

车槽 • 切断 • 铣槽 • 插削 • 仿形铣削 • 钻孔 • 铰削



Supermini® & Mini

内孔加工

Internal Machining

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 Supermini® Chapter Supermini®

刀具系列 / System 105

镗孔,槽加工,倒角,螺纹,端面槽

Boring, Grooving, Chamfering, Threading, Face Grooving

刀具系列 / System 109

镗孔,槽加工,倒角,螺纹,端面槽

Boring, Grooving, Chamfering, Threading, Face Grooving

刀具系列 / System 110

镗孔,槽加工,端面槽

Boring, Grooving, Face Grooving

B Mini Chapter Mini

刀具系列 / System 106

镗孔,槽加工,倒角

Boring, Grooving, Chamfering

System / System 107

镗孔,槽加工,倒角,螺纹

Boring, Grooving, Chamfering, Threading

刀具系列 / System 108

镗孔,槽加工,倒角,螺纹

Boring, Grooving, Chamfering, Threading

刀具系列 / System 10P

槽加工

Grooving

刀具系列 / System 111

镗孔,槽加工,倒角,螺纹

Boring, Grooving, Chamfering, Threading

刀具系列 / System 11P

槽加工

Grooving

刀具系列 / System 114

镗孔,槽加工,倒角,螺纹,端面槽

Boring, Grooving, Chamfering, Threading, Face Grooving

刀具系列 / System 116

镗孔,槽加工,倒角,螺纹

Boring, Grooving, Chamfering, Threading

刀具系列 / System 18P

槽加工

Grooving

C 技术说明 Chapter Technical Instructions

技术说明,加工实例,附加设备

Technical Instructions, Examples for machining, Additional equipment

A

B

C

品质与环境承诺

客户的标准就是我们的质量. 他们对我们产品的意见至关重要.

员工是我们最重要的资产之一. 卓越的职业素养和社交技能是一个先决条件, 持续保持和发展它们是至关重要的.

我们的目标是在过程的早期发现潜在的错误, 并将其作为消除其原因和进一步持续改进的动力. "一次成功率"是我们的座右铭.

我们一直在努力提高管理体系的效率. 我们识别潜在的风险和机遇, 并制定改善措施.

我们确定所有活动, 产品和服务的环境方面, 并评估这些可能导致重大生态影响的程度, 然后得出目标和环境方案.

我们的环保工作旨在尽量减少噪音, 空气污染物, 废物和废水, 以及节约用水和能源等资源.

我们的环境管理系统不断监测和改善环境保护. 守法是我们不断发展和优化的环境管理制度的基本要素.

我们致力于一项既符合法律要求又符合行业协会自愿承诺的能源政策, 并符合生态和经济要求. 我们还致力于不断审查和改进与能源有关的方面和业绩.

我们已根据ISO 50001实施能源管理系统, 以执行我们的能源政策, 并优化我司在能源的有效利用方面的工艺. 我们通过能源经理、作为协调者和共享信息者, 确保所有员工的理解及参与.

Quality and Environment Commitment

Our customers set the standard for our quality. Their opinion of our products is crucial.

Our employees are one of our most important assets. Excellent qualifications and social skills are a prerequisite and it is vital that they are constantly maintained and developed.

We aim to detect potential errors early on in the process and use them as an impetus to eliminate their causes and for further and continuous improvement. "Right first time!" is our motto.

We are constantly working to improve the effectiveness of our management system. We identify potential risks and opportunities and develop measures to improve them.

We identify the environmental aspects of all activities, products and services and assess the extent to which these can lead to significant ecological impacts, then derive objectives and an environmental programme.

Our environmental performance is designed to reduce noise, air pollutants, waste and waste water as much as possible and to conserve resources such as water and energy.

Our environmental management system continuously monitors and improves environmental protection. Legal compliance is an essential element of our environmental management system, which is continuously developed and optimised.

We are committed to an energy policy that is in line with both legal requirements and the voluntary commitments of industry associations and which meets ecological and economical requirements. We are also committed to continually reviewing and improving energy-related aspects and performance.

We have implemented an energy management system in accordance with ISO 50001 in order to implement our energy policy and optimise the processes in our company with regard to the efficient use of energy. We ensure the comprehensive, active involvement of all employees through an energy manager, who acts as a coordinator, and a network of employees who share information.



系列/System

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刀杆
Toolholder

B105

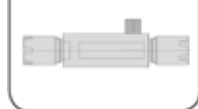


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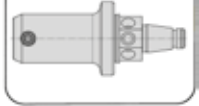
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WF

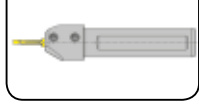


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HC105
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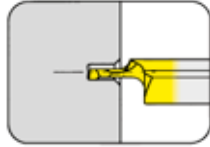
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B105

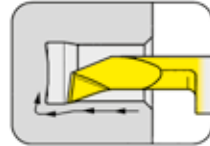


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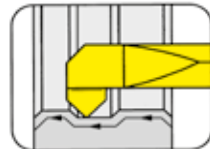
Schneidplatte
Insert
105



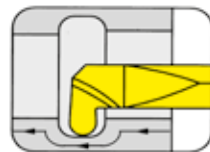
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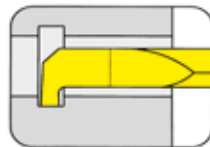
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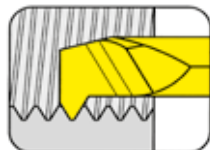
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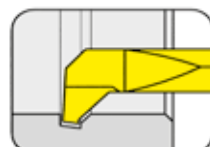
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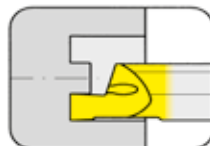
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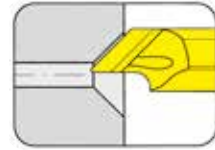
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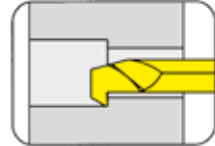
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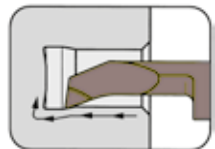
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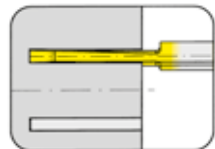
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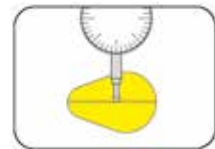
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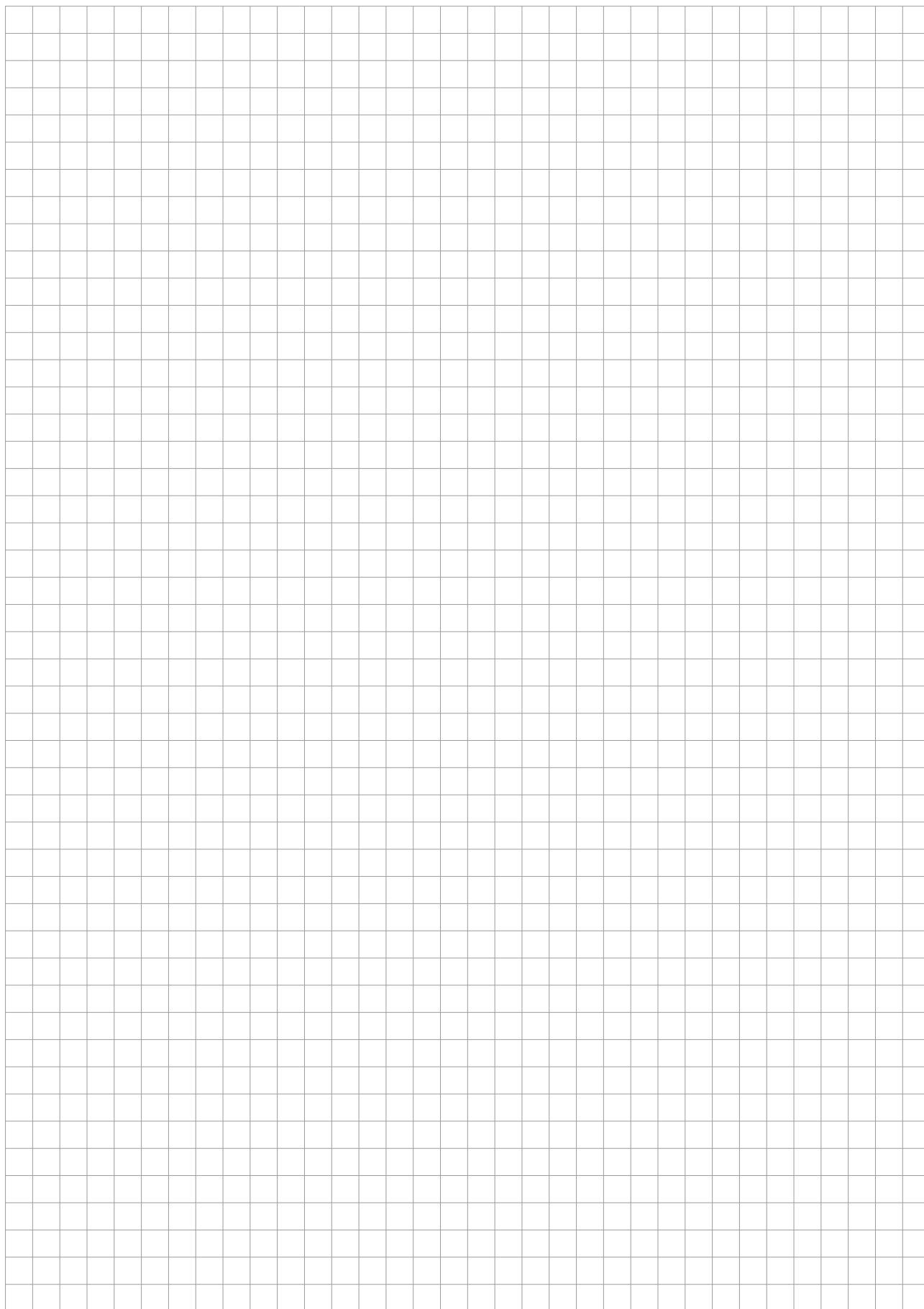


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刀片
Insert
105



105



机夹式刀杆

槽宽0,5 - 2 mm

Toolholder with Inserts

Width of groove 0,5 - 2 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0,2	•											
≥ 0,5	•											
≥ 0,7	•											
≥ 1,0	•											
≥ 1,5	•											
≥ 2,0	•											
≥ 3,0	•											
≥ 4,0	•											
≥ 5,0	•											
≥ 6,0	•	•	•	•								
≥ 6,8		•	•	•								
≥ 7,0		•			•							
≥ 7,8			•		•	•						
≥ 8,0			•		•	•						
≥ 9,0			•		•	•	•					
≥ 10,0			•				•	•	•			
≥ 10,5									•			
≥ 11,0								•	•			
≥ 11,5									•			
≥ 13,8										•		
≥ 14,0										•	•	
≥ 16,0											•	
≥ 16,5										(•)		
≥ 18,0												•

槽深 Depth of groove	2,5	2,5	4,0	0,8	2,0	1,0	3,0	2,3	3,5	4,0 (6,5)	4,3	8,0
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槽宽 Width of groove	0,5-2,0	1,0-2,0	1,0-3,0	0,7-1,5	1,0-2,0	0,7-2,0	1,0-3,0	0,7-3,0	1,0-3,0	0,7-3,0	0,7-4,0	2,0-3,0
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加工 / Machining												
切槽 / Grooving	•	•	•	•	•	•	•	•	•	•	•	•
镗孔 / Boring	•	•	•	•	•	•		•		•	•	
螺纹切削 / Threading	•	•			•	•		•		•	•	
倒角 / Chamfering	•	•		•	•	•		•		•	•	
端面切槽 / Face Grooving	•	•	•							•		
硬车削 / Hard turning	•					•		•		•	•	

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

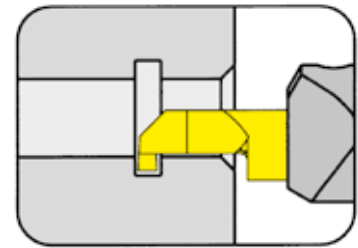
B105

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深可达
槽宽可达

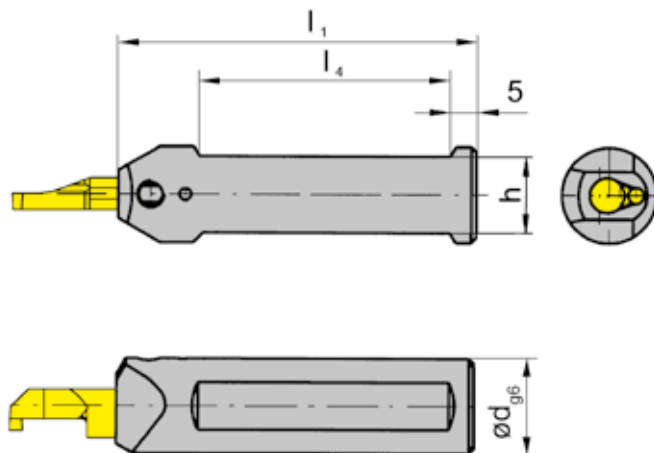
Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
2 mm



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
B105.0010.01	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
B105.0022.01	22	90	20	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

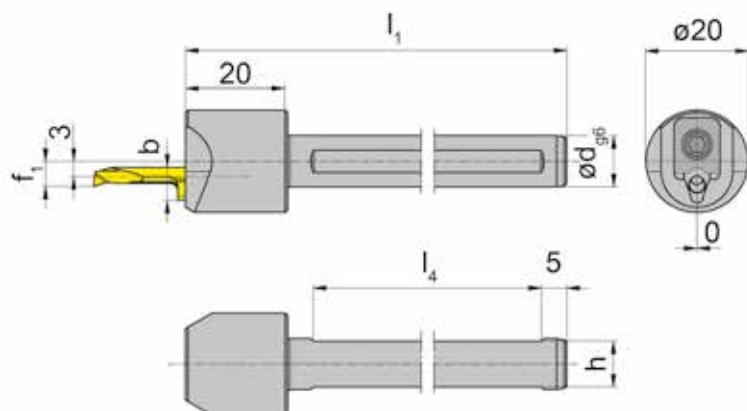
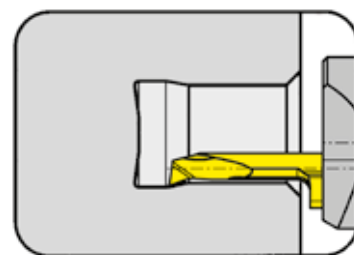
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

刀杆

Toolholder

B105

直接冷却液供应
with through coolant supply孔径Ø 自
槽深
槽宽可达Bore Ø from
Depth of groove
Width of groove up to0,2 mm
2,5 mm
2 mm配合刀片
for Insert型号 105
Type端面夹紧刀片
Face clamped insert!

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

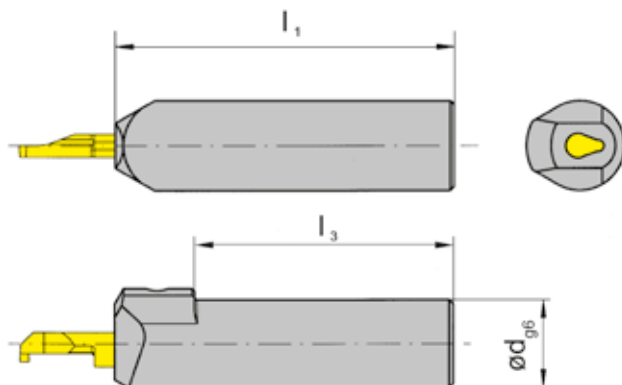
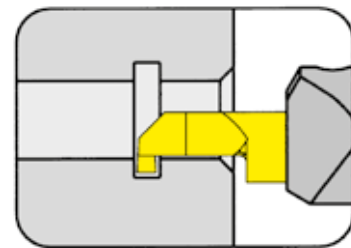
B105

直接冷却液供应
with through coolant supply

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



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	l ₃
B105.0010.01A	10	75	57
B105.0012.01A	12	75	63
B105.0016.01A	16	75	63

按需提供更多尺寸

Further sizes upon request

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

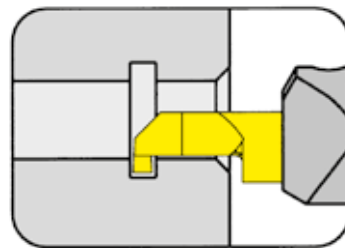
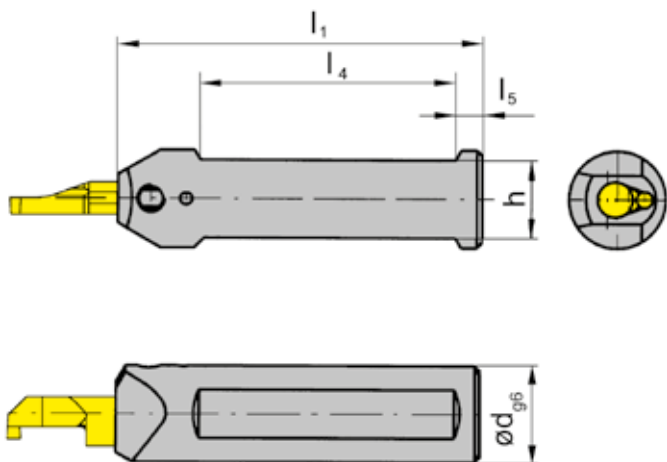
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

刀杆

Toolholder

B105/BU105

直接冷却液供应
with through coolant supply孔径Ø 自
槽深可达
槽宽可达Bore Ø from
Depth of groove up to
Width of groove up to0,2 mm
2,5 mm
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	l ₅
B105.0028.01	28,00	120.0	26.00	72	12
BU105.0750.5.01	3/4"	90.0	17.04	70	5
BU105.0750.5.3.01	3/4"	152.5	17.05	70	5
BU105.1000.5.01	1"	90.0	23.40	65	5
BU105.1000.5.3.01	1"	152.5	23.40	70	5

按需提供更多尺寸

Further sizes upon request

不包含内冷接口 M12×1.5

Adapter of cooling M12x1,5 - Coolant supply is not included.

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.

单位：mm和inch

Dimensions in mm and inch

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

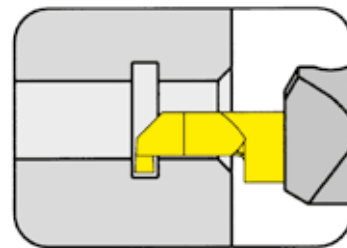
B105

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深
槽宽可达

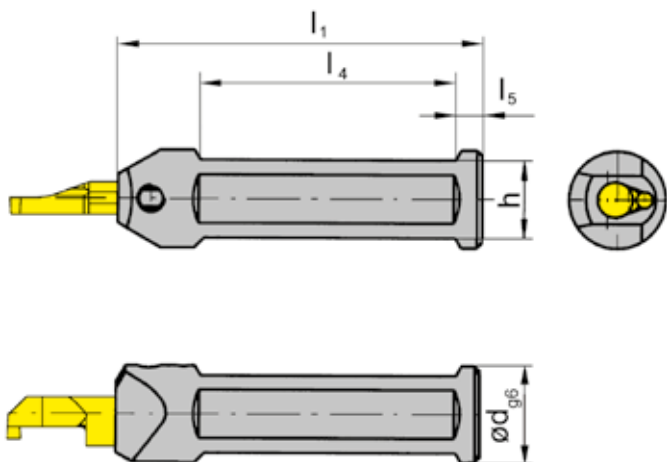
Bore Ø from
Depth of groove
Width of groove up to

0,2 mm
2,5 mm
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	l ₅
B105.0022.1.2.01	22	120	20	72	5

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

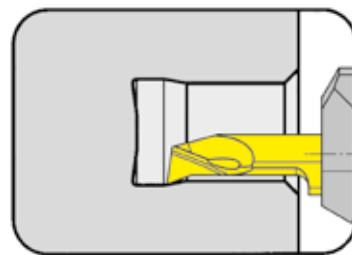
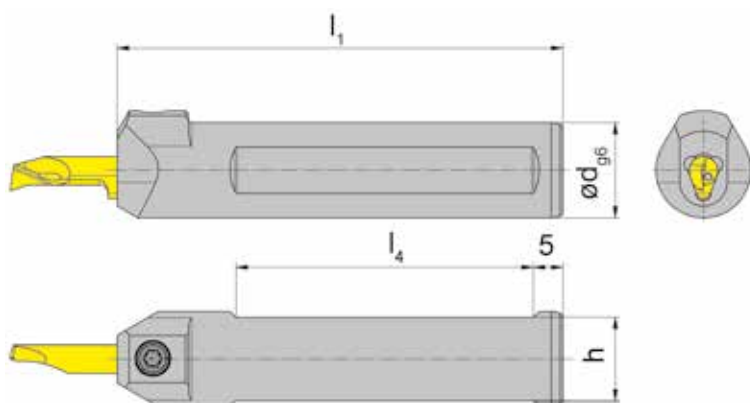
Spare Parts

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

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 groove0,2 mm
2,5 mm
2 mm配合刀片
for Insert型号 105
Type

图示=右手型

Picture = right hand cutting version

带有多个冷却孔
with additional through
coolant bores

产品型号 Part number	d	l_1	h	l_4
B105.0012.K.01	12	75	11	50
B105.0016.K.01	16	75	14	50
B105.0020.K.01	20	90	18	50
**B105.0012.M8.K.01	12	75	11	50
**B105.0016.M8.K.01	16	75	14	50
**B105.0020.M8.K.01	20	90	18	50

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.

** 内冷接口 M8X1(004.00.19)见A49页. 内冷管部分需分开采购!

** Adapter of cooling M8x1 (004.00.19) see page A49. Coolant supply must be ordered separately!

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

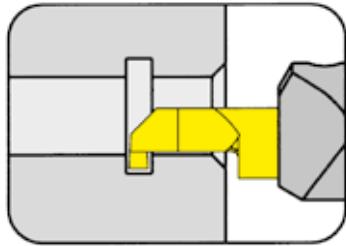
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	T15PQ

刀杆

Toolholder

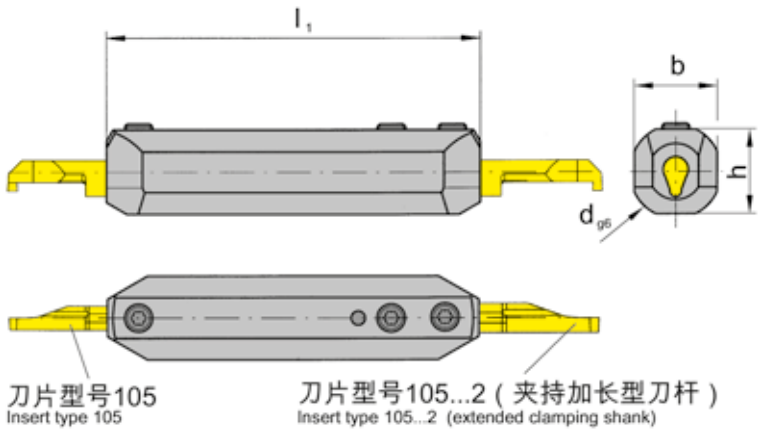
B105



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



配合刀片
for Insert

型号 105
Type 105...2

图示=右手型
Picture = right hand cutting version

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

按需提供更多尺寸
Further sizes upon request

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
B105.0020.1.03	6.075T15P	T15PQ

刀杆

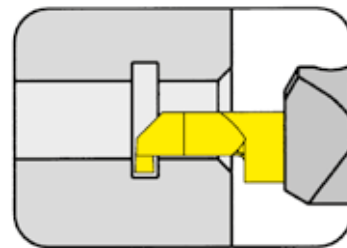
Toolholder

B105

孔径Ø 自
槽深可达
槽宽可达

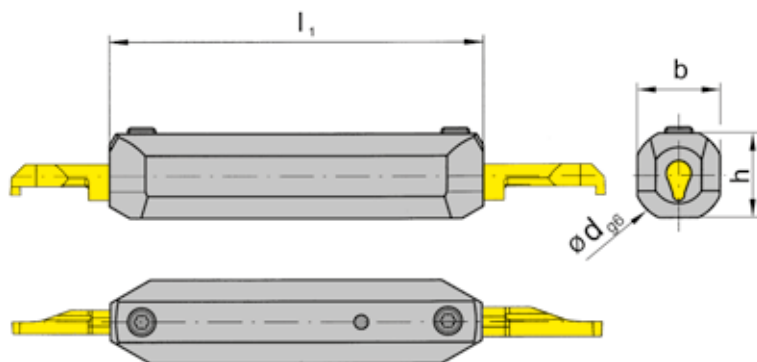
Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
2 mm



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	b
B105.0022.2.1.01	22	80	20	20
B105.0022.2.2.01	22	120	20	20

按需提供更多尺寸
Further sizes upon request

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

切槽和镗孔

Grooving and Boring



A

刀杆

Toolholder

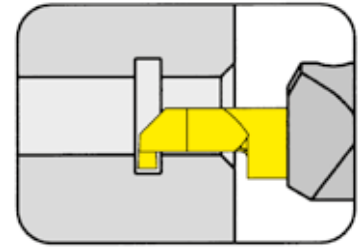
B105

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深
槽宽

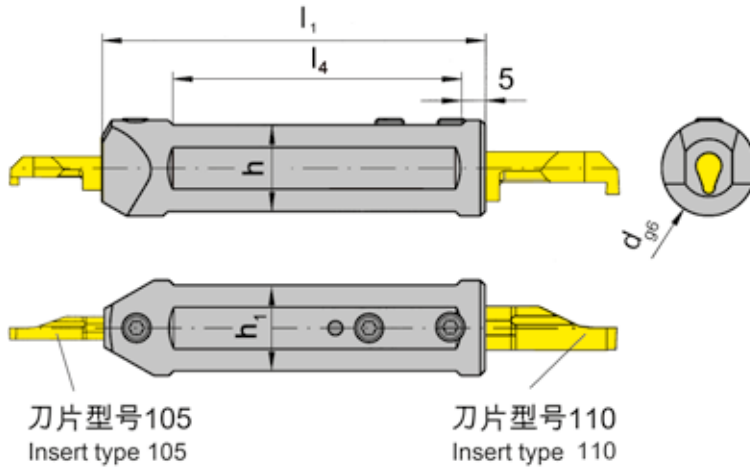
Bore Ø from
Depth of groove
Width of groove

0,2/6 mm
2,5/4 mm
2/3 mm



配合刀片
for Insert

型号 105
Type 110



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₄
B105.0020.1.10	20	80	18	60

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
B105.0020.1.10	6.075T15P	T15PQ

GRAF常规刀柄 型号

Basic toolholder Graf

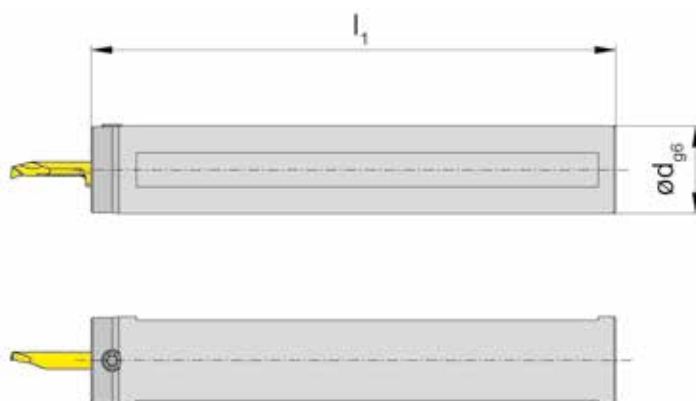
IR105

直接冷却液供应
with through coolant supply

孔径Ø 自

Bore Ø from

0,2 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	机床型号 Machine type
IR105.34.100	3/4"	100	Citizen
IR105.34.40	3/4"	40	Citizen
IR105.34.50	3/4"	50	Citizen
IR105.34.70	3/4"	70	Citizen
IR105.20.30	20	30	Citizen
IR105.20.50	20	50	Citizen
IR105.10.100	1"	100	Citizen
IR105.10.60	1"	60	Citizen
IR105.16.30	16	30	Star
IR105.16.50	16	50	Star
IR105.16.70	16	70	Star
IR105.22.100	22	100	Star
IR105.22.120	22	120	Star
IR105.22.38	22	38	Star
IR105.22.50	22	50	Star
IR105.22.70	22	70	Star
IR105.18.310	18	310	Tornos
IR105.20.170	20	170	Tornos
IR105.20.185	20	185	Tornos
IR105.25.100	25	100	Tornos
IR105.25.150	25	150	Tornos
IR105.28.80	28	80	Tornos

按需提供更多尺寸

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.

单位：mm和inch
Dimensions in mm and inch

配件

Spare Parts

Graf刀夹 Cartridge Graf	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench
IR105...	6.075T15P	004.00.19	T15PQ

切槽和镗孔

Grooving and Boring



Graf刀夹 Cartridge Graf

IR105

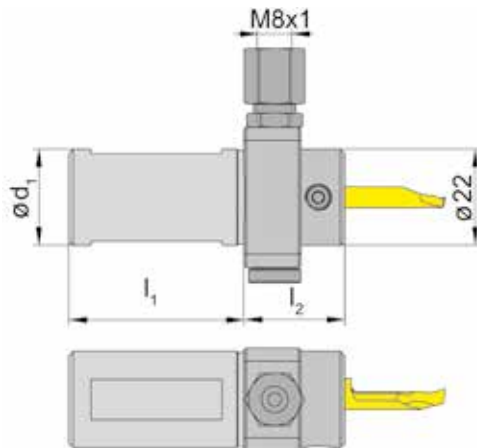
直接冷却液供应
with through coolant supply



孔径Ø 自

Bore Ø from

0,2 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 ₁	l ₁	l ₂
IR105.1640.IKV	16	40	23
IR105.3440.IKV	3/4"	40	23
IR105.2040.IKV	20	40	23
IR105.2240.IKV	22	40	23
IR105.2560.IKV	25	60	23
IR105.1060.IKV	1"	60	23

按需提供更多尺寸

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.

单位：mm和inch
Dimensions in mm and inch

配件

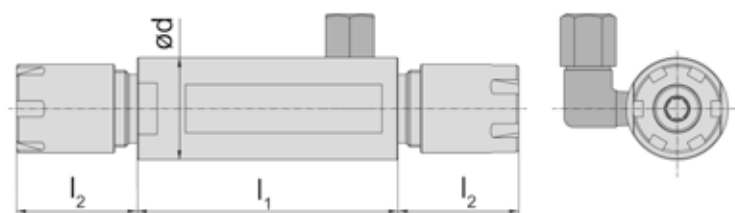
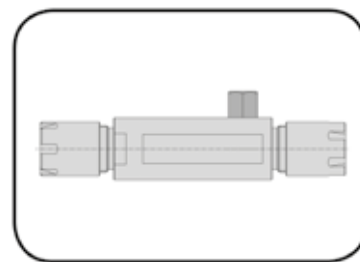
Spare Parts

Graf刀夹 Cartridge Graf	锁紧螺钉 Clamping Screw	冷却液供应 Coolant supply	TORX PLUS®扳手 TORX PLUS® Wrench
IR105...	6.075T15P	004.00.19	T15PQ

双头夹紧刀柄

Double chuck holders

GZ79

直接冷却液供应
with through coolant supply用于带ER16夹紧螺母的ER刀杆
for chuck holders ER with chucking nuts ER16

产品型号 Part number	d	l ₁	l ₂
GZ79.1065.16	1"	65	32
GZ79.2065.16	20	65	32
GZ79.22100.16	22	100	32
GZ79.2262.16	22	62	32
GZ79.2580.16	25	80	32
GZ79.3470.16	3/4"	70	32

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

注意事项：
冷却液管需要单独订购！

Note:
Coolant supply must be ordered separately!

切槽和镗孔

Grooving and Boring



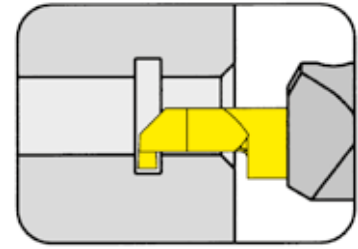
A

刀杆

Toolholder

B105

直接冷却液供应
with through coolant supply



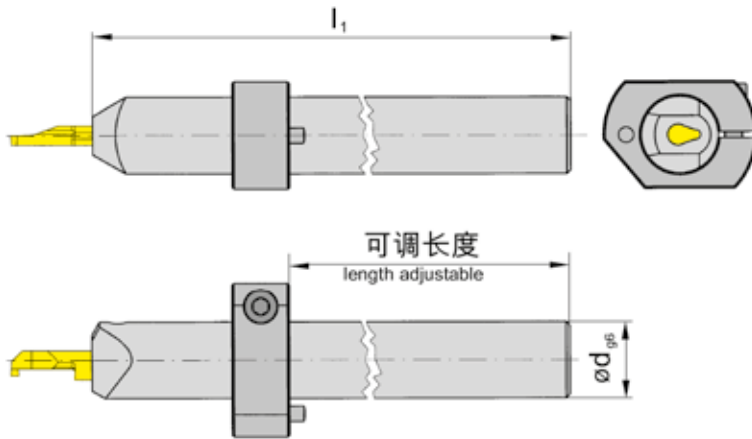
孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

0,2 mm
2,5 mm
2 mm

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
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

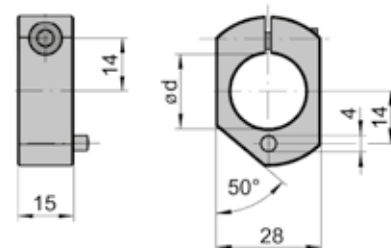
Ordering note:

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!

调整环 Adjusting ring	d	机床类型 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 angled screw coupling	TORX PLUS®扳手 TORX PLUS® Wrench
B105...	6.075T15P	KQ2L06-M5	T15PQ

刀杆

Toolholder

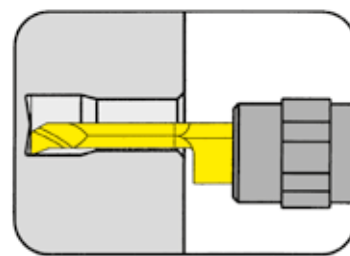
B105

直接冷却液供应
with through coolant supply

孔径Ø 自

Bore Ø from

<3 / >5 mm

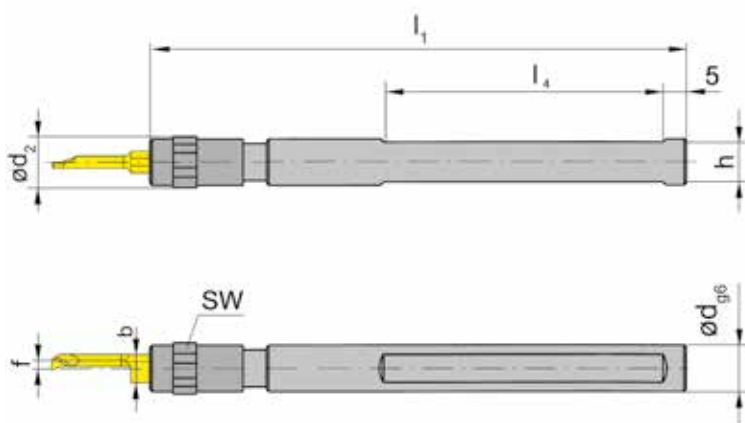


配合刀片

for Insert

型号 105,,,01 <3

Type 105...11.01 >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

* b = 刀片高度

* b = Height of insert

刀杆可以安装左，右手刀片

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

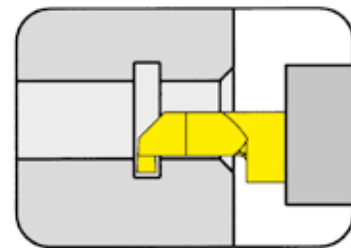
Grooving and Boring



刀杆

Toolholder

H105



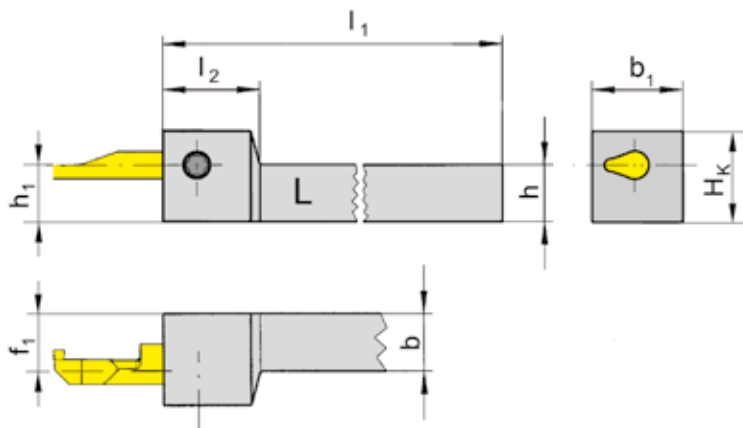
孔径Ø 自

Bore Ø from

0,2 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	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

刀杆

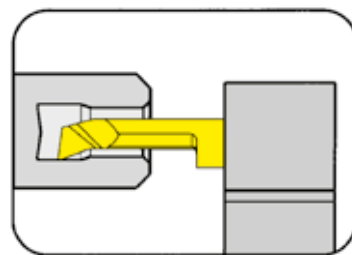
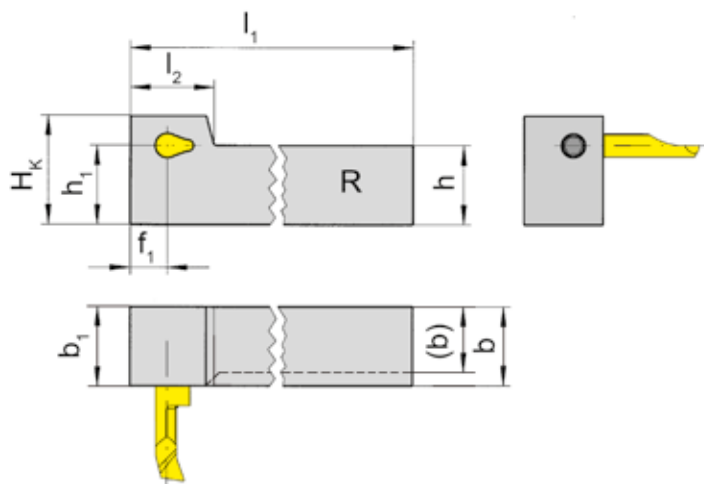
Toolholder

HC105

孔径Ø 自

Bore Ø from

0,2 mm

配合刀片
for 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

切槽和镗孔

Grooving and Boring

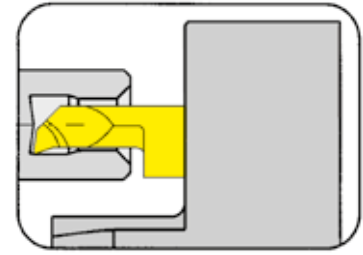


A

刀杆

Toolholder

HC105



孔径 Ø 自

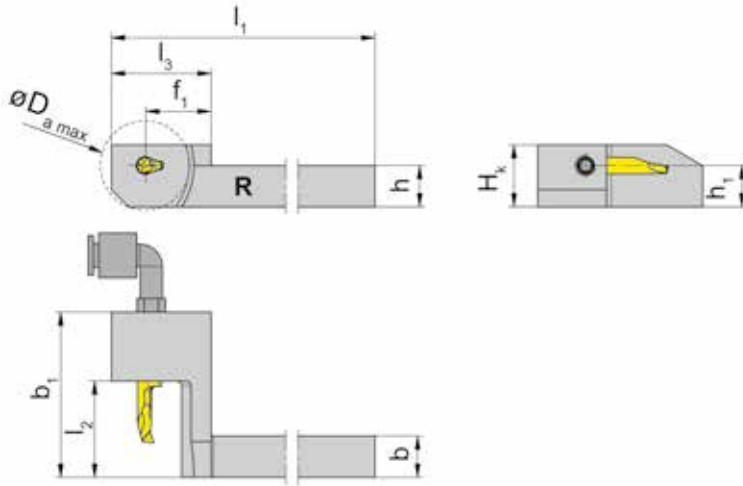
Bore Ø from

0,2 mm

通过曲型接头供给冷却液
Coolant supply through cranked fitting

配合刀片
for 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 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
R/LHC105.0812.21	8	12	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

尺寸单位: mm
Dimensions in mm

注意事项:

R/LHC105.07.../08.../1010.11 ohne Innenkühlung

Note:

R/LHC105.07.../08.../1010.11 without trough coolant

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	旋紧型角度接头 SMC angled screw coupling
R/LHC105...	6.075T15P	T15PQ	
R/LHC105...21/...41	6.075T15P	T15PQ	KQ2L06-M5

刀杆

Toolholder

962



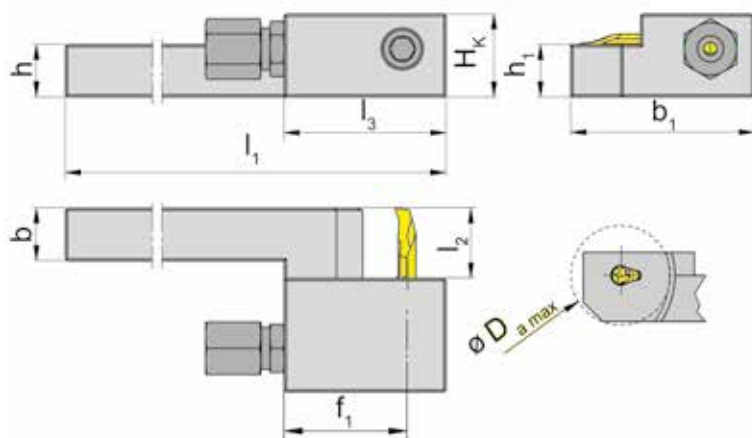
孔径Ø 自

Bore Ø from

0,2 mm

内冷装置

Coolant through fitting

配合刀片
for 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	f ₁	l ₁	l ₃	h ₁	H _k	b ₁	l ₂	D _{a max}
962.08.01R	8	8	27	130	37	8	15	42	18	26
962.08.02L	8	8	27	130	37	8	15	42	18	26
962.10.01R	10	10	27	130	37	10	17	42	18	26
962.10.02L	10	10	27	130	37	10	17	42	18	26
962.12.01R	12	12	27	130	37	12	19	42	18	26
962.12.02L	12	12	27	130	37	12	19	42	18	26
962.16.01R	16	16	27	130	37	16	23	42	18	32
962.16.02L	16	16	27	130	37	16	23	42	18	32
962.20.01R	20	20	27	130	37	20	27	42	18	32
962.20.02L	20	20	27	130	37	20	27	42	18	32

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

For torque 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
962...	6.075T15P	GE 6 LR - G1/8	T15PQ

刀杆 Toolholder

962



孔径 Ø 自

Bore Ø from

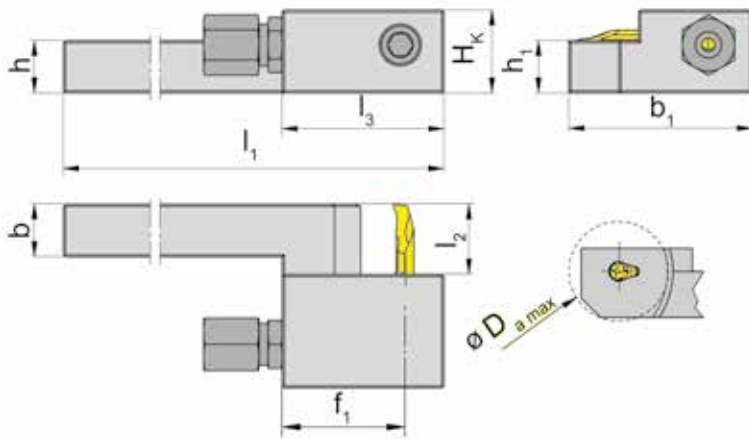
0,2 mm

内冷装置

Coolant through fitting

配合刀片
for 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	f ₁	l ₁	l ₃	h ₁	H _k	b ₁	l ₂	D _{a max}
962.08.03R	8	8	27	130	37	8	15	57	30	26
962.08.04L	8	8	27	130	37	8	15	57	30	26
962.10.03R	10	10	27	130	37	10	17	57	30	26
962.10.04L	10	10	27	130	37	10	17	57	30	26
962.12.03R	12	12	27	130	37	12	19	57	30	26
962.12.04L	12	12	27	130	37	12	19	57	30	26
962.16.03R	16	16	27	130	37	16	23	57	30	32
962.16.04L	16	16	27	130	37	16	23	57	30	32
962.20.03R	20	20	27	130	37	20	27	57	30	32
962.20.04L	20	20	27	130	37	20	27	57	30	32

