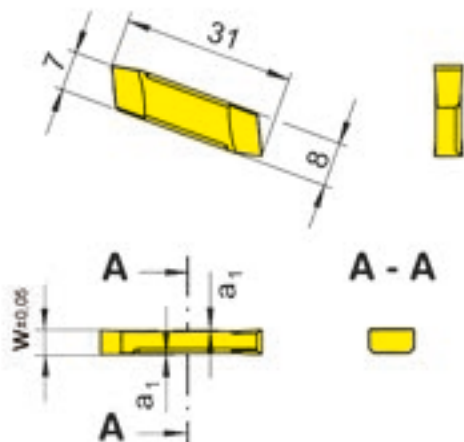
带直断屑槽
with straight chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2.5-3.5 mm



配合刀杆
for Toolholder

型号 208
Type 211

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	a ₁	尺寸规格 Size	TC92
R/L231.0250.20	2.5	0.2	02	ΔΔ
R/L231.0300.20	3.0	0.2	03	ΔΔ
R/L231.0350.20	3.5	0.2	03	ΔΔ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

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

硬质合金牌号
Carbide grades

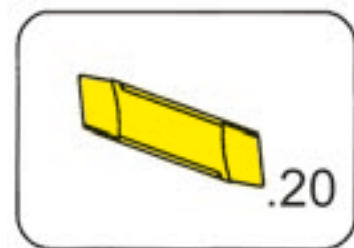
P	•
M	-
K	-
N	-
S	-
H	-

切槽 (内圆和外圆) Grooving (external and internal)



可转位刀片 Indexable insert

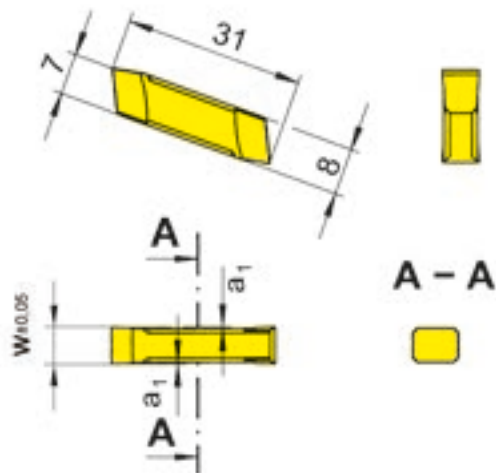
231
带直断屑槽
with straight chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
4-10 mm



配合刀杆
for Toolholder

型号 208
Type 211

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

产品型号 Part number	w	a ₁	尺寸规格 Size		K10	AS46	TC92	TF45
231.0400.20	4	0,2	04				Δ	x
231.0500.20	5	0,2	05				Δ	x
231.0600.20	6	0,2	05				Δ	x
231.0700.20	7	0,2	07				Δ	x
231.0800.20	8	0,2	07				Δ	x
231.0900.20	9	0,2	09				Δ	x
231.1000.20	10	0,2	09		Δ	Δ	Δ	x

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

端面切槽

Face Grooving



刀杆

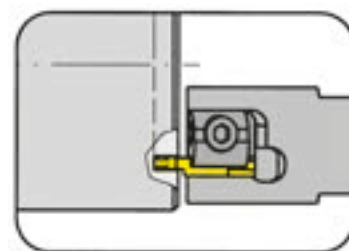
Toolholder

221

端面槽起始外径
槽深可达
夹持范围

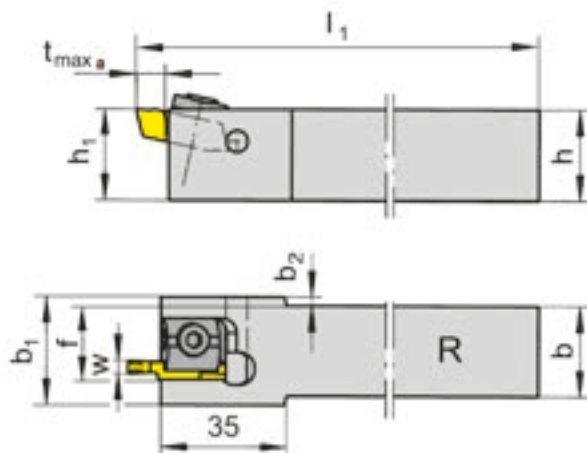
from outer groove Ø
Depth of groove up to
Clamping range

40 mm
8 mm
3-10 mm



配合可转位刀片
for Indexable insert

型号 231
Type N231



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	b_1	f	$t_{max a}$	b_2	$D_{a min}$	尺寸规格 Size	夹持范围 Clamping range
R/L221.2020.04	20	20	125	20	28	17.9	8	4.0	40	04	3.0-4.0
R/L221.2525.04	25	25	150	25	28	20.4	8	1.5	40	04	3.0-4.0
R/L221.2020.05	20	20	125	20	30	18.9	8	5.0	40	05	4.1-6.0
R/L221.2525.05	25	25	150	25	30	21.4	8	2.5	40	05	4.1-6.0
R/L221.2020.07	20	20	125	20	32	19.9	8	6.0	40	07	6.1-8.0
R/L221.2525.07	25	25	150	25	32	22.4	8	3.5	40	07	6.1-8.0
R/L221.2020.09	20	20	125	20	34	20.9	8	7.0	40	09	8.1-10.0
R/L221.2525.09	25	25	150	25	34	23.4	8	4.5	40	09	8.1-10.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

取决于切槽深度，当 $D_a=30$ mm到 ∞ 时可以使用此刀杆。

This toolholder can be used from $D_a = 30$ mm up to ∞ depending on grooving depth.

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	定位销 Stop Pin	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L221...	3.6.28	01.60.12	T20PQ

端面切槽

Face Grooving

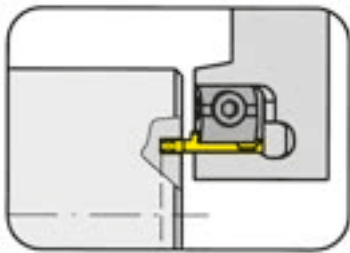


刀杆

Toolholder

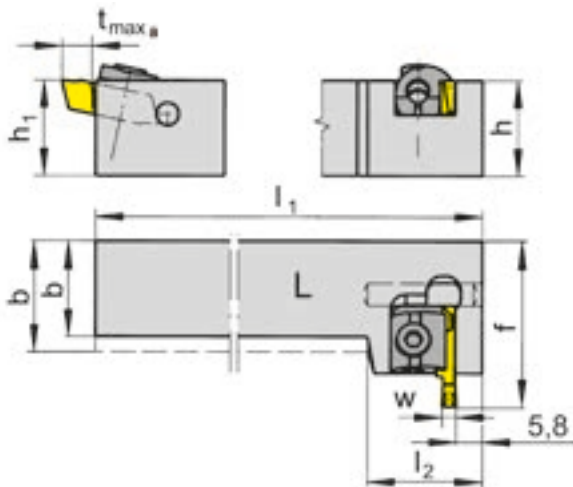
228

端面槽起始外径	from outer groove Ø	40 mm
槽深可达	Depth of groove up to	8 mm
夹持范围	Clamping range	3-10 mm



配合可转位刀片
for Indexable insert

型号 208
Type 211



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

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

D _{min}	t _{max}
75	5,0
85	6,0
95	6,5
110	7,0
140	8,0
200	9,0

产品型号 Part number	h	b	h ₁	f	t _{max a}	D _{a min}	I ₁	I ₂	尺寸规格 Size	夹持范围 Clamping range
R/L228.2020.04	20	20	20	38.5	8	40	125	35.5	04	3.0-4.0
R/L228.2525.04	25	25	25	38.5	8	40	150	35.5	04	3.0-4.0
R/L228.2020.05	20	20	20	38.5	8	40	125	35.5	05	4.1-6.0
R/L228.2525.05	25	25	25	38.5	8	40	150	35.5	05	4.1-6.0
R/L228.2020.07	20	20	20	38.5	8	40	125	35.5	07	6.1-8.0
R/L228.2525.07	25	25	25	38.5	8	40	150	35.5	07	6.1-8.0
R/L228.2020.09	20	20	20	38.5	8	40	125	35.5	09	8.1-10.0
R/L228.2525.09	25	25	25	38.5	8	40	150	35.5	09	8.1-10.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

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

配件

Spare Parts

刀杆 Toolholder	定位销 Stop Pin	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L228...	3.6.28	01.60.12	T20PQ

端面切槽

Face Grooving

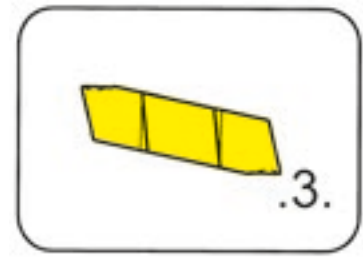


可转位刀片

Indexable insert

231

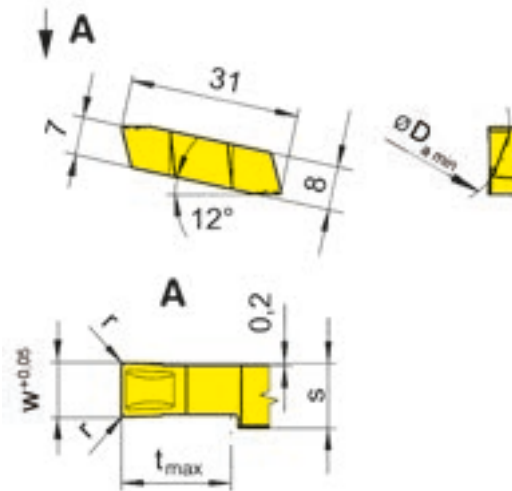
带卷屑器
with chip former



端面槽起始外径
槽深可达
槽宽

from outer groove $\varnothing$
Depth of groove up to
Width of groove

40 mm
8 mm
3-10 mm



配合刀杆
for Toolholder

型号 221
Type 228

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

产品型号 Part number	w	r	t _{max}	s	D _{a min}	尺寸规格 Size	TN35
R/L231.4030.32	3	0.2	8	3.8	40	04	▲/▲
R/L231.4040.32	4	0.2	8	3.8	40	04	▲/▲
R/L231.4050.34	5	0.4	8	5.8	40	05	▲/▲
N231.4060.34	6	0.4	8	5.8	40	05	▲
N231.4070.36	7	0.6	8	7.8	40	07	▲
N231.4080.36	8	0.6	8	7.8	40	07	▲
N231.4090.38	9	0.8	8	9.8	40	09	▲
N231.4100.38	10	0.8	8	9.8	40	09	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R, L或N型

State R, L or N version

槽外径 $\varnothing < 40\text{mm}$ 时可定制非标产品

Outer- $\varnothing$ of groove $< 40\text{ mm}$ upon request.

P	●
M	●
K	●
N	●
S	●
H	-

硬质合金牌号
Carbide grades



R

R = 右手型
R = right hand version



L

L = 左手型
L = left hand version



N

N = 右手型和左手型
N = right and left hand version

螺纹切削 (外圆) -全牙型

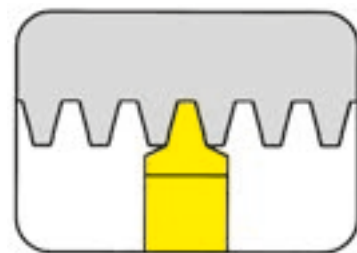
Threading (external) Full profile



可转位刀片

Indexable insert

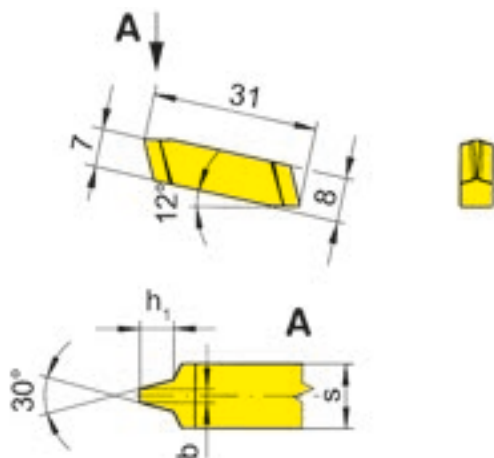
231



螺距	Pitch	7-12 mm

配合刀杆
for Toolholder

型号 221
Type 228



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

产品型号 Part number	P	h_1	b	s	尺寸规格 Size	TN35
231.4070.02	7	4.0	2.29	5.8	05	▲
231.4580.02	8	4.5	2.66	5.8	05	▲
231.5090.02	9	5.0	3.02	7.8	07	△
231.5500.02	10	5.5	3.39	7.8	07	▲
231.6020.02	12	6.5	4.12	9.8	09	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades



机夹式刀杆

槽宽0.025 - 6 mm

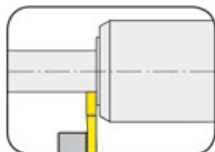
Toolholder with Inserts

Width of groove 0.025 - 6 mm

切槽 (外圆)

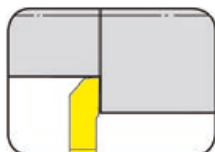
Grooving (external)

刀杆
Toolholder
H262

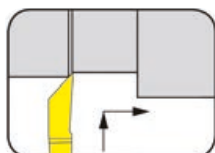


页/Page
J3

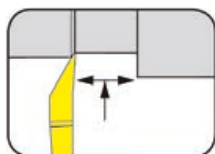
可转位刀片
Indexable insert
S262



页/Page
J4



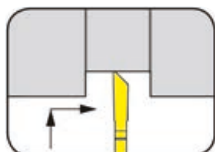
页/Page
J5



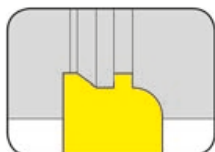
页/Page
J6



页/Page
J7



页/Page
J8-J9



页/Page
J10

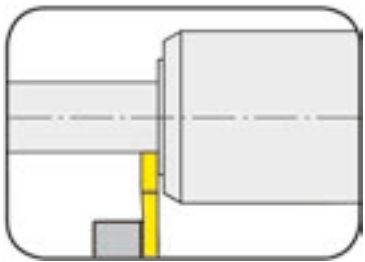
刀杆
Toolholder

H262

槽深可达
槽宽可达

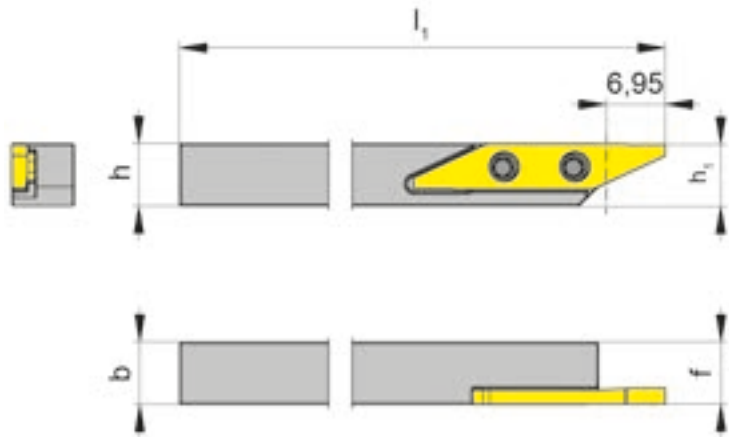
Depth of groove up to
Width of groove up to

7.5 mm
0.025-6 mm



配合可转位刀片
for Indexable insert

型号 LS262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	h	b	l_1	h_1	f	t_{max}	尺寸规格 Size
LH262.0606.04	6	6	100	5.83	5.95	7.5	04
LH262.0707.04	7	7	100	6.83	6.95	7.5	04
LH262.0808.04	8	8	100	7.83	7.95	7.5	04
LH262.0808.2.04	8	8	150	7.83	7.95	7.5	04
LH262.1010.04	10	10	100	9.83	9.95	7.5	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LH262...	030.2557.T8P	T8PL

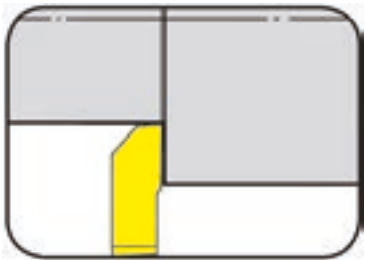
切槽和侧车削

Grooving and Side Turning



可转位刀片
Indexable insert

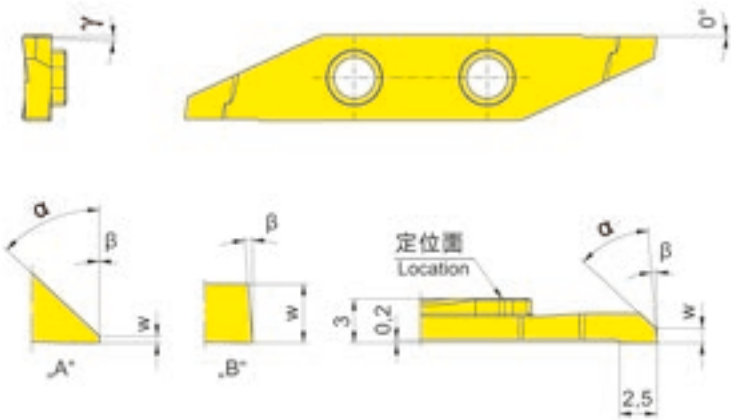
S262



槽宽	Width of groove	0.05-2 mm

配合刀杆
for Toolholder

型号 LH262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	w	γ	α	形式 Form	β	EG35	
LS262.0547.04	0.05	0°	47°	A	0°	▲	●
LS262.2047.03	2.00	3°	0°	B	4°	Δ	○

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

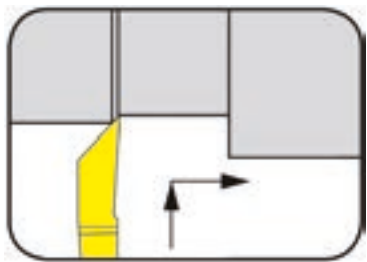
尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

P	●
M	●
K	○
N	-
S	-
H	-

可转位刀片
Indexable insert

S262



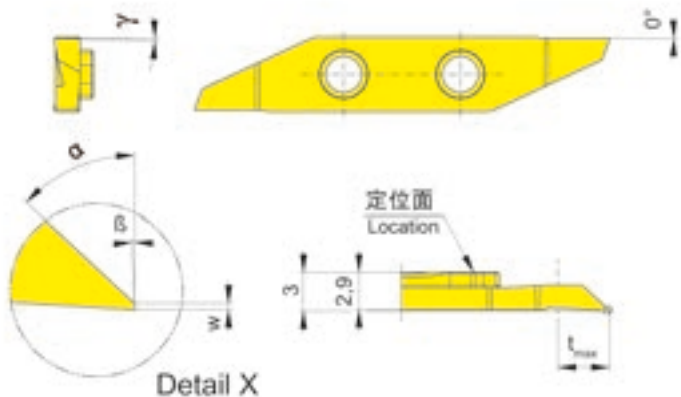
槽宽
切深可达

Width of groove
Depth of cut up to

0.025 mm
1.8 mm

配合刀杆
for Toolholder

型号 LH262
Type



L=左手型-如图
L = left hand version shown

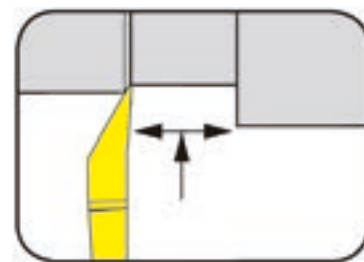
产品型号 Part number	w	t _{max}	γ	α	β	EG35	
LS262.0247.04	0.025	1.8	1.5°	47°	2°	▲	▲
						P	●
						M	●
						K	○
						N	-
						S	-
						H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
○ 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

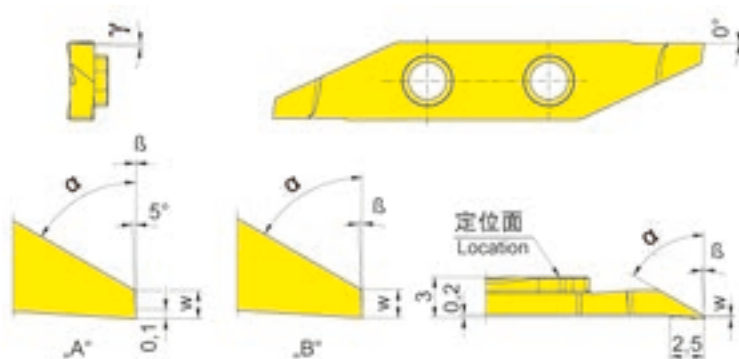
硬质合金牌号
Carbide grades

S262



0.03-0.105 mm
3 mm

型号 LH262
Type



产品型号 Part number	w	t _{max}	γ	α	形式 Form	β	EG35 ▲ ▲
LS262.0147.04	0.030	1.8	0°	47°	A	0°	
LS262.0160.03	0.105	3.0	3°	60°	B	2°	

Dimensions in mm

P	•
M	•
K	o
N	-
S	-
H	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S262



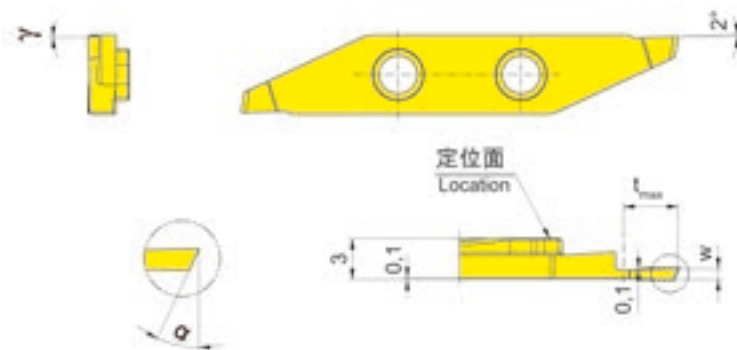
槽宽
切深可达

Width of groove
Depth of cut up to

0.7-1 mm
5 mm

配合刀杆
for Toolholder

型号 LH262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	w	t _{max}	γ	α	EG35
LS262.2007.02	0.7	2	0°	20°	▲
LS262.2508.03	0.8	3	0°	25°	▲
LS262.2509.04	0.9	4	0°	25°	▲
LS262.2510.05	1.0	5	0°	25°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

硬质合金牌号
Carbide grades

P	●
M	●
K	○
N	-
S	-
H	-

J

切槽/背车

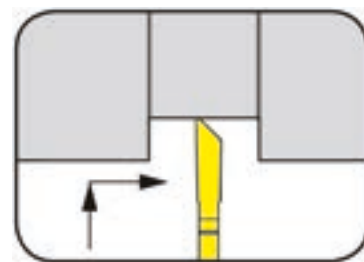
Grooving/Backturning



可转位刀片

Indexable insert

S262



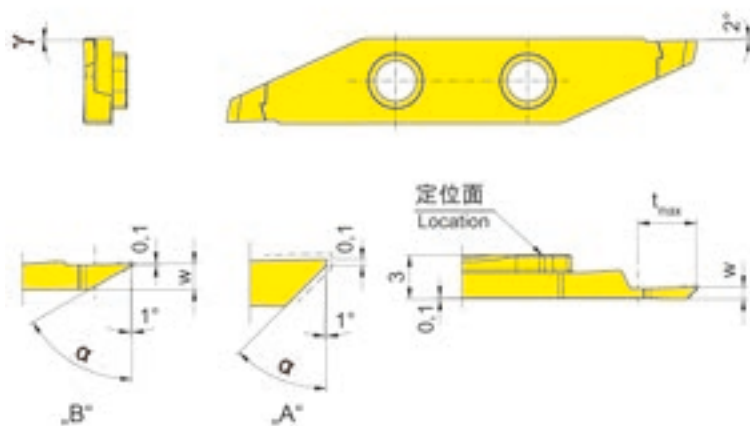
槽宽
切深可达

Width of groove
Depth of cut up to

0.8-1.8 mm
6 mm

配合刀杆
for Toolholder

型号 H262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	w	t _{max}	γ	α	形式 Form	EG35
LS262.4508.04	0.8	2.0	0°	45°	A	▲
LS262.4509.04	0.9	4.0	0°	45°	A	▲
LS262.4510.06	1.0	6.0	0°	45°	A	▲
LS262.4512.06	1.2	6.0	0°	45°	A	▲
LS262.6015.02	1.8	2.5	0°	60°	B	▲
LS262.7010.02	1.2	2.5	0°	70°	B	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	○
N	-
S	-
H	-

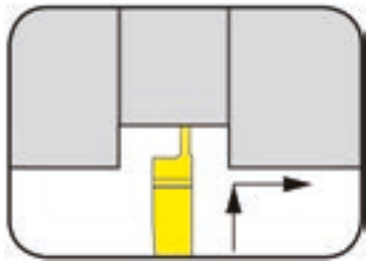
硬质合金牌号
Carbide grades

切槽/背车
Grooving/Backturning



可转位刀片
Indexable insert

S262



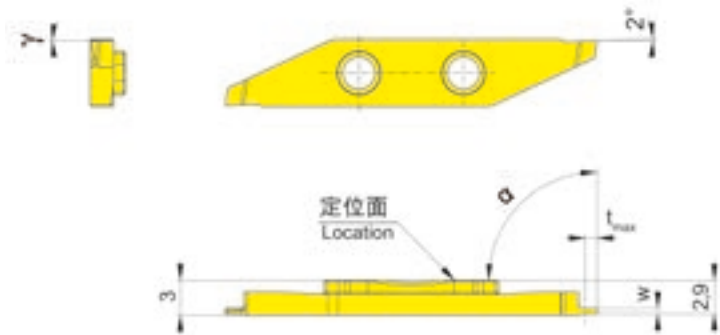
槽宽
切深可达

Width of groove
Depth of cut up to

0.5-2 mm
3 mm

配合刀杆
for Toolholder

型号 H262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	W	t _{max}	γ	α	EG35
LS262.0005.01	0.5	1	0°	90°	▲
LS262.0010.02	1.0	2	0°	90°	▲
LS262.0012.02	1.2	2	0°	90°	▲
LS262.0015.03	1.5	3	0°	90°	▲
LS262.0020.03	2.0	3	0°	90°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

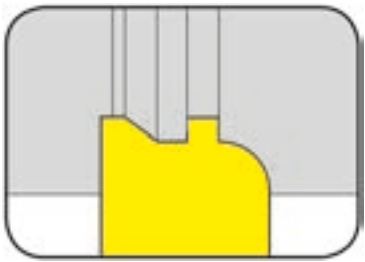
J

半精加工刀片
Semi-finished Insert



可转位刀片
Indexable insert

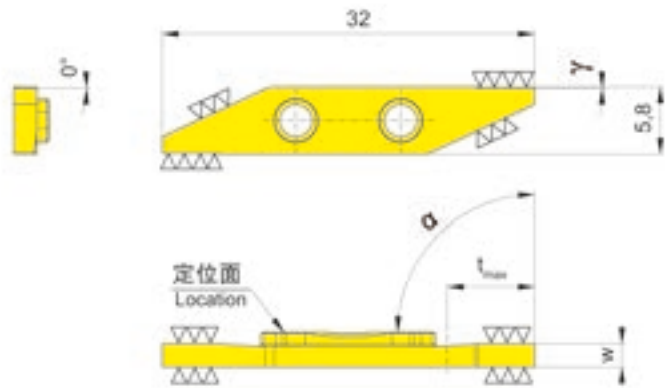
S262



槽宽 切深可达	Width of groove Depth of cut up to	2 mm 7.5 mm

配合刀杆
for Toolholder

型号 H262
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	w	t _{max}	γ	α	MG12	
LS262.8520.06	2	7.5	0°	90°	▲	○
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request ● 推荐 / recommended ○ 次推荐 / alternative recommendation - 不合适 / not suitable ■ 非涂层 / uncoated grades ■ 涂层 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet 尺寸单位 : mm Dimensions in mm						P
						M
						K
						N
						S
						H

硬质合金牌号
Carbide grades

切槽和侧车削 (外圆)

Grooving and Side Turning (external)



机夹式刀杆

槽宽 1.5 - 3 mm

Toolholder with Inserts

Width of groove 1.5 - 3 mm

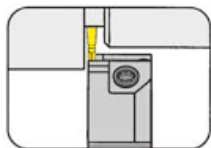
K

切槽和侧车削 (外圆)

Grooving and Side Turning (external)

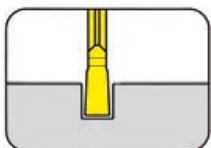


刀杆
Toolholder
H264

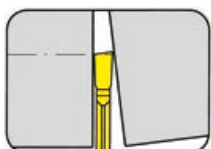


页/Page
K3-K6

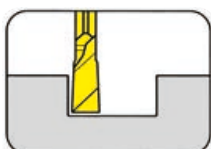
可转位刀片
Indexable insert
264



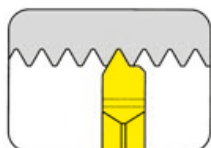
页/Page
K7, K9, K11



页/Page
K8, K10



页/Page
K12-K13



页/Page
K14

切槽和切断

Grooving and Parting Off

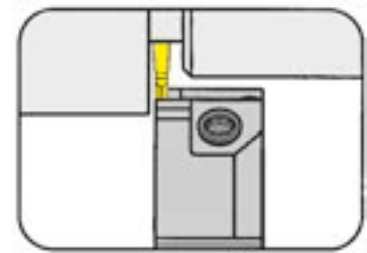


刀杆

Toolholder

H264

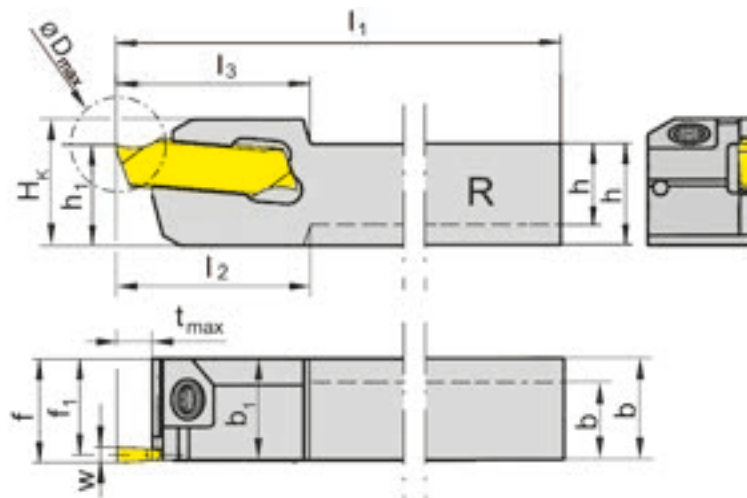
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
1.5-2 mm



配合可转位刀片
for Indexable insert

型号 264
Type S264

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

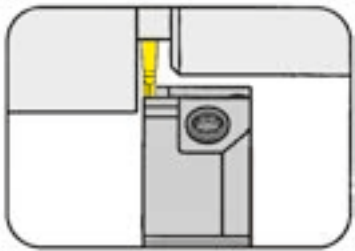


刀杆

Toolholder

H264

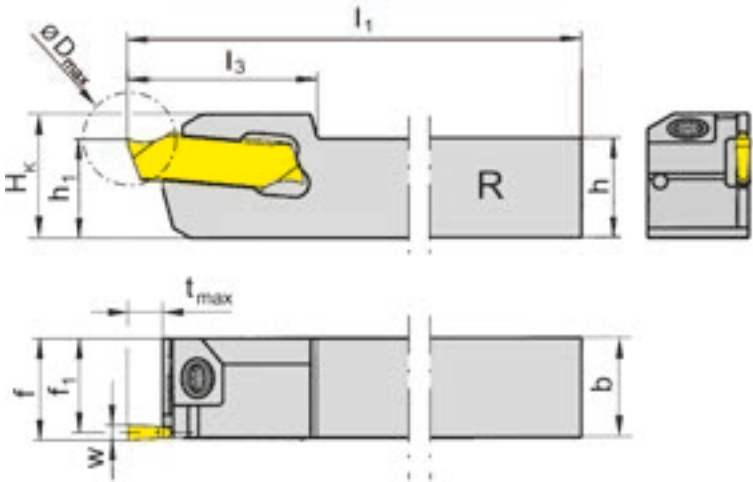
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
2,5 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 264
Type S264

产品型号 Part number	h	b	l ₁	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	尺寸规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	32	18.5	03
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	32	18.5	03
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	32	18.5	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

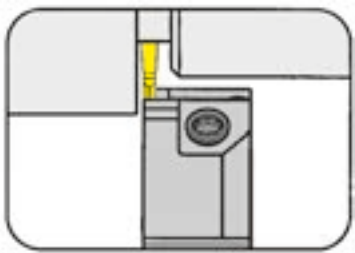


刀杆

Toolholder

H264

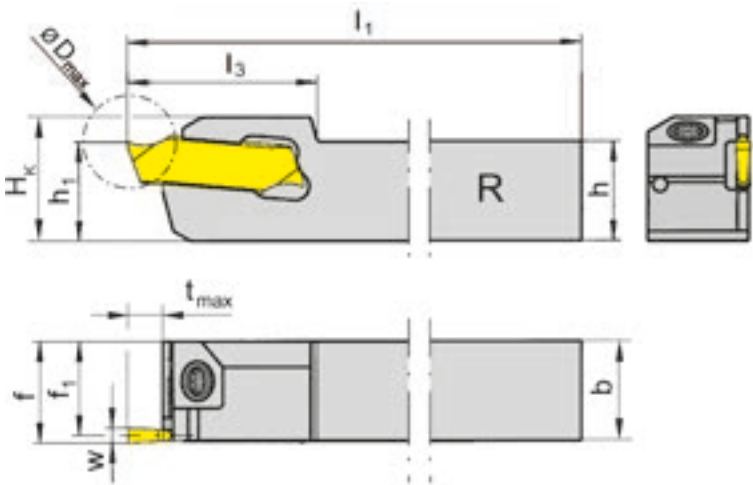
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 264
Type S264

产品型号 Part number	h	b	l ₁	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	尺寸规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	32	15	04
R/LH264.1616.04	16	16	120	17.5	16	14.5	16	5	32	19	04
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	32	15	04
R/LH264.1616.14	16	16	120	19.0	16	14.5	16	10	32	19	04
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	32	15	04
R/LH264.1616.24	16	16	120	25.0	16	14.5	16	16	32	19	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

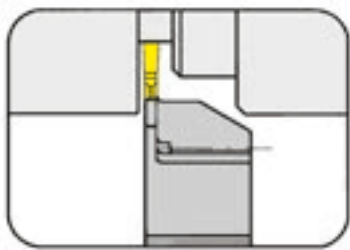
Grooving and Parting Off



刀杆

Toolholder

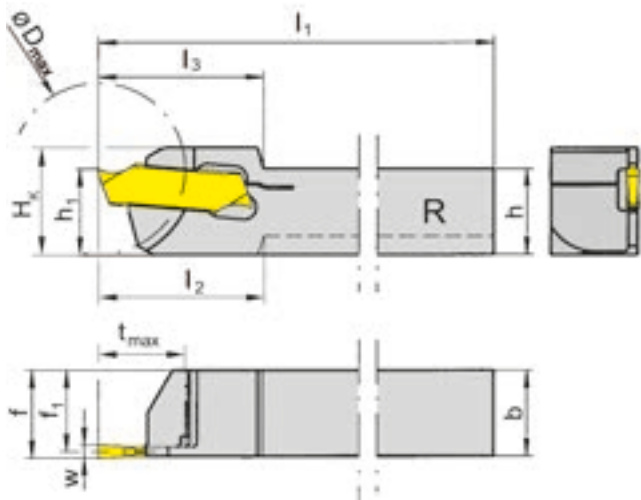
H264
自夹紧
with self clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

10 mm
1.5-3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 264
Type S264

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	尺寸规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	32	14.5	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Note:
Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

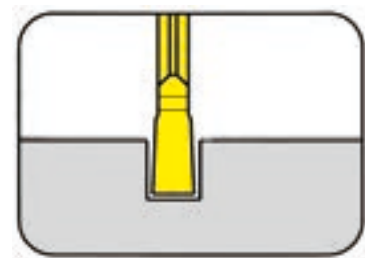
切槽和切断

Grooving and Parting Off



可转位刀片 Indexable insert

264

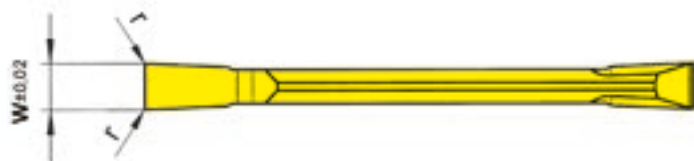
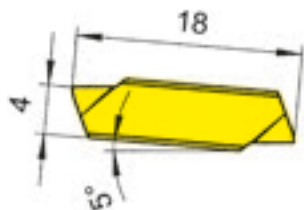


槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
1.5-3 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H264
Type

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

产品型号 Part number	w	r	尺寸规格 Size	MG12	TH35	TN35
264.0150.M0	1.5	0.05	01	▲	△	▲
264.0200.M0	2.0	0.05	02	▲	△	▲
264.0250.M0	2.5	0.10	03	△	△	▲
264.0300.M0	3.0	0.10	04	△	△	△
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	o	•
● 推荐 / recommended				M	-	•
o 次推荐 / alternative recommendation				K	-	•
- 不合适 / not suitable				N	-	•
■ 非涂层 / uncoated grades				S	-	•
■ 涂层 / coated grades				H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

K

切断

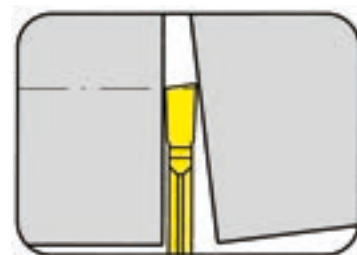
Parting Off



可转位刀片

Indexable insert

264

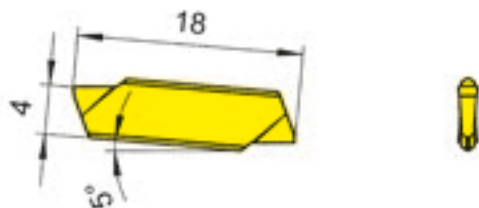


槽深可达
槽宽

Depth of groove up to
Width of groove

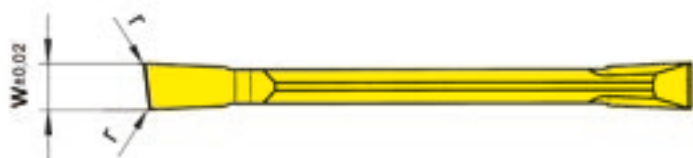
16 mm
1.5-3 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H264
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	TH35	TN35
R/L264.0815.M0	1.5	0.05	8°	01	Δ/▲	Δ/Δ	▲/▲
R/L264.1515.M0	1.5	0.05	15°	01	▲/▲	Δ/Δ	▲/Δ
R/L264.0820.M0	2.0	0.05	8°	02	Δ/Δ	Δ/Δ	▲/Δ
R/L264.1520.M0	2.0	0.05	15°	02	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.0825.M0	2.5	0.10	8°	03	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.1525.M0	2.5	0.10	15°	03	Δ/Δ	Δ/x	▲/Δ
R/L264.0830.M0	3.0	0.10	8°	04	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.1530.M0	3.0	0.10	15°	04	Δ/Δ	Δ/Δ	▲/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

K

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

264

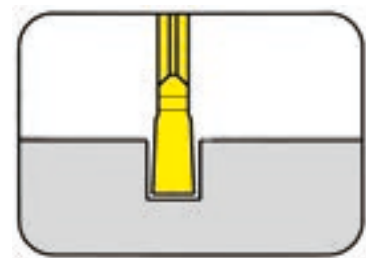
槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
1.5-3 mm

精密磨削

precision ground



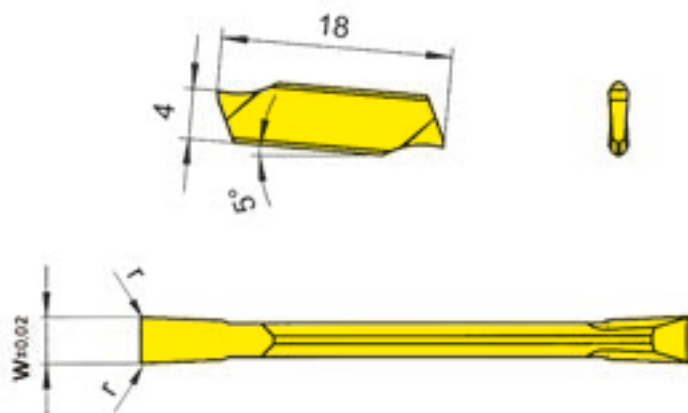
配合刀杆

for Toolholder

型号

H264

Type



刀片长度重复定位精度

±0.015 mm

Indexability length

± 0.015 mm

产品型号 Part number	w	r	尺寸规格 Size	MG12	TH35	TI25	TN35
264.0150.10	1.5	0.05	01	▲	△	△	▲
264.0200.10	2.0	0.05	02	▲	△	△	▲
264.0250.10	2.5	0.10	03	△	△	△	▲
264.0300.10	3.0	0.10	04	▲	△	△	▲
				P	o	•	•
				M	-	•	•
				K	-	•	•
				N	-	•	•
				S	-	•	•
				H	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

K

切断

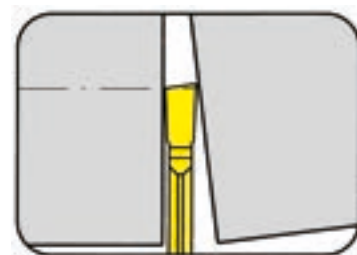
Parting Off



可转位刀片

Indexable insert

264



槽深可达
槽宽

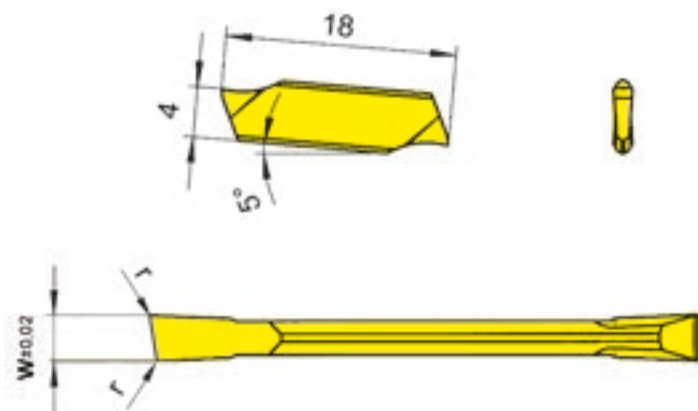
Depth of groove up to
Width of groove

16 mm
1.5-3 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H264
Type



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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	TH35	Ti25	TN35
R/L264.0815.10	1.5	0.05	8°	01	▲/△	△/△	△/△	▲/▲
R/L264.1515.10	1.5	0.05	15°	01	▲/△	△/△		▲/▲
R/L264.0820.10	2.0	0.05	8°	02	▲/△	△/△		▲/▲
R/L264.1520.10	2.0	0.05	15°	02	▲/△	△/△		▲/▲
R/L264.0825.10	2.5	0.10	8°	03	△/△	△/△		▲/△
R/L264.1525.10	2.5	0.10	15°	03	△/△	△/△		▲/△
R/L264.0830.10	3.0	0.10	8°	04	△/△	△/△		△/△
R/L264.1530.10	3.0	0.10	15°	04	△/△	△/△		▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

K

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

264

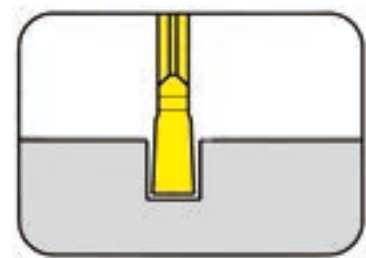
槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
1.5-3 mm

精密磨削

precision ground



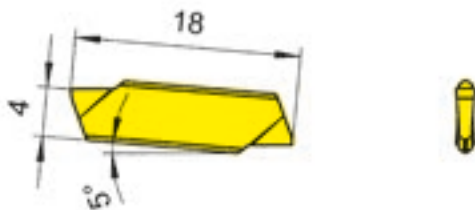
配合刀杆

for Toolholder

型号

H264

Type



刀片长度重复定位精度

±0.015 mm

Indexability length

± 0.015 mm

产品型号 Part number	w	r	尺寸规格 Size	MG12	TH35	TI25	TN35
264.0150.20	1.5	0.05	01	Δ	Δ	Δ	▲
264.0200.20	2.0	0.05	02	Δ	Δ		▲
264.0250.20	2.5	0.10	03	Δ	Δ		▲
264.0300.20	3.0	0.10	04	Δ	Δ		▲
				P	o	•	•
				M	-	•	•
				K	-	•	•
				N	-	•	•
				S	-	•	•
				H	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

• 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

K

切槽和侧车削

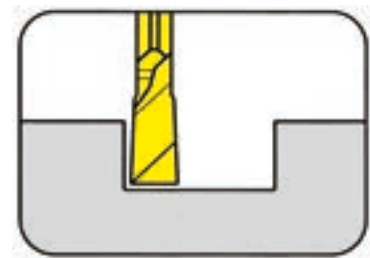
Grooving and Side Turning



可转位刀片

Indexable insert

264



槽深可达
槽宽

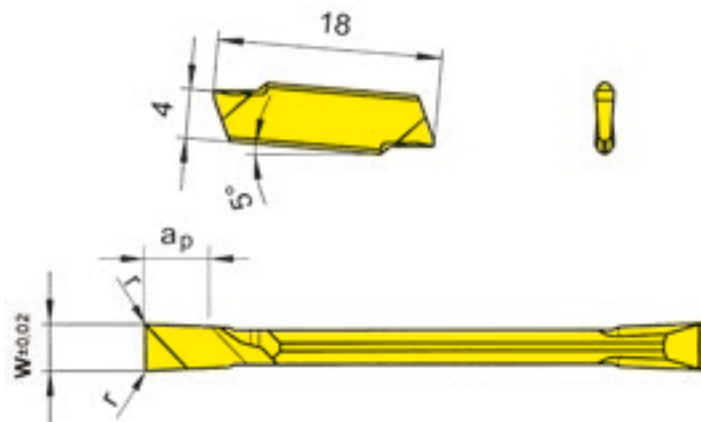
Depth of groove up to
Width of groove

16 mm
1.5-3 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H264
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

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

产品型号 Part number	w	r	尺寸规格 Size	MG12	TH35	T125	TN35
R/L264.0150.P0	1.5	0.05	01	△/△	△/△	▲/▲	▲/▲
R/L264.0200.P0	2.0	0.05	02	△/△	△/△	▲/▲	▲/▲
R/L264.0200.P2	2.0	0.20	02				△/△
R/L264.0250.P0	2.5	0.10	03	△/△	△/△	△/△	▲/▲
R/L264.0250.P2	2.5	0.20	03				△/△
R/L264.0300.P0	3.0	0.10	04	△/△	△/△	▲/▲	▲/▲
R/L264.0300.P2	3.0	0.20	04				△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

$a_p = 1.5 \times w$

$a_p = 1.5 \times w$

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

硬质合金牌号
Carbide grades

K

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

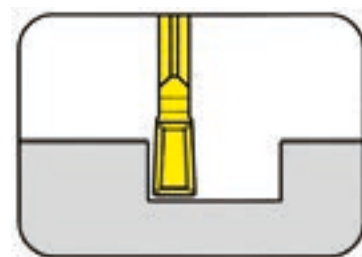
264

槽深可达
槽宽

Depth of groove up to
Width of groove

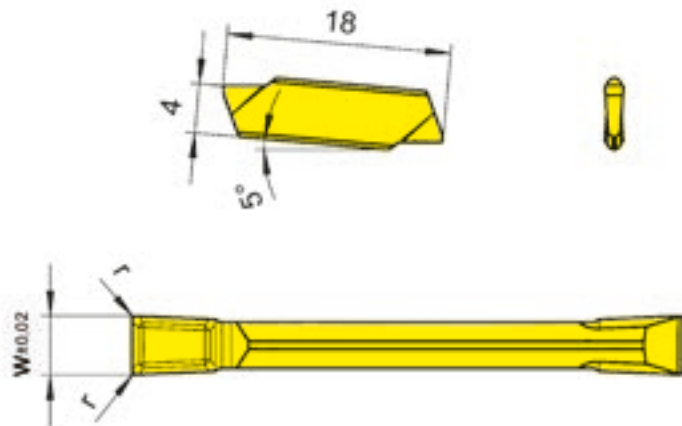
16 mm
1.5-3 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H264
Type



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

产品型号 Part number	w	r	尺寸规格 Size	MG12	TN35
S264.0150.D1	1.5	0.05	01	Δ	▲
S264.0200.D1	2.0	0.05	02	Δ	▲
S264.0250.D1	2.5	0.10	03	Δ	▲
S264.0300.D1	3.0	0.10	04	Δ	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•
● 推荐 / recommended				M	•
○ 次推荐 / alternative recommendation				K	•
- 不合适 / not suitable				N	•
■ 非涂层 / uncoated grades				S	•
■ 涂层 / coated grades				H	-
■ 钎焊/金属陶瓷 / brazed/Cermet					
尺寸单位 : mm Dimensions in mm				硬质合金牌号 Carbide grades	
此可转位刀片可用于右手和左手型刀杆 Indexable inserts can be used in right and left hand toolholders.					

K

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

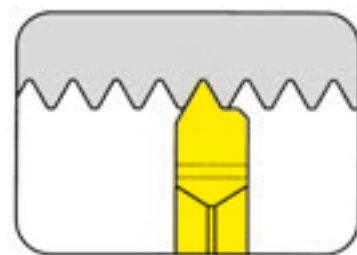


可转位刀片

Indexable insert

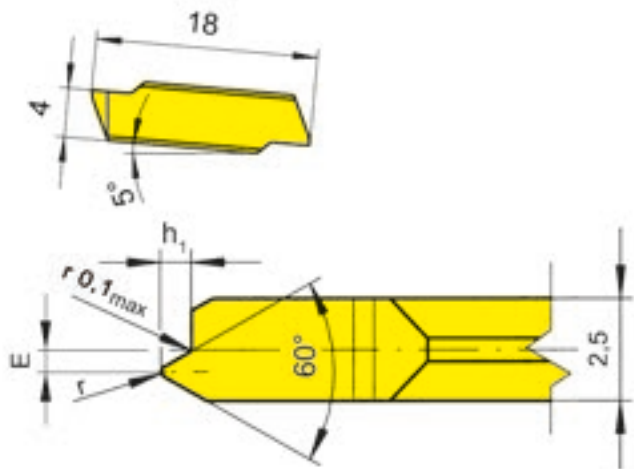
264

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-1.5 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H264
Type

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

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

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

K

274



机夹式刀杆

槽宽0.5 - 7 mm

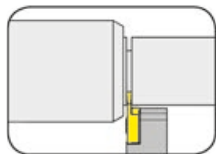
Toolholder with Inserts

Width of groove 0.5 - 7 mm

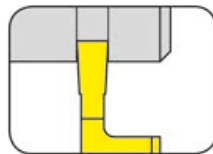
刀杆

Toolholder

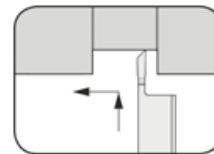
H274/H274...E/
H274...SF/HC274



页/Page
L3, L6, L29, L46-L47



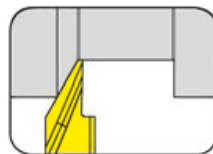
页/Page
L15-L17, L32-L34



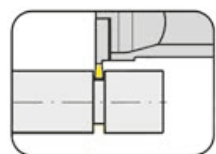
页/Page
L53-L54



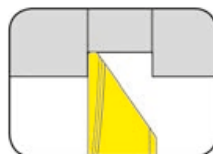
页/Page
L4-L5



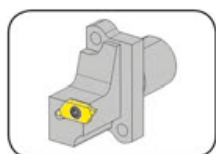
页/Page
L18, L35



页/Page
L8



页/Page
L19, L36



页/Page
L9



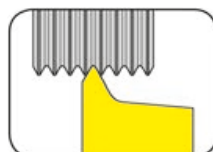
页/Page
L20-L25, L37-L42, L51-L52

Graf刀杆 型号

Toolholder Graf
974



页/Page
L7



页/Page
L26, L43

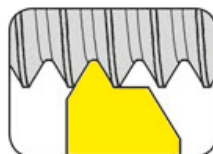
刀夹

Cartridge

KT274/KTC274



页/Page
L10-L11



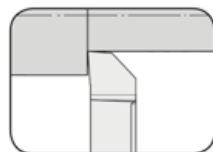
页/Page
L27-L28, L44-L45

Graf刀夹

Cartridge Graf
99



页/Page
L12

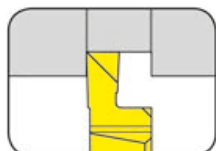


页/Page
L48

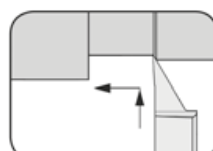
可转位刀片

Indexable insert

S274/S274...E/
S274...SF



页/Page
L13-L14, L30-L31



页/Page
L49-L50

切槽和侧车削

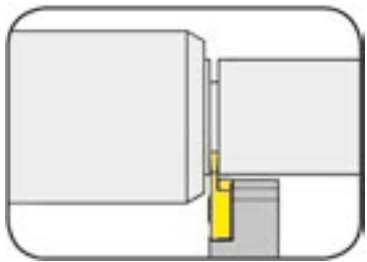
Grooving and Side Turning



刀杆

Toolholder

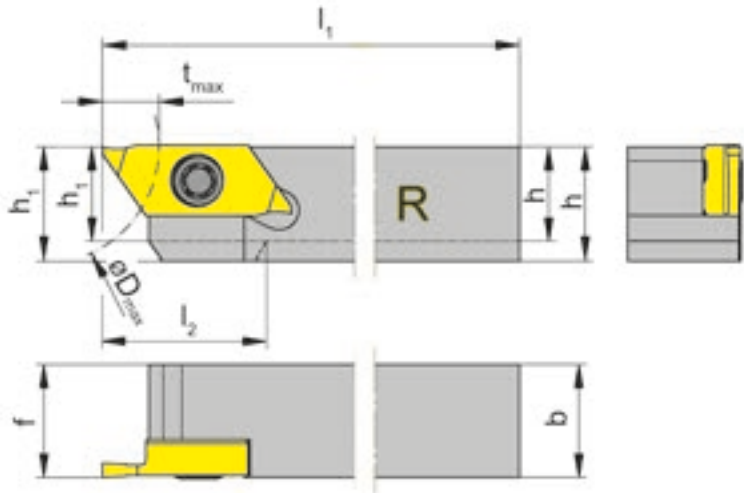
H274



槽深	Depth of groove	6 mm
槽宽	Width of groove	0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH274.0808.04	030.350P.0744	T15PQ
R/LH274...	030.3509.T15P	T15PQ



刀杆
Toolholder

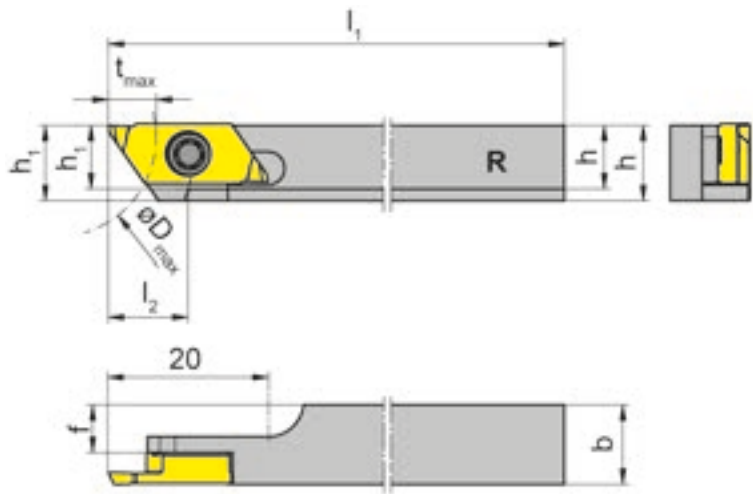
H274

槽深 槽宽	Depth of groove Width of groove	6 mm 0.5-3 mm



配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

产品型号 Part number	h	b	l_1	l_2	h_1	f	t_{max}	D_{max}	尺寸规格 Size
RH274.0808.6.04	8	8	100	10	9.5	4	6	25	04
RH274.1010.6.04	10	10	100	10	9.5	6	6	25	04
RH274.1212.6.04	12	12	100	10	9.5	8	6	25	04

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RH274...	030.350P.0981	T15PQ

刀杆
Toolholder

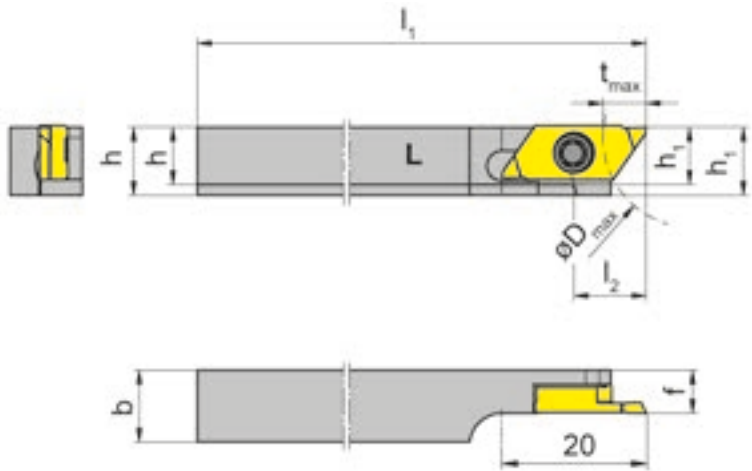
H274

槽深 槽宽	Depth of groove Width of groove	6 mm 0.5-3 mm



配合可转位刀片
for Indexable insert

型号 S274
Type



L=左手型-如图
L = left hand version shown

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f	t _{max}	D _{max}	尺寸规格 Size
LH274.0808.6.04.M	8	8	100	10	9.5	6	6	25	04
LH274.1010.6.04.M	10	10	100	10	9.5	6	6	25	04
LH274.1212.6.04.M	12	12	100	10	9.5	6	6	25	04

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

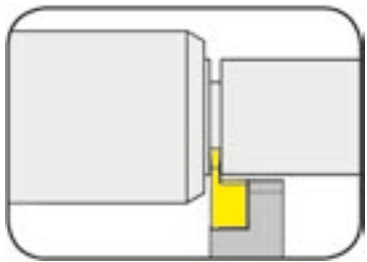
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LH274...	030.350P.0981	T15PQ



刀杆
Toolholder

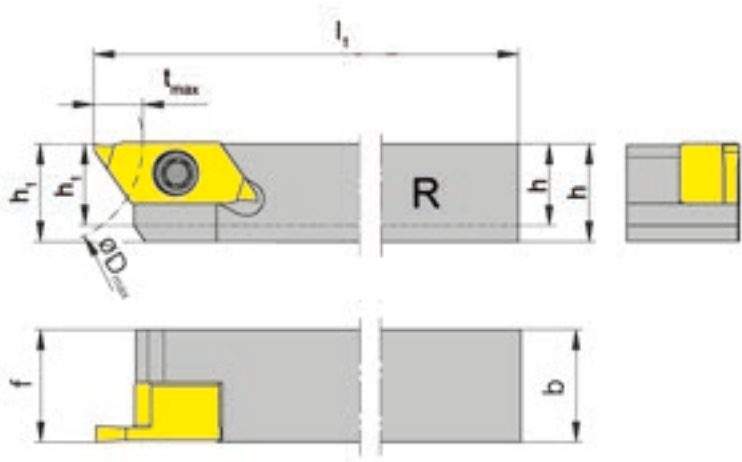
H274

槽深 槽宽可达	Depth of groove Width of groove up to	6 mm 7 mm



配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于特殊宽度
for special widths

产品型号 Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	尺寸规格 Size
R/LH274.1214.07	12	14	100	12	14	6	25	07
R/LH274.1616.07	16	16	125	16	16	6	25	07

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

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



切槽和侧车削

Grooving and Side Turning



Graf刀杆 型号

Toolholder Graf

974

直接冷却液供应
with through coolant supply



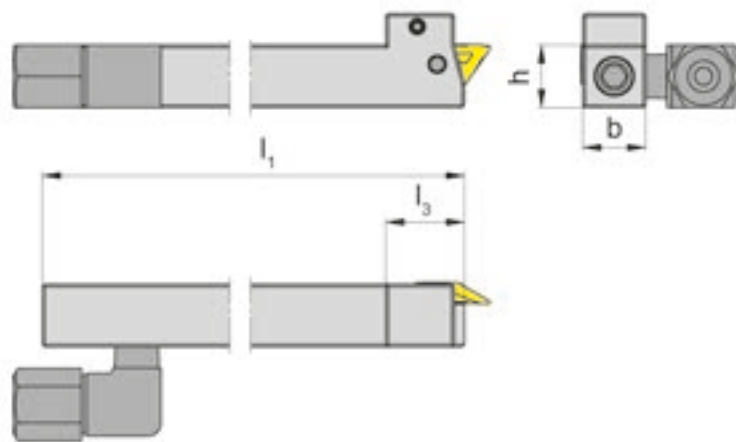
槽深
槽宽

Depth of groove
Width of groove

6 mm
0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_3	尺寸规格 Size
974 L 1012.04 IK	10	12	100	15	04
974.R 1012.04 IK	10	12	100	15	04
974.L 1212.04 IK	12	12	100	15	04
974.R 1212.04 IK	12	12	100	15	04
974.L 1616.04 IK	16	16	100	15	04
974.R 1616.04 IK	16	16	100	15	04
974.L 2020.04 IK	20	20	100	15	04
974.R 2020.04 IK	20	20	100	15	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

L

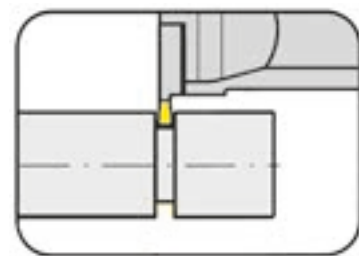
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆
Toolholder

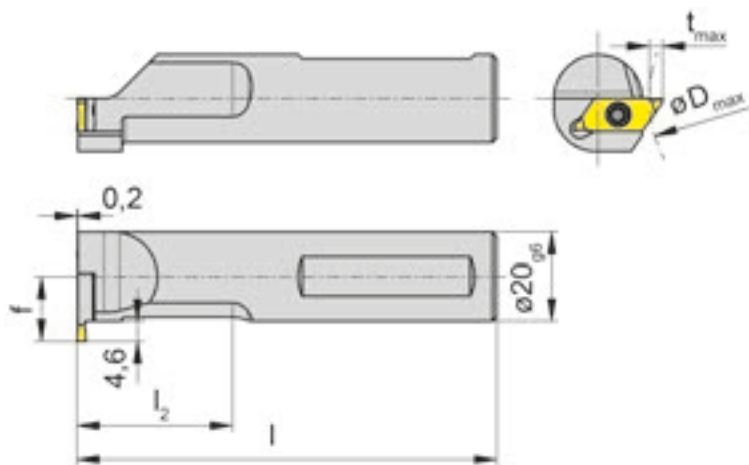
HC274



槽深可达
槽宽可达

Depth of groove up to
Width of groove up to

4 mm
3 mm



配合可转位刀片
for Indexable insert

型号 LS274...
Type

直径-Ø与切深关系
Depth of groove in relation to bore Ø

D _{max}	t _{max}
40	2,0
60	3,0
120	3,5

TRAUB TNL18 / 32

R=右手型-如图
R = right hand version shown

产品型号 Part number	l	l ₂	f	t _{max}	尺寸规格 Size
RHC274.0020.1.04	95	35	14.6	4	04

按需提供更多尺寸
Further sizes upon request

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
使用左手刀片用于右手刀杆。

Ordering note:
Use left hand insert in right hand toolholder.

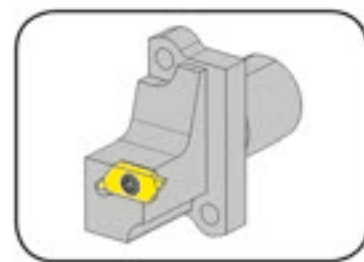
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RHC274.0020.1.04	030.3509.T15P	T15PQ

刀杆 Toolholder

H274

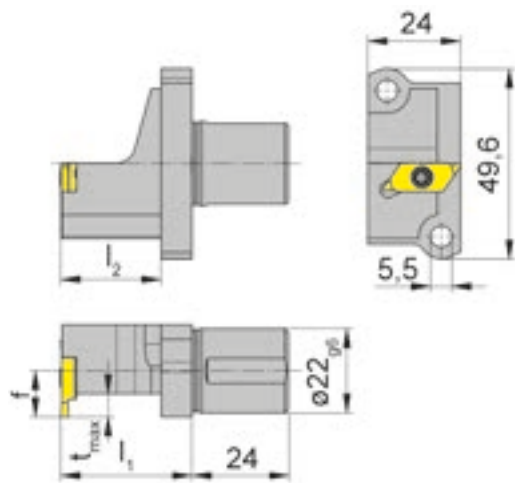


槽深可达
槽宽可达

Depth of groove up to
Width of groove up to

6 mm
7 mm

孔位 13,7 x 37,6 mm
Hole pattern 13,7 x 37,6 mm



配合可转位刀片
for Indexable insert

型号 S274
Type

适用于Star Swiss机床
for Swiss type machines Star

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件 Spare Parts

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

切槽和侧车削

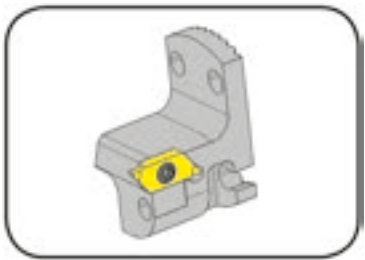
Grooving and Side Turning



刀夹

Cartridge

KT274



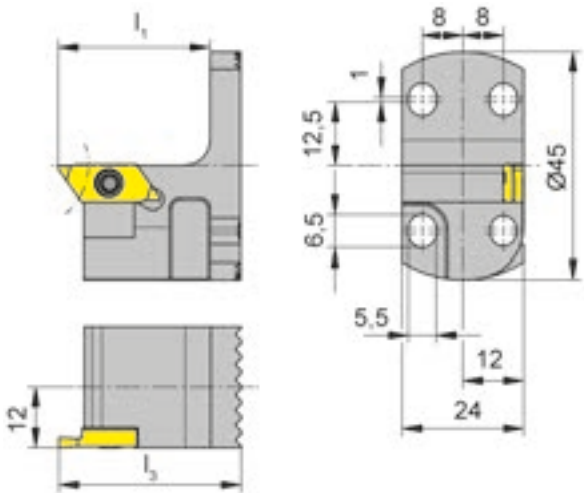
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_3	l_1	尺寸规格 Size
R/LKT274.2445.04	36	30	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LKT274.2445.04	030.3509.T15P	T15PQ

切槽和侧车削

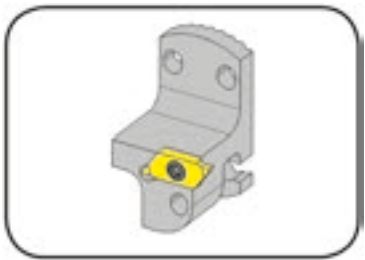
Grooving and Side Turning



刀夹

Cartridge

KTC274



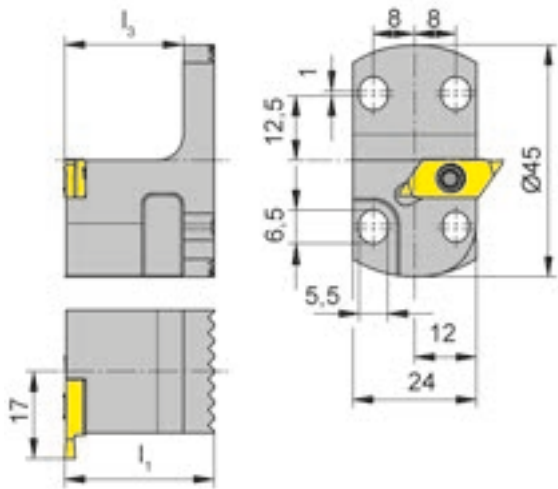
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

产品型号 Part number	L ₁	L ₃	尺寸规格 Size
RKTC274.2445.04	29	23	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
使用左手刀片用于右手刀杆。

Ordering note:
Use left hand insert in right hand toolholder.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RKTC274.2445.04	030.3509.T15P	T15PQ

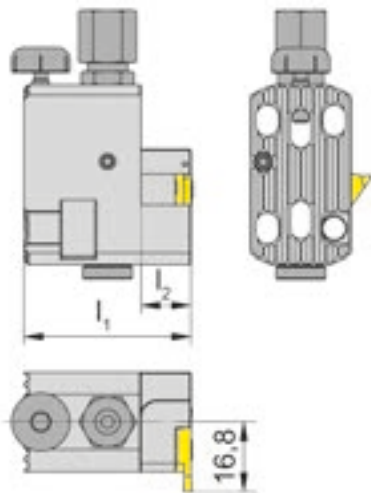


Graf刀夹
Cartridge Graf

R76IK
直接冷却液供应
with through coolant supply



槽深	Depth of groove	6 mm
槽宽	Width of groove	0.5-3 mm



配合可转位刀片
for Indexable insert

型号 S274
Type

R=右手型-如图
R = right hand version shown

产品型号 Part number	l_1	l_2	尺寸规格 Size
R76IK	40	12	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
使用左手刀片用于右手刀杆。

Ordering note:
Use left hand insert in right hand toolholder.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

Graf刀夹 Cartridge Graf	高度调节螺钉 Screw to adjust the height	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R76IK	002.00.69	004.00.19	030.3509.T15P	T15PQ

切槽和侧车削

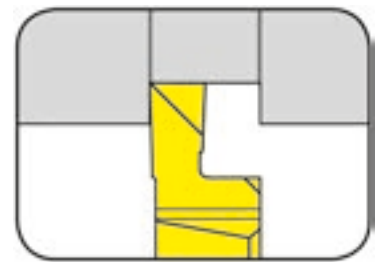
Grooving and Side Turning



可转位刀片

Indexable insert

S274

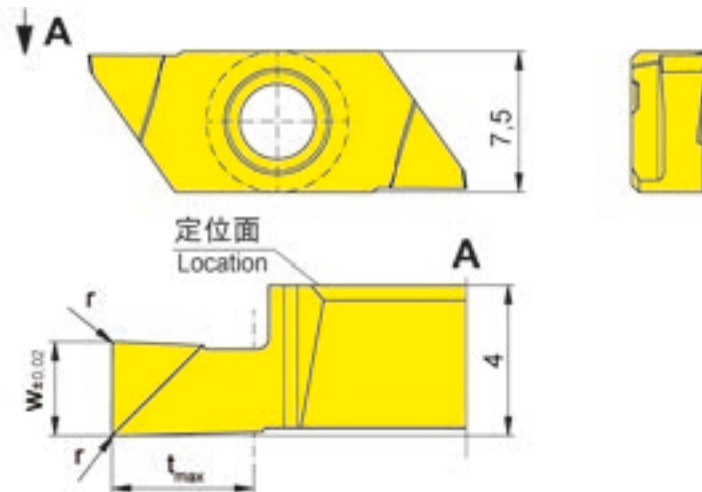


槽深可达
槽宽

Depth of groove up to
Width of groove

4.5 mm
0.5-3 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
76
H274KM
HC274KM

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

产品型号 Part number	w	r	t _{max}	尺寸规格 Size	AN25	IG35	TH35
R/LS274.0050.P0	0.5	-	1.00	04	▲/▲	▲/▲	▲/▲
R/LS274.0100.P0	1.0	-	2.00	04	▲/▲	▲/▲	▲/▲
R/LS274.0150.P0	1.5	0.05	2.25	04		▲/▲	▲/▲
R/LS274.0200.P0	2.0	0.05	3.00	04		▲/Δ	▲/▲
R/LS274.0250.P0	2.5	0.10	3.75	04		▲/▲	▲/▲
R/LS274.0300.P0	3.0	0.10	4.50	04		▲/Δ	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	•	•
● 推荐 / recommended					M	○	•
○ 次推荐 / alternative recommendation					K	-	-
- 不合适 / not suitable					N	-	•
■ 非涂层 / uncoated grades					S	-	•
■ 涂层 / coated grades					H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet							

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

硬质合金牌号
Carbide grades

L

切槽和侧车削

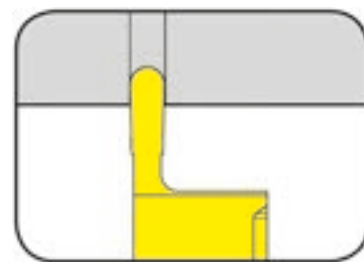
Grooving and Side Turning



可转位刀片

Indexable insert

S274

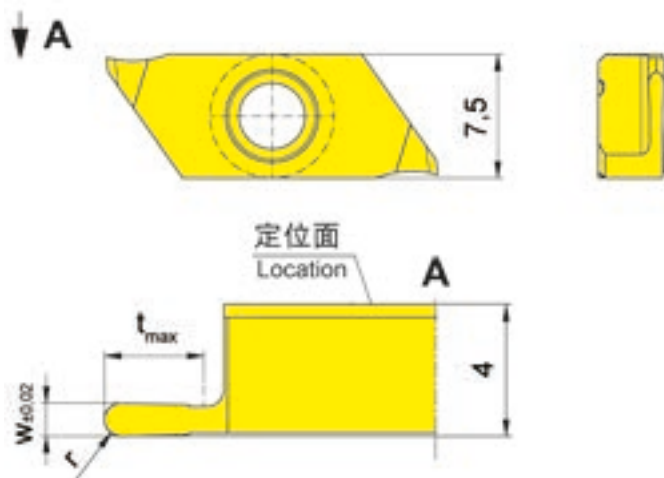


槽深可达
圆头

Depth of groove up to
Full radius

4 mm
0.25-1 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	w	t _{max}	r	尺寸规格 Size	IG35	TH35
R/LS274.0205.01.10	0.5	1.5	0.25	04	▲/▲	▲/▲
R/LS274.0510.03.10	1.0	3.0	0.50	04	▲/▲	▲/▲
R/LS274.1020.04.10	2.0	4.0	1.00	04	▲/Δ	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

切槽和切断

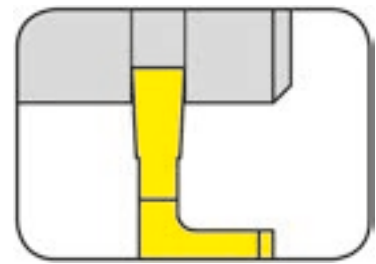
Grooving and Parting Off



可转位刀片

Indexable insert

S274



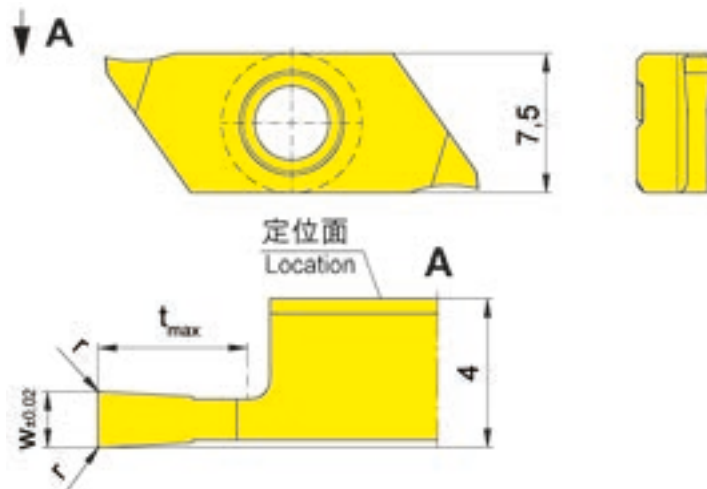
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号

Type

H274

KT274

KTC274

974

R76

H274KM

HC274KM

刀片长度重复定位精度

±0.015 mm

Indexability length

± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	t _{max}	尺寸规格 Size	IG35	TH35
R/LS274.0050.01.10	0.5	0.05	1.5	04	▲/▲	▲/▲
R/LS274.0070.02.10	0.7	0.05	2.0	04	x/Δ	▲/Δ
R/LS274.0080.03.10	0.8	0.05	3.0	04	▲/▲	▲/▲
R/LS274.0100.03.10	1.0	0.05	3.0	04	▲/▲	▲/▲
R/LS274.0120.03.10	1.2	0.05	3.0	04	▲/▲	▲/▲
R/LS274.0150.04.10	1.5	0.05	4.0	04	▲/▲	▲/▲
R/LS274.0150.06.10	1.5	0.05	6.0	04	▲/▲	▲/▲
R/LS274.0200.04.10	2.0	0.05	4.0	04	▲/▲	▲/▲
R/LS274.0200.06.10	2.0	0.05	6.0	04	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

L

切槽和切断

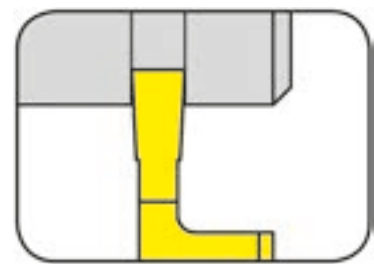
Grooving and Parting Off



可转位刀片

Indexable insert

S274



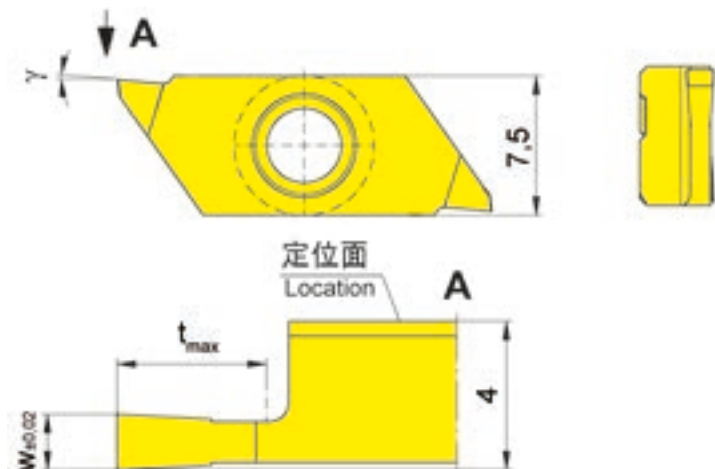
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号

Type

H274

KT274

KTC274

974

R76

H274KM

HC274KM

刀片长度重复定位精度

± 0.015 mm

Indexability length

± 0.015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	t _{max}	γ	尺寸规格 Size	IG35	TH35
R/LS274.0050.01.20	0.5	1.5	5°	04	▲/△	▲/▲
R/LS274.0070.02.20	0.7	2.0	5°	04	△/△	▲/▲
R/LS274.0080.03.20	0.8	3.0	5°	04	△/△	▲/△
R/LS274.0100.03.20	1.0	3.0	5°	04	▲/△	▲/△
R/LS274.0120.03.20	1.2	3.0	5°	04	△/△	▲/△
R/LS274.0150.04.20	1.5	4.0	5°	04	▲/▲	▲/▲
R/LS274.0150.06.20	1.5	6.0	5°	04	△/△	△/▲
R/LS274.0200.04.20	2.0	4.0	5°	04	△/△	▲/△
R/LS274.0200.06.20	2.0	6.0	5°	04	△/△	▲/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

L

切槽和切断

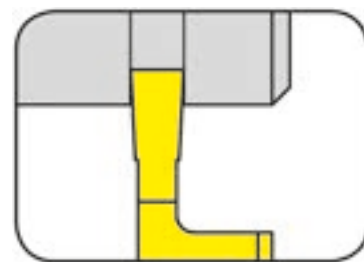
Grooving and Parting Off



可转位刀片

Indexable insert

S274



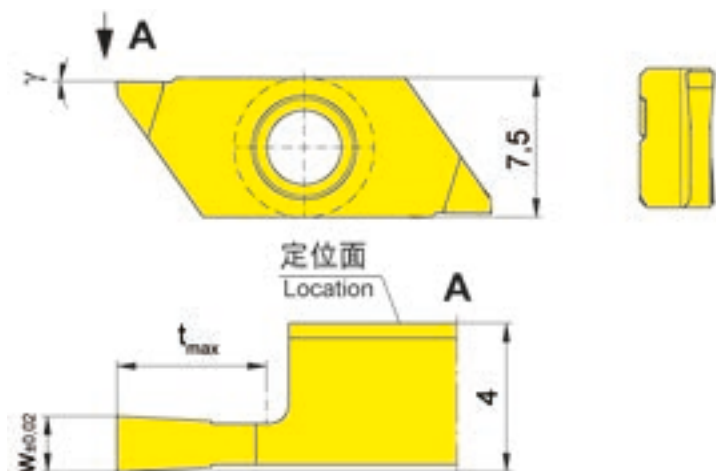
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号

H274

Type

KT274

KTC274

974

R76

H274KM

HC274KM

刀片长度重复定位精度

± 0.015 mm

Indexability length

± 0.015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	t _{max}	γ	尺寸规格 Size	IG35	TH35
R/LS274.0050.01.M0	0.5	1.5	0°	04	Δ/Δ	▲/Δ
R/LS274.0070.02.M0	0.7	2.0	0°	04	Δ/▲	Δ/Δ
R/LS274.0080.03.M0	0.8	3.0	0°	04	Δ/Δ	Δ/Δ
R/LS274.0100.03.M0	1.0	3.0	0°	04	Δ/Δ	▲/Δ
R/LS274.0120.03.M0	1.2	3.0	0°	04	Δ/Δ	▲/Δ
R/LS274.0150.04.M0	1.5	4.0	0°	04	Δ/Δ	Δ/Δ
R/LS274.0150.06.M0	1.5	6.0	0°	04	Δ/Δ	Δ/Δ
R/LS274.0200.04.M0	2.0	4.0	0°	04	Δ/Δ	Δ/Δ
R/LS274.0200.06.M0	2.0	6.0	0°	04	Δ/Δ	▲/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

L

背车削 (外圆)

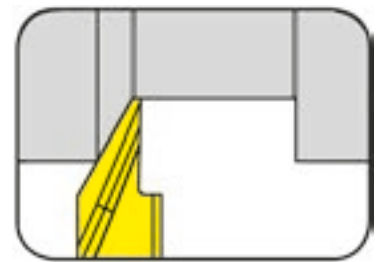
Backturning (external)



可转位刀片

Indexable insert

S274



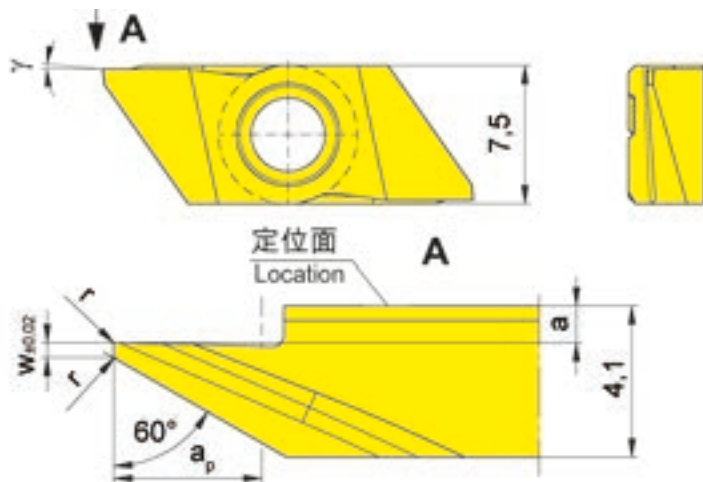
切深可达

Depth of cut up to

6 mm

精密磨削

precision ground



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合刀杆

for Toolholder

型号

H274

Type

KT274

KTC274

974

R76

H274KM

HC274KM

刀片长度重复定位精度

± 0.015 mm

Indexability length

± 0.015 mm

产品型号 Part number	w	r	a	γ	a_p	尺寸规格 Size		K10	IG35	TH35
R/LS274.0060.04.10	-	0.05	1.00	15°	4	04			▲/△	▲/△
R/LS274.0460.04.10	0.4	0.05	1.00	15°	4	04			▲/▲	▲/▲
R/LS274.0460.04.M0	0.4	0.05	1.00	0°	4	04		▲/△	△/△	△/△
R/LS274.0560.06.11	0.5	0.10	0.05	15°	6	04			▲/▲	▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

γ =前角

γ = rake angle

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

硬质合金牌号

Carbide grades

侧面车削

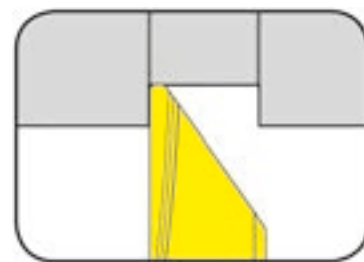
Side Turning



可转位刀片

Indexable insert

S274

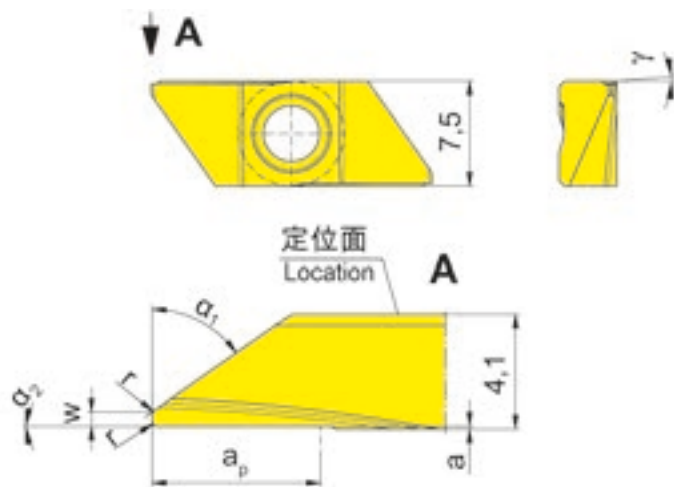


切深可达

Depth of cut up to

6 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	w	r	α_1	a	γ	a_p	α_2	尺寸规格 Size	IG35	TH35
R/LS274.0035.04.20	-	0.05	35°	0.1	5°	4	0°	04	▲/△	▲/△
R/LS274.0055.04.20	-	0.05	55°	0.1	5°	4	0°	04	△/△	▲/▲
R/LS274.0235.04.20	0.2	-	35°	0.1	5°	4	0°	04	▲/△	▲/▲
R/LS274.0255.04.20	0.2	-	55°	0.1	5°	4	0°	04	△/△	▲/△
R/LS274.0535.06.20	0.5	0.20	35°	0.1	5°	6	0°	04	▲/△	▲/△
R/LS274.0555.06.20	0.5	0.20	55°	0.1	5°	6	0°	04	▲/▲	▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

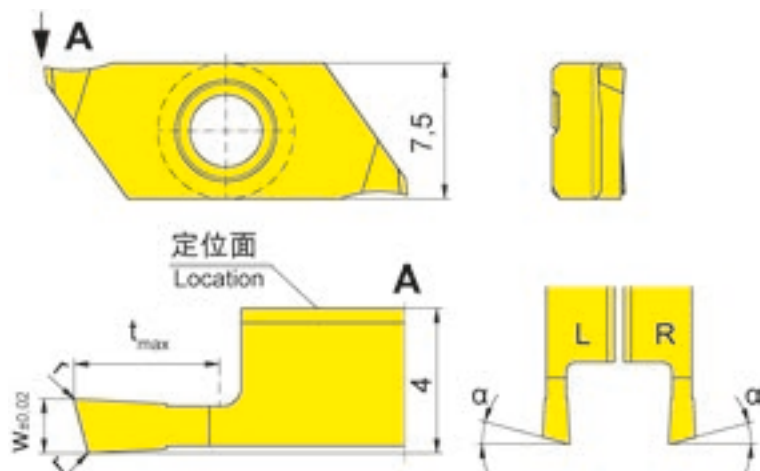
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.10	0.8	0.05	3	15°	04	▲/▲	▲/▲
R/LS274.1510.03.10	1.0	0.05	3	15°	04	▲/▲	▲/▲
R/LS274.1515.04.10	1.5	0.05	4	15°	04	▲/▲	▲/▲
R/LS274.1520.06.10	2.0	0.05	6	15°	04	▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P	•
● 推荐 / recommended						M	•
○ 次推荐 / alternative recommendation						K	•
- 不合适 / not suitable						N	•
■ 非涂层 / uncoated grades						S	•
■ 涂层 / coated grades						H	-
■ 钎焊/金属陶瓷 / brazed/Cermet							

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274

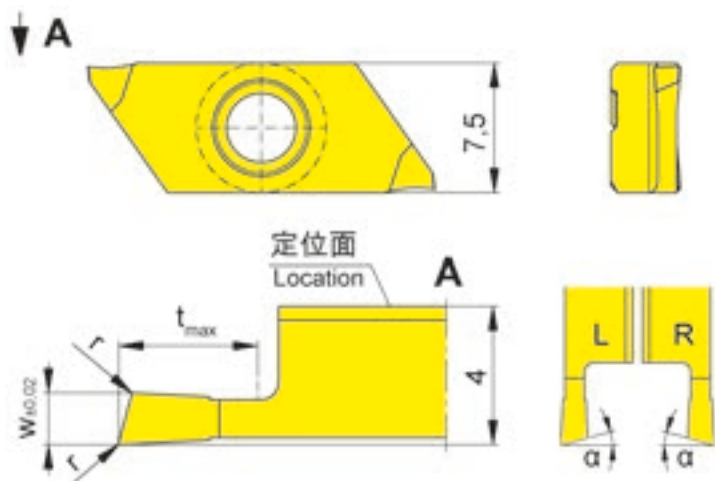


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
LS274.1508.03.10R	0.8	0.05	3	15°	04	▲	▲
LS274.1510.03.10R	1.0	0.05	3	15°	04	▲	▲
LS274.1515.04.10R	1.5	0.05	4	15°	04	▲	▲
LS274.1520.06.10R	2.0	0.05	6	15°	04	▲	▲
RS274.1508.03.10L	0.8	0.05	3	15°	04	△	△
RS274.1510.03.10L	1.0	0.05	3	15°	04	△	△
RS274.1515.04.10L	1.5	0.05	4	15°	04	△	△
RS274.1520.06.10L	2.0	0.05	6	15°	04	△	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

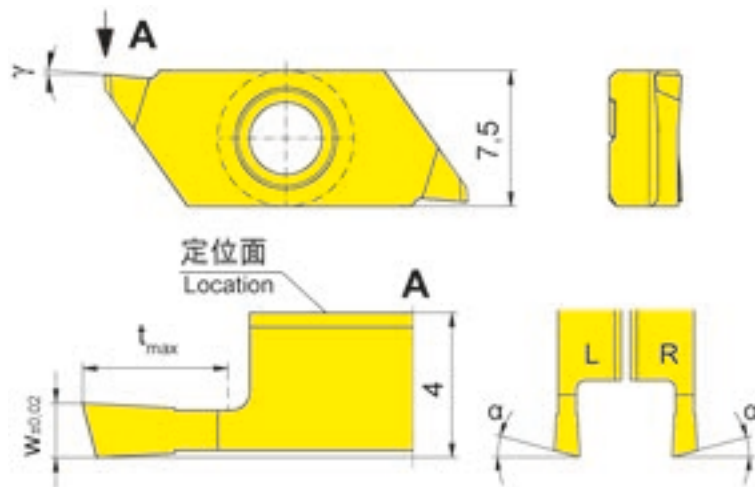
Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1515.04.20	1.5	4	15°	5°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.20	2.0	6	15°	5°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274

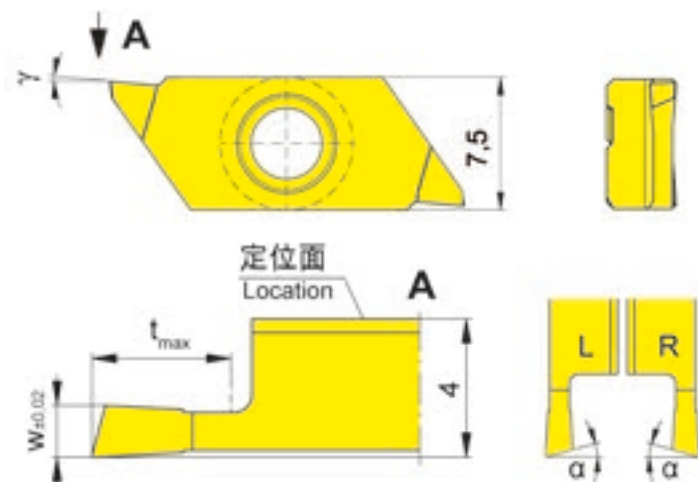


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1515.04.20R	1.5	4	15°	5°	04	Δ	Δ
LS274.1520.06.20R	2.0	6	15°	5°	04	Δ	Δ
RS274.1515.04.20L	1.5	4	15°	5°	04	Δ	Δ
RS274.1520.06.20L	2.0	6	15°	5°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

	P	M	K	N	S	H
IG35	-	•	-	-	•	-
TH35	•	•	•	•	•	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274

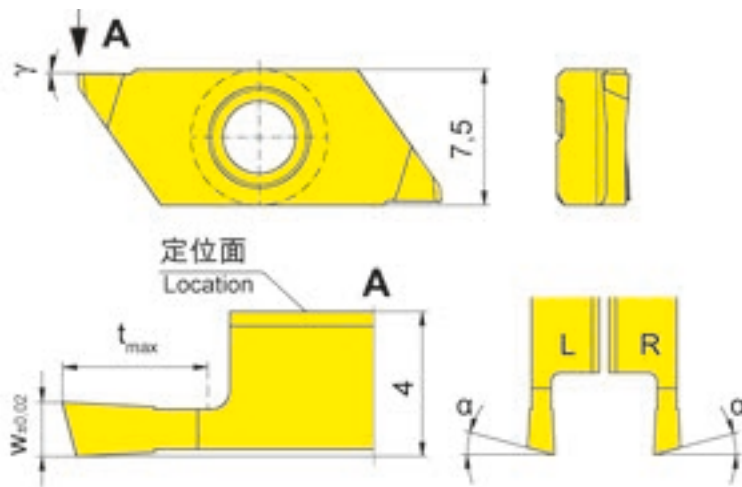


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.M0	0.8	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.M0	1.0	3	15°	0°	04	Δ/Δ	▲/Δ
R/LS274.1515.04.M0	1.5	4	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.M0	2.0	6	15°	0°	04	Δ/Δ	Δ/Δ
						P	•
						M	•
						K	•
						N	•
						S	•
						H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

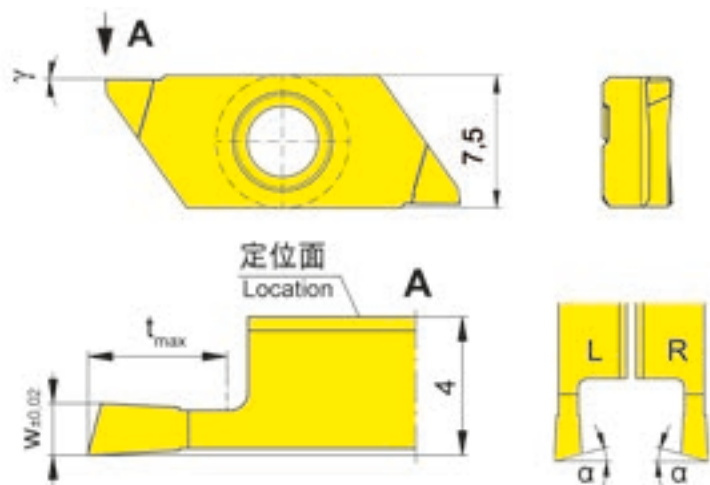
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1508.03.M0R	0.8	3	15°	0°	04	Δ	▲
LS274.1510.03.M0R	1.0	3	15°	0°	04	Δ	Δ
LS274.1515.04.M0R	1.5	4	15°	0°	04	Δ	Δ
LS274.1520.06.M0R	2.0	6	15°	0°	04	Δ	Δ
RS274.1508.03.M0L	0.8	3	15°	0°	04	Δ	Δ
RS274.1510.03.M0L	1.0	3	15°	0°	04	Δ	Δ
RS274.1515.04.M0L	1.5	4	15°	0°	04	Δ	Δ
RS274.1520.06.M0L	2.0	6	15°	0°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

L

螺纹切削 (外圆) -非全牙型

Threading (external) Partial profile

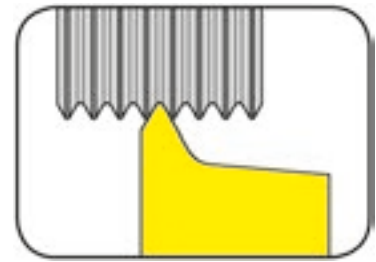


可转位刀片

Indexable insert

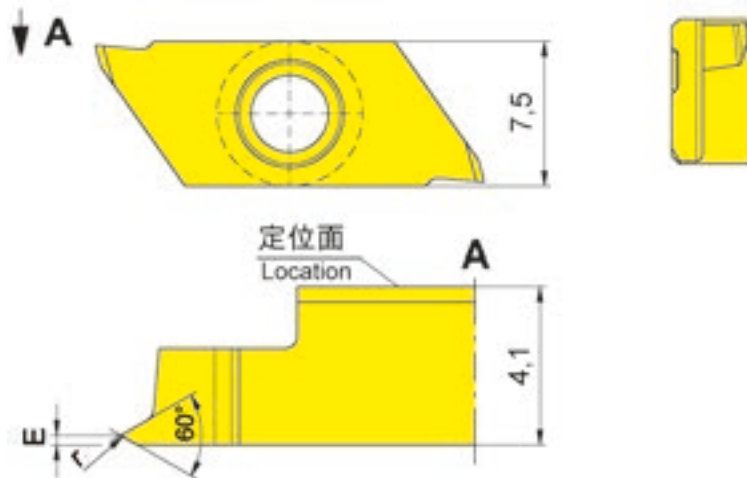
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.25-0.4 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	P	E	r	尺寸规格 Size	IG35	TH35
RS274.0102.01	0.25	0.20	0.04	04	▲	▲
RS274.0203.01	0.35	0.25	0.05	04	▲	▲
RS274.0204.01	0.40	0.30	0.06	04	▲	▲
					P	•
					M	•
					K	•
					N	•
					S	•
					H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

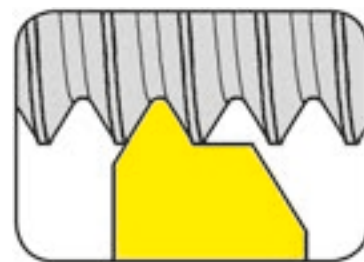


可转位刀片

Indexable insert

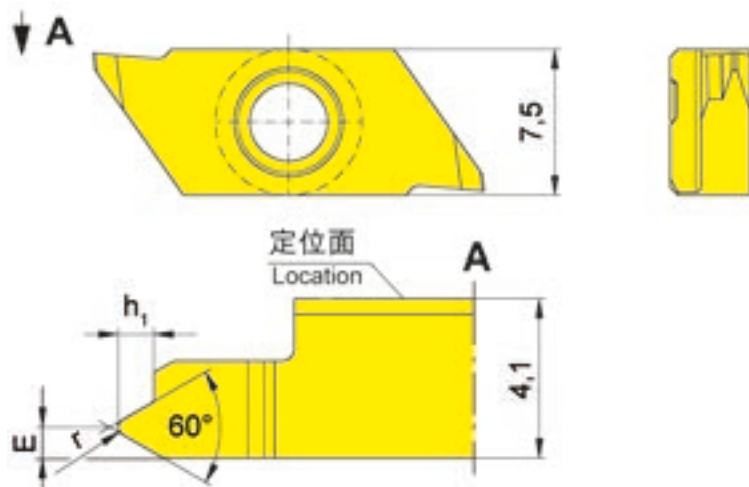
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-1.5 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	IG35	TH35
R/LS274.0305.02	0.50	0.40	0.07	0.31	04	▲/▲	▲/▲
R/LS274.0306.02	0.60	0.45	0.09	0.37	04	▲/▲	▲/▲
R/LS274.0307.02	0.70	0.50	0.10	0.43	04	▲/▲	▲/▲
R/LS274.0407.02	0.75	0.50	0.11	0.46	04	▲/▲	▲/▲
R/LS274.0408.02	0.80	0.55	0.12	0.49	04	▲/▲	▲/▲
R/LS274.0610.02	1.00	0.60	0.14	0.61	04	▲/▲	▲/▲
R/LS274.0712.02	1.25	0.70	0.15	0.77	04	▲/▲	▲/▲
R/LS274.0915.02	1.50	0.80	0.20	0.92	04	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

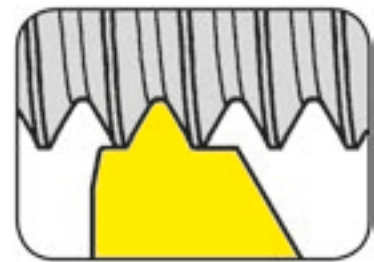


可转位刀片

Indexable insert

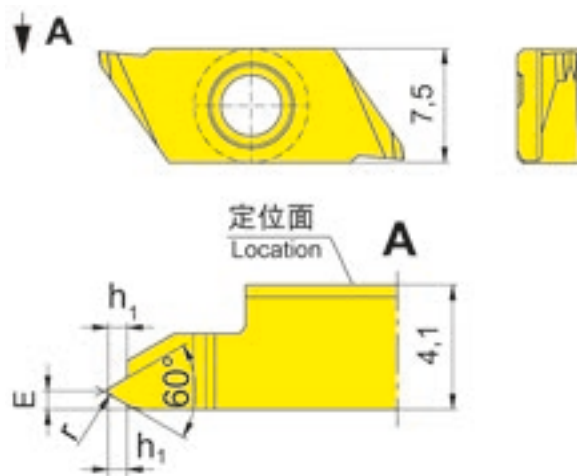
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-1.5 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274
Type KT274
KTC274
974
R76
H274KM
HC274KM

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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	IG35	TH35
R/LS274.0305.03	0.50	0.40	0.07	0.31	04	△/△	▲/▲
R/LS274.0306.03	0.60	0.45	0.09	0.37	04	△/△	△/△
R/LS274.0307.03	0.70	0.50	0.10	0.43	04	△/△	▲/△
R/LS274.0407.03	0.75	0.50	0.11	0.46	04	△/△	△/△
R/LS274.0408.03	0.80	0.55	0.12	0.49	04	△/△	△/△
R/LS274.0610.03	1.00	0.60	0.14	0.61	04	▲/△	▲/△
R/LS274.0712.03	1.25	0.70	0.15	0.77	04	△/△	△/△
R/LS274.0915.03	1.50	0.80	0.20	0.92	04	△/△	▲/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

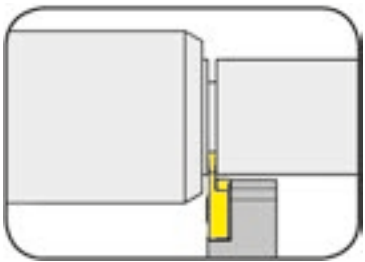
No shims necessary. All HORN thread profiles are manufactured with **full ground radial clearance**.

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

刀杆 Toolholder

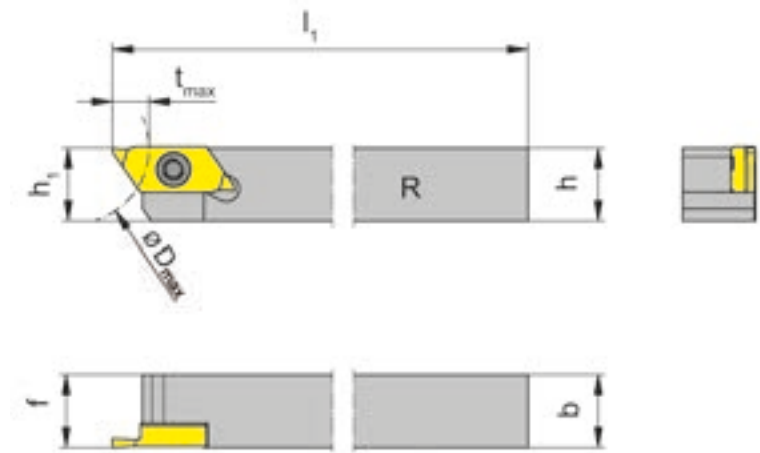
H274...E



槽深 槽宽	Depth of groove Width of groove	6 mm 0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

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



切槽和侧车削

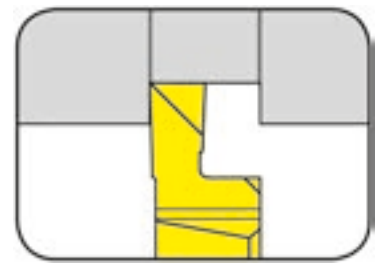
Grooving and Side Turning



可转位刀片

Indexable insert

S274...E

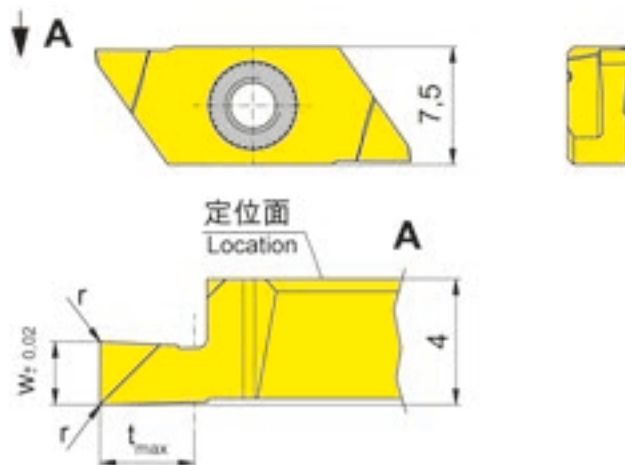


槽深可达
槽宽

Depth of groove up to
Width of groove

4.5 mm
1.5-3 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	尺寸规格 尺寸规格	IG35	TH35
R/LS274.0150.P0.E	1.5	0.05	2.25	04	Δ/Δ	Δ/Δ
R/LS274.0200.P0.E	2.0	0.05	3.00	04	Δ/Δ	Δ/Δ
R/LS274.0250.P0.E	2.5	0.10	3.75	04	Δ/Δ	Δ/Δ
R/LS274.0300.P0.E	3.0	0.10	4.50	04	Δ/Δ	Δ/Δ
					P	•
					M	•
					K	•
					N	•
					S	•
					H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号
Carbide grades

切槽和侧车削

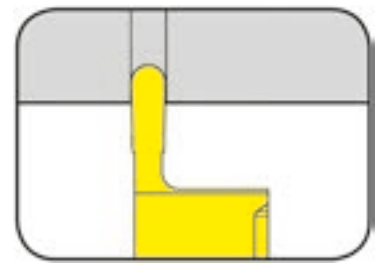
Grooving and Side Turning



可转位刀片

Indexable insert

S274...E

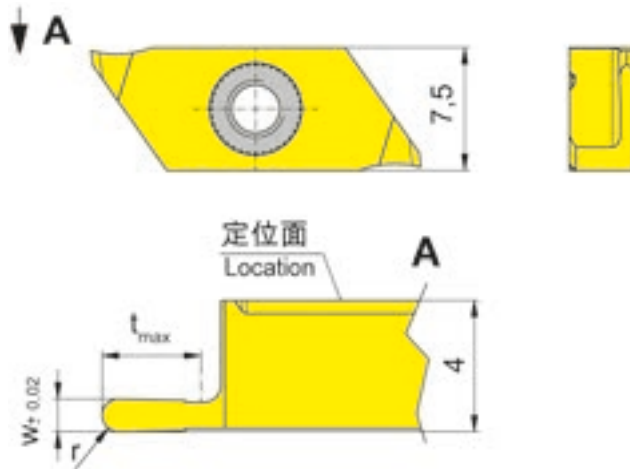


槽深可达
圆头

Depth of groove up to
Full radius

4 mm
0.25-1 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	r	尺寸规格 尺寸规格	IG35	TH35
R/LS274.0205.01.10.E	0.5	1.5	0.25	04	△/△	△/△
R/LS274.0510.03.10.E	1.0	3.0	0.50	04	△/△	▲/△
R/LS274.1020.04.10.E	2.0	4.0	1.00	04	△/△	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

切槽和切断

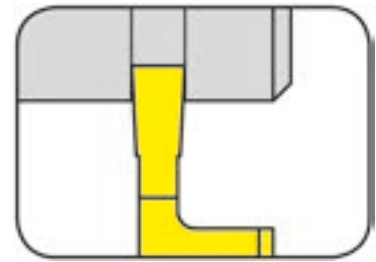
Grooving and Parting Off



可转位刀片

Indexable insert

S274...E



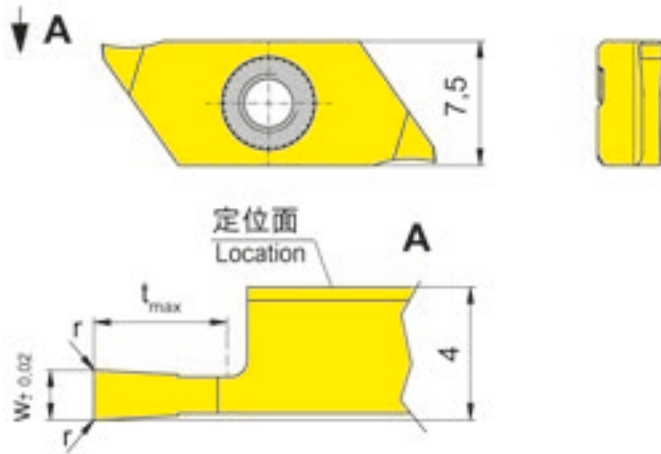
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号

H274...E

Type

刀片长度重复定位精度

±0.015 mm

Indexability length

± 0,015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	t _{max}	尺寸规格 Size	IG35	TH35
R/LS274.0120.03.10.E	1.2	0.05	3.0	04	Δ/Δ	Δ/Δ
R/LS274.0050.01.10.E	0.5	0.05	1.5	04	Δ/Δ	Δ/Δ
R/LS274.0070.02.10.E	0.7	0.05	2.0	04	Δ/Δ	Δ/Δ
R/LS274.0080.03.10.E	0.8	0.05	3.0	04	Δ/Δ	Δ/Δ
R/LS274.0100.03.10.E	1.0	0.05	3.0	04	Δ/x	Δ/Δ
R/LS274.0150.04.10.E	1.5	0.05	4.0	04	Δ/Δ	Δ/Δ
R/LS274.0150.06.10.E	1.5	0.05	6.0	04	Δ/Δ	Δ/Δ
R/LS274.0200.04.10.E	2.0	0.05	4.0	04	Δ/Δ	Δ/Δ
R/LS274.0200.06.10.E	2.0	0.05	6.0	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

切槽和切断

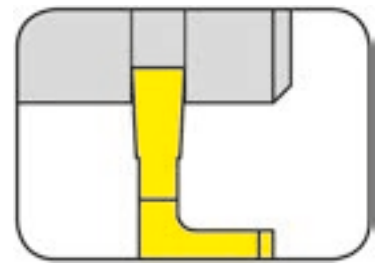
Grooving and Parting Off



可转位刀片

Indexable insert

S274...E



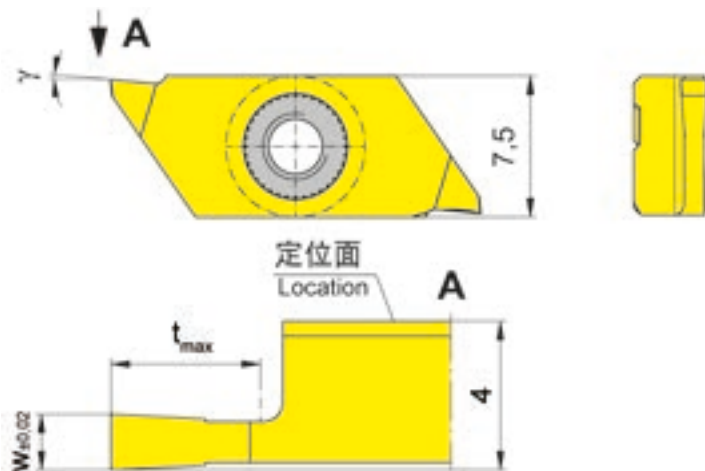
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号

H274...E

Type

刀片长度重复定位精度

± 0.015 mm

Indexability length

± 0.015 mm

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	t _{max}	γ	尺寸规格 Size	IG35	TH35
R/LS274.0050.01.20.E	0.5	1.5	5°	04	Δ/Δ	Δ/Δ
R/LS274.0070.02.20.E	0.7	2.0	5°	04	Δ/Δ	Δ/Δ
R/LS274.0080.03.20.E	0.8	3.0	5°	04	Δ/Δ	Δ/Δ
R/LS274.0100.03.20.E	1.0	3.0	5°	04	Δ/Δ	Δ/Δ
R/LS274.0120.03.20.E	1.2	3.0	5°	04	Δ/Δ	Δ/Δ
R/LS274.0150.04.20.E	1.5	4.0	5°	04	Δ/Δ	Δ/Δ
R/LS274.0150.06.20.E	1.5	6.0	5°	04	Δ/Δ	Δ/Δ
R/L/S274.0200.04.20.E	2.0	4.0	5°	04	Δ/Δ	Δ/Δ
R/L/S274.0200.06.20.E	2.0	6.0	5°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

L

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S274...E

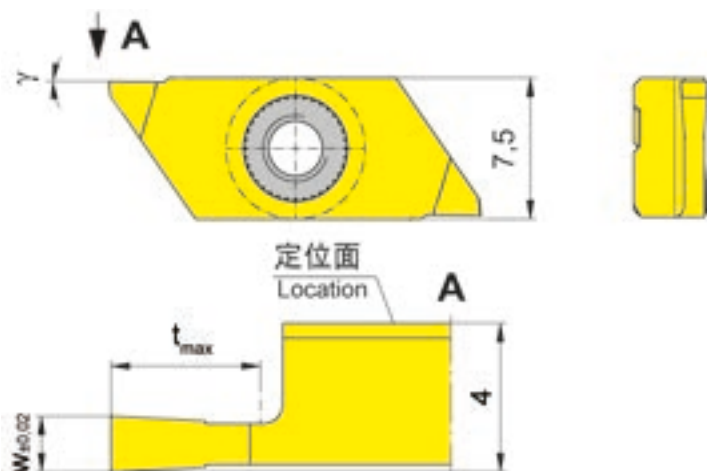
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

精密磨削

precision ground

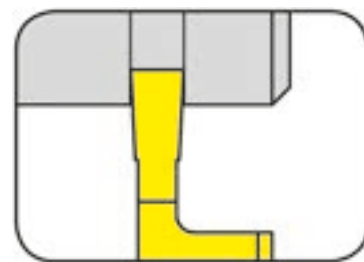


R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version



配合刀杆

for Toolholder

型号 H274...E

Type

刀片长度重复定位精度

± 0.015 mm

Indexability length

± 0.015 mm

产品型号 Part number	w	t _{max}	γ	尺寸规格 Size	IG35	TH35
R/LS274.0050.01.M0.E	0.5	1.5	0°	04	△△	△△
R/LS274.0070.02.M0.E	0.7	2.0	0°	04	△△	△△
R/LS274.0080.03.M0.E	0.8	3.0	0°	04	△△	△△
R/LS274.0100.03.M0.E	1.0	3.0	0°	04	△△	△△
R/LS274.0120.03.M0.E	1.2	3.0	0°	04	△△	△△
R/LS274.0150.04.M0.E	1.5	4.0	0°	04	△△	△△
R/LS274.0150.06.M0.E	1.5	6.0	0°	04	△△	△△
R/LS274.0200.04.M0.E	2.0	4.0	0°	04	△△	△△
R/LS274.0200.06.M0.E	2.0	6.0	0°	04	△△	△△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号

Carbide grades

背车削 (外圆)

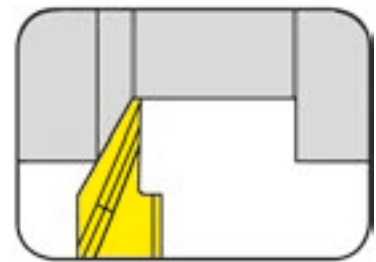
Backturning (external)



可转位刀片

Indexable insert

S274...E

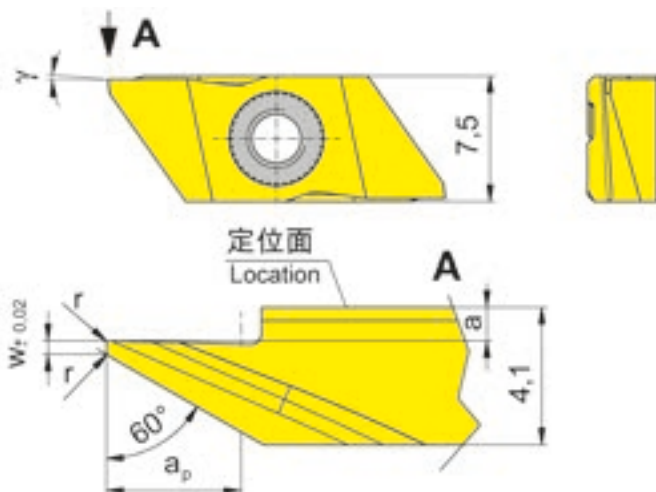


切深可达

Depth of cut up to

6 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274...E
Type

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

产品型号 Part number	w	r	a	γ	a _p	尺寸规格 Size			
							K10	IG35	TH35
R/LS274.0060.04.10.E	-	0.05	1.00	15°	4	04		Δ/Δ	Δ/Δ
R/LS274.0460.04.10.E	0.4	0.05	1.00	15°	4	04		Δ/Δ	▲/Δ
R/LS274.0460.04.M0.E	0.4	0.05	1.00	0°	4	04	Δ/Δ	Δ/Δ	Δ/Δ
R/LS274.0560.06.11.E	0.5	0.10	0.05	15°	6	04		Δ/Δ	▲/Δ
							P	•	•
							M	o	•
							K	•	•
							N	•	•
							S	o	•
							H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号
Carbide grades

L

侧面车削

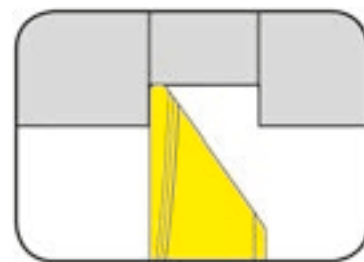
Side Turning



可转位刀片

Indexable insert

S274...E



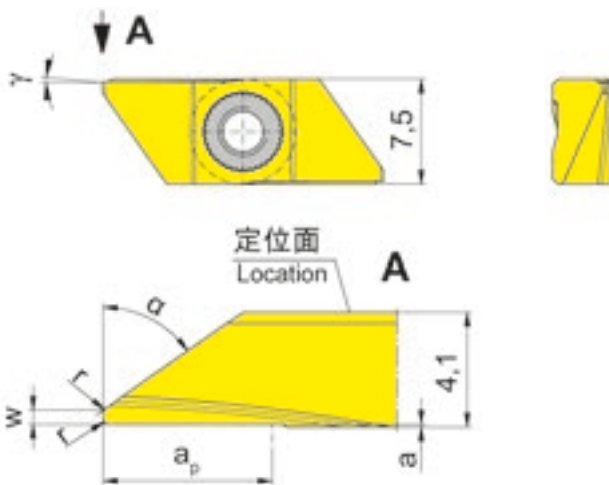
切深可达

Depth of cut up to

6 mm

精密磨削

precision ground



配合刀杆

for Toolholder

型号 H274...E

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

刀片长度重复定位精度

±0.015 mm

Indexability length

± 0,015 mm

产品型号 Part number	w	r	a	γ	a _p	α	尺寸规格 Size	IG35	TH35
R/LS274.0035.04.20.E	-	0.05	0.1	5°	4	35°	04	Δ/Δ	Δ/Δ
R/LS274.0235.04.20.E	0.2	-	0.1	5°	4	35°	04	Δ/Δ	Δ/Δ
R/LS274.0535.06.20.E	0.5	0.20	0.1	5°	6	35°	04	Δ/Δ	Δ/Δ
R/LS274.0055.04.20.E	-	0.05	0.1	5°	4	55°	04	Δ/Δ	Δ/Δ
R/LS274.0255.04.20.E	0.2	-	0.1	5°	4	55°	04	Δ/Δ	Δ/Δ
R/LS274.0555.06.20.E	0.5	0.20	0.1	5°	6	55°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号

Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

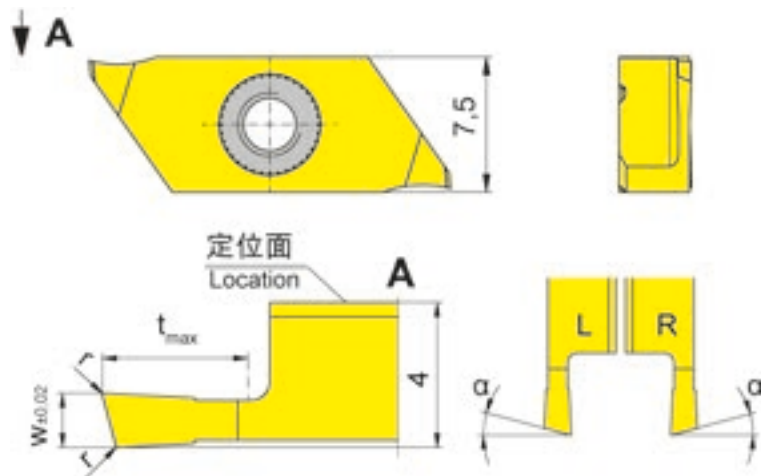
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.10.E	0.8	0.05	3	15°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.10.E	1.0	0.05	3	15°	04	Δ/Δ	Δ/Δ
R/LS274.1515.04.10.E	1.5	0.05	4	15°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.10.E	2.0	0.05	6	15°	04	Δ/Δ	Δ/Δ
							P
							M
							K
							N
							S
							H

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274...E

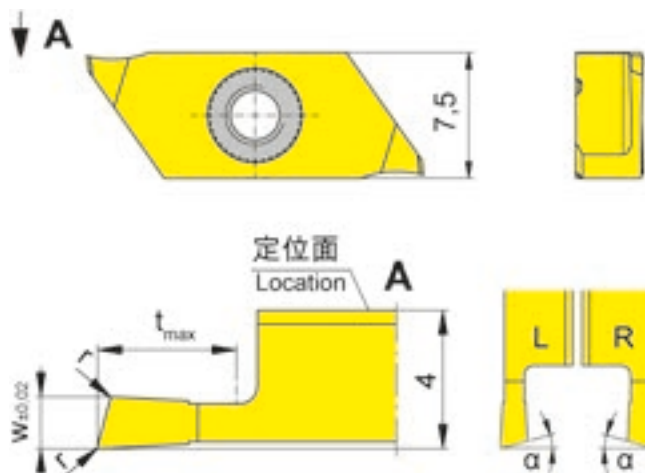


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
LS274.1508.03.1R.E	0.8	0.05	3	15°	04	Δ	Δ
LS274.1510.03.1R.E	1.0	0.05	3	15°	04	Δ	Δ
LS274.1515.04.1R.E	1.5	0.05	4	15°	04	Δ	Δ
LS274.1520.06.1R.E	2.0	0.05	6	15°	04	Δ	Δ
RS274.1508.03.1L.E	0.8	0.05	3	15°	04	Δ	Δ
RS274.1510.03.1L.E	1.0	0.05	3	15°	04	Δ	Δ
RS274.1515.04.1L.E	1.5	0.05	4	15°	04	Δ	Δ
RS274.1520.06.1L.E	2.0	0.05	6	15°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

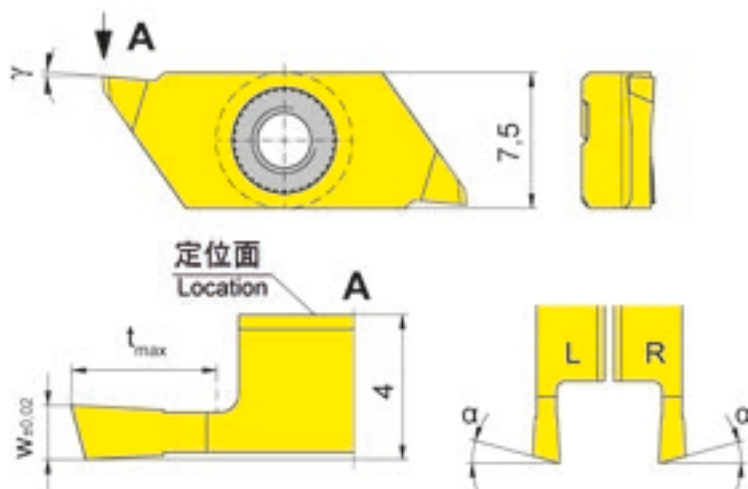
Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1515.04.20.E	1.5	4	15°	5°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.20.E	2.0	6	15°	5°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

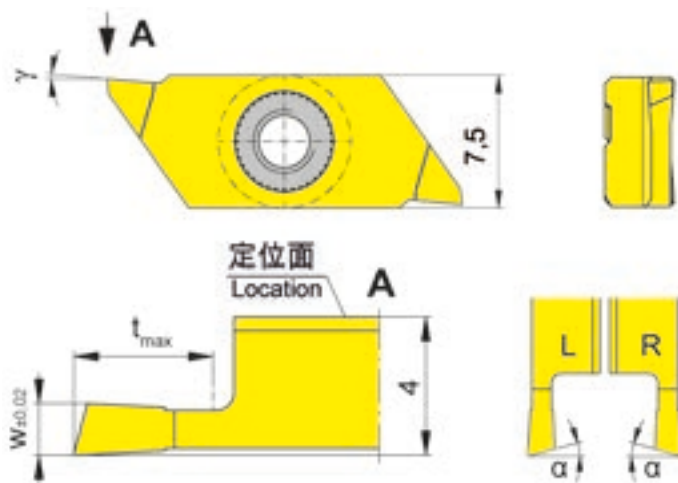
Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1515.04.2R.E	1.5	4	15°	5°	04	Δ	Δ
LS274.1520.06.2R.E	2.0	6	15°	5°	04	Δ	Δ
RS274.1515.04.2L.E	1.5	4	15°	5°	04	Δ	Δ
RS274.1520.06.2L.E	2.0	6	15°	5°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

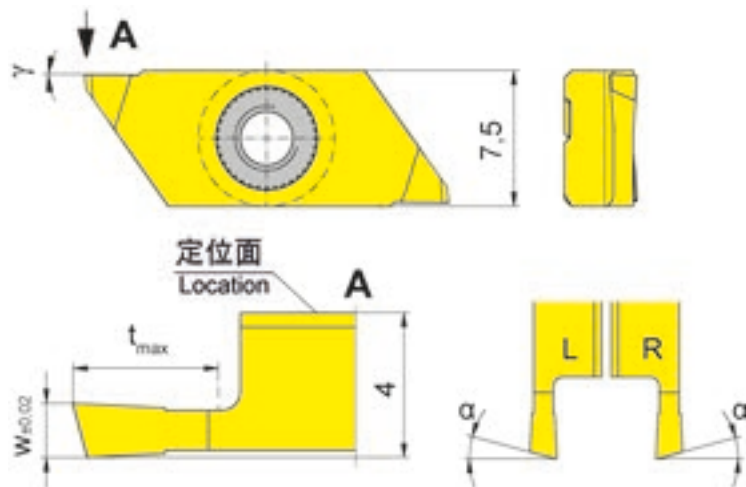
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.M0.E	0.8	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.M0.E	1.0	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1515.04.M0.E	1.5	4	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.M0.E	2.0	6	15°	0°	04	Δ/Δ	Δ/Δ
						P	•
						M	•
						K	•
						N	•
						S	•
						H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

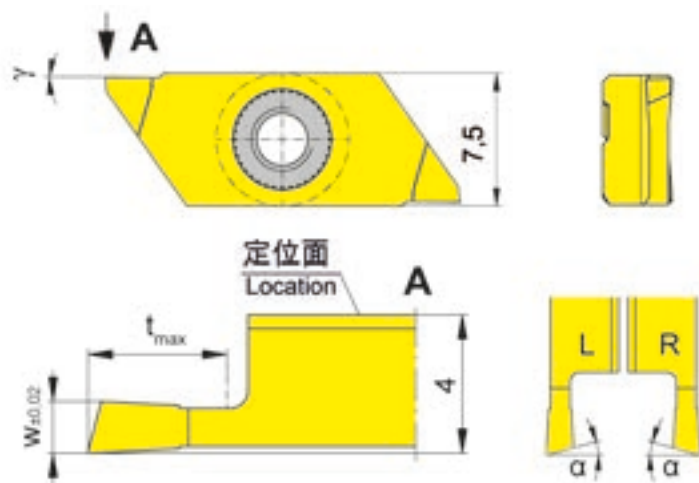
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1508.03.MR.E	0.8	3	15°	0°	04	Δ	Δ
LS274.1510.03.MR.E	1.0	3	15°	0°	04	Δ	Δ
L/S274.1515.04.MR.E	1.5	4	15°	0°	04	Δ	Δ
LS274.1520.06.MR.E	2.0	6	15°	0°	04	Δ	Δ
R/S274.1508.03.ML.E	0.8	3	15°	0°	04	Δ	Δ
R/S274.1510.03.ML.E	1.0	3	15°	0°	04	Δ	Δ
R/S274.1515.04.ML.E	1.5	4	15°	0°	04	Δ	Δ
R/S274.1520.06.ML.E	2.0	6	15°	0°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -非全牙型

Threading (external) Partial profile

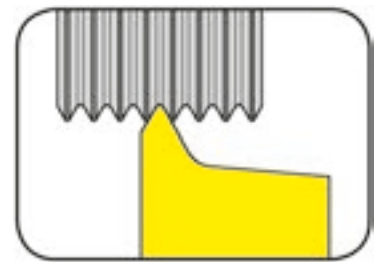


可转位刀片

Indexable insert

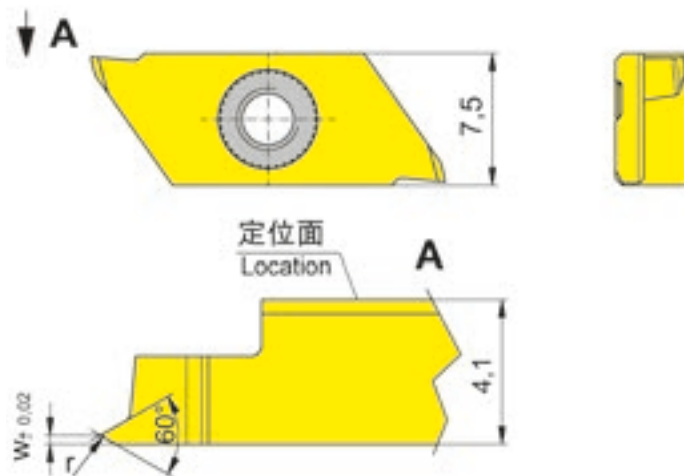
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.25-0.4 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

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

R=右手型-如图
R = right hand version shown

产品型号 Part number	P	E	r	尺寸规格 Size	IG35	TH35
RS274.0102.01.E	0.25	0.20	0.04	04	Δ	Δ
RS274.0203.01.E	0.35	0.25	0.05	04	Δ	Δ
RS274.0204.01.E	0.40	0.30	0.06	04	Δ	Δ
					P	•
					M	•
					K	•
					N	•
					S	•
					H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

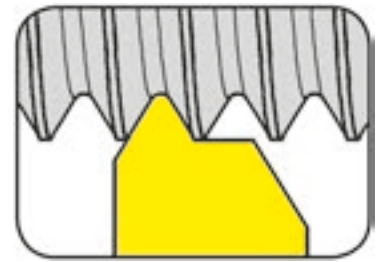


可转位刀片

Indexable insert

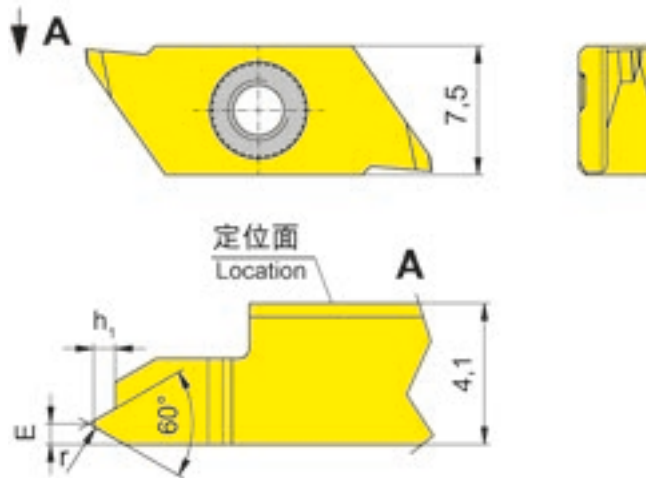
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-1.5 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274...E
Type

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

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	IG35	TH35
R/LS274.0305.02.E	0.50	0.40	0.07	0.31	04	Δ/Δ	Δ/Δ
R/LS274.0306.02.E	0.60	0.45	0.09	0.37	04	Δ/Δ	Δ/Δ
R/LS274.0307.02.E	0.70	0.50	0.10	0.43	04	Δ/Δ	Δ/Δ
R/LS274.0407.02.E	0.75	0.50	0.11	0.46	04	Δ/Δ	Δ/Δ
R/LS274.0408.02.E	0.80	0.55	0.12	0.49	04	Δ/Δ	Δ/Δ
R/LS274.0610.02.E	1.00	0.60	0.14	0.61	04	Δ/Δ	Δ/Δ
R/LS274.0712.02.E	1.25	0.70	0.15	0.77	04	Δ/Δ	Δ/Δ
R/LS274.0915.02.E	1.50	0.80	0.20	0.92	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

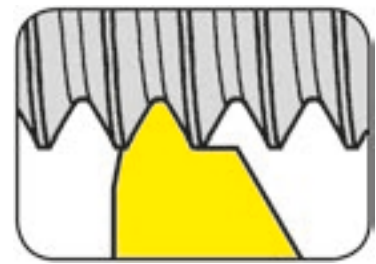


可转位刀片

Indexable insert

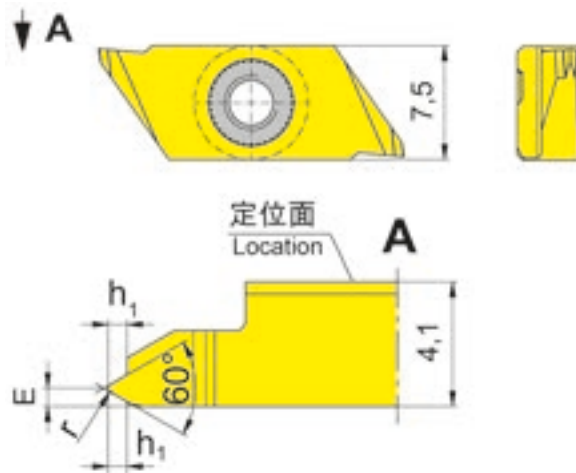
S274

ISO米制螺纹
Metric ISO thread



螺距	Pitch	0.5-1.5 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	P	E	r	h_1	尺寸规格 Size	IG35	TH35
R/LS274.0305.03.E	0.50	0.40	0.07	0.31	04	Δ/Δ	Δ/Δ
R/LS274.0306.03.E	0.60	0.45	0.09	0.37	04	Δ/Δ	Δ/Δ
R/LS274.0307.03.E	0.70	0.50	0.10	0.43	04	Δ/Δ	Δ/Δ
R/LS274.0407.03.E	0.75	0.50	0.11	0.46	04	Δ/Δ	Δ/Δ
R/LS274.0408.03.E	0.80	0.55	0.12	0.49	04	Δ/Δ	Δ/Δ
R/LS274.0610.03.E	1.00	0.60	0.14	0.61	04	Δ/Δ	Δ/Δ
R/LS274.0712.03.E	1.25	0.70	0.15	0.77	04	Δ/Δ	Δ/Δ
R/L/S274.0915.03.E	1.50	0.80	0.20	0.92	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

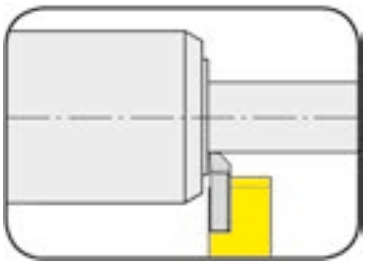
P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

L

刀杆
Toolholder

H274...SF



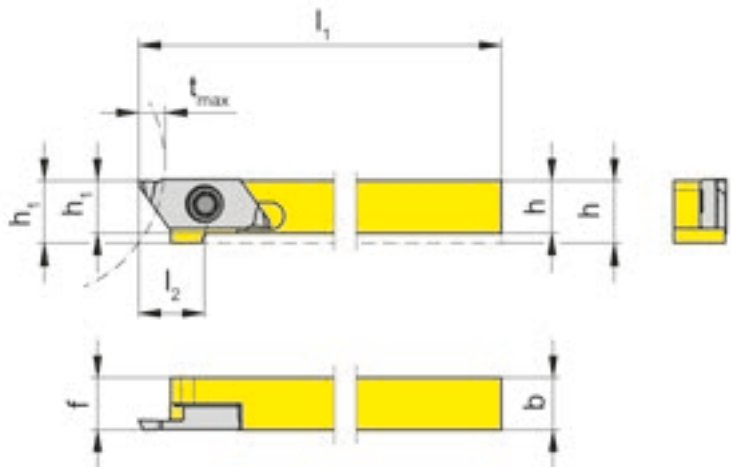
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-2 mm

配合可转位刀片
for Indexable insert

型号 S274...SF
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f	t_{max}	尺寸规格 Size
RH274.0808.SF.04	8	8	100	10	9.5	8	6	04
RH274.1010.SF.04	10	10	100	-	10.0	10	6	04
RH274.1212.SF.04	12	12	100	-	12.0	12	6	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

只有当零件 $\varnothing \leq 25\text{mm}$ 时才能达到最大切深 t_{max} 6mm。
 t_{max} 6 mm can be reached only with workpiece $\varnothing \leq 25\text{ mm}$.