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

For torque 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
962...	6.075T15P	GE 6 LR - G1/8	T15PQ

刀杆

Toolholder

963



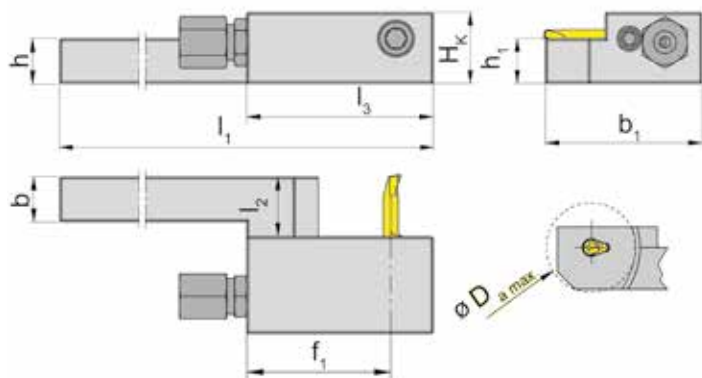
孔径Ø 自

Bore Ø from

0,2 mm

内冷装置

Coolant through fitting

配合刀片
for 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	f ₁	l ₁	l ₃	h ₁	H _K	b ₁	l ₂	D _{a max}
963.08.01R	8	8	40	130	50	8	15	42	15	26
963.08.02L	8	8	40	130	50	8	15	42	15	26
963.10.01R	10	10	40	130	50	10	17	42	15	26
963.10.02L	10	10	40	130	50	10	17	42	15	26
963.12.01R	12	12	40	130	50	12	19	42	15	26
963.12.02 L	12	12	40	130	50	12	19	42	15	26
963.16.01R	16	16	45	130	50	16	23	42	15	32
963.16.02L	16	16	45	130	50	16	23	42	15	32
963.20.01R	20	20	45	130	50	20	27	42	15	32
963.20.02L	20	20	45	130	50	20	27	42	15	32

按需提供更多尺寸

Further sizes upon request

尺寸单位：mm

Dimensions in mm

螺丝的扭矩规格，详见技术说明。

For torque 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
962...	6.075T15P	GE 6 LR - G1/8	T15PQ

刀杆

Toolholder

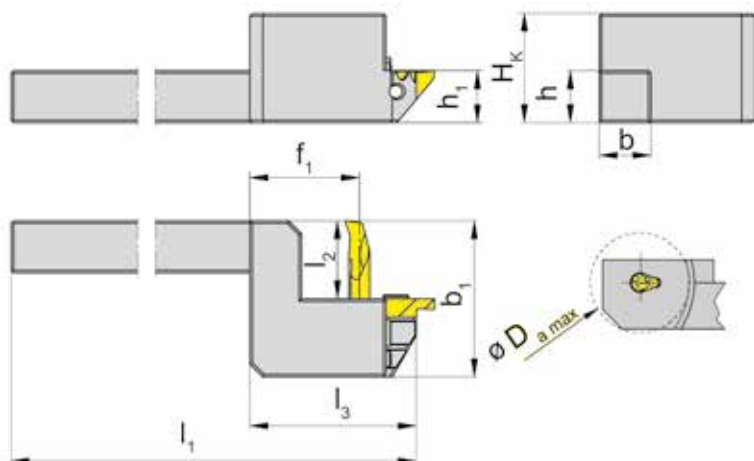
AIH



孔径Ø 自

Bore Ø from

0,2 mm



配合刀片
for 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	f ₁	l ₁	l ₃	h ₁	H _K	b ₁	l ₂	D _{a max}
AIH.974.L 1010.K04	10	10	23	130	35	10	17	30	15	20
AIH.974.L 1212.K04	12	12	23	130	35	12	19	30	15	20
AIH.974.L 1616.K04	16	16	26	130	38	16	23	30	15	26
AIH.974.L 2020.K04	20	20	29	130	38	20	23	30	15	32
AIH.974.R 1010.K04	10	10	23	130	35	10	17	30	15	20
AIH.974.R 1212.K04	12	12	23	130	35	12	19	30	15	20
AIH.974.R 1616.K04	16	16	26	130	38	16	23	30	15	26
AIH.974.R 2020.K04	20	20	29	130	38	20	23	30	15	32
AIH L 1010 K08	10	10	21	130	30	10	17	30	15	20
AIH L 1212 K08	12	12	21	130	30	12	19	30	15	20
AIH L 1616 K08	16	16	24	130	30	16	23	30	15	26
AIH L 2020 K08	20	20	27	130	30	20	23	30	15	32
AIH R 1010 K08	10	10	21	130	30	10	17	30	15	20
AIH.R 1212.K08	12	12	21	130	30	12	19	30	15	20
AIH R 1616 K08	16	16	24	130	30	16	23	30	15	26
AIH R 2020 K08	20	20	27	130	30	20	23	30	15	32

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

注意事项：

该刀杆可配合HORN105和S274系列的刀片

该刀杆可配合Horn105系列刀片和Graf刀片CS08。

Note:

Toolholders AIH...K04 can be equipped with HORN inserts type 105 and S274

Toolholders AIH...K08 can be equipped with HORN inserts type 105 and Graf inserts CS08

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
AIH...	6.075T15P	T15PQ

常规刀柄

Basic toolholder

HC105

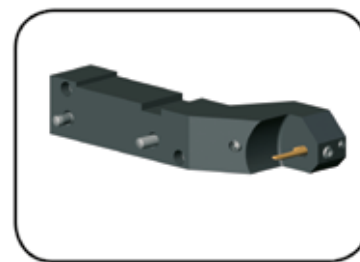
孔径Ø 自

Bore Ø from

0,2 mm

用于机床Tornos

Tool for Tornos

配合刀片
for Insert型号 105
Type

产品型号 Part number	机床型号 Machine type	刀片 Insert
RHC105.0710.21	EvoDECO 10	105...21 I ₂ 以内可达15 mm
RHC105.0710.41	EvoDECO 10	105...41 I ₂ 以内可达25 mm

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	旋紧型角度接头 SMC angled screw coupling	TORX PLUS®扳手 TORX PLUS® Wrench	销 Straight pin
RHC105...	6.075T15P	KQ2L06-M5	T15PQ	020.0518.1610

切槽和镗孔

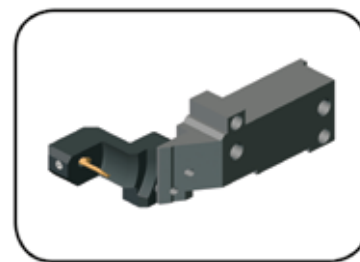
Grooving and Boring



常规刀柄

Basic toolholder

760



孔径Ø 自

Bore Ø from

0,2 mm

用于机床Tornos
Tool for Tornos



配合刀片
for Insert

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 I ₂ 以内可达15 mm	RKC760.0105.21
L760.2026.K1	EvoDECO 20/EvoDECO 32	105...41 I 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

常规刀柄

Basic toolholder

BGT

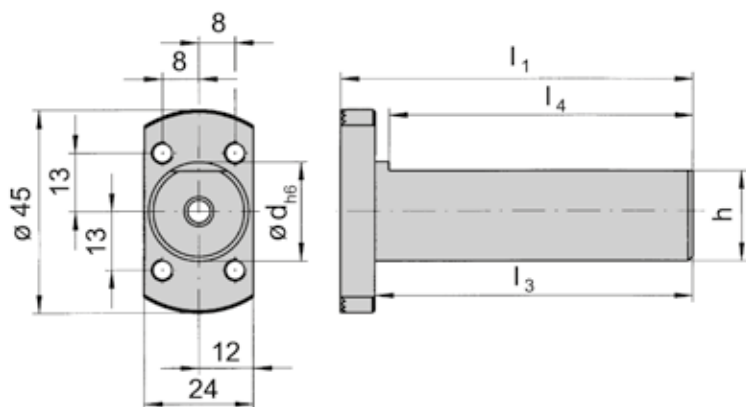
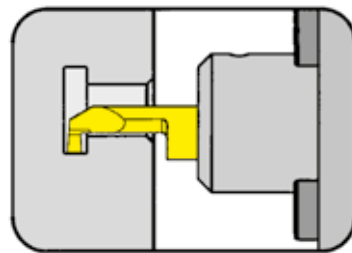
without cartridge

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

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	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



常规刀柄

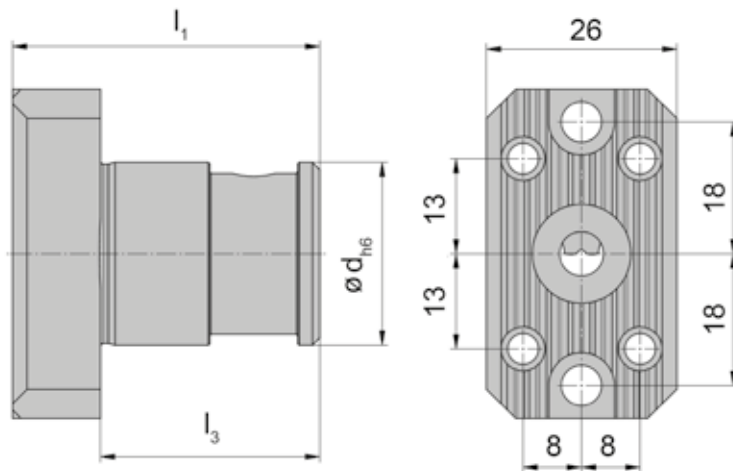
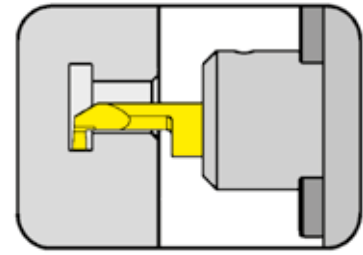
Basic toolholder

BGT

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	l_3	机床型号 Machine type
BGT001.C025.30IK	25	42	30	Citizen L20X

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

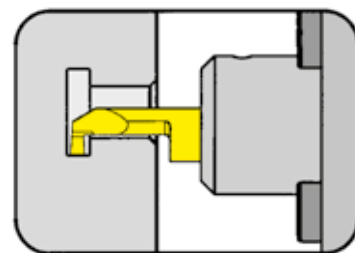
配件

Spare Parts

常规刀柄 Basic toolholder	扳手 Allen Wrench	O型圈 O-ring
BGT001.C025.30IK	SW4,0 DIN911	DIN3770-7x3

可调刀杆

Adjustable holder

BKT

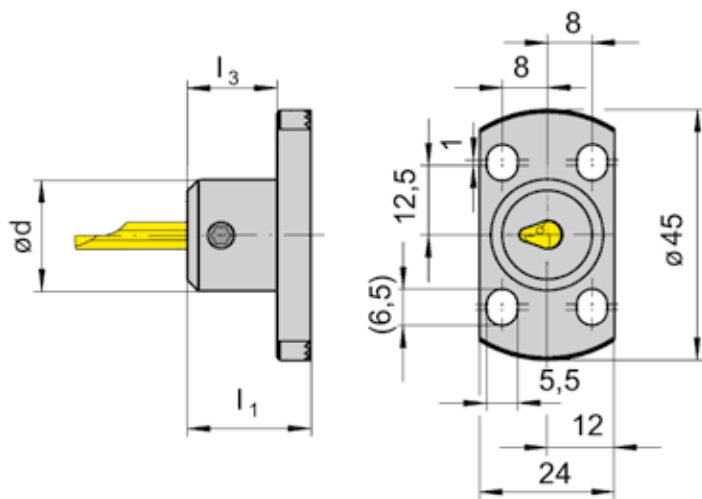
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
2 mm

直接冷却液供应

with through coolant supply



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

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...	6.075T15P	T15PQ

常规刀柄

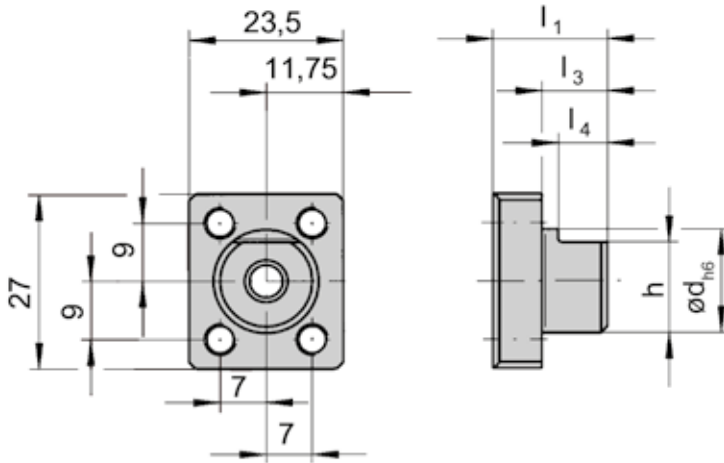
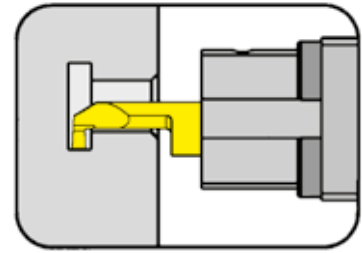
Basic toolholder

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

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	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

常规刀柄

Basic toolholder

BGT

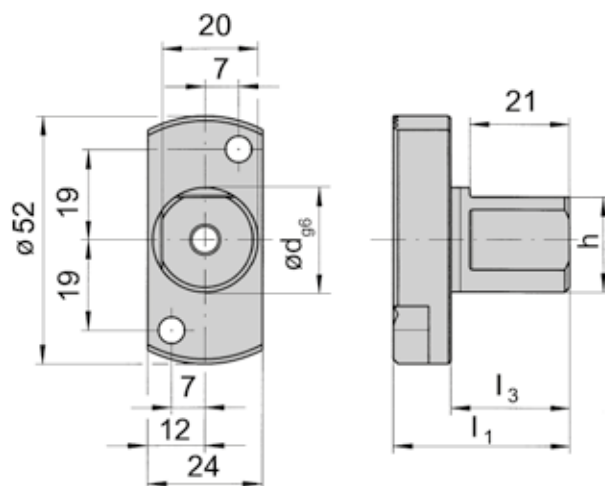
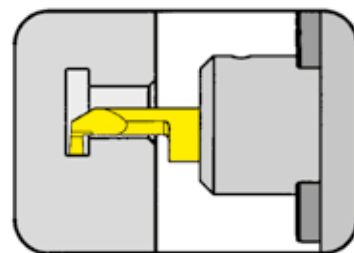
无刀夹
without cartridge

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
BGT001.0R22.25	22	37	20	25	21

按需提供更多尺寸

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	扳手 Allen Wrench
BGT001.0R22.25	M 5 x 10 DIN 912-12.9	SW4,0 DIN911

切槽和镗孔

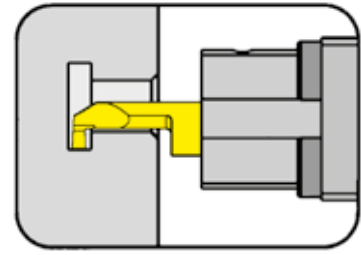
Grooving and Boring



可调刀杆

Adjustable holder

BKT



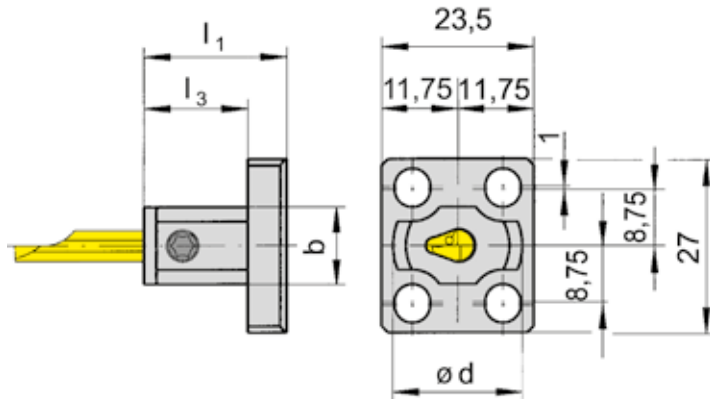
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
2 mm

直接冷却液供应

with through coolant supply



配合刀片
for Insert

型号 105
Type

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

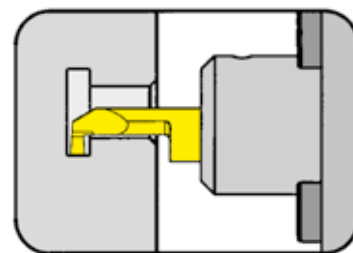
Spare Parts

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

可调刀杆

Adjustable holder

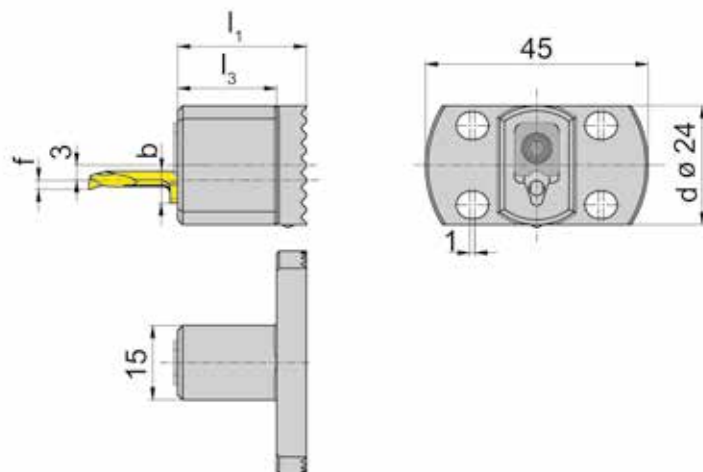
BKT



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



配合刀片
for 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

f见105系列刀片
f see inserts type 105

尺寸单位：mm
Dimensions in mm

* b = 刀片高度
* b = Height of insert

配件

Spare Parts

刀杆 Toolholder	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

GRAF常规刀柄 型号

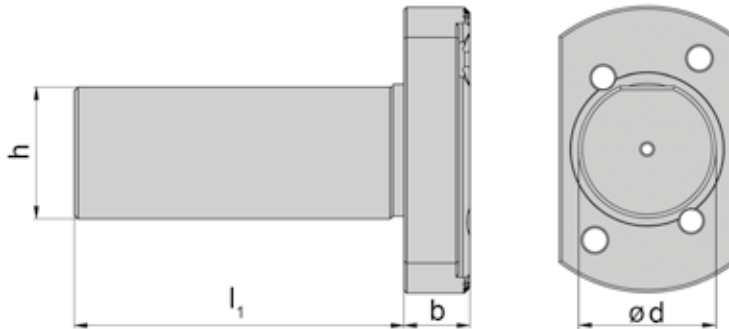
Basic toolholder Graf

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



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	19.05	40	18	6	Citizen
G034050	0.75	50	18	6	Citizen
G034120	19.05	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

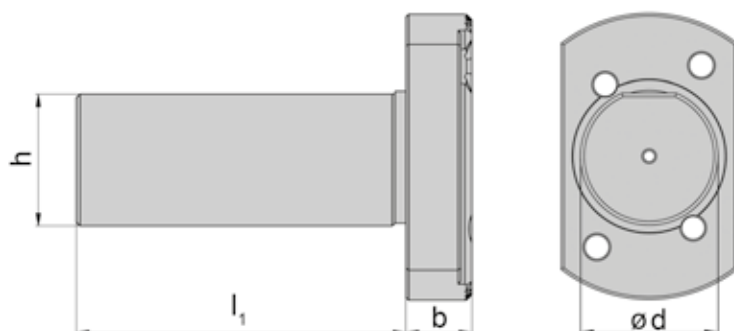
GRAF常规刀柄 型号

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



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

切槽和镗孔

Grooving and Boring



GRAF接头

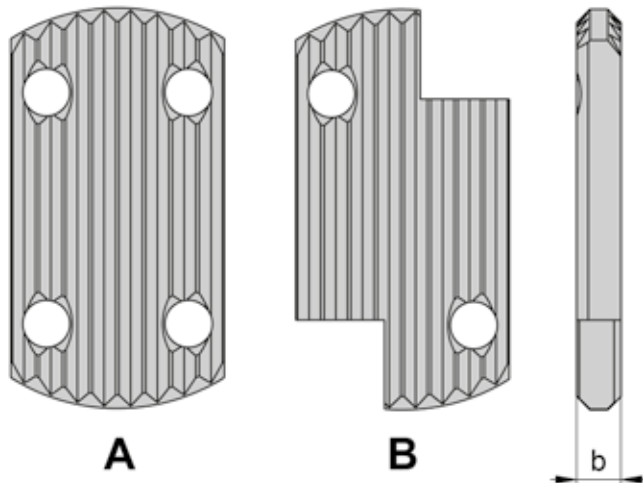
Adaptor Graf

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



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

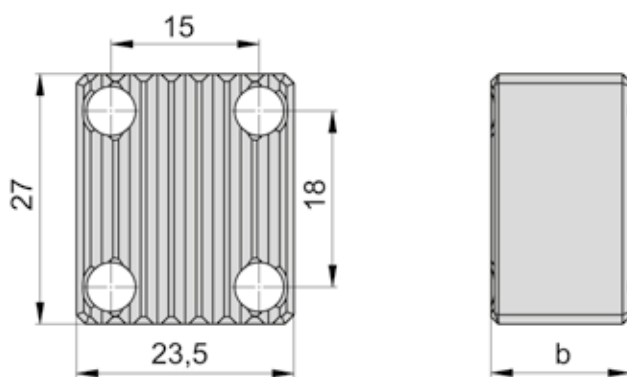
GRAF接头

Adaptor Graf

Z

无刀夹
without cartridge

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



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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

GRAF接头

Adaptor Graf

N

无刀夹
without cartridge

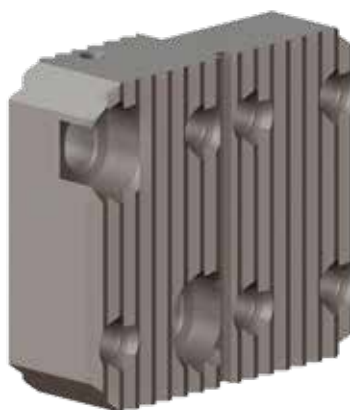
GRAF
WERKZEUGSYSTEME

用于可调Graf N型或者Horn BKT105.2445.01/02刀柄
for adjustable holder Graf type N and HORN BKT105.2445.01/02

用于背面加工
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

N



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

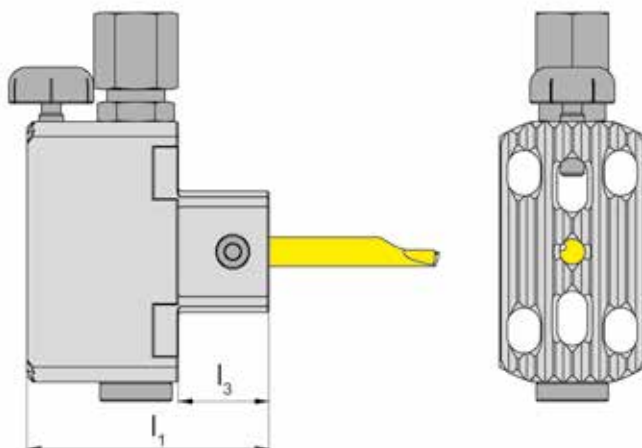
0,2 mm
2,5 mm
2 mm

直接冷却液供应

with through coolant supply

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	l_1	l_3
N09IK	40	15

按需提供更多尺寸

Further sizes upon request

不包含冷却液管-需要单独订购！

Coolant tube is not included - separate order required!

螺丝的扭矩规格，详见技术说明。

For torque 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	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

切槽和镗孔

Grooving and Boring



可调刀杆

Adjustable holder

N



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

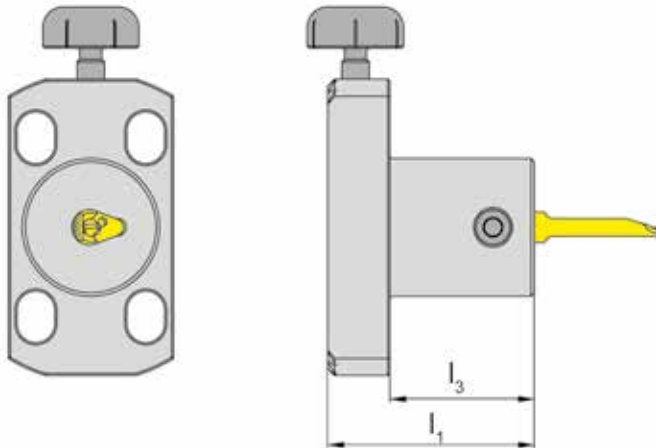
0,2 mm
2,5 mm
2 mm

无内冷

no through coolant supply

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	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

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 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



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

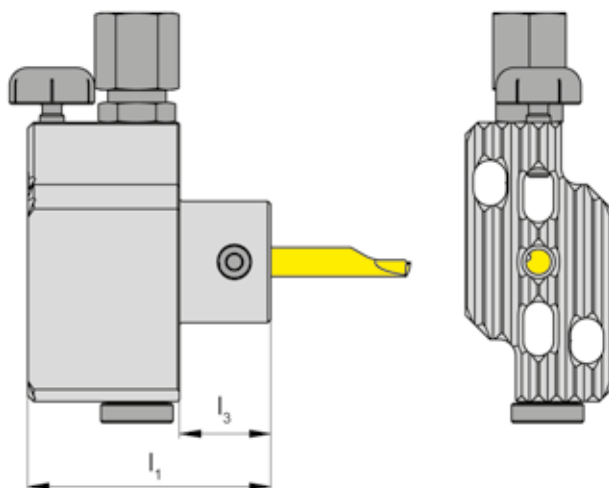
0,2 mm
2,5 mm
2 mm

直接冷却液供应

with through coolant supply

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	l_1	l_3
N73IK	40	15

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

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
N73IK	6.075T15P	002.00.69	004.00.19

可调刀杆

Adjustable holder

N



孔径Ø 自
槽深可达
槽宽可达

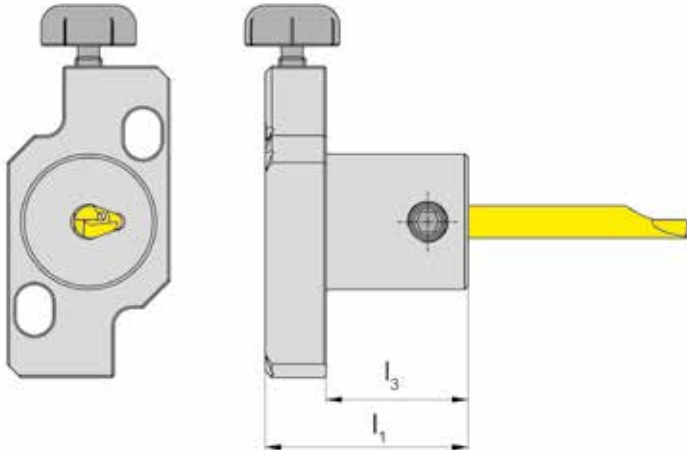
Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
2 mm

无内冷
no through coolant supply

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	l_1	l_3
N73	30	20

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

可调刀杆 Adjustable holder	锁紧螺钉 Clamping Screw	高度调节螺钉 Screw to adjust the height
N73	6.075T15P	002.00.69

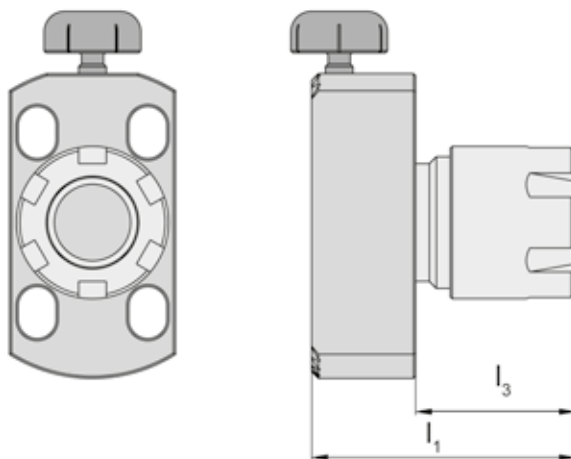
可调刀杆

Adjustable holder

N



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

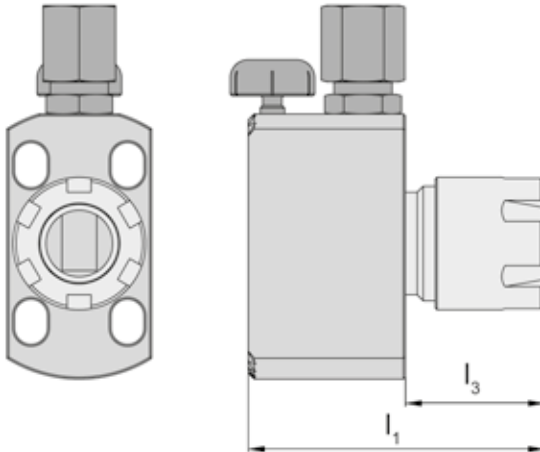
Adjustable holder

N



配合Graf ER16/ER20筒夹
with chucking nut ER16 / E20 system Graf

直接冷却液供应
with through coolant supply



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	锁紧螺母 Clamping nut
N07IK	64.600.16.3-10	002.00.69	004.00.19	62.000.16
N41IK	64.600.20.3-13	002.00.69	004.00.19	62.000.20

可调刀杆

Adjustable holder

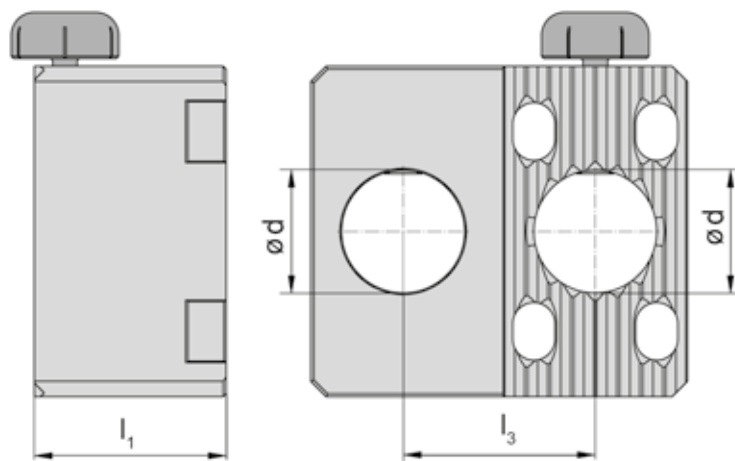
N



配合Graf ER11/ER16筒夹接头
for collet adaptors ER11/ER16 System Graf

配合刀片
for Insert

型号 Horn
Type GBT
 Graf



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

不包含筒夹接头-需单独订购！

The collet adaptors are not included - separate order required!

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



冷却系统标准连接头

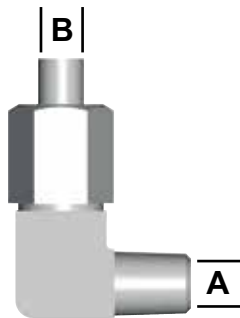
Standard connection for coolant supply for pipe Ø 6 mm



冷却液连接器
垂直锁紧

Connection for coolant supply
straight screwed

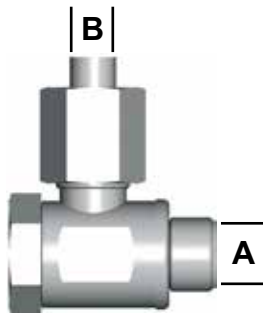
A	B	物料号 Part number
M8 x 1	ø 6 mm	004.00.19
G1/8"	ø 6 mm	004.00.14



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



栓塞
Plug

M8 x 1 - 004.00.56
G1/8" - 004.00.57



栓塞
Plug

Ø 6 mm - 004.00.59

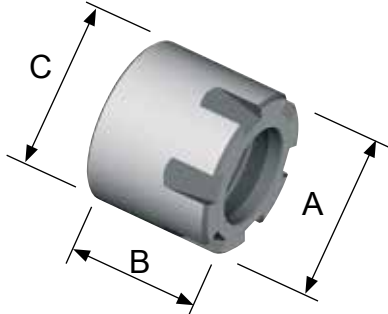


夹紧螺母

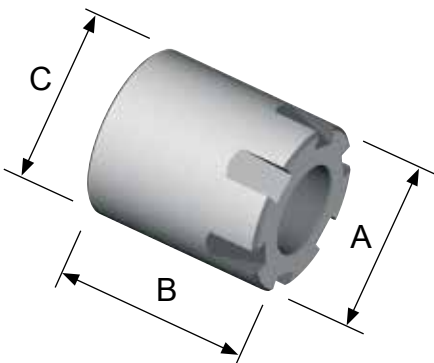
Chucking nut



ER-M



ER-M	A	B	C
62 000 08-ER 8	12	10,8	M10x0,75
62 000 11-ER 11	16	12	M13x0,75
62 000 16-ER 16	22	18	M19x1
62 000 20-ER 20	28	19	M24x1
62 000 25-ER 25	35	20	M30x1

ER-MA abdichtbar
sealed

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

尺寸单位 : mm
Dimensions in mm

密封圈

用于ER-MA密封螺母

Sealing rings
for chucking nuts ER-MA...

全组合 :

completed set:

产品编号 Part number	Ø D3
64 600 16-ER 16	3,0-3,5...9,5-10,0 mm
64 600 20-ER 20	3,0-3,5...12,5-13,0 mm
64 600 25-ER 25	3,0-3,5...15,5-16,0 mm

尺寸单位 : mm
Dimensions in mm

密封环可单独购买

例如 :

The sealing rings can be ordered separately.

Example:

产品编号 Part number	直径范围 Diameter range	可能自-达 possible from-up to
ER 16 64 600 16 <u>30</u>	3,01 - 3,50	3 - 10
ER 20 64 600 20 <u>45</u>	4,51 - 5,00	3 - 13
ER 25 64 600 25 <u>80</u>	8,01 - 8,50	3 - 16

尺寸单位 : mm
Dimensions in mm

高度调节装置

Device for Height Adjusting



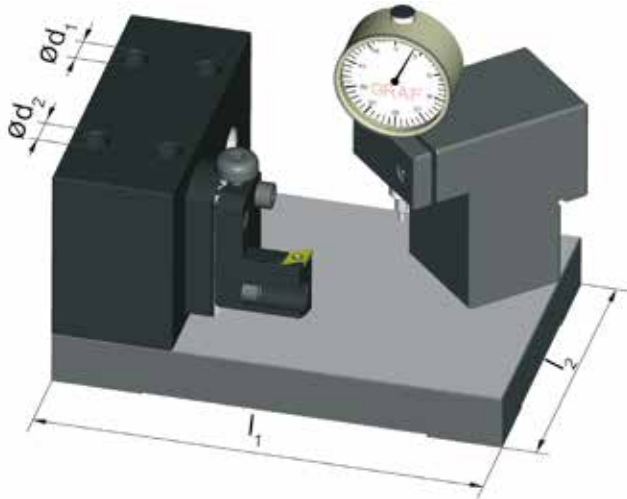
高度调节装置

Device for height adjusting

HVR40



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



产品型号 Part number	l_1	l_2	d_1	d_2	机床型号 Machine type
12.0506	250	180	16	22	Star
12.0507	250	180	3/4"	1"	Citizen
12.0508	250	180	30	34	Maier
12.0511	250	180	25	33	Hanwha
12.0523	250	180	20	28	Hanwha

按需提供更多尺寸
Further sizes upon request

单位：mm和inch
Dimensions in mm and inch

刀杆

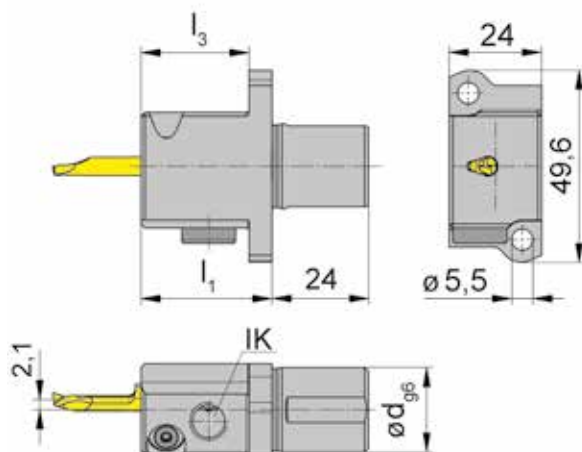
Toolholder

B105

直接冷却液供应
with through coolant supply孔径Ø 自
槽深可达
槽宽可达Bore Ø from
Depth of groove up to
Width of groove up to0,2 mm
2,5 mm
2 mm

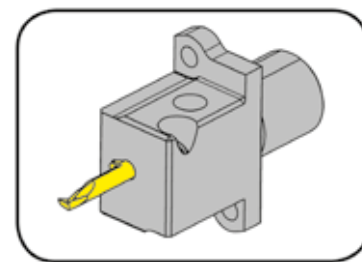
内冷管G1/8" 安装孔位置 13,7x37,6 mm

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



L=左手型

L = left hand version

配合刀片
for Insert型号 105
Type适用于Star Swiss机床
for Swiss type machines Star

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

刀杆 Toolholder

N105



孔径Ø 自
槽深
槽宽

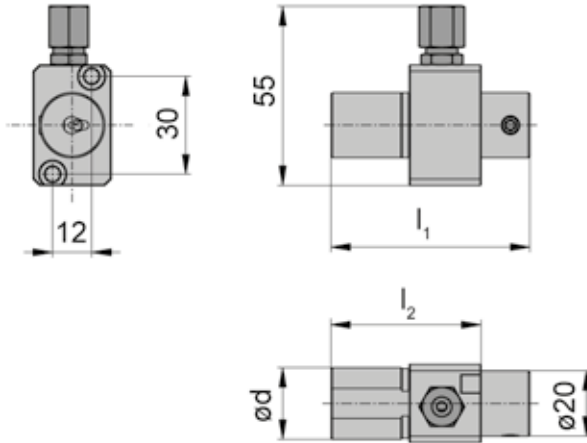
Bore Ø from
Depth of groove
Width of groove

0,2 mm
2,5 mm
2 mm

安装孔位置 12x30 mm
Hole pattern 12 x 30 mm

配合刀片
for Insert

型号 105
Type



适用于Star Swiss机床
for Swiss type machines Star

产品型号 Part number	d	l ₁	l ₂
RHF.N.105.01.D.2.22S1.IK	22	61	46

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

适用于Star Swiss机床: SW-20

Swiss Type Machines Star: SW-20

螺丝的扭矩规格，详见技术说明。

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

刀杆

Toolholder

N105



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

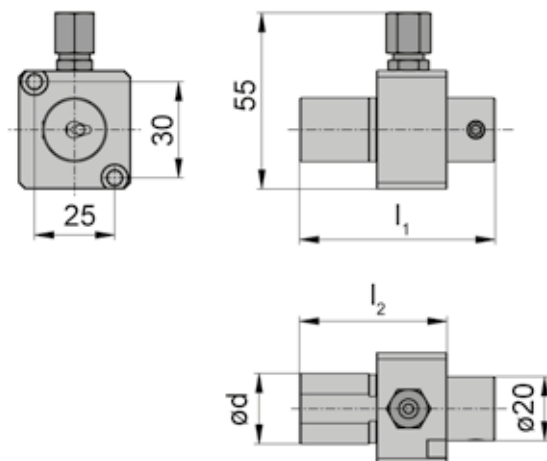
0,2 mm
2,5 mm
2 mm

安装孔位置 12x30 mm

Hole pattern 12 x 30 mm

配合刀片
for Insert

型号 105
Type



适用于Star Swiss机床
for Swiss type machines Star

产品型号 Part number	d	l_1	l_2
RHF.N105.01.D.2.22S2.IK	22	61	46

按需提供更多尺寸

Further sizes upon request

适用于Star Swiss机床: SW-20

Swiss Type Machines Star: SW-20

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

切槽和镗孔

Grooving and Boring



A

刀杆

Toolholder

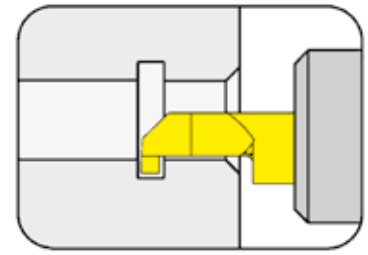
VDI

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深可达
槽宽可达

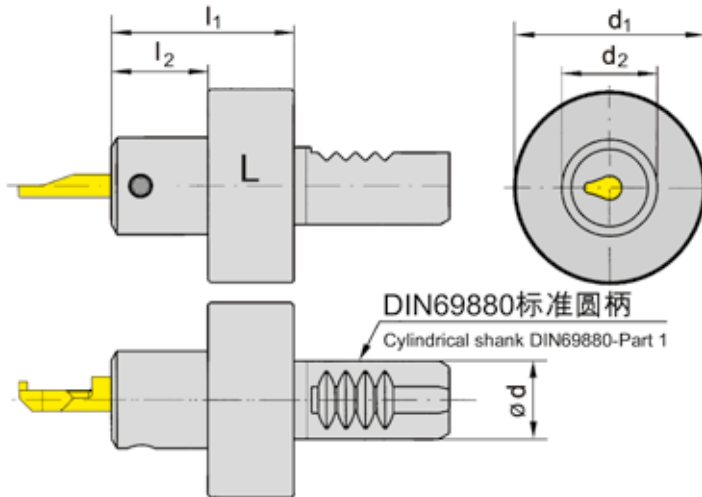
Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
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

切槽 (内圆)

Grooving (internal)



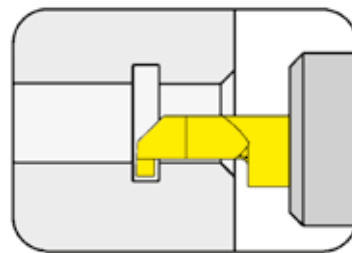
刀杆

Toolholder

B105C

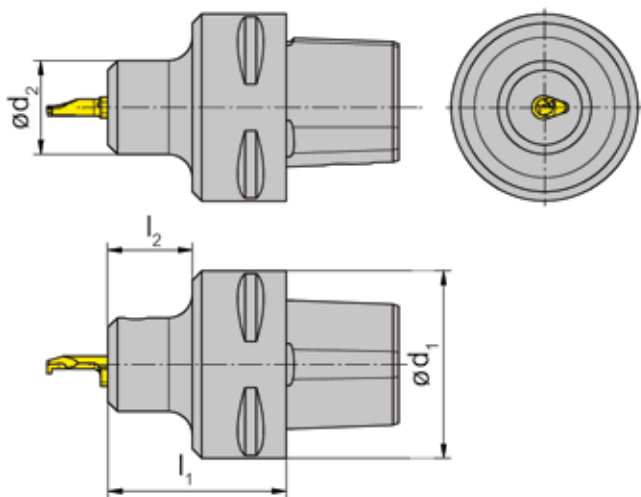
直接冷却液供应
with through coolant supply

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



配合刀片
for 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	d ₁	d ₂	l ₁	l ₂
R/LB105.00C3.20.1.01	32	20	30	15
R/LB105.00C4.20.1.01	40	20	38	18
R/LB105.00C5.20.1.01	50	20	38	18
R/LB105.00C6.20.1.01	63	20	42	20

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/LB105...	6.075T15P	T15PQ

切槽 (内圆)

Grooving (internal)