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RH274...	030.350P.0852	T15PQ

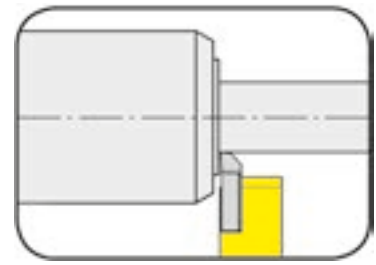
切槽和车削

Grooving and Turning



刀杆 Toolholder

H274...SF



槽深
槽宽

Depth of groove
Width of groove

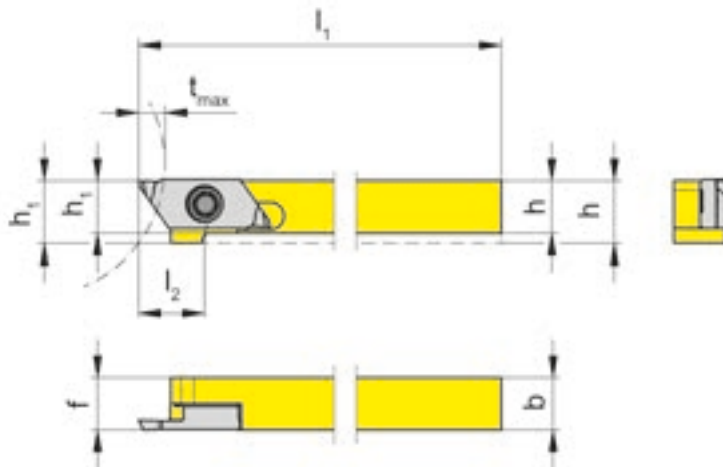
6 mm
0.5-2 mm

刀杆材质：钨基合金 - 良好的抗振性能

Material of shank: tungsten alloy (giving good vibration resistance)

配合可转位刀片
for Indexable insert

型号 S274...SF
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f	t_{max}	尺寸规格 Size
RH274.0808.SF.S4	8	8	100	10	9.5	8	6	04
RH274.1010.SF.S4	10	10	100	-	10.0	10	6	04
RH274.1212.SF.S4	12	12	100	-	12.0	12	6	04

按需提供更多尺寸

Further sizes upon request

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

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

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RH274...	030.350P.0852	T15PQ

L

侧面车削

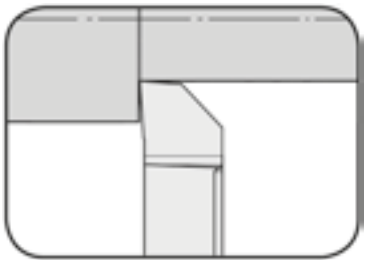
Side Turning



可转位刀片

Indexable insert

S274...SF

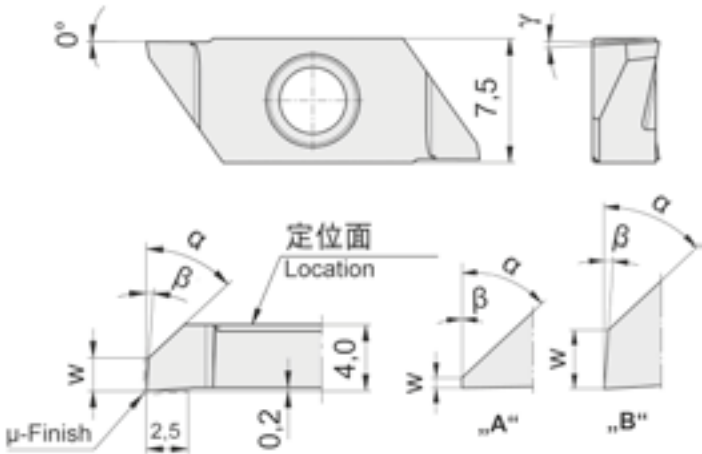


切深可达	Depth of cut up to	2,5 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...SF
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	γ	α	形式 Form	β	尺寸规格 Size		MG12	AC25	AC2P	ES15	ES1P
RS274.0547.04.SF	0.05	0°	47°	A	0°	04			Δ	Δ	▲	Δ
R/LS274.2047.03.SF	2.00	3°	47°	B	4°	04		Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	Δ/Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request								P	○	●	●	●
● 推荐 / recommended								M	-	○	○	○
○ 次推荐 / alternative recommendation								K	-	-	-	-
- 不合适 / not suitable								N	-	-	-	-
■ 非涂层 / uncoated grades								S	-	-	-	-
■ 涂层 / coated grades								H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位 : mm
Dimensions in mm

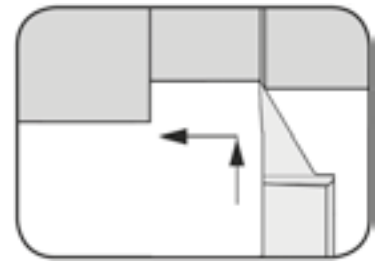
硬质合金牌号
Carbide grades

仿形车削 (精加工) Copy Turning (Finishing)



可转位刀片 Indexable insert

S274...SF



切深可达

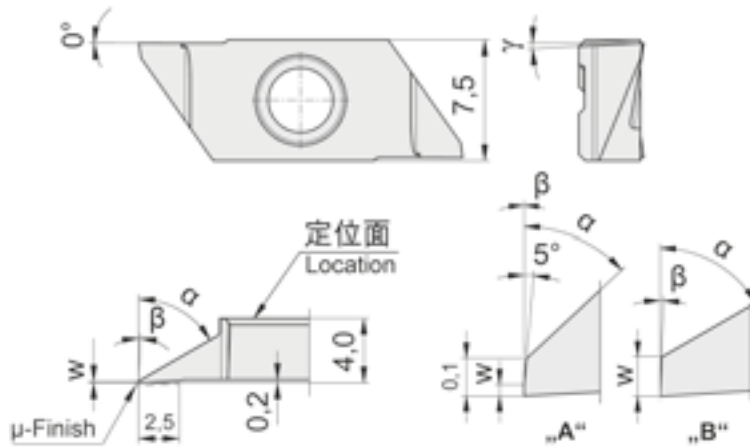
Depth of cut up to

2,5 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...SF
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	γ	α	形式 Form	β	尺寸规格 Size	MG12	AC25	AC2P	ES15	ES1P
RS274.0147.04.SF	0.030	0°	47°	A	0°	04	Δ	Δ	Δ	Δ	Δ
R/LS274.0160.03.SF	0.105	3°	60°	B	2°	04	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	o	•	•	•
● 推荐 / recommended							M	-	o	o	o
o 次推荐 / alternative recommendation							K	-	-	-	-
- 不合适 / not suitable							N	-	-	-	-
■ 非涂层 / uncoated grades							S	-	-	-	-
■ 涂层 / coated grades							H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

L

可转位刀片
Indexable insert

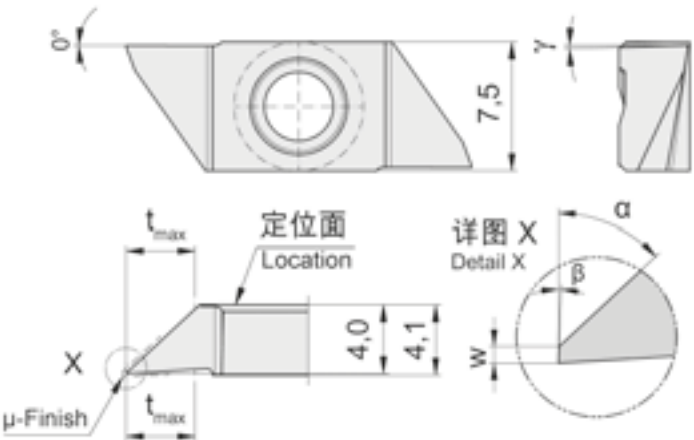
S274...SF

切深可达

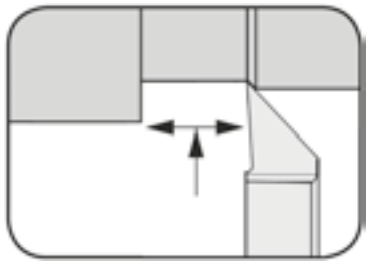
Depth of cut up to

4 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown



配合刀杆
for Toolholder

型号 H274...SF
Type

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

产品型号 Part number	w	t _{max}	γ	α	β	尺寸规格 Size		AC25	AC2P	ES15	ES1P
RS274.0247.04.SF	0.025	4	1.5°	47°	2°	04		Δ	Δ	▲	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	●	●	●	●
● 推荐 / recommended							M	○	○	○	○
○ 次推荐 / alternative recommendation							K	-	-	●	-
- 不合适 / not suitable							N	-	-	-	-
■ 非涂层 / uncoated grades							S	-	-	-	-
■ 涂层 / coated grades							H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

尺寸单位：mm
Dimensions in mm

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...SF



槽深可达
槽宽

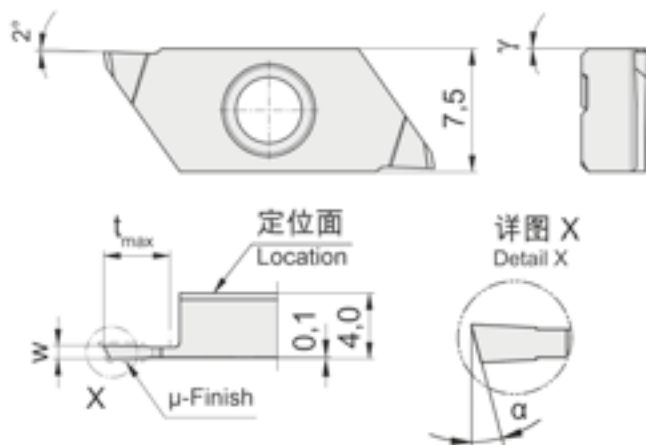
Depth of groove up to
Width of groove

6 mm
0.8-1.5 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...SF
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size
R/LS274.2508.04.SF	0.8	4	25°	0°	04
RS274.2509.04.SF	0.9	4	25°	0°	04
RS274.2510.04.SF	1.0	4	25°	0°	04
RS274.2510.06.SF	1.0	6	25°	0°	04
RS274.2512.06.SF	1.2	6	25°	0°	04
RS274.2515.06.SF	1.5	6	25°	0°	04

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

	MG12	AC25	AC2P	ES15	ES1P
Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ
Δ	Δ	Δ	Δ	Δ	Δ
P	o	o	o	o	o
M	-	o	o	o	o
K	-	-	-	o	-
N	-	-	-	-	-
S	-	-	-	-	-
H	-	-	-	-	-

硬质合金牌号
Carbide grades

L

切断

Parting Off



可转位刀片

Indexable insert

S274...SF

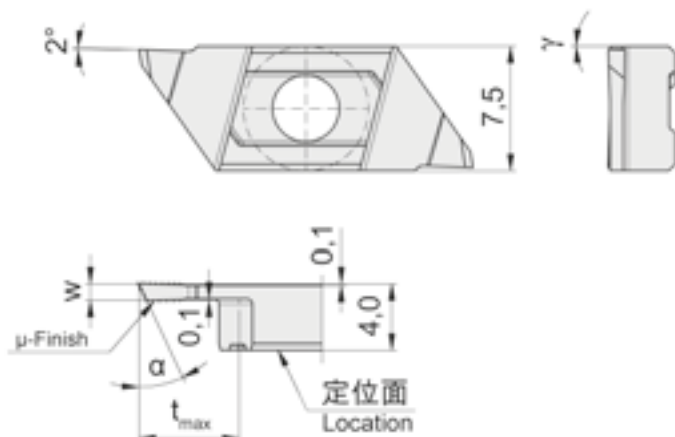


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.8-1.5 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...SF
Type

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

L=左手型-如图
L = left hand version shown

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size		AC25	AC2P	ES15	ES1P
LS274.2508.04.SF.R	0.8	4	25°	0°	04		Δ	Δ	Δ	Δ
LS274.2509.04.SF.R	0.9	4	25°	0°	04		Δ	Δ	Δ	Δ
LS274.2510.06.SF.R	1.0	6	25°	0°	04		Δ	Δ	Δ	Δ
LS274.2512.06.SF.R	1.2	6	25°	0°	04		Δ	Δ	Δ	Δ
LS274.2515.06.SF.R	1.5	6	25°	0°	04		Δ	Δ	▲	Δ
							P	•	•	•
							M	o	o	o
							K	-	-	-
							N	-	-	-
							S	-	-	-
							H	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

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

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

硬质合金牌号
Carbide grades

切槽/背车

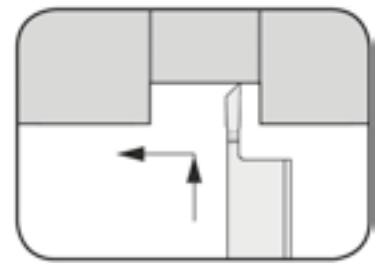
Grooving/Backturning



可转位刀片

Indexable insert

S274...SF



槽深可达
槽宽

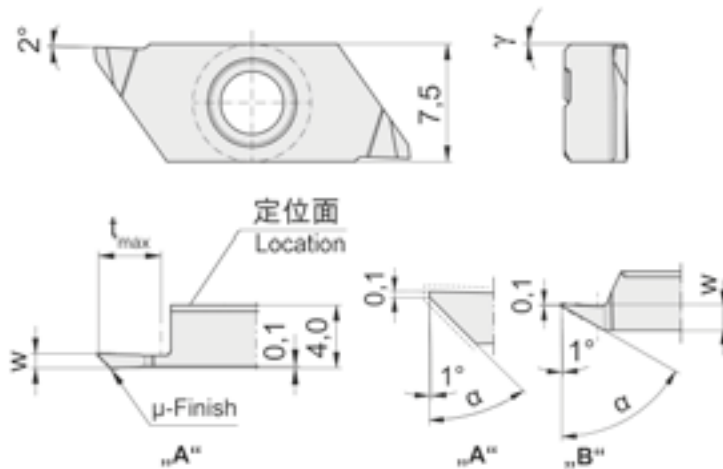
Depth of groove up to
Width of groove

6 mm
0.8-1.8 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...SF
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	形式 Form	尺寸规格 Size		MG12	AC25	AC2P	ES15	ES1P
RS274.4508.04.SF	0.8	4.0	45°	0°	A	04			Δ	Δ	Δ	Δ
R/LS274.4509.04.SF	0.9	4.0	45°	0°	A	04		Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	Δ/Δ
RS274.4510.06.SF	1.0	6.0	45°	0°	A	04			Δ	Δ	▲	Δ
RS274.4512.06.SF	1.2	6.0	45°	0°	A	04			Δ	Δ	Δ	Δ
RS274.6015.02.SF	1.8	2.5	60°	0°	B	04			Δ	Δ	▲	Δ
RS274.7010.02.SF	1.2	2.5	70°	0°	B	04			Δ	Δ	Δ	Δ
								P	○	●	●	●
								M	-	○	○	○
								K	-	-	-	-
								N	-	-	-	-
								S	-	-	-	-
								H	-	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号
Carbide grades

L

可转位刀片

Indexable insert

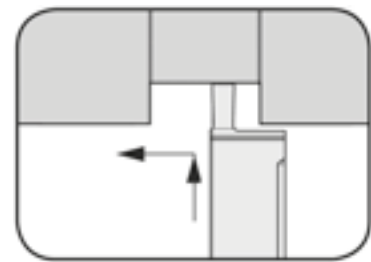
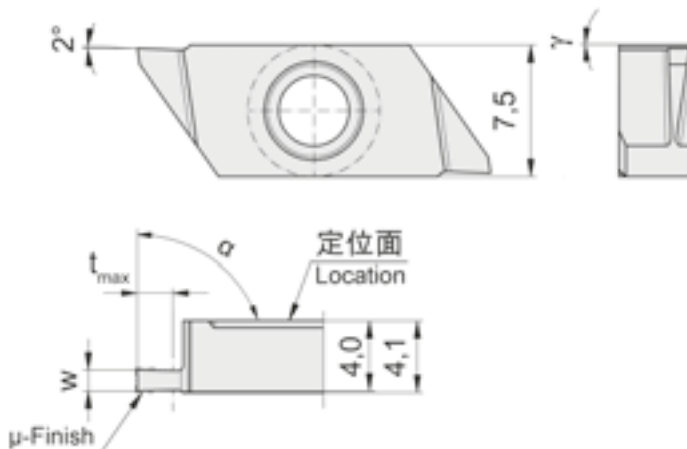
S274...SF

槽深可达
槽宽

Depth of groove up to
Width of groove

3 mm
0.5-2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...SF
Type

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

R=右手型-如图
R = right hand version shown

产品型号 Part number	w	t _{max}	γ	尺寸规格 Size		AC25	AC2P	ES15	ES1P
RS274.0005.01.SF	0.5	1	0°	04		Δ	Δ	▲	Δ
RS274.0010.02.SF	1.0	2	0°	04		Δ	Δ	▲	Δ
RS274.0012.02.SF	1.2	2	0°	04		Δ	Δ	Δ	Δ
RS274.0015.03.SF	1.5	3	0°	04		Δ	Δ	Δ	Δ
RS274.0020.03.SF	2.0	3	0°	04		Δ	Δ	Δ	Δ
						P	•	•	•
						M	o	o	o
						K	-	-	-
						N	-	-	-
						S	-	-	-
						H	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

硬质合金牌号
Carbide grades

34T



机夹式刀杆
槽宽2 - 5 mm

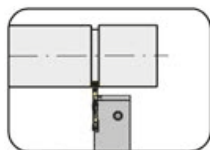
Toolholder with Inserts
Width of groove 2 - 5 mm

切槽和切断

Grooving and Parting Off

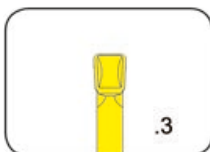


刀杆
Toolholder
H34T

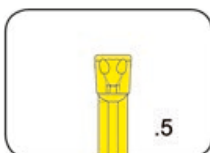


页/Page
M3

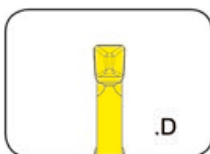
可转位刀片
Indexable insert
S34T



页/Page
M4



页/Page
M5



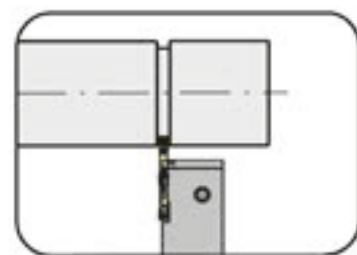
页/Page
M6

切槽 (外圆) Grooving (external)



刀杆 Toolholder

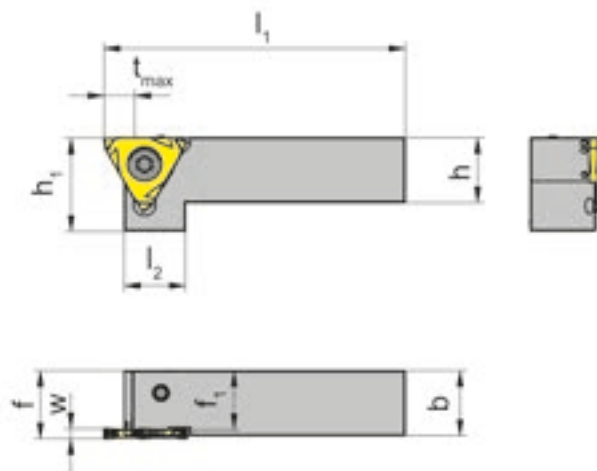
H34T



槽深可达
夹持范围

Depth of groove up to
Clamping range

6.5 mm
2-4,01 mm



配合可转位刀片
for Indexable insert

型号 S34T
Type

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH34T.1616.4.10.IK	16	16	69	15	21	14.5	f_1+w-a_1	6.5	01	2.00-2.00
R/LH34T.2020.4.10.IK	20	20	84	15	25	18.5	f_1+w-a_1	6.5	01	2.00-2.00
R/LH34T.2525.4.10.IK	25	25	99	15	30	23.5	f_1+w-a_1	6.5	01	2.00-2.00
R/LH34T.1616.4.20.IK	16	16	69	15	21	13.5	f_1+w-a_1	6.5	02	2.01-3.00
R/LH34T.2020.4.20.IK	20	20	84	15	25	17.5	f_1+w-a_1	6.5	02	2.01-3.00
R/LH34T.2525.4.20.IK	25	25	99	15	30	22.5	f_1+w-a_1	6.5	02	2.01-3.00
R/LH34T.2020.4.30.IK	20	20	84	15	25	16.5	f_1+w-a_1	6.5	03	3.01-4.00
R/LH34T.2525.4.30.IK	25	25	99	15	30	21.5	f_1+w-a_1	6.5	03	3.01-4.00
R/LH34T.2020.4.40.IK	20	20	84	15	25	15.5	f_1+w-a_1	6.5	04	4.01-5.00
R/LH34T.2525.4.40.IK	25	25	99	15	30	20.5	f_1+w-a_1	6.5	04	4.01-5.00

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH34T...10.IK	030.4093.T15P	T15PQ
R/LH34T...20.IK	030.4010.T15P	T15PQ
R/LH34T...30.IK	030.5012.T15P	T15PQ
R/LH34T...40.IK	030.5012.T15P	T20PQ

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

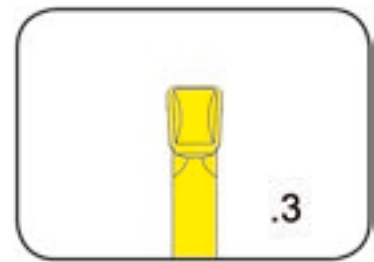
S34T

带烧结槽型
with sintered geometries

槽宽

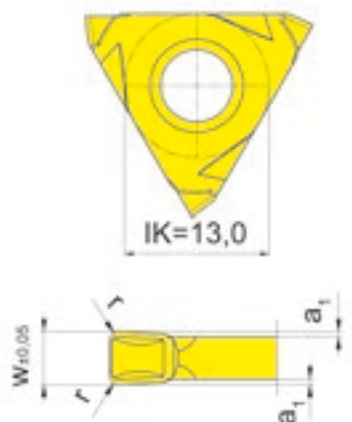
Width of groove

2-5 mm



配合刀杆
for Toolholder

型号 H34T
Type



槽型 .3
Geometry .3

产品型号 Part number	w	r	a ₁	尺寸规格 Size	AS45	EG55
S34T.0200.32	2.0	0.2	0.25	01	▲	▲
S34T.0200.34	2.0	0.4	0.25	01	▲	▲
S34T.0250.32	2.5	0.2	0.25	02	△	▲
S34T.0250.34	2.5	0.4	0.25	02	△	▲
S34T.0300.32	3.0	0.2	0.25	02	△	▲
S34T.0300.34	3.0	0.4	0.25	02	△	▲
S34T.0400.32	4.0	0.2	0.25	03	▲	▲
S34T.0500.32	5.0	0.2	0.25	04	▲	▲
S34T.0500.34	5.0	0.4	0.25	04	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	•
● 推荐 / recommended					M	•
○ 次推荐 / alternative recommendation					K	•
- 不合适 / not suitable					N	○
■ 非涂层 / uncoated grades					S	•
■ 涂层 / coated grades					H	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

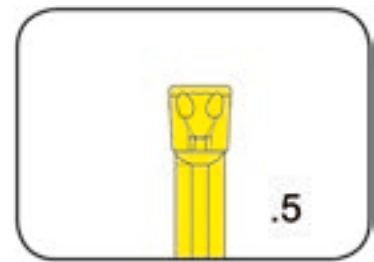
S34T

带烧结槽型
with sintered geometries

槽宽

Width of groove

2.5-5 mm



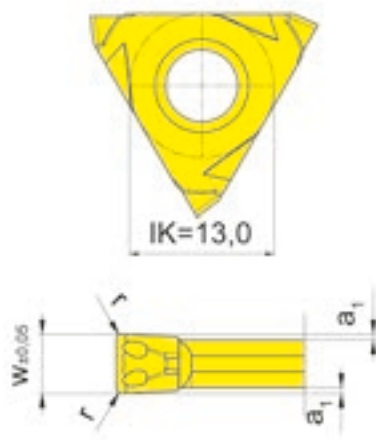
配合刀杆

for Toolholder

型号

H34T

Type



槽型.5
Geometry .5

产品型号 Part number	w	r	a ₁	尺寸规格 Size	AS45	EG55
S34T.0250.52	2.5	0.2	0.25	02	▲	▲
S34T.0250.54	2.5	0.4	0.25	02	▲	▲
S34T.0300.52	3.0	0.2	0.25	02	△	▲
S34T.0300.54	3.0	0.4	0.25	02	△	▲
S34T.0400.52	4.0	0.2	0.25	03	▲	▲
S34T.0400.54	4.0	0.4	0.25	03	▲	▲
S34T.0500.52	5.0	0.2	0.25	04	▲	▲
S34T.0500.54	5.0	0.4	0.25	04	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	●
● 推荐 / recommended					M	●
○ 次推荐 / alternative recommendation					K	●
- 不合适 / not suitable					N	○
■ 非涂层 / uncoated grades					S	●
■ 涂层 / coated grades					H	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

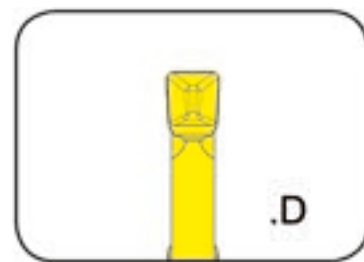
S34T

带烧结槽型
with sintered geometries

槽宽

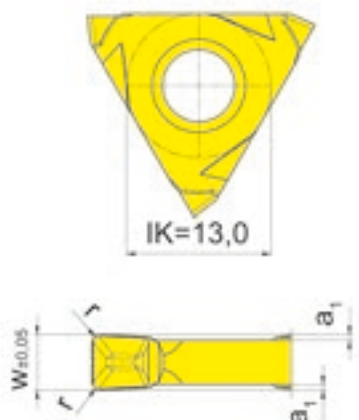
Width of groove

2-3 mm



配合刀杆
for Toolholder

型号 H34T
Type



槽型.D
Geometry .D

产品型号 Part number	w	r	a ₁	尺寸规格 Size	AS45	EG55
S34T.0200.D2	2.0	0.2	0.25	01	▲	▲
S34T.0200.D4	2.0	0.4	0.25	01	△	▲
S34T.0250.D2	2.5	0.2	0.25	02	△	▲
S34T.0250.D4	2.5	0.4	0.25	02	▲	▲
S34T.0300.D2	3.0	0.2	0.25	02	△	▲
S34T.0300.D4	3.0	0.4	0.25	02	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	●
● 推荐 / recommended					M	●
○ 次推荐 / alternative recommendation					K	●
- 不合适 / not suitable					N	○
■ 非涂层 / uncoated grades					S	●
■ 涂层 / coated grades					H	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

312



机夹式刀杆

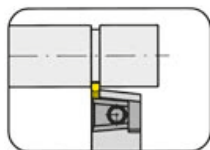
槽宽0.5 - 6.3 mm

Toolholder with Inserts

Width of groove 0.5 - 6.3 mm

刀杆

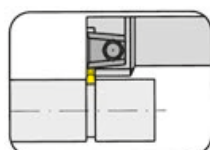
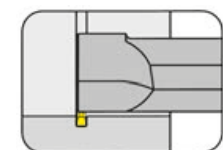
Toolholder

360/361/369/390/
391/340/368/309页/Page
N4-N8, N18-N19

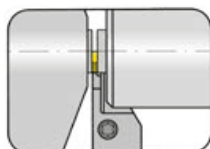
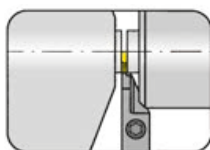
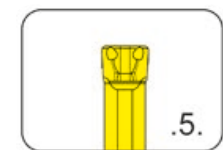
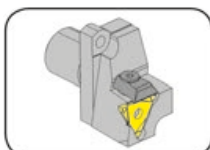
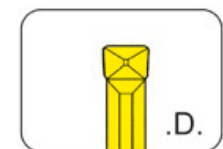
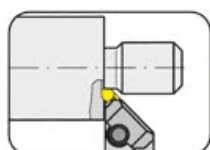
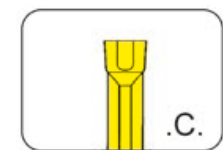
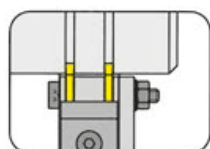
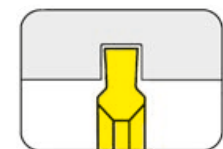
可调刀杆

Adjustable holder
N06/N68/N69页/Page
N17

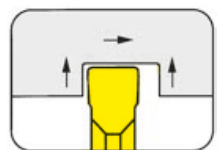
常规刀柄

Basic toolholder
330页/Page
N13页/Page
N23

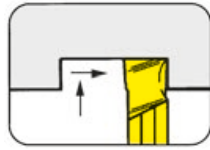
可转位刀片

Indexable insert
S312/312页/Page
N9-N10页/Page
N24页/Page
N11-N12页/Page
N25页/Page
N14页/Page
N26页/Page
N20页/Page
N27页/Page
N21-N22页/Page
N28-N32

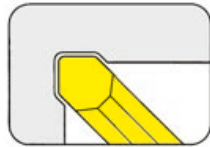
Graf刀夹

Cartridge Graf
64/65/99页/Page
N15-N16页/Page
N33

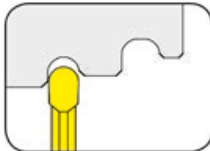
可转位刀片
Indexable insert
S312/312



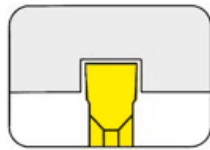
页/Page
N34



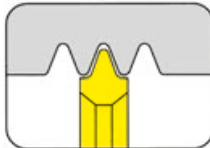
页/Page
N35-N36



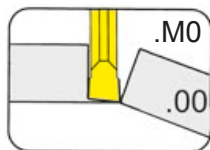
页/Page
N37



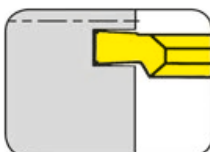
页/Page
N38-N39



页/Page
N40



页/Page
N41-N44

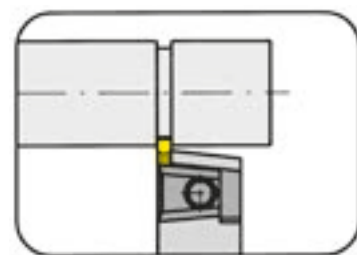
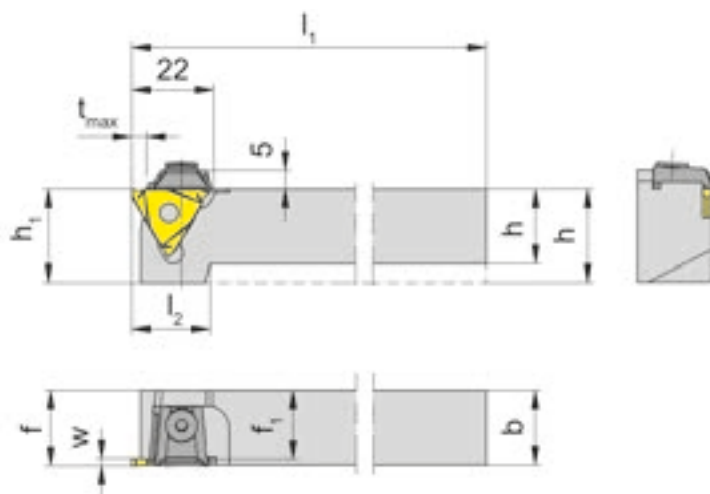


页/Page
N45

刀杆

Toolholder

360

槽深可达
夹持范围Depth of groove up to
Clamping range6 mm
0.5-2.9 mm配合可转位刀片
for Indexable insert型号 312
Type S312
N312

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.01	12	12	100	24	25	10.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.1616.01	16	16	125	22	25	14.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.2020.01	20	20	125	21	25	18.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.2525.01	25	25	150	-	25	23.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.3232.01	32	32	170	-	32	30.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.1212.02	12	12	100	24	25	9.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.1616.02	16	16	125	22	25	13.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.2020.02	20	20	125	21	25	17.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.2525.02	25	25	150	-	25	22.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.3232.02	32	32	170	-	32	29.5	f_1+w-a_1	6	02	1.9-2.9

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 t_{max} t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

 w, a_1 见刀片 w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L360.1...	SW3,0 DIN911	11.3
R/L360...	SW3,0 DIN911	16.4

切槽和切断

Grooving and Parting Off



N

刀杆

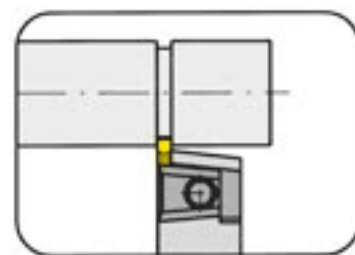
Toolholder

360

槽深可达
夹持范围

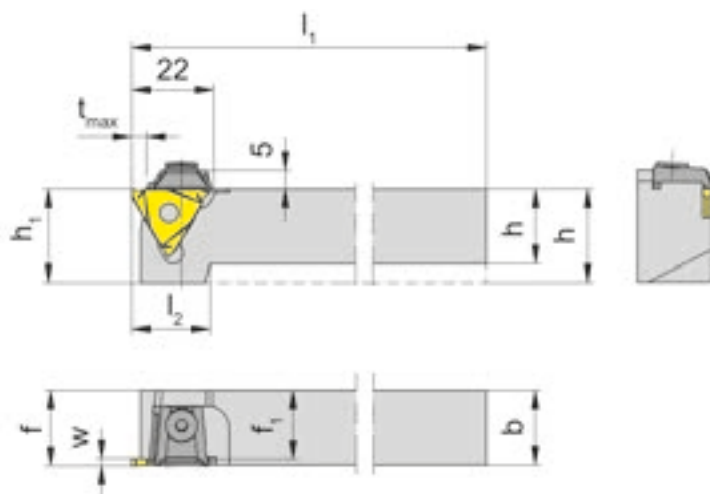
Depth of groove up to
Clamping range

6 mm
0.5-2.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.03	12	12	100	24	25	8.5	f_1+w-a_1	6	03	2.9-3.9
R/L360.1616.03	16	16	125	22	25	12.5	f_1+w-a_1	6	03	2.9-3.9
R/L360.2020.03	20	20	125	21	25	16.5	f_1+w-a_1	6	03	2.9-3.9
R/L360.2525.03	25	25	150	-	25	21.5	f_1+w-a_1	6	03	2.9-3.9
R/L360.3232.03	32	32	170	-	32	28.5	f_1+w-a_1	6	03	2.9-3.9
R/L360.1616.04	16	16	125	22	25	10.8	f_1+w-a_1	6	04	3.9-6.3
R/L360.2020.04	20	20	125	21	25	14.8	f_1+w-a_1	6	04	3.9-6.3
R/L360.2525.04	25	25	150	-	25	19.8	f_1+w-a_1	6	04	3.9-6.3
R/L360.3232.04	32	32	170	-	32	26.8	f_1+w-a_1	6	04	3.9-6.3

注明R或L型
State R or L version

w, a_1 见刀片
 w, a_1 see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 t_{max}
 t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

配件

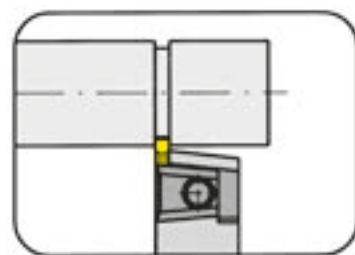
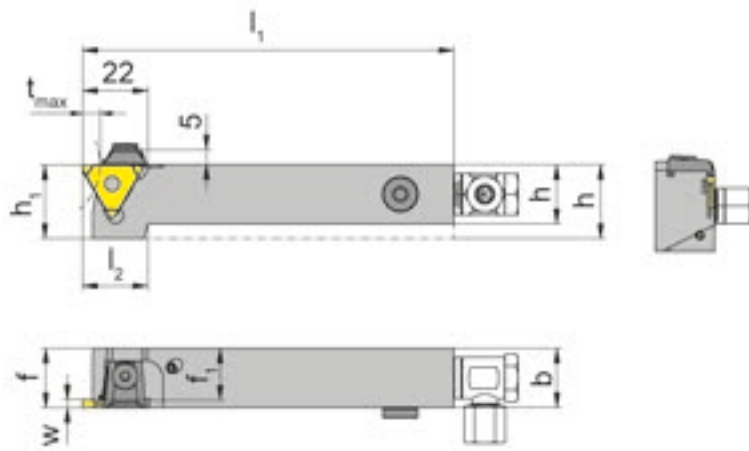
Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L360.1212./1616.03	SW3,0 DIN911	11.3
R/L360.1616.04	SW3,0 DIN911	16.4
R/L360...	SW3,0 DIN911	13.4

刀杆

Toolholder

360

槽深可达
夹持范围Depth of groove up to
Clamping range6 mm
0.5-2.9 mm配合可转位刀片
for Indexable insert型号 312
Type S312
N312

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.01.IK	12	12	100	24	25	10.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.1616.01.IK	16	16	125	22	25	14.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.2020.01.IK	20	20	125	21	25	18.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.2525.01.IK	25	25	150	-	25	23.5	f_1+w-a_1	4	01	0.5-1.9
R/L360.1212.02.IK	12	12	100	24	25	9.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.1616.02.IK	16	16	125	22	25	13.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.2020.02.IK	20	20	125	21	25	17.5	f_1+w-a_1	6	02	1.9-2.9
R/L360.2525.02.IK	25	25	150	-	25	22.5	f_1+w-a_1	6	02	1.9-2.9

注明R或L型

State R or L version

 w, a_1 见刀片 w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 t_{max}
 t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	冷却液供应 Coolant supply	压板 Clamping element	密封塞 Sealing plug
R/L360.1212.03.IK	SW3,0 DIN911	004.00.61	11.3	
R/L360.1616.03.IK	SW3,0 DIN911	SBD 6 LR - G1/8"	11.3	004.00.26
R/L360....	SW3,0 DIN911	SBD 6 LR - G1/8"	16.4	

切槽和切断

Grooving and Parting Off



N

刀杆

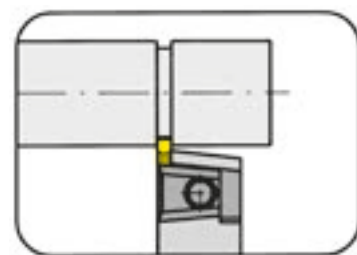
Toolholder

360

槽深可达
夹持范围

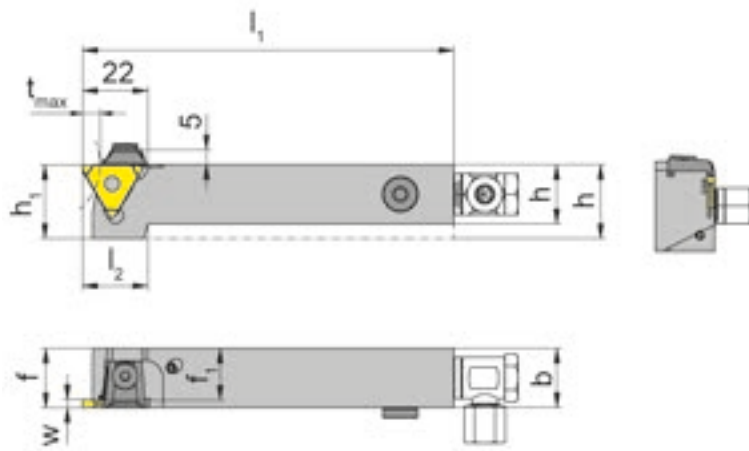
Depth of groove up to
Clamping range

6 mm
2.9-3.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.03.IK	12	12	100	24	25	8.5	$f_1 + w - a_1$	6	03	2.9-3.9
R/L360.1616.03.IK	16	16	125	22	25	12.5	$f_1 + w - a_1$	6	03	2.9-3.9
R/L360.2020.03.IK	20	20	125	21	25	16.5	$f_1 + w - a_1$	6	03	2.9-3.9
R/L360.2525.03.IK	25	25	150	-	25	21.5	$f_1 + w - a_1$	6	03	2.9-3.9

注明R或L型

State R or L version

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

只有当工件直径 $\phi \leq 40\text{mm}$ 时才能达到 t_{max}
 t_{max} can be reached only with workpiece $\phi \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	冷却液供应 Coolant supply	压板 Clamping element	密封塞 Sealing plug
R/L360.1212.03.IK	SW3,0 DIN911	004.00.61	11.3	
R/L360.1616.03.IK	SW3,0 DIN911	SBD 6 LR - G1/8"	11.3	004.00.26
R/L360....	SW3,0 DIN911	SBD 6 LR - G1/8"	16.4	

切槽 (外圆)

Grooving (external)



刀杆

Toolholder

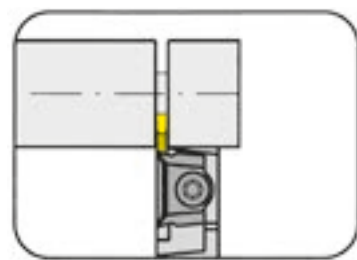
361

减小头部尺寸
reduced head size

槽深可达
夹持范围

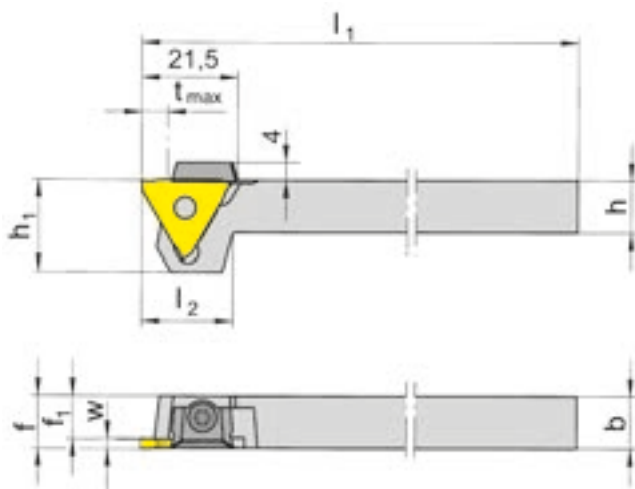
Depth of groove up to
Clamping range

6 mm
0.5-3.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L361.1212.01	12	12	100	17	19	10.5	f_1+w-a_1	4	01	0.5-1.9
R/L361.1212.02	12	12	100	17	19	9.5	f_1+w-a_1	6	02	1.9-2.9
R/L361.1212.03	12	12	100	21	21	8.5	f_1+w-a_1	6	03	2.9-3.9

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 t_{max}

t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	压板 Clamping element	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L361...	12.3	030.0422.T10P	T10PL

切断

Parting Off



N

刀杆

Toolholder

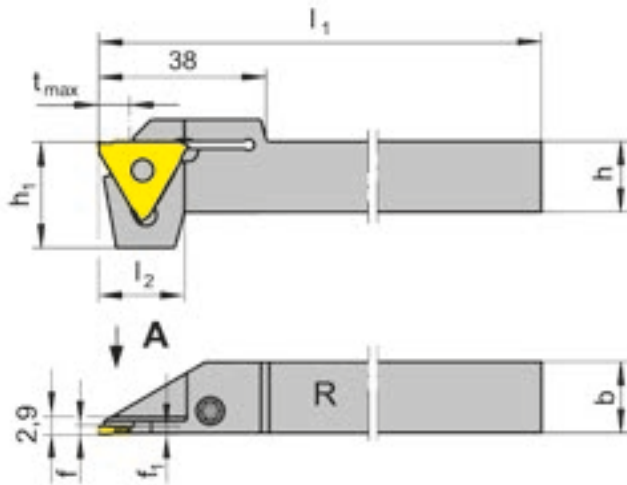
368

槽深可达
槽宽

Depth of groove up to
Width of groove

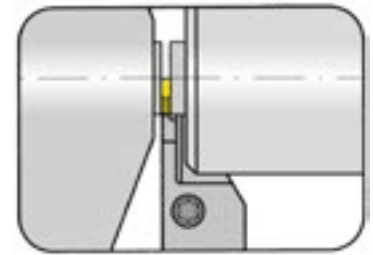
8 mm
0.5-1.5 mm

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



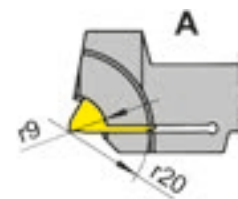
R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



配合可转位刀片
for Indexable insert

型号 312 w ≤ 1.5 mm
Type



仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}
R/L368.1212.08	12	12	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1616.08	16	16	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1212.11	12	12	95	19.5	24	1.3	f ₁ +a ₁	8
R/L368.1616.11	16	16	95	19.5	24	1.3	f ₁ +a ₁	8

注明R或L型
State R or L version

a1见刀片
a1 see indexable inserts

尺寸单位：mm
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：

R/L312.0515... / R/L312.0015...V1

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...V1

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368...	4.15T15P	T15PQ

刀杆

Toolholder

368

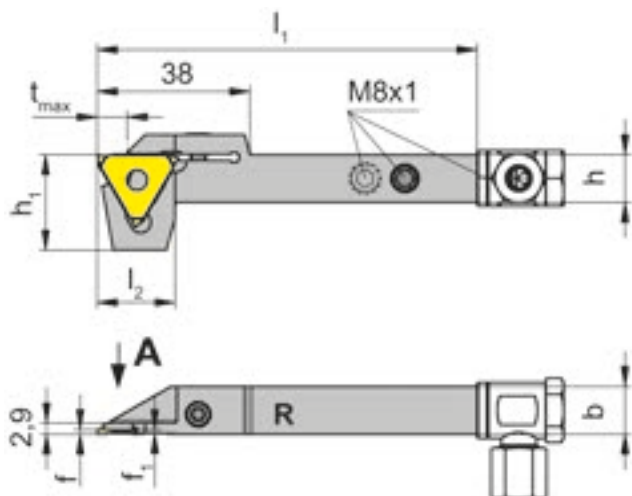
直接冷却液供应
with through coolant supply

槽深可达
槽宽

Depth of groove up to
Width of groove

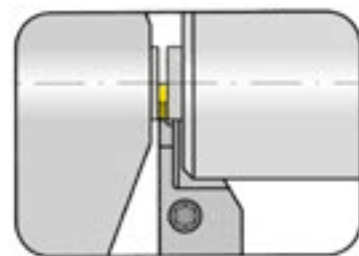
8 mm
0.5-1.5 mm

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



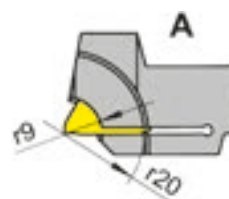
R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



配合可转位刀片
for Indexable insert

型号 312 w ≤ 1.5 mm
Type



仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}
R/L368.1212.08.IK	12	12	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1616.08.IK	16	16	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1212.11.IK	12	12	95	19.5	24	1.3	f ₁ +a ₁	8
R/L368.1616.11.IK	16	16	95	19.5	24	1.3	f ₁ +a ₁	8

注明R或L型
State R or L version

a1见刀片
a1 see indexable inserts

尺寸单位：mm
Dimensions in mm

刀杆R/L368...08.IK用于可转位刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08.IK for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510... / R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11.IK用于可转位刀片：

R/L312.0515... / R/L312.0015...V1

Toolholder R/L368...11.IK for indexable inserts

R/L312.0515... / R/L312.0015...V1

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368.1212...	4.15T15P	004.00.61	T15PQ
R/L368.1616...	4.15T15P	SBD 6 LR - G1/8"	T15PQ

切断

Parting Off



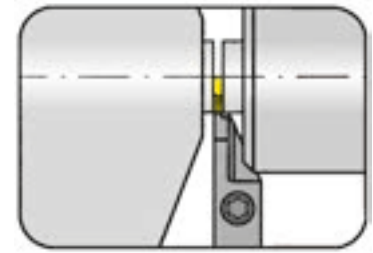
N

刀杆

Toolholder

368

加强型
reinforced version



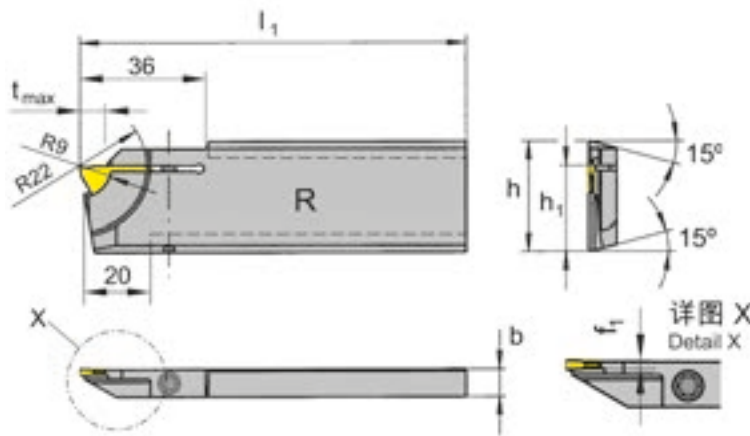
槽深可达
槽宽

Depth of groove up to
Width of groove

8 mm
0.5-1.5 mm

配合可转位刀片
for Indexable insert

型号 312 w ≤ 1.5 mm
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}
R/L368.2608.08	26	8	110	21.4	1.0	8
R/L368.3208.08	32	8	110	24.8	1.0	8
R/L368.2608.11	26	8	110	21.4	1.3	8
R/L368.3208.11	32	8	110	24.8	1.3	8

注明R或L型
State R or L version

尺寸单位：mm
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：
R/L312.0515... / R/L312.0015...V1

Toolholder R/L368...11 for indexable inserts:
R/L312.0515... / R/L312.0015...V1

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368...	4.15T15P	T15PQ

切断

Parting Off



刀杆

Toolholder

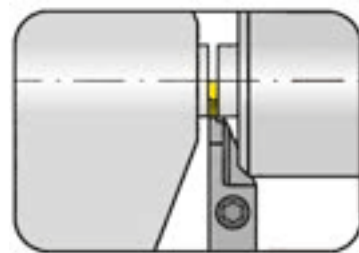
368

加强型
reinforced version

槽深可达
槽宽

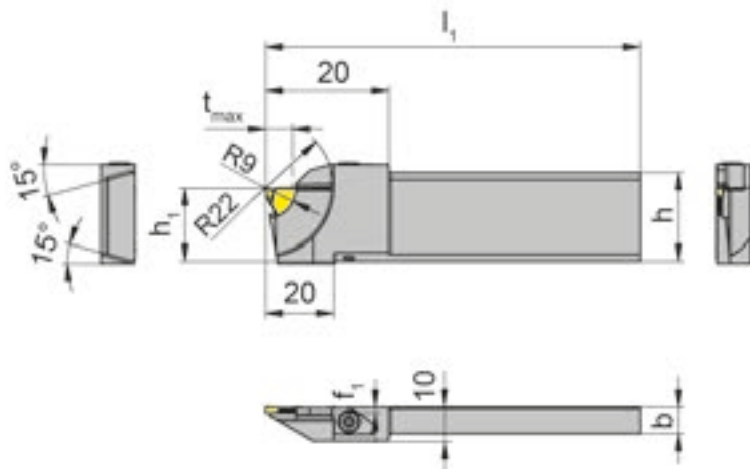
Depth of groove up to
Width of groove

8 mm
1.1-2 mm



配合可转位刀片
for Indexable insert

型号 312 w ≤ 2 mm
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}
R/L368.2608.10.01	26	8	110	21.2	1	8

注明R或L型
State R or L version

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368.2608.10.01	010.0004.0536	T10PL

切槽 (外圆)

Grooving (external)



N

刀杆

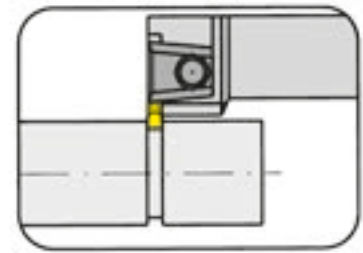
Toolholder

369

槽深可达
夹持范围

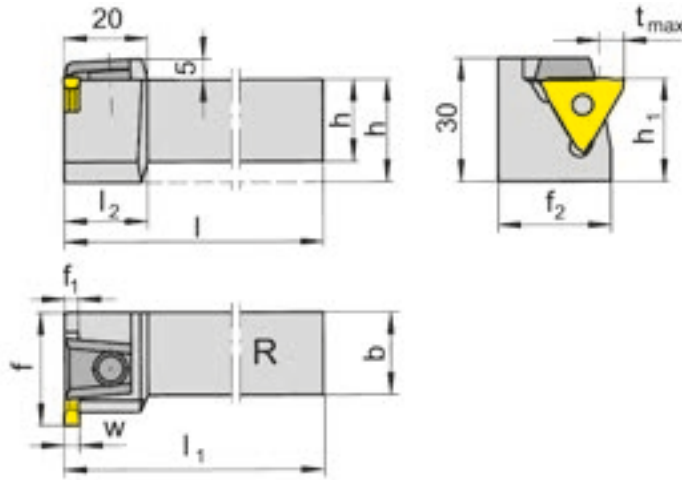
Depth of groove up to
Clamping range

6 mm
0.5-6.3 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l	l_1	l_2	h_1	f	t_{max}	f_1	f_2	尺寸规格 Size	夹持范围 Clamping range
R/L369.2020.01	20	20	125	$l-f_1+w-a_1$	20	25	27	4	1.5	23.5	01	0.5-1.9
R/L369.2525.01	25	25	150	$l-f_1+w-a_1$	-	25	32	4	1.5	28.5	01	0.5-1.9
R/L369.2020.02	20	20	125	$l-f_1+w-a_1$	20	25	27	6	2.5	23.5	02	1.9-2.9
R/L369.2525.02	25	25	150	$l-f_1+w-a_1$	-	25	32	6	2.5	28.5	02	1.9-2.9
R/L369.2020.03	20	20	125	$l-f_1+w-a_1$	20	25	27	6	3.5	23.5	03	2.9-3.9
R/L369.2525.03	25	25	150	$l-f_1+w-a_1$	-	25	32	6	3.5	28.5	03	2.9-3.9
R/L369.2020.04	20	20	125	$l-f_1+w-a_1$	20	25	27	6	4.5	23.5	04	3.9-6.3
R/L369.2525.04	25	25	150	$l-f_1+w-a_1$	-	25	32	6	4.5	28.5	04	3.9-6.3

注明R或L型
State R or L version

w, a_1 见刀片
 w, a_1 see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到 t_{max}
 t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L369...	SW3,0 DIN911	16.4

刀杆

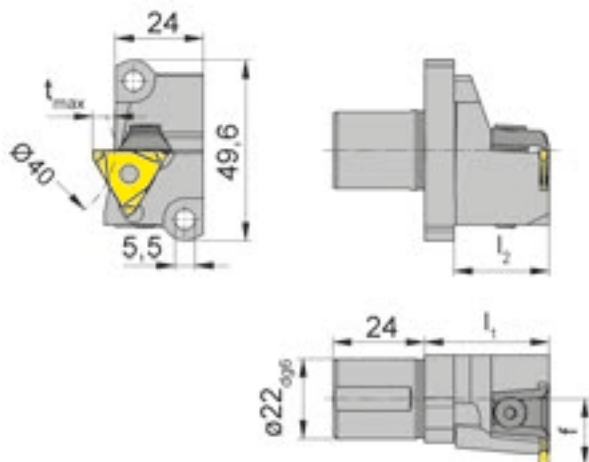
Toolholder

369

槽深
夹持范围Depth of groove
Clamping range4-6 mm
0.5-2.9 mm

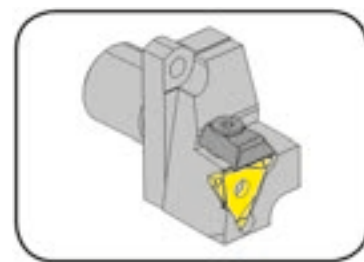
孔位 13,7 x 37,6 mm

Hole pattern 13,7 x 37,6 mm



L=左手型-如图

L = left hand version shown

配合可转位刀片
for Indexable insert型号 312
Type S312
N312适用于Star Swiss机床
for Swiss type machines Star

产品型号 Part number	l_2	f	t_{max}	l_1	尺寸规格 Size	夹持范围 Clamping range
L369.A022.18.01	26	18.2	4	34	01	0.5-1.9
L369.A022.18.02	26	18.2	6	34	02	1.9-2.9

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

适用于Star Swiss机床: 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

尺寸单位: mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
L369...	SW3,0 DIN911	16.4

Graf刀夹

Cartridge Graf

64/65

直接冷却液供应
with through coolant supply

槽深
夹持范围

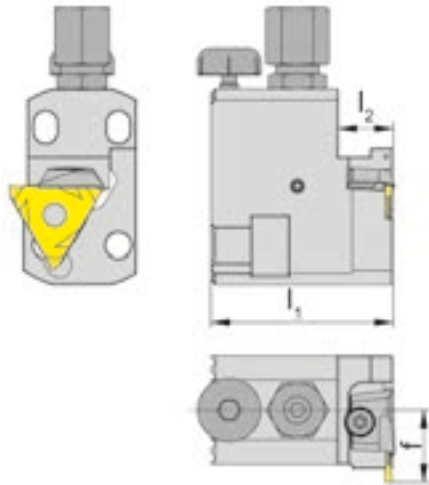
Depth of groove
Clamping range

4 mm
0.5-2.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l_2	f	尺寸规格 Size	夹持范围 Clamping range
R/L64IK	40	12	16	01	0.5-1.9
R/L65IK	40	12	16	02	1.9-2.9

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

Graf刀夹 Cartridge Graf	高度调节螺钉 Screw to adjust the height	冷却液供应 Coolant supply	压板 Clamping element
L6...	002.00.69	004.00.19	4.082L
R6...	002.00.69	004.00.19	4.081R

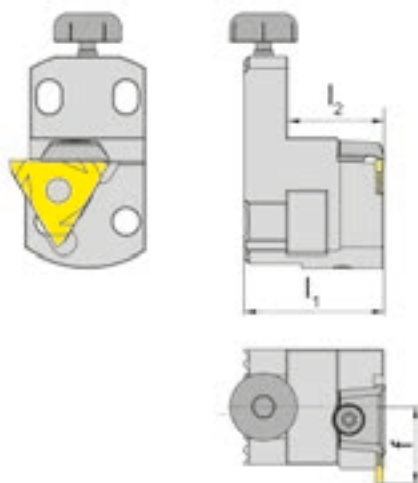
Graf刀夹

Cartridge Graf

64/65/99

槽深
夹持范围Depth of groove
Clamping range4 mm
0.5-3.9 mm配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l_2	f	尺寸规格 Size	夹持范围 Clamping range
R/L64	29	20	16	01	0.5-1.9
R/L65	29	20	16	02	1.9-2.9
R/L99	29	20	16	03	2.9-3.9

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

Graf刀夹 Cartridge Graf	高度调节螺钉 Screw to adjust the height	压板 Clamping element
R/L...	002.00.69	12.3

可调刀杆

Adjustable holder

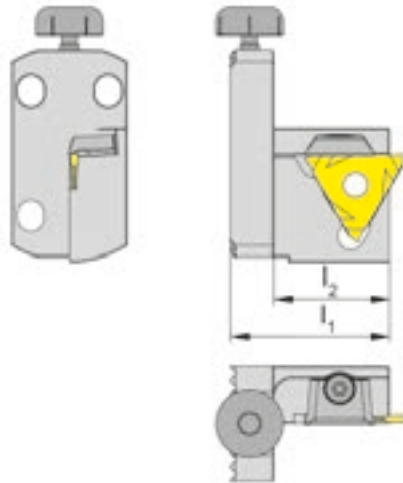
N67/N68/N99



槽深
夹持范围

Depth of groove
Clamping range

4 mm
0.5-3.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312

产品型号 Part number	l_1	l_2	尺寸规格 Size	夹持范围 Clamping range
N67	33	29	01	0.5-1.9
N68	33	29	02	1.9-2.9
N98	33	29	02	2.9-3.9

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

可调刀杆 Adjustable holder	高度调节螺钉 Screw to adjust the height	压板 Clamping element
N...	002.00.69	12.3

切槽 (外圆)

Grooving (external)

刀杆

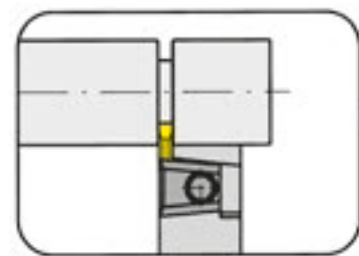
Toolholder

390

槽深可达
夹持范围

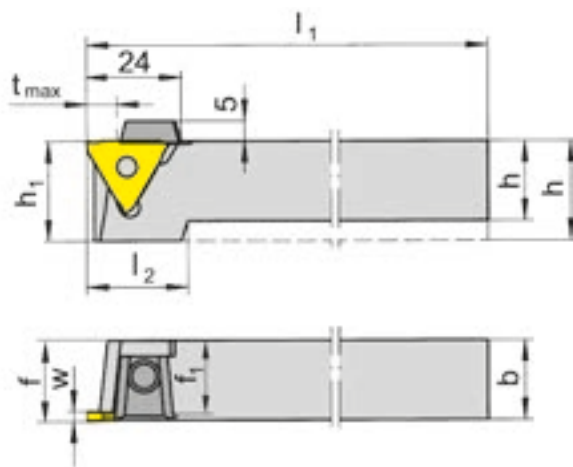
Depth of groove up to
Clamping range

8 mm
1.4-5.3 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L390.2020.01	20	20	125	22	25	18.5	f_1+w-a_1	8	01	1.4-1.9
R/L390.2525.01	25	25	150	-	25	23.5	f_1+w-a_1	8	01	1.4-1.9
R/L390.2020.02	20	20	125	22	25	17.5	f_1+w-a_1	8	02	1.9-2.9
R/L390.2525.02	25	25	150	-	25	22.5	f_1+w-a_1	8	02	1.9-2.9
R/L390.3232.02	32	32	170	-	32	29.5	f_1+w-a_1	8	02	1.9-2.9
R/L390.2020.03	20	20	125	22	25	16.5	f_1+w-a_1	8	03	2.9-3.9
R/L390.2525.03	25	25	150	-	25	21.5	f_1+w-a_1	8	03	2.9-3.9
R/L390.3232.03	32	32	170	-	32	28.5	f_1+w-a_1	8	03	2.9-3.9
R/L390.2020.04	20	20	125	22	25	14.8	f_1+w-a_1	8	04	3.9-5.3
R/L390.2525.04	25	25	150	-	25	19.8	f_1+w-a_1	8	04	3.9-5.3
R/L390.3232.04	32	32	170	-	32	26.8	f_1+w-a_1	8	04	3.9-5.3

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\phi \leq 125\text{mm}$ 时才能达到最大切深 t_{max}

t_{max} can be reached only with workpiece $\phi \leq 125\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L390...	SW3,0 DIN911	16.4

切槽 (外圆)

Grooving (external)



N

刀杆

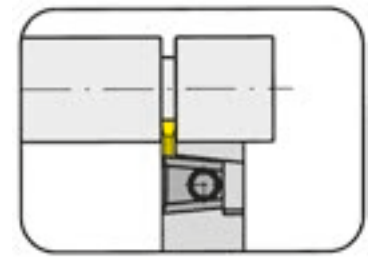
Toolholder

391

槽深可达
夹持范围

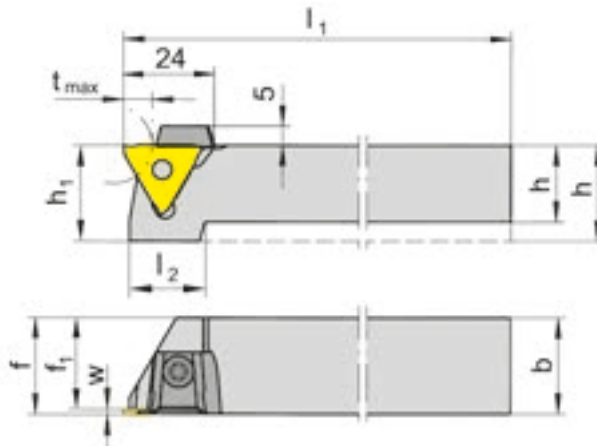
Depth of groove up to
Clamping range

8 mm
0.5-1.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L391.1212.01	12	12	100	21	21	10.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.1616.01	16	16	125	21	21	14.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.2020.01	20	20	125	21	21	18.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.2525.01	25	25	150	-	25	23.8	f_1+w-a_1	8	01	0.5-1.9

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\phi \leq 20\text{mm}$ 时才能达到 t_{max}

t_{max} can be reached only with workpiece $\phi \leq 20\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Allen Wrench
R/L391.1212.01	12.3	T10PL	-
R/L391.1616.01	14.4	T15PQ	-
R/L391....	16.4	-	SW3,0 DIN911

切退刀槽 (外圆)

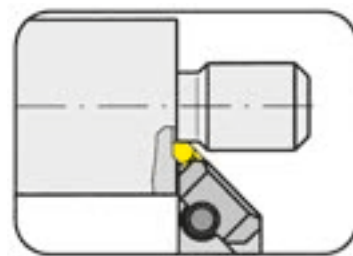
Grooving Corner Reliefs (external)

刀杆

Toolholder

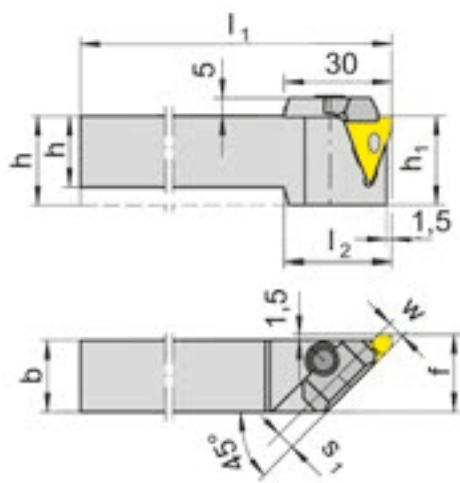
309

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



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f	s_1	尺寸规格 Size	夹持范围 Clamping range
R/L309.1616.01	16	16	125	30	25	21.5	1.5	01	0.5-1.9
R/L309.2020.02	20	20	125	30	25	21.5	2.5	02	1.9-2.9
R/L309.2525.02	25	25	150	-	25	26.5	2.5	02	1.9-2.9
R/L309.3232.02	32	32	170	-	32	33.5	2.5	02	1.9-2.9
R/L309.2020.03	20	20	125	30	25	21.5	3.5	03	2.9-3.9
R/L309.2525.03	25	25	150	-	25	26.5	3.5	03	2.9-3.9
R/L309.3232.03	32	32	170	-	32	33.5	3.5	03	2.9-3.9
R/L309.2020.04	20	20	125	30	25	21.5	5.2	04	3.9-5.3
R/L309.2525.04	25	25	150	-	25	26.5	5.2	04	3.9-5.3
R/L309.3232.04	32	32	170	-	32	33.5	5.2	04	3.9-5.3

注明R或L型

State R or L version

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L309...	SW3,0 DIN911	21.4

切槽 (外圆) Grooving (external)

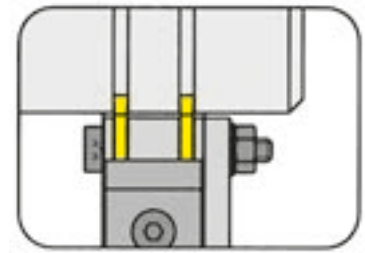


N

刀杆 Toolholder

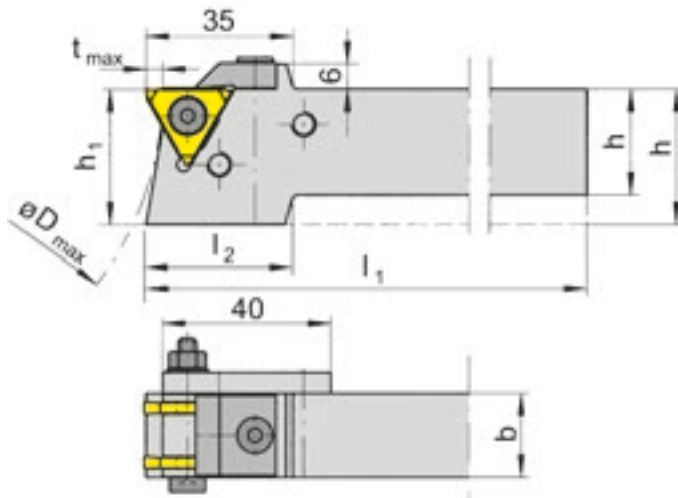
340

多槽切削
Multi grooving



配合可转位刀片
for Indexable insert

型号 312 Special
Type



产品型号 Part number	h	b	l ₁	l ₂	h ₁	D _{max}	t _{max}	尺寸规格 Size
340.2020.01	20	20	170	35	32	160	4	01
340.2520.01	25	20	170	35	32	160	4	01
340.3220.01	32	20	170	-	32	160	4	01

按需提供更多尺寸
Further sizes upon request

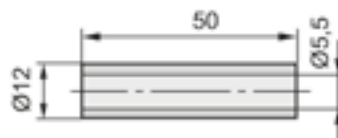
尺寸单位：mm
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

用于间隔环的管子 产品型号:340.0012.50 需单独订购

Tube for producing spacing rings Part number 340.0012.50 separate order required



配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	弹簧片 Spring plate	法兰 Flange	扳手 Allen Wrench	压板 Clamping element	垫圈 Washer
340...	5.30.7984	5.12.03	24.40	SW3,0 DIN911	340.0200	B5.3 DIN 125-St

切槽 (外圆)

Grooving (external)

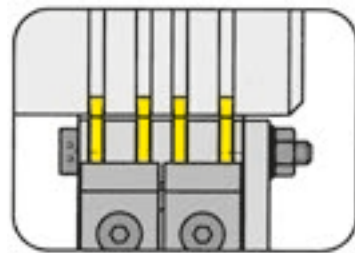


刀杆

Toolholder

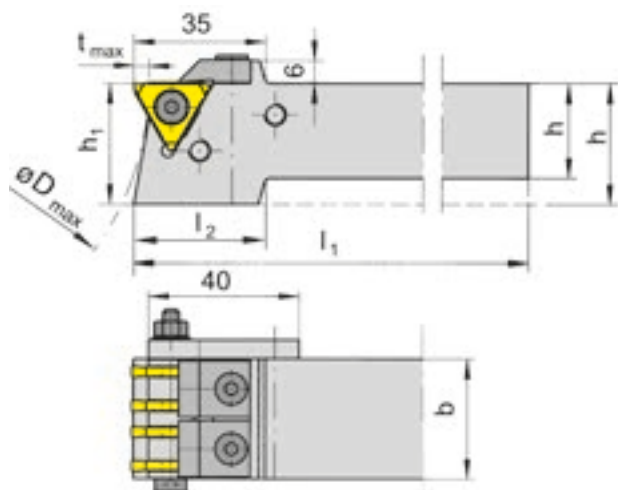
340

多槽切削
Multi grooving



für Wendeschneidplatte
for Indexable insert

型号 312 Special
Type



右手安装
Right hand mounted

产品型号 Part number	h	b	l_1	l_2	h_1	D_{max}	t_{max}	尺寸规格 Size
340.2532.02	25	32	170	35	32	160	4	02
340.3232.02	32	32	170	-	32	160	4	02

按需提供更多尺寸
Further sizes upon request

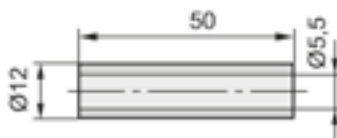
尺寸单位：mm
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

用于间隔环的管子 产品型号:340.0012.50 需单独订购

Tube for producing spacing rings Part number 340.0012.50 separate order required



配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Screw	弹簧片 Spring plate	法兰 Flange	螺纹垫圈 Thread-Ring	扳手 Wrench	螺钉 Package screw
340...	6.16.7991	5.12.03	24.40	12.3.8.5	SW3,0 DIN911	5.40.7984

刀杆 Toolholder	压板 Clamping element	垫圈 Washer
340...	22.16	B5.3 DIN 125-St

切槽 (内圆)

Grooving (internal)



N

常规刀柄

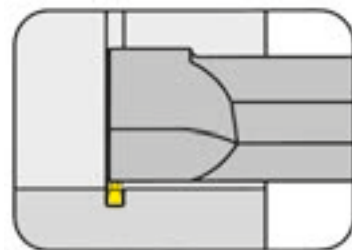
Basic toolholder

330

孔径Ø 自
夹持范围

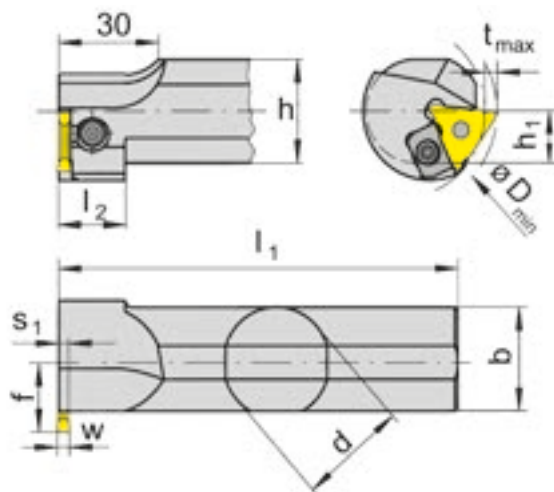
Bore Ø from
Clamping range

46 mm
1.9-6.3 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312
N312



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

D _{min}	t _{max}
46	2,0
50	3,0
60	4,0
80	4,5
100	5,0

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	s ₁	h ₁	f	D _{min}	b	尺寸规格 Size	夹持范围 Clamping range
R/L330.0025.K2	25	170	20	23	2.5	11.5	20	46	25	02	1.9-2.9
R/L330.0032.K2	32	200	20	30	2.5	15.0	20	46	30	02	1.9-2.9
R/L330.0040.K2	40	250	-	38	2.5	19.0	24	46	38	02	1.9-2.9
R/L330.0025.K3	25	170	20	23	3.5	11.5	20	46	25	03	2.9-3.9
R/L330.0032.K3	32	200	20	30	3.5	15.0	20	46	30	03	2.9-3.9
R/L330.0040.K3	40	250	-	38	3.5	19.0	24	46	38	03	2.9-3.9
R/L330.0025.K4	25	170	20	23	5.5	11.5	20	46	25	04	3.9-6.3
R/L330.0032.K4	32	200	20	30	5.5	15.0	20	46	30	04	3.9-6.3
R/L330.0040.K4	40	250	20	38	5.5	19.0	24	46	38	04	3.9-6.3

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

常规刀柄 Basic toolholder	导向块 Attachment bar	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L330...	020.1025.0170	5.12T20P	SW3,0 DIN911	15.4	T20PQ

可转位刀片

Indexable insert

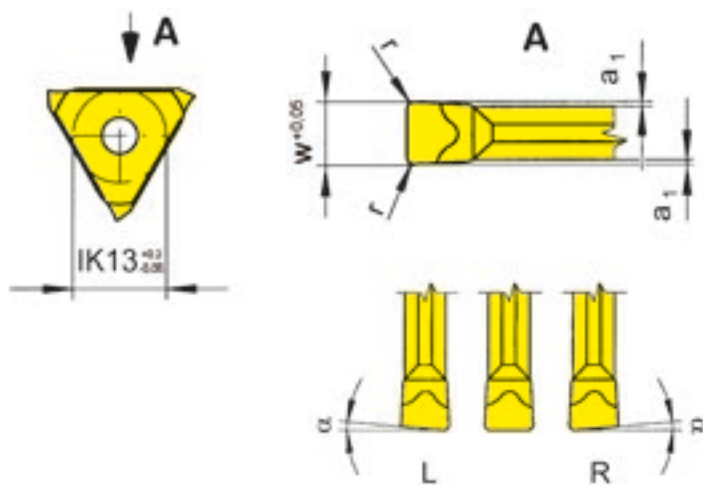
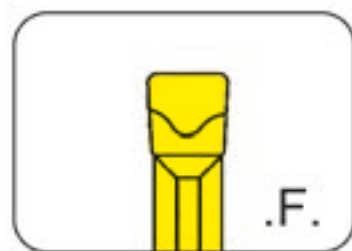
S312

带烧结槽型
with sintered geometries

槽宽

Width of groove

2-5 mm



R=右手型-如图

R = right hand version shown

1 = 左手型

L = left hand version

配合刀杆

for Toolholder

型号

Type

309

360

361

390

369

330

360C

360TS
N100N68
65

65

槽型.F

Geometry .F

产品型号 Part number	w	r	α	a ₁	尺寸规格 Size		AL96	EG56	TC92	TF45	TF46	T125
R/LS312.0520.F2	2.0	0.2	5°	0.25	02			Δ/Δ			▲/Δ	▲/▲
S312.0200.F2	2.0	0.2	0°	0.25	02		Δ	▲	Δ	Δ	▲	▲
R/LS312.0525.F2	2.5	0.2	5°	0.25	02			▲/Δ			▲/Δ	▲/▲
S312.0250.F2	2.5	0.2	0°	0.25	02		Δ	Δ	Δ	Δ	▲	▲
S312.0400.F2	4.0	0.2	0°	0.25	04			Δ			▲	Δ
S312.0400.F4	4.0	0.4	0°	0.25	04			▲			▲	▲
S312.0500.F2	5.0	0.2	0°	0.25	04			▲			▲	
S312.0500.F4	5.0	0.4	0°	0.25	04			Δ			Δ	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

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

硬质合金牌号
Carbide grades

尺寸单位: mm

Dimensions in mm

注明R或I 型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

切槽 (内圆和外圆)

Grooving (external and internal)



N

可转位刀片

Indexable insert

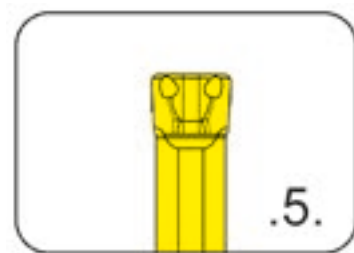
S312

带烧结槽型
with sintered geometries

槽宽

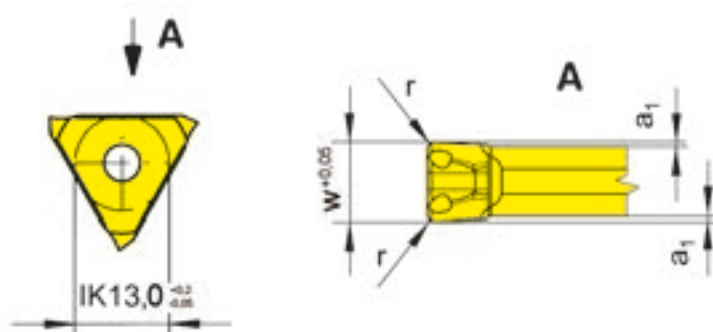
Width of groove

2.5-5 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



槽型.5
Geometry .5

产品型号 Part number	w	r	a ₁	尺寸规格 Size		AL96	AS62	AS66	EG56	TC92	TF45	TF46	TI25	TN32	TN35
S312.0250.52	2.5	0.2	0.25	02		▲	▲	▲	▲	△	▲	▲	▲	▲	
S312.0250.54	2.5	0.4	0.25	02		△	▲	▲	▲	△	▲	▲	▲	▲	▲
S312.0300.52	3.0	0.2	0.25	03		△	▲	▲	▲	△	▲	▲	▲	▲	
S312.0300.54	3.0	0.4	0.25	03		△	▲	▲	▲	△	△	▲	▲	▲	
S312.0400.52	4.0	0.2	0.25	04			▲	▲	▲			▲	▲	△	
S312.0400.54	4.0	0.4	0.25	04			▲	▲	▲			▲	▲	▲	
S312.0500.52	5.0	0.2	0.25	04			▲	▲	▲			▲	△	△	
S312.0500.54	5.0	0.4	0.25	04			▲	▲	△			▲	▲	△	
						P	●	●	●	●	●	●	●	●	●
						M	-	-	○	○	-	○	●	-	●
						K	●	-	●	○	-	●	●	-	●
						N	●	-	●	-	-	●	●	-	●
						S	-	-	○	-	-	○	●	-	●
						H	-	-	-	-	-	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

可转位刀片

Indexable insert

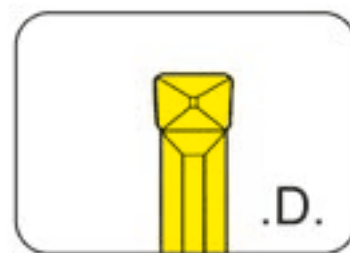
S312

带烧结槽型
with sintered geometries

槽宽

Width of groove

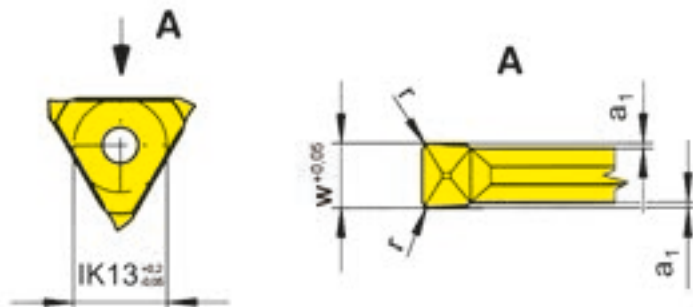
2-3 mm



配合刀杆

for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

槽型.D
Geometry .D

产品型号 Part number	w	r	a ₁	尺寸规格 Size	AL96	AS62	AS66	EG56	TC92	TF45	TF46	TI25	TN32
S312.0200.D2	2.0	0.2	0.25	02	Δ	▲	▲	▲	Δ	Δ	▲	▲	▲
S312.0200.D4	2.0	0.4	0.25	02	Δ	▲	▲	▲	Δ	Δ	Δ	▲	Δ
S312.0250.D2	2.5	0.2	0.25	02	Δ	▲	▲	▲	▲	▲	▲	▲	▲
S312.0250.D4	2.5	0.4	0.25	02	Δ	▲	▲	▲	▲	▲	▲	▲	▲
S312.0300.D2	3.0	0.2	0.25	03	Δ	Δ	▲	▲	Δ	▲	▲	▲	▲
S312.0300.D4	3.0	0.4	0.25	03	Δ	▲	▲	▲	Δ	Δ	Δ	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	o	o	-	●	o	●
o 次推荐 / alternative recommendation					K	●	-	●	o	-	●	●	-
- 不合适 / not suitable					N	●	-	●	-	-	●	●	-
■ 非涂层 / uncoated grades					S	-	-	o	-	-	●	o	●
■ 涂层 / coated grades					H	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切断

Parting Off



N

可转位刀片

Indexable insert

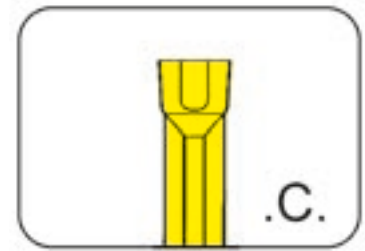
S312

带烧结槽型
with sintered geometries

槽深可达
槽宽

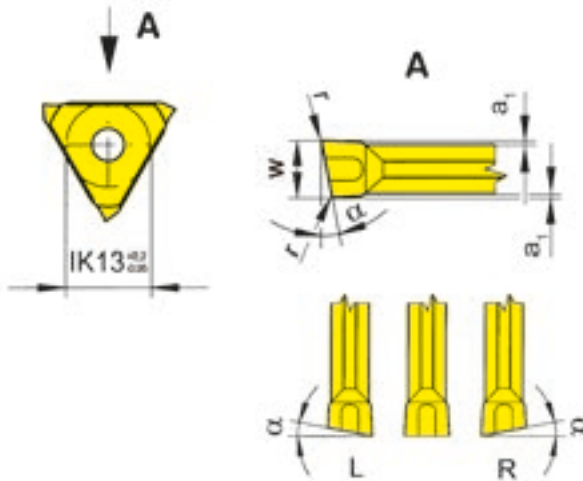
Depth of groove up to
Width of groove

5 mm
2-3 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.C
Geometry .C

产品型号 Part number	w	r	α	a_1	尺寸规格 Size	EG55	TF46	TI25
S312.0200.C2	2.0	0.2	0°	0.25	02	▲	▲	▲
R/LS312.0520.C2	2.0	0.2	5°	0.25	02	▲/▲	▲/Δ	▲/▲
S312.0250.C2	2.5	0.2	0°	0.25	02	▲	Δ	▲
R/LS312.0525.C2	2.5	0.2	5°	0.25	02	Δ/▲	▲/Δ	▲/▲
S312.0300.C2	3.0	0.2	0°	0.25	03	Δ	Δ	Δ
R/LS312.0530.C2	3.0	0.2	5°	0.25	03	Δ/Δ	Δ/Δ	▲/Δ
						P	•	•
						M	o	o
						K	o	•
						N	-	•
						S	-	o
						H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

• 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽 (外圆)

Grooving (external)



可转位刀片

Indexable insert

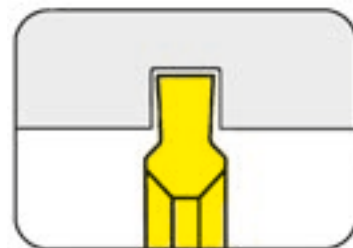
312

带圆形断屑槽
with round chip breaker

卡簧槽
卡簧宽度Nw

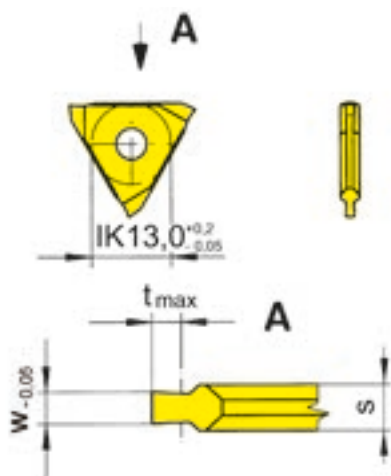
Circlip grooves
Width of circlip Nw

DIN 471/472
0.5-1 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



刀片长度重复定位精度
±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	Nw	t _{max}	s	尺寸规格 Size	EG52	TN32
312.0050.15	0.57	0.5	0.7	1.5	01	▲	▲
312.0060.15	0.67	0.6	0.8	1.5	01	▲	▲
312.0070.15	0.77	0.7	1.1	1.5	01	▲	▲
312.0080.15	0.87	0.8	1.2	1.5	01	▲	▲
312.0090.15	0.97	0.9	1.4	1.5	01	▲	▲
312.0100.15	1.07	1.0	1.6	1.5	01	▲	▲
						P	•
						M	-
						K	-
						N	-
						S	-
						H	•

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆和外圆)

Grooving (external and internal)



N

可转位刀片

Indexable insert

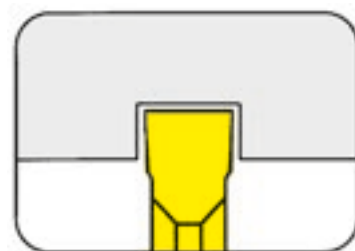
312

带圆形断屑槽
with round chip breaker

卡簧槽
卡簧宽度Nw

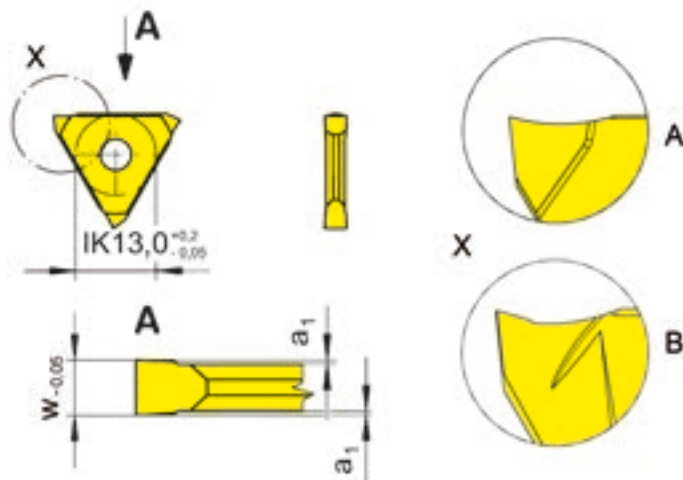
Circlip grooves
Width of circlip Nw

DIN 471/472
0.5-1 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



形式A = 完全研磨
Form A = completely ground

形式B = 部分研磨
Form B = partially ground

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	w	Nw	a ₁	形式 Form	尺寸规格 Size	K10	MG12	EG35	EG55	EG56	H20	HS32	HS36	P20	TA45	TC92	TF45	TF46	TI25	TN32	TN35
312.0050.00	0.57	0.50	0.07	A	01	▲			▲					▲			▲	▲		▲	
312.0060.00	0.67	0.60	0.07	A	01	▲			▲					▲			▲	▲		▲	
312.0070.00	0.77	0.70	0.08	A	01	▲			▲					▲			▲	▲		▲	
312.0080.00	0.87	0.80	0.08	A	01	▲			▲					▲			▲	▲		▲	
312.0090.00	0.97	0.90	0.08	A	01	▲			▲					▲			▲	▲		▲	▲
312.0100.00	1.07	1.00	0.09	A	01	▲			▲		Δ			▲			▲	▲		▲	▲
312.0110.00	1.24	1.10	0.20	A	01	▲			▲			Δ	Δ	▲		▲	▲	▲		▲	▲
312.0130.00	1.44	1.30	0.20	A	01	▲			▲					▲		▲	▲	▲		▲	▲
312.0160.00	1.74	1.60	0.20	A	01	▲			▲					▲		▲	▲	▲		▲	▲
312.0185.00	1.99	1.85	0.20	B	01	▲	▲		▲	Δ	▲			▲		▲	▲	▲	▲	▲	▲
312.0215.00	2.29	2.15	0.20	B	02	▲	▲		▲		▲			▲		▲	▲	▲		▲	▲
312.0265.00	2.79	2.65	0.20	B	02	▲	▲		▲		▲			▲	Δ	▲	▲	▲		▲	▲
312.0315.00	3.29	3.15	0.20	B	03	▲			▲		▲			▲		▲	▲	▲		▲	▲
312.0415.00	4.29	4.15	0.20	B	04	▲			▲		▲			▲		▲	▲	▲		▲	▲
312.0515.00	5.29	5.15	0.20	B	04	▲		▲	▲		▲			▲		Δ	▲	▲		▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks X 根据要求 / upon request						P	●	○	●	●	●	○	-	●	●	●	●	●	●	●	●
● 推荐 / recommended						M	○	●	●	○	○	○	-	-	●	-	●	○	●	-	●
○ 次推荐 / alternative recommendation						K	●	●	○	○	○	-	-	-	●	-	●	●	●	-	●
- 不合适 / not suitable						N	●	●	-	-	-	-	-	-	●	-	●	●	●	-	●
非涂层 / uncoated grades						S	○	●	-	-	-	-	-	-	●	-	●	○	●	-	●
涂层 / coated grades						H	-	-	-	-	-	●	●	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet																					

尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

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

切槽 (内圆和外圆)

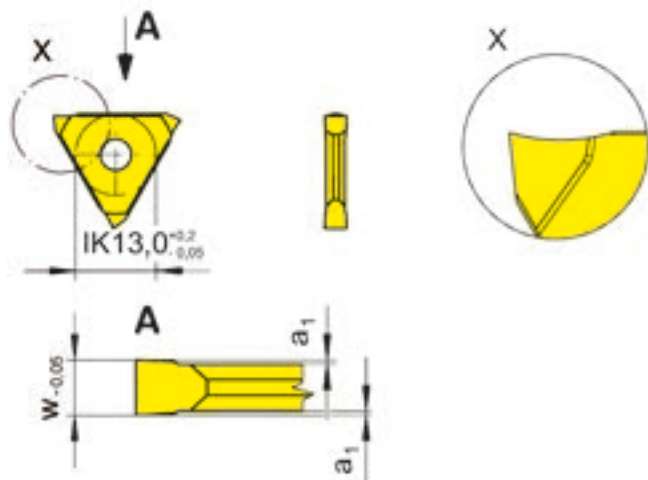
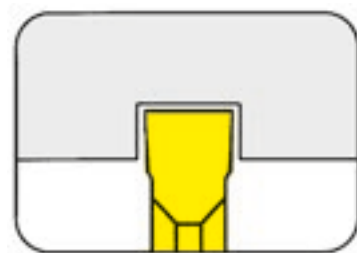
Grooving (external and internal)



可转位刀片

Indexable insert

312

带圆形断屑槽
with round chip breaker卡簧槽
卡簧宽度NwCirclip grooves
Width of circlip NwDIN 471/472
1.85-5.15 mm完全研磨
completely ground配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度

 ± 0.02 mmIndexability length ± 0.02 mm

产品型号 Part number	w	Nw	a ₁	尺寸规格 Size	K10 EG56 P20 TN32
312.0185.10	1.99	1.85	0.2	01	
312.0215.10	2.29	2.15	0.2	02	
312.0265.10	2.79	2.65	0.2	02	
312.0315.10	3.29	3.15	0.2	03	
312.0415.10	4.29	4.15	0.2	04	
312.0515.10	5.29	5.15	0.2	04	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					
● 推荐 / recommended					
○ 次推荐 / alternative recommendation					
- 不合适 / not suitable					
■ 非涂层 / uncoated grades					
■ 涂层 / coated grades					
■ 钎焊/金属陶瓷 / brazed/Cermet					

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

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽 (外圆)

Grooving (external)



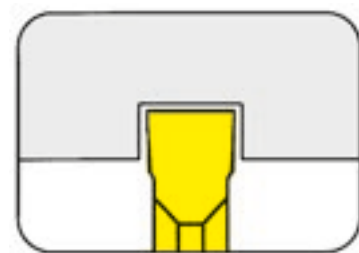
N

可转位刀片

Indexable insert

312

带圆形断屑槽
with round chip breaker

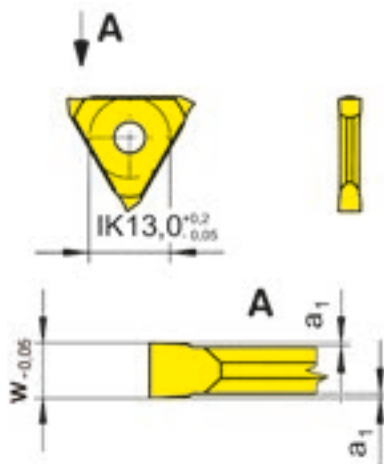


卡簧槽
卡簧宽度Nw

Circlip grooves
Width of circlip Nw

DIN 471/472
1.1-5.15 mm

推荐用于断续切削
recommended for interrupted cut



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度
 ± 0.02 mm
Indexability length $\pm 0,02$ mm

产品型号 Part number	w	Nw	a ₁	尺寸规格 Size	EG55	TN35
312.0110.80	1.24	1.10	0.2	01	▲	▲
312.0130.80	1.44	1.30	0.2	01	▲	▲
312.0160.80	1.74	1.60	0.2	01	▲	▲
312.0185.80	1.99	1.85	0.2	01	▲	▲
312.0215.80	2.29	2.15	0.2	02	▲	▲
312.0265.80	2.79	2.65	0.2	02	▲	▲
312.0315.80	3.29	3.15	0.2	03	▲	▲
312.0415.80	4.29	4.15	0.2	04	▲	▲
312.0515.80	5.29	5.15	0.2	04	▲	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	●	●
M	○	●
K	○	●
N	-	●
S	-	●
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆和外圆)

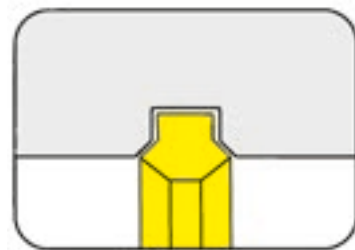
Grooving (external and internal)



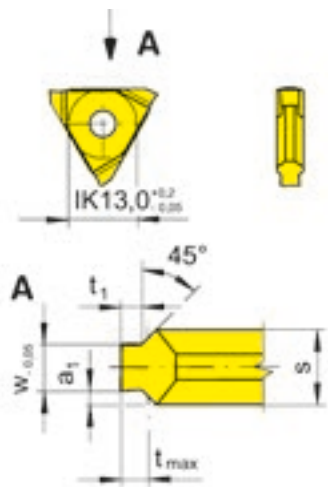
可转位刀片

Indexable insert

312

带圆形断屑槽
with round chip breaker卡簧槽
卡簧宽度NwCirclip grooves
Width of circlip NwDIN 471/472
1.1-5.15 mm带倒角
with chamfer配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度
±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	Nw	t _{max}	a ₁	s	t ₁	尺寸规格 Size	EG52	P20	TN32	TN35
312.1101.25	1.24	1.10	0.20	0.64	2.5	0.19	02	Δ		Δ	
312.1102.25	1.24	1.10	0.25	0.64	2.5	0.24	02	▲		▲	
312.1103.25	1.24	1.10	0.30	0.64	2.5	0.29	02	▲		▲	
312.1104.25	1.24	1.10	0.35	0.64	2.5	0.33	02	Δ		▲	
312.1105.25	1.24	1.10	0.40	0.64	2.5	0.36	02	▲	▲	▲	Δ
312.1306.25	1.44	1.30	0.55	0.54	2.5	0.45	02	▲	Δ	▲	
312.1607.33	1.74	1.60	0.70	0.79	3.3	0.60	03	▲		▲	
312.1608.33	1.74	1.60	0.85	0.79	3.3	0.75	03	▲	Δ	▲	
312.1609.33	1.74	1.60	1.00	0.79	3.3	0.85	03	▲		▲	
312.1810.33	1.99	1.85	1.00	0.67	3.3	0.85	03	▲		▲	
312.1812.33	1.99	1.85	1.25	0.67	3.3	1.10	03	▲	Δ	▲	
312.2115.43	2.29	2.15	1.50	1.02	4.3	1.35	04	▲	▲	▲	
312.2616.43	2.79	2.65	1.50	0.77	4.3	1.35	04	▲	Δ	▲	
312.2617.43	2.79	2.65	1.75	0.77	4.3	1.60	04	▲	Δ	▲	
312.3118.53	3.29	3.15	1.75	1.02	5.3	1.60	04	▲	Δ	▲	
312.4120.53	4.29	4.15	2.00	0.52	5.3	1.85	04	▲		▲	
312.4125.53	4.29	4.15	2.50	0.52	5.3	2.35	04	Δ		▲	
312.5130.63	5.29	5.15	3.00	0.52	6.3	2.85	04	Δ		▲	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

N32

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

硬质合金牌号
Carbide grades

可转位刀片

Indexable insert

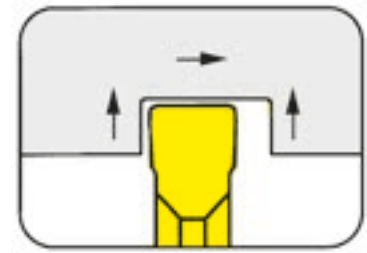
312

带圆形断屑槽
with round chip breaker

槽深可达
槽宽

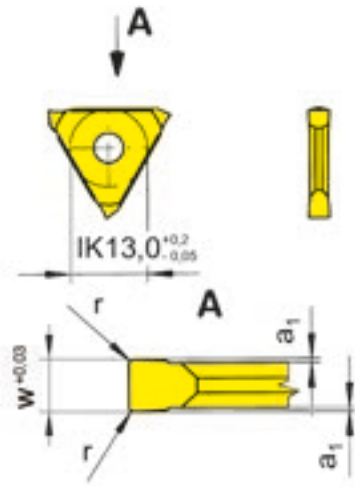
Depth of groove up to
Width of groove

6 mm
1-4 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



刀片长度重复定位精度

±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	r	a ₁	尺寸规格 Size		K10	AS62	EG52	H20	P20	TF45	TI22	TI25	TN32	TN35	TN38
312.0100.02	1.0	0.2	0.10	01				▲					▲	▲		
312.0150.02	1.5	0.2	0.25	01		Δ		▲		▲			▲	▲	▲	
312.0200.02	2.0	0.2	0.25	02		▲		▲	▲	▲	▲	▲	▲	▲	▲	
312.0200.04	2.0	0.4	0.25	02			▲	▲	▲	▲				▲		
312.0300.02	3.0	0.2	0.25	03		Δ		▲	▲	▲			▲	▲		
312.0300.06	3.0	0.6	0.25	03				▲		▲				▲		
312.0300.08	3.0	0.8	0.25	03				▲		Δ				▲		Δ
312.0400.02	4.0	0.2	0.25	04				▲	▲	▲				▲		
312.0400.08	4.0	0.8	0.25	04				▲	▲	Δ				▲		
312.0400.12	4.0	1.2	0.25	04				Δ		Δ						
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P	●	●	●	●	●	●	●	●	●	●
● 推荐 / recommended						M	○	-	○	○	-	-	●	-	●	●
○ 次推荐 / alternative recommendation						K	●	-	-	-	●	-	-	-	●	-
- 不合适 / not suitable						N	●	-	-	-	●	-	●	-	●	-
■ 非涂层 / uncoated grades						S	○	-	-	-	●	-	○	-	●	-
■ 涂层 / coated grades						H	-	-	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet																

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

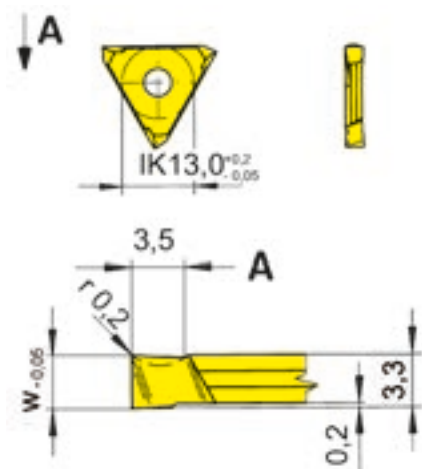
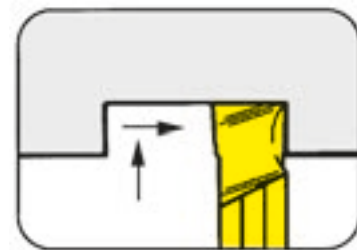
可转位刀片
Indexable insert

312

切深可达

Depth of cut up to

3,5 mm



L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

配合刀杆

for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度

±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	尺寸规格 Size		EG52	P20	TC92	TN32
R/L312.3031.33	3.29	03		▲/▲	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•
● 推荐 / recommended				M	o	-	-
o 次推荐 / alternative recommendation				K	o	-	-
- 不合适 / not suitable				N	-	-	-
■ 非涂层 / uncoated grades				S	-	-	-
■ 涂层 / coated grades				H	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet							

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

特殊的刀尖几何结构在径向和轴向右侧切槽时都有一个正切削角。

The special cutting geometry permits a positive chip breaking angle when keeping a straight and right angled cutting edge.

硬质合金牌号

Carbide grades

切退刀槽 (外圆)

Grooving Corner Reliefs (external)



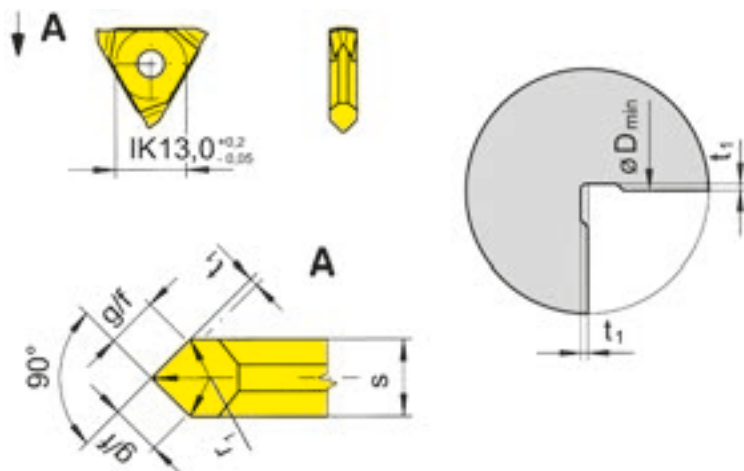
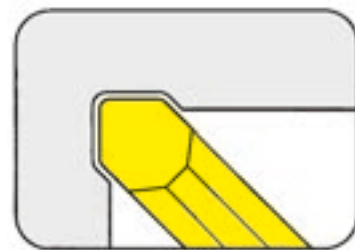
可转位刀片

Indexable insert

312

带圆形断屑槽
with round chip breaker

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



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度
 $\pm 0.02 \text{ mm}$
Indexability length $\pm 0,02 \text{ mm}$

产品型号 Part number	$D_{\min}$	t_1	s	g/f	r_1	尺寸规格 Size		AS62	EG52	P20	TC92
312.0602.24	19	0.2	2.4	1.7	0.6	02		▲	▲	▲	▲
312.0603.33	23	0.3	3.3	2.3	0.6	03			▲	▲	
312.1002.30	20	0.2	3.0	2.1	1.0	03			△	▲	
312.1004.50	29	0.4	5.0	3.6	1.0	04			▲	▲	
312.1603.50	25	0.3	5.0	3.6	1.6	04			△	△	
							P	•	•	•	•
							M	-	o	-	-
							K	-	-	-	-
							N	-	-	-	-
							S	-	-	-	-
							H	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切退刀槽 (外圆)

Grooving Corner Reliefs (external)



可转位刀片

Indexable insert

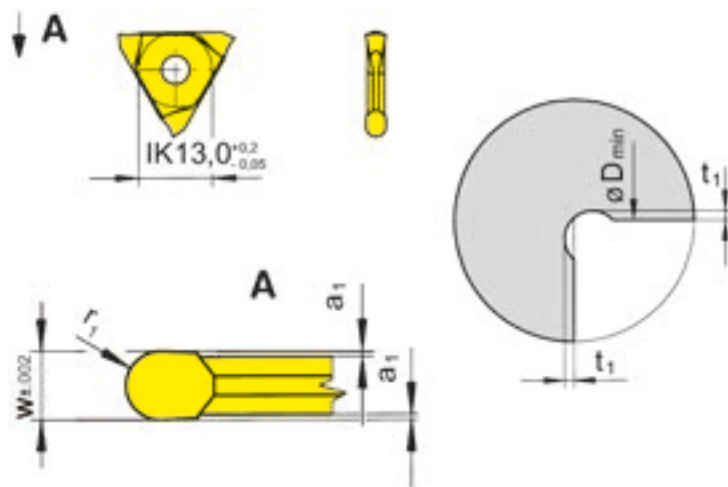
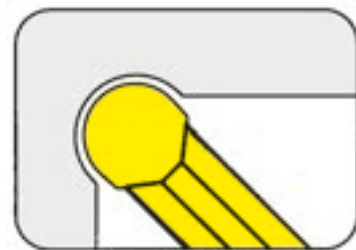
312

带圆形断屑槽
with round chip breaker

圆头

Full radius

1-2.5 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65

刀片长度重复定位精度
±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	a ₁	r ₁	D _{min}	t ₁	尺寸规格 Size		K10	EG52	P20	TC92	TF45	TN32	TN35
312.0010.20	2	0.2	1.0	22	0.7	02		▲	▲	▲	▲	Δ	▲	▲
312.0015.30	3	0.2	1.5	27	1.0	03		▲	▲	▲	▲		▲	
312.0020.40	4	0.2	2.0	30	1.2	04		▲	▲	▲	▲		▲	
312.0025.50	5	0.2	2.5	35	1.5	04		Δ	▲	▲	Δ		▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request								P	•	•	•	•	•	•
● 推荐 / recommended								M	○	○	-	-	•	•
○ 次推荐 / alternative recommendation								K	•	○	-	-	•	•
- 不合适 / not suitable								N	•	-	-	-	•	•
■ 非涂层 / uncoated grades								S	○	-	-	-	•	•
■ 涂层 / coated grades								H	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet														

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和仿形加工 (圆头)

Grooving and Profiling (Full radius)



可转位刀片

Indexable insert

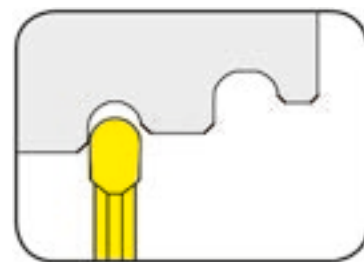
312

带圆形断屑槽
with round chip breaker

槽深可达
圆头

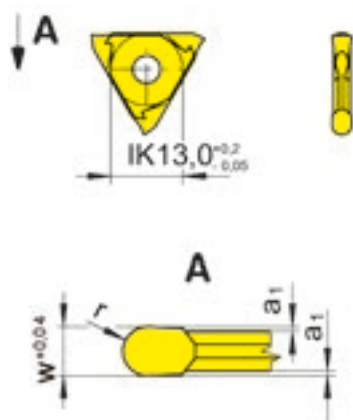
Depth of groove up to
Full radius

6 mm
0.25-2 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



刀片长度重复定位精度
±0.02 mm

Indexability length ± 0,02 mm

产品型号 Part number	w	a ₁	r	尺寸规格 Size	AS45	EG35	EG55	P20	TF45	TH35	TI25	TN32	TN35
312.0050.02	0.5	0.07	0.25	01	▲	▲		▲				▲	
312.0100.05	1.0	0.09	0.50	01	▲	▲		▲		Δ		▲	Δ
312.0110.05	1.1	0.09	0.55	01	▲		Δ						
312.0120.06	1.2	0.20	0.60	01	▲		▲	▲				▲	
312.0140.07	1.4	0.20	0.70	01	▲		▲						
312.0160.08	1.6	0.25	0.80	01	▲		▲	▲				▲	
312.0180.09	1.8	0.25	0.90	01	▲		▲						
312.0200.10	2.0	0.25	1.00	01	▲		▲	▲	Δ		Δ	▲	
312.0220.11	2.2	0.25	1.10	02	▲		▲						
312.0250.12	2.5	0.25	1.25	02	▲		Δ	▲				▲	
312.0280.14	2.8	0.25	1.40	02	▲		Δ						
312.0300.15	3.0	0.25	1.50	02	▲		▲	▲				▲	
312.0360.18	3.6	0.25	1.80	03	▲		Δ						
312.0400.20	4.0	0.25	2.00	03	▲		▲	▲				▲	
312.0400.20	4.0	0.25	2.00	03	▲		Δ	▲				▲	
					P	•	•	•	•	•	•	•	•
					M	•	•	•	•	•	•	•	•
					K	•	•	•	•	•	•	•	•
					N	•	•	•	•	•	•	•	•
					S	•	•	•	•	•	•	•	•
					H	-	-	-	-	-	-	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

按需提供更多尺寸

Further radii upon request

尺寸单位 : mm

Dimensions in mm

硬质合金牌号

Carbide grades

注意事项 :

切宽1.6mm以上只推荐用于切槽

Note:

Width of groove up to 1.6 mm recommend only for grooving

此可转位刀片可用于右手和左手型刀杆

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

切槽 (外圆)

Grooving (external)

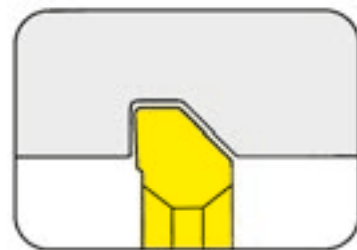
可转位刀片

Indexable insert

312

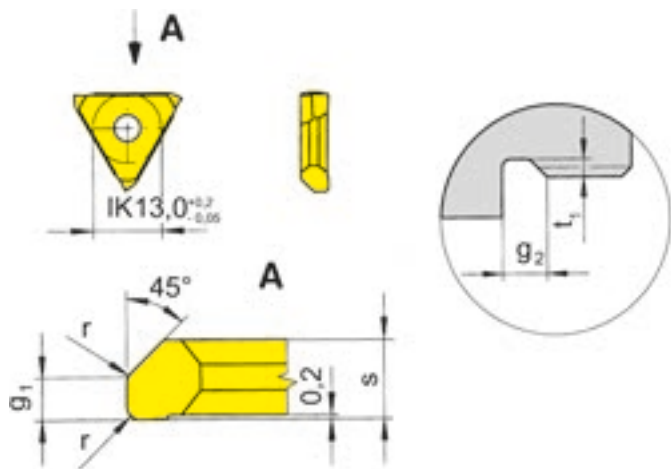
带圆形断屑槽
with round chip breaker

DIN76短型螺纹退刀槽
Thread relief DIN 76 „Short form“



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	P	r	t ₁	s	g ₁	g ₂	尺寸规格 Size	EG55	P20	TN35
R/L312.1050.17	0.50	0.2	0.40	1.7	0.60	1.0	01	▲/△	△/△	▲/△
R/L312.1060.17	0.60	0.4	0.50	1.7	0.70	1.2	01	△/△	△/△	△/△
R/L312.1070.17	0.70	0.4	0.55	1.7	0.85	1.4	01	△/△	△/△	△/△
R/L312.1080.27	0.80	0.4	0.65	2.7	0.95	1.6	02	▲/△	△/△	▲/▲
R/L312.1100.27	1.00	0.6	0.80	2.7	1.20	2.0	02	▲/△	△/△	▲/△
R/L312.1125.27	1.25	0.6	1.00	2.7	1.50	2.5	02	▲/△	△/△	▲/▲
R/L312.1150.37	1.50	0.8	1.15	3.7	1.85	3.0	03	▲/△	△/△	▲/△
R/L312.1175.37	1.75	1.0	1.30	3.7	2.20	3.5	03	△/△	△/△	△/△
R/L312.1200.53	2.00	1.0	1.50	5.3	2.50	4.0	04	△/△	▲/△	△/△
R/L312.1250.53	2.50	1.2	1.80	5.3	3.20	5.0	04	△/△	△/△	△/△
R/L312.1300.63	3.00	1.6	2.20	6.3	3.80	6.0	04	△/△	△/△	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

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

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

硬质合金牌号
Carbide grades

切槽 (外圆)

Grooving (external)



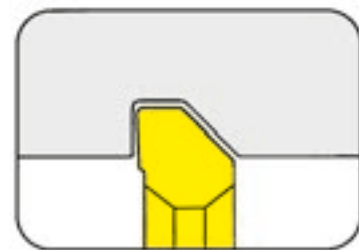
可转位刀片

Indexable insert

312

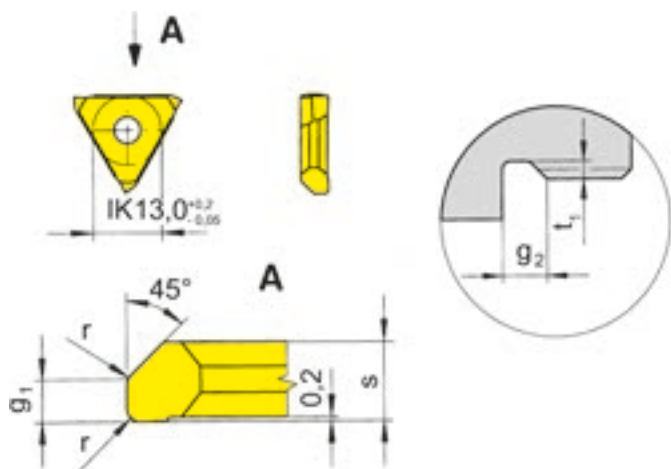
带圆形断屑槽
with round chip breaker

DIN76标准型螺纹退刀槽
Thread relief DIN 76 „Standard form“



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	P	r	t ₁	s	g ₁	g ₂	尺寸规格 Size	EG55	P20	TN35
R/L312.3050.17	0.50	0.2	0.40	1.7	1.10	1.5	01	Δ/Δ	x/Δ	Δ/Δ
R/L312.3060.27	0.60	0.4	0.50	2.7	1.30	1.8	02	▲/▲	Δ/Δ	▲/Δ
R/L312.3070.27	0.70	0.4	0.55	2.7	1.55	2.1	02	Δ/Δ	Δ/Δ	Δ/Δ
R/L312.3080.27	0.80	0.4	0.65	2.7	1.75	2.4	02	Δ/Δ	Δ/Δ	Δ/Δ
R/L312.3100.37	1.00	0.6	0.80	3.7	2.20	3.0	03	▲/Δ	Δ/Δ	▲/Δ
R/L312.3125.53	1.25	0.6	1.00	5.3	2.80	3.8	04	Δ/Δ	Δ/Δ	Δ/Δ
R/L312.3150.53	1.50	0.8	1.15	5.3	3.35	4.5	04	▲/Δ	Δ/Δ	▲/Δ
R/L312.3175.56	1.75	1.0	1.30	5.6	4.00	5.3	04	Δ/Δ	Δ/Δ	Δ/Δ
R/L312.3200.63	2.00	1.0	1.50	6.3	4.50	6.0	04	Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

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

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

硬质合金牌号
Carbide grades

切槽 (外圆)

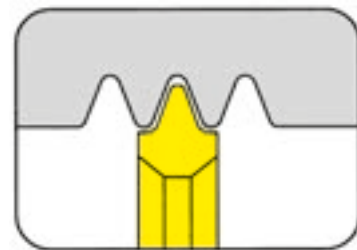
Grooving (external)

可转位刀片

Indexable insert

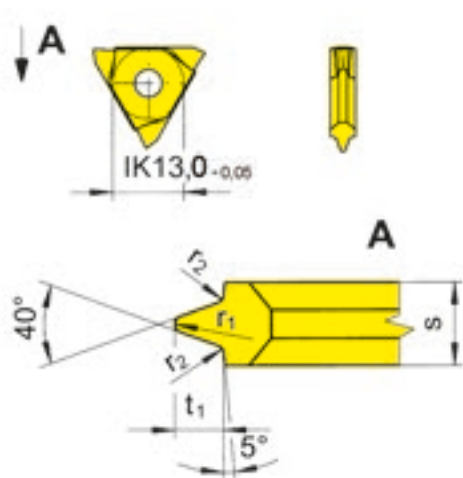
312

J型复合V形皮带轮槽
Poly-V-belt grooves profile „J“



配合刀杆
for Toolholder

型号 ...23 = 340
Type ...30 = 360/369



刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	r ₂	t ₁	s	r ₁	尺寸规格 Size	EG52	P20	TN32
312.0223.23	0.2	2.3	2.34	0.25	02	▲	▲	▲
312.0223.30	0.2	2.3	3.00	0.25	03	▲	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

312.0223.23刀片用于多槽切削 312.0223.30刀片用于单槽切削

Insert 312.0223.23 for multi grooving Insert 312.0223.30 for single grooving

此可转位刀片可用于右手和左手型刀杆

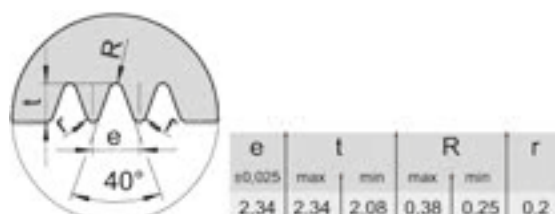
Indexable inserts can be used in right and left hand toolholders.

槽型 :

J型复合V形皮带轮槽

Shape of groove:

Poly-V-belt grooves profile „J“



	P	M	K	N	S	H
EG52	●	○	○	-	-	-
P20	●	-	-	-	-	-
TN32	●	-	-	-	-	-

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

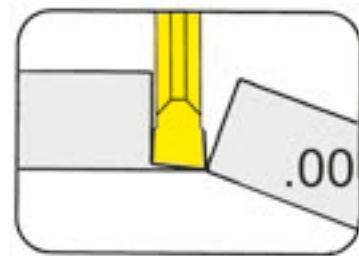
312

带圆形断屑槽
with round chip breaker

槽深可达
槽宽

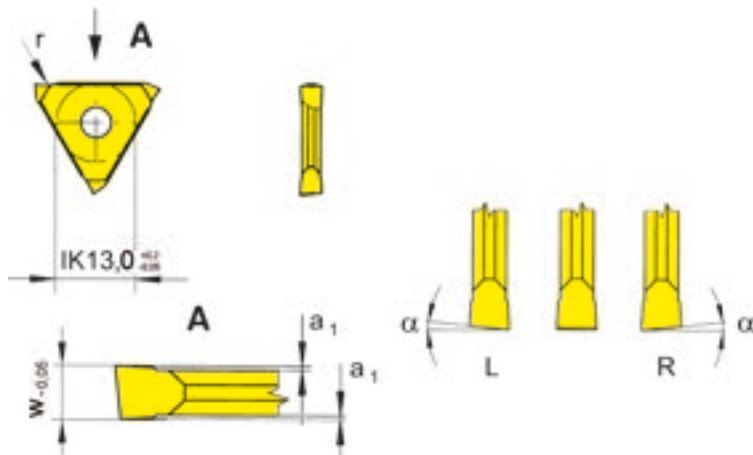
Depth of groove up to
Width of groove

5.00 mm
1.44 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	α	a_1	尺寸规格 Size	EG35	TF45	TF46	Ti25	TN35
R/L312.0614.00	1.44	6°	0.2	01	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	•	•	•	•
● 推荐 / recommended					M	•	•	•	•
o 次推荐 / alternative recommendation					K	•	•	•	•
- 不合适 / not suitable					N	-	•	•	•
■ 非涂层 / uncoated grades					S	-	•	•	•
■ 涂层 / coated grades					H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet									

尺寸单位 : mm
Dimensions in mm

注明R或L型
State R or L version

硬质合金牌号
Carbide grades

外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆，左手型刀片配合左手型刀杆

External machining:

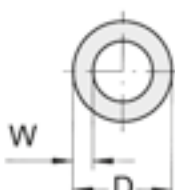
for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

实心棒料切断
parting off solid bars



D 可达 11 mm
D up to 11 mm

空心棒料切断
parting off tubes



D ≥ 50 mm 可达 W ≈ 5 mm
D ≤ 50 mm 可达 W ≈ 4 mm
D ≥ 50 mm up to W ≈ 5 mm
D ≤ 50 mm up to W ≈ 4 mm

切断

Parting Off



可转位刀片

Indexable insert

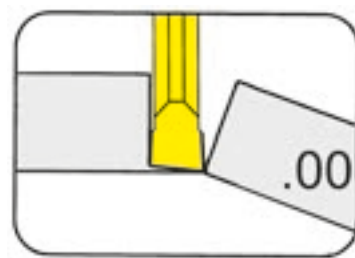
312

带圆形断屑槽
with round chip breaker

槽深可达
槽宽

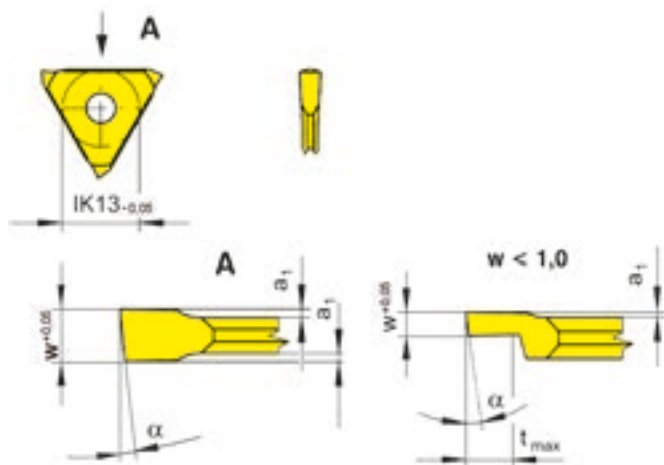
Depth of groove up to
Width of groove

8 mm
0.5-1.5 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
368
390
391
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	W	t _{max}	α	a ₁	尺寸规格 Size
R/L312.0805.00	0.5	1.0	8°	0.1	01
R/L312.0808.00	0.8	1.5	8°	0.1	01
R/L312.0510.00	1.0	8.0	5°	0.1	01
R/L312.1210.00	1.0	8.0	12°	0.1	01
R/L312.0512.00	1.2	8.0	5°	0.2	01
R/L312.0515.00	1.5	8.0	5°	0.2	01

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

	K10	EG35	EG55	H20	P20	TC92	TF45	TF46	TI25	TN32	TN35
R/L312.0805.00	▲/▲	▲/▲					▲/▲				
R/L312.0808.00	▲/▲	▲/▲					▲/▲				
R/L312.0510.00	▲/▲	▲/▲					▲/▲				
R/L312.1210.00	▲/▲	▲/▲					▲/▲		Δ/Δ		▲/▲
R/L312.0512.00	▲/▲	▲/▲					▲/▲				
R/L312.0515.00	▲/x	▲/▲	▲/x	▲/x	▲/x	Δ/x	▲/▲	▲/x		▲/x	
P	●	●	●	●	●	●	●	●	●	●	●
M	o	●	o	o	-	-	●	o	●	-	●
K	●	o	o	-	-	-	●	●	●	-	●
N	●	-	-	-	-	-	●	●	●	-	●
S	o	-	-	-	-	-	●	o	●	-	●
H	-	-	-	-	-	-	-	-	-	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



N

可转位刀片

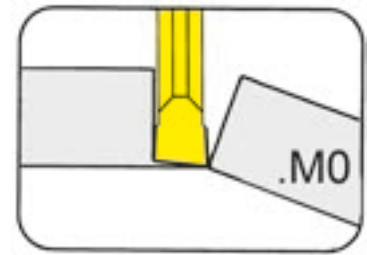
Indexable insert

312

槽深可达
槽宽

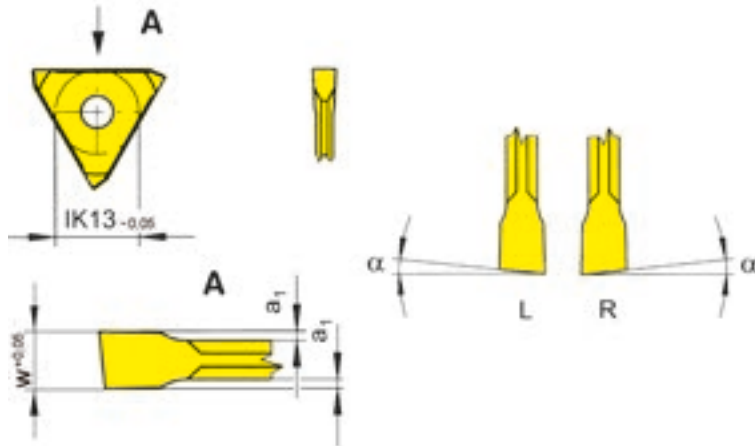
Depth of groove up to
Width of groove

8 mm
1.2-1.5 mm



配合刀杆
for Toolholder

型号 309
Type 360
361
368
390
391
369
330
360C
360TS
N68
65



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	t _{max}	α	a ₁	尺寸规格 Size		K10	EG35	TF45
R/L312.0512.M0	1.2	8	5°	0.2	01		Δ/Δ	▲/▲	▲/▲
R/L312.0515.M0	1.5	8	5°	0.2	01		▲/Δ	▲/▲	▲/▲
							P	•	•
							M	o	•
							K	•	o
							N	•	-
							S	o	-
							H	-	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

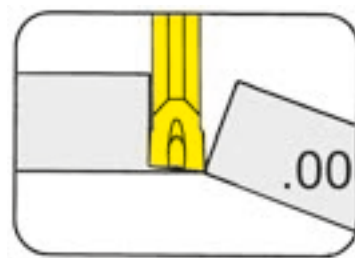
State R or L version

硬质合金牌号
Carbide grades

可转位刀片

Indexable insert

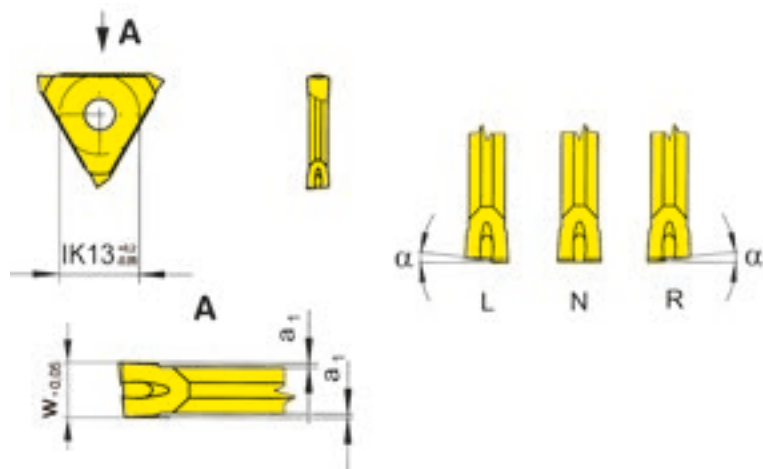
312

带圆形断屑槽
with round chip breaker槽深可达
槽宽Depth of groove up to
Width of groove5 mm
1.44-2.29 mm

配合刀杆

for Toolholder

型号 309
Type 360
361
390
369
330
360C
360TS
N68
65



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	a_1	尺寸规格 Size	MG12	EG55	P20	TC92	TF45	TN32	TN35
N312.0014.00	1.44	0°	0.2	02		▲		△	▲		
N312.0018.00	1.99	0°	0.2	02		▲		△	▲	△	△
N312.0021.00	2.29	0°	0.2	02		▲	△	△			▲
R/L312.0514.00	1.44	5°	0.2	02		△/△	△/△		▲/△		
R/L312.0518.00	1.99	5°	0.2	02		▲/▲	▲/▲	△/△		▲/▲	▲/▲
R/L312.0521.00	2.29	5°	0.2	02	△/△	▲/△	△/△	△/△		▲/▲	▲/▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	o	•	•	•	•	•
● 推荐 / recommended					M	•	o	-	•	-	•
o 次推荐 / alternative recommendation					K	•	o	-	•	-	•
- 不合适 / not suitable					N	•	-	-	•	-	•
■ 非涂层 / uncoated grades					S	•	-	-	•	-	•
■ 涂层 / coated grades					H	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

尺寸单位 : mm

Dimensions in mm

注明R或L型

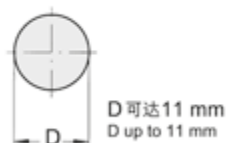
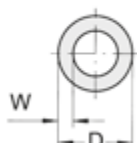
State R or L version

外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:

for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

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

$D \geq 50$ mm 可达 $W \approx 5$ mm
 $D \leq 50$ mm 可达 $W \approx 4$ mm
 $D \geq 50$ mm up to $W \approx 5$ mm
 $D \leq 50$ mm up to $W \approx 4$ mm

硬质合金牌号

Carbide grades

端面切槽

Face Grooving

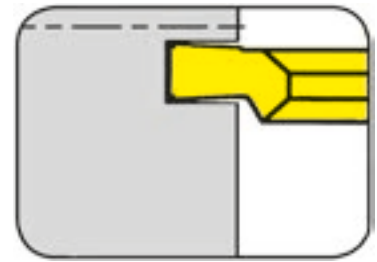


N

可转位刀片

Indexable insert

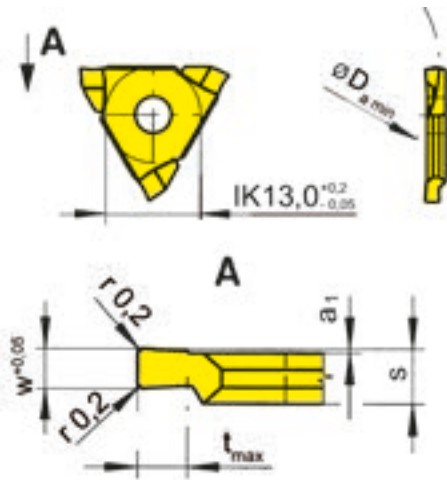
312



端面槽起始外径
槽深可达
槽宽

from outer groove $\varnothing$
Depth of groove up to
Width of groove

20 mm
3 mm
1.5-3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 309
Type 360
361
390
369
360C
360TS
N68
65

刀片长度重复定位精度
 ± 0.02 mm
Indexability length ± 0.02 mm

产品型号 Part number	w	t _{max}	a ₁	s	D _{a min}	尺寸规格 Size	MG12	EG55	TN35
R/L312.2015.02	1.5	2	0.2	2.7	20	02		▲/▲	▲/▲
R/L312.3020.02	2.0	3	0.2	2.7	30	02	x/Δ	▲/▲	▲/▲
R/L312.3030.02	3.0	3	0.2	3.7	30	03		▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

360系列刀杆注意事项

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Note for toolholder type 360

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

369系列刀杆注意事项

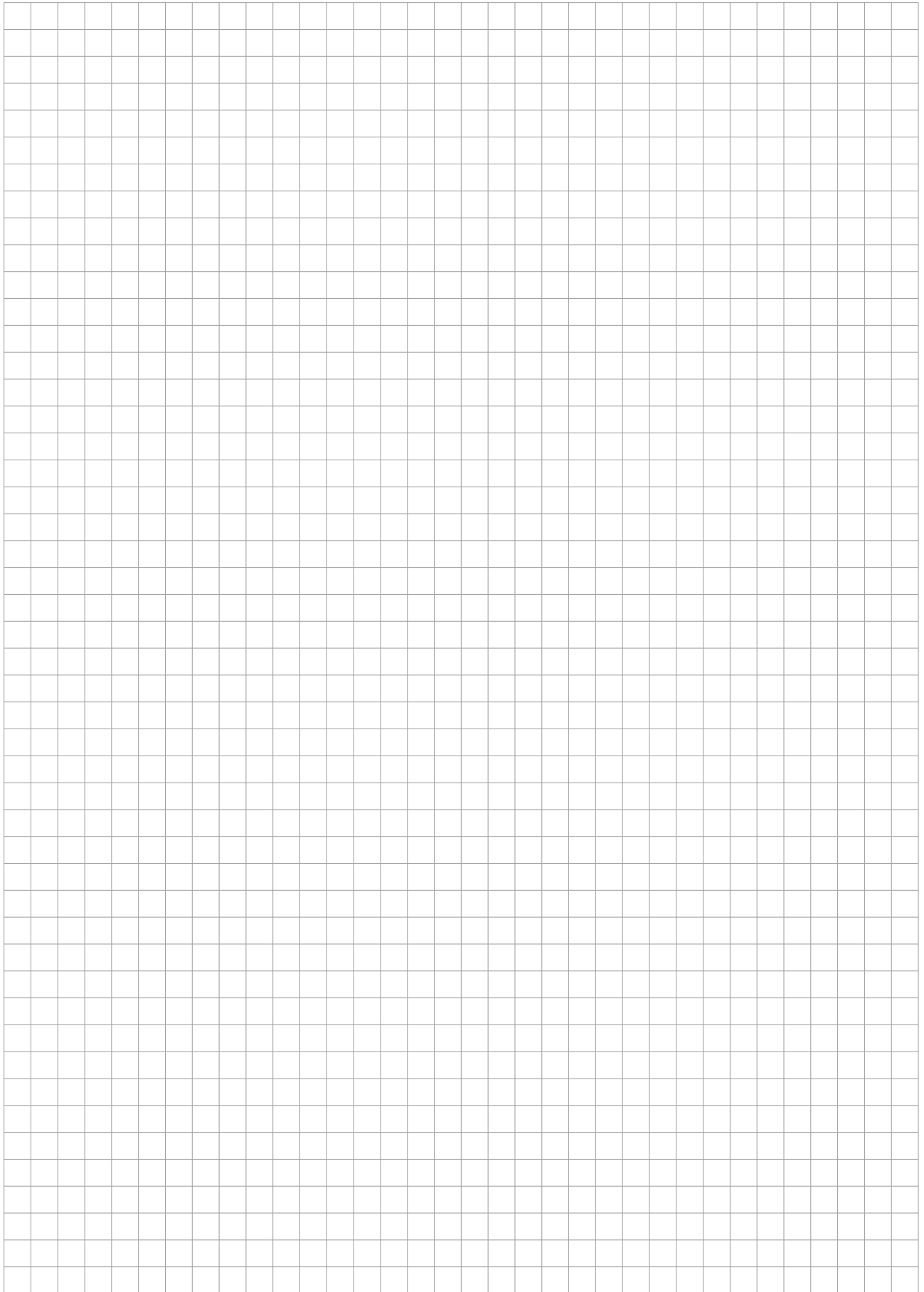
右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

Note for toolholder type 369

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

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

硬质合金牌号
Carbide grades





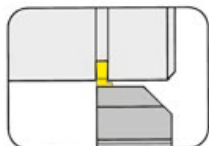
机夹式刀杆

槽宽0.5 - 8 mm

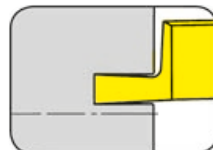
Toolholder with Inserts

Width of groove 0.5 - 8 mm

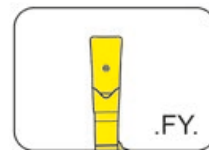
刀杆
Toolholder
356/357/333



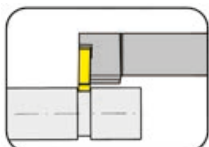
页/Page
O3-O6, O9



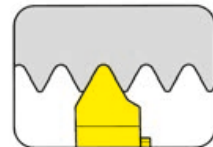
页/Page
O19-O20



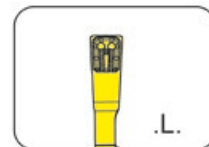
页/Page
O30



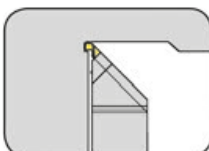
页/Page
O7-O8



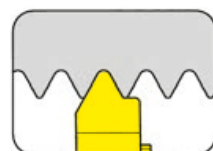
页/Page
O21



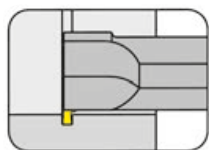
页/Page
O31



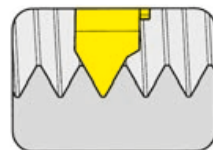
页/Page
O10



页/Page
O22, O25

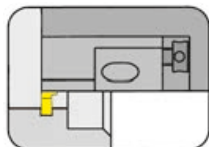


页/Page
O11

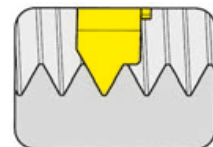


页/Page
O23

刀夹
Cartridge
357

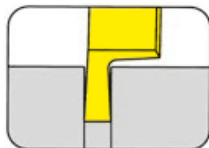


页/Page
O12

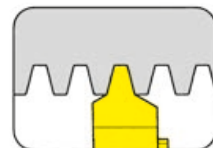


页/Page
O24

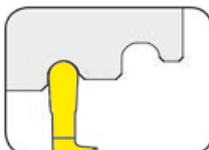
可转位刀片
Indexable insert
315/A315/S315



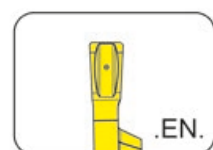
页/Page
O14-O16



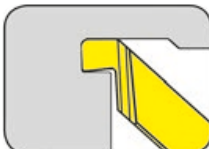
页/Page
O26



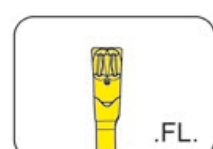
页/Page
O17



页/Page
O28



页/Page
O18



页/Page
O29

切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆

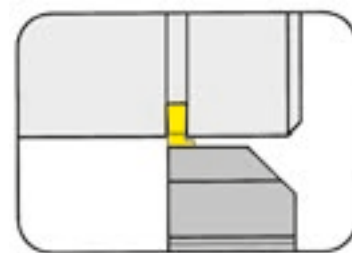
Toolholder

356

槽深可达
槽宽

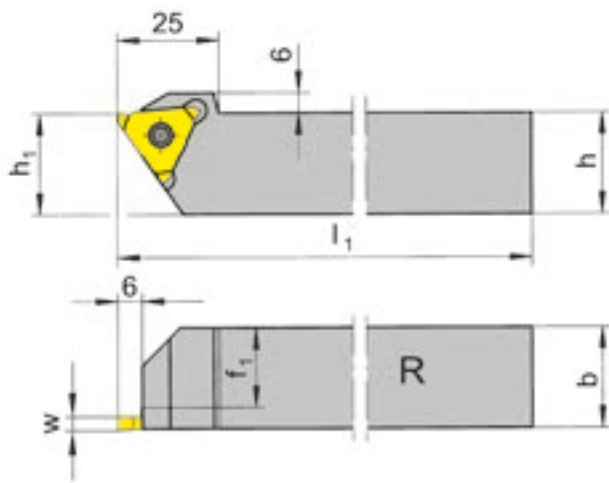
Depth of groove up to
Width of groove

5 mm
0.5-7,3 mm



配合可转位刀片
for Indexable insert

型号 315
Type LA315
RA315



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	尺寸规格 Size
R/L356.1616.03	16	16	125	20	13.0	03
R/L356.2020.03	20	20	125	20	17.0	03
R/L356.2525.03	25	25	150	25	22.0	03
R/L356.3232.03	32	32	170	32	29.0	03
R/L356.1616.05	16	16	125	20	10.8	05
R/L356.2020.05	20	20	125	20	14.8	05
R/L356.2525.05	25	25	150	25	19.8	05
R/L356.3232.05	32	32	170	32	26.8	05
R/L356.2020.07	20	20	125	20	13.0	07
R/L356.2525.07	25	25	150	25	18.0	07
R/L356.3232.07	32	32	170	32	25.0	07

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5.12T20P	T20PQ

切槽和切断

Grooving and Parting Off



刀杆

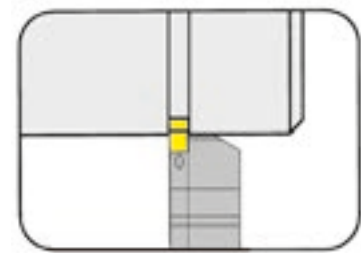
Toolholder

356

槽深可达
槽宽

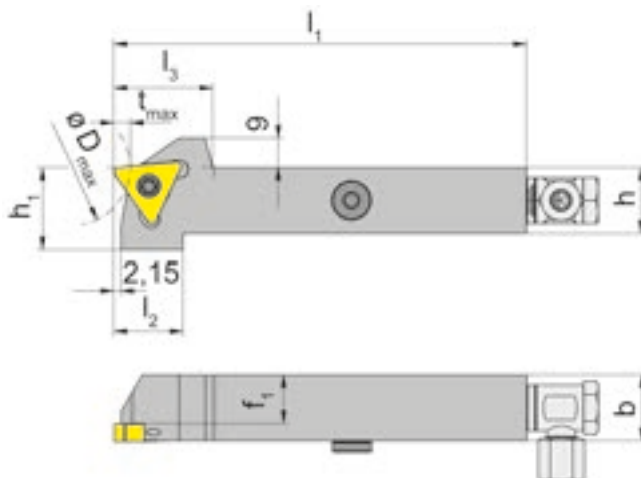
Depth of groove up to
Width of groove

5 mm
0.5-5,3 mm



配合可转位刀片
for Indexable insert

型号 315
Type A315



槽深与外径 $\varnothing$ 的对应关系
Depth of groove in relation to outer- $\varnothing$

D _{max}	t _{max}
30	5,0
40	4,5
60	4,0
115	3,5
185	3,0

带集成内冷
with integrated through
coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	尺寸规格 Size
R/L356.1616.0.13.IK	16	16	125	22	28	21	13.0	03
R/L356.2020.0.13.IK	20	20	125	21	30	25	17.0	03
R/L356.2525.0.13.IK	25	25	150	21	30	30	22.0	03
R/L356.1616.0.15.IK	16	16	125	22	28	21	10.8	05
R/L356.2020.0.15.IK	20	20	125	21	30	25	14.8	05
R/L356.2525.0.15.IK	25	25	150	21	30	30	19.8	05

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	密封塞 Sealing plug	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5.12T20P	004.00.26	SBD 6 LR - G1/8"	T20PQ

切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆

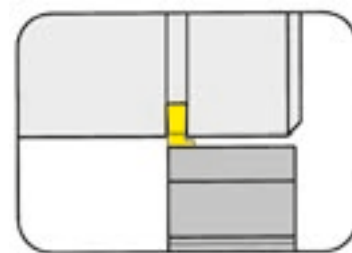
Toolholder

356

槽深可达
槽宽

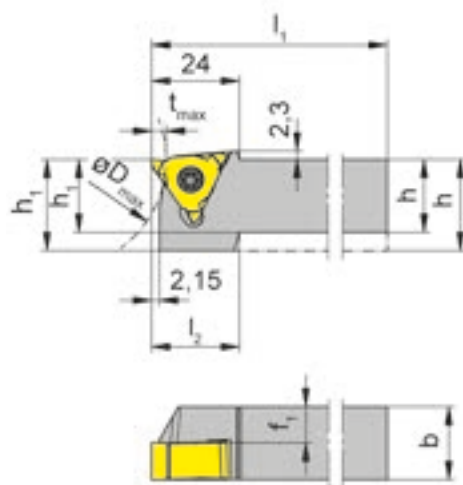
Depth of groove up to
Width of groove

5 mm
0.5-10.3 mm



配合可转位刀片
for Indexable insert

型号 315
Type A315



槽深与外径Ø的对应关系
Depth of groove in relation to outer-Ø

D _{max}	t _{max}
30	5,0
40	4,5
60	4,0
115	3,5
185	3,0

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	尺寸规格 Size
R/L356.1616.13	16	16	125	21	20	13.0	03
R/L356.2020.13	20	20	125	-	20	17.1	03
R/L356.2525.13	25	25	150	-	25	22.1	03
R/L356.1616.15	16	16	125	21	20	10.8	05
R/L356.2020.15	20	20	125	21	20	14.8	05
R/L356.2525.15	25	25	150	-	25	19.8	05
R/L356.1616.16	16	16	125	-	20	10.0	06
R/L356.2020.16	20	20	125	21	25	14.0	06
R/L356.2525.16	25	25	150	-	25	19.0	06
R/L356.2020.17	20	20	125	21	25	13.0	07
R/L356.2525.17	25	25	150	-	25	18.1	07
R/L356.2020.10	20	20	125	21	25	10.0	10

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...13/15/16.	5.12T20P	T20PQ
R/L356....10/17	5.15T20P	T20PQ

切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆

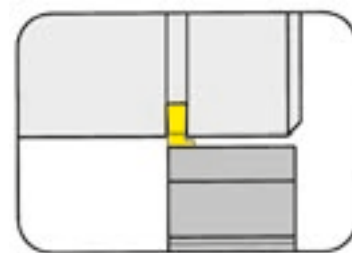
Toolholder

356

槽深可达
槽宽

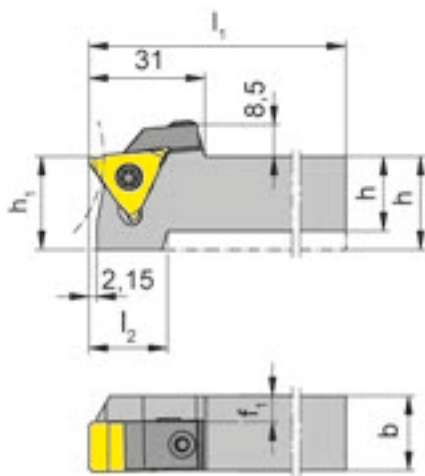
Depth of groove up to
Width of groove

5 mm
10.3-13,3 mm



配合可转位刀片
for Indexable insert

型号 315
Type A315



槽深与外径 $\varnothing$ 的对应关系
Depth of groove in relation to outer- $\varnothing$

D _{max}	t _{max}
30	5,0
40	4,5
60	4,0
115	3,5
185	3,0

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	尺寸规格 Size
R/L356.2020.2.13	20	20	125	21	25	7	13
R/L356.2525.2.13	25	25	150	-	25	12	13

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356.2020.2.13	5.12T20P	010.2013.0468	T20PQ
R/L356.2525.2.13	5.15T20P	010.2013.0468	T20PQ

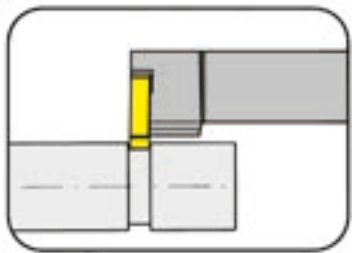
切槽和螺纹切削 (外圆)

Grooving and Threading (external)

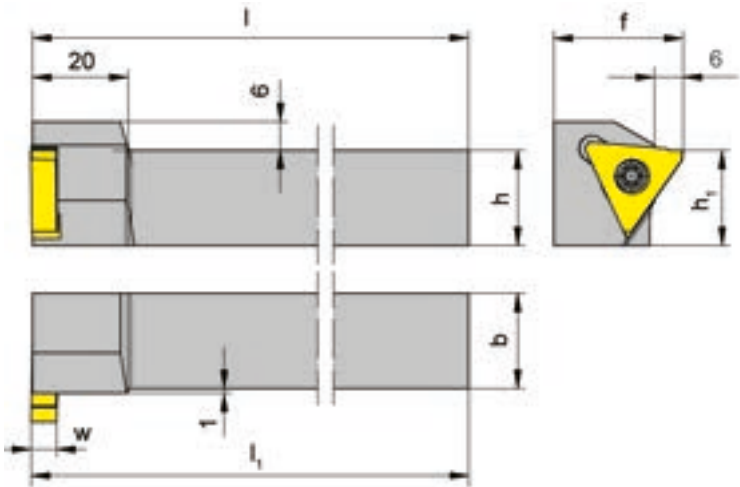


刀杆
Toolholder

357



槽深可达	Depth of groove up to	5 mm
槽宽	Width of groove	0.5-5,3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 315
Type A315

产品型号 Part number	h	b	l ₁	l	h ₁	f	尺寸规格 Size
R/L357.2020.05	20	20	125.3	125	20	27	05
R/L357.2525.05	25	25	150.3	150	25	32	05

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L357...	5.12T20P	T20PQ

切槽和螺纹切削 (外圆)

Grooving and Threading (external)



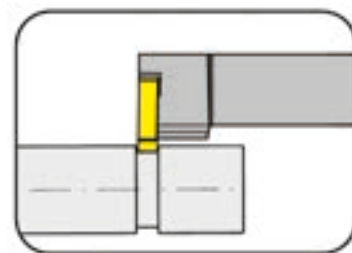
刀杆 Toolholder

357

槽深可达
槽宽

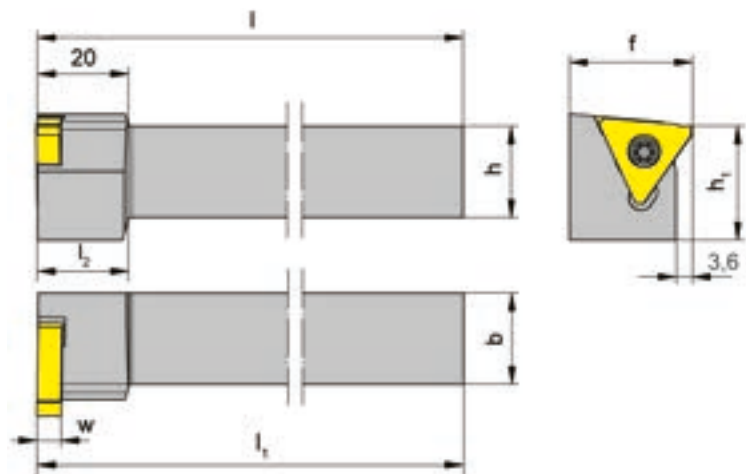
Depth of groove up to
Width of groove

5 mm
0.5-5,3 mm



配合可转位刀片
for Indexable insert

型号 315
Type A315



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l	l_2	h_1	f	尺寸规格 Size
R/L357.2020.15	20	20	125.3	125	20	25	27	05
R/L357.2525.15	25	25	150.3	150	-	25	32	05

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

订货须知 :
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L357...	5.12T20P	T20PQ

切槽 (外圆)

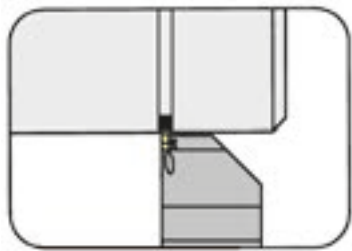
Grooving (external)



刀杆
Toolholder

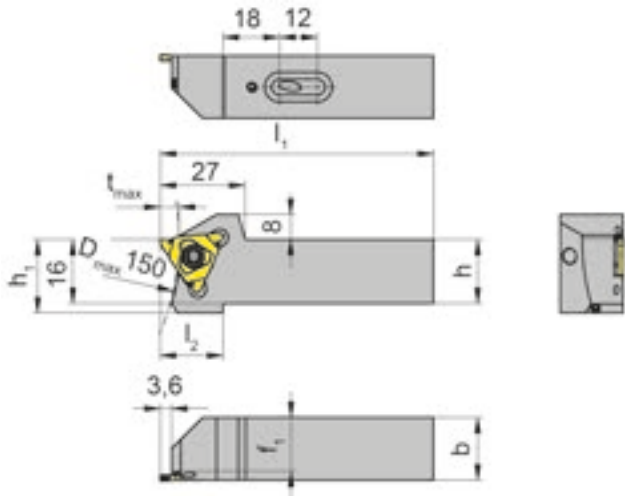
356

槽深可达 槽宽	Depth of groove up to Width of groove	6 mm 1,1-2 mm



配合可转位刀片
for Indexable insert

型号 S315
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	t _{max}	尺寸规格 Size
R/L356.1616.S.4.03.IK	16	16	74	20	23	13.2	6	03
R/L356.2020.S.4.03.IK	20	20	87	20	23	17.2	6	03
R/L356.2525.S.4.03.IK	25	25	104	20	28	22.2	6	03

注明R或L型
State R or L version

尺寸单位：mm
Dimensions in mm

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆
Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5.12T20P	T20PQ

切退刀槽 (外圆)

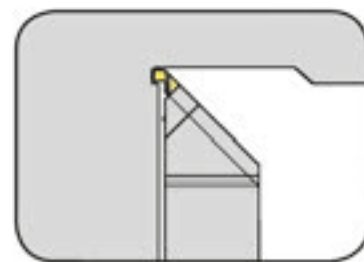
Grooving Corner Reliefs (external)



刀杆
Toolholder

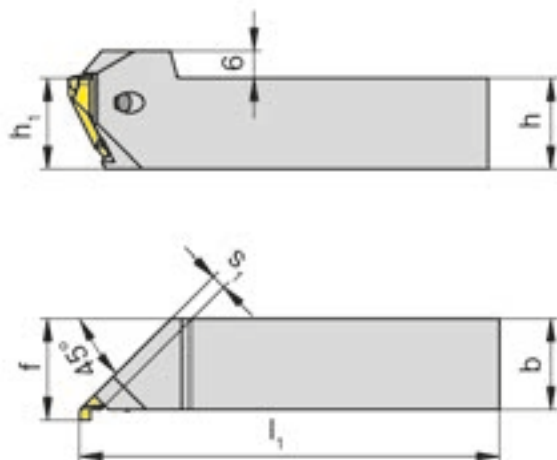
356

退刀槽(45°)
Corner reliefs (45°)



配合可转位刀片
for Indexable insert

型号 LA315...R
Type RA315...L



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	s ₁	尺寸规格 Size
R/L356.2020.45.03	20	20	125	20	22.3	3.25	03
R/L356.2525.45.03	25	25	150	25	27.3	3.25	03

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

右手型刀片配合左手型刀杆, 左手型刀片配合右手型刀杆

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5F.08T20P	T20PQ

切槽和螺纹切削 (内圆)

Grooving/Threading (internal)



刀杆

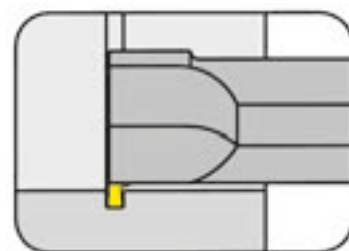
Toolholder

333

孔径Ø 自
槽宽

Bore Ø from
Width of groove

43 mm
0.5-5,3 mm

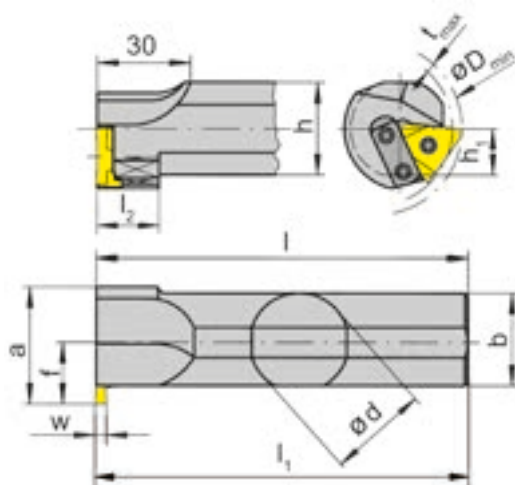


配合可转位刀片
for Indexable insert

型号 315
Type A315

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

D _{min}	t _{max}
43	1,8
46	2,0
50	3,0
60	4,0
80	4,5
100	5,0



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l	l ₁	l ₂	h	a	h ₁	f	D _{min}	b	尺寸规格 Size
R/L333.0025.03	25	170	170.3	20	23	38	11.5	20	43	25	03
R/L333.0032.03	32	200	200.3	20	30	38	15.0	20	43	30	03
R/L333.0025.05	25	170	170.3	20	23	38	11.5	20	43	25	05
R/L333.0032.05	32	200	200.3	20	30	38	15.0	20	43	30	05
R/L333.0040.05	40	250	250.3	-	38	44	19.0	24	45	38	05

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆
Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	导向块 Attachment Bar	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L333...	020.7000.0193	5.12T20P	T20PQ

切槽和螺纹切削 (内圆)

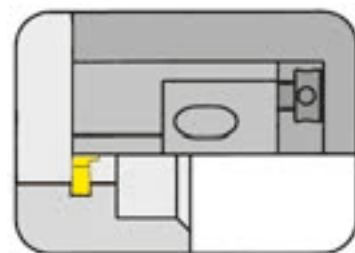
Grooving/Threading (internal)



刀夹

Cartridge

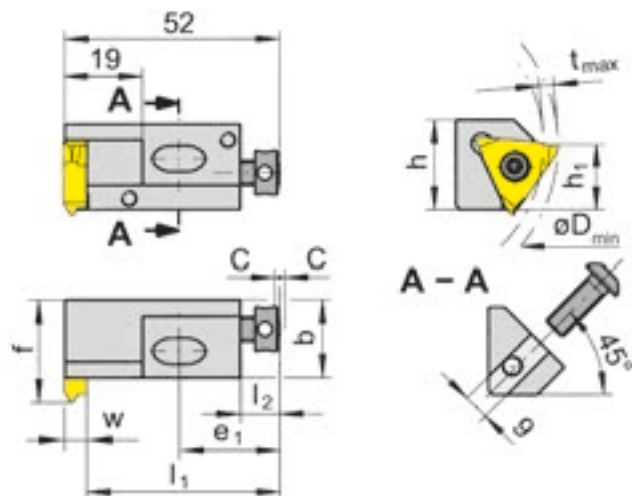
357



孔径Ø 自
槽宽

Bore Ø from
Width of groove

50 mm
0.5-5,3 mm



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

配合可转位刀片
for Indexable insert

型号 315
Type

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

D _{min}	t _{max}
50	3,0
60	4,0
80	4,5
100	5,0

产品型号 Part number	h	b	h ₁	f	l ₁	E ₁	l ₂	C	尺寸规格 Size
R/L357.1619.05	21	19	16	25	46.8	24	9	2	05

注明R或L型

State R or L version

基座尺寸见下一页

Dimensions of seating see following page

订货须知：

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L357...	4.08.913	6.12.020	T20PQ

切槽 (内圆)

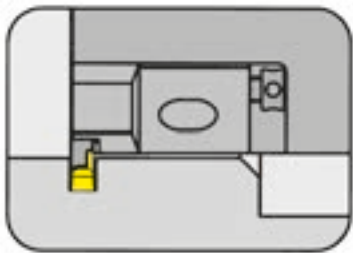
Grooving (internal)



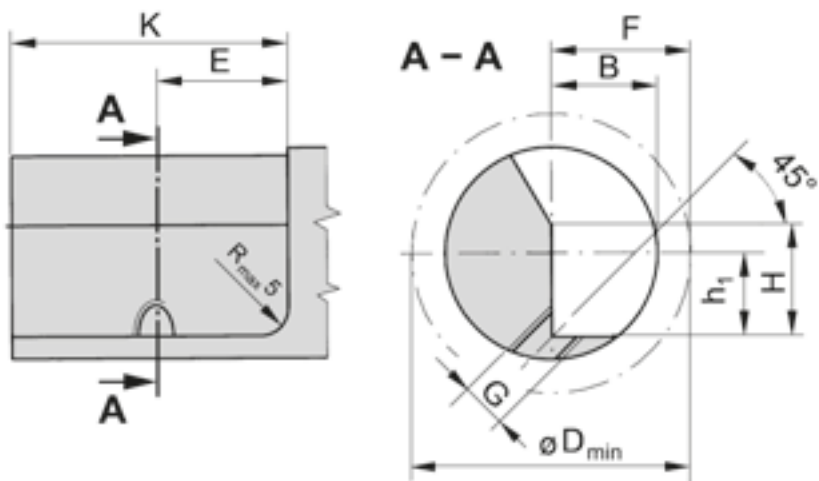
外形尺寸 刀夹 型号

Seating Dimensions Cartridge

357



O



刀夹 Cartridge	F	G	H	K	E	B	h ₁	D _{min}	紧固螺钉 Fastening screw
357.1619.05	25	M8	21	50	24	19	16	50	8.25.351

尺寸单位 : mm
Dimensions in mm

切槽 (外圆)

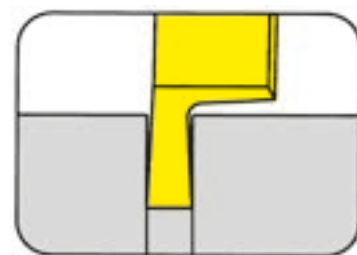
Grooving (external)



可转位刀片

Indexable insert

315



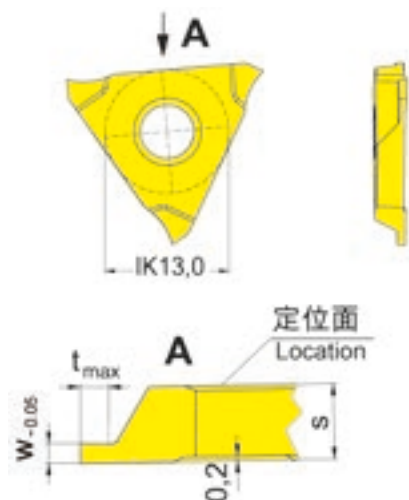
卡簧槽
卡簧宽度Nw

Circlip grooves
Width of circlip Nw

DIN471/472
0.5-1 mm

配合刀杆
for Toolholder

型号 356...03
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	Nw	t _{max}	s	尺寸规格 Size	TN32
R/L315.0050.32.00	0.57	0.5	0.7	3.2	03	▲/△
R/L315.0060.32.00	0.67	0.6	0.8	3.2	03	△/△
R/L315.0070.32.00	0.77	0.7	1.1	3.2	03	▲/△
R/L315.0080.32.00	0.87	0.8	1.2	3.2	03	▲/△
R/L315.0090.32.00	0.97	0.9	1.4	3.2	03	△/△
R/L315.0100.32.00	1.07	1.0	1.6	3.2	03	▲/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

P	●
M	-
K	-
N	-
S	-
H	-

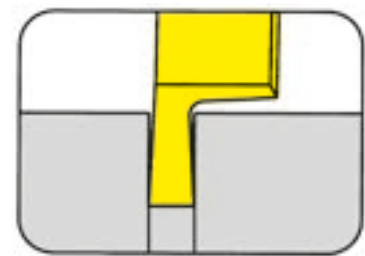
硬质合金牌号
Carbide grades

切槽 (内圆和外圆) Grooving (external and internal)



可转位刀片 Indexable insert

315

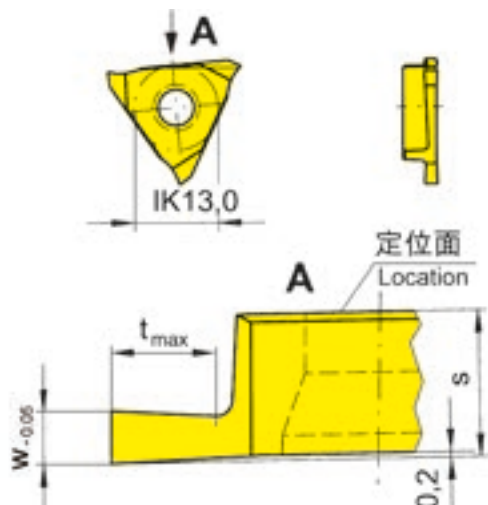


O

卡簧槽
卡簧宽度Nw

Circlip grooves
Width of circlip Nw

DIN471/472
1.1-5.15 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 356
Type 357
333

产品型号 Part number	w	Nw	t _{max}	s	尺寸规格 Size	AL96	AS42	AS46	TC92	TF45	TN35
R/L315.0110.00	1.24	1.10	2	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	▲/▲
R/L315.0130.00	1.44	1.30	2	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/▲	▲/▲
R/L315.0160.00	1.74	1.60	3	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/▲
R/L315.0185.00	1.99	1.85	3	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/▲
R/L315.0215.00	2.29	2.15	4	5.4	05	Δ/Δ	▲/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/▲
R/L315.0265.00	2.79	2.65	4	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/▲
R/L315.0315.00	3.29	3.15	5	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	▲/▲
R/L315.0415.00	4.29	4.15	5	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	▲/▲
R/L315.0515.00	5.29	5.15	5	5.4	05	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工 :

左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。

Internal machining:

Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.

	AL96	AS42	AS46	TC92	TF45	TN35
P	●	●	o	●	●	●
M	-	●	o	-	●	●
K	●	●	●	-	●	●
N	●	●	o	-	●	●
S	-	●	o	-	●	●
H	-	-	-	-	-	-

可转位刀片

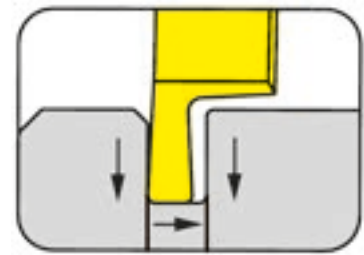
Indexable insert

315

槽深可达
槽宽

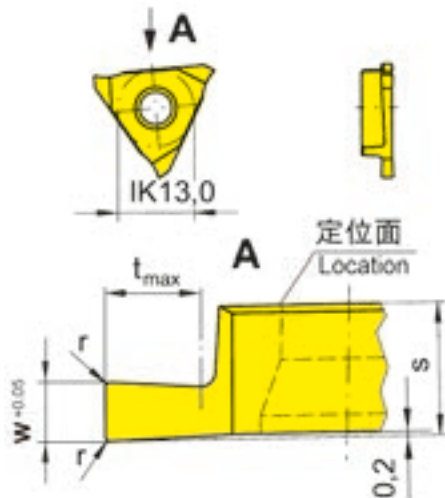
Depth of groove up to
Width of groove

5 mm
2-8 mm



配合刀杆
for Toolholder

型号 356
Type 357
333



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
 $\pm 0.02 \text{ mm}$
Indexability length $\pm 0.02 \text{ mm}$

产品型号 Part number	W	r	t _{max}	S	尺寸规格 Size	AL96	AS42	AS45	AS46	TC92	TF45	TN35
R/L315.0200.02	2	0.2	3	5.4	05	△/△	▲/▲		△/△	△/△	△/△	▲/▲
R/L315.0200.04	2	0.4	3	5.4	05	△/△	△/△		△/△	△/△	△/△	▲/△
R/L315.0300.02	3	0.2	4	5.4	05	△/△	▲/△		△/△	△/△	△/△	▲/▲
R/L315.0300.04	3	0.4	4	5.4	05	△/△	△/△		△/△	△/△	△/△	▲/▲
R/L315.0400.02	4	0.2	5	5.4	05		△/△		△/△			△/▲
R/L315.0400.04	4	0.4	5	5.4	05		△/△		△/△			▲/▲
R/L315.0500.02	5	0.2	5	5.4	05			△/△				
R/L315.0600.04	6	0.4	5	6.4	06			△/▲				
R/L315.0800.04	8	0.4	5	8.4	07			△/△				

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位: mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工:

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工:

左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。

Internal machining:

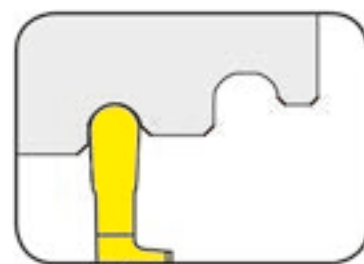
Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.

ph HORN ph

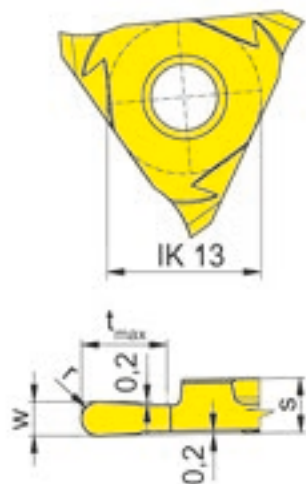
315
帶圓形斷屑槽
with round chip breaker

Depth of groove up to
Full radius

5 mm
0.5-2 mm



型号	356
Type	333
	357



L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0.02 mm

Width of groove up to 1,6 mm recommend only for grooving

P	•
M	•
K	•
N	o
S	•
H	-

端面切槽

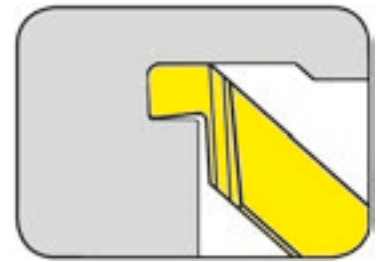
Face Grooving



可转位刀片

Indexable insert

A315



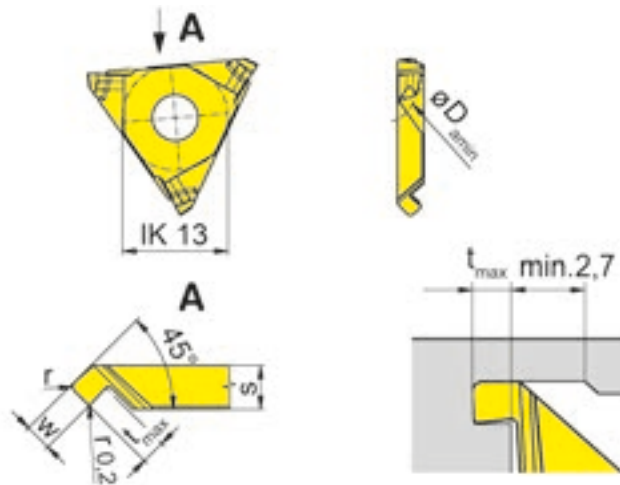
端面槽起始外径
槽深可达
槽宽

from outer groove $\varnothing$
Depth of groove up to
Width of groove

8 mm
2 mm
1.5-2.4 mm

配合刀杆
for Toolholder

型号 R/L356...45.03
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

刀片长度重复定位精度
 ± 0.02 mm
Indexability length ± 0.02 mm

产品型号 Part number	w	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35	TN35
LA315.0815.45.04R	1.5	0.4	1.6	8	3.25	03	▲	▲
RA315.0815.45.04L	1.5	0.4	1.6	8	3.25	03	▲	▲
LA315.1220.45.05R	2.0	0.5	1.8	12	3.25	03	▲	▲
RA315.1220.45.05L	2.0	0.5	1.8	12	3.25	03	▲	▲
LA315.2024.45.06R	2.4	0.6	2.0	20	3.25	03	▲	▲
RA315.2024.45.06L	2.4	0.6	2.0	20	3.25	03	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	•
● 推荐 / recommended							M	•
o 次推荐 / alternative recommendation							K	•
- 不合适 / not suitable							N	•
■ 非涂层 / uncoated grades							S	•
■ 涂层 / coated grades							H	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

尺寸单位 : mm
Dimensions in mm

右手型刀片配合左手型刀杆, 左手型刀片配合右手型刀杆

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

在轴向加工前必须先完成退刀槽。

The undercut must be placed BEFORE the axial machining!

硬质合金牌号
Carbide grades

端面切槽

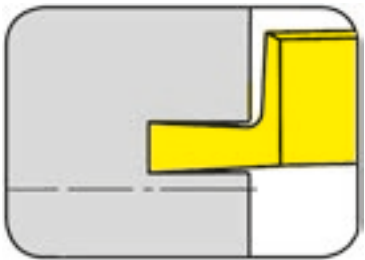
Face Grooving



可转位刀片

Indexable insert

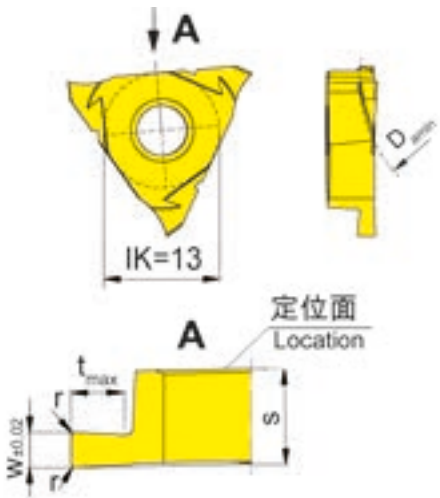
A315



槽深可达 槽宽	Depth of groove up to Width of groove	3 mm 1.5-3 mm

配合刀杆
for Toolholder

型号 357
Type 356...03-07



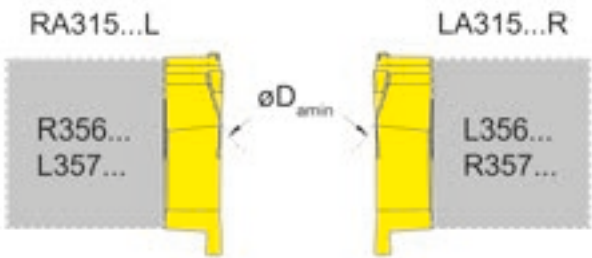
R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35	TN35
R/LA315.2015.02R	1.5	0.2	2	20	5.4	05	Δ/▲	
R/LA315.3020.02R	2.0	0.2	3	30	5.4	05	▲/▲	x/Δ
R/LA315.3030.02R	3.0	0.2	3	30	5.4	05	Δ/▲	
RA315.2015.02L	1.5	0.2	2	20	5.4	05	▲	
RA315.3020.02L	2.0	0.2	3	30	5.4	05	▲	
RA315.3030.02L	3.0	0.2	3	30	5.4	05	▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	•
● 推荐 / recommended							M	•
o 次推荐 / alternative recommendation							K	•
- 不合适 / not suitable							N	•
■ 非涂层 / uncoated grades							S	•
■ 涂层 / coated grades							H	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

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

硬质合金牌号
Carbide grades



端面切槽

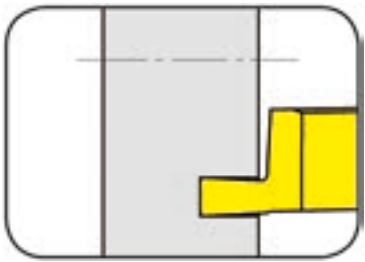
Face Grooving



可转位刀片

Indexable insert

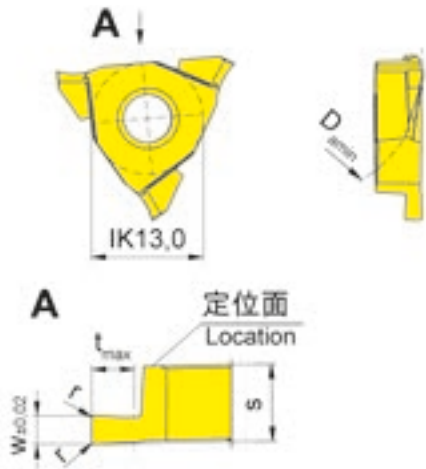
A315



端面槽起始外径	from outer groove Ø	30 mm
槽深可达	Depth of groove up to	3 mm
槽宽	Width of groove	1.5-3 mm

配合刀杆
for Toolholder

型号 356
Type 357



R=右手型-如图
R = right hand version shown

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0.02 mm

产品型号 Part number	w	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35	TN35
R/LA315.2015.02R	1.5	0.2	2	20	5.4	05	Δ/▲	
R/LA315.3020.02R	2.0	0.2	3	30	5.4	05	▲/▲	x/Δ
R/LA315.3030.02R	3.0	0.2	3	30	5.4	05	Δ/▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	•
● 推荐 / recommended							M	•
o 次推荐 / alternative recommendation							K	•
- 不合适 / not suitable							N	•
■ 非涂层 / uncoated grades							S	•
■ 涂层 / coated grades							H	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -非全牙型

Threading (external) Partial profile



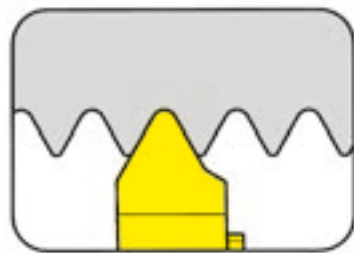
可转位刀片

Indexable insert

315

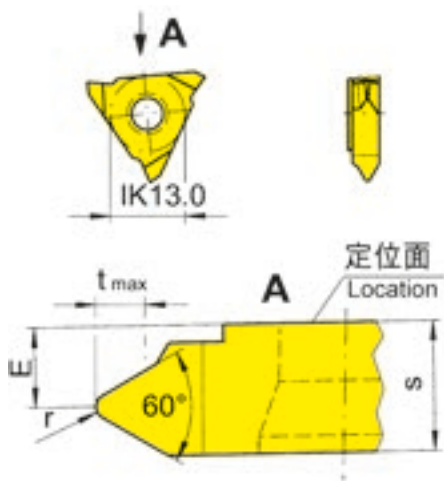
ISO米制螺纹
Metric ISO thread

螺距	Pitch	1-6 mm



配合刀杆
for Toolholder

型号 356
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	P _{max}	E	r	t _{max}	s	尺寸规格 Size	TN35
R/L315.0610.01	1.00	1.00	4.50	0.14	0.61	5.45	05	▲/△
R/L315.0712.01	1.25	1.25	4.50	0.15	0.77	5.45	05	▲/△
R/L315.0915.01	1.50	1.50	4.15	0.20	0.92	5.45	05	▲/▲
R/L315.1017.01	1.75	1.75	4.15	0.25	1.07	5.45	05	▲/△
R/L315.1220.01	2.00		4.15	0.25	1.23	5.45	05	▲/△
R/L315.1525.01	2.50	2.50	3.80	0.35	1.53	5.45	05	▲/△
R/L315.1830.01	3.00	3.00	3.60	0.40	1.84	5.45	05	▲/△
R/L315.3060.01	3.00	6.00	3.00	0.40	4.15	6.10	05	▲/▲
R/L315.2135.01	3.50	3.50	3.40	0.50	2.15	5.45	05	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

螺纹切削 (外圆) -全牙型

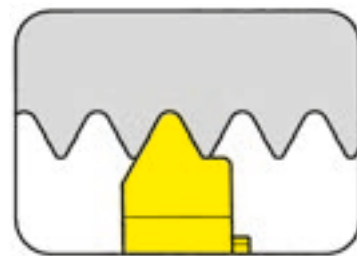
Threading (external) Full profile



可转位刀片

Indexable insert

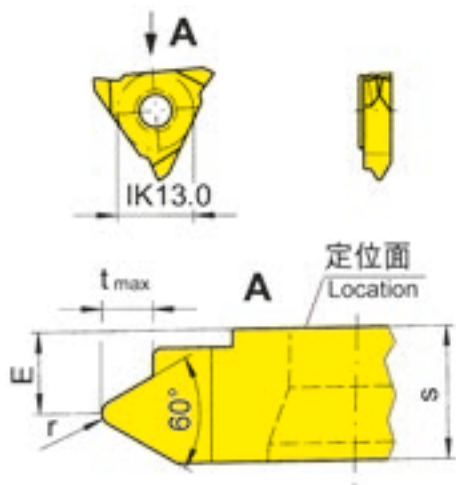
315
ISO米制螺纹
Metric ISO thread



螺距	Pitch	1-6 mm

配合刀杆
for Toolholder

型号 356
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	E	r	t _{max}	s	尺寸规格 Size	TN35
R/L315.0610.02	1.00	4.50	0.14	0.61	5.45	05	▲/▲
R/L315.0712.02	1.25	4.50	0.15	0.77	5.45	05	▲/△
R/L315.0915.02	1.50	4.15	0.20	0.92	5.45	05	▲/▲
R/L315.1017.02	1.75	4.15	0.25	1.07	5.45	05	▲/△
R/L315.1220.02	2.00	4.15	0.25	1.23	5.45	05	▲/△
R/L315.1525.02	2.50	3.80	0.35	1.55	5.45	05	▲/△
R/L315.1830.02	3.00	3.60	0.40	1.84	5.45	05	▲/▲
R/L315.2135.02	3.50	3.40	0.50	2.15	5.45	05	▲/△
R/L315.2440.02	4.00	3.30	0.55	2.45	5.45	05	△/△
R/L315.3050.02	5.00	4.00	0.70	3.07	6.50	06	▲/△
R/L315.3660.02	6.00	4.10	0.85	3.68	7.00	05	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

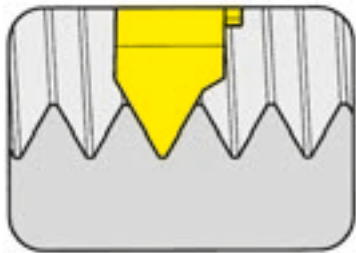
Threading (internal) Partial profile



可转位刀片

Indexable insert

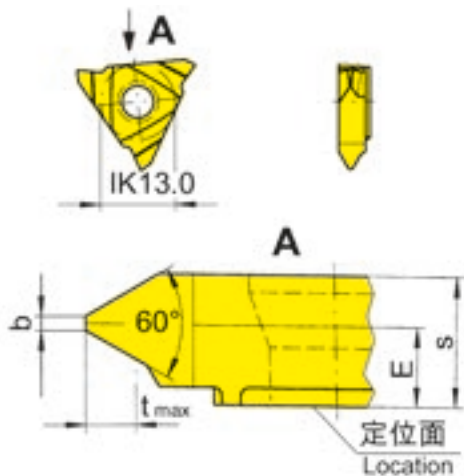
315
ISO米制螺纹
Metric ISO thread



螺距	Pitch	1-3.5 mm

配合刀杆
for Toolholder

型号 333
Type 357



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	E	t _{max}	b	s	D _{min}	尺寸规格 Size	TN35
R/L315.0510.01	1.0	4.85	0.55	0.12	5.45	40	05	△△
R/L315.0815.01	1.5	4.65	0.81	0.18	5.45	40	05	△△
R/L315.1020.01	2.0	4.45	1.08	0.25	5.45	40	05	△△
R/L315.1325.01	2.5	4.25	1.35	0.31	5.45	43	05	△△
R/L315.1630.01	3.0	4.05	1.62	0.37	5.45	43	05	△△
R/L315.1835.01	3.5	3.90	1.89	0.43	5.45	43	05	△△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

内圆加工 :

右手型螺纹刀片配合右手型333/357刀杆, 左手型螺纹刀片配合左手型333/357刀杆

Internal machining:

Right hand insert in right hand toolholder 333/357, left hand insert in left hand toolholder 333/357

P	•
M	•
K	•
N	•
S	•
H	-

螺纹切削 (内圆) -全牙型

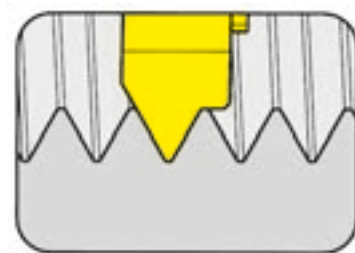
Threading (internal) Full profile



可转位刀片

Indexable insert

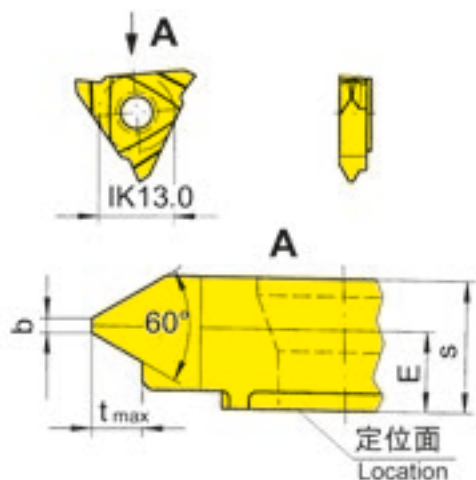
315
ISO米制螺纹
Metric ISO thread



螺距	Pitch	1-3.5 mm

配合刀杆
for Toolholder

型号 333
Type 357



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	P	E	t _{max}	b	s	D _{min}	尺寸规格 Size	TN35
R/L315.0510.02	1.0	4.85	0.55	0.12	5.45	40	05	△/△
R/L315.0815.02	1.5	4.65	0.81	0.18	5.45	40	05	▲/△
R/L315.1020.02	2.0	4.45	1.08	0.25	5.45	40	05	▲/△
R/L315.1325.02	2.5	4.25	1.35	0.31	5.45	43	05	△/△
R/L315.1630.02	3.0	4.05	1.62	0.37	5.45	43	05	▲/△
R/L315.1835.02	3.5	3.90	1.89	0.43	5.45	43	05	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

内圆加工 :

右手型螺纹刀片配合右手型333/357刀杆, 左手型螺纹刀片配合左手型333/357刀杆

Internal machining:

Right hand insert in right hand toolholder 333/357, left hand insert in left hand toolholder 333/357

P	•
M	•
K	•
N	•
S	•
H	-

螺纹切削 (外圆) -全牙型

Threading (external) Full profile

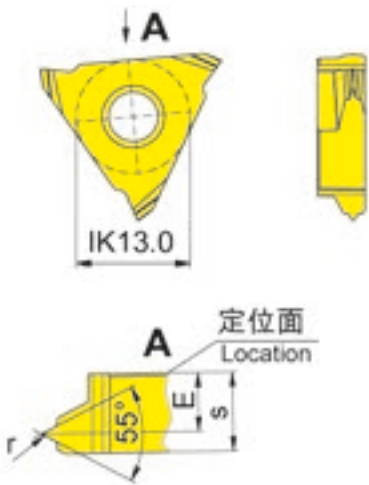
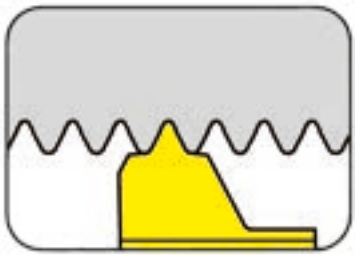


可转位刀片

Indexable insert

315
惠氏管螺纹
Whitworth pipe thread

每英寸牙数	Threads per inch	11 - 28



配合刀杆
for Toolholder

型号 356
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	TPI	E	r	s	尺寸规格 Size	TH35
R/L315.5528.02	28	4.35	0.11	5.45	05	△/△
R/L315.5519.02	19	4.05	0.17	5.45	05	▲/△
R/L315.5514.02	14	3.75	0.23	5.45	05	▲/△
R/L315.5511.02	11	3.55	0.30	5.45	05	▲/△
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request						P •
● 推荐 / recommended						M •
○ 次推荐 / alternative recommendation						K •
- 不合适 / not suitable						N •
■ 非涂层 / uncoated grades						S •
■ 涂层 / coated grades						H -
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位 : mm
Dimensions in mm

注明R或L型
State R or L version

硬质合金牌号
Carbide grades

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

外圆加工 :
右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:
Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

螺纹切削-全牙型

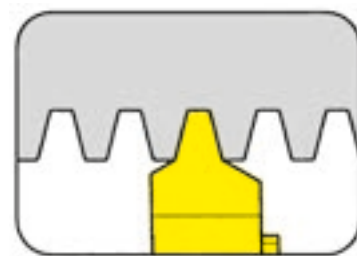
Threading Full profile



可转位刀片

Indexable insert

315



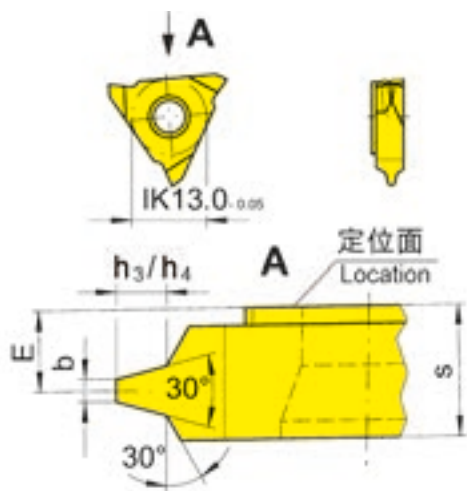
螺距

Pitch

1.5-6 mm

配合刀杆
for Toolholder

型号 356
Type 357
333



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	P	E	h_1	b	s	D_{min}	尺寸规格 Size	TN35
R/L315.1015.02	1.5	4.5	0.90	0.47	5.45	43	05	▲/▲
R/L315.1320.02	2.0	4.3	1.25	0.60	5.45	43	05	▲/▲
R/L315.1730.02	3.0	4.0	1.75	0.96	5.45	43	05	▲/▲
R/L315.2240.02	4.0	3.6	2.25	1.33	5.45	43	05	▲/▲
R/L315.2750.02	5.0	3.3	2.75	1.70	5.45	43	05	▲/▲
R/L315.3560.02	6.0	3.0	3.50	1.93	5.45	43	05	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

无需垫片。所有HORN螺纹刀片都有全轮廓后角。

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

外圆加工 :

右手型刀片配合右手型356系列刀杆,左手型刀片配合左手型356系列刀杆。

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356.

内圆加工 :

左手型333/357系列刀杆配合右手型刀片,右手型333/357刀杆配合左手型刀片。

Internal machining:

Right hand insert in left hand toolholder 333/357, left hand insert in right hand toolholder 333/357.

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

基本规格 型号

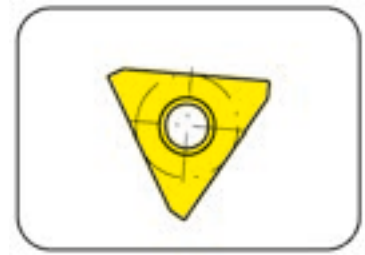
Basic sizes



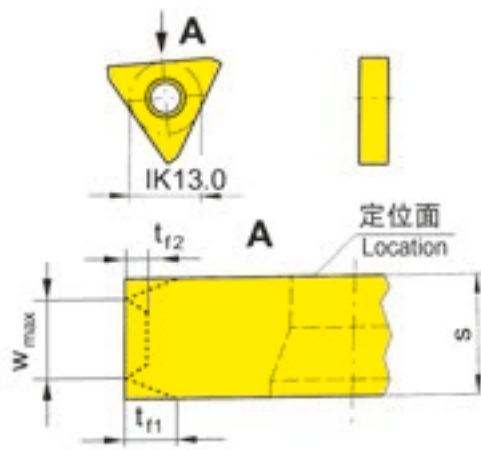
可转位刀片

Indexable insert

315



基本规格 型号 315
Basic sizes type 315



配合刀杆
for Toolholder

型号 356
Type

R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	W _{max}	t _{f2}	t _{f2}	s	Größe Size	TN35	TI25	TA45	TA46
R/L315...	3,05	5,0	-	3,25	03				
R/L315...	5,25	5,0	2,0	5,45	05				
R/L315...	5,90	5,0	2,0	6,10	05 / 06				
R/L315...	6,40	5,0	2,0	6,60	06 / 07				
R/L315...	6,90	5,0	2,0	7,10	07				
R/L315...	7,30	5,0	2,0	7,50	07				
R/L315...	8,30	5,0	2,0	8,50	07				
R/L315...	9,30	5,0	2,0	9,50	10				
R/L315...	10,30	5,0	2,0	10,50	10				
R/L315...	13,30	5,0	2,0	13,50	13				
R/L315...	15,30	5,0	2,0	15,50	13				
按照要求 UPON REQUEST						P			
						M			
						K			
						N			
						S			
						H			

尺寸单位 : mm
Dimensions in mm

注明R或L型
State R or L version

硬质合金牌号
Carbide grades

外圆加工:

右手刀片安装于356右手刀杆, 左手刀片安装于356左手刀杆

External machining:

Right hand insert in right hand toolholder 356, left hand insert in left hand toolholder 356 useable.

切槽和切断 (外圆)

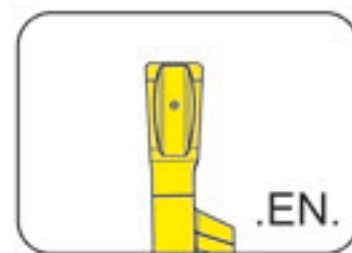
Grooving and Parting off (external)



可转位刀片

Indexable insert

S315



槽深可达
槽宽可达

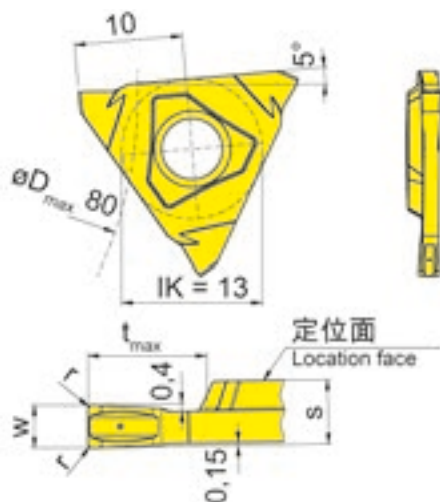
Depth of groove up to
Width of groove up to

5.5 mm
2 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 356...S.4...
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	EG5G
R/LS315.0200.EN2	2	0.2	5.5	3	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

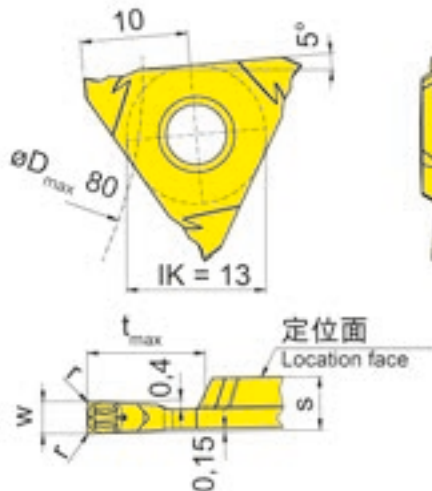
P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

S315

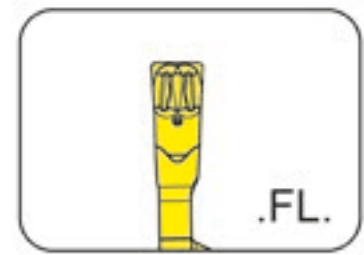
5.5 mm
1.5 mm

精密烧结
precision sintered



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



配合刀杆
for Toolholder

型号 356...S.4...
Type

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	EG55
R/LS315.0150.FL15	1.5	0.15	5.5	2.5	03	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P ●
● 推荐 / recommended						M ○
○ 次推荐 / alternative recommendation						K ○
- 不合适 / not suitable						N -
■ 非涂层 / uncoated grades						S -
■ 涂层 / coated grades						H -
■ 钎焊/金属陶瓷 / brazed/Cermet						

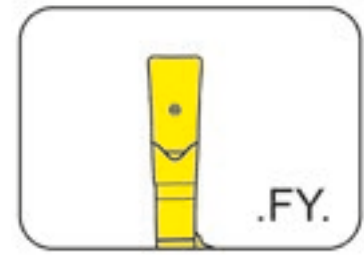
硬质合金牌号
Carbide grades

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

可转位刀片

Indexable insert

S315



槽深可达
槽宽

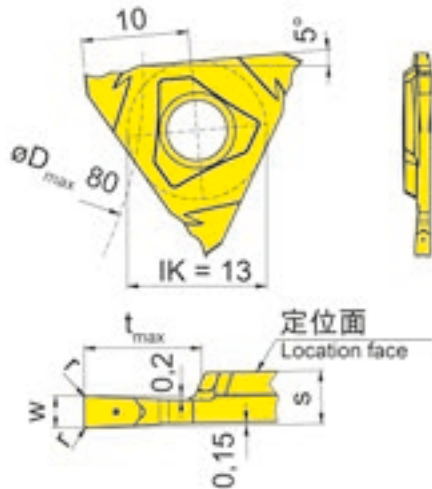
Depth of groove up to
Width of groove

5.5 mm
1.5-2 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 356...S.4...
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	EG55
R/LS315.0150.FY15	1.5	0.15	5.5	2.5	03	▲/▲
R/LS315.0200.FY2	2.0	0.20	5.5	3.0	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

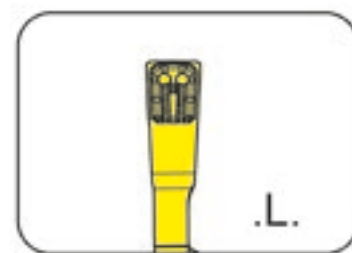
可转位刀片

Indexable insert

S315

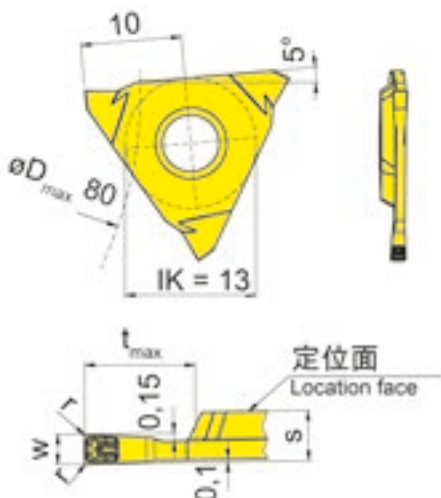
槽深可达 槽宽	Depth of groove up to Width of groove	5.5 mm 1.1-2 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 356...S.4...
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	EG55
R/LS315.0110.L1	1.1	0.10	5.5	2.5	03	▲/▲
R/LS315.0130.L1	1.3	0.10	5.5	2.5	03	▲/▲
R/LS315.0150.L15	1.5	0.15	5.5	2.5	03	▲/▲
R/LS315.0200.L2	2.0	0.20	5.5	3.0	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

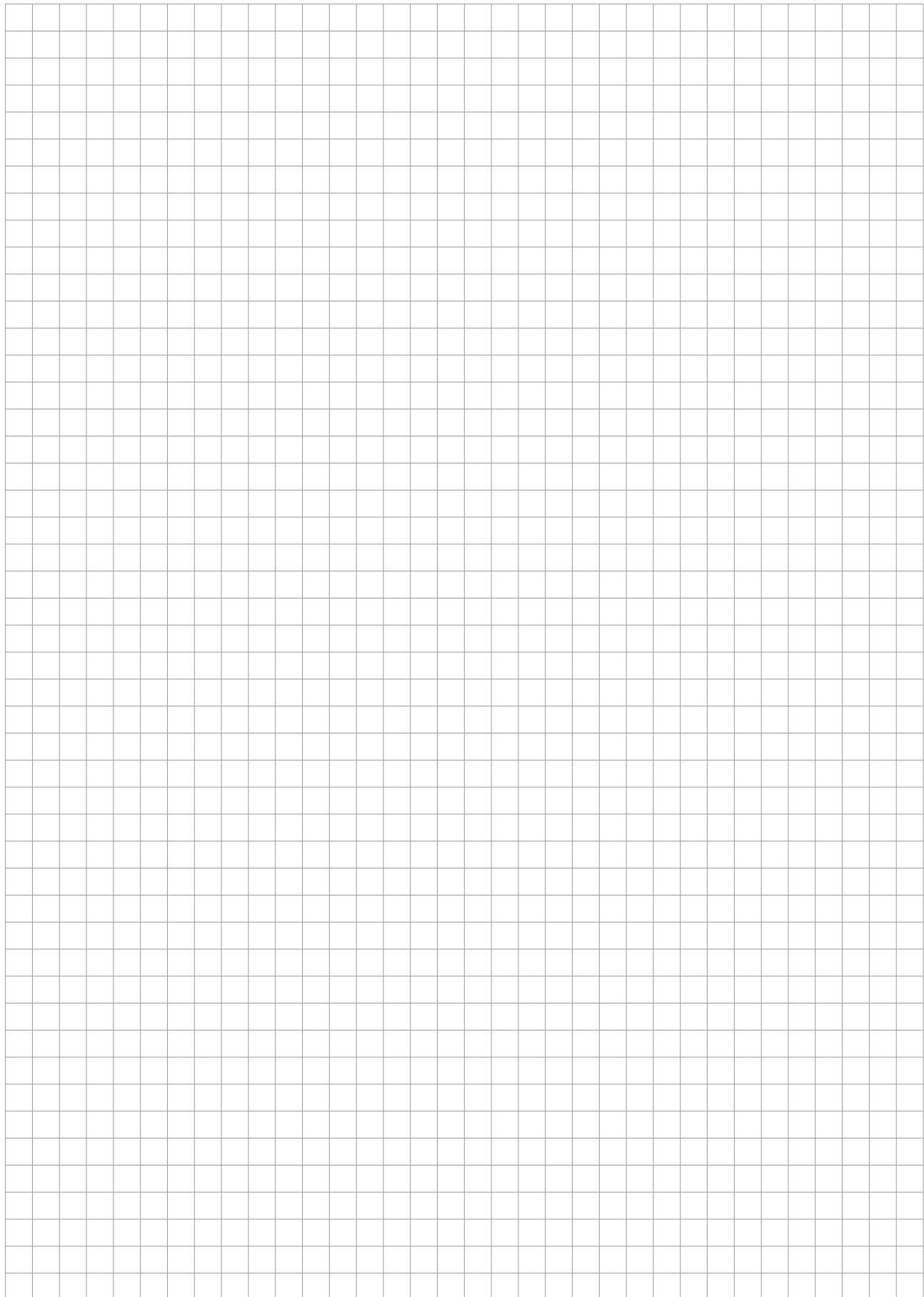
注明R或L型

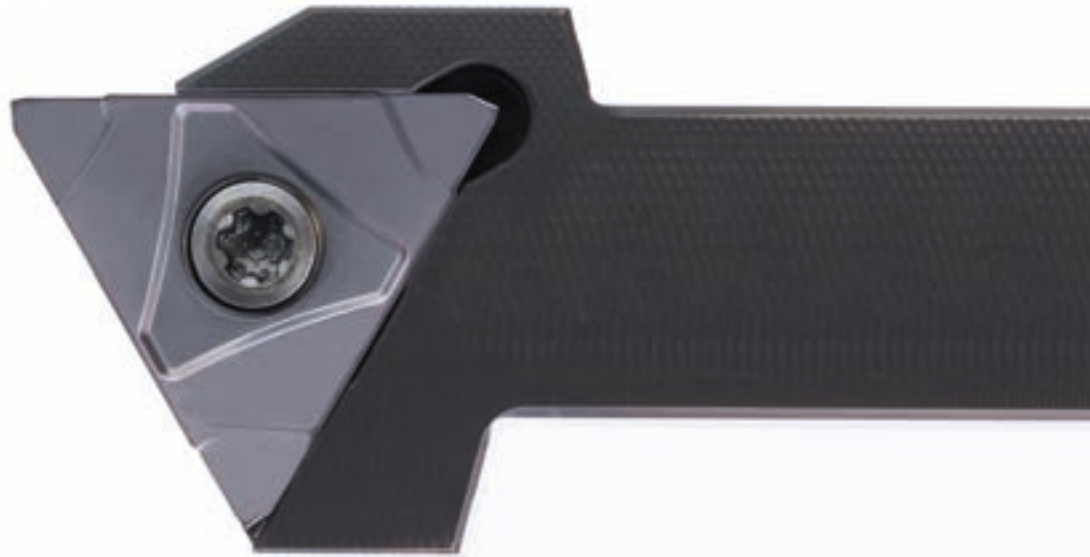
State R or L version

P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

O





机夹式刀杆

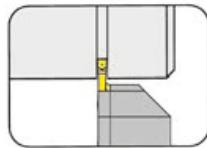
槽宽 1.5 - 3 mm

Toolholder with Inserts

Width of groove 1.5 - 3 mm

P

刀杆
Toolholder
H316/HC316

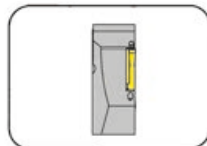


页/Page
P3



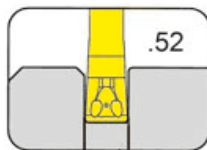
页/Page
P11

刀夹
Cassette
NK316

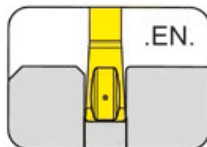


页/Page
P6, P12

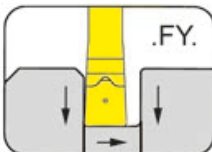
可转位刀片
Indexable insert
S316



页/Page
P7, P9



页/Page
P8



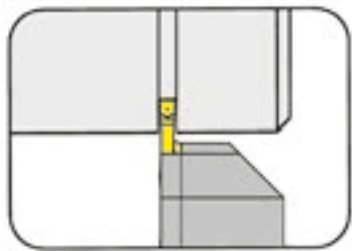
页/Page
P9

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

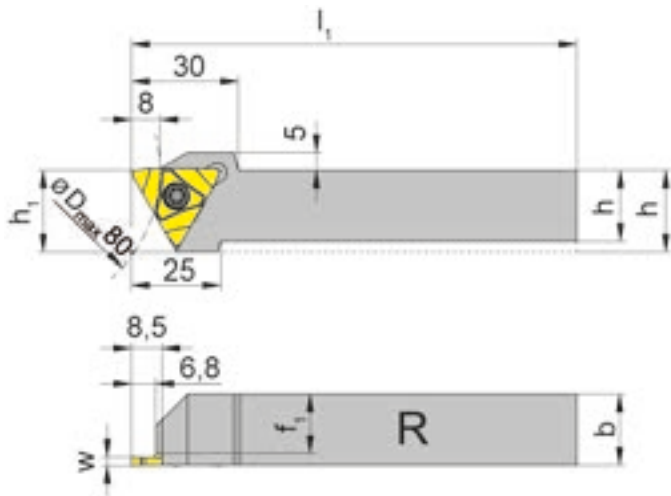
H316



槽深可达 夹持范围	Depth of groove up to Clamping range	8 mm 1.5-3 mm

配合可转位刀片
for Indexable insert

型号 S316
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	尺寸规格 Size
R/LH316.1616.S3.03	16	16	125	23	12.7	03
R/LH316.2020.S3.03	20	20	125	23	16.7	03
R/LH316.2525.S3.03	25	25	150	25	21.7	03
R/LH316.3225.S3.03	32	25	150	32	21.7	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件
Spare Parts

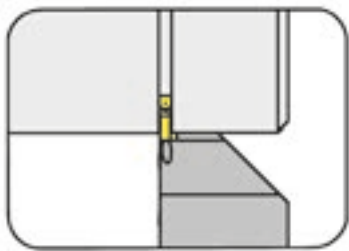
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH316...	5.12T20P	T20PQ

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

H316



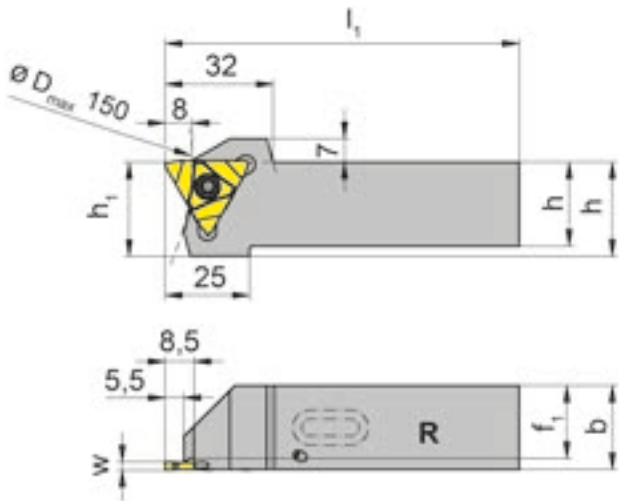
槽深可达
夹持范围

Depth of groove up to
Clamping range

8 mm
1.5-5 mm

配合可转位刀片
for Indexable insert

型号 S316
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带集成内冷
with integrated through
coolant supply

产品型号 Part number	h	b	l_1	h_1	f_1	尺寸规格 Size
R/LH316.2020.S3.03.IK	20	20	90	28	16.7	03
R/LH316.2525.S3.03.IK	25	25	105	28	21.7	03
R/LH316.2020.S5.05.IK	20	20	90	28	14.8	05
R/LH316.2525.S5.05.IK	25	25	105	28	19.8	05

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH316...	5.12T20P	T20PQ

切槽和螺纹切削 (外圆)

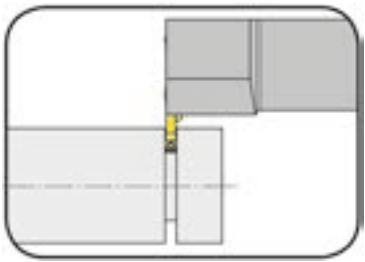
Grooving and Threading (external)



刀杆 Toolholder

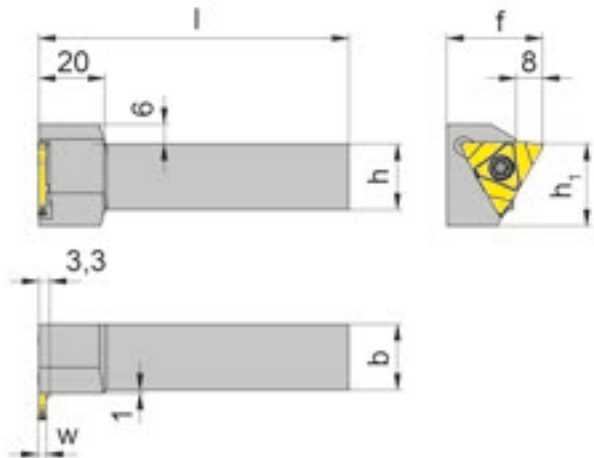
HC316

槽深可达 槽宽	Depth of groove up to Width of groove	8 mm 1.5-3 mm



配合可转位刀片
for Indexable insert

型号 S316
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l	h ₁	f	尺寸规格 Size
R/LHC316.1616.S3.03	16	16	125	25	29	03
R/LHC316.2020.S3.03	20	20	125	25	29	03
R/LHC316.2525.S3.03	25	25	150	25	34	03
R/LHC316.3225.S3.03	32	25	150	32	34	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LHC316...	5.12T20P	T20PQ

切槽 (外圆)

Grooving (external)

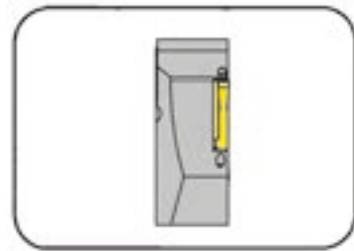


刀夹

Cassette

NK316

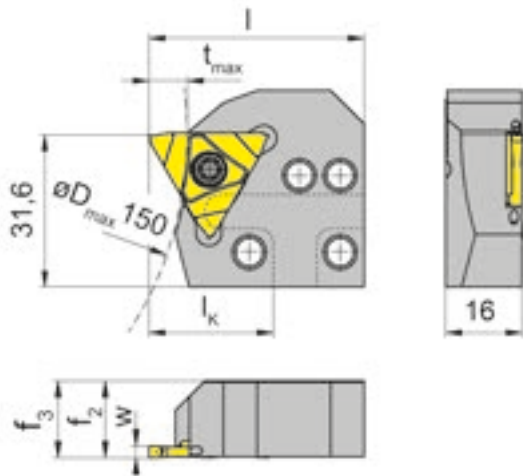
直接冷却液供应
with through coolant supply



槽深可达

Depth of groove up to

8 mm



配合可转位刀片
for Indexable insert

型号 S316
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	$t_{\max}$	f_2	f_3	l	l_k	尺寸规格 Size
R/LNK316.0220.S3.4.03.IK	8	16.2	$f_3=f_2$	45	26	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

订货须知：
按需提供更多尺寸

Ordering note:

Further sizes upon request

锁紧螺钉包含在刀杆内,不需要单独订购

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK316.0220.S3.4.03.IK	5.12T20P	T20PQ

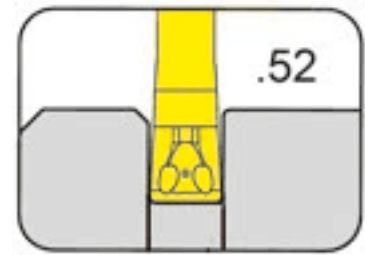
可转位刀片

Indexable insert

S316

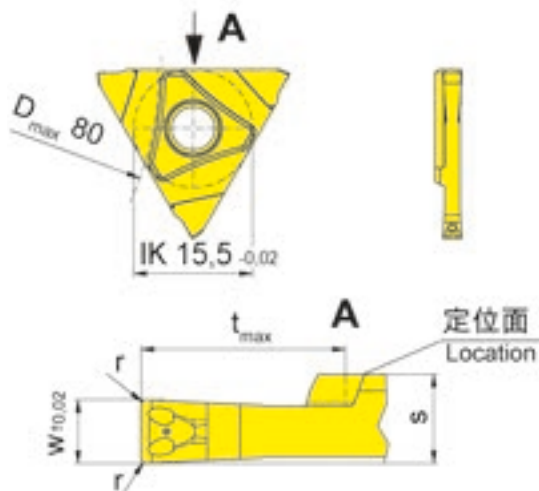
槽深可达 槽宽	Depth of groove up to Width of groove	8 mm 2-3 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 H316...S3...
Type HC316...S3...
NK316...S3...



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
 ± 0.02 mm
Indexability length ± 0.02 mm

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	AS45
R/LS316.0200.52	2.0	0.2	8	3.5	03	▲/▲
R/LS316.0250.52	2.5	0.2	8	3.5	03	▲/▲
R/LS316.0300.52	3.0	0.2	8	3.5	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

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

P	•
M	•
K	•
N	o
S	•
H	-

切断

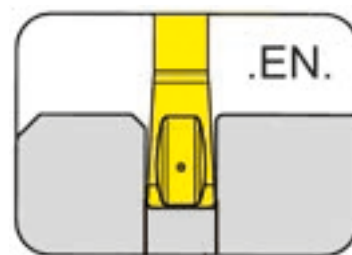
Parting Off



可转位刀片

Indexable insert

S316



槽深可达
槽宽

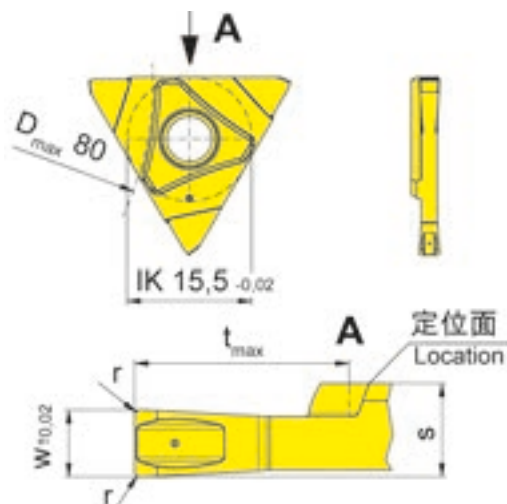
Depth of groove up to
Width of groove

8 mm
2-3 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H316...S3...
Type HC316...S3...
NK316...S3...



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0.02 mm

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	AS6G
R/LS316.0200.EN2	2.0	0.2	8	3.5	03	▲/▲
R/LS316.0250.EN2	2.5	0.2	8	3.5	03	▲/▲
R/LS316.0300.EN2	3.0	0.2	8	3.5	03	△/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工 :

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

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

P	•
M	•
K	•
N	•
S	•
H	-

可转位刀片

Indexable insert

S316

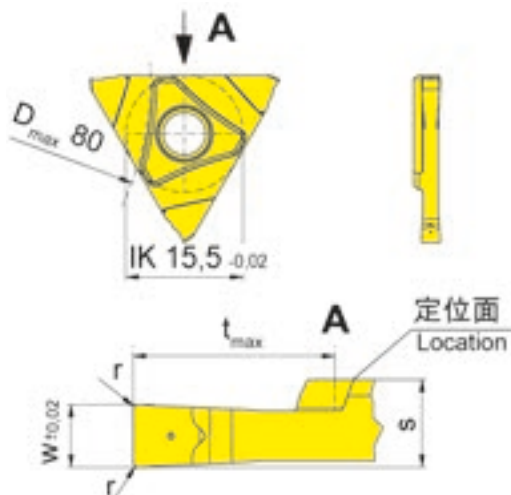
槽深可达
槽宽

Depth of groove up to
Width of groove

8 mm
1.5-3 mm

精密烧结

precision sintered

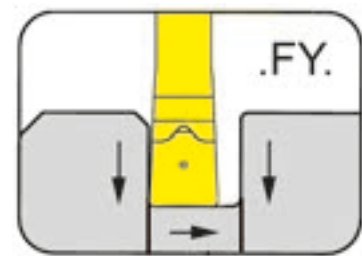


R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version



配合刀杆

for Toolholder

型号 H316...S3...
Type HC316...S3...
NK316...S3...

刀片长度重复定位精度

±0.02 mm

Indexability length ± 0.02 mm

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	T125
R/LS316.0150.FY1	1.5	0.1	8	3.3	03	▲/▲
R/LS316.0200.FY2	2.0	0.2	8	3.5	03	▲/▲
R/LS316.0250.FY2	2.5	0.2	8	3.5	03	▲/▲
R/LS316.0300.FY2	3.0	0.2	8	3.5	03	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位: mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

外圆加工:

右手型刀杆配合右手型刀片, 左手型刀杆配合左手型刀片

External machining:

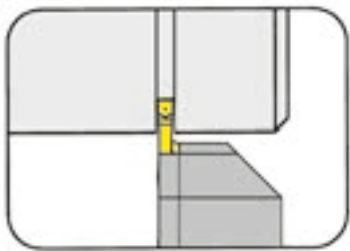
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

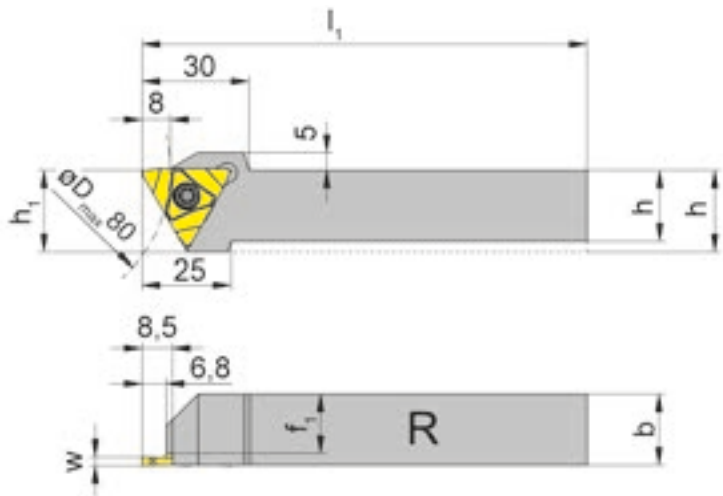
H316



槽深可达
夹持范围

Depth of groove up to
Clamping range

8 mm
1.5-3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 316
Type 按照要求
upon request

仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l ₁	h ₁	f ₁	尺寸规格 Size
R/LH316.1616.03	16	16	125	23	12.7	03
R/LH316.2020.03	20	20	125	23	16.7	03
R/LH316.2525.03	25	25	150	25	21.7	03
R/LH316.3225.03	32	25	150	32	21.7	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH316...	5.12T20P	T20PQ

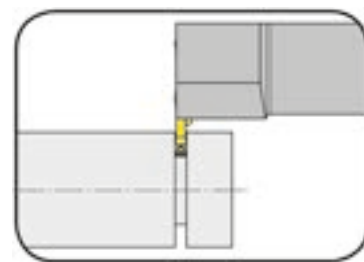
切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆 Toolholder

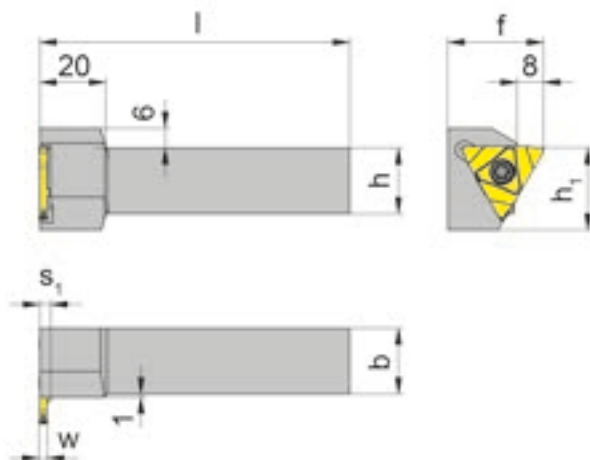
HC316



槽深可达 槽宽	Depth of groove up to Width of groove	8 mm 1.5-3 mm

配合可转位刀片
for Indexable insert

型号 316
Type 按照要求
upon request



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l	h ₁	f	s ₁	尺寸规格 Size
R/LHC316.1616.03	16	16	125	25	29	3.3	03
R/LHC316.2020.03	20	20	125	25	29	3.3	03
R/LHC316.2525.03	25	25	150	25	34	3.3	03
R/LHC316.3225.03	32	25	150	32	34	3.3	03
R/LHC316.2020.05	20	20	125	25	29	5.2	05
R/LHC316.2525.05	25	25	150	25	34	5.2	05
R/LHC316.3225.05	32	25	150	32	34	5.2	05

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

订货须知：
右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

Ordering note:
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LHC316...	5.12T20P	T20PQ

切槽 (外圆)

Grooving (external)

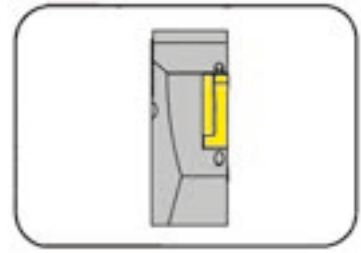


刀夹

Cassette

NK316

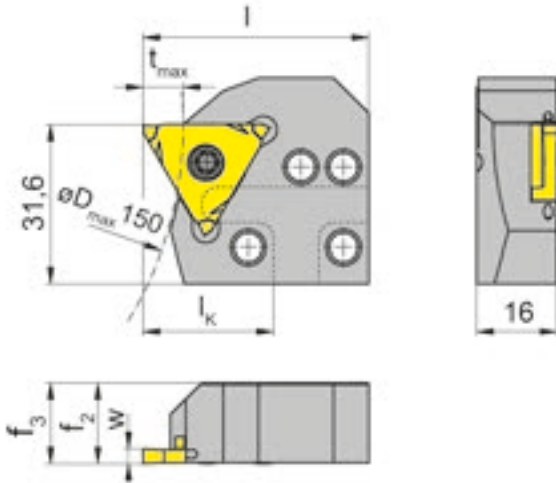
直接冷却液供应
with through coolant supply



槽深可达

Depth of groove up to

8 mm



配合可转位刀片

for Indexable insert

型号 316

Type 按照要求
upon request

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	$t_{\max}$	f_2	f_3	l	l_K	尺寸规格 Size
R/LNK316.0220.4.03.IK	8	16.2	$f_3=f_2$	45	26	03
R/LNK316.0220.4.05.IK	8	16.2	$f_3=f_2$	45	26	05

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK316...	5.12T20P	T20PQ

64T



Q

机夹式刀杆

槽宽0.5 - 3.15 mm

Toolholder with Inserts

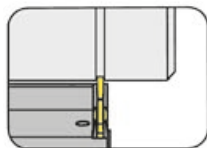
Width of groove 0.5 - 3.15 mm

切槽和切断

Grooving and Parting Off

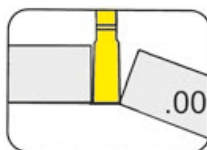


刀杆
Toolholder
H64T

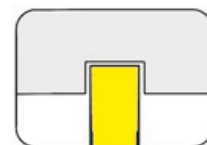


页/Page
Q3-Q4

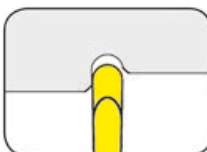
可转位刀片
Indexable insert
S64T



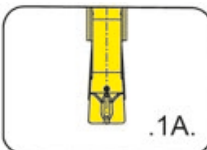
页/Page
Q5



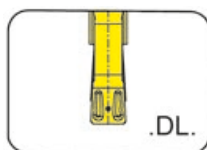
页/Page
Q6



页/Page
Q7



页/Page
Q8



页/Page
Q9

Q

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

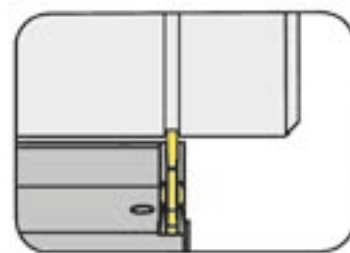
H64T

直接冷却液供应
with through coolant supply

槽深可达

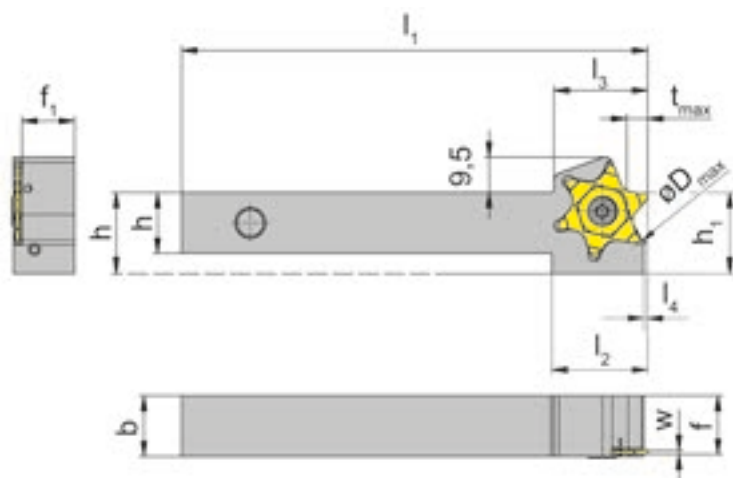
Depth of groove up to

5.5 mm



配合可转位刀片
for Indexable insert

型号 S64T
Type



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

D _{max}	t _{max}
40	5.5
45	5.0
50	4.5
55	4.0
65	3.5
70	3.5
80	3.0
100	2.5



L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	h	b	L ₁	L ₂	L ₃	h ₁	f ₁	f	L ₄	冷却液供应 Coolant supply	尺寸规格 Size
R/LH64T.1212.6.10.IK	12	12	125	25	24.5	19	9.8	f ₁ +w+a ₁	1	G1/8	01
R/LH64T.1212.6.20.IK	12	12	125	25	24.5	19	9.3	f ₁ +w+a ₁	1	G1/8	02
R/LH64T.1616.4.10.IK	16	16	125	25	24.5	21	13.8	f ₁ +w+a ₁	1	VDI	01
R/LH64T.1616.4.20.IK	16	16	125	25	24.5	21	13.3	f ₁ +w+a ₁	1	VDI	02
R/LH64T.1616.6.10.IK	16	16	125	25	24.5	21	13.8	f ₁ +w+a ₁	1	G1/8	01
R/LH64T.1616.6.20.IK	16	16	125	25	24.5	21	13.3	f ₁ +w+a ₁	1	G1/8	02
R/LH64T.2020.4.10.IK	20	20	125	25	24.5	25	17.8	f ₁ +w+a ₁	1	VDI	01
R/LH64T.2020.4.20.IK	20	20	125	25	24.5	25	17.3	f ₁ +w+a ₁	1	VDI	02
R/LH64T.2020.6.10.IK	20	20	125	25	24.5	25	17.8	f ₁ +w+a ₁	1	G1/8	01
R/LH64T.2020.6.20.IK	20	20	125	25	24.5	25	17.3	f ₁ +w+a ₁	1	G1/8	02
R/LH64T.2525.4.10.IK	25	25	125	25	24.5	30	22.8	f ₁ +w+a ₁	1	VDI	01
R/LH64T.2525.4.20.IK	25	25	125	25	24.5	30	22.3	f ₁ +w+a ₁	1	VDI	02
R/LH64T.2525.6.10.IK	25	25	125	25	24.5	25	22.8	f ₁ +w+a ₁	1	G1/8	01
R/LH64T.2525.6.20.IK	25	25	125	25	24.5	25	22.3	f ₁ +w+a ₁	1	G1/8	02

注明R或L型

State R or L version

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH64T.1212.6...	004.00.61	030.4010 T15P	T15PQ	-
R/LH64T...4...		030.4010 T15P	T15PQ	-
R/LH64T...6...	SBD 6 LR - G1/8"	030.4010 T15P	T15PQ	004.00.26

切槽和切断

Grooving and Parting Off



刀杆

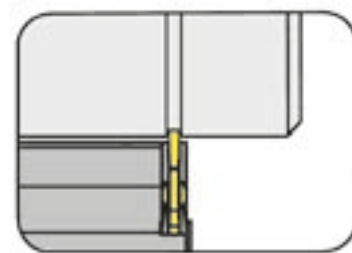
Toolholder

H64T

槽深可达

Depth of groove up to

5,5 mm

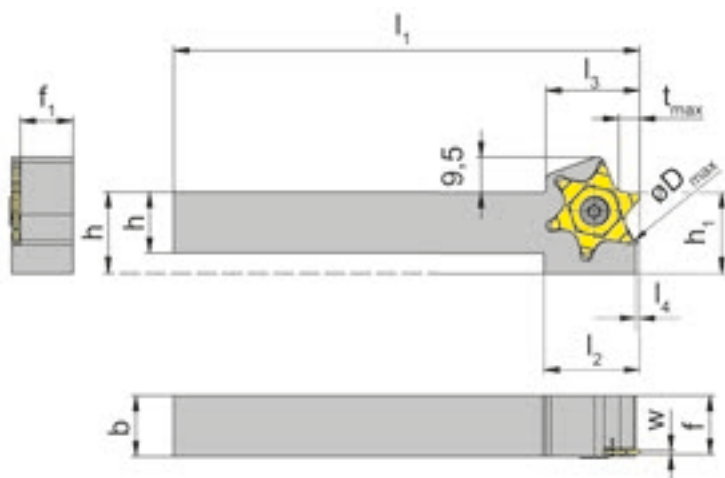


配合可转位刀片
for Indexable insert

型号 S64T
Type

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

D _{max}	t _{max}
40	5,5
45	5,0
50	4,5
55	4,0
65	3,5
70	3,5
80	3,0
100	2,5



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	l ₄	尺寸规格 Size
R/LH64T.1212.10	12	12	125	25	25.4	19	9.8	f ₁ +w+a ₁	1	01
R/LH64T.1212.20	12	12	125	25	25.4	19	9.3	f ₁ +w+a ₁	1	02
R/LH64T.1616.10	16	16	125	25	25.4	21	13.8	f ₁ +w+a ₁	1	01
R/LH64T.1616.20	16	16	125	25	25.4	21	13.3	f ₁ +w+a ₁	1	02
R/LH64T.2020.10	20	20	125	25	25.4	25	17.8	f ₁ +w+a ₁	1	01
R/LH64T.2020.20	20	20	125	25	25.4	25	17.3	f ₁ +w+a ₁	1	02
R/LH64T.2525.10	25	25	125	-	25.4	25	22.8	f ₁ +w+a ₁	1	01
R/LH64T.2525.20	25	25	125	-	25.4	25	22.3	f ₁ +w+a ₁	1	02

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH64T...	030.4010 T15P	T15PQ

切槽和切断

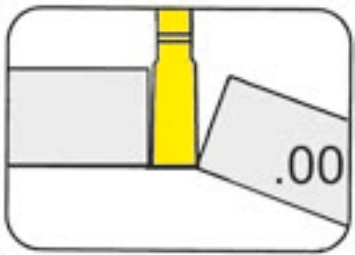
Grooving and Parting Off



可转位刀片

Indexable insert

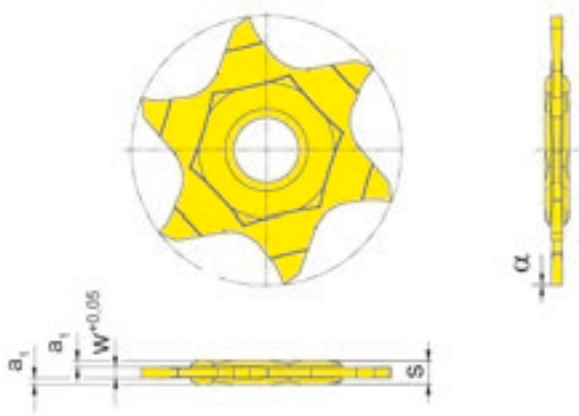
S64T



槽宽	Width of groove	1-1.5 mm

配合刀杆
for Toolholder

型号 H64T
Type



产品型号 Part number	w	a ₁	s	α	尺寸规格 Size	EG55
S64T.0010.00	1.0	0.58	2.2	0°	01	▲
S64T.0015.00	1.5	0.34	2.2	0°	01	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

切槽和切断

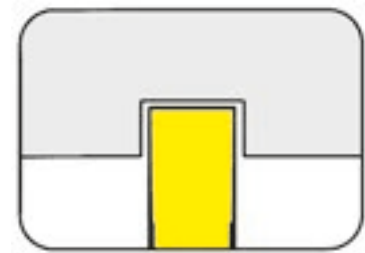
Grooving and Parting Off



可转位刀片

Indexable insert

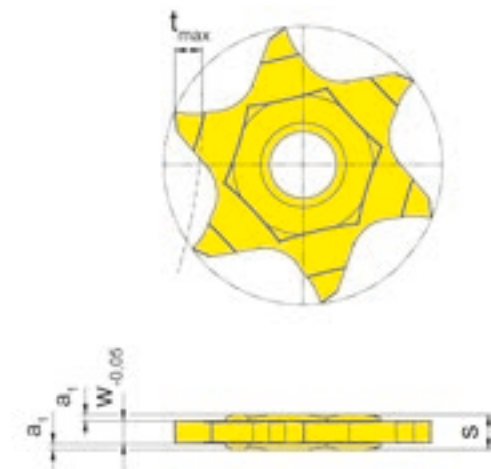
S64T



卡簧槽
卡簧宽度Nw

Circlip grooves
Width of circlip Nw

DIN471/472
0.5-3.15 mm



配合刀杆
for Toolholder

型号 H64T
Type

产品型号 Part number	w	Nw	t _{max}	a ₁	s	尺寸规格 Size	EG55
S64T.0050.00	0.57	0.50	0.7	0.83	2.2	01	▲
S64T.0060.00	0.67	0.60	0.8	0.78	2.2	01	▲
S64T.0070.00	0.77	0.70	1.1	0.73	2.2	01	▲
S64T.0080.00	0.87	0.80	1.2	0.68	2.2	01	▲
S64T.0090.00	0.97	0.90	1.4	0.63	2.2	01	▲
S64T.0100.00	1.07	1.00	1.6	0.58	2.2	01	▲
S64T.0110.00	1.24	1.10	1.6	0.49	2.2	01	▲
S64T.0130.00	1.44	1.30	2.0	0.39	2.2	01	▲
S64T.0160.00	1.74	1.60	3.5	0.24	2.2	01	▲
S64T.0185.00	1.99	1.85	3.5	0.12	2.2	01	▲
S64T.0215.00	2.29	2.15	3.5	0.07	2.4	01	▲
S64T.0265.00	2.79	2.65	3.5	0.07	2.9	02	▲
S64T.0315.00	3.29	3.15	3.5	0.07	3.4	02	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades

切槽 (内圆和外圆)

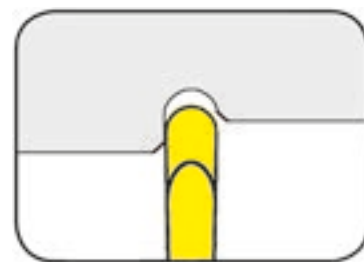
Grooving (external and internal)



可转位刀片

Indexable insert

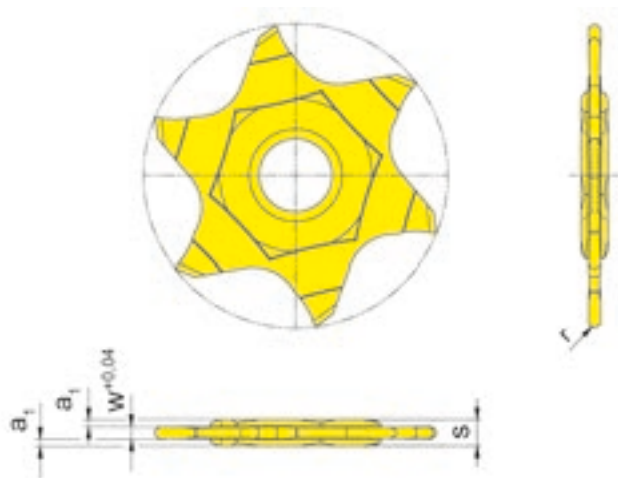
S64T



圆头

Full radius

0.5-1.5 mm



配合刀杆
for Toolholder

型号 H64T
Type

Q

产品型号 Part number	w	a ₁	r	s	尺寸规格 Size	EG55
S64T.0100.05	1.0	0.59	0.50	2.2	01	▲
S64T.0120.06	1.2	0.49	0.60	2.2	01	▲
S64T.0160.08	1.6	0.29	0.80	2.2	01	▲
S64T.0200.10	2.0	0.09	1.00	2.2	01	▲
S64T.0250.12	2.5	0.09	1.25	2.7	02	▲
S64T.0300.15	3.0	0.09	1.50	3.2	02	▲
						P •
						M ○
						K ○
						N -
						S -
						H -

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

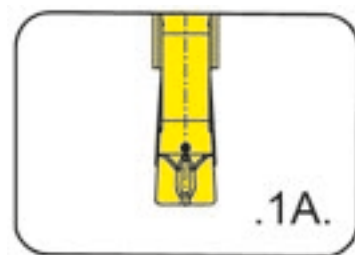
Grooving and Parting Off



可转位刀片

Indexable insert

S64T



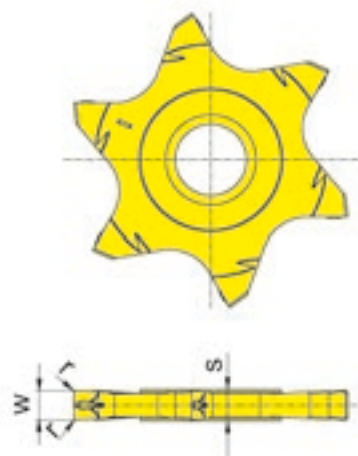
槽宽

Width of groove

1.5-3 mm

配合刀杆
for Toolholder

型号 H64T
Type



产品型号 Part number	w	r	s	尺寸规格 Size	EG55	IG35
S64T.0150.1A2	1.5	0.2	2.2	01	▲	▲
S64T.0200.1A2	2.0	0.2	2.2	01	▲	▲
S64T.0250.1A2	2.5	0.2	2.7	02	▲	▲
S64T.0300.1A2	3.0	0.2	3.2	02	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	•
● 推荐 / recommended					M	○
○ 次推荐 / alternative recommendation					K	○
- 不合适 / not suitable					N	-
■ 非涂层 / uncoated grades					S	-
■ 涂层 / coated grades					H	-
■ 钎焊/金属陶瓷 / brazed/Cermet						

尺寸单位：mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和侧车削

Grooving and Side Turning



可转位刀片

Indexable insert

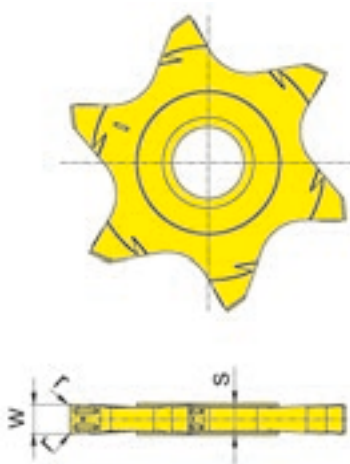
S64T



槽宽

Width of groove

1.5-3 mm



配合刀杆
for Toolholder

型号 H64T
Type

Q

产品型号 Part number	w	r	s	尺寸规格 Size	EG55
S64T.0150.DL2	1.5	0.2	2.2	01	▲
S64T.0150.DL4	1.5	0.4	2.2	01	△
S64T.0200.DL2	2.0	0.2	2.2	01	▲
S64T.0200.DL4	2.0	0.4	2.2	01	△
S64T.0250.DL2	2.5	0.2	2.7	02	▲
S64T.0250.DL4	2.5	0.4	2.7	02	△
S64T.0300.DL2	3.0	0.2	3.2	02	▲
S64T.0300.DL4	3.0	0.4	3.2	02	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

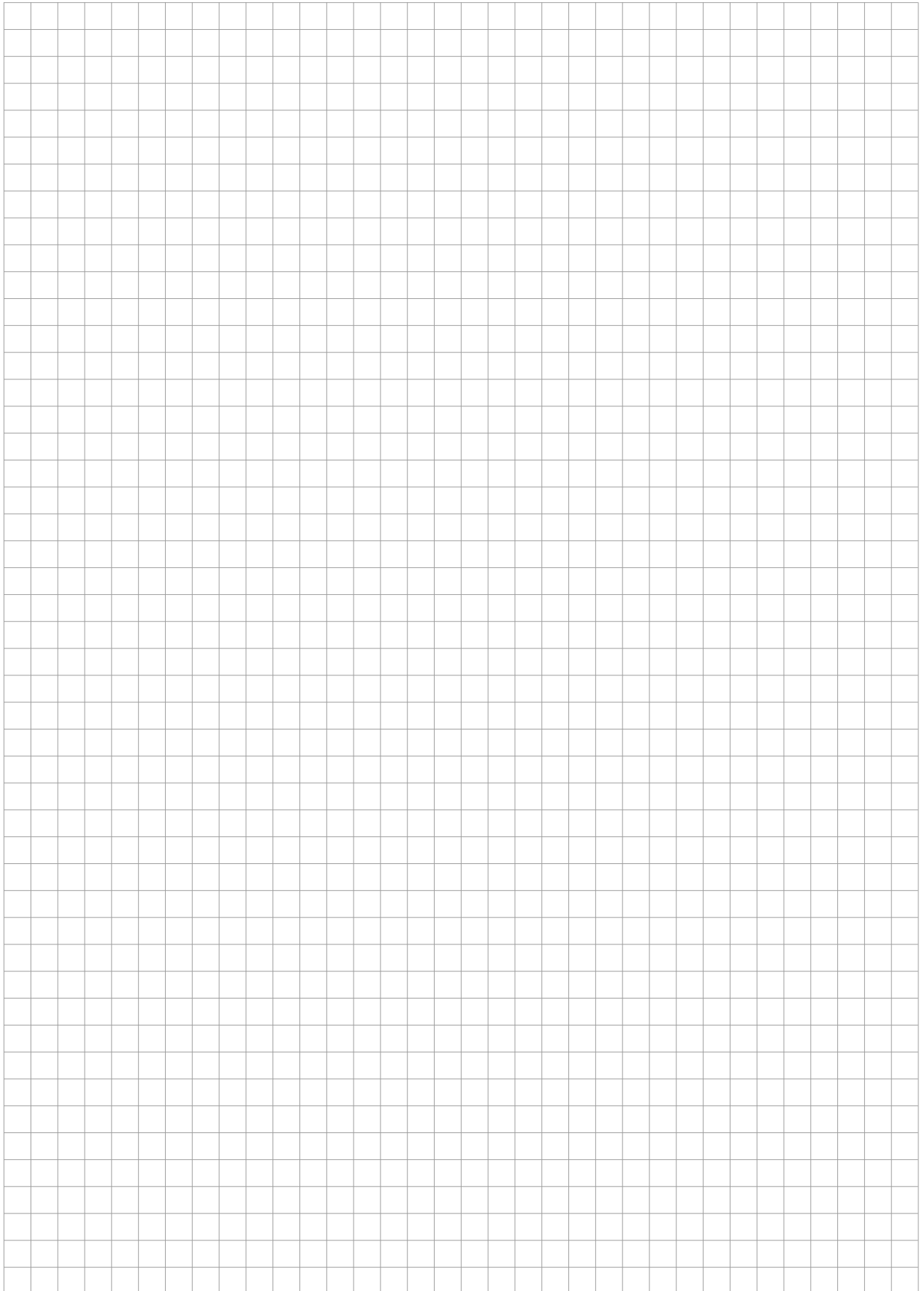
Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

P	●
M	○
K	○
N	-
S	-
H	-

硬质合金牌号
Carbide grades





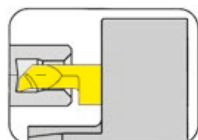
R

适用于Swiss
机床的刀具

Tools for
Swiss Type Machines

配合刀片
for Inserts

105



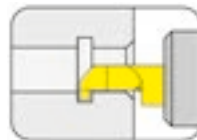
I 页 / Page
R3, R5-R6



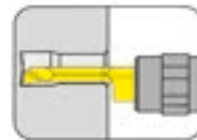
I 页 / Page
R7



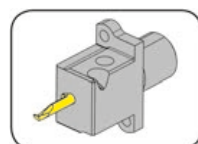
I 页 / Page
R8



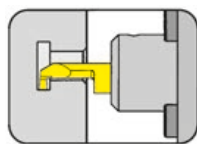
I 页 / Page
R4, R9, R11



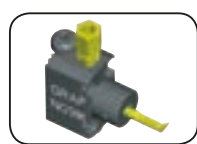
I 页 / Page
R10



I 页 / Page
R12

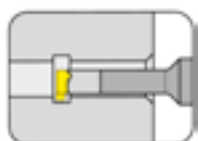


I 页 / Page
R13-R20



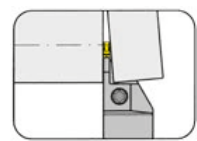
I 页 / Page
R23-R28

108



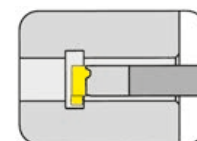
I 页 / Page
R29

S100



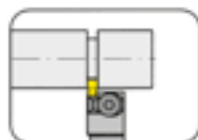
I 页 / Page
R31

111



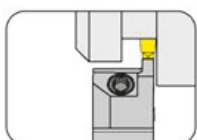
I 页 / Page
R30

217

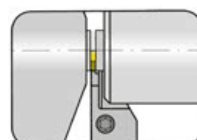


I 页 / Page
R36

S224

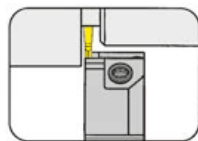


I 页 / Page
R40-R41

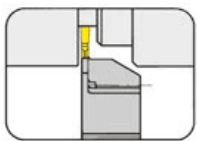


I 页 / Page
R42-R44

264

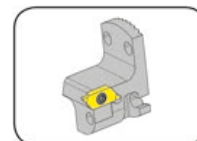


I 页 / Page
R32-R34

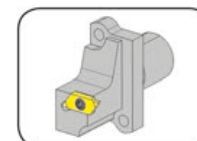


I 页 / Page
R35

S274

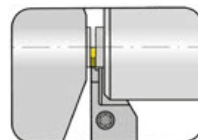


I 页 / Page
R37-R38

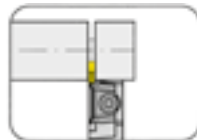


I 页 / Page
R39

312



I 页 / Page
R42-R44, R46



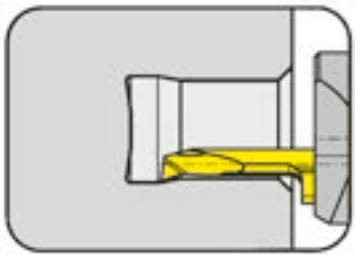
I 页 / Page
R45



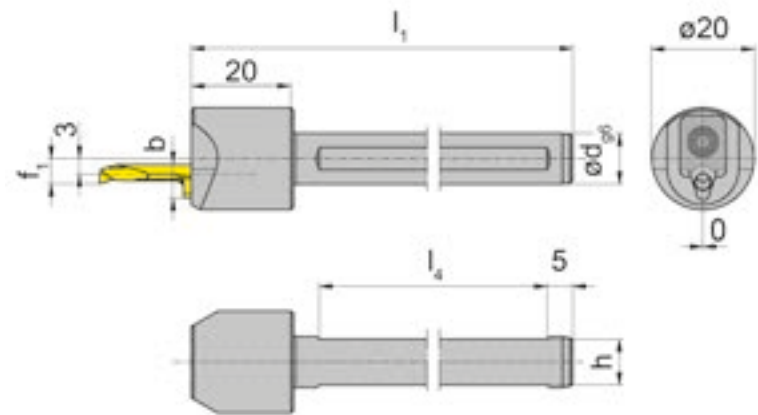
I 页 / Page
R47

刀杆
Toolholder

B105
直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	0.2 mm
槽深	Depth of groove	2.5 mm
槽宽可达	Width of groove up to	2 mm



刀片
Insert

型号
Type

R

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄	f ₁	b
B105.0010.S.03	10	80	9	50	4.3	5.9
B105.0012.S.03	12	80	11	50	4.3	5.9
B105.0016.S.03	16	80	14	50	4.3	5.9
B105.0020.S.03	20	90	18	55	4.3	5.9
B105.0025.S.03	25	100	23	55	4.3	5.9
B105.0010.S.04	10	80	9	50	4.9	6.4
B105.0012.S.04	12	80	11	50	4.9	6.4
B105.0016.S.04	16	80	14	50	4.9	6.4
B105.0020.S.04	20	90	18	55	4.9	6.4
B105.0025.S.04	25	100	23	55	4.9	6.4
B105.0010.S.05	10	80	9	50	6.3	7.0
B105.0012.S.05	12	80	11	50	6.3	7.0
B105.0016.S.05	16	80	14	50	6.3	7.0
B105.0020.S.05	20	90	18	55	6.3	7.0
B105.0025.S.05	25	100	23	55	6.3	7.0

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左，右手刀片
Ordering note:
Toolholders can be used with right and left hand inserts.

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

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
B105.00...S.03	010.0105.03	T15PL
B105.00...S.04	010.0105.04	T15PL
B105.00...S.05	010.0105.05	T15PL

切槽和镗孔

Grooving and Boring

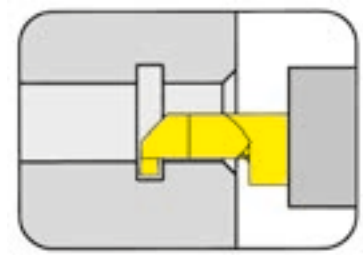


刀杆

Toolholder

H105

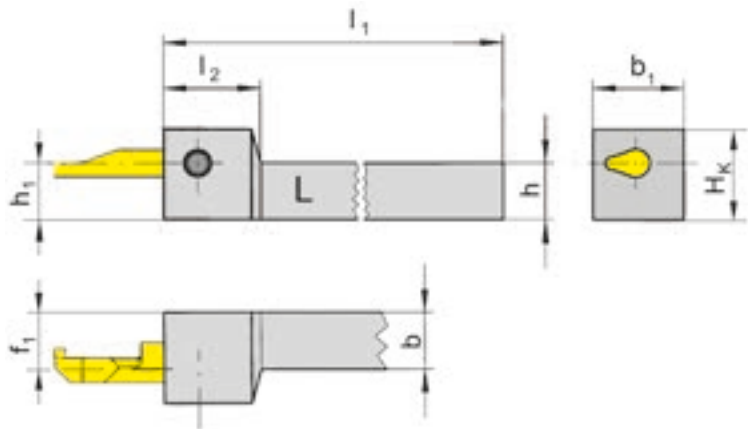
螺钉夹紧
with screwed clamping



孔径Ø 自 Bore Ø from 0.2 mm

刀片
Insert

型号 105
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	h_1	b_1	f_1	H_k	l_2
R/LH105.0808.01	8	8	90	8	16	7.5	14	17
R/LH105.1010.01	10	10	90	10	16	7.5	16	17
R/LH105.1212.01	12	12	90	12	16	7.5	18	17
R/LH105.1616.01	16	16	110	16	16	7.5	22	17

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

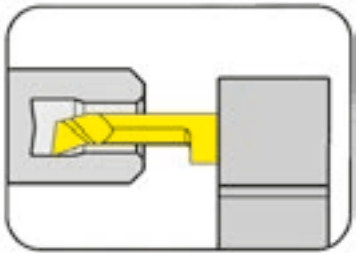
切槽和镗孔
Grooving and Boring



刀杆
Toolholder

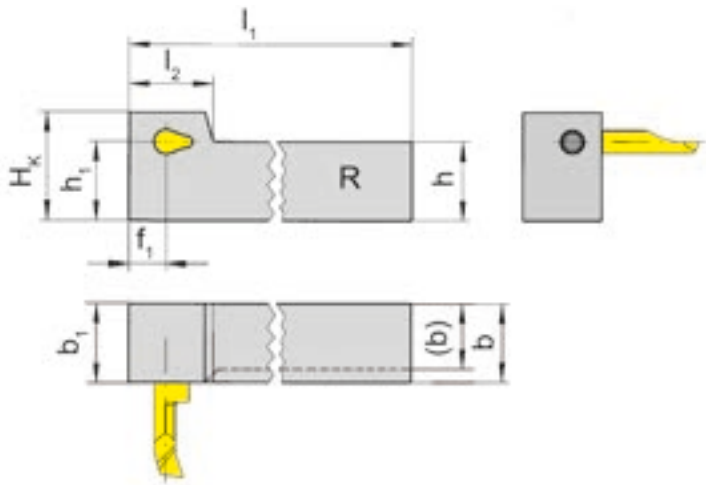
HC105
螺钉夹紧
with screwed clamping

孔径Ø 自	Bore Ø from	0.2 mm



刀片
Insert

型号 105
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	b ₁	f ₁	H _k
R/LHC105.1212.01	12	12	90	17	12	16	7.5	18
R/LHC105.1616.01	16	16	130	17	16	16	7.5	22

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

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

R

切槽和镗孔

Grooving and Boring

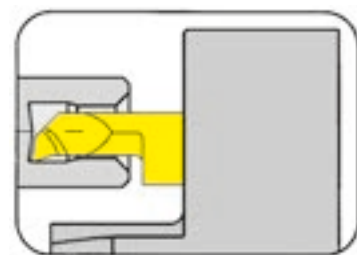


刀杆

Toolholder

HC105

螺钉夹紧
with screwed clamping



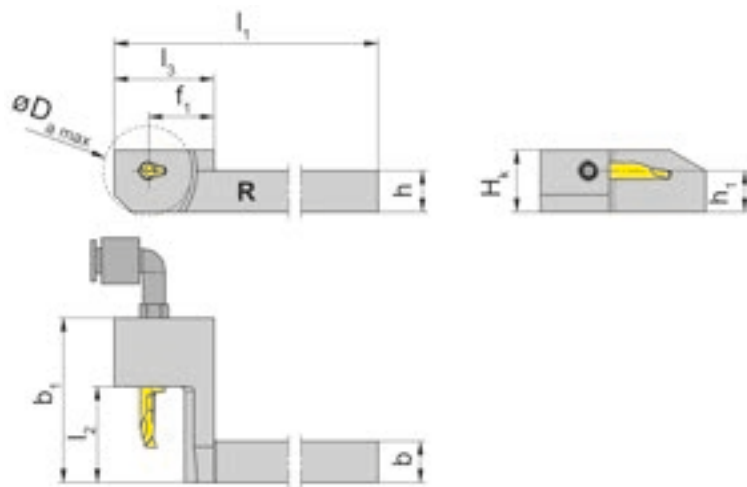
孔径Ø 自

Bore Ø from

0.2 mm

刀片
Insert

型号 105
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

通过曲型接头供给冷却液
Coolant supply through
cranked fitting

产品型号 Part number	h	b	l ₁	l ₃	h ₁	b ₁	f ₁	D _{a max}	H _k	l ₂
R/LHC105.0707.21	7	7	99	29	7	32.0	19	26	13	18
R/LHC105.0808.21	8	8	99	29	8	32.0	19	26	13	18
RHC105.1010.11	10	10	99	29	10	22.7	19	26	16	8
R/LHC105.1010.21	10	10	99	29	10	38.0	19	26	16	18
R/LHC105.1010.41	10	10	99	29	10	48.0	19	26	16	28
R/LHC105.1212.21	12	12	99	29	12	38.0	19	26	18	18
R/LHC105.1212.41	12	12	99	29	12	48.0	19	26	18	28
R/LHC105.1616.21	16	16	104	34	16	38.0	24	36	22	18
R/LHC105.1616.41	16	16	104	34	16	48.0	24	36	22	28

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

注意事项：

*=无内冷!

Note:

* = no through coolant supply!

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	旋紧型角度接头 SMC angle screwing
R/LHC105.0707.21/0808.21	6.075T15P	T15PQ	
R/LHC105...11	6.075T15P	T15PQ	
R/LHC105....	6.075T15P	T15PQ	KQ2L06-M5

常规刀柄

Basic toolholder

HC105



孔径Ø 自

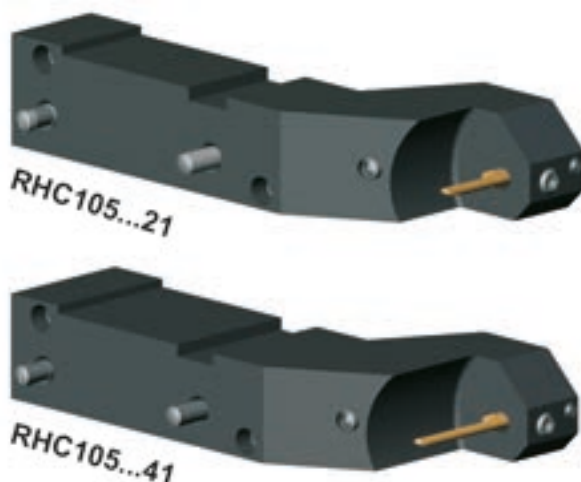
Bore Ø from

0.2 mm

用于机床Tornos
Tool for Tornos

刀片
Insert

型号 105
Type



R

产品型号 Part number	机床型号 Machine type	刀片 Insert
RHC105.0710.21	EvoDECO 10	105...21 l_2 以内可达15 mm
RHC105.0710.41	EvoDECO 10	105...41 l_2 以内可达25 mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

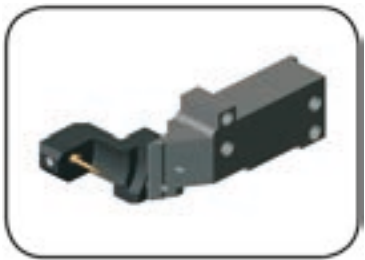
配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	旋紧型角度接头 SMC angle screwing	TORX PLUS®扳手 TORX PLUS® Wrench
RHC105...	6.075T15P	KQ2L06-M5	T15PQ

常规刀柄
Basic toolholder

760



槽深可达	Depth of groove up to	0.2 mm

用于机床Tornos
Tool for Tornos

配合刀夹
for Cassette

型号 RKC760
Type



产品型号 Part number	机床型号 Machine type	刀片 Insert	刀夹 Cassette
L760.0013.K1	EvoDECO 16	105...21 l ₂ 以内可达15 mm	RKC760.0105.21
L760.2026.K1	EvoDECO 20/EvoDECO 32	105...41 l ₂ 以内可达25 mm	RKC760.0105.41

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

常规刀柄 Basic toolholder	扳手 Allen Wrench
L760...	SW5,0 DIN911

切槽和镗孔

Grooving and Boring

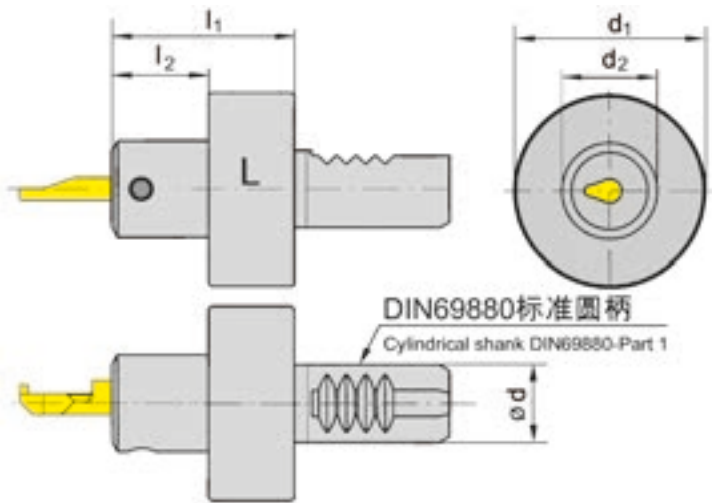
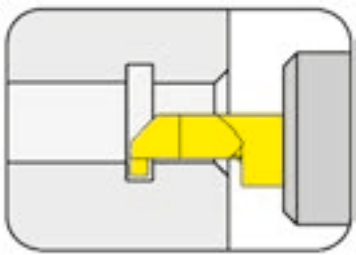


刀杆

Toolholder

VDI
直接冷却液供应
with through coolant supply

孔径Ø 自	Bore Ø from	0.2 mm



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

刀片
Insert

型号 105
Type

R

产品型号 Part number	d	l ₁	l ₂	d ₂	d ₁
VDI16.L105.20.01	16	38	20	20	40
VDI16.R105.20.01	16	38	20	20	40
VDI20.L105.20.01	20	38	20	20	50
VDI20.R105.20.01	20	38	20	20	50
VDI25.L105.20.01	25	38	20	20	58
VDI25.R105.20.01	25	38	20	20	58
VDI30.L105.20.01	30	38	20	20	68
VDI30.R105.20.01	30	38	20	20	68
VDI40.L105.20.01	40	38	20	20	83
VDI40.R105.20.01	40	38	20	20	83

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

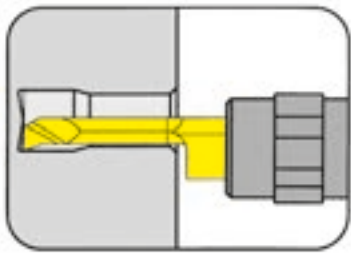
配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
VDI16...	6.075T15P	T15PQ

刀杆
Toolholder

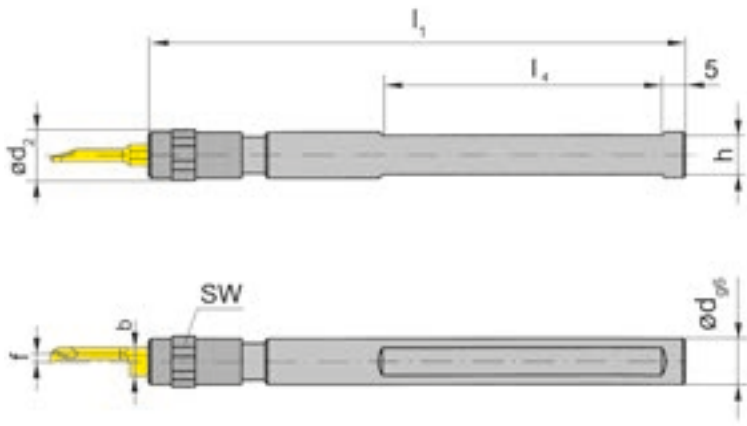
B105
直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	<3 / >5 mm

刀片
Insert

型号	105.0010... Ø ≤ 3
Type	105.0012... Ø ≥ 5
	105.0016... Ø ≥ 5



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄	f	d ₂	SW	b
B105.0010.9.01	10	100	9	50	1.6	11	10	5.9
B105.0012.11.01	12	100	11	50	1.2	16	13	7.0
B105.0016.11.01	16	100	15	50	1.2	16	13	7.0

按需提供更多尺寸
Further sizes upon request

b = Height of insert

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左，右手刀片

Ordering note:
Toolholders can be used with right and left hand inserts.

配件
Spare Parts

刀杆 Toolholder	锁紧螺母 Clamping nut
B105.0010.9.01	020.0010.1719
B105.00...	020.0016.1999

切槽和镗孔

Grooving and Boring

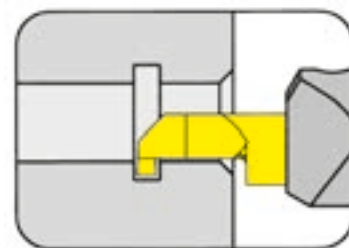


刀杆

Toolholder

B105

直接冷却液供应
with through coolant supply



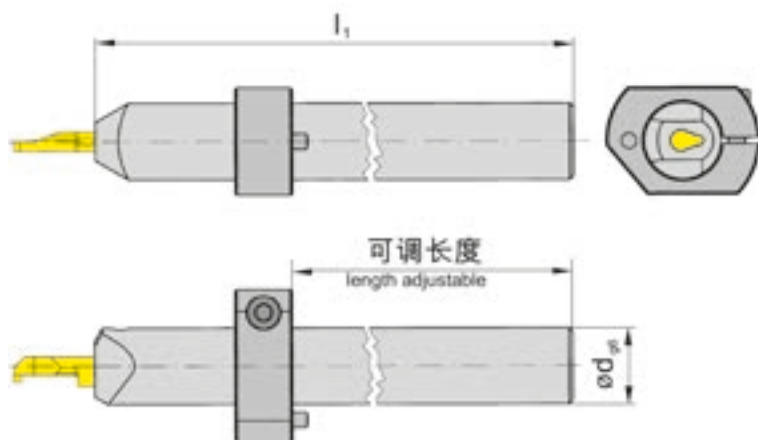
孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

0.2 mm
2.5 mm
2 mm

刀片
Insert

型号 105
Type



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁
B105.0020.2.01	20	150
B105.0025.2.01	25	150

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

刀杆可以安装左，右手刀片

Ordering note:

Toolholders can be used with right and left hand inserts.

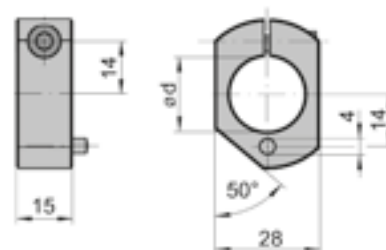
调整环不包含在刀杆内-需要单独订购！

Adjusting ring is not combined with the toolholder - separate order required!

螺丝的扭矩规格，详见技术说明。

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

调整环 Adjusting ring	d	机床型号 Type of machine
020.0020.1665	20	Tornos
020.0025.2234	25	Tornos



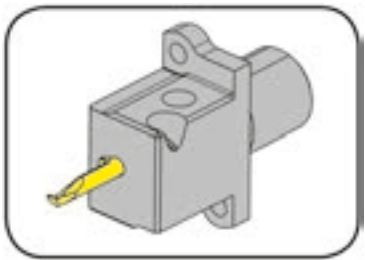
配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	旋紧型角度接头 SMC angle screwing	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	KQ2L06-M5	T15PQ

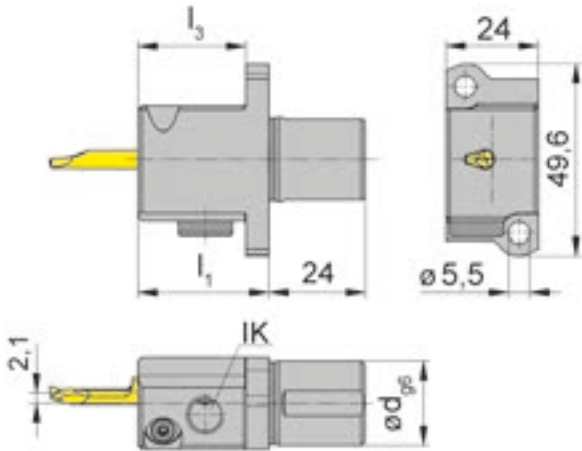
刀杆
Toolholder

B105
直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	0.2 mm
槽深	Depth of groove	2.5 mm
槽宽	Width of groove	2 mm

内冷管G1/8" xxx Hole pattern xxx 13.7 x 37,6 mm
Through coolant supply G1/8" Hole pattern 13.7 x 37,6 mm



刀片
Insert

型号 105
Type

适用于Star Swiss机床
for Swiss type machines Star

图示=左手型切削
Picture = left hand cutting version

产品型号 Part number	d	I ₁	I ₃
LB105.A022.26.31	22	35	29

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

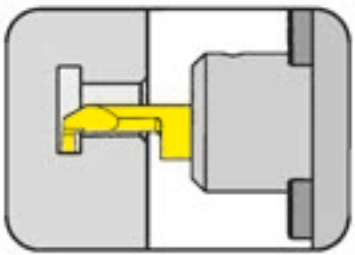
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.
适用于Star Swiss机床:ECAS-12/20. SB16D/E, SR-20. SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RIII
Swiss Type Machines Star: ECAS-12/20. SB16D/E, SR-20. SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RII

配件
Spare Parts

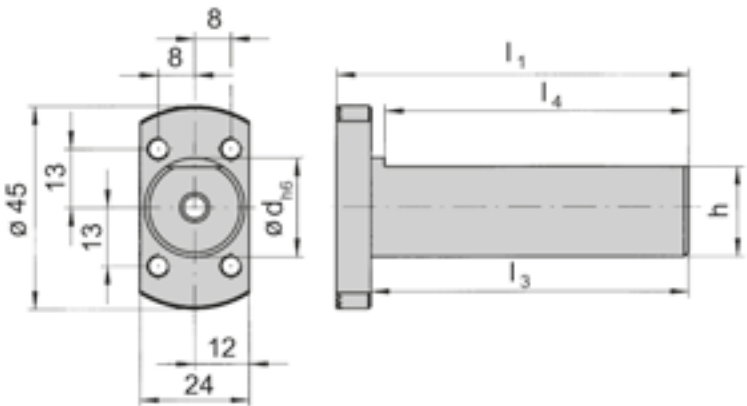
刀杆 Toolholder	扳手 Allen Wrench	楔形块 Clamping	TORX PLUS®扳手 TORX PLUS® Wrench
LB105.A022.26.31	SW3.0 DIN911	070.0010.0118	T10PL

常规刀柄
Basic toolholder

BGT
无刀夹
without cartridge



配合BKT105.2445.01/2刀杆的可调圆刀杆
Adjustable round shanks for toolholder BKT105.2445.01/02



直接冷却液供应
with through coolant supply

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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

注意事项：
BGT001.0022.30无内冷
Note:
BGT001.0022.30 without through coolant supply

配件
Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	O型圈 O-ring
BGT001...	M 5 x 10 DIN 912-12.9	SW4,0 DIN911	DIN3770-7x3
BGT001.0022.30	M 5 x 10 DIN 912-12.9	SW4,0 DIN911	

切槽和镗孔

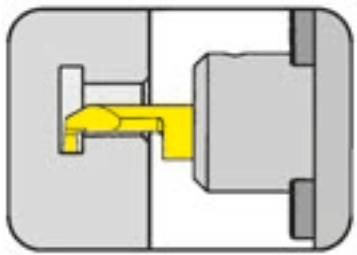
Grooving and Boring



可调刀杆 型号

Adjustable holder

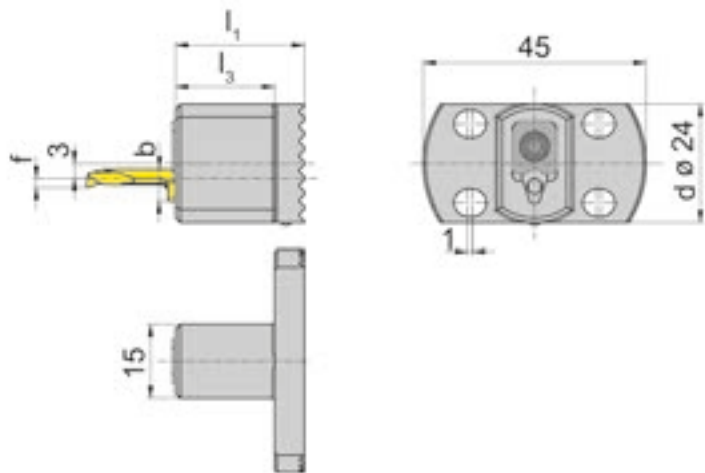
BKT



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2 mm

刀片
Insert

型号 105
Type



产品型号 Part number	l_1	d	l_3	b
BKT105.2445.S.03	26	24	20	5.9
BKT105.2445.S.04	26	24	20	6.4
BKT105.2445.S.05	26	24	20	7.0

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

f见105系列刀片
f see inserts type 105

b = Height of insert

配件

Spare Parts

可调刀杆 型号 Adjustable holder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
BKT105.2445.S.03	010.0105.03	T15PL
BKT105.2445.S.04	010.0105.04	T15PL
BKT105.2445.S.05	010.0105.05	T15PL

切槽和镗孔

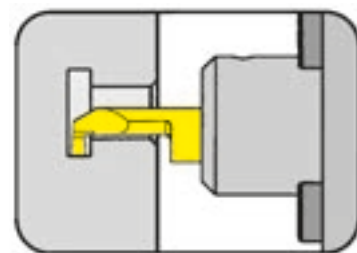
Grooving and Boring



可调刀杆 型号

Adjustable holder

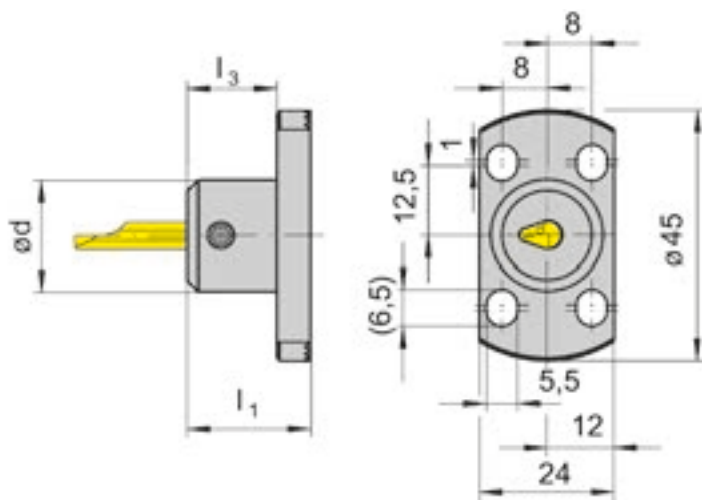
BKT



孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

0.2 mm
2.5 mm
2 mm



刀片
Insert

型号 105
Type

直接冷却液供应
with through coolant supply

R

产品型号 Part number	d	l ₁	l ₃
BKT105.2445.01	20	22	16
BKT105.2445.02	20	32	26

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

注意事项：

如果使用Horn BKT刀夹配合Graf G型 或者Graf N型和Z型，将会没有内冷

Note:

If using cartridge HORN type BKT with basic toolholder Graf G or adaptor Graf type N and Z, no through coolant supply will be possible.

螺丝的扭矩规格，详见技术说明。

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

配件

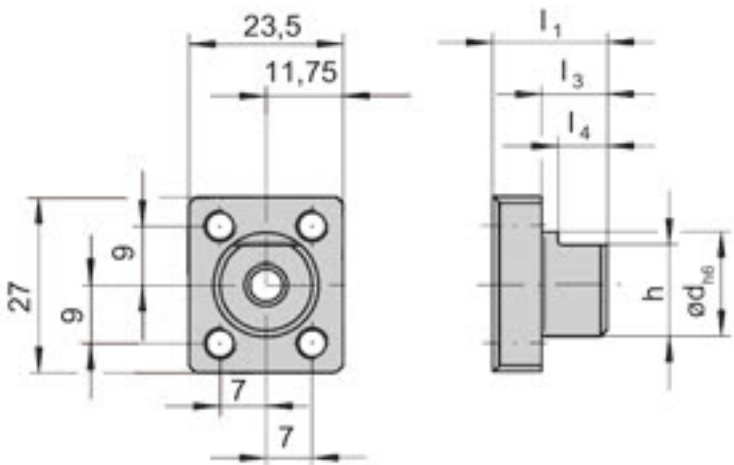
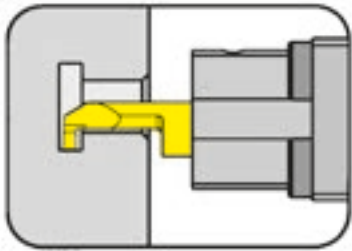
Spare Parts

可调刀杆 型号 Adjustable holder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
BKT105...	6.075T15P	T15PQ

常规刀柄
Basic toolholder

BGT
无刀夹
without cartridge

配合BKT105.2327.01刀杆的可调圆柄
Adjustable round shanks for toolholder BKT105.2327.01



直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	h	l ₃	l ₄	机床型号 Machine type
BGT001.1627.10	16	17.5	14	10	7.5	Star

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	O型圈 O-ring
BGT001.1627.10	M 5 x 10 DIN 912-12.9	SW4,0 DIN911	DIN3770-7x3

切槽和镗孔

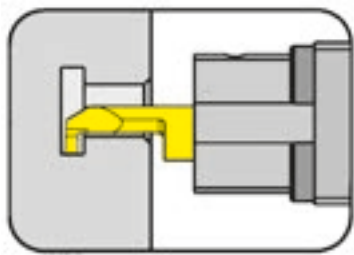
Grooving and Boring



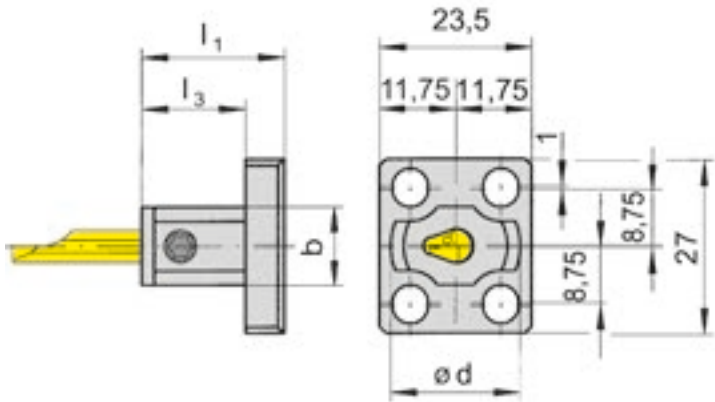
可调刀杆

Adjustable holder

BKT



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2 mm



刀片
Insert

型号 105
Type

直接冷却液供应
with through coolant supply

R

产品型号 Part number	d	l ₁	l ₃	b
BKT105.2327.01	20	22	16	12

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

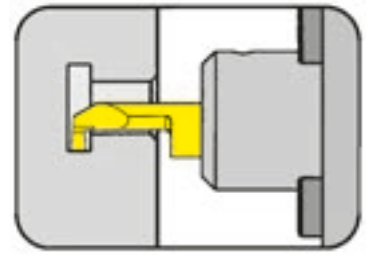
可调刀杆 Adjustable holder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
BKT105.2327.01	6.075T15P	T15PQ

Grooving and Boring

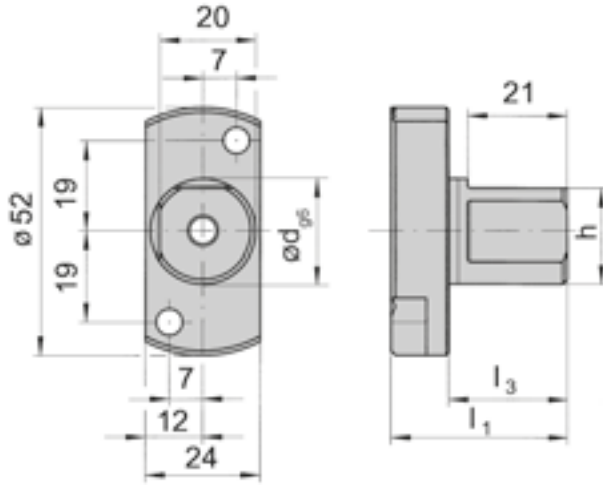


Basic toolholder

无刀夹
without cartridge



配合BKT105.2327.01刀杆的可调圆柄
Adjustable round shanks for toolholder BKT105.2327.01



直接冷却液供应
with through coolant supply

产品型号 Part number	d	l ₁	h	l ₃	l ₄
BGT001.0R22.25	22	37	20	25	21

按需提供更多尺寸
 Further sizes upon request

尺寸单位: mm
Dimensions in mm

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
BGT001.0R22.25	M 5 x 10 DIN 912-12.9	SW4,0 DIN911

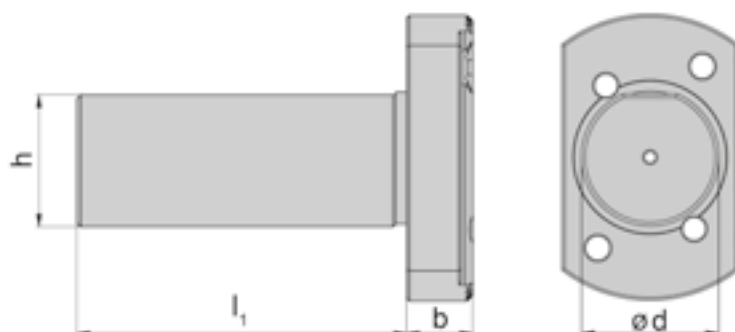
GRAF常规刀柄 型号

Basic toolholder Graf

G
无刀夹
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2
for adjustable holder Graf type N and HORN BKT105.2445.01/02



R

产品型号 Part number	d	l_1	h	b	机床型号 Machine type
G016021	16.00	21	14	6	Star
G016040	16.00	40	14	6	Traub/Manurhin
G034040	3/4"	40	18	6	Citizen
G034050	3/4"	50	18	6	Citizen
G034120	3/4"	120	18	6	Citizen
G020030	20.00	30	18	6	Citizen
G020040	20.00	40	18	6	Hanwha
G020100	20.00	100	18	6	Tornos
G020150	20.00	150	18	6	Manurhin/Tornos
G022023	22.00	23	20	6	Star
G 022 025 SR16/20R	22.00	25	20	12	Star
G022030	22.00	30	20	6	Star
G022030SR32	22.00	30	20	12	Star
G022070	22.00	70	20	6	Star

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

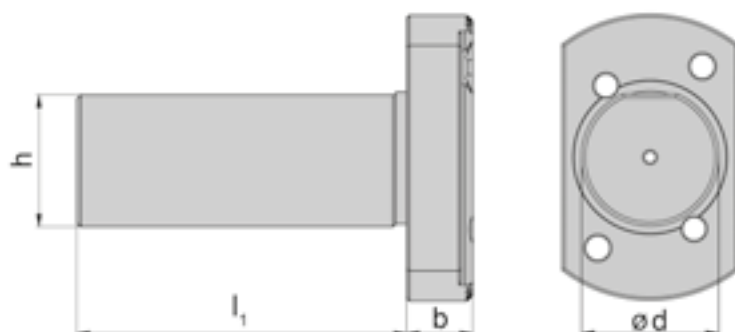
常规刀柄

Basic toolholder Graf

G
无刀夹
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2
for adjustable holder Graf type N and HORN BKT105.2445.01/02



产品型号 Part number	d	l ₁	h	b	机床型号 Machine type
G025060	25	60	23	12	Hanwha
G025070	25	70	23	6	Manurhin/Tornos
G025100	25	100	23	6	Manurhin/Tornos
G025160	25	160	23	6	Manurhin/Tornos
G010060	1"	60	23	6	Citizen
G010100	1"	100	23	6	Citizen
G028006	28	6	26	12	Hanwha
G028080	28	80	26	12	Traub
G030045	30	45	27	12	Maier
G033040	33	40	31	12	Hanwha
G034020	34	20	32	12	Maier
G034044	34	44	32	12	Maier/Hanwha

按需提供更多尺寸
Further sizes upon request

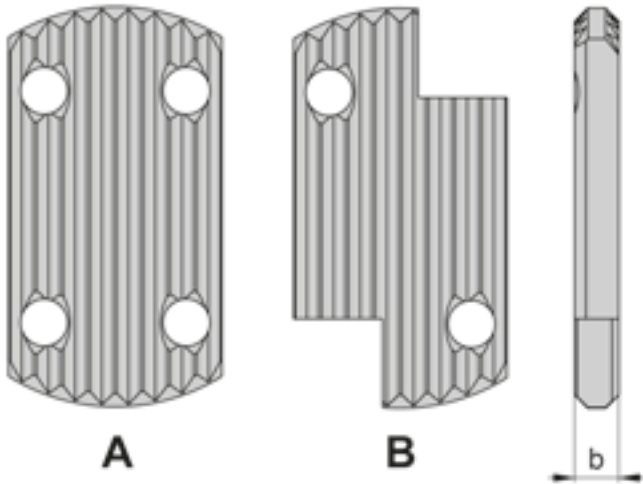
单位：mm和inch
Dimensions in mm and inch

GRAF接头
Adaptor Graf

Z
无刀夹
without cartridge



配合Graf N型可调节刀杆和Horn可调节刀杆BKT105.2445.01/2
for adjustable holder Graf type N and HORN BKT105.2445.01/02



R

产品型号 Part number	b	形式 Form
Z5	5	A
Z10	10	A
Z15	15	A
Z20	20	A
Z25	25	A
Z30	30	A
Z5SR16/20R	5	B
Z10SR16/20R	10	B
Z15SR16/20R	15	B
Z20SR16/20R	20	B
Z25SR16/20R	25	B
Z30SR16/20R	30	B

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

平面间 GRAF Adaptor GRAF

N

无刀夹
without cartridge



用于可调Graf N型或者Horn BKT105.2445.01/02刀柄
for adjustable holder Graf type N and HORN BKT105.2445.01/02

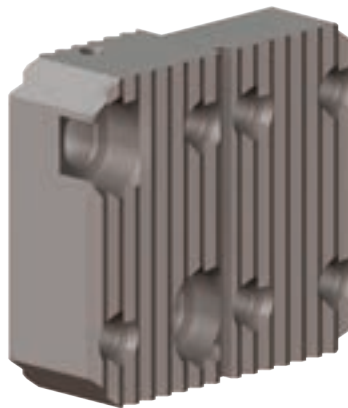
用于背面加工
for back working

产品编号 N11

Part number

适合两刃刀片

For alternatively 2 cartridges

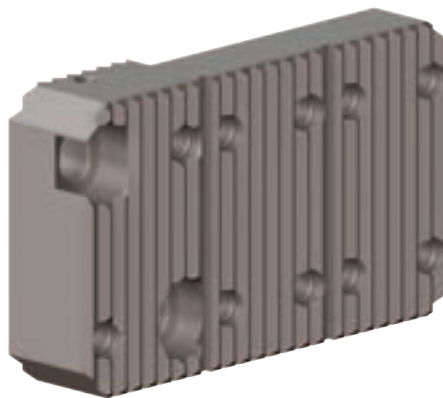


产品编号 N12

Part number

适合三刃刀片

For alternatively 3 cartridges



产品编号 N93IK

Part number

内冷

with through coolant supply

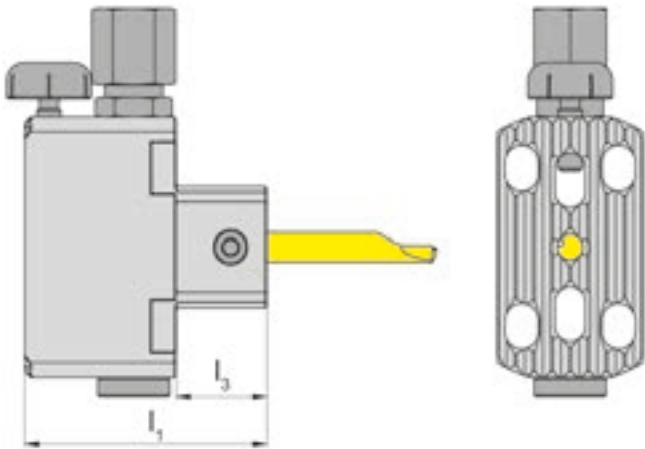


可调刀杆
Adjustable holder

N09IK



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2 mm



刀片
Insert

型号 105
Type

直接冷却液供应
with through coolant supply

产品型号 Part number	l_1	l_3
N09IK	40	15

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

可调刀杆 Adjustable holder	锁紧螺钉 Clamping Screw	高度调节螺钉 Screw to adjust the height	冷却液供应 Coolant supply
N09IK	6.075T15P	002.00.69	004.00.19

可调刀杆
Adjustable holder

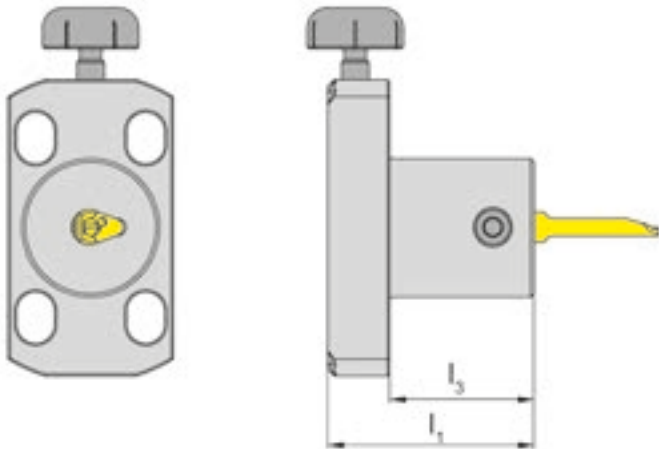
N09



孔径Ø 自	Bore Ø from	0.2 mm
槽深可达	Depth of groove up to	2.5 mm
槽宽可达	Width of groove up to	2 mm

刀片
Insert

型号 105
Type



直接冷却液供应
with through coolant supply

产品型号 Part number	l_1	l_3
N09	30	20

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

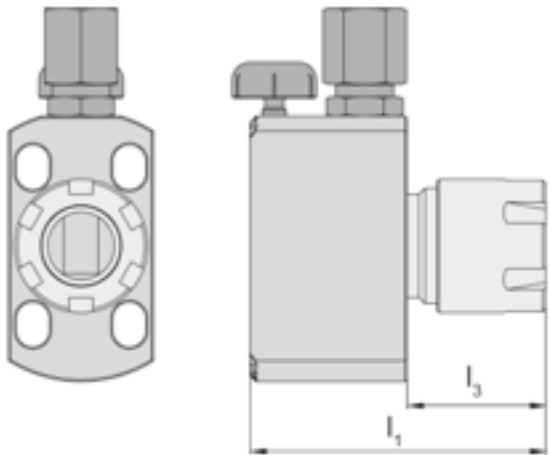
可调刀杆 Adjustable holder	锁紧螺钉 Clamping Screw	高度调节螺钉 Screw to adjust the height
N09	6.075T15P	002.00.69

可调刀杆
Adjustable holder

N



配合Graf ER16/ER20筒夹
with chucking nut ER16 / E20 system Graf



配合常规刀杆
for Basic Toolholder

Typ Horn BGT
Type Graf G

直接冷却液供应
with through coolant supply

R

产品型号 Part number	l_1	l_3	锁紧螺母 Clamping nut
N07IK	54	18	ER16
N41IK	64	26	ER20

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

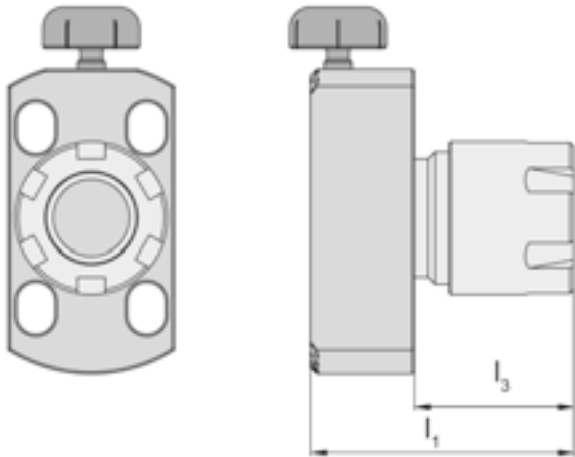
可调刀杆 Adjustable holder	垫圈组D3 Sealing disc set D3	高度调节螺钉 Screw to adjust the height	冷却液供应 Coolant supply
N07IK	64.600.16.3-10	002.00.69	004.00.19
N41IK	64.600.20.3-13	002.00.69	004.00.19

可调刀杆
Adjustable holder

N07



配合Graf系统 ER16 筒夹
with chucking nut ER16 system Graf



产品型号 Part number	l_1	l_3	锁紧螺母 Clamping nut
N07	37	18	ER16

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

可调刀杆 Adjustable holder	高度调节螺钉 Screw to adjust the height	锁紧螺母 Clamping nut
N07	002.00.69	62.000.16

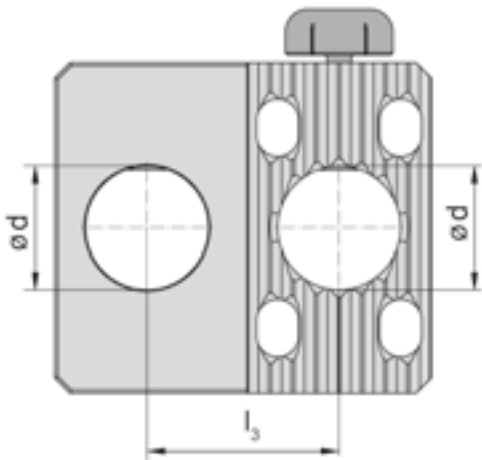
可调刀杆

Adjustable holder

N10



带Graf ER11/ER16夹紧螺母
with chucking nut ER11 / E16 system Graf



R

产品型号 Part number	d	l ₁	l ₃
N10	16	25	25

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

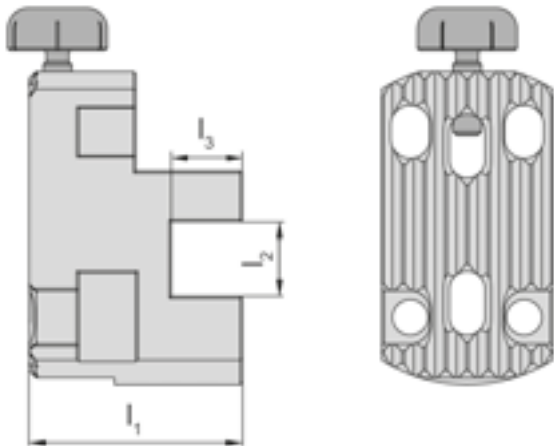
可调刀杆 Adjustable holder	销 Threaded Pin	高度调节螺钉 Screw to adjust the height
N10	002.00.11	002.00.69

可调刀杆
Adjustable holder

N06



配合Graf方刀杆
for square shank system Graf



产品型号 Part number	l_1	l_3	l_2
N06	30	10	10

按需提供更多尺寸
Further sizes upon request

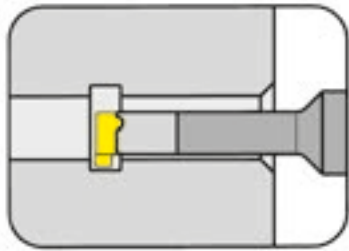
尺寸单位：mm
Dimensions in mm

配件
Spare Parts

可调刀杆 Adjustable holder	销 Threaded Pin	高度调节螺钉 Screw to adjust the height
N06	002.00.11	002.00.69

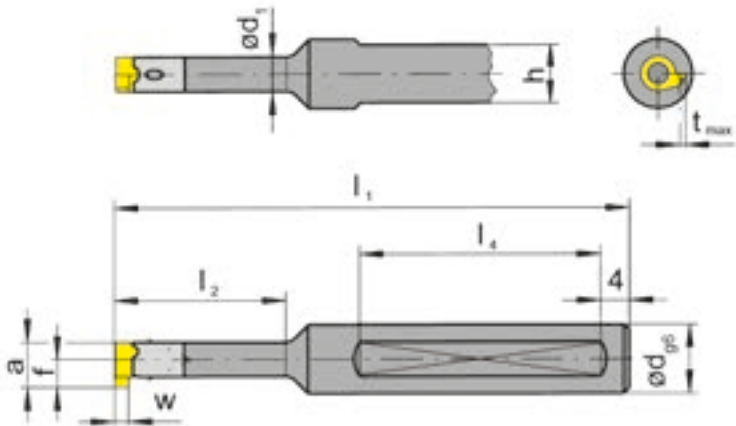
刀杆
Toolholder

B108
直接冷却液供应
with through coolant supply



孔径Ø 自 槽宽可达	Bore Ø from Width of groove up to	8 mm 2 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance



刀片
Insert

型号 S108
Type

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	l ₄	d ₁
B108.0008.00	8	60	12.5	7	35	6
B108.0008.01	8	70	21.0	7	40	6

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左手型或右手型刀片。
HORN可以返修刀杆上损坏的的基座。

Ordering note:
Toolholders can be used with right and left hand inserts. Toolholders with damaged seating can be repaired by HORN.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B108...	2.6.5T8EP	T8PL

切槽和镗孔

Grooving and Boring

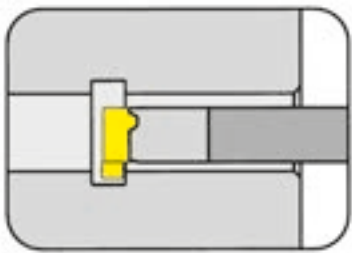


刀杆

Toolholder

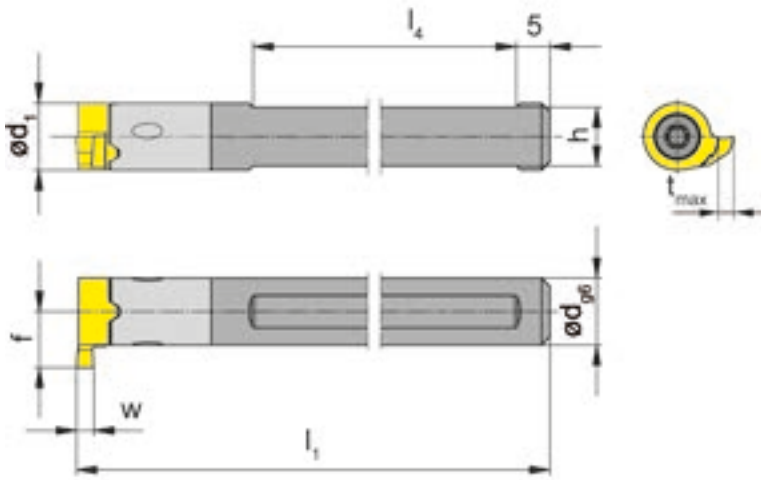
B111

直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	11 mm
槽深	Depth of groove	2.3 mm
槽宽可达	Width of groove up to	3 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance



刀片
Insert

型号 111
Type S111

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄	d ₁
B111.0008.01	8	80	7	55	8

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

订货须知：
Upínací držáky jsou použitelné pro pravé i levé břitové destičky. Upínací držáky s poškozeným lůžkem pro VBD mohou být opraveny našim servisem.