刀杆

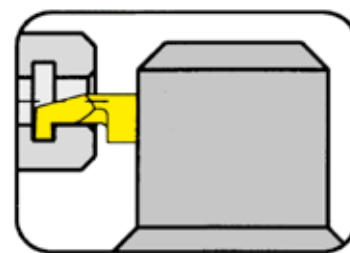
Toolholder

B105C

直接冷却液供应
with through coolant supply

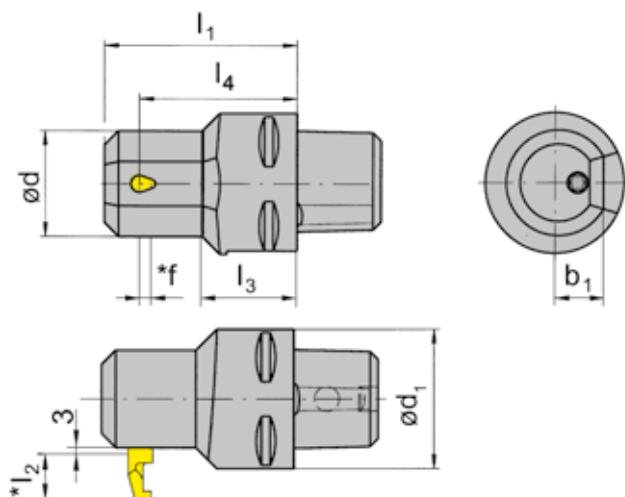
HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于INDEX多主轴机床
for INDEX Multi spindle machines



配合刀片
for Insert

型号 105
Type



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

按需提供更多尺寸
Further sizes upon request

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

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
RB105...	6.075T15P	T15PQ

切槽 (内圆)

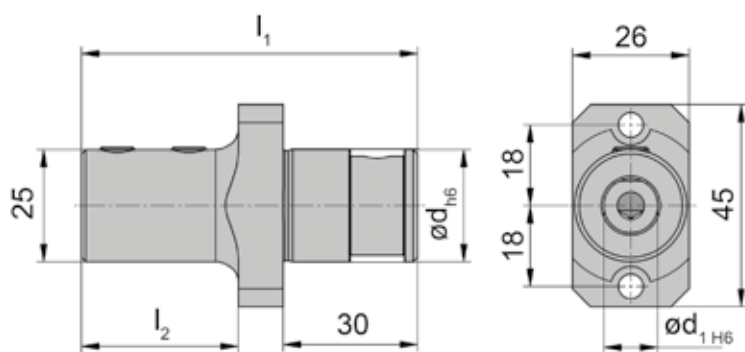
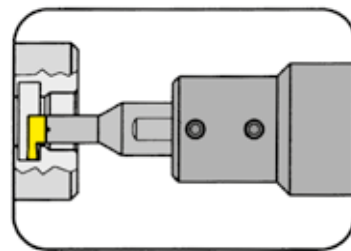
Grooving (internal)

镗孔杆接纳器

Adaptor for boring bars

001C

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



产品型号 Part number	d	l_1	d_1	l_2	机床型号 Machine type
001.C025.12.30IK	25	75	12	35	Citizen L20X/

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

镗孔杆接纳器 Adaptor for boring bars	扳手 Allen Wrench
001.C025.12.30IK	SW4,0 DIN911

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

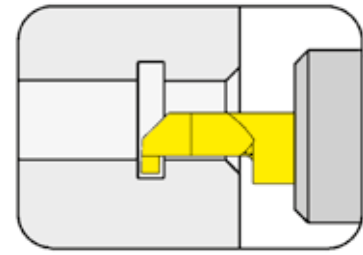
B105.WF

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深可达
槽宽可达

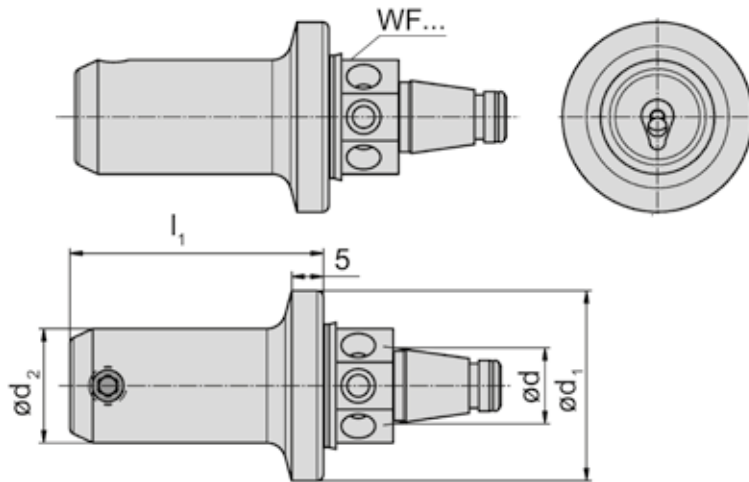
Bore Ø from
Depth of groove up to
Width of groove up to

0,2 mm
2,5 mm
3 mm



配合刀片
for Insert

型号 105
Type



产品型号 Part number	d ₁	l ₁	d	d ₂
B105.WF20.2.01	30	40	12	18
B105.WF20.3.01	30	55	12	18
B105.WF32.2.01	50	40	20	18

按需提供更多尺寸

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
B105.WF...	6.075T15P	T15PQ

刀片

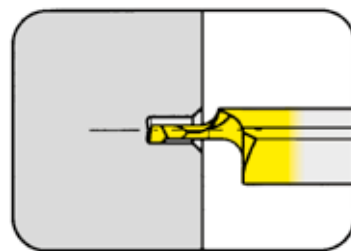
Insert

105

孔径 Ø 自

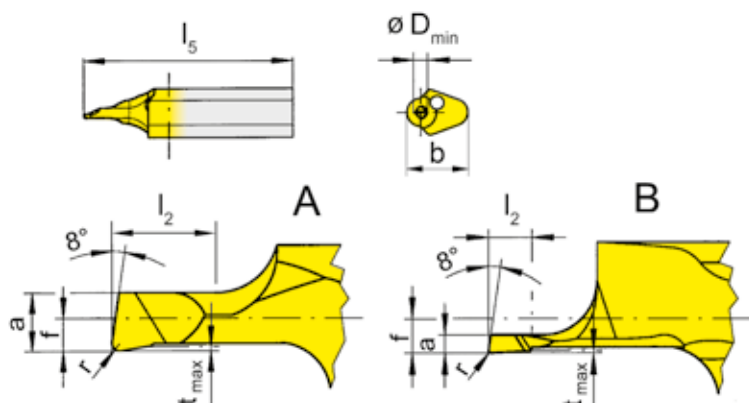
Bore Ø from

0,2 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	b	l_2	l_5	t_{max}	D_{min}	形式 Form	MG12	EG35
R/L105.1802.0.02	0.02	1.0	0.17	5.9	1	23	0.02	0.2	B	▲/Δ	Δ/Δ
R/L105.1802.0.03	0.02	1.0	0.25	5.9	1	23	0.02	0.3	B	▲/Δ	Δ/Δ
R/L105.1802.0.05	0.05	1.0	0.40	5.9	2	23	0.05	0.5	B	▲/▲	Δ/Δ
R/L105.1803.0.07	0.05	0.3	0.60	5.9	2	23	0.05	0.7	A	▲/▲	▲/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

按需提供更多尺寸

Further sizes upon request

P	○	●
M	●	●
K	●	○
N	●	-
S	●	-
H	-	-

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling



刀片

Insert

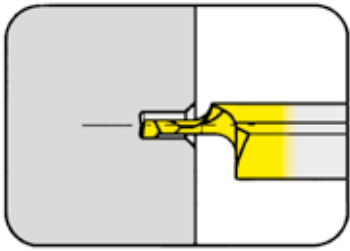
105

微小加工
for ultrafine machining

孔径Ø 自

Bore Ø from

0.2 mm



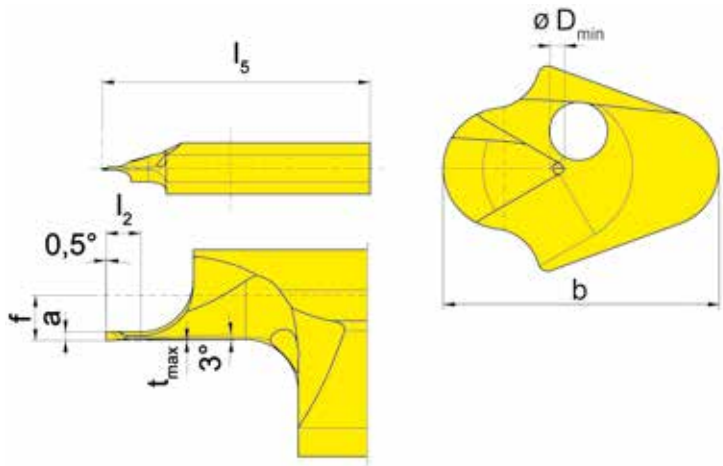
配合刀杆

for Toolholder

型号

Type

H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	f	a	b	l ₂	l ₅	t _{max}	D _{min}	MG12	AN25	ES15
R105.9013.000.0.02	1.3	0.17	5.9	1	23	0.015	0.2		Δ	Δ
R105.9013.000.0.03	1.3	0.25	5.9	1	23	0.015	0.3		Δ	Δ
R105.9013.000.0.05	1.3	0.40	5.9	2	23	0.020	0.5	Δ	Δ	Δ
R105.9013.000.0.07	1.3	0.60	5.9	2	23	0.020	0.7		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

硬质合金牌号
Carbide grades

刀片

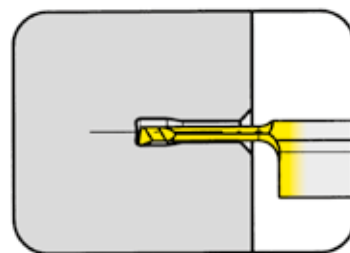
Insert

105

孔径 Ø 自

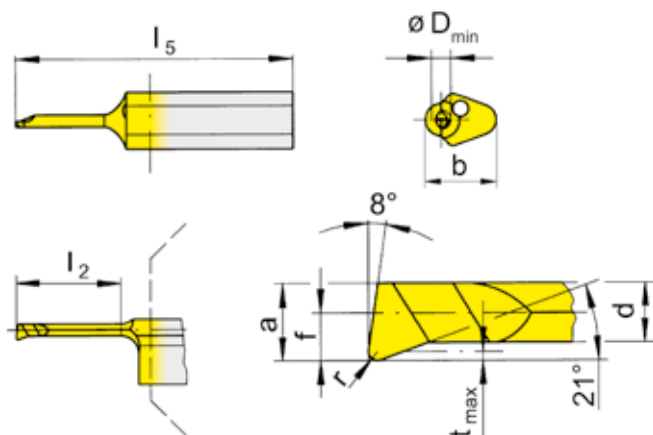
Bore Ø from

1 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L105.1805.005.0.1	0.05	0.5	0.9	0.65	5.9	4	25	0.10	1.0	▲/Δ	▲/Δ	▲/▲			
R/L105.1805.005.1.1	0.05	0.5	0.9	0.65	5.9	6	25	0.10	1.0	Δ/x	Δ/Δ	▲/▲			
R/L105.1805.005.2.1	0.05	0.5	0.9	0.65	5.9	8	25	0.10	1.0	▲/Δ	Δ/Δ	▲/▲	Δ/x		
R/L105.1805.0.1	0.10	0.5	0.9	0.65	5.9	4	25	0.10	1.0	▲/Δ	▲/▲	Δ/x		▲/▲	▲/▲
R/L105.1805.1.1	0.10	0.5	0.9	0.65	5.9	6	25	0.10	1.0	Δ/x	▲/▲			▲/▲	▲/▲
R/L105.1805.2.1	0.10	0.5	0.9	0.65	5.9	8	25	0.10	1.0		▲/Δ			▲/Δ	▲/▲
R/L105.1813.005.0.15	0.05	1.3	1.4	1.10	5.9	6	25	0.15	1.5		▲/Δ	▲/▲	Δ/Δ		
R/L105.1813.005.1.15	0.05	1.3	1.4	1.10	5.9	9	25	0.15	1.5		▲/Δ	▲/▲	Δ/x		
R/L105.1813.005.2.15	0.05	1.3	1.4	1.10	5.9	12	30	0.15	1.5		▲/Δ	▲/Δ	Δ/x		
R/L105.1813.01.0.15	0.10	1.3	1.4	1.10	5.9	6	25	0.15	1.5		▲/Δ		▲/▲	▲/▲	
R/L105.1813.01.1.15	0.10	1.3	1.4	1.10	5.9	9	25	0.15	1.5		Δ/Δ		▲/▲	▲/▲	
R/L105.1813.01.2.15	0.10	1.3	1.4	1.10	5.9	12	30	0.15	1.5		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	-	-	-	-	-

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

硬质合金牌号

Carbide grades

刀片

Insert

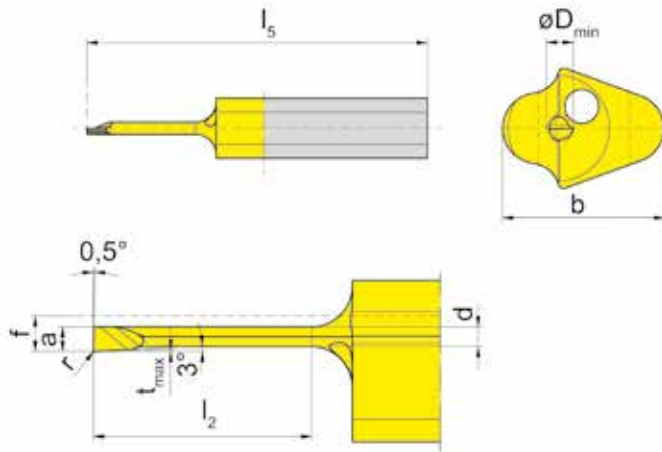
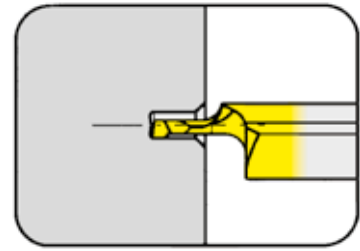
105

微小加工
for ultrafine machining

孔径Ø 自

Bore Ø from

1 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}		AN25	ES15
R105.9013.000.0.1	-	1.3	0.9	0.72	5.9	4	25	0.05	1.0		Δ	▲
R105.9013.000.2.1	-	1.3	0.9	0.72	5.9	8	25	0.05	1.0		Δ	Δ
R105.9013.003.0.1	0.03	1.3	0.9	0.72	5.9	4	25	0.05	1.0		Δ	Δ
R105.9013.003.2.1	0.03	1.3	0.9	0.72	5.9	8	25	0.05	1.0		▲	Δ
R105.9013.000.0.15	-	1.3	1.4	1.15	5.9	6	25	0.10	1.5		Δ	▲
R105.9013.000.1.15	-	1.3	1.4	1.15	5.9	9	25	0.10	1.5		Δ	Δ
R105.9013.003.0.15	0.03	1.3	1.4	1.15	5.9	6	25	0.10	1.5		Δ	▲
R105.9013.003.1.15	0.03	1.3	1.4	1.15	5.9	9	25	0.10	1.5		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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

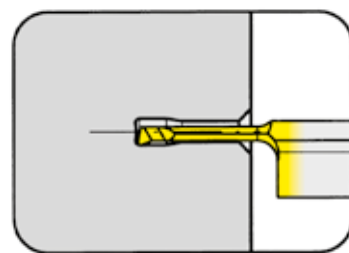
Insert

105

孔径Ø 自

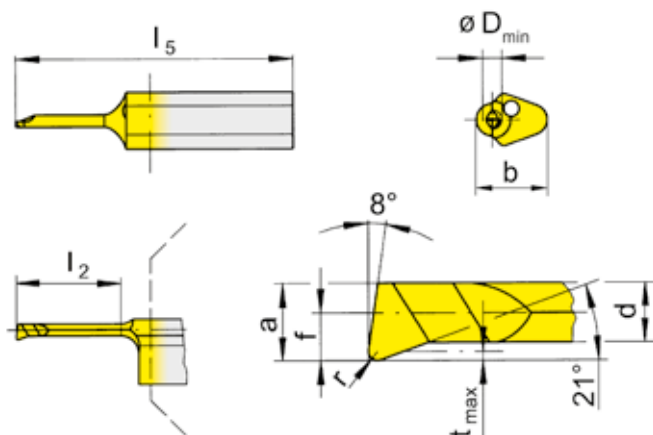
Bore Ø from

2 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L105.1809.005.0.2	0.05	1.0	1.9	1.60	5.9	6	25	0.15	2.0	Δ/Δ	Δ/Δ	▲/▲	Δ/Δ	Δ/x	Δ/x
R/L105.1809.005.1.2	0.05	1.0	1.9	1.60	5.9	9	25	0.15	2.0	Δ/x	Δ/Δ	▲/▲	x/Δ		Δ/x
R/L105.1809.005.2.2	0.05	1.0	1.9	1.60	5.9	12	30	0.15	2.0		Δ/Δ	▲/▲	Δ/x	Δ/x	Δ/x
R/L105.1809.01.0.2	0.10	1.0	1.9	1.60	5.9	6	25	0.15	2.0		Δ/Δ		▲/▲	▲/▲	
R/L105.1809.01.1.2	0.10	1.0	1.9	1.60	5.9	9	25	0.15	2.0		Δ/Δ	Δ/x	▲/▲	▲/Δ	
R/L105.1809.01.2.2	0.10	1.0	1.9	1.60	5.9	12	30	0.15	2.0		Δ/Δ		▲/▲	▲/▲	
R/L105.1809.0.2	0.15	1.0	1.9	1.60	5.9	6	25	0.15	2.0	▲/Δ	▲/▲		▲/▲	▲/▲	▲/▲
R/L105.1809.1.2	0.15	1.0	1.9	1.60	5.9	9	25	0.15	2.0	▲/Δ	▲/▲		▲/▲	▲/▲	▲/▲
R/L105.1809.2.2	0.15	1.0	1.9	1.60	5.9	12	30	0.15	2.0	▲/Δ	▲/▲		▲/▲	▲/▲	▲/▲
R/L105.1813.005.0.25	0.05	1.3	2.3	1.95	5.9	6	25	0.15	2.5		▲/Δ	Δ/x	▲/▲		
R/L105.1813.005.1.25	0.05	1.3	2.3	1.95	5.9	9	25	0.15	2.5		Δ/Δ	▲/▲	Δ/x		
R/L105.1813.005.2.25	0.05	1.3	2.3	1.95	5.9	12	30	0.15	2.5		Δ/Δ	▲/▲	▲/Δ		
R/L105.1813.005.3.25	0.05	1.3	2.3	1.95	5.9	16	35	0.15	2.5		▲/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

硬质合金牌号

Carbide grades

刀片

Insert

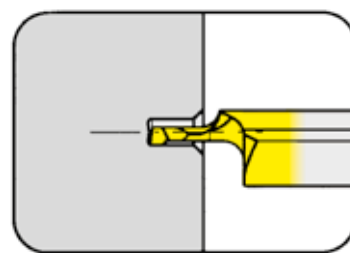
105

微小加工
for ultrafine machining

孔径 Ø 自

Bore Ø from

2 mm

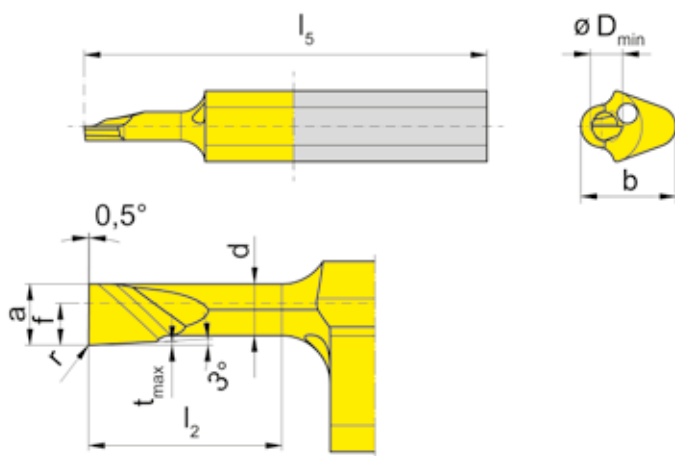


配合刀杆

for Toolholder

型号

Type
H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	AN25	ES15
R105.9013.000.0.2	-	1.3	1.9	1.6	5.9	6	25	0.1	2.0		Δ	▲
R105.9013.000.2.2	-	1.3	1.9	1.6	5.9	12	30	0.1	2.0		Δ	Δ
R105.9013.003.0.2	0.03	1.3	1.9	1.6	5.9	6	25	0.1	2.0		Δ	▲
R105.9013.003.2.2	0.03	1.3	1.9	1.6	5.9	12	30	0.1	2.0		Δ	Δ
R105.9013.000.0.25	-	1.3	2.3	2.0	5.9	6	25	0.1	2.5		Δ	Δ
R105.9013.000.2.25	-	1.3	2.3	2.0	5.9	12	30	0.1	2.5	Δ	Δ	Δ
R105.9013.000.3.25	-	1.3	2.3	2.0	5.9	16	35	0.1	2.5		Δ	Δ
R105.9013.003.0.25	0.03	1.3	2.3	2.0	5.9	6	25	0.1	2.5		Δ	▲
R105.9013.003.2.25	0.03	1.3	2.3	2.0	5.9	12	30	0.1	2.5	Δ	Δ	Δ
R105.9013.003.3.25	0.03	1.3	2.3	2.0	5.9	16	35	0.1	2.5		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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号

Carbide grades

刀片

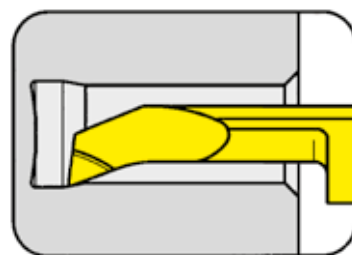
Insert

105

孔径 Ø 自

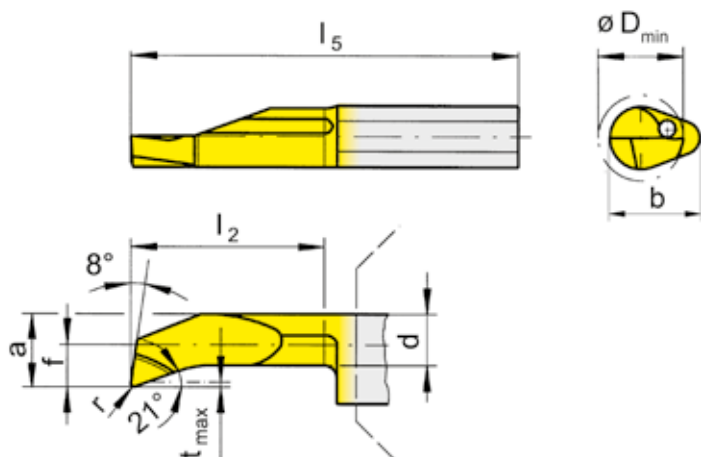
Bore Ø from

3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L/105.1813.005.1.3	0.05	1.3	2.6	2.3	5.9	10	25	0.15	3		▲/Δ	▲/▲	Δ/x	Δ/x	x/x
R/L/105.1813.005.2.3	0.05	1.3	2.6	2.3	5.9	15	30	0.15	3		Δ/Δ	▲/▲		x/x	Δ/x
R/L/105.1813.005.3.3	0.05	1.3	2.6	2.3	5.9	20	35	0.15	3		Δ/Δ	▲/▲		Δ/x	x/x
R/L105.1813.01.1.3	0.10	1.3	2.6	2.3	5.9	10	25	0.15	3		▲/Δ		▲/▲	▲/▲	
R/L105.1813.01.2.3	0.10	1.3	2.6	2.3	5.9	15	30	0.15	3		Δ/Δ		▲/▲	▲/▲	
R/L105.1813.01.3.3	0.10	1.3	2.6	2.3	5.9	20	35	0.15	3		Δ/Δ		▲/▲	▲/▲	
R/L105.1813.1.3	0.20	1.3	2.6	2.3	5.9	10	25	0.15	3	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L105.1813.2.3	0.20	1.3	2.6	2.3	5.9	15	30	0.15	3	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L105.1813.3.3	0.20	1.3	2.6	2.3	5.9	20	35	0.15	3	▲/Δ	▲/▲	x/x	▲/▲	▲/▲	▲/▲
R/L/105.1819.005.1.4	0.05	1.9	3.7	2.9	6.4	10	25	0.30	4		▲/Δ	▲/▲	Δ/Δ	Δ/x	x/x
R/L/105.1819.005.2.4	0.05	1.9	3.7	2.9	6.4	15	30	0.30	4		▲/Δ	▲/▲		x/x	x/x
R/L/105.1819.005.3.4	0.05	1.9	3.7	2.9	6.4	20	35	0.30	4		▲/Δ	▲/▲	Δ/Δ		x/x
R/L105.1819.1.4	0.20	1.9	3.7	2.9	6.4	10	25	0.30	4	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L105.1819.2.4	0.20	1.9	3.7	2.9	6.4	15	30	0.30	4	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L105.1819.3.4	0.20	1.9	3.7	2.9	6.4	20	35	0.30	4	▲/▲	▲/▲	Δ/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

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

硬质合金牌号

Carbide grades

镗孔和仿形加工

Boring and Profiling

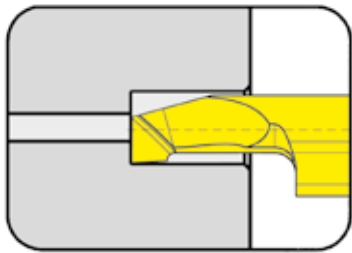


刀片

Insert

105

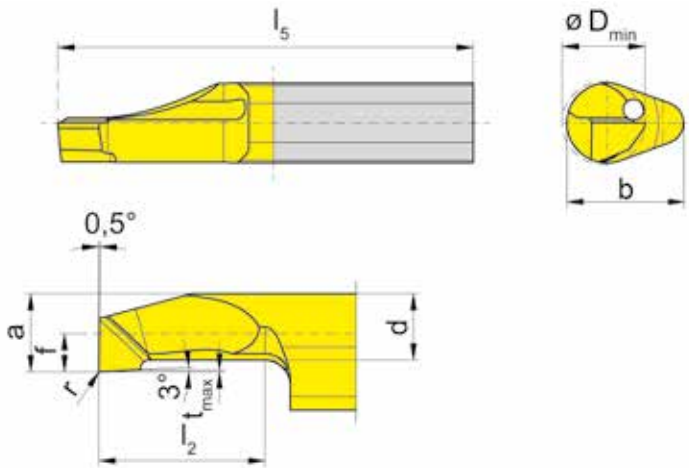
微小加工
for ultrafine machining



孔径Ø 自

Bore Ø from

3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}		AN25	ES15
R105.9013.000.1.3	-	1.3	2.6	2.3	5.9	10	25	0.1	3		Δ	▲
R105.9013.000.3.3	-	1.3	2.6	2.3	5.9	20	35	0.1	3		Δ	Δ
R105.9013.003.1.3	0.03	1.3	2.6	2.3	5.9	10	25	0.1	3		Δ	▲
R105.9013.003.3.3	0.03	1.3	2.6	2.3	5.9	20	35	0.1	3		Δ	▲
R105.9019.000.1.4	-	1.9	3.7	3.2	6.4	10	25	0.1	4		▲	Δ
R105.9019.000.3.4	-	1.9	3.7	3.2	6.4	20	35	0.1	4		Δ	Δ
R105.9019.003.1.4	0.03	1.9	3.7	3.2	6.4	10	25	0.1	4		▲	Δ
R105.9019.003.3.4	0.03	1.9	3.7	3.2	6.4	20	35	0.1	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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

P	●	●
M	○	○
K	-	●
N	-	-
S	-	-
H	-	-

硬质合金牌号
Carbide grades

刀片

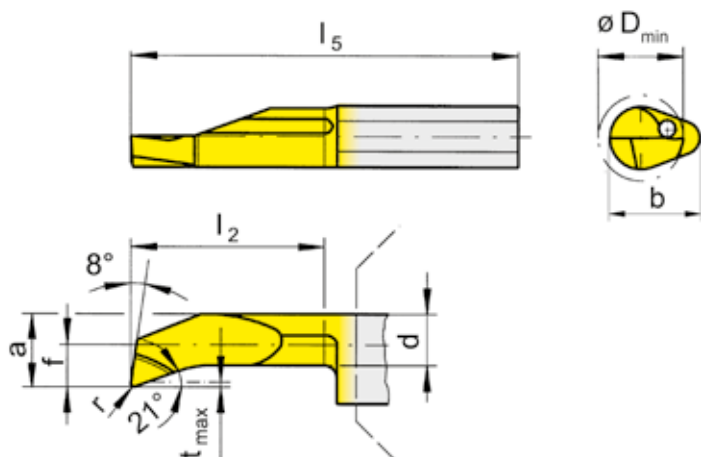
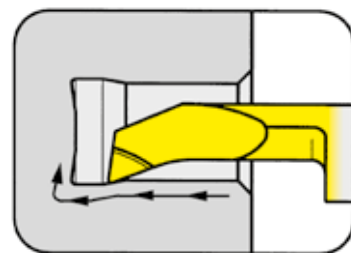
Insert

105

孔径 Ø 自

Bore Ø from

5 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L/105.1823.005.1.5	0.05	2.3	4.7	4	7	10	25	0.5	5		Δ/Δ	▲/▲	x/x		x/x
R/L/105.1823.005.2.5	0.05	2.3	4.7	4	7	15	30	0.5	5		▲/Δ	▲/▲	Δ/x		Δ/x
R/L/105.1823.005.3.5	0.05	2.3	4.7	4	7	20	35	0.5	5		Δ/Δ	▲/▲	Δ/x	x/x	Δ/x
R/L/105.1823.005.4.5	0.05	2.3	4.7	4	7	25	40	0.5	5		Δ/Δ	▲/▲			Δ/x
R/L/105.1823.005.5.5	0.05	2.3	4.7	4	7	30	45	0.5	5		Δ/Δ	▲/▲	Δ/x		x/x
R/L/105.1823.1.5	0.20	2.3	4.7	4	7	10	25	0.5	5	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L/105.1823.2.5	0.20	2.3	4.7	4	7	15	30	0.5	5	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L/105.1823.3.5	0.20	2.3	4.7	4	7	20	35	0.5	5	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L/105.1823.4.5	0.20	2.3	4.7	4	7	25	40	0.5	5	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L/105.1823.5.5	0.20	2.3	4.7	4	7	30	45	0.5	5	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
▲ 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					

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

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling



刀片

Insert

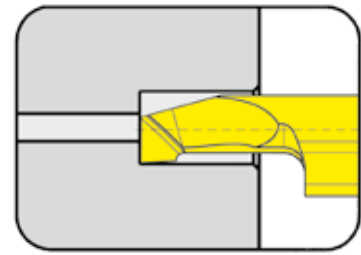
105

微小加工
for ultrafine machining

孔径Ø 自

Bore Ø from

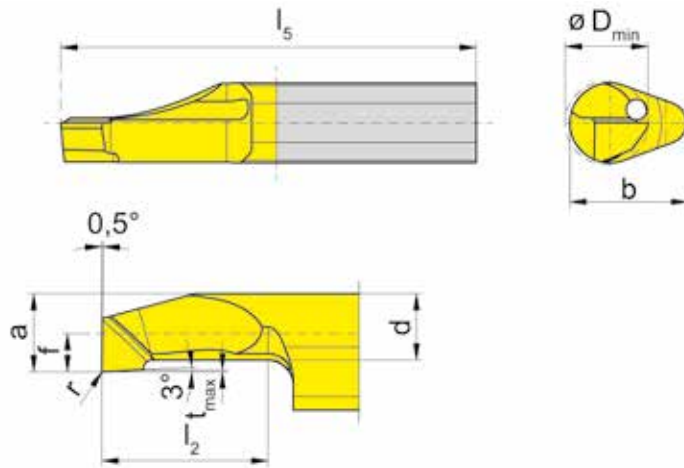
5 mm



配合刀杆

for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}		AN25	ES15
R105.9023.000.1.5	-	2.3	4.7	4	7	10	25	0.1	5		Δ	Δ
R105.9023.000.3.5	-	2.3	4.7	4	7	20	35	0.1	5		Δ	Δ
R105.9023.000.5.5	-	2.3	4.7	4	7	30	45	0.1	5		Δ	Δ
R105.9023.003.1.5	0.03	2.3	4.7	4	7	10	25	0.1	5		Δ	Δ
R105.9023.003.3.5	0.03	2.3	4.7	4	7	20	35	0.1	5		Δ	Δ
R105.9023.003.5.5	0.03	2.3	4.7	4	7	30	45	0.1	5		Δ	Δ
										P	•	•
										M	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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

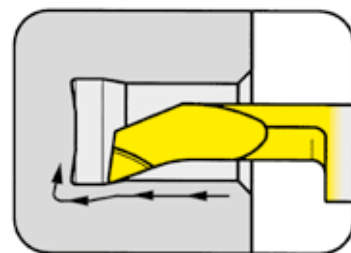
Insert

105

孔径 Ø 自

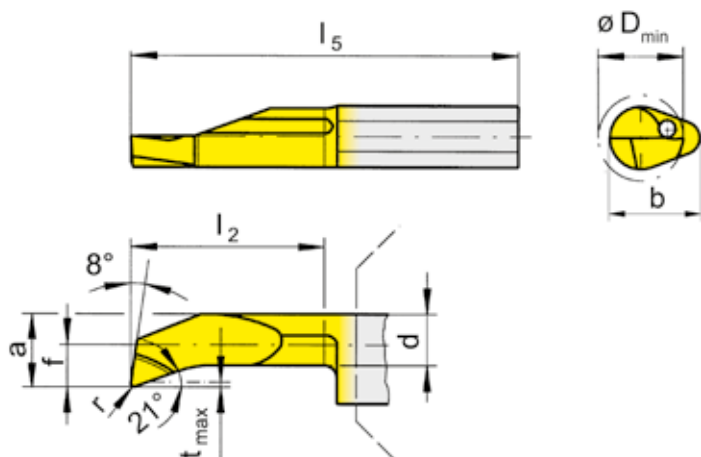
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L/105.1833.005.2.6	0.05	3.3	5.7	4.7	7	15	30	0.5	6.0		Δ/Δ	▲/▲	x/Δ		x/x
R/L/105.1833.005.3.6	0.05	3.3	5.7	4.7	7	20	35	0.5	6.0		Δ/Δ	▲/▲			x/x
R/L/105.1833.005.4.6	0.05	3.3	5.7	4.7	7	25	40	0.5	6.0		Δ/Δ	▲/Δ			x/x
R/L/105.1833.005.5.6	0.05	3.3	5.7	4.7	7	30	45	0.5	6.0		Δ/Δ	▲/Δ			Δ/x
R/L/105.1833.2.6	0.20	3.3	5.7	4.7	7	15	30	0.5	6.0	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L/105.1833.3.6	0.20	3.3	5.7	4.7	7	20	35	0.5	6.0	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L/105.1833.4.6	0.20	3.3	5.7	4.7	7	25	40	0.5	6.0	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L/105.1833.5.6	0.20	3.3	5.7	4.7	7	30	45	0.5	6.0	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
R/L/105.1840.005.3.7	0.05	4.0	6.4	5.2	7	20	35	0.5	6.8		Δ/Δ	▲/▲			
R/L/105.1840.005.4.7	0.05	4.0	6.4	5.2	7	25	40	0.5	6.8		Δ/Δ	▲/▲		x/x	
R/L/105.1840.005.5.7	0.05	4.0	6.4	5.2	7	30	45	0.5	6.8		Δ/Δ	▲/▲		x/x	
R/L/105.1840.3.7	0.20	4.0	6.4	5.2	7	20	35	0.5	6.8	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L/105.1840.4.7	0.20	4.0	6.4	5.2	7	25	40	0.5	6.8	▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
R/L/105.1840.5.7	0.20	4.0	6.4	5.2	7	30	45	0.5	6.8	▲/▲	▲/▲		▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号

Carbide grades

刀片

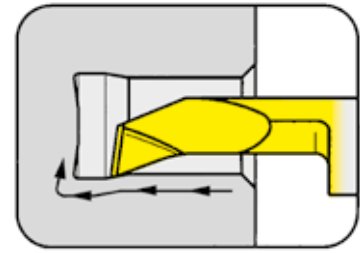
Insert

105

孔径 Ø 自

Bore Ø from

4 mm

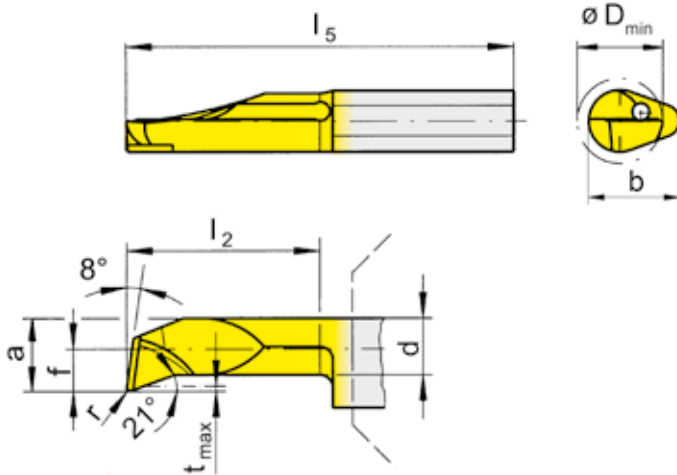


配合刀杆

for Toolholder

型号

Type
H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

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

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TF45	TH35
R/L105.1819.1.H.4	0.2	1.9	3.7	2.9	7	10	25	0.3	4.0	Δ/Δ	▲/▲	▲/Δ
R/L105.1819.2.H.4	0.2	1.9	3.7	2.9	7	15	30	0.3	4.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1819.3.H.4	0.2	1.9	3.7	2.9	7	20	35	0.3	4.0	Δ/Δ	▲/▲	▲/▲
R/L105.1823.1.H.5	0.2	2.3	4.7	4.0	7	10	25	0.5	5.0	Δ/Δ	▲/▲	▲/▲
R/L105.1823.2.H.5	0.2	2.3	4.7	4.0	7	15	30	0.5	5.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1823.3.H.5	0.2	2.3	4.7	4.0	7	20	35	0.5	5.0	Δ/Δ	▲/Δ	▲/▲
R/L105.1823.4.H.5	0.2	2.3	4.7	4.0	7	25	40	0.5	5.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1823.5.H.5	0.2	2.3	4.7	4.0	7	30	45	0.5	5.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1833.2.H.6	0.2	3.3	5.7	4.7	7	15	30	0.5	6.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1833.3.H.6	0.2	3.3	5.7	4.7	7	20	35	0.5	6.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1833.4.H.6	0.2	3.3	5.7	4.7	7	25	40	0.5	6.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1833.5.H.6	0.2	3.3	5.7	4.7	7	30	45	0.5	6.0	Δ/Δ	▲/Δ	▲/Δ
R/L105.1840.3.H.7	0.2	4.0	6.4	5.2	7	20	35	0.5	6.8	▲/Δ	▲/▲	▲/Δ
R/L105.1840.4.H.7	0.2	4.0	6.4	5.2	7	25	40	0.5	6.8	Δ/Δ	▲/Δ	▲/Δ
R/L105.1840.5.H.7	0.2	4.0	6.4	5.2	7	30	45	0.5	6.8	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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

刀片

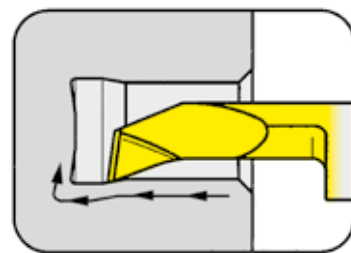
Insert

105

孔径 Ø 自

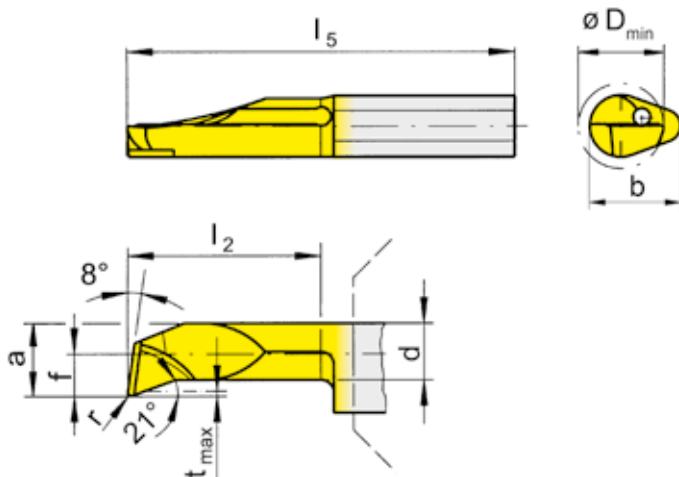
Bore Ø from

4 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	r	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}	EG35	TH35
R/L105.1819.1.HV4	0.2	1.9	3.7	2.9	7	10	25	0.3	4.0	Δ/Δ	▲/Δ
R/L105.1819.2.HV4	0.2	1.9	3.7	2.9	7	15	30	0.3	4.0	Δ/Δ	▲/▲
R/L105.1819.3.HV4	0.2	1.9	3.7	2.9	7	20	35	0.3	4.0	Δ/Δ	▲/▲
R/L105.1823.1.HV5	0.2	2.3	4.7	4.0	7	10	25	0.5	5.0	Δ/Δ	▲/▲
R/L105.1823.2.HV5	0.2	2.3	4.7	4.0	7	15	30	0.5	5.0	Δ/Δ	▲/▲
R/L105.1823.3.HV5	0.2	2.3	4.7	4.0	7	20	35	0.5	5.0	Δ/Δ	▲/▲
R/L105.1823.4.HV5	0.2	2.3	4.7	4.0	7	25	40	0.5	5.0	Δ/Δ	▲/Δ
R/L105.1823.5.HV5	0.2	2.3	4.7	4.0	7	30	45	0.5	5.0	Δ/Δ	▲/Δ
R/L105.1833.2.HV6	0.2	3.3	5.7	4.7	7	15	30	0.5	6.0	Δ/Δ	▲/▲
R/L105.1833.3.HV6	0.2	3.3	5.7	4.7	7	20	35	0.5	6.0	Δ/Δ	▲/Δ
R/L105.1833.4.HV6	0.2	3.3	5.7	4.7	7	25	40	0.5	6.0	Δ/▲	▲/▲
R/L105.1833.5.HV6	0.2	3.3	5.7	4.7	7	30	45	0.5	6.0	Δ/Δ	▲/Δ
R/L105.1840.2.HV7	0.2	4.0	6.4	5.2	7	15	30	0.5	6.8	Δ/Δ	▲/▲
R/L105.1840.3.HV7	0.2	4.0	6.4	5.2	7	20	35	0.5	6.8	Δ/Δ	▲/Δ
R/L105.1840.4.HV7	0.2	4.0	6.4	5.2	7	25	40	0.5	6.8	▲/Δ	▲/Δ
R/L105.1840.5.HV7	0.2	4.0	6.4	5.2	7	30	45	0.5	6.8	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号

Carbide grades

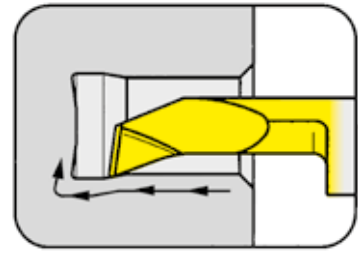
刀片 Insert

105

孔径Ø 自

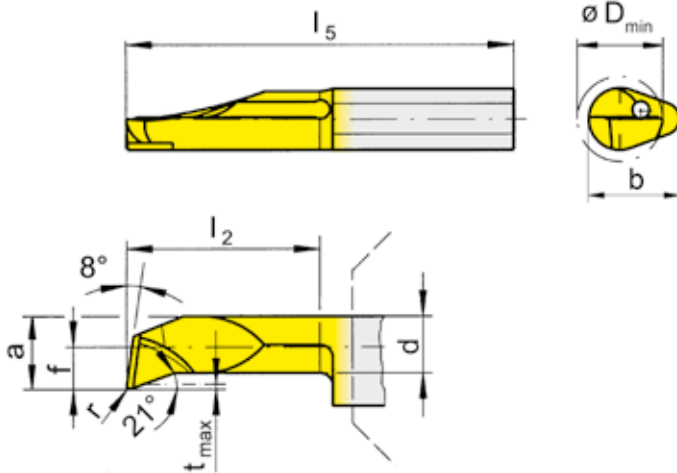
Bore Ø from

4 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	r	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}	EG35	TH35
R/L105.1819.04.1.HV4	0.4	1.9	3.7	2.9	7	10	25	0.3	4.0	Δ/Δ	▲/▲
R/L105.1819.04.2.HV4	0.4	1.9	3.7	2.9	7	15	30	0.3	4.0	▲/Δ	▲/Δ
R/L105.1819.04.3.HV4	0.4	1.9	3.7	2.9	7	20	35	0.3	4.0	Δ/Δ	▲/Δ
R/L105.1823.04.1.HV5	0.4	2.3	4.7	4.0	7	10	25	0.5	5.0	Δ/Δ	▲/▲
R/L105.1823.04.2.HV5	0.4	2.3	4.7	4.0	7	15	30	0.5	5.0	Δ/Δ	▲/Δ
R/L105.1823.04.3.HV5	0.4	2.3	4.7	4.0	7	20	35	0.5	5.0	Δ/Δ	▲/Δ
R/L105.1823.04.4.HV5	0.4	2.3	4.7	4.0	7	25	40	0.5	5.0	Δ/Δ	▲/Δ
R/L105.1823.04.5.HV5	0.4	2.3	4.7	4.0	7	30	45	0.5	5.0	Δ/Δ	▲/▲
R/L105.1833.04.2.HV6	0.4	3.3	5.7	4.7	7	15	30	0.5	6.0	Δ/Δ	▲/▲
R/L105.1833.04.3.HV6	0.4	3.3	5.7	4.7	7	20	35	0.5	6.0	Δ/Δ	▲/Δ
R/L105.1833.04.4.HV6	0.4	3.3	5.7	4.7	7	25	40	0.5	6.0	Δ/Δ	▲/Δ
R/L105.1833.04.5.HV6	0.4	3.3	5.7	4.7	7	30	45	0.5	6.0	Δ/Δ	▲/Δ
R/L105.1840.04.2.HV7	0.4	4.0	6.4	5.2	7	15	30	0.5	6.8	Δ/Δ	▲/▲
R/L105.1840.04.3.HV7	0.4	4.0	6.4	5.2	7	20	35	0.5	6.8	Δ/Δ	▲/▲
R/L105.1840.04.4.HV7	0.4	4.0	6.4	5.2	7	25	40	0.5	6.8	Δ/Δ	▲/Δ
R/L105.1840.04.5.HV7	0.4	4.0	6.4	5.2	7	30	45	0.5	6.8	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

Insert

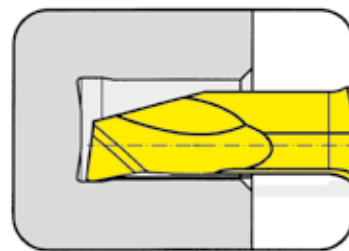
105

加强型
reinforced version

孔径Ø 自

Bore Ø from

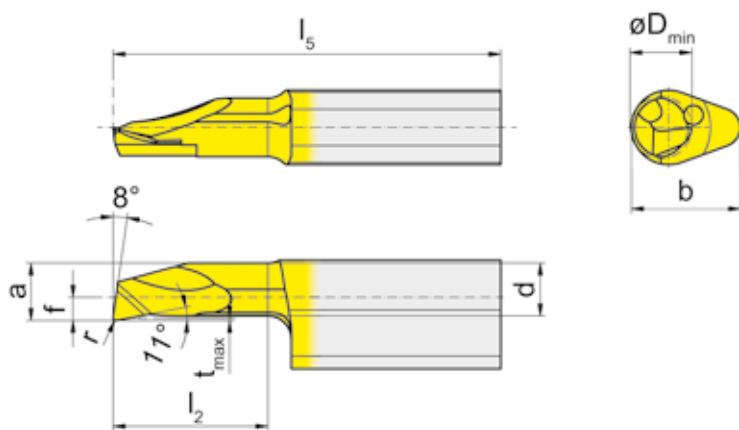
4 mm



配合刀杆

for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35
R/L105.1019.005.1.4	0.05	1.5	3.7	3.4	7	10	25	0.15	4	Δ/Δ	▲/▲
R/L105.1019.005.2.4	0.05	1.5	3.7	3.4	7	15	30	0.15	4	Δ/Δ	▲/▲
R/L105.1019.005.3.4	0.05	1.5	3.7	3.4	7	20	35	0.15	4	Δ/Δ	▲/▲
R/L105.1019.005.4.4	0.05	1.5	3.7	3.4	7	25	40	0.15	4	Δ/Δ	▲/▲
R/L105.1019.1.4	0.20	1.5	3.7	3.4	7	10	25	0.15	4	▲/Δ	▲/▲
R/L105.1019.2.4	0.20	1.5	3.7	3.4	7	15	30	0.15	4	▲/Δ	▲/▲
R/L105.1019.3.4	0.20	1.5	3.7	3.4	7	20	35	0.15	4	▲/Δ	▲/▲
R/L105.1019.4.4	0.20	1.5	3.7	3.4	7	25	40	0.15	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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

Insert

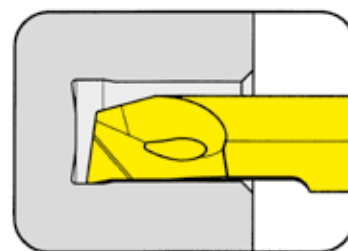
105

加强型
reinforced version

孔径 Ø 自

Bore Ø from

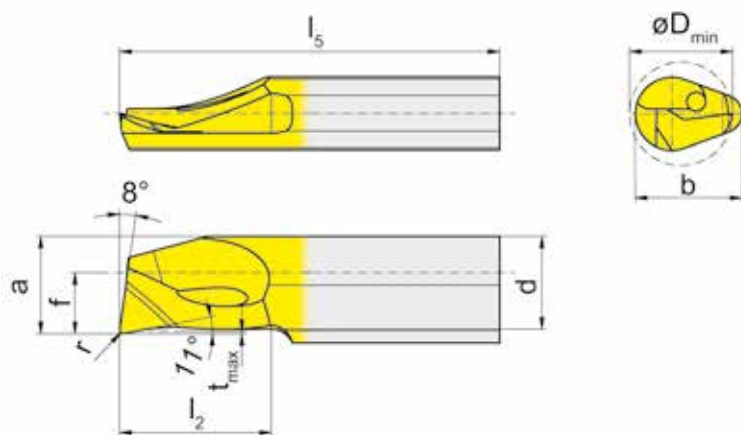
5 mm



配合刀杆
for Toolholder

型号
Type

H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35
R/L/105.1023.005.1.5	0.05	2.8	4.7	4.4	7	10	25	0.15	5	▲/Δ	▲/▲
R/L/105.1023.005.2.5	0.05	2.8	4.7	4.4	7	15	30	0.15	5	Δ/Δ	▲/Δ
R/L/105.1023.005.3.5	0.05	2.8	4.7	4.4	7	20	35	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.005.4.5	0.05	2.8	4.7	4.4	7	25	40	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.005.5.5	0.05	2.8	4.7	4.4	7	30	45	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.005.6.5	0.05	2.8	4.7	4.4	7	35	50	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.1.5	0.20	2.8	4.7	4.4	7	10	25	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.2.5	0.20	2.8	4.7	4.4	7	15	30	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.3.5	0.20	2.8	4.7	4.4	7	20	35	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.4.5	0.20	2.8	4.7	4.4	7	25	40	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.5.5	0.20	2.8	4.7	4.4	7	30	45	0.15	5	Δ/Δ	▲/▲
R/L/105.1023.6.5	0.20	2.8	4.7	4.4	7	35	50	0.15	5	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

Insert

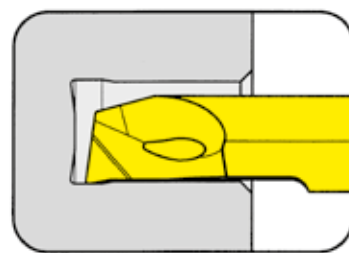
105

加强型
reinforced version

孔径Ø 自

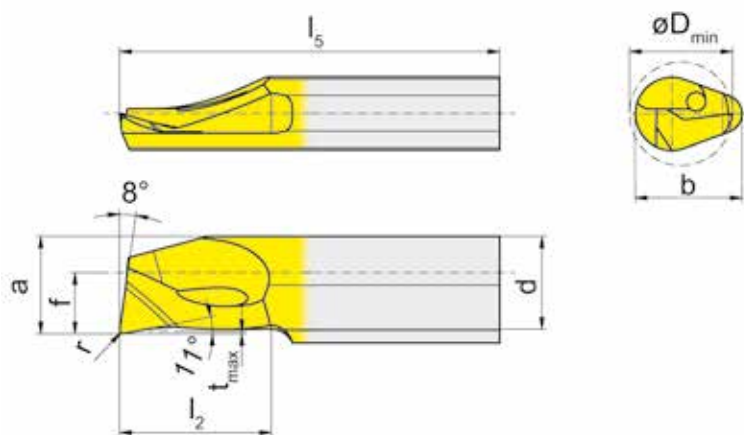
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35
R/L105.1033.005.1.6	0.05	3.3	5.7	5.4	7	10	25	0.15	6	Δ/Δ	▲/▲
R/L105.1033.005.2.6	0.05	3.3	5.7	5.4	7	15	30	0.15	6	Δ/Δ	▲/▲
R/L105.1033.005.3.6	0.05	3.3	5.7	5.4	7	20	35	0.15	6	Δ/Δ	▲/▲
R/L105.1033.005.4.6	0.05	3.3	5.7	5.4	7	25	40	0.15	6	Δ/Δ	▲/Δ
R/L105.1033.005.5.6	0.05	3.3	5.7	5.4	7	30	45	0.15	6	Δ/Δ	▲/▲
R/L105.1033.005.6.6	0.05	3.3	5.7	5.4	7	35	50	0.15	6	Δ/Δ	▲/▲
R/L105.1033.1.6	0.20	3.3	5.7	5.4	7	10	25	0.15	6	▲/Δ	▲/▲
R/L105.1033.2.6	0.20	3.3	5.7	5.4	7	15	30	0.15	6	▲/Δ	▲/▲
R/L105.1033.3.6	0.20	3.3	5.7	5.4	7	20	35	0.15	6	▲/Δ	▲/▲
R/L105.1033.4.6	0.20	3.3	5.7	5.4	7	25	40	0.15	6	Δ/Δ	▲/▲
R/L105.1033.5.6	0.20	3.3	5.7	5.4	7	30	45	0.15	6	Δ/Δ	▲/▲
R/L105.1033.6.6	0.20	3.3	5.7	5.4	7	35	50	0.15	6	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

Insert

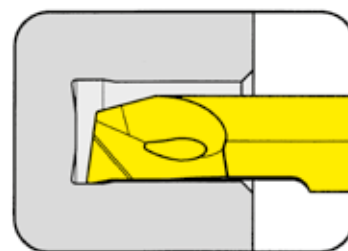
105

加强型
reinforced version

孔径 Ø 自

Bore Ø from

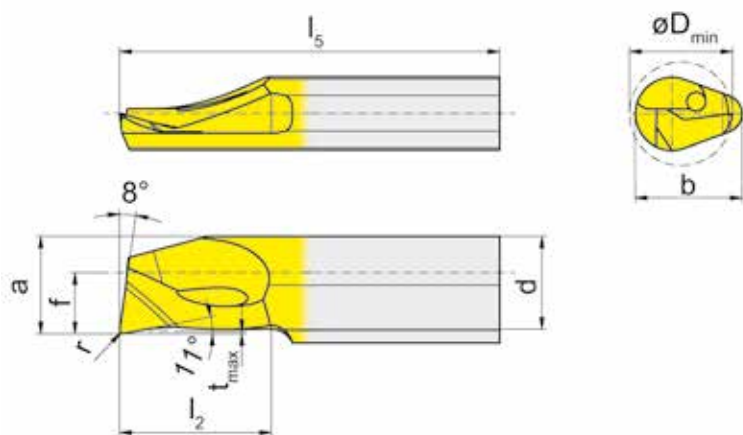
6,8 mm



配合刀杆
for Toolholder

型号
Type

H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35
R/L105.1040.1.7	0.2	4	6.4	6.1	7	10	25	0.15	6.8	▲/Δ	▲/▲
R/L105.1040.2.7	0.2	4	6.4	6.1	7	15	30	0.15	6.8	▲/Δ	▲/▲
R/L105.1040.3.7	0.2	4	6.4	6.1	7	20	35	0.15	6.8	▲/Δ	▲/▲
R/L105.1040.4.7	0.2	4	6.4	6.1	7	25	40	0.15	6.8	Δ/Δ	▲/▲
R/L105.1040.5.7	0.2	4	6.4	6.1	7	30	45	0.15	6.8	Δ/Δ	▲/▲
R/L105.1040.6.7	0.2	4	6.4	6.1	7	35	50	0.15	6.8	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

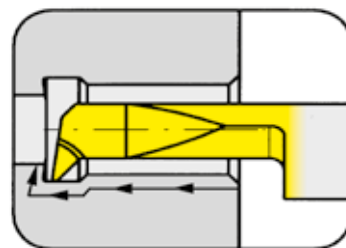
Insert

105

孔径Ø 自

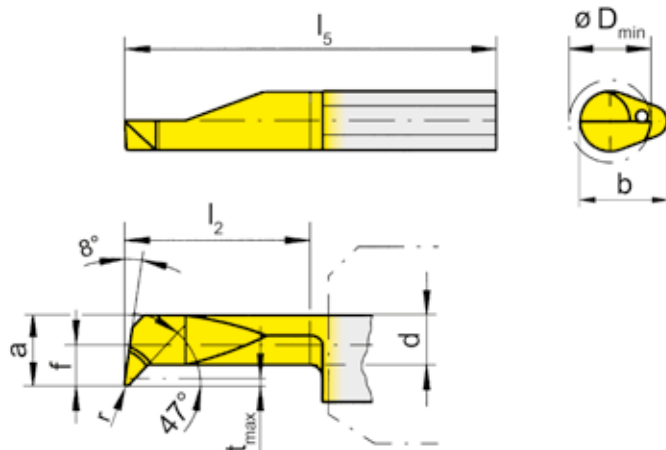
Bore Ø from

2 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	MG12	AN25	EG35	ES15	TF45	TH35	TI25	TN35
R105.4715.005.1.2	0.05	1.5	1.9	1.45	5.9	9	25	0.3	2		Δ	▲	▲				
R105.4715.005.2.2	0.05	1.5	1.9	1.45	5.9	12	30	0.3	2		Δ	Δ	Δ				
R105.4713.005.1.3	0.05	1.3	2.6	2.00	5.9	10	25	0.4	3	▲	Δ	▲	▲				
R105.4713.005.2.3	0.05	1.3	2.6	2.00	5.9	15	30	0.4	3		Δ	Δ	▲				
R/L105.4719.1.4	0.15	1.9	3.7	2.90	6.4	10	25	0.6	4			▲/▲			▲/▲		
R/L105.4719.3.4	0.15	1.9	3.7	2.90	6.4	20	35	0.6	4	Δ/x		▲/▲		x/x	▲/▲	▲/▲	▲/▲
R/L105.4723.2.5	0.15	2.3	4.7	3.70	7.0	15	30	0.8	5			▲/Δ			▲/▲		Δ/x
R/L105.4723.4.5	0.15	2.3	4.7	3.70	7.0	25	40	0.8	5			▲/▲			▲/▲	▲/▲	▲/▲
R/L105.4733.3.6	0.15	3.3	5.7	3.70	7.0	20	35	1.8	6			▲/Δ			▲/▲		
R/L105.4733.5.6	0.15	3.3	5.7	3.70	7.0	30	45	1.8	6	Δ/x		▲/▲			▲/▲	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

硬质合金牌号
Carbide grades

刀片

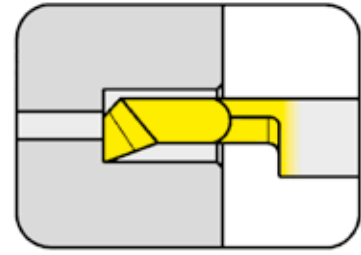
Insert

105

孔径 Ø 自

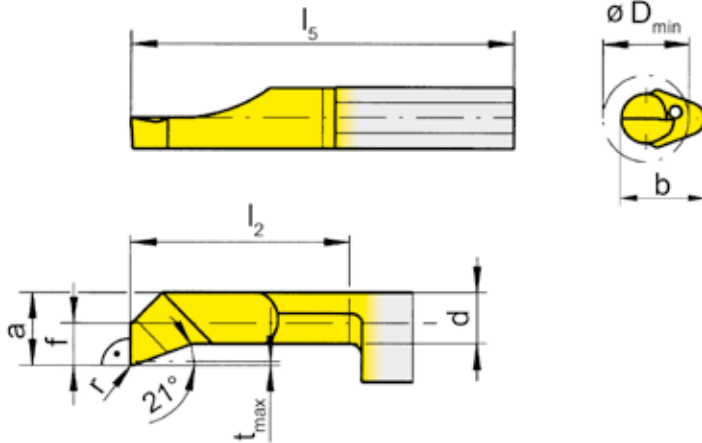
Bore Ø from

3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}		EG35	TH35	TI25	TN35
R/L105.9013.01.1.3	0.1	1.3	2.6	2.3	5.9	10	25	0.15	3		Δ/Δ	▲/▲		
R/L105.9013.01.2.3	0.1	1.3	2.6	2.3	5.9	15	30	0.15	3		Δ/Δ	▲/Δ		
R/L105.9013.01.3.3	0.1	1.3	2.6	2.3	5.9	20	35	0.15	3		▲/Δ	Δ/Δ		
R/L105.9013.1.3	0.2	1.3	2.6	2.3	5.9	10	25	0.15	3		▲/▲			▲/▲
R/L105.9013.2.3	0.2	1.3	2.6	2.3	5.9	15	30	0.15	3		▲/▲			▲/▲
R/L105.9019.01.1.4	0.1	1.9	3.7	2.9	6.4	10	25	0.30	4		Δ/Δ	▲/Δ		
R/L105.9019.01.2.4	0.1	1.9	3.7	2.9	6.4	15	30	0.30	4		Δ/Δ	▲/Δ		
R/L105.9019.01.3.4	0.1	1.9	3.7	2.9	6.4	20	35	0.30	4		Δ/Δ	▲/Δ		
R/L105.9019.1.4	0.2	1.9	3.7	2.9	6.4	10	25	0.30	4		▲/▲			▲/▲
R/L105.9019.2.4	0.2	1.9	3.7	2.9	6.4	15	30	0.30	4		▲/▲		Δ/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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

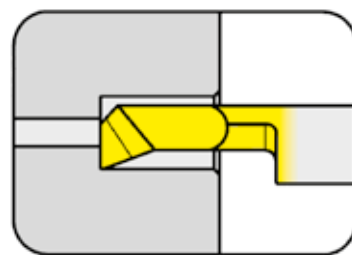
Insert

105

孔径 Ø 自

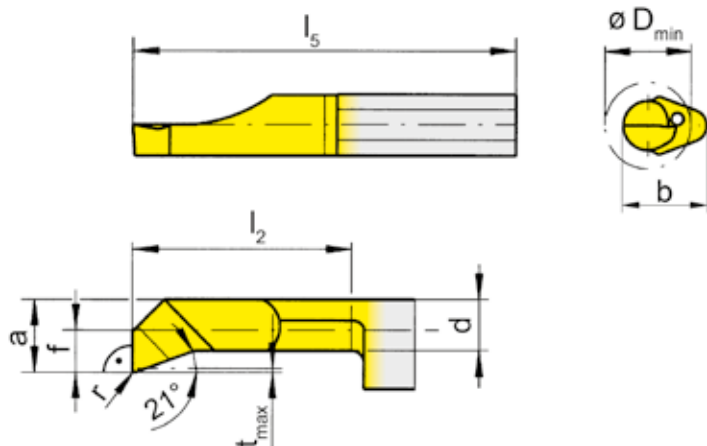
Bore Ø from

5 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}	EG35	TH35	TN35
R/L105.9023.01.1.5	0.1	2.3	4.7	4.0	7	10	25	0.5	5	Δ/Δ	▲/Δ	
R/L105.9023.01.2.5	0.1	2.3	4.7	4.0	7	15	30	0.5	5	▲/Δ	▲/▲	
R/L105.9023.01.3.5	0.1	2.3	4.7	4.0	7	20	35	0.5	5	Δ/Δ	▲/▲	
R/L105.9023.01.4.5	0.1	2.3	4.7	4.0	7	25	40	0.5	5	Δ/Δ	▲/Δ	
R/L105.9023.1.5	0.2	2.3	4.7	4.0	7	10	25	0.5	5	▲/▲	▲/x	▲/▲
R/L105.9023.2.5	0.2	2.3	4.7	4.0	7	15	30	0.5	5	▲/▲	▲/x	▲/▲
R/L105.9023.3.5	0.2	2.3	4.7	4.0	7	20	35	0.5	5	▲/▲		▲/▲
R/L105.9033.1.6	0.2	3.3	5.7	4.7	7	10	25	0.5	6	Δ/Δ	▲/x	
R/L105.9033.2.6	0.2	3.3	5.7	4.7	7	15	30	0.5	6	Δ/Δ	▲/Δ	
R/L105.9033.3.6	0.2	3.3	5.7	4.7	7	20	35	0.5	6	Δ/Δ	▲/▲	
R/L105.9033.4.6	0.2	3.3	5.7	4.7	7	25	40	0.5	6	Δ/Δ	▲/Δ	
R/L105.9033.5.6	0.2	3.3	5.7	4.7	7	30	45	0.5	6	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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

镗孔，仿形加工和倒角

Boring, Profiling and Chamfering



刀片

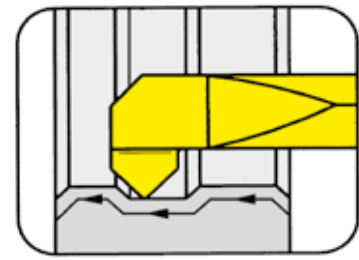
Insert

105

孔径Ø 自

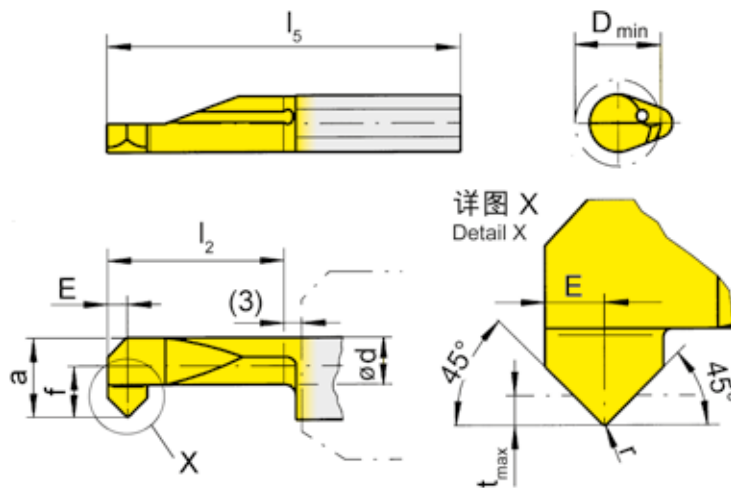
Bore Ø from

5 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	E	a	d	b	l_2	l_5	$t_{\max}$	$D_{\min}$		EG35	TF45	TI25	TN35	
R/L105.4545.2.5	0.2	2.3	1	4.7	3.5	7	15	30	0.7	5		▲/▲	x/x		▲/▲	
R/L105.4545.3.7	0.2	4.0	1	6.4	4.7	7	20	35	0.7	7		▲/▲		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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

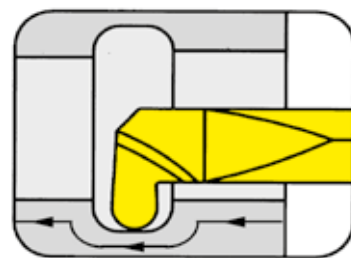
切槽 (内圆)

Grooving (internal)

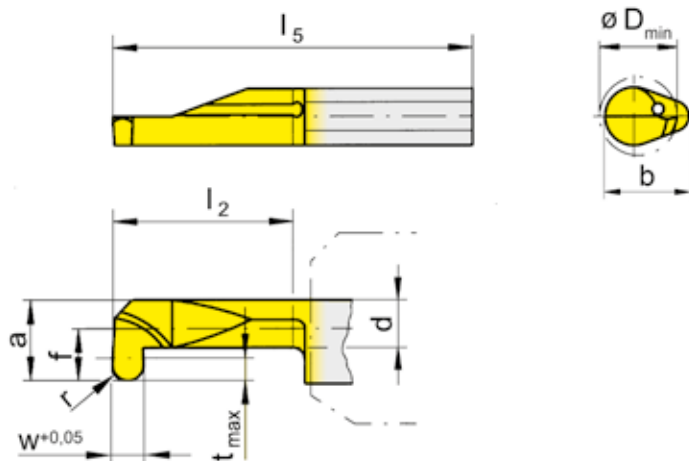
刀片

Insert

105

孔径Ø 自
圆头Bore Ø from
Full radius4 mm
0,25-1 mm配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



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	a	d	b	l_2	l_5	t_{max}	D_{min}	AN25	EG35	ES15	TF45	TH35	TN35
R/105.0025.2.3	0.5	0.25	1.4	2.7	1.9	5.9	15	30	0.6	3	Δ	Δ	Δ			
R/L/105.0005.1.4	1.0	0.50	1.9	3.7	2.7	6.4	10	25	0.8	4		Δ/▲			▲/▲	
R/L/105.0005.2.4	1.0	0.50	1.9	3.7	2.7	6.4	15	30	0.8	4		▲/▲				▲/▲
R105.0025.3.5	0.5	0.25	2.3	4.7	3.9	7.0	20	35	0.6	5	Δ	Δ	Δ			
R/L/105.0005.3.5	1.0	0.50	2.3	4.7	3.5	7.0	20	35	1.0	5		▲/▲		x/x		▲/▲
R/L/105.0007.1.5	1.5	0.75	2.3	4.7	3.5	7.0	10	25	1.0	5		Δ/Δ			▲/Δ	
R/L/105.0007.3.5	1.5	0.75	2.3	4.7	3.5	7.0	20	35	1.0	5		▲/Δ				▲/▲
R/L/105.0010.1.5	2.0	1.00	2.3	4.7	3.5	7.0	10	25	1.0	5		▲/Δ			▲/Δ	
R/L/105.0010.3.5	2.0	1.00	2.3	4.7	3.5	7.0	20	35	1.0	5		▲/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

硬质合金牌号
Carbide grades

切槽 (内圆)

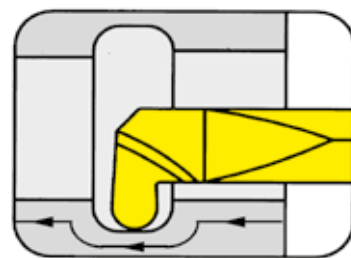
Grooving (internal)



刀片

Insert

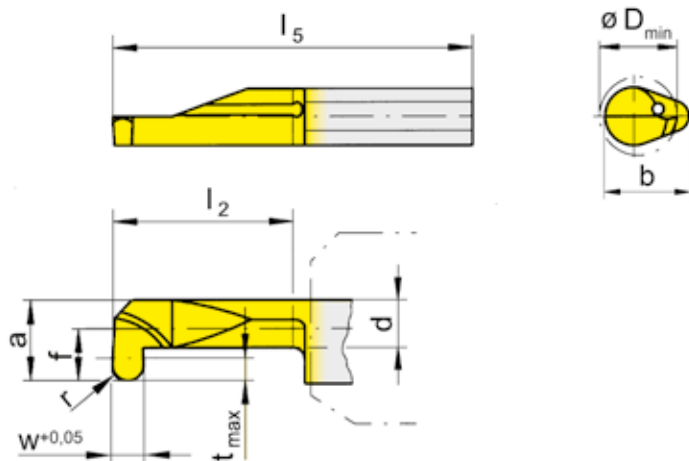
105



孔径Ø 自
圆头

Bore Ø from
Full radius

6 mm
0,5-1 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

圆头
Full radius

R=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	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35	TN35	
R/L105.0005.2.6	1.0	0.50	3.3	5.7	3.7	7	15	30	1.8	6				
R/L105.0007.2.6	1.5	0.75	3.3	5.7	3.7	7	15	30	1.8	6				
R/L105.0010.2.6	2.0	1.00	3.3	5.7	3.7	7	15	30	1.8	6				
R/L105.0005.4.6	1.0	0.50	3.3	5.7	3.7	7	25	40	1.8	6				
R/L105.0007.4.6	1.5	0.75	3.3	5.7	3.7	7	25	40	1.8	6				
R/L105.0010.4.6	2.0	1.00	3.3	5.7	3.7	7	25	40	1.8	6				
▲ 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

硬质合金牌号
Carbide grades

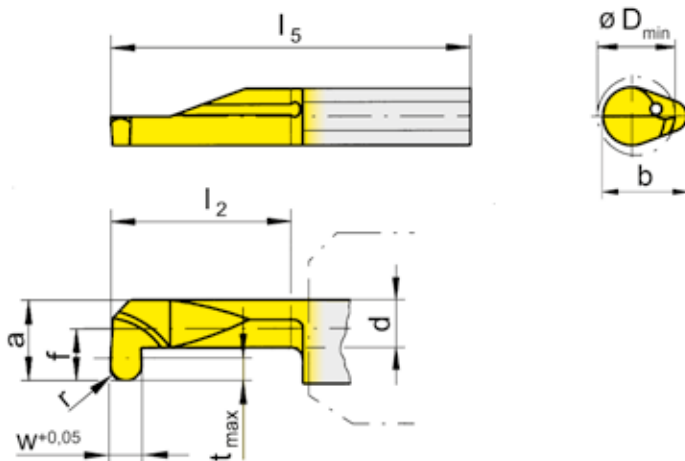
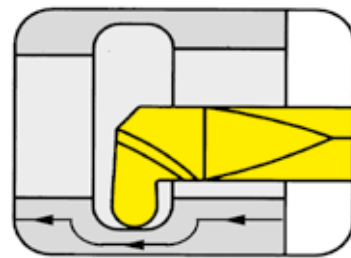
切槽 (内圆)

Grooving (internal)

刀片

Insert

105

孔径Ø 自
圆头Bore Ø from
Full radius6,8 mm
0,5-1 mm配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

圆头
Full radius

R=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	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35	TN35
R/L105.0005.3.7	1.0	0.50	4	6.4	3.7	7	20	35	2.5	6.8	▲/Δ	▲/▲	
R/L105.0007.3.7	1.5	0.75	4	6.4	3.7	7	20	35	2.5	6.8	Δ/Δ	▲/▲	
R/L105.0010.3.7	2.0	1.00	4	6.4	3.7	7	20	35	2.5	6.8	▲/Δ	▲/▲	
R/L105.0005.5.7	1.0	0.50	4	6.4	3.7	7	30	45	2.5	6.8	▲/Δ		▲/▲
R/L105.0007.5.7	1.5	0.75	4	6.4	3.7	7	30	45	2.5	6.8	▲/Δ		▲/▲
R/L105.0010.5.7	2.0	1.00	4	6.4	3.7	7	30	45	2.5	6.8	▲/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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

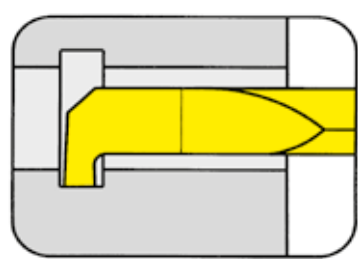
切槽 (内圆)

Grooving (internal)



刀片
Insert

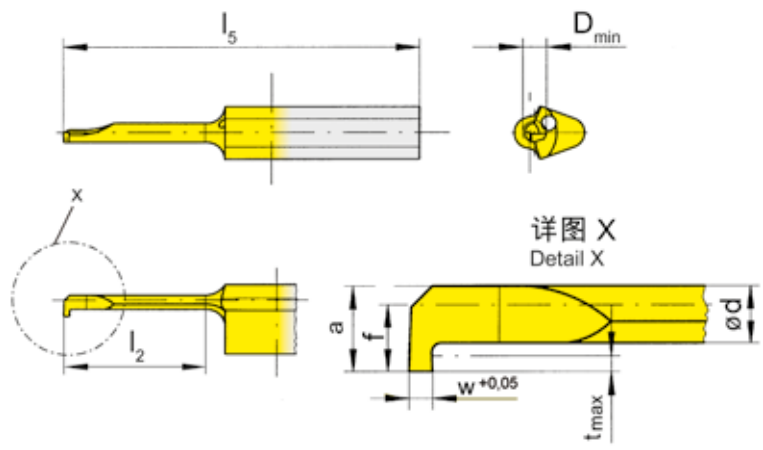
105



孔径Ø 自 槽深可达	Bore Ø from Depth of groove up to	2 mm 0,4 mm
---------------	--------------------------------------	----------------

配合刀杆
for Toolholder

- 型号
Type
- H105
 - HC105
 - B105
 - VDI
 - B105C
 - B105TS
 - IR105
 - 962
 - AIH
 - 963
 - N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}	EG35	TI25
R/L105.0050.0.2	0.5	1.4	1.8	1.2	5.9	6	25	0.4	2	▲/▲	▲/▲
R/L105.0050.1.2	0.5	1.4	1.8	1.2	5.9	9	25	0.4	2	▲/Δ	▲/▲
R/L105.0050.2.2	0.5	1.4	1.8	1.2	5.9	12	30	0.4	2	▲/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
按需提供更多尺寸
Further sizes upon request

P	•	•
M	•	•
K	o	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



刀片

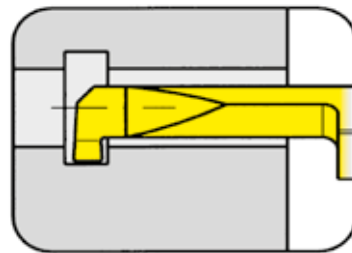
Insert

105

孔径Ø 自
槽深可达

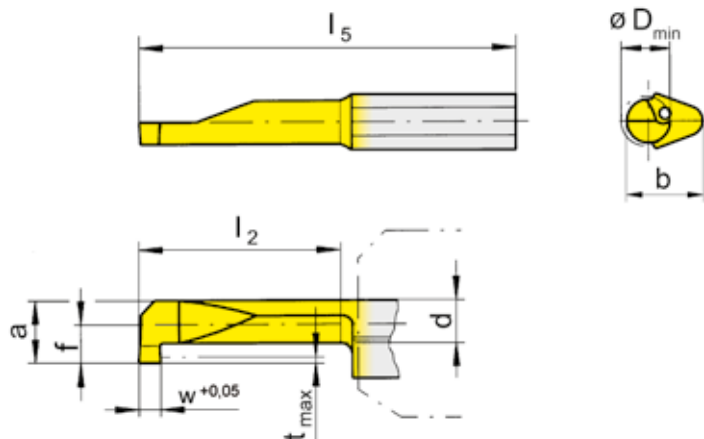
Bore Ø from
Depth of groove up to

3 mm
0,6 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	a	d	b	l_2	l_5	t_{max}	D_{min}		MG12	AN25	EG35	ES15	TI25
R105.0050.1.3	0.5	1.4	2.7	2.0	5.9	8	25	0.5	3			Δ	Δ	Δ	
R105.0050.2.3	0.5	1.4	2.7	2.0	5.9	12	30	0.5	3		Δ	Δ	Δ	Δ	
R105.0050.3.3	0.5	1.4	2.7	2.0	5.9	16	35	0.5	3			Δ	Δ	Δ	
R/L105.0070.1.3	0.7	1.4	2.7	1.9	5.9	8	25	0.6	3				▲/▲		▲/▲
R/L105.0070.2.3	0.7	1.4	2.7	1.9	5.9	12	30	0.6	3				▲/Δ		▲/▲
R/L105.0070.3.3	0.7	1.4	2.7	1.9	5.9	16	35	0.6	3				▲/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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)

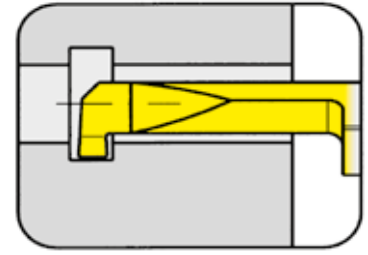


A

刀片

Insert

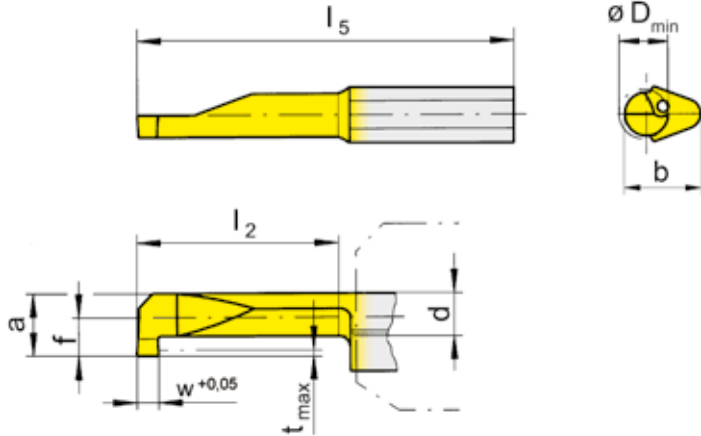
105



孔径Ø 自
槽深可达

Bore Ø from
Depth of groove up to

4 mm
0,8 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	a	d	b	l_2	l_5	t_{max}	D_{min}		MG12	AN25	EG35	ES15	TN35
R105.0050.1.4	0.5	1.9	3.7	2.9	6.4	10	25	0.6	4			Δ	Δ	▲	
R/105.0050.2.4	0.5	1.9	3.7	2.9	6.4	15	30	0.6	4			Δ	Δ	Δ	
R105.0050.3.4	0.5	1.9	3.7	2.9	6.4	20	35	0.6	4			Δ	Δ	Δ	
R/L/105.0100.1.4	1.0	1.9	3.7	2.7	6.4	10	25	0.8	4		▲/▲		▲/Δ		▲/▲
R/L105.0100.2.4	1.0	1.9	3.7	2.7	6.4	15	30	0.8	4		▲/Δ		▲/Δ		▲/▲
R/L105.0100.3.4	1.0	1.9	3.7	2.7	6.4	20	35	0.8	4		▲/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 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

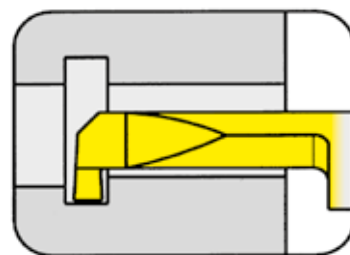
切槽 (内圆)

Grooving (internal)

刀片

Insert

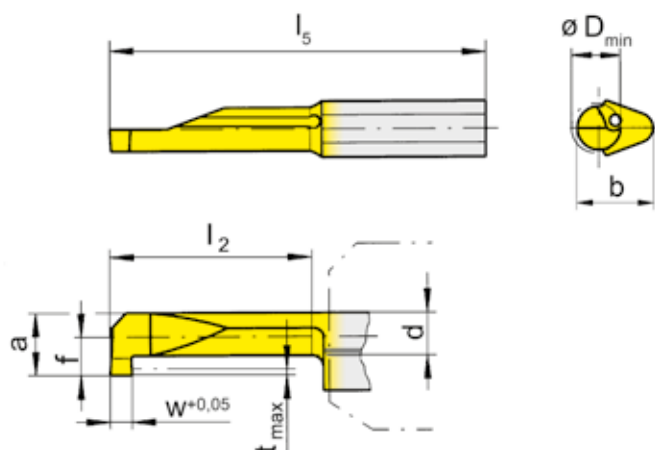
105



孔径Ø 自
槽深可达

Bore Ø from
Depth of groove up to

5 mm
1 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}		MG12	EG35	TH35	TN35
R/L105.0100.1.5	1.0	2.3	4.7	3.5	7	10	25	1	5		▲/△	▲/▲	▲/▲	▲/▲
R/L105.0150.1.5	1.5	2.3	4.7	3.5	7	10	25	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0200.1.5	2.0	2.3	4.7	3.5	7	10	25	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0100.2.5	1.0	2.3	4.7	3.5	7	15	30	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0150.2.5	1.5	2.3	4.7	3.5	7	15	30	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0200.2.5	2.0	2.3	4.7	3.5	7	15	30	1	5		▲/△	▲/△	▲/▲	▲/▲
R/L105.0100.3.5	1.0	2.3	4.7	3.5	7	20	35	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0150.3.5	1.5	2.3	4.7	3.5	7	20	35	1	5		▲/△	▲/△	▲/△	▲/▲
R/L105.0200.3.5	2.0	2.3	4.7	3.5	7	20	35	1	5		△/x	▲/△	▲/△	▲/△
R/L105.0100.4.5	1.0	2.3	4.7	3.5	7	25	40	1	5			▲/△	△/△	▲/△
R/L105.0150.4.5	1.5	2.3	4.7	3.5	7	25	40	1	5			▲/△	▲/△	▲/△
R/L105.0200.4.5	2.0	2.3	4.7	3.5	7	25	40	1	5			▲/△	▲/△	▲/△
R/L105.0100.5.5	1.0	2.3	4.7	3.5	7	30	45	1	5			▲/△	▲/△	▲/△
R/L105.0150.5.5	1.5	2.3	4.7	3.5	7	30	45	1	5			△/△	▲/△	▲/△
R/L105.0200.5.5	2.0	2.3	4.7	3.5	7	30	45	1	5			△/△	▲/△	▲/△

▲ 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

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

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)

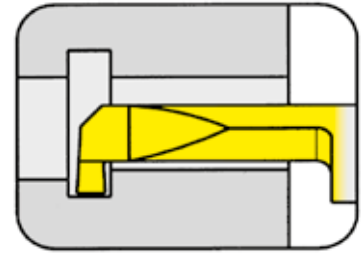


A

刀片

Insert

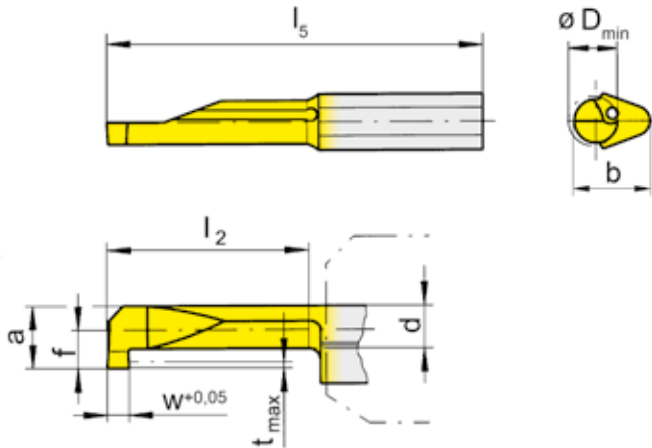
105



孔径Ø 自
槽深可达

Bore Ø from
Depth of groove up to

6 mm
1,8 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}		MG12	EG35	TH35	TN35
R/L105.0100.1.6	1.0	3.3	5.7	3.7	7	10	25	1.8	6		▲/▲	▲/▲	▲/▲	▲/▲
R/L105.0150.1.6	1.5	3.3	5.7	3.7	7	10	25	1.8	6		▲/Δ	▲/▲	▲/▲	▲/▲
R/L105.0200.1.6	2.0	3.3	5.7	3.7	7	10	25	1.8	6		▲/Δ	▲/Δ	▲/▲	▲/▲
R/L105.0100.2.6	1.0	3.3	5.7	3.7	7	15	30	1.8	6		▲/Δ	▲/Δ	▲/▲	▲/▲
R/L105.0150.2.6	1.5	3.3	5.7	3.7	7	15	30	1.8	6		▲/Δ	▲/▲	▲/▲	▲/▲
R/L105.0200.2.6	2.0	3.3	5.7	3.7	7	15	30	1.8	6		▲/Δ	▲/▲	▲/▲	▲/▲
R/L105.0100.3.6	1.0	3.3	5.7	3.7	7	20	35	1.8	6		▲/Δ	▲/Δ	▲/▲	▲/▲
R/L105.0150.3.6	1.5	3.3	5.7	3.7	7	20	35	1.8	6		▲/Δ	▲/Δ	▲/▲	▲/▲
R/L105.0200.3.6	2.0	3.3	5.7	3.7	7	20	35	1.8	6		▲/Δ	▲/▲	▲/▲	▲/▲
R/L105.0100.4.6	1.0	3.3	5.7	3.7	7	25	40	1.8	6			▲/Δ	▲/▲	▲/Δ
R/L105.0150.4.6	1.5	3.3	5.7	3.7	7	25	40	1.8	6			▲/Δ	▲/Δ	▲/▲
R/L105.0200.4.6	2.0	3.3	5.7	3.7	7	25	40	1.8	6			▲/Δ	▲/Δ	▲/▲
R/L105.0100.5.6	1.0	3.3	5.7	3.7	7	30	45	1.8	6			▲/Δ	▲/Δ	▲/Δ
R/L105.0150.5.6	1.5	3.3	5.7	3.7	7	30	45	1.8	6			▲/Δ	▲/Δ	▲/▲
R/L105.0200.5.6	2.0	3.3	5.7	3.7	7	30	45	1.8	6			▲/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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