Ordering note:
Toolholders can be used with right and left hand inserts. Toolholders with damaged seating can be repaired by HORN.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B111.0008.01	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

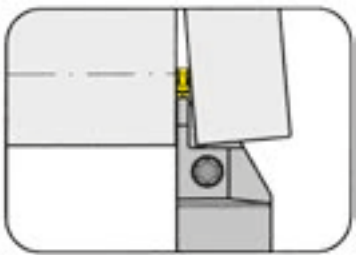


刀杆

Toolholder

H100

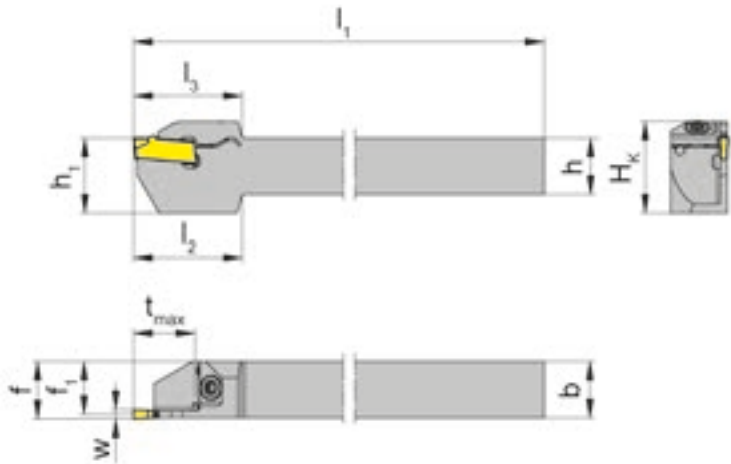
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

17 mm
2-3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片
Insert

型号 S100
Type

适用于Swiss机床
for Swiss type machines

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH100.1212.24.61	12	12	125	23	23	12	11.25	f ₁ +w/2	13	26	19.5	02
R/LH100.1212.32.63	12	12	125	27	24	12	10.85	f ₁ +w/2	17	34	19.5	03
R/LH100.1616.24.61	16	16	125	23	-	16	15.25	f ₁ +w/2	13	26	19.5	02
R/LH100.1616.32.63	16	16	125	27	-	16	14.85	f ₁ +w/2	17	34	19.5	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

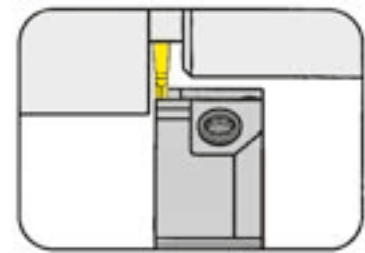


刀杆

Toolholder

H264

螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

4-16 mm
1.5-2 mm

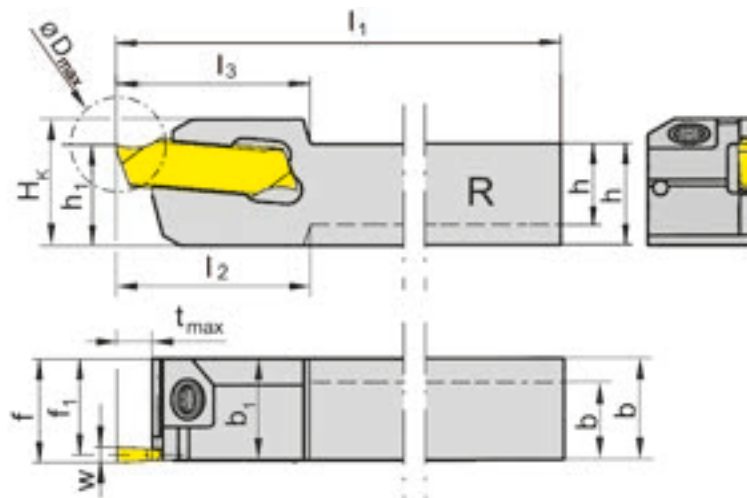
可转位刀片

Indexable insert

型号

264

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

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

注明R或L型

State R or L version

尺寸单位 : mm

Dimensions in mm

螺丝的扭矩规格, 详见技术说明。

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

w见刀片

w see inserts

按需提供更多尺寸

Further sizes upon request

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

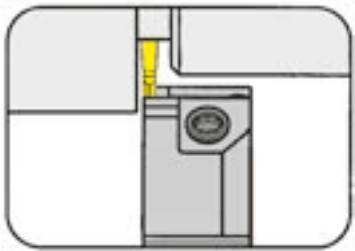


刀杆

Toolholder

H264

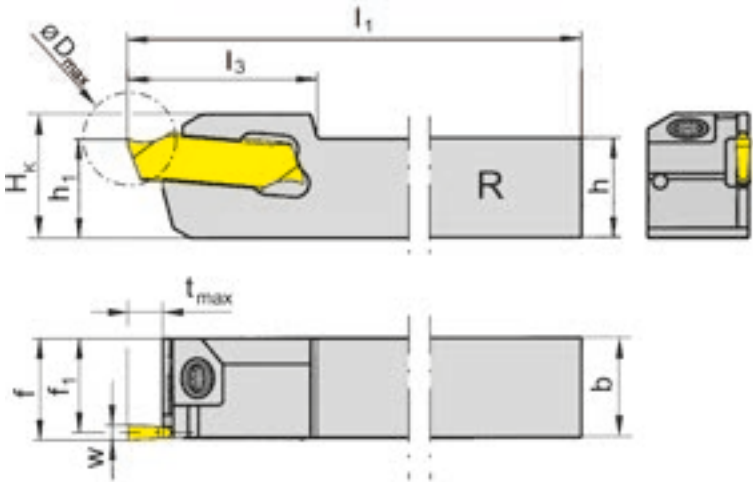
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
2.5 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

可转位刀片
Indexable insert

型号 264
Type

R

产品型号 Part number	h	b	l ₁	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	32	18.5	03
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	32	18.5	03
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	32	18.5	03

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

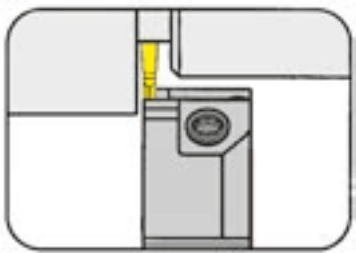


刀杆

Toolholder

H264

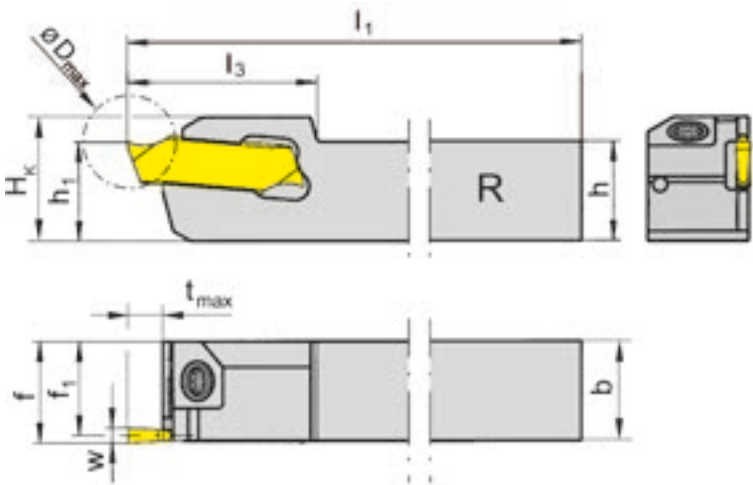
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
3 mm



可转位刀片
Indexable insert

型号 264
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	尺寸规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	32	15	04
R/LH264.1616.04	16	16	120	17.5	16	14.5	16	5	32	19	04
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	32	15	04
R/LH264.1616.14	16	16	120	19.0	16	14.5	16	10	32	19	04
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	32	15	04
R/LH264.1616.24	16	16	120	25.0	16	14.5	16	16	32	19	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

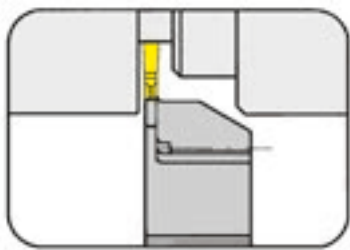
H264

自夹紧
with self clamping

槽深可达
槽宽

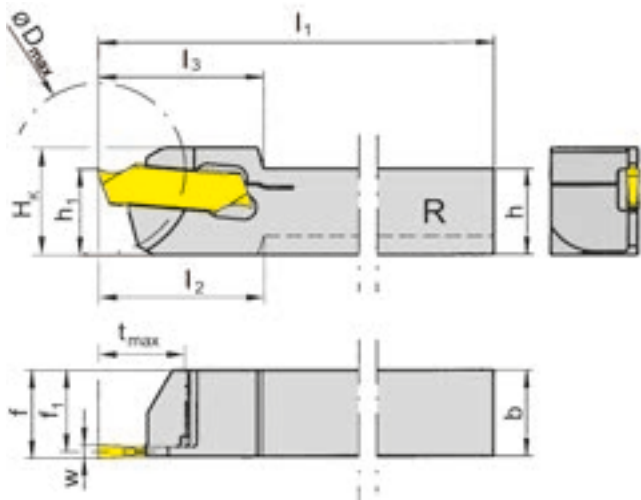
Depth of groove up to
Width of groove

10 mm
1.5-3 mm



可转位刀片
Indexable insert

型号 264
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _K	尺寸规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	32	14.5	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手P39L不包含在刀板中，需单独订购！
Note:
扳手P39L不包含在刀板中，需单独订购！

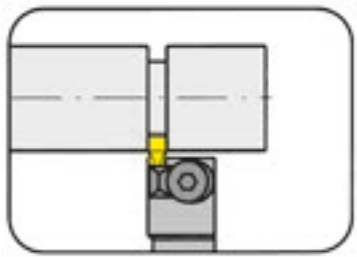
R

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

248



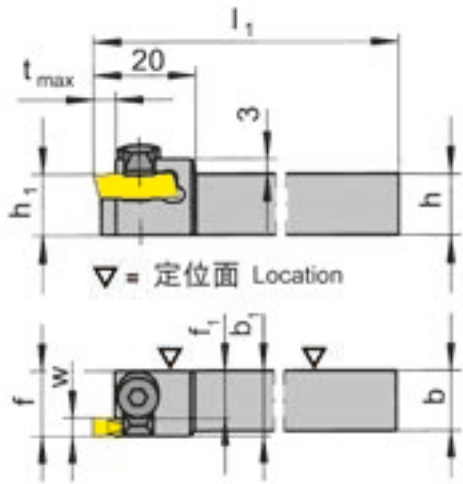
槽深可达
夹持范围

Depth of groove up to
Clamping range

4 mm
0.5 - 2.7 mm

可转位刀片
Indexable insert

型号 217
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L248.1212.01	12	12	95	12	13	1.5	f ₁ +a ₁	4	01	0.5-1.7
R/L248.1212.02	12	12	95	12	13	2.5	f ₁ +a ₁	4	02	1.7-2.7

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w, a₁见刀片
w, a₁ see indexable inserts

尺寸单位 : mm
Dimensions in mm

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

配件
Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L248...	SW2.5 DIN911	8.3

切槽和侧车削

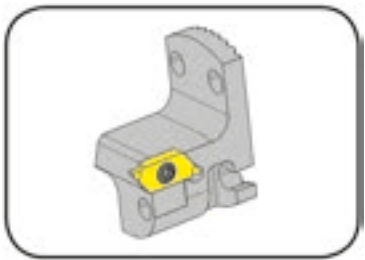
Grooving and Side Turning



刀夹

Cartridge

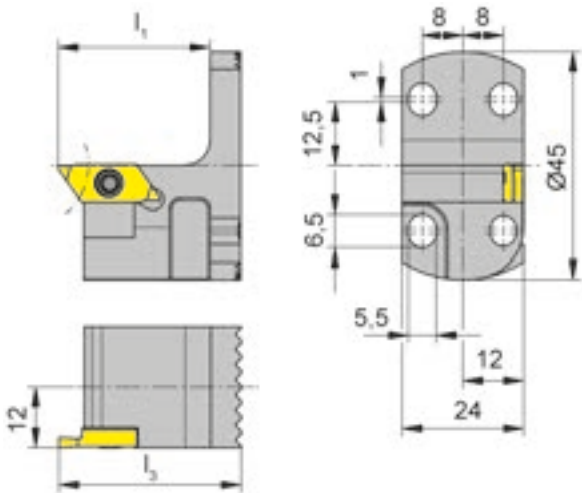
KT274



槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

可转位刀片
Indexable insert

型号 S274
Type

R

产品型号 Part number	l_3	l_1	尺寸规格 Size
R/LKT274.2445.04	36	30	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LKT274.2445.04	030.3509.T15P	T15PQ

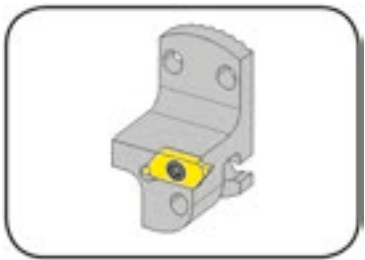
切槽和侧车削

Grooving and Side Turning



刀夹
Cartridge

KTC274



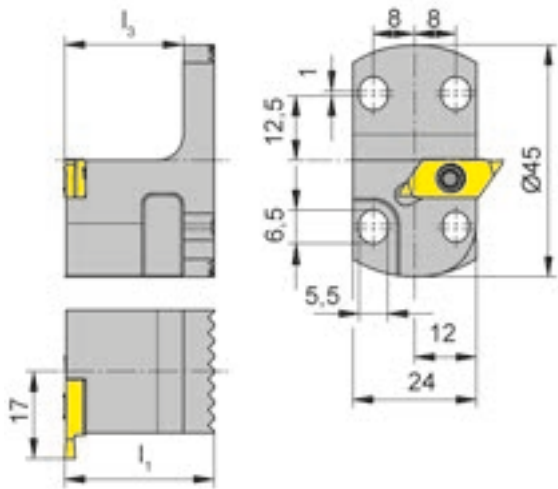
槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.5-3 mm

可转位刀片
Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

产品型号 Part number	l_1	l_3	尺寸规格 Size
RKTC274.2445.04	29	23	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
？

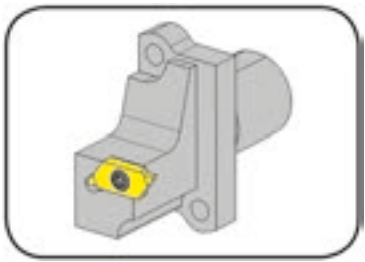
Ordering note:
Use left hand insert in right hand toolholder.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RKTC274.2445.04	030.3509.T15P	T15PQ

刀杆
Toolholder

H274

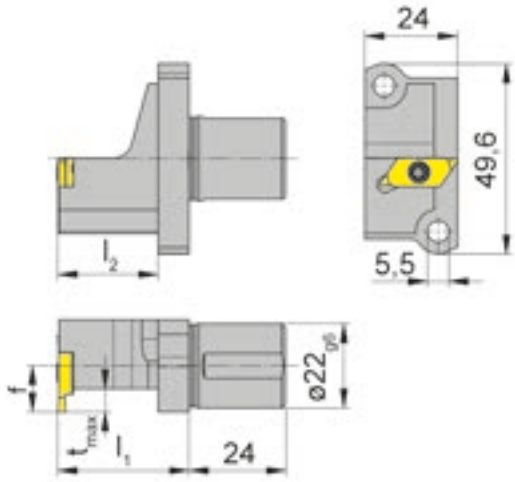


槽深可达
槽宽可达

Depth of groove up to
Width of groove up to

6 mm
7 mm

孔位 13.7 x 37,6 mm
Hole pattern 13.7 x 37,6 mm



可转位刀片
Indexable insert

型号 S274
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于Star Swiss机床
for Swiss type machines Star

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

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆
Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

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

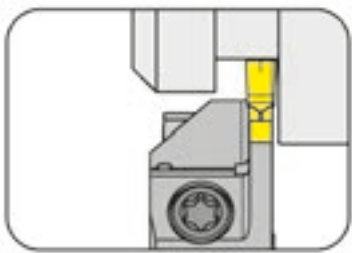
切槽和侧车削 (外圆)

Grooving and Side Turning (external)



刀杆
Toolholder

H224



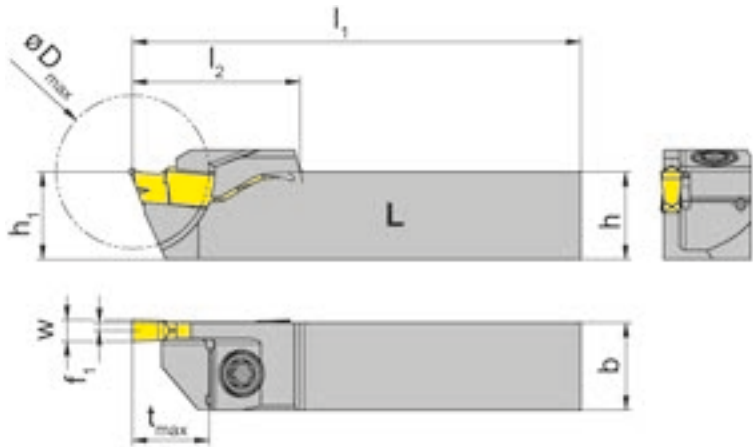
槽深可达
夹持范围

Depth of groove up to
Clamping range

10.5 mm
2-3.7 mm

可转位刀片
Indexable insert

型号 S224
Type NS224



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

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

切槽和侧车削 (内圆)

Grooving and Side Turning (internal)



刀杆

Toolholder

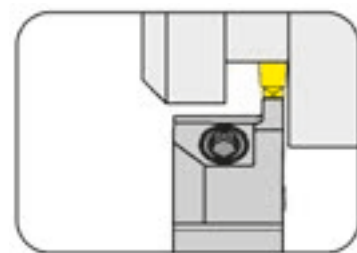
H224

螺钉夹紧
with screwed clamping

槽深可达
夹持范围

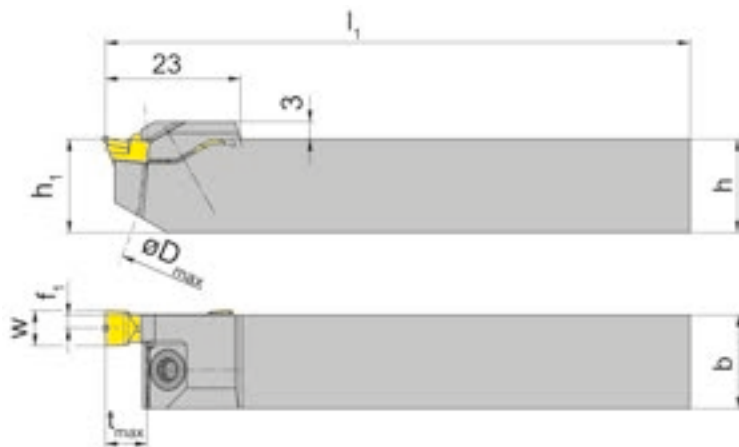
Depth of groove up to
Clamping range

7 mm
2-6,1 mm



可转位刀片
Indexable insert

型号 S224
Type NS224



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1212.61	12	12	100	12	0.70	7	100	01	2.0-2.4
R/LH224.1616.61	16	16	100	16	0.70	7	100	01	2.0-2.4
R/LH224.1212.62	12	12	100	12	0.90	7	100	02	2.4-2.8
R/LH224.1616.62	16	16	100	16	0.90	7	100	02	2.4-2.8
R/LH224.1212.63	12	12	100	12	1.10	7	100	03	2.8-3.7
R/LH224.1616.63	16	16	100	16	1.10	7	100	03	2.8-3.7
R/LH224.1212.64	12	12	100	12	1.45	7	100	04	3.7-4.4
R/LH224.1616.64	16	16	100	16	1.45	7	100	04	3.7-4.4
R/LH224.1616.65	16	16	100	16	1.85	7	100	05	4.4-5.1
R/LH224.1616.66	16	16	100	16	2.25	7	100	06	5.1-6.1

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224....	4.12T15EP	T15PL
R/LH224.1616....	5.13T20EP	T20PQ

切槽和切断

Grooving and Parting Off

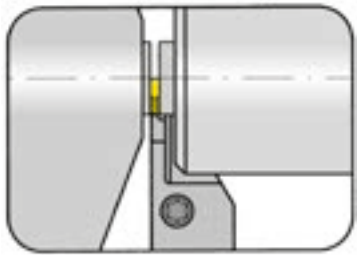


刀杆
Toolholder

368

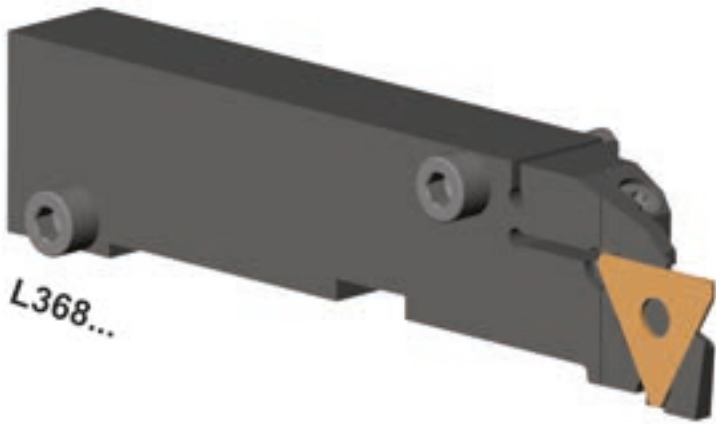
槽深可达	Depth of groove up to	8 mm
槽宽	Width of groove	0.5-1.5 mm

用于机床Tornos
Tool for Tornos



可转位刀片
Indexable insert

型号 312
Type



产品型号 Part number	t _{max}	W _{min}	W _{max}	机床型号 Machine type	刀片 Insert
L368.0710.08	8	0.5	1.2	EvoDECO 10	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1012... 312.0012...
L368.0710.11	8	1.5	1.5	EvoDECO 10	R/L312.0515... 312.0015...

按需提供更多尺寸
 Further sizes upon request
 螺丝的扭矩规格，详见技术说明。
 For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
 Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	TORX PLUS®扳手 TORX PLUS® Wrench	销 Straight pin
L368...	4.18T15EP	SW4,0 DIN911	T15PQ	020.0518.1610

R

切槽和切断

Grooving and Parting Off



常规刀柄

Basic toolholder

760



槽深可达
槽宽

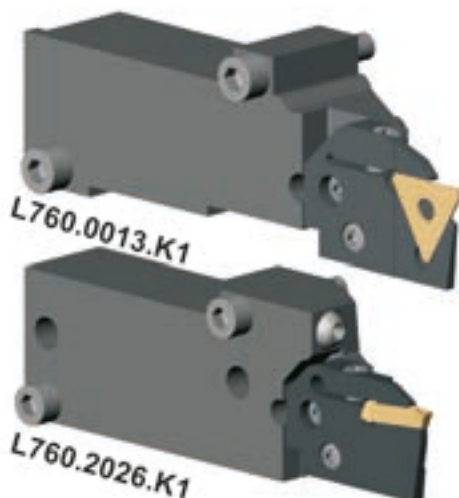
Depth of groove up to
Width of groove

15 mm
0.5-3.7 mm

用于机床Tornos
Tool for Tornos

配合刀夹
for Cassette

型号 LNK368
Type LNK760



R

Bestellnummer Part number	t _{max}	W	机床型号 Machine type	刀夹 Cassette	刀片 Insert
L760.0013.K1	8	0.5 - 1.2	DECO13	LNK368.0760.08	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...
L760.0013.K1	8	1.5	DECO13	LNK368.0760.11	R/L312.0515... 312.0015...
L760.2026.K1	15	2.0 - 2.4 2.4 - 2.8 2.8 - 3.7	DECO20/26	LNK760.0224.01 LNK760.0224.02 LNK760.0224.03	S224...

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	扳手 Allen Wrench
L760...	SW5,0 DIN911

切槽和切断

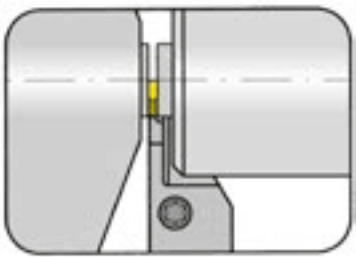
Grooving and Parting Off



刀夹

Cassette

LNK368/LNK760

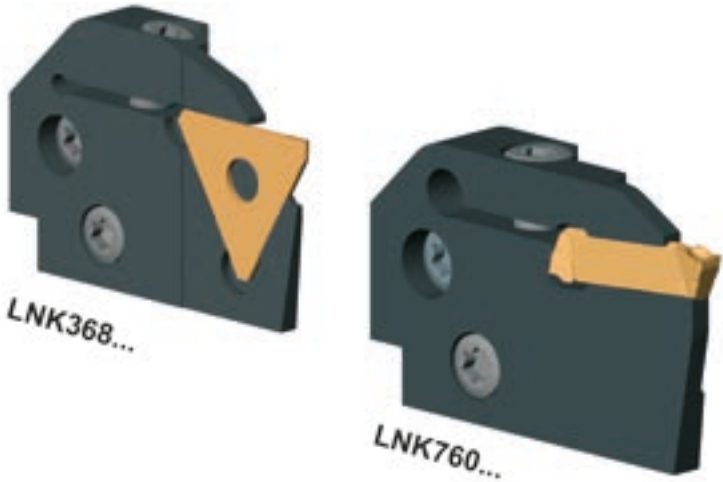


槽深可达 槽宽	Depth of groove up to Width of groove	15 mm 0.5-3.7 mm

用于机床Tornos
Tool for Tornos

可转位刀片
Indexable insert

型号 312
Type S224



产品型号 Part number	t _{max}	W _{min}	W _{max}	机床型号 Machine type	刀片 Insert
LNK368.0760.08	9	0.5	1.2	EvoDECO 16	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...
LNK368.0760.11	9	1.5	1.5	EvoDECO 16	R/L312.0515... 312.0015...
LNK760.0224.01	15	2.0	2.4	EvoDECO 20/EvoDECO 32	S224...
LNK760.0224.02	15	2.4	2.8	EvoDECO 20/EvoDECO 32	S224...
LNK760.0224.03	15	2.8	3.7	EvoDECO 20/EvoDECO 32	S224...

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LNK368.0760...	5.10T20P	T20PQ
LNK760.0224....	5.12T20P	T20PQ

切槽 (外圆)
Grooving (external)



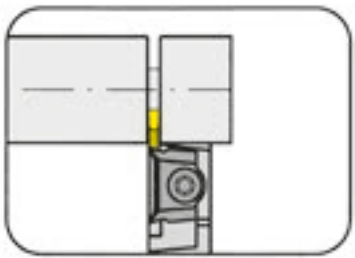
刀杆
Toolholder

361
减小头部尺寸
reduced head size

槽深可达
夹持范围

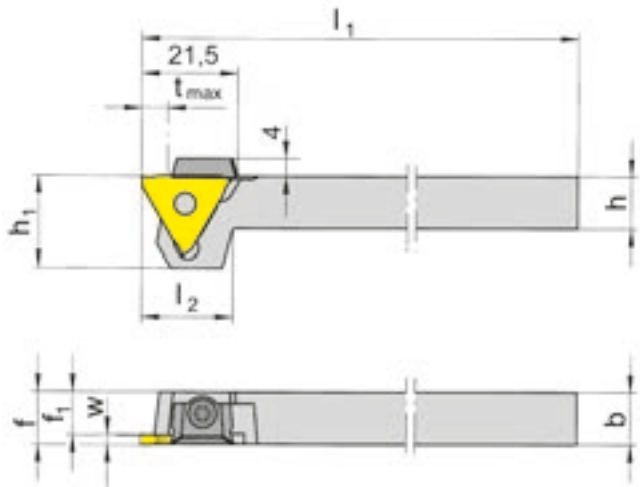
Depth of groove up to
Clamping range

6 mm
0.5-3.9 mm



可转位刀片
Indexable insert

型号 312
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L361.1212.01	12	12	100	17	19	10.5	f ₁ +w-a ₁	4	01	0.5-1.9
R/L361.1212.02	12	12	100	17	19	9.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L361.1212.03	12	12	100	21	21	8.5	f ₁ +w-a ₁	6	03	2.9-3.9

注明R或L型
State R or L version

w, a₁见刀片
w, a₁ see indexable inserts

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

只有当工件直径 $\varnothing \leq 40\text{mm}$ 时才能达到t_{max}
t_{max} can be reached only with workpiece $\varnothing \leq 40\text{ mm}$

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

配件
Spare Parts

刀杆 Toolholder	压板 Clamping element	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L361...	12.3	030.0422.T10P	T10PL

切断
Parting Off



刀杆
Toolholder

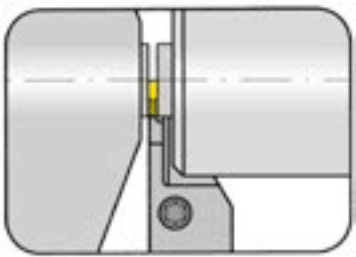
368

槽深可达
槽宽

Depth of groove up to
Width of groove

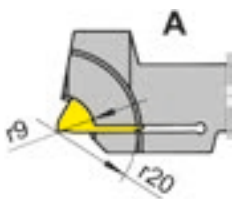
8 mm
0.5-1.5 mm

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

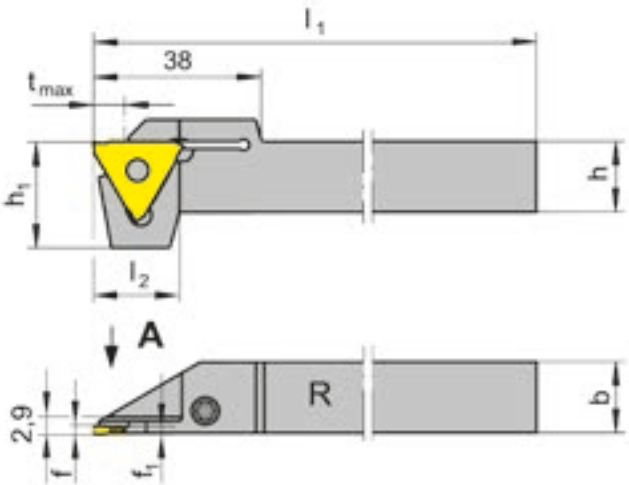


可转位刀片
Indexable insert

型号 312 w ≤ 1.5 mm
Type



仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}
R/L368.1212.08	12	12	95	19.5	24	1.0	f_1+a_1	8
R/L368.1616.08	16	16	95	19.5	24	1.0	f_1+a_1	8
R/L368.1212.11	12	12	95	19.5	24	1.3	f_1+a_1	8
R/L368.1616.11	16	16	95	19.5	24	1.3	f_1+a_1	8

注明R或L型
State R or L version

a1见刀片
a1 see indexable inserts

尺寸单位：mm
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210.../ R/L312.0012...

Toolholder R/L368...08 for indexable inserts:
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210.../ R/L312.0012...

刀杆R/L368...11适合安装以下刀片：
R/L312.0515... / R/L312.0015...V1
Toolholder R/L368...11 for indexable inserts:
R/L312.0515... / R/L312.0015...V1

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368...	4.15T15P	T15PQ

切槽和车削

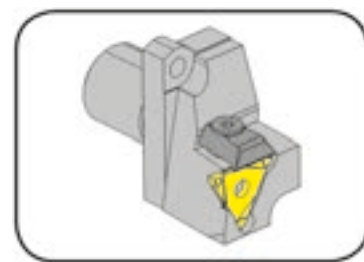
Grooving and Turning



刀杆

Toolholder

369

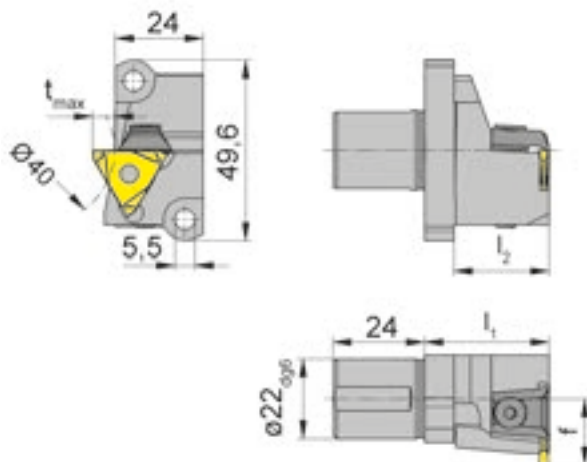


槽深
夹持范围

Depth of groove
Clamping range

4-6 mm
0.5-2.9 mm

孔位 13.7 x 37,6 mm
Hole pattern 13.7 x 37,6 mm



可转位刀片
Indexable insert

型号 312
Type

L=左手型-如图
L = left hand version shown

适用于Star Swiss机床
for Swiss type machines Star

产品型号 Part number	l_2	f	t_{max}	l_1	尺寸规格 Size	夹持范围 Clamping range
L369.A022.18.01	26	18.2	4	34	01	0.5-1.9
L369.A022.18.02	26	18.2	6	34	02	1.9-2.9

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

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

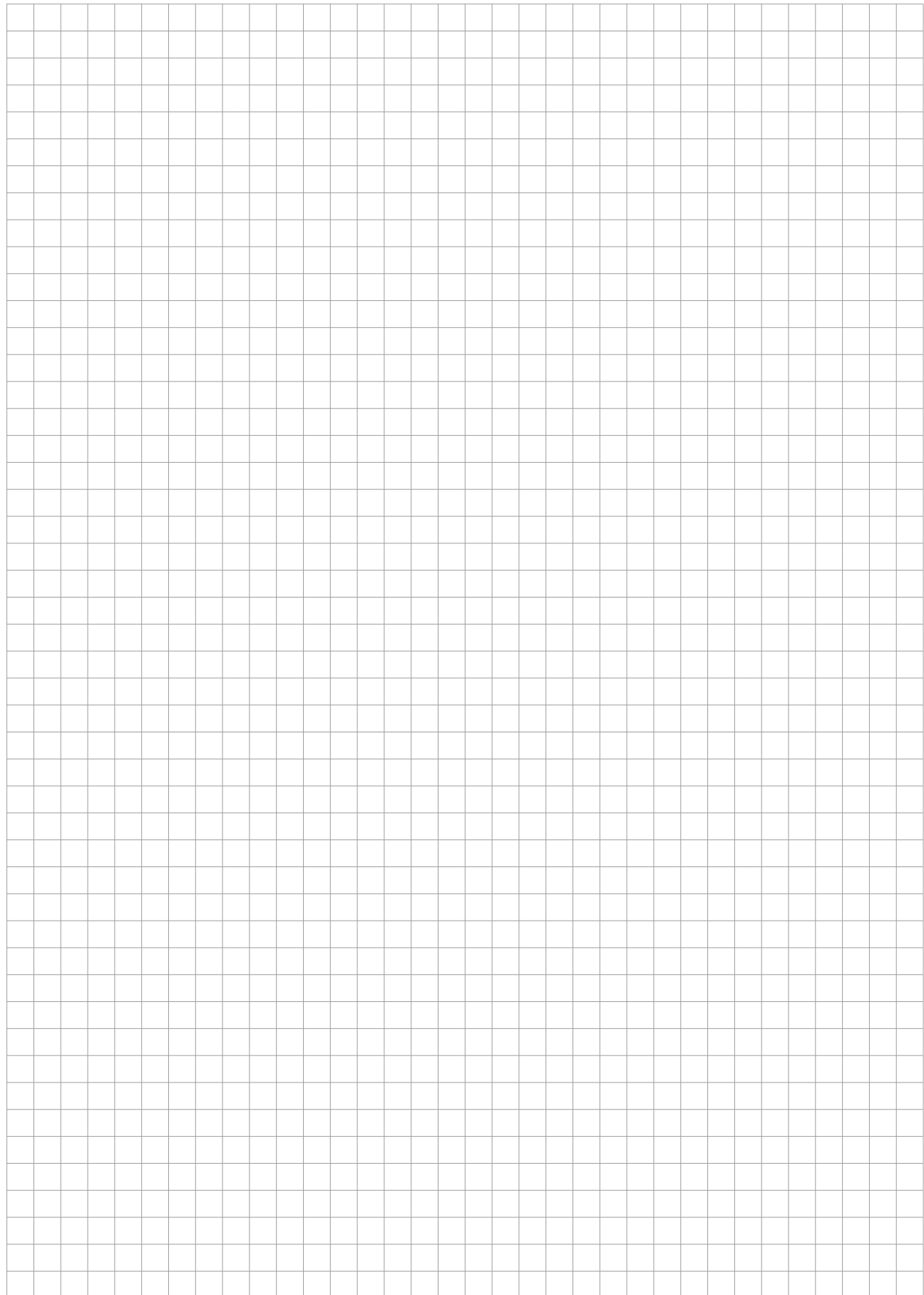
适用于Star Swiss机床: ECAS-12/20. SB16D/E, SR-20. SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RIII
Swiss Type Machines Star: ECAS-12/20. SB16D/E, SR-20. SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RII

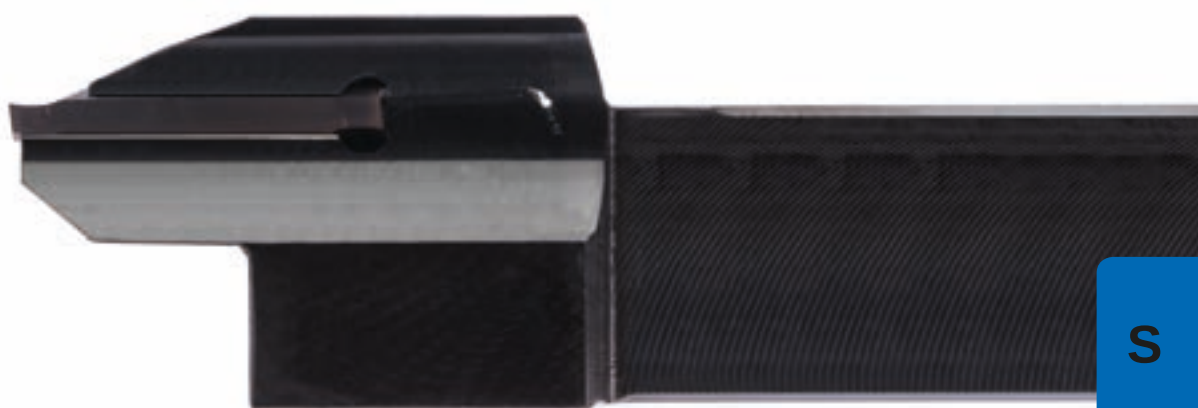
配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
L369...	SW3.0 DIN911	16.4

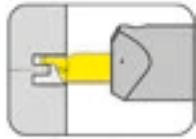
R





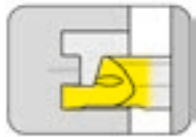
系列/System	页/Page
105	S2
110	S16
114	S22
15A/25A	S34
224	S44
229	S62
231	S90
312	S96
A315	S102

刀杆
Toolholder
B105/BU105



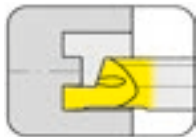
页/Page
S4-S5

刀杆
Toolholder
H105/HC105/VDI



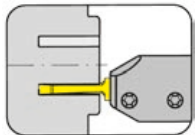
页/Page
S6-S8

刀片
Insert
105/A105



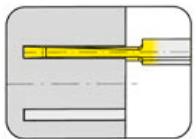
页/Page
S9-S13

刀杆
Toolholder
B105



页/Page
S14

刀片
Insert
A105



页/Page
S15

105



S

机夹式刀杆

槽宽 2 - 3 mm

Toolholder with Inserts

Width of groove 2 - 3 mm

端面切槽

Face Grooving

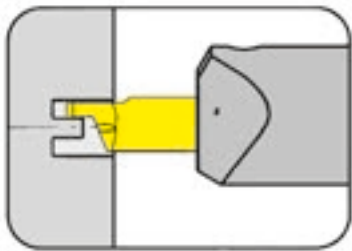


刀杆

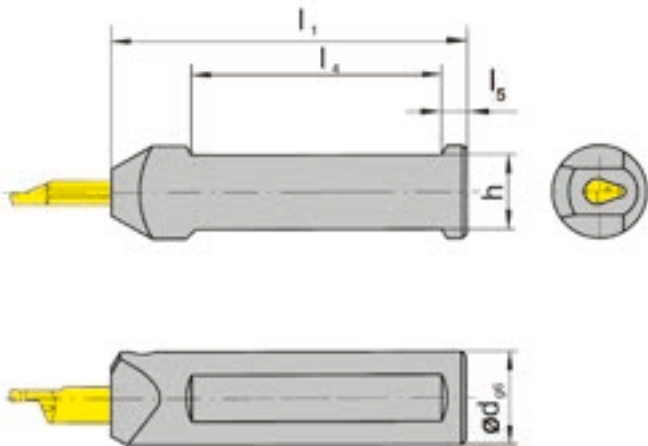
Toolholder

B105

直接冷却液供应
with through coolant supply



端面槽起始外径	from outer groove Ø	5 mm
槽深	Depth of groove	6 mm
槽宽可达	Width of groove up to	2 mm



配合刀片
for Insert

型号 105
Type

图示=左手型切削
Picture = left hand cutting version

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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左，右手刀片

Ordering note:
Toolholders can be used with right and left hand inserts.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

端面切槽

Face Grooving

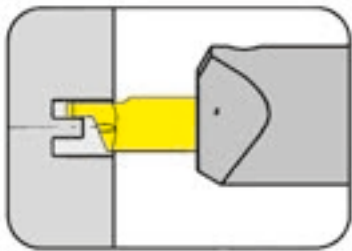


刀杆

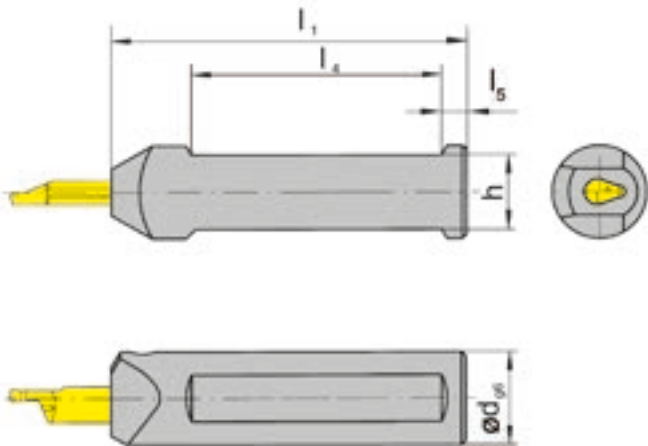
Toolholder

B105

直接冷却液供应
with through coolant supply



端面槽起始外径	from outer groove Ø	5 mm
槽深可达	Depth of groove up to	6 mm
槽宽可达	Width of groove up to	2 mm



配合刀片
for Insert

型号 105
Type

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄
B105.0022.01	22.00	90	20.00	55
B105.0028.01	28.00	120	26.00	72
BU105.0750.5.01	0.75	90	17.04	70
BU105.1000.5.01	1.00	90	23.40	65

按需提供更多尺寸
Further sizes upon request

不包含M12×1.5内冷接纳器
Adapter of cooling M12x1,5 Coolant supply is not included.

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左，右手刀片

Ordering note:
Toolholders can be used with right and left hand inserts.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

端面切槽

Face Grooving

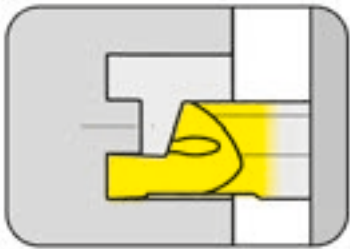


刀杆

Toolholder

H105

螺钉夹紧
with screwed clamping

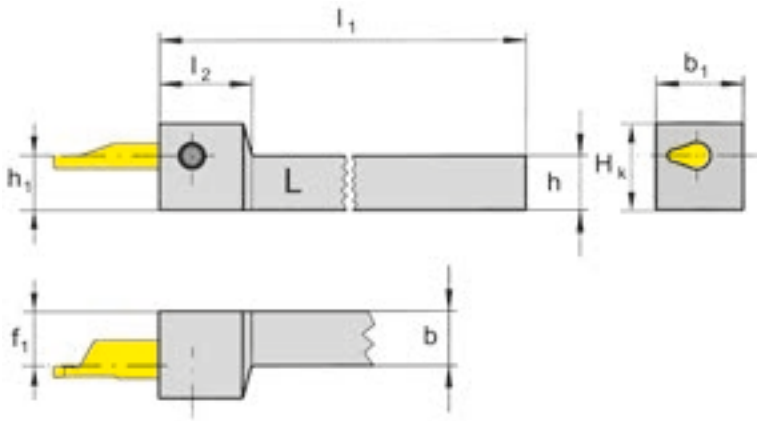


端面槽起始外径	from outer groove Ø	5 mm
槽深可达	Depth of groove up to	6 mm
槽宽可达	Width of groove up to	3 mm

直接冷却液供应
with through coolant supply

配合刀片
for Insert

型号 105
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f ₁	H _k	l ₂
R/LH105.0808.01	8	8	90	8	16	7.5	14	17
R/LH105.1010.01	10	10	90	10	16	7.5	16	17
R/LH105.1212.01	12	12	90	12	16	7.5	18	17
R/LH105.1616.01	16	16	110	16	16	7.5	22	17

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

端面切槽

Face Grooving

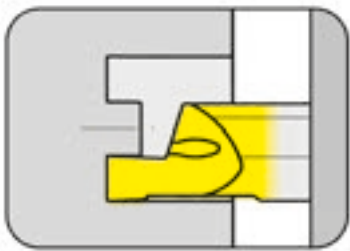


刀杆

Toolholder

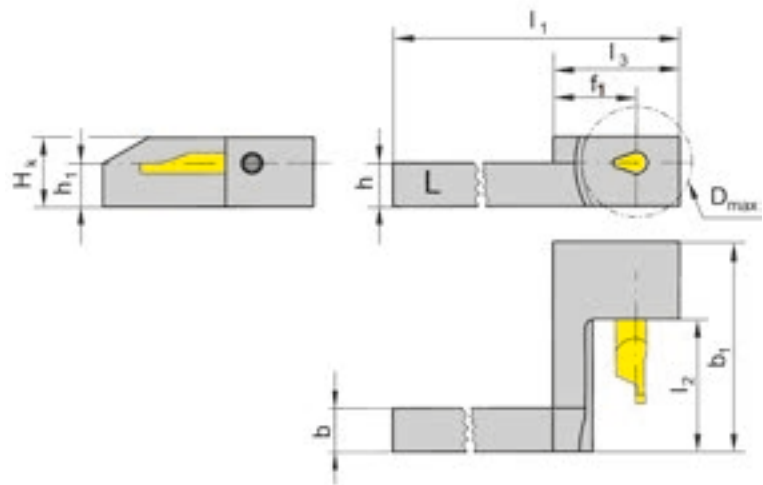
HC105

螺钉夹紧
with screwed clamping



端面槽起始外径	from outer groove Ø	5 mm
槽深可达	Depth of groove up to	6 mm
槽宽可达	Width of groove up to	3 mm

通过曲型接头供给冷却液
Coolant supply through cranked fitting



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

配合刀片
for Insert

型号 105
Type

产品型号 Part number	h	b	l ₁	l ₃	h ₁	b ₁	f ₁	D _{a max}	H _K	l ₂
R/LHC105.0707.21	7	7	99	29	7	32.0	19	26	13	18
R/LHC105.0808.21	8	8	99	29	8	32.0	19	26	13	18
RHC105.1010.11	10	10	99	29	10	22.7	19	26	16	8
R/LHC105.1010.21	10	10	99	29	10	38.0	19	26	16	18
R/LHC105.1010.41	10	10	99	29	10	48.0	19	26	16	28
R/LHC105.1212.21	12	12	99	29	12	38.0	19	26	18	18
R/LHC105.1212.41	12	12	99	29	12	48.0	19	26	18	28
R/LHC105.1616.21	16	16	104	34	16	38.0	24	36	22	18
R/LHC105.1616.41	16	16	104	34	16	48.0	24	36	22	28

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
注意事项：

R/LHC105.07.../.08.../.1010.11 =无内冷!

Note:
R/LHC105.07.../.08.../.1010.11 = no through coolant supply!
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	旋紧型角度接头 SMC angled screw coupling
R/LHC105...07/08/10	6.075T15P	T15PQ	-
R/LHC105....	6.075T15P	T15PQ	KQ2L06-M5

端面切槽

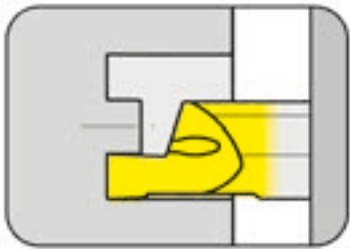
Face Grooving



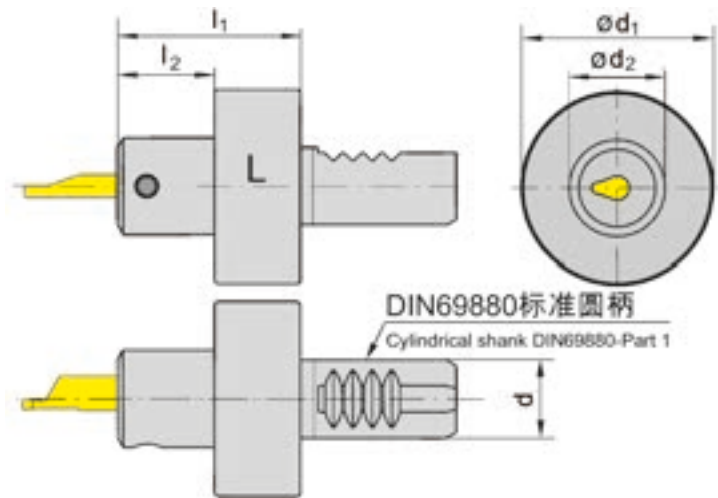
刀杆

Toolholder

VDI
直接冷却液供应
with through coolant supply



端面槽起始外径	from outer groove Ø	5 mm
槽深可达	Depth of groove up to	6 mm
槽宽可达	Width of groove up to	3 mm



配合刀片
for Insert

型号 105
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	d	l ₁	l ₂	d ₂	d ₁
VDI16.L105.20.01	16	38	20	20	40
VDI16.R105.20.01	16	38	20	20	40
VDI20.L105.20.01	20	38	20	20	50
VDI20.R105.20.01	20	38	20	20	50
VDI25.L105.20.01	25	38	20	20	58
VDI25.R105.20.01	25	38	20	20	58
VDI30.L105.20.01	30	38	20	20	68
VDI30.R105.20.01	30	38	20	20	68
VDI40.L105.20.01	40	38	20	20	83
VDI40.R105.20.01	40	38	20	20	83

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
VDI16...	6.075T15P	T15PQ

端面切槽

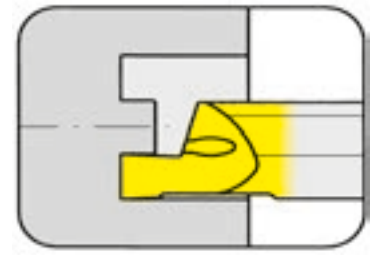
Face Grooving



刀片

Insert

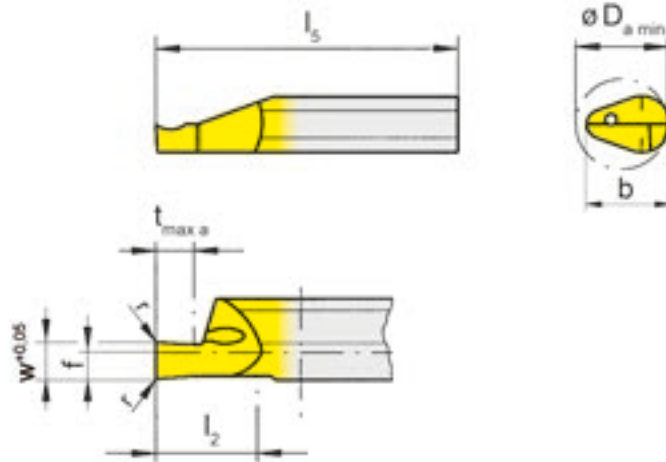
105



端面槽起始外径
槽深
槽宽可达

from outer groove $\varnothing$
Depth of groove
Width of groove up to

5 mm
5 mm
2 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	f	b	l_2	l_5	$t_{max a}$	$D_{a min}$		MG12	EG35	Ti25
R/L105.0510.1.8	1.0	0.05	2	7	10	25	2	5		▲/▲	▲/▲	▲/▲
R/L105.0515.1.8	1.5	0.05	2	7	10	25	3	5		▲/▲	▲/▲	▲/▲
R/L105.0520.1.8	2.0	0.05	2	7	10	25	5	5		▲/Δ	▲/▲	▲/▲
R/L105.0510.2.8	1.0	0.05	2	7	15	35	2	5		Δ/Δ	▲/Δ	▲/▲
R/L105.0515.2.8	1.5	0.05	2	7	15	35	3	5		Δ/Δ	▲/▲	▲/▲
R/L105.0520.2.8	2.0	0.05	2	7	15	35	5	5		Δ/Δ	▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request										P	o	•
● 推荐 / recommended										M	-	•
o 次推荐 / alternative recommendation										K	-	o
- 不合适 / not suitable										N	-	-
■ 非涂层 / uncoated grades										S	-	•
■ 涂层 / coated grades										H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

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

硬质合金牌号
Carbide grades

S

端面切槽

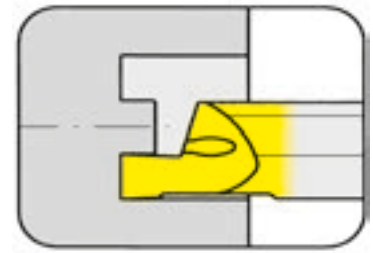
Face Grooving



刀片

Insert

105



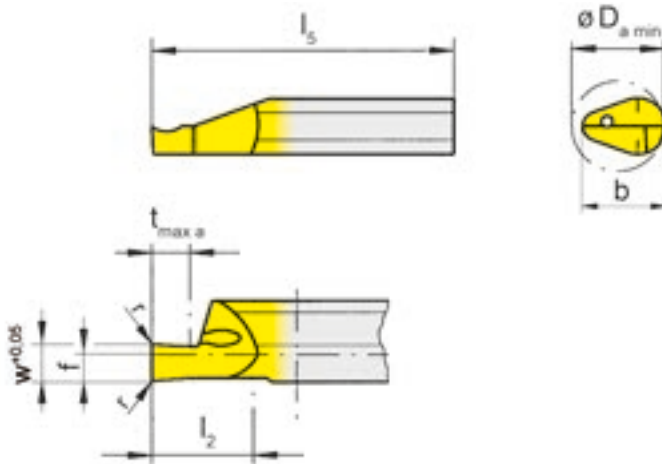
端面槽起始外径
槽深
槽宽可达

from outer groove $\varnothing$
Depth of groove
Width of groove up to

6 mm
5 mm
2 mm

配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	f	b	l_2	l_5	$t_{max a}$	$D_{a min}$		MG12	EG35	TI25
R/L105.0610.1.8	1.0	0.05	2	7	10	25	2	6		▲/△	▲/▲	▲/▲
R/L105.0615.1.8	1.5	0.05	2	7	10	25	3	6		▲/△	▲/▲	▲/▲
R/L105.0620.1.8	2.0	0.05	2	7	10	25	5	6		▲/△	▲/▲	▲/▲
R/L105.0610.2.8	1.0	0.05	2	7	15	35	2	6		▲/△	▲/△	▲/▲
R/L105.0615.2.8	1.5	0.05	2	7	15	35	3	6		▲/△	▲/△	▲/▲
R/L105.0620.2.8	2.0	0.05	2	7	15	35	5	6		▲/△	▲/▲	▲/▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request										P	o	•
● 推荐 / recommended										M	-	•
o 次推荐 / alternative recommendation										K	-	o
- 不合适 / not suitable										N	-	-
■ 非涂层 / uncoated grades										S	-	•
■ 涂层 / coated grades										H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

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

硬质合金牌号
Carbide grades

端面切槽

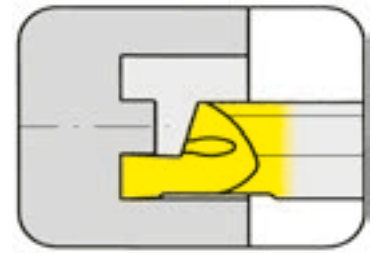
Face Grooving



刀片

Insert

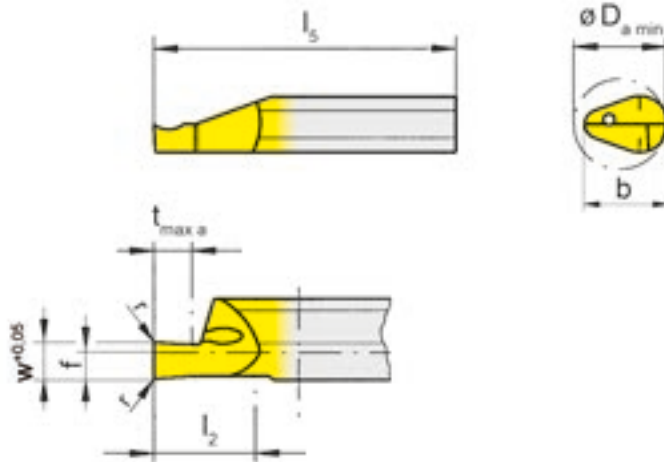
105



端面槽起始外径	from outer groove $\varnothing$	8 mm
槽深	Depth of groove	6 mm
槽宽可达	Width of groove up to	3 mm

配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	f	b	l_2	l_5	$t_{\max a}$	$D_{a \min}$	EG35	TI25
R/L105.0810.1.8	1.0	0.15	2	7	10	25	2	8	▲/▲	▲/▲
R/L105.0815.1.8	1.5	0.15	2	7	10	25	3	8	▲/▲	▲/▲
R/L105.0820.1.8	2.0	0.15	2	7	10	25	4	8	▲/▲	▲/▲
R/L105.0825.1.8	2.5	0.15	2	7	10	25	5	8	▲/▲	▲/▲
R/L105.0830.1.8	3.0	0.15	2	7	10	25	6	8	▲/▲	▲/▲
R/L105.0810.2.8	1.0	0.15	2	7	15	35	2	8	▲/▲	▲/▲
R/L105.0815.2.8	1.5	0.15	2	7	15	35	3	8	▲/▲	▲/▲
R/L105.0820.2.8	2.0	0.15	2	7	15	35	4	8	▲/▲	▲/▲
R/L105.0825.2.8	2.5	0.15	2	7	15	35	5	8	▲/▲	▲/▲
R/L105.0830.2.8	3.0	0.15	2	7	15	35	6	8	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

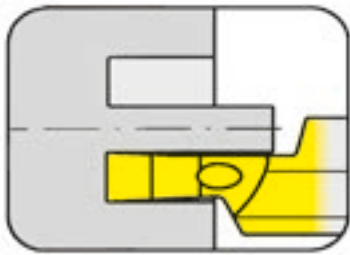
S

端面切槽
Face Grooving

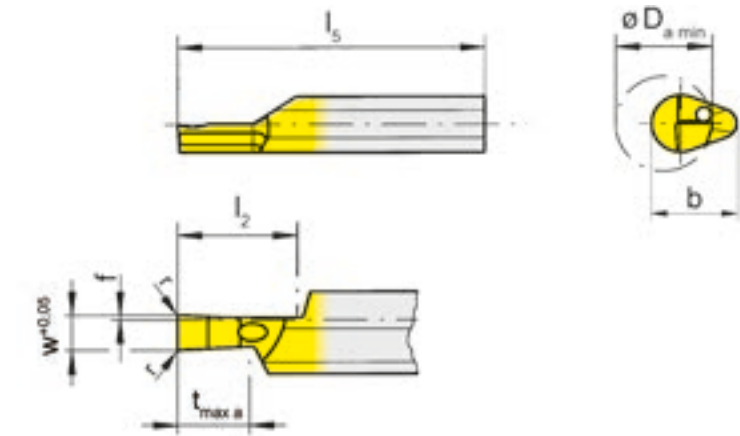


刀片
Insert

105



端面槽起始外径	from outer groove $\varnothing$	8 mm
槽深	Depth of groove	6 mm
槽宽可达	Width of groove up to	3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	f	b	l ₂	l ₅	t _{max a}	D _{a min}		EG35	TI25	
R/L105.0810.1.9	1.0	0.15	0.4	7	10	25	2	8		▲/▲	▲/▲	
R/L105.0815.1.9	1.5	0.15	0.4	7	10	25	3	8		▲/▲	▲/▲	
R/L105.0820.1.9	2.0	0.15	0.4	7	10	25	4	8		▲/▲	▲/▲	
R/L105.0825.1.9	2.5	0.15	0.4	7	10	25	5	8		▲/▲	▲/▲	
R/L105.0830.1.9	3.0	0.15	0.4	7	10	25	6	8		▲/▲	▲/▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request										P	●	●
● 推荐 / recommended										M	●	●
o 次推荐 / alternative recommendation										K	o	●
- 不合适 / not suitable										N	-	●
非涂层 / uncoated grades										S	-	●
涂层 / coated grades										H	-	-
钎焊/金属陶瓷 / brazed/Cermet												

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

硬质合金牌号
Carbide grades

端面切槽

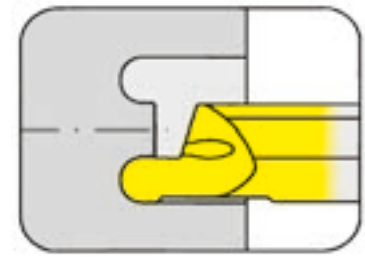
Face Grooving



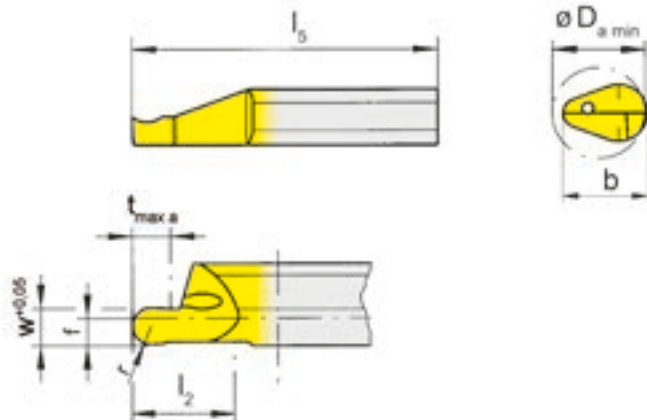
刀片

Insert

105



端面槽起始外径	from outer groove $\varnothing$	8 mm
槽深	Depth of groove	6 mm
槽宽可达	Width of groove up to	3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

圆头
Full radius

产品型号 Part number	w	r	f	b	l_2	l_5	$t_{\max a}$	$D_{a \min}$	EG35	TI25
R/L105.8V10.1.8	1.0	0.50	2	7	10	25	2	8	▲/▲	▲/▲
R/L105.8V16.1.8	1.6	0.80	2	7	10	25	3	8	▲/▲	▲/▲
R/L105.8V20.1.8	2.0	1.00	2	7	10	25	4	8	▲/▲	▲/▲
R/L105.8V25.1.8	2.5	1.25	2	7	10	25	5	8	▲/Δ	▲/▲
R/L105.8V30.1.8	3.0	1.50	2	7	10	25	6	8	▲/▲	▲/▲
R/L105.8V10.2.8	1.0	0.50	2	7	15	35	2	8	▲/▲	▲/▲
R/L105.8V16.2.8	1.6	0.80	2	7	15	35	3	8	▲/Δ	▲/▲
R/L105.8V20.2.8	2.0	1.00	2	7	15	35	4	8	▲/▲	▲/▲
R/L105.8V25.2.8	2.5	1.25	2	7	15	35	5	8	▲/Δ	▲/Δ
R/L105.8V30.2.8	3.0	1.50	2	7	15	35	6	8	▲/Δ	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

端面切槽

Face Grooving

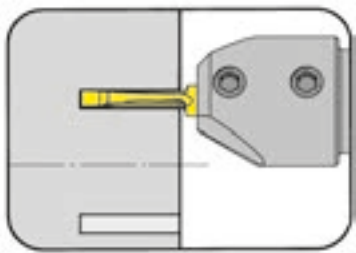


刀杆

Toolholder

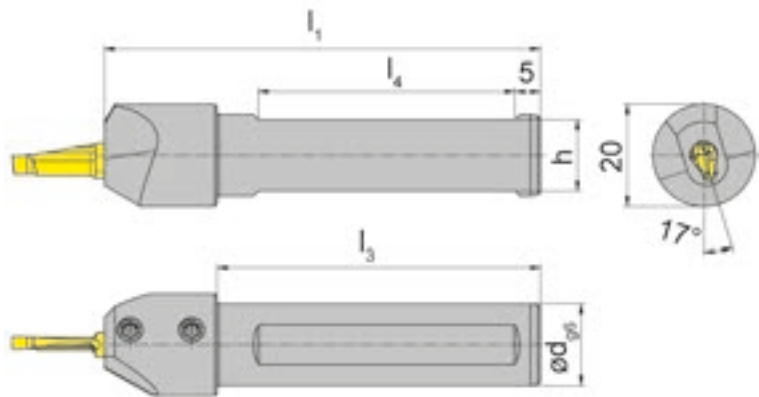
B105

直接冷却液供应
with through coolant supply



端面槽起始外径	from outer groove Ø	10 mm
槽深	Depth of groove	15 mm
槽宽	Width of groove	2-3 mm

加长型刀杆
Extended depth of insert seat



配合刀片
for Insert

型号 A105...2.2
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	d	l ₁	l ₃	h	l ₄
R/LB105.0016.12.2	16	85	63	14	50
R/LB105.0020.12.2	20	100	-	18	55

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

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB105...	6.075T15P	T15PQ

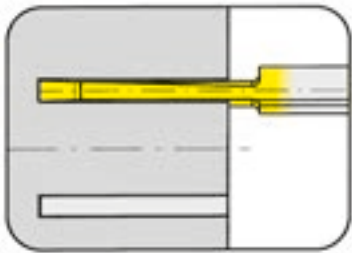
端面切槽

Face Grooving

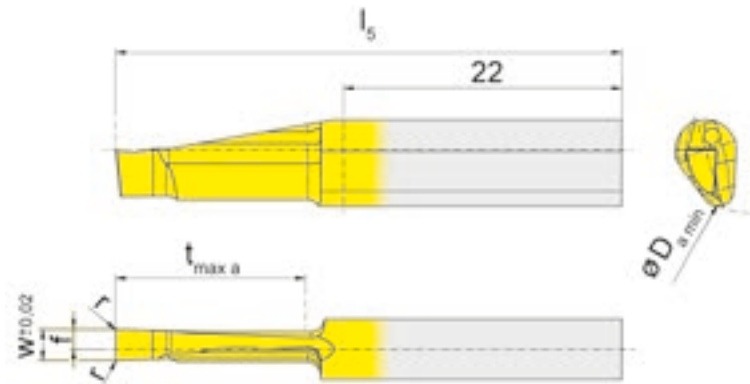


刀片
Insert

A105



端面槽起始外径	from outer groove $\varnothing$	10 mm
槽深	Depth of groove	15 mm
槽宽	Width of groove	2-3 mm



配合刀杆
for Toolholder

型号 B105...12.2
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	w	r	f	l_5	$t_{\max a}$	$D_{a \min}$	EG35	TI25
R/LA105.1020.2.2	2.0	0.1	1.4	40	15	10	▲/▲	▲/▲
R/LA105.1025.2.2	2.5	0.1	1.6	40	15	10	▲/▲	▲/▲
R/LA105.1030.2.2	3.0	0.1	1.0	40	15	10	▲/▲	▲/▲
							P	•
							M	•
							K	•
							N	•
							S	•
							H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

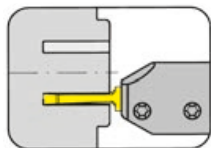
注意事项 :
刀片RA105安装于刀杆RB105上 刀片LA105安装于刀杆LB105上

Note:
Use insert RA105 in toolholder RB105...12.2 and insert LA105 in toolholder LB105...12.2.
Dmin在10和40mm之间时, 可达到满切情况下的最大切深
Face grooving with full width of the full depth only possible between $D_{a \min}$ 10 - 40 mm!

硬质合金牌号
Carbide grades

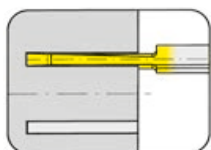
S

刀杆
Toolholder
B110

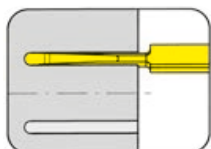


页/Page
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刀片
Insert
A110



页/Page
S19



页/Page
S20

110



机夹式刀杆

槽宽 3 mm

Toolholder with Inserts

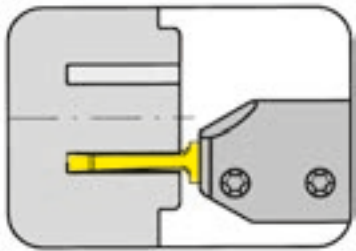
Width of groove 3 mm

端面切槽
Face Grooving



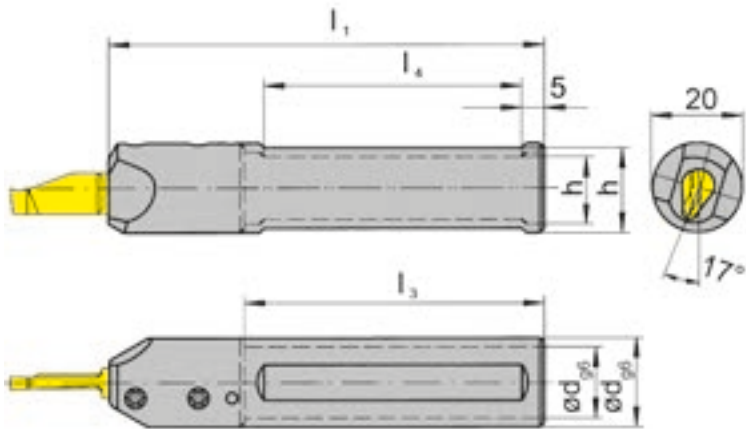
刀杆
Toolholder

B110
直接冷却液供应
with through coolant supply



端面槽起始外径	from outer groove Ø	20 mm
槽深	Depth of groove	30 mm
槽宽可达	Width of groove up to	3 mm

加长型刀杆
Extended depth of insert seat



配合刀片
for Insert

型号 A110
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₃	h	l ₄
R/LB110.0016.16.2	16	100	70	14	55
R/LB110.0020.16.2	20	100	-	18	55

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB110...	6.075T15P	T15PQ

端面切槽

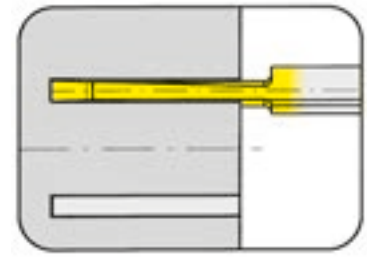
Face Grooving



刀片

Insert

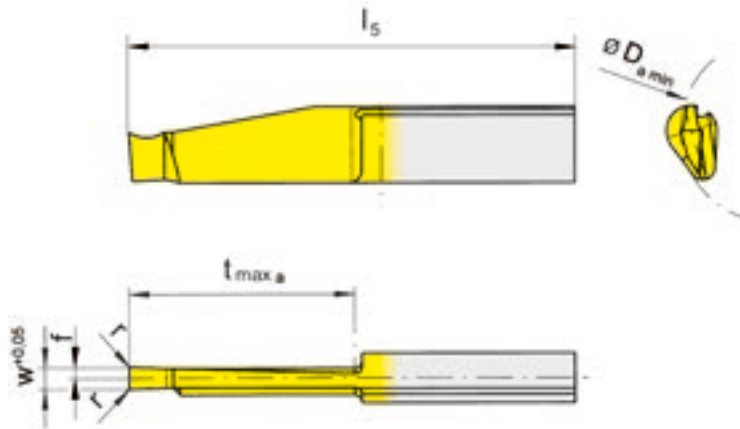
A110



端面槽起始外径
槽深
槽宽

from outer groove $\varnothing$
Depth of groove
Width of groove

20 mm
30 mm
3 mm



配合刀杆
for Toolholder

型号 B110
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	w	r	f	l_5	$t_{max a}$	$D_{a min}$	EG35	TH35	TI25	TN35
R/LA110.2030.3.0	3	0.2	1.5	50	20	20	▲/▲	▲/▲	▲/▲	▲/▲
R/LA110.2030.5.0	3	0.2	1.5	60	30	20	▲/▲	▲/▲	▲/▲	▲/▲
R/LA110.5030.3.0	3	0.2	1.5	50	20	50	▲/▲		▲/▲	
R/LA110.5030.5.0	3	0.2	1.5	60	30	50	▲/▲		▲/▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	•	•	•
● 推荐 / recommended							M	•	•	•
○ 次推荐 / alternative recommendation							K	○	•	•
- 不合适 / not suitable							N	-	•	•
■ 非涂层 / uncoated grades							S	-	•	•
■ 涂层 / coated grades							H	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet										

尺寸单位：mm

Dimensions in mm

注明R或L型

State R or L version

注意事项：

RB110...16.2刀杆配合RA110刀片 LB110...16.2刀杆配合LA110刀片

Note:

Use insert RA110 in toolholder RB110...16.2 and insert LA110 in toolholder LB110...16.2.

Dmin在20和50mm之间时，端面切槽可达满切下的最大切深。

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

硬质合金牌号
Carbide grades

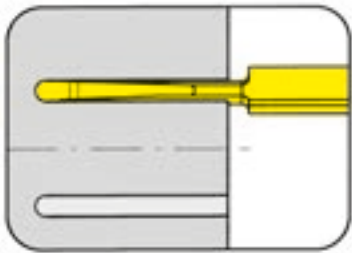
S

端面切槽
Face Grooving

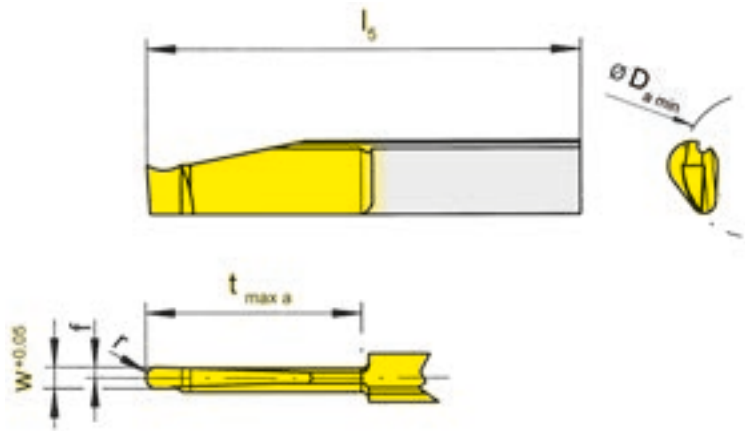


刀片
Insert

A110



端面槽起始外径	from outer groove $\varnothing$	20 mm
槽深	Depth of groove	30 mm
槽宽	Width of groove	3 mm



配合刀杆
for Toolholder

型号 B110
Type

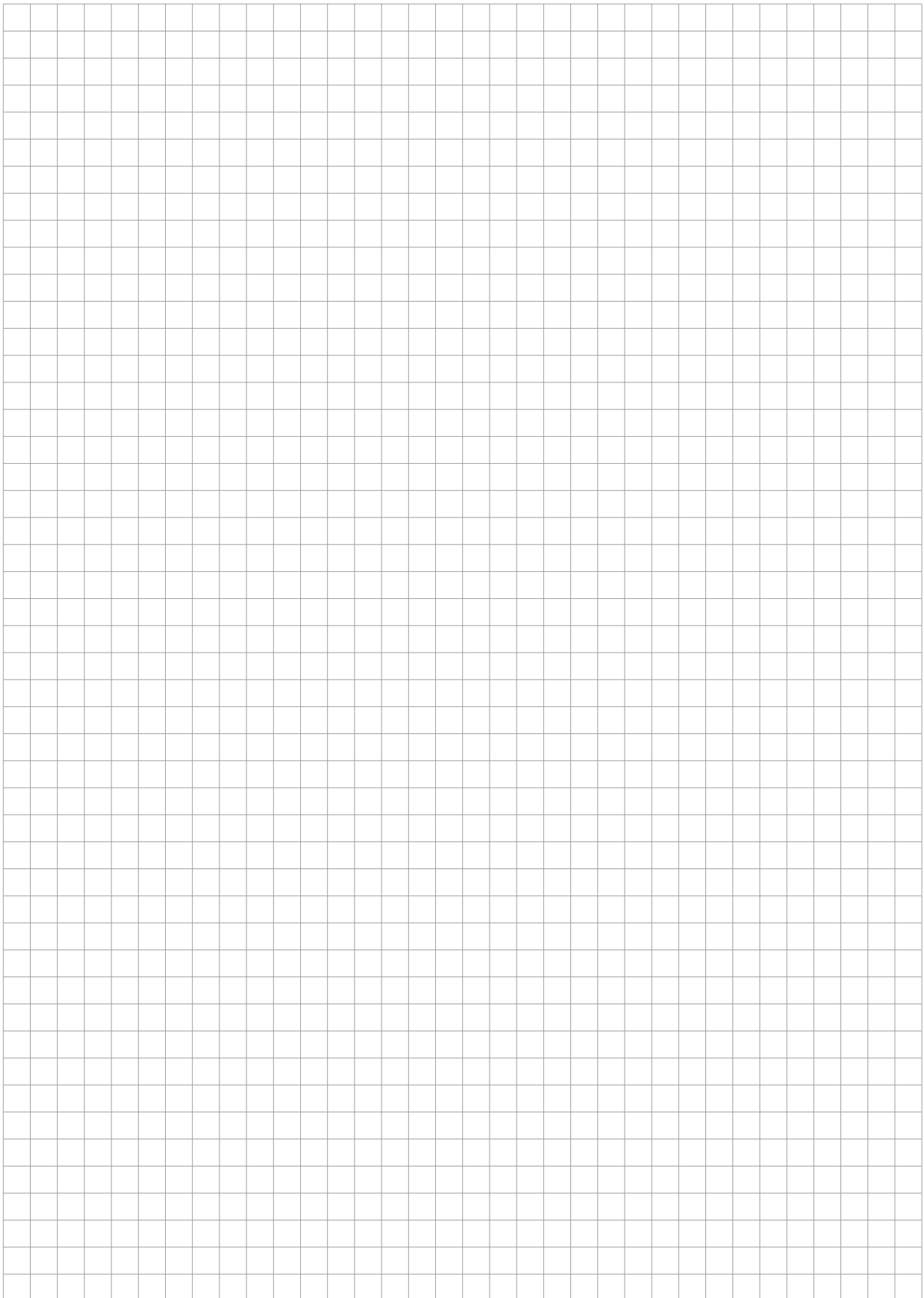
圆头
Full radius

L=左手型-如图
L = left hand version shown
R=右手型
R = right hand version

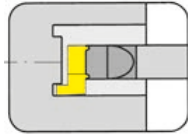
产品型号 Part number	w	r	f	l_5	$t_{\max a}$	$D_{a \min}$		EG35	TN35
R/LA110.2030.15.5.0	3	1.5	1.5	60	30	20		▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request								P	•
● 推荐 / recommended								M	•
o 次推荐 / alternative recommendation								K	•
- 不合适 / not suitable								N	•
非涂层 / uncoated grades								S	•
涂层 / coated grades								H	•
钎焊/金属陶瓷 / brazed/Cermet									

尺寸单位 : mm
Dimensions in mm
注明R或L型
State R or L version
注意事项 :
RB110...16.2刀杆配合RA110刀片 LB110...16.2刀杆配合LA110刀片
Note:
Use insert RA110 in toolholder RB110...16.2 and insert LA110 in toolholder LB110...16.2.
Dmin在20和50mm之间时, 端面切槽可达满切下的最大切深。
Face grooving with full width of the full depth only possible between $D_{a \min}$ 20 - 50 mm.

硬质合金牌号
Carbide grades

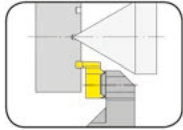


刀杆
Toolholder
B114/BA114



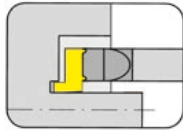
页/Page
S24-S27

刀杆
Toolholder
HC114



页/Page
S28

刀片
Insert
114



页/Page
S29-S32

114



机夹式刀杆

槽宽 1 - 3 mm

Toolholder with Inserts

Width of groove 1 - 3 mm

端面切槽

Face Grooving

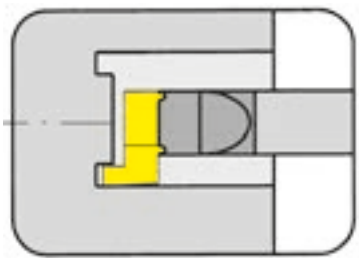


刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply

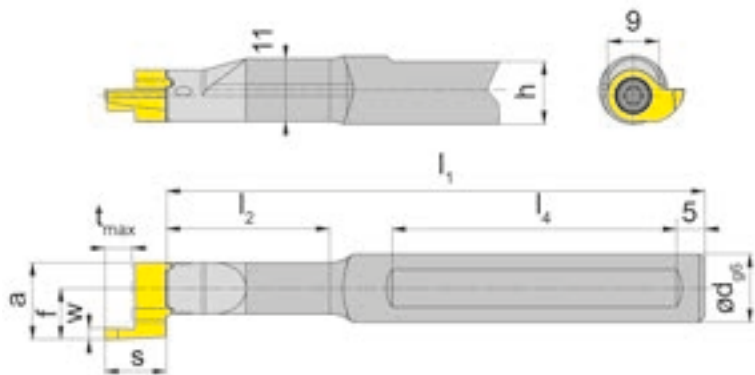


孔深可达	Depth of bore up to	64 mm
槽深可达	Depth of groove up to	6 mm
槽宽	Width of groove	1-3 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 114
Type S114



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	l ₄
B114.0012.00	12	69,7	14,2	11	40
B114.0012.01	12	94,7	28,7	11	50
B114.0012.02	12	104,7	39,7	11	50
B114.0012.03	12	124,7	58,7	11	50
B114.0016.00	16	74,7	14,2	15	40
B114.0016.01	16	94,7	28,7	15	50
B114.0016.02	16	104,7	39,7	15	50
B114.0016.03	16	124,7	58,7	15	50

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左手型或右手型刀片。
HORN可以返修刀杆上损坏的的基座。

Ordering note:
Toolholders can be used with right and left hand inserts. Toolholders with damaged seating can be repaired by HORN.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B114...	4.12T15EP	T15PQ

端面切槽

Face Grooving

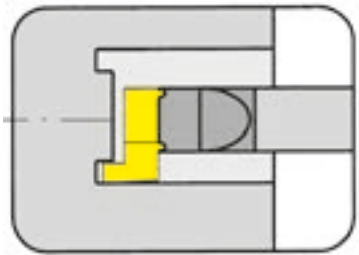


刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply

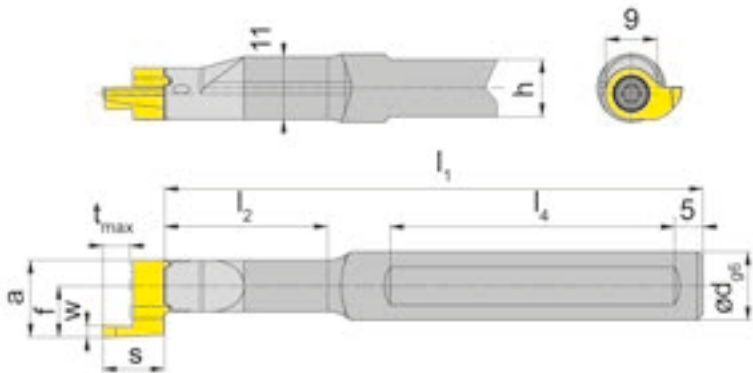


孔深可达	Depth of bore up to	64 mm
槽深可达	Depth of groove up to	6 mm
槽宽	Width of groove	1-3 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 114
Type S114



图示=右手型
Picture = right hand cutting version

带2个夹持面
with 2 clamping flats

产品型号 Part number	d	l ₁	l ₂	h	l ₄
B114.0012.2.00	12	69,7	14,2	11	40
B114.0012.2.01	12	94,7	28,7	11	50
B114.0012.2.02	12	104,7	39,7	11	50
B114.0012.2.03	12	124,7	58,7	11	50
B114.0016.2.00	16	74,7	14,2	14	40
B114.0016.2.01	16	94,7	28,7	14	50
B114.0016.2.02	16	104,7	39,7	14	50
B114.0016.2.03	16	124,7	58,7	14	50

按需提供更多尺寸
 Further sizes upon request
 w,a,s,t_{max}和f见刀片
 w, a, s, t_{max} and f see inserts
 尺寸单位：mm
 Dimensions in mm

订货须知：
 刀杆可以安装左手型或右手型刀片。
 HORN可以返修刀杆上损坏的的基座。
Ordering note:
 Toolholders can be used with right and left hand inserts. Toolholders with damaged seating can be repaired by HORN.
 螺丝的扭矩规格，详见技术说明。
 For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B114...	4.12T15EP	T15PQ



端面切槽

Face Grooving

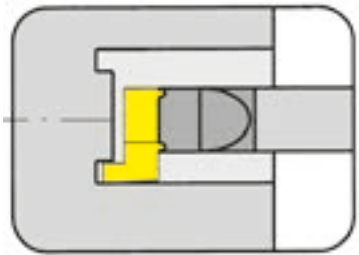


刀杆

Toolholder

BA114

直接冷却液供应
with through coolant supply

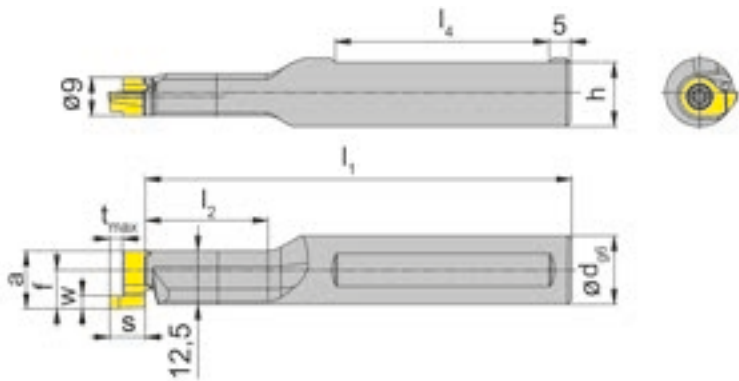


孔径	Bore Ø	14 mm
槽深	Depth of groove	6 mm
槽宽可达	Width of groove up to	3 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 114
Type S114



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	l ₄
RBA114.0016.01	16	99.7	28.7	15	50
RBA114.0016.02	16	109.7	39.7	15	50

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

订货须知：
HORN可以返修损坏的刀杆基座。

Ordering note:
Toolholders with damaged seating can be repaired by HORN.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RBA114...	4.12T15EP	T15PQ

端面切槽

Face Grooving

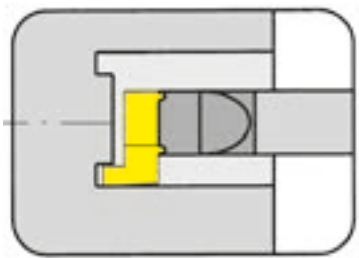


刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply

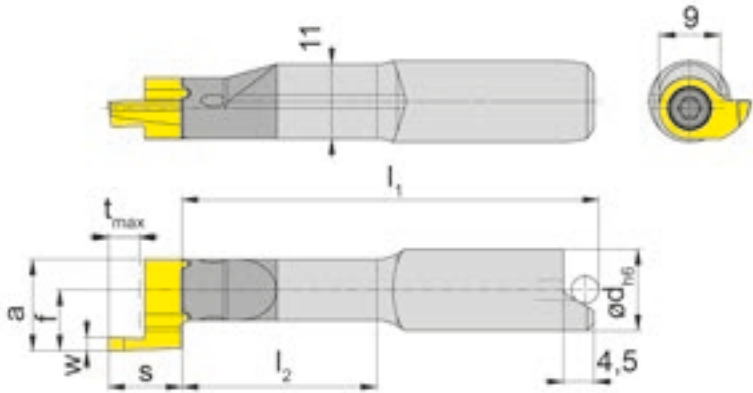


孔径Ø 自 槽深可达 槽宽	Bore Ø from Depth of groove up to Width of groove	14 mm 6 mm 1-3 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 114
Type S114



图示=右手型
Picture = right hand cutting version

用于收缩型定位
for shrinkage location

产品型号 Part number	d	l ₁	l ₂
B114.0012.00S	12	47,4	14,2
B114.0012.01S	12	61,4	28,7
B114.0012.02S	12	72,4	39,7
B114.0012.03S	12	91,4	58,7

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

订货须知：
刀杆可以安装左手型或右手型刀片。
HORN可以返修刀杆上损坏的的基座。

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

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B114...	4.12T15EP	T15PQ

切槽和端面切槽

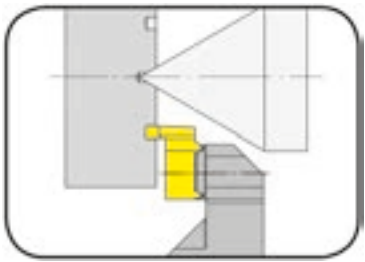
Grooving and Face Grooving



刀杆

Toolholder

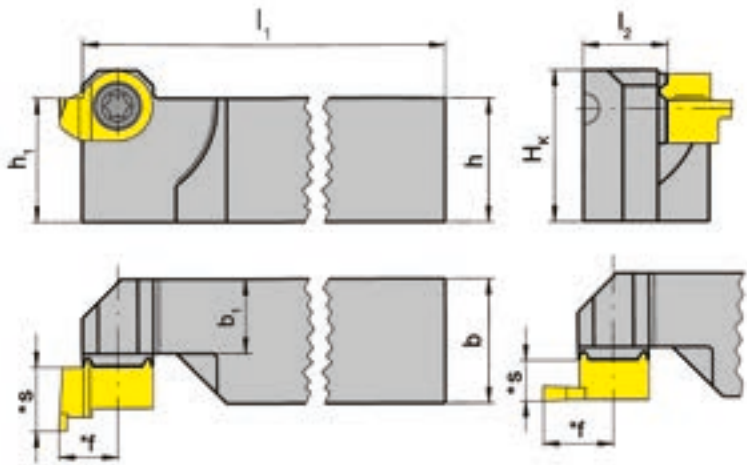
HC114



槽深可达	Depth of groove up to	6 mm
槽宽可达	Width of groove up to	3 mm

配合刀片
for Insert

型号 114
Type S114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

轴向和径向
axial and radial

产品型号 Part number	h	b	l ₁	l ₂	h ₁	b ₁	H _k
R/LHC114.1212.01	12	12	122	11.2	12	9.5	15.6
R/LHC114.1616.01	16	16	122	11.2	16	9.5	19.6
R/LHC114.2020.01	20	20	122	15.2	20	13.5	23.6
R/LHC114.2525.01	25	25	147	20.2	25	18.5	28.6

按需提供更多尺寸
Further sizes upon request

*见刀片
* see inserts

尺寸单位：mm
Dimensions in mm

注明R或L型

State R or L version

订货须知：

右手刀杆配合左手刀片 左手刀杆配合右手刀片

Ordering note:

Right hand toolholders use left hand inserts. Left hand toolholders use right hand inserts.

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

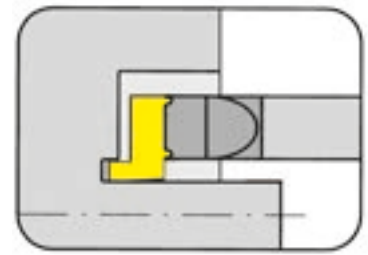
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LHC114...	4.12T15EP	T15PQ

端面切槽 Face Grooving



刀片 Insert

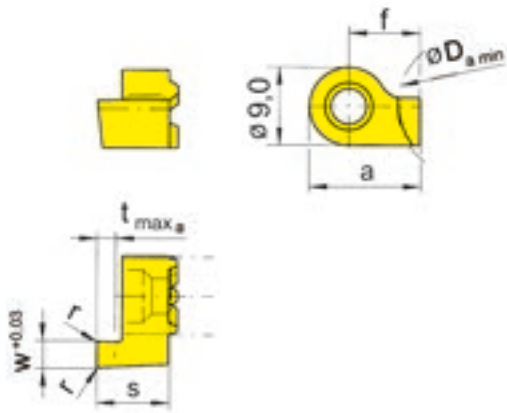
114



端面槽起始外径
槽深可达
槽宽

from outer groove $\varnothing$
Depth of groove up to
Width of groove

12 mm
6 mm
1-3 mm



配合刀杆
for Toolholder

型号 B114
Type RBA114
HC114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于中心线后加工
Machining **BEHIND** centre
line

产品型号 Part number	w	s	f	a	r	t _{max a}	D _{a min}	EG55	TN35
R/L 114.1210.00	1.0	8.3	7.5	12	-	1.5	12	▲/▲	▲/▲
R/L 114.1215.00	1.5	8.3	7.5	12	0.2	2.5	12	▲/▲	▲/▲
R/L 114.1220.00	2.0	8.3	7.5	12	0.2	3.0	12	▲/▲	▲/▲
R/L 114.1225.00	2.5	8.3	7.5	12	0.2	3.0	12	▲/▲	▲/▲
R/L 114.1230.00	3.0	8.3	7.5	12	0.2	3.0	12	▲/▲	▲/▲
R/L 114.1220.5.00	2.0	10.8	7.5	12	0.2	5.0	12	▲/▲	▲/▲
R/L 114.1225.5.00	2.5	10.8	7.5	12	0.2	5.0	12	▲/▲	▲/▲
R/L 114.1230.6.00	3.0	11.8	7.5	12	0.2	6.0	12	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R=逆时针方向旋转 使用114系列端面槽刀片和B114刀杆时, l_1 和 l_2 会增加3.0/5.5或者 6.5mm。

Note:

R = rotation anti-clockwise! Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be enlarged by 3,0 / 5,5 or 6,5 mm.

P	•	•
M	o	•
K	o	•
N	-	•
S	-	•
H	-	-

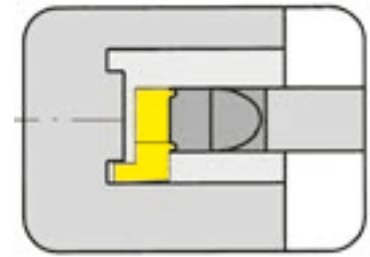
硬质合金牌号
Carbide grades

端面切槽 Face Grooving



刀片 Insert

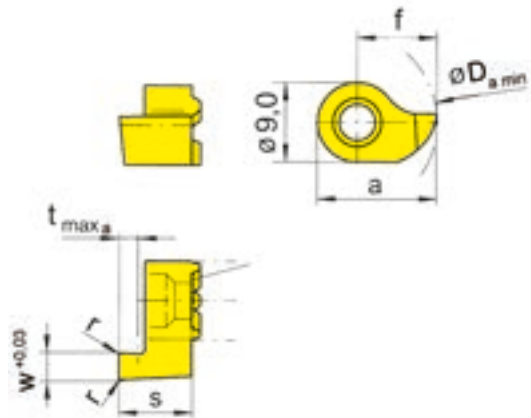
114



端面槽起始外径
槽深可达
槽宽

from outer groove $\varnothing$
Depth of groove up to
Width of groove

14 mm
6 mm
1-3 mm



配合刀杆
for Toolholder

型号 B114
Type RBA114
HC114

适用于中心线前加工
Machining **IN-FRONT** of
centre line

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	t _{max a}	D _{a min}		MG12	EG55	TF45	TN35
R/L114.1410.00	1.0	8.3	9	13.5	-	1.5	14		Δ/Δ	▲/▲		▲/▲
R/L114.1415.00	1.5	8.3	9	13.5	0.2	2.5	14			▲/▲		▲/▲
R/L114.1420.00	2.0	8.3	9	13.5	0.2	3.0	14			▲/▲	x/x	▲/▲
R/L114.1425.00	2.5	8.3	9	13.5	0.2	3.0	14			▲/▲		▲/▲
R/L114.1430.00	3.0	8.3	9	13.5	0.2	3.0	14		▲/Δ	▲/▲		▲/▲
R/L114.1420.5.00	2.0	10.8	9	13.5	0.2	5.0	14			▲/▲		▲/▲
R/L114.1425.5.00	2.5	10.8	9	13.5	0.2	5.0	14			▲/▲		▲/▲
R/L114.1430.6.00	3.0	11.8	9	13.5	0.2	6.0	14			▲/▲		▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R=顺时针旋转 ! 使用114刀片和B114刀杆时刀杆时, l_1 和 l_2 会相应增加3.0/5.5或6.5 mm。

Note:

R = rotation clockwise! Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be enlarged by 3,0 / 5,5 or 6,5 mm.

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

硬质合金牌号
Carbide grades

端面切槽

Face Grooving



刀片

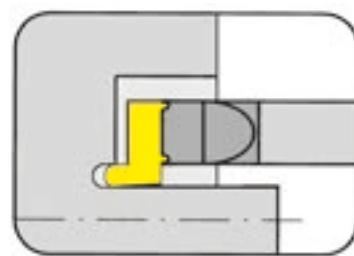
Insert

114

端面槽起始外径
槽深可达
槽宽

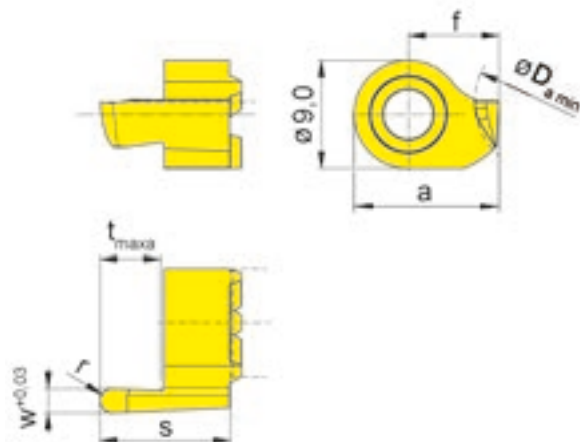
from outer groove Ø
Depth of groove up to
Width of groove

12 mm
6 mm
2-3 mm



配合刀杆
for Toolholder

型号 B114
Type RBA114
HC114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

圆头刀片 适用于中心
线后加工
Full radius Machining
BEHIND centre line

产品型号 Part number	w	s	f	a	r	t _{max a}	D _{a min}	EG55	TN35
R/L 114.1220.5.10	2.0	10.8	7.5	12	1.00	5	12	▲/▲	▲/▲
R/L 114.1225.5.12	2.5	10.8	7.5	12	1.25	5	12	▲/▲	▲/▲
R/L 114.1230.6.15	3.0	11.8	7.5	12	1.50	6	12	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R = 顺时针旋转! 使用114系列端面槽刀片和B114刀杆时, I1和I2将会增加5.5 mm或6.5mm。

Note:

R = rotation anti-clockwise! Using the face grooving insert type 114 on toolholder type B114 the size I1 and I2 will be enlarged by 5,5 mm or 6,5 mm.

P	●	●
M	○	●
K	○	●
N	-	●
S	-	●
H	-	-

硬质合金牌号
Carbide grades

端面切槽

Face Grooving



刀片

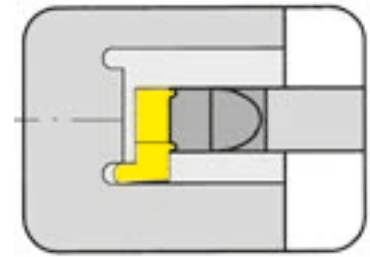
Insert

114

端面槽起始外径
槽深可达
槽宽

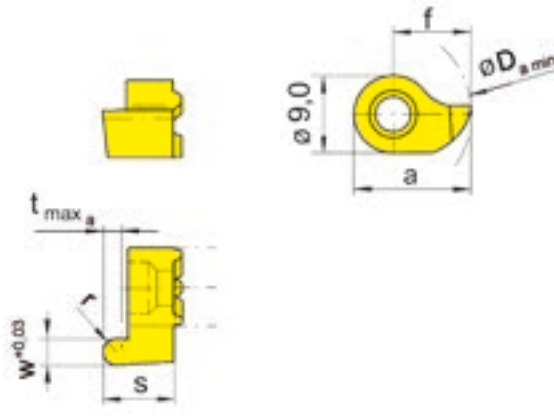
from outer groove $\varnothing$
Depth of groove up to
Width of groove

14 mm
3 mm
1-3 mm



配合刀杆
for Toolholder

型号 B114
Type RBA114
HC114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

圆头刀片 适用于中心线
前加工
Full radius Machining
IN-FRONT of centre line

产品型号 Part number	w	s	f	a	r	t _{max a}	D _{a min}	EG55	TN35
R/L114.1410.05	1.0	8.3	9	13.5	0.50	1.5	14	▲/▲	▲/▲
R/L114.1416.08	1.6	8.3	9	13.5	0.80	2.5	14	▲/▲	▲/▲
R/L114.1420.10	2.0	8.3	9	13.5	1.00	3.0	14	▲/▲	▲/▲
R/L114.1425.12	2.5	8.3	9	13.5	1.25	3.0	14	▲/▲	▲/▲
R/L114.1430.15	3.0	8.3	9	13.5	1.50	3.0	14	▲/▲	▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

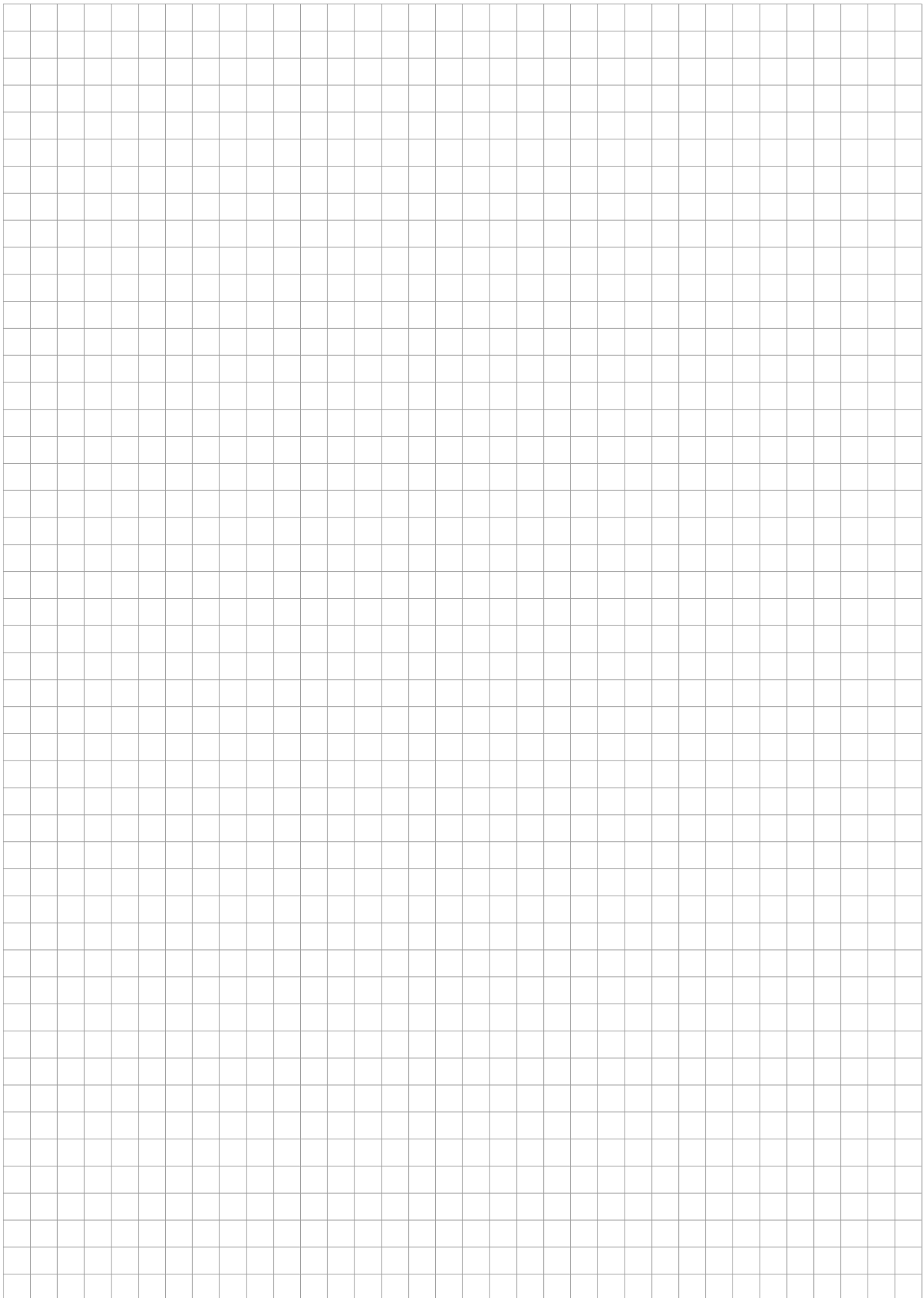
R=逆时针旋转 使用114系列端面槽刀片和B114刀杆时, l1和l2会增大3.0 mm。

Note:

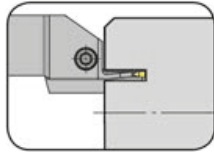
R = rotation clockwise! Using the face grooving insert type 114 on toolholder type B114 the size l1 and l2 will be enlarged by 3,0 mm.

P	•	•
M	o	•
K	o	•
N	-	•
S	-	•
H	-	-

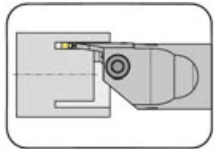
硬质合金牌号
Carbide grades



刀杆
Toolholder
H25A/IB25A

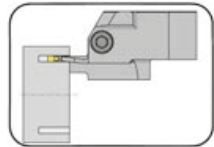


页/Page
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页/Page
S38

刀夹
Cassette
K25A

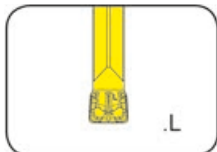


页/Page
S37

刀片
Insert
S15A



页/Page
S39-S40



页/Page
S41

可转位刀片
Indexable insert
S25A



页/Page
S42-S43

S

15A/25A



S

机夹式刀杆
槽宽2 - 4 mm

Toolholder with Inserts
Width of groove 2 - 4 mm

端面切槽

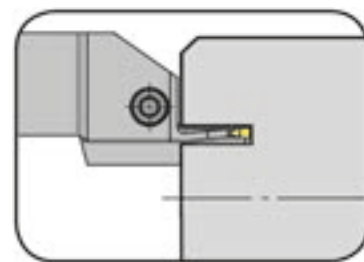
Face Grooving



刀杆

Toolholder

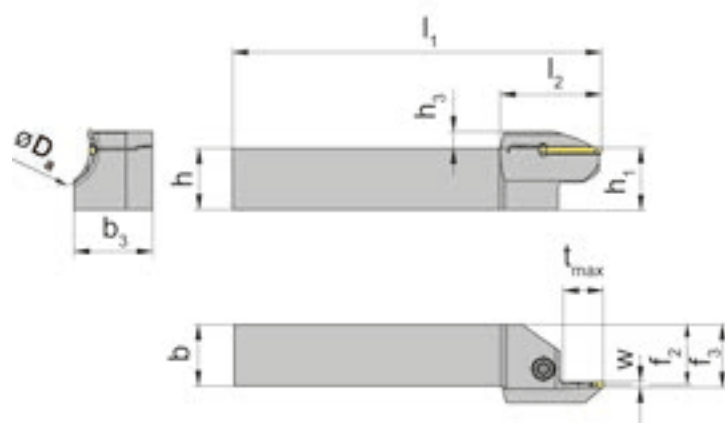
H25A



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

15 mm
15 mm
2-3 mm



配合可转位刀片
for Indexable insert

型号 S15A
Type S25A

切削刃高度设定需高于中心
高0.3mm
The cutting edge is above 0,3
mm the centre height

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	b ₃	f ₂	f ₃	t _{max}	h ₃	D _{a min}	D _{a max}	尺寸规格 Size
R/LAH25A.12.1520.02	12	12	120	32	12.3	15.5	11.5	12.5	12	5.0	15	20	02
R/LAH25A.16.1520.02	16	16	120	32	16.3	19.5	15.5	16.5	12	5.0	15	20	02
R/LAH25A.20.1520.02	20	20	120	32	20.3	23.5	19.5	20.5	12	5.0	15	20	02
R/LAH25A.12.2025.02	12	12	120	32	12.3	16.5	11.5	12.5	12	5.0	20	25	02
R/LAH25A.16.2025.02	16	16	120	32	16.3	20.5	15.5	16.5	12	5.0	20	25	02
R/LAH25A.20.2025.02	20	20	120	32	20.3	24.5	19.5	20.5	12	5.0	20	25	02
R/LAH25A.12.2530.02	12	12	120	33	12.3	17.5	11.5	12.5	13	5.5	25	30	02
R/LAH25A.16.2530.02	16	16	120	33	16.3	21.5	15.5	16.5	13	5.5	25	30	02
R/LAH25A.20.2530.02	20	20	120	33	20.3	25.5	19.5	20.5	13	5.5	25	30	02
R/LAH25A.12.1520.03	12	12	120	33	12.3	17.0	11.0	12.5	13	5.5	15	20	03
R/LAH25A.16.1520.03	16	16	120	33	16.3	21.0	15.0	16.5	13	5.5	15	20	03
R/LAH25A.20.1520.03	20	20	120	33	20.3	25.0	19.0	20.5	13	5.5	15	20	03
R/LAH25A.12.2025.03	12	12	120	34	12.3	18.5	11.0	12.5	14	5.5	20	25	03
R/LAH25A.16.2025.03	16	16	120	34	16.3	22.5	15.0	16.5	14	5.5	20	25	03
R/LAH25A.20.2025.03	20	20	120	34	20.3	26.5	19.0	20.5	14	5.5	20	25	03
R/LAH25A.12.2530.03	12	12	120	35	12.3	19.5	11.0	12.5	15	6.0	25	30	03
R/LAH25A.16.2530.03	16	16	120	35	16.3	23.5	15.0	16.5	15	6.0	25	30	03
R/LAH25A.20.2530.03	20	20	120	35	20.3	27.5	19.0	20.5	15	6.0	25	30	03

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

w=2.0mm的螺丝扭矩规格为2.5Nm
w=3.0mm的螺丝扭矩规格为3.0Nm

Torque specification of the screw for w = 2,0 mm is 2,5 Nm
Torque specification of the screw for w = 3,0 mm is 3,0 Nm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LAH25A.12...	5.14T20P	T20PQ
R/LAH25A...	5.13 T20P	T20PQ

端面切槽

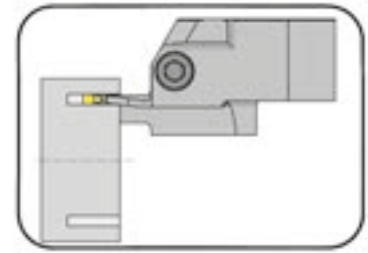
Face Grooving



刀夹

Cassette

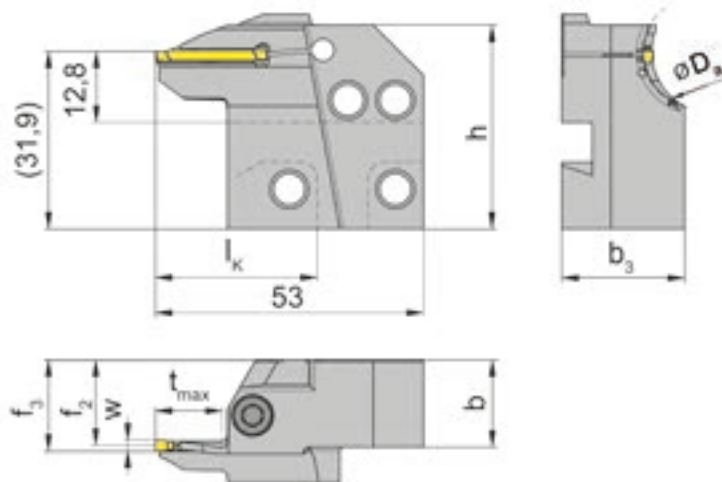
K25A



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

15 mm
20 mm
2-4 mm



配合可转位刀片
for Indexable insert

型号 S15A
Type S25A

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

切削刃高度设定需高于中心
高0.3mm
The cutting edge is above 0,3
mm the centre height

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	h	l _k	尺寸规格 Size
R/LAK25A.1520.02.IK	15	20	12	15.7	21	15.4	f ₂ +w/2	38.6	34	02
R/LAK25A.2025.02.IK	20	25	12	15.7	22	15.4	f ₂ +w/2	38.6	34	02
R/LAK25A.2530.02.IK	25	30	13	15.7	23	15.4	f ₂ +w/2	38.6	34	02
R/LAK25A.2025.03.IK	20	25	14	15.7	24	14.9	f ₂ +w/2	38.6	34	03
R/LAK25A.2530.03.IK	25	30	15	15.7	25	14.9	f ₂ +w/2	38.6	34	03
R/LAK25A.3040.03.IK	30	40	16	15.7	23	14.9	f ₂ +w/2	38.6	34	03
R/LAK25A.4050.03.IK	40	50	18	15.7	24	14.9	f ₂ +w/2	38.6	34	03
R/LAK25A.2025.04.IK	20	25	16	15.7	24	15.1	f ₂ +w/2	38.6	34	04
R/LAK25A.2530.04.IK	25	30	17	15.7	24	15.1	f ₂ +w/2	38.6	34	04
R/LAK25A.3040.04.IK	30	40	18	15.7	24	15.1	f ₂ +w/2	38.6	34	04
R/LAK25A.4050.04.IK	40	50	20	15.7	24	15.1	f ₂ +w/2	39.2	34	04

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

w=2.0mm的螺丝扭矩规格为2.5Nm
w=3.0mm的螺丝扭矩规格为3.0Nm
w=4.0mm的螺丝扭矩规格为3.5Nm

Torque specification of the screw for w = 2,0 mm is 2,5 Nm
Torque specification of the screw for w = 3,0 mm is 3,0 Nm
Torque specification of the screw for w = 4,0 mm is 3,5 Nm

注意事项：

配220系统接口

Note:

for use with pocket seat system 220!

注明R或L型

State R or L version

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LAK25A...	5.13 T20P	T20PQ

端面切槽

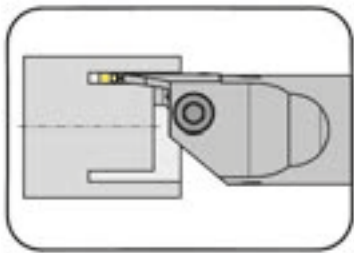
Face Grooving



刀杆

Toolholder

IB25A



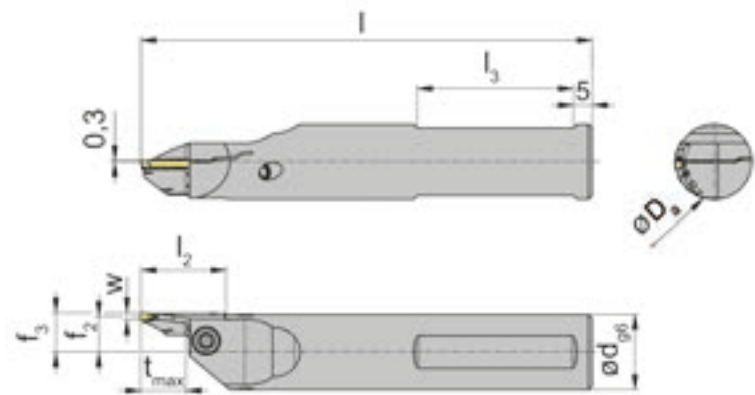
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

20 mm
20 mm
2-4 mm

配合可转位刀片
for Indexable insert

型号 S15A
Type S25A



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

切削刃高度设定需高于中心
高0.3mm
The cutting edge is above
0,3 mm the centre height

产品型号 Part number	d	l	l ₂	l ₃	f ₃	f ₂	t _{max}	D _{a min}	D _{a max}	槽宽 Width of groove
R/LIB25A.20.2025.02.IK	20	120	23	55	f ₂ +w/2	9.5	12	20	25	2
R/LIB25A.20.2530.02.IK	20	120	23	55	f ₂ +w/2	9.5	13	25	30	2
R/LIB25A.20.2025.03.IK	20	120	24	55	f ₂ +w/2	9.0	14	20	25	3
R/LIB25A.20.2530.03.IK	20	120	25	55	f ₂ +w/2	9.0	15	25	30	3
R/LIB25A.20.3040.03.IK	20	120	27	55	f ₂ +w/2	9.0	16	30	40	3
R/LIB25A.20.4050.03.IK	20	120	30	55	f ₂ +w/2	9.0	18	40	50	3
R/LIB25A.20.2025.04.IK	20	120	26	55	f ₂ +w/2	8.5	16	20	25	4
R/LIB25A.20.2530.04.IK	20	120	27	55	f ₂ +w/2	8.5	17	25	30	4
R/LIB25A.20.3040.04.IK	20	120	29	55	f ₂ +w/2	8.5	18	30	40	4
R/LIB25A.20.4050.04.IK	20	120	31	55	f ₂ +w/2	8.5	20	40	50	4

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

w=2.0mm的螺丝扭矩规格为2.5Nm
w=3.0mm的螺丝扭矩规格为3.0Nm
w=4.0mm的螺丝扭矩规格为3.5Nm

Torque specification of the screw for w = 2,0 mm is 2,5 Nm
Torque specification of the screw for w = 3,0 mm is 3,0 Nm
Torque specification of the screw for w = 4,0 mm is 3,5 Nm

注明R或L型
State R or L version

配件

Spare Parts

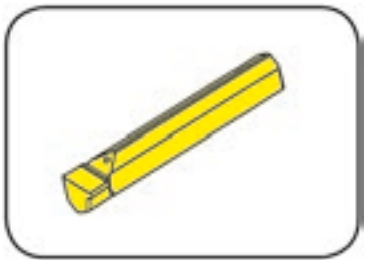
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LIB25A...	5.13T20EP	T20PQ

端面切槽
Face Grooving



刀片
Insert

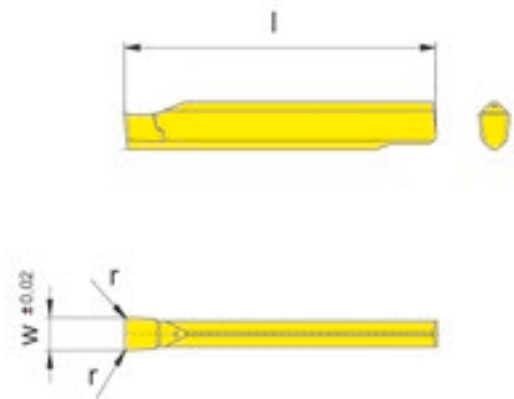
S15A



槽宽	Width of groove	2-4 mm

刀杆
Toolholder

型号 H25A
Type K25A
IB25A



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

S

产品型号 Part number	w	r	l	尺寸规格 Size	TH35
S15A.0200.12	2	0.2	20	02	▲
S15A.0300.12	3	0.2	21	03	▲
S15A.0400.12	4	0.2	24	04	▲
					P •
					M •
					K •
					N •
					S •
					H -

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

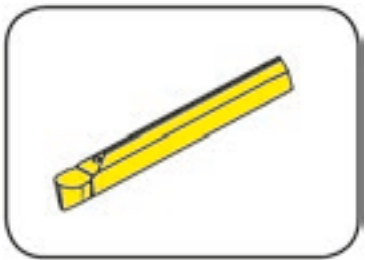
硬质合金牌号
Carbide grades

端面切槽
Face Grooving



刀片
Insert

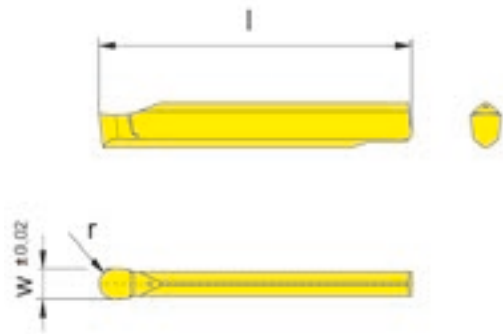
S15A



圆头 槽宽	Full radius Width of groove	1-2 mm 2-4 mm

配合刀杆
for Toolholder

型号 H25A
Type K25A
IB25A



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

产品型号 Part number	w	l	r	尺寸规格 Size	TH35	
S15A.0200.10.10	2	20	1.0	02	▲	●
S15A.0300.10.15	3	21	1.5	03	▲	●
S15A.0400.10.20	4	24	2.0	04	▲	●
					P	●
					M	●
					K	●
					N	●
					S	●
					H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

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

硬质合金牌号
Carbide grades

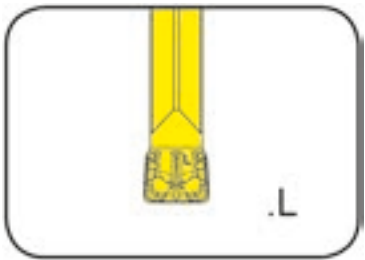
端面切槽
Face Grooving



刀片
Insert

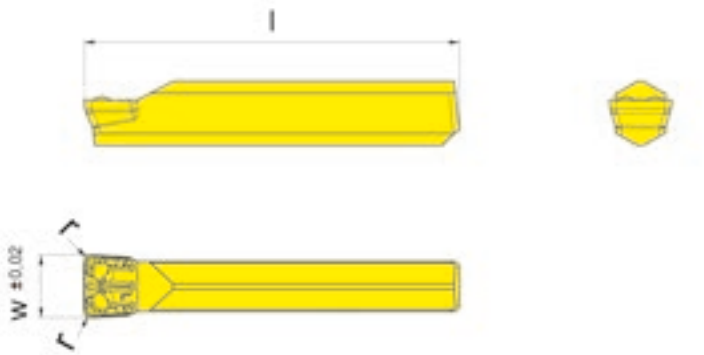
S15A

槽宽	Width of groove	4 mm



配合刀杆
for Toolholder

型号 H25A
Type K25A
IB25A



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

产品型号 Part number	w	r	l	尺寸规格 Size	AS45
S15A.0400.L4	4	0.4	24	04	▲
▲ 库存 / on stock	△ 4周 / 4 weeks	x 根据要求 / upon request			P •
● 推荐 / recommended					M •
o 次推荐 / alternative recommendation					K •
- 不合适 / not suitable					N ○
非涂层 / uncoated grades					S •
涂层 / coated grades					H -
钎焊/金属陶瓷 / brazed/Cermet					

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

硬质合金牌号
Carbide grades

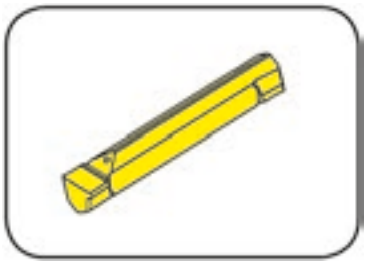
S

端面切槽
Face Grooving



可转位刀片
Indexable insert

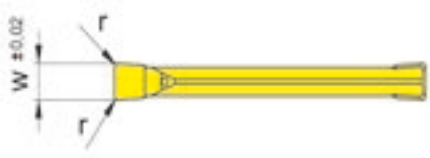
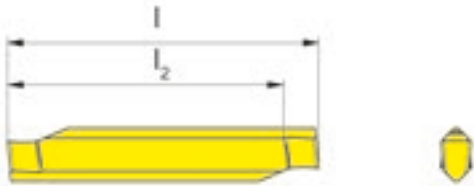
S25A



槽宽	Width of groove	2-4 mm

配合刀杆
for Toolholder

型号 H25A
Type K25A
IB25A



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

产品型号 Part number	w	r	l	l ₂	尺寸规格 Size	TH35
S25A.0200.12	2	0.2	20	17.0	02	▲
S25A.0300.12	3	0.2	21	18.0	03	▲
S25A.0400.12	4	0.2	24	20.5	04	▲
						P •
						M •
						K •
						N •
						S •
						H -

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

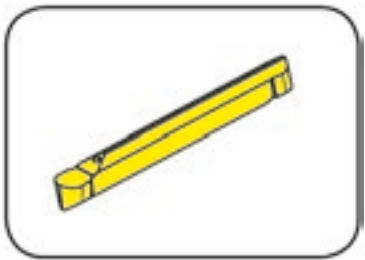
硬质合金牌号
Carbide grades

端面切槽
Face Grooving



可转位刀片
Indexable insert

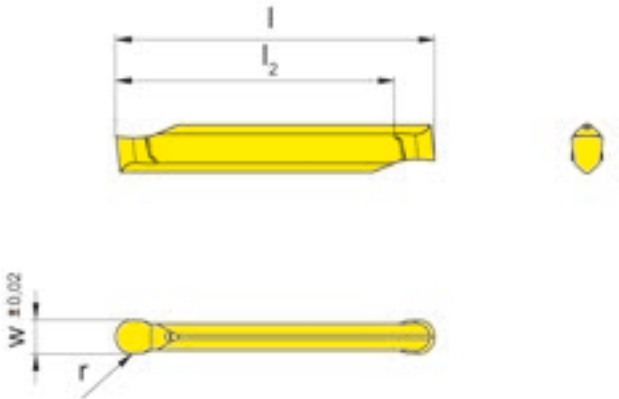
S25A



圆头 槽宽	Full radius Width of groove	1-2 mm 2-4 mm

配合刀杆
for Toolholder

型号 H25A
Type K25A
IB25A



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

产品型号 Part number	w	l	r	l ₂	尺寸规格 Size	TH35
S25A.0200.10.10	2	20	1.0	17.0	02	▲
S25A.0300.10.15	3	21	1.5	18.0	03	▲
S25A.0400.10.20	4	24	2.0	20.5	04	▲
						P •
						M •
						K •
						N •
						S •
						H -

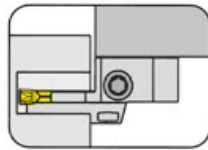
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

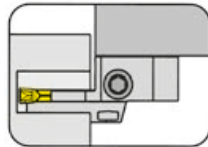
硬质合金牌号
Carbide grades

S

常规刀柄
Basic toolholder
220/B224



页/Page
S46-S47, S50



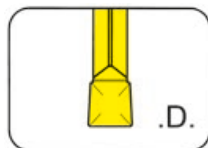
页/Page
S48-S49

刀夹
Cassette
LAK224/RAK224/
LIK224/RIK224

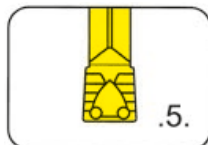


页/Page
S51-S58

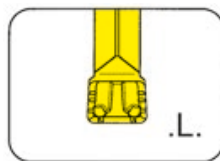
可转位刀片
Indexable insert
S224



页/Page
S59



页/Page
S60



页/Page
S61

224



S

机夹式刀杆

槽宽 3 - 6 mm

Toolholder with Inserts

Width of groove 3 - 6 mm

端面切槽

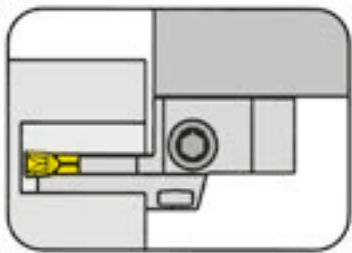
Face Grooving



常规刀柄

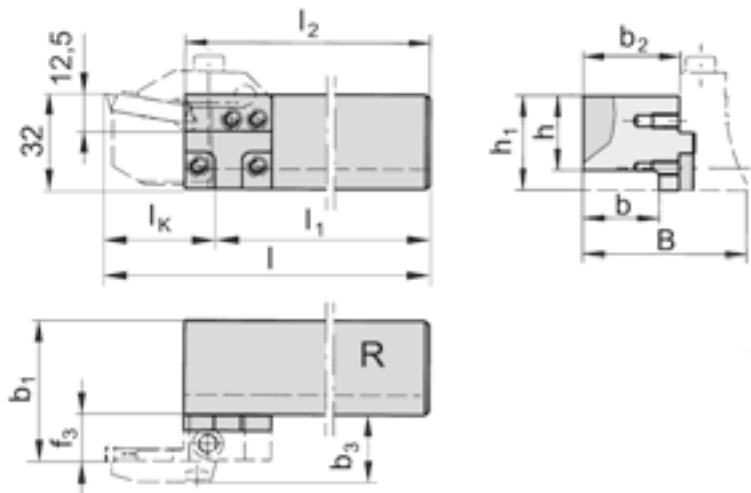
Basic toolholder

220
无刀夹
without cassette



配合220/224型刀夹的常规刀柄
Basic toolholder for cassettes type 220/224

刀杆平行于工件轴线
Shank parallel to the axis of workpiece



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	h ₁	l ₁	b	b ₁	b ₂	l ₂	l	B
R/L220.1616.K1	16	32	l ₂ -10	16	b ₂ +f ₃	25	64	l ₁ +l _K	b ₂ +b ₃
R/L220.2020.K1	20	32	l ₂ -10	20	b ₂ +f ₃	27	74	l ₁ +l _K	b ₂ +b ₃
R/L220.2525.K1	25	32	l ₂ -10	25	b ₂ +f ₃	32	94	l ₁ +l _K	b ₂ +b ₃
R/L220.3225.K1	32	32	l ₂ -10	-	b ₂ +f ₃	25	109	l ₁ +l _K	b ₂ +b ₃
R/L220.3232.K1	32	32	l ₂ -10	-	b ₂ +f ₃	32	109	l ₁ +l _K	b ₂ +b ₃

注明R或L型
State R or L version
IK, b₃和 f₃见刀夹
l_K, b₃ and f₃ see cassettes

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request
右手型刀杆配合右手型刀夹，左手型刀杆配合左手型刀夹。
Use right hand basic toolholder for right hand cassettes and left hand basic toolholder for left hand cassettes.

配件

Spare Parts

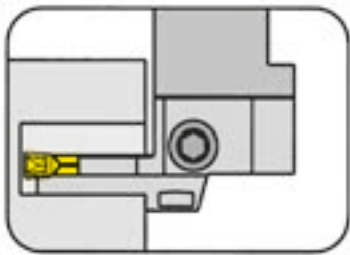
常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	T20PQ

端面切槽
Face Grooving



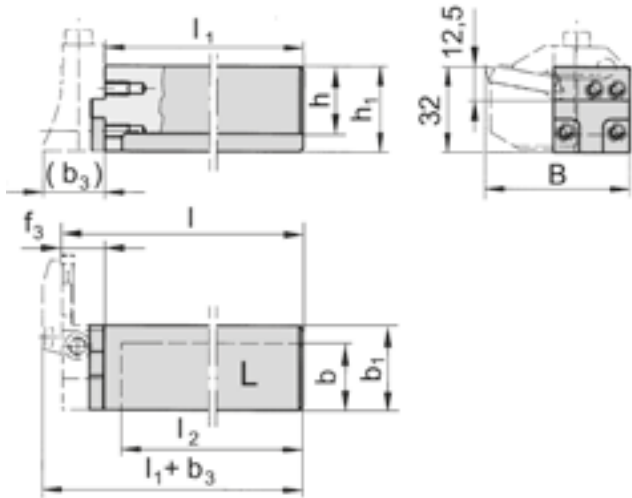
常规刀柄
Basic toolholder

220
无刀夹
without cassette



配合220/224型刀夹的常规刀柄
Basic toolholder for cassettes type 220/224

刀杆90°于工件轴线
Shank 90° to the axis of workpiece



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	h ₁	b	l ₂	l	B	b ₁	l ₁
R/L220.1616.K2	16	32	16	60	l ₁ +f ₃	l _k +19	29	70
R/L220.2020.K2	20	32	20	75	l ₁ +f ₃	l _k +19	29	85
R/L220.2525.K2	25	32	25	93	l ₁ +f ₃	l _k +22	32	100
R/L220.3225.K2	32	32	-	108	l ₁ +f ₃	l _k +19	29	115
R/L220.3232.K2	32	32	-	115	l ₁ +f ₃	l _k +22	32	115

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
右手型刀杆配合左手型刀夹，左手型刀杆配合右手型刀夹。
Use right hand basic toolholder for left hand cassettes and left hand basic toolholder for right hand cassettes.

IK,b3和 f3见刀夹
l_k, b₃ and f₃ see cassettes

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

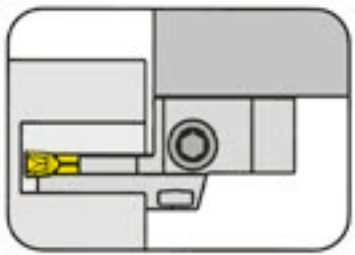
常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	T20PQ

端面切槽
Face Grooving



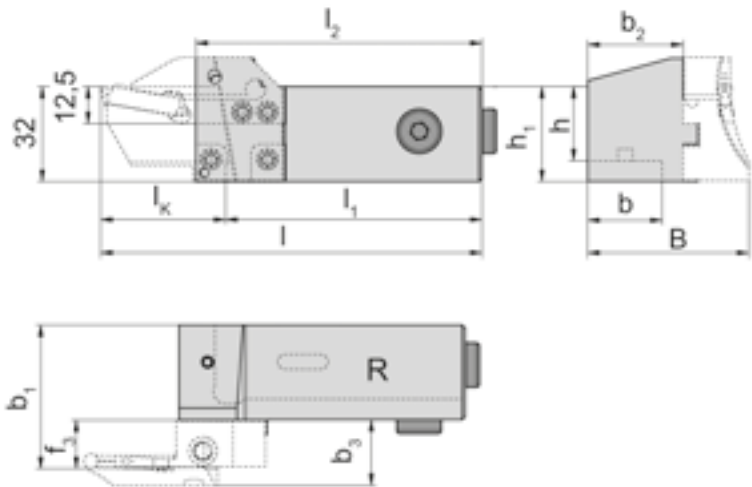
常规刀柄
Basic toolholder

220
无刀夹
without cassette



配合VDI接纳器,提供内冷
suitable for HORN adaptors VDI with integrated through coolant supply

刀杆平行于工件轴线
Shank parallel to the axis of workpiece



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带集成内冷
with integrated through
coolant supply

产品型号 Part number	h	h ₁	l ₁	b	b ₁	b ₂	l ₂	l	B
R/L220.2020.2.K1.IK	20	32	l ₂ -10	20	b ₂ +f ₃	27	84	l ₁ +l _K	b ₂ +b ₃
R/L220.2525.2.K1.IK	25	32	l ₂ -10	25	b ₂ +f ₃	32	96	l ₁ +l _K	b ₂ +b ₃

注明R或L型
State R or L version

IK,b3和 f3见刀夹
l_K, b₃ and f₃ see cassettes

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

右手型刀杆配合右手型刀夹，左手型刀杆配合左手型刀夹。
Use right hand basic toolholder for right hand cassettes and left hand basic toolholder for left hand cassettes.

配件
Spare Parts

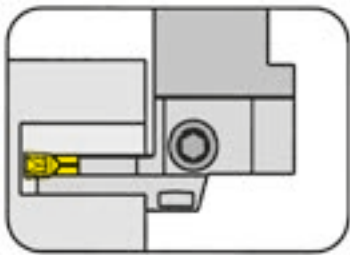
常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R220.2020.2.K1.IK	5.12T20P	T20PQ

端面切槽
Face Grooving



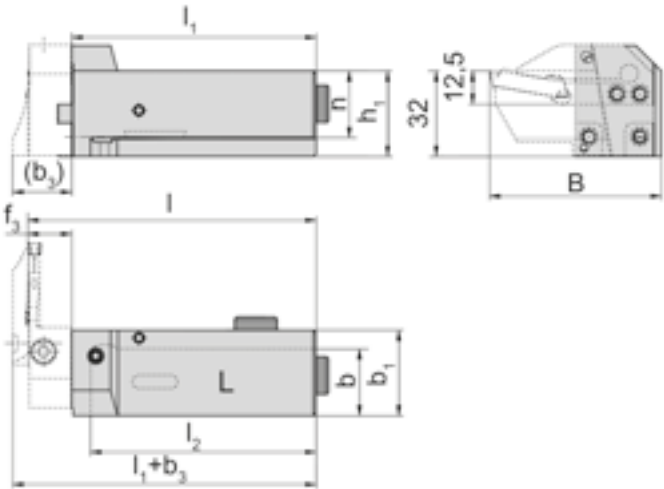
常规刀柄
Basic toolholder

220
无刀夹
without cassette



配合VDI接纳器,提供内冷
suitable for HORN adaptors VDI with integrated through coolant supply

刀杆90°于工件轴线
Shank 90° to the axis of workpiece



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

带集成内冷
with integrated through
coolant supply

产品型号 Part number	h	h ₁	b	l ₂	l	B	b ₁	l ₁
R/L220.2020.2.K2.IK	20	32	20	69	l ₁ +f ₃	l _k +19	29	79
R/L220.2525.2.K2.IK	25	32	25	84	l ₁ +f ₃	l _k +19	32	91

注明R或L型
State R or L version

IK,b3和 f3见刀夹
l_k, b₃ and f₃ see cassettes

尺寸单位 : mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

右手型刀杆配合左手型刀夹，左手型刀杆配合右手型刀夹。
Use right hand basic toolholder for left hand cassettes and left hand basic toolholder for right hand cassettes.