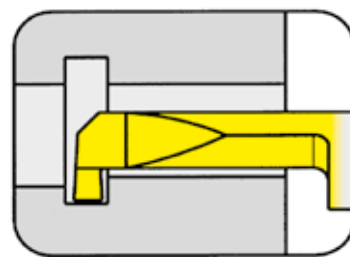
切槽 (内圆)

Grooving (internal)

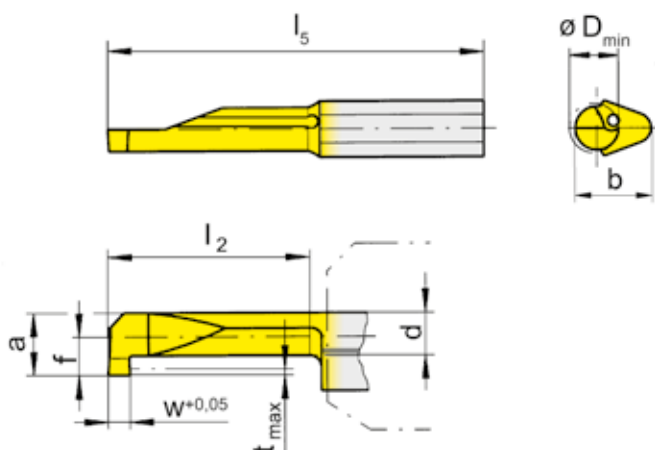
刀片

Insert

105

孔径Ø 自
槽深可达Bore Ø from
Depth of groove up to6,8 mm
2,5 mm配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	f	a	d	b	l ₂	l ₅	t _{max}	D _{min}	MG12 EG35 TH35 TN35	
R/L105.0100.1.7	1.0	4	6.4	3.7	7	10	25	2.5	6.8		▲/▲
R/L105.0150.1.7	1.5	4	6.4	3.7	7	10	25	2.5	6.8		▲/▲
R/L105.0200.1.7	2.0	4	6.4	3.7	7	10	25	2.5	6.8		▲/▲
R/L105.0100.2.7	1.0	4	6.4	3.7	7	15	30	2.5	6.8		▲/Δ
R/L105.0150.2.7	1.5	4	6.4	3.7	7	15	30	2.5	6.8		▲/▲
R/L105.0200.2.7	2.0	4	6.4	3.7	7	15	30	2.5	6.8		▲/▲
R/L105.0100.3.7	1.0	4	6.4	3.7	7	20	35	2.5	6.8		▲/▲
R/L105.0150.3.7	1.5	4	6.4	3.7	7	20	35	2.5	6.8		▲/Δ
R/L105.0200.3.7	2.0	4	6.4	3.7	7	20	35	2.5	6.8		▲/Δ
R/L105.0100.4.7	1.0	4	6.4	3.7	7	25	40	2.5	6.8		▲/Δ
R/L105.0150.4.7	1.5	4	6.4	3.7	7	25	40	2.5	6.8		▲/Δ
R/L105.0200.4.7	2.0	4	6.4	3.7	7	25	40	2.5	6.8		▲/Δ
R/L105.0100.5.7	1.0	4	6.4	3.7	7	30	45	2.5	6.8		Δ/Δ
R/L105.0150.5.7	1.5	4	6.4	3.7	7	30	45	2.5	6.8		▲/Δ
R/L105.0200.5.7	2.0	4	6.4	3.7	7	30	45	2.5	6.8	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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号

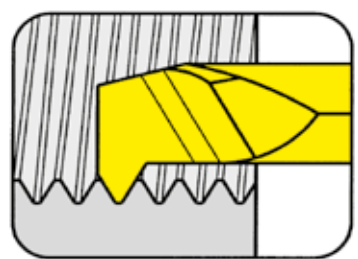
Carbide grades

螺纹切削 (内圆) -非全牙型 Threading (internal) Partial profile



刀片
Insert

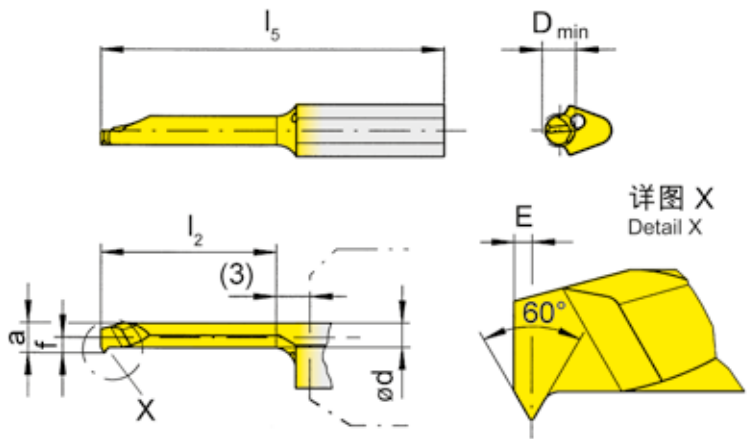
105



孔径Ø 自 螺距	Bore Ø from Pitch	3 mm P 0,25 mm
-------------	----------------------	-------------------

für Klemmhalter
for Toolholder

- 型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	b	l ₂	l ₅	D _{min}	EG35 Δ/Δ	TN35 ▲/▲
R/L105.0102.2.3	0.25	0.3	1.4	2.7	2.2	5.9	15	30	3		

- ▲ 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
按需提供更多尺寸
Further sizes upon request

P	•	•
M	•	•
K	o	•
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



刀片

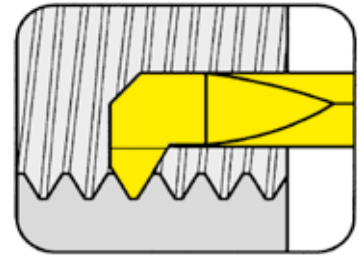
Insert

105

孔径Ø 自
螺距

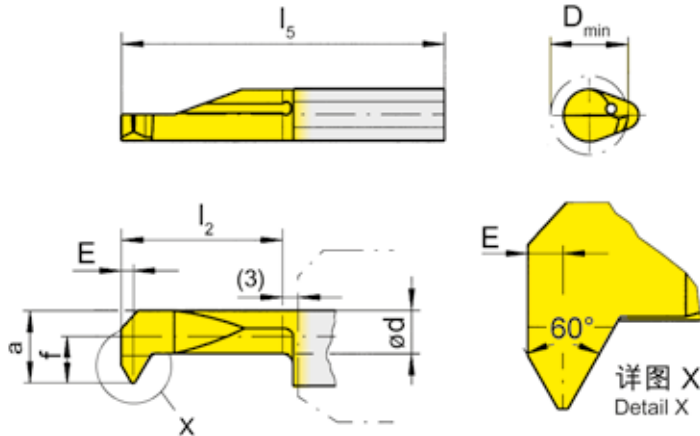
Bore Ø from
Pitch

3 mm
P 0,35 mm



für Klemmhalter
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	b	l_2	l_5	D_{min}		EG35	TN35
R/L105.0203.1.3	0.35	0.3	1.4	2.7	2.1	5.9	10	25	3		▲/Δ	▲/Δ
R/L105.0203.2.5	0.35	0.3	2.3	4.7	3.5	7.0	15	30	5		▲/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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



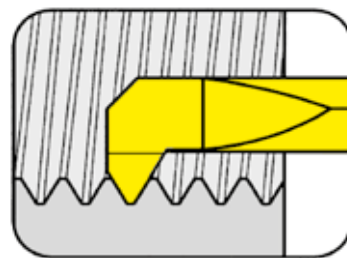
刀片
Insert

105

孔径Ø 自
螺距

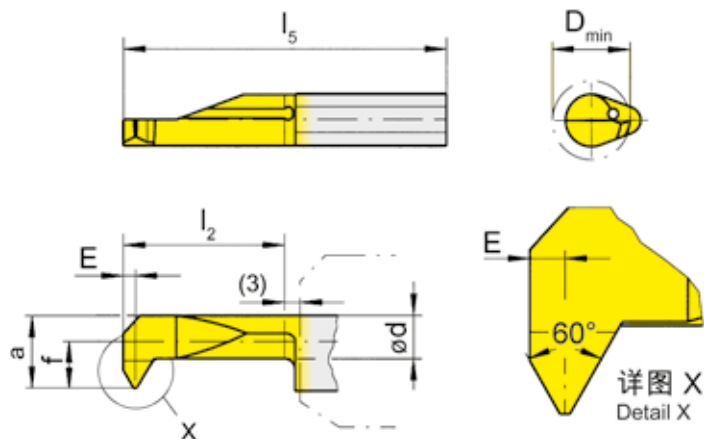
Bore Ø from
Pitch

3 mm
P 0,5 mm



für Klemmhalter
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	b	l_2	l_5	D_{min}		MG12	EG35	TH35	TN35
R/L/105.0205.2.3	0.5	0.35	1.4	2.7	2.1	5.9	15	30	3			▲/Δ		▲/▲
R/L/105.0205.2.4	0.5	0.35	1.9	3.7	2.7	6.4	15	30	4			▲/Δ	▲/Δ	▲/▲
R/L/105.0205.3.4	0.5	0.35	1.9	3.7	2.7	6.4	20	35	4			▲/Δ		▲/Δ
R/L/105.0205.2.5	0.5	0.35	2.3	4.7	3.5	7.0	15	30	5	▲/Δ	▲/Δ	▲/Δ		▲/▲
R/L/105.0205.3.5	0.5	0.35	2.3	4.7	3.5	7.0	20	35	5		Δ/Δ			▲/Δ
R/L/105.0205.4.5	0.5	0.35	2.3	4.7	3.5	7.0	25	40	5		Δ/Δ			▲/Δ
R/L/105.0205.3.6	0.5	0.35	3.3	5.7	4.8	7.0	20	35	6		▲/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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



刀片

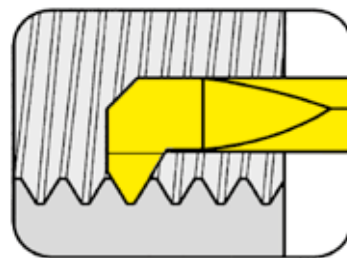
Insert

105

孔径Ø 自
螺距

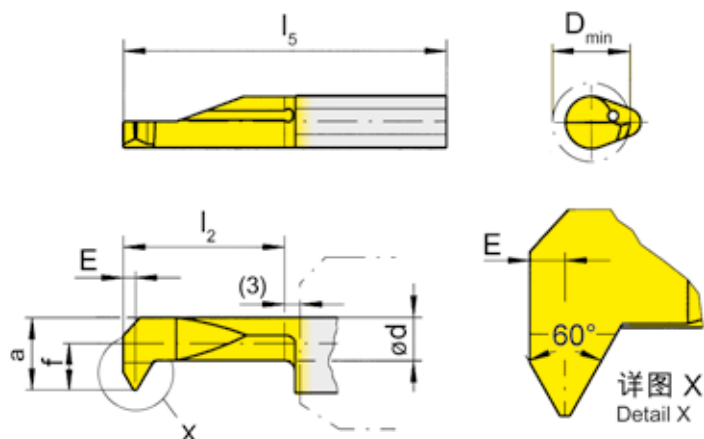
Bore Ø from
Pitch

3 mm
P 0,5-0,75 mm



für Klemmhalter
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	b	l ₂	l ₅	D _{min}	EG35	TH35	TN35
R/L105.0407.2.3	0.5	0.75	0.45	1.4	2.7	2.0	5.9	15	30	3	▲/Δ		▲/Δ
R/L105.0407.1.4	0.5	0.75	0.45	1.9	3.7	2.7	6.4	10	25	4	▲/Δ		▲/▲
R/L105.0407.2.4	0.5	0.75	0.45	1.9	3.7	2.7	6.4	15	30	4	▲/Δ		▲/▲
R/L105.0407.3.4	0.5	0.75	0.45	1.9	3.7	2.7	6.4	20	35	4	▲/Δ		▲/Δ
R/L105.0407.2.5	0.5	0.75	0.45	2.3	4.7	3.5	7.0	15	30	5	▲/▲	▲/▲	▲/▲
R/L105.0407.3.5	0.5	0.75	0.45	2.3	4.7	3.5	7.0	20	35	5	Δ/Δ		▲/Δ
R/L105.0407.4.5	0.5	0.75	0.45	2.3	4.7	3.5	7.0	25	40	5	▲/Δ		▲/Δ
R/L105.0407.3.6	0.5	0.75	0.45	3.3	5.7	4.7	7.0	20	35	6	▲/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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



A

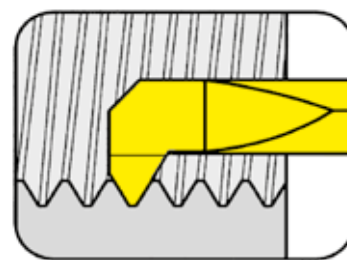
刀片
Insert

105

孔径Ø 自
螺距

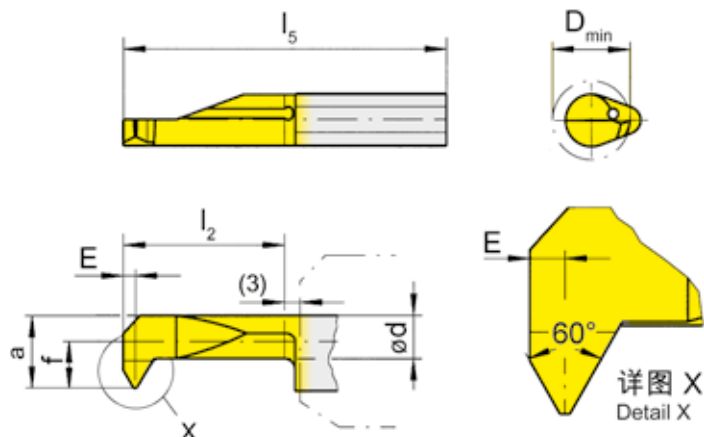
Bore Ø from
Pitch

4,8 mm
P 1-1,5 mm



für Klemmhalter
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	b	l ₂	l ₅	D _{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L/105.0510.2.5	1.00	1.00	0.55	2.1	4.5	3.5	7	15	30	4.8	▲/△	▲/▲		▲/▲	△/x	▲/▲
R/L/105.0510.3.5	1.00	1.00	0.55	2.1	4.5	3.5	7	20	35	4.8		▲/△				▲/▲
R/L/105.0510.4.5	1.00	1.00	0.55	2.1	4.5	3.5	7	25	40	4.8		▲/△				▲/▲
R/L/105.0510.2.6	1.00	1.00	0.55	3.3	5.7	3.7	7	15	30	6.0		▲/▲		▲/▲		▲/▲
R/L/105.0612.2.6	1.25	1.25	0.65	3.3	5.7	3.7	7	15	30	6.0	△/△	▲/▲		▲/▲		▲/▲
R/L/105.0612.3.6	1.25	1.25	0.65	3.3	5.7	3.7	7	20	35	6.0		▲/△				▲/▲
R/L/105.0612.4.6	1.25	1.25	0.65	3.3	5.7	3.7	7	25	40	6.0		▲/△				▲/▲
R/L/105.0815.2.7	1.50	1.50	0.75	4.0	6.4	3.7	7	15	30	7.0		▲/△	△/x	▲/▲		▲/▲
R/L/105.0815.3.7	1.50	1.50	0.75	4.0	6.4	3.7	7	20	35	7.0		▲/△				▲/▲
R/L/105.0815.4.7	1.50	1.50	0.75	4.0	6.4	3.7	7	25	40	7.0		▲/△				▲/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



刀片

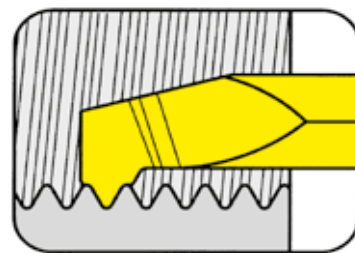
Insert

105

孔径Ø 自
螺距

Bore Ø from
Pitch

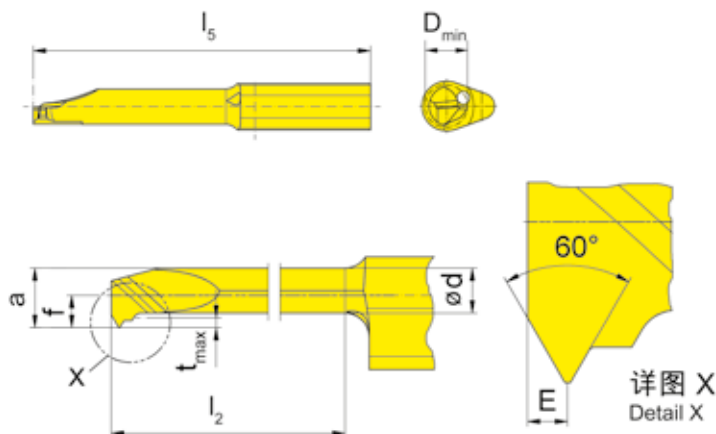
2,4 mm
P 0,5-1,25 mm



配合刀杆

for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	b	l_2	l_5	D_{min}	EG35	TH35
R/L/105.VPM3.2.3	0.50	0.3	1.4	2.2	1.65	5.9	9	25	2.4	▲/△	▲/▲
R/L/105.VPM3.4.3	0.50	0.3	1.4	2.2	1.65	5.9	16	35	2.4	▲/△	▲/△
R/L/105.VPM4.2.4	0.70	0.4	1.5	2.9	2.10	6.4	15	30	3.2	▲/△	▲/△
R/L/105.VPM4.3.4	0.70	0.4	1.5	2.9	2.10	6.4	20	35	3.2	▲/△	▲/△
R/L/105.VPM5.2.5	0.80	0.5	2.0	3.7	2.80	7.0	15	30	4.1	▲/△	▲/▲
R/L/105.VPM5.4.5	0.80	0.5	2.0	3.7	2.80	7.0	25	40	4.1	▲/△	▲/▲
R/L/105.VPM6.3.6	1.00	0.5	2.4	4.5	3.40	7.0	20	35	4.9	▲/▲	▲/▲
R/L/105.VPM6.4.6	1.00	0.5	2.4	4.5	3.40	7.0	25	40	4.9	▲/△	▲/△
R/L/105.VPM6.5.6	1.00	0.5	2.4	4.5	3.40	7.0	30	45	4.9	▲/△	▲/▲
R/L/105.VPM8.3.8	1.25	0.7	3.8	6.2	4.70	7.0	20	35	6.6	▲/△	▲/▲
R/L/105.VPM8.5.8	1.25	0.7	3.8	6.2	4.70	7.0	30	45	6.6	▲/△	▲/▲

▲ 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

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



刀片

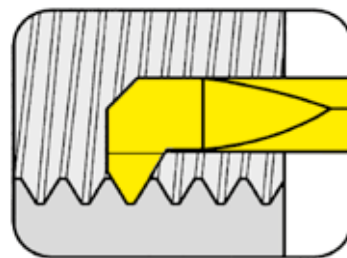
Insert

105

孔径Ø 自
每英寸牙数

Bore Ø from
Threads per inch

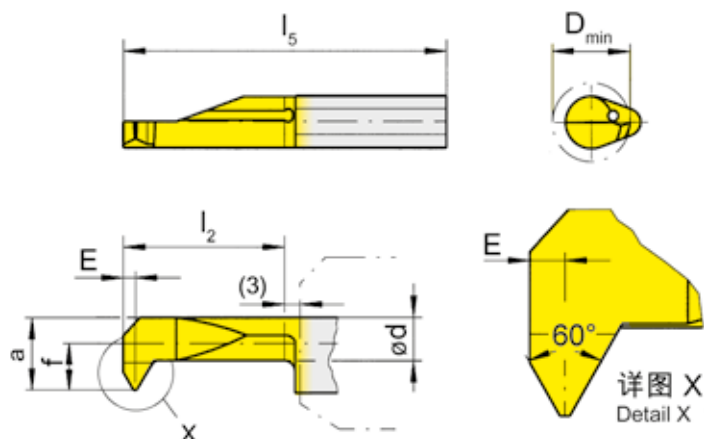
4 mm
16-40



配合刀杆

for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

UN螺纹
Thread UN

产品型号 Part number	TPI _{min}	TPI _{max}	E	f	a	d	b	l ₂	l ₅	D _{min}	MG12	EG35	TF45	TH35	TI25	TN35
R/L/105.3240.2.4	32	40	0.45	1.9	3.7	2.7	6.4	15	30	4		▲/Δ	x/x		Δ/x	▲/▲
R/L/105.1620.2.5	16	20	0.70	2.3	4.7	3.3	7.0	15	30	5		▲/Δ		▲/▲		
R/L/105.1620.3.5	16	20	0.70	2.3	4.7	3.3	7.0	20	35	5		Δ/Δ		▲/Δ		
R/L/105.2428.2.5	24	28	0.55	2.3	4.7	3.5	7.0	15	30	5		▲/Δ		x/x	Δ/x	▲/▲
R/L/105.3240.2.5	32	40	0.45	2.3	4.7	3.5	7.0	15	30	5		▲/Δ	Δ/x		Δ/x	▲/▲
R/L105.1620.2.6	16	20	0.70	3.3	5.7	3.7	7.0	15	30	6		▲/▲	Δ/x	Δ/x	Δ/x	▲/▲
R/L105.1620.3.6	16	20	0.70	3.3	5.7	3.7	7.0	20	35	6		▲/Δ				▲/Δ
R/L105.1620.4.6	16	20	0.70	3.3	5.7	3.7	7.0	25	40	6		▲/Δ				▲/Δ
R/L105.2428.2.6	24	28	0.55	3.3	5.7	3.7	7.0	15	30	6	Δ/x	▲/▲			Δ/x	▲/▲
R/L105.2428.3.6	24	28	0.55	3.3	5.7	3.7	7.0	20	35	6		▲/Δ				▲/Δ
R/L/105.2428.4.6	24	28	0.55	3.3	5.7	3.7	7.0	25	40	6		▲/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

按需提供更多尺寸

Further sizes upon request

	P	M	K	N	S	H
MG12	○	●	●	●	●	●
EG35	●	●	●	●	●	●
TF45	●	○	●	●	●	●
TH35	●	●	●	●	●	●
TI25	●	●	●	●	●	●
TN35	●	●	●	●	●	●

硬质合金牌号

Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



刀片

Insert

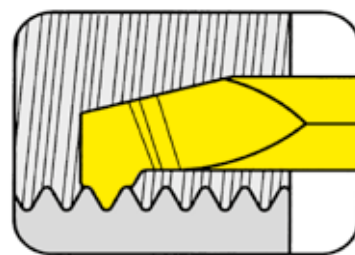
105

惠氏螺纹
Whitworth thread

孔径Ø 自
每英寸牙数

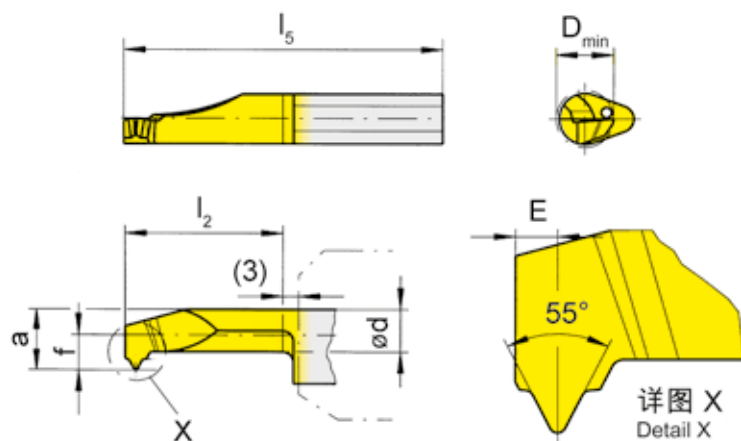
Bore Ø from
Threads per inch

4 mm
20-28



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

BSW/BSF螺纹
Thread BSW/BSF

产品型号 Part number	TPI	E	f	a	d	b	l_2	l_5	D_{min}	EG35	TN35
R/L105.5520.2.4	20	1.0	1.9	3.7	2.5	6.4	15	30	4	▲/x	▲/x
R/L105.5524.2.5	24	0.8	2.3	4.7	3.5	7.0	15	30	5	△/△	△/△
R/L105.5526.2.5	26	0.8	2.3	4.7	3.5	7.0	15	30	5	△/△	▲/△
R/L105.5528.2.5	28	0.8	2.3	4.7	3.5	7.0	15	30	5	▲/△	▲/△

▲ 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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



刀片

Insert

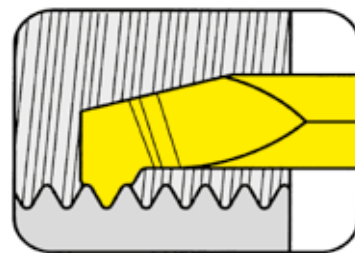
105

惠氏螺纹
Whitworth thread

孔径Ø 自
每英寸牙数

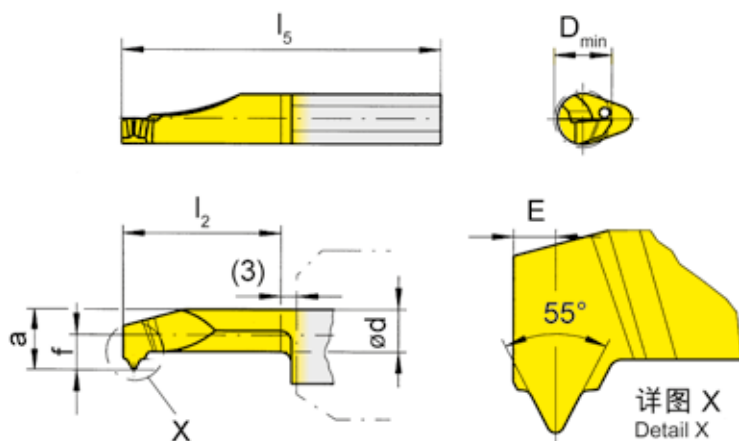
Bore Ø from
Threads per inch

6 mm
19-28



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

BSW/BSF螺纹
Thread BSW/BSF

产品型号 Part number	TPI	E	f	a	d	b	I ₂	I ₅	D _{min}	EG35	TH35	TN35
R/L105.5524.2.6	24	0.8	3.3	5.7	3.7	7	15	30	6	Δ/Δ		Δ/Δ
R/L105.5526.2.6	26	0.8	3.3	5.7	3.7	7	15	30	6	Δ/Δ		▲/Δ
R/L105.5528.2.6	28	0.8	3.3	5.7	3.7	7	15	30	6	▲/Δ		▲/Δ
R/L105.5519.2.6	19	1.0	3.3	5.7	3.7	7	15	30	6	▲/Δ	Δ/x	▲/▲
R/L105.5520.2.6	20	1.0	3.3	5.7	3.7	7	15	30	6	Δ/Δ		▲/Δ
R/L105.5522.2.6	22	1.0	3.3	5.7	3.7	7	15	30	6	Δ/Δ		Δ/Δ
R/L105.5524.3.6	24	0.8	3.3	5.7	3.7	7	20	35	6	Δ/x		Δ/x
R/L105.5526.3.6	26	0.8	3.3	5.7	3.7	7	20	35	6	Δ/x		Δ/x
R/L105.5528.3.6	28	0.8	3.3	5.7	3.7	7	20	35	6	▲/Δ		▲/Δ
R/L105.5519.3.6	19	1.0	3.3	5.7	3.7	7	20	35	6	▲/x		▲/x
R/L105.5522.3.6	22	1.0	3.3	5.7	3.7	7	20	35	6	Δ/x		Δ/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

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



刀片

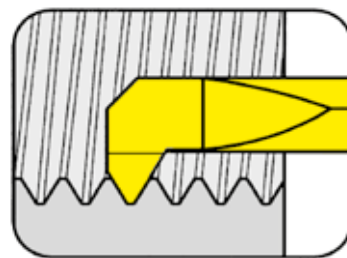
Insert

105

孔径Ø 自
每英寸牙数

Bore Ø from
Threads per inch

6 mm
18-27



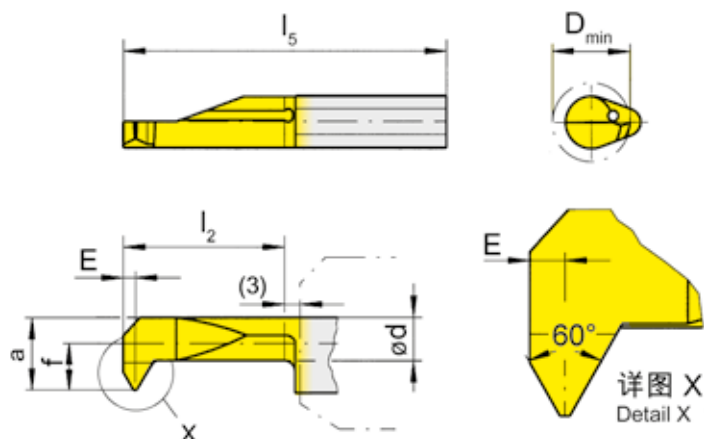
配合刀杆

for Toolholder

型号

Type

H105
HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

NPT / NPTF螺纹
Thread NPT / NPTF

产品型号 Part number	TPI	E	f	a	d	b	l_2	l_5	D_{min}	MG12	EG35	TH35	T125	TN35
R/L105.NP18.2.6	18	1.0	3.3	5.7	3.7	7	15	30	6	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/L105.NP18.3.6	18	1.0	3.3	5.7	3.7	7	20	35	6	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/L105.NP18.4.6	18	1.0	3.3	5.7	3.7	7	25	40	6	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/L105.NP27.2.6	27	0.8	3.3	5.7	3.7	7	15	30	6	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/L105.NP27.3.6	27	0.8	3.3	5.7	3.7	7	20	35	6	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ	Δ/Δ
R/L105.NP27.4.6	27	0.8	3.3	5.7	3.7	7	25	40	6	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

● 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

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

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

Pregrooving and Chamfering (internal)



刀片

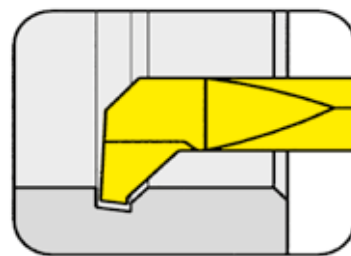
Insert

105

孔径 Ø 自

Bore Ø from

3 mm



配合刀杆

for Toolholder

型号

H105

Type

HC105

B105

VDI

B105C

B105TS

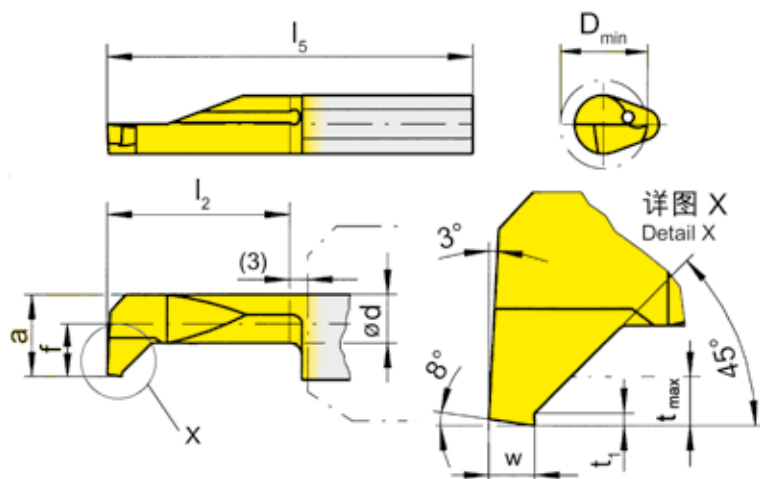
IR105

962

AIH

963

N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	f	a	d	b	l_2	l_5	t_{max}	t_1	D_{min}		MG12	EG35	TI25	TN35
R/L105.0810.1.3	0.7	1.4	2.7	2.0	5.9	10	25	0.5	0.2	3			▲/△		▲/▲
R/L105.0810.2.3	0.7	1.4	2.7	2.0	5.9	15	30	0.5	0.2	3			△/△		▲/▲
R/L105.0810.1.4	1.0	1.9	3.7	2.7	6.4	10	25	0.7	0.2	4			▲/△		▲/△
R/L105.0810.2.4	1.0	1.9	3.7	2.7	6.4	15	30	0.7	0.2	4			▲/△		▲/▲
R/L105.0810.3.4	1.0	1.9	3.7	2.7	6.4	20	35	0.7	0.2	4			△/△		▲/▲
R/L105.0810.2.5	1.0	2.3	4.7	3.5	7.0	15	30	0.7	0.2	5	▲/▲	▲/▲			▲/▲
R/L105.0810.3.5	1.0	2.3	4.7	3.5	7.0	20	35	0.7	0.2	5		▲/△	▲/▲		▲/▲
R/L105.0810.4.5	1.0	2.3	4.7	3.5	7.0	25	40	0.7	0.2	5		▲/△	▲/▲		▲/▲
R/L105.0810.5.5	1.0	2.3	4.7	3.5	7.0	30	45	0.7	0.2	5		△/△	▲/▲		▲/▲
R/L105.0810.5.6	1.0	3.1	5.5	4.2	7.0	30	45	1.0	0.2	6		▲/△			▲/▲
R/L105.0810.7.6	1.0	3.1	5.5	4.2	7.0	40	55	1.0	0.2	6		△/△			▲/△

▲ 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

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

硬质合金牌号

Carbide grades

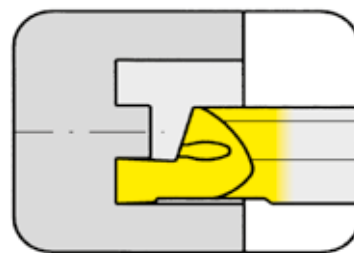
端面切槽

Face Grooving

刀片

Insert

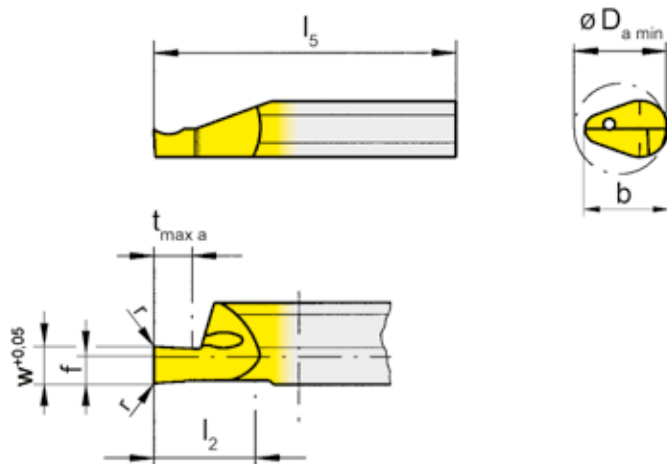
105



端面槽起始外径
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
B105C
B105TS
IR105
962
AIH
963
N

R=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	AN25	EG35	ES15	TI25
R105.0505.1.8	0.5	-	2	7	10	25	2	5		Δ	Δ	▲	
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

● 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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

端面切槽

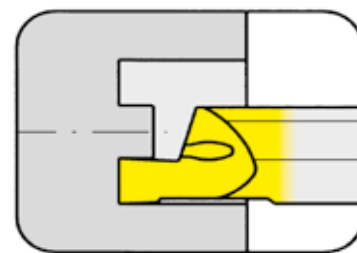
Face Grooving



刀片

Insert

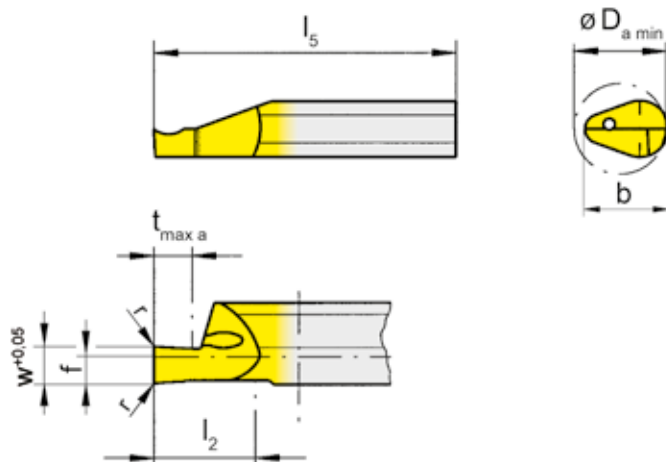
105



端面槽起始外径
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
B105C
B105TS
IR105
962
AIH
963
N

R=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		▲/△	▲/▲	▲/▲
										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

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

端面切槽

Face Grooving

刀片

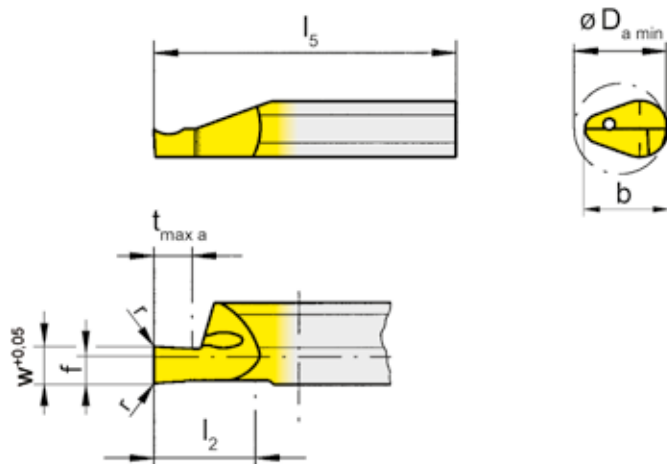
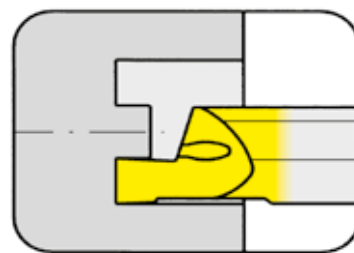
Insert

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

8 mm
6 mm
3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=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	T125
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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

端面切槽

Face Grooving

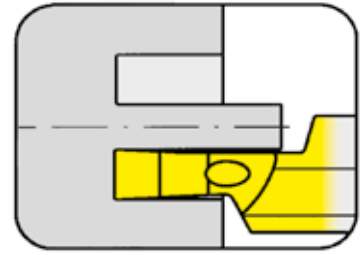


A

刀片

Insert

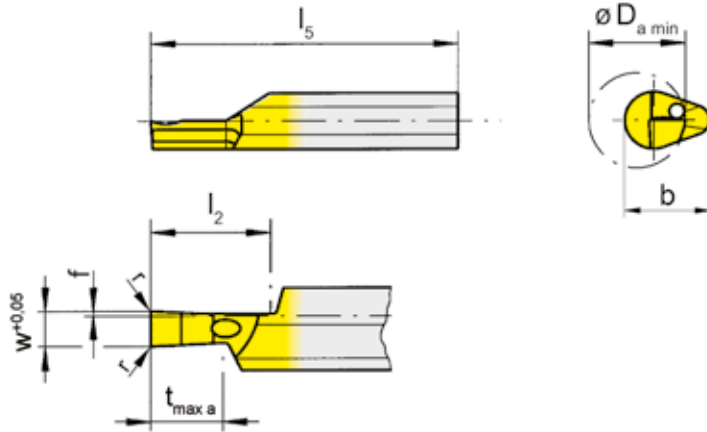
105



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

8 mm
6 mm
3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

R=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

● 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

P	•	•
M	•	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

端面切槽

Face Grooving

刀片

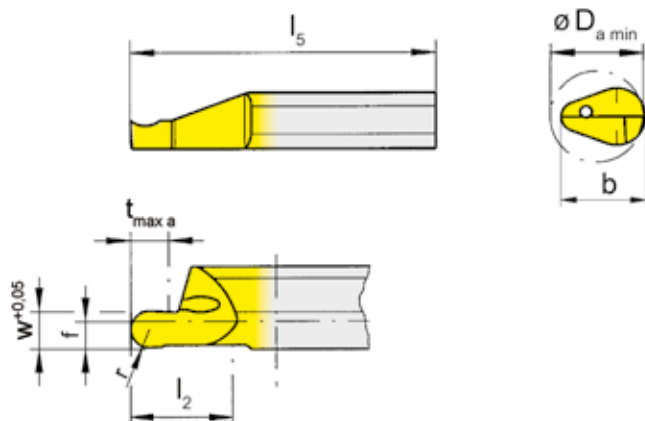
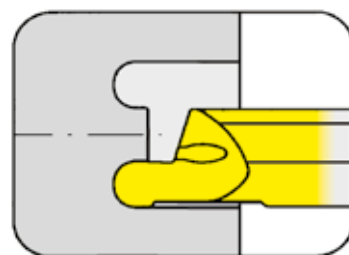
Insert

105

端面槽起始外径
槽深
槽宽可达

from outer groove $\varnothing$
Depth of groove
Width of groove up to

8 mm
6 mm
3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N

圆头
Full radius

R=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	T125
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	▲/▲	▲/▲
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	▲/▲	▲/▲
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	▲/▲	▲/▲
R/L105.8V30.2.8	3.0	1.50	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	•	•
K	•	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

倒角

Chamfering



刀片

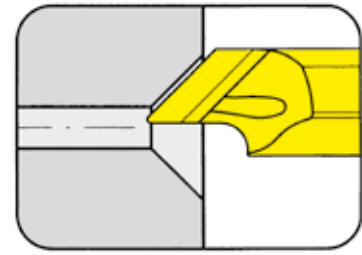
Insert

105

倒角角度
倒角宽度可达

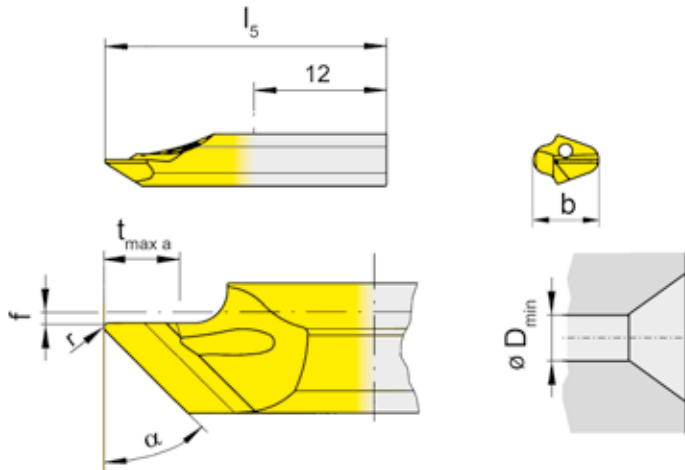
Angle of chamfer
Width of chamfer up to

45°/60°
4 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	b	l_5	$t_{\max a}$	$D_{\min}$	a	EG35	TF45	TI25	TN35
R/L105.0045.0.1	0.2	0.5	5.9	20	3.5	1	45°	▲/▲	▲/▲	Δ/Δ	▲/▲
R/L105.0045.1.1	0.2	0.5	5.9	25	3.5	1	45°	▲/▲	▲/▲	Δ/Δ	▲/▲
R/L105.0060.0.1	0.2	0.5	5.9	20	4.0	1	60°	▲/▲	▲/▲	Δ/Δ	▲/▲
R/L105.0060.1.1	0.2	0.5	5.9	25	4.0	1	60°	▲/▲	▲/▲	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

硬质合金牌号
Carbide grades

背镗 (内圆)

Backboring (internal)



刀片

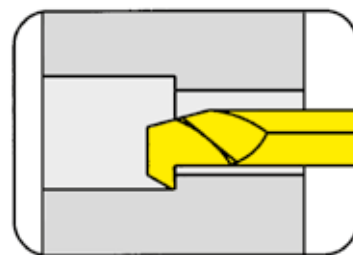
Insert

105

孔径Ø 自

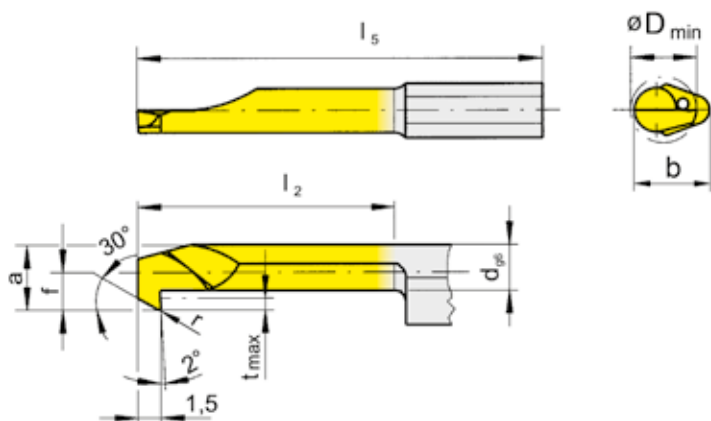
Bore Ø from

3 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	EG35	TH35	T125
R/L105.3013.2.3	0.10	1.3	2.6	1.9	5.9	15	30	0.5	3.0	▲/Δ	Δ/x	▲/▲
R/L105.3013.3.3	0.10	1.3	2.6	1.9	5.9	20	35	0.5	3.0	▲/Δ		▲/Δ
R/L105.3019.2.4	0.15	1.9	3.7	2.7	6.4	15	30	0.8	4.0	▲/Δ	x/x	▲/Δ
R/L105.3019.4.4	0.15	1.9	3.7	2.7	6.4	25	40	0.8	4.0	▲/Δ		▲/Δ
R/L105.3023.3.5	0.20	2.3	4.7	3.5	7.0	20	35	1.0	5.0	▲/▲		▲/▲
R/L105.3023.5.5	0.20	2.3	4.7	3.5	7.0	30	45	1.0	5.0	▲/Δ		▲/Δ
R/L105.3033.3.6	0.20	3.3	5.7	3.7	7.0	20	35	1.8	6.0	▲/Δ		▲/▲
R/L105.3033.5.6	0.20	3.3	5.7	3.7	7.0	30	45	1.8	6.0	▲/Δ		▲/Δ
R/L105.3040.3.7	0.20	4.0	6.4	3.7	7.0	20	35	2.5	6.8	▲/▲		▲/▲
R/L105.3040.5.7	0.20	4.0	6.4	3.7	7.0	30	45	2.5	6.8	▲/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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

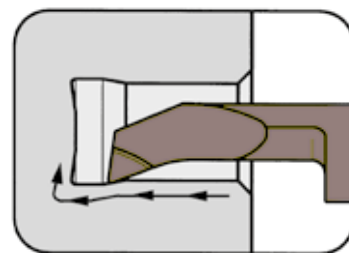
Insert

105

孔径Ø 自

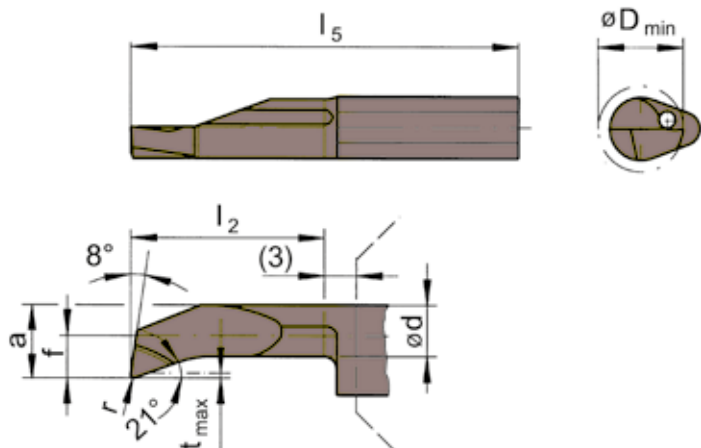
Bore Ø from

4 mm



配合刀杆
for Toolholder

型号 H105
Type HC105
B105
VDI
B105C
B105TS
IR105
962
AIH
963
N



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	HS36
R/L105.1819.01.1.4F	0.10	1.9	3.7	2.9	6.4	10	25	0.3	4	▲/▲
R/L105.1819.01.2.4F	0.10	1.9	3.7	2.9	6.4	15	30	0.3	4	▲/▲
R/L105.1823.15.2.5F	0.15	2.3	4.7	4.0	7.0	15	30	0.5	5	▲/▲
R/L105.1823.15.3.5F	0.15	2.3	4.7	4.0	7.0	20	35	0.5	5	▲/▲
▲ 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

硬质合金牌号
Carbide grades

刀杆

Toolholder

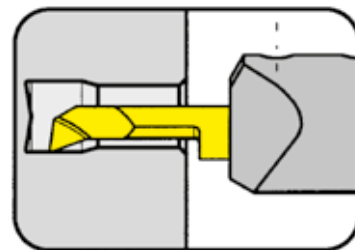
B105

直接冷却液供应
with through coolant supply

孔径Ø 自

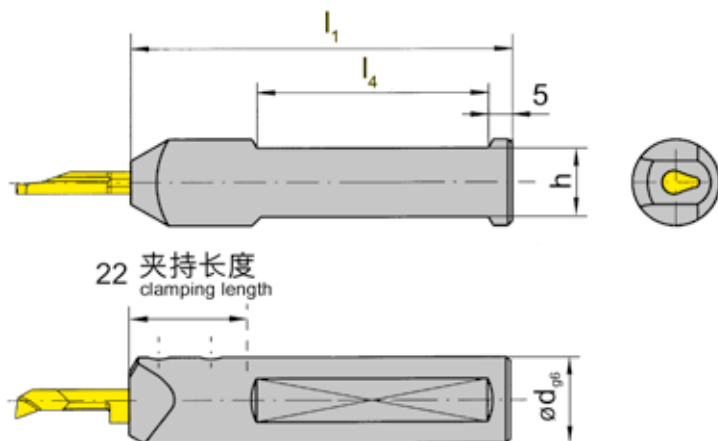
Bore Ø from

5 mm



配合刀片
for Insert

型号 105...2
Type



图示=右手型

Picture = right hand cutting version

仅适用于夹持加长型刀片
only usable for inserts with
extended clamping length

产品型号 Part number	d	l_1	h	l_4
B105.0012.02	12	85	11	50
B105.0016.02	16	85	14	50
B105.0020.02	20	100	18	55
B105.0022.02	22	100	20	55

按需提供更多尺寸
Further sizes upon request

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

切槽 (内圆)

Grooving (internal)



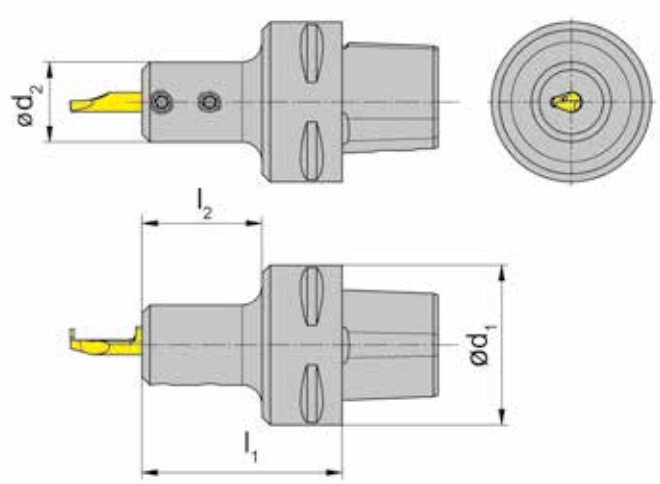
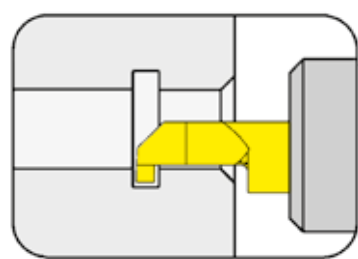
刀杆

Toolholder

B105C

直接冷却液供应
with through coolant supply

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



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...2
Type

仅适用于夹持加长型刀片
only usable for inserts with
extended clamping length

产品型号 Part number	d ₁	d ₂	l ₁	l ₂
R/LB105.00C4.20.1.02	40	20	50	20
R/LB105.00C6.20.1.02	63	20	52	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/LB105...	6.075T15P	T15PQ

刀片

Insert

105

夹持长度增长
with extended clamping length

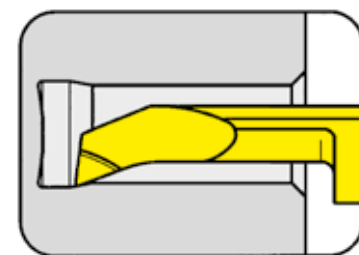
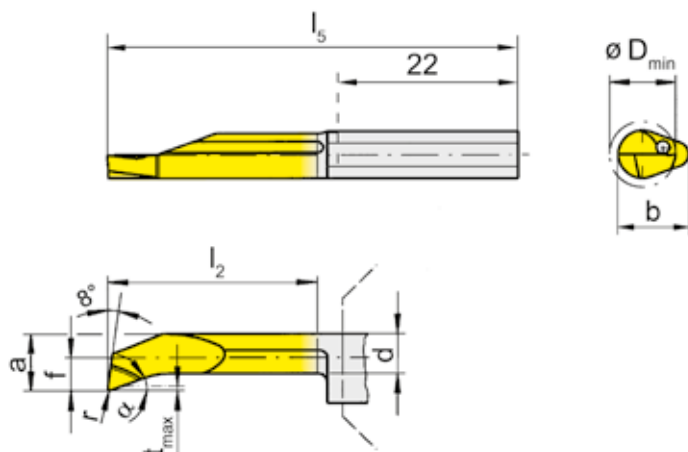
孔径 Ø 自

Bore Ø from

5 mm

夹持长度22mm

Clamping length 22 mm



配合刀杆

for Toolholder

型号 B105.0012.02
Type B105.0016.02
B105.0020.02
B105.0022.02
R/LB105.00C...02

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	b	l_2	l_5	t_{max}	D_{min}	α	EG35	TF45	TH35	TI25	TN35
R/L105.1823.4.5.2	0.1	2.3	4.7	4.2	7	25	50	0.3	5.0	20°	Δ/Δ		▲/▲	▲/▲	
R/L105.1823.5.5.2	0.1	2.3	4.7	4.2	7	30	55	0.3	5.0	20°	Δ/Δ		▲/▲	▲/Δ	
R/L105.1833.4.6.2	0.1	3.3	5.7	4.9	7	25	50	0.3	6.0	20°	Δ/Δ	x/x	▲/Δ	▲/Δ	
R/L105.1833.5.6.2	0.1	3.3	5.7	4.9	7	30	55	0.3	6.0	20°	Δ/Δ		▲/▲	▲/Δ	
R/L105.1840.4.7.2	0.1	4.0	6.4	5.4	7	25	50	0.3	6.8	20°	Δ/Δ		▲/▲	▲/▲	
R/L105.1840.5.7.2	0.1	4.0	6.4	5.4	7	30	55	0.3	6.8	20°	Δ/Δ		▲/Δ	▲/▲	Δ/x
R/L105.1840.7.7.2	0.1	4.0	6.4	5.4	7	40	65	0.3	6.8	20°	Δ/Δ			▲/Δ	
R/L105.4733.5.6.2	0.1	3.3	5.7	3.7	7	30	55	1.8	6.0	47°	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

硬质合金牌号

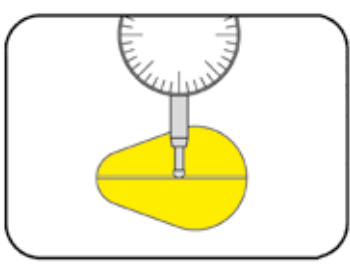
Carbide grades

调整
Set Up

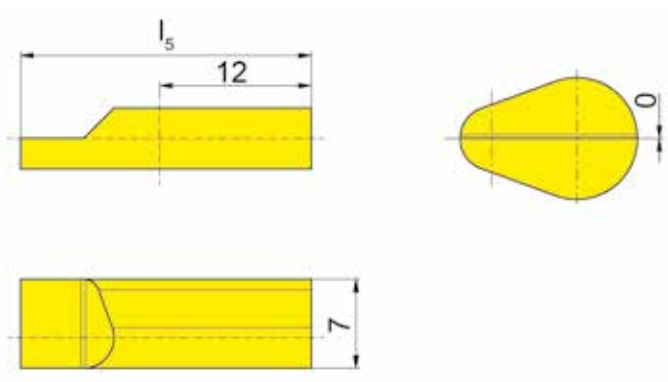


刀片
Insert

105



刀片用于刀杆的调整
Insert for tool set up



R=右手型-如图
R = right hand version shown

产品型号 Part number	l_5
R105.LEHR.H.01	23

尺寸单位 : mm
Dimensions in mm

刀杆

Toolholder

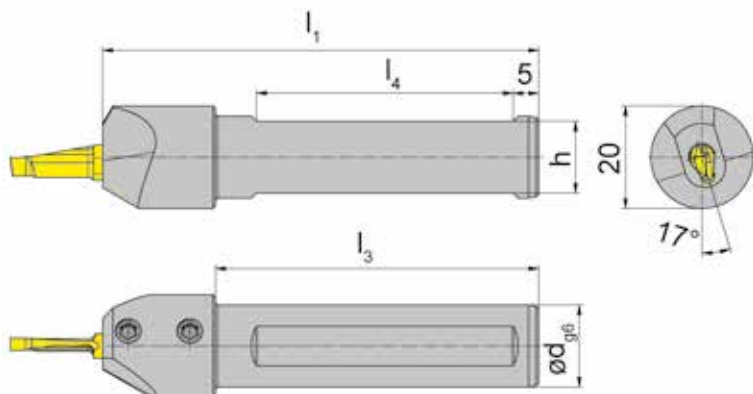
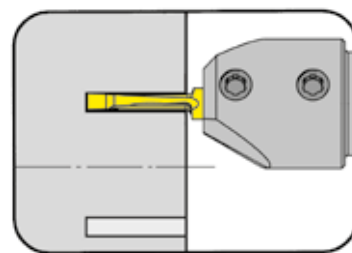
B105

直接冷却液供应
with through coolant supply

端面槽起始外径
槽深
槽宽

from outer groove Ø
Depth of groove
Width of groove

10 mm
15 mm
2-3 mm



配合刀片
for Insert

型号 A105
Type

仅适用于夹持加长型刀片
only usable for inserts with
extended clamping length

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

按需提供更多尺寸

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/LB105...	6.075T15P	T15PQ

端面切槽

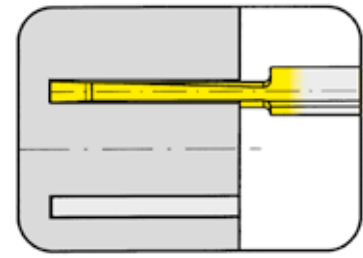
Face Grooving



刀片

Insert

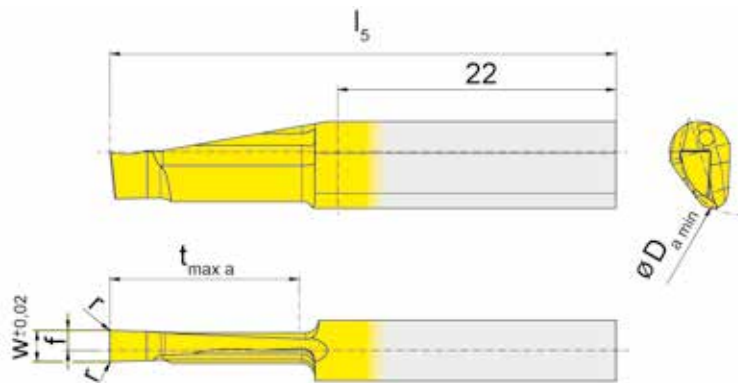
A105



端面槽起始外径
槽深
槽宽

from outer groove $\varnothing$
Depth of groove
Width of groove

10 mm
15 mm
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

○ 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

端面切槽

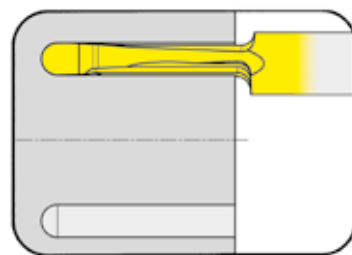
Face Grooving



刀片

Insert

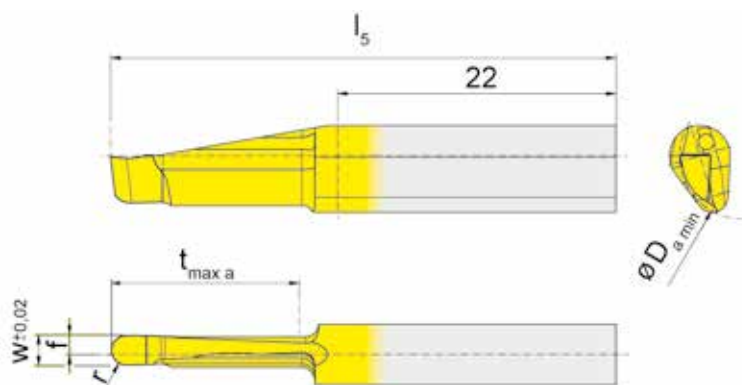
A105



端面槽起始外径
槽深
槽宽

from outer groove $\varnothing$
Depth of groove
Width of groove

10 mm
15 mm
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

圆头
Full radius

产品型号 Part number	w	r	f	l_5	$t_{\max a}$	$D_{a \min}$		EG35	Ti25
R/LA105.1020.10.2.2	2.0	1.00	1.4	40	15	10	▲/△	▲/▲	▲/▲
R/LA105.1025.12.2.2	2.5	1.25	1.6	40	15	10	△/△	▲/△	▲/△
R/LA105.1030.15.2.2	3.0	1.50	1.9	40	15	10	▲/△	▲/▲	▲/▲

▲ 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 :

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

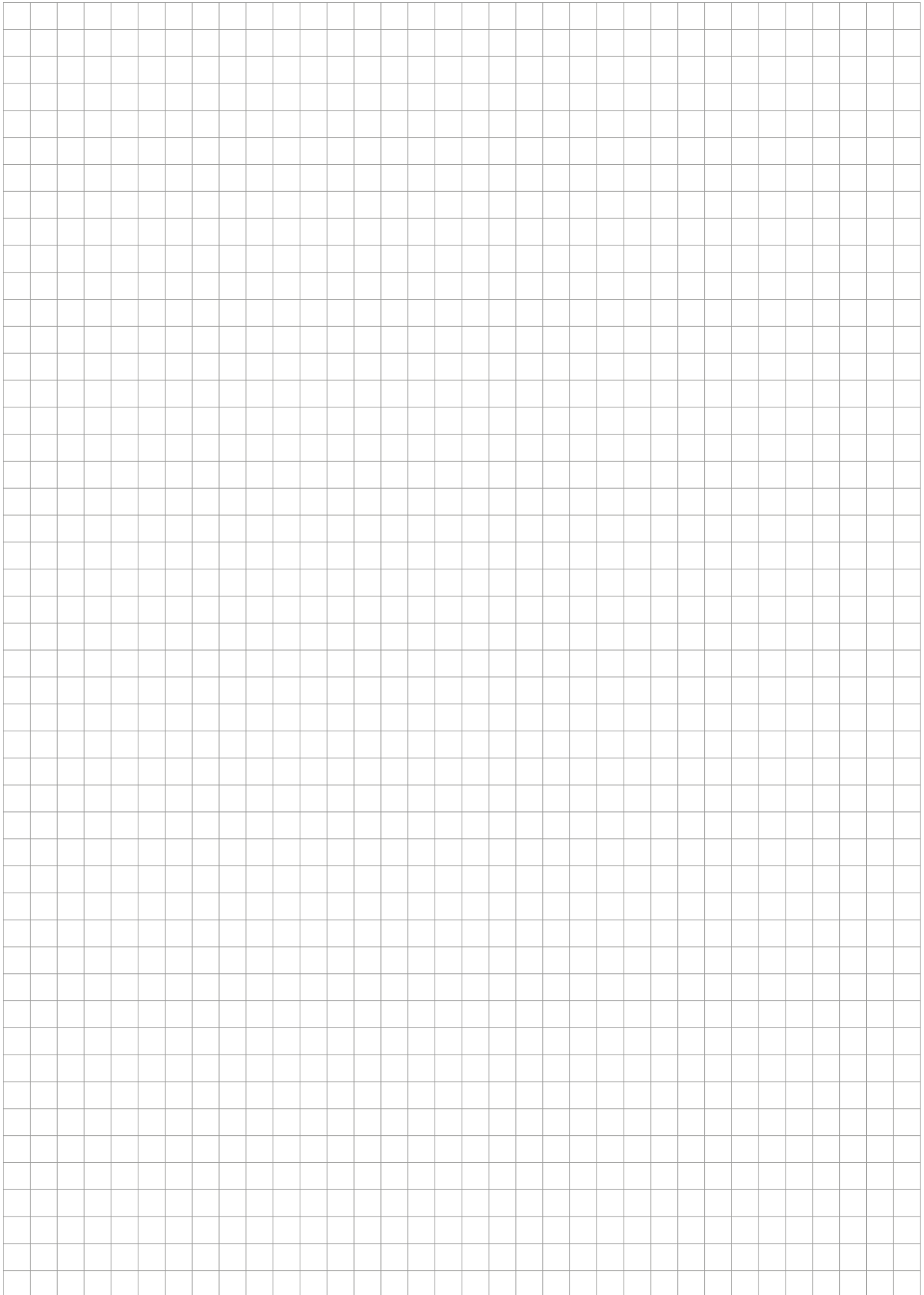
Face grooving with full width of the full depth only possible between $D_{a \min}$ 10 - 40 mm!

按需提供更多尺寸

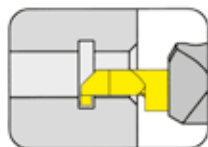
Further sizes upon request

硬质合金牌号
Carbide grades

P	•	•
M	•	•
K	○	•
N	-	•
S	-	•
H	-	-



刀杆
Toolholder
B109/B105

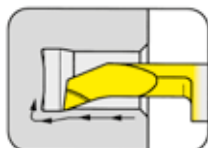


页/Page
A121-A123

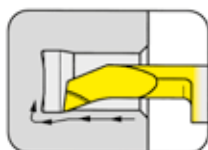


页/Page
A136

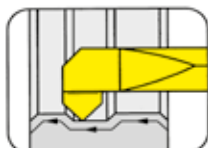
刀片
Insert
109/A109



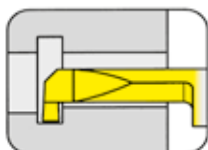
页/Page
A124-A125



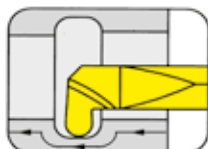
页/Page
A126-A127



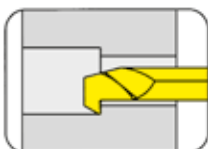
页/Page
A128



页/Page
A129-A130

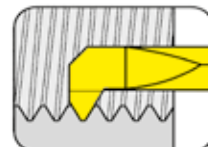


页/Page
A131

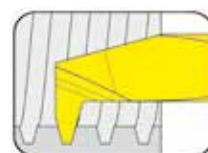


页/Page
A132

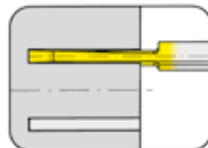
刀片
Insert
109/A109



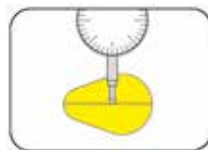
页/Page
A133



页/Page
A134



页/Page
A137



页/Page
A135

109



机夹式刀杆
槽宽1 - 2 mm

Toolholder with Inserts
Width of groove 1 - 2 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0,2	•											
≥ 0,5	•											
≥ 0,7	•											
≥ 1,0	•											
≥ 1,5	•											
≥ 2,0	•											
≥ 3,0	•											
≥ 4,0	•											
≥ 5,0	•											
≥ 6,0	•	•	•	•								
≥ 6,8		•	•	•								
≥ 7,0		•			•							
≥ 7,8			•		•	•						
≥ 8,0			•		•	•						
≥ 9,0			•		•	•	•					
≥ 10,0			•				•	•	•			
≥ 10,5									•			
≥ 11,0								•	•			
≥ 11,5									•			
≥ 13,8										•		
≥ 14,0										•	•	
≥ 16,0											•	
≥ 16,5										(•)		
≥ 18,0												•

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

槽宽 Width of groove	0,5-2,0	1,0-2,0	1,0-3,0	0,7-1,5	1,0-2,0	0,7-2,0	1,0-3,0	0,7-3,0	1,0-3,0	0,7-3,0	0,7-4,0	2,0-3,0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

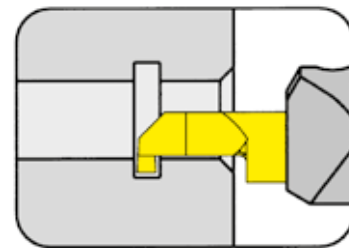
B109

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深可达
槽宽可达

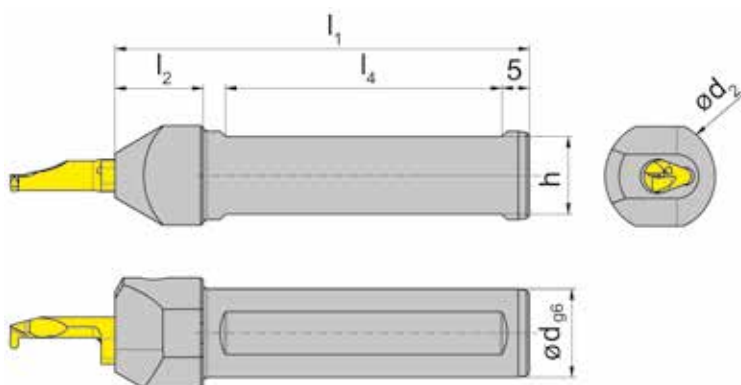
Bore Ø from
Depth of groove up to
Width of groove up to

6 mm
2,5 mm
2 mm



配合刀片
for Insert

型号 109
Type



图示=右手型

Picture = right hand cutting version

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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

刀杆可以安装左，右手刀片

Ordering note:

Toolholders can be used with right and left hand inserts.

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

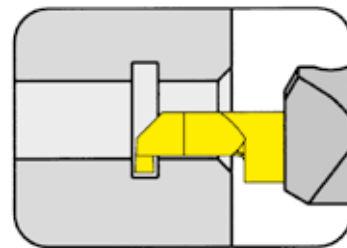
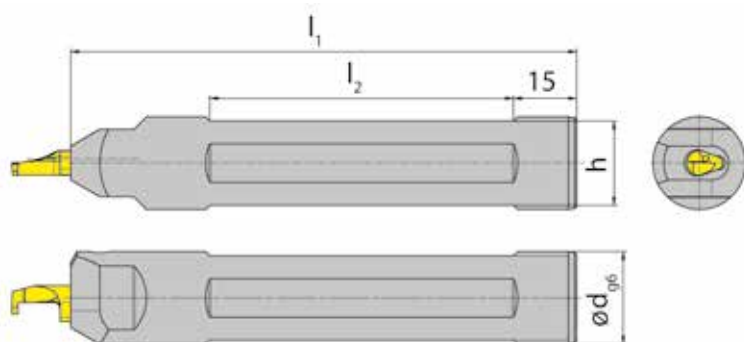
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B109...	6.075T15P	T15PQ

刀杆

Toolholder

B109

直接冷却液供应
with through coolant supply孔径Ø 自
槽深
槽宽可达Bore Ø from
Depth of groove
Width of groove up to6 mm
2,5 mm
2 mm配合刀片
for Insert型号 109
Type

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l ₁	h	l ₂
B109.0022.1.2.01	22	120	20	72

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
B109.0022.1.2.01	6.075T15P	T15PQ

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

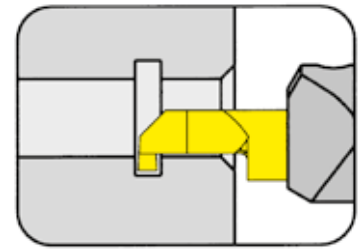
B105

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深
槽宽

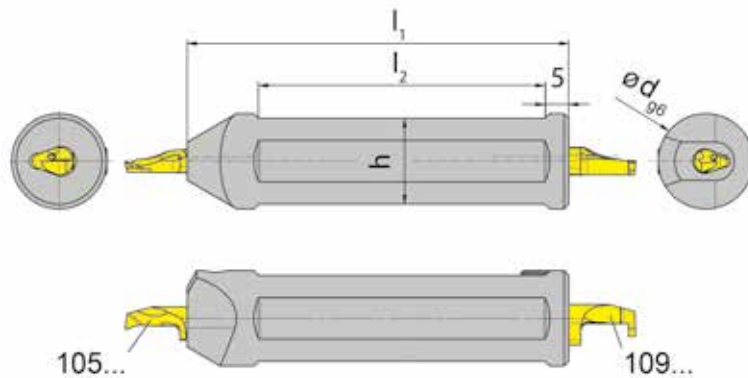
Bore Ø from
Depth of groove
Width of groove

0,2 / 6 mm
2,5 mm
2 mm



配合刀片
for Insert

型号 105
Type 109



图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	h	l_2
B105.0020.1.09	20	80	18	60

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
B105.0020.1.09	6.075T15P	T15PQ

刀片

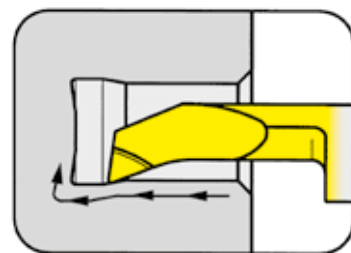
Insert

109

孔径Ø 自

Bore Ø from

6 mm



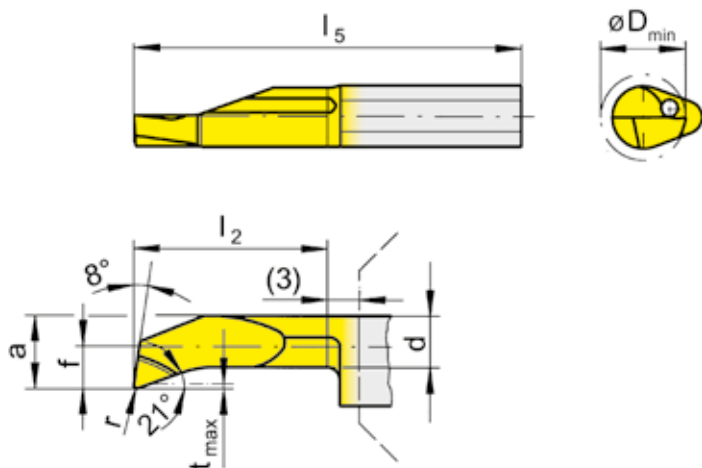
配合刀杆

for Toolholder

型号

B109

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.1828.1.6	0.2	2.8	5.7	5	10	28	0.4	6	△/△
R/L109.1828.2.6	0.2	2.8	5.7	5	15	33	0.4	6	△/△
R/L109.1828.3.6	0.2	2.8	5.7	5	20	38	0.4	6	▲/△
R/L109.1828.4.6	0.2	2.8	5.7	5	25	43	0.4	6	△/△
R/L109.1828.5.6	0.2	2.8	5.7	5	30	48	0.4	6	△/△
R/L109.1828.6.6	0.2	2.8	5.7	5	35	53	0.4	6	△/△
R/L109.1828.7.6	0.2	2.8	5.7	5	40	58	0.4	6	▲/△
R/L109.1838.2.7	0.2	3.8	6.7	6	15	33	0.4	7	△/△
R/L109.1838.3.7	0.2	3.8	6.7	6	20	38	0.4	7	△/△
R/L109.1838.4.7	0.2	3.8	6.7	6	25	43	0.4	7	△/△
R/L109.1838.5.7	0.2	3.8	6.7	6	30	48	0.4	7	▲/△
R/L109.1838.6.7	0.2	3.8	6.7	6	35	53	0.4	7	▲/△
R/L109.1838.7.7	0.2	3.8	6.7	6	40	58	0.4	7	▲/△
R/L109.1838.8.7	0.2	3.8	6.7	6	45	63	0.4	7	▲/△

▲ 库存 / on stock △ 4周 / 4 weeks × 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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号

Carbide grades

刀片

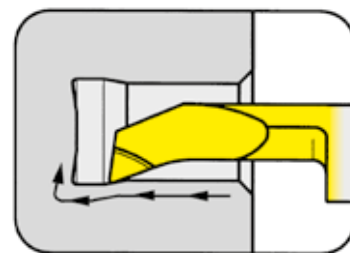
Insert

109

孔径Ø 自

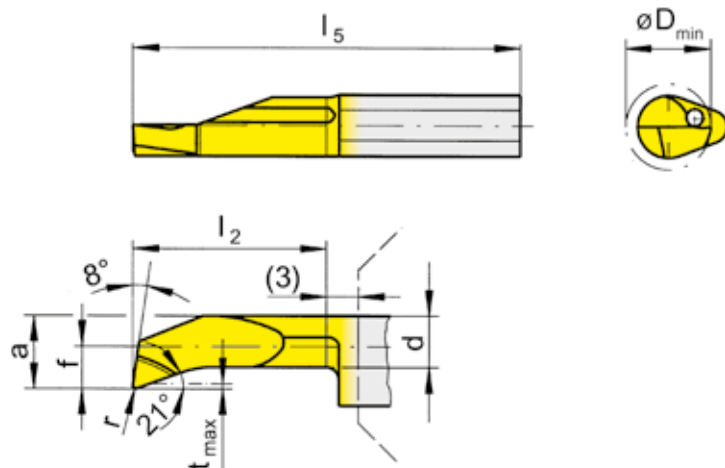
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 B109
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	l ₂	l ₅	t _{max}	D _{min}	TH35
R/L109.1828.04.1.6	0.4	2.8	5.7	5	10	28	0.4	6	△/△
R/L109.1828.04.2.6	0.4	2.8	5.7	5	15	33	0.4	6	△/△
R/L109.1828.04.3.6	0.4	2.8	5.7	5	20	38	0.4	6	△/△
R/L109.1828.04.4.6	0.4	2.8	5.7	5	25	43	0.4	6	△/△
R/L109.1828.04.5.6	0.4	2.8	5.7	5	30	48	0.4	6	△/△
R/L109.1828.04.6.6	0.4	2.8	5.7	5	35	53	0.4	6	△/△
R/L109.1828.04.7.6	0.4	2.8	5.7	5	40	58	0.4	6	△/△
R/L109.1838.04.2.7	0.4	3.8	6.7	6	15	33	0.4	7	△/△
R/L109.1838.04.3.7	0.4	3.8	6.7	6	20	38	0.4	7	△/△
R/L109.1838.04.4.7	0.4	3.8	6.7	6	25	43	0.4	7	△/△
R/L109.1838.04.5.7	0.4	3.8	6.7	6	30	48	0.4	7	△/△
R/L109.1838.04.6.7	0.4	3.8	6.7	6	35	53	0.4	7	△/△
R/L109.1838.04.7.7	0.4	3.8	6.7	6	40	58	0.4	7	▲/△
R/L109.1838.04.8.7	0.4	3.8	6.7	6	45	63	0.4	7	▲/△

▲ 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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号

Carbide grades

刀片

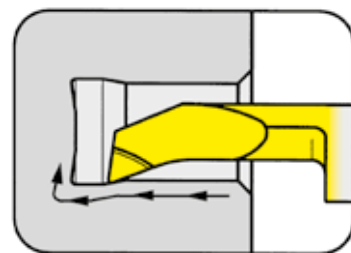
Insert

109

孔径Ø 自

Bore Ø from

6 mm



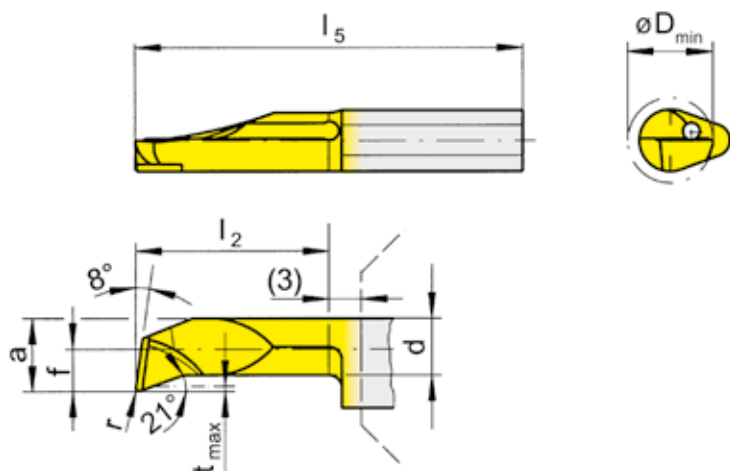
配合刀杆

for Toolholder

型号

B109

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

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

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.1828.1.HV6	0.2	2.8	5.7	5	10	28	0.4	6	△/△
R/L109.1828.2.HV6	0.2	2.8	5.7	5	15	33	0.4	6	△/△
R/L109.1828.3.HV6	0.2	2.8	5.7	5	20	38	0.4	6	△/△
R/L109.1828.4.HV6	0.2	2.8	5.7	5	25	43	0.4	6	△/△
R/L109.1828.5.HV6	0.2	2.8	5.7	5	30	48	0.4	6	▲/△
R/L109.1828.6.HV6	0.2	2.8	5.7	5	35	53	0.4	6	▲/△
R/L109.1828.7.HV6	0.2	2.8	5.7	5	40	58	0.4	6	▲/△
R/L109.1838.2.HV7	0.2	3.8	6.7	6	15	33	0.4	7	△/△
R/L109.1838.3.HV7	0.2	3.8	6.7	6	20	38	0.4	7	△/△
R/L109.1838.4.HV7	0.2	3.8	6.7	6	25	43	0.4	7	△/△
R/L109.1838.5.HV7	0.2	3.8	6.7	6	30	48	0.4	7	△/△
R/L109.1838.6.HV7	0.2	3.8	6.7	6	35	53	0.4	7	△/△
R/L109.1838.7.HV7	0.2	3.8	6.7	6	40	58	0.4	7	△/△
R/L109.1838.8.HV7	0.2	3.8	6.7	6	45	63	0.4	7	△/△

▲ 库存 / on stock △ 4周 / 4 weeks × 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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号

Carbide grades

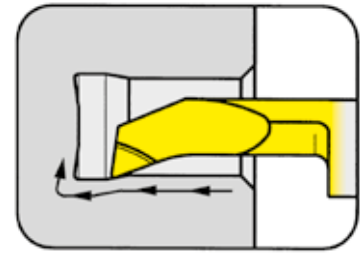
刀片 Insert

109

孔径Ø 自

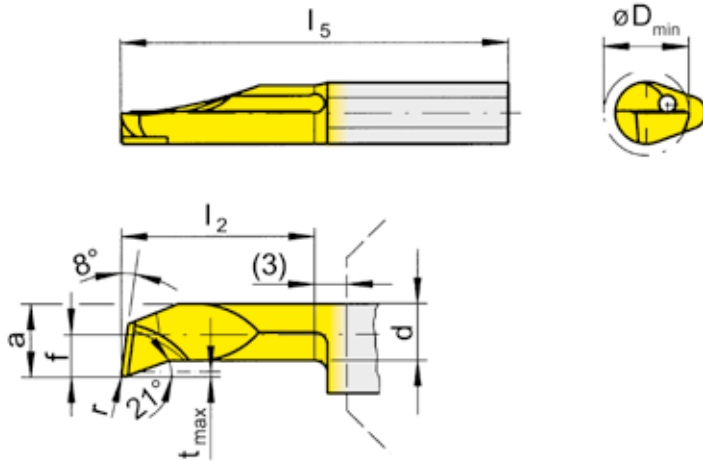
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 B109
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.1828.04.1.HV6	0.4	2.8	5.7	5	10	28	0.4	6	△/△
R/L109.1828.04.2.HV6	0.4	2.8	5.7	5	15	33	0.4	6	△/△
R/L109.1828.04.3.HV6	0.4	2.8	5.7	5	20	38	0.4	6	△/△
R/L109.1828.04.4.HV6	0.4	2.8	5.7	5	25	43	0.4	6	△/△
R/L109.1828.04.5.HV6	0.4	2.8	5.7	5	30	48	0.4	6	△/△
R/L109.1828.04.6.HV6	0.4	2.8	5.7	5	35	53	0.4	6	△/△
R/L109.1828.04.7.HV6	0.4	2.8	5.7	5	40	58	0.4	6	△/△
R/L109.1838.04.2.HV7	0.4	3.8	6.7	6	15	33	0.4	7	△/△
R/L109.1838.04.3.HV7	0.4	3.8	6.7	6	20	38	0.4	7	△/△
R/L109.1838.04.4.HV7	0.4	3.8	6.7	6	25	43	0.4	7	△/△
R/L109.1838.04.5.HV7	0.4	3.8	6.7	6	30	48	0.4	7	△/△
R/L109.1838.04.6.HV7	0.4	3.8	6.7	6	35	53	0.4	7	△/△
R/L109.1838.04.7.HV7	0.4	3.8	6.7	6	40	58	0.4	7	△/△
R/L109.1838.04.8.HV7	0.4	3.8	6.7	6	45	63	0.4	7	▲/△

▲ 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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

刀片

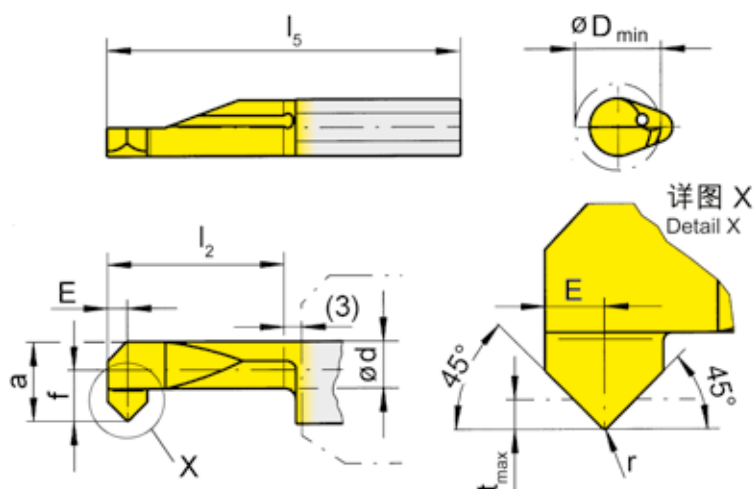
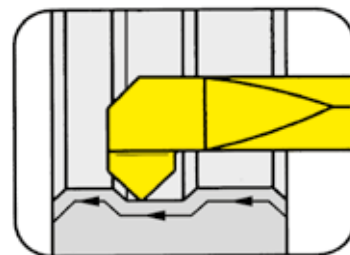
Insert

109

孔径Ø 自

Bore Ø from

6 mm



配合刀杆

for Toolholder

型号

B109

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	E	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.4545.3.6	0.2	2.8	1.2	5.7	4.3	20	38	0.9	6	Δ/Δ
R/L109.4545.5.7	0.2	3.8	1.2	6.7	5.3	30	48	0.9	7	▲/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

按需提供更多尺寸

Further sizes upon request

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号

Carbide grades

切槽 (内圆)

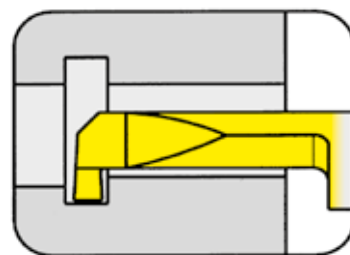
Grooving (internal)