配件
Spare Parts

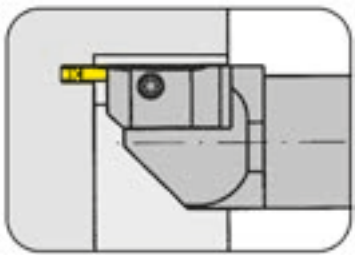
常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	T20PQ

端面切槽
Face Grooving



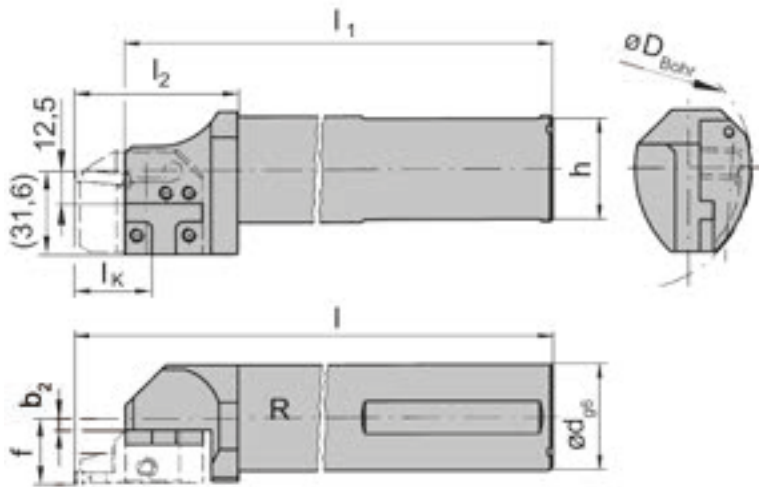
常规刀柄
Basic toolholder

B224
无刀夹
without cassette



配合RIK/LIK224型刀夹的常规刀柄
Basic toolholder for cassettes type RIK/LIK224

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	f	d	l_1	h	l_2	b_2	l	D_{Bohr}
R/LB224.0032.K1	b_2+f_3	32	181	30	59	0.41	200	90
R/LB224.0040.K1	b_2+f_3	40	231	38	59	4.41	250	90

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

Da min / f3 / lK见刀夹
 $D_{a\min} / f_3 / l_K$ see cassettes

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB224...	5.12T20P	T20PQ

端面切槽

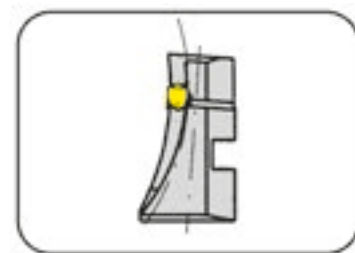
Face Grooving



刀夹

Cassette

LAK224



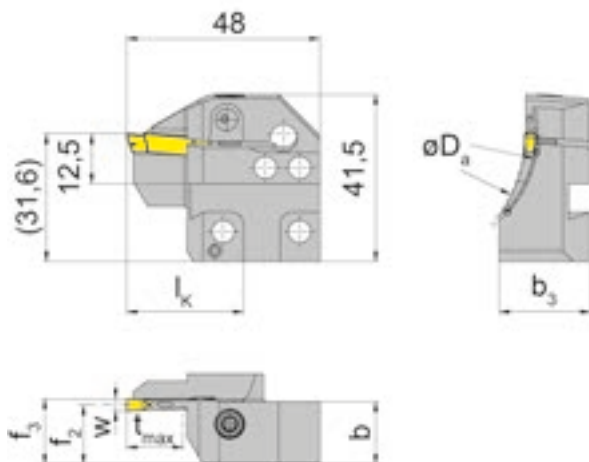
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm

可转位刀片
Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	$t_{\max}$	b	b_3	f_2	f_3	w	l_k
LAK224.5060.03.IK	50	60	14	15.7	23.7	14.9	$f_2+w/2$	3	29
LAK224.6075.03.IK	60	75	14	15.7	22.7	14.9	$f_2+w/2$	3	29
LAK224.7590.03.IK	75	90	14	15.7	22.7	14.9	$f_2+w/2$	3	29
LAK224.9011.03.IK	90	110	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1113.03.IK	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1318.03.IK	130	180	14	15.7	20.0	14.9	$f_2+w/2$	3	29
LAK224.1830.03.IK	180	300	14	15.7	19.0	14.9	$f_2+w/2$	3	29
LAK224.3000.03.IK	300	1000	14	15.7	16.9	14.9	$f_2+w/2$	3	29
LAK224.3847.04.IK	38	47	14	15.7	24.2	14.4	$f_2+w/2$	4	29
LAK224.4760.04.IK	47	60	14	15.7	23.7	14.4	$f_2+w/2$	4	29
LAK224.6075.04.IK	60	75	14	15.7	23.7	14.4	$f_2+w/2$	4	29
LAK224.7590.04.IK	75	90	14	15.7	22.7	14.4	$f_2+w/2$	4	29
LAK224.9013.04.IK	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1318.04.IK	130	180	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1830.04.IK	180	300	14	15.7	19.0	14.4	$f_2+w/2$	4	29
LAK224.3000.04.IK	300	1000	14	15.7	16.7	14.4	$f_2+w/2$	4	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK224...	5.13 T20P	T20PQ

端面切槽

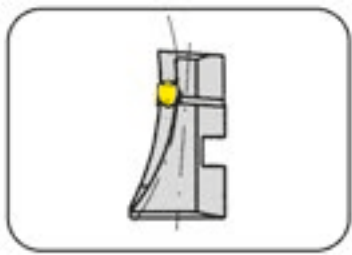
Face Grooving



刀夹

Cassette

LAK224



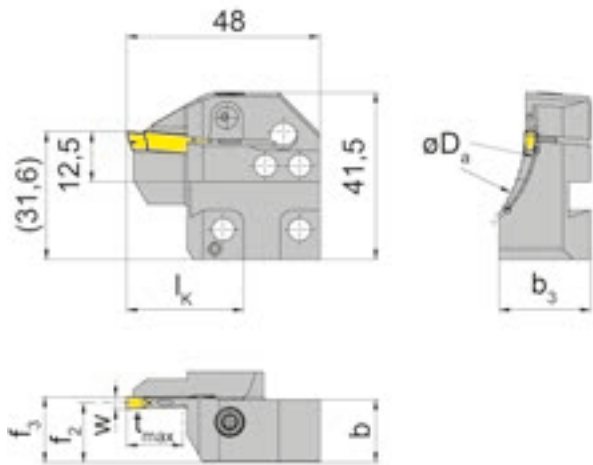
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

可转位刀片
Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK224.3847.05.IK	38	47	14	15.7	23.7	13.9	f ₂ +w/2	5	29
LAK224.4760.05.IK	47	60	14	15.7	23.7	13.9	f ₂ +w/2	5	29
LAK224.6075.05.IK	60	75	14	15.7	23.7	13.9	f ₂ +w/2	5	29
LAK224.7590.05.IK	75	90	14	15.7	22.0	13.9	f ₂ +w/2	5	29
LAK224.9013.05.IK	90	130	14	15.7	22.0	13.9	f ₂ +w/2	5	29
LAK224.1318.05.IK	130	180	14	15.7	21.0	13.9	f ₂ +w/2	5	29
LAK224.1830.05.IK	180	300	14	15.7	19.0	13.9	f ₂ +w/2	5	29
LAK224.3000.05.IK	300	1000	14	15.7	16.7	13.9	f ₂ +w/2	5	29
LAK224.6075.06.IK	60	75	14	15.7	23.0	13.4	f ₂ +w/2	6	29
LAK224.7590.06.IK	75	90	14	15.7	23.0	13.4	f ₂ +w/2	6	29
LAK224.9013.06.IK	90	130	14	15.7	21.0	13.4	f ₂ +w/2	6	29
LAK224.1318.06.IK	130	180	14	15.7	21.0	13.4	f ₂ +w/2	6	29
LAK224.1830.06.IK	180	300	14	15.7	19.0	13.4	f ₂ +w/2	6	29
LAK224.3000.06.IK	300	1000	14	15.7	16.7	13.4	f ₂ +w/2	6	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK224...	5.13 T20P	T20PQ

端面切槽

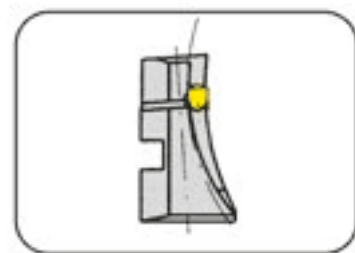
Face Grooving



刀夹

Cassette

RAK224



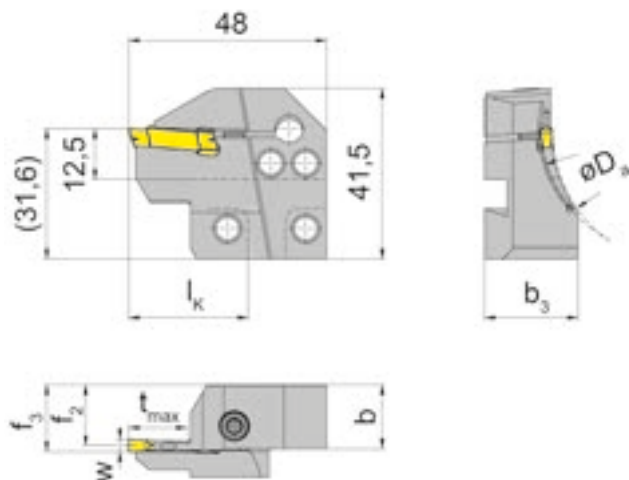
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm

可转位刀片
Indexable insert

型号 S224
Type



R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK224.5060.03.IK	50	60	14	15.7	23.7	14.9	f ₂ +w/2	3	29
RAK224.6075.03.IK	60	75	14	15.7	22.7	14.9	f ₂ +w/2	3	29
RAK224.7590.03.IK	75	90	14	15.7	22.7	14.9	f ₂ +w/2	3	29
RAK224.9011.03.IK	90	110	14	15.7	21.0	14.9	f ₂ +w/2	3	29
RAK224.1113.03.IK	110	130	14	15.7	21.0	14.9	f ₂ +w/2	3	29
RAK224.1318.03.IK	130	180	14	15.7	20.0	14.9	f ₂ +w/2	3	29
RAK224.1830.03.IK	180	300	14	15.7	19.0	14.9	f ₂ +w/2	3	29
RAK224.3000.03.IK	300	1000	14	15.7	16.9	14.9	f ₂ +w/2	3	29
RAK224.3847.04.IK	38	47	14	15.7	24.2	14.4	f ₂ +w/2	4	29
RAK224.4760.04.IK	47	60	14	15.7	23.7	14.4	f ₂ +w/2	4	29
RAK224.6075.04.IK	60	75	14	15.7	23.7	14.4	f ₂ +w/2	4	29
RAK224.7590.04.IK	75	90	14	15.7	22.7	14.4	f ₂ +w/2	4	29
RAK224.9013.04.IK	90	130	14	15.7	21.0	14.4	f ₂ +w/2	4	29
RAK224.1318.04.IK	130	180	14	15.7	21.0	14.4	f ₂ +w/2	4	29
RAK224.1830.04.IK	180	300	14	15.7	19.0	14.4	f ₂ +w/2	4	29
RAK224.3000.04.IK	300	1000	14	15.7	16.7	14.4	f ₂ +w/2	4	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK224...	5.13 T20P	T20PQ

端面切槽

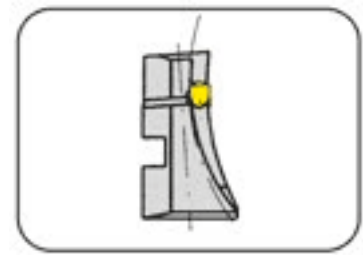
Face Grooving



刀夹

Cassette

RAK224



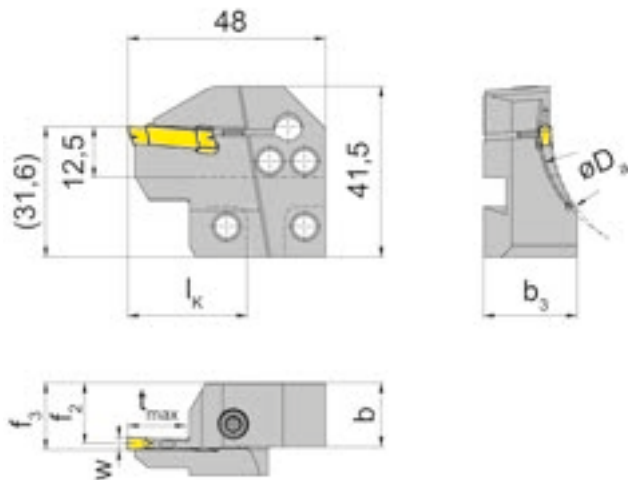
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

可转位刀片
Indexable insert

型号 S224
Type



R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK224.3847.05.IK	38	47	14	15.7	23.7	13.9	f ₂ +w/2	5	29
RAK224.4760.05.IK	47	60	14	15.7	23.7	13.9	f ₂ +w/2	5	29
RAK224.6075.05.IK	60	75	14	15.7	23.7	13.9	f ₂ +w/2	5	29
RAK224.7590.05.IK	75	90	14	15.7	22.0	13.9	f ₂ +w/2	5	29
RAK224.9013.05.IK	90	130	14	15.7	22.0	13.9	f ₂ +w/2	5	29
RAK224.1318.05.IK	130	180	14	15.7	21.0	13.9	f ₂ +w/2	5	29
RAK224.1830.05.IK	180	300	14	15.7	19.0	13.9	f ₂ +w/2	5	29
RAK224.3000.05.IK	300	1000	14	15.7	16.7	13.9	f ₂ +w/2	5	29
RAK224.6075.06.IK	60	75	14	15.7	23.0	13.4	f ₂ +w/2	6	29
RAK224.7590.06.IK	75	90	14	15.7	23.0	13.4	f ₂ +w/2	6	29
RAK224.9013.06.IK	90	130	14	15.7	21.0	13.4	f ₂ +w/2	6	29
RAK224.1318.06.IK	130	180	14	15.7	21.0	13.4	f ₂ +w/2	6	29
RAK224.1830.06.IK	180	300	14	15.7	19.0	13.4	f ₂ +w/2	6	29
RAK224.3000.06.IK	300	1000	14	15.7	16.7	13.4	f ₂ +w/2	6	29

配合常规刀杆 L...K1/L...K1.IK 和 R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位: mm
Dimensions in mm

订货须知:
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK224...	5.13 T20P	T20PQ

端面切槽

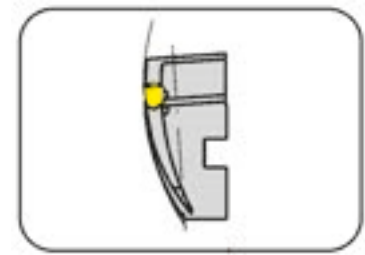
Face Grooving



刀夹

Cassette

LIK224



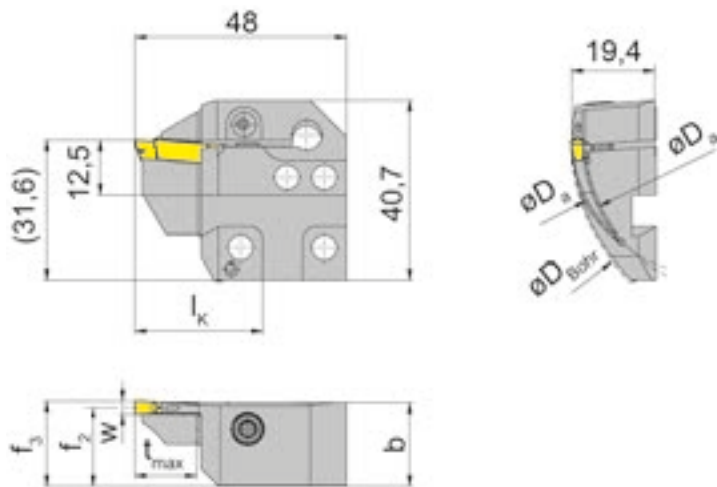
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm

可转位刀片
Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK224.5060.03.IK	90	50	60	14	19	17.9	f ₂ +w/2	3	29
LIK224.6075.03.IK	90	60	75	14	19	17.9	f ₂ +w/2	3	29
LIK224.7590.03.IK	90	75	90	14	19	17.9	f ₂ +w/2	3	29
LIK224.9011.03.IK	90	90	110	14	19	17.9	f ₂ +w/2	3	29
LIK224.1113.03.IK	110	110	130	14	19	17.9	f ₂ +w/2	3	29
LIK224.1318.03.IK	130	130	180	14	19	17.9	f ₂ +w/2	3	29
LIK224.1830.03.IK	180	180	300	14	19	17.9	f ₂ +w/2	3	29
LIK224.3847.04.IK	90	38	47	14	19	17.4	f ₂ +w/2	4	29
LIK224.4760.04.IK	90	47	60	14	19	17.4	f ₂ +w/2	4	29
LIK224.6075.04.IK	90	60	75	14	19	17.4	f ₂ +w/2	4	29
LIK224.7590.04.IK	90	75	90	14	19	17.4	f ₂ +w/2	4	29
LIK224.9013.04.IK	90	90	130	14	19	17.4	f ₂ +w/2	4	29
LIK224.1318.04.IK	130	130	180	14	19	17.4	f ₂ +w/2	4	29
LIK224.3000.04.IK	300	300	1000	14	19	17.4	f ₂ +w/2	4	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK224...	5.13 T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

LIK224



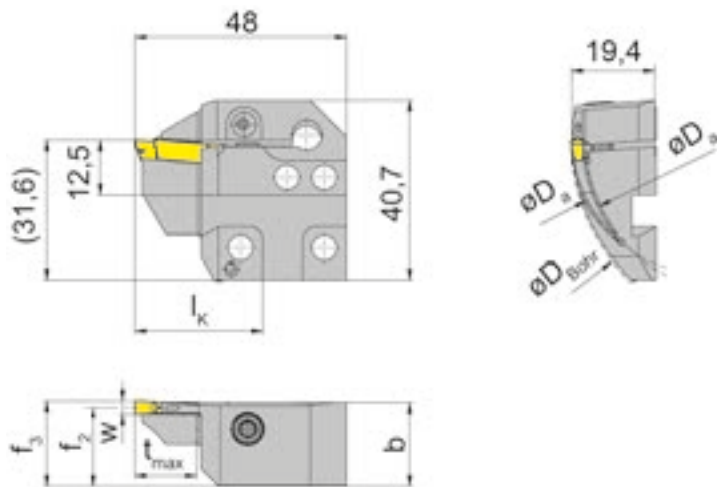
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

可转位刀片
Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK224.3847.05.IK	90	38	47	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.4760.05.IK	90	47	60	14	19.00	17.4	f ₂ +w/2	5	29
LIK224.6075.05.IK	90	60	75	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.7590.05.IK	90	75	90	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.9013.05.IK	90	90	130	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.1318.05.IK	130	130	180	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.1830.05.IK	180	180	300	14	19.00	16.9	f ₂ +w/2	5	29
LIK224.3000.05.IK	300	300	1000	14	18.90	16.9	f ₂ +w/2	5	29
LIK224.6075.06.IK	90	60	75	14	19.00	16.4	f ₂ +w/2	6	29
LIK224.7590.06.IK	90	75	90	14	19.00	16.4	f ₂ +w/2	6	29
LIK224.9013.06.IK	90	90	130	14	19.00	16.4	f ₂ +w/2	6	29
LIK224.1318.06.IK	130	130	180	14	19.00	16.4	f ₂ +w/2	6	29
LIK224.1830.06.IK	180	180	300	14	19.00	16.4	f ₂ +w/2	6	29
LIK224.3000.06.IK	300	300	1000	14	18.75	16.4	f ₂ +w/2	6	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK224...	5.13 T20P	T20PQ

端面切槽 Face Grooving



刀夹 Cassette

RIK224



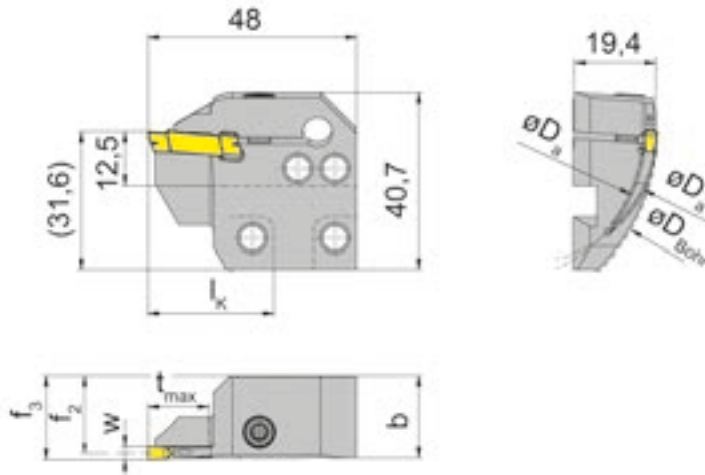
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm

可转位刀片
Indexable insert

型号 S224
Type



R=右手型
R = right hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
RIK224.5060.03.IK	90	50	60	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.6075.03.IK	90	60	75	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.7590.03.IK	90	75	90	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.9011.03.IK	90	90	110	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.1113.03.IK	110	110	130	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.1318.03.IK	130	130	180	14	19.05	17.9	f ₂ +w/2	3	29
RIK224.1830.03.IK	180	180	300	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.3847.04.IK	90	38	47	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.4760.04.IK	90	47	60	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.6075.04.IK	90	60	75	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.7590.04.IK	90	75	90	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.9013.04.IK	90	90	130	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.1318.04.IK	130	130	180	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.3000.04.IK	300	300	1000	14	19.00	17.4	f ₂ +w/2	4	29

配合常规刀杆L...K1/L...K1.IK和R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK224...	5.13 T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

RIK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

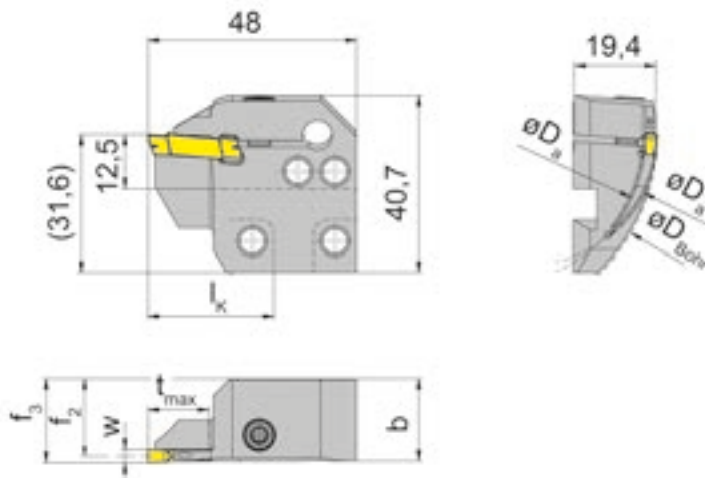
可转位刀片

Indexable insert

型号

S224

Type



R=右手型

R = right hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
RIK224.3847.05.IK	90	38	47	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.4760.05.IK	90	47	60	14	19.00	17.4	f ₂ +w/2	5	29
RIK224.6075.05.IK	90	60	75	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.7590.05.IK	90	75	90	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.9013.05.IK	90	90	130	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.1318.05.IK	130	130	180	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.1830.05.IK	180	180	300	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.3000.05.IK	300	300	1000	14	18.90	16.9	f ₂ +w/2	5	29
RIK224.6075.06.IK	90	60	75	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.7590.06.IK	90	75	90	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.9013.06.IK	90	90	130	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.1318.06.IK	130	130	180	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.1830.06.IK	180	180	300	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.3000.06.IK	300	300	1000	14	18.75	16.4	f ₂ +w/2	6	29

配合常规刀杆 L...K1/L...K1.IK 和 R...K2/R...K2.IK
For basic toolholder L...K1/L...K1.IK and R...K2/R...K2.IK

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK224...	5.13 T20P	T20PQ

端面切槽

Face Grooving



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

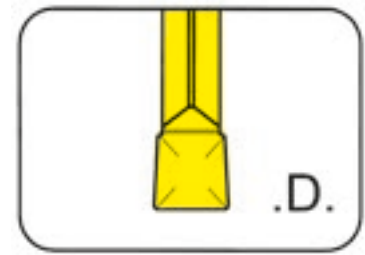
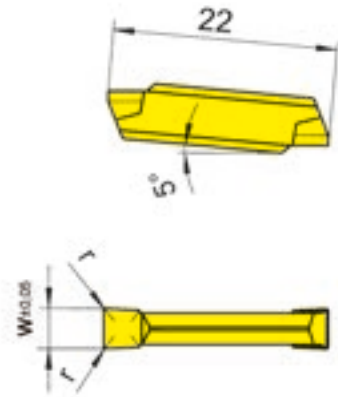
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3-4 mm

D2精密烧结/*D2.G精密磨削

D2 precision sintered / *D2.G precision ground



配合刀夹

for Cassette

型号 R/LAK224

Type R/LIK224

*刀片长度重复定位精度
±0.06 mm

*Indexability length ± 0,06 mm

产品型号 Part number	w	r	尺寸规格 Size
S224.0300.D2.G	3	0.2	03
S224.0300.D2	3	0.2	03
S224.0400.D2.G	4	0.2	04
S224.0400.D2	4	0.2	04

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。

Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

	H54	TF45	TF46	T122	T125	TN32	TN35
	▲	▲	▲	▲	▲	▲	▲
	▲	▲	▲	▲	▲	▲	▲
	Δ	▲	▲	▲	▲	▲	▲
P	●	●	●	●	●	●	●
M	●	●	o	-	●	-	●
K	-	●	●	-	●	-	●
N	-	●	●	-	●	-	●
S	-	●	o	-	●	-	●
H	-	-	-	-	-	-	-

硬质合金牌号

Carbide grades

端面切槽

Face Grooving



可转位刀片

Indexable insert

S224

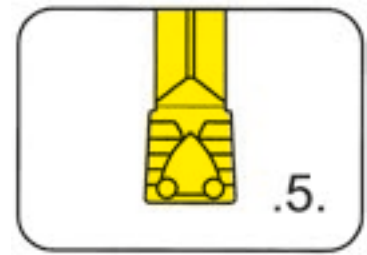
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

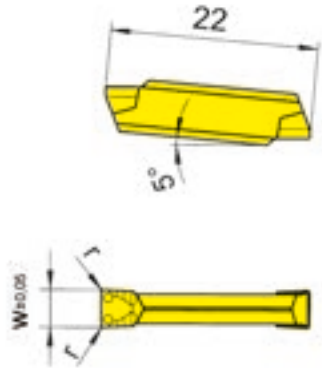
18 mm
3-5 mm

精密烧结
precision sintered



配合刀夹
for Cassette

型号 R/LAK224
Type R/LIK224



刀片长度重复定位精度

±0.06 mm

Indexability length ± 0,06 mm

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	EG56	H54	TC92	TF45	TI25	TN32	TN35
S224.0300.52	3	0.2	03	Δ	▲	▲	▲	Δ	▲	▲	▲	▲	▲
S224.0300.54	3	0.4	03	▲	▲	▲	▲	Δ	▲	▲	▲	▲	▲
S224.0400.52	4	0.2	04	▲	▲	▲	▲	Δ	Δ	▲	▲	▲	▲
S224.0400.54	4	0.4	04	▲	▲	▲	▲	Δ	▲	▲	▲	▲	▲
S224.0500.54	5	0.4	05	Δ	▲	▲	▲	Δ	▲	▲	▲	▲	▲
S224.0500.58	5	0.8	05	Δ	▲	▲	Δ	Δ	Δ	Δ	▲	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	●	●	●	●	●	●	●
● 推荐 / recommended				M	-	-	o	o	●	-	●	-	●
o 次推荐 / alternative recommendation				K	●	-	●	o	-	-	●	-	●
- 不合适 / not suitable				N	●	-	●	-	-	●	●	-	●
非涂层 / uncoated grades				S	-	-	o	-	-	●	●	-	●
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。

Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

硬质合金牌号

Carbide grades

端面切槽

Face Grooving



可转位刀片

Indexable insert

S224

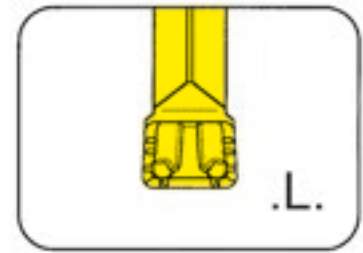
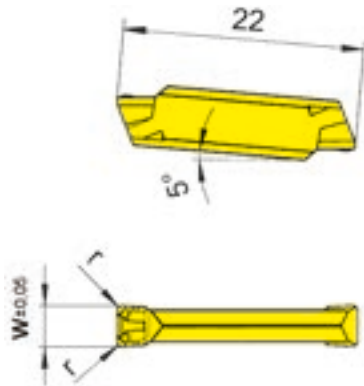
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
4-6 mm

精密烧结
precision sintered



配合刀夹
for Cassette

型号 R/LAK224
Type R/LIK224

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	ASG6	TF42	TI22
S224.0400.L4	4	0.4	04	▲	▲	▲		▲	▲
S224.0500.L4	5	0.4	05	▲	▲	▲	△	▲	▲
S224.0500.L6	5	0.6	05	△	▲	▲	△	▲	△
S224.0600.L4	6	0.4	06	△	▲			▲	▲
S224.0600.L6	6	0.6	06	▲	▲		△	△	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•	•	•
● 推荐 / recommended				M	-	-	o	o	-
o 次推荐 / alternative recommendation				K	•	-	•	o	-
- 不合适 / not suitable				N	•	-	•	-	-
■ 非涂层 / uncoated grades				S	-	-	o	-	-
■ 涂层 / coated grades				H	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet									

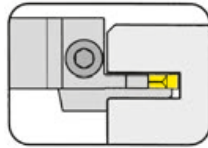
尺寸单位 : mm
Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK224和L/RIK224。
Indexable inserts can be used in right and left hand cassettes L/RAK224 and L/RIK224.

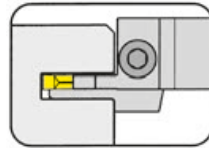
硬质合金牌号
Carbide grades

S

刀杆
Toolholder
A226/A210

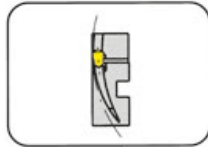


页/Page
S64,S66



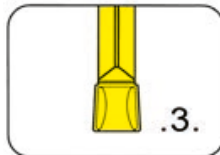
页/Page
S65,S67

刀夹
Cassette
LIK220/RIK220/
LAK220/RAK220

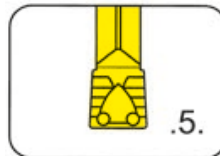


页/Page
S68-S83

可转位刀片
Indexable insert
S229



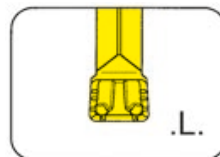
页/Page
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页/Page.
S85

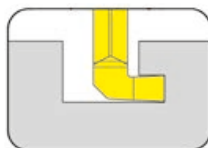


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S87

刀片
Insert
229



页/Page
S88

229



S

机夹式刀杆

槽宽 4 mm

Toolholder with Inserts

Width of groove 4 mm

端面切槽

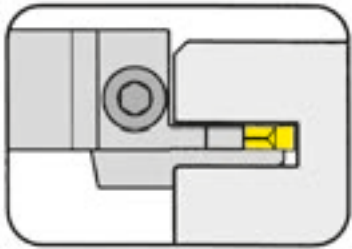
Face Grooving



刀杆

Toolholder

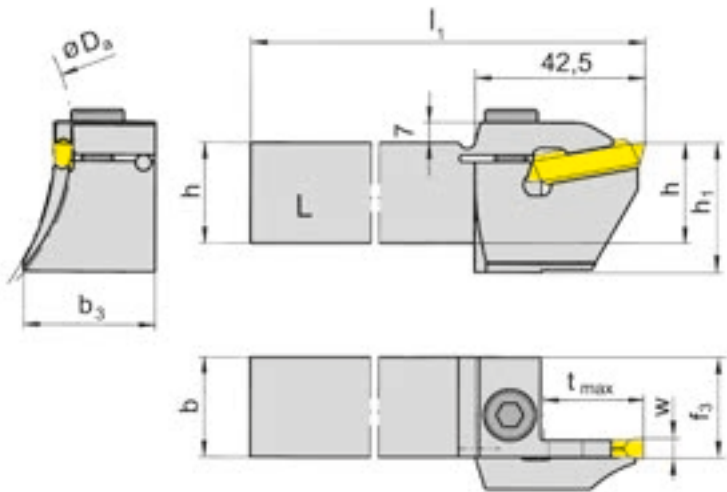
LA226



端面槽起始外径	from outer groove Ø	95 mm
槽深可达	Depth of groove up to	25 mm
槽宽	Width of groove	4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₃	t _{max}	D _{a min}	D _{a min2}	w	b ₃	尺寸规格 Size
LA226.20.1318.04	20	20	150	32	20.5	25	130	180	4	25	04
LA226.20.9513.04	20	20	150	32	20.5	25	95	130	4	26	04
LA226.25.1318.04	25	25	150	32	25.5	25	130	180	4	30	04
LA226.25.9513.04	25	25	150	32	25.5	25	95	130	4	31	04
LA226.20.1318.05	20	20	150	32	20.5	25	130	180	5	25	05
LA226.20.9513.05	20	20	150	32	20.5	25	95	130	5	28	05
LA226.25.1318.05	25	25	150	32	25.5	25	130	180	5	30	05
LA226.25.9513.05	25	25	150	32	25.5	25	95	130	5	33	05

按需提供更多尺寸
 Further sizes upon request
 螺丝的扭矩规格，详见技术说明。
 For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
 Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
LA226...	218.3	SW6,0 DIN911

端面切槽

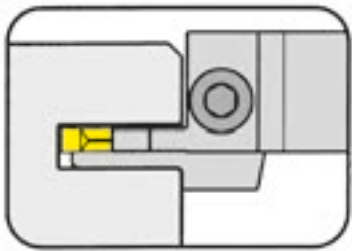
Face Grooving



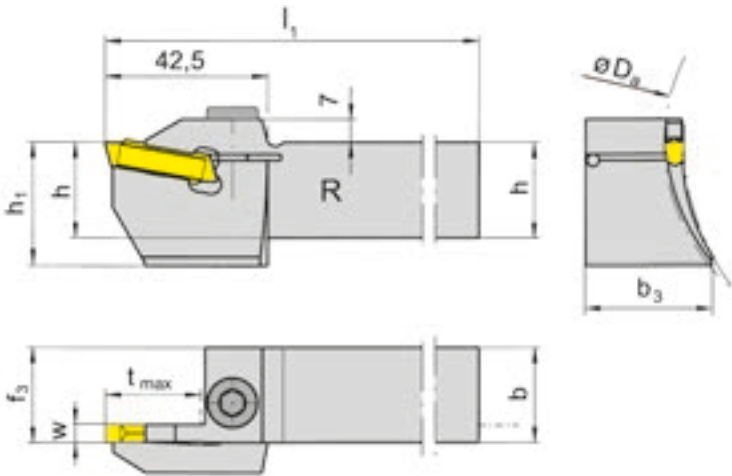
刀杆

Toolholder

RA226



端面槽起始外径	from outer groove Ø	95 mm
槽深可达	Depth of groove up to	25 mm
槽宽	Width of groove	4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₃	t _{max}	D _{a min}	D _{a min2}	w	b ₃	尺寸规格 Size
RA226.20.1318.04	20	20	150	32	20.5	25	130	180	4	25	04
RA226.20.9513.04	20	20	150	32	20.5	25	95	130	4	26	04
RA226.25.1318.04	25	25	150	32	25.5	25	130	180	4	30	04
RA226.25.9513.04	25	25	150	32	25.5	25	95	130	4	31	04
RA226.20.1318.05	20	20	150	32	20.5	25	130	180	5	25	05
RA226.20.9513.05	20	20	150	32	20.5	25	95	130	5	28	05
RA226.25.1318.05	25	25	150	32	25.5	25	130	180	5	30	05
RA226.25.9513.05	25	25	150	32	25.5	25	95	130	5	33	05

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
RA226...	218.3	SW6,0 DIN911

S

端面切槽

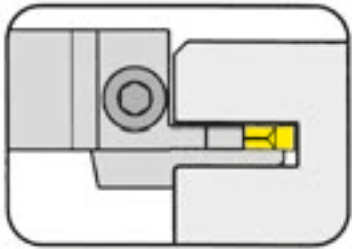
Face Grooving



刀杆

Toolholder

LA210



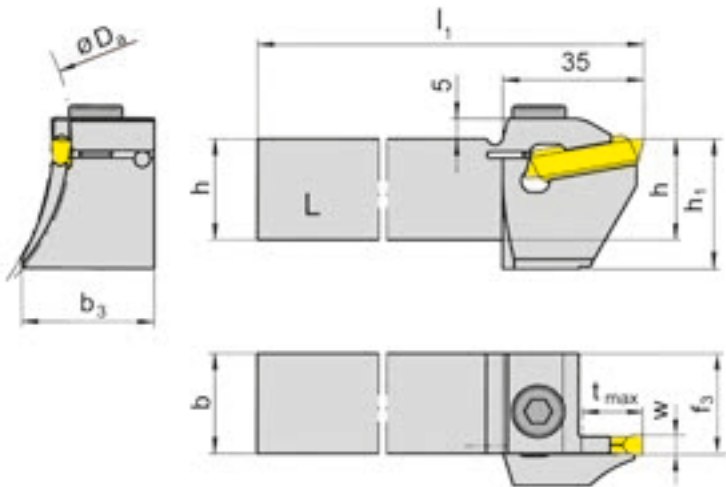
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
15 mm
4-8 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	b_3	f_3	t_{max}	$D_{a\ min}$	$D_{a\ max}$	w	尺寸规格 Size
LA210.20.1318.14	20	20	150	32	25.0	20.5	15	130	180	4	04
LA210.20.9513.14	20	20	150	32	26.0	20.5	15	95	130	4	04
LA210.25.1318.14	25	25	150	32	30.0	25.5	15	130	180	4	04
LA210.25.9513.14	25	25	150	32	31.0	25.5	15	95	130	4	04
LA210.20.1318.15	20	20	150	32	25.0	20.5	15	130	180	5	05
LA210.20.9513.15	20	20	150	32	28.0	20.5	15	95	130	5	05
LA210.25.1318.15	25	25	150	32	30.0	25.5	15	130	180	5	05
LA210.25.9513.15	25	25	150	32	33.0	25.5	15	95	130	5	05
LA210.25.1318.18	25	25	150	32	30.5	25.5	15	130	180	8	08

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
LA210...	218.3	SW6,0 DIN911

端面切槽

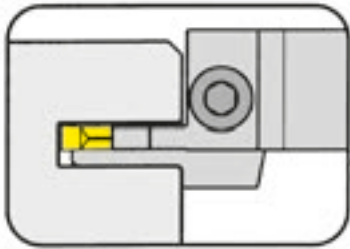
Face Grooving



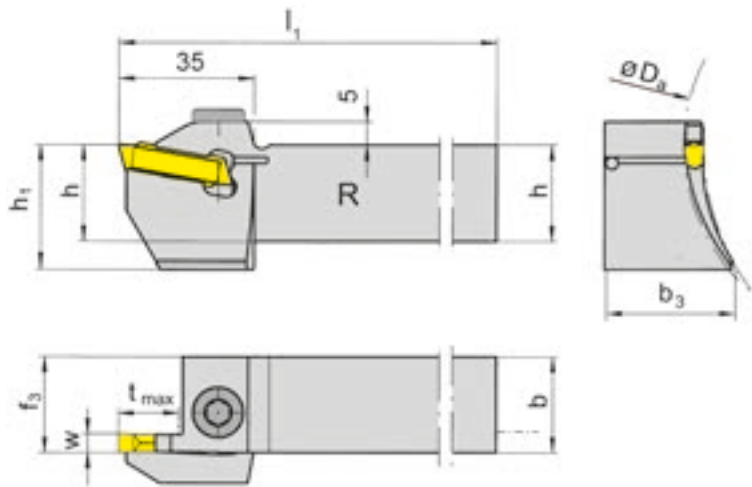
刀杆

Toolholder

RA210



端面槽起始外径	from outer groove Ø	95 mm
槽深可达	Depth of groove up to	15 mm
槽宽	Width of groove	4-8 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₃	f ₃	t _{max}	D _{a min}	D _{a max}	w	尺寸规格 Size
RA210.20.1318.14	20	20	150	32	25.0	20.5	15	130	180	4	04
RA210.20.9513.14	20	20	150	32	26.0	20.5	15	95	130	4	04
RA210.25.1318.14	25	25	150	32	30.0	25.5	15	130	180	4	04
RA210.25.9513.14	25	25	150	32	31.0	25.5	15	95	130	4	04
RA210.20.1318.15	20	20	150	32	25.0	20.5	15	130	180	5	05
RA210.25.1318.15	25	25	150	32	30.0	25.5	15	130	180	5	05
RA210.32.1318.15	32	32	150	32	37.0	32.5	15	130	180	5	05
RA210.20.9513.15	20	20	150	32	28.0	20.5	15	95	130	5	05
RA210.25.9513.15	25	25	150	32	33.0	25.5	15	95	130	5	05
RA210.25.1318.18	25	25	150	32	30.5	25.5	15	130	180	8	08

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
RA210...	218.3	SW6,0 DIN911



端面切槽

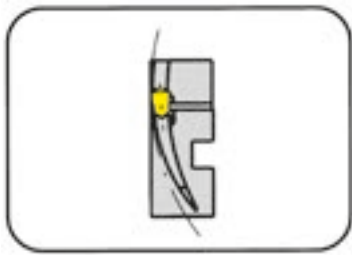
Face Grooving



刀夹

Cassette

LIK220



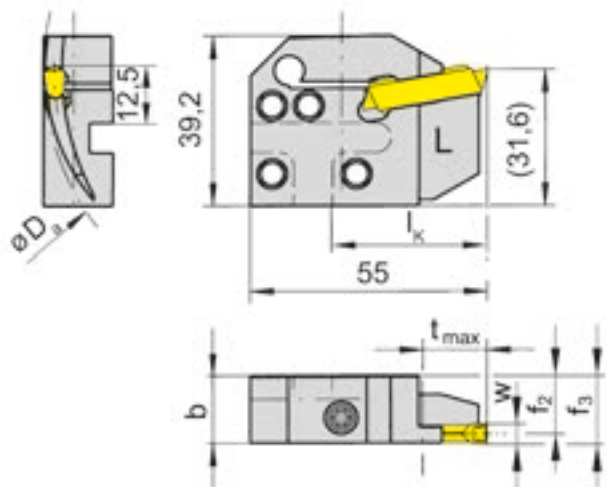
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK220.6575.14	65	75	10	15.7	14.4	f ₂ +w/2	4	36
LIK220.7595.14	75	95	15	15.7	14.4	f ₂ +w/2	4	36
LIK220.9513.14	95	130	15	15.7	14.4	f ₂ +w/2	4	36
LIK220.1318.14	130	180	15	15.7	14.4	f ₂ +w/2	4	36
LIK220.1830.14	180	300	15	15.7	14.4	f ₂ +w/2	4	36
LIK220.6075.15	60	75	10	15.7	13.9	f ₂ +w/2	5	36
LIK220.7595.15	75	95	15	15.7	13.9	f ₂ +w/2	5	36
LIK220.9513.15	95	130	15	15.7	13.9	f ₂ +w/2	5	36
LIK220.1318.15	130	180	15	15.7	13.9	f ₂ +w/2	5	36
LIK220.1830.15	180	300	15	15.7	13.9	f ₂ +w/2	5	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no sepearte order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

S68

端面切槽

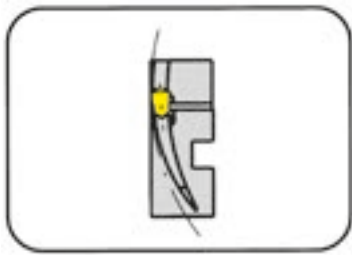
Face Grooving



刀夹

Cassette

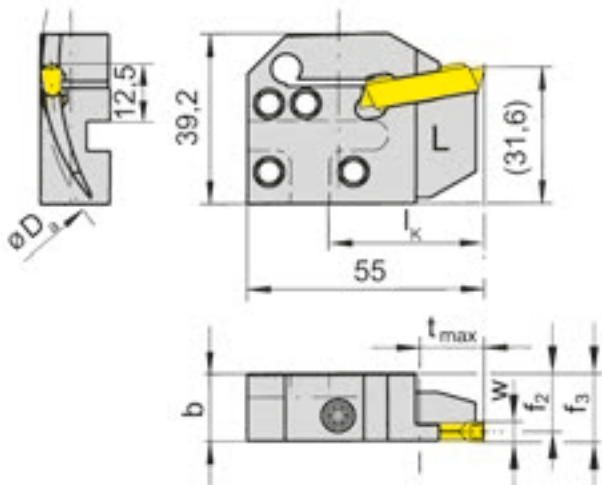
LIK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK220.6075.16	60	75	10	15.7	13.4	f ₂ +w/2	6	36
LIK220.7595.16	75	95	15	15.7	13.4	f ₂ +w/2	6	36
LIK220.9513.16	95	130	15	15.7	13.4	f ₂ +w/2	6	36
LIK220.1318.16	130	180	15	15.7	13.4	f ₂ +w/2	6	36
LIK220.1830.16	180	300	15	15.7	13.4	f ₂ +w/2	6	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

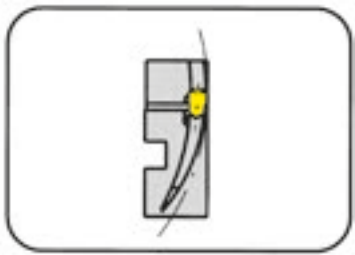
Face Grooving



刀夹

Cassette

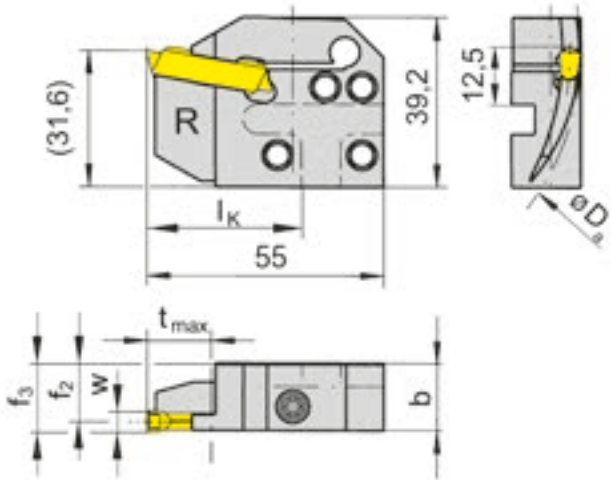
RIK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _K
RIK220.6575.14	65	75	10	15.7	14.4	f ₂ +w/2	4	36
RIK220.7595.14	75	95	15	15.7	14.4	f ₂ +w/2	4	36
RIK220.9513.14	95	130	15	15.7	14.4	f ₂ +w/2	4	36
RIK220.1318.14	130	180	15	15.7	14.4	f ₂ +w/2	4	36
RIK220.1830.14	180	300	15	15.7	14.4	f ₂ +w/2	4	36
RIK220.6075.15	60	75	10	15.7	13.9	f ₂ +w/2	5	36
RIK220.7595.15	75	95	15	15.7	13.9	f ₂ +w/2	5	36
RIK220.9513.15	95	130	15	15.7	13.9	f ₂ +w/2	5	36
RIK220.1318.15	130	180	15	15.7	13.9	f ₂ +w/2	5	36
RIK220.1830.15	180	300	15	15.7	13.9	f ₂ +w/2	5	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separte order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

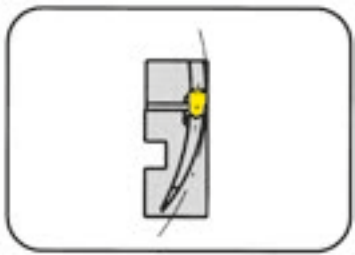
端面切槽

Face Grooving



刀夹
Cassette

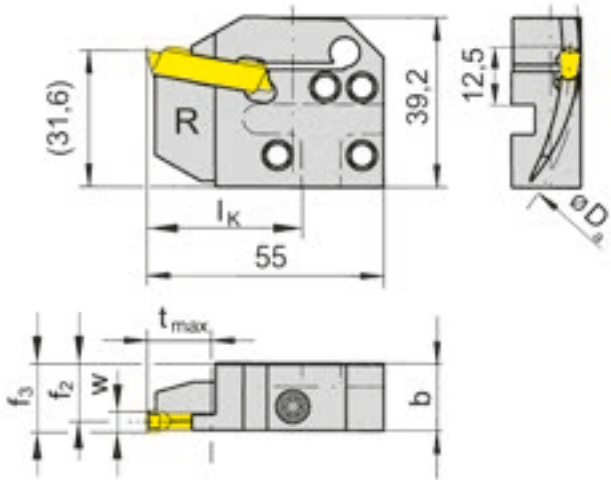
RIK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _K
RIK220.6075.16	60	75	10	15.7	13.4	f ₂ +w/2	6	36
RIK220.7595.16	75	95	15	15.7	13.4	f ₂ +w/2	6	36
RIK220.9513.16	95	130	15	15.7	13.4	f ₂ +w/2	6	36
RIK220.1318.16	130	180	15	15.7	13.4	f ₂ +w/2	6	36
RIK220.1830.16	180	300	15	15.7	13.4	f ₂ +w/2	6	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

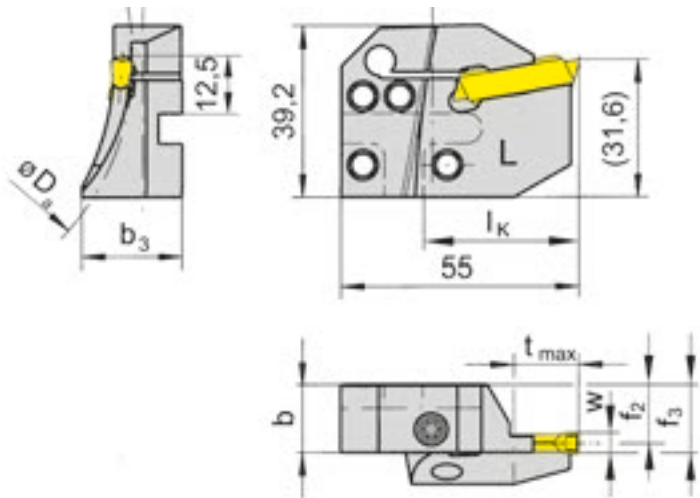
LAK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK220.6575.14	65	75	10	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.7595.14	75	95	15	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.9513.14	95	130	15	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1318.14	130	180	15	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1830.14	180	300	15	15.7	19.0	14.4	f ₂ +w/2	4	36
LAK220.6075.15	60	75	10	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.7595.15	75	95	15	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.9513.15	95	130	15	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.1318.15	130	180	15	15.7	21.2	13.9	f ₂ +w/2	5	36
LAK220.1830.15	180	300	15	15.7	19.0	13.9	f ₂ +w/2	5	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



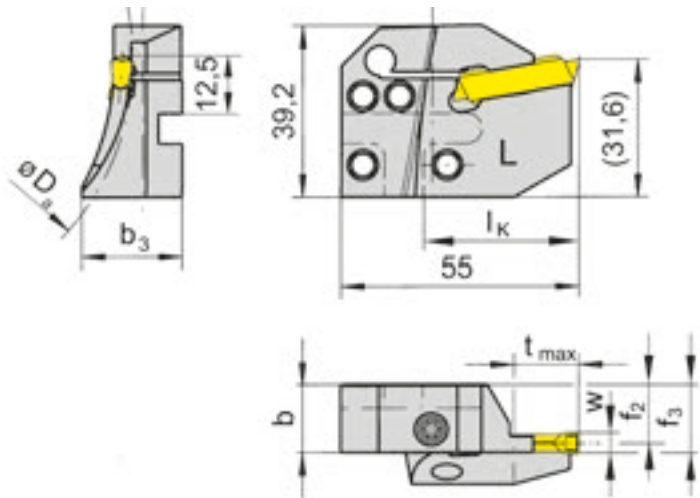
刀夹

Cassette

LAK220



端面槽起始外径	from outer groove Ø	95 mm
槽深可达	Depth of groove up to	25 mm
槽宽	Width of groove	4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _K
LAK220.6075.16	60	75	10	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.7595.16	75	95	15	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.9513.16	95	130	15	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.1318.16	130	180	15	15.7	21.2	13.4	f ₂ +w/2	6	36
LAK220.1830.16	180	300	15	15.7	19.0	13.4	f ₂ +w/2	6	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no seperate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ



端面切槽

Face Grooving



刀夹

Cassette

RAK220



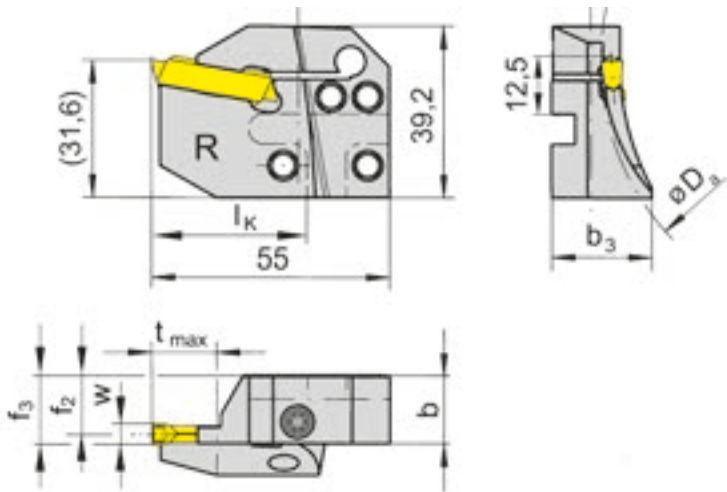
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6575.14	65	75	10	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.7595.14	75	95	15	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.9513.14	95	130	15	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1318.14	130	180	15	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1830.14	180	300	15	15.7	19.0	14.4	f ₂ +w/2	4	36
RAK220.6075.15	60	75	10	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.7595.15	75	95	15	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.9513.15	95	130	15	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.1318.15	130	180	15	15.7	21.2	13.9	f ₂ +w/2	5	36
RAK220.1830.15	180	300	15	15.7	19.0	13.9	f ₂ +w/2	5	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

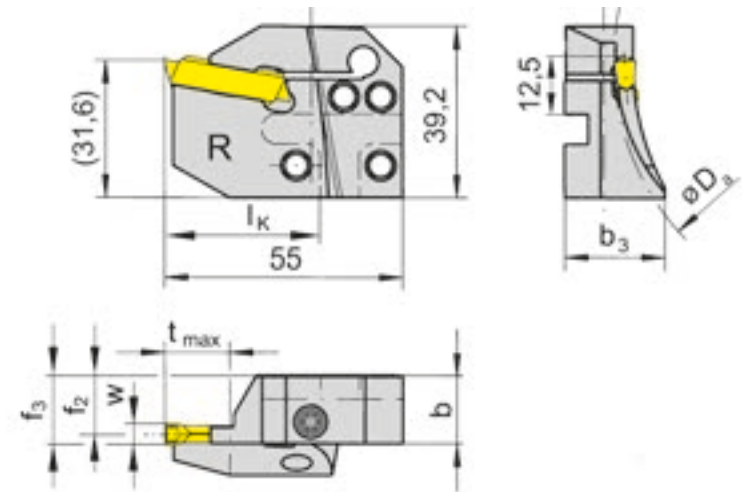
RAK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6075.16	60	75	10	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.7595.16	75	95	15	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.9513.16	95	130	15	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.1318.16	130	180	15	15.7	21.2	13.4	f ₂ +w/2	6	36
RAK220.1830.16	180	300	15	15.7	19.0	13.4	f ₂ +w/2	6	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

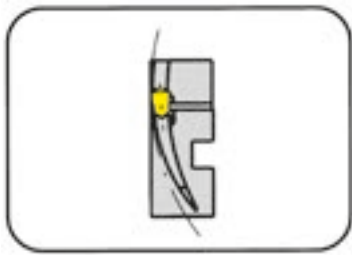
Face Grooving



刀夹

Cassette

LIK220



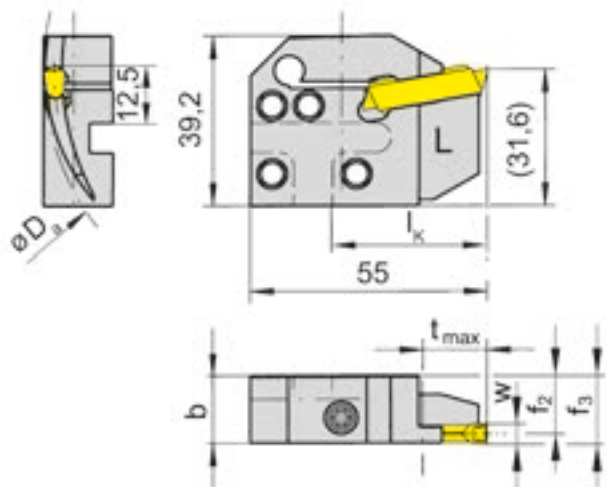
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229
N229



L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK220.6575.04	65	75	10	15.7	14.4	f ₂ +w/2	4	36
LIK220.7595.04	75	95	15	15.7	14.4	f ₂ +w/2	4	36
LIK220.9513.04	95	130	25	15.7	14.4	f ₂ +w/2	4	36
LIK220.1318.04	130	180	25	15.7	14.4	f ₂ +w/2	4	36
LIK220.1830.04	180	300	25	15.7	14.4	f ₂ +w/2	4	36
LIK220.3000.04	300	1000	25	15.7	14.4	f ₂ +w/2	4	36
LIK220.6075.05	60	75	10	15.7	13.9	f ₂ +w/2	5	36
LIK220.7595.05	75	95	17	15.7	13.9	f ₂ +w/2	5	36
LIK220.9513.05	95	130	25	15.7	13.9	f ₂ +w/2	5	36
LIK220.1318.05	130	180	25	15.7	13.9	f ₂ +w/2	5	36
LIK220.1830.05	180	300	25	15.7	13.9	f ₂ +w/2	5	36
LIK220.3000.05	300	1000	25	15.7	13.9	f ₂ +w/2	5	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

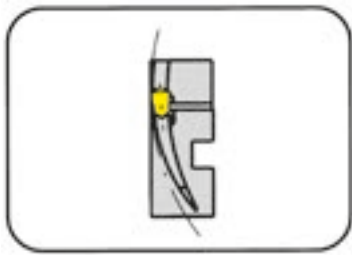
Face Grooving



刀夹

Cassette

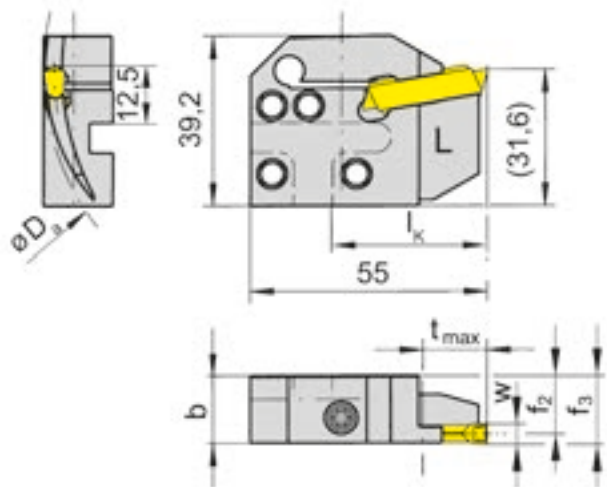
LIK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
LIK220.6075.06	60	75	10	15.7	13.4	f ₂ +w/2	6	36
LIK220.7595.06	75	95	17	15.7	13.4	f ₂ +w/2	6	36
LIK220.9513.06	95	130	25	15.7	13.4	f ₂ +w/2	6	36
LIK220.1318.06	130	180	25	15.7	13.4	f ₂ +w/2	6	36
LIK220.1830.06	180	300	25	15.7	13.4	f ₂ +w/2	6	36
LIK220.3000.06	300	1000	25	15.7	13.4	f ₂ +w/2	6	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

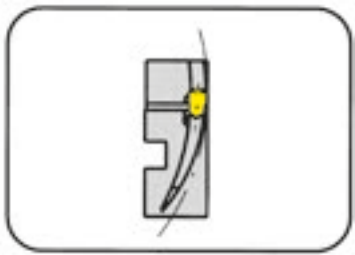
Face Grooving



刀夹

Cassette

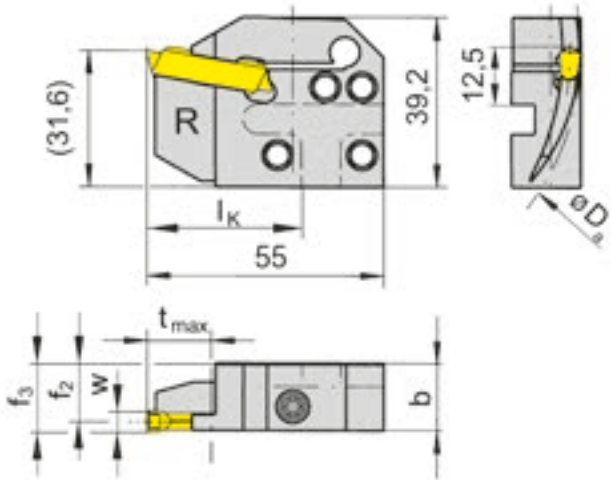
RIK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _K
RIK220.6575.04	65	75	10-15	15.7	14.4	f ₂ +w/2	4	36
RIK220.7595.04	75	95	15-25	15.7	14.4	f ₂ +w/2	4	36
RIK220.9513.04	95	130	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.1318.04	130	180	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.1830.04	180	300	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.3000.04	300	1000	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.6075.05	60	75	10	15.7	13.9	f ₂ +w/2	5	36
RIK220.7595.05	75	95	17	15.7	13.9	f ₂ +w/2	5	36
RIK220.9513.05	95	130	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.1318.05	130	180	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.1830.05	180	300	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.3000.05	300	1000	25	15.7	13.9	f ₂ +w/2	5	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

端面切槽

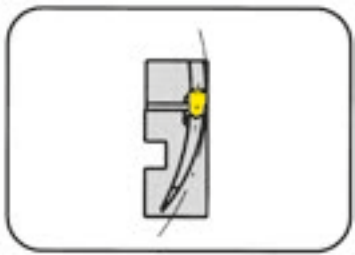
Face Grooving



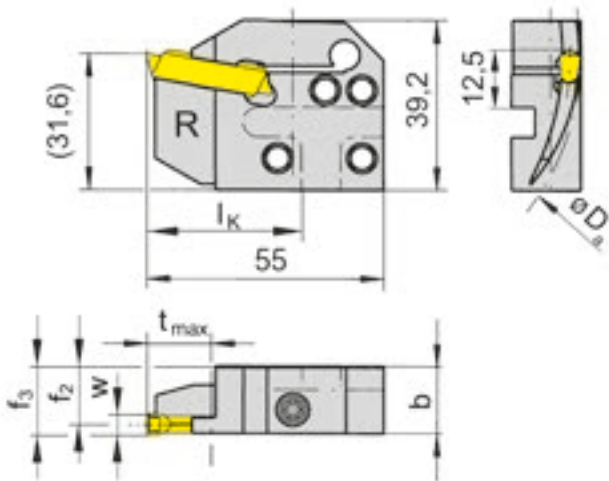
刀夹

Cassette

RIK220



端面槽起始外径	from outer groove Ø	95 mm
槽深可达	Depth of groove up to	25 mm
槽宽	Width of groove	4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _a min	D _a max	t _{max}	b	f ₂	f ₃	w	l _K
RIK220.6075.06	60	75	10-17	15.7	13.4	f ₂ +w/2	6	36
RIK220.7595.06	75	95	17-24	15.7	13.4	f ₂ +w/2	6	36
RIK220.9513.06	95	130	25	15.7	13.4	f ₂ +w/2	6	36
RIK220.1318.06	130	180	25	15.7	13.4	f ₂ +w/2	6	36
RIK220.1830.06	180	300	25	15.7	13.4	f ₂ +w/2	6	36
RIK220.3000.06	300	1000	25	15.7	13.4	f ₂ +w/2	6	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no seperate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ



端面切槽

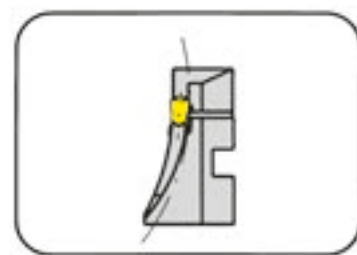
Face Grooving



刀夹

Cassette

LAK220



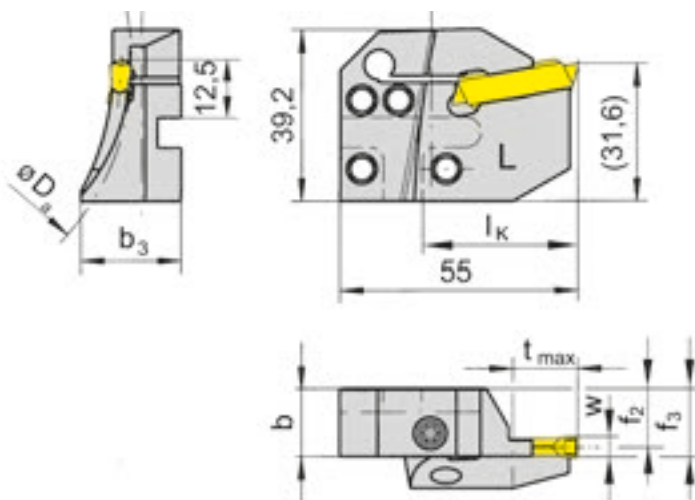
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK220.6575.04	65	75	10-17	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.7595.04	75	95	15-25	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.9513.04	95	130	25-25	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1318.04	130	180	25-25	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1830.04	180	300	25-25	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.3000.04	300	1000	25-25	15.7	16.8	14.4	f ₂ +w/2	4	36
LAK220.6075.05	60	75	10-17	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.7595.05	75	95	17-25	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.9513.05	95	130	25-25	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.1318.05	130	180	25-25	15.7	21.2	13.9	f ₂ +w/2	5	36
LAK220.1830.05	180	300	25-25	15.7	21.2	13.9	f ₂ +w/2	5	36
LAK220.3000.05	300	1000	25-25	15.7	16.8	13.9	f ₂ +w/2	5	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

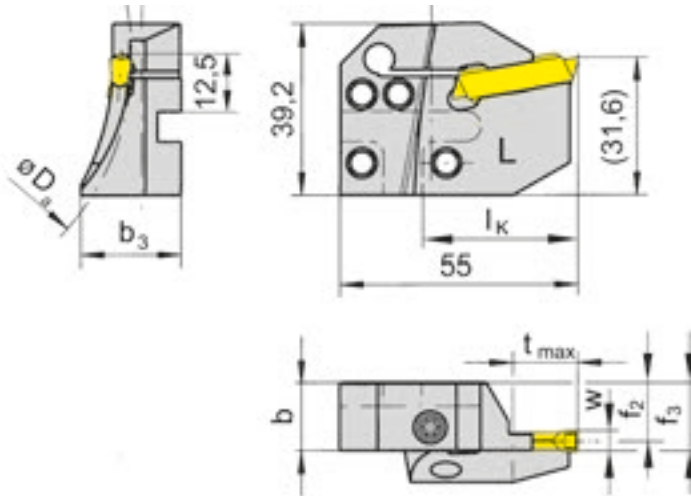
LAK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK220.6075.06	60	75	10-17	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.7595.06	75	95	17-25	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.9513.06	95	130	25-25	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.1318.06	130	180	25-25	15.7	21.2	13.4	f ₂ +w/2	6	36
LAK220.1830.06	180	300	25-25	15.7	21.2	13.4	f ₂ +w/2	6	36
LAK220.3000.06	300	1000	25-25	15.7	16.8	13.4	f ₂ +w/2	6	36

配合常规刀杆L...K1和R...K2
For basic toolholder L...K1 and R...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

RAK220



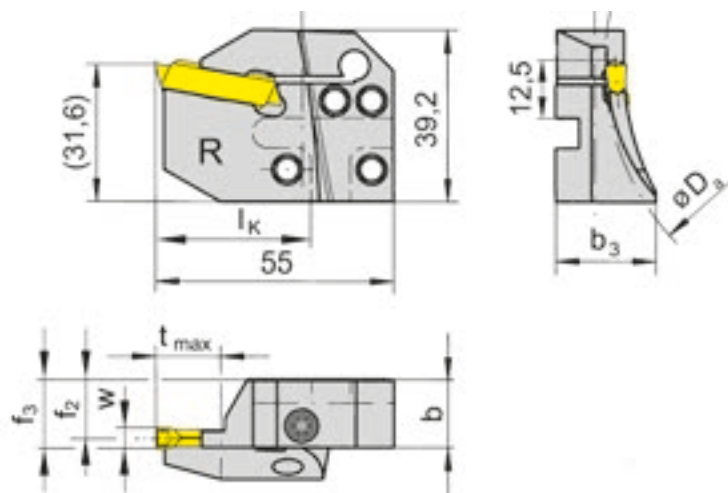
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm

配合可转位刀片
for Indexable insert

型号 229
Type S229



R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6575.04	65	75	10	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.7595.04	75	95	15	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.9513.04	95	130	25	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1318.04	130	180	25	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1830.04	180	300	25	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.3000.04	300	1000	25	15.7	16.8	14.4	f ₂ +w/2	4	36
RAK220.6075.05	60	75	10	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.7595.05	75	95	17	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.9513.05	95	130	25	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.1318.05	130	180	25	15.7	21.2	13.9	f ₂ +w/2	5	36
RAK220.1830.05	180	300	25	15.7	21.2	13.9	f ₂ +w/2	5	36
RAK220.3000.05	300	1000	25	15.7	16.8	13.9	f ₂ +w/2	5	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

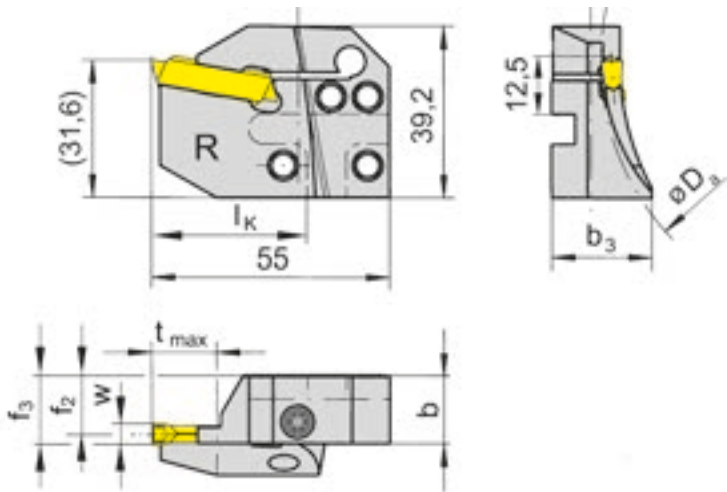
RAK220



端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

95 mm
25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 229
Type S229

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6075.06	60	75	10	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.7595.06	75	95	17	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.9513.06	95	130	25	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.1318.06	130	180	25	15.7	21.2	13.4	f ₂ +w/2	6	36
RAK220.1830.06	180	300	25	15.7	21.2	13.4	f ₂ +w/2	6	36
RAK220.3000.06	300	1000	25	15.7	16.8	13.4	f ₂ +w/2	6	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no seperate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ



端面切槽

Face Grooving

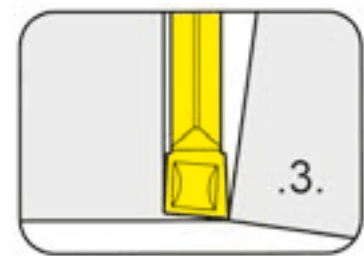


可转位刀片

Indexable insert

S229

带卷屑器
with chip former



槽深可达
槽宽

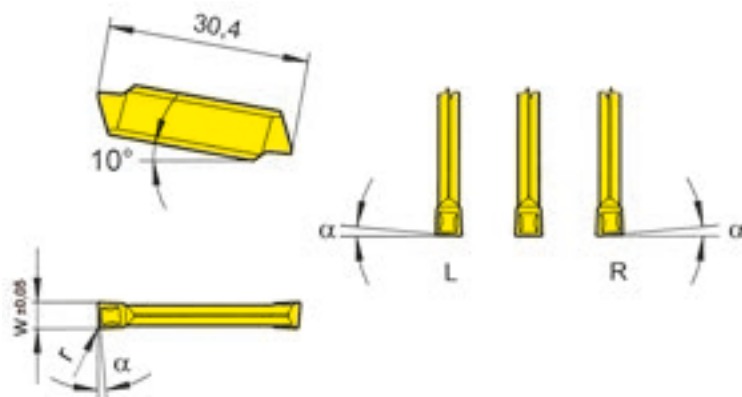
Depth of groove up to
Width of groove

25 mm
4-6 mm

精密烧结
precision sintered

配合刀夹
for Cassette

型号 R/LAK220
Type R/LIK220



宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 mm
Width 6 mm

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

产品型号 Part number	w	r	尺寸规格 Size	MG12	AL96	AS62	AS66	H54	P20	TA45	TC92	TF42	TF45	TI22	TI25	TN32	TN35
S229.0400.32	4	0.2	04	Δ	▲	▲	▲	▲	Δ	Δ	▲		▲	Δ	▲	▲	▲
S229.0400.34	4	0.4	04	Δ	▲	▲	▲	▲	Δ		▲	▲	▲	Δ	▲	▲	▲
S229.0500.34	5	0.4	04	Δ	▲	▲	▲	Δ	Δ	Δ	▲		▲	▲	▲	▲	▲
S229.0500.36	5	0.6	04					Δ	Δ		Δ			Δ	Δ	Δ	Δ
S229.0600.34	6	0.4	05	Δ	▲	▲	▲	Δ	Δ	Δ	Δ		▲	Δ	▲	▲	▲
S229.0600.38	6	0.8	05		▲	▲	▲				▲			Δ			
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	o	•	•	•	•	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	o	•	-	•	-	•	-	•	-	•
o 次推荐 / alternative recommendation				K	-	•	-	•	-	•	-	-	•	-	•	-	•
- 不合适 / not suitable				N	-	•	-	•	-	•	-	-	•	-	•	-	•
■ 非涂层 / uncoated grades				S	-	-	-	o	-	•	-	-	•	-	•	-	•
■ 涂层 / coated grades				H	-	-	-	-	-	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet																	

尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

端面切槽 Face Grooving



可转位刀片 Indexable insert

S229

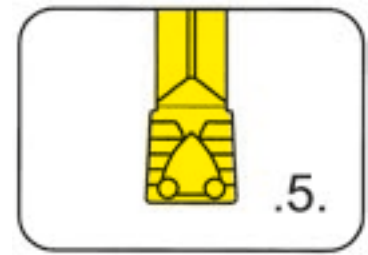
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

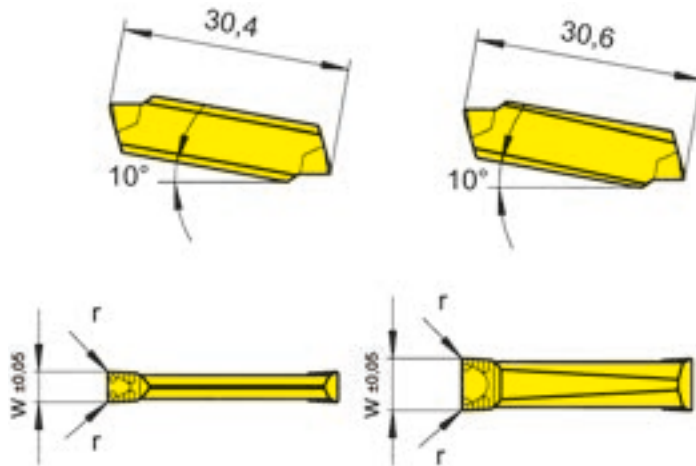
25 mm
4-6 mm

精密烧结
precision sintered



配合刀夹
for Cassette

型号 R/LAK220
Type R/LIK220



宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 mm
Width 6 mm

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

S

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	P20	TC92	TF45	TI22	TI25	TN32	TN35
S229.0400.52	4	0.2	04	Δ	▲	Δ	Δ	▲	▲	▲	▲	▲
S229.0400.54	4	0.4	04	Δ	▲			▲	▲	▲	▲	▲
S229.0500.54	5	0.4	04	Δ	▲	Δ	▲	▲	▲	▲	▲	▲
S229.0500.56	5	0.6	06				Δ			Δ	Δ	Δ
S229.0600.54	6	0.4	05	Δ	▲	Δ	▲	▲		▲	▲	▲
S229.0600.56	6	0.6	05	Δ			Δ			Δ	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	•	-	•	-	•
o 次推荐 / alternative recommendation				K	•	-	-	•	-	•	-	•
- 不合适 / not suitable				N	•	-	-	•	-	•	-	•
非涂层 / uncoated grades				S	-	-	-	•	-	-	-	•
涂层 / coated grades				H	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位 : mm
Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

硬质合金牌号
Carbide grades

端面切槽 Face Grooving



可转位刀片 Indexable insert

S229

带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

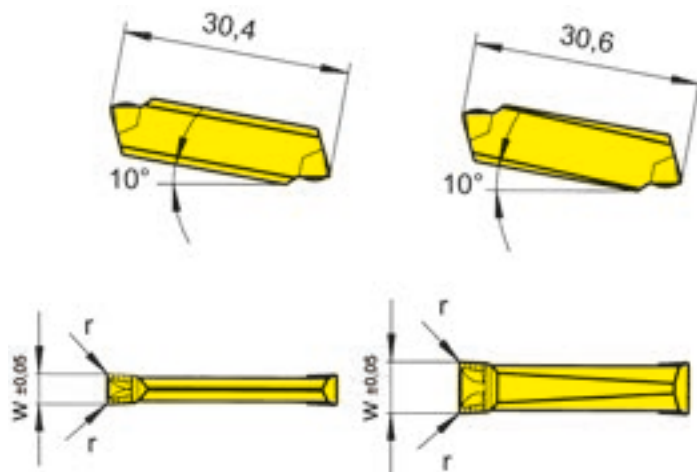
25 mm
4-6 mm

精密烧结
precision sintered



配合刀夹
for Cassette

型号 R/LAK220
Type R/LIK220



宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 mm
Width 6 mm

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	P20	TC92	TF42	TF45	TI22	TI25	TN32	TN35
S229.0400.A2	4	0.2	04	Δ	▲	Δ	Δ	▲	▲	Δ	▲	▲	▲
S229.0400.A4	4	0.4	04	Δ	▲	Δ	Δ	▲	Δ	▲	▲	▲	▲
S229.0500.A4	5	0.4	04	Δ	▲	Δ	Δ	▲	Δ	▲	▲	▲	▲
S229.0600.A4	6	0.4	05	Δ	▲	Δ	Δ	▲	▲	Δ	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•	•	•	•	•	•	•	•	•
● 推荐 / recommended				M	-	-	-	-	•	-	•	-	•
o 次推荐 / alternative recommendation				K	•	-	-	-	•	-	•	-	•
- 不合适 / not suitable				N	•	-	-	-	•	-	•	-	•
非涂层 / uncoated grades				S	-	-	-	-	•	-	•	-	•
涂层 / coated grades				H	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm
Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。
Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

硬质合金牌号
Carbide grades

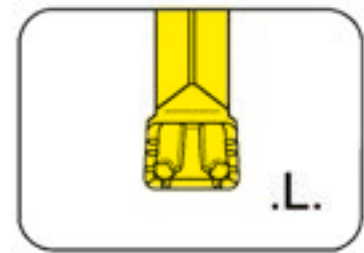
端面切槽 Face Grooving



可转位刀片 Indexable insert

S229

带卷屑器
with chip forming

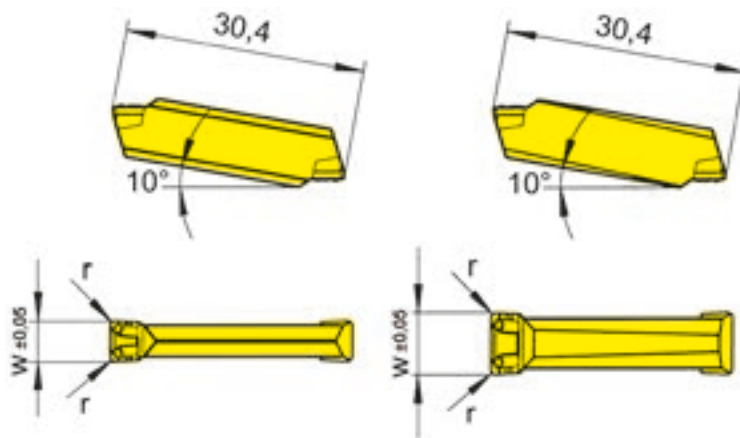


槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-6 mm

精密烧结
precision sintered



配合刀夹
for Cassette

型号 R/LAK220
Type R/LIK220

宽度 4 - 5 mm
Width 4 - 5 mm

宽度 6 mm
Width 6 mm

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

产品型号 Part number	w	r	尺寸规格 Size	AL96	AS62	AS66	TF42	Ti22
S229.0400.L4	4	0.4	04	▲	▲	▲	▲	▲
S229.0500.L4	5	0.4	04	▲	▲	▲	▲	▲
S229.0500.L6	5	0.6	04	▲	▲	▲	▲	△
S229.0600.L4	6	0.4	05	△	▲	▲	▲	▲
S229.0600.L6	6	0.6	05	△	▲	▲	▲	▲
P				●	●	●	●	●
M				-	-	o	-	-
K				●	-	●	-	-
N				●	-	●	-	-
S				-	-	o	-	-
H				-	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

可转位刀片均适用于左手型和右手型刀夹L/RAK220 and L/RIK220。

Indexable inserts can be used in right and left hand cassettes L/RAK220 and L/RIK220.

硬质合金牌号
Carbide grades

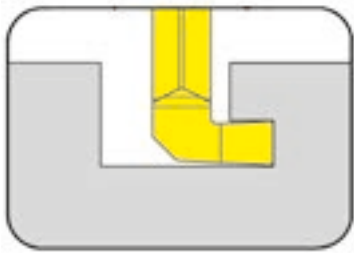
端面切槽

Face Grooving



刀片
Insert

229



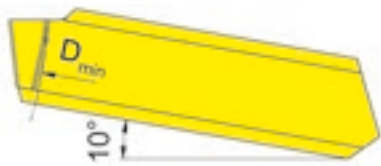
槽深可达
槽宽

Depth of groove up to
Width of groove

4 mm
3-4 mm

配合刀杆
for Toolholder

型号 210
Type 213
214
218
219
225
226
257



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	a	f	D _{min}	尺寸规格 Size	AS65
R/L229.3040.HA50.12	3	0.2	4	8.3	6.3	50	04	ΔΔ
R/L229.4040.HA50.12	4	0.2	4	8.3	6.3	50	04	ΔΔ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

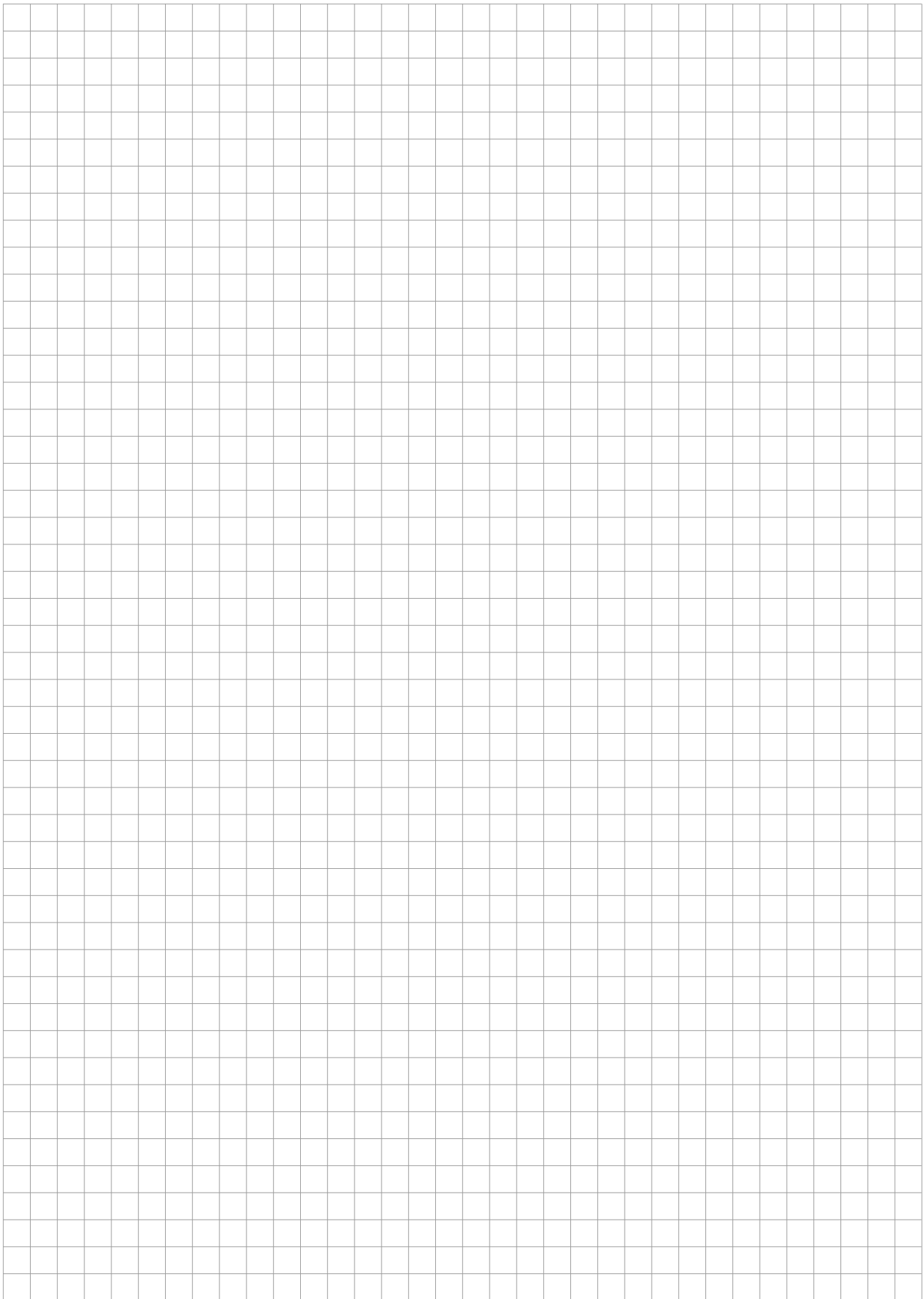
Dimensions in mm

注明R或L型

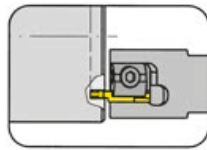
State R or L version

P	•
M	o
K	o
N	-
S	-
H	-

硬质合金牌号
Carbide grades

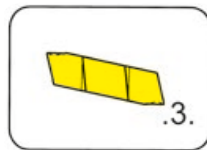


刀杆
Toolholder
221/228



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可转位刀片
Indexable insert
231



页/Page
S94

231



机夹式刀杆

槽宽 3,0 - 10,0 mm

Toolholder with Inserts

Width of groove 3,0 - 10,0 mm

端面切槽

Face Grooving

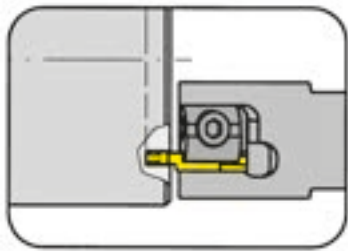


刀杆

Toolholder

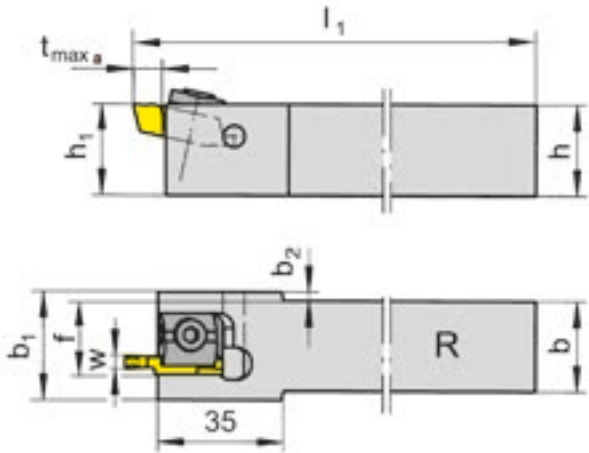
221

端面槽起始外径	from outer groove Ø	40 mm
槽深可达	Depth of groove up to	8 mm
夹持范围	Clamping range	3-10 mm



配合可转位刀片
for Indexable insert

型号 231
Type N231



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	b ₁	f	t _{max a}	b ₂	D _{a min}	尺寸规格 Size	夹持范围 Clamping range
R/L221.2020.04	20	20	125	20	28	17.9	8	4.0	40	04	3.0-4.0
R/L221.2525.04	25	25	150	25	28	20.4	8	1.5	40	04	3.0-4.0
R/L221.2020.05	20	20	125	20	30	18.9	8	5.0	40	05	4.1-6.0
R/L221.2525.05	25	25	150	25	30	21.4	8	2.5	40	05	4.1-6.0
R/L221.2020.07	20	20	125	20	32	19.9	8	6.0	40	07	6.1-8.0
R/L221.2525.07	25	25	150	25	32	22.4	8	3.5	40	07	6.1-8.0
R/L221.2020.09	20	20	125	20	34	20.9	8	7.0	40	09	8.1-10.0
R/L221.2525.09	25	25	150	25	34	23.4	8	4.5	40	09	8.1-10.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

取决于切槽深度，当D_a=30 mm到∞时可以使用此刀杆。

This toolholder can be used from D_a = 30 mm up to ∞ depending on grooving depth.

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	定位销 Stop Pin	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L221...	3.6.28	01.60.12	T20PQ

端面切槽

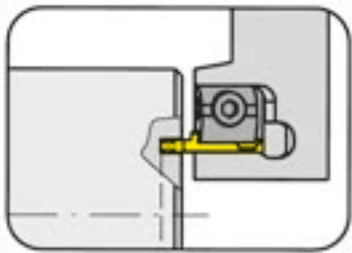
Face Grooving



刀杆

Toolholder

228



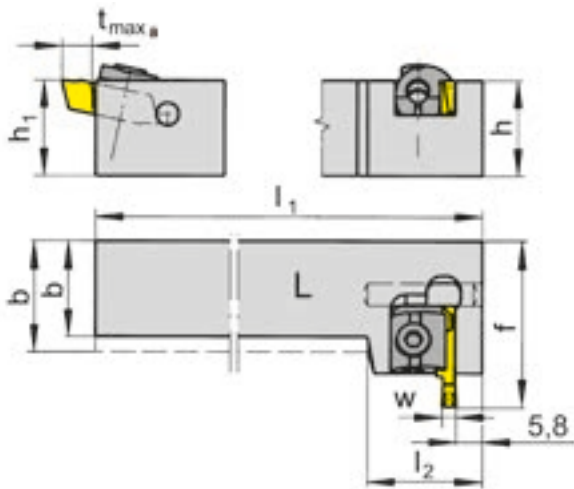
端面槽起始外径
槽深可达
夹持范围

from outer groove Ø
Depth of groove up to
Clamping range

40 mm
8 mm
3-10 mm

配合可转位刀片
for Indexable insert

型号 231
Type N231



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	h ₁	f	t _{max a}	D _{a min}	I ₁	I ₂	尺寸规格 Size	夹持范围 Clamping range
R/L228.2020.04	20	20	20	38.5	8	40	125	35.5	04	3.0-4.0
R/L228.2525.04	25	25	25	38.5	8	40	150	35.5	04	3.0-4.0
R/L228.2020.05	20	20	20	38.5	8	40	125	35.5	05	4.1-6.0
R/L228.2525.05	25	25	25	38.5	8	40	150	35.5	05	4.1-6.0
R/L228.2020.07	20	20	20	38.5	8	40	125	35.5	07	6.1-8.0
R/L228.2525.07	25	25	25	38.5	8	40	150	35.5	07	6.1-8.0
R/L228.2020.09	20	20	20	38.5	8	40	125	35.5	09	8.1-10.0
R/L228.2525.09	25	25	25	38.5	8	40	150	35.5	09	8.1-10.0

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
取决于切槽深度，当D_a=30 mm到∞时可以使用此刀杆。
This toolholder can be used from D_a = 30 mm up to ∞ depending on grooving depth.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	定位销 Stop Pin	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/L228...	3.6.28	01.60.12	T20PQ

端面切槽

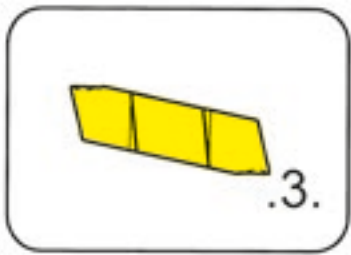
Face Grooving



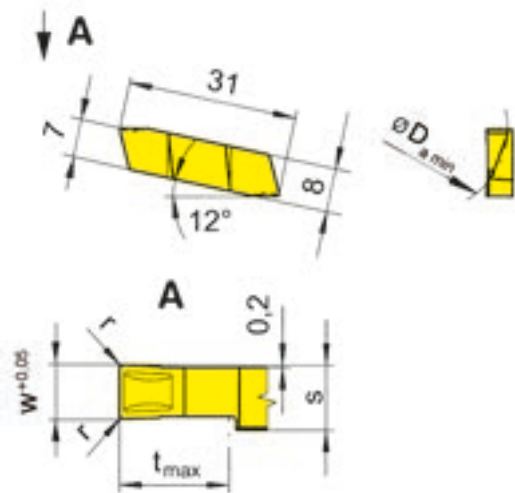
可转位刀片

Indexable insert

231
带卷屑器
with chip former



端面槽起始外径	from outer groove Ø	40 mm
槽深可达	Depth of groove up to	8 mm
槽宽	Width of groove	3-10 mm



配合刀杆
for Toolholder

型号 221
Type 228

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

产品型号 Part number	w	r	t _{max}	s	D _{a min}	尺寸规格 Size	TN35
R/L231.4030.32	3	0.2	8	3.8	40	04	▲/▲
R/L231.4040.32	4	0.2	8	3.8	40	04	▲/▲
R/L231.4050.34	5	0.4	8	5.8	40	05	▲/▲
N231.4060.34	6	0.4	8	5.8	40	05	▲
N231.4070.36	7	0.6	8	7.8	40	07	Δ
N231.4080.36	8	0.6	8	7.8	40	07	▲
N231.4090.38	9	0.8	8	9.8	40	09	Δ
N231.4100.38	10	0.8	8	9.8	40	09	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R, L或N型

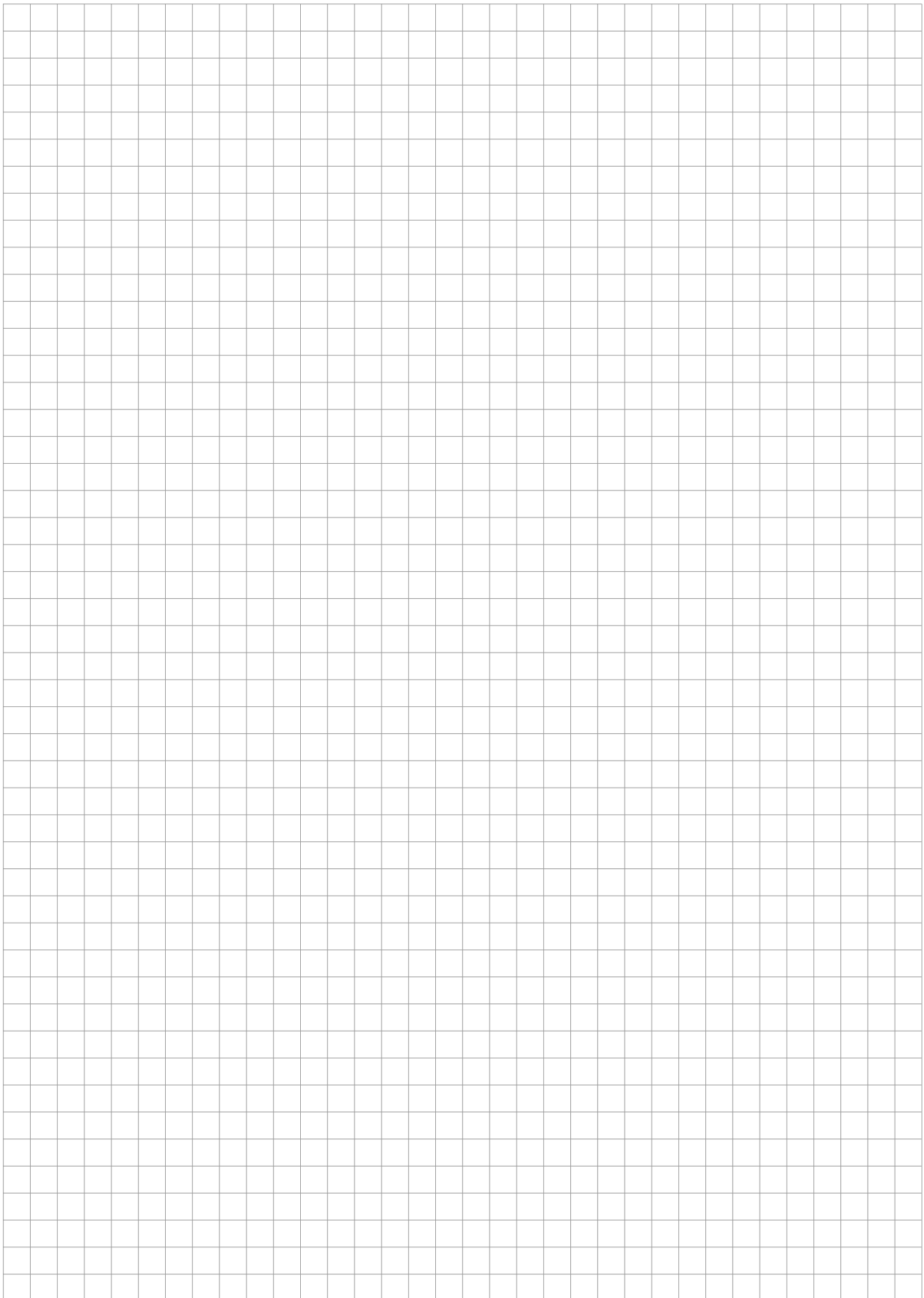
State R, L or N version

槽外径Ø<40mm时可定制非标产品

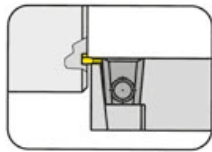
Outer-Ø of groove < 40 mm upon request.

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

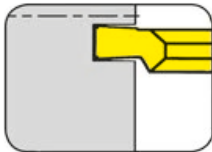


刀杆
Toolholder
360/369



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可转位刀片
Indexable insert
312



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312



S

机夹式刀杆

槽宽 1,5 - 3 mm

Toolholder with Inserts

Width of groove 1,5 - 3 mm

端面切槽
Face Grooving



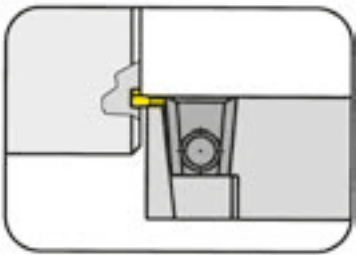
刀杆
Toolholder

360

端面槽起始外径
槽深可达
夹持范围

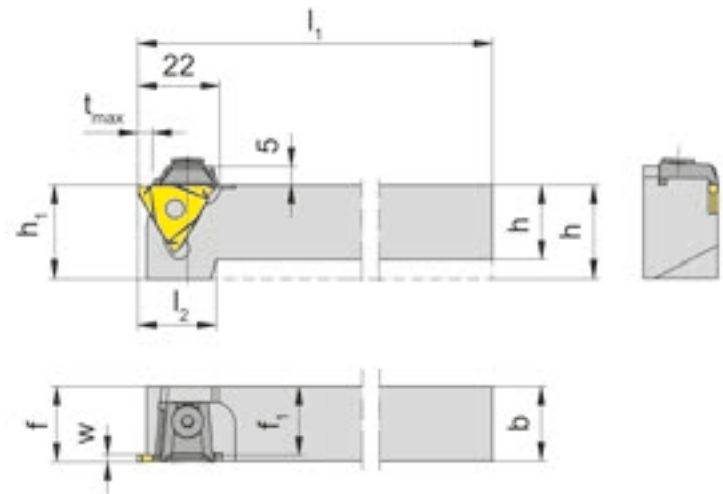
from outer groove Ø
Depth of groove up to
Clamping range

20 mm
6 mm
1,9-3,9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.02	12	12	100	24	25	9.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L360.1616.02	16	16	125	22	25	13.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L360.2020.02	20	20	125	21	25	17.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L360.2525.02	25	25	150	-	25	22.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L360.3232.02	32	32	170	-	32	29.5	f ₁ +w-a ₁	6	02	1.9-2.9
R/L360.1212.03	12	12	100	24	25	8.5	f ₁ +w-a ₁	6	03	2.9-3.9
R/L360.1616.03	16	16	125	22	25	12.5	f ₁ +w-a ₁	6	03	2.9-3.9
R/L360.2020.03	20	20	125	21	25	16.5	f ₁ +w-a ₁	6	03	2.9-3.9
R/L360.2525.03	25	25	150	-	25	21.5	f ₁ +w-a ₁	6	03	2.9-3.9
R/L360.3232.03	32	32	170	-	32	28.5	f ₁ +w-a ₁	6	03	2.9-3.9

注明R或L型
State R or L version

w,a₁见刀片
w, a₁ see indexable inserts

尺寸单位：mm
Dimensions in mm

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

配件
Spare Parts

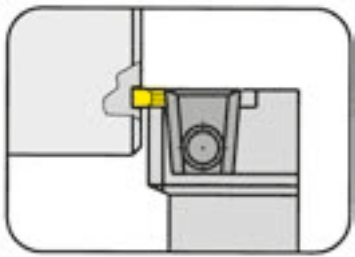
刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L360.1...	SW3,0 DIN911	11.3
R/L360...	SW3,0 DIN911	16.4

端面切槽
Face Grooving

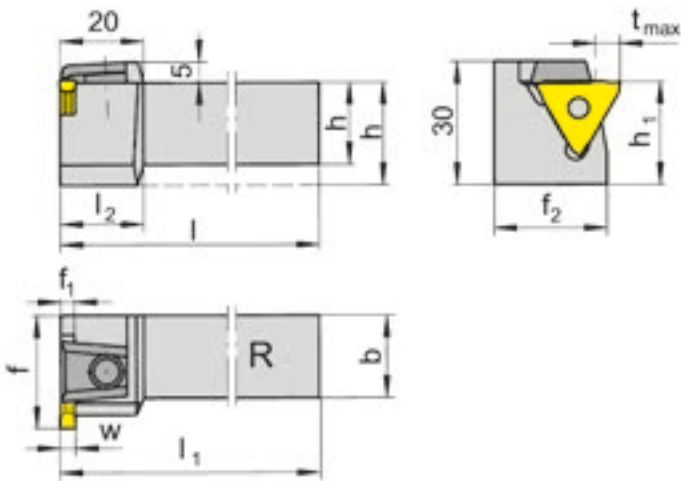


刀杆
Toolholder

369



端面槽起始外径	from outer groove $\varnothing$	20 mm
槽深可达	Depth of groove up to	6 mm
夹持范围	Clamping range	1,9-3,9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l	l_1	l_2	h_1	f	t_{max}	f_1	f_2	尺寸规格 Size	夹持范围 Clamping range
R/L369.2020.02	20	20	125	$l-f_1+w-a_1$	20	25	27	6	2.5	23.5	02	1.9-2.9
R/L369.2525.02	25	25	150	$l-f_1+w-a_1$	-	25	32	6	2.5	28.5	02	1.9-2.9
R/L369.2020.03	20	20	125	$l-f_1+w-a_1$	20	25	27	6	3.5	23.5	03	2.9-3.9
R/L369.2525.03	25	25	150	$l-f_1+w-a_1$	-	25	32	6	3.5	28.5	03	2.9-3.9

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

w, a₁ 见刀片
w, a₁ see indexable inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L369...	SW3,0 DIN911	16.4

端面切槽

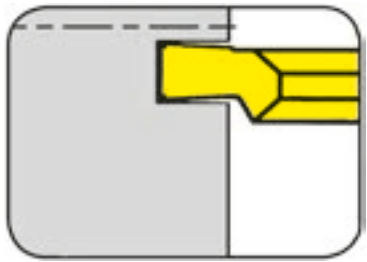
Face Grooving



可转位刀片

Indexable insert

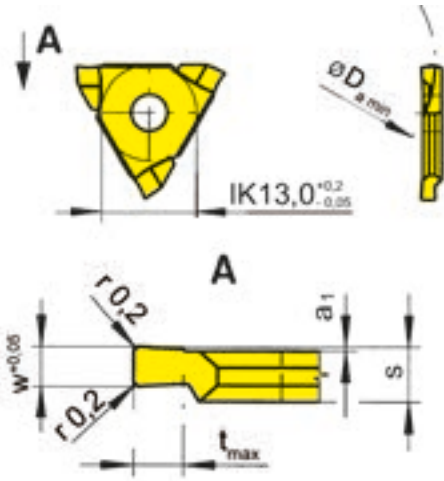
312



端面槽起始外径	from outer groove Ø	20 mm
槽深可达	Depth of groove up to	3 mm
槽宽	Width of groove	1.5-3 mm

配合刀杆
for Toolholder

型号 360
Type 369



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	w	t _{max}	a ₁	s	D _{a min}	尺寸规格 Size	MG12	EG55	TN35
R/L312.2015.02	1.5	2	0.2	2.7	20	02		▲/▲	▲/▲
R/L312.3020.02	2.0	3	0.2	2.7	30	02	x/Δ	▲/▲	▲/▲
R/L312.3030.02	3.0	3	0.2	3.7	30	03		▲/▲	▲/▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request							P	o	•
● 推荐 / recommended							M	-	o
o 次推荐 / alternative recommendation							K	-	o
- 不合适 / not suitable							N	-	-
非涂层 / uncoated grades							S	-	-
涂层 / coated grades							H	-	-
钎焊/金属陶瓷 / brazed/Cermet									

尺寸单位 : mm
Dimensions in mm

注明R或L型

State R or L version

360系列刀杆注意事项

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Note for toolholder type 360

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

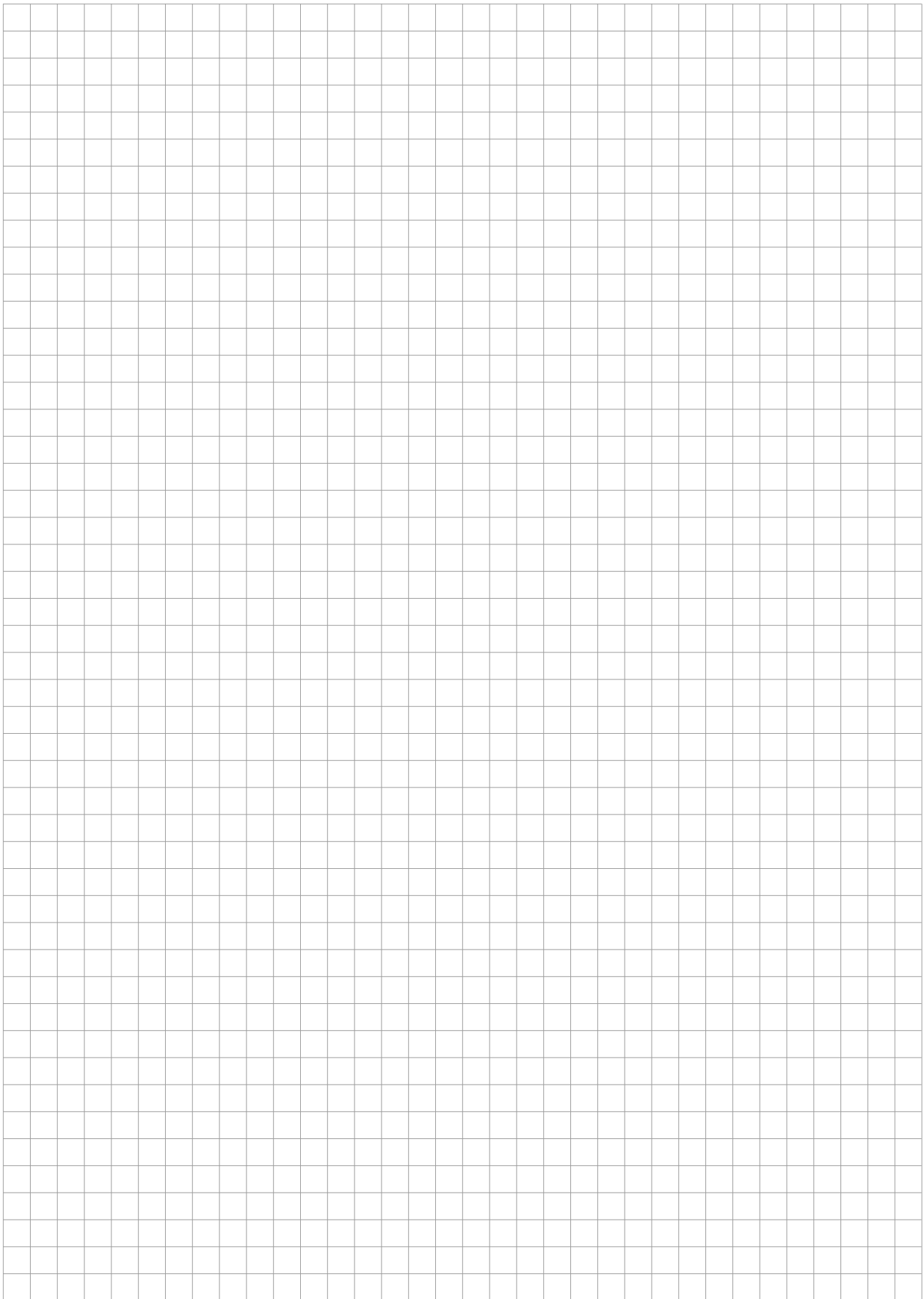
369系列刀杆注意事项

右手型刀杆配合右手型刀片，左手型刀杆配合左手型刀片

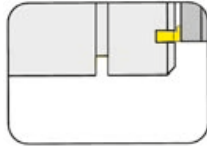
Note for toolholder type 369

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

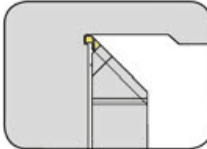
硬质合金牌号
Carbide grades



刀杆
Toolholder
356/357



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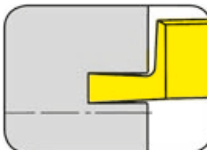


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可转位刀片
Indexable insert
A315



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A315



S

机夹式刀杆

槽宽 1,5 - 3 mm

Toolholder with Inserts

Width of groove 1,5 - 3 mm

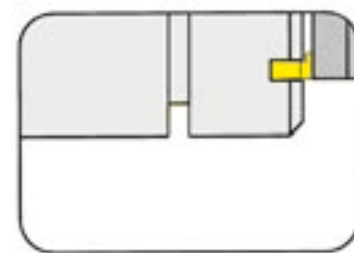
切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆
Toolholder

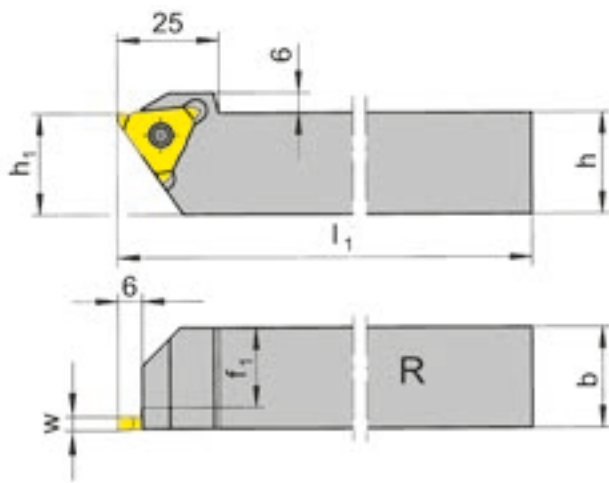
356



槽深可达
槽宽

Depth of groove up to
Width of groove

5 mm
0,5 - 7,3 mm



配合可转位刀片
for Indexable insert

型号 LA315
Type RA315

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	尺寸规格 Size
R/L356.1616.03	16	16	125	20	13.0	03
R/L356.1616.05	16	16	125	20	10.8	05
R/L356.2020.03	20	20	125	20	17.0	03
R/L356.2020.05	20	20	125	20	14.8	05
R/L356.2020.07	20	20	125	20	13.0	07
R/L356.2525.03	25	25	150	25	22.0	03
R/L356.2525.05	25	25	150	25	19.8	05
R/L356.2525.07	25	25	150	25	18.0	07
R/L356.3232.03	32	32	170	32	29.0	03
R/L356.3232.05	32	32	170	32	26.8	05
R/L356.3232.07	32	32	170	32	25.0	07

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5.12T20P	T20PQ

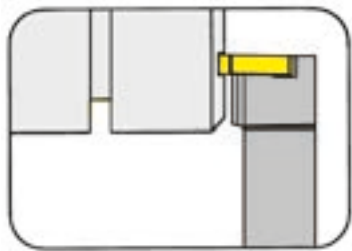
切槽和螺纹切削 (外圆)

Grooving and Threading (external)



刀杆
Toolholder

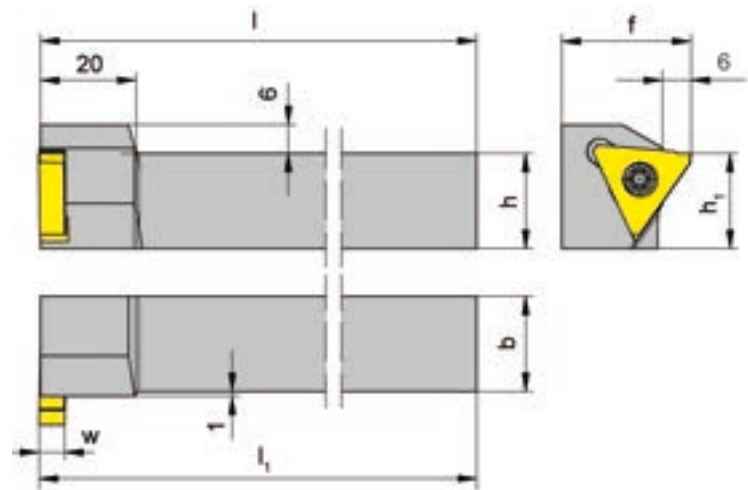
357



槽深可达
槽宽

Depth of groove up to
Width of groove

5 mm
0,5 - 5,3 mm



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合可转位刀片
for Indexable insert

型号 LA315
Type RA315

产品型号 Part number	h	b	l ₁	l	h ₁	f	尺寸规格 Size
R/L357.2020.05	20	20	125.3	125	20	27	05
R/L357.2525.05	25	25	150.3	150	25	32	05

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

订货须知 :
右手型刀片配合左手型刀杆 , 左手型刀片配合右手型刀杆
Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格 , 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L357...	5.12T20P	T20PQ

S

切退刀槽 (外圆)

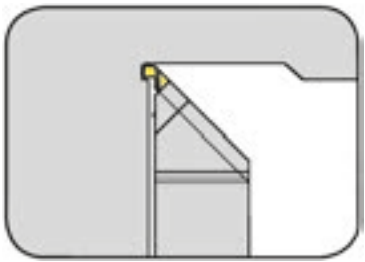
Grooving Corner Reliefs (external)



刀杆 356

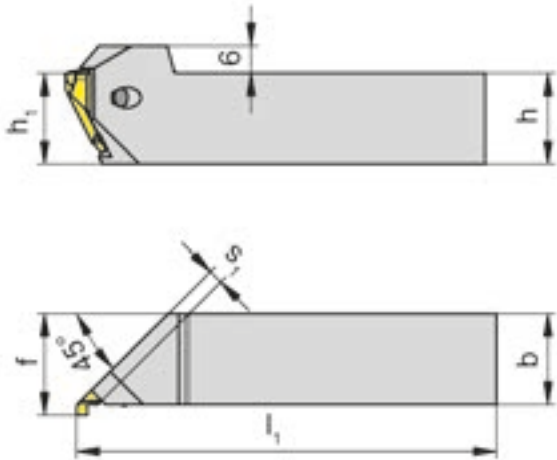
Toolholder

退刀槽(45°)
Corner reliefs (45°)



配合可转位刀片
for Indexable insert

型号 LA315...45...R
Type RA315...45...L



R=右手型-如图 L=左手型
R = right hand version shown L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	s ₁	尺寸规格 Size
R/L356.2020.45.03	20	20	125	20	22.3	3.25	03
R/L356.2525.45.03	25	25	150	25	27.3	3.25	03

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

订货须知：
右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆
Ordering note:
Use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

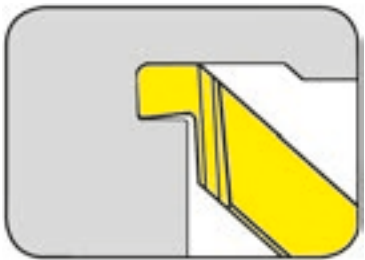
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L356...	5F.08T20P	T20PQ

端面切槽
Face Grooving



可转位刀片
Indexable insert

A315



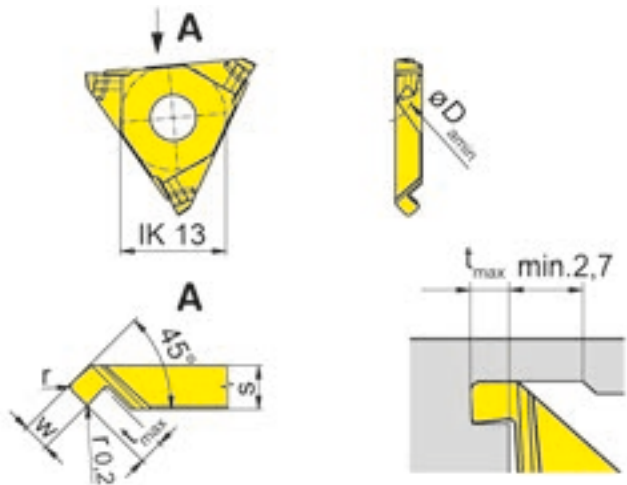
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

8 mm
2 mm
1.5-2.4 mm

配合刀杆
for Toolholder

型号 R/L356...45.03
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

产品型号 Part number	W	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35	TN35
LA315.0815.45.04R	1.5	0.4	1.6	8	3.25	03	▲	▲
RA315.0815.45.04L	1.5	0.4	1.6	8	3.25	03	▲	▲
LA315.1220.45.05R	2.0	0.5	1.8	12	3.25	03	▲	▲
RA315.1220.45.05L	2.0	0.5	1.8	12	3.25	03	▲	▲
LA315.2024.45.06R	2.4	0.6	2.0	20	3.25	03	▲	▲
RA315.2024.45.06L	2.4	0.6	2.0	20	3.25	03	Δ	▲

▲ 库存 / on stock Δ / x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

356...45..系列刀杆注意事项

右手型刀片配合左手型刀杆，左手型刀片配合右手型刀杆

Note for toolholder type 356...45..

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

在轴向加工前必须先完成退刀槽。

The undercut must be placed BEFORE the axial machining!

P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

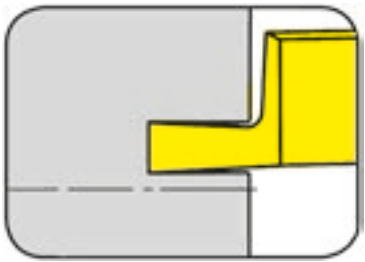
S

端面切槽
Face Grooving



可转位刀片
Indexable insert

A315



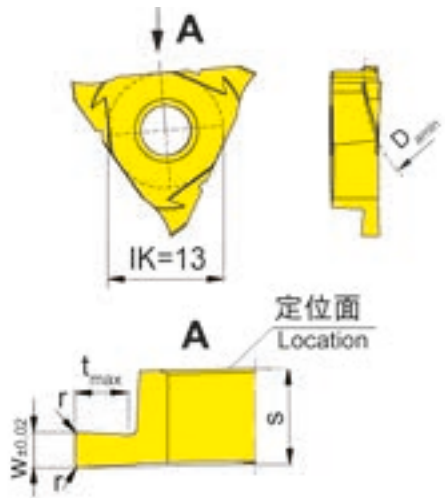
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

20 mm
3 mm
1.5-3 mm

配合刀杆
for Toolholder

型号 356...03-07
Type 357



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35
LA315.2015.02R	1.5	0.2	2	20	5.4	05	▲
RA315.2015.02L	1.5	0.2	2	20	5.4	05	▲
LA315.3020.02R	2.0	0.2	3	30	5.4	05	▲
RA315.3020.02L	2.0	0.2	3	30	5.4	05	▲
LA315.3030.02R	3.0	0.2	3	30	5.4	05	▲
RA315.3030.02L	3.0	0.2	3	30	5.4	05	▲
							P •
							M •
							K •
							N •
							S •
							H -

▲ 库存 / on stock Δ / x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

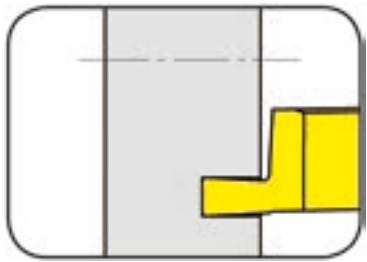
硬质合金牌号
Carbide grades

端面切槽
Face Grooving



可转位刀片
Indexable insert

A315



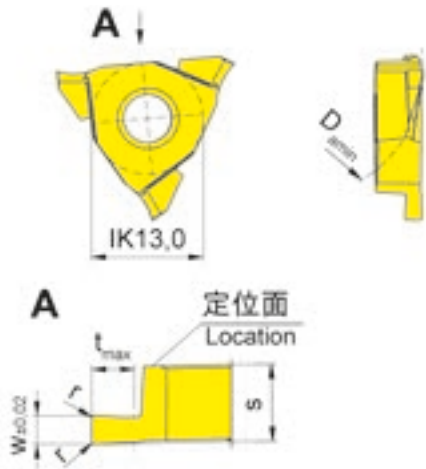
端面槽起始外径
槽深可达
槽宽

from outer groove Ø
Depth of groove up to
Width of groove

20 mm
3 mm
1.5-3 mm

配合刀杆
for Toolholder

型号 356
Type 357



R=右手型-如图
R = right hand version shown

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0,02 mm

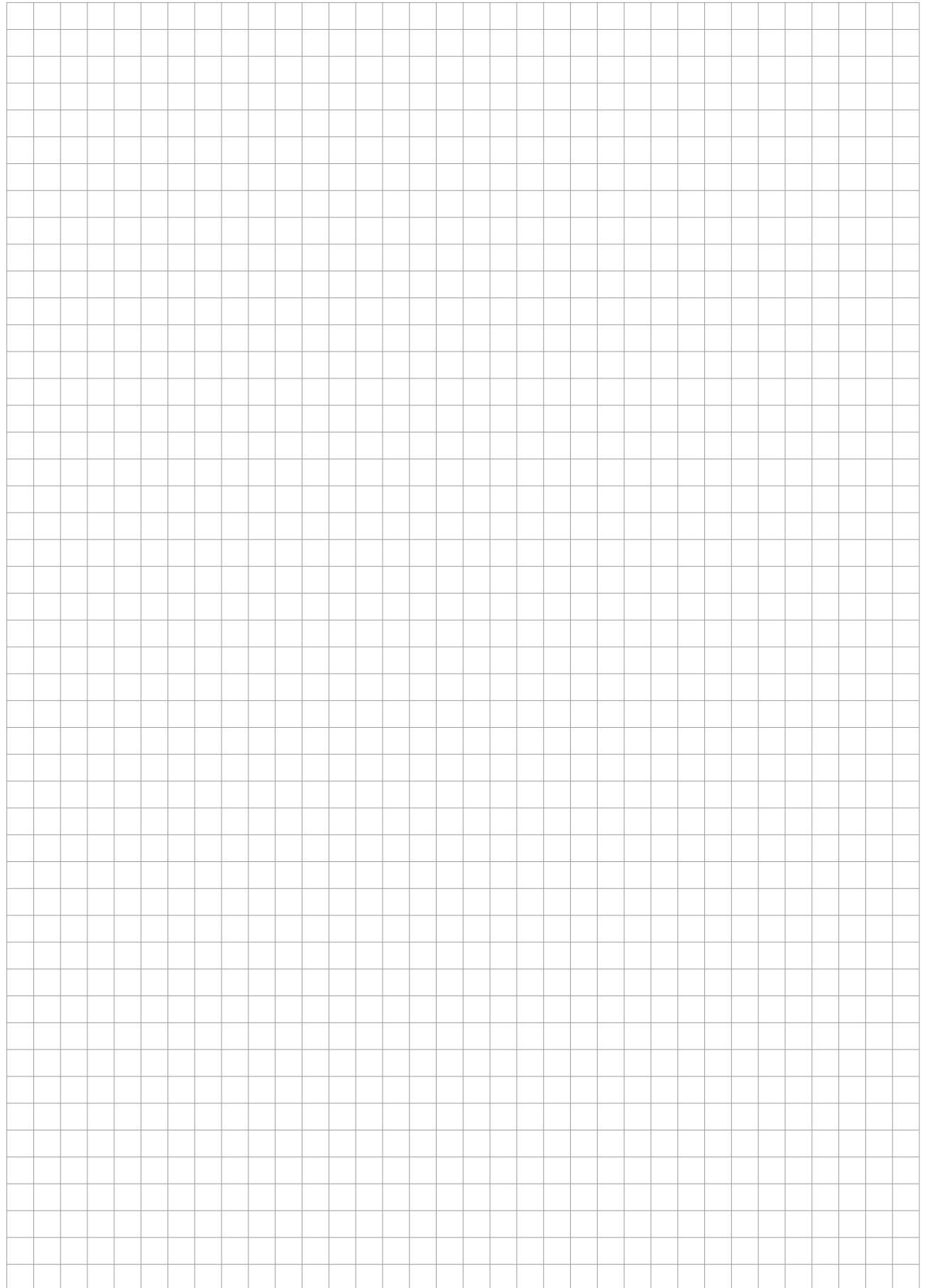
产品型号 Part number	w	r	t _{max}	D _{a min}	s	尺寸规格 Size	TH35	TN35
R/LA315.2015.02R	1.5	0.2	2	20	5.4	05	Δ/▲	
R/LA315.3020.02R	2.0	0.2	3	30	5.4	05	▲/▲	x/Δ
R/LA315.3030.02R	3.0	0.2	3	30	5.4	05	Δ/▲	
▲ 库存 / on stock Δ / x 根据要求 / upon request							P	•
● 推荐 / recommended							M	•
o 次推荐 / alternative recommendation							K	•
- 不合适 / not suitable							N	•
■ 非涂层 / uncoated grades							S	•
■ 涂层 / coated grades							H	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

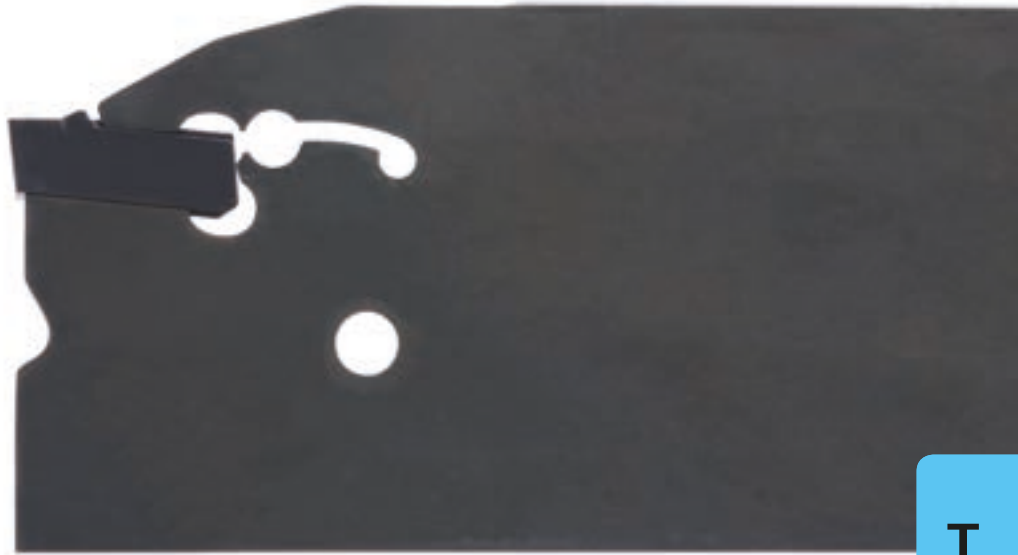
尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades



S





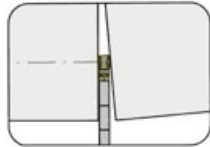
T

系列/System	页/Page
100	T2
123/223	T52
224	T62
264	T80
274	T88
229	T104
312	T116
316	T130

刀杆
Toolholder
H100



页/Page
T4, T7, T18



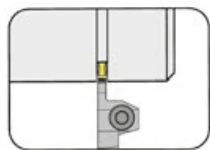
页/Page
T5



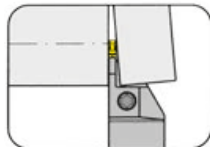
页/Page
T6



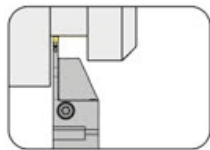
页/Page
T8-T15



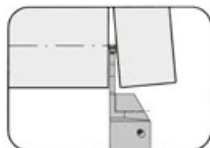
页/Page
T16-T17



页/Page
T19-T34

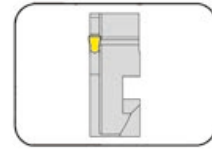


页/Page
T35

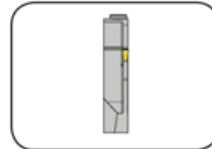


页/Page
T46-T47

刀夹
Cassette
NK100



页/Page
T36, T38



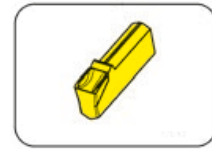
页/Page
T48



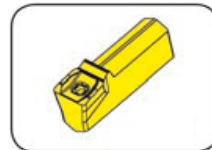
页/Page
T37

常规刀柄
Basic toolholder
220

刀片
Insert
S100



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T39-T45



页/Page
T49-T50

100



T

机夹式刀杆

槽宽2 - 16 mm

槽深可达55 mm

Toolholder with Inserts

Width of groove 2 - 16 mm

Depth of groove up to 55 mm

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

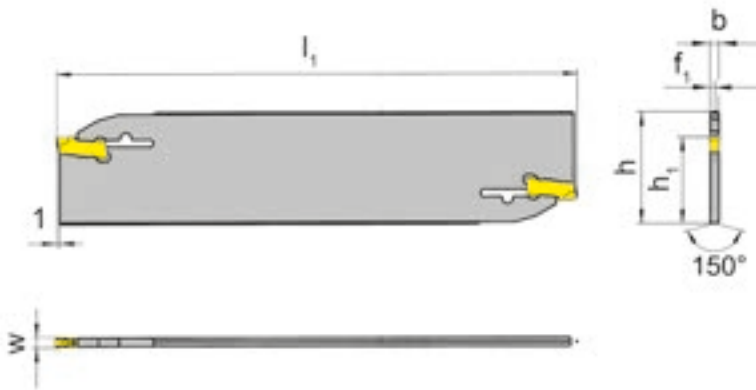
H100
自夹紧
with self clamping

槽深可达 槽宽	Depth of groove up to Width of groove	55 mm 2-5 mm



配合刀片
for Insert

型号 S100
Type



产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	尺寸规格 Size
H100.2601.01	26	1.5	110	21.4	0.75	25.0	01
H100.2602.02	26	1.9	110	21.4	0.95	37.5	02
H100.2603.03	26	2.3	110	21.4	1.15	37.5	03
H100.2604.04	26	3.1	110	21.8	1.65	40.0	04
H100.3201.01	32	1.5	150	24.8	0.75	25.0	01
H100.3202.02	32	1.9	150	24.8	0.95	50.0	02
H100.3203.03	32	2.3	150	24.8	1.15	50.0	03
H100.3204.04	32	3.1	160	24.8	1.65	55.0	04
H100.3205.05	32	3.9	160	24.8	2.00	55.0	05

按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：
 扳手P39L不包含在刀板中，需单独订购！
Note:
 Wrench P39L ist not combined with blade - separate order required!

切断

Parting Off



刀杆

Toolholder

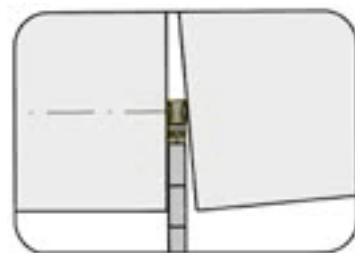
H100

直接冷却液供应
with through coolant supply

槽深可达
槽宽

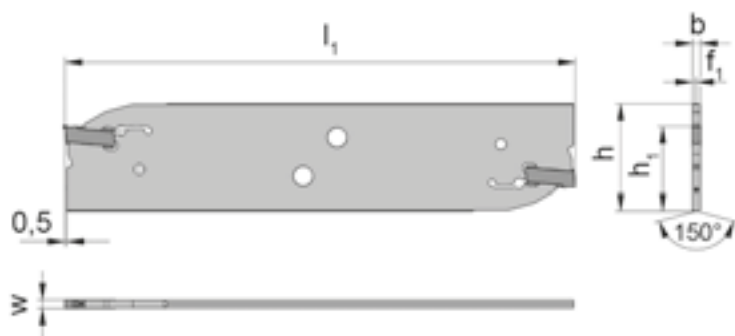
Depth of groove up to
Width of groove

34 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type S100...IK



产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	尺寸规格 Size
H100.2602.8.02.IK	26	1.9	110	21.4	0.95	35	02
H100.2603.8.03.IK	26	2.3	110	21.4	1.15	35	03
H100.2604.8.04.IK	26	3.1	110	21.4	1.55	35	04
H100.3202.8.02.IK	32	1.9	150	24.8	0.95	55	02
H100.3203.8.03.IK	32	2.3	150	24.8	1.15	60	03
H100.3204.8.04.IK	32	3.1	150	24.8	1.55	60	04

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

扳手P101.02不包含在刀板中，需单独订购！
Wrench P101.02 is not combined with tool holder - separate order required!

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	冷却塞 Coolant plug
H100...	SW3.0 DIN911	020.IK01.5732

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

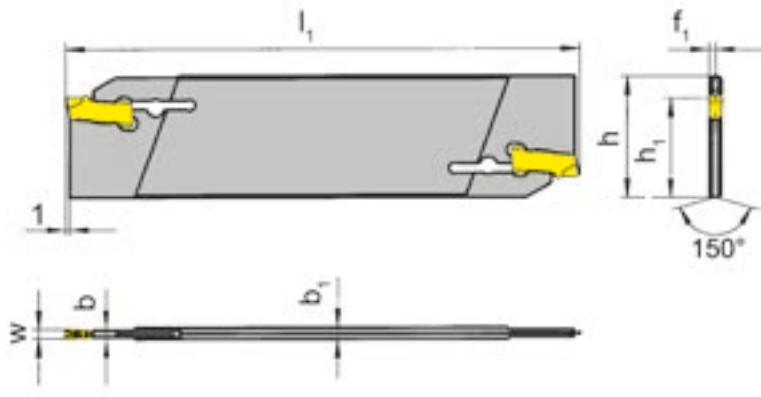
H100

槽深可达 槽宽	Depth of groove up to Width of groove	25 mm 2-2.5 mm



配合刀片
for Insert

型号 S100
Type



T

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	b ₁	尺寸规格 Size
H100.2603.01	26	1.5	110	21.4	1.15	21	2.3	01
H100.2603.02	26	1.9	110	21.4	1.15	21	2.3	02
H100.3203.01	32	1.5	150	24.8	1.15	25	2.3	01
H100.3203.02	32	1.9	150	24.8	1.15	25	2.3	02

按需提供更多尺寸
Further sizes upon request
扳手P39L不包含在刀板中，需单独订购！
Wrench P39L ist not combined with blade - separate order required!

尺寸单位：mm
Dimensions in mm

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

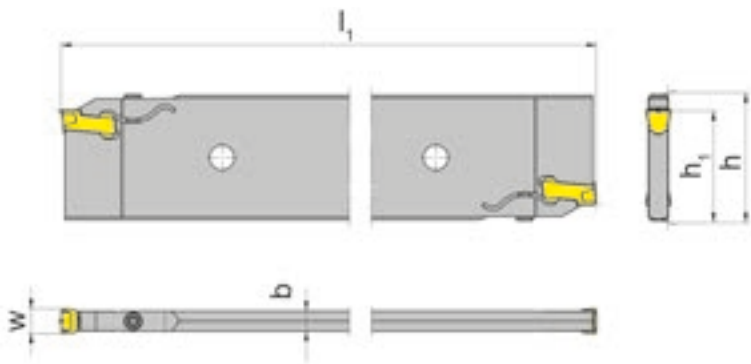
H100



槽宽	Width of groove	8-12 mm

配合刀片
for Insert

型号 S100
Type



产品型号 Part number	h	b	l ₁	h ₁	槽宽 Width of groove
H100.5208.26.08	52.6	7.4	260	45	8
H100.5210.26.10	52.6	8.2	260	45	10
H100.5212.26.12	52.6	10.4	260	45	12

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
H100...	5.13 T20P	T20PQ

T

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

自夹紧
with self clamping

槽深可达
槽宽

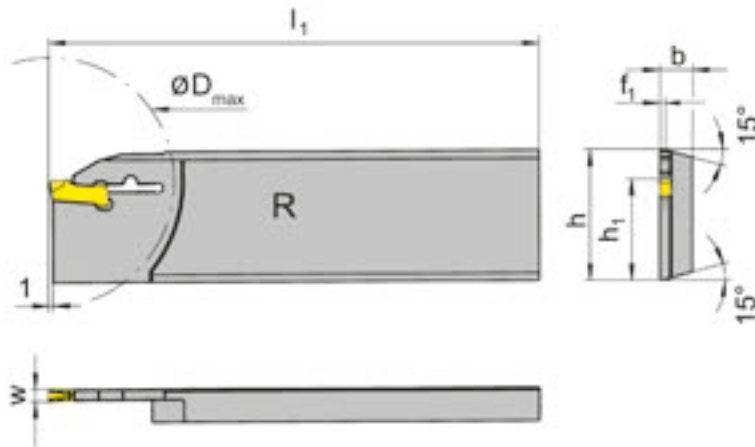
Depth of groove up to
Width of groove

34 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size
R/LH100.2608.31	26	7.9	110	21.4	0.75	21	42	01
R/LH100.2608.32	26	7.9	110	21.4	0.95	25	50	02
R/LH100.2608.33	26	7.9	110	21.4	1.15	25	50	03
R/LH100.2608.34	26	7.9	110	21.4	1.55	25	50	04
R/LH100.3208.31	32	7.9	112	24.8	0.75	25	50	01
R/LH100.3208.32	32	7.9	112	24.8	0.95	34	68	02
R/LH100.3208.33	32	7.9	112	24.8	1.15	34	68	03
R/LH100.3208.34	32	7.9	112	24.8	1.55	34	68	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

推荐用于Traub系列机床：

Recommended for Traub machines type:

R/L100.2608.31-34

R/LH100.3208.31-34

TNC 30
TNM 28
TNS 26
TNS 30/42
TNA 300
TNK 28/36
TNL 26

TNC 42/65
TNM 42/65
TNS 65
TNS 60
TNA 400
TNA 300

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

自夹紧
with self clamping

槽深可达
槽宽

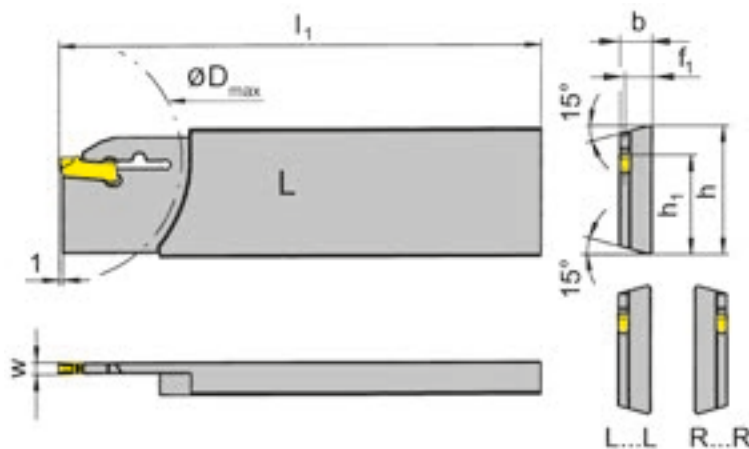
Depth of groove up to
Width of groove

34 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	h_1	f_1	t_{max}	D_{max}	尺寸规格 Size
LH100.2608.31L	26	7.9	110	21.4	7.15	21	42	01
RH100.2608.31R	26	7.9	110	21.4	7.15	21	42	01
LH100.3208.31L	32	7.9	112	24.8	7.15	25	50	01
RH100.3208.31R	32	7.9	112	24.8	7.15	25	50	01
LH100.2608.32L	26	7.9	110	21.4	6.95	25	50	02
RH100.2608.32R	26	7.9	110	21.4	6.95	25	50	02
LH100.3208.32L	32	7.9	112	24.8	6.95	34	68	02
RH100.3208.32R	32	7.9	112	24.8	6.95	34	68	02
LH100.2608.33L	26	7.9	110	21.4	6.75	25	50	03
RH100.2608.33R	26	7.9	110	21.4	6.75	25	50	03
LH100.3208.33L	32	7.9	112	24.8	6.75	34	68	03
RH100.3208.33R	32	7.9	112	24.8	6.75	34	68	03
LH100.2608.34L	26	7.9	110	21.4	6.35	25	50	04
RH100.2608.34R	26	7.9	110	21.4	6.35	25	50	04
LH100.3208.34L	32	7.9	112	24.8	6.35	34	68	04
RH100.3208.34R	32	7.9	112	24.8	6.35	34	68	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

注意事项：

扳手P39L不包含在刀板中，需单独订购！

Note:

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

T

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

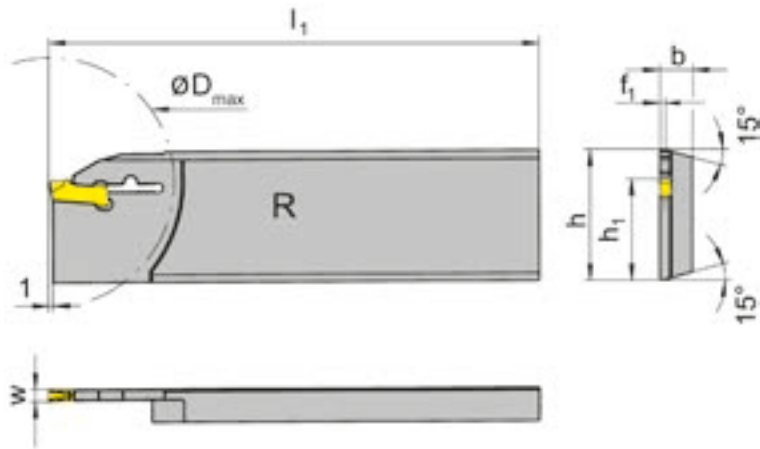
H100
自夹紧
with self clamping

槽深可达	Depth of groove up to	41 mm
槽宽	Width of groove	4 mm



配合刀片
for Insert

型号 S100
Type



R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size
RH100.3208.2.44	32	7.9	160	24.8	1.55	41	80	04
RH100.3208.44	32	7.9	130	24.8	1.55	41	80	04

按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手P39L不包含在刀板中，需单独订购！

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

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

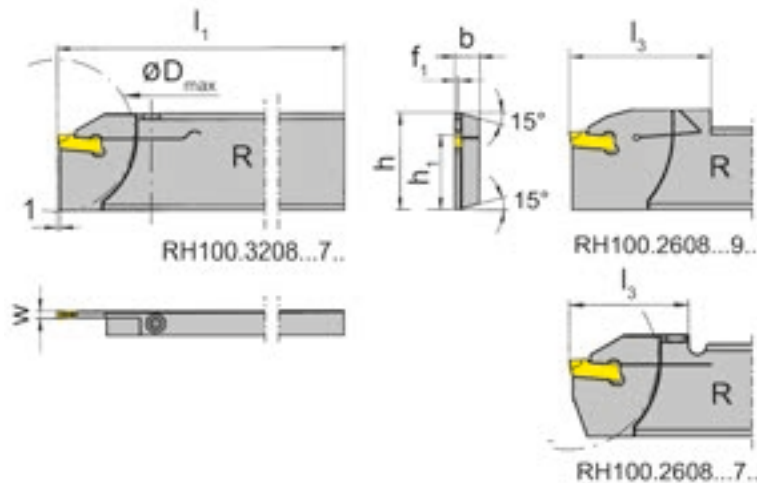
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
2-3 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	f_1	l_3	t_{max}	D_{max}	尺寸规格 Size
R/LH100.2608.71	26	7.9	110	21.4	0.75	33.8	25.0	50	01
R/LH100.3208.71	32	7.9	112	24.8	0.75	33.8	25.0	50	01
R/LH100.2608.72	26	7.9	110	21.4	0.95	33.8	25.0	50	02
R/LH100.3208.72	32	7.9	112	24.8	0.95	33.8	25.0	50	02
R/LH100.2608.93	26	8.0	112	21.4	1.15	40.0	25.0	50	03
R/LH100.3208.93	32	8.0	112	24.8	1.15	40.0	32.5	65	03

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	紧固螺钉 Pin
R/LH100...	4.15T15P	T15PQ	
R/LH100...93	030.0413.T15P	T15PQ	020.0040.0999

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

螺钉夹紧
with screwed clamping



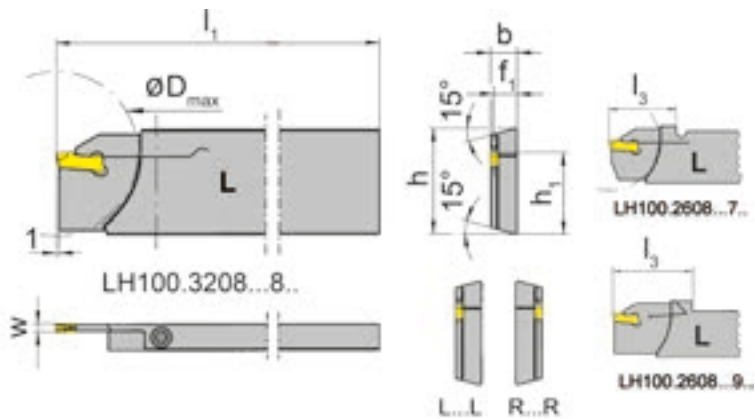
槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
2-3 mm

配合刀片
for Insert

型号 S100
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	h_1	f_1	l_3	t_{max}	D_{max}	尺寸规格 Size
LH100.2608.71L	26	7.9	110	21.4	7.15	33.8	25.0	50	01
LH100.3208.71L	32	7.9	112	24.8	7.15	33.8	25.0	50	01
RH100.2608.71R	26	7.9	110	21.4	7.15	33.8	25.0	50	01
RH100.3208.71R	32	7.9	112	24.8	7.15	33.8	25.0	50	01
LH100.2608.72L	26	7.9	110	21.4	6.95	33.8	25.0	50	02
LH100.3208.72L	32	7.9	112	24.8	6.95	33.8	25.0	50	02
RH100.2608.72R	26	7.9	110	21.4	6.95	33.8	25.0	50	02
RH100.3208.72R	32	7.9	112	24.8	6.95	33.8	25.0	50	02
LH100.2608.93L	26	8.0	115	21.4	6.85	40.0	25.0	50	03
LH100.3208.93L	32	8.0	115	24.8	6.85	42.0	32.5	65	03
RH100.2608.93R	26	8.0	115	21.4	6.85	40.0	25.0	50	03
RH100.3208.93R	32	8.0	115	24.8	6.85	42.0	32.5	65	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	紧固螺钉 Pin
R/LH100...	4.15T15P	T15PQ	
R/LH100...93R/L	030.0413.T15P	T15PQ	020.0040.0999

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

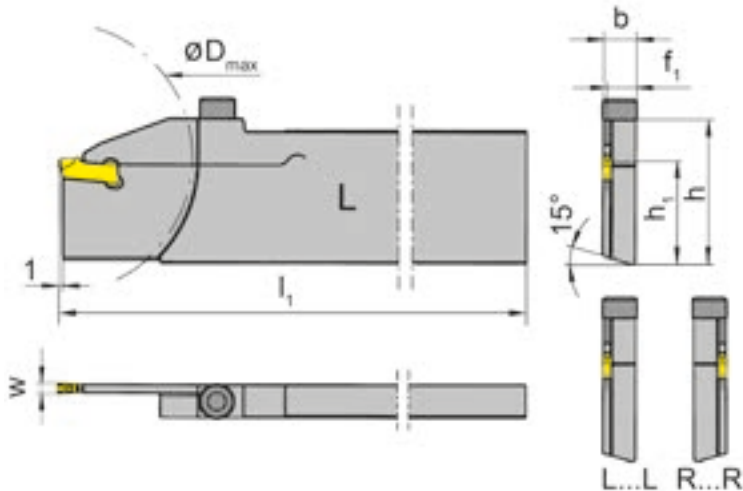
槽深可达	Depth of groove up to	32.5 mm
槽宽	Width of groove	3-4 mm

用于TRAUB (TNX65) 机床
for machines TRAUB (TNX65)



配合刀片
for Insert

型号 S100
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	尺寸规格 Size
LH100.3280.73L	32	7.9	130	24.8	6.75	32.5	65	03
RH100.3280.73R	32	7.9	130	24.8	6.75	32.5	65	03
LH100.3280.74L	32	7.9	130	24.8	6.35	32.5	65	04
RH100.3280.74R	32	7.9	130	24.8	6.35	32.5	65	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench
LH100...	SW4,0 DIN911

T

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

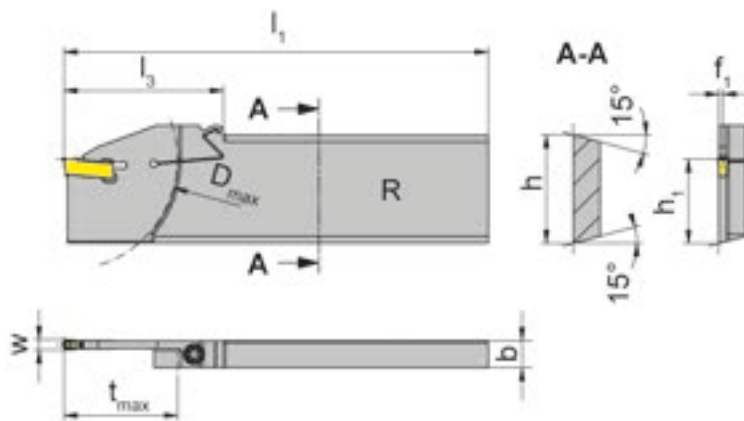
Depth of groove up to
Width of groove

33.5 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于TRAUB和INDEX机
床
for machines TRAUB and
INDEX

产品型号 Part number	h	b	l_1	h_1	f_1	l_3	t_{max}	D_{max}	机床型号 Machine type	尺寸规格 Size
R/LH100.3208.83	32	8	125	24.8	1.15	47	33.5	65	TraubTNX65/42. IndexC65	03
LH100.3208.15.83	32	8	150	24.8	1.15	47	33.5	65	TraubTNX65/42. IndexC65	03
R/LH100.3208.84	32	8	125	24.8	1.50	47	33.5	65	TraubTNX65/42. IndexC65	04
LH100.3208.15.84	32	8	150	24.8	1.15	47	33.5	65	TraubTNX65/42. IndexC65	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	030.505P.0718	T15PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

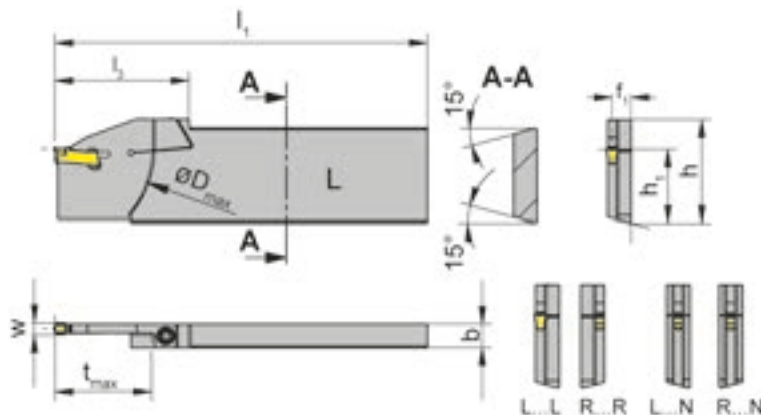
Depth of groove up to
Width of groove

41 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

适用于TRAUB和INDEX机
床
for machines TRAUB and
INDEX

T

产品型号 Part number	h	b	l_1	h_1	f_1	l_3	t_{max}	D_{max}	机床型号 Machine type	尺寸规格 Size
LH100.3208.83L	32	8	125	24.8	6.75	47.0	33.5	65	TraubTNX65/42. IndexC65	03
RH100.3208.83R	32	8	125	24.8	6.75	47.0	33.5	65	TraubTNX65/42. IndexC65	03
R/LH100.3208.83N	32	8	125	24.8	4.00	47.0	33.5	65	TraubTNX65/42. IndexC65	03
LH100.3208.84L	32	8	125	24.8	6.35	47.0	33.5	65	TraubTNX65/42. IndexC65	04
RH100.3208.84R	32	8	125	24.8	6.35	47.0	33.5	65	TraubTNX65/42. IndexC65	04
R/LH100.3208.84N	32	8	134	24.8	4.00	54.5	41.0	80	TraubTNX80/65	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	030.505P.0718	T15PQ

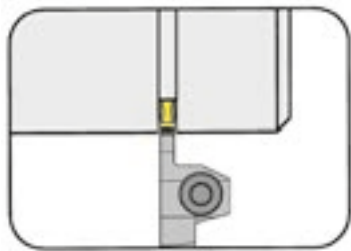
切槽和切断

Grooving and Parting Off



刀杆
Toolholder

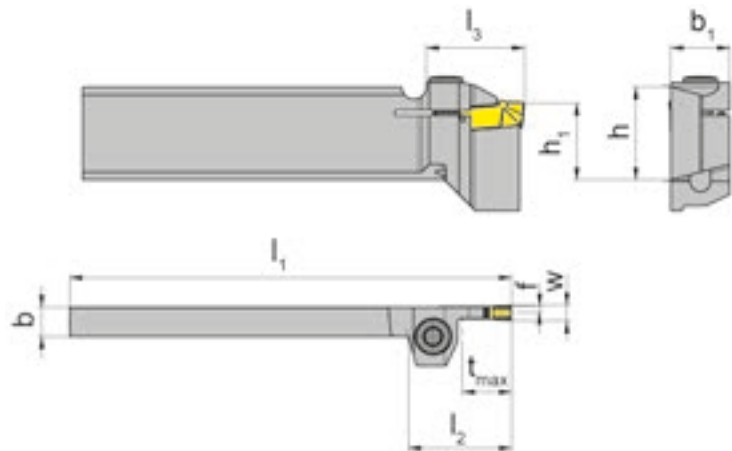
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

10 mm
3 mm



配合刀片
for Insert

型号 S100
Type

配 REIKA机床
for machines REIKA

L=左手型-如图
L = left hand version shown

产品型号 Part number	h	b	l ₁	h ₁	l ₂	f	l ₃	t _{max}	b ₁	尺寸规格 Size
LH100.1908.R.13	19	8	90	15.7	16	1.15	20	10	12	03
LH100.3208.R.13	32	8	110	24.8	16	1.15	20	10	12	03

按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	5.17T20P	T20PQ

切槽和切断

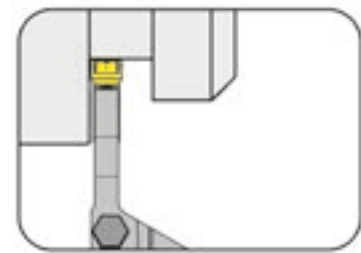
Grooving and Parting Off



刀杆

Toolholder

H100



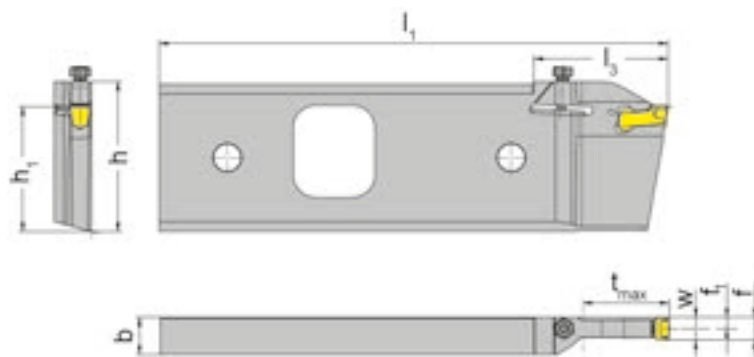
槽深可达
槽宽

Depth of groove up to
Width of groove

65 mm
8-12 mm

配合刀片
for Insert

型号 S100
Type



L=左手型-如图
L = left hand version shown

配 REIKA机床
for machines REIKA

产品型号 Part number	h	b	l_1	h_1	f_1	l_3	f	t_{max}	尺寸规格 Size
LH100.5517.38.8.08	65	16.4	224	55	4	59	$f_1 + w/2$	38	08
LH100.5517.54.8.08	65	16.4	224	55	4	75	$f_1 + w/2$	54	08
LH100.5517.38.8.10	65	16.4	224	55	5	59	$f_1 + w/2$	38	10
LH100.5517.54.8.10	65	16.4	224	55	5	75	$f_1 + w/2$	54	10
LH100.5517.44.8.12	65	16.4	224	55	6	65	$f_1 + w/2$	44	12
LH100.5517.65.8.12	65	16.4	224	55	6	86	$f_1 + w/2$	65	12

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LH100...	030.6075.T20P	T20PQ

切槽和切断

Grooving and Parting Off

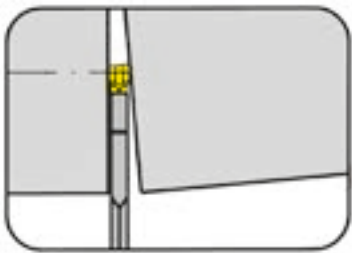


刀杆

Toolholder

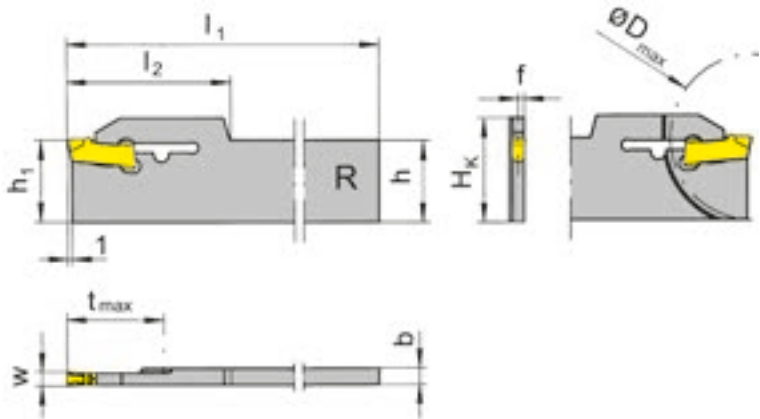
H100
自夹紧
with self clamping

槽深可达	Depth of groove up to	38 mm
槽宽	Width of groove	2-3 mm



配合刀片
for Insert

型号 S100
Type



R=右手型
R = right hand version

产品型号 Part number	H _k	b	l ₁	h ₁	f	l ₂	t _{max}	D _{max}	h	尺寸规格 Size
RH100.1703.21	22.1	3.2	110	17.4	0.75	32.0	17.5	35	17.4	01
RH100.2203.21	26.9	3.2	150	22.2	0.75	32.0	38.0	50	22.1	01
RH100.1703.33	22.1	3.2	110	17.4	1.15	34.5	30.0	60	17.4	03
RH100.2203.33	26.9	3.2	150	22.2	1.15	34.5	38.0	76	22.1	03

按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手**P39L**不包含在刀板中R/LH100...33，需单独订购！

Note:
Wrench **P39L** ist not combined with blade R/LH100...33 - separate order required!