刀片

Insert

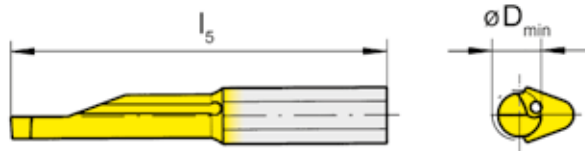
109



孔径Ø 自
槽深可达

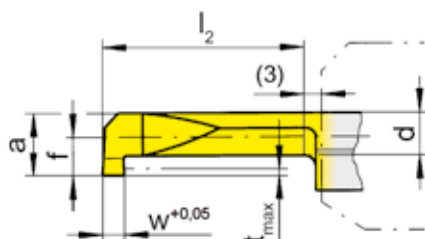
Bore Ø from
Depth of groove up to

6 mm
1.8 mm



配合刀杆
for Toolholder

型号 B109
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.0100.1.6	1.0	2.8	5.7	3.7	10	28	1.8	6	△/△
R/109.0150.1.6	1.5	2.8	5.7	3.7	10	28	1.8	6	△/△
R/L109.0200.1.6	2.0	2.8	5.7	3.7	10	28	1.8	6	△/△
R/L109.0100.2.6	1.0	2.8	5.7	3.7	15	33	1.8	6	△/△
R/L109.0150.2.6	1.5	2.8	5.7	3.7	15	33	1.8	6	△/△
R/L109.0200.2.6	2.0	2.8	5.7	3.7	15	33	1.8	6	△/△
R/L109.0100.3.6	1.0	2.8	5.7	3.7	20	38	1.8	6	△/△
R/L109.0150.3.6	1.5	2.8	5.7	3.7	20	38	1.8	6	△/△
R/L109.0200.3.6	2.0	2.8	5.7	3.7	20	38	1.8	6	△/△
R/L109.0100.4.6	1.0	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0150.4.6	1.5	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0200.4.6	2.0	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0100.5.6	1.0	2.8	5.7	3.7	30	48	1.8	6	△/△
R/L109.0150.5.6	1.5	2.8	5.7	3.7	30	48	1.8	6	△/△
R/L109.0200.5.6	2.0	2.8	5.7	3.7	30	48	1.8	6	△/△
R/L109.0100.6.6	1.0	2.8	5.7	3.7	35	53	1.8	6	△/△
R/L109.0150.6.6	1.5	2.8	5.7	3.7	35	53	1.8	6	△/△
R/L109.0200.6.6	2.0	2.8	5.7	3.7	35	53	1.8	6	▲/△

▲ 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

按需提供更多尺寸

Further sizes upon request

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

P	•
M	•
K	•
N	•
S	•
H	-

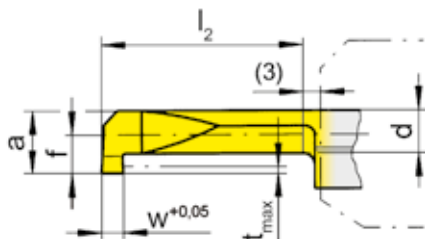
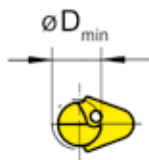
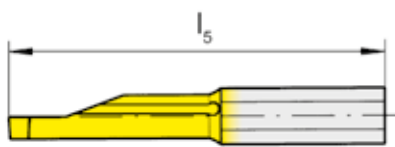
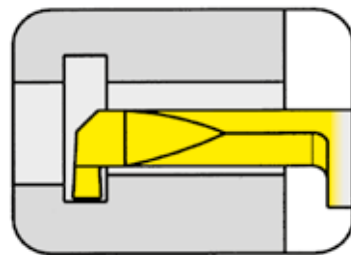
切槽 (内圆)

Grooving (internal)

刀片

Insert

109

孔径Ø 自
槽深可达Bore Ø from
Depth of groove up to7 mm
2.5 mm

配合刀杆

for Toolholder

型号 B109

Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.0100.1.7	1.0	3.8	6.7	4	10	28	2.5	7	△/△
R/L109.0150.1.7	1.5	3.8	6.7	4	10	28	2.5	7	△/△
R/L109.0200.1.7	2.0	3.8	6.7	4	10	28	2.5	7	▲/△
R/L109.0100.2.7	1.0	3.8	6.7	4	15	33	2.5	7	△/△
R/L109.0150.2.7	1.5	3.8	6.7	4	15	33	2.5	7	▲/△
R/L109.0200.2.7	2.0	3.8	6.7	4	15	33	2.5	7	▲/△
R/L109.0100.3.7	1.0	3.8	6.7	4	20	38	2.5	7	△/△
R/L109.0150.3.7	1.5	3.8	6.7	4	20	38	2.5	7	△/△
R/L109.0200.3.7	2.0	3.8	6.7	4	20	38	2.5	7	△/△
R/L109.0100.4.7	1.0	3.8	6.7	4	25	43	2.5	7	△/△
R/L109.0200.4.7	2.0	3.8	6.7	4	25	43	2.5	7	△/△
R/L109.0150.4.7	1.5	3.8	6.7	4	25	43	2.5	7	△/△
R/L109.0100.5.7	1.0	3.8	6.7	4	30	48	2.5	7	△/▲
R/L109.0150.5.7	1.5	3.8	6.7	4	30	48	2.5	7	△/△
R/L109.0200.5.7	2.0	3.8	6.7	4	30	48	2.5	7	▲/△
R/L109.0100.6.7	1.0	3.8	6.7	4	35	53	2.5	7	△/△
R/L109.0150.6.7	1.5	3.8	6.7	4	35	53	2.5	7	△/△
R/L109.0200.6.7	2.0	3.8	6.7	4	35	53	2.5	7	▲/△

▲ 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

按需提供更多尺寸

Further sizes upon request

注明R或L型

State R or L version

硬质合金牌号

Carbide grades

P	•
M	•
K	•
N	•
S	•
H	-

切槽 (内圆)

Grooving (internal)



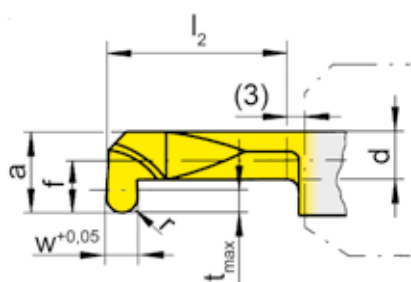
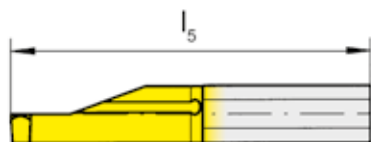
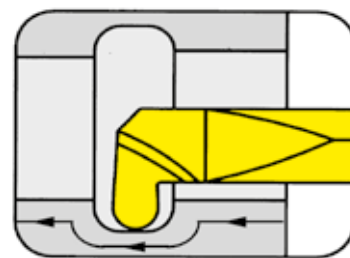
刀片
Insert

109

孔径Ø 自
圆头

Bore Ø from
Full radius

6 mm
0.5-1 mm



配合刀杆
for Toolholder

型号 B109
Type

圆头
Full radius

R=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	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.0005.4.6	1.0	0.50	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0007.4.6	1.5	0.75	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0010.4.6	2.0	1.00	2.8	5.7	3.7	25	43	1.8	6	△/△
R/L109.0005.6.7	1.0	0.50	3.8	6.7	4.0	35	53	2.5	7	△/△
R/L109.0007.6.7	1.5	0.75	3.8	6.7	4.0	35	53	2.5	7	△/△
R/L109.0010.6.7	2.0	1.00	3.8	6.7	4.0	35	53	2.5	7	▲/△

▲ 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

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

背镗 (内圆)

Backboring (internal)

刀片

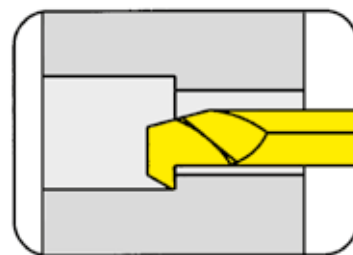
Insert

109

孔径Ø 自

Bore Ø from

6 mm



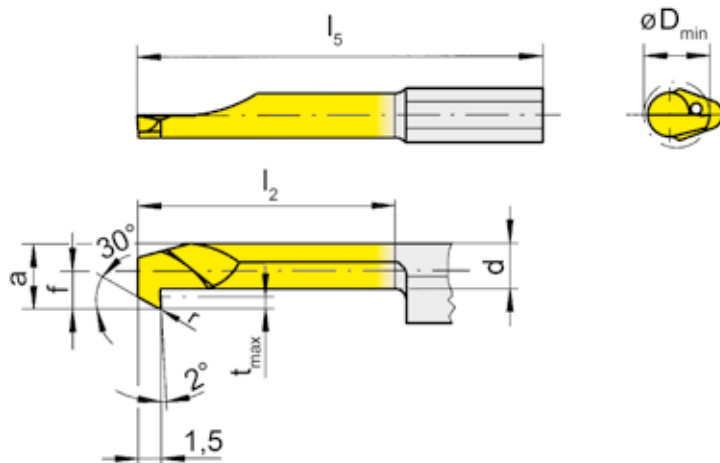
配合刀杆

for Toolholder

型号

B109

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	TH35
R/L109.3028.3.6	0.2	2.8	5.7	3.7	20	38	1.8	6	Δ/Δ
R/L109.3028.5.6	0.2	2.8	5.7	3.7	30	48	1.8	6	Δ/Δ
R/L109.3038.3.7	0.2	3.8	6.7	4.0	20	38	2.5	7	▲/Δ
R/L109.3038.5.7	0.2	3.8	6.7	4.0	30	48	2.5	7	▲/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

按需提供更多尺寸

Further sizes upon request

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号

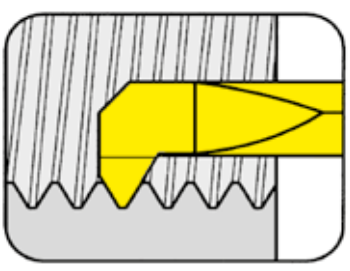
Carbide grades

螺纹切削 (内圆) -非全牙型 Threading (internal) Partial profile



刀片
Insert

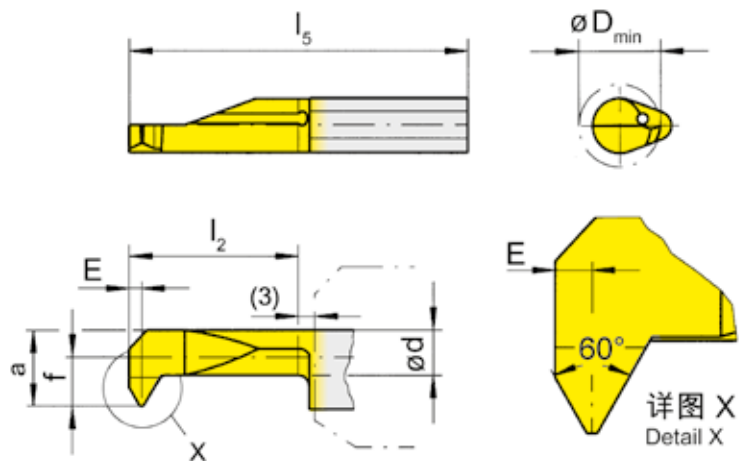
109



孔径Ø 自 螺距	Bore Ø from Pitch	7 mm 1.5-1.75 mm
-------------	----------------------	---------------------

配合刀杆
for Toolholder

型号 B109
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	l ₂	l ₅	D _{min}	TH35
R/L109.0815.1.7	1.5	1.75	0.9	3.8	6.7	5.1	10	28	7	Δ/Δ
R/L109.0815.3.7	1.5	1.75	0.9	3.8	6.7	5.1	20	38	7	▲/Δ
R/L109.0815.5.7	1.5	1.75	0.9	3.8	6.7	5.1	30	48	7	▲/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
按需提供更多尺寸
Further sizes upon request

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

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



刀片

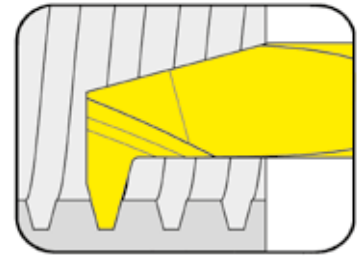
Insert

109

孔径Ø 自
螺距

Bore Ø from
Pitch

6 mm
1.5-3 mm



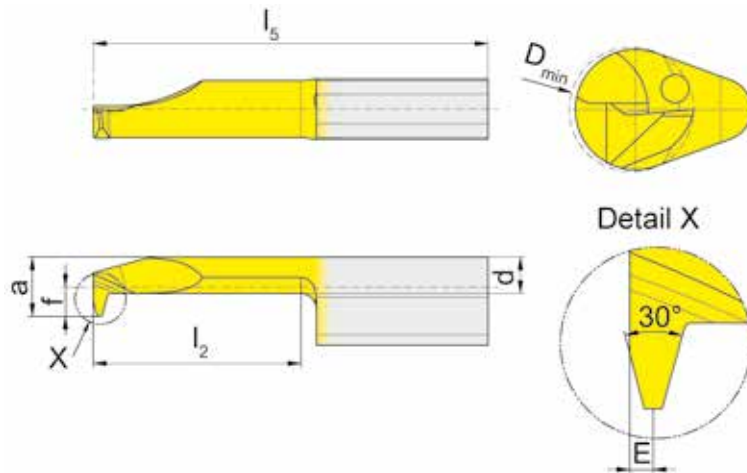
配合刀杆

for Toolholder

型号

B109

Type



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

R=右手型-如图

R = right hand version shown

产品型号 Part number	P	E	f	a	d	l_2	l_5	D_{min}	TH35
R109.0915.3.6	1.5	0.6	2.8	5.7	3.5	20	38	6	▲
R109.1220.3.6	2.0	0.8	2.8	5.7	3.5	20	38	6	▲
R109.1220.3.7	2.0	0.8	3.8	6.7	4.8	20	38	7	▲
R109.1220.5.7	2.0	0.8	3.8	6.7	4.8	30	48	7	▲
R109.1730.3.7	3.0	1.2	3.8	6.7	4.3	20	38	7	▲

▲ 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

按需提供更多尺寸

Further sizes upon request

P	•
M	•
K	•
N	•
S	•
H	-

硬质合金牌号
Carbide grades

调整

Set Up

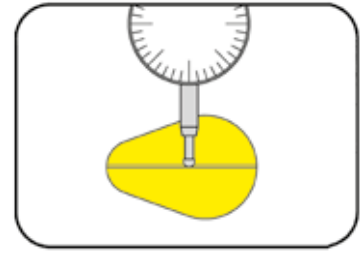


刀片

Insert

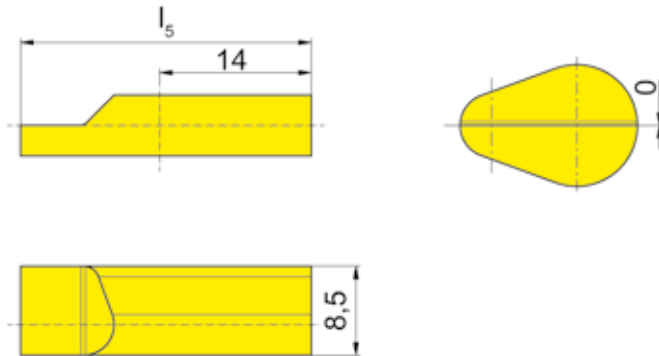
109

刀片用于刀杆的调整
Insert for tool set up



配合刀杆
for Toolholder

型号 B109
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_5
L109.LEHR.H.01 MG12	28

尺寸单位 : mm
Dimensions in mm

端面切槽

Face Grooving



刀杆

Toolholder

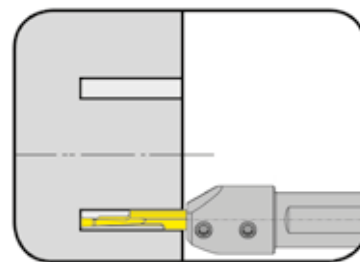
B109

直接冷却液供应
with through coolant supply

端面槽起始外径
槽深
槽宽

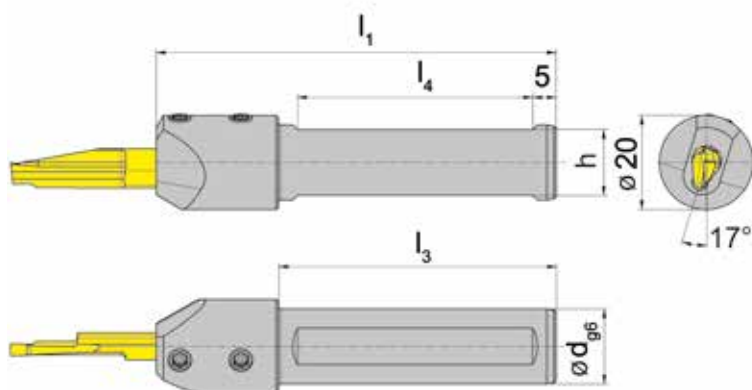
from outer groove $\varnothing$
Depth of groove
Width of groove

15 mm
20 mm
2-3 mm



配合刀片
for Insert

型号 A109
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

仅适用于夹持加长型刀片
only usable for inserts with
extended clamping length

产品型号 Part number	d	l_1	l_3	h	l_4
R/LB109.0016.14.2	16	85	59	14	50

注明R或L型

State R or L version

按需提供更多尺寸

Further sizes upon request

螺钉6.075T25P的扭矩规格=5Nm。

Torque specification of the screw 6.075T25P = 5 Nm.

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/LB109.0016.14.2	6.075T15P	T15PQ

端面切槽

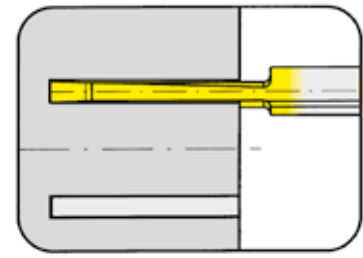
Face Grooving



刀片

Insert

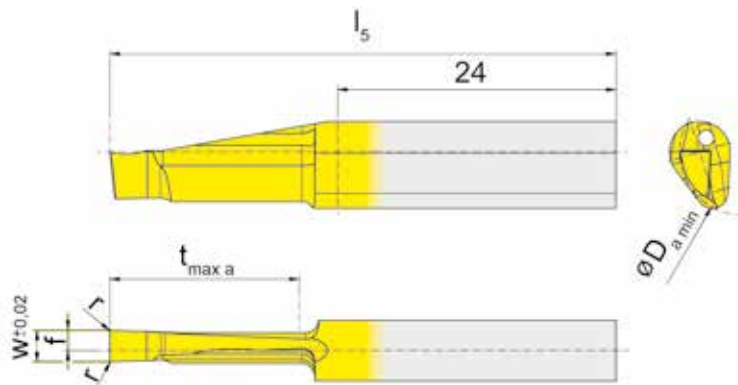
A109



端面槽起始外径
槽深
槽宽

from outer groove $\varnothing$
Depth of groove
Width of groove

15 mm
20 mm
2-3 mm



配合刀杆
for Toolholder

型号 B109
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_s	$t_{\max a}$	$D_{a \min}$	Ti25
R/LA109.1520.3.2	2.0	0.1	1.0	48	20	15	▲/△
R/LA109.1525.3.2	2.5	0.1	1.2	48	20	15	▲/△
R/LA109.1530.3.2	3.0	0.1	1.5	48	20	15	▲/▲

▲ 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 :

刀片RA109安装于刀杆RB109上 刀片LA109安装于刀杆LB109上

Note:

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

Dmin在15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 $D_{a \min}$ 15 - 40 mm!

按需提供更多尺寸

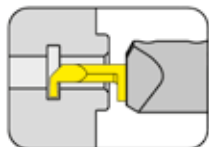
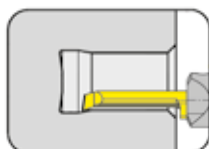
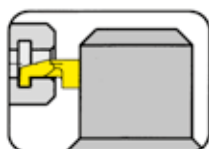
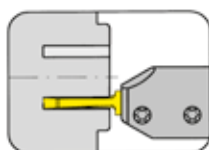
Further sizes upon request

硬质合金牌号
Carbide grades

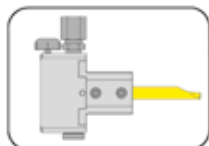
P	•
M	•
K	•
N	•
S	•
H	-

刀杆

Toolholder

B110/B110C/VDI/
B110.WF/B110TS页/Page
A141, A145, A147-A148页/Page
A142页/Page
A143-A144页/Page
A155

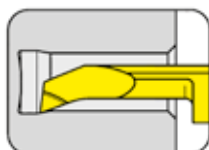
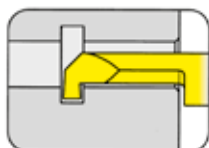
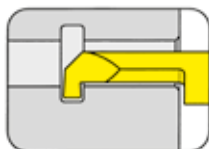
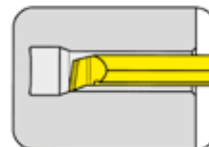
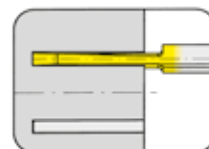
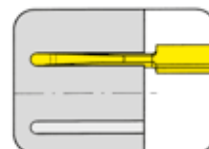
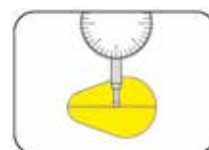
可调刀杆

Adjustable holder
N页/Page
A141

刀片

Insert

110/A110

页/Page
A149页/Page
A150-A154页/Page
A151刀片
Insert
110页/Page
A152页/Page
A156页/Page
A157页/Page
A153

110



机夹式刀杆

槽宽 1 - 3 mm

Toolholder with Inserts

Width of groove 1 - 3 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0,2	•											
≥ 0,5	•											
≥ 0,7	•											
≥ 1,0	•											
≥ 1,5	•											
≥ 2,0	•											
≥ 3,0	•											
≥ 4,0	•											
≥ 5,0	•											
≥ 6,0	•	•	•	•								
≥ 6,8		•	•	•								
≥ 7,0		•			•							
≥ 7,8			•		•	•						
≥ 8,0			•		•	•						
≥ 9,0			•		•	•	•					
≥ 10,0			•				•	•	•			
≥ 10,5									•			
≥ 11,0								•	•			
≥ 11,5									•			
≥ 13,8										•		
≥ 14,0										•	•	
≥ 16,0											•	
≥ 16,5										(•)		
≥ 18,0												•

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

槽宽 Width of groove	0,5-2,0	1,0-2,0	1,0-3,0	0,7-1,5	1,0-2,0	0,7-2,0	1,0-3,0	0,7-3,0	1,0-3,0	0,7-3,0	0,7-4,0	2,0-3,0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring



刀杆

Toolholder

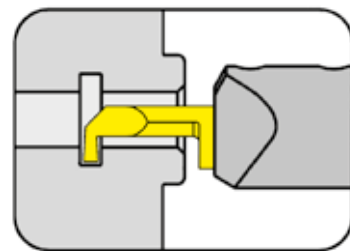
B110

直接冷却液供应
with through coolant supply

孔径Ø 自
槽深可达
槽宽可达

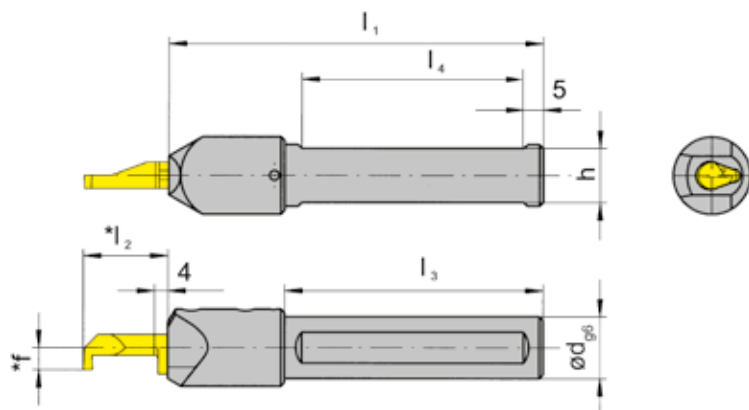
Bore Ø from
Depth of groove up to
Width of groove up to

6,mm
4 mm
3 mm



配合刀片
for Insert

型号 110
Type



图示=右手型

Picture = right hand cutting version

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

按需提供更多尺寸
Further sizes upon request

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

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

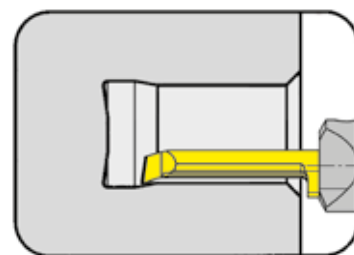
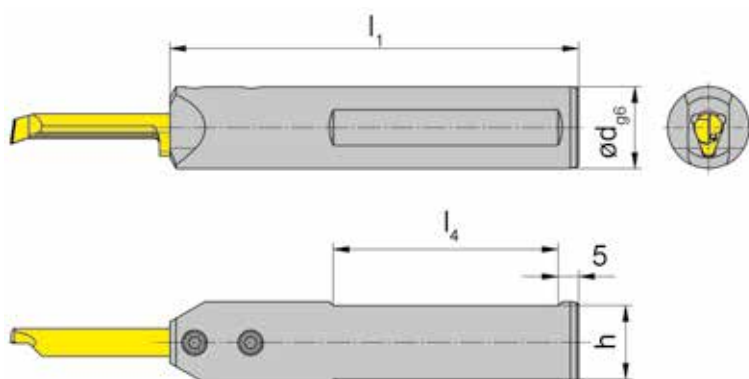
Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B110...	6.075T15P	T15PQ

刀杆

Toolholder

B110

直接冷却液供应
with through coolant supply孔径Ø 自
槽深可达
槽宽可达Bore Ø from
Depth of groove up to
Width of groove up to6 mm
4 mm
3 mm配合刀片
for Insert型号 110
Type

图示=右手型

Picture = right hand cutting version

带有多个冷却孔
with additional through
coolant bores

产品型号 Part number	d	l_1	h	l_4
B110.0020.K.02	20	100	18	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

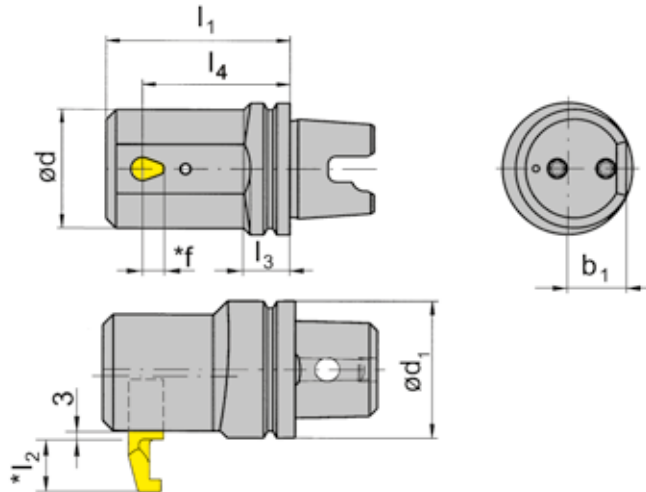
刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
B110.0020.K.02	6.075T15P	T15PQ

刀杆 Toolholder

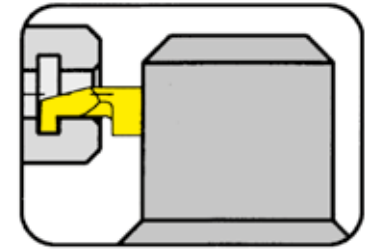
B110TS

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

用于INDEX多主轴机床
for INDEX Multi spindle machines



R=右手型-如图
R = right hand version shown



配合刀片
for Insert

型号 110
Type

HORN TS (ISO 26622)
HORN TS according to ISO
26622

产品型号 Part number	d ₁	l ₃	d	l ₁	b ₁	l ₄	机床型号 Machine type
RB110.TS40.2.2.02	40	14	36	56	18	45	MS32
RB110.TS50.2.2.02	50	22	36	56	18	45	MS52

按需提供更多尺寸
Further sizes upon request

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

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
RB110.TS...	6.075T15P	T15PQ

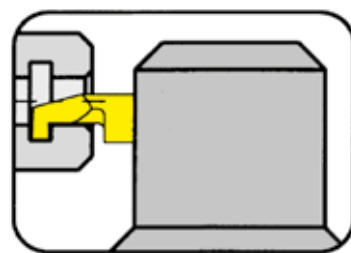
刀杆

Toolholder

B110C

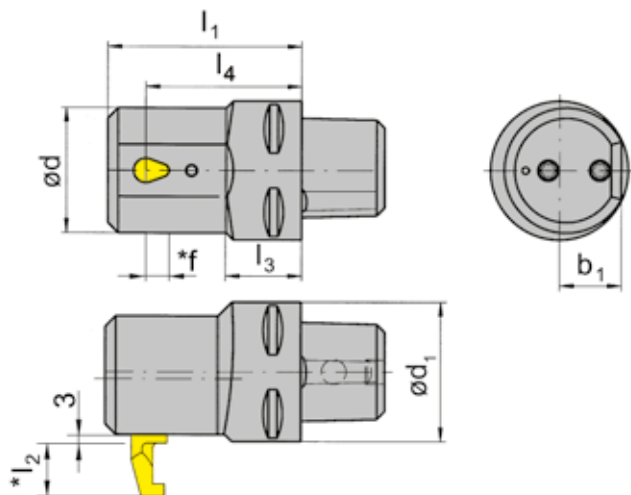
HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于INDEX多主轴机床
for INDEX Multi spindle machines



配合刀片
for Insert

型号 110
Type



R=右手型-如图
R = right hand version shown

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

按需提供更多尺寸
Further sizes upon request

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

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
RB110...	6.075T15P	T15PQ

切槽和镗孔

Grooving and Boring



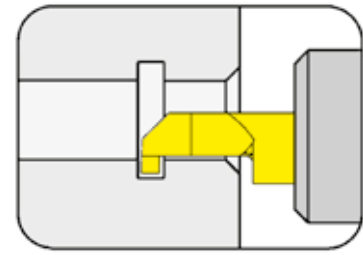
刀杆

Toolholder

B110C

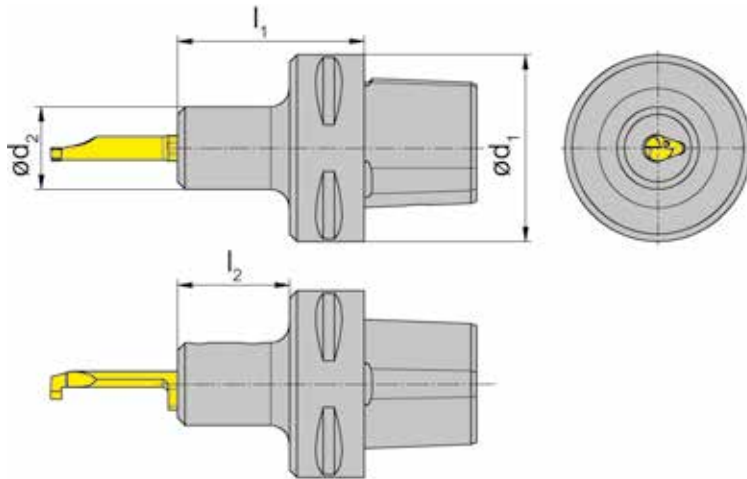
HORN多边形刀杆 (ISO26623)
HORN Polygon shank according ISO 26623

用于INDEX多主轴机床
for INDEX Multi spindle machines



配合刀片
for Insert

型号 110
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d ₁	d ₂	l ₁	l ₂
R/LB110.00C3.22.1.02	32	22	45	30
R/LB110.00C4.22.1.02	40	22	50	30
R/LB110.00C5.22.1.02	50	22	50	30
R/LB110.00C6.22.1.02	63	22	52	30

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
R/LB110...	6.075T15P	T15PQ

刀杆

Toolholder

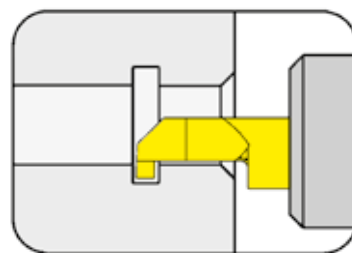
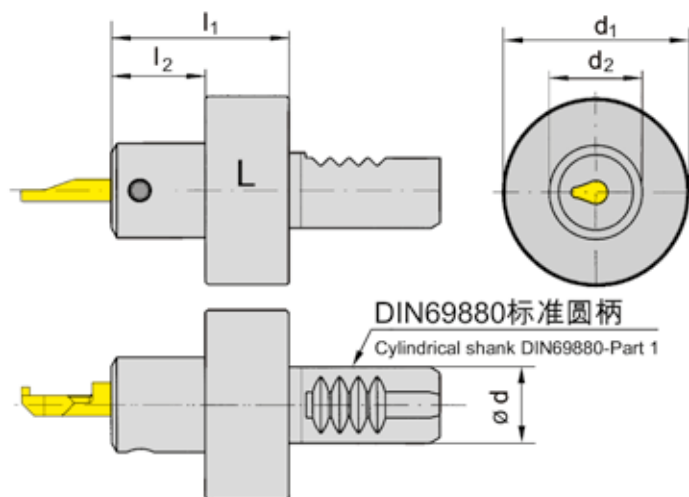
VDI

直接冷却液供应
with through coolant supply

孔径Ø 自

Bore Ø from

6 mm

配合刀片
for Insert型号 110
Type

L=左手型-如图

L = left hand version shown

R=右手型

R = right hand version

产品型号 Part number	d	l ₁	l ₂	d ₂	d ₁
VDI16.L110.30.02	16	48	30	22	40
VDI16.R110.30.02	16	48	30	22	40
VDI20.L110.30.02	20	48	30	22	50
VDI20.R110.30.02	20	48	30	22	50
VDI25.L110.30.02	25	48	30	22	58
VDI25.R110.30.02	25	48	30	22	58
VDI30.L110.30.02	30	48	30	22	68
VDI30.R110.30.02	30	48	30	22	68
VDI40.L110.30.02	40	48	30	22	83
VDI40.R110.30.02	40	48	30	22	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

切槽和镗孔

Grooving and Boring



可调刀杆

Adjustable holder

N



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

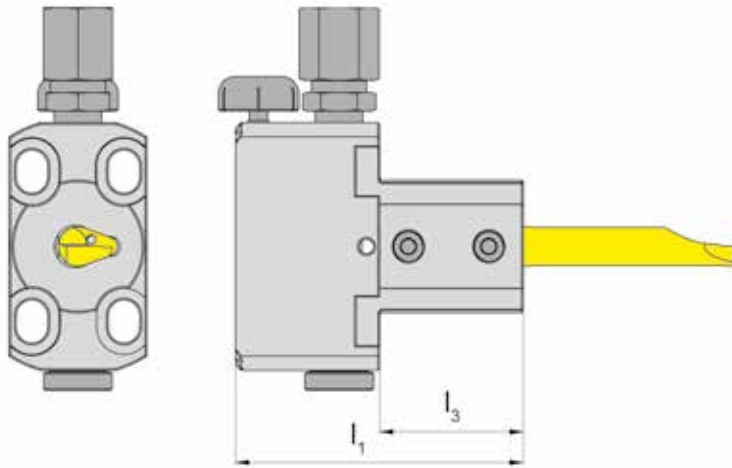
6 mm
4 mm
3 mm

直接冷却液供应

with through coolant supply

配合刀片
for Insert

型号 110
Type



图示=右手型

Picture = right hand cutting version

产品型号 Part number	l_1	l_3
N79IK	50	25

按需提供更多尺寸

Further sizes upon request

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

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
N79IK	6.075T15P	002.00.69	004.00.19

刀杆

Toolholder

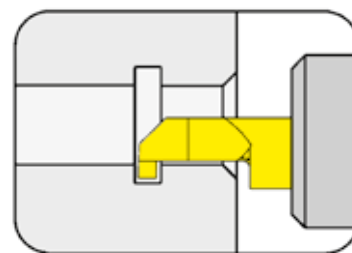
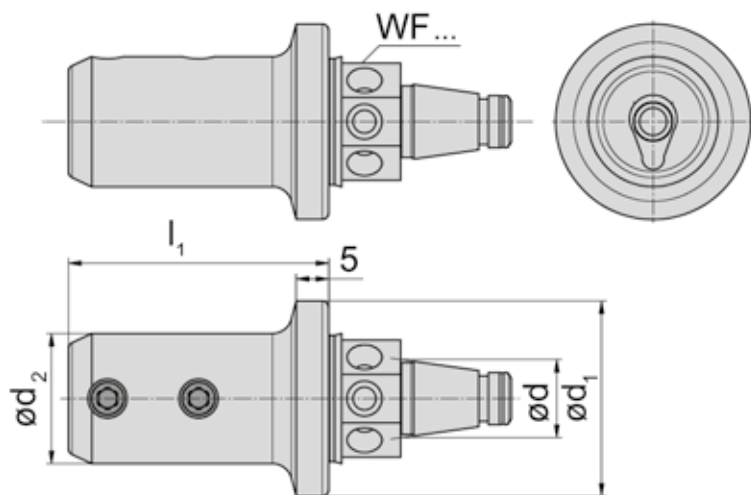
B110.WF

直接冷却液供应
with through coolant supply

孔径Ø 自

Bore Ø from

6 mm

配合刀片
for Insert型号 110
Type

产品型号 Part number	d_1	l_1	d	d_2
B110.WF20.2.02	30	40	12	20
B110.WF24.2.02	37	40	16	20
B110.WF32.2.02	50	40	20	20

按需提供更多尺寸

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.

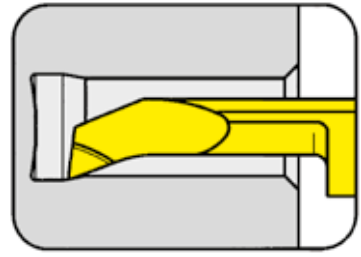
尺寸单位：mm

Dimensions in mm

刀片

Insert

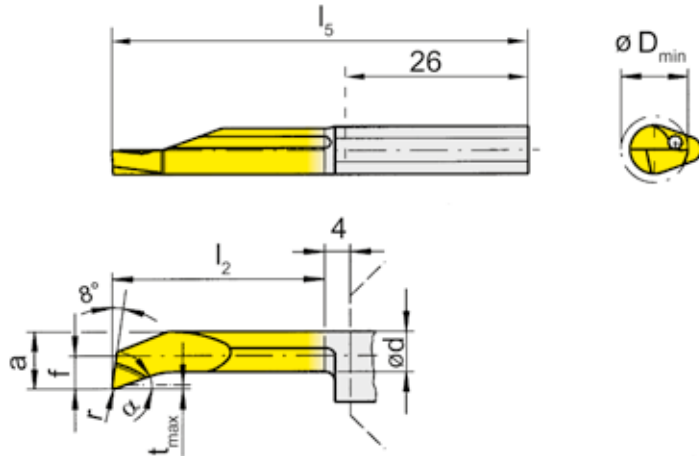
110



孔径Ø 自

Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 B110C
Type B110TS
B110.WF
N
VDI

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	α	EG35	TH35	TI25
R/L110.1829.7.6	0.2	2.9	5.7	4.8	40	70	0.5	6	20°	▲/▲	▲/▲	▲/▲
R/L110.1829.9.6	0.2	2.9	5.7	4.8	50	80	0.5	6	20°	▲/▲	▲/▲	▲/▲
R/L110.1829.9.8	0.2	4.0	7.4	6.0	50	80	0.5	8	20°	▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)

刀片

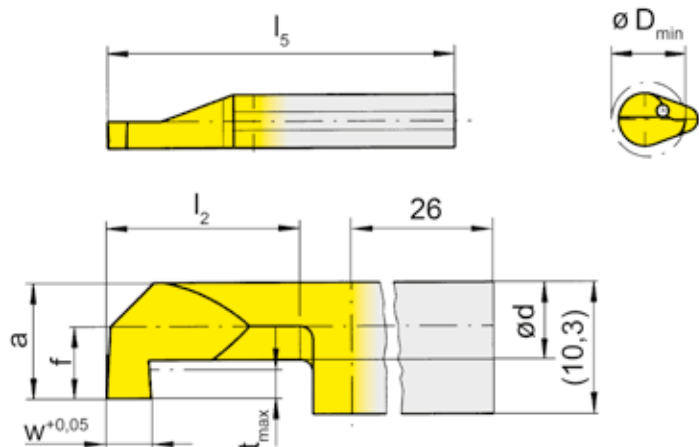
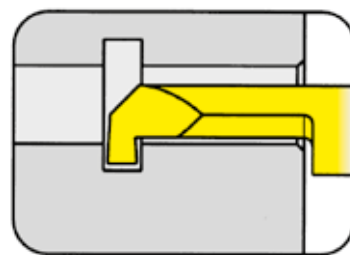
Insert

110

孔径Ø 自

Bore Ø from

8 mm



配合刀杆

for Toolholder

型号 B110C
Type B110TS
B110.WF
N
VDI

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	f	a	d	l_2	l_5	t_{max}	D_{min}	EG35	TI25	TN35
R/L110.0100.5.8	1.0	4	7.4	4.2	30	60	2.8	8	▲/▲		▲/▲
R/L110.0200.5.8	2.0	4	7.4	4.2	30	60	2.8	8	▲/▲	Δ/x	▲/▲
R/L110.0250.5.8	2.5	4	7.4	4.2	30	60	2.8	8	▲/▲	Δ/x	▲/▲
R/L110.0100.7.8	1.0	4	7.4	4.2	40	70	2.8	8	▲/Δ		▲/▲
R/L110.0200.7.8	2.0	4	7.4	4.2	40	70	2.8	8	▲/▲		▲/▲
R/L110.0250.7.8	2.5	4	7.4	4.2	40	70	2.8	8	▲/Δ		▲/▲
R/L110.0100.5.0	1.0	6	9.4	5.0	30	60	4.0	10	▲/▲		▲/▲
R/L110.0200.5.0	2.0	6	9.4	5.0	30	60	4.0	10	▲/▲	Δ/x	▲/▲
R/L110.0300.5.0	3.0	6	9.4	5.0	30	60	4.0	10	▲/▲	Δ/x	▲/▲
R/L110.0100.9.0	1.0	6	9.4	5.0	50	80	4.0	10	Δ/Δ		▲/Δ
R/L110.0200.9.0	2.0	6	9.4	5.0	50	80	4.0	10	▲/Δ		▲/▲
R/L110.0300.9.0	3.0	6	9.4	5.0	50	80	4.0	10	▲/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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号

Carbide grades

切槽 (内圆)

Grooving (internal)



刀片

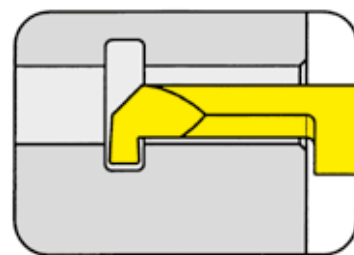
Insert

110

孔径 Ø 自

Bore Ø from

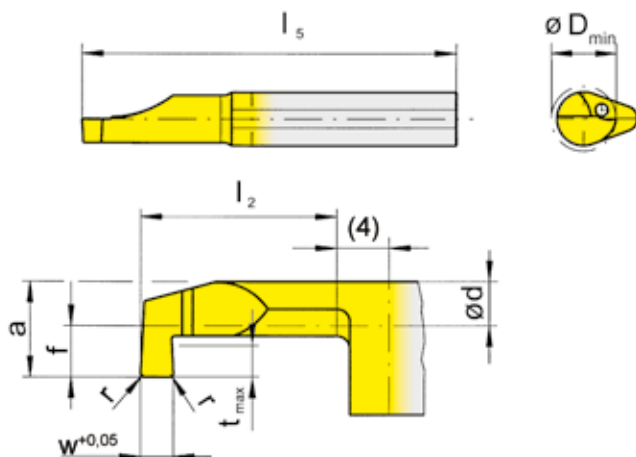
8 mm



配合刀杆

for Toolholder

型号 B110C
Type B110TS
B110.WF
N
VDI



R=右手型-如图

R = right hand version shown

带圆角
with corner radius

产品型号 Part number	w	r	f	a	d	l_2	l_5	t_{max}	D_{min}		EG35	TN35
R110.0200.02.3.8	2	0.2	4	7.4	4.2	20	50	2.8	8		▲	▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

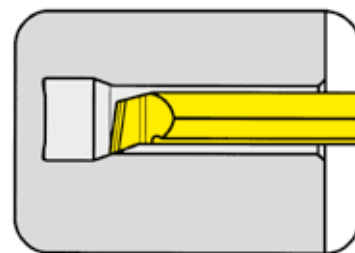
Insert

110

孔径Ø 自

Bore Ø from

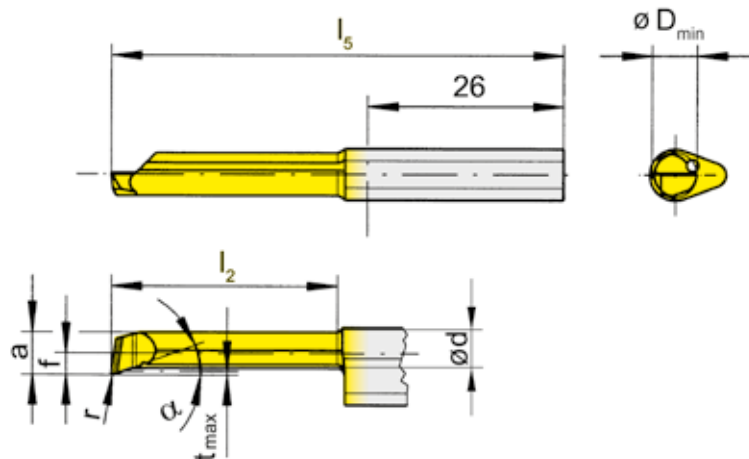
6 mm



配合刀杆

for Toolholder

型号 B110C
Type B110TS
B110.WF
N
VDI



R=右手型-如图

R = right hand version shown

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

产品型号 Part number	r	f	a	d	l_2	l_5	t_{max}	D_{min}	α		EG35	T125
R110.1829.9.H6	0.2	2.9	5.7	4.8	50	80	0.5	6	20°		▲	▲
R110.1829.9.H8	0.2	4.0	7.4	6.0	50	80	0.5	8	20°		▲	▲
▲ 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

按需提供更多尺寸

Further sizes upon request

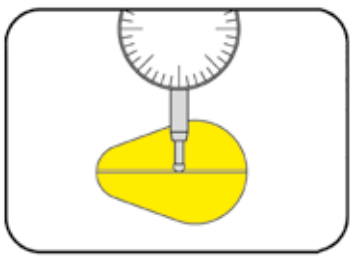
硬质合金牌号
Carbide grades

调整
Set Up



刀片
Insert

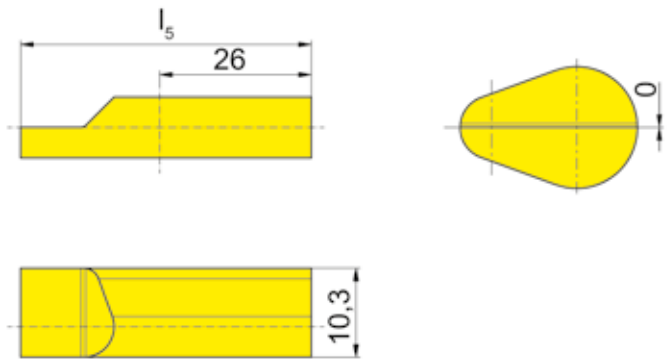
110



刀片用于刀杆的调整
Insert for tool set up

配合刀杆
for Toolholder

型号 110
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_5
R/L110.LEHR.H.02	40

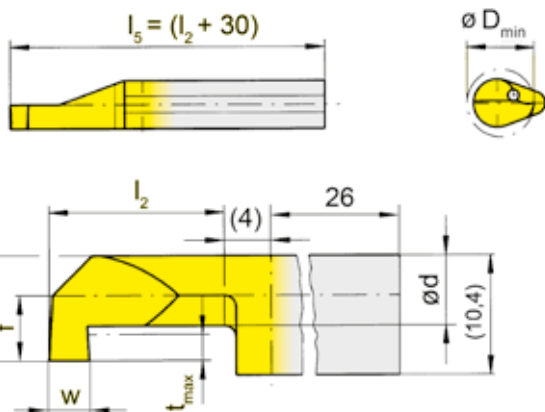
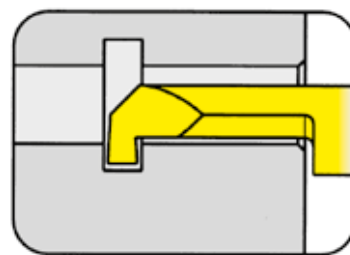
尺寸单位 : mm
Dimensions in mm

刀片

Insert

110

基本规格 型号 110
Basic sizes type 110



配合刀杆
for Toolholder

型号 B110C
Type B110TS
B110.WF
N
VDI

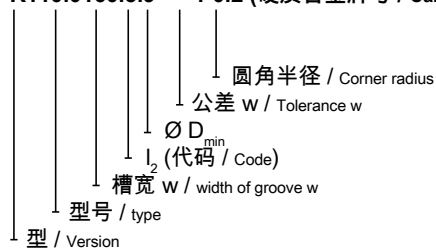
产品型号 Part number	D _{min}	f	a	d	t _{max}	w	代码 Code	l ₂	MG12	TN35	TI25	TH35
110...8	8	4	7,4	4,2	2,8	0,5-3,0	1	10	按照要求 Upon Request			
110...9	9	5	8,4	4,8	3,5		2	15				
110...0	10	6	9,4	5,2	4,0		3	20				
							4	25				
							5	30				
							6	35				
							7	40				

尺寸单位 : mm
Dimensions in mm

如何订购:

Ordering example:

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



端面切槽

Face Grooving



刀杆

Toolholder

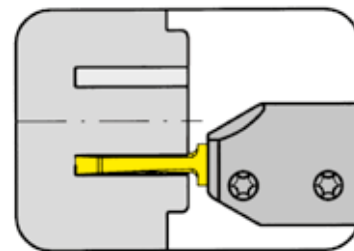
B110

直接冷却液供应
with through coolant supply

端面槽起始外径
槽深可达
槽宽可达

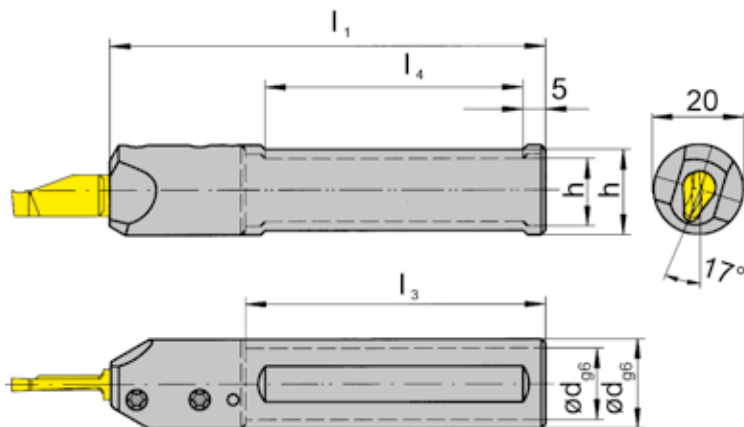
from outer groove Ø
Depth of groove up to
Width of groove up to

20 mm
30 mm
3 mm



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

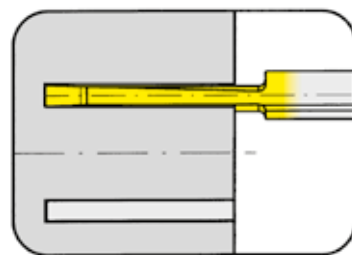
端面切槽

Face Grooving

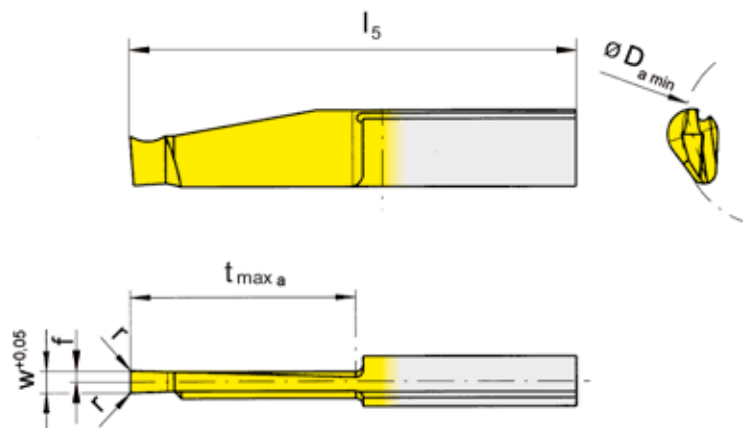
刀片

Insert

A110



端面槽起始外径	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

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

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

注明R或L型

State R or L version

注意事项 :

RB110...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.

注意 : 配合R/LA110.2030...刀杆

Dmin在20和50mm之间时, 端面切槽可达满切下的最大切深。

Note for R/LA110.2030...:

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

端面切槽

Face Grooving

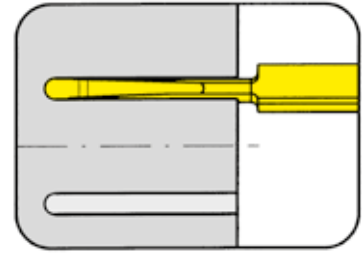


A

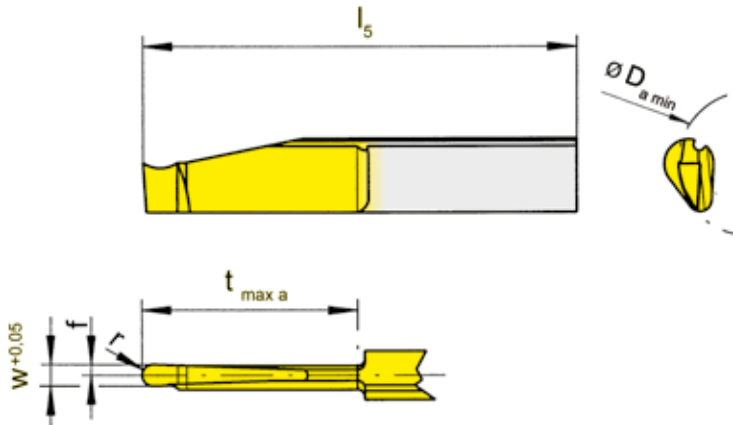
刀片

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

L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

圆头
Full radius

产品型号 Part number	w	r	f	l_5	$t_{\max a}$	$D_{a \min}$	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
- 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

按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

注明R或L型

State R or L version

注意事项 :

RB110...16.2刀杆配合RA110刀片 LB110...16.2刀杆配合LA110刀片

Note:

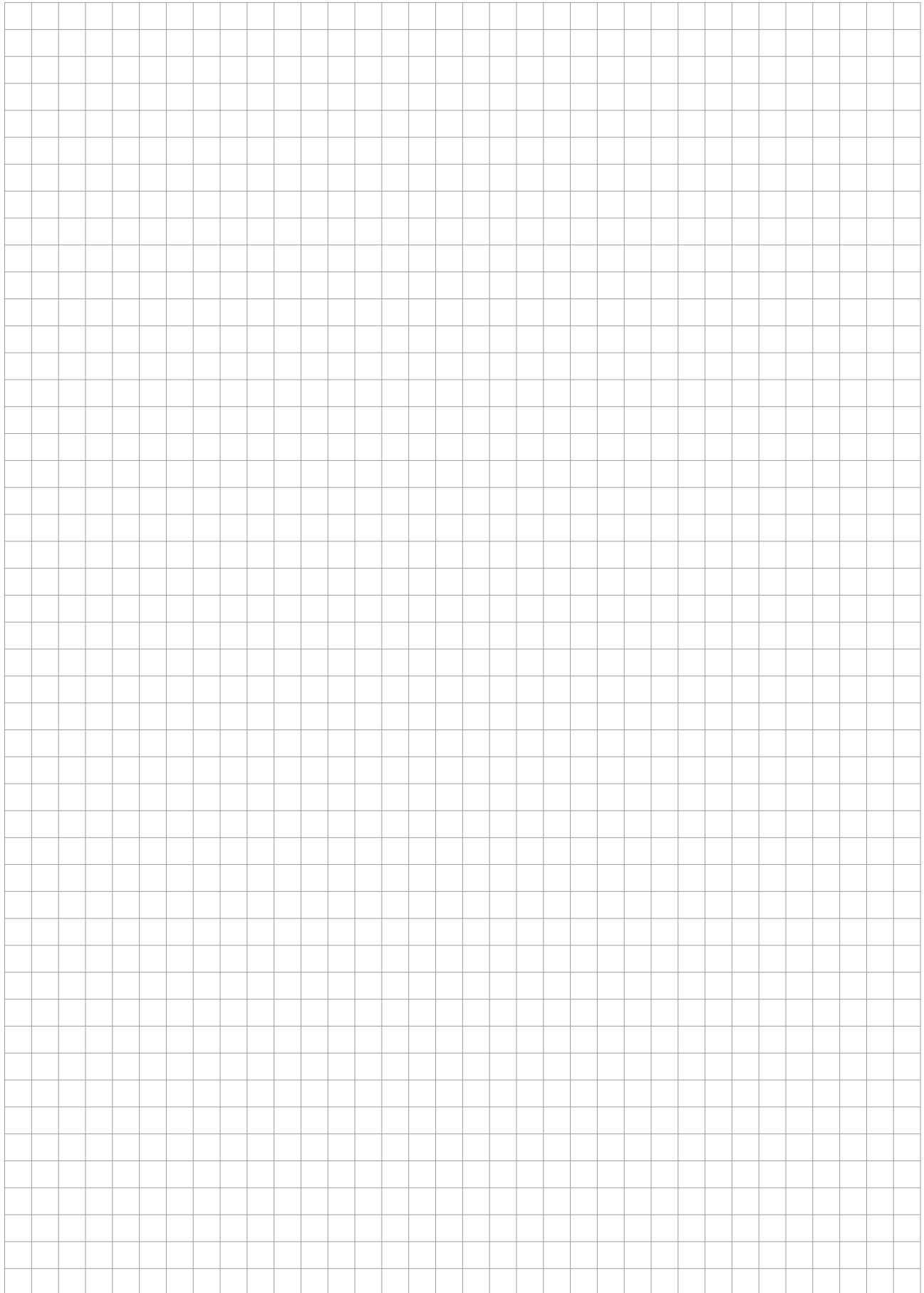
Use insert RA110 in toolholder RB110...16.2 and insert LA110 in toolholder LB110...16.2.

注意 : 配合R/LA110.2030...刀杆

Dmin在20和50mm之间时, 端面切槽可达满切下的最大切深。

Note for R/LA110.2030...:

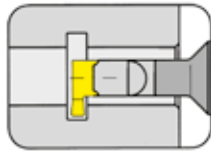
Face grooving with full width of the full depth only possible between $D_{a \min}$ 20 - 50 mm.





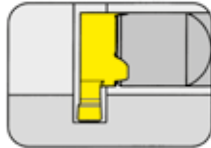
系列/System	页/Page
106	B2
107	B10
108	B20
10P	B44
111	B56
11P	B82
114	B94
116	B126
18P	B148

刀杆
Toolholder
B106

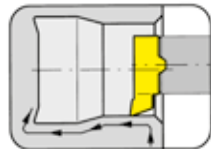


页/Page
B5

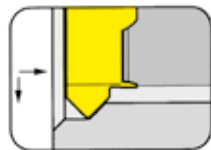
刀片
Insert
106



页/Page
B6



页/Page
B7



页/Page
B8

106



机夹式刀杆

槽宽0,7 - 1,5 mm

Toolholder with Inserts

Width of groove 0,7 - 1,5 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring

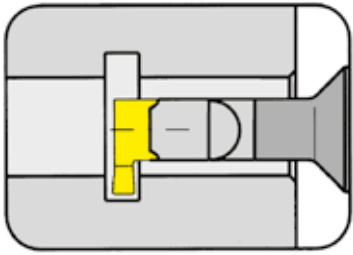


刀杆

Toolholder

B106

直接冷却液供应
with through coolant supply

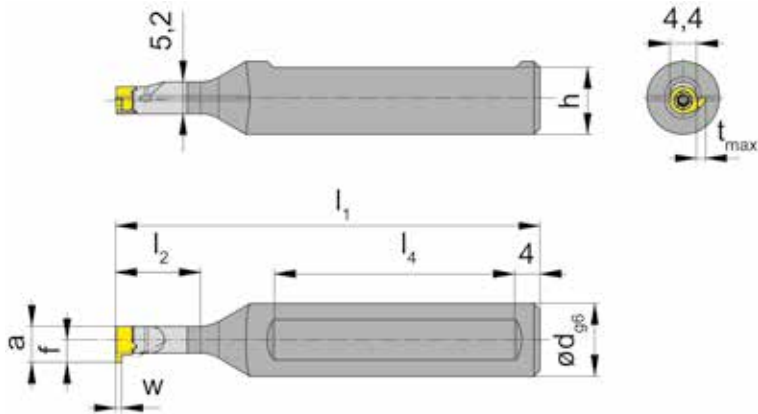


孔径Ø 自 槽深可达 槽宽可达	Bore Ø from Depth of groove up to Width of groove up to	6 mm 0,8 mm 1,5 mm
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刀杆材质：整体硬质合金 - 良好的抗振性能
Material of shank: Carbide - Giving a good vibration resistance

配合刀片
for Insert

型号 106
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	l ₄
R/LB106.0012.01	12	70	14	11	40
R/LB106.0012.02	12	80	20	11	40
R/LB106.0012.03	12	90	26	11	45

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：
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
R/LB106...	1.8.4T6EP	T6PL

切槽 (内圆)

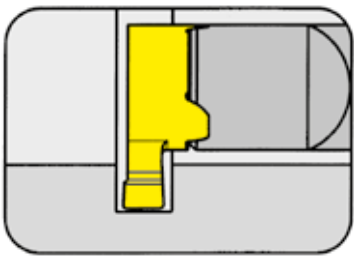
Grooving (internal)



B

刀片
Insert

106



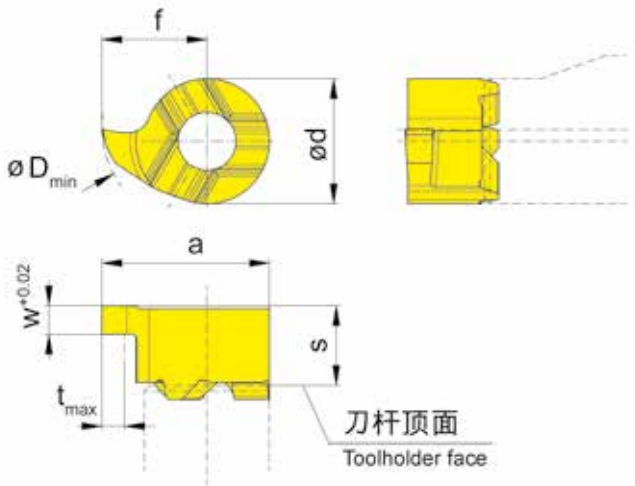
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

6.5 mm
0.8 mm
1.5 mm

配合刀杆
for Toolholder

型号 B106
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}		EG55	TH35
R/L106.0070.2.00	0.74	2.8	3.7	5.9	4.4	0.8	6.5		▲/Δ	▲/Δ
R/L106.0100.2.00	1.00	2.8	3.7	5.9	4.4	0.8	6.5		Δ/Δ	▲/Δ
R/L106.0150.2.00	1.50	2.8	3.7	5.9	4.4	0.8	6.5		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

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

硬质合金牌号
Carbide grades

刀片 Insert

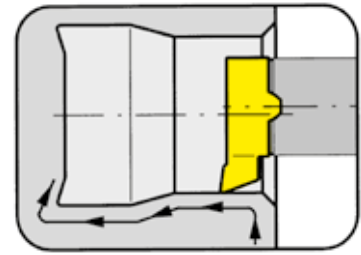
106

B

孔径Ø 自

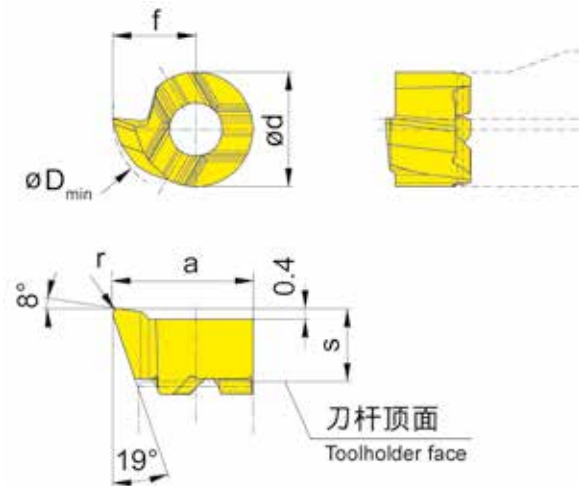
Bore Ø from

6 mm



配合刀杆
for Toolholder

型号 B106
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	s	f	a	r	d	D _{min}		EG55	TH35
R/L106.1831.1.005	2.8	3.2	5.4	0.05	4.4	6		▲/Δ	▲/Δ
R/L106.1831.1.02	2.8	3.2	5.4	0.20	4.4	6		▲/Δ	▲/▲
R/L106.1831.1.04	2.8	3.2	5.4	0.40	4.4	6		▲/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

按需提供更多尺寸

Further sizes upon request

右手型刀片配合右手型刀杆，左手型刀片配合左手型刀杆

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

硬质合金牌号
Carbide grades

倒角和背镗 (内圆)

Chamfering and Backboring (internal)



B

刀片

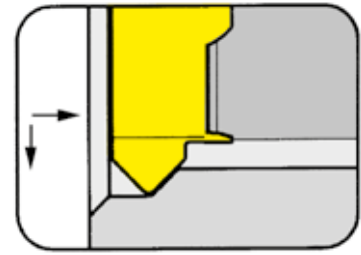
Insert

106

孔径Ø 自
切深可达

Bore Ø from
Depth of cut up to

6 mm
0.6 mm



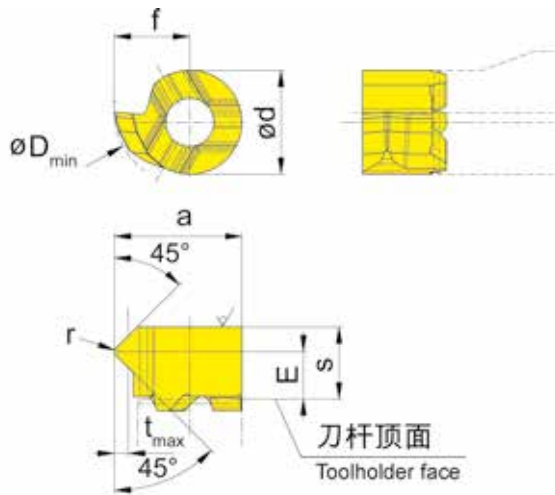
配合刀杆

for Toolholder

型号

B106

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	E	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35
R/L106.4545.1.02	2	3.05	3.2	5.4	0.2	4.4	0.6	6		▲/Δ	▲/Δ
▲ 库存 / on stock										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

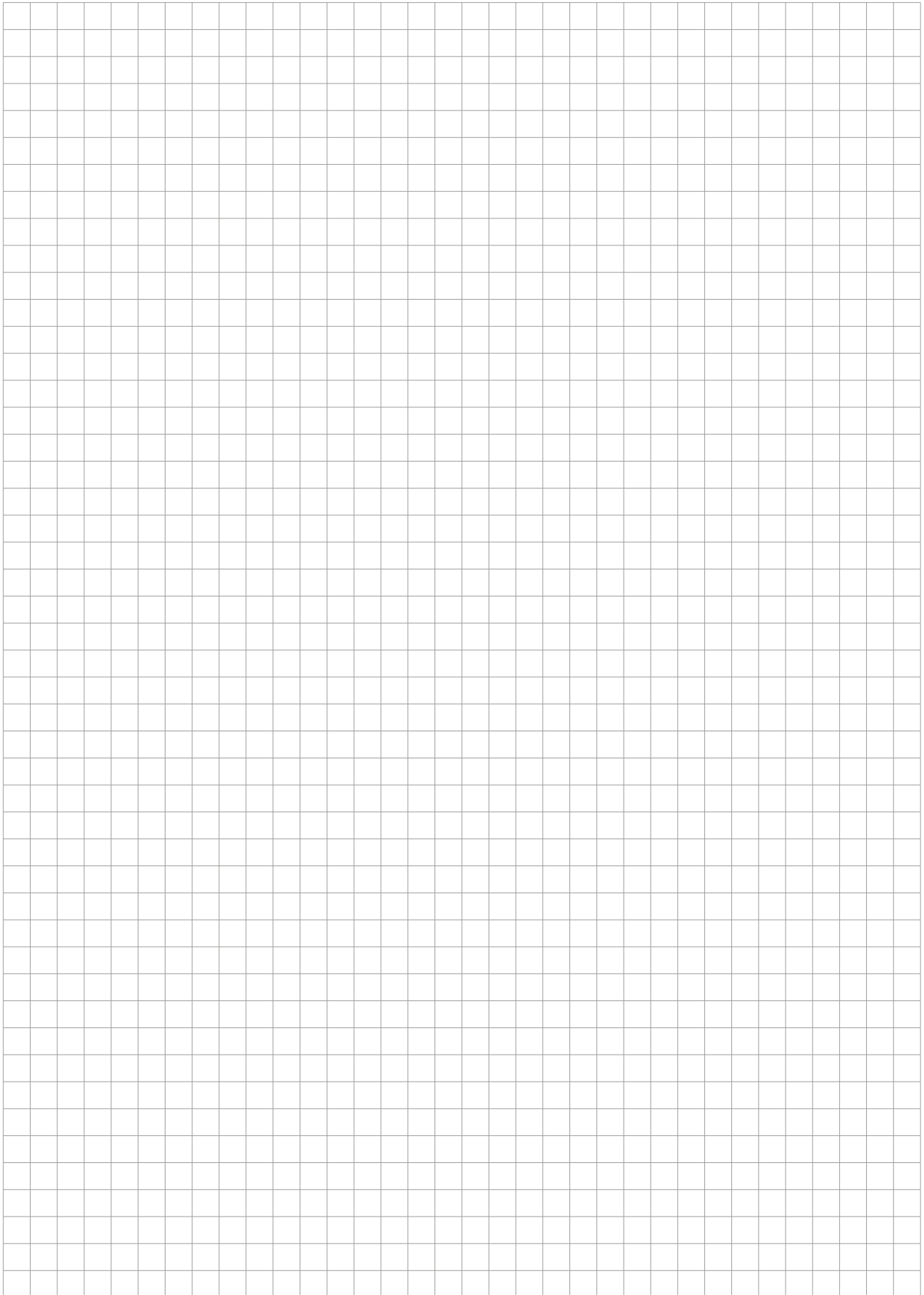
按需提供更多尺寸

Further sizes upon request

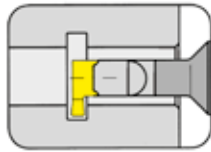
右手型刀片配合右手型刀杆, 左手型刀片配合左手型刀杆

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

硬质合金牌号
Carbide grades

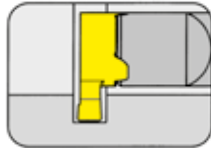


刀杆
Toolholder
B107

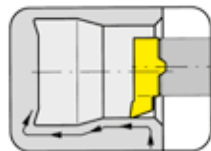


页/Page
B13

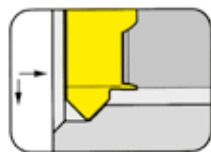
刀片
Insert
107



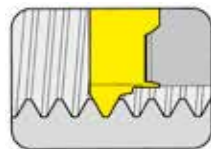
页/Page
B14-B15



页/Page
B16



页/Page
B17



页/Page
B18

107



机夹式刀杆
槽宽1 - 2 mm

Toolholder with Inserts
Width of groove 1 - 2 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring

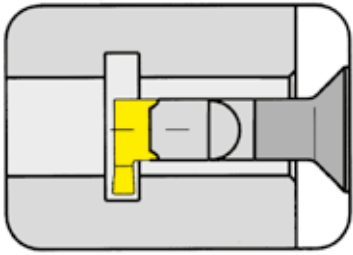


刀杆

Toolholder

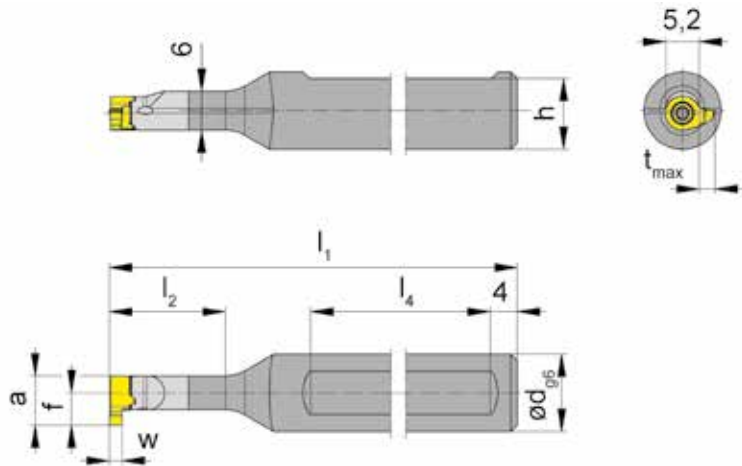
B107

直接冷却液供应
with through coolant supply



孔径Ø 自	Bore Ø from	7 mm
槽深可达	Depth of groove up to	2 mm
槽宽可达	Width of groove up to	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



配合刀片
for Insert

型号 107
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

注明R或L型
State R or L version

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

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
HORN可以返修损坏的刀杆基座。

Ordering note:
Toolholders with damaged seating can be repaired by HORN.
螺丝的扭矩规格，详见技术说明。
For torque 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/LB107...	2.2.5T7EP	T7PL

切槽 (内圆)

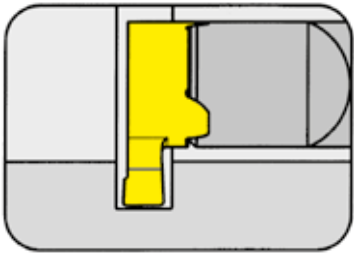
Grooving (internal)



B

刀片
Insert

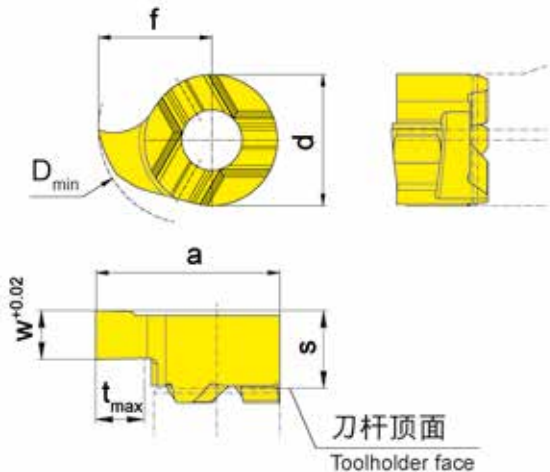
107



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

7 mm
1 mm
1.5 mm



配合刀杆
for Toolholder

型号 B107
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}		EG55	TH35
R/L107.0100.1.00	1.0	3.3	4	6.6	5.2	1	7		▲/△	▲/△
R/L107.0150.1.00	1.5	3.3	4	6.6	5.2	1	7		▲/△	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



刀片
Insert

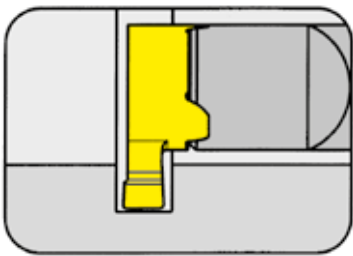
107

B

孔径Ø 自
槽深可达
槽宽可达

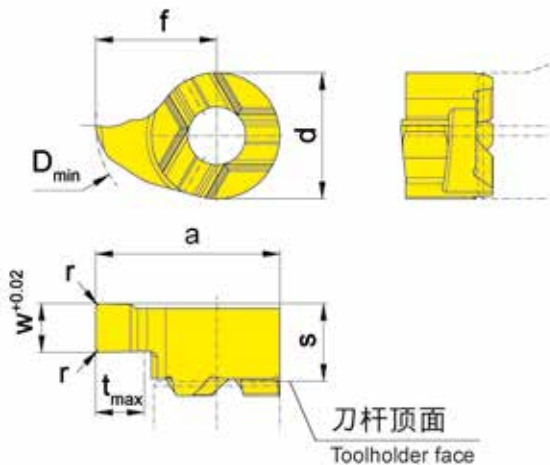
Bore Ø from
Depth of groove up to
Width of groove up to

8 mm
2 mm
2 mm



配合刀杆
for Toolholder

型号 B107
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L107.0100.2.00	1.0	3.3	5	7.6	-	5.2	2	8	▲/Δ	▲/Δ
R/L107.0150.2.01	1.5	3.3	5	7.6	0.1	5.2	2	8	▲/Δ	▲/x
R/L107.0200.2.02	2.0	3.3	5	7.6	0.2	5.2	2	8	▲/Δ	▲/▲
									P	•
									M	o
									K	o
									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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

刀片

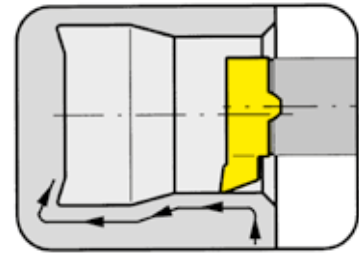
Insert

107

孔径Ø 自

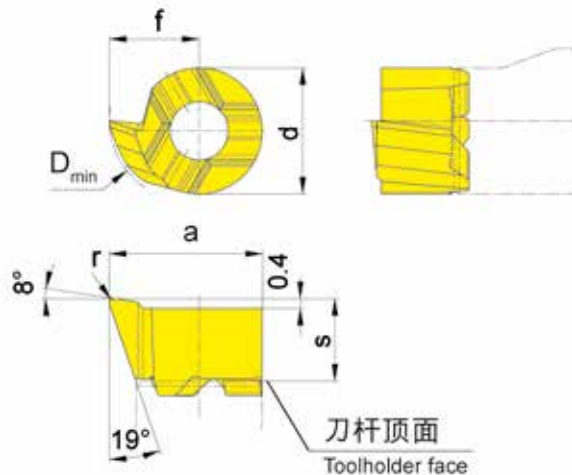
Bore Ø from

6.8 mm



配合刀杆
for Toolholder

型号 B107
Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/L107.1837.02	3.3	3.7	6.3	0.2	5.2	6.8		▲/▲	▲/▲
R/L107.1837.04	3.3	3.7	6.3	0.4	5.2	6.8		▲/▲	▲/▲
▲ 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

改进后的几何槽形可镗≥Ø6.8mm的孔和仿形加工DIN509E型和F型退刀槽。

The modified geometry allows boring of bores ≥ Ø 6,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

倒角和背镗 (内圆)

Chamfering and Backboring (internal)



刀片

Insert

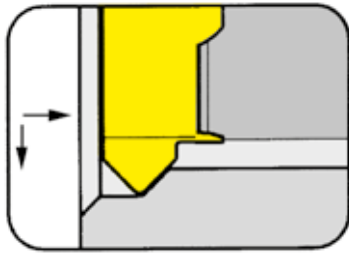
107

B

孔径Ø 自
切深可达

Bore Ø from
Depth of cut up to

6.8 mm
0.8 mm



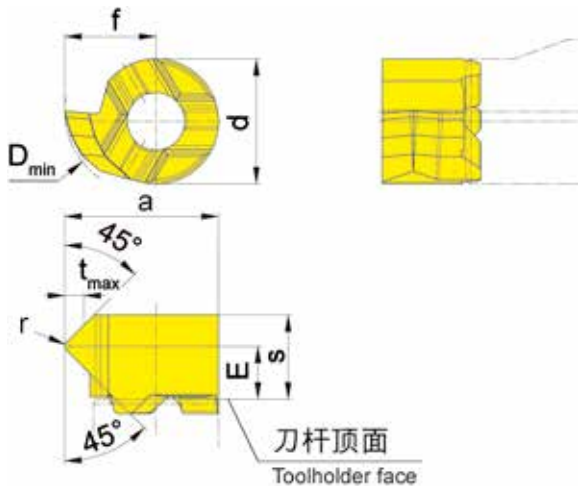
配合刀杆

for Toolholder

型号

B107

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	E	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L107.4545.1.02	2.2	3.5	3.8	6.4	0.2	5.2	0.8	6.8	▲/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

按需提供更多尺寸

Further sizes upon request

P	●	●
M	○	●
K	○	●
N	-	●
S	-	●
H	-	-

硬质合金牌号

Carbide grades

螺纹切削 (内圆) -非全牙型
Threading (internal) Partial profile



B

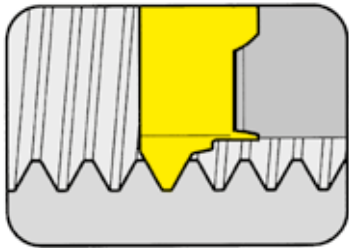
刀片
Insert

107

孔径Ø 自
螺距

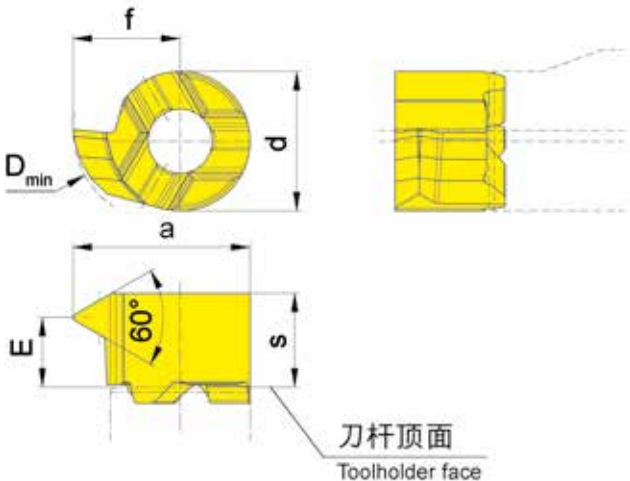
Bore Ø from
Pitch

7 mm
0,5-1,75 mm



配合刀杆
for Toolholder

型号 B107
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

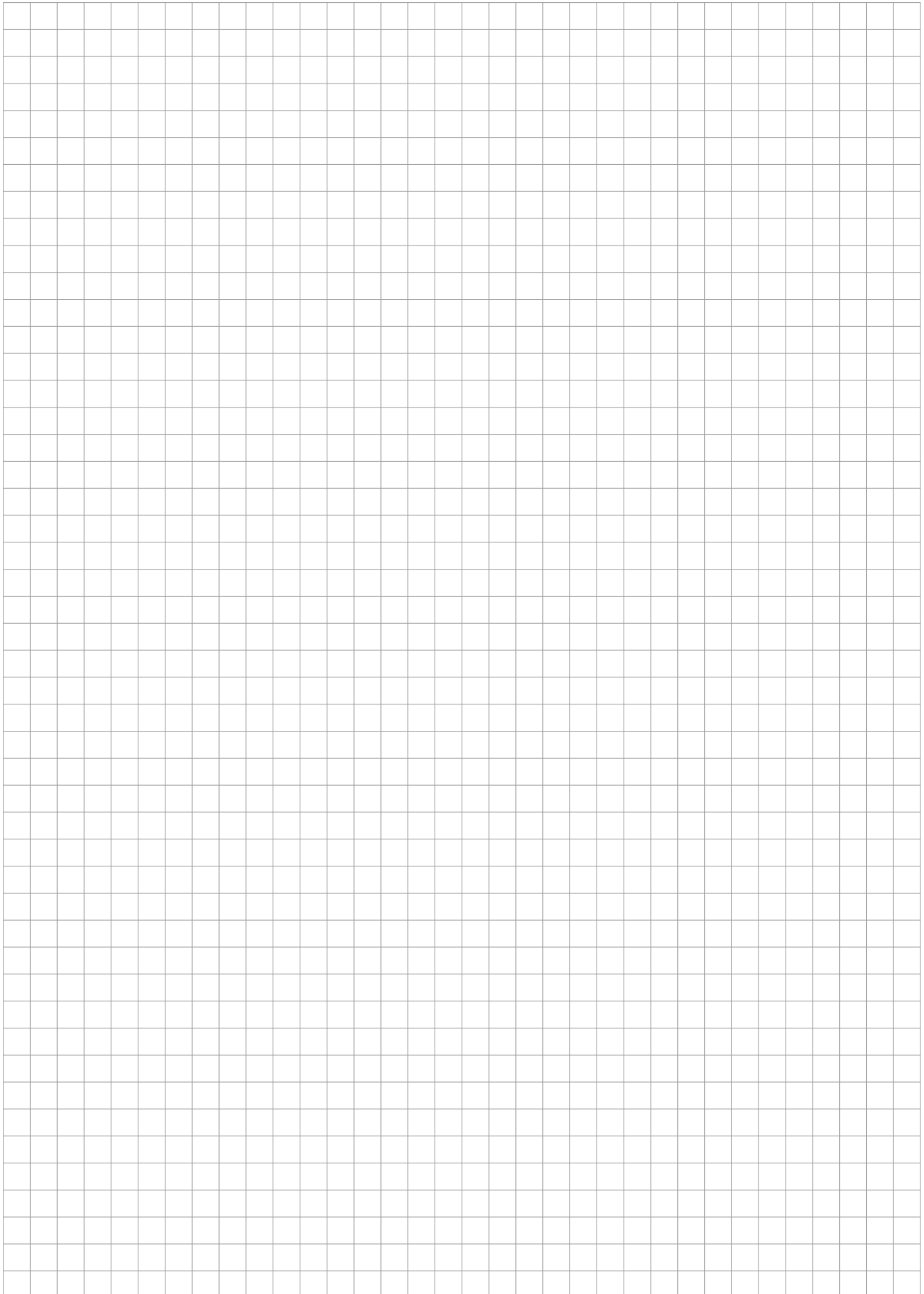
ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	s	D _{min}		EG55	TH35	
R/L107.0205.1.01	0.5	0.75	3.0	4	6.6	5.2	3.5	7		Δ/Δ	▲/Δ	
R/L107.0510.1.01	1.0	1.25	2.8	4	6.6	5.2	3.5	7		▲/Δ	▲/▲	
R/L107.0815.1.01	1.5	1.75	2.6	4	6.6	5.2	3.5	7		▲/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												

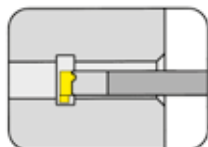
▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
○ 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

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

硬质合金牌号
Carbide grades



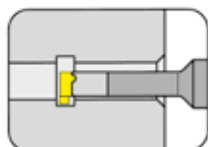
刀杆
Toolholder
B108/B108KM



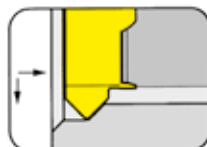
页/Page
B23



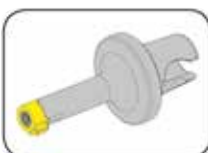
页/Page
B35



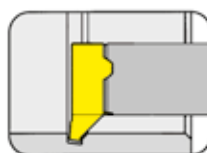
页/Page
B24



页/Page
B37



页/Page
B25-B26

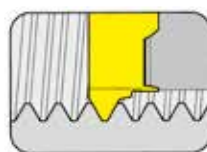


页/Page
B38

刀片
Insert
108/S108/107



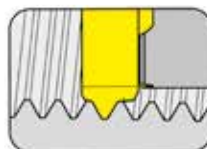
页/Page
B27-B28, B30



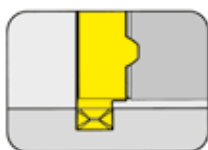
页/Page
B39-B40



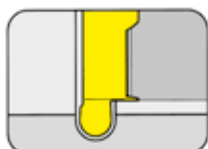
页/Page
B29



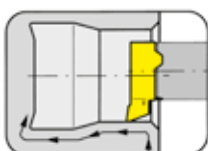