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

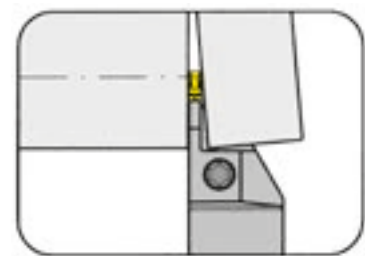
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

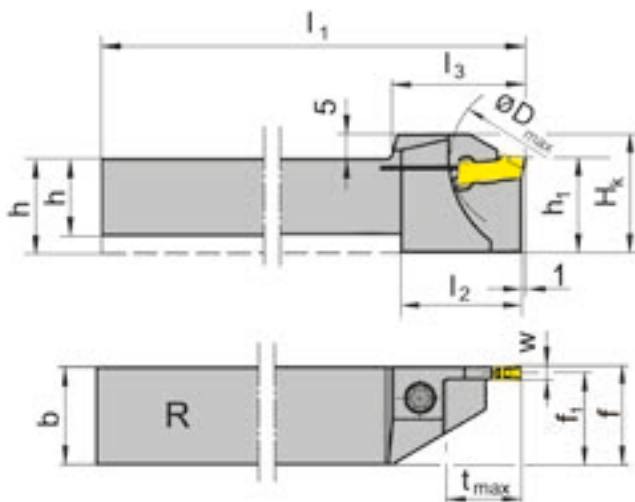
Depth of groove up to
Width of groove

21 mm
2 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	尺寸规格 Size
R/LH100.1010.01	10	10	125	19	21.0	13	9.25	$f_1+w/2$	10.5	21	18	01
R/LH100.1010.11	10	10	125	21	23.0	16	9.25	$f_1+w/2$	13.0	42	21	01
R/LH100.1212.01	12	12	125	21	23.0	16	11.25	$f_1+w/2$	13.0	26	21	01
R/LH100.1212.11	12	12	125	21	26.0	16	11.25	$f_1+w/2$	16.0	42	21	01
R/LH100.1616.11	16	16	125	24	26.0	20	15.25	$f_1+w/2$	16.0	42	25	01
R/LH100.1616.21	16	16	125	30	33.5	20	15.25	$f_1+w/2$	21.0	42	25	01
R/LH100.2020.11	20	20	125	-	33.5	20	19.25	$f_1+w/2$	16.0	42	25	01
R/LH100.2020.21	20	20	125	-	33.5	20	19.25	$f_1+w/2$	21.0	42	25	01
R/LH100.2525.21	25	25	150	-	33.5	25	24.30	$f_1+w/2$	21.0	42	30	01

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	4.15T15P	T15PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

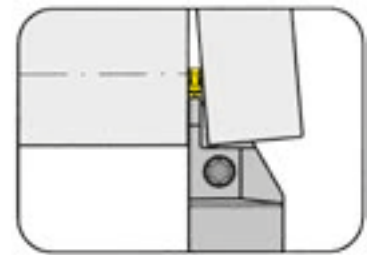
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

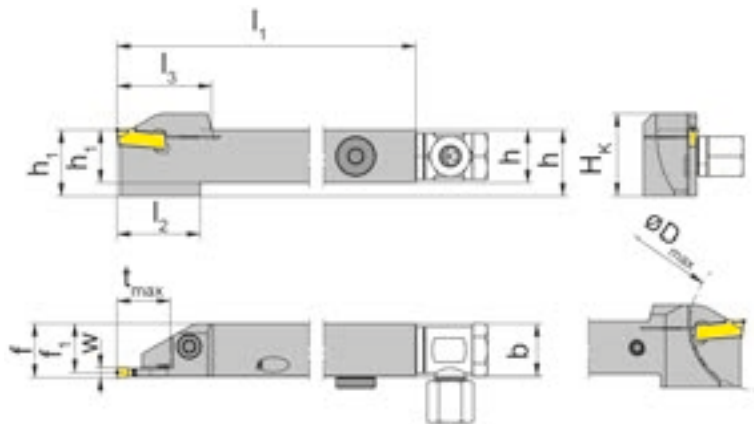
Depth of groove up to
Width of groove

21 mm
2 mm



配合刀片
for Insert

型号 S100
Type



直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	尺寸规格 Size
R/LH100.1212.01.IK	12	12	125	21	23.0	12	11.25	$f_1 + w/2$	13	26	21	01
R/LH100.1212.11.IK	12	12	125	21	26.0	12	11.25	$f_1 + w/2$	16	42	21	01
R/LH100.1616.11.IK	16	16	125	24	26.0	16	15.25	$f_1 + w/2$	16	42	25	01
R/LH100.1616.21.IK	16	16	125	30	33.5	16	15.25	$f_1 + w/2$	21	42	25	01
R/LH100.2020.11.IK	20	20	125	-	33.5	20	19.25	$f_1 + w/2$	16	42	25	01
R/LH100.2020.21.IK	20	20	125	-	33.5	20	19.25	$f_1 + w/2$	21	42	25	01
R/LH100.2525.21.IK	25	25	150	-	33.5	25	24.30	$f_1 + w/2$	21	42	30	01

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH100.1212...	4.15T15P	004.00.61	T15PQ	
R/LH100...	4.15T15P	SBD 6 LR - G1/8"	T15PQ	004.00.26

切槽和切断

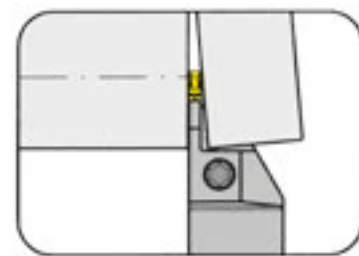
Grooving and Parting Off



刀杆

Toolholder

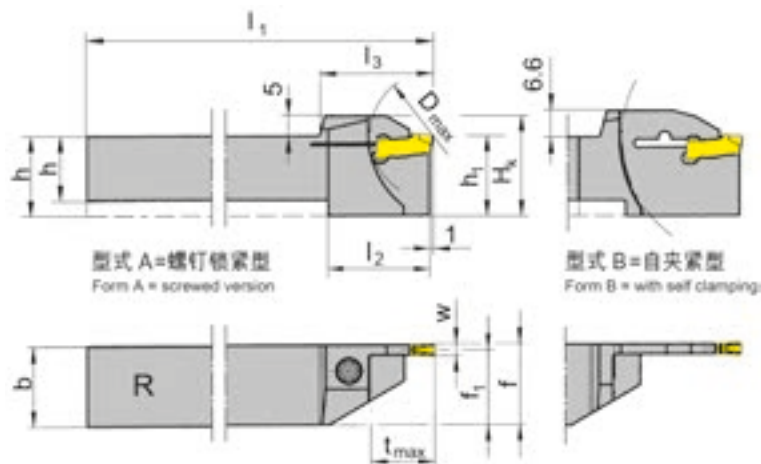
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
2.5 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	形式 Form	尺寸规 Size
R/LH100.1212.02	12	12	125	21	23.0	16	11.05	$f_1 + w/2$	13.0	25	21.0	A	02
R/LH100.1212.12	12	12	125	24	26.0	16	11.05	$f_1 + w/2$	16.0	42	25.0	A	02
R/LH100.1616.02	16	16	125	19	21.0	20	15.05	$f_1 + w/2$	10.5	42	25.0	A	02
R/LH100.1616.12	16	16	125	24	26.0	20	15.05	$f_1 + w/2$	16.0	42	25.0	A	02
R/LH100.1616.22	16	16	125	30	33.5	20	15.05	$f_1 + w/2$	21.0	42	25.0	A	02
R/LH100.2020.12	20	20	125	-	26.0	20	19.05	$f_1 + w/2$	16.0	42	25.0	A	02
R/LH100.2020.22	20	20	125	-	33.5	20	19.05	$f_1 + w/2$	21.0	42	25.0	A	02
R/LH100.2020.32	20	20	125	35	38.5	25	19.05	$f_1 + w/2$	32.5	65	31.6	B	02
R/LH100.2525.22	25	25	150	-	33.5	25	24.05	$f_1 + w/2$	21.0	42	30.0	A	02

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

订货须知：

扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	4.15T15P	T15PQ

切槽和切断

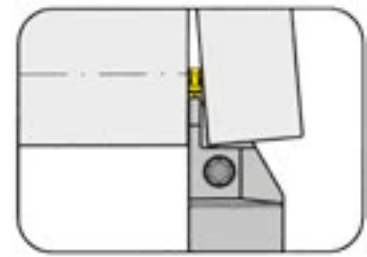
Grooving and Parting Off



刀杆

Toolholder

H100



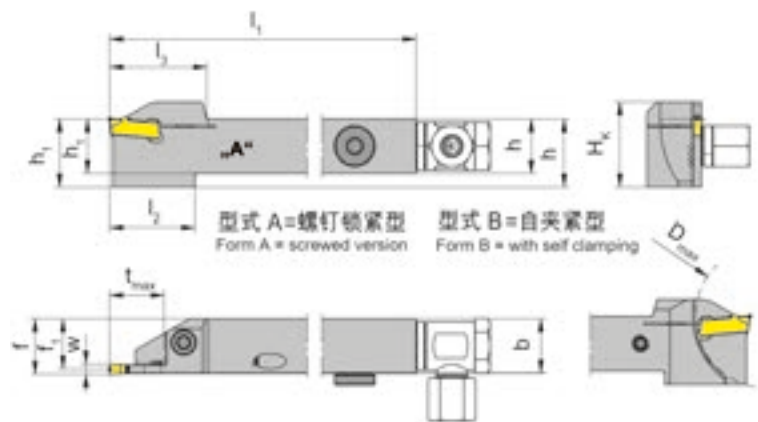
槽深可达
槽宽

Depth of groove up to
Width of groove

21 mm
2.5 mm

配合刀片
for Insert

型号 S100
Type



直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1212.02.IK	12	12	125	21	23.0	16	11.05	$f_1+w/2$	13.0	25	21	A	02
R/LH100.1616.02.IK	16	16	125	19	21.0	20	15.05	$f_1+w/2$	10.5	42	25	A	02
R/LH100.1212.12.IK	12	12	125	24	26.0	16	11.05	$f_1+w/2$	16.0	42	25	A	02
R/LH100.1616.12.IK	16	16	125	24	28.5	20	15.05	$f_1+w/2$	16.0	42	25	A	02
R/LH100.2020.12.IK	20	20	125	-	26.0	20	19.05	$f_1+w/2$	16.0	42	25	A	02
R/LH100.1616.22.IK	16	16	125	30	33.5	20	15.05	$f_1+w/2$	21.0	42	25	A	02
R/LH100.2020.22.IK	20	20	125	-	33.5	20	19.05	$f_1+w/2$	21.0	42	25	A	02
R/LH100.2525.22.IK	25	25	150	-	33.5	25	24.05	$f_1+w/2$	21.0	42	30	A	02

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug
R/LH100.1212...	4.15T15P	004.00.61	T15PQ	-
R/LH100.1616.02.IK	4.15T15P	004.00.61	T15PQ	004.00.26
R/LH100.1616.22.IK	4.15T15P	004.00.16	T15PQ	004.00.26
R/LH100.2020.22.IK	5.17T20P	004.00.16	T20PQ	004.00.26
R/LH100.2525.22.IK	4.15T15P	004.00.16	T15PQ	004.00.26

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

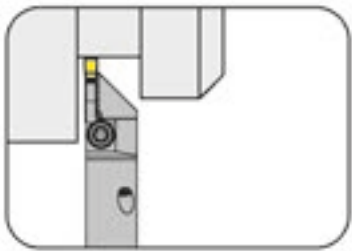
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

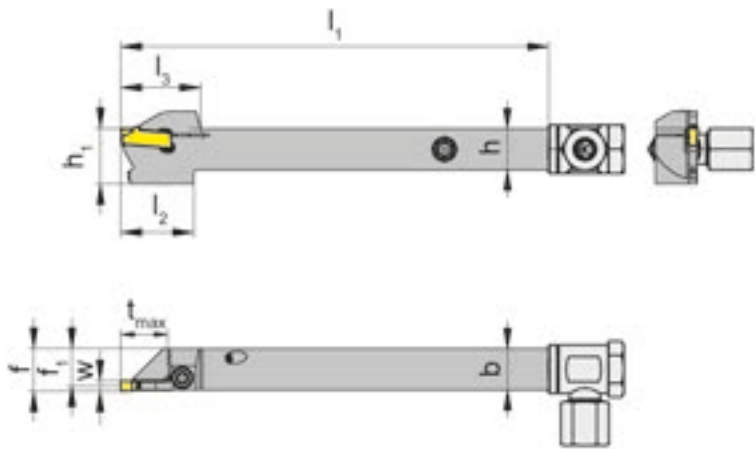
Depth of groove up to
Width of groove

13.5 mm
3 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

直接冷却液供应
with through coolant supply

T

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.1212.5.23.IK	12	12	125	21	23	16	10.85	$f_1 + w/2$	13.5	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100.1212.5.23.IK	4.15T15P	004.00.61	T15PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

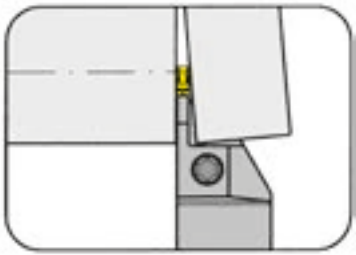
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

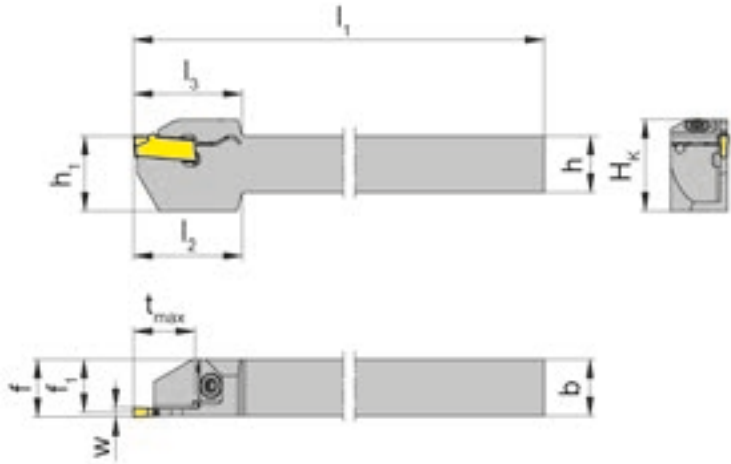
Depth of groove up to
Width of groove

17 mm
2-3 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于Swiss机床
for Swiss type machines

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	尺寸规格 Size
R/LH100.1212.24.61	12	12	125	23	23	12	11.25	$f_1+w/2$	13	26	19.5	02
R/LH100.1212.32.63	12	12	125	27	24	12	10.85	$f_1+w/2$	17	34	19.5	03
R/LH100.1616.24.61	16	16	125	23	-	16	15.25	$f_1+w/2$	13	26	19.5	02
R/LH100.1616.32.63	16	16	125	27	-	16	14.85	$f_1+w/2$	17	34	19.5	03

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	3.5.12T10EP	T10PL

切槽和切断

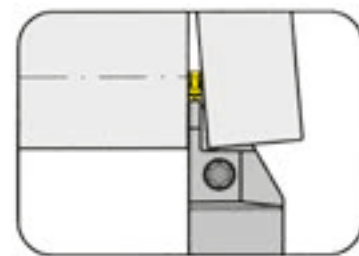
Grooving and Parting Off



刀杆

Toolholder

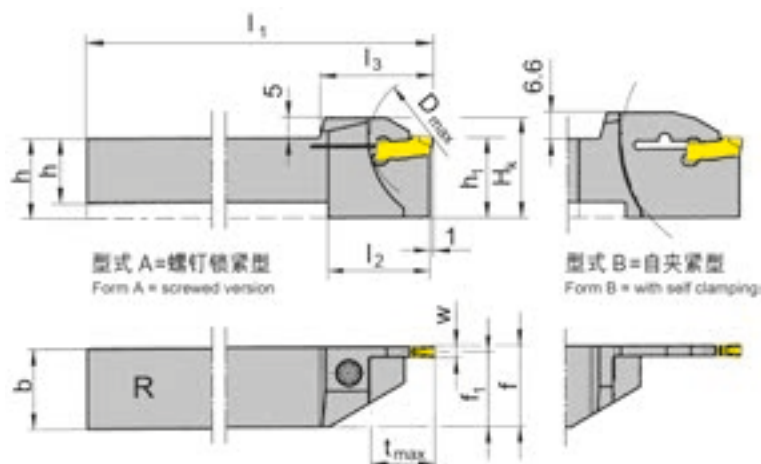
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
3 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1212.03	12	12	125	21.0	23.0	16	10.85	$f_1+w/2$	13.0	26	25.0	A	03
R/LH100.1616.03	16	16	125	19.5	23.0	20	14.85	$f_1+w/2$	10.5	42	25.0	A	03
R/LH100.1616.13	16	16	125	25.0	28.5	20	14.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.1616.23	16	16	125	30.0	33.5	20	14.85	$f_1+w/2$	21.0	42	25.0	A	03
R/LH100.2020.13	20	20	125	-	28.5	20	18.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.2020.23	20	20	125	-	33.5	20	18.85	$f_1+w/2$	21.0	42	25.0	A	03
R/LH100.2020.33	20	20	125	35.0	38.5	25	18.85	$f_1+w/2$	32.5	65	31.6	B	03
R/LH100.2525.13	25	25	150	-	28.5	25	23.85	$f_1+w/2$	16.0	42	30.0	A	03
R/LH100.2525.23	25	25	150	-	33.5	25	23.85	$f_1+w/2$	21.0	42	30.0	A	03
R/LH100.2525.33	25	25	150	-	38.5	25	23.85	$f_1+w/2$	32.5	65	31.6	B	03

注明R或L型

State R or L version

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 TORX PLUS® Wrench
R/LH100...	5.17T20P	T20PQ	-
R/LH100...33	-	-	P39L

切槽和切断

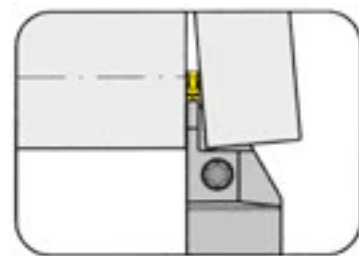
Grooving and Parting Off



刀杆

Toolholder

H100



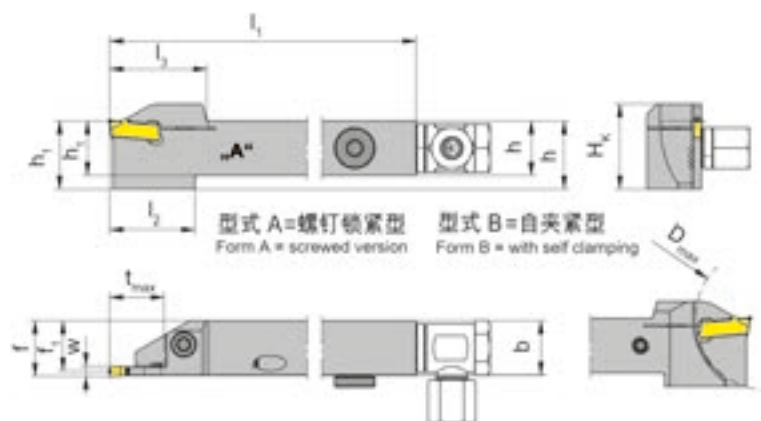
槽深可达
槽宽

Depth of groove up to
Width of groove

32.5 mm
3 mm

配合刀片
for Insert

型号 S100
Type



直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1212.03.IK	12	12	125	21.0	23.0	16	10.85	$f_1+w/2$	13.0	26	25.0	A	03
R/LH100.1616.03.IK	16	16	125	19.5	23.0	20	14.85	$f_1+w/2$	10.5	42	25.0	A	03
R/LH100.1616.13.IK	16	16	125	25.0	28.5	20	14.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.2020.13.IK	20	20	125	-	28.5	20	18.85	$f_1+w/2$	16.0	42	25.0	A	03
R/LH100.2525.13.IK	25	25	150	-	28.5	25	23.85	$f_1+w/2$	16.0	42	30.0	A	03
R/LH100.1616.23.IK	16	16	125	30.0	33.5	20	14.85	$f_1+w/2$	21.0	42	25.0	A	03
R/LH100.2020.23.IK	20	20	125	-	33.5	20	18.85	$f_1+w/2$	21.0	42	25.0	A	03
RH100.2525.23.IK	25	25	150	-	33.5	25	23.85	$f_1+w/2$	21.0	42	30.0	A	03
R/LH100.2020.33.IK	20	20	125	35.0	38.5	25	18.85	$f_1+w/2$	32.5	65	31.6	B	03
R/LH100.2525.33.IK	25	25	150	-	38.5	25	23.85	$f_1+w/2$	32.5	65	31.6	B	03

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

订货须知：

扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Ordering note:

Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	密封塞 Sealing plug	扳手 Wrench
R/LH100...33IK	-	004.00.61	-	004.00.26	P39L
R/LH100...IK	5.17T20P	004.00.16	T20PQ	004.00.26	-

切槽和切断

Grooving and Parting Off

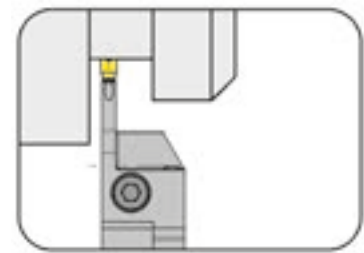


刀杆

Toolholder

H100

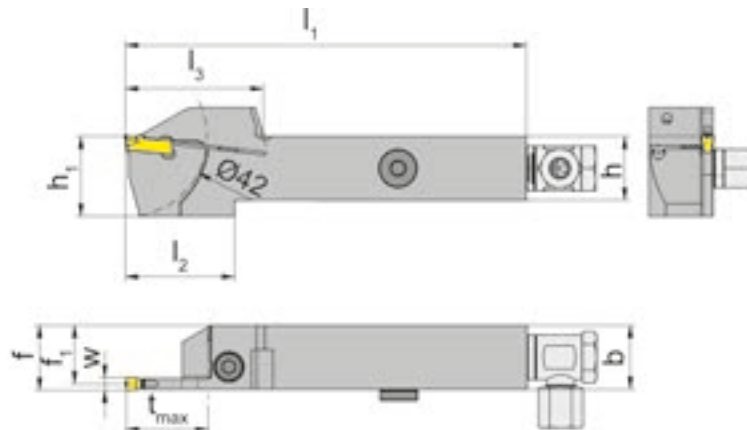
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

21.5 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.1616.0.23.IK	16	16	125	35	39	25	14.65	$f_1 + w/2$	21.5	03
R/LH100.2020.0.23.IK	20	20	125	33	39	25	18.65	$f_1 + w/2$	21.5	03
R/LH100.2525.0.23.IK	25	25	150	33	39	30	23.65	$f_1 + w/2$	21.5	03
R/LH100.1616.0.24.IK	16	16	125	35	39	25	14.30	$f_1 + w/2$	21.5	04
R/LH100.2020.0.24.IK	20	20	125	33	39	25	18.30	$f_1 + w/2$	21.5	04
R/LH100.2525.0.24.IK	25	25	150	33	39	30	23.30	$f_1 + w/2$	21.5	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ

切槽和切断

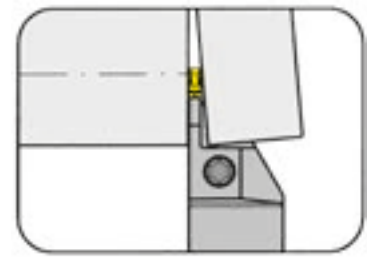
Grooving and Parting Off



刀杆

Toolholder

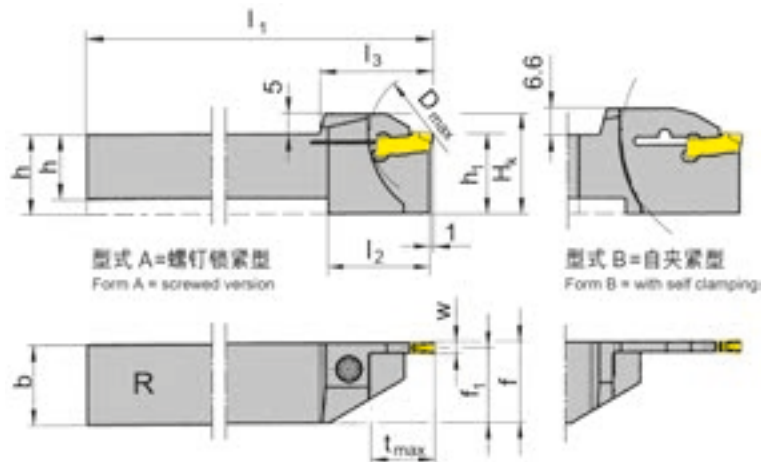
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

40.5 mm
4 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	形式 Form	尺寸规格 Size
R/LH100.1616.04	16	16	125	19.5	23.0	20	14.45	$f_1 + w/2$	10.5	42	25.0	A	04
R/LH100.1616.14	16	16	125	25.0	28.5	20	14.45	$f_1 + w/2$	16.0	42	25.0	A	04
R/LH100.1616.24	16	16	125	30.0	33.5	20	14.45	$f_1 + w/2$	21.0	42	25.0	A	04
R/LH100.2020.14	20	20	125	-	28.5	20	18.45	$f_1 + w/2$	16.0	42	25.0	A	04
R/LH100.2020.34	20	20	125	35.0	38.5	25	18.45	$f_1 + w/2$	32.5	65	31.6	B	04
R/LH100.2525.14	25	25	150	-	28.5	25	23.45	$f_1 + w/2$	16.0	42	30.0	A	04
R/LH100.2525.34	25	25	150	40.0	46.5	32	23.45	$f_1 + w/2$	40.5	81	31.6	B	04

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	5.17T20P	T20PQ

切槽和切断

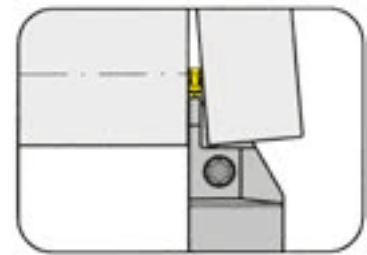
Grooving and Parting Off



刀杆

Toolholder

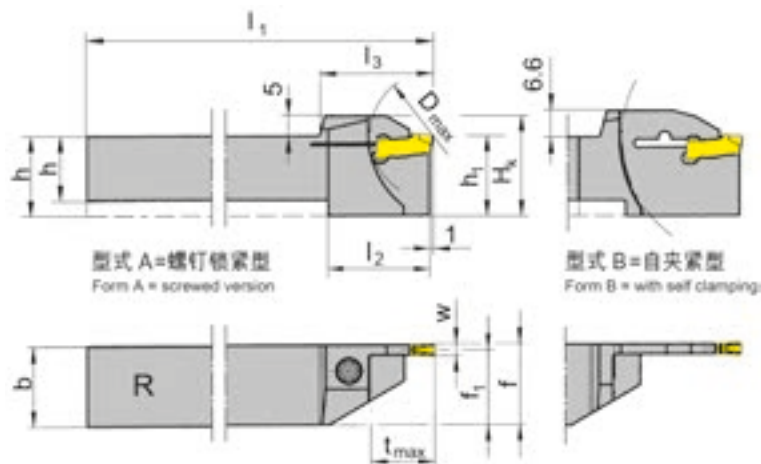
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

40.5 mm
5 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	形式 Form	尺寸规格 Size
R/LH100.2020.15	20	20	125	-	28.5	20	18.05	$f_1+w/2$	16.0	42	25.0	A	05
R/LH100.2020.35	20	20	125	35	38.5	25	18.05	$f_1+w/2$	32.5	65	31.6	B	05
R/LH100.2525.15	25	25	150	-	28.5	25	23.05	$f_1+w/2$	16.0	42	30.0	A	05
R/LH100.2525.35	25	25	150	40	46.5	32	23.05	$f_1+w/2$	40.5	81	38.6	B	05

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100....	5.17T20P	T20PQ

切槽和切断

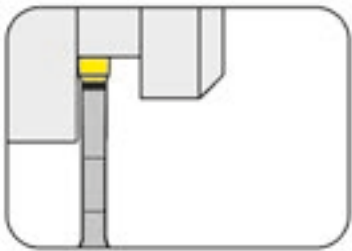
Grooving and Parting Off



刀杆

Toolholder

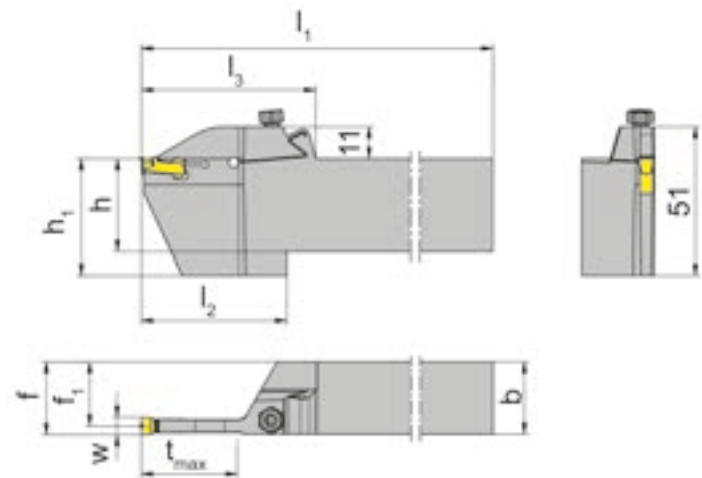
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

41 mm
4-2 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.2020.3.04	20	20	150	50	60	32	18.2	$f_1+w/2$	33	04
R/LH100.2020.3.05	20	20	150	50	60	32	17.7	$f_1+w/2$	33	05
R/LH100.2525.3.05	25	25	150	50	60	32	22.7	$f_1+w/2$	33	05
R/LH100.2525.3.06	25	25	150	50	60	40	22.2	$f_1+w/2$	33	06
R/LH100.3225.3.06	32	25	170	50	60	40	22.2	$f_1+w/2$	33	06
R/LH100.3225.3.08	32	25	170	50	60	40	21.2	$f_1+w/2$	33	08
R/LH100.3225.3.8	32	25	170	50	60	40	21.2	$f_1+w/2$	35	08
R/LH100.3225.4.08	32	25	170	55	65	40	21.2	$f_1+w/2$	41	08
R/LH100.3225.4.10	32	25	170	55	65	40	20.3	$f_1+w/2$	41	10
R/LH100.3225.4.12	32	25	170	55	65	40	19.3	$f_1+w/2$	41	12

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	030.6075.T20P	T20PQ

切槽和切断

Grooving and Parting Off

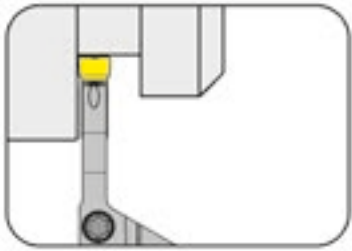


刀杆

Toolholder

H100

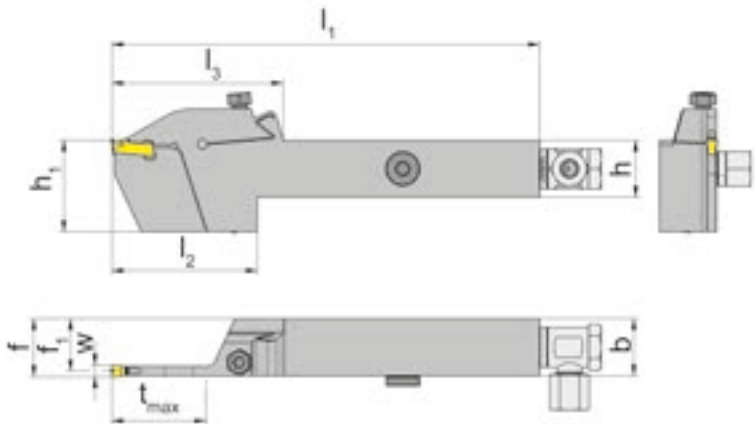
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

33 mm
4 mm



配合刀片
for Insert

型号 S100
Type

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.2020.3.0.04.IK	20	20	150	51	60	32	18.3	$f_1+w/2$	33	04
R/LH100.2525.3.0.04.IK	25	25	150	50	60	32	23.3	$f_1+w/2$	33	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	004.00.26	SBD 6 LR - G1/8"	030.6075.T20P	T20PQ

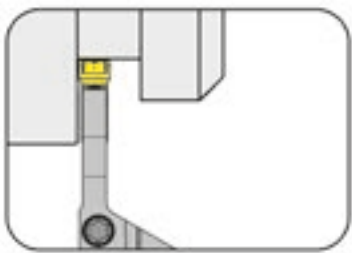
切槽和切断

Grooving and Parting Off



刀杆
Toolholder

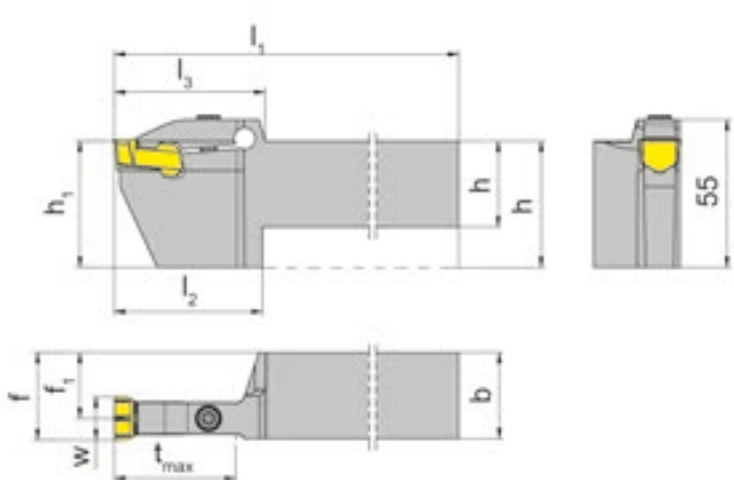
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

45 mm
16 mm



配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	l ₃	尺寸规格 Size
R/LH100.3232.5.16	32	32	170	55	47	24.5	f ₁ +w/2	45	56	16

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100.3232.5.16	030.0625.T25P	T25PQ

切槽和切断

Grooving and Parting Off

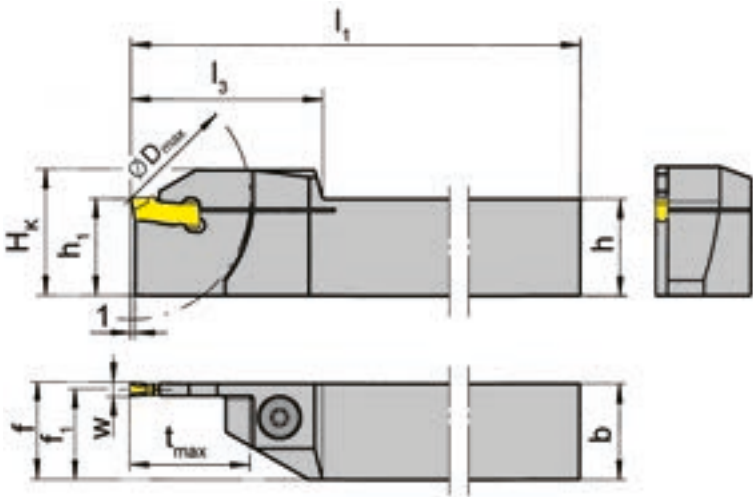
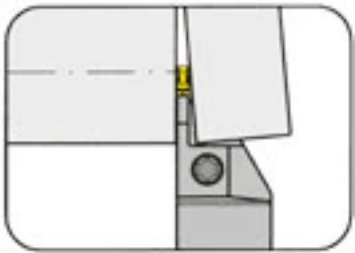


刀杆

Toolholder

H100

槽深可达	Depth of groove up to	25 mm
槽宽	Width of groove	3-4 mm



配合刀片
for Insert

型号 S100
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	l_3	h_1	f_1	f	t_{max}	D_{max}	H_K	尺寸规格 Size
R/LH100.2020.73	20	20	125	40	20	18.85	$f_1+w/2$	25	50	26	03
R/LH100.2525.73	25	25	150	40	25	23.85	$f_1+w/2$	25	50	31	03
R/LH100.2020.74	20	20	125	40	20	18.85	$f_1+w/2$	25	50	26	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	6.23T25P	T25PQ

T

切槽和切断

Grooving and Parting Off

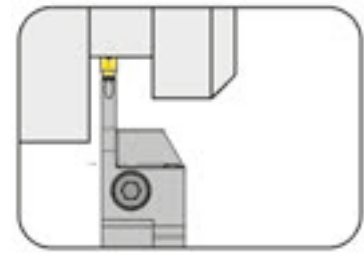


刀杆

Toolholder

H100

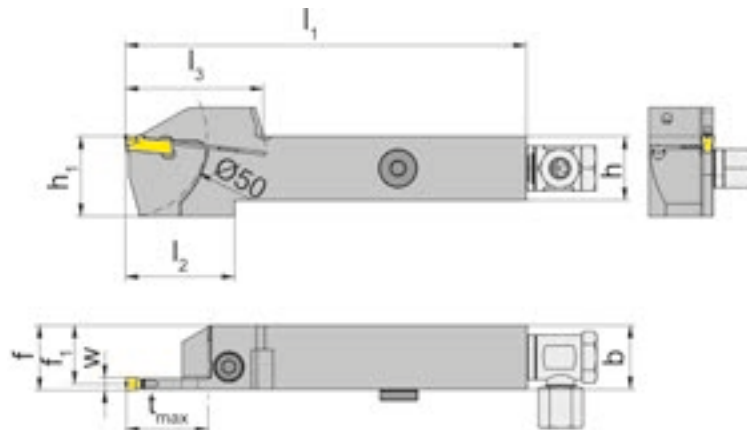
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

25.5 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type

直接冷却液供应
with through coolant supply

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	尺寸规格 Size
R/LH100.2020.0.73.IK	20	20	125	37	43	25	18.65	$f_1 + w/2$	25.5	03
R/LH100.2525.0.73.IK	25	25	150	37	43	30	23.65	$f_1 + w/2$	25.5	03
R/LH100.2525.0.74.IK	25	25	150	37	43	30	23.30	$f_1 + w/2$	25.5	04
R/LH100.2020.0.74.IK	20	20	125	37	43	25	18.30	$f_1 + w/2$	25.5	04

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	密封塞 Sealing plug	冷却液供应 Coolant supply	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	004.00.26	SBD 6 LR - G1/8"	6.23T25P	T25PQ

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

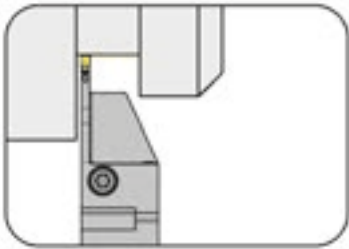
H100

螺钉夹紧
with screwed clamping

槽深可达
槽宽

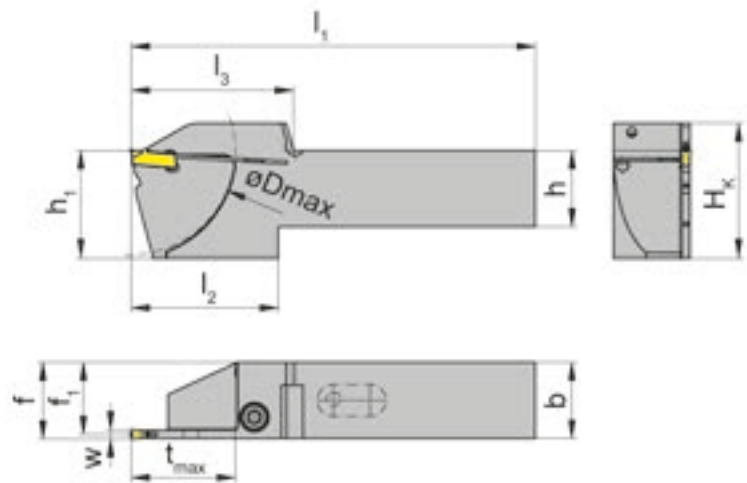
Depth of groove up to
Width of groove

34 mm
3-4 mm



配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带集成内冷
with integrated through
coolant supply

T

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH100.2525.34.4.73.IK	25	25	132	48	53	35	23.65	f ₁ +w/2	34	68	44	03
R/LH100.2020.34.4.73.IK	20	20	115	48	53	30	18.65	f ₁ +w/2	34	68	39	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH100...	6.23T25P	T25PQ

切槽和切断 (外圆)

Grooving and Parting off (external)



刀夹
Cassette

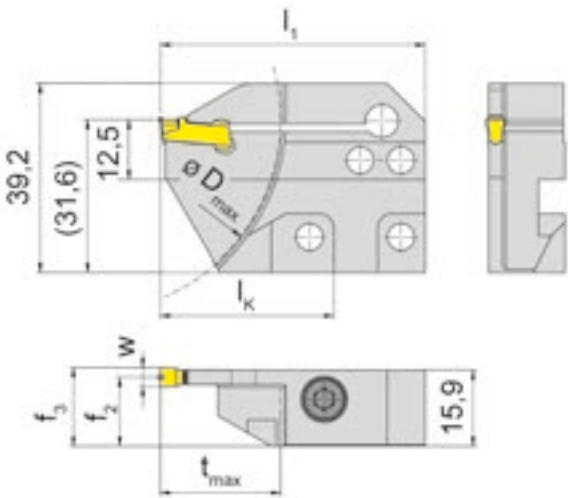
NK100



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2-4 mm



配合刀片
for Insert

型号 S100
Type

L=左手型-如图
L = left hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	f ₂	f ₃	w	D _{max}	l ₁	l _k
R/LNK100.3215.21	25	15.4	f ₂ +w/2	2	80	55	36
R/LNK100.3215.23	25	14.9	f ₂ +w/2	3	80	55	36
R/LNK100.3215.24	25	14.4	f ₂ +w/2	4	80	55	36

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位 : mm
Dimensions in mm

订货须知 :
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

注明R或L型
State R or L version

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK100...	6.23T25P	T25PQ

切断

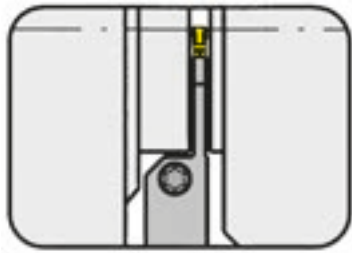
Parting Off



常规刀柄

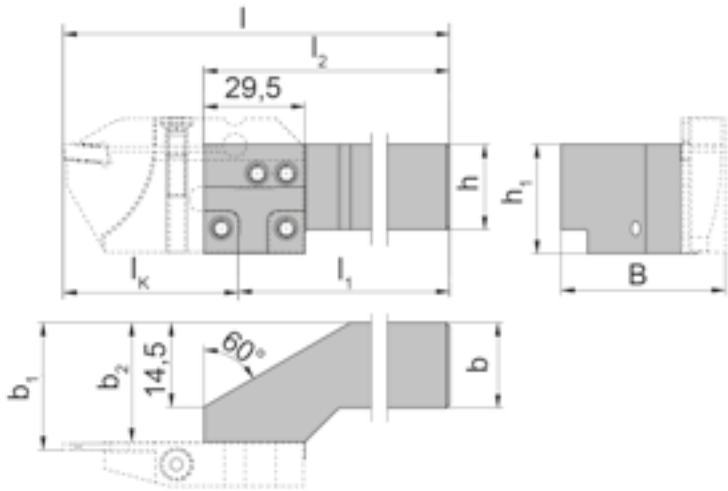
Basic toolholder

220
无刀夹
without cassette



配合RNK100的常规刀杆
Basic adapter for cassettes type RNK100

刀杆平行于工件轴线
Shank parallel to the axis of workpiece



配合刀片
for Insert

型号 RNK100...L
Type

R=右手型
R = right hand version

多主轴MS52系列
Multi spindle system MS52

T

产品型号 Part number	h	h ₁	l ₁	b ₁	b	l ₂	l	B	b ₂
R220.2529.60.K1	25	32	l ₂ -10	b ₂ +f ₃	25	160	l ₁ +l _k	b ₂ +b ₃	29.5
R220.2535.60.K1	25	32	l ₂ -10	b ₂ +f ₃	25	160	l ₁ +l _k	b ₂ +b ₃	34.9

按需提供更多尺寸
Further sizes upon request

l_k, b₃和 f₃见刀夹
l_k, b₃ and f₃ see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R220...	5.12T20P	T20PQ

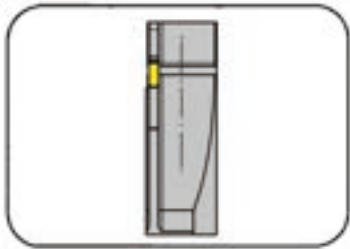
切槽和切断 (外圆)

Grooving and Parting off (external)



刀夹
Cassette

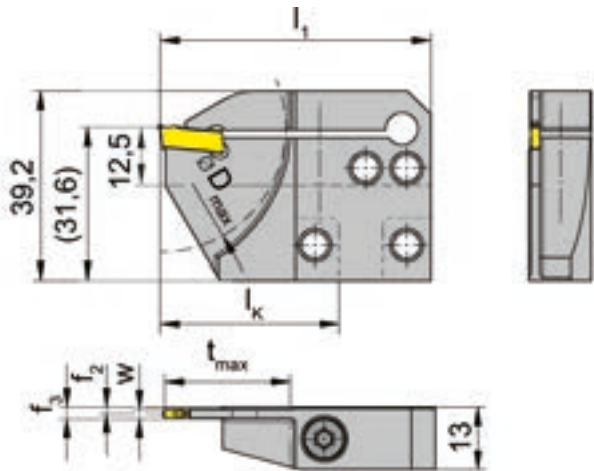
NK100



槽深可达 槽宽	Depth of groove up to Width of groove	26 mm 2.5-3 mm

配合刀片
for Insert

型号 S100
Type



R=右手型-如图
R = right hand version shown

产品型号 Part number	t _{max}	f ₂	f ₃	w	D _{max}	l ₁	l _k
RNK100.5625.02L	26	1.40	f ₂ +w/2	2.5	52	56	37
RNK100.7025.02L	26	1.40	f ₂ +w/2	2.5	52	70	51
RNK100.5625.03L	26	1.65	f ₂ +w/2	3.0	52	56	37
RNK100.7025.03L	26	1.65	f ₂ +w/2	3.0	52	70	51

配合常规刀杆R...K1和L...K2
For basic toolholder R...K1 and L...K2

尺寸单位：mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RNK100.5625....	6.17T25P	T25PQ
RNK100.7025....	6.23T25P	T25PQ

切槽和切断

Grooving and Parting Off

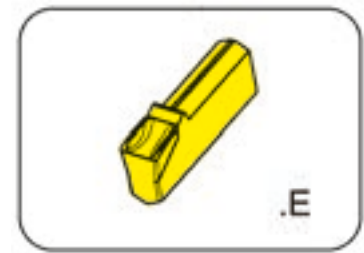


刀片

Insert

S100

带卷屑器
with chip former



槽宽

Width of groove

2-5 mm

配合刀杆

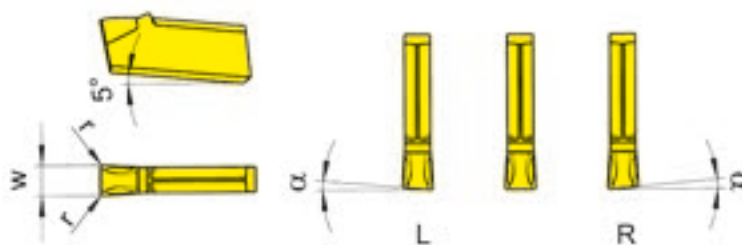
for Toolholder

型号

H100

Type

NK100



R=右手型

R = right hand version

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	ALX2	ALX3	AS63	AS66	TC92	TC93	TF42	TF43	TF45	TF46	T122
S100.0200.E2	2.0	0.2	0°	01		▲			▲	Δ		▲	▲	▲	Δ
R/LS100.0520.E2	2.0	0.2	5°	01					Δ/Δ	Δ/Δ		▲/Δ	▲/▲	Δ/Δ	Δ/Δ
S100.0250.E2	2.5	0.2	0°	02					Δ	Δ		▲	▲	▲	▲
R/LS100.0525.E2	2.5	0.2	5°	02					Δ/Δ	▲/Δ		▲/Δ	▲/Δ	Δ/▲	Δ/Δ
S100.0300.E2	3.0	0.2	0°	03	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
R/LS100.0530.E2	3.0	0.2	5°	03		▲/Δ			Δ/▲	▲/Δ	▲/Δ	▲/▲	▲/▲	▲/▲	▲/Δ
S100.0400.E3	4.0	0.3	0°	04		▲			Δ	▲		▲	▲	▲	▲
R/LS100.0540.E2	4.0	0.2	5°	04		Δ/Δ			Δ/Δ	Δ/Δ		▲/▲	▲/▲	Δ/Δ	Δ/Δ
S100.0500.E3	5.0	0.3	0°	05				Δ	Δ	▲		▲	▲	Δ	Δ
▲ 库存 / on stock Δ / x 根据要求 / upon request					P	●	●	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	-	o	-	-	-	●	o	-
o 次推荐 / alternative recommendation					K	-	-	-	●	-	-	-	●	●	-
- 不合适 / not suitable					N	-	-	-	●	-	-	-	●	●	-
非涂层 / uncoated grades					S	-	-	-	o	-	-	-	●	o	-
涂层 / coated grades					H	-	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet															

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

HM-Sorten

Carbide grades

T

切槽和切断

Grooving and Parting Off



刀片

Insert

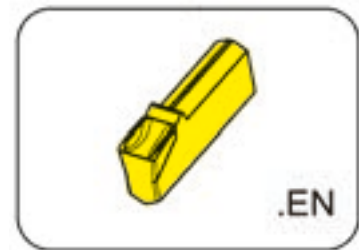
S100

带卷屑器
with chip former

槽宽

Width of groove

2-16 mm



配合刀杆

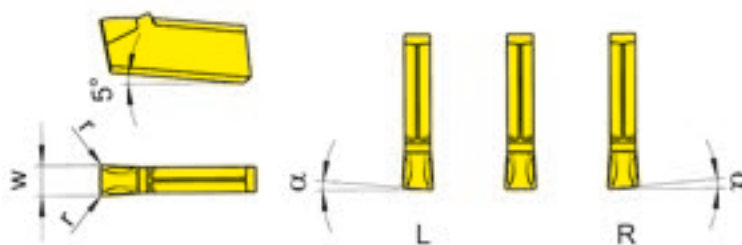
for Toolholder

型号

H100

Type

NK100



R=右手型

R = right hand version

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	ALX3	ALX5	AS62	AS63	AS66	AS6G	TF45	TH35
S100.0200.EN2	2.0	0.2	0°	01	▲	Δ				▲		Δ
S100.0220.EN2	2.2	0.2	0°	01	▲					▲		
S100.0250.EN2	2.5	0.2	0°	02	▲					▲		
S100.0300.EN2	3.0	0.2	0°	03	▲	Δ		▲	▲	▲	Δ	
RS100.0530.EN2	3.0	0.2	5°	03			▲		▲			
S100.0400.EN3	4.0	0.3	0°	04	▲			▲		▲		
R/LS100.0540.EN2	4.0	0.2	5°	04	▲/▲							
S100.0500.EN3	5.0	0.3	0°	05	▲							
S100.0600.EN6	6.0	0.8	0°	06								
S100.0800.EN8	8.0	0.8	0°	08					▲	▲		
LS100.0480.EN8	8.0	0.8	4°	08					▲			
S100.1000.EN8	10.0	0.8	0°	10						▲		
S100.1200.EN8	12.0	0.8	0°	12						▲		
S100.1600.EN8	16.0	0.8	0°	16						▲		
▲ 库存 / on stock Δ / x 根据要求 / upon request					P	•	•	•	•	•	•	•
● 推荐 / recommended					M	-	•	-	-	o	•	•
o 次推荐 / alternative recommendation					K	-	•	-	-	•	•	•
- 不合适 / not suitable					N	-	•	-	-	•	•	•
■ 非涂层 / uncoated grades					S	-	•	-	-	o	•	•
■ 涂层 / coated grades					H	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位：mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



刀片

Insert

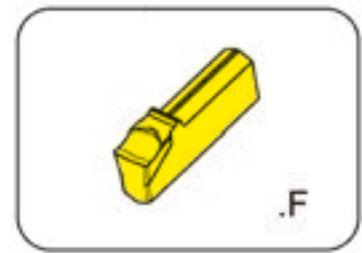
S100

带卷屑器
with chip forming

槽宽

Width of groove

2-4 mm

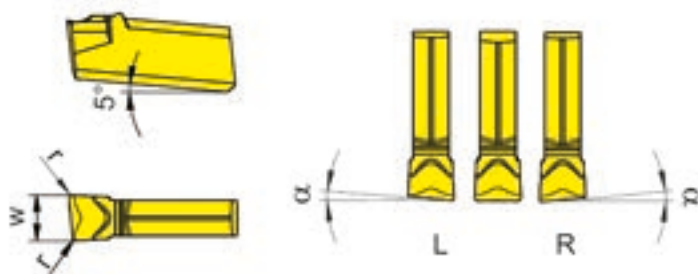


配合刀杆

for Toolholder

型号 H100

Type NK100



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	ALX3	TC92	TC93	TF42	TF43	TF45	TF46	T122
S100.0200.F2	2.0	0.2	0°	01		▲	Δ		▲	▲	▲	▲
R/LS100.0520.F2	2.0	0.2	5°	01		Δ/Δ	Δ/Δ		Δ/Δ	▲/▲	▲/Δ	Δ/Δ
S100.0250.F2	2.5	0.2	0°	02		Δ	Δ		Δ	▲	Δ	▲
R/LS100.0525.F2	2.5	0.2	5°	02		Δ/Δ	Δ/Δ		Δ/Δ	▲/Δ	Δ/Δ	Δ/Δ
S100.0300.F2	3.0	0.2	0°	03		▲	▲	Δ	▲	▲	▲	▲
R/LS100.0530.F2	3.0	0.2	5°	03		Δ/Δ	Δ/▲		▲/▲	▲/▲	Δ/▲	Δ/Δ
S100.0400.F3	4.0	0.3	0°	04		Δ	Δ		▲	▲	▲	▲
R/LS100.0540.F2	4.0	0.2	5°	04		Δ/Δ	Δ/Δ		Δ/Δ	▲/▲	Δ/Δ	Δ/Δ
S100.0500.F3	5.0	0.3	0°	05	x	Δ	Δ		Δ	▲	Δ	▲
▲ 库存 / on stock Δ / x 根据要求 / upon request					P	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	-	-	●	○	-
○ 次推荐 / alternative recommendation					K	-	-	-	-	●	●	-
- 不合适 / not suitable					N	-	-	-	-	●	●	-
非涂层 / uncoated grades					S	-	-	-	-	●	○	-
涂层 / coated grades					H	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet												

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

T

切槽和切断

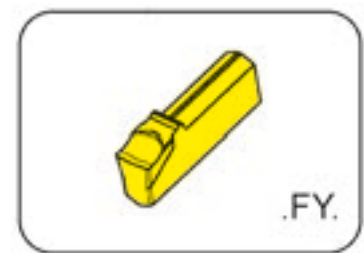
Grooving and Parting Off



刀片

Insert

S100
带卷屑器
with chip forming

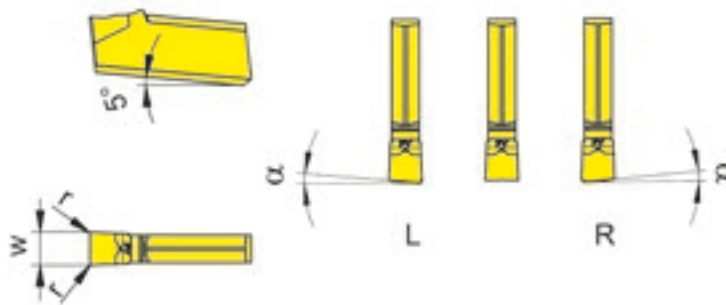


槽宽	Width of groove	2-4 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H100
Type NK100



R=右手型
R = right hand version

L=左手型
L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size		AS45	HP65	IG35	PH35	TI25
S100.0200.FY2	2.0	0.2	0°	01		△	▲	▲	▲	▲
R/LS100.1520.FY0	2.0	-	15°	01		▲/▲		▲/▲		
S100.0220.FY2	2.2	0.2	0°	01				▲		▲
S100.0250.FY2	2.5	0.2	0°	02		△	▲	▲		▲
S100.0300.FY2	3.0	0.2	0°	03		△	▲	▲	▲	▲
R/LS100.1530.FY0	3.0	-	15°	03		▲/▲		▲/▲		
S100.0400.FY3	4.0	0.3	0°	04			▲	▲		▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
○ 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

硬质合金牌号
Carbide grades

尺寸单位 : mm
Dimensions in mm
此可转位刀片可用于右手和左手型刀杆
Indexable inserts can be used in **right and left** hand toolholders.
注明R或L型
State R or L version

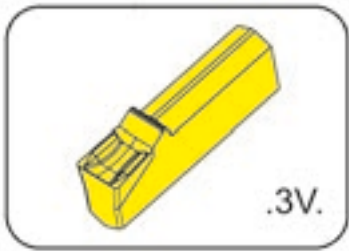
切槽和切断

Grooving and Parting Off



刀片
Insert

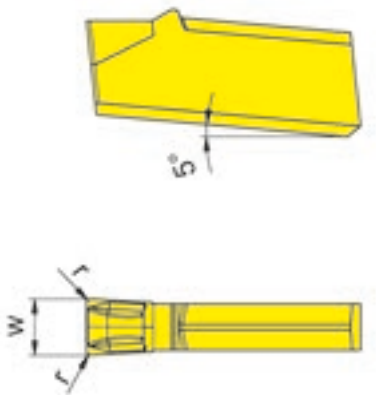
S100
带卷屑器
with chip forming



槽宽	Width of groove	2-4 mm

配合刀杆
for Toolholder

型号 H100
Type NK100



产品型号 Part number	w	r	尺寸规格 Size		AS45	HP35	HP65	IG35	PH35
S100.0200.3V2	2.0	0.2	01		▲	△	▲	▲	▲
S100.0250.3V2	2.5	0.2	02		▲		▲	▲	
S100.0300.3V2	3.0	0.2	03		▲		▲	▲	▲
S100.0400.3V3	4.0	0.3	04		▲		▲	▲	
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request ● 推荐 / recommended o 次推荐 / alternative recommendation - 不合适 / not suitable ■ 非涂层 / uncoated grades ■ 涂层 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet				P	●	●	-	o	●
				M	●	●	●	o	●
				K	●	●	-	●	●
				N	o	o	-	-	●
				S	●	●	●	-	●
				H	-	-	-	-	-

硬质合金牌号
 Carbide grades

T

切槽和切断

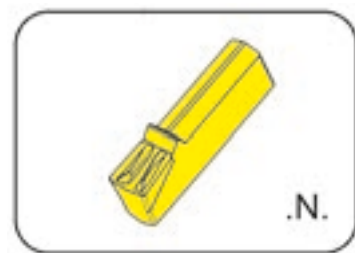
Grooving and Parting Off



刀片

Insert

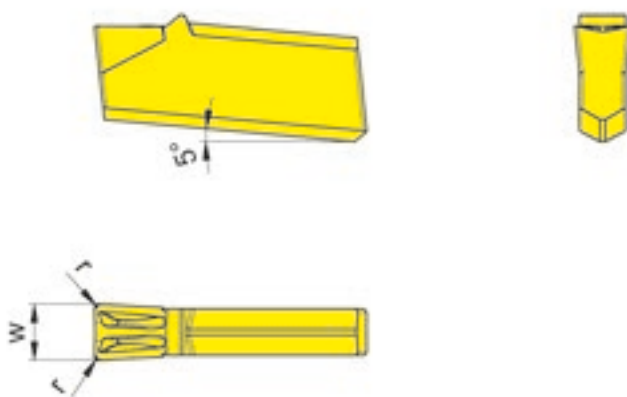
S100
带卷屑器
with chip forming



槽宽	Width of groove	3-4 mm

配合刀杆
for Toolholder

型号 H100
Type NK100



T

产品型号 Part number	w	r	尺寸规格 Size		AS45	HP65
S100.0300.N2	3	0.2	03	▲	▲	▲
S100.0400.N3	4	0.3	04	▲	▲	▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request				P	•	•
● 推荐 / recommended				M	•	•
o 次推荐 / alternative recommendation				K	•	•
- 不合适 / not suitable				N	o	o
■ 非涂层 / uncoated grades				S	•	•
■ 涂层 / coated grades				H	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet				硬质合金牌号 Carbide grades		
尺寸单位 : mm Dimensions in mm						

切槽和切断

Grooving and Parting Off

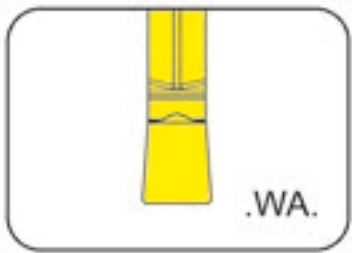


刀片
Insert

S100
带卷屑器
with chip forming

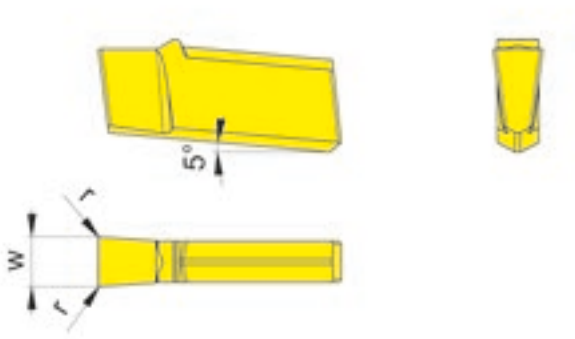
槽宽	Width of groove	2-3 mm

präzisionsgeschliffen und poliert
precision ground and polished



配合刀杆
for Toolholder

型号 H100
Type NK100



für Aluminium
for Aluminium

T

产品型号 Part number	w	r	尺寸规格 Size		K10	DD26
S100.0200.WA2	2	0.2	02	▲	▲	▲
S100.0300.WA2	3	0.2	03	▲	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request ● 推荐 / recommended o 次推荐 / alternative recommendation - 不合适 / not suitable 非涂层 / uncoated grades 涂层 / coated grades 钎焊/金属陶瓷 / brazed/Cermet				P	●	-
尺寸单位 : mm Dimensions in mm				M	o	-
此可转位刀片可用于右手和左手型刀杆 Indexable inserts can be used in right and left hand toolholders.				K	●	-
				N	●	●
				S	o	o
				H	-	-
				硬质合金牌号 Carbide grades		

切槽和切断

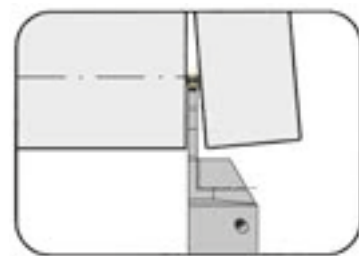
Grooving and Parting Off



刀杆

Toolholder

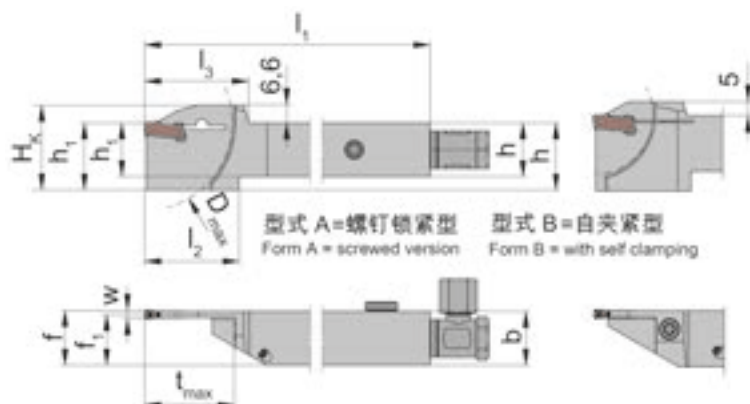
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

41 mm
3-4 mm



配合刀片
for Insert

型号 S100...IK
Type

冷却液供应通过刀片
Coolant supply through insert

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	l_2	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	形式 Form	尺寸规格 Size
R/LH100.1616.1.23.IK	16	16	125	35	33.5	27	14.85	$f_1+w/2$	21.5	42	32.0	A	03
R/LH100.2020.1.13.IK	20	20	125	30	28.5	27	18.85	$f_1+w/2$	16.0	42	32.0	A	03
R/LH100.2020.1.23.IK	20	20	125	35	33.5	27	18.85	$f_1+w/2$	21.5	42	32.0	A	03
R/LH100.2020.1.33.IK	20	20	125	35	38.5	27	18.85	$f_1+w/2$	33.0	65	33.6	B	03
R/LH100.2525.1.33.IK	25	25	150	35	38.5	32	23.85	$f_1+w/2$	33.0	65	38.6	B	03
R/LH100.2020.1.34.IK	20	20	125	35	38.5	27	18.45	$f_1+w/2$	33.0	65	33.6	B	04
R/LH100.2525.1.34.IK	25	25	150	40	46.5	32	23.45	$f_1+w/2$	41.0	81	38.6	B	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

订货须知：
扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Ordering note:
Wrench P39L ist not combined with blade R/LH100...33 - separate order required!
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	密封塞 Sealing plug	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Wrench
R/LH100...13/23.IK	5.17T20P	004.00.26	004.00.16	T20PQ	-
R/LH100....	-	004.00.26	004.00.16	-	P39L

切槽和切断

Grooving and Parting Off



刀杆
Toolholder

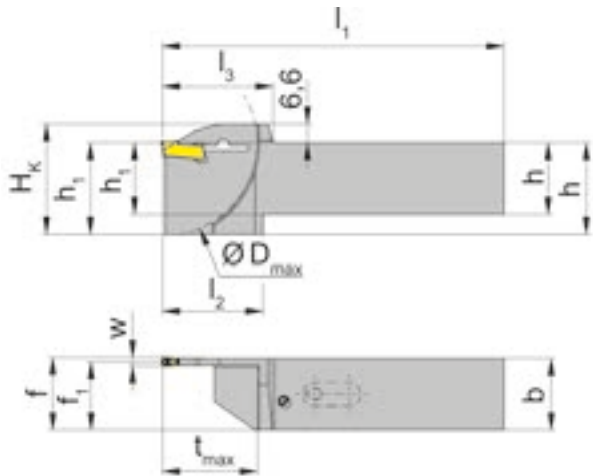
H100



槽深可达
槽宽

Depth of groove up to
Width of groove

33 mm
3 mm



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

配合刀片
for Insert

型号 S100...IK
Type

冷却液供应通过刀片
Coolant supply through insert

T

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH100.2020.3.33.IK	20	20	104	35	38.5	27	18.85	f ₁ +w/2	33	65	33.6	03
R/LH100.2525.3.33.IK	25	25	119	35	38.5	32	23.85	f ₁ +w/2	33	65	38.6	03

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

订货须知：
扳手P39L不包含在刀板中R/LH100...33，需单独订购！
Ordering note:
Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

切槽和切断 (外圆)

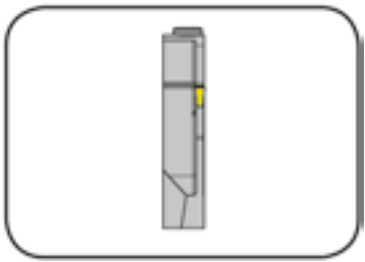
Grooving and Parting off (external)



刀夹
Cassette

NK100

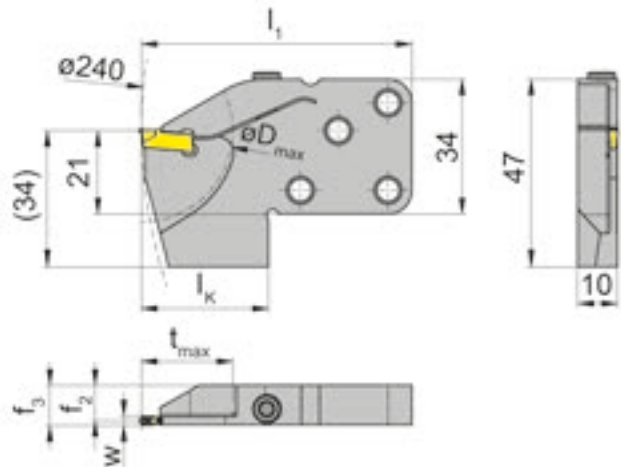
Interface 842



槽深	Depth of groove	34 mm
槽宽	Width of groove	2.5-4 mm

配合刀片
for Insert

型号 S100...IK
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

冷却液供应通过刀片
Coolant supply through insert

产品型号 Part number	t _{max}	f ₂	f ₃	w	D _{max}	l ₁	l _K
R/LNK100.0842.23.3.72.IK	23	8.95	f ₂ +w/2	2.5	46	68	32
R/LNK100.0842.34.3.73.IK	34	8.70	f ₂ +w/2	3.0	68	76	40
R/LNK100.0842.34.3.74.IK	34	8.20	f ₂ +w/2	4.0	68	76	40

注明R或L型
State R or L version

尺寸单位：mm
Dimensions in mm

订货须知：
紧固螺钉与切槽刀架配合使用 - 无需单独订购。
Ordering note:
The fastening screws are combined with the grooving toolholder - no separate order required.
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK100...	5.13 T20P	T20PQ

切槽和切断

Grooving and Parting Off



刀片

Insert

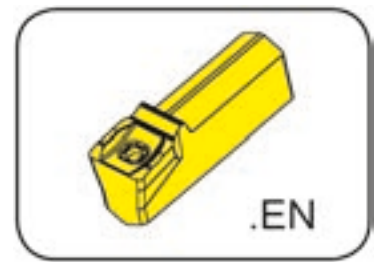
S100

带卷屑器
with chip former

槽宽

Width of groove

2.5-4 mm

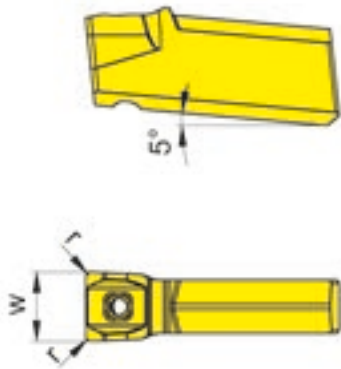


配合刀杆

for Toolholder

型号 H100...13/23/33/34.IK

Type NK100...IK



冷却液供应通过刀片
Coolant supply through insert

T

产品型号 Part number	w	r	尺寸规格 Size		AS45	EG55	HP65
S100.0250.EN2.IK	2.5	0.2	02		▲	▲	▲
S100.0300.EN2.IK	3.0	0.2	03		▲	▲	▲
S100.0400.EN3.IK	4.0	0.3	04		▲	▲	▲
				P	●	●	●
				M	●	○	●
				K	●	○	●
				N	○	-	○
				S	●	-	●
				H	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

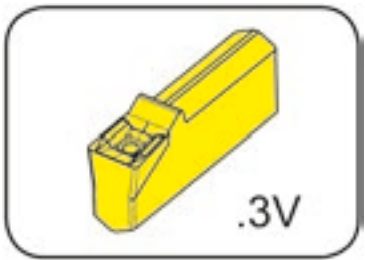
Grooving and Parting Off



刀片
Insert

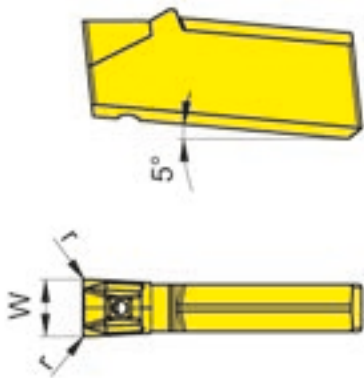
S100
带卷屑器
with chip former

槽宽	Width of groove	2.5-3 mm



配合刀杆
for Toolholder

型号 H100...13/23/33/34.IK
Type NK100...IK



冷却液供应通过刀片
Coolant supply through insert

产品型号 Part number	w	r	尺寸规格 Size		HP65	IG35
S100.0250.3V2.IK	2.5	0.2	02		▲	▲
S100.0300.3V2.IK	3.0	0.2	03		▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request ● 推荐 / recommended o 次推荐 / alternative recommendation - 不合适 / not suitable ■ 非涂层 / uncoated grades ■ 涂层 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet				P	●	-
尺寸单位 : mm Dimensions in mm 此可转位刀片可用于右手和左手型刀杆 Indexable inserts can be used in right and left hand toolholders.				M	●	●
				K	●	-
				N	○	-
				S	●	●
				H	-	-
				硬质合金牌号 Carbide grades		

冷却液供应选择

Possible coolant supply.



冷却液通过刀片侧边的喷嘴输出

Coolant outlet through spray nozzle at the side of the insert.



冷却液通过刀片侧边的喷嘴输出

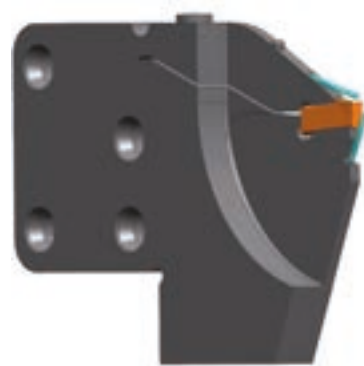
Coolant outlet through spray nozzle at the side of the insert.



冷却液通过夹紧部位输出

Coolant outlet through clamping finger.

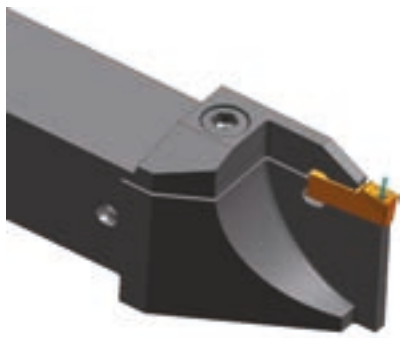
S100
S224
S229



冷却液通过夹紧部位上下输出

Coolant outlet through clamping finger and insert support

S100
S224
S229

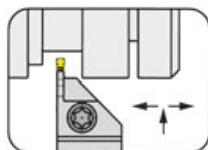


冷却液通过刀片输出

Coolant outlet through insert.

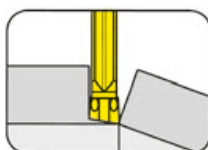
S100
S224

刀杆
Toolholder
H223



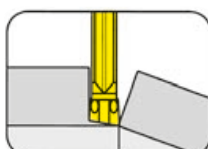
页/Page
T54-T55

刀片
Insert
S123

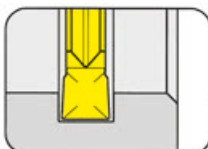


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T56-T57

可转位刀片
Indexable insert
S223



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T58-T59



页/Page
T60

123/223



T

机夹式刀杆

带卷屑器

槽宽 2 - 3 mm

槽深可达 25 mm

Toolholder with Inserts

with chip forming

Width of groove 2 - 3 mm

Depth of groove up to 25 mm

切槽和切断

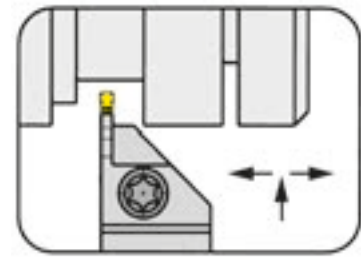
Grooving and Parting Off



刀杆

Toolholder

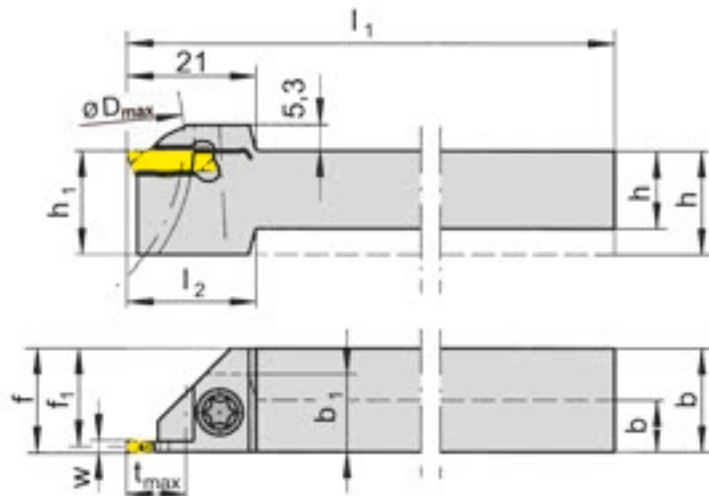
H223



槽深可达
槽宽

Depth of groove up to
Width of groove

10 mm
2-3 mm



配合刀片
for Insert

型号 S223
Type S123

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	b_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH223.1010.01	10	10	80	20	12	12	9.20	$f_1+w/2$	8	25	01	2.0
R/LH223.1212.01	12	12	100	21	16	-	11.20	$f_1+w/2$	10	50	01	2.0
R/LH223.1616.01	16	16	125	-	16	-	15.20	$f_1+w/2$	10	50	01	2.0
R/LH223.2020.01	20	20	125	-	20	-	19.20	$f_1+w/2$	10	50	01	2.0
R/LH223.2525.01	25	25	150	-	25	-	24.20	$f_1+w/2$	10	50	01	2.0
R/LH223.1010.02	10	10	80	20	12	12	9.05	$f_1+w/2$	8	25	02	2.5
R/LH223.1212.02	12	12	100	21	16	-	11.05	$f_1+w/2$	10	50	02	2.5
R/LH223.1616.02	16	16	125	-	16	-	15.05	$f_1+w/2$	10	50	02	2.5
R/LH223.2020.02	20	20	125	-	20	-	19.05	$f_1+w/2$	10	50	02	2.5
R/LH223.2525.02	25	25	150	-	25	-	24.05	$f_1+w/2$	10	50	02	2.5
R/LH223.1010.03	10	10	80	20	12	12	8.80	$f_1+w/2$	8	25	03	3.0
R/LH223.1212.03	12	12	100	21	16	-	10.80	$f_1+w/2$	10	50	03	3.0
R/LH223.1616.03	16	16	125	-	16	-	14.80	$f_1+w/2$	10	50	03	3.0
R/LH223.2020.03	20	20	125	-	20	-	18.80	$f_1+w/2$	10	50	03	3.0
R/LH223.2525.03	25	25	150	-	25	-	23.80	$f_1+w/2$	10	50	03	3.0

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

切槽和切断

Grooving and Parting Off

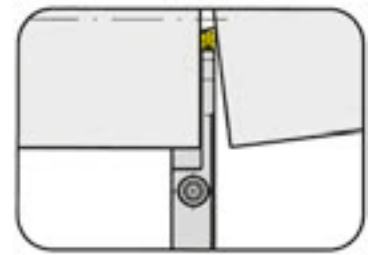


刀杆

Toolholder

H223

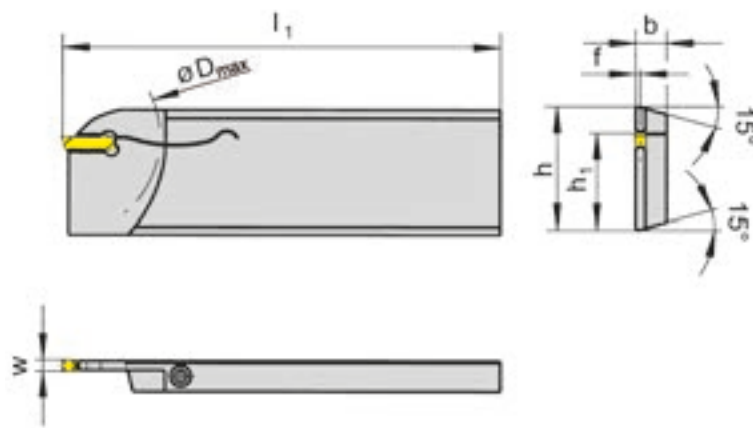
加强型
reinforced version



槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
2-3 mm



配合刀片
for Insert

型号 S223
Type S123

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	f	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH223.2608.01	26	7.9	110	21.4	0.80	50	01	2.0
R/LH223.3208.01	32	7.9	110	24.8	0.80	50	01	2.0
R/LH223.2608.02	26	7.9	110	21.4	0.95	50	02	2.5
R/LH223.3208.02	32	7.9	110	24.8	0.95	50	02	2.5
R/LH223.2608.03	26	7.9	110	21.4	1.20	50	03	3.0
R/LH223.3208.03	32	7.9	110	24.8	1.20	50	03	3.0

注明R或L型
State R or L version

w见刀片
w see indexable inserts

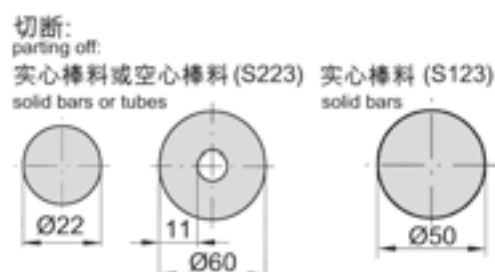
尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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



配件

Spare Parts

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

切槽和切断

Grooving and Parting Off



刀片

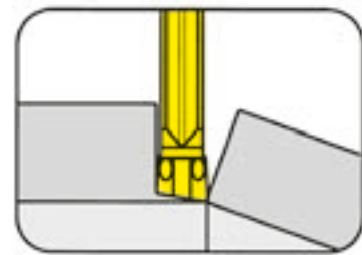
Insert

S123

槽深可达
槽宽

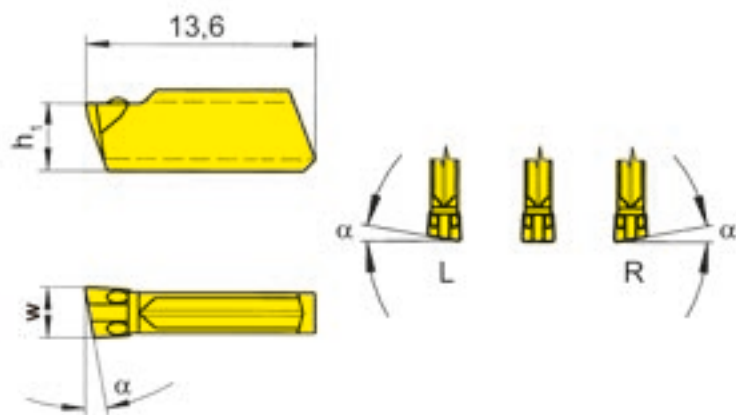
Depth of groove up to
Width of groove

25 mm
2-3 mm



配合刀杆
for Toolholder

型号 H223
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	α	h_1	尺寸规格 Size	TF45	T125	TN35
S123.0020.C0	2	0°	3.65	01	Δ	Δ	Δ
R/LS123.0420.C0	2	4°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0820.C0	2	8°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.1520.C0	2	15°	3.65	01	▲/Δ	Δ/Δ	Δ/Δ
S123.0030.C0	3	0°	3.95	03	Δ	Δ	Δ
R/LS123.0430.C0	3	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0830.C0	3	8°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切槽和切断

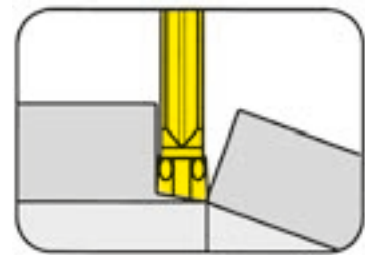
Grooving and Parting Off



刀片

Insert

S123



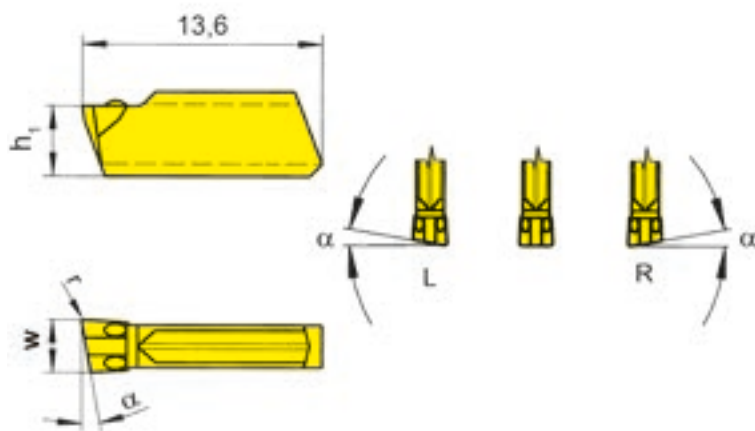
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
2-3 mm

配合刀杆
for Toolholder

型号 H223
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	α	h ₁	尺寸规格 Size	TF45	T125	TN35
S123.0020.C1	2	0.15	0°	3.65	01	Δ	Δ	Δ
R/LS123.0420.C1	2	0.15	4°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0820.C1	2	0.15	8°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.1520.C1	2	0.15	15°	3.65	01	Δ/Δ	Δ/Δ	Δ/Δ
S123.0030.C1	3	0.15	0°	3.95	03	Δ	Δ	Δ
R/LS123.0430.C1	3	0.15	4°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ
R/LS123.0830.C1	3	0.15	8°	3.95	03	Δ/Δ	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

T

切槽和切断

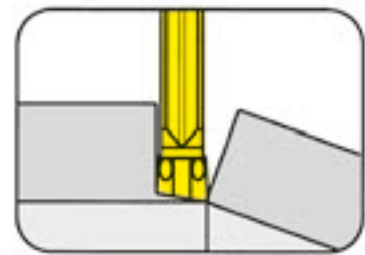
Grooving and Parting Off



可转位刀片

Indexable insert

S223



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm

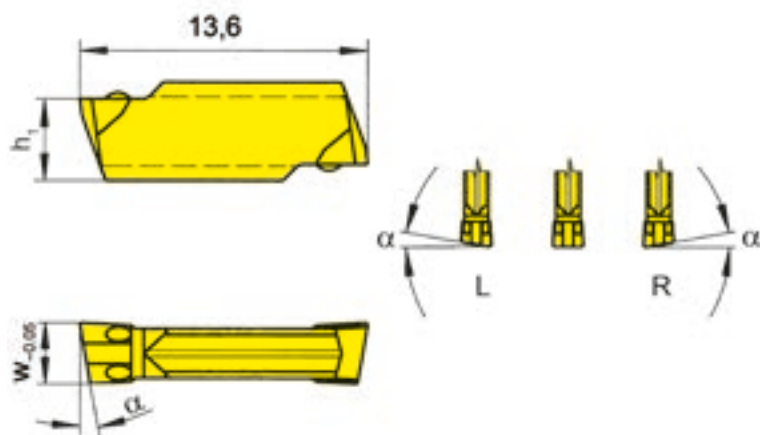
配合刀杆

for Toolholder

型号

H223

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	h_1	尺寸规格 Size	TF45	T125	TN35
S223.0020.C0	2.0	0°	3.65	01	▲	▲	▲
R/LS223.0420.C0	2.0	4°	3.65	01	△/△	▲/△	▲/▲
R/LS223.0820.C0	2.0	8°	3.65	01	▲/△	▲/▲	▲/▲
R/LS223.1520.C0	2.0	15°	3.65	01	▲/△	▲/▲	▲/▲
S223.0025.C0	2.5	0°	3.75	02	△	▲	△
R/LS223.0425.C0	2.5	4°	3.75	02	△/△	▲/△	△/△
R/LS223.0825.C0	2.5	8°	3.75	02	▲/△	▲/△	▲/△
S223.0030.C0	3.0	0°	3.95	03	△	▲	▲
R/LS223.0430.C0	3.0	4°	3.95	03	△/△	△/△	△/△
R/LS223.0830.C0	3.0	8°	3.95	03	▲/△	▲/△	▲/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

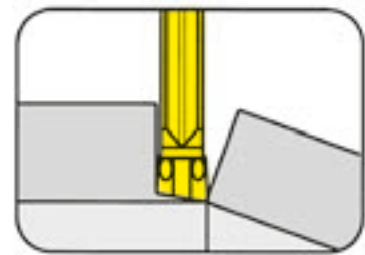
Indexable insert

S223

槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm



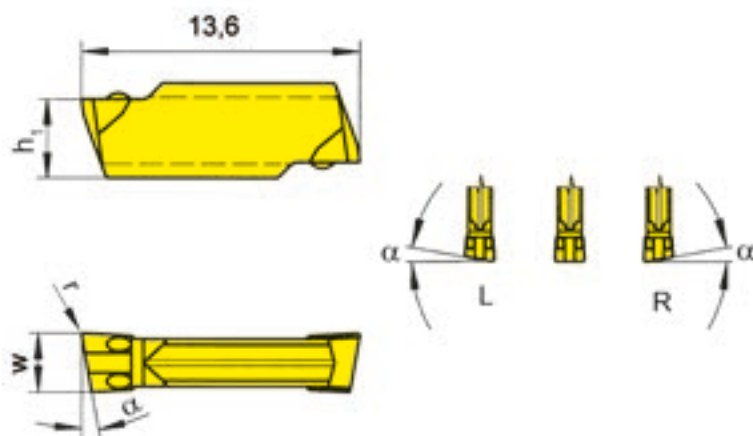
配合刀杆

for Toolholder

型号

H223

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	h ₁	尺寸规格 Size	TF45	T125	TN35
S223.0020.C1	2.0	0.15	0°	3.65	01	▲	▲	▲
R/LS223.0420.C1	2.0	0.15	4°	3.65	01	△/△	△/△	▲/▲
R/LS223.0820.C1	2.0	0.15	8°	3.65	01	▲/△	▲/△	▲/△
R/LS223.1520.C1	2.0	0.15	15°	3.65	01	▲/△	△/△	▲/△
S223.0025.C1	2.5	0.15	0°	3.75	02	△	▲	△
R/LS223.0425.C1	2.5	0.15	4°	3.75	02	△/△	△/△	△/△
R/LS223.0825.C1	2.5	0.15	8°	3.75	02	△/△	▲/△	△/△
S223.0030.C1	3.0	0.15	0°	3.95	03	▲	▲	▲
R/LS223.0430.C1	3.0	0.15	4°	3.95	03	△/△	△/△	△/△
R/LS223.0830.C1	3.0	0.15	8°	3.95	03	▲/△	△/△	△/△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

T

切槽和切断

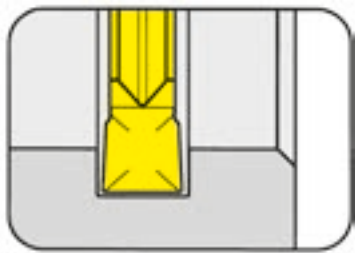
Grooving and Parting Off



可转位刀片

Indexable insert

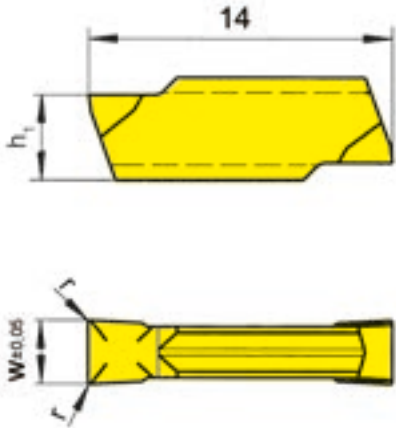
S223



槽深可达
槽宽

Depth of groove up to
Width of groove

11 mm
2-3 mm

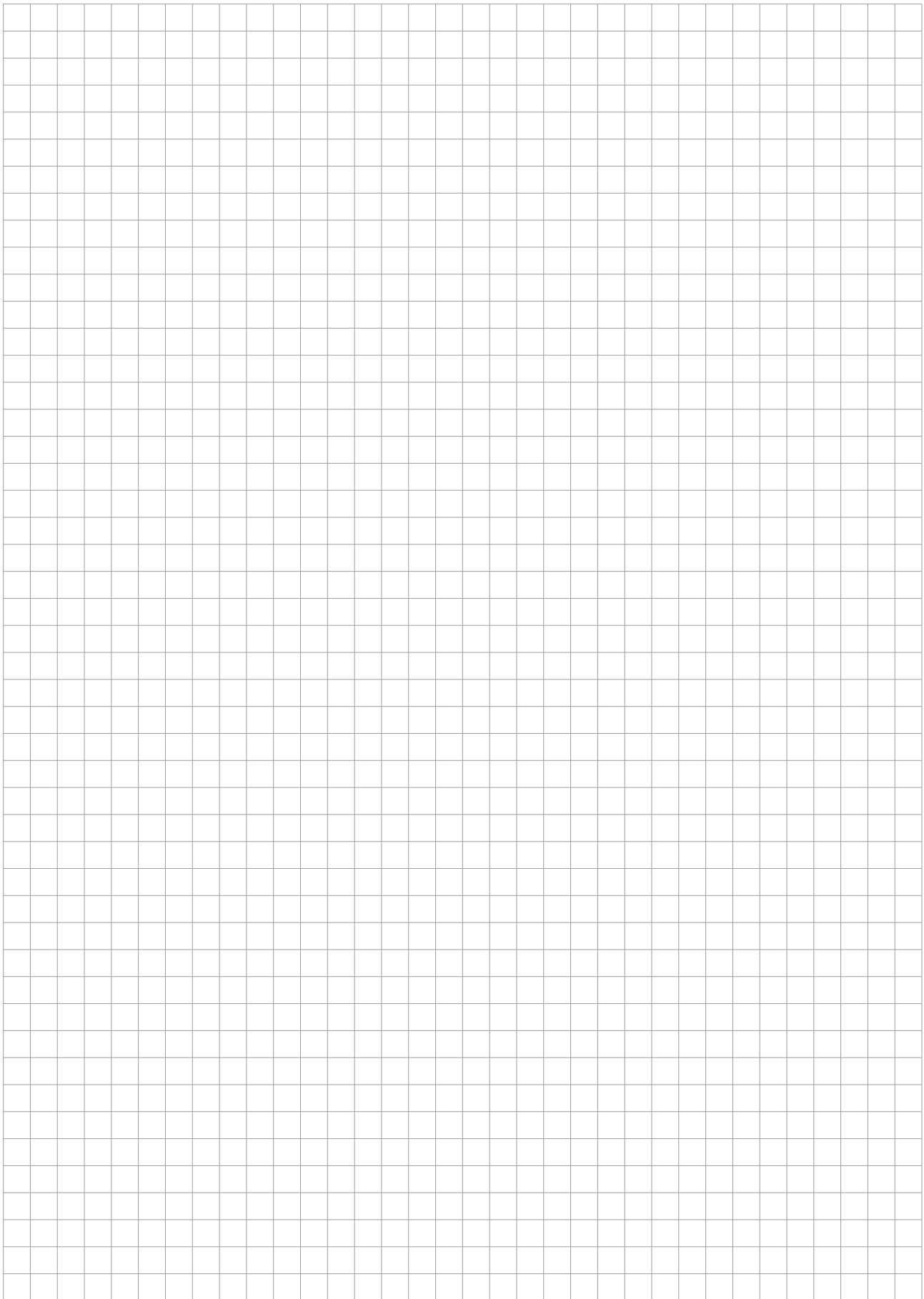


配合刀杆
for Toolholder

型号 H223
Type

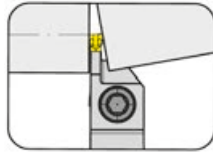
T

产品型号 Part number	w	r	h ₁	尺寸规格 Size		MG12	H54	Ti25	TN35	
S223.0200.32	2.0	0.2	3.65	01		▲	▲	▲	▲	
S223.0250.32	2.5	0.2	3.75	02		▲	▲	▲	▲	
S223.0300.32	3.0	0.2	3.95	03		▲	▲	▲	▲	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P	o	•	•	•
● 推荐 / recommended						M	•	•	•	•
○ 次推荐 / alternative recommendation						K	•	-	•	•
- 不合适 / not suitable						N	•	-	•	•
■ 非涂层 / uncoated grades						S	•	-	•	•
■ 涂层 / coated grades						H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet										
尺寸单位：mm Dimensions in mm						硬质合金牌号 Carbide grades				

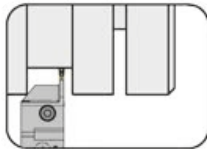


T

刀杆
Toolholder
H224

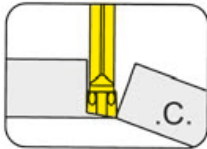


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T64-T71

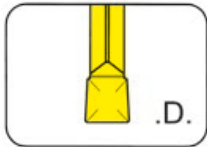


页/Page
T76

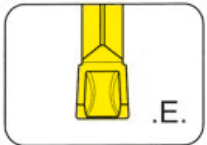
可转位刀片
Indexable insert
S224



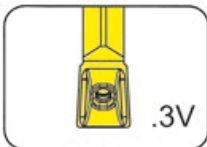
页/Page
T72-T73



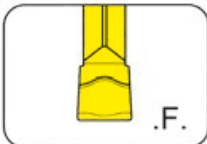
页/Page
T74



页/Page
T75



页/Page
T77



页/Page
T78

S224



T

机夹式刀杆

槽宽 2 - 3 mm

Toolholder with Inserts

Width of groove 2 - 3 mm

切槽和切断

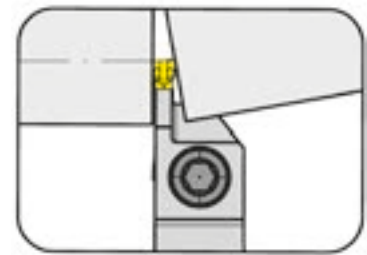
Grooving and Parting Off



刀杆

Toolholder

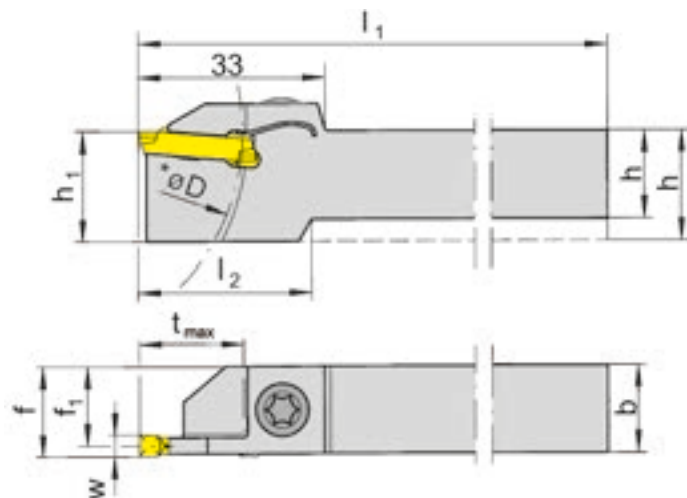
H224



槽深可达
夹持范围

Depth of groove up to
Clamping range

14 mm
2-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.01	16	16	125	25	20	15.3	$f_1 + w/2$	14	80	01	2.0-2.4
R/LH224.2020.01	20	20	125	-	20	19.3	$f_1 + w/2$	14	80	01	2.0-2.4
R/LH224.2525.01	25	25	150	-	25	24.3	$f_1 + w/2$	14	80	01	2.0-2.4
R/LH224.1616.02	16	16	125	25	20	15.1	$f_1 + w/2$	14	80	02	2.4-2.8
R/LH224.2020.02	20	20	125	-	20	19.1	$f_1 + w/2$	14	80	02	2.4-2.8
R/LH224.2525.02	25	25	150	-	25	24.1	$f_1 + w/2$	14	80	02	2.4-2.8
R/LH224.1616.03	16	16	125	25	20	14.9	$f_1 + w/2$	14	80	03	2.8-3.7
R/LH224.2020.03	20	20	125	-	20	18.9	$f_1 + w/2$	14	80	03	2.8-3.7
R/LH224.2525.03	25	25	150	-	25	23.9	$f_1 + w/2$	14	80	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

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

切槽和切断

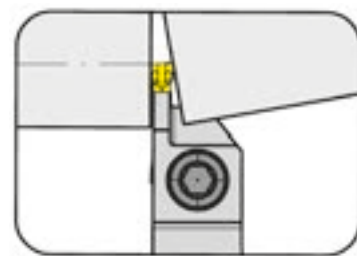
Grooving and Parting Off



刀杆

Toolholder

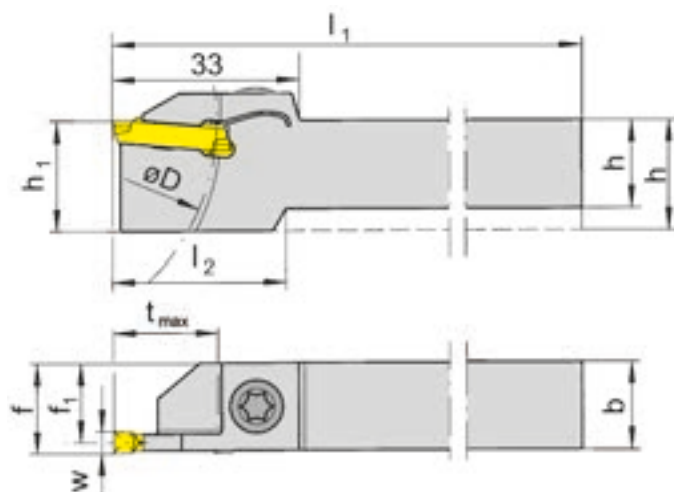
H224



槽深可达
夹持范围

Depth of groove up to
Clamping range

18 mm
2-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.1616.21	16	16	125	30	20	15.3	f ₁ +w/2	18	80	01	2.0-2.4
R/LH224.2020.21	20	20	125	-	20	19.3	f ₁ +w/2	18	80	01	2.0-2.4
R/LH224.2525.21	25	25	150	-	25	24.3	f ₁ +w/2	18	80	01	2.0-2.4
R/LH224.1616.22	16	16	125	30	20	15.1	f ₁ +w/2	18	80	02	2.4-2.8
R/LH224.2020.22	20	20	125	-	20	19.1	f ₁ +w/2	18	80	02	2.4-2.8
R/LH224.2525.22	25	25	150	-	25	24.1	f ₁ +w/2	18	80	02	2.4-2.8
R/LH224.1608.23	16	8	100	-	20	6.9	f ₁ +w/2	18	80	03	2.8-3.7
R/LH224.1616.23	16	16	125	30	20	14.9	f ₁ +w/2	18	80	03	2.8-3.7
R/LH224.2020.23	20	20	125	-	20	18.9	f ₁ +w/2	18	80	03	2.8-3.7
R/LH224.2525.23	25	25	150	-	25	23.9	f ₁ +w/2	18	80	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	6.23T25P	T25PQ
R/LH224.1608.23	4.15T15P	T15PQ

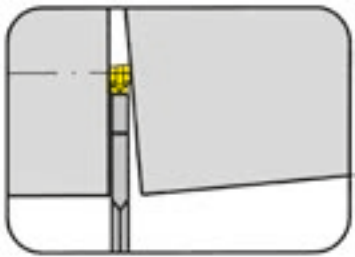
切槽和切断

Grooving and Parting Off



刀杆
Toolholder

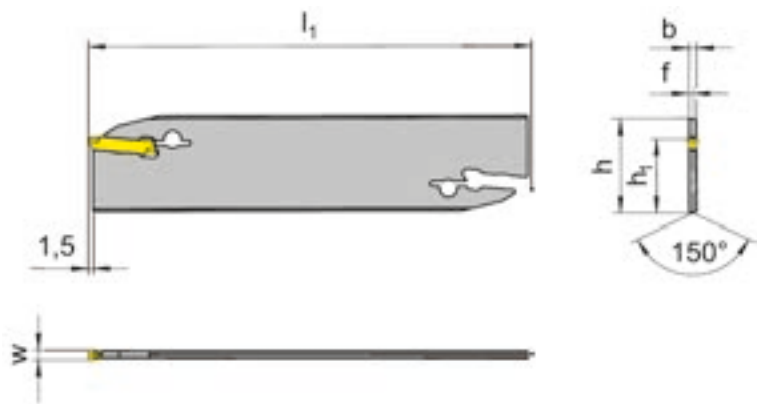
H224
自夹紧
with self clamping



槽深可达 夹持范围	Depth of groove up to Clamping range	18 mm 2-3.7 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



产品型号 Part number	h	b	l_1	h_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
H224.2602.02	26	1.9	110	21.4	0.95	18	02	2.4-2.8
H224.2603.03	26	2.3	110	21.4	1.15	18	03	2.8-3.7
H224.3203.03	32	2.3	150	24.8	1.15	18	03	2.8-3.7

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Note:
Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

切槽和切断

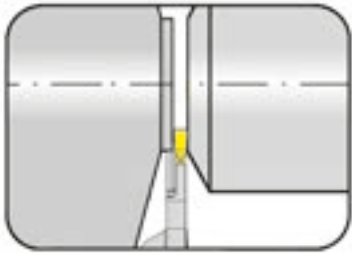
Grooving and Parting Off



刀杆

Toolholder

H224
加强型
reinforced version



槽深可达
槽宽

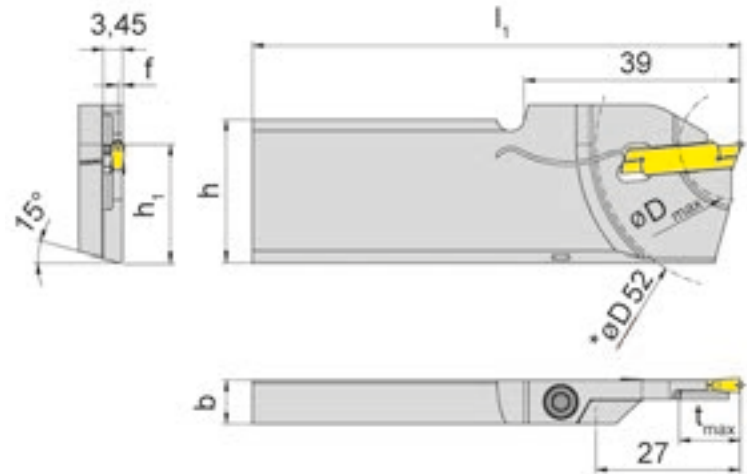
Depth of groove up to
Width of groove

11 mm
2-3 mm

用于机床：TRAUB (TNL18P)
for machines TRAUB (TNL18P)

配合可转位刀片
for Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
LH224.2608.20.T.81	26	7.9	88	21.4	0.7	11	20	01	2.0
LH224.2608.20.T.82	26	7.9	88	21.4	0.9	11	20	02	2.5
LH224.2608.20.T.83	26	7.9	88	21.4	1.1	11	20	03	3.0

按需提供更多尺寸
Further sizes upon request

*副主轴的D_{max}=D52
*D 52 = D_{max} of the subspindle

尺寸单位：mm
Dimensions in mm

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LH224...	4.15T15P	T15PQ

T

切槽和切断

Grooving and Parting Off

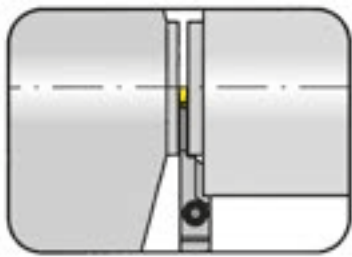


刀杆

Toolholder

H224

加强型
reinforced version

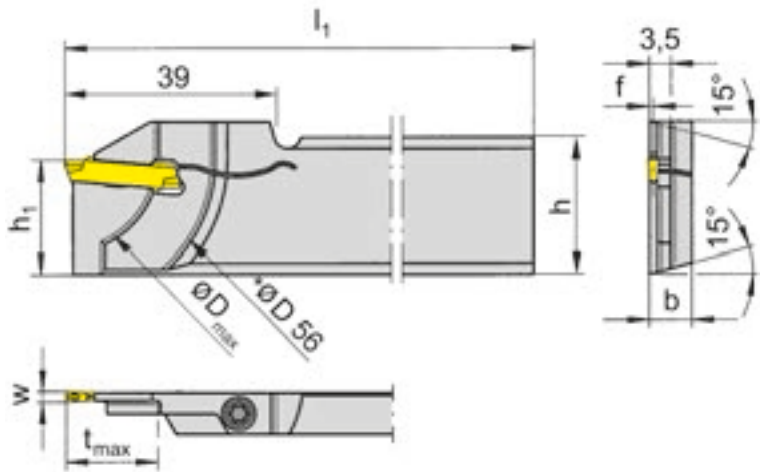


槽深可达 18 mm
夹持范围 2.4-3.7 mm

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

配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

*副主轴D_{max}=D56
*D 56 = D_{max} of the subspindle
按需提供更多尺寸

Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224.2608....	4.15T15P	T15PQ

切槽和切断

Grooving and Parting Off

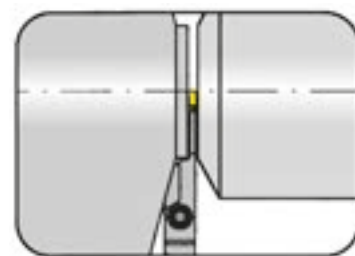


刀杆

Toolholder

H224

加强型
reinforced version

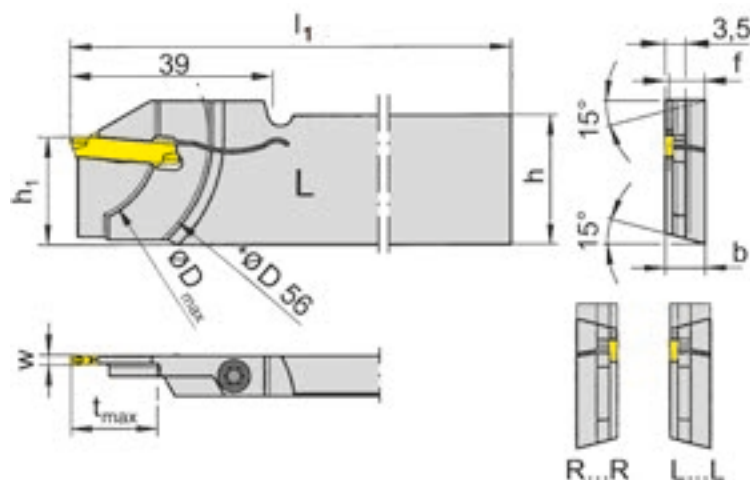


槽深可达
夹持范围

Depth of groove up to
Clamping range

21 mm
2-3.7 mm

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



配合可转位刀片
for Indexable insert

型号 S224
Type

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l_1	h_1	f	t_{max}	D_{max}	尺寸规格 Size	夹持范围 Clamping range
LH224.2608.81L	26	7.9	110	21.4	7.15	18	36	01	2.0-2.4
RH224.2608.81R	26	7.9	110	21.4	7.15	18	36	01	2.0-2.4
LH224.2608.82L	26	7.9	110	21.4	6.95	18	36	02	2.4-2.8
RH224.2608.82R	26	7.9	110	21.4	6.95	18	36	02	2.4-2.8
LH224.2608.83L	26	7.9	110	21.4	6.75	18	36	03	2.8-3.7
RH224.2608.83R	26	7.9	110	21.4	6.75	18	36	03	2.8-3.7
RH224.3208.83R	32	7.9	110	24.8	6.80	21	42	03	2.8-3.7

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

*副主轴 D_{max} =D56

* $D 56 = D_{max}$ of the subspindle

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

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

螺丝的扭矩规格, 详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位: mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	4.15T15P	T15PL
R/LH224.3208.83R/L	5.13 T20P	T20PQ

切槽和切断

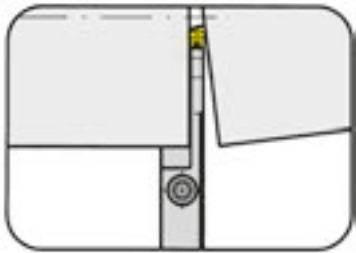
Grooving and Parting Off



刀杆
Toolholder

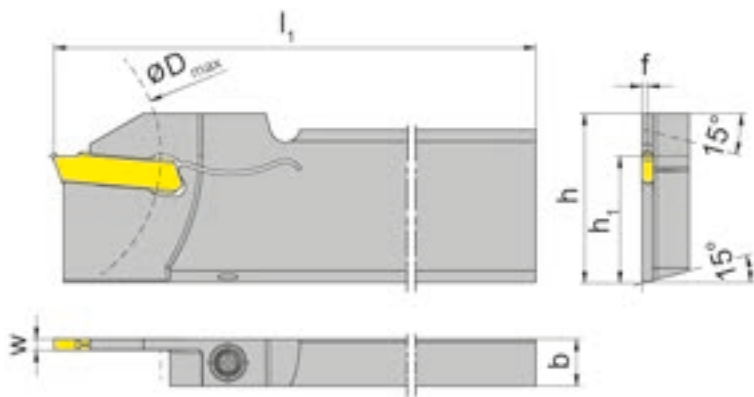
H224
加强型
reinforced version

槽深可达 夹持范围	Depth of groove up to Clamping range	18 mm 2-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

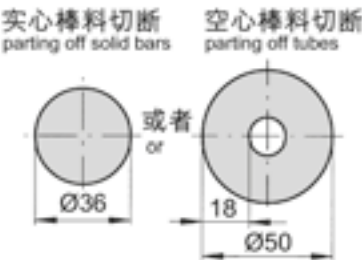
注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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



配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH224...	4.20T15P	T15PQ

切槽和切断

Grooving and Parting Off



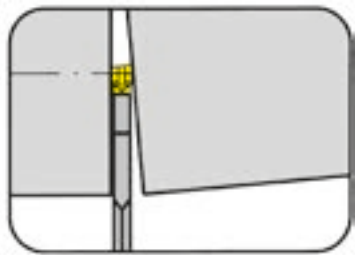
刀杆

Toolholder

H224

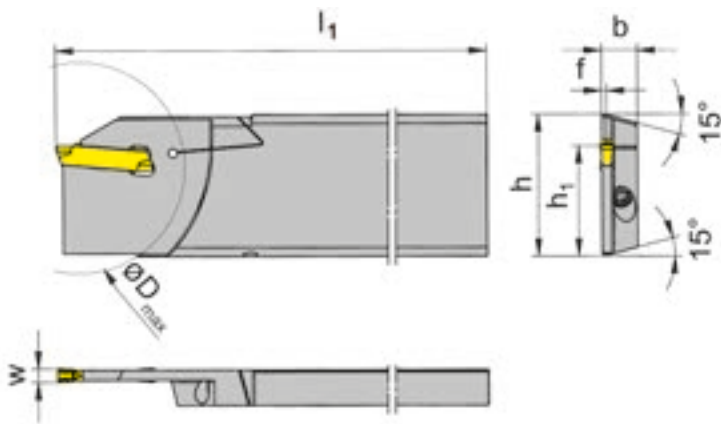
螺钉夹紧
with screwed clamping

槽深可达 夹持范围	Depth of groove up to Clamping range	32.5 mm 2.8-3.7 mm



配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	尺寸规格 Size	夹持范围 Clamping range
R/LH224.3208.93	32	8	112	24.8	1.15	32.5	65	03	2.8-3.7

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	紧固螺钉 Pin
R/LH224.3208.93	030.0413.T15P	T15PQ	020.0040.0999

T

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

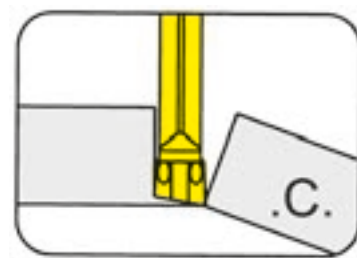
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



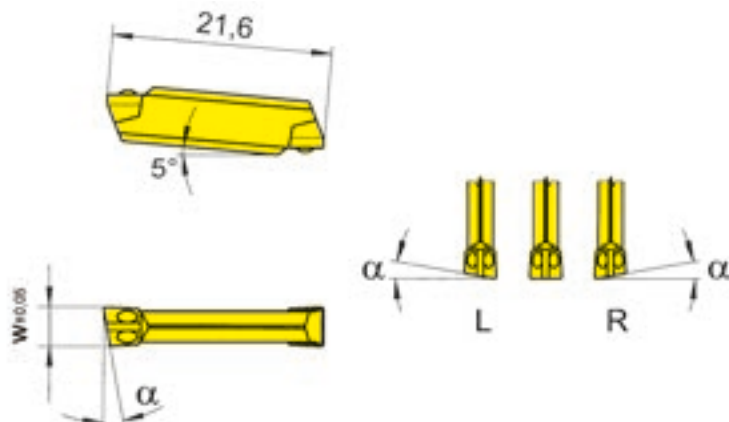
配合刀杆

for Toolholder

型号

H224

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	尺寸规格 Size	TC92	TF45	TI25	TN35
S224.0020.C0	2.0	0°	01	Δ	▲	▲	▲
R/LS224.0520.C0	2.0	5°	01	Δ/Δ	▲/▲	Δ/Δ	▲/▲
R/LS224.0820.C0	2.0	8°	01	Δ/Δ	▲/▲	Δ/Δ	▲/▲
R/L/S224.1520.C0	2.0	15°	01	Δ/Δ	▲/▲	x/x	▲/▲
S224.0025.C0	2.5	0°	02	Δ	▲	▲	▲
R/LS224.0525.C0	2.5	5°	02	Δ/Δ	▲/Δ	Δ/Δ	▲/Δ
R/L/S224.0825.C0	2.5	8°	02	Δ/Δ	▲/Δ	Δ/x	▲/▲
S224.0030.C0	3.0	0°	03	Δ	▲	▲	▲
R/LS224.0530.C0	3.0	5°	03	▲/Δ	▲/Δ	Δ/Δ	▲/▲
R/L/S224.0830.C0	3.0	8°	03	Δ/Δ	▲/▲	x/x	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

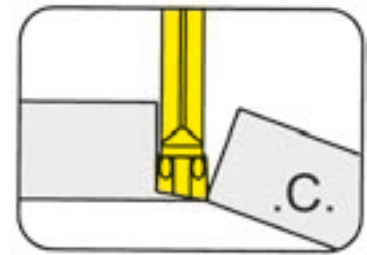
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



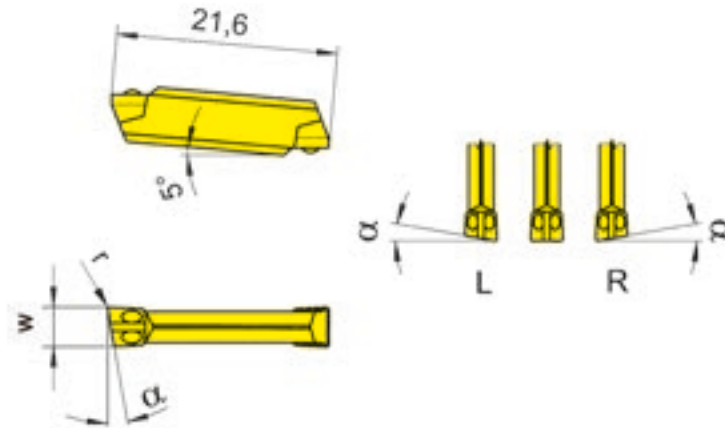
配合刀杆

for Toolholder

型号

H224

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	TC92	TF45	TI25	TN35
S224.0020.C1	2.0	0.15	0°	01	▲	▲	▲	▲
R/LS224.0520.C1	2.0	0.15	5°	01	△△	▲/▲		▲/▲
R/LS224.0820.C1	2.0	0.15	8°	01	△△	▲/▲		△△
R/LS224.1520.C1	2.0	0.15	15°	01	△△	▲/▲		▲/▲
S224.0025.C1	2.5	0.15	0°	02	△	▲	▲	▲
R/LS224.0525.C1	2.5	0.15	5°	02	△△	▲/▲		△△
R/LS224.0825.C1	2.5	0.15	8°	02	△△	▲/▲		△△
S224.0030.C1	3.0	0.15	0°	03	△	▲	▲	▲
R/LS224.0530.C1	3.0	0.15	5°	03	△△	▲/▲		▲/▲
R/LS224.0830.C1	3.0	0.15	8°	03	△△	▲/▲		▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号

Carbide grades

T

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip forming

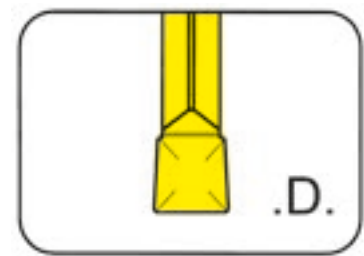
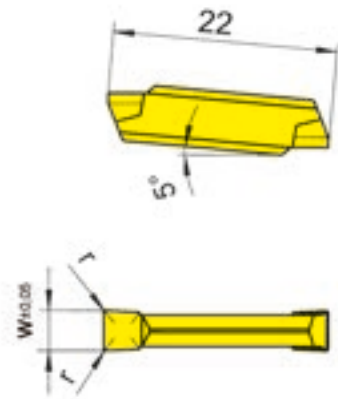
槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 H224

Type

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size	H54	TF45	TF46	T125	TN32	TN35
S224.0200.D2	2.0	0.2	01	▲	▲	▲	▲	▲	▲
S224.0250.D2	2.5	0.2	02	△	▲	▲	▲	▲	▲
S224.0300.D2	3.0	0.2	03	▲	▲	▲	▲	▲	▲
				P	•	•	•	•	•
				M	•	•	○	•	•
				K	-	•	•	-	•
				N	-	•	•	-	•
				S	-	•	○	-	•
				H	-	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S224

带卷屑器
with chip former

槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

精密烧结

precision sintered



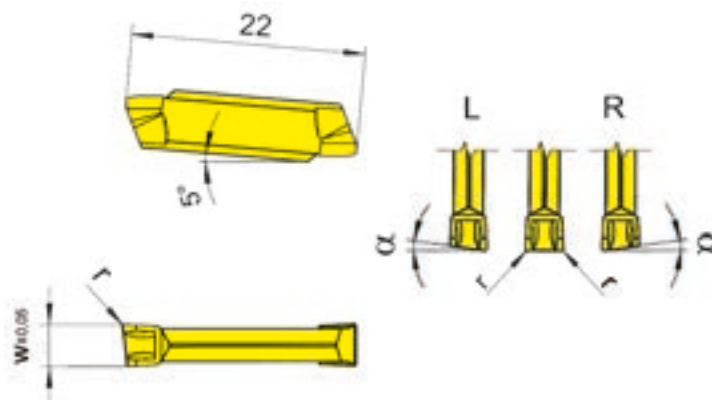
配合刀杆

for Toolholder

型号

H224

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	AL96	AS62	TA43	TC92	TC93	TF43	TF45	TI22	TI25	TN32	TN35
S224.0200.E2	2.0	0.2	0°	01		▲		Δ	Δ	▲	▲				
R/LS224.0520.E2	2.0	0.2	5°	01		▲/▲		Δ/Δ	Δ/Δ	Δ/Δ	x/Δ				
S224.0250.E2	2.5	0.2	0°	02		▲		Δ	Δ	▲	▲				
R/LS224.0525.E2	2.5	0.2	5°	02		▲/Δ		Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ				
S224.0300.E2	3.0	0.2	0°	03	Δ	▲	Δ	Δ	Δ	▲	▲	▲	Δ	Δ	Δ
S224.0300.E4	3.0	0.4	-	03	Δ	▲		Δ	Δ	Δ	▲		Δ	Δ	Δ
R/LS224.0530.E2	3.0	0.2	5°	03		▲/▲		Δ/Δ	Δ/Δ	Δ/Δ	▲/▲				
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	-	-	-	●	-	●	-	●
○ 次推荐 / alternative recommendation					K	●	-	-	-	-	●	-	●	-	●
- 不合适 / not suitable					N	●	-	-	-	-	●	-	●	-	●
■ 非涂层 / uncoated grades					S	-	-	-	-	-	●	-	●	-	●
■ 涂层 / coated grades					H	-	-	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet															

尺寸单位：mm

Dimensions in mm

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

T

切槽和切断

Grooving and Parting Off

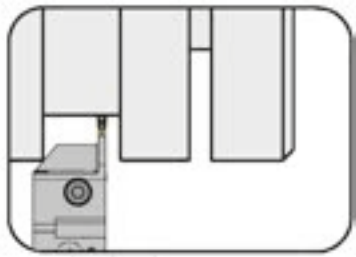


刀杆

Toolholder

H224

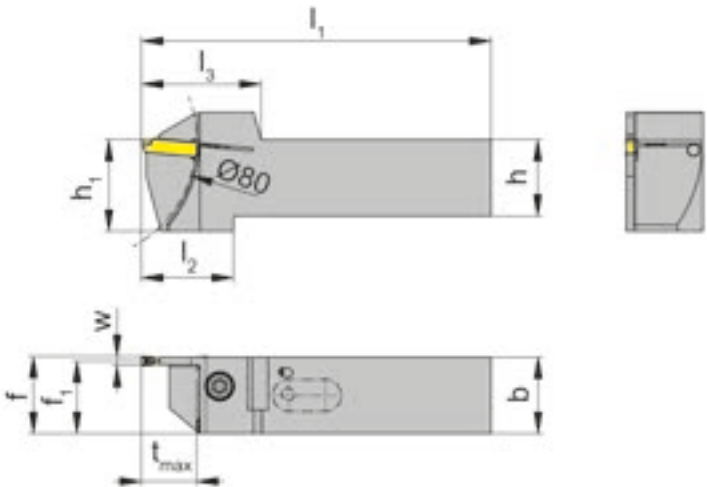
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
3 mm



配合可转位刀片
for Indexable insert

型号 S224...IK
Type

冷却液供应通过刀片
Coolant supply through insert

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	尺寸规格 Size
R/LH224.1616.3.23.IK	16	16	87	33	39	25	14.75	f ₁ +w/2	18	03
R/LH224.2020.3.23.IK	20	20	99	30	39	25	18.75	f ₁ +w/2	18	03
R/LH224.2525.3.23.IK	25	25	114	30	39	30	23.75	f ₁ +w/2	18	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/IH224...	6.23T25P	T25PQ

切槽和切断

Grooving and Parting Off



可转位刀片

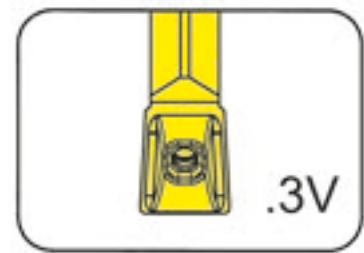
Indexable insert

S224
带卷屑器
with chip former

槽宽

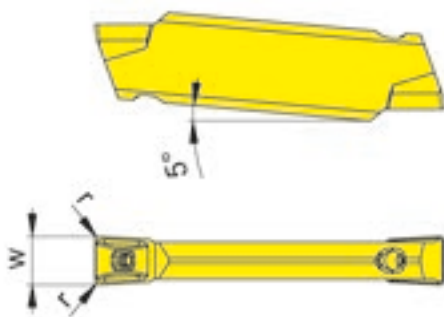
Width of groove

3 mm



配合刀杆
for Toolholder

型号 H224...IK
Type



冷却液供应通过刀片
Coolant supply through insert

T

产品型号 Part number	w	r	尺寸规格 Size	HP65	IG35
S224.0300.3V2.IK	3	0.2	03	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	•
● 推荐 / recommended				M	•
o 次推荐 / alternative recommendation				K	•
- 不合适 / not suitable				N	o
非涂层 / uncoated grades				S	•
涂层 / coated grades				H	-
钎焊/金属陶瓷 / brazed/Cermet					

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

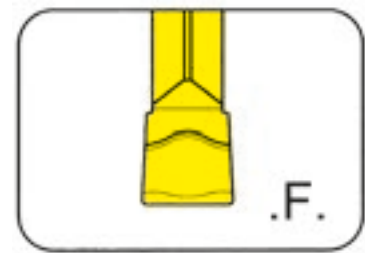
S224

带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

18 mm
2-3 mm

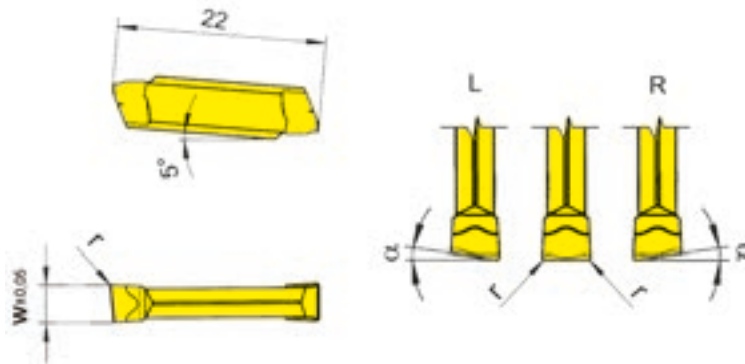


配合刀杆

for Toolholder

型号 H224

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	AL96	TA43	TF42	TF43	TF45	TF46	Ti22	Ti25	TN32
S224.0200.F2	2.0	0.2	0°	01	Δ		Δ	▲	▲	▲	▲	▲	Δ
R/LS224.0520.F2	2.0	0.2	5°	01					▲/▲	▲/Δ			
S224.0250.F2	2.5	0.2	0°	02	Δ		Δ	Δ	▲	▲	Δ	Δ	Δ
R/LS224.0525.F2	2.5	0.2	5°	02				▲/Δ	▲/▲				
S224.0300.F2	3.0	0.2	0°	03	Δ	Δ		▲	▲	▲	Δ	▲	Δ
R/LS224.0530.F2	3.0	0.2	5°	03				▲/Δ	▲/▲		Δ/Δ		
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	-	●	○	-	●	-
○ 次推荐 / alternative recommendation					K	●	-	-	-	●	-	●	-
- 不合适 / not suitable					N	●	-	-	-	●	-	●	-
非涂层 / uncoated grades					S	-	-	-	●	○	-	●	-
涂层 / coated grades					H	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm

Dimensions in mm

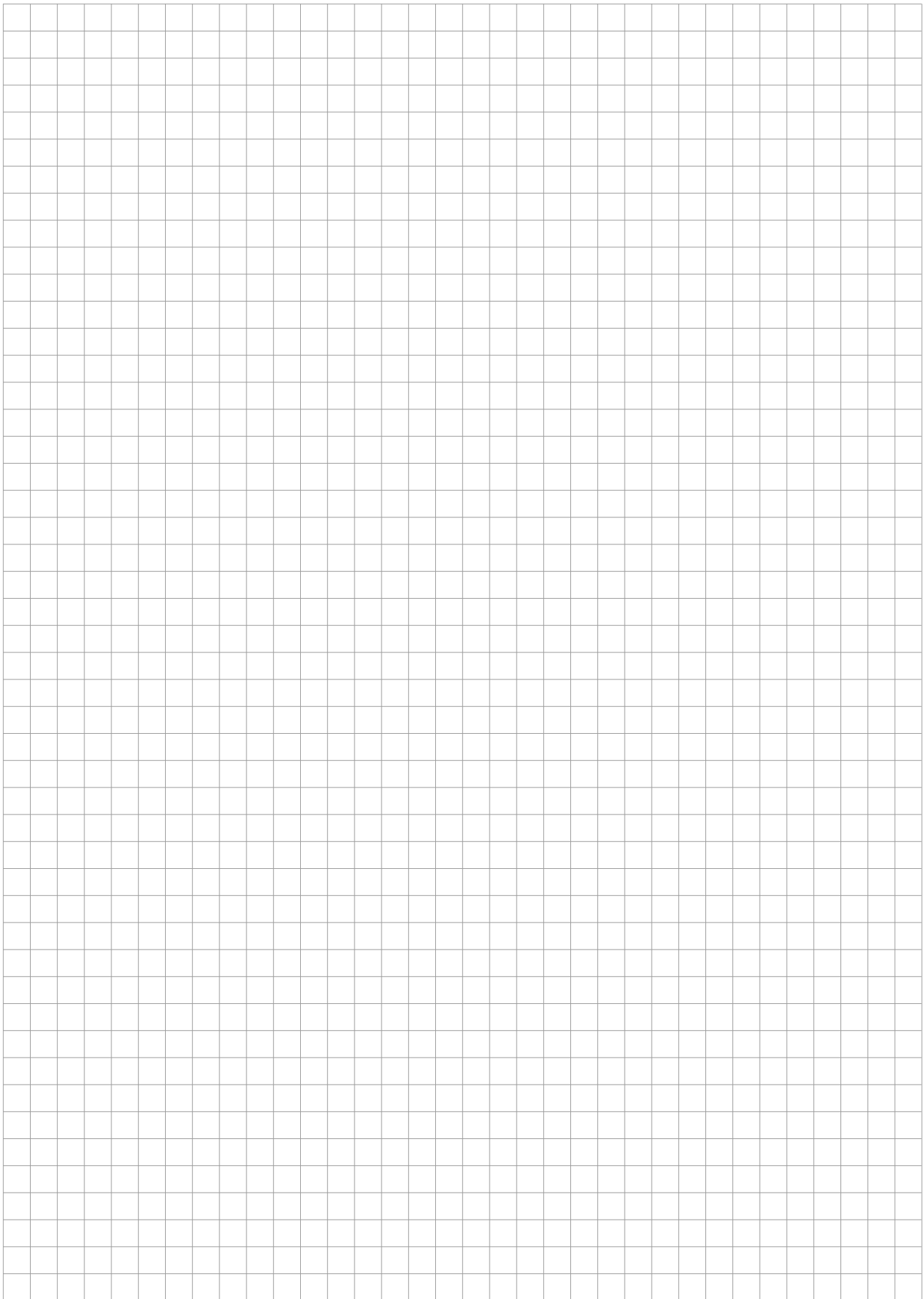
注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号
Carbide grades



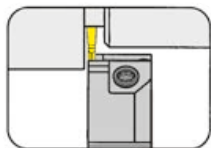
T

切槽和切断

Grooving and Parting Off

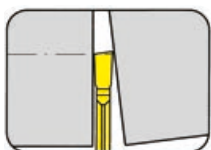


刀杆
Toolholder
H264



页/Page
T82-T85

可转位刀片
Indexable insert
264



页/Page
T86-T87

T

264



T

机夹式刀杆

槽宽 1.5 - 3 mm

Toolholder with Inserts

Width of groove 1.5 - 3 mm

切槽和切断

Grooving and Parting Off

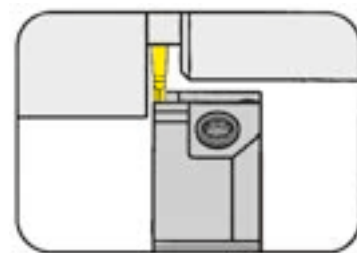


刀杆

Toolholder

H264

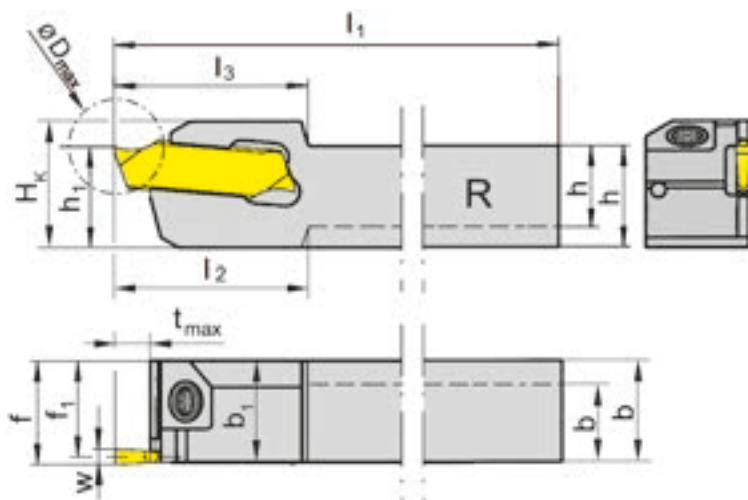
螺钉夹紧
with screwed clamping



槽深可达
槽宽

Depth of groove up to
Width of groove

16 mm
1.5-2 mm



配合可转位刀片
for Indexable insert

型号 264
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

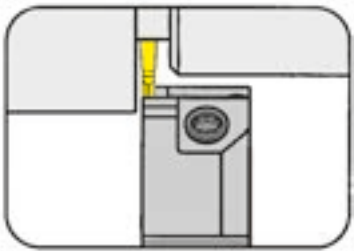
H264

螺钉夹紧
with screwed clamping

槽深可达
槽宽

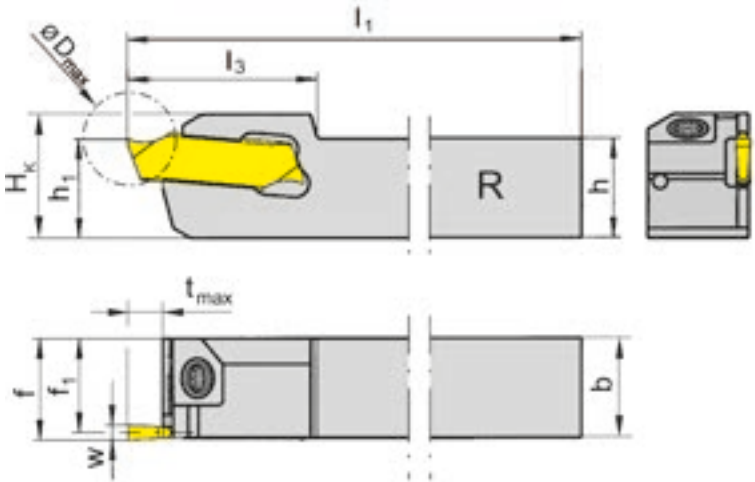
Depth of groove up to
Width of groove

16 mm
2.5 mm



配合可转位刀片
for Indexable insert

型号 264
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_3	h_1	f_1	f	t_{max}	D_{max}	H_k	尺寸规格 Size
R/LH264.1212.03	12	12	120	17.5	12	10.75	12	4	32	14.5	03
R/LH264.1616.03	16	16	120	17.5	16	14.75	16	4	32	18.5	03
R/LH264.1212.13	12	12	120	19.0	12	10.75	12	10	32	14.5	03
R/LH264.1616.13	16	16	120	19.0	16	14.75	16	10	32	18.5	03
R/LH264.1212.23	12	12	120	25.0	12	10.75	12	16	32	14.5	03
R/LH264.1616.23	16	16	120	25.0	16	14.75	16	16	32	18.5	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off

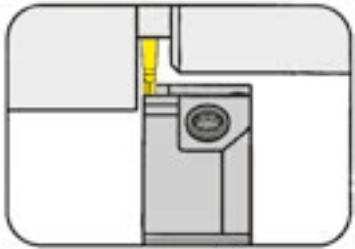


刀杆

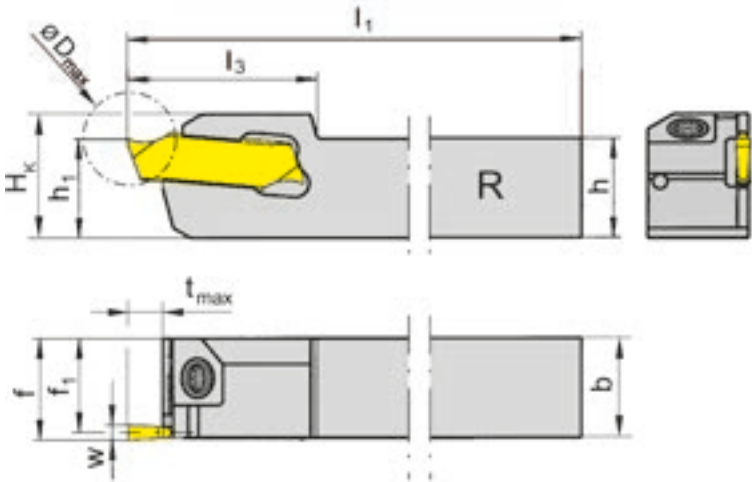
Toolholder

H264

螺钉夹紧
with screwed clamping



槽深可达	Depth of groove up to	16 mm
槽宽	Width of groove	3 mm



配合可转位刀片
for Indexable insert

型号 264
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH264.1212.04	12	12	120	17.5	12	10.5	12	5	32	15	04
R/LH264.1616.04	16	16	120	17.5	16	14.5	16	5	32	19	04
R/LH264.1212.14	12	12	120	19.0	12	10.5	12	10	32	15	04
R/LH264.1616.14	16	16	120	19.0	16	14.5	16	10	32	19	04
R/LH264.1212.24	12	12	120	25.0	12	10.5	12	16	32	15	04
R/LH264.1616.24	16	16	120	25.0	16	14.5	16	16	32	19	04

注明R或L型
State R or L version
 按需提供更多尺寸
Further sizes upon request
 螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH264...	3.5.12T10EP	T10PL

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

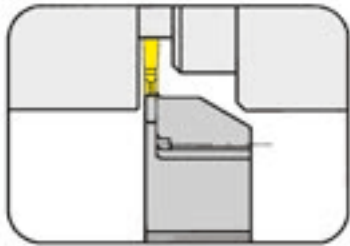
H264

自夹紧
with self clamping

槽深可达
槽宽

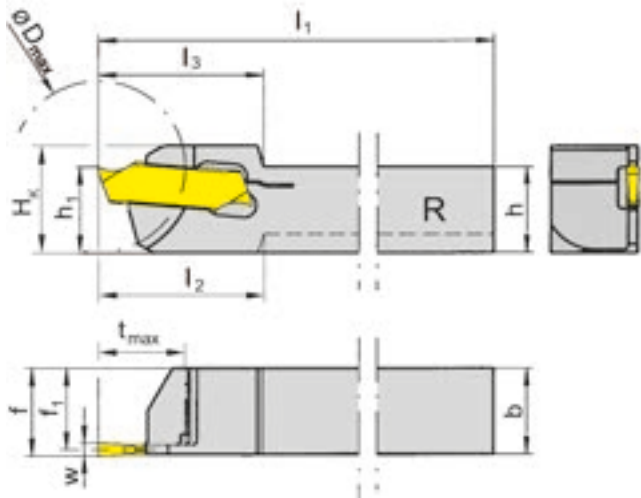
Depth of groove up to
Width of groove

10 mm
1.5-3 mm



配合可转位刀片
for Indexable insert

型号 264
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	t _{max}	D _{max}	H _k	尺寸规格 Size
R/LH264.0808.51	8	8	120	18	18	10	7.25	8	7	20	12.5	01
R/LH264.1010.61	10	10	120	-	19	10	9.25	10	10	20	12.5	01
R/LH264.1010.62	10	10	120	-	19	10	9.00	10	10	20	12.5	02
R/LH264.1212.62	12	12	120	-	19	12	11.00	12	10	20	14.5	02
R/LH264.1212.63	12	12	120	-	19	12	10.75	12	10	32	14.5	03
R/LH264.1212.64	12	12	120	-	19	12	10.50	12	10	32	14.5	04

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

注意事项：
扳手P39L不包含在刀板中R/LH100...33，需单独订购！

Note:
Wrench P39L ist not combined with blade R/LH100...33 - separate order required!

T

切断

Parting Off



可转位刀片

Indexable insert

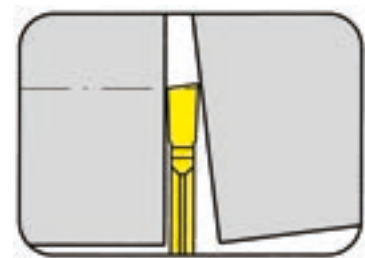
264

槽深可达
槽宽

Depth of groove up to
Width of groove

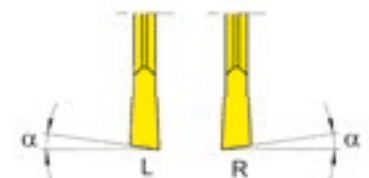
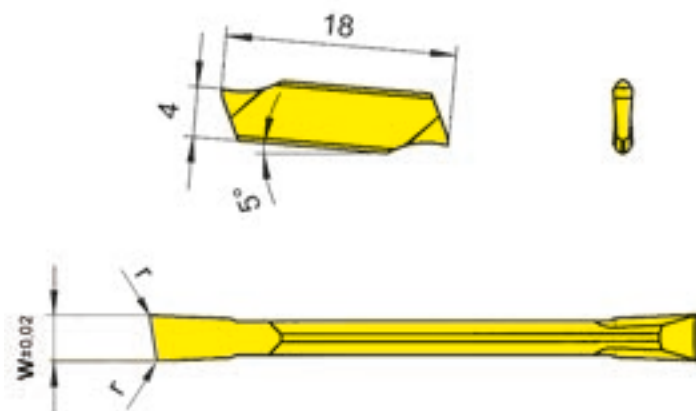
16 mm
1.5-3 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H264
Type



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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	TH35	T125	TN35
R/L264.0815.10	1.5	0.05	8°	01	▲/△	△/△	△/△	▲/▲
R/L264.1515.10	1.5	0.05	15°	01	▲/△	△/△		▲/▲
R/L264.0820.10	2.0	0.05	8°	02	▲/△	△/△		▲/▲
R/L264.1520.10	2.0	0.05	15°	02	▲/△	△/△		▲/▲
R/L264.0825.10	2.5	0.10	8°	03	△/△	△/△		▲/△
R/L264.1525.10	2.5	0.10	15°	03	△/△	△/△		▲/△
R/L264.0830.10	3.0	0.10	8°	04	△/△	△/△		△/△
R/L264.1530.10	3.0	0.10	15°	04	△/△	△/△		▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

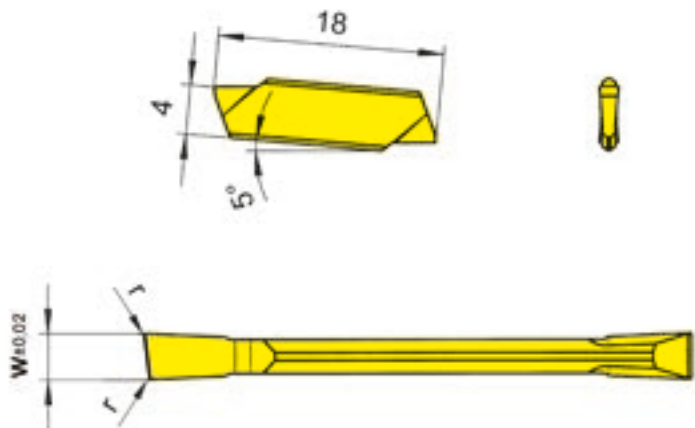
264

槽深可达
槽宽

Depth of groove up to
Width of groove

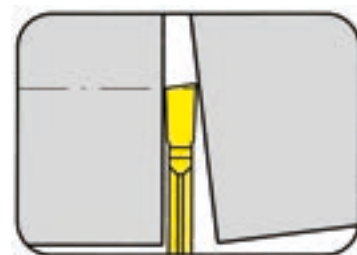
16 mm
1.5-3 mm

精密磨削
precision ground



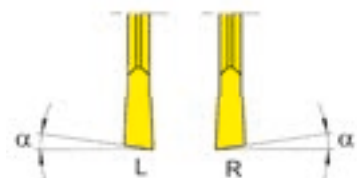
R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



配合刀杆
for Toolholder

型号 H264
Type



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

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	TH35	TN35
R/L264.0815.M0	1.5	0.05	8°	01	Δ/▲	Δ/Δ	▲/▲
R/L264.1515.M0	1.5	0.05	15°	01	▲/▲	Δ/Δ	▲/Δ
R/L264.0820.M0	2.0	0.05	8°	02	Δ/Δ	Δ/Δ	▲/Δ
R/L264.1520.M0	2.0	0.05	15°	02	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.0825.M0	2.5	0.10	8°	03	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.1525.M0	2.5	0.10	15°	03	Δ/Δ	Δ/x	▲/Δ
R/L264.0830.M0	3.0	0.10	8°	04	Δ/Δ	Δ/Δ	Δ/Δ
R/L264.1530.M0	3.0	0.10	15°	04	Δ/Δ	Δ/Δ	▲/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

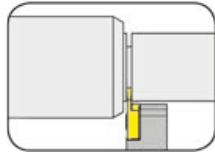
Indexable inserts can be used in right and left hand toolholders.

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

硬质合金牌号
Carbide grades

T

刀杆
Toolholder
H274/H274...E



页/Page
T90. T97

可转位刀片
Indexable insert
S274/S274...E



页/Page
T91-T96, T98-T103

274



T

机夹式刀杆

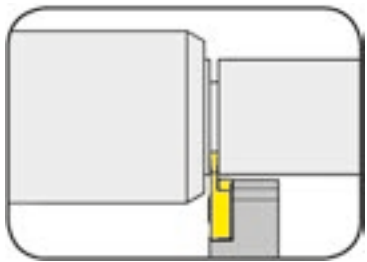
槽宽0.5 - 3 mm

Toolholder with Inserts

Width of groove 0.5 - 3 mm

刀杆
Toolholder

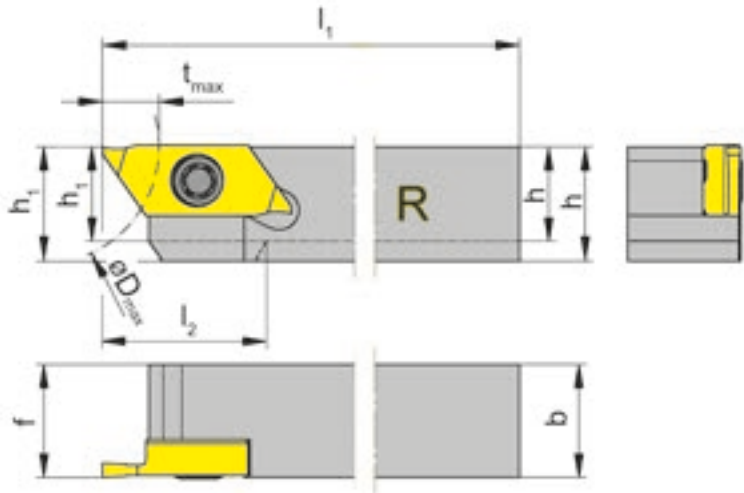
H274



槽深 槽宽	Depth of groove Width of groove	6 mm 0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH274.0808.04	030.350P.0744	T15PQ
R/LH274...	030.3509.T15P	T15PQ

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

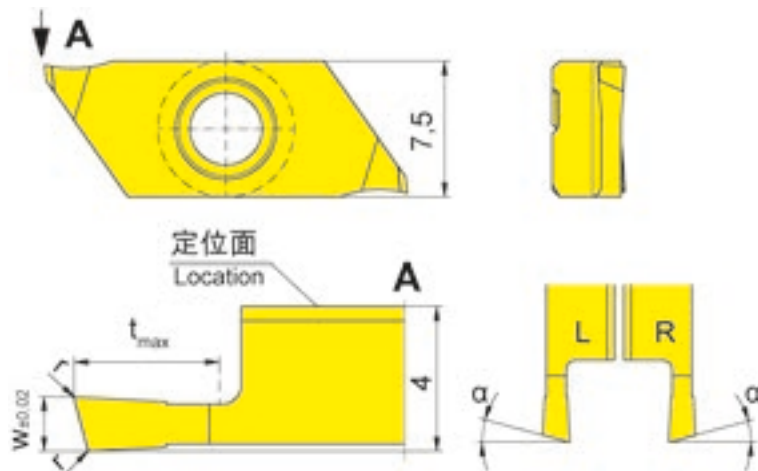
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

T

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.10	0.8	0.05	3	15°	04	▲/▲	▲/▲
R/LS274.1510.03.10	1.0	0.05	3	15°	04	▲/▲	▲/▲
R/LS274.1515.04.10	1.5	0.05	4	15°	04	▲/▲	▲/▲
R/LS274.1520.06.10	2.0	0.05	6	15°	04	▲/▲	▲/▲
						P	•
						M	•
						K	•
						N	•
						S	•
						H	-

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

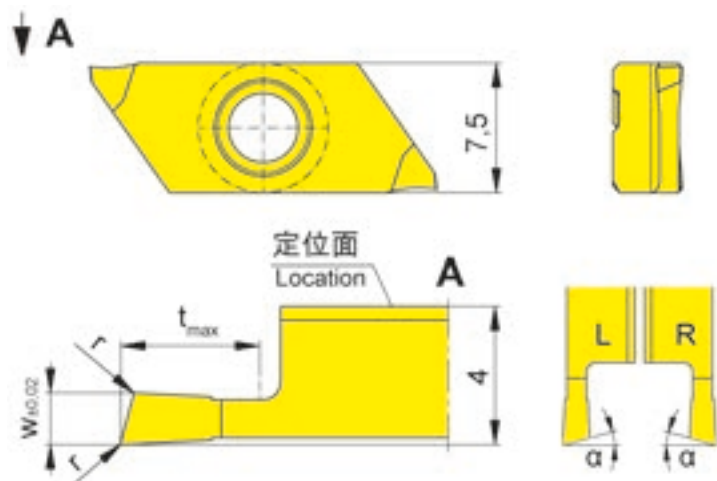
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
LS274.1508.03.10R	0.8	0.05	3	15°	04	▲	▲
LS274.1510.03.10R	1.0	0.05	3	15°	04	▲	▲
LS274.1515.04.10R	1.5	0.05	4	15°	04	▲	▲
LS274.1520.06.10R	2.0	0.05	6	15°	04	▲	▲
RS274.1508.03.10L	0.8	0.05	3	15°	04	△	△
RS274.1510.03.10L	1.0	0.05	3	15°	04	△	△
RS274.1515.04.10L	1.5	0.05	4	15°	04	△	△
RS274.1520.06.10L	2.0	0.05	6	15°	04	△	△

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

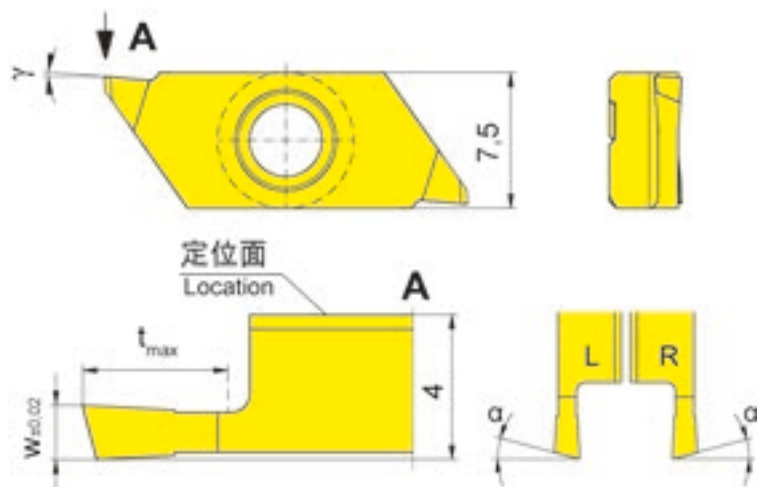
Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1515.04.20	1.5	4	15°	5°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.20	2.0	6	15°	5°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274

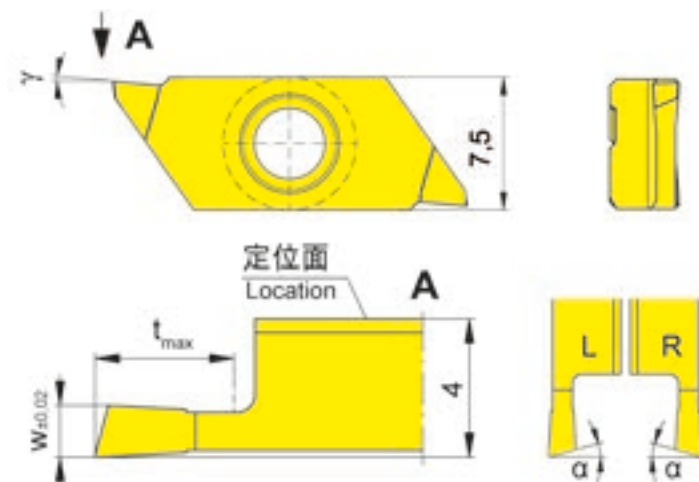


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274
Type

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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1515.04.20R	1.5	4	15°	5°	04	Δ	Δ
LS274.1520.06.20R	2.0	6	15°	5°	04	Δ	Δ
RS274.1515.04.20L	1.5	4	15°	5°	04	Δ	Δ
RS274.1520.06.20L	2.0	6	15°	5°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

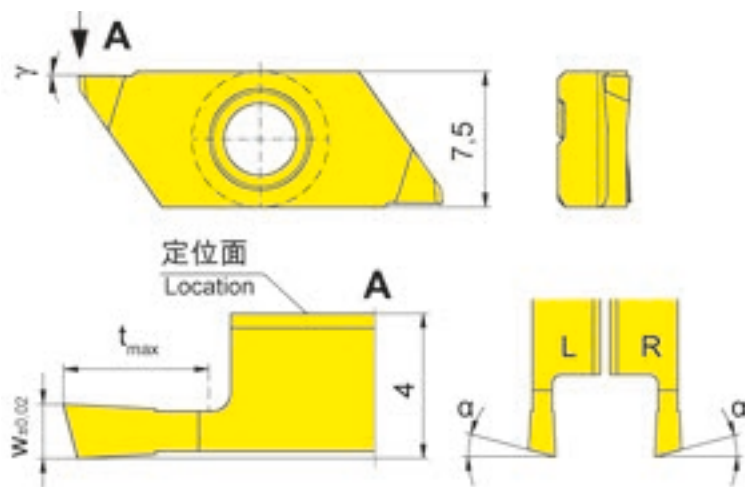
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.M0	0.8	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.M0	1.0	3	15°	0°	04	Δ/Δ	▲/Δ
R/LS274.1515.04.M0	1.5	4	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.M0	2.0	6	15°	0°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

	P	M	K	N	S	H
IG35	-	•	•	-	•	-
TH35	•	•	•	•	•	-

硬质合金牌号
Carbide grades

T

切断

Parting Off



可转位刀片

Indexable insert

S274



槽深可达
槽宽

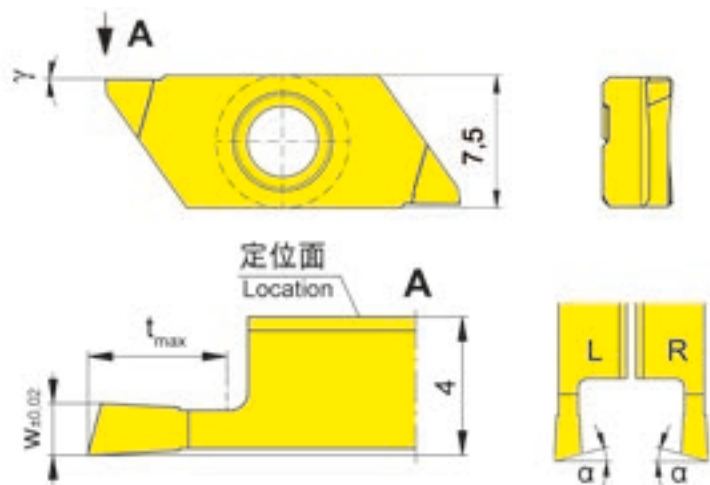
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1508.03.M0R	0.8	3	15°	0°	04	Δ	▲
LS274.1510.03.M0R	1.0	3	15°	0°	04	Δ	Δ
LS274.1515.04.M0R	1.5	4	15°	0°	04	Δ	Δ
LS274.1520.06.M0R	2.0	6	15°	0°	04	Δ	Δ
RS274.1508.03.M0L	0.8	3	15°	0°	04	Δ	Δ
RS274.1510.03.M0L	1.0	3	15°	0°	04	Δ	Δ
RS274.1515.04.M0L	1.5	4	15°	0°	04	Δ	Δ
RS274.1520.06.M0L	2.0	6	15°	0°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

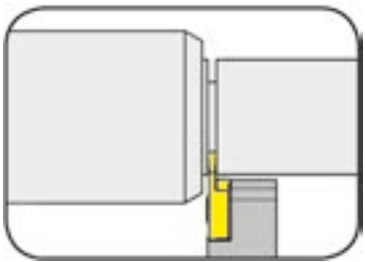
t_{max} 6 mm can be reached only with workpiece $\varnothing \leq 25\text{ mm}$.

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

刀杆
Toolholder

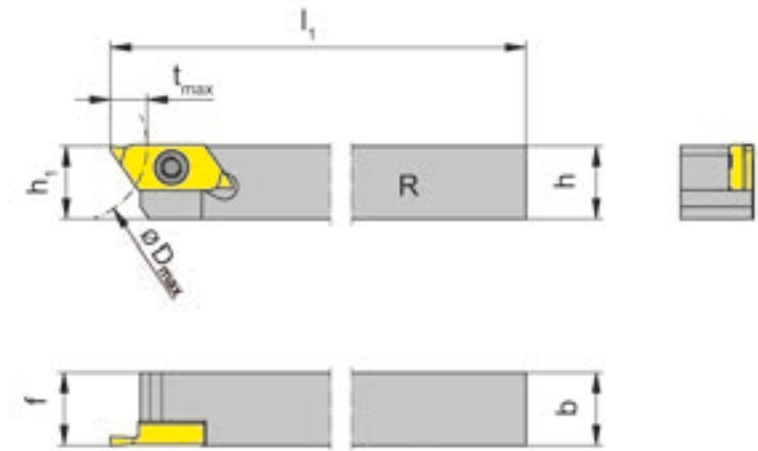
H274...E



槽深 槽宽	Depth of groove Width of groove	6 mm 0.5-3 mm

配合可转位刀片
for Indexable insert

型号 S274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件
Spare Parts

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

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

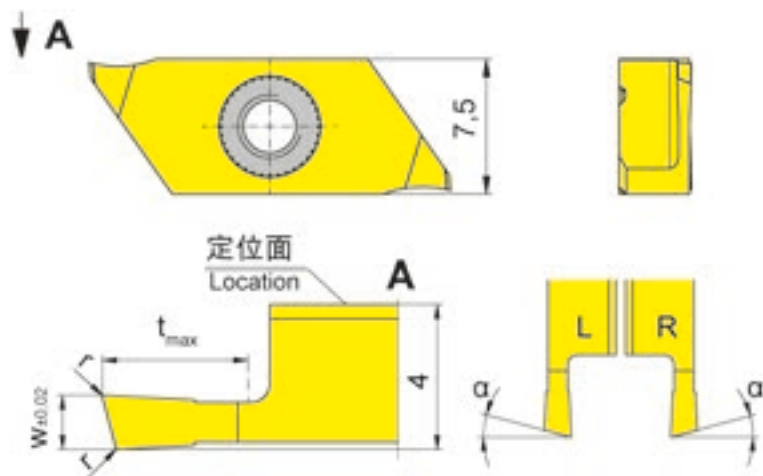
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.10.E	0.8	0.05	3	15°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.10.E	1.0	0.05	3	15°	04	Δ/Δ	Δ/Δ
R/LS274.1515.04.10.E	1.5	0.05	4	15°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.10.E	2.0	0.05	6	15°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...E

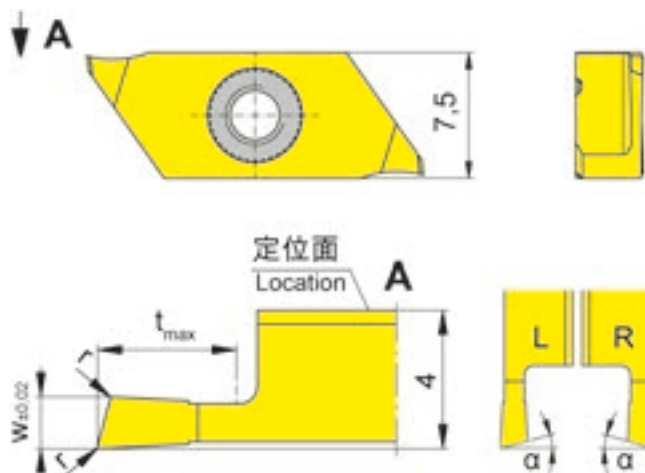


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground



配合刀杆
for Toolholder

型号 H274...E
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	r	t _{max}	α	尺寸规格 Size	IG35	TH35
LS274.1508.03.1R.E	0.8	0.05	3	15°	04	Δ	Δ
LS274.1510.03.1R.E	1.0	0.05	3	15°	04	Δ	Δ
LS274.1515.04.1R.E	1.5	0.05	4	15°	04	Δ	Δ
LS274.1520.06.1R.E	2.0	0.05	6	15°	04	Δ	Δ
RS274.1508.03.1L.E	0.8	0.05	3	15°	04	Δ	Δ
RS274.1510.03.1L.E	1.0	0.05	3	15°	04	Δ	Δ
RS274.1515.04.1L.E	1.5	0.05	4	15°	04	Δ	Δ
RS274.1520.06.1L.E	2.0	0.05	6	15°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

T

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

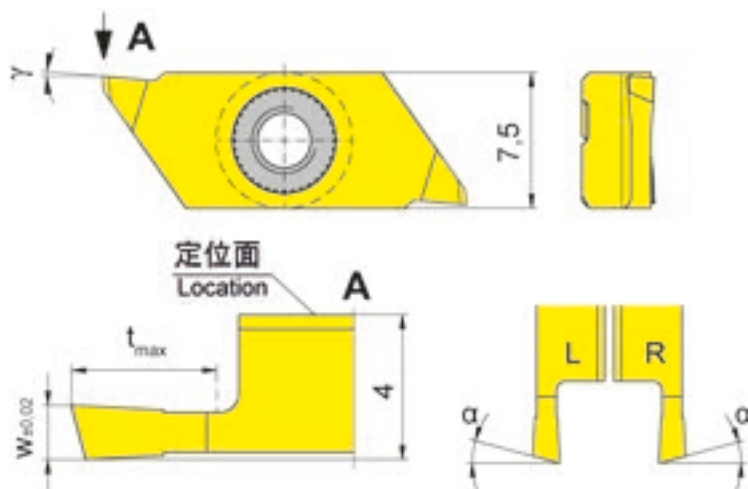
Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1515.04.20.E	1.5	4	15°	5°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.20.E	2.0	6	15°	5°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...E

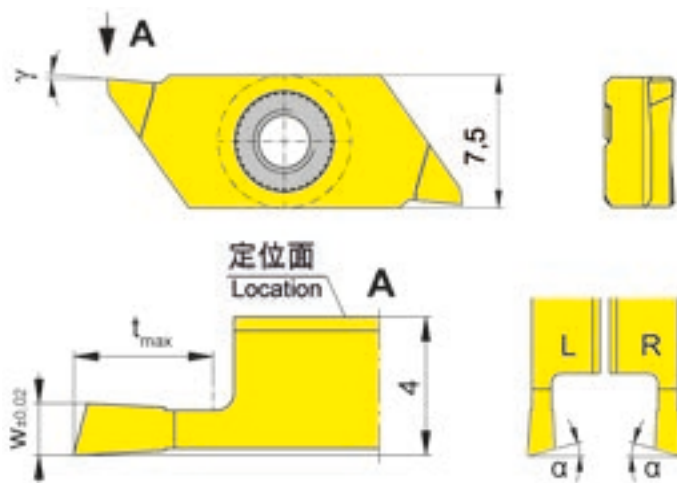


槽深可达
槽宽

Depth of groove up to
Width of groove

6 mm
1.5-2 mm

精密磨削
precision ground



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

配合刀杆
for Toolholder

型号 H274...E
Type

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1515.04.2R.E	1.5	4	15°	5°	04	Δ	Δ
LS274.1520.06.2R.E	2.0	6	15°	5°	04	Δ	Δ
RS274.1515.04.2L.E	1.5	4	15°	5°	04	Δ	Δ
RS274.1520.06.2L.E	2.0	6	15°	5°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

T

切断 Parting Off



可转位刀片 Indexable insert

S274...E



槽深可达
槽宽

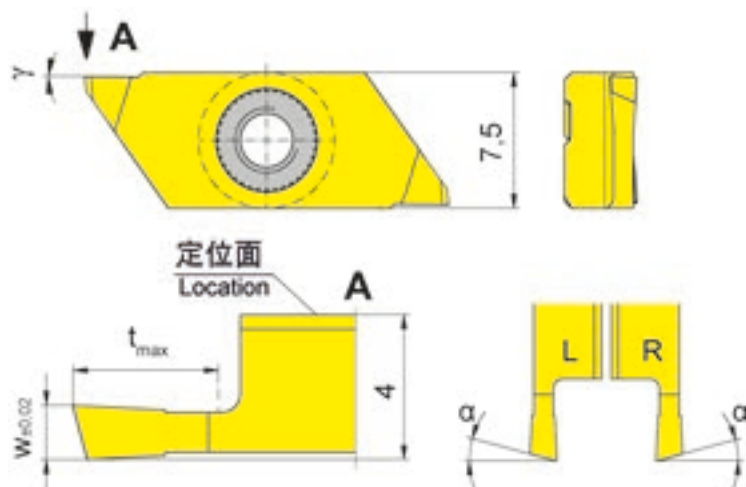
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
R/LS274.1508.03.M0.E	0.8	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1510.03.M0.E	1.0	3	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1515.04.M0.E	1.5	4	15°	0°	04	Δ/Δ	Δ/Δ
R/LS274.1520.06.M0.E	2.0	6	15°	0°	04	Δ/Δ	Δ/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

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

P	-	•
M	•	•
K	-	•
N	-	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S274...E



槽深可达
槽宽

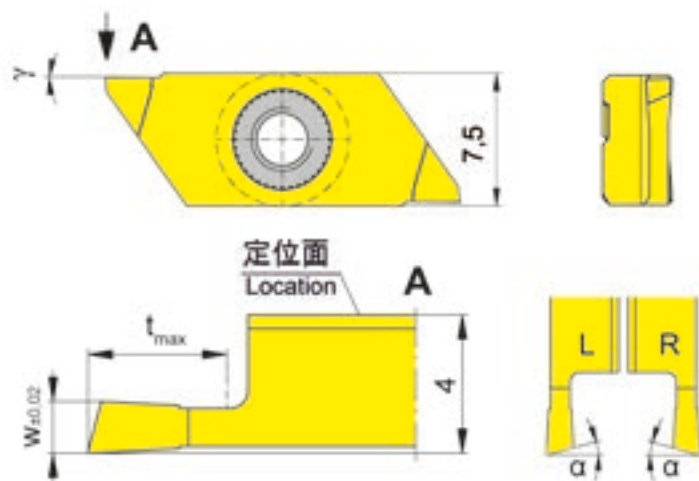
Depth of groove up to
Width of groove

6 mm
0.8-2 mm

精密磨削
precision ground

配合刀杆
for Toolholder

型号 H274...E
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	w	t _{max}	α	γ	尺寸规格 Size	IG35	TH35
LS274.1508.03.MR.E	0.8	3	15°	0°	04	Δ	Δ
LS274.1510.03.MR.E	1.0	3	15°	0°	04	Δ	Δ
L/S274.1515.04.MR.E	1.5	4	15°	0°	04	Δ	Δ
LS274.1520.06.MR.E	2.0	6	15°	0°	04	Δ	Δ
R/S274.1508.03.ML.E	0.8	3	15°	0°	04	Δ	Δ
R/S274.1510.03.ML.E	1.0	3	15°	0°	04	Δ	Δ
R/S274.1515.04.ML.E	1.5	4	15°	0°	04	Δ	Δ
R/S274.1520.06.ML.E	2.0	6	15°	0°	04	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

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

Note:

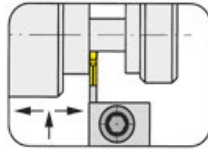
t_{max} 6 mm can be reached only with workpiece $\varnothing \leq 25\text{ mm}$.

P	-	●
M	●	●
K	-	●
N	-	●
S	●	●
H	-	-

硬质合金牌号
Carbide grades

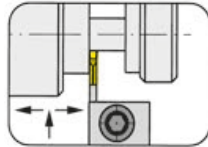
T

刀杆
Toolholder
218/226



页/Page
T106

常规刀柄
Basic toolholder
218

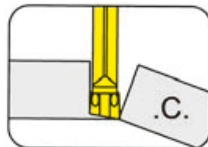


页/Page
T107

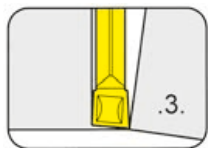


页/Page
T108-T109

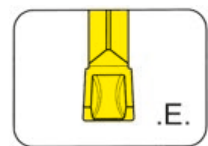
可转位刀片
Indexable insert
S229/229



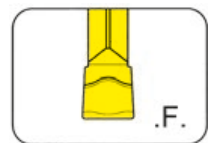
页/Page
T110-T111



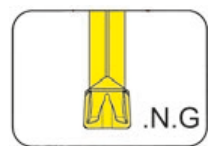
页/Page
T112



页/Page
T113



页/Page
T114



页/Page
T115

229



T

机夹式刀杆

槽宽3.0 - 5.0 mm

Toolholder with Inserts

Width of groove 3.0 - 5.0 mm

切槽和切断

Grooving and Parting Off



刀杆

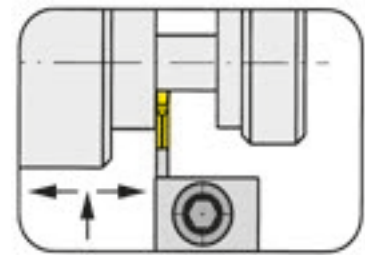
Toolholder

218

槽深可达
夹持范围

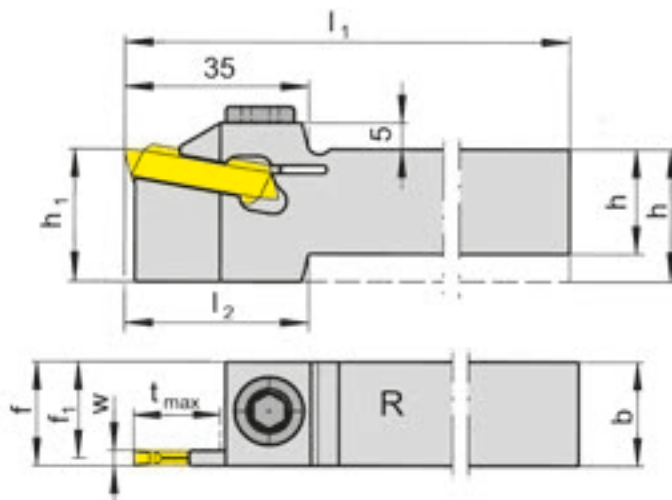
Depth of groove up to
Clamping range

18 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.1616.03	16	16	150	45	25	14.55	$f_1 + w/2$	18	03	3-4
R/L218.2020.03	20	20	150	35	25	18.55	$f_1 + w/2$	18	03	3-4
R/L218.2525.03	25	25	150	-	25	23.55	$f_1 + w/2$	18	03	3-4
R/L218.3225.03	32	25	170	-	32	23.55	$f_1 + w/2$	18	03	3-4
R/L218.2020.04	20	20	150	35	25	17.70	$f_1 + w/2$	18	04	4-5
R/L218.2525.04	25	25	150	-	25	22.70	$f_1 + w/2$	18	04	4-5
R/L218.3225.04	32	25	170	-	32	22.70	$f_1 + w/2$	18	04	4-5

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

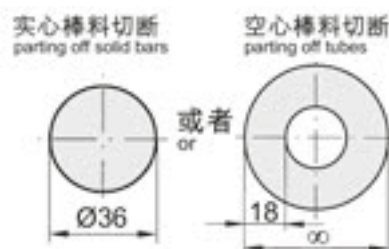
For torque specification of the screw, please see Technical Instructions.

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm



配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
R/L218...	218.3	SW6,0 DIN911

切槽和切断

Grooving and Parting Off



常规刀柄

Basic toolholder

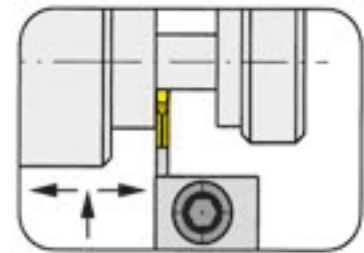
218

带可换刀夹
with changeable cassette

槽深可达
夹持范围

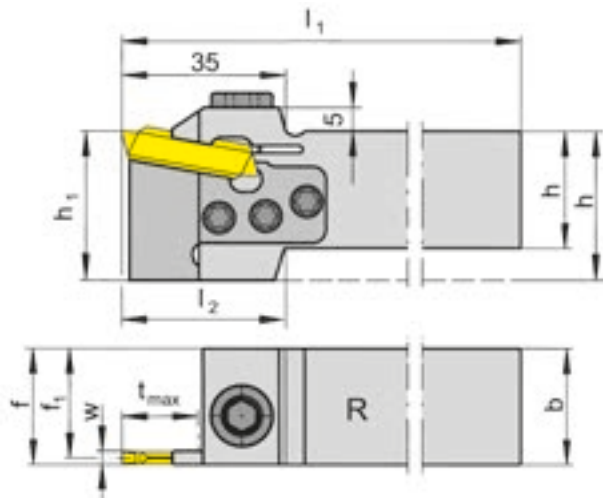
Depth of groove up to
Clamping range

18 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L218.2525.K3	25	25	150	35	32	23.55	$f_1 + w/2$	18	03	3-4
R/L218.3225.K3	32	25	170	-	32	23.55	$f_1 + w/2$	18	03	3-4
R/L218.2525.K4	25	25	150	35	32	22.70	$f_1 + w/2$	18	04	4-5
R/L218.3225.K4	32	25	170	-	32	22.70	$f_1 + w/2$	18	04	4-5

注明R或L型
State R or L version

w见刀片
w see indexable inserts

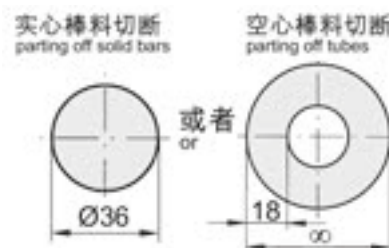
尺寸单位：mm
Dimensions in mm

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

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



配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench	刀夹 Cassette	TORX PLUS®扳手 TORX PLUS® Wrench
R/L210...K3	030.0518T20P	SW6,0 DIN911	NK210.32.03	T20PQ
R/L210...K4	030.0518T20P	SW6,0 DIN911	NK210.32.04	T20PQ
R/L210...K5	030.0518T20P	SW6,0 DIN911	NK210.32.05	T20PQ
R/L210...K7	030.0518T20P	SW6,0 DIN911	NK210.32.07	T20PQ

切槽和切断

Grooving and Parting Off



刀杆

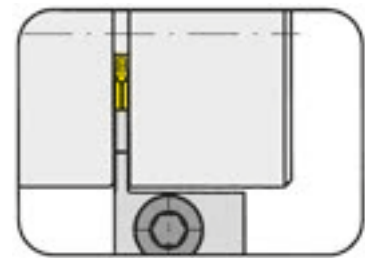
Toolholder

226

槽深可达
夹持范围

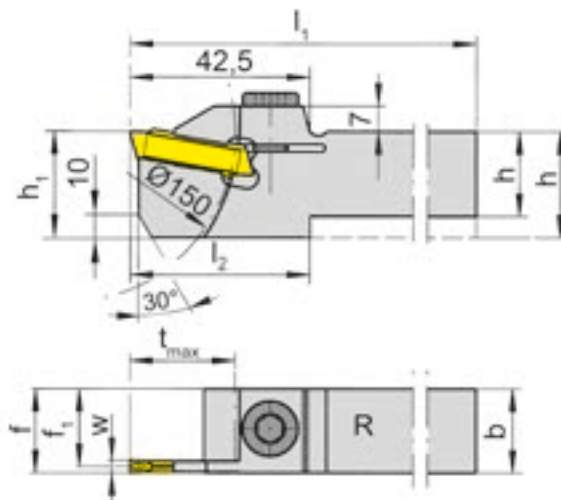
Depth of groove up to
Clamping range

25 mm
3-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L226.1616.03	16	16	150	52.5	32	18.55	$f_1 + w/2$	25	03	3-4
R/L226.2020.03	20	20	150	42.5	32	18.55	$f_1 + w/2$	25	03	3-4
R/L226.2525.03	25	25	150	-	32	23.55	$f_1 + w/2$	25	03	3-4
R/L226.3225.03	32	25	170	-	32	23.55	$f_1 + w/2$	25	03	3-4
R/L226.1616.04	16	16	150	52.5	32	13.70	$f_1 + w/2$	25	04	4-5
R/L226.2020.04	20	20	150	42.5	32	17.70	$f_1 + w/2$	25	04	4-5
R/L226.2525.04	25	25	150	-	32	22.70	$f_1 + w/2$	25	04	4-5
R/L226.3225.04	32	25	170	-	32	22.70	$f_1 + w/2$	25	04	4-5

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺丝的扭矩规格，详见技术说明。

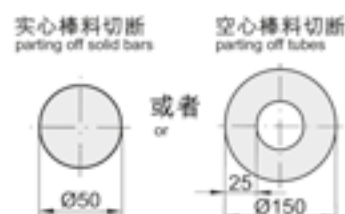
For torque specification of the screw, please see Technical Instructions.

w见刀片

w see indexable inserts

尺寸单位：mm

Dimensions in mm



配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	扳手 Allen Wrench
R/L226...	218.3	SW6,0 DIN911

切槽和切断

Grooving and Parting Off



刀杆

Toolholder

226

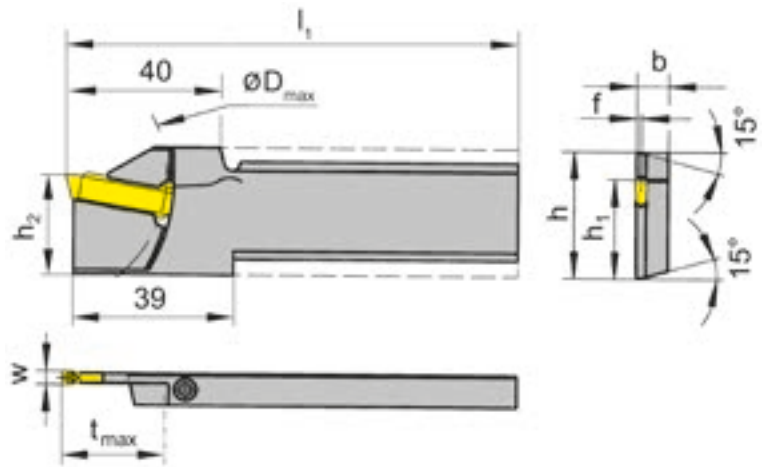
加强型
reinforced version



槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
3-4 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l ₁	h ₂	f	t _{max}	D _{max}	h ₁	尺寸规格 Size	夹持范围 Clamping range
R/L226.2608.03	26	8	110	24.8	1.2	25	150	21.4	03	3
R/L226.3208.03	32	8	110	24.8	1.2	25	150	24.8	03	3
R/L226.2608.04	26	8	110	24.8	1.7	25	150	21.4	04	4
R/L226.3208.04	32	8	110	24.8	1.7	25	150	24.8	04	4

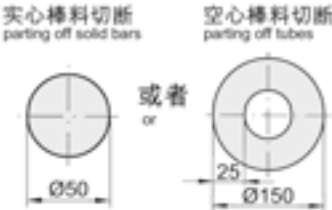
注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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



配件 Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS® 扳手 TORX PLUS® Wrench
R/L226...	4.15T15P	T15PQ

切断

Parting Off



可转位刀片

Indexable insert

S229

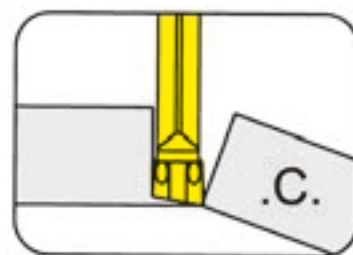
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

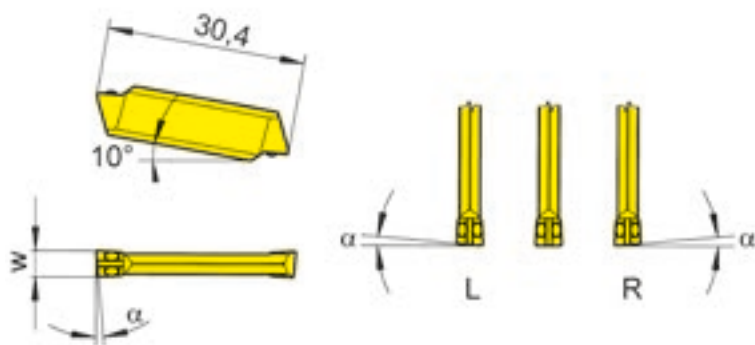
25 mm
3-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 218
Type 226



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

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	α	尺寸规格 Size	TC92	TF45	T125	TN35
R/LS229.0530.C0	3	5°	03	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0540.C0	4	5°	03	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0830.C0	3	8°	03	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0840.C0	4	8°	03	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
S229.0030.C0	3	0°	03	Δ	Δ	Δ	Δ
S229.0040.C0	4	0°	03	Δ	Δ	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

S229

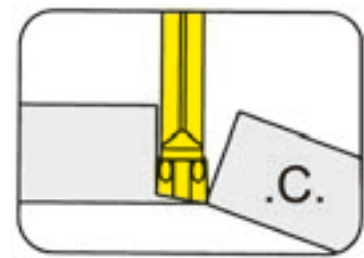
带卷屑器
with chip forming

槽深可达
槽宽

Depth of groove up to
Width of groove

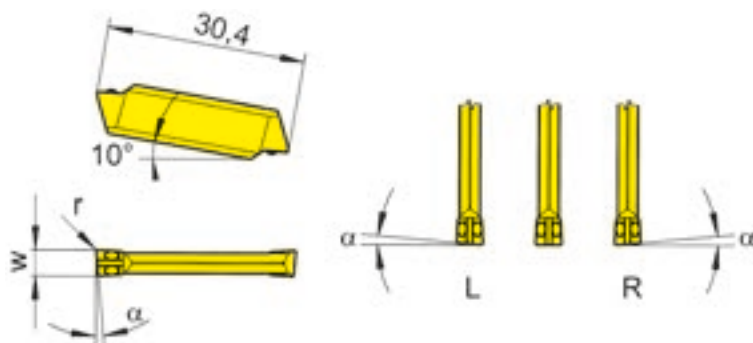
25 mm
3-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 218
Type 226



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

T

产品型号 Part number	w	r	α	尺寸规格 Size	TC92	TF45	T125	TN35
R/LS229.0530.C1	3	0.15	5°	03	Δ/Δ	Δ/Δ	▲/▲	▲/▲
R/LS229.0830.C1	3	0.15	8°	03	Δ/Δ	▲/▲	▲/Δ	▲/▲
S229.0030.C1	3	0.15	0°	03	Δ	Δ	▲	▲
R/LS229.0540.C1	4	0.15	5°	04	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0540.C1	4	0.15	5°	04	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/LS229.0840.C1	4	0.15	8°	04	Δ/Δ	Δ/Δ	Δ/Δ	▲/Δ
S229.0040.C1	4	0.15	0°	04	Δ	Δ	Δ	Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

	P	M	K	N	S	H
TC92	●	●	●	●	●	●
TF45	-	●	●	●	●	●
T125	-	●	●	●	●	●
TN35	-	●	●	●	●	●

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

229/S229

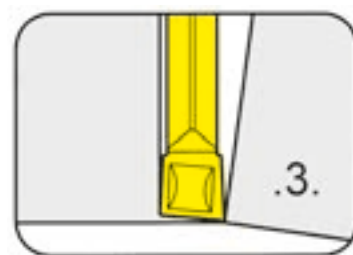
带卷屑器
with chip former

槽深可达
槽宽

Depth of groove up to
Width of groove

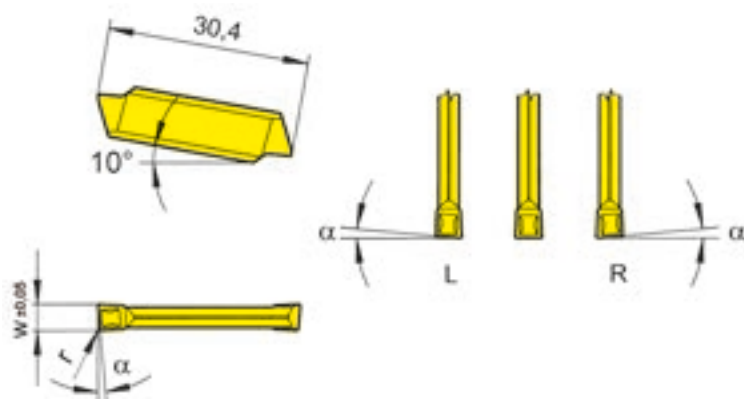
25 mm
3-4 mm

精密烧结
precision sintered



配合刀杆
for Toolholder

型号 218
Type 226



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

长度重复定位精度
±0.04 mm
Indexability length ± 0.04 mm

产品型号 Part number	w	r	α	尺寸规格 Size	MG12	AL96	AS62	AS66	H54	P20	TA45	TC92	TF45	TI22	TI25	TN32	TN35
R/L229.5300.31	3	0.2	5°	03	▲/▲		▲/▲					▲/▲			▲/▲	▲/▲	▲/▲
R/LS229.0530.32	3	0.2	5°	03			▲/▲				Δ/Δ	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
S229.0300.32	3	0.2	-	03	▲	▲	▲	▲	▲	Δ	Δ	▲	▲	▲		▲	▲
R/LS229.0540.32	4	0.2	5°	04			▲/Δ				Δ/Δ	Δ/Δ	▲/▲		▲/▲	▲/▲	Δ/Δ
S229.0400.32	4	0.2	-	04	Δ	▲	▲	▲	▲	Δ	Δ	▲	▲	Δ	▲	▲	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注意事项 :

R/L229.5300.31精密磨削, 长度30.0mm

Note:

R/L229.5300.31 precision ground, length 30.0 mm

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

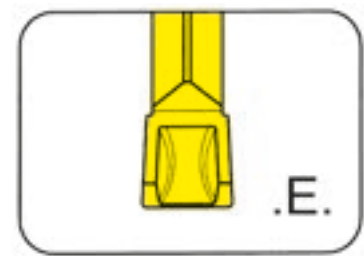
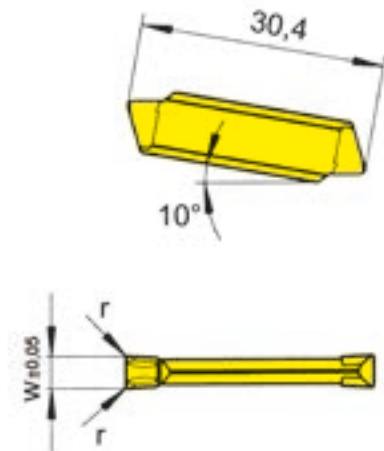
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结

precision sintered



配合刀杆

for Toolholder

型号 218

Type 226

刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

T

产品型号 Part number	w	r	尺寸规格 Size	AS62	TC92	TF45	TF46	TI25
S229.0300.E2	3	0.2	03	▲	△	▲	▲	▲
S229.0300.E4	3	0.4	03	▲	△	▲	△	▲
S229.0400.E2	4	0.2	04	▲	△	▲	△	▲
S229.0400.E4	4	0.4	04	▲	△	▲	△	▲
				P	•	•	•	•
				M	-	-	•	•
				K	-	-	•	•
				N	-	-	•	•
				S	-	-	•	•
				H	-	-	-	-

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

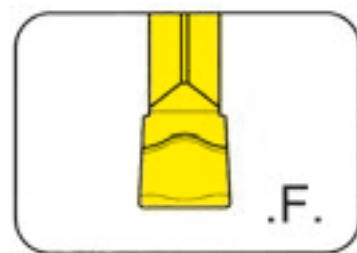
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-4 mm

精密烧结

precision sintered

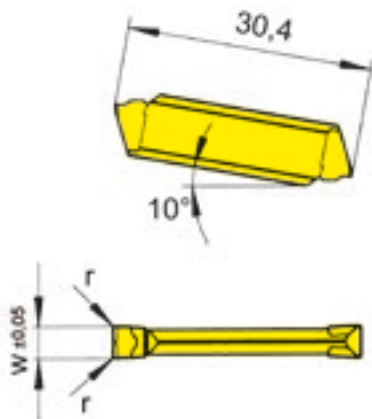


配合刀杆

for Toolholder

型号 218

Type 226



刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size	TC92	TF43	TF45	TF46	TI22	TI25
S229.0300.F2	3	0.2	03	Δ	▲	▲	▲	▲	Δ
S229.0300.F4	3	0.4	03	Δ	Δ	▲	Δ	Δ	Δ
S229.0400.F2	4	0.2	04	Δ	Δ	▲	Δ	Δ	Δ
S229.0400.F4	4	0.4	04	Δ	Δ	▲	Δ	Δ	Δ
▲ 库存 / on stock	Δ 4周 / 4 weeks	x 根据要求 / upon request		P	●	●	●	●	●
● 推荐 / recommended				M	-	-	○	-	●
○ 次推荐 / alternative recommendation				K	-	-	●	-	●
- 不合适 / not suitable				N	-	-	●	-	●
非涂层 / uncoated grades				S	-	-	○	-	●
涂层 / coated grades				H	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet									

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

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

硬质合金牌号

Carbide grades

切槽和切断

Grooving and Parting Off



可转位刀片

Indexable insert

S229

带卷屑器
with chip forming

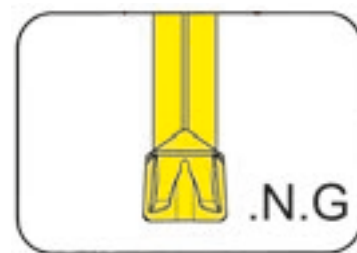
槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
3-5 mm

精密烧结

precision sintered

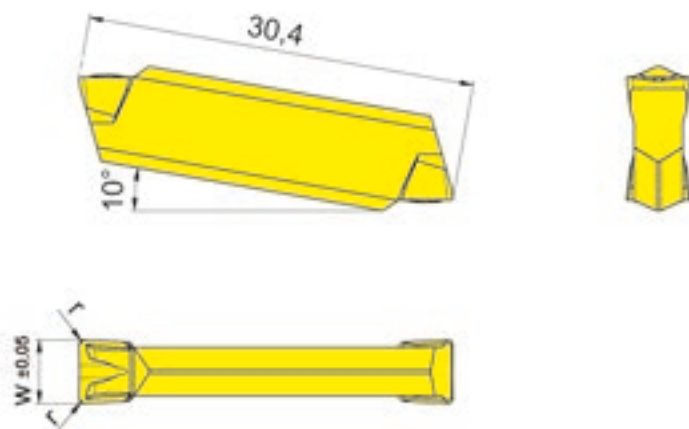


配合刀杆

for Toolholder

型号 218

Type 226



刀片长度重复定位精度

±0.06 mm

Indexability length ± 0.06 mm

产品型号 Part number	w	r	尺寸规格 Size		AS45	AS62	DD25	T125
S229.0300.N2.G	3	0.2	03		▲			
S229.0300.N4.G	3	0.4	03		▲			
S229.0400.N2.G	4	0.2	04		▲			
S229.0400.N4.G	4	0.4	04		▲			
S229.0500.N2.G	5	0.2	04				Δ	▲
S229.0500.N4.G	5	0.4	04		▲	▲	Δ	Δ
S229.0500.N6.G	5	0.6	04		Δ	▲		Δ
S229.0500.N8.G	5	0.8	04			▲		
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request				P	●	●	-	●
● 推荐 / recommended				M	●	-	-	●
o 次推荐 / alternative recommendation				K	●	-	-	●
- 不合适 / not suitable				N	o	-	●	●
■ 非涂层 / uncoated grades				S	●	-	o	●
■ 涂层 / coated grades				H	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet								

尺寸单位 : mm

Dimensions in mm

此可转位刀片可用于右手和左手型刀杆

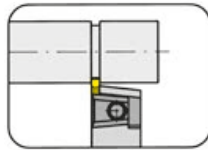
Indexable inserts can be used in right and left hand toolholders.

硬质合金牌号

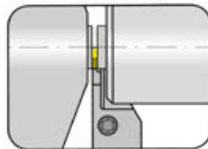
Carbide grades

T

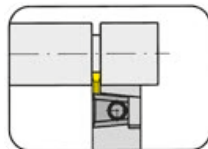
刀杆
Toolholder
360/368/391



页/Page
T118

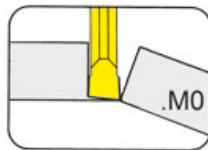


页/Page
T119-T120

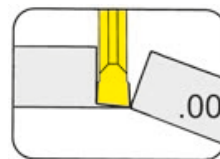


页/Page
T121

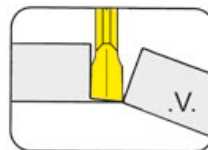
可转位刀片
Indexable insert
312/S312



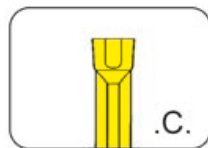
页/Page
T122



页/Page
T124-T126



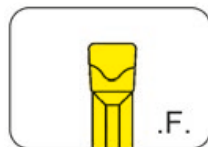
页/Page
T123



页/Page
T127



页/Page
T128



页/Page
T129

312



T

机夹式刀杆

槽宽0.5 - 3 mm

Toolholder with Inserts

Width of groove 0.5 - 3 mm

切槽和切断

Grooving and Parting Off



刀杆

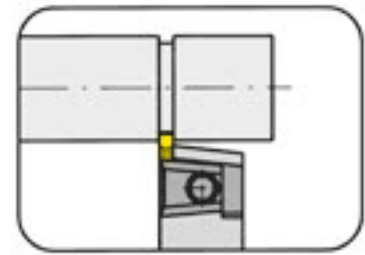
Toolholder

360

槽深可达
夹持范围

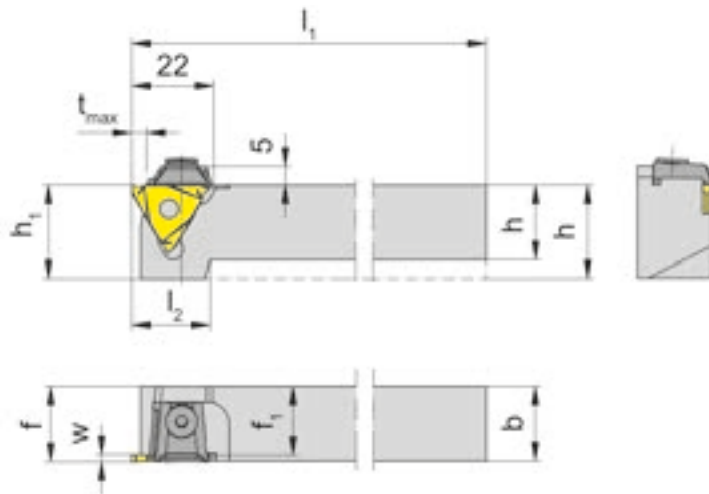
Depth of groove up to
Clamping range

6 mm
1.9-2.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L360.1212.02	12	12	100	24	25	9.5	$f_1 + w - a_1$	6	02	1.9-2.9
R/L360.1616.02	16	16	125	22	25	13.5	$f_1 + w - a_1$	6	02	1.9-2.9
R/L360.2020.02	20	20	125	21	25	17.5	$f_1 + w - a_1$	6	02	1.9-2.9
R/L360.2525.02	25	25	150	-	25	22.5	$f_1 + w - a_1$	6	02	1.9-2.9
R/L360.3232.02	32	32	170	-	32	29.5	$f_1 + w - a_1$	6	02	1.9-2.9

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\phi \leq 40\text{mm}$ 时才能达到 t_{max}

t_{max} can be reached only with workpiece $\phi \leq 40\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	扳手 Allen Wrench	压板 Clamping element
R/L360.1...	SW3.0 DIN911	11.3
R/L360...	SW3.0 DIN911	16.4

切断

Parting Off



刀杆

Toolholder

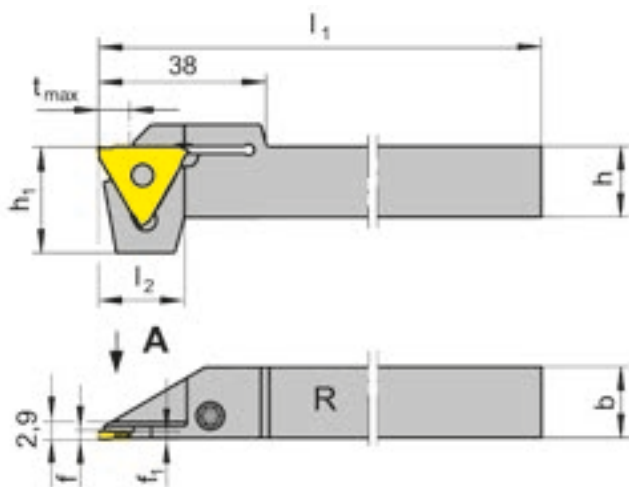
368

槽深可达
槽宽

Depth of groove up to
Width of groove

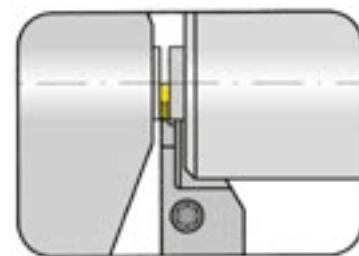
8 mm
0.5-1.5 mm

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



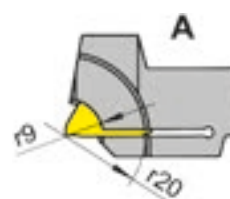
R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



配合可转位刀片
for Indexable insert

型号 312 w ≤ 1.5 mm
Type



仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l ₁	l ₂	h ₁	f ₁	f	t _{max}
R/L368.1212.08	12	12	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1616.08	16	16	95	19.5	24	1.0	f ₁ +a ₁	8
R/L368.1212.11	12	12	95	19.5	24	1.3	f ₁ +a ₁	8
R/L368.1616.11	16	16	95	19.5	24	1.3	f ₁ +a ₁	8

注明R或L型
State R or L version

a1见刀片
a1 see indexable inserts

尺寸单位：mm
Dimensions in mm

刀杆R/L368...08适合安装以下刀片：

R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆R/L368...11适合安装以下刀片：

R/L312.0515... / R/L312.0015...V1

Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...V1

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368...	4.15T15P	T15PQ

切断

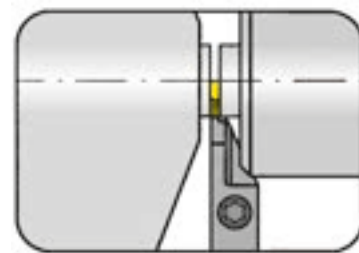
Parting Off



刀杆

Toolholder

368
加强型
reinforced version



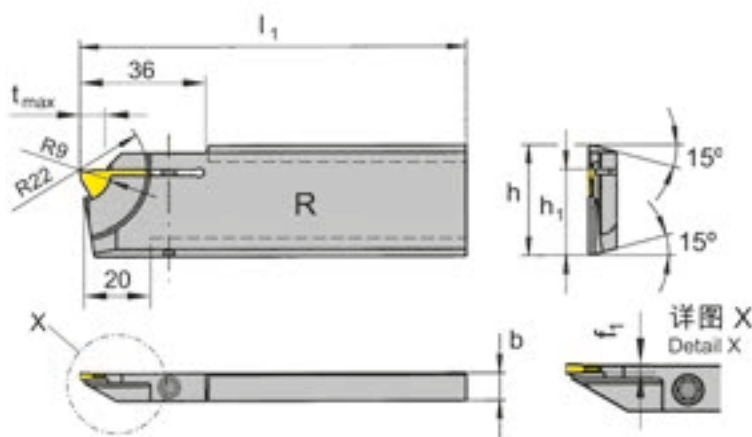
槽深可达
槽宽

Depth of groove up to
Width of groove

8 mm
0.5-1.5 mm

配合可转位刀片
for Indexable insert

型号 312 $w \leq 1.5$ mm
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

仅用于周边轮廓磨削刀片
only for periferal grounded
profiled inserts

产品型号 Part number	h	b	l_1	h_1	f_1	t_{max}
R/L368.2608.08	26	8	110	21.4	1.0	8
R/L368.3208.08	32	8	110	24.8	1.0	8
R/L368.2608.11	26	8	110	21.4	1.3	8
R/L368.3208.11	32	8	110	24.8	1.3	8

注明R或L型
State R or L version

尺寸单位：mm
Dimensions in mm

刀杆**R/L368...08**适合安装以下刀片：
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

Toolholder R/L368...08 for indexable inserts:
R/L312.0805... / R/L312.0808... / R/L312.0510... R/L312.0512... / R/L312.1210... / R/L312.0012...

刀杆**R/L368...11**适合安装以下刀片：
R/L312.0515... / R/L312.0015...V1

Toolholder R/L368...11 for indexable inserts:
R/L312.0515... / R/L312.0015...V1

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L368...	4.15T15P	T15PQ

切槽 (外圆)

Grooving (external)



刀杆

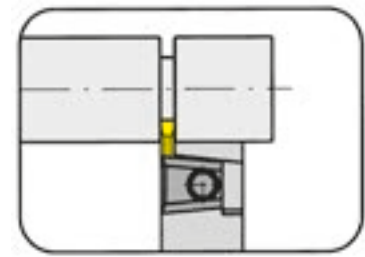
Toolholder

391

槽深可达
夹持范围

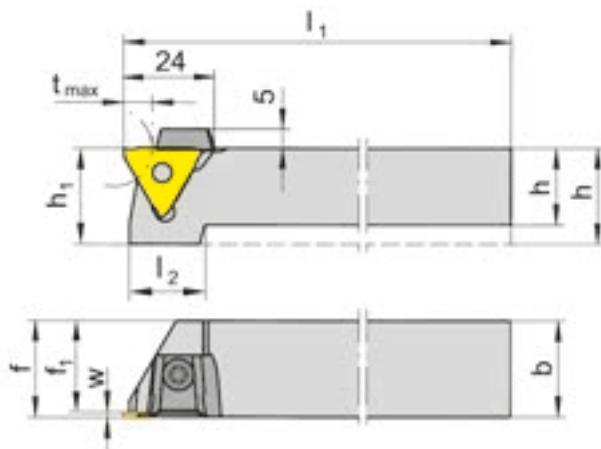
Depth of groove up to
Clamping range

8 mm
0.5-1.9 mm



配合可转位刀片
for Indexable insert

型号 312
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	l_2	h_1	f_1	f	t_{max}	尺寸规格 Size	夹持范围 Clamping range
R/L391.1212.01	12	12	100	21	21	10.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.1616.01	16	16	125	21	21	14.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.2020.01	20	20	125	21	21	18.5	f_1+w-a_1	8	01	0.5-1.9
R/L391.2525.01	25	25	150	-	25	23.8	f_1+w-a_1	8	01	0.5-1.9

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

只有当工件直径 $\phi \leq 20\text{mm}$ 时才能达到 t_{max}

t_{max} can be reached only with workpiece $\phi \leq 20\text{ mm}$

螺丝的扭矩规格，详见技术说明。

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

w, a_1 见刀片

w, a_1 see indexable inserts

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀杆 Toolholder	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Allen Wrench
R/L391.1212.01	12.3	T10PL	-
R/L391.1616.01	14.4	T15PQ	-
R/L391....	16.4	-	SW3.0 DIN911

切断

Parting Off



可转位刀片

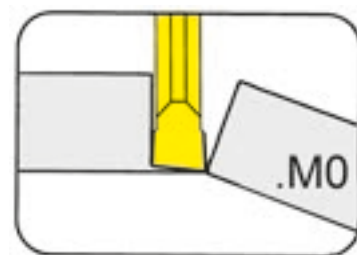
Indexable insert

312

槽深可达
槽宽

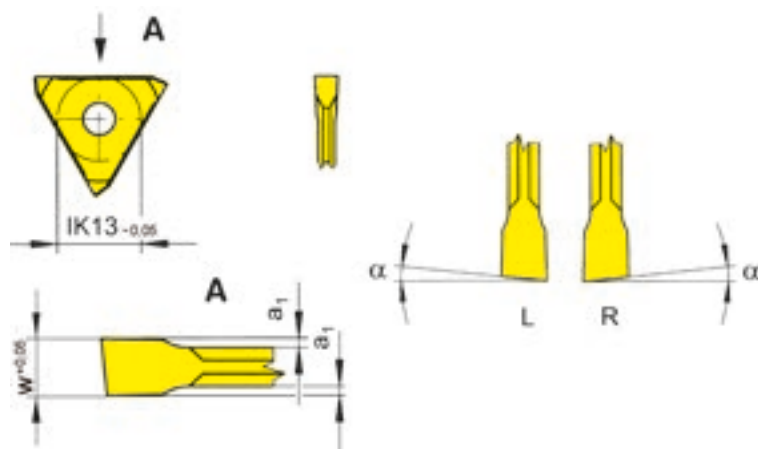
Depth of groove up to
Width of groove

8 mm
1.2-1.5 mm



配合刀杆
for Toolholder

型号 360
Type 368
391



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	t _{max}	α	a ₁	尺寸规格 Size	K10	EG35	TF45
R/L312.0512.M0	1.2	8	5°	0.2	01	Δ/Δ	▲/▲	▲/Δ
R/L312.0515.M0	1.5	8	5°	0.2	01	▲/Δ	▲/▲	▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

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

HM-Sorten
Carbide grades

切断
Parting Off



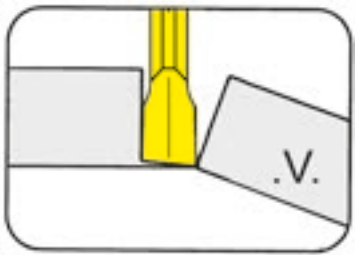
可转位刀片
Indexable insert

312

槽深可达
槽宽

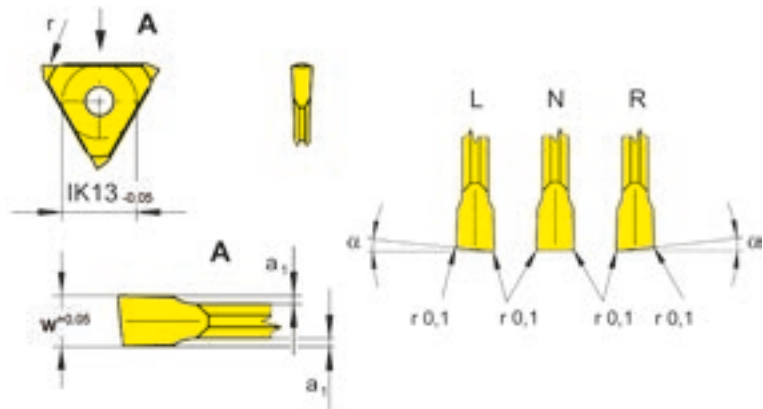
Depth of groove up to
Width of groove

8 mm
1.2-2 mm



配合刀杆
for Toolholder

型号 360
Type 368
391



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	α	a_1	尺寸规格 Size	EG35	TF45	TH35
312.0012.V1	1.2	0°	0.2	01	▲	▲	
R/L312.0512.V1	1.2	5°	0.2	01	▲/▲	▲/▲	
312.0015.V1	1.5	0°	0.2	01	▲	▲	
R/L312.0515.V1	1.5	5°	0.2	01	▲/▲	▲/▲	
R/L312.0520.V2	2.0	5°	0.2	01	▲/▲		▲/▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

注明R或L型

State R or L version

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

硬质合金牌号
Carbide grades

T

切断

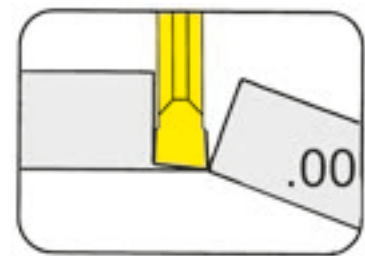
Parting Off



可转位刀片

Indexable insert

312
带圆形断屑槽
with round chip breaker



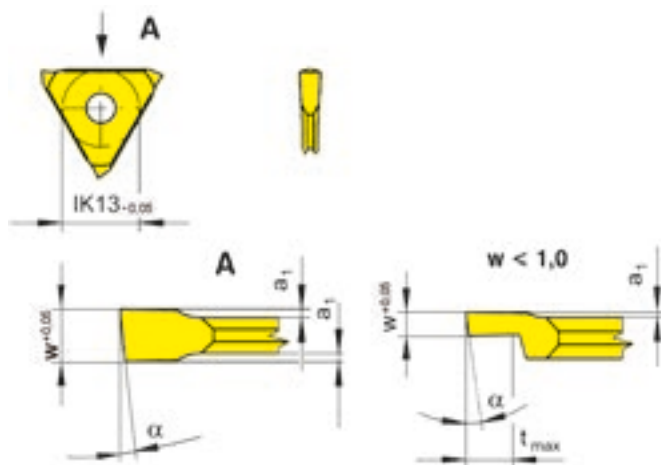
槽深可达
槽宽

Depth of groove up to
Width of groove

8 mm
0.5-1.5 mm

配合刀杆
for Toolholder

型号 360
Type 368
391



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	t _{max}	a	a ₁	尺寸规格 Size		K10	EG35	EG55	H20	P20	TC92	TF45	TF46	TI25	TN32	TN35
R/L312.0805.00	0.5	1.0	8°	0.1	01			▲/▲					▲/▲				
R/L312.0808.00	0.8	1.5	8°	0.1	01			▲/▲					▲/▲				
R/L312.0510.00	1.0	8.0	5°	0.1	01			▲/▲					▲/▲				
R/L312.1210.00	1.0	8.0	12°	0.1	01			▲/▲					▲/▲		Δ/Δ		▲/▲
R/L312.0512.00	1.2	8.0	5°	0.2	01			▲/▲					▲/▲				
R/L312.0515.00	1.5	8.0	5°	0.2	01		▲/x	▲/▲	▲/x	▲/x	▲/x	Δ/x	▲/▲	▲/x		▲/x	
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P	●	●	●	●	●	●	●	●	●	●	●
● 推荐 / recommended						M	○	●	○	○	-	-	●	○	●	-	●
○ 次推荐 / alternative recommendation						K	●	○	○	-	-	-	●	●	●	-	●
- 不合适 / not suitable						N	●	-	-	-	-	-	●	●	●	-	●
非涂层 / uncoated grades						S	○	-	-	-	-	-	●	○	●	-	●
涂层 / coated grades						H	-	-	-	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet																	

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

硬质合金牌号
Carbide grades

切槽和切断

Grooving and Parting Off

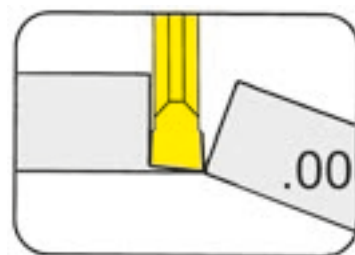


可转位刀片

Indexable insert

312

带圆形断屑槽
with round chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

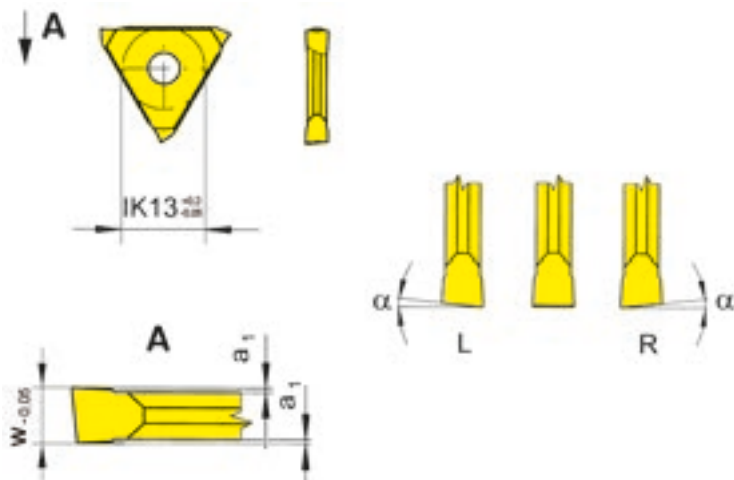
5 mm
1.07-1.44 mm

配合刀杆

for Toolholder

型号 360

Type 391



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	α	a_1	尺寸规格 Size		K10	EG35	EG55	H20	P20	TC92	TF45	TF46	T125	TN32	TN35
312.0100.00	1.07	-	0.09	01		▲		▲	△	▲		▲	▲		▲	▲
312.0130.00	1.44	-	0.20	01		▲		▲		▲		▲	▲		▲	▲
R/L312.0614.00	1.44	6°	0.20	01			▲/▲					▲/▲	▲/▲	▲/▲		▲/▲
▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	○	●	○	○	-	-	●	○	●	-	●
○ 次推荐 / alternative recommendation					K	●	○	○	-	-	-	●	●	●	-	●
- 不合适 / not suitable					N	●	-	-	-	-	-	●	●	●	-	●
■ 非涂层 / uncoated grades					S	○	-	-	-	-	-	●	○	●	-	●
■ 涂层 / coated grades					H	-	-	-	-	-	-	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet																

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

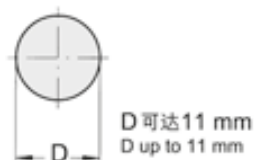
外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

External machining:

for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

实心棒料切断
parting off solid bars



空心棒料切断
parting off tubes



切槽和切断

Grooving and Parting Off

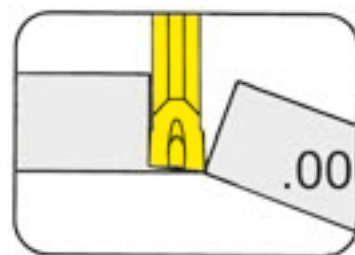


可转位刀片

Indexable insert

312

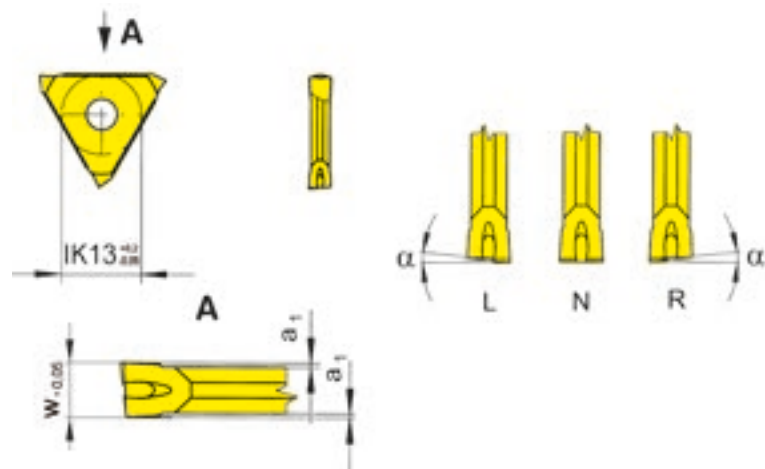
带圆形断屑槽
with round chip breaker



槽深可达
槽宽

Depth of groove up to
Width of groove

5 mm
1.44-2.29 mm



配合刀杆
for Toolholder

型号 360
Type 391

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	α	a_1	尺寸规格 Size	MG12	EG55	P20	TC92	TF45	TN32	TN35
N312.0014.00	1.44	0°	0.2	02		▲		△	▲		
N312.0018.00	1.99	0°	0.2	02		▲		△	▲	△	△
N312.0021.00	2.29	0°	0.2	02		▲	△	△			▲
R/L312.0514.00	1.44	5°	0.2	02		△/△	△/△		▲/△		
R/L312.0518.00	1.99	5°	0.2	02		▲/▲	▲/▲	△/△		▲/▲	▲/▲
R/L312.0521.00	2.29	5°	0.2	02	△/△	▲/△	▲/▲	△/△		▲/▲	▲/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

外圆加工 :

360系列刀杆右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

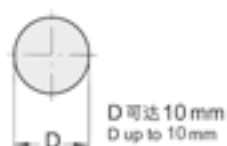
External machining:

for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

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

硬质合金牌号
Carbide grades

实心棒料切断
parting off solid bars



空心棒料切断
parting off tubes



$D \geq 50$ mm可达 $W \approx 5$ mm
 $D \leq 50$ mm可达 $W \approx 4$ mm
 $D \geq 50$ mm up to $W \approx 5$ mm
 $D \leq 50$ mm up to $W \approx 4$ mm

切断

Parting Off



可转位刀片

Indexable insert

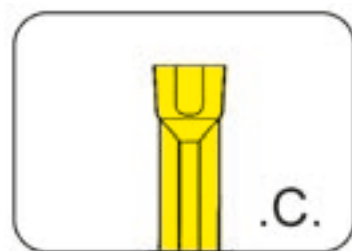
S312

带烧结槽型
with sintered geometries

槽深可达
槽宽

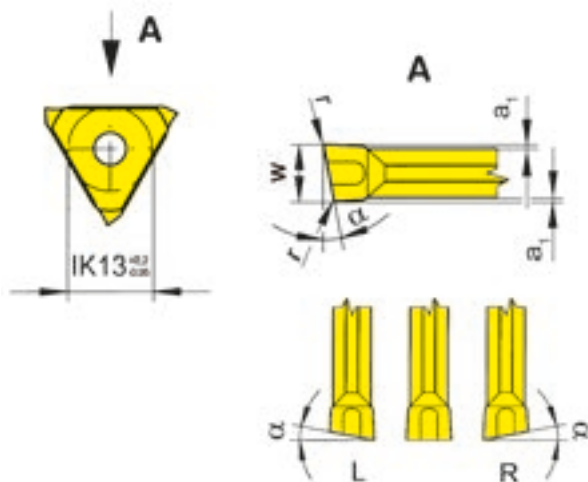
Depth of groove up to
Width of groove

5 mm
2-3 mm



配合刀杆
for Toolholder

型号 360
Type 391



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.C
Geometry .C

产品型号 Part number	w	r	α	a_1	尺寸规格 Size	EG55	TF46	TI25
S312.0200.C2	2.0	0.2	0°	0.25	02	▲	▲	▲
R/LS312.0520.C2	2.0	0.2	5°	0.25	02	▲/▲	▲/Δ	▲/▲
S312.0250.C2	2.5	0.2	0°	0.25	02	▲	Δ	▲
R/LS312.0525.C2	2.5	0.2	5°	0.25	02	Δ/▲	▲/Δ	▲/▲
S312.0300.C2	3.0	0.2	0°	0.25	03	Δ	Δ	Δ
R/LS312.0530.C2	3.0	0.2	5°	0.25	03	Δ/Δ	Δ/Δ	▲/Δ

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注明R或L型

State R or L version

此可转位刀片可用于右手和左手型刀杆

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

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

硬质合金牌号
Carbide grades

T

切断

Parting Off



可转位刀片

Indexable insert

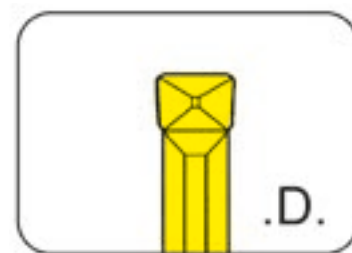
S312

带烧结槽型
with sintered geometries

槽深可达
槽宽

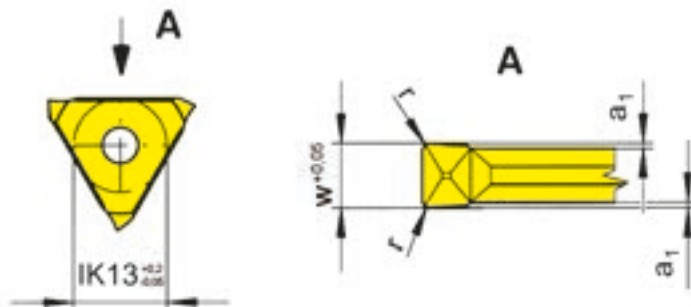
Depth of groove up to
Width of groove

5 mm
2-3 mm



配合刀杆
for Toolholder

型号 360
Type 391



槽型.D
Geometry .D

产品型号 Part number	w	r	a ₁	尺寸规格 Size	AL96	AS62	AS66	EG56	TC92	TF45	TF46	TI25	TN32
S312.0200.D2	2.0	0.2	0.25	02	Δ	▲	▲	▲	Δ	Δ	▲	▲	▲
S312.0200.D4	2.0	0.4	0.25	02	Δ	▲	▲	▲	Δ	Δ	Δ	▲	Δ
S312.0250.D2	2.5	0.2	0.25	02	Δ	▲	▲	▲	▲	▲	▲	▲	▲
S312.0250.D4	2.5	0.4	0.25	02	Δ	▲	▲	▲	▲	▲	▲	▲	▲
S312.0300.D2	3.0	0.2	0.25	03	Δ	Δ	▲	▲	Δ	▲	▲	▲	▲
S312.0300.D4	3.0	0.4	0.25	03	Δ	▲	▲	▲	Δ	Δ	Δ	Δ	Δ
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request					P	●	●	●	●	●	●	●	●
● 推荐 / recommended					M	-	-	o	o	-	●	o	●
o 次推荐 / alternative recommendation					K	●	-	●	o	-	●	●	-
- 不合适 / not suitable					N	●	-	●	-	-	●	●	-
非涂层 / uncoated grades					S	-	-	o	-	-	●	o	●
涂层 / coated grades					H	-	-	-	-	-	-	-	-
钎焊/金属陶瓷 / brazed/Cermet													

尺寸单位 : mm
Dimensions in mm

硬质合金牌号
Carbide grades

切断

Parting Off



可转位刀片

Indexable insert

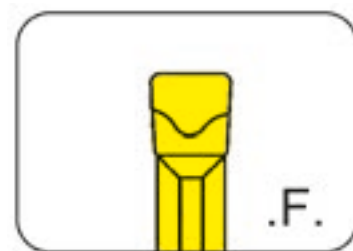
S312

带烧结槽型
with sintered geometries

槽深可达
槽宽

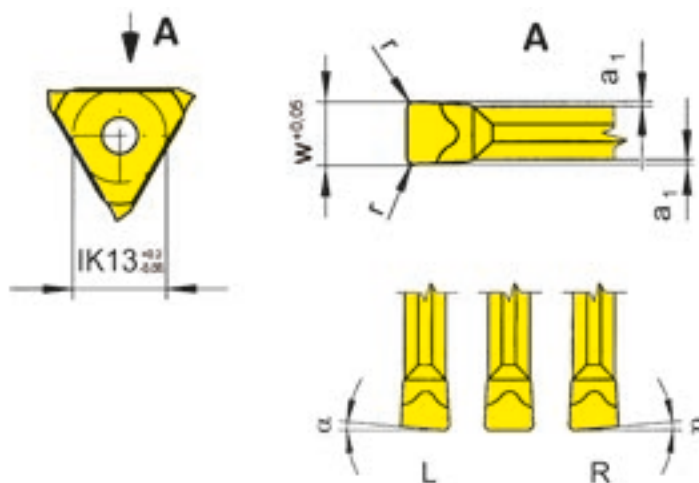
Depth of groove up to
Width of groove

5 mm
2-2.5 mm



配合刀杆
for Toolholder

型号 360
Type 391



R=右手型
R = right hand version

L=左手型
L = left hand version

槽型.F
Geometry .F

产品型号 Part number	w	r	α	a_1	尺寸规格 Size	AL96	EG56	TC92	TF45	TF46	TI25
R/LS312.0520.F2	2.0	0.2	5°	0.25	02		Δ/Δ			▲/Δ	▲/▲
S312.0200.F2	2.0	0.2	0°	0.25	02	Δ	▲	Δ	Δ	▲	▲
R/LS312.0525.F2	2.5	0.2	5°	0.25	02		▲/Δ			▲/Δ	▲/▲
S312.0250.F2	2.5	0.2	0°	0.25	02	Δ	Δ	Δ	Δ	▲	▲
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request						P	●	●	●	●	●
● 推荐 / recommended						M	-	○	-	○	●
○ 次推荐 / alternative recommendation						K	●	○	-	●	●
- 不合适 / not suitable						N	●	-	-	●	●
■ 非涂层 / uncoated grades						S	-	-	-	○	●
■ 涂层 / coated grades						H	-	-	-	-	-
■ 钎焊/金属陶瓷 / brazed/Cermet											

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

硬质合金牌号
Carbide grades

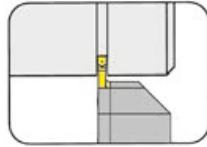
T

切断

Parting Off

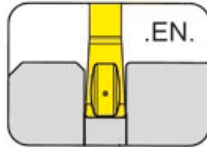


刀杆
Toolholder
H316



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可转位刀片
Indexable insert
S316



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T133

T

316



T

机夹式刀杆

槽宽 2 - 3 mm

Toolholder with Inserts

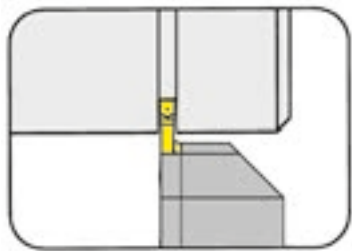
Width of groove 2 - 3 mm

切槽 (外圆)
Grooving (external)



刀杆
Toolholder

H316



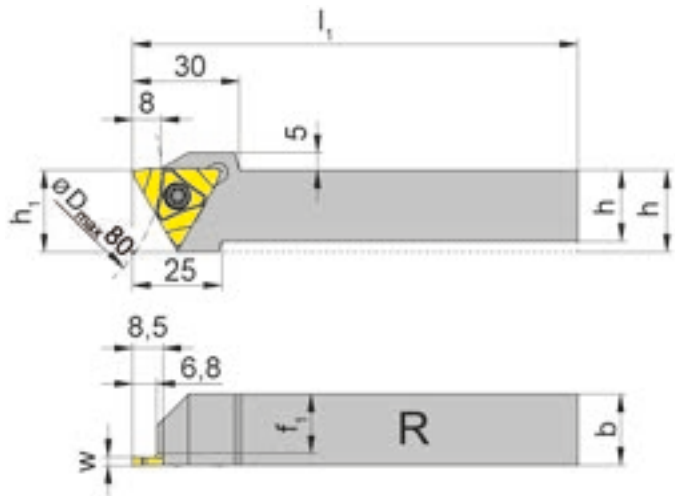
槽深可达
夹持范围

Depth of groove up to
Clamping range

8 mm
1.5-3 mm

配合可转位刀片
for Indexable insert

型号 S316
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	b	l_1	h_1	f_1	尺寸规格 Size
R/LH316.1616.S3.03	16	16	125	23	12.7	03
R/LH316.2020.S3.03	20	20	125	23	16.7	03
R/LH316.2525.S3.03	25	25	150	25	21.7	03
R/LH316.3225.S3.03	32	25	150	32	21.7	03

注明R或L型
State R or L version

w见刀片
w see indexable inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LH316...	5.12T20P	T20PQ

切断

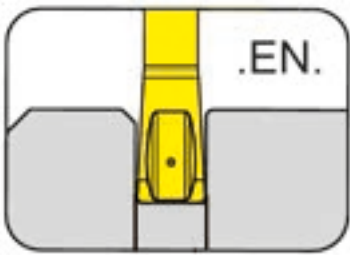
Parting Off



可转位刀片

Indexable insert

S316



槽深可达
槽宽

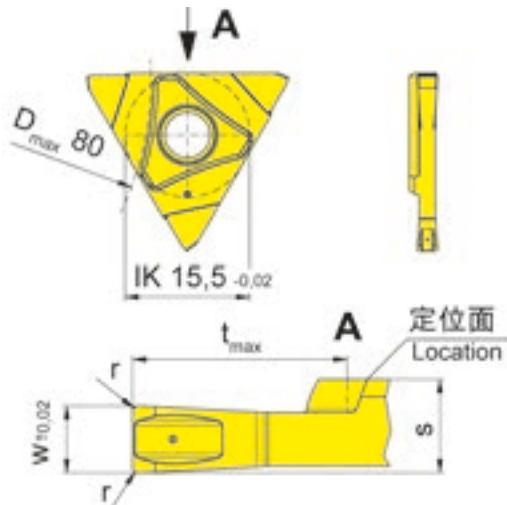
Depth of groove up to
Width of groove

8 mm
2-3 mm

精密烧结
precision sintered

配合刀杆
for Toolholder

型号 H316...S3.03
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

刀片长度重复定位精度
±0.02 mm
Indexability length ± 0.02 mm

T

产品型号 Part number	w	r	t _{max}	s	尺寸规格 Size	AS6G
R/LS316.0200.EN2	2.0	0.2	8	3.5	03	▲/▲
R/LS316.0250.EN2	2.5	0.2	8	3.5	03	▲/▲
R/LS316.0300.EN2	3.0	0.2	8	3.5	03	△/▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	•
M	•
K	•
N	•
S	•
H	-

尺寸单位 : mm
Dimensions in mm

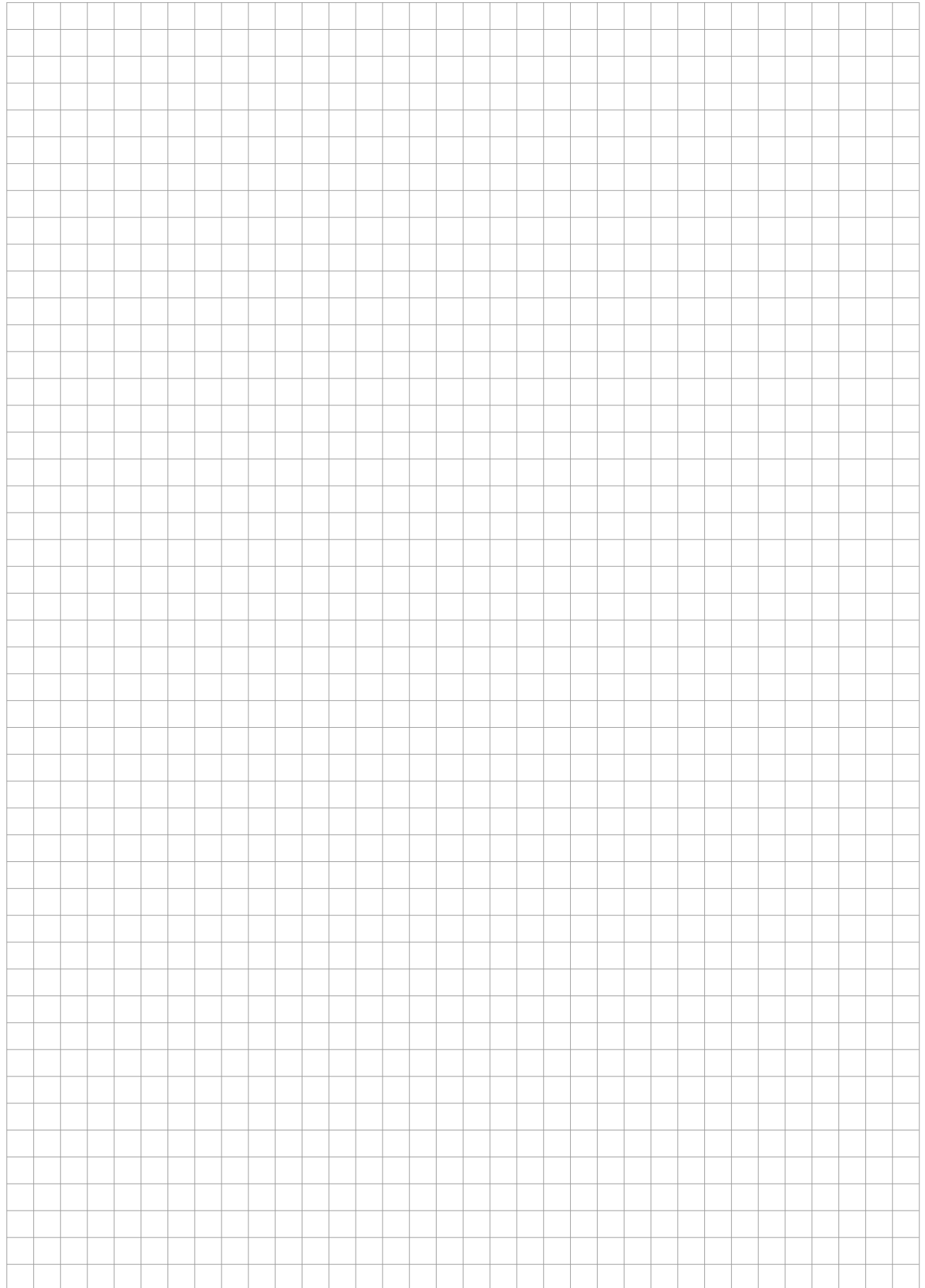
注明R或L型
State R or L version

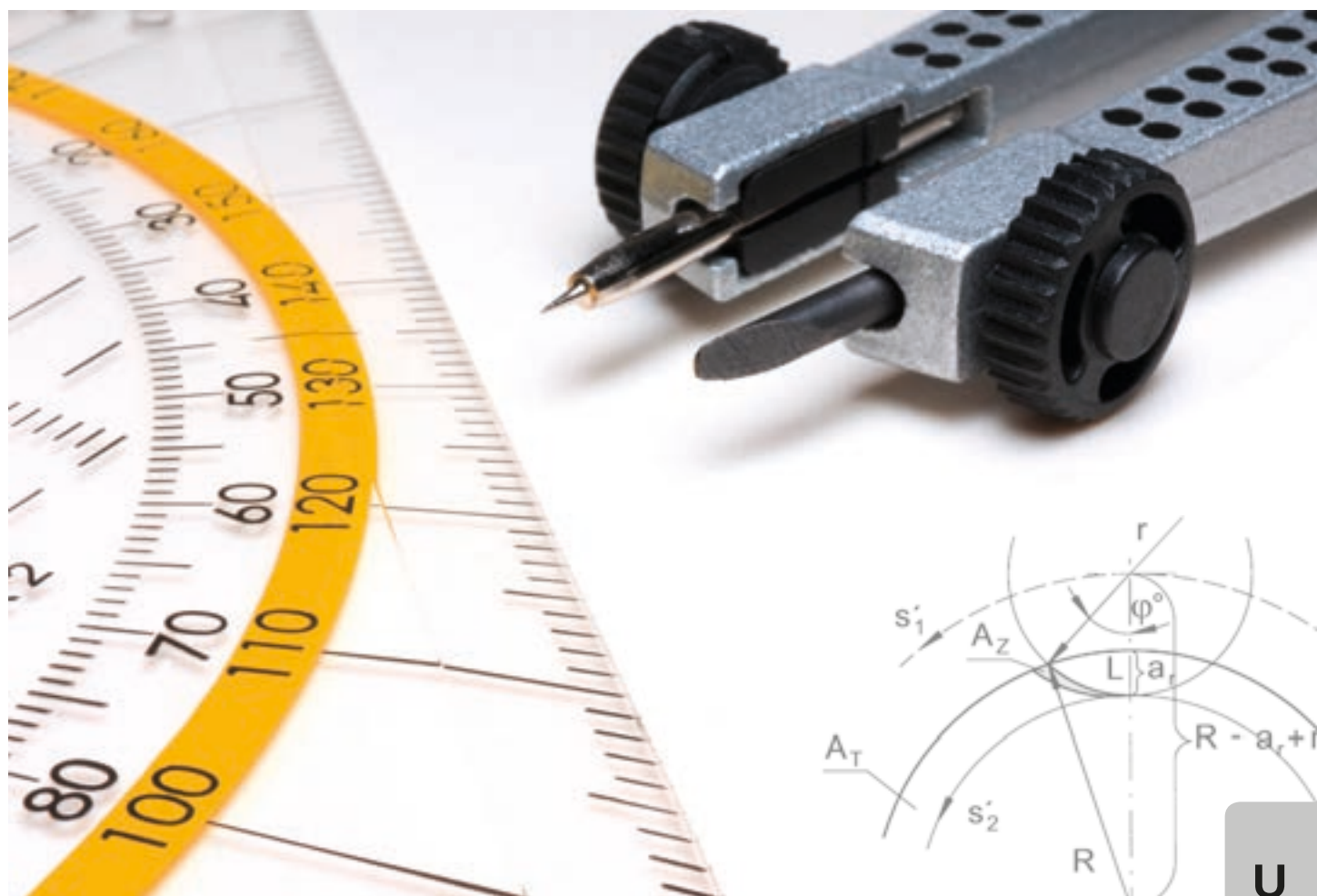
硬质合金牌号
Carbide grades

外圆加工 :
右手型刀杆配合右手型刀片 , 左手型刀杆配合左手型刀片

External machining:
Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

T





摘要/Summary	页/Page
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技术信息	U7-U18
Technical Information	
槽型与进给率	U19-U33
Geometries and feed rates	
切削参数	U34-U37
Cutting Data	
切槽与切断的硬质合金材质	U38-U39
Carbide grades for grooving and parting off	
硬质合金材质描述	U40-U42
Description carbide grades	

螺钉扭矩

Torque of Screws



以下扭矩适用于刀片的螺钉,我们建议对螺钉不要额外使用润滑剂(如铜膏)

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

关于扭矩扳手,见章节辅助装置

For torque screw drivers please see chapter additional equipment.

型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
050	030.0518.T20P	5,0	T20PQ	DT20PK
208	6.16	3,0	SW3DIN911	DSW30K
210	218.3	7,0	SW6DIN911	DSW60K
210...09/...K9	5.32T15P	5,0	T15PQ	DT15PK
211	6.19	3,0	SW3DIN911	DSW30K
213	218.3	7,0	SW6DIN911	DSW60K
213...09	5.32T15P	5,0	T15PQ	DT15PK
213...IK	DIN912-M6x14	6,0	SW5DIN911	DSW50K
214	218.3	7,0	SW6DIN911	DSW60K
214...09	5.32T15P	5,0	T15PQ	DT15PK
218	218.3	7,0	SW6DIN911	DSW60K
218...0.03.IK - 0.05.IK 218...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
218...09/...K9	5.32T15P	5,0	T15PQ	DT15PK
219	218.3	7,0	SW6DIN911	DSW60K
219...09	5.32.3T15P	5,0	T15PQ	DT15PK
221	6.20.70P	5,0	T20PQ	DT20PK
225	218.3	7,0	SW6DIN911	DSW60K
226	218.3	7,0	SW6DIN911	DSW60K
226...09	5.32T15P	4,5	T15PQ	DT15PK
226...0.03.IK - 0.05.IK 226...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
226.2608.../3208...	4.15T15P	5,0	T15PQ	DT15PQ
228	6.20.70P	5,0	T20PQ	DT20PK/DT20PQ
230	5.14	2,5	SW2,5DIN911	DSW25K
232	5.14	2,5	SW2,5DIN911	DSW25K
233	5.14	2,5	SW2,5DIN911	DSW25K
234	5.14	2,5	SW2,5DIN911	DSW25K
235	5.14	2,5	SW2,5DIN911	DSW25K
240	5.14	2,5	SW2,5DIN911	DSW25K
245	51.27.984P	4,0	T15PQ	DT15PK
248	5.14	2,5	SW2,5DIN911	DSW25K
250	5.14	2,5	SW2,5DIN911	DSW25K
253	5.14	2,5	SW2,5DIN911	DSW25K

型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
254	5.14	2,5	SW2,5DIN911	DSW25K
255	5.14	2,5	SW2,5DIN911	DSW25K
257...05	218.3	6,5	SW6DIN911	DSW60K
257...07/...09	5.32.3T15P	5,0	T15PQ	DT15PK
309	6.25	4,5	SW3DIN911	DSW30K
330	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
333	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
340	6.25	4,5	SW3DIN911	DSW30K
356...3/...5	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
356...45.03	5F.08T20P	5,0	T20PQ	DT20PK/DT20PQ
356...6/...7/...10/...2.13 356...2.13.IK/...2.15.IK	5.15T20P	6,5	T20PQ	DT20PK/DT20PQ
357	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
360	6.25	4,5	SW3DIN911	DSW30K
361	030.0422.T10P	3,0	T10PL	DT10PK
368	4.15T15P	4,0	T15PQ	DT15PK
368...10.01	030.0422.T10	4,0	T10PL	DT10PK
369	6.25	4,5	SW3DIN911	DSW30K
390	6.25	4,5	SW3DIN911	DSW30K
391.1212...	030.0422.T10P	3,0	T10PL	DT10PK
391.1616...	5.32.3T15P	5,0	T15PQ	DT15PK
391.2...	6.25	4,5	SW3DIN911	DSW30K
974	030.3509.T15P	3,0	T15PQ	DT15PK
B105/BU105 B105KM BU105	6.075T15P	5,0	T15PQ	DT15PK
B105.A022...	030.0422.T10P	3,0	T10PL	DT10PK
B105MD	DIN913-M5x5	1,0	SW2,5DIN911	DSW25K
B108 B108KM	2.6.5T8EP	1,2	T8PL	DT8PK
B110	6.075T15P	5,0	T15PQ	DT15PK
B111	3.5.12T10EP	3,0	T10PL	DT10PK
B114	4.12T15EP	5,0	T15PQ	DT15PK
B119	5.11T15P	3,0	T15PL	DT15PK
B209	3.5.12T10EP	2,5	T10PL	DT10PK
B216.0020.1.2...IK	3.5.12T10EP	3,0	T10PL	DT10PK
B216...IK	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
B223	5.11T15P	3,0	T15PL	DT15PK
B223...K2	4.09T15P	3,0	T15PL	DT15PK

螺钉扭矩

Torque of Screws



型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
B224.00...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
B224.45... B224.60...	6.14T25P	7,0	T25PQ	DT25PK/DT25PQ
BK224	5.13T20EP	6,5	T20PQ	DT20PK/DT20PQ
BK229	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
BKT	6.075T15P	5,5	T15PQ	DT15PK
E223	5.11T15P	3,0	T15PL	DT15PK
H34T...10.IK	030.4093.T15P	3,0	T15PQ	DT15PK
H34T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H34T...30.IK	030.5012.T15P	6,0	T15PQ	DT15PK
H34T...40.IK	030.5012.T20P	6,0	T20PQ	DT20PK/DT20PQ
H64T...10.IK	030.4010.T15P	4,0	T15PQ	DT15PK
H64T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H105	6.075T15P	5,0	T15PQ	DT15PK
H100...01/...11/...21 + IK H100...02/...12/...22 + IK H100...71/...72 H100...71R/L/...72R/L	4.15T15P	5,0	T15PQ	DT15PK
H100...03/...13/...23 H100...04/...14/...24 H100...15 H100...1.23.IK	5.17T20P	6,5	T20PQ	DT20PK/DT20PQ
H100...04.IK H100...23.IK/...24.IK H100...73.IK/...74.IK	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
H100...73R/L/...74R/L	DIN912-M5x20	4,0	SW4DIN911	DSW40K
H100...83/...84	030.505P.0718	5,0	T15PQ	DT15PK
H100...83R/L/N/...84R/L/N	030.505P.0660	5,0	T15PQ	DT15PK
H100...93/...93R/L	030.0413.T15P	3,0	T15PQ	DT15PK
H100.2020.3.0.. H100.2525.3.0.. H100.3225.3.0./...38 H100.3225.4.0./...4.1.. H100...08/...10/...12	030.6075.T20P	5,0	T20PQ	DT20PK
H100.3232...	030.0625.T25P	7,0	T25PQ	DT25PK/DT25PQ
H100.52...	5.13T20P	5,0	T20PQ	DT20PK/DT20PQ
H117...10/...12 H117.1407.../...1439... H117.1441.../...1442...	4.09T15P	5,0	T15PQ	DT15PK
H117.1010.10	030.400P0227	5,0	T15PQ	DT15PK
H117...16/...32/...45 H117.1419.../...1440...	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
H117...20/...26	6.17T20P	7,0	T20PQ	DT20PK/DT20PQ

螺钉扭矩

Torque of Screws



型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
H117MD	030.400P.0227	5,0	T15PQ	DT15PK
H223	5.11T15P	3,0	T15PL	DT15PK
H223.2608.../.3208...	4.15T15P	5,0	T15PL	DT15PK
H224	6.23T25P	6,0	T25PQ	DT25PK/DT25PQ
H224.1212.81	6.17T25P	5,0	T25PQ	DT15PK
H224.1608.02/.23/.24 H224.2608.81/.82/.83	4.15T15P	5,0	T15PQ	DT15PK
H224.2608.01/.02/.03 H224.3208.01/.02/.03	4.20T15P	4,3	T15PL	DT15PK
H224.3208.93	030.0413T15P	3,0	T15PQ	DT15PK
H224..61/..62/..63/..64+IK	4.12.T15EP	5,0	T15PQ	DT15PK
H224...65/...66/...83R	5.13.T20EP	6,5	T20PQ	DT20PK/DT20PQ
H262	030.2557.T8P	1,0	T8PL	DT8PK
H264 H264KM	3.5.12T10EP	3,0	T10PL	DT10PK
H274...04/...04.E	030.3509.T15P	3,0	T15PQ	DT15PK
H274...07	030.3513.T15P	3,0	T15PQ	DT15PK
H274KM	030.3509.T15P	3,0	T15PQ	DT15PK
H316	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
HC105	6.075T15P	5,5	T15PQ	DT15PK
HC105MD	DIN911-M4x5	1,0	SW2,0DIN911	SW20K
HC114	4.12T15EP	5,0	T15PQ	DT15PK
HC274KM	030.3509.T15P	3,0	T15PQ	DT15PK
HC316	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
KT274 KTC274	030.3509.T15P	3,0	T15PQ	DT15PK
L368	4.18T15EP	4,0	T15PQ	DT15PK
L849.0226.L...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LA210	218.3	7,0	SW6.911	DSW60K
LA226	218.3	7,0	SW6.911	DSW60K
LAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LNK368	5.10T20P	6,0	T20PQ	DT20PK/DT20PQ
LNK760	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
N849...10.00/...12.00	4.09T15P	5,0	T15PQ	DT15PK
N849...16.00/...32.00	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
N849...20.00/...26.00	6.17T20P	7,0	T20PQ	DT20PK/DT20PQ

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型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
N849....K1	DIN1835-B M10x12	6,0	SW5,0DIN911	DSW50K
NH105MD	DIN911-M4x5	1,0	SW2,0DIN911	SW20K
NK100	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK100.0840...	4.20T15P	4,3	T15PL	DT15PK
NK100.3215...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK224.0840...	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
NK264	4.20T15P	4,3	T15PL	DT15PK
NK274	030.3509.T15P	3,0	T15PQ	DT15PK
NK356	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	5,0	T15PQ	DT15PK
NK360.0840.1.01/02/03	030.0422.T10P	3,0	T10PL	DT10PK
NK360.0840.1.04	5.32.3T15P	5,0	T15PQ	DT15PK
NK368	030.400P.0602	4,0	T10PL	DT10PK
R76	030.3509.T15P	5,0	T15PQ	DT15PK
R849.0226.R...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
R849...K2	DIN913-M8x12	7,0	SW5DIN911	DSW50K
RA210	218.3	7,0	SW6.911	DSW60K
RA226	218.3	7,0	SW6.911	DSW60K
RAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RBA114	4.12.T15EP	5,0	T15PQ	DT15PK/DT15PQ
RIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RHC274	030.3509.T15P	5,0	T15PQ	DT15PK
RIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
SB105	6.075T15P	5,0	T15PQ	DT15PQ
SB110	6.075T15P	5,0	T15PQ	DT15PQ
SH117...08	030.3509.T15P	3,5	T15PQ	DT15PK
SH117...10/...12	4.09T15P	5,0	T15PQ	DT15PK
SH117...16	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
SHM117...08	030.3509.T15P	3,5	T15PQ	DT15PK
VDI	6.075T15P	5,0	T15PQ	DT15PK

侧车削

Side Turning

HORN-切槽刀具能为您提供轮廓和角度的绝对精准,即使使用单边侧刃切削时.
具有韧性的刀片可能适合一般车削,但不适合精密槽加工.

HORN-Grooving Tools will give you absolute accuracy of profile and angles, even when profiling with one-sided cutting forces.

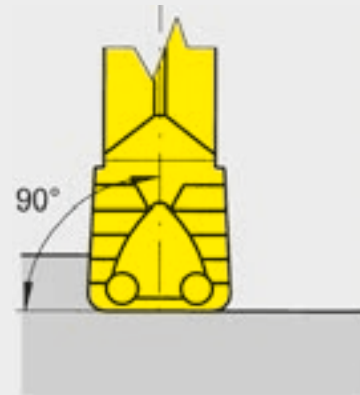
A flexible cutting edge would be desirable for turning, but not useful for precision grooving.

请注意刀具的设置

确保刀具一直和工件轴向成直角

Please note when setting tool:

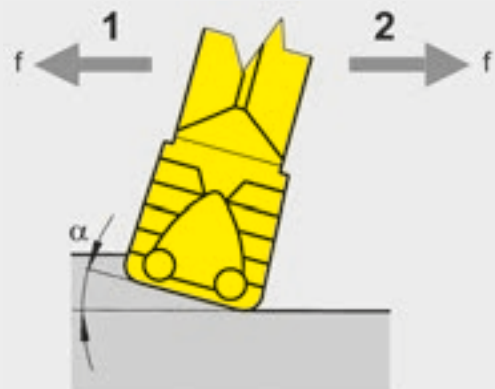
Always ensure that the tool is perpendicular to the axis of the workpiece.



不正确的操作

进给方向1将会产生振动,并将增加刚性工件的振动倾向.

进给方向2适合车削,对于操作不会有负面影响.



Improper setting:

Feed direction **1** will create vibrations. The tendency to vibrate will increase on rigid workpieces.

Feed direction **2** is suitable for turning and will have no negative effects to the operation.

侧车削 Side Turning

槽刀不能作为车刀的替代品使用,但某些加工中,使用槽刀进行车削,可以降低换刀次数并缩短加工周期

The grooving tool should not be seen as a replacement for a turning tool with ISO-inserts. On certain operations, for instance grooving and turning can reduce the number of tool changes and offer reduced cycle time.

刀片宽度:

4,5和6mm宽的刀片适合侧走,工件的轮廓和刚性决定了刀片宽度,并尽可能的选择最大的刀尖圆角.

Width of insert:

The width 4, 5 and 6 mm are recommended for side turning. The profile and rigidity of the workpiece determines the width of insert. Always choose the largest possible edge radius.

切深 a_p :

当需要横向切削时,切削深度决定于刀片宽度及工件的材质和刚性,最大切深受限于切削刃的长度

计算的经验

$$\begin{aligned} a_{p \max} &= w \times 0,7 \text{ 或者 } \max. 3,0 \text{ mm} \\ a_{p \min} &= \text{圆角半径 } (r) \end{aligned}$$

最小的切削深度 $a_{p \min}$ 来自刀尖圆角半径,如果切深小于刀尖圆角半径,切削状况将很差.

最大进给率 $f_{\max}$:
根据经验计算:

$$f_{\max} = w \times 0,1$$

Cutting depth a_p :

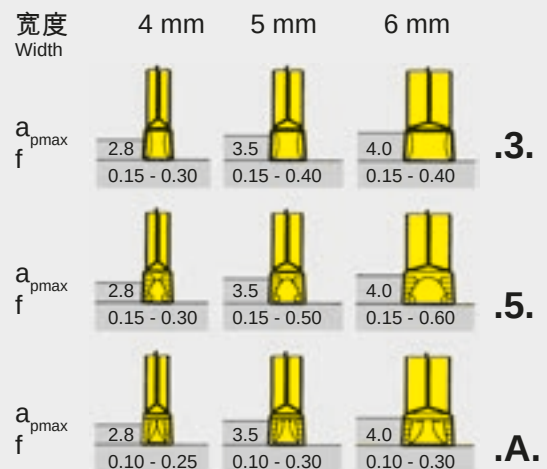
When side turning the cutting depth is dependent upon the width of insert as well as on the material and the rigidity of the workpiece. The max. depth would be limited by the length of the cutting edge.

Rule of thumb for calculation: $a_{p \max} = w \times 0,7 \text{ or } \max. 3,0 \text{ mm}$
 $a_{p \min} = \text{corner radius } (r)$

The smallest cutting depth $a_{p \min}$ is governed by the edge radius of the insert. Cutting depth below the corner radius will create poor cutting conditions.

Max. feed rate $f_{\max}$:

Rule of thumb for calculation: $f_{\max} = w \times 0,1$

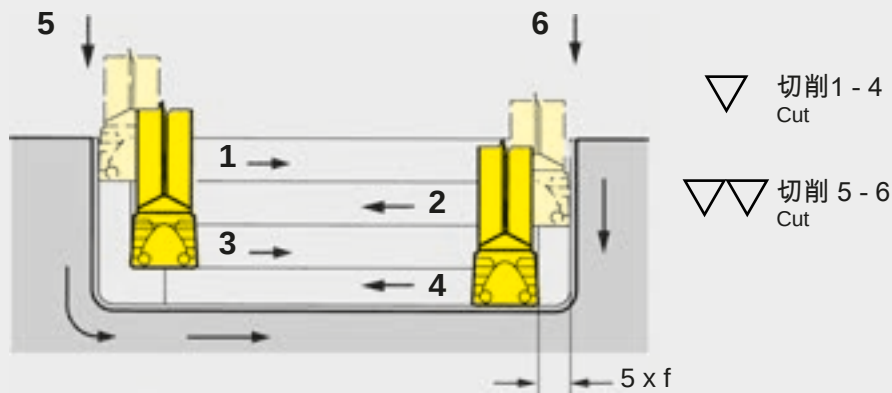


侧车削

Side Turning

双肩间的横向切削

Side turning between shoulders



刀片横走总是自一侧面开始至另一面结束.这样的横走影响切削的排出并有刀片崩损的危险.切槽和车削的建议见图所示.

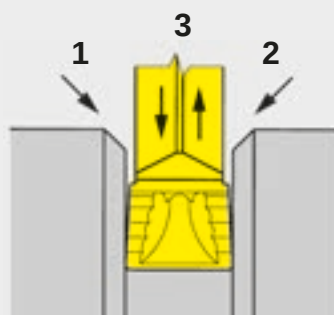
切削步骤2及后切削的起始位置都离肩部 $5 \times f$ 的距离,这样可以避免切屑卡在前行中的切削刃上.

Always start at the shoulder when side turning, towards shoulder. An operation towards the shoulder will influence the run off the chip and creates the risk of insert breaking. Grooving and turning is recommended as shown.

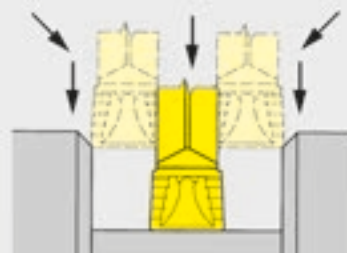
Cut 2 and subsequent cuts leave a distance of $5 \times f$ to the shoulder. This cut width will help to prevent swarf being trapped under the advancing cutting edge.

倒角 配合标准刀片

Chamfering with standard inserts



槽和刀片的宽度相等
Width of groove and insert are equal



槽比刀片宽
Groove wider than insert

精加工槽

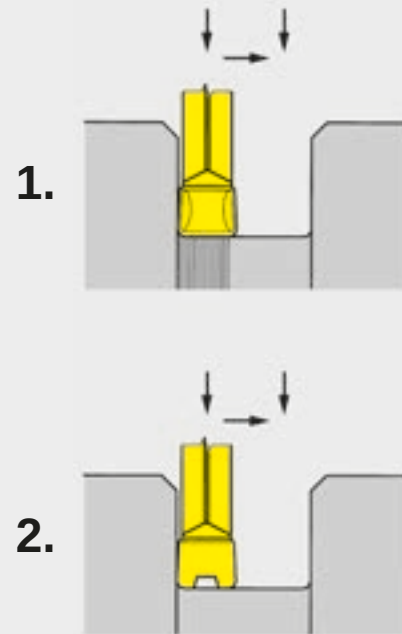
(密封槽)

Finishing of Grooves

(Sealing Grooves)

该工艺要求车削和切槽都达到很高的表面光洁度。
图2为修改后的 S224...NC...D2刀片。

This process requires both turning and grooving where very high quality surface finishes are required.
Diagram 2 shows the modified insert type S224...NC...D2.



环形余屑

SWarf RING CREATION

通过切削时通过重叠区域可以避免余屑环的产生。
锋利的切削刃和更小的刀尖角能够降低余屑环的产生。

Swarf ring creation can be avoided by turning across the smaller diameter in one continuous pass. Well defined cutting edges and small corner radii will reduce the tendency to create rings.



产生环形余屑
Ring creation

无环形铁屑
No ring creation

端面切槽 Face Grooving

刀夹的选择

选择适合加工的端面槽大径的刀夹

Cassette Selection

Select the cassette to suit the major diameter of the face groove to be cut.

稳定设置

刀具应该使用允许的最小悬伸以达到最大的稳定性.

Stable Setup

The tool should be set to give the minimum overhang to achieve maximum stability.

实践

当车端面槽时加工方向是由大径 $\varnothing$ -向小径 $\varnothing$.

Working Practice

When turning to open up the face groove the cut should be taken from the major $\varnothing$ towards the minor $\varnothing$.

刀具设置

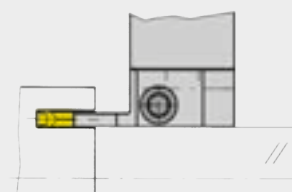
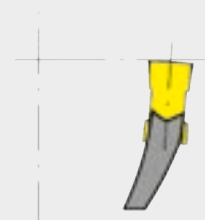
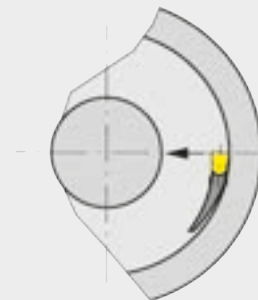
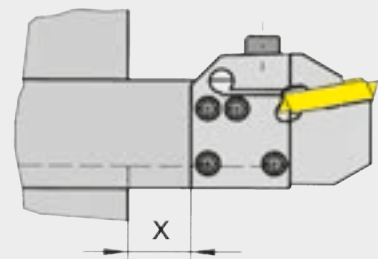
刀具应设定至中心高,确保正确的切削和支撑间隙.

Tool Setup

The tool should be set to centre height to ensure correct cutting and support clearance.

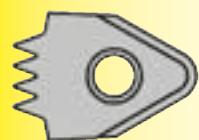
刀具必须平行于工件旋转轴.

The tool must be set parallel to the rotation axis of the workpiece.



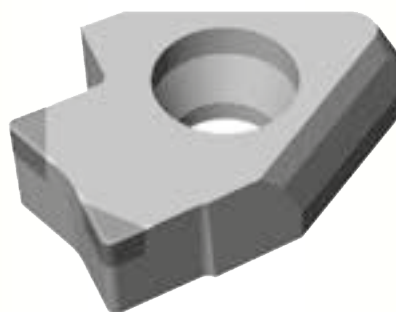
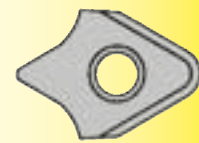
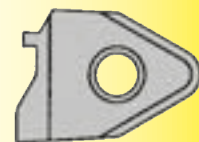
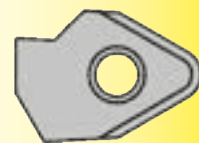
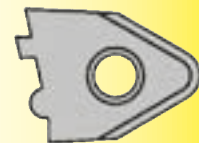
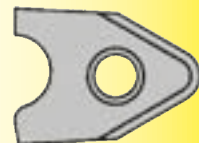
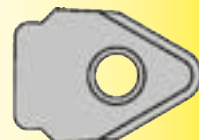
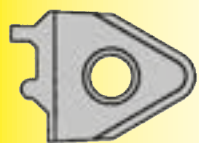
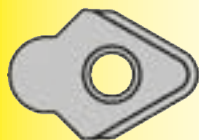
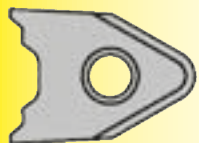
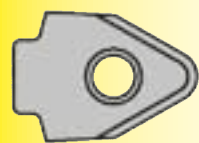
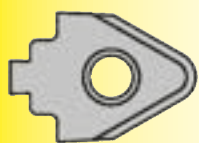
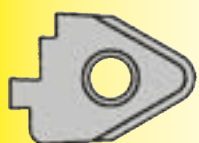
仿形刀片
Profiled Inserts

仿形实例
Examples of profiles



根据客户要求生产仿形刀片。
我们提供各种后角的刀片。如果客户想重磨刀片,建议使用小后角刀片。
每个刀片可重磨的次数决定于其磨损或破损的程度。

Profiled inserts are manufactured according to customer special requirements.
It is also possible to supply inserts with different relief angles. If the customer wants to regrind or resharpen the insert, we recommend to use small relief angles around the cutting edge profile.
How many times the customer can regrind the insert, depends on the condition of each individual insert.



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

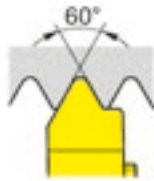
螺纹综述

Thread-Overview



ISO米制标准螺纹(外圆)

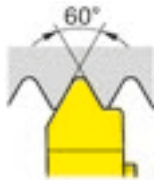
Metric ISO standard thread (external)



螺纹 Thread	非全牙型 Partial profile	全牙型 Full profile
M6 (M7)	R/L315.0610.01	R/L315.0610.02
M8 (M9)	R/L315.0712.01	R/L315.0712.02
M10 (M11)	R/L315.0915.01	R/L315.0915.02
M12	R/L315.1017.01	R/L315.1017.02
M14; M16	R/L315.1220.01	R/L315.1220.02
M18; M20; M22	R/L315.1525.01	R/L315.1525.02
M24; M27	R/L315.1830.01	R/L315.1525.02
M30; M33	R/L315.2135.01	R/L315.2135.02
M36	-	R/L315.2440.02
M24 - M68	R/L315.3060.01	-
M48; M52	-	R/L315.3050.02
M64; M68	-	R/L315.3660.02

ISO米制细牙螺纹(外圆)

Metric ISO fine thread (external)



螺纹 Thread	非全牙型 Partial profile	全牙型 Full profile
M7,5x1	R/L315.0610.01	R/L315.0610.02
M10x1,25	R/L315.0712.01	R/L315.0712.02
M12x1,5	R/L315.0915.01	R/L315.0915.02
M17x2	R/L315.1220.01	R/L315.1220.02
M24x2,5	R/L315.1525.01	R/L315.1525.02
M30x3	R/L315.1830.01	R/L315.1525.02

ISO米制细牙螺纹(内圆)

Metric ISO fine thread (internal)



螺纹 Thread	非全牙型 Partial profile	全牙型 Full profile
M45x1	R/L315.0510.01	R/L315.0510.02
M45x1,5	R/L315.0815.01	R/L315.0815.02
M48x2	R/L315.1020.01	R/L315.1020.02
M48x2,5	R/L315.1325.01	R/L315.1325.02
M48x3	R/L315.1630.01	R/L315.1630.02
M48x3,5	R/L315.1835.01	R/L315.1835.02

全牙,G螺纹(外圆)

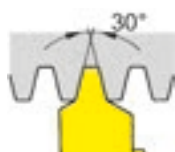
Full profile, Whitworth (external)



螺纹 Thread	全牙型 Full profile
G ^{1/16} / G ^{1/8}	R/L315.5528.02
G ^{1/4} / G ^{3/8}	R/L315.5519.02
G ^{1/2} / G ^{3/4}	R/L315.5514.02
G1 - G6	R/L315.5511.02

ISO米制梯形螺纹 DIN103 (外圆)

Metric ISO trapezoidal thread DIN103 (external)



螺纹 Thread	全牙型 Full profile
Tr8x1,5	R/L315.1015.02
Tr9-10x2	R/L315.1320.02
Tr12-14x3	R/L315.1730.02
Tr16-20x4	R/L315.2240.02
Tr22-28x5	R/L315.2750.02
Tr30-36x6	R/L315.3560.02

U

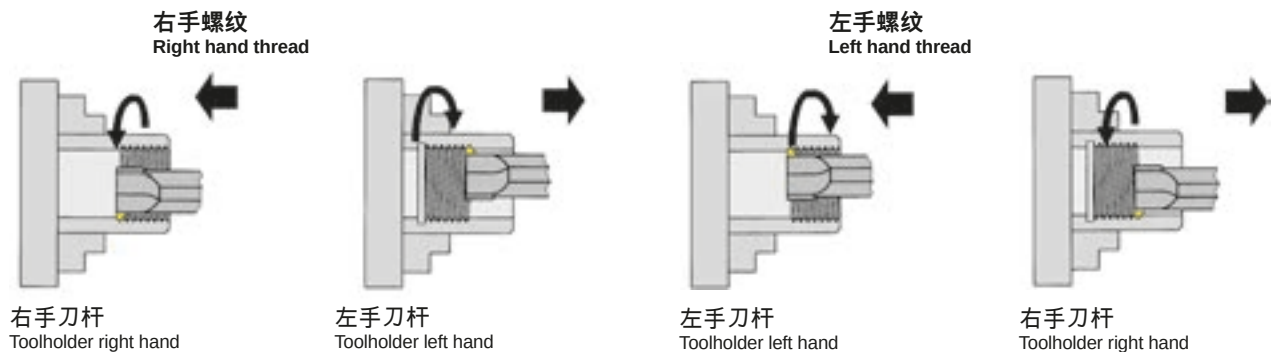
推荐走刀次数

Recommended number of passes

硬质合金牌号 Carbide grade		钢 (Nmm ² 拉伸强度) Steel (N/mm ² Tensile strength)					不锈钢 Stainless steel	灰铸铁 Grey cast iron	铝 Aluminium
TN35		400-500	500-700	700-850	850-1150	> 1150			
V _{max} m/min		160	140	120	90	70	90	100	300
螺距 / Pitch mm		走刀次数 / Number of passes							
每英寸齿数 tpi									
0,8	32	8	8	9	9	10	10	9	8
1,0	24	10	10	12	12	12	12	12	10
1,25	20-19	12	12	14	14	15	15	14	12
1,5	16	15	15	17	17	18	18	17	15
1,75	14	17	17	19	19	21	21	18	17
2,0	12-11	19	20	22	22	25	25	20	18
2,5	10	22	24	26	26	31	31	22	20
3,0-3,5	8	28	30	32	32	38	38	24	22

内螺纹进给方向

Feed direction internal threading



进给

In-Feed

径向进给

Radial In-Feed

同时切削刀片两边的材料,这是加工螺纹时最普通的方法。

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

改进的侧进给

Modified flank in-feed

更小的后刀面磨损和相应的工件侧面上的更好的表面光洁度。

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

变化的后刀面进给

Alternating flank in-feed

两个刃都被充分利用,意味着刀片寿命更长。

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

后刀面进给

Flank in-feed

更好的断屑和散热。

More easily formed chip and better heat dissipation.



切断

Parting Off

方形切削刃的可转位刀片

方形切削刃的刀片是加工中的最佳选择,尽可能的使用该类刀片.

- 优点:
- 增加刀具寿命
 - 更好的切屑控制和表面质量
 - 可选择更高的切削参数

Indexable inserts with square cutting edge

The best selection for applications are inserts with a square cutting edge, wherever possible to use them.

- Advantages:
- increased tool life
 - better swarf control and a high surface quality will be obtained
 - possibility to choose the maximum cutting data

进给率

使用正切削角时进给率最高可能降低40%,这也会受到零件材质的拉伸强度的影响.

Feed rates

The feed rate when cutting with front cutting angle will need to be reduced up to 40 %. This may also be influenced by the tensile strength of the material to be cut.

切屑控制

通过选择合适的切削速度和进给率以得到最好的切屑控制和表面光洁度.

Swarf control

Best swarf control and highest surface finish will be obtained by choosing the right speed and feed rate.

避免尖角

通过使用左手或右手刀具并调整正确的中心高可以减小尖角和毛刺的发生.

Avoiding Pips

By using right or left handed inserts and the correct centre height occurring of pips and burrs can be reduced.

切断时有副主轴或工件夹具

具有副主轴或夹持夹具可以在切断加工时保护切削刃.如果无夹持的话在切断时要求越接近工件中心进给越小.

Parting off with a sub spindle or part catcher

The cutting edge will be protected by having a second spindle or fixture to pick up the workpiece. Parting off without a support requires the feed rate to be reduced as the tool approaches centre.

凹或凸曲面

曲面的产生可以通过使用左手或者右手刀具降低进给率避免.

Convex or concave surfaces

Convex or concave surfaces will be avoided when using right or left hand inserts by reducing the feed rate.

冷却

丰富而有目的性的冷却能够延续刀具寿命.

Coolant

A copious well aimed coolant supply will give long tool life.

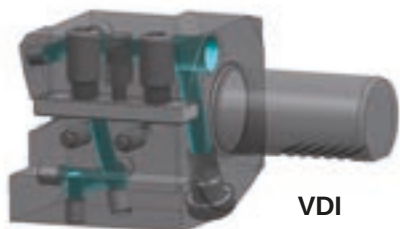
不同方法的冷却液供应.

Different methods of coolant supply.



外部连接 如:通过高压泵输入刀柄

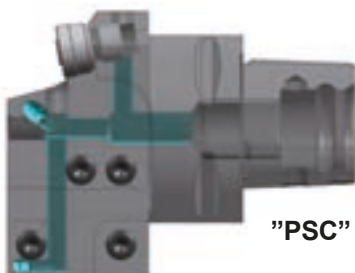
External connection e.g. through high pressure pump to the toolholder.



VDI

内部连接 通过刀塔输入刀柄.

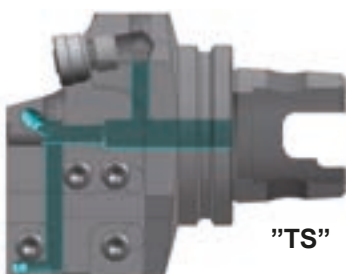
Internal connection through turret to the toolholder.



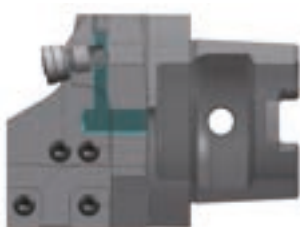
"PSC"

内部连接通过刀柄输入刀夹

Internal connection through toolholder back-end to the cassette.



"TS"



HSK

冷却液供应选择

Coolant supply options.



冷却液通过刀片侧边的喷嘴输出

Coolant outlet through spray nozzle at the side of the insert.



冷却液通过刀片侧边的喷嘴输出

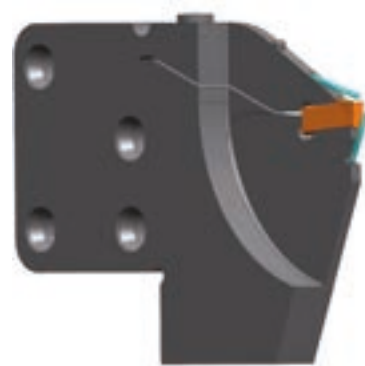
Coolant outlet through spray nozzle at the side of the insert.



冷却液通过夹紧部位输出

Coolant outlet through clamping finger.

S100
S224
S229



冷却液通过夹紧部位上下输出

Coolant outlet through clamping finger and insert support.

S100
S224
S229



冷却液通过刀片输出

Coolant outlet through insert.

S100
S224

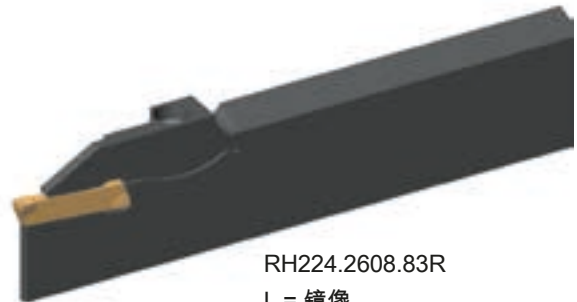
强化型刀片-定位 Reinforced Blades - Positioning

定位
"上端朝下"
Position
"upside down"

副主轴
Subspindle

主轴
Mainspindle

M4 逆时针
M4 Anticlockwise



RH224.2608.83R
L = 镜像
L = mirror inverted

定位
"正常"
Position
"normal"

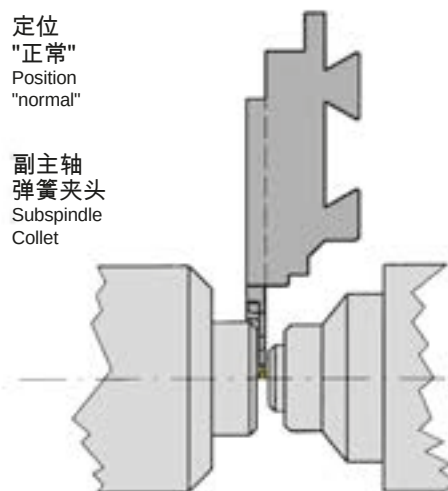
副主轴
弹簧夹头
Subspindle
Collet

主轴
Mainspindle

M3 顺时针方向
M3 Clockwise



LH224.2608.83
R = 镜像
R = mirror inverted

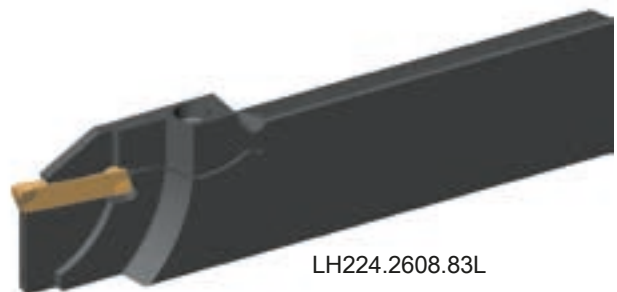


定位
"正常"
Position
"normal"

副主轴
弹簧夹头
Subspindle
Collet

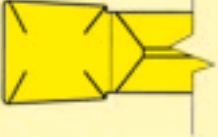
主轴
Mainspindle

M3 顺时针方向
M3 Clockwise



LH224.2608.83L
R = 镜像
R = mirror inverted

所有的刀片都可增加这些增强结构的非标设计
These special reinforced form can be produced on all blades.

槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.3. 	切槽,槽精加工, 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料. grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,03 - 0,15 ↔ 0,05 - 0,20 a_{pmax} 1,5
.C. 	切断,适合长切屑材料 parting off, for long chipping materials	↓ 0,02 - 0,12
.5. 	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,08 - 0,20 ↔ 0,15 - 0,20 a_{pmax} 1,5

↓ 切槽
Grooving ↔ 侧车削
Side turning

槽型和进给率 型号 S209 / 216
Geometries and feed rates type S209 / 216



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.1A. 	切槽,槽精加工,长切屑材料,低进给率. grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,03 - 0,12
.5. 	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,06 - 0,20 ↔ 0,05 - 0,20
.KF 	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,03 - 0,15 ↔ 0,05 - 0,15
↓ 切槽 Grooving ↔ 侧车削 Side turning		

槽型和进给率 型号 217

Geometries and feed rates type 217



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.00 	切槽,槽精加工,长切屑材料,低进给率. grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,02 - 0,12
非标刀片的断屑槽 Chipbreaker for special inserts 	切槽,槽精加工, 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料. grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,02 - 0,12



切槽
Grooving



侧车削
Side turning

槽型和进给率 型号 224 / S224

Geometries and feed rates type 224 / S224



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.3.	切槽,侧车削,仿形槽加工,适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,15 - 0,25 ↔ 0,15 - 0,40*
.5.	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度. grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,10 - 0,45 ↔ 0,15 - 0,60*
.A.	切槽,侧车削,仿形槽加工,加工中等拉伸强度材料时出色的断屑性能. grooving, side turning, finishing or profiling of grooves, excellent chip breaking in materials with medium tensile strength	↓ 0,05 - 0,30 ↔ 0,10 - 0,30*
.C.	切断,适合长切屑材料 parting off, for long chipping materials	↓ 0,02 - 0,10
.D.	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,03 - 0,15 ↔ 0,05 - 0,20
.E./EN.	切槽,侧车削,仿形槽加工,适合加工高拉伸强度材料. grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,08 - 0,30
.F./FY	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,03 - 0,15
.H.	啄削槽,局部轮廓切削,长切屑. grooving in "pecking process", profiling in partial cut, for long chipping	↓ 0,15 - 0,25 ↔ 0,10 - 0,25
.K./KF	切槽,侧车削,仿形槽加工. grooving, side turning, finishing or profiling of grooves	↓ 0,05 - 0,25 ↔ 0,05 - 0,25
.L.	全刃或局部切削时都有良好的切屑控制 control in full and partial cut with excellent chip control	↓ 0,10 - 0,22 ↔ 0,05 - 0,20
.ZG.	切槽,侧车削,仿形槽加工 grooving, side turning, profiling of grooves	↓ 0,10 - 0,22 ↔ 0,05 - 0,20

* 决定于刀片宽度,刃尖圆角和材质

* dependent upon insert width, edge radii and material

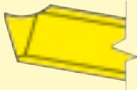
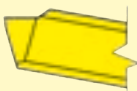
↓ 切槽
Grooving

↔ 侧车削
Side turning

槽型和进给率 型号 229/S229

Geometries and feed rates type 229/S229



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.10 	切槽,槽精加工,长切屑材料,低进给率. grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,05 - 0,15
.20 	切槽,槽精加工, 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,07 - 0,25
.3. 	切槽,侧车削,仿形槽加工,适合加工高拉伸强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,15 - 0,25 ↔ 0,15 - 0,40*
.5. 	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度. grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,10 - 0,45 ↔ 0,15 - 0,60*
.A. 	切槽,侧车削,仿形槽加工,加工中等拉伸强度材料时出色的断屑性能. grooving, side turning, finishing or profiling of grooves, excellent chip breaking in materials with medium tensile strength	↓ 0,05 - 0,30 ↔ 0,10 - 0,30*
.C. 	切断,适合长切屑材料 parting off, for long chipping materials	↓ 0,02 - 0,10
.E./EN 	切槽,侧车削,仿形槽加工,适合加工高拉伸强度材料. grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,08 - 0,30
.F./FY 	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,03 - 0,15
.H. 	啄削槽,局部轮廓切削,长切屑. grooving in "pecking process", profiling in partial cut, for long chipping	↓ 0,15 - 0,25 ↔ 0,10 - 0,25
.HR. 	满槽或局部切削时都有良好的切屑控制 grooving in full and partial cut with excellent chip control	↓ 0,20 - 0,30
.L. 	满槽或局部切削时都有良好的切屑控制 grooving in full and partial cut with excellent chip control	↓ 0,10 - 0,22 ↔ 0,05 - 0,20
.K./KF 	切槽,侧车削,精加工或仿形加工槽. grooving, side turning, finishing or profiling of grooves	↓ 0,05 - 0,25 ↔ 0,05 - 0,25
.N. 	切槽,侧车削,精加工或仿形加工槽,出色断屑用于加工中等拉伸强度材料. grooving, side turning, finishing or profiling of grooves, excellent chip breaking in materials with medium tensile strength	↓ 0,05 - 0,25 ↔ 0,05 - 0,20

* 决定于刀片宽度,刃尖圆角和材质

* dependent upon insert width, edge radii and material



切槽
Grooving



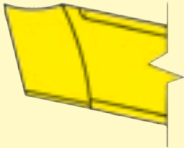
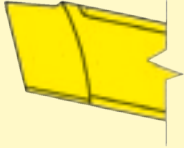
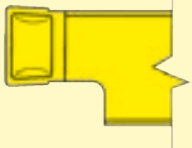
侧车削
Side turning

U

槽型和进给率 型号 231

Geometries and feed rates type 231



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.10 	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,02 - 0,12
.20 	切槽,槽精加工, 刀片断屑槽轮廓,适合短切屑和高拉伸强度的材料. grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,02 - 0,12
.3. 	切槽,侧车削,仿形槽加工, 适合长切屑和高拉伸强度的材料. grooving, side turning, profiling and finishing of grooves, for long chipping materials with high tensile strength	↓ 0,15 - 0,25 ↔ 0,15 - 0,40*

* 决定于刀片宽度,刃尖圆角和材质
 * dependent upon insert width, edge radii and material

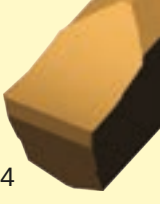
↓ 切槽 ↔ 侧车削
 Grooving Side turning

U

槽型和进给率 型号 264 / S264

Geometries and feed rates type 264 / S264



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.10  264	切槽和切断 Grooving and parting off	↓ 0,02 - 0,08
.20  264	切槽和切断,用于高强度材料 Grooving and parting off for materials high tensile strength	↓ 0,02 - 0,08
.D1  S264	切槽和车削 Grooving and turning	↓ 0,03 - 0,13 ↔ 0,05 - 0,20 $a_{pmax} = 1,5 \times w$
.M0  264	切槽,车削和切断用于黄铜 (Ms58) Grooving, turning and parting off for Brass (Ms58)	↓ 0,02 - 0,10 ↔ 0,02 - 0,15
.P.  264	切槽和切断 Grooving and parting off	↓ 0,02 - 0,08 ↔ 0,02 - 0,04 $a_{pmax} = 1,5 \times w$



切槽
Grooving



侧车削
Side turning

U

槽型和进给率 型号 S274

Geometries and feed rates type S274



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.10 	切槽,精加工槽,长屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,02 - 0,12
.M. 	切槽,精加工槽,仿形加工槽型,短屑材料和高强度材料. grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,02 - 0,12
.P. 	切槽和车削(单方向) Grooving and turning (in one direction)	↓ 0,02 - 0,10 ↔ 0,02 - 0,10

↓切槽
Grooving

↔侧车削
Side turning

槽型和进给率 型号 34T

Geometries and feed rates type 34T



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.3. 	切槽,侧车削,仿形槽加工, 适合长切屑和高拉伸强度的材料. grooving, side turning, profiling and finishing of grooves, for long chipping materials with high tensile strength	↓ 0,15 - 0,25 ↔ 0,15 - 0,40*
.5. 	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度. grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,08 - 0,25 ↔ 0,10 - 0,20*
.D. 	切槽,仿形加工槽,适合高强度材料. grooving, profiling of grooves, suitable for materials with high tensile strength	↓ 0,03 - 0,15 ↔ 0,05 - 0,20

* 决定于刀片宽度,刃尖圆角和材质

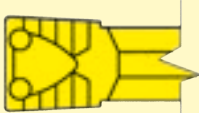
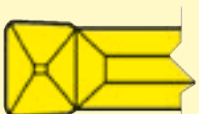
* dependent upon insert width, edge radii and material



切槽
Grooving



侧车削
Side turning

槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.00  312	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,02 - 0,12
非标刀片的断屑槽 Chipbreaker for special inserts  312	切槽,槽精加工, 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,02 - 0,12
.V.  312	切槽,出色的切削控制. grooving, with excellent chip control	↓ 0,04 - 0,15
.F.  S312	切槽,仿形槽加工,易切削. grooving, profiling of grooves, easy cut	↓ 0,03 - 0,15
.5.  S312	切槽,侧车削,仿形槽加工,加工中等拉伸强度的材料时能很好的减小切屑宽度. grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,08 - 0,25 ↔ 0,10 - 0,20*
.D.  S312	切槽,仿形槽加工,适合加工高拉伸强度材料. grooving, profiling of grooves, suitable for materials with high tensile strength	↓ 0,03 - 0,15 ↔ 0,05 - 0,20
.C.  S312	切断,切槽 parting off, grooving	↓ 0,02 - 0,10

* 决定于刀片宽度,刃尖圆角和材质
* dependent upon insert width, edge radii and material



切槽
Grooving



侧车削
Side turning

槽型和进给率 型号 315 / S315

Geometries and feed rates type 315 / Sf15



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.00  315	切槽,槽精加工,长切屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,02 - 0,12
非标刀片的断屑槽 Chipbreaker for special inserts  315	切槽,槽精加工, 刀片断屑槽轮廓适合短切屑和高拉伸强度的材料 grooving, finishing of grooves, geometry for inserts with profile, for short chipping materials and high tensile strength	↓ 0,02 - 0,12
.EN.  S315	切槽,侧车削,仿形加工槽,适合高强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,08 - 0,15
.FL.  S315	切槽,槽精加工,适合长屑材料,在低进给率下优秀的切屑控制 grooving, finishing of grooves, for long chipping materials, "low feed rates" with excellent chip control	↓ 0,03 - 0,15
.FY.  S315	切槽,槽精加工,适合长切屑材料,在低进给率下优秀的切屑控制 grooving, finishing of grooves, for long chipping materials, "low feed rates" with excellent chip control	↓ ↔ 0,03 - 0,15
.L.  S315	切满槽和单边切削,优秀的切屑控制 grooving in full and partial cut with excellent chip control	↓ ↔ 0,10 - 0,15 ↔ 0,05 - 0,10



切槽
Grooving



侧车削
Side turning

U

槽型和进给率 型号 S316

Geometries and feed rates type S316



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.5.	切槽,侧车削,仿形加工槽,在中等强度材料下可减小切屑宽度 grooving, side turning, profiling of grooves, excellent reduction of chip width in materials with medium tensile strength	↓ 0,06 - 0,25
.EN.	切槽,侧车削,仿形加工槽,适合高强度材料 grooving, side turning, profiling of grooves, suitable for materials with high tensile strength	↓ 0,08 - 0,20
.FY.	切槽,槽精加工,适合长屑材料,在低进给率下出色的切屑控制 grooving, finishing of grooves, for long chipping materials, "low feed rates" with excellent chip control	↓ 0,03 - 0,15

↓

切槽
Grooving

↔

侧车削
Side turning

U

槽型和进给率 型号 64T

Geometries and feed rates type 64T



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.1A 	切槽,槽精加工,适合长屑材料,低进给率 grooving, finishing of grooves, for long chipping materials, low feed rates	↓ 0,03 - 0,12
.DL 	切槽,侧车削,槽精加工和仿形加工 grooving, side turning, finishing or profiling of grooves	↓ 0,05 - 0,15 ↔ 0,05 - 0,20

↓ 切槽
Grooving ↔ 侧车削
Side turning

U

适合铝合金的槽型及进给率

Geometries and feed rates for Aluminium



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)
.WA. 	切槽和切断,槽精加工,轻快切削. Grooving and parting off, finishing of grooves, easy cut	↓ 0,07 - 0,25
↓ 切槽 Grooving ↔ 侧车削 Side turning		

切削参数

Cutting data

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

槽型和进给率 切断

Geometries and feed rates Parting off



槽型 Geometry	应用 Applications	进给率 f (mm/U) Feed rate f (mm/rev)	可选择的几何槽型和前角 Available geometries and lead angle								
			S100	S123/S223	S274	S264	S224	229/S229	312/S312	S315	S316
 .00	切断 Parting off 薄壁管材 Tubes with small thickness	0,02 - 0,10							0°		
		0,02 - 0,08							5°		
		0,02 - 0,06				8°			8°		
		0,02 - 0,05			15°	15°			12°		
 .00	切断带切屑成形 Parting off with chip former	0,02 - 0,15							0°		
		0,02 - 0,15							5°		
 .M.	切断脆性材料 (MS58) Parting off brittle materials (MS58)	0,02 - 0,15							0°	0°	
		0,02 - 0,15							5°		
		0,02 - 0,12				8°					
		0,02 - 0,10				15°					
 .V.	切断带切屑成形 Parting off with chip forming	0,02 - 0,12							0°		
		0,02 - 0,08							5°		
 .3V.	切断 Parting off	0,05 - 0,2	0°								
 .C.	切断 Parting off	0,02 - 0,10		0°			0°	0°	0°		
		0,02 - 0,08		4°			5°	5°	5°		
		0,02 - 0,06		8°			8°	8°	8°		
		0,02 - 0,05		15°			15°				
 .E.	切断 Parting off	0,02 - 0,12	0°				0°	0°			
		0,05 - 0,12	5°				5°				
 .EN	切断 Parting off	0,10 - 0,25	0°				0°	0°			0°
		0,10 - 0,20	5°								
 *.D. (.32)	切断 Parting off	0,02 - 0,10		0°			0°		0°		
 .F.	切断 Parting off	0,02 - 0,12	0°				0°	0°			
		0,02 - 0,10	5°				5°				
 .3.	切断 Parting off	0,10 - 0,15					0°	0°			
		0,08 - 0,12						5°			
 .N.	切断 Parting off	0,05 - 0,2	0°					0°			

* 仅刀片 S123 / S223

* only Inserts S123 / S223

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切削参数 切槽和切断

Cutting data Grooving and parting off



材料 Material			硬度 Hardness 布氏硬度 (HB)	切削速度 v _c (m/min) Cutting speed v _c (m/min)										
				K10	MG12	P20	TI22 TN32	TI25 TN35	TA45 TH35	TA46	AS62	AL96 AS66	H20	H54
P	碳钢 Carbon steel	0,2% C	140			180-120	200-160	180-130	200-160	280-180	250-180	300-180	230-170	200-140
		0,4% C	180			160-110	180-150	170-120	180-150	250-140	230-170	270-150	220-160	180-120
		0,6% C	200			140-90	180-140	150-100		230-120	220-160	250-120	210-150	160-100
	合金钢 Alloyed steel (<5%)	退火 annealed	180			140-100	180-140	160-110	180-140	230-100	200-150	250-100	210-150	180-120
		调质 quenched	280			110-90	160-110	130-90		190-90	160-110	220-90	170-120	160-100
		调质 quenched	350			80	140-90	100-70		170-80	130-100	200-80	140-80	120-80
	高合金钢 high alloyed steel (>5%)	退火 annealed	200			120-80	120-90			200-140	180-120	220-140	120-100	100-90
		硬化 hardened	-											
	铸钢 Cast steel	非合金 unalloyed	180				130-100				200-150	200-150	180-120	
		合金 alloyed	220				110-80				160-100	150-90	140-90	
M	不锈钢 Stainless steel	马氏体,铁素体 martensitic, ferritic	200		90-70		130-100	120-60		180-120	170-120	190-140	190-120	
		奥氏体 austenitic	180		90-60			100-70		140-110		140-110	170-120	
K	灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	180	90-60	80-60				130-90	180-120	180-120	200-120		
		高拉伸强度 high tensile strength	250	90-60	80-60				90-70	140-100	140-100	160-120		
	球墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160				90-70	90-70	120-80	170-90	170-90	180-130		
		珠光体 perlitic	250				70-60	70-60	110-80	180-80	150-80	160-120		
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125		100-80		140-120	100-70		120-100	190-140	220-120		
		珠光体 perlitic	225		70-50		100-80	80-60		90-80	140-100	190-100		
N	铝合金 Al-alloys	非热处理 not heat treatable	30-80	1000-600	800-400			1000-600						
		热处理 heat treatable	80-120	400-220	300-200			400-220						
	铸铝合金 Al-cast-alloy	非热处理 not heat treatable	80	1000-600	800-400			1000-600						
		热处理 heat treatable	100	600-300	400-250			600-300						
	铜合金 Copper-alloys	非热处理 not heat treatable	90	200-120			200-150	210-130		200-150				
		热处理 heat treatable	100	150-90			150-60	160-90		150-110				
S	耐热合金(铁基) Heat resistant alloy (Fe)	退火 annealed	200		50-30			50-30						
		硬化 hardened	275		40-20			40-20						
	耐热合金 (镍基,钴基) Heat resistant alloy (Ni, Co)	退火 annealed	250		30-20			30-20						
		硬化 hardened	350		20-10			20-10						

切削参数 端面槽

Cutting data Face grooving



材料 Material			硬度 Hardness 布氏硬度 (HB)	切削速度 v _c (m/min) Cutting speed v _c (m/min)										
				K10	MG12	P20	Ti22 TN32	Ti25 TN35	TA45 TH35	TA46	AS62	AS66	H20	H54
P	碳钢 Carbon steel	0,2% C	140			140-100	160-130	140-110	160-130	220-140	200-140	240-140	190-140	200-140
		0,4% C	180			130-90	140-120	130-100	140-120	200-120	190-130	220-120	180-130	180-120
		0,6% C	200			120-80	140-120	120-180		190-100	180-130	200-100	170-120	160-100
	合金钢 Alloyed steel (<5%)	退火 annealed	180			120-80	140-120	140-100	140-120	190-80	160-120	200-80	170-120	180-120
		调质 quenched	280			90-70	140-90	110-80		170-80	140-90	180-80	140-100	160-100
		调质 quenched	350			60	120-70	80-60		140-60	110-80	160-70	120-60	120-80
	高合金钢 high alloyed steel (>5%)	退火 annealed	200			100-60	100-70			160-120	150-100	180-120	110-80	100-90
		硬化 hardened	-											
	碳钢 Cast steel	非合金 unalloyed	180				110-80				160-120	160-120	140-100	
		合金 alloyed	220				90-60				140-80	120-80	120-80	
M	不锈钢 Stainless steel	马氏体,铁素体 martensitic, ferritic	200		80-60		110-80	110-50		160-100	130-110	150-120	150-100	
		奥氏体 austenitic	180		60-40			80-60		120-100		110-80	140-100	
K	灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	180	70-50	70-50				110-70	140-100	140-100	160-100		
		高拉伸强度 high tensile strength	250	70-50	70-50				80-60	120-80	120-80	140-100		
	球墨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160				90-60	80-60	100-60	140-80	150-70	150-110		
		珠光体 perlitic	250				80-60	60-50	90-60	130-70	120-60	140-100		
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125		80-60		120-100	80-60		100-80	160-110	180-100		
		珠光体 perlitic	225		60-40		80-60	60-50		80-60	120-80	150-120		
N	Al-Legierungen Al-alloys	nicht vergütbar not heat treatable	30-80	1000-600	800-400			1000-600						
		vergütbar heat treatable	80-120	400-220	300-200			400-220						
	铸铝合金 Al-cast-alloy	非热处理 not heat treatable	80	1000-600	800-400			1000-600						
		热处理 heat treatable	100	600-300	400-250			600-300						
	铜合金 Copper-alloys	非热处理 not heat treatable	90	160-100			160-130	190-110						
		热处理 heat treatable	100	130-80			130-60	140-80						
S	耐热合金 (铁基) Heat resistant alloy (Fe)	退火 annealed	200		40-30			40-30						
		硬化 hardened	275		35-20			35-20						
	耐热合金 (镍基,钴基) Heat resistant alloy (Ni, Co)	退火 annealed	250		25-20			20-10						
		硬化 hardened	350		20-10			20-10						

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切削参数 端面槽 型号 S15A/S25A

Cutting data Face grooving type S15A / S25A



材料 Material			硬度 Hardness 布氏硬度 (HB)	切削速度 v _c (m/min) Cutting speed v _c (m/min)	进给率 f (mm/U) Feed rate f (mm/rev)
				TH35	
P	碳钢 Carbon steel	0,2% C	140	110 - 140	0,02 - 0,05
		0,4% C	180	100 - 130	
		0,6% C	200	90 - 120	
	合金钢 Alloyed steel (<5%)	退火 annealed	180	100 - 140	0,02 - 0,03
		调质 quenched	280	80 - 110	
		调质 quenched	350	60 - 80	
	高合金钢 high alloyed steel (>5%)	退火 annealed	200	60 - 80	0,02 - 0,03
	铸钢 Cast steel	非合金 unalloyed	180	100 - 140	0,02 - 0,03
		合金 alloyed	220	80 - 110	
M	不锈钢 Stainless steel	马氏体,铁素体	200	50 - 120	0,02 - 0,03
		martensitic, ferritic			
		奥氏体 austenitic	180	50 - 110	
K	灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	180	100 - 140	0,01 - 0,03
		高拉伸强度 high tensile strength	250	80 - 120	
	球磨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	160	80 - 140	
		珠光体 perlitic	250	70 - 130	
	可锻铸铁 Malleable cast iron	铁素体 ferritic	125	80 - 100	
		珠光体 perlitic	225	60 - 80	
N	铝合金 Al-alloys	非热处理 not heat treatable	30-80	100 - 600	0,01 - 0,08
		热处理 heat treatable	80-120	100 - 600	
	铸铝合金 Al-cast-alloy	非热处理 not heat treatable	80	100 - 600	
		热处理 heat treatable	100	100 - 600	
	铜合金 Copper-alloys	非热处理 not heat treatable	90	110 - 190	
		热处理 heat treatable	100	80 - 140	
S	耐热合金(铁基) Heat resistant alloy (Fe)	退火 annealed	200	30 - 40	0,01 - 0,02
		硬化 hardened	275	20 - 35	
	耐热合金(镍基,钴基) Heat resistant alloy (Ni, Co)	退火 annealed	250	15 - 75	
		硬化 hardened	350	18 - 40	

Horn各牌号对应名义切削速度

Nominal cutting speeds with HORN grades

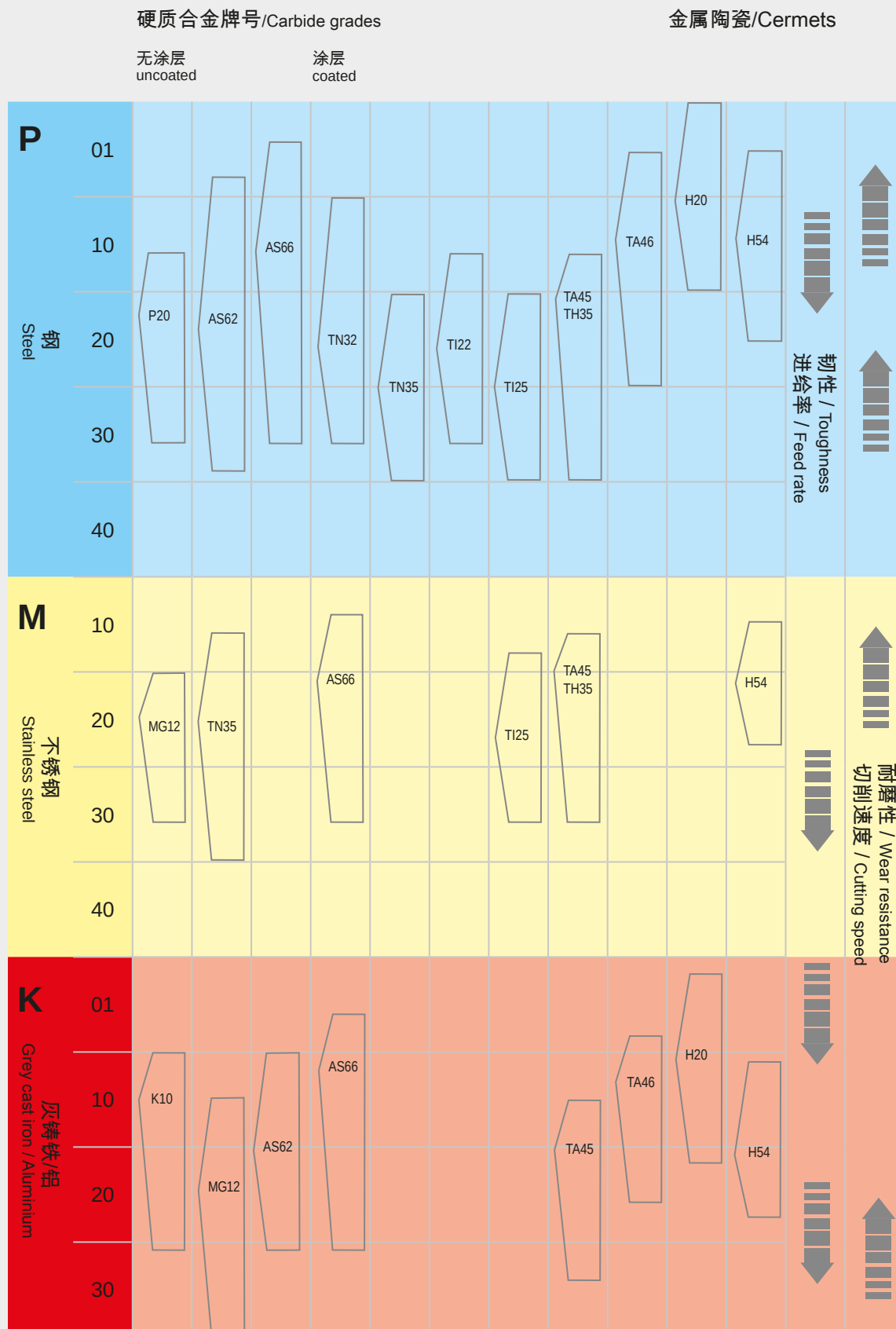
材料 Material			硬度 Hardness 布氏硬度 (HB)	* 切削速度 v_c (m/min) *Cutting speed v_c (m/min)			
				MG12	TN35	Ti25	TA45 / TH35
P	碳钢, 非合金 Carbon steel, unalloyed	C < 0,4%	125	14-110	14-180	14-180	14-180
		C > 0,4% < 0,6%	150	14-110	14-180	14-180	14-180
		C > 0,6% < 0,8%	200	14-110	14-180	14-180	14-180
	低合金钢 low alloyed steel	退火 annealed	180	16-90	16-150	16-150	
		调质 quenched	275	16-90	16-150	16-150	
		调质 quenched	160	16-90	16-150	16-150	
	高合金钢 high alloyed steel	退火 annealed	200		19-90	19-90	
		调质 quenched	325		19-90	19-90	
	铸钢 Cast steel	调质 unalloyed	180	19-110	19-180	19-180	
		低合金 low alloyed	200	19-110	19-180	19-180	
		高合金 high alloyed	225	19-110	19-180	19-180	
M	不锈钢 Stainless steel	马氏体, 铁素体, 退火 martensitic, ferritic, annealed	200		19-90	19-90	
		奥氏体 austenitic Ni>8%/Cr 18-20%	180		16-80		
N	铝合金 Al-alloys			14-220	16-600	16-600	
	铜和铜合金 Copper and brass alloys			14-220	14-700	14-700	
S	耐热合金 Heat resistant alloy	NiFe				18-75	18-75
		NiCo				18-40	18-40

v_c 决定于孔径及机床的最大转速

v_c is depending on the bore diameter and therefore of the maximum numbers of revolutions of the machine.

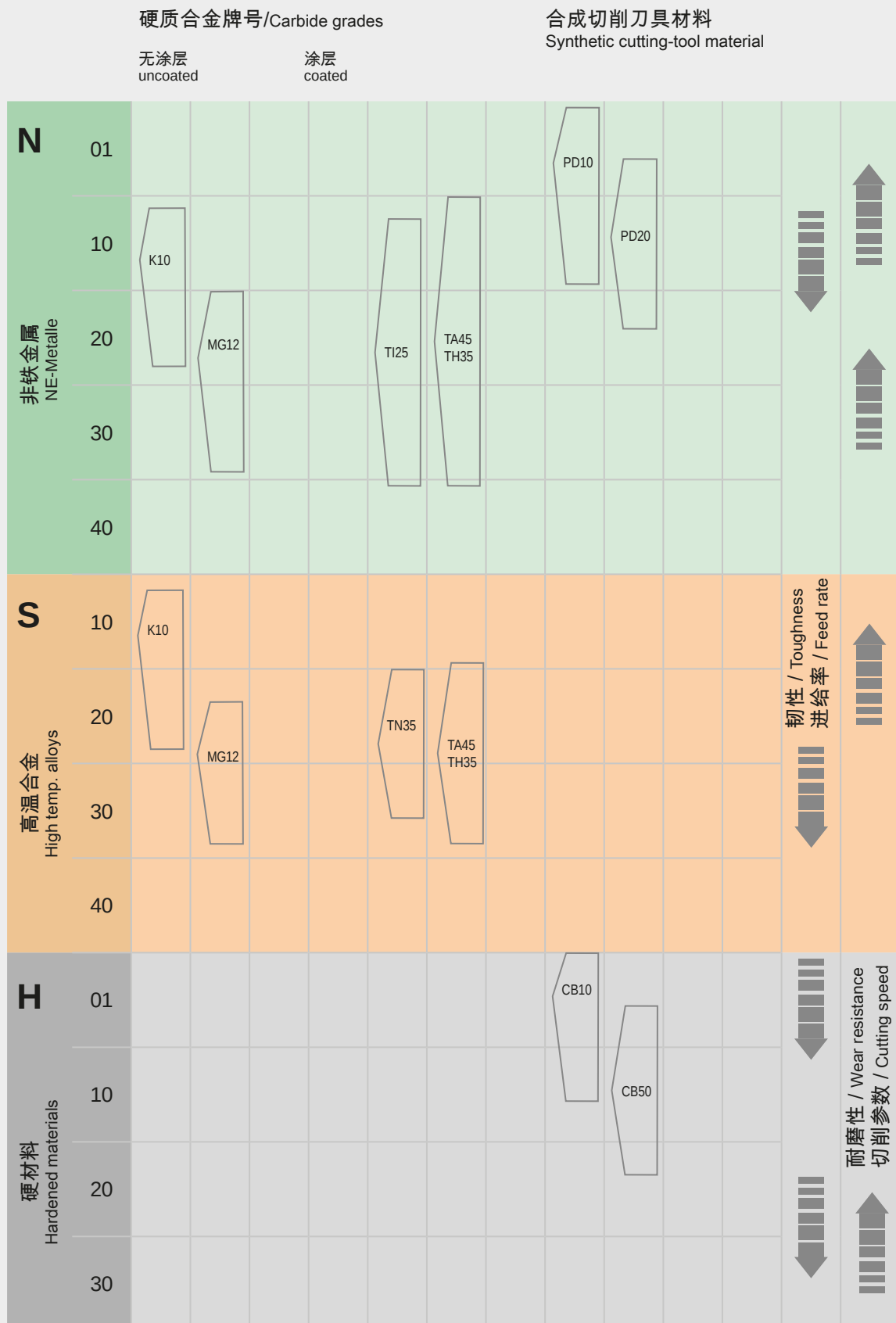
用于切槽和切断的硬质合牌号

Carbide grades for grooving and parting off



用于切槽和切断的硬质合金牌号

Carbide grades for grooving and parting off



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HORN- 牌号	ISO513	性能	工件材质	推荐应用
H20	HT	金属陶瓷	碳钢, 低合金钢, 铸铁,不锈钢,特种合金	适于切槽和精加工,适于最佳的表面质量,不易产生积屑瘤,耐磨损
H54	HT	金属陶瓷	碳钢, 低合金钢, 铸铁,不锈钢,特种合金	适于切槽和精加工,适于最佳的表面质量,不易产生积屑瘤,耐磨损
P20	HW	无涂层牌号	钢,铸钢, 可锻铸铁	适用于中等切削速度切槽和精加工
AS62	HC	TiAlN- 涂层	钢,铸钢, 可锻铸铁	适合高速切槽和精加工
AS66	HC	TiAlN- 涂层	钢,铸钢,可锻铸铁,马氏体不锈钢	用于切槽和精加工,高切削速度,热抗性,干切稳定.
AL96	HC	多层涂层(Al ₂ O ₃)	钢,铸钢,可锻铸铁,马氏体不锈钢	用于高切削速度,较高热抗性的开槽和精加工,适用于干式切削.
TN32	HC	TiN- 涂层	钢,铸钢, 可锻铸铁	适用于切槽和精加工,高速切削.
TN35	HC	TiN- 涂层	钢,铸钢, 可锻铸铁, 马氏体不锈钢	适用于切槽和精加工,低切削速度,螺纹加工,不理想加工条件
TI22	HC	TiCN- 涂层	钢,铸钢, 可锻铸铁	适用于高速切削下切槽和精加工
TI25	HC	TiCN- 涂层	钢,铸铁, 可锻铸铁 马氏体不锈钢	适用于切槽和精加工,地切削参数,螺纹加工,不理想加工条件
TH35 AS6G	HC	TiAlN- 涂层	钢,铸铁, 可锻铸铁 马氏体不锈钢	用于切槽和精加工,高切削速度,热抗性,干切稳定.
TA45 TF45	HC	TiAlN- 涂层	钢,铸铁, 可锻铸铁 马氏体不锈钢	适用于高速切削下切槽和精加工,油冷
TA46 TF46	HC	TiAlN- 涂层	钢,铸铁, 可锻铸铁 马氏体不锈钢	用于切槽和精加工,高切削速度,热抗性,干切稳定.
K10	HW	无涂层牌号	灰铸铁,可锻铸铁,硅铝和铜合金,耐热合金	用于切槽和精加工
MG12	HF	无涂层牌号 (微粒)	灰铸铁,可锻铸铁,硅铝和铜合金,耐热合金	适用于不利条件下低速切槽和精加工

根据要求提供PCD或CBN刀片.

可以在样本和价格或库存清单中查有库存的硬质合金牌号.
未提及的牌号只提供给稳定的订单.

Description carbide grades



HORN-Grades	ISO513	Properties	Workpiece material	Recommended applications
H20	HT	Cermet	carbon steels, low alloyed steels, cast steel, stainless steel, exotic alloys	for grooving and finishing, for best surface qualities, no tendency to built up edge, resistant to wear
H54	HT	Cermet	carbon steels, low alloyed steels, cast steel, stainless steel, exotic alloys	for grooving and finishing, for best surface qualities, no tendency to built up edge, resistant to wear
P20	HW	uncoated grades	steel, cast steel, malleable cast iron	for grooving and finishing at moderate cutting speed
AS62	HC	TiAlN-Coating	steel, cast steel, malleable cast iron,	for grooving and finishing at high cutting speed
AS66	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
AL96	HC	multilayer coating (AL ₂ O ₃)	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at very high cutting speed, heat resistant, suitable for dry cutting
TN32	HC	TiN-Coating	steel, cast steel, malleable cast iron	for grooving and finishing, at high cutting speed
TN35	HC	TiN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at low cutting speed, thread cutting, unfavourable conditions
TI22	HC	TiCN-Coating	steel, cast steel, malleable cast iron	for grooving and finishing at high cutting speed
TI25	HC	TiCN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at low cutting speed, thread cutting, unfavourable conditions
TH35 AS6G	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
TA45 TF45	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing at low cutting speed, cooling with oil
TA46 TF46	HC	TiAlN-Coating	steel, cast steel, malleable cast iron, martensitic stainless steel	for grooving and finishing, at high cutting speed, heat resistant, suitable for dry cutting
K10	HW	uncoated grades	grey cast iron, malleable cast iron, Si-aluminium and copper alloys, heat resistant alloys	for grooving and finishing
MG12	HF	uncoated grades (micro grain)	grey cast iron, malleable cast iron, aluminium and copper alloys, heat resistant alloys	for grooving and finishing, at low cutting speed, unfavourable conditions

PCD- or PCBN-tipped inserts upon request..

Carbide grades on stock are shown in the catalogue or in the price- and stocklist.
Not mentioned grades can be supplied only against firm order..

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硬质合金材质描述

Description carbide grades



HORN- 牌号	ISO513	工件材质	推荐应用
CB07	BN	淬硬钢 > 56 HRC, 非断续切削	满槽切 vc ≈ 150 m/min, f = 0,03 - 0,04 mm 精加工 ap 0,1 - 0,2 mm vc ≈ 160 m/min, f = 0,04 - 0,08 mm
CB10	BN	淬硬钢 > 56 HRC, 非断续切削	满槽切 vc ≈ 140 m/min, f = 0,03 - 0,04 mm 精加工 ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
CB50	BN	淬硬钢 > 45 HRC, 断续切削	满槽切 vc ≈ 140 m/min, f = 0,03 - 0,04 mm 精加工 ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
		灰铸铁,珠光体	满槽切 vc ≈ 1200 m/min, f = 0,1 - 0,25 mm 精加工 ap 0,3 - 1,0 mm vc ≈ 1300 m/min, f = 0,2 - 0,4 mm
		球墨铸铁	满槽切 vc ≈ 900 m/min, f = 0,07 - 0,2 mm 精加工 ap 0,1 - 0,7 mm vc ≈ 1000 m/min, f = 0,1 - 0,3 mm
根据要求提供PCD或CBN刀片			
可以在样本和价格或库存清单中查有库存的硬质合金牌号。 未提及的牌号只提供给稳定的订单。			

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HORN- Grades	ISO513	Workpiece material	Recommended applications
CB07	BN	hardened Steel > 56 HRC, non interrupted cut	Grooving in full material vc ≈ 150 m/min, f = 0,03 - 0,04 mm Finishing with ap 0,1 - 0,2 mm vc ≈ 160 m/min, f = 0,04 - 0,08 mm
CB10	BN	hardened Steel > 56 HRC, non interrupted cut	Grooving in full material vc ≈ 140 m/min, f = 0,03 - 0,04 mm Finishing with ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
CB50	BN	hardened Steel > 45 HRC, interrupted cut	Grooving in full material vc ≈ 140 m/min, f = 0,03 - 0,04 mm Finishing with ap 0,1 - 0,2 mm vc ≈ 150 m/min, f = 0,04 - 0,08 mm
		Grey cast iron, perlitic	Grooving in full material vc ≈ 1200 m/min, f = 0,1 - 0,25 mm Partial cut with ap 0,3 - 1,0 mm vc ≈ 1300 m/min, f = 0,2 - 0,4 mm
		Spheroidal graphite cast iron	Grooving in full material vc ≈ 900 m/min, f = 0,07 - 0,2 mm Partial cut with ap 0,1 - 0,7 mm vc ≈ 1000 m/min, f = 0,1 - 0,3 mm
PCD- or PCBN-tipped inserts upon request..			
Carbide grades on stock are shown in the catalogue or in the price- and stocklist. Not mentioned grades can be supplied only against firm order..			



系列/System

105/110

117

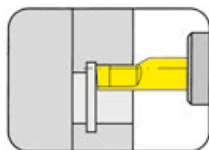
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V2

V20

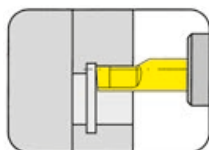
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刀杆
Toolholder
SB105/B105/SB110



页/Page
V4-V11

刀片
Insert
N105/N110



页/Page
V12-V17

105/110



机夹式刀杆

孔径Ø 自 6 mm

Toolholder with Inserts

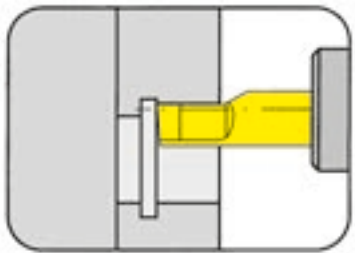
Bore Ø from 6 mm

V

刀杆
Toolholder

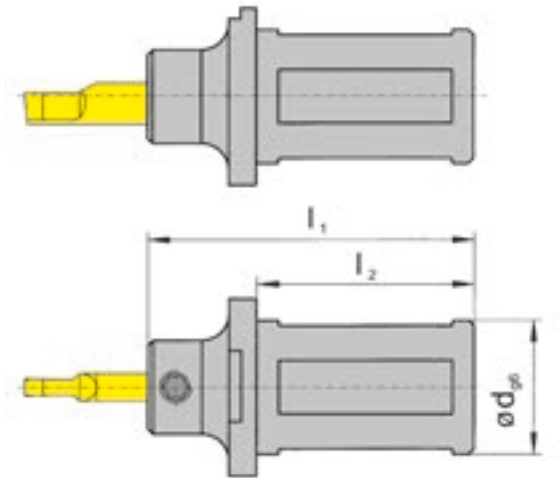
SB105

孔径Ø 自	Bore Ø from	6 mm



配合刀片
for Insert

型号 N105
Type



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB105.0016.1.01	16	73	50	6
SB105.0020.1.01	20	73	50	6
SB105.0022.1.01	22	73	50	6
SB105.0025.1.01	25	73	50	6

按需提供更多尺寸
Further sizes upon request

刀片的夹持长度=12mm !
Clamping length of inserts = 12 mm!
螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

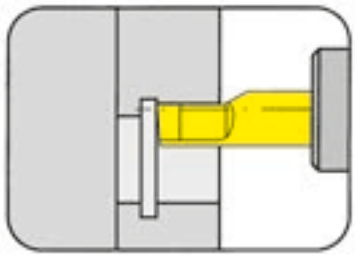
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB105...	6.075T15P	T15PQ

刀杆
Toolholder

SB105

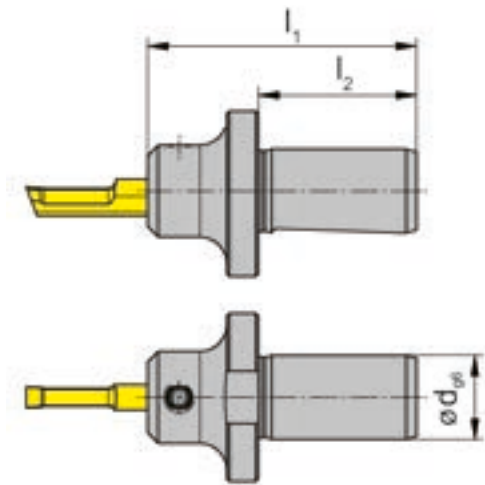
孔径Ø 自	Bore Ø from	6 mm

只适用于插削动力座EWS-Slot, BENZ LinA
only usable for broaching devices EWS-Slot, BENZ LinA



配合刀片
for Insert

型号 N105
Type



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB105.0016.E1.01	16	51	30	6

按需提供其他类型接口
Further sizes for other device interfaces upon request

尺寸单位：mm
Dimensions in mm

刀片的夹持长度=12mm !
Clamping length of inserts = 12 mm!
螺丝的扭矩规格，详见技术说明。

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

配件
Spare Parts

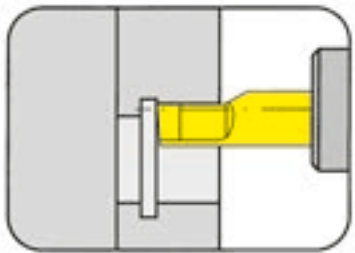
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB105.0016.E1.01	6.075T15P	T15PQ

刀杆
Toolholder

B105

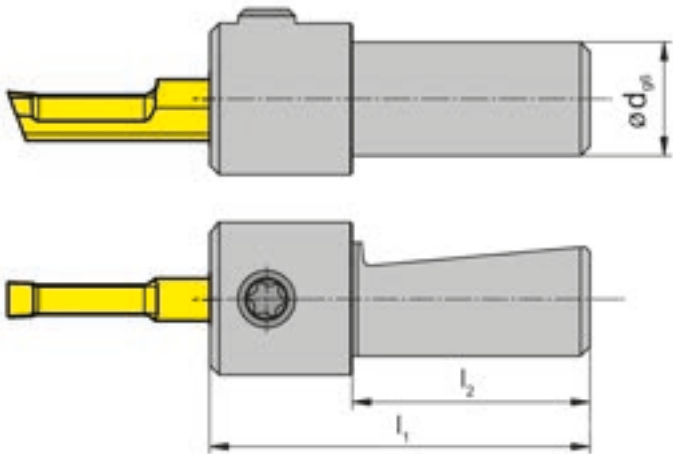
孔径Ø 自	Bore Ø from	6 mm

用于插削动力座Schwarzer
for broaching device Schwarzer



配合刀片
for Insert

型号 N105
Type



产品型号 产品型号	d	l ₁	l ₂	D _{min}
B105.0012.0220	12	40	25	6

按需提供其他类型接口
Further sizes for other device interfaces upon request

刀片的夹持长度=12mm !
Clamping length of inserts = 12 mm!
螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 刀杆	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105.0012.0220	6.075T15P	T15PQ

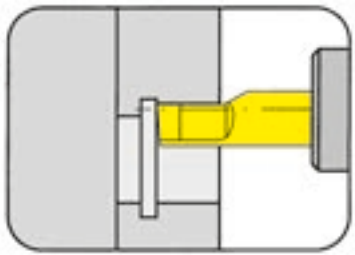


刀杆
Toolholder

SB105/SB110

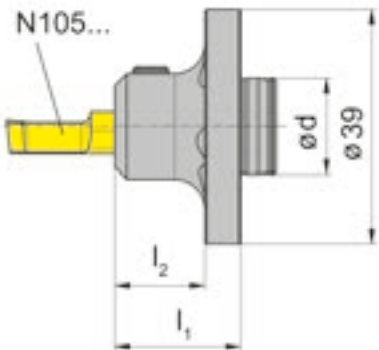
孔径Ø 自	Bore Ø from	6 mm

用于插削动力座WTO
for broaching device WTO



配合刀片
for Insert

型号 N105
Type N110



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB105.1816.W1.01	16	21	15	6
SB110.2016.W1.02	16	42	36	9

按需提供其他类型接口
Further sizes for other device interfaces upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB105...	6.075T15P	T15PQ

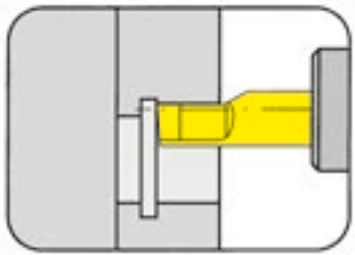


刀杆
Toolholder

SB105/SB110

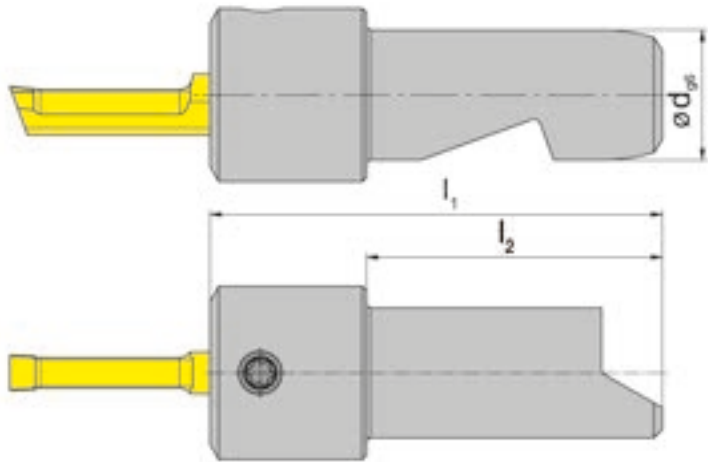
孔径Ø 自	Bore Ø from	6 mm

用于插削动力座Schwarzer“2in1”
for broaching device Schwarzer „2in1”



配合刀片
for Insert

型号 N105
Type N110



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB105.0015.S1.01	15	52	34	6
SB110.0015.S1.02	15	66	34	9

按需提供其他类型接口

Further sizes for other device interfaces upon request

刀片夹持长度=12mm(105)/26mm(110)!

Clamping length of inserts = 12 mm (105) / 26 mm (110)!

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

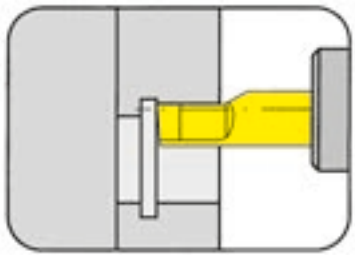
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB105...	6.075T15P	T15PQ

刀杆
Toolholder

SB105/SB110

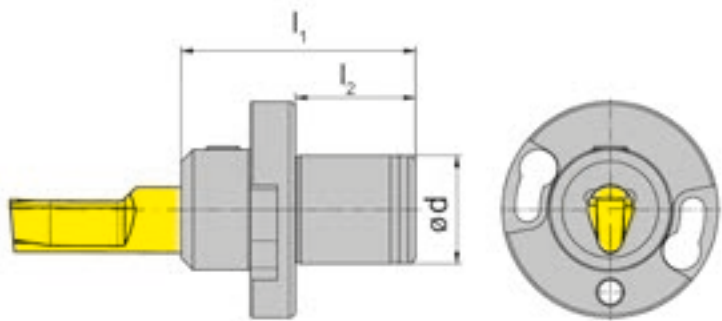
孔径Ø 自	Bore Ø from	6 mm

用于插削设备AR2P
for broaching device AR2P



配合刀片
for Insert

型号 N105
Type N110



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB105.0018.A.01	18	38	20	6
SB110.0018.A.01	18	39	20	6
SB110.0018.A.02	18	52	20	6

按需提供其他类型接口

Further sizes for other device interfaces upon request

刀片夹持长度=12mm(105)/26mm(110)!

Clamping length of inserts = 12 mm (105) / 26 mm (110)!

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

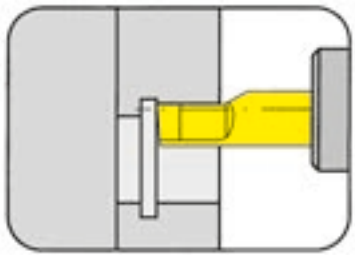
配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB105...	6.075T15P	T15PQ

刀杆
Toolholder

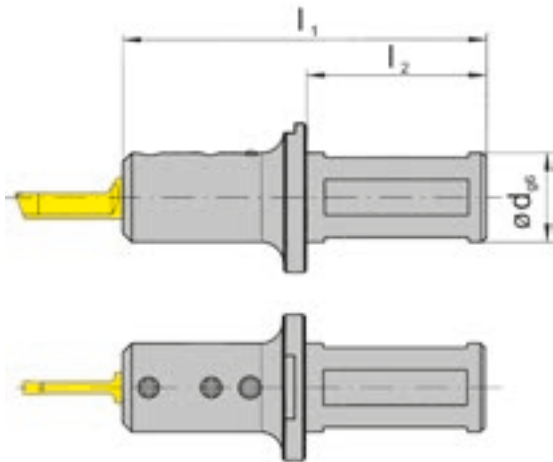
SB110

孔径Ø 自	Bore Ø from	9 mm



配合刀片
for Insert

型号 N110
Type



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB110.0025.1.02	25	88	50	9
SB110.0032.1.02	32	88	50	9

按需提供更多尺寸
Further sizes upon request

刀片的夹持长度=26mm !

Clamping length of inserts = 26 mm!

螺丝的扭矩规格，详见技术说明。

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

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB110...	6.075T15P	T15PQ

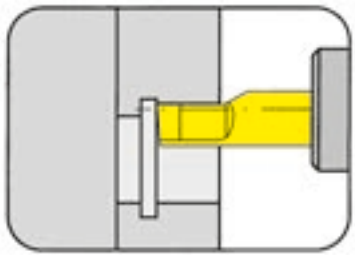


刀杆
Toolholder

SB110

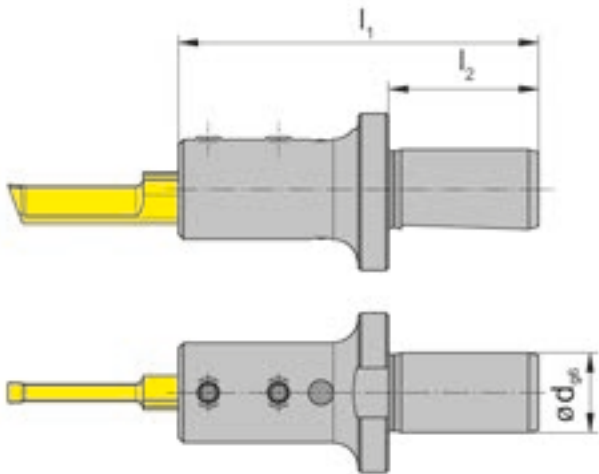
孔径Ø 自	Bore Ø from	9 mm

只适用于插削动力座EWS-Slot, BENZ LinA
only usable for broaching devices EWS-Slot, BENZ LinA



配合刀片
for Insert

型号 N110
Type



产品型号 Part number	d	l ₁	l ₂	D _{min}
SB110.0016.E1.02	16	72	30	9

按需提供其他类型接口
Further sizes for other device interfaces upon request

尺寸单位：mm
Dimensions in mm

刀片的夹持长度=26mm !
Clamping length of inserts = 26 mm!
螺丝的扭矩规格，详见技术说明。

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SB110.0016.E1.02	6.075T15P	T15PQ

刀片

Insert

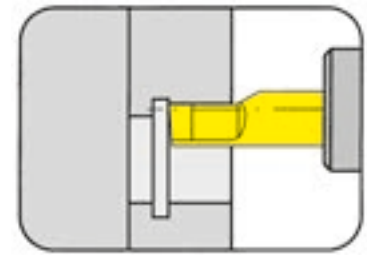
N105/N110

公差等级 C11
Tolerance grade C11

孔径Ø 自

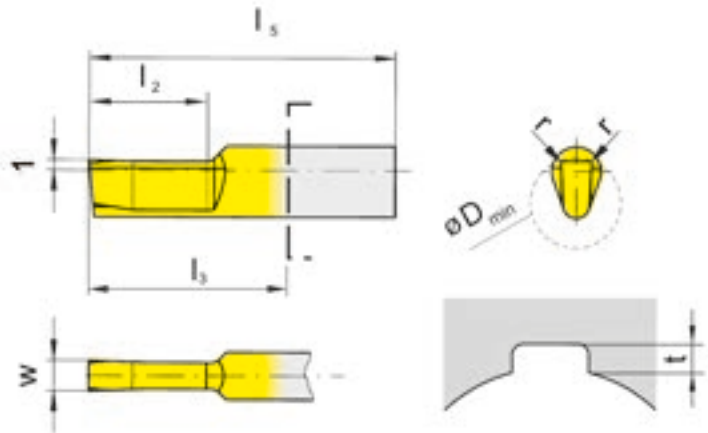
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 SB105
Type B105
SB110



键槽 (DIN138)
Keyways according to DIN138

产品型号 Part number	w	l ₁	l ₂	l ₃	r	可用于自Ø Applicable from Ø	TA45
N105.0210.2.08	2.11	30	12	18	0.35	6.0	▲
N105.0310.2.10	3.11	30	12	18	0.35	6.5	▲
N105.0310.2.13	3.11	30	12	18	0.50	6.5	▲
N105.0410.2.16	4.13	30	12	18	0.50	6.5	▲
N110.0410.05.04	4.13	60	25	34	0.50	9.0	▲
N110.0410.05.07	4.13	75	40	49	0.50	9.0	▲
N110.0510.05.04	5.13	60	25	34	0.50	9.0	▲
N110.0510.05.07	5.13	75	40	49	0.50	9.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

订货须知 :

DIN标槽尺寸详见V18页

Ordering note:

For Dimensions of Groove DIN please see page V18

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

刀片

Insert

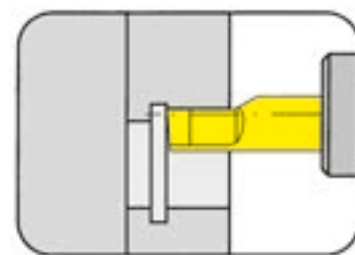
N105/N110

公差等级 C11
Tolerance grade C11

孔径Ø 自

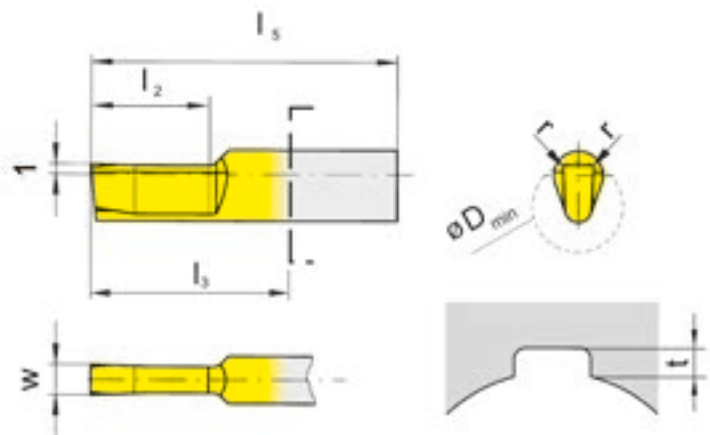
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 SB105
Type B105
SB110



键槽 (DIN6885)
Keyways according to
DIN6885

产品型号 Part number	w	l ₁	l ₂	l ₃	r	可用于自Ø Applicable from Ø	TA45
N105.0198.01.01	1.982	30	12	18	0.1	6.0	▲
N105.0298.01.01	2.982	30	12	18	0.1	6.5	▲
N105.0397.01.01	3.973	35	15	23	0.1	6.5	▲
N110.0397.02.04	3.976	60	25	34	0.2	9.0	▲
N110.0397.02.07	3.976	75	40	49	0.2	9.0	▲
N110.0497.02.04	4.976	60	25	34	0.2	9.0	▲
N110.0497.02.07	4.976	75	40	49	0.2	9.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

订货须知 :

DIN标槽尺寸详见V18页

Ordering note:

For Dimensions of Groove DIN please see page V18

硬质合金牌号
Carbide grades

P	•
M	•
K	•
N	•
S	•
H	-

V

刀片

Insert

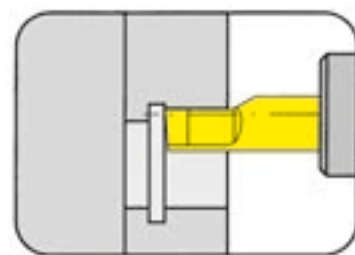
N105/N110

公差等级 JS9
Tolerance grade JS9

孔径Ø 自

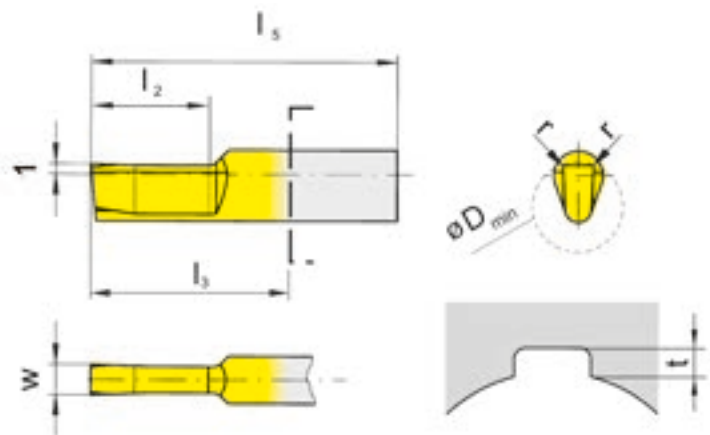
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 SB105
Type B105
SB110



键槽 (DIN6885)
Keyways according to
DIN6885

产品型号 Part number	w	l ₅	l ₂	l ₃	r	可用于自Ø Applicable from Ø	TA45
N105.0200.01.01	2	30	12	18	0.1	6.0	▲
N105.0300.01.01	3	30	12	18	0.1	6.5	▲
N105.0400.01.01	4	35	15	23	0.1	6.5	▲
N105.0400.02.01	4	35	15	23	0.2	6.5	▲
N110.0400.02.04	4	60	25	34	0.2	9.0	▲
N110.0400.02.07	4	75	40	49	0.2	9.0	▲
N110.0500.02.04	5	60	25	34	0.2	9.0	▲
N110.0500.02.07	5	75	40	49	0.2	9.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

订货须知 :

DIN标槽尺寸详见V18页

Ordering note:

For Dimensions of Groove DIN please see page V18

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

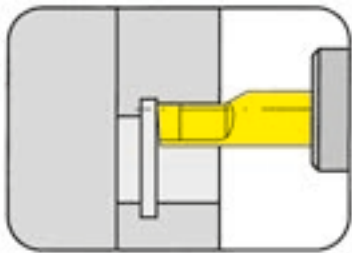
插削 - 倒角
Broaching-Chamfering



刀片
Insert

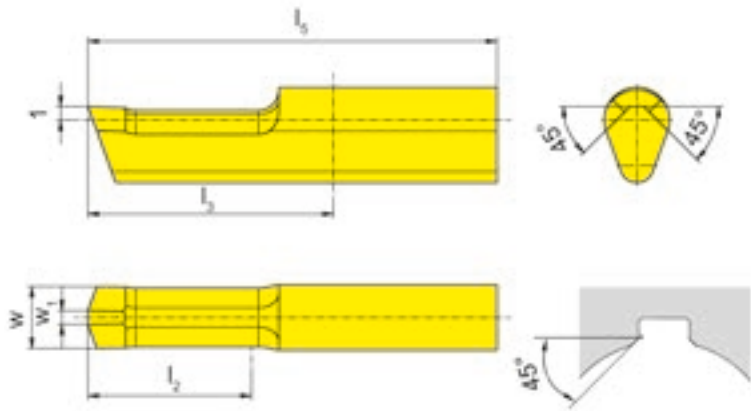
N105/N110

孔径Ø 自	Bore Ø from	6 mm



配合刀杆
for Toolholder

型号 SB105
Type B105
SB110



倒角
Chamfering

产品型号 Part number	w	w1	l ₅	l ₂	l ₃	D _{min}	可用于自Ø Applicable from Ø	TA45	硬质合金牌号 Carbide grades
N105.4545.2.6	4.5	1	30	12	18	6	6	▲	P •
N105.4545.3.6	4.5	1	35	20	23	6	6	▲	M •
N110.4545.4.9	6.3	2	60	25	34	9	9	▲	K •
N110.4545.7.9	6.3	2	75	40	49	9	9	▲	N •
									S •
									H -

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
○ 次推荐 / alternative recommendation
- 不合适 / not suitable

非涂层 / uncoated grades
涂层 / coated grades
钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm



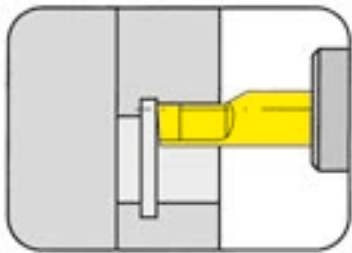
插削 - 内六角

Broaching - Hexagon Socket



刀片
Insert

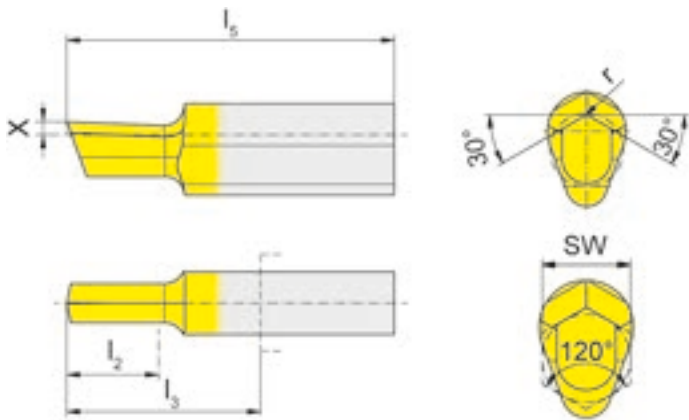
N105/N110



内六角自

Hexagon socket from

SW 2.0



配合刀杆
for Toolholder

型号 SB105
Type B105
SB110

内六角
Hexagon socket

产品型号 Part number	l_5	l_2	l_3	r	X	SW	底孔 Pilot $\varnothing$	TA45
N105.SW20.20.01	25	4.0	13	0.05	1.0	2.0	SW	▲
N105.SW25.25.01	25	4.0	13	0.05	1.0	2.5 - 2.9	SW	▲
N105.SW30.30.01	25	4.5	13	0.05	1.0	2.9 - 3.5	SW	▲
N105.SW35.35.01	25	5.5	13	0.05	1.0	3.5 - 4.0	SW	▲
N105.SW40.40.01	25	6.0	13	0.10	1.0	4.0 - 4.5	SW	▲
N105.SW45.45.01	25	7.0	13	0.10	1.0	4.5 - 5.0	SW	▲
N105.SW56.56.01	25	9.0	13	0.10	1.0	5.0 - 8.0	SW	▲
N105.SW80.80.01	30	12.0	18	0.10	1.0	8.0 - 10.0	SW+.01	▲
N110.SW14.14.03	55	20.0	29	0.20	1.5	10.0 - 14.0	SW+.01	▲
N110.SW16.16.04	55	25.0	29	0.20	2.0	14.0-16.5/ 16.8 - 18.0	SW+.01/ SW+0.2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

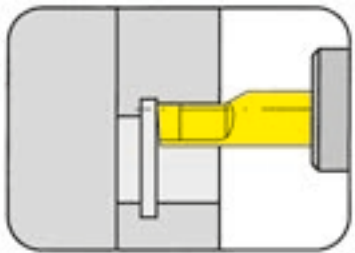
P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

刀片
Insert

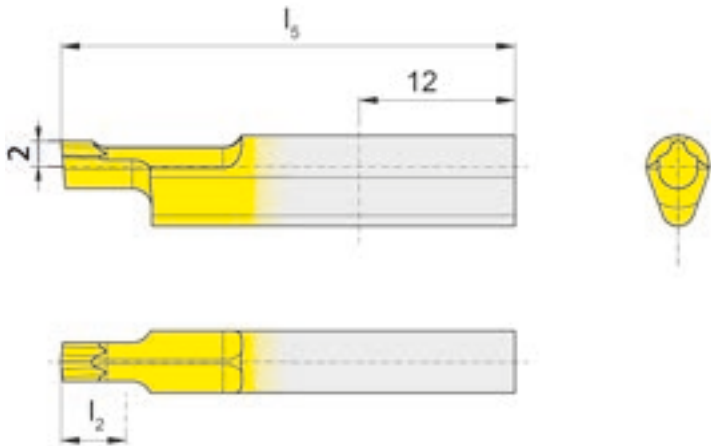
N105

Torx自	Torx from	T15-T30



配合刀杆
for Toolholder

型号 SB105
Type B105



Torx
Torx

产品型号 Part number	Torx	l_5	l_2	TA45
N105.TX15.24.03	T15	35	4	▲
N105.TX20.28.03	T20	35	4	▲
N105.TX25.32.03	T25	35	5	▲
N105.TX30.40.03	T30	35	5	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

P	•
M	•
K	•
N	•
S	•
H	-

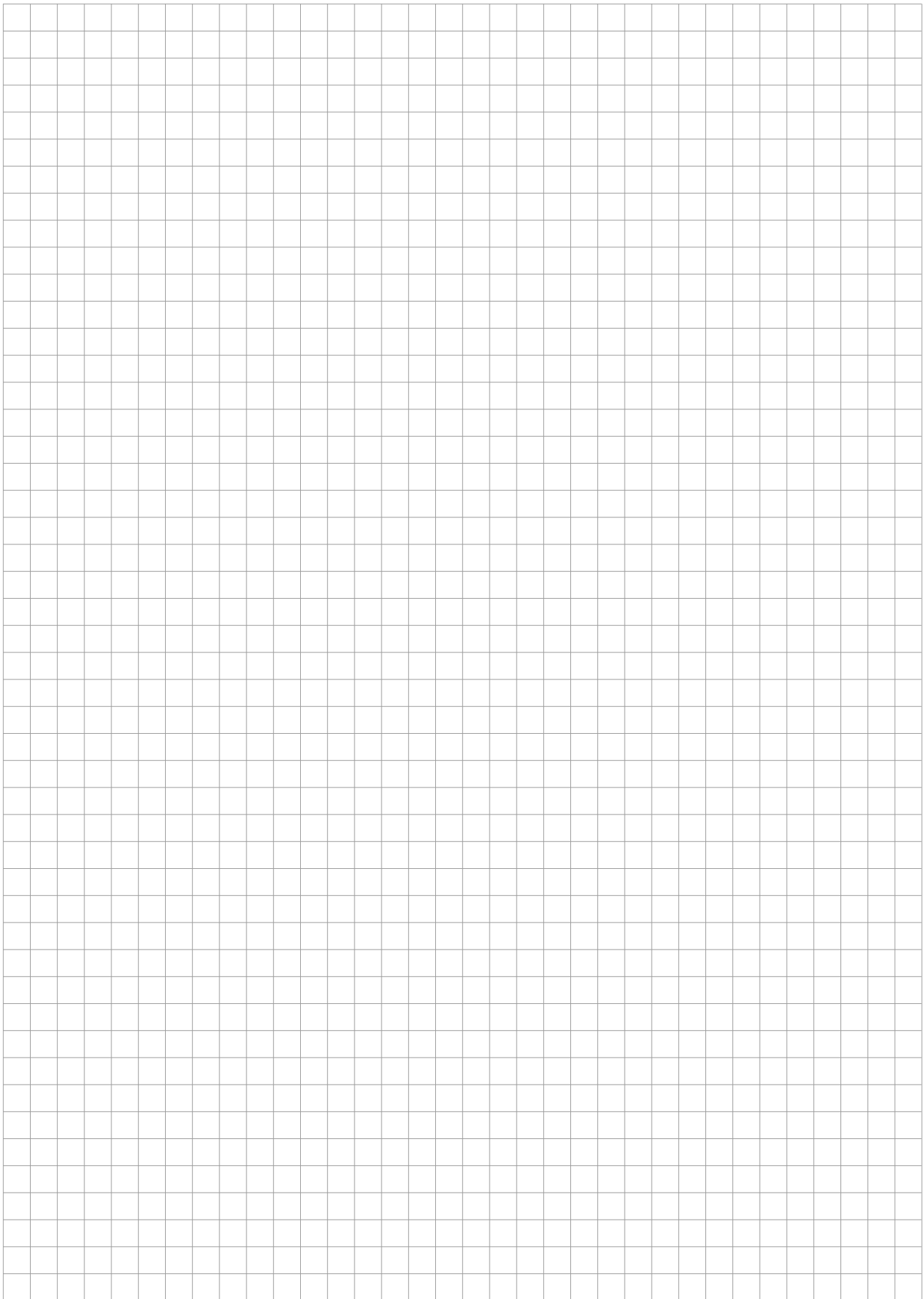
硬质合金牌号
Carbide grades



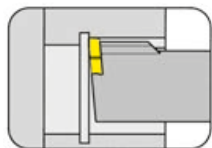
型号 **SB105/SB110** - 刀杆可以直接安装在刀塔和m/c主轴上

Type **SB105/SB110** - Holder can be located directly in the turret or m/c spindle

尺寸 DIN Dimensions DIN				插削 Broaching		倒角 Chamfering	
宽 Width	公差等级 Tolerance grade	D _{min}	t	刀片 Inserts	l ₂ 刀杆 Toolholder	刀片 Inserts	刀杆 Toolholder
2	C11	8	1.0	N105.0210.2.08	12	N105.4545.2.6	SB105.0020.1.01 SB105.0025.1.01
3	C11	10	1.8	N105.0310.2.10	12		
3	C11	13	1.8	N105.0310.2.13	12		
4	C11	16	2.0	N105.0410.2.16	12		
4	C11	16	2.0	N110.0410.05.04	25	N110.4545.4.9	SB110.0025.1.02
4	C11	16	2.0	N110.0410.05.07	40	N110.4545.7.9	SB110.0032.1.02
5	C11	-	-	N110.0510.05.04	25	N110.4545.4.9	SB110.0025.1.02
5	C11	-	-	N110.0510.05.07	40	N110.4545.7.9	SB110.0032.1.02
2	P9	6	1.1	N105.0198.01.01	12	N105.4545.2.6	SB105.0020.1.01
3	P9	8	1.5	N105.0298.01.01	12		
4	P9	10	1.9	N105.0397.01.01	15	N105.4545.3.6	SB105.0025.1.01
4	P9	10	1.9	N110.0397.02.04	25	N110.4545.4.9	SB110.0025.1.02 SB110.0032.1.02
4	P9	10	1.9	N110.0397.02.07	40	N110.4545.7.9	
5	P9	12	2.4	N110.0497.02.04	25	N110.4545.4.9	
5	P9	12	2.4	N110.0497.02.07	40	N110.4545.7.9	
2	JS9	6	1.1	N105.0200.01.01	12	N105.4545.2.6	SB105.0020.1.01 SB105.0025.1.01
3	JS9	8	1.5	N105.0300.01.01	12		
4	JS9	10	1.9	N105.0400.01.01	15	N105.4545.3.6	SB110.0025.1.02 SB110.0032.1.02
4	JS9	10	1.9	N105.0400.02.01	15		
4	JS9	10	1.9	N110.0400.02.04	25	N110.4545.4.9	SB110.0025.1.02 SB110.0032.1.02
4	JS9	10	1.9	N110.0400.02.07	40	N110.4545.7.9	
5	JS9	12	2.4	N110.0500.02.04	25	N110.4545.4.9	
5	JS9	12	2.4	N110.0500.02.07	40	N110.4545.7.9	

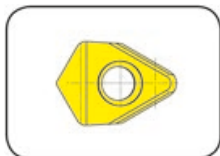


刀杆
Toolholder
SH117



页/Page
V22-V30

刀片
Insert
S117



页/Page
V31-V35

117



机夹式刀杆

孔径Ø 自 14 mm

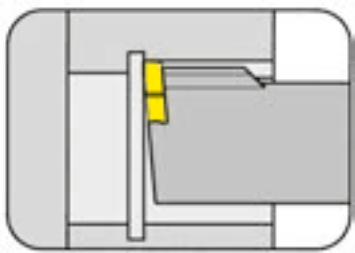
Toolholder with Inserts

Bore Ø from 14 mm

V

刀杆
Toolholder

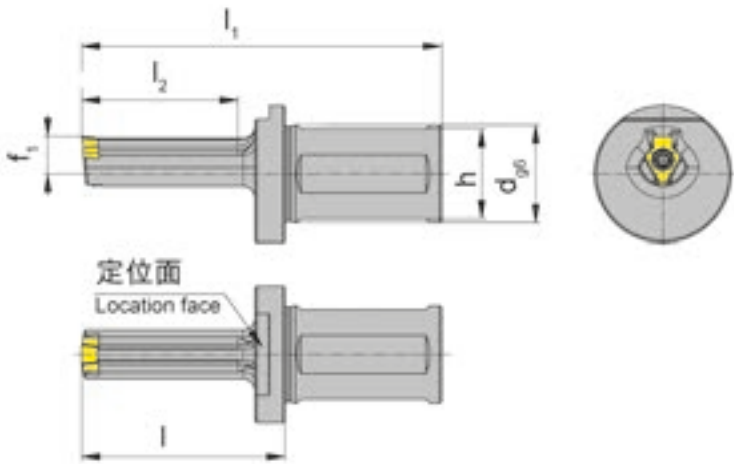
SH117



孔径Ø 自	Bore Ø from	14 mm

配合刀片
for Insert

型号 S117
Type



产品型号 Part number	d	h	l	l ₁	l ₂	D _{min}	f ₁	形式 Form
SH117.1425.1.3.08	25	23	32	72	20	14	9.6	G
SH117.1425.1.08	25	23	42	82	30	14	9.6	F
SH117.1425.2.08	25	23	52	92	40	14	9.6	F

按需提供更多尺寸
Further sizes upon request

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

尺寸单位：mm
Dimensions in mm

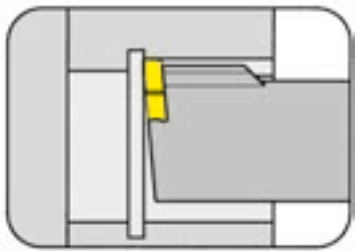
配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117...	030.3509.T15P	T15PQ



刀杆
Toolholder

SH117
直接冷却液供应
with through coolant supply

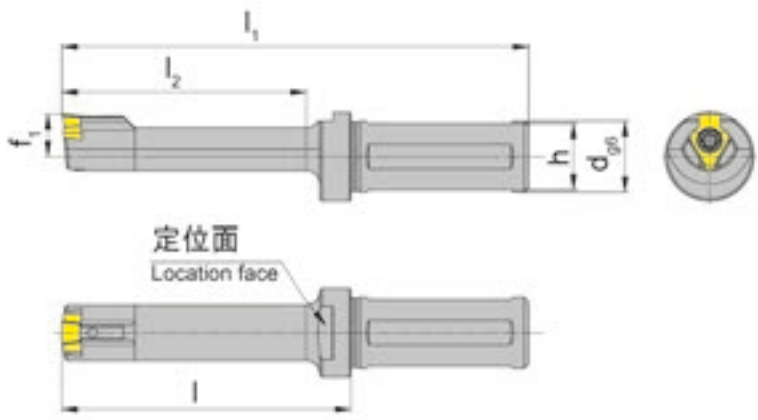


孔径Ø 自 Bore Ø from 14 mm

刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 S117...08
Type



直接冷却液供应
with through coolant supply

产品型号 Part number	d	h	l	l ₁	l ₂	D _{min}	f ₁	形式 Form
SHM117.1416.3.08	16	15	65	105	55	14	9.6	F

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

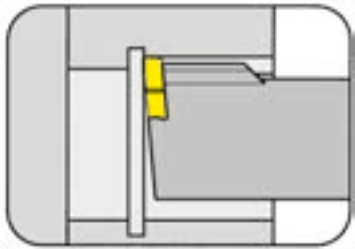
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

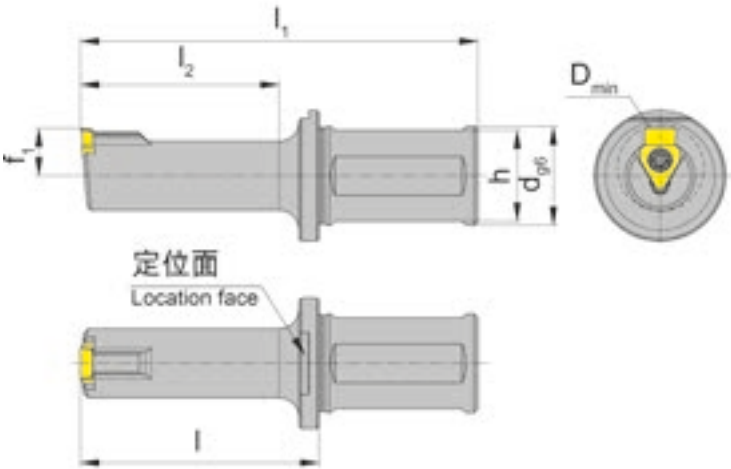
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SHM117.1416.3.08	030.3509.T15P	T15PQ

刀杆
Toolholder

SH117



孔径Ø 自 Bore Ø from 17 mm



配合刀片
for Insert

型号 S117
Type

产品型号 Part number	d	h	l	l ₁	l ₂	D _{min}	f ₁	形式 Form
SH117.1725.1.10	25	23	50	90	40	17	9.5	A
SH117.1725.2.10	25	23	65	105	55	17	9.5	A
SH117.0025.1.10	25	23	60	100	50	22	12.0	B
SH117.0025.2.10	25	23	80	120	70	22	12.0	B
SH117.3032.1.16	32	30	60	100	50	30	16.5	C
SH117.3032.2.16	32	30	85	125	75	30	16.5	C
SH117.3032.3.16	32	30	110	170	100	30	16.5	C
SH117.0032.1.16	32	30	60	100	50	38	22.0	d
SH117.0032.2.16	32	30	85	125	75	38	22.0	d
SH117.0032.3.16	32	30	110	170	100	38	22.0	d
SH117.4032.1.16	32	30	62	122	50	40	21.5	E
SH117.4032.2.16	32	30	87	147	75	40	21.5	E
SH117.4032.3.16	32	30	112	172	100	40	21.5	E

按需提供更多尺寸
Further sizes upon request

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

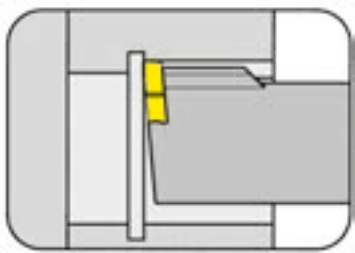
尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117...10	4.09T15P	T15PQ
SH117...16	5.12T20P	T20PQ

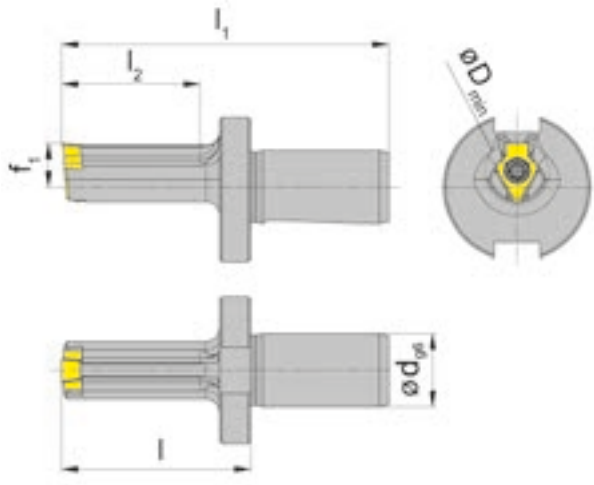
刀杆
Toolholder

SH117



孔径Ø 自 Bore Ø from 14 mm

只适用于插削动力座EWS-Slot, BENZ LinA
only usable for broaching devices EWS-Slot, BENZ LinA



配合刀片
for Insert

型号 S117
Type

外圆和内圆
external and internal

产品型号 Part number	d	l	l ₁	l ₂	D _{min}	f ₁	形式 Form
SH117.1416.E1.08	16	41	71	35	14	9.6	F
SH117.1716.E0.10	16	31	61	20	17	9.5	A
SH117.1716.E1.10	16	41	71	35	17	9.5	A
SH117.1716.E2.10	16	51	81	40	17	9.5	A
SH117.1716.E3.10	16	64	94	53	17	9.5	A
SH117.0016.E1.10	16	41	71	35	22	12.0	B
SH117.0016.E2.10	16	51	81	40	22	12.0	B
SH117.0016.E3.10	16	64	94	53	22	12.0	B

按需提供更多尺寸
Further sizes upon request

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

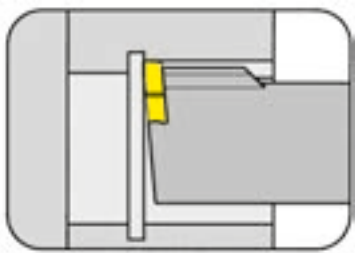
尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117.1416.E1.08	030.3509.T15P	T15PQ
SH117...	4.09T15P	T15PQ

刀杆
Toolholder

SH117/H117

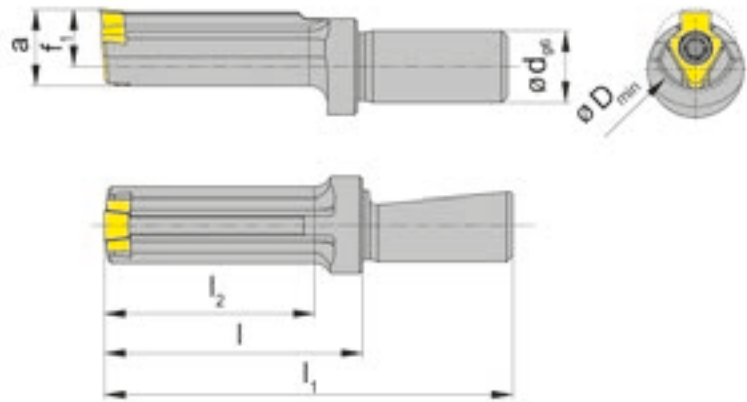


孔径Ø 自	Bore Ø from	14 mm

用于插削动力座Schwarzer
for broaching device Schwarzer

配合刀片
for Insert

型号 S117
Type



产品型号 Part number	d	l	l ₁	l ₂	D _{min}	f ₁	a	形式 Form
SH117.1412.S1.08	12	33	58	25	14	9.6	12.80	F
SH117.1412.S2.08	12	43	68	35	14	9.6	12.80	F
H117.1712.1439	12	33	58	25	17	9.5	16.00	A
H117.1712.1407	12	43	68	35	17	9.5	16.00	A
H117.2212.1441	12	33	58	25	22	12.0	20.75	B
H117.2212.1442	12	43	68	35	22	12.0	20.75	B
H117.3012.1440	12	33	58	25	30	16.5	28.50	C
H117.3012.1419	12	43	68	35	30	16.5	28.50	C

按需提供其他类型接口
Further sizes for other device interfaces upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

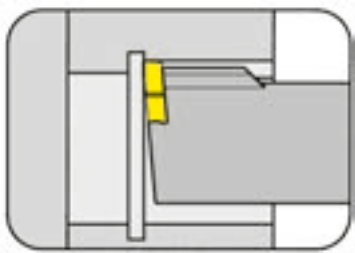
尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117.1412....	030.3509.T15P	T15PQ
H117...	4.09T15P	T15PQ
H117.3012.1...	5.12T20P	T20PQ

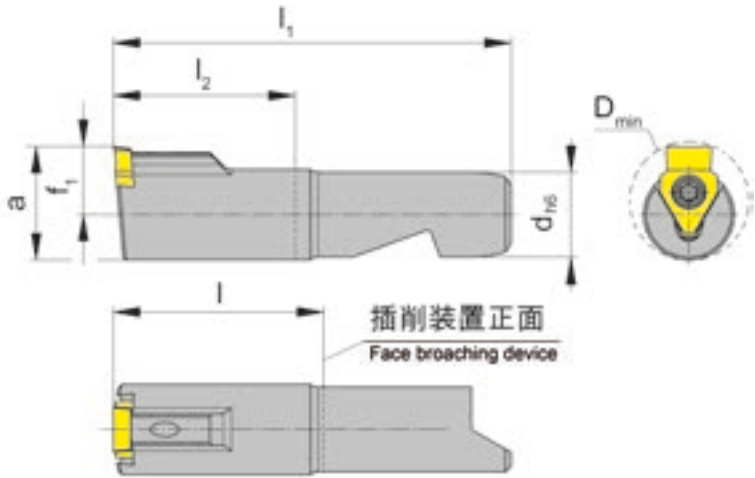
刀杆
Toolholder

SH117
直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	14 mm

用于插削动力座Schwarzer“2in1”
for broaching device Schwarzer „2in1”



配合刀片
for Insert

型号 S117
Type

产品型号 Part number	d	l	l ₁	l ₂	D _{min}	f ₁	a	形式 Form
SH117.0932.S.08	15	37	70	32	14	9.6	12.8	F
SH117.0932.S.10	15	37	70	32	17	9.5	16.0	A
SH117.1532.S.10	15	37	70	32	22	12.0	20.0	B
SH117.1538.S.16	15	43	76	38	30	15.0	24.0	C
SH117.1544.S.16	15	49	82	44	30	15.0	24.0	C

按需提供其他类型接口
Further sizes for other device interfaces upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

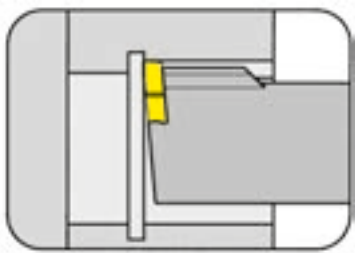
尺寸单位：mm
Dimensions in mm

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117.0932.S.08	030.3509.T15P	T15PQ
SH117...	4.09T15P	T15PQ
SH117.1...	5.12T20P	T20PQ

刀杆
Toolholder

SH117

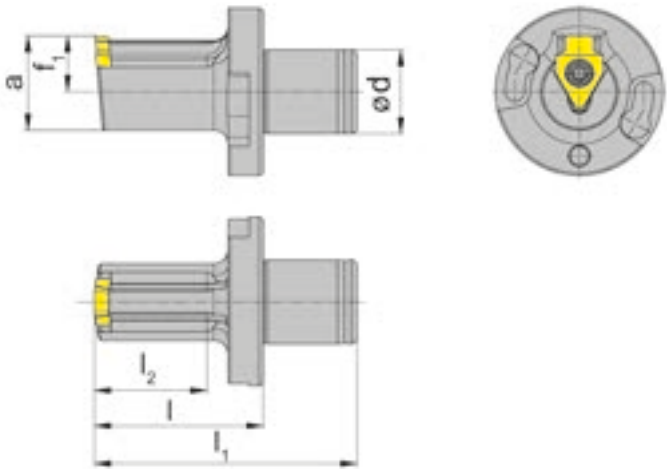


孔径Ø 自	Bore Ø from	22 mm

用于插削设备AR2P
for broaching device AR2P

配合刀片
for Insert

型号 S117
Type



产品型号 Part number	d	l	l ₁	l ₂	D _{min}	f ₁	a	形式 Form
SH117.2218.A1.10	18	36	56	24	22	12	20.25	B

按需提供其他类型接口
Further sizes for other device interfaces upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

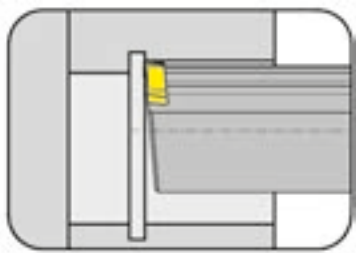
配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117.2218.A1.10	4.09T15P	T15PQ



刀杆
Toolholder

SH117

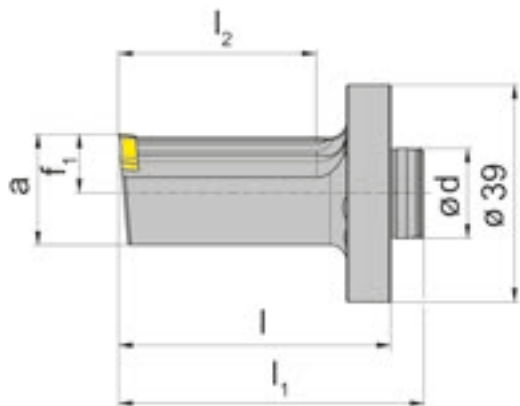


孔径Ø 自	Bore Ø from	17 mm

用于插削设备WTO
for broaching device WTO

配合刀片
for Insert

型号 S117
Type



产品型号 Part number	d	l	l ₁	l ₂	D _{min}	f ₁	a	形式 Form
SH117.1716.W1.10	16	49	55	35	17	8.3	15.1	A
SH117.2216.W1.10	16	49	55	35	22	10.6	19.8	B
SH117.2616.W1.16	16	49	55	35	26	12.6	23.5	C

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

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

配件
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117...	4.09T15P	T15PQ
SH117.2616.W1.16	5.12T20P	T20PQ

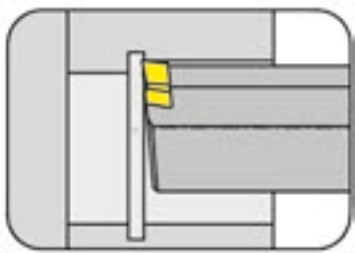


插削 - 内六角
Broaching - Hexagon Socket

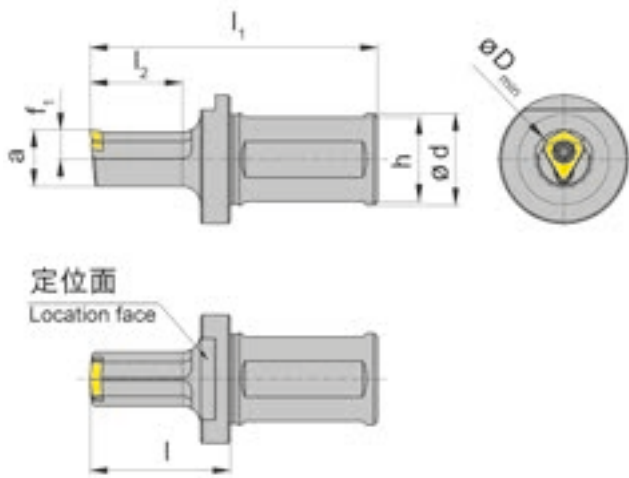


刀杆
Toolholder

SH117



孔径Ø 自	Bore Ø from	14.2 mm



配合刀片
for Insert

型号 S117
Type

内六角
Hexagon socket

产品型号 Part number	d	h	l	l ₁	l ₂	D _{min}	f ₁	a	刀片 Insert
SH117.1425.30.1.08	25	23	33	73	20	14.2	6.75	13	S117.SW14.08
SH117.1625.30.1.10	25	23	38	78	25	16.2	7.75	15	S117.SW16.10
SH117.2432.30.1.12	32	30	43	83	30	24.3	11.50	22	S117.SW24.12
SH117.3032.30.1.16	32	30	53	93	40	30.3	14.50	28	S117.SW30.16

按需提供更多尺寸
Further sizes upon request
螺丝的扭矩规格，详见技术说明。
For torque specification of the screw, please see Technical Instructions.

尺寸单位：mm
Dimensions in mm

配件
Spare Parts

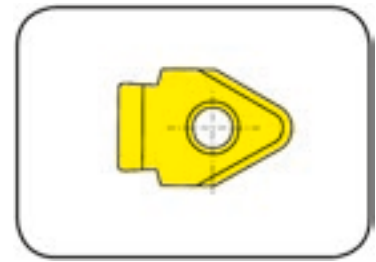
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
SH117.1425.30.1.08	030.3509.T15P	T15PQ
SH117...	4.09T15P	T15PQ
SH117.3032.30.1.16	5.12T20P	T20PQ

刀片

Insert

S117

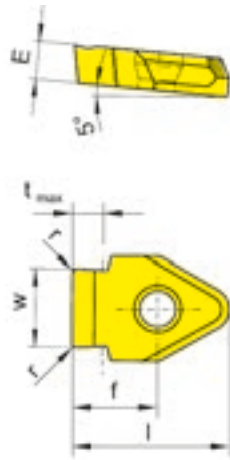
公差等级 C11
Tolerance grade C11



孔径Ø 自
切槽深度可达

Bore Ø from
Depth of groove up to

14 mm
8.5 mm



配合刀杆
for Toolholder

型号 SH117
Type SHM117
H117

键槽 (DIN138)
Keyways according to DIN138

产品型号 Part number	Nw	w	l	r	E	D _{min}	t _{max}	f	形式 Form	TA45	TI25
S117.0310.04.08	3	3.10	13	0.35	4	14	2.0	6.0	G	▲	
S117.0410.05.08	4	4.12	13	0.50	4	14	2.1	6.0	F	▲	
S117.0610.22	6	6.12	16	0.85	3	22	2.6	8.0	B	▲	▲
S117.0710.27	7	7.13	16	0.85	3	22	3.3	8.0	B	▲	Δ
S117.0810.32	8	8.13	16	1.05	3	22	3.4	8.0	B	▲	▲
S117.1014.40	10	10.13	21	1.05	6	30	4.2	11.2	C	▲	Δ
S117.1214.50	12	12.15	21	1.35	6	38	5.1	11.2	D	▲	Δ
S117.1614.70	16	12.15	21	1.75	6	38	6.6	11.2	D	▲	
S117.2414.100	24	12.15	21	2.25	6	38	8.5	11.2	D	Δ	

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注意事项 :

刀片类型应与刀杆类型相对应。 例如 : A型刀杆配A型刀片

Note:

The insert form must correspond to the holder form. E.g.: Form A Toolholder = Form A Insert

订货须知 :

DIN标槽尺寸详见V36

Ordering note:

For Dimensions of Groove DIN please see page V36

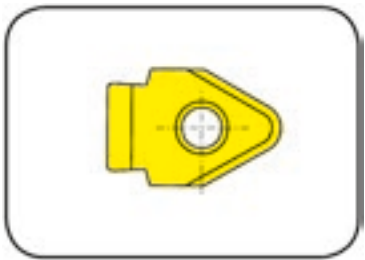
P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	-	-

硬质合金牌号
Carbide grades

刀片
Insert

S117

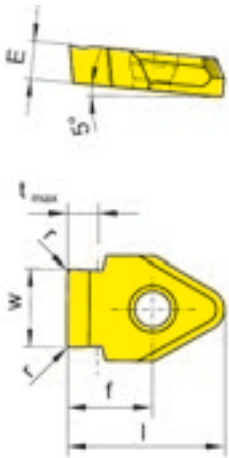
公差等级 C11
Tolerance grade P9



孔径Ø 自
切槽深度可达

Bore Ø from
Depth of groove up to

14 mm
6.8 mm



配合刀杆
for Toolholder

型号 SH117
Type SHM117
H117

键槽 (DIN6885)
Keyways according to
DIN6885

产品型号 Part number	Nw	w	l	r	E	D _{min}	t _{max}	f	形式 Form	TA45
S117.0298.01.08	3	2.99	13.0	0.12	4	14	2.0	6.0	G	▲
S117.0397.01.08	4	3.98	13.0	0.12	4	14	2.1	6.0	F	▲
S117.0497.02.08	5	4.98	13.0	0.20	4	14	2.7	6.0	F	▲
S117.0497.02.10	5	4.98	14.5	0.20	3	17	2.7	6.5	A	▲
S117.0597.02.10	6	5.98	14.5	0.20	3	17	3.4	6.5	A	▲
S117.0796.02.10	8	7.98	16.0	0.20	3	22	4.1	8.0	B	▲
S117.0996.03.14	10	9.98	21.0	0.30	6	30	4.2	11.2	C	▲
S117.1196.03.14	12	11.97	21.0	0.30	6	38	5.7	11.2	D	▲
S117.1396.03.16	14	13.97	21.0	0.30	6	40	6.8	11.2	E	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注意事项 :

刀片类型应与刀杆类型相对应。 例如 : A型刀杆配A型刀片

Note:

The insert form must correspond to the holder form. E.g.: Form A Toolholder = Form A Insert

订货须知 :

DIN标槽尺寸详见V36

Ordering note:

For Dimensions of Groove DIN please see page V36

P	•
M	•
K	•
N	•
S	•
H	-

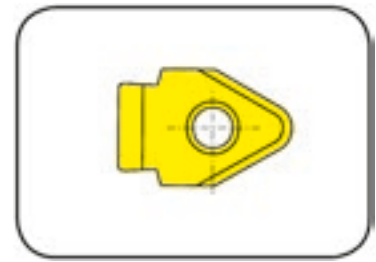
硬质合金牌号
Carbide grades

刀片

Insert

S117

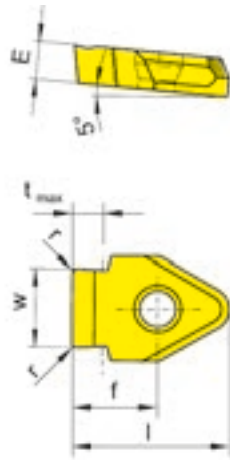
公差等级 C11
Tolerance grade JS9



孔径Ø 自
切槽深度可达

Bore Ø from
Depth of groove up to

14 mm
8.5 mm



配合刀杆
for Toolholder

型号 SH117
Type SHM117
H117

键槽 (DIN6885)
Keyways according to
DIN6885

产品型号 Part number	Nw	w	l	r	E	D _{min}	t _{max}	f	形式 Form	TA45
S117.0300.01.08	3	3.01	13.0	0.12	4	14	2.0	6.0	G	▲
S117.0400.01.08	4	4.01	13.0	0.12	4	14	2.1	6.0	F	▲
S117.0500.02.08	5	5.01	13.0	0.20	4	14	2.7	6.0	F	▲
S117.0500.02.10	5	5.01	14.5	0.20	3	17	2.7	6.5	A	▲
S117.0600.02.10	6	6.01	14.5	0.20	3	17	3.4	6.5	A	▲
S117.0800.02.10	8	8.01	16.0	0.20	3	22	4.1	8.0	B	▲
S117.1000.03.14	10	10.01	21.0	0.30	6	30	4.2	11.2	C	▲
S117.1200.05.14	12	12.00	21.0	0.50	6	38	8.5	11.2	D	▲
S117.1200.03.14	12	12.01	21.0	0.30	6	38	5.7	11.2	D	▲
S117.1400.03.16	14	14.01	21.0	0.30	6	40	6.8	11.2	E	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注意事项 :

刀片S117.1200.05.14=Nw自 12mm开始!

Note:

Insert S117.1200.05.14 = Nw from 12 mm!

刀片类型应与刀杆类型相对应。 例如 : A型刀杆配A型刀片

The insert form must correspond to the holder form. E.g.: Form A Toolholder = Form A Insert

订货须知 :

DIN标槽尺寸详见V36

Ordering note:

For Dimensions of Groove DIN please see page V36

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

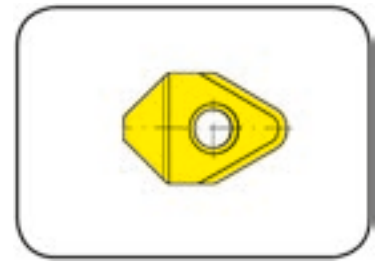
插削 - 倒角

Broaching-Chamfering



刀片
Insert

S117



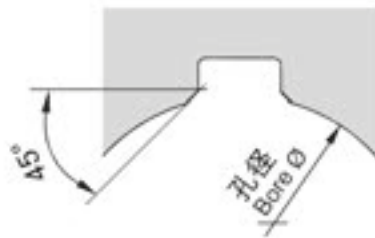
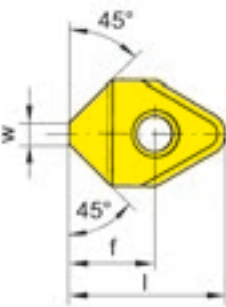
孔径Ø 自

Bore Ø from

14 mm

配合刀杆
for Toolholder

型号 SH117
Type SHM117
H117



倒角
Chamfering

产品型号 Part number	w	l	E	D _{min}	f	形式 Form	TA45
S117.2445.08	2.4	13	4	14	6.0	F	▲
S117.1545.10	1.5	16	3	17	8.0	A	▲
S117.3045.10	3.0	16	3	22	8.0	B	▲
S117.6045.14	6.0	21	6	30	11.2	C/D	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

注意事项 :

刀片类型应与刀杆类型相对应。 例如 : A型刀杆配A型刀片

Note:

The insert form must correspond to the holder form. E.g.: Form A Toolholder = Form A Insert

P	•
M	•
K	•
N	•
S	•
H	-

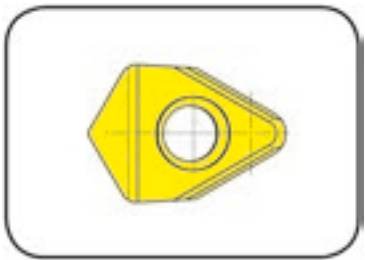
硬质合金牌号
Carbide grades

插削 - 内六角
Broaching - Hexagon Socket



刀片
Insert

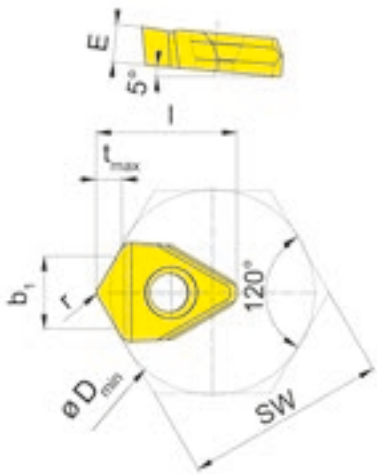
S117



内六角自	Hexagon socket from	SW14 - SW36

配合刀杆
for Toolholder

型号 SH117
Type SHM117



内六角
Hexagon socket

产品型号 Part number	SW	b ₁	l	r	E	D _{min}	t _{max}	刀杆 Toolholder	Ti25	
S117.SW14.08	14-16	4.94-5.80	13.0	0.2	4.0	14.2-16.2	1.9	SH117.1425.30.1.08	▲	•
S117.SW16.10	16-22	5.80-8.43	14.0	0.2	3.0	16.2-22.2	2.5	SH117.1625.30.1.10	▲	•
S117.SW24.12	24-27	8.70-10.00	17.0	0.3	4.5	24.3-27.3	3.0	SH117.2432.30.1.12	▲	•
S117.SW30.16	30-36	11.32-13.97	20.7	0.3	6.0	30.3-36.3	4.2	SH117.3032.30.1.16	▲	•
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request • 推荐 / recommended o 次推荐 / alternative recommendation - 不合适 / not suitable ■ 非涂层 / uncoated grades ■ 涂层 / coated grades ■ 钎焊/金属陶瓷 / brazed/Cermet 尺寸单位 : mm Dimensions in mm									P	•
									M	•
									K	•
									N	•
									S	•
									H	-

硬质合金牌号
Carbide grades



型号 SH117 / SHM117 - 刀杆可以直接安装在刀塔和m/c主轴上

type SH117 / SHM117 - Holder can be located directly in the turret or m/c spindle

尺寸 DIN Dimensions DIN				插削 Broaching		倒角 Chamfering	
宽 Width	公差等级 Tolerance grade	D _{min}	t	刀片 Inserts	刀杆 Toolholder	刀片 Inserts	刀杆 Toolholder
3		14	2.0	S117.0310.04.08	SH117.1425.1.3.08	S117.2445.08	SH/SHM117...08
4		14	2.1	S117.0410.05.08	SH/SHM117...08	S117.2445.08	SH/SHM117...08
6		22	2.6	S117.0610.22	SH117.0025...10	S117.3045.10	SH117.0025...10
7		27	3.3	S117.0710.27	SH117.0025...10	S117.3045.10	SH117.0025...10
8	C11	32	3.4	S117.0810.32	SH117.0025...10	S117.3045.10	SH117.0025...10
10		40	4.2	S117.1014.40	SH117.0032...16	S117.6045.14	SH117.0032...16
12		50	5.1	S117.1214.50	SH117.0032...16	S117.6045.14	SH117.0032...16
16		70	6.6	S117.1614.70	SH117.0032...16	S117.6045.14	SH117.0032...16
24		100	8.5	S117.2414.100	SH117.0032...16	S117.6045.14	SH117.0032...16
3		14	2.0	S117.0298.01.08	SH117.1425.1.3.08	S117.2445.08	SH/SHM117...08
4		14	2.1	S117.0397.01.08	SH/SHM117...08	S117.2445.08	SH/SHM117...08
5		14	2.7	S117.0497.02.08	SH/SHM117...08	S117.2445.08	SH/SHM117...08
5		17	2.7	S117.0497.02.10	SH117.1725...10	S117.1545.10	SH117.1725...10
6	P9	17	3.4	S117.0597.02.10	SH117.1725...10	S117.1545.10	SH117.1725...10
8		22	4.1	S117.0796.02.10	SH117.0025...10	S117.3045.10	SH117.0025...10
10		30	4.2	S117.0996.03.14	SH117.3032...16	S117.6045.14	SH117.3032...16
12		38	5.7	S117.1196.03.14	SH117.0032...16	S117.6045.14	SH117.0032...16
14		40	6.8	S117.1396.03.16	SH117.4032...16	S117.6045.14	SH117.0032...16
3		14	2.0	S117.0300.01.08	SH117.1425.1.3.08	S117.2445.08	SH/SHM117...08
4		14	2.1	S117.0400.01.08	SH/SHM117...08	S117.2445.08	SH/SHM117...08
5		14	2.7	S117.0500.02.08	SH/SHM117...08	S117.2445.08	SH/SHM117...08
5		17	2.7	S117.0500.02.10	SH117.1725...10	S117.1545.10	SH117.1725...10
6	JS9	17	3.4	S117.0600.02.10	SH117.1725...10	S117.1545.10	SH117.1725...10
8		22	4.1	S117.0800.02.10	SH117.0025...10	S117.3045.10	SH117.0025...10
10		30	4.2	S117.1000.03.14	SH117.3032...16	S117.6045.14	SH117.3032...16
12		38	5.7	S117.1200.03.14	SH117.0032...16	S117.6045.14	SH117.0032...16
12		38	8.5	S117.1200.05.14	SH117.0032...16	S117.6045.14	SH117.0032...16
14		40	6.8	S117.1400.03.16	SH117.4032...16	S117.6045.14	SH117.0032...16

技巧和窍门

- 插削末端的退刀槽是必需的
- 刀片应与材料接触
- 冷却油或冷却乳液的使用有助于提高刀具寿命和表面光洁度，并有助于切屑的排出
- 刀具应被设定在12点钟方向，确保切屑从成槽中排出
- 刀具的设定非常重要，进行第一步前一定要仔细检查工件直径
- 测量刀具的精度，并在加工第一刀时仔细观察工件直径
- 第一冲程中定位刀具的初始位置，并在程序中编入停止项，以便去目测是否存在碰撞。

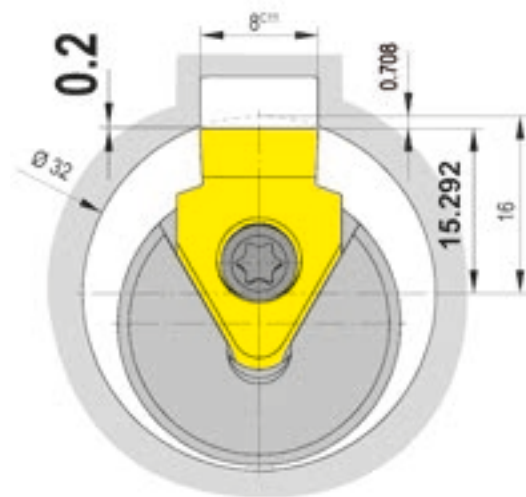
Application Tips:

- It is important to use a machine with mechanical spindle lock.
- The use of proper coolant is key to a good surface finish, long tool life as well as chip evacuation.
- A relief groove or the possibility for a "ramp down" exit out of the cut is necessary at the end of the broached groove.
- Setting of the tool is very important. Double check the component diameter before taking the first pass.
- The tool should be set at the 12 o'clock position to ensure that chips fall away from the groove.
- Take an accurate measurement of the insert and program the dimension into the machine tool parameter.
- Position the tool at the start position of the first stroke and program a stop to perform a visual check to assure a collision free first pass of the tool.

加工实例:

孔径32mm，槽宽8mm：

半径16mm，安全间隙0.2mm，刀尖圆角r0.2mm，刀刃在X轴方向设定在15.292处，避免开始加工时碰撞。



Machining example:

Bore diameter 32 mm, groove width 8 mm:

At a radius of 16 mm and with a clearance of 0,2 mm for safety at the r 0,2 mm corner radii, the tool has to be set at 15,292 mm in X-axis to avoid any collision at the beginning of the process.

计算起始位置 b_1 :

Calculation of the start position b_1 :

$$c^2 = a^2 + b^2$$

$$b^2 = c^2 - a^2$$

$$b = \sqrt{c^2 - a^2}$$

$$b = \sqrt{16^2 - 4^2}$$

$$b = 15.491933$$

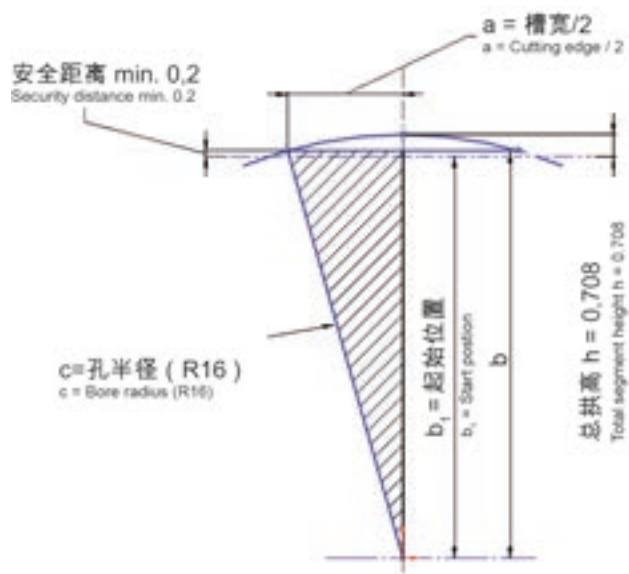
$$b_1 = b - \text{安全距离}$$

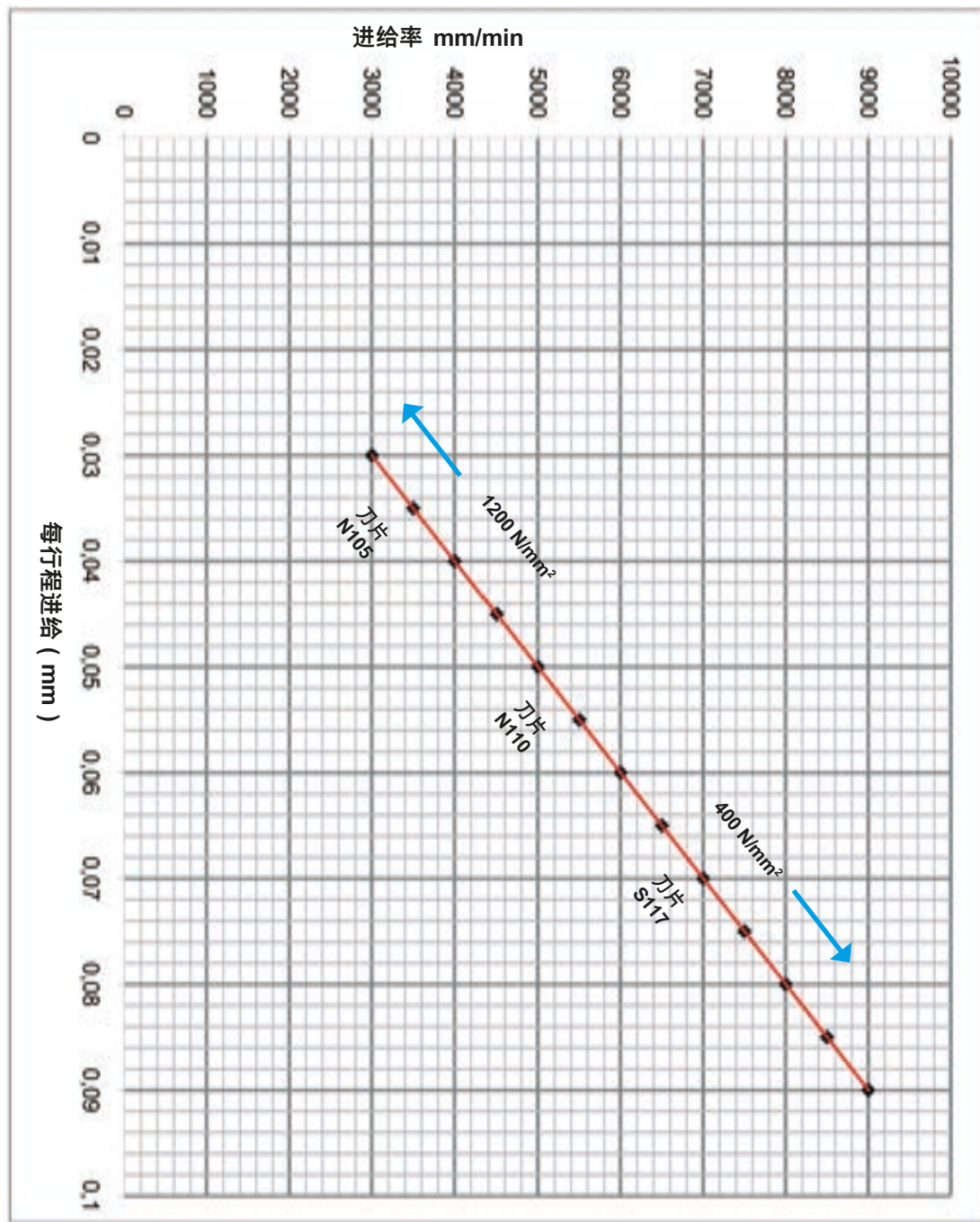
Clearance distance

$$b_1 = 15.492 - 0.2 = 15.292 \text{ mm}$$

→ 相当于起始位置 $\varnothing 30.584\text{mm}$

→ equals as a start position at $\varnothing 30.584 \text{ mm}$

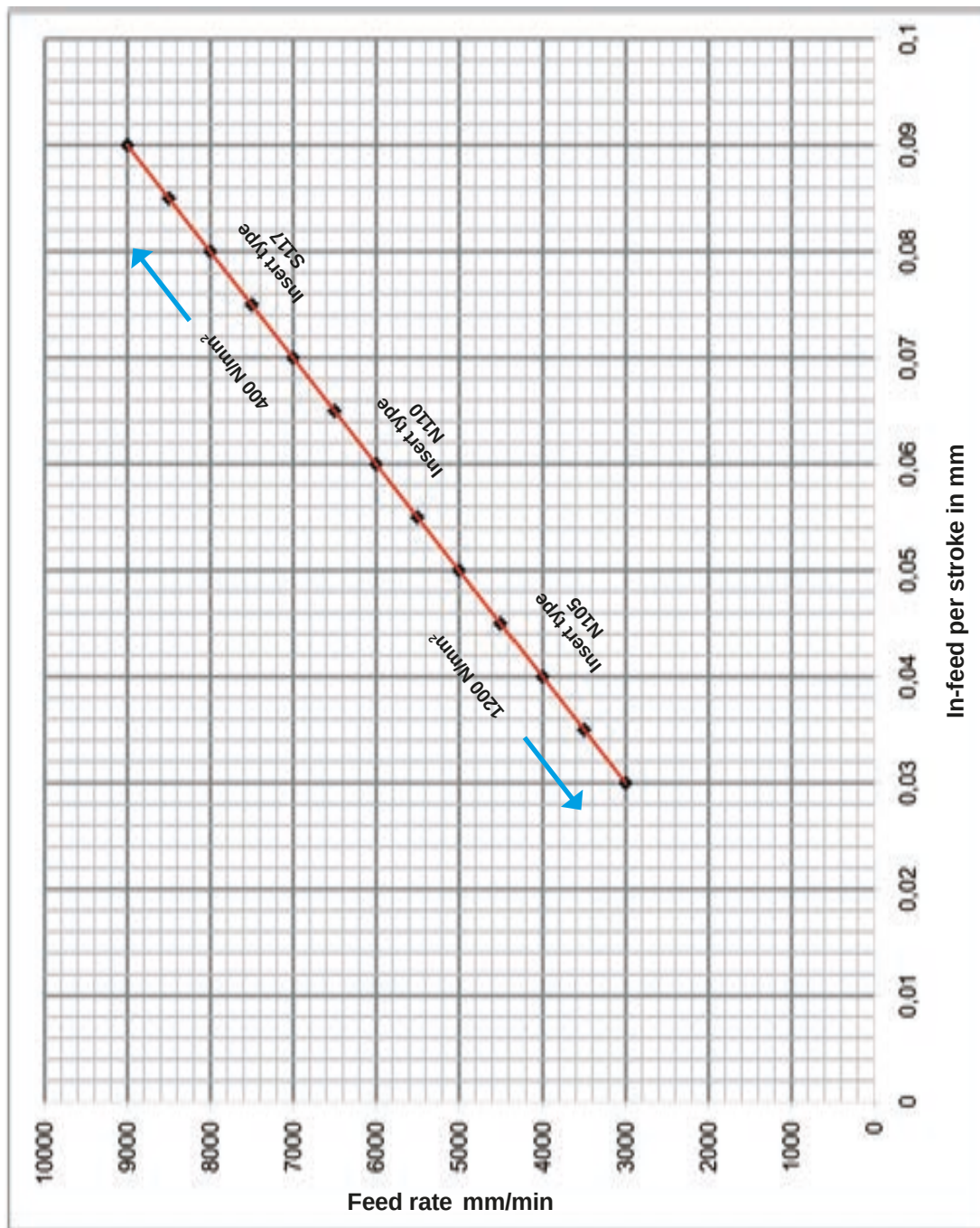




上述值仅供参考，机床情况、工件轮廓、夹紧方式以及工件材质都影响切深和进给率。

应用细节：

- 插槽时需要退刀槽或者底部的斜面以便退刀。
- 退刀之前切削刃必须在槽外设定正确的位置。
- 精确测量刀片并将尺寸编程进入刀具参数内。
- 在第一冲程中定位刀具的初始位置，并在程序中编入停止项，以便去目测是否存在碰撞。
- 使用合适的冷却液是提高表面光洁度、刀具寿命和将切屑排出盲孔的关键



The above values are guidelines only. The physical condition of the machine, the work piece profile and clamping, as well as the type of material have great influence on the depth of cut and feed rate.

Application Tips:

- A relief groove or the possibility for a 'ramp down' exit out of the groove is necessary at the end of the broached groove.
- The insert cutting edge has to be positioned outside the groove before retracting the tool.
- Take an accurate measurement of the insert and program the dimension into the machine tool parameter.
- Position the tool at the start position of the first stroke and program a stop to perform a visual check to assure a collision free first pass of the tool.
- The use of proper coolant is key to a good surface finish, long tool life as well as chip evacuation out of a blind hole.

TRAUB TNA 400 (含C轴) 上的插削实例

NC - 程序

N.....(插削)	编号及应用
G97 T.....	M5 恒定转速，刀具调出，主轴停止
M17	开启C轴
G94	进给率 mm/min
L1 = 30.584	选择初始参数 Ø
M8 M19	冷却开, 主轴暂停开
N100 开始	重复START
G0 XL1 Z5	零件前面X和Z轴方向上的起始位置
G1 Z-25 F8000	Z方向直线进给速率8000 mm/min
G0 X30.584	X方向快速移动至起始 Ø i.e. 停止位置
G0 Z5	Z方向快速移动至起始位置
L1 = L1+0.16	编程中Ø 增加两倍切深
N200	重复END编号
G22 P100 Q200 H45	重复循环自START到END

例如：

- 按照表格孔径Ø32mm内的槽
- 槽宽8^{C11}
- 进给0.08mm
- 行程数是完整的槽深，即自起始位置到槽底，除以每行程切深。
- 这个数值必须是2的倍数（因为Ø编程需要），它将被在NC程序中设定为行程数。

计算:

- 起始位置=安全距离+距离自Ø切削刃起32mm (见P25页实例)
拱高0.508 mm +0.20 mm安全距离共0.708 mm
- 起始位置=30.584 mm (32 - [0.708 x 2] = 30.584 mm.
槽深2.90 mm加上 0.708 mm = 3.608 mm。
- 这是在Ø编程使用的尺寸：自起始位置到槽底的距离
- 3.608是起始位置到槽底的尺寸，编程过程中3.608需乘以2等于7.216mm
- 7.216除以每行程 (2*00.08mm) 0.16得出行程数45

用于精加工的最后尺寸的0.1行程必须精确计算然后编入程序内

注意：刀片的真实切深为0.08mm

Example for broaching on a TRAUB TNA 400 with C-Axis

NC - Programme

N.....(BROACHING)	Sequence Number and Application
G97 T..... M5	constant RPM, Tool callout, Spindle Stop
M17	C - axis ON
G94	Feed Rate in mm/min
L1 = 30.584	choose Parameter for start Ø
M8 M19	Coolant ON, Spindle Break ON
N100	Sequence Number for repetition START
G0 XL1 Z5	Start position in X and Z in front of part
G1 Z-25 F8000	Linear move in Z at feed rate of 8000 mm/min
G0 X30.584	Rapid move in X to start Ø i.e. drop down position
G0 Z5	Rapid move in Z to start position.
L1 = L1+0.16	As Ø programming is in effect the depth of cut must be doubled (Depth of Cut is 0.08 mm)
N200	Sequence Number of repetition END.
G22 P100 Q200 H45	Repetition Cycle with Sequence Number from START to END and Number of repetitions

Example:

- Groove according to table in bore **Ø 32 mm**
- Groove width **8^{c11}**
- Depth of Cut per Stroke 0.08 mm
- The **Number of Strokes** resulted out of complete cutting depth from start position to the bottom of the groove divided by depth of cut per stroke
- This Value must then be multiplied by 2 (because Ø Programming) and Value is programmed as the Number of Strokes in the NC-Programme.

Calculation:

- Starting Position = Security Distance + Distance from Ø 32 mm to Cutting Edge (see Example on Page V37) equals a segment height of **0.508 mm** + Security Distance of **0.20 mm** to a total of **0.708 mm**.
- Starting Position = **30.584 mm** (32 - [0.708 x 2] = 30.584 mm).
- The groove depth of **2.90 mm** added to the **0.708 mm** = **3.608 mm**.
- This is the dimension from the starting position to the bottom of the groove and in order to program this on the Ø, the **3.608 mm** dimension must be **multiplied by 2** which will equal the sum of **7.216 mm**.
- When the **7.216 mm** is divided by (**2 x 0.08 mm**) = **0.16 mm** depth per stroke the Result will be **45.1 Strokes** and therefore **45 total Strokes** are programmed.

The remainder of 0.1 Strokes to achieve the finish dimension must be programmed using the fine correction.

Attention: The true depth of cut for the insert will be 0.08 mm.

可锁定主轴的机床上 (西门子程序) 的加工实例

NC - 程序

N.....(插削)	编号及应用
T..... M5 LF	刀具调出, 主轴停止
M..... LF	暂停开
G94 LF	进给率 in mm/min
R1 = 30.584 LF	选择初始参数Ø
M8 LF	冷却开
N100 LF START	编号
G0 X=R1 Z5 LF	X和Z方向起始位置
G1 Z-25 F8000 LF	Z方向直线进给速率8000 mm/min
G0 X30.584	X方向快速复位
G0 Z5	Z方向快速移动至起始位置
R1 = R1+0.16	编程中Ø 增加两倍切深
N200	重复END编号
.....LF	重复循环自START到END

例如：

- 按照表格孔径Ø32mm内的槽
- 槽宽8^{C11}
- 进给0.08mm
- 行程数是完整的槽深，即自起始位置到槽底，除以每行程切深。
- 这个数值必须是2的倍数（因为Ø编程需要），它将被在NC程序中设定为行程数。

计算：

- 起始位置=安全距离+距离自Ø切削刃起32mm（见P25页实例）
拱高0.508 mm +0.20 mm安全距离共0.708 mm
- 起始位置=30.584 mm (32 - [0.708 x 2] = 30.584 mm.
槽深2.90 mm加上 0.708 mm = 3.608 mm。
- 这是在Ø编程使用的尺寸：自起始位置到槽底的距离
- 3.608是起始位置到槽底的尺寸，编程过程中3.608需乘以2等于7.216mm
- 7.216除以每行程（2*0.08mm）0.16得出行程数45

用于精加工的最后尺寸的0.1行程必须精确计算然后编入程序内

Example for broaching on SIEMENS Control Machines with lockable Spindle

NC - Programme

N.....(BROACHING)	Sequence Number and Application
T..... M5 LF	Tool callout, Spindle Stop
M..... LF	Brake ON
G94 LF	Feed Rate in mm/min
R1 = 30.584 LF	choose Parameter for start Ø
M8 LF	Coolant ON
N100 LF	Sequence Number for repetition START
G0 X=R1 Z5 LF	Start position in X and Z in front of part
G1 Z-25 F8000 LF	Linear move in Z at feed rate of 8000 mm/min
G0 X30.584	Rapid move in X to start Ø i.e. drop down position
G0 Z5	Rapid move in Z to start position.
R1 = R1+0.16	As Ø programming is in effect the depth of cut must be doubled (Depth of Cut is 0.08 mm)
N200	Sequence Number of repetition END.
.....LF	Repetition Cycle with Sequence Number from START to END and Number of repetitions

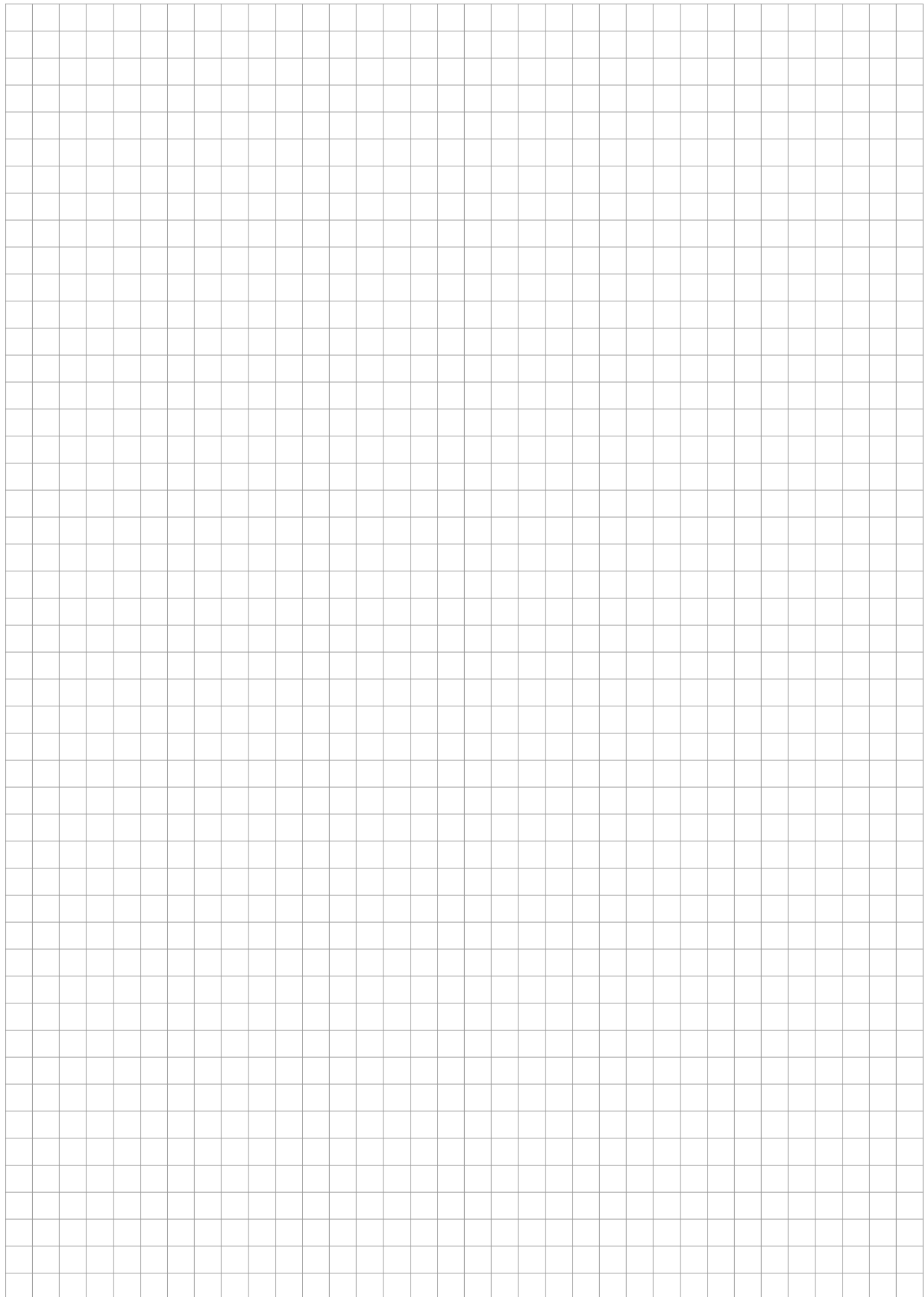
Example:

- Groove according to table in bore **Ø 32 mm**
- Groove width **8^{c11}**
- Depth of Cut per Stroke 0.08 mm
- The **Number of Strokes** resulted out of complete cutting depth from start position to the bottom of the groove divided by depth of cut per stroke
- This Value must then be multiplied by 2 (because Ø Programming) and Value is programmed as the Number of Strokes in the NC-Programme.

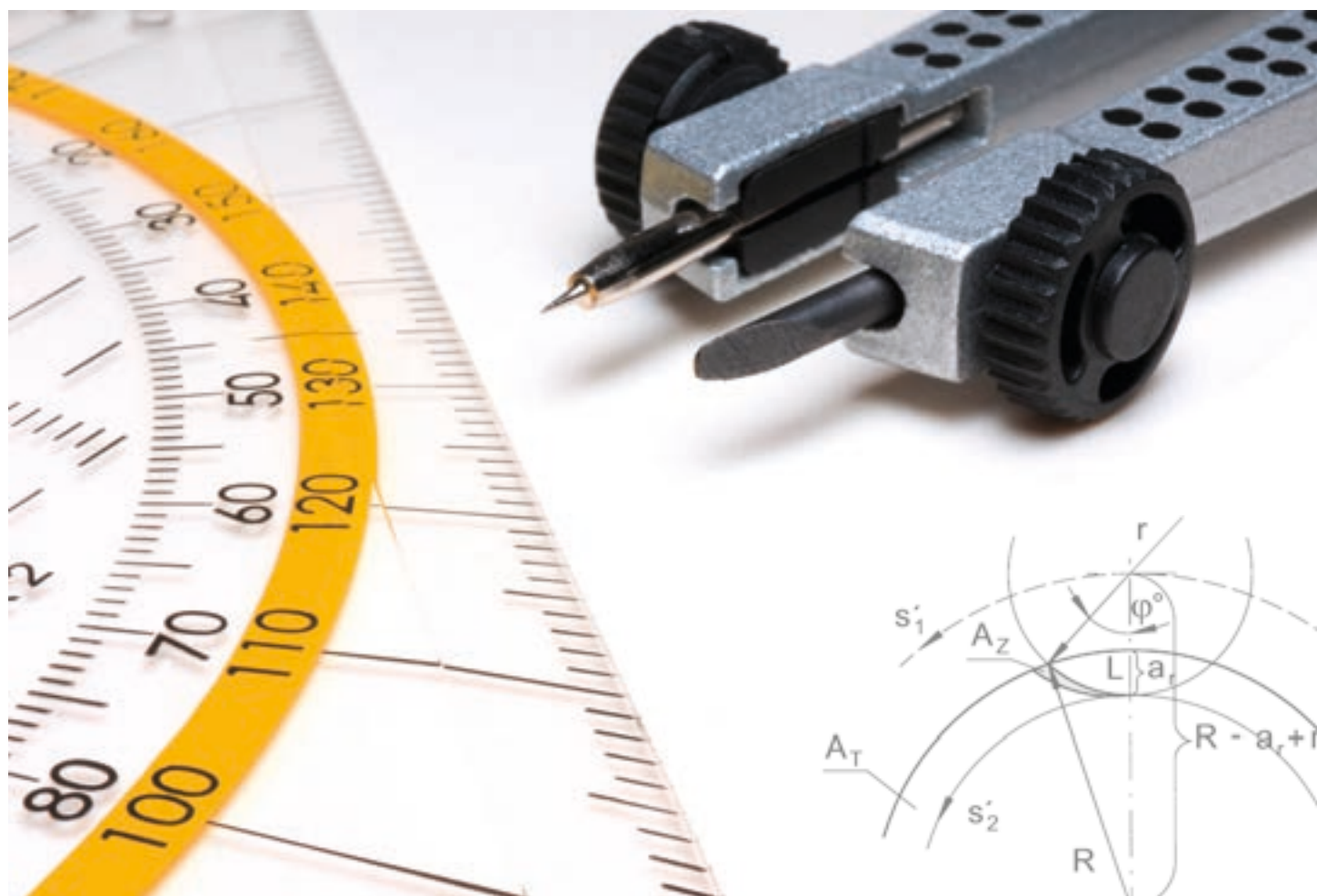
Calculation:

- Starting Position = Security Distance + Distance from Ø 32 mm to Cutting Edge (see Example on Page V37) equals a segment height of **0.508 mm** + Security Distance of **0.20 mm** to a total of **0.708 mm**.
- Starting Position = **30.584 mm** ($32 - [0.708 \times 2] = 30.584$ mm).
- The groove depth of **2.90 mm** added to the **0.708 mm** = **3.608 mm**.
- This is the dimension from the starting position to the bottom of the groove and in order to program this on the Ø, the **3.608 mm** dimension must be **multiplied by 2** which will equal the sum of **7.216 mm**.
- When the **7.216 mm** is divided by (**2 x 0.08 mm**) = **0.16 mm** depth per stroke the Result will be **45.1 Strokes** and therefore **45 total Strokes** are programmed.

The remainder of 0.1 Strokes to achieve the finish dimension must be programmed using the fine correction.



V



摘要/Summary

页/Page

附加设备
Additional equipment

W2-W7

W



使用GRAF上的可移动高压系统，
能够非常好的冷却刀具。

明显的优点: 寿命长!

With the mobile high-pressure systems from **GRAF**
you can employ the through cooled tools optimally.

The advantages are obvious: longer tool life!





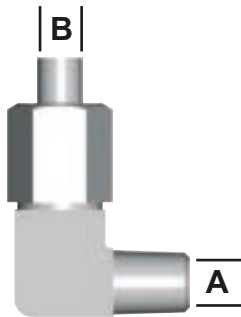
冷却系统标准连接头

Standard connection for coolant supply for pipe Ø 6 mm



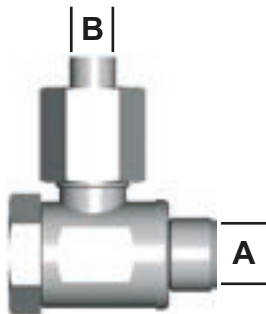
冷却液连接器
垂直锁紧
Connection for coolant supply
straight screwed

A	B	物料号 Part number
M8 x 1	Ø 6 mm	004.00.19
G1/8"	Ø 6 mm	004.00.14



冷却液连接器
带角度固定
Connection for coolant
supply angled and fix

A	B	物料号 Part number
M8 x 1	Ø 6 mm	004.00.22
G1/8"	Ø 6 mm	004.00.33



可旋转, 夹紧装配
Swivelling screw-fitting

A	B	物料号 Part number
M8 x 1	Ø 6 mm	004.00.61
G1/8"	Ø 6 mm	004.00.16

冷却系统快速接头

Clip connection for coolant supply

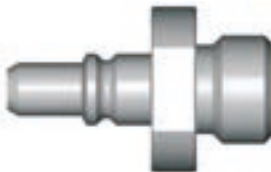
快速夹头
Quick connector

M10 x 1 - 004.00.49



柱塞
Plug

M8 x 1 - 004.00.56
G1/8" - 004.00.57



柱塞
Plug

Ø 6 mm - 004.00.59





D 041 VL
0,4-1 Nm

带刻度的扭矩扳手
-扭矩可调
-屏幕显示调整扭矩

扭矩无极调节，符合人体工程学的多组件手柄，轻而紧凑的设计，当达到设定扭矩时单击信号按钮。
(标准: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)
(精度: $\pm 6\%$)



D 15 VL
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
2-7 Nm



ED 28 VL
配 / for
D041VL / D15VL / D28VL

设定扭矩的设备

柄部：醋酸纤维材质，表面为细微结构

刃部：八角形，硬化处理，镀锌

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

配 / for
D041VL / D15VL / D28VL



Plus

刀头-Torx螺钉

刀头： 高品质铬钒钢，硬化处理，镀铬
Wiha镀铬刀头保证了最好的精密度。
颜色代码为绿色

用途： 拧紧螺钉到指定扭矩，和Wiha扭矩扳手刀柄组合。

Blade for TORX-Plus® screws

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.
Wiha Chrome Blade guarantees maximum precision.
Colored code dark green

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle.



DT6K
DT8K
DT15K

配 / for
D041VL / D15VL / D28VL



刀头-Torx螺钉

刀头： 高品质铬钒钢，硬化处理，镀铬
Wiha镀铬刀头保证了最好的精密度。
颜色代码为绿色

用途： 拧紧螺钉到指定扭矩，和Wiha扭矩扳手刀柄组合。

Blade for Torx screws

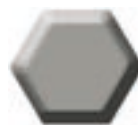
Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.
Wiha Chrome Blade guarantees maximum precision.
Colored code dark green

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle.



DSW15K
DSW20K
DSW25K
DSW30K
DSW40K

配 / for
D041VL / D15VL / D28VL



扳手刀头-内六角螺钉

刀头： 高品质的铬钒钢，硬化处理，镀铬。
Wiha镀铬刀片保证了最好的精密度。
使用红色代码

应用： 使用给定的拧紧扭矩，结合一个Wiha扭矩扳手。

Blade for allen screws

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.
Wiha Chrome Blade guarantees maximum precision.
Colored code red

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle

DSW50K
DSW60K

配 / for
D15QL



D14ZBK

配 / for
D041VL / D15VL / D28VL

通用钻套

适用于S.DM08、S.DM10及S.DM12，也用于所有的C6.3和E6.3(1/4")钻头

刀头： 高品质铬钒钢，经过硬化处理，镀铬。
刀颈： 不锈钢
应用： 用于固定扭矩，扭矩标与柄部。

Universal Bitholder for 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

5-14 Nm

带刻度的扭矩扳手

-扭矩可调
-屏幕显示调整扭矩

扭矩无极调节，符合人体工程学的多组件手柄，轻而紧凑的设计，当达到设定扭矩时单击信号按钮。
(标准: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)
(精度: $\pm 6\%$)

Torque screw driver with scale

- variable torque setting
- adjusted torque is shown on display

The Torque can be adjusted with a special torque setter (included).
Ergonomical form gives perfect handling abilities. Audible signal when set torque is reached.
(Standard: EN ISO 6798, BS EN 26789, ASME B 107.14.M.)
(Precision: $\pm 6\%$)



ED515QL

配 / for
D515QL

扭矩调整扳手

柄部： 纤维素乙酸酯微观结构表面

刃部： 8角形状,经过硬化处理，镀铬。

Device for setting the required torque.

Handle: Celluloseacetat with micro structured surface
Blade: Octogonal (8 flats) blade, hardened galvanized



DT15PQ
DT20PQ
DT25PQ
DT27PQ
DT30PQ

配 / for
D515QL



Plus

扳手刀头配 TORX PLUS® 螺钉

刀头： 高品质铬钒钢，经过硬化处理，镀铬。

Wiha镀铬刀片保证了最好的精密度。

使用深绿色代码

应用： 使用给定的扭紧扭矩，结合一个Wiha扭矩扳手。

Blade for 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

配 / for
D515QL

通用钻套

也用于所有的C6.3和E6.3(1/4")钻头

刀头： 高品质铬钒钢，经过硬化处理，镀铬。

刀颈： 不锈钢

应用： 用于固定扭矩，扭矩标与柄部。

Universal Bitholder

for C6,3 and E6,3 (1/4") Bits

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Collar: Stainless steel

Utilization: For controlled screw setting with definite torque in combination with torque screw driver handle.



14ZQK

通用T型刀柄的钻套

适用于S.DM08、S.DM10及S.DM12，也用于所有的C6.3和E6.3(1/4")钻头

刀头： 高品质铬钒钢，经硬化处理，镀铬

刀颈： 不锈钢

应用： 开关控制

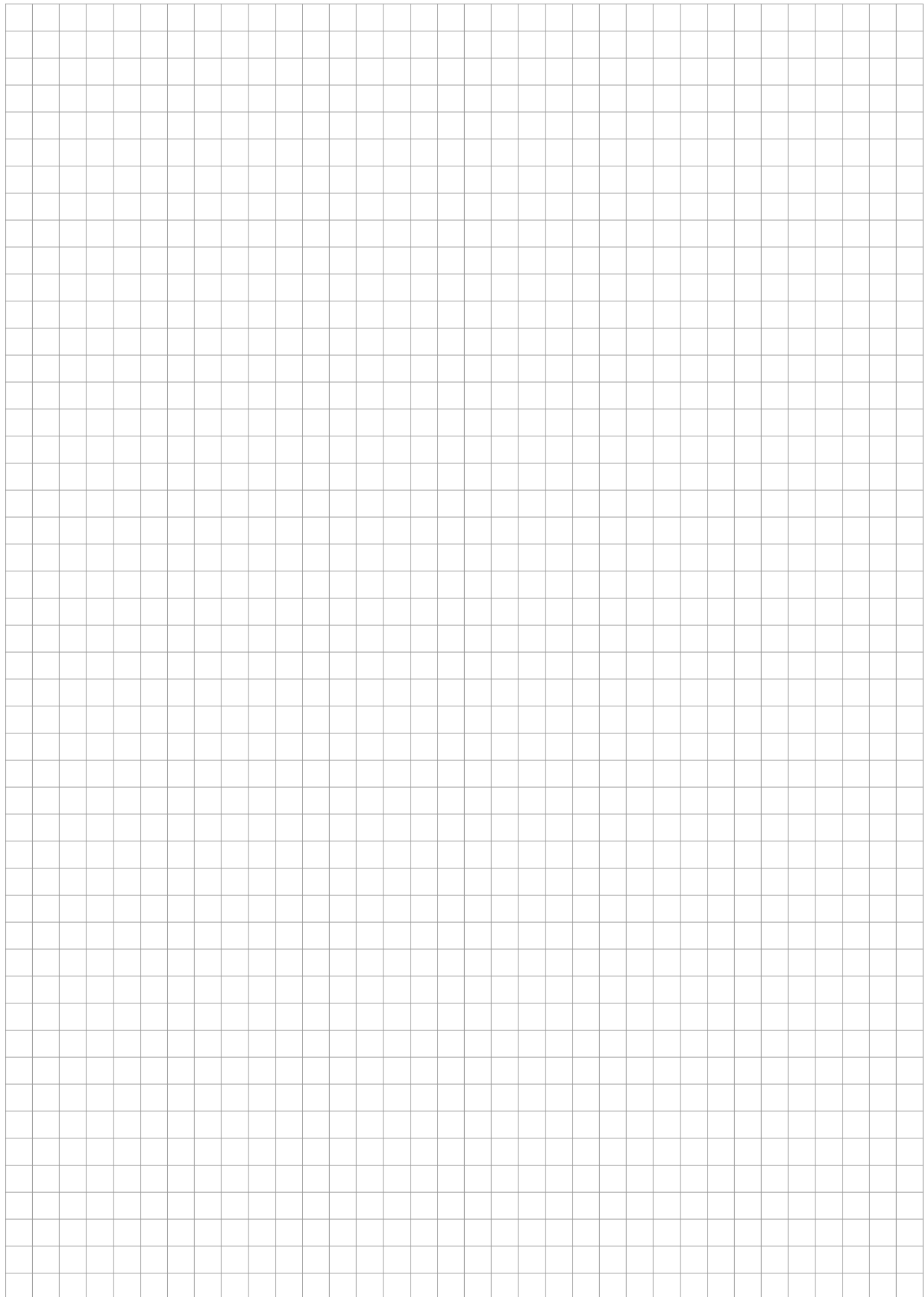
Universal Bitholder with T-handle

for 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



W

加工材料组 nach DIN ISO 513

Cutting Material Groups per DIN ISO 513

组别 Main group	标志	子组别 Subgroups
硬质合金 Carbide	HW	非涂层硬质合金, WC基体 uncoated carbides based upon WC
	HT	非涂层硬质合金, TiC/TiN-基体 (金属陶瓷) uncoated carbides based upon TiC/TiN (Cermets)
	HF	细微颗粒硬质合金 micro grane carbides
	HC	涂层硬质合金/金属陶瓷 coated carbides / cermets
陶瓷 Ceramic cutting material	CA	氧化物陶瓷, Al ₂ O ₃ -基体 Oxide ceramics based upon Al ₂ O ₃
	CM	混合陶瓷, Al ₂ O ₃ + 金属碳化物-基体 Mixed ceramics based upon Al ₂ O ₃ + metal carbide
	CN	氮化物陶瓷, Si ₃ N ₄ -基体 Nitride ceramics based upon Si ₃ N ₄
	CC	涂层陶瓷 Coated ceramics
金刚石 Diamond	DM	单晶金刚石 (MCD) Monocrystalline diamond (MCD)
	DP	立方金刚石 (PCD) Polycrystalline diamond (PCD)
氮化硼 Boron nitride	BN	立方氮化硼 (CBN) Polycrystalline, cubic boron nitride (PCBN)

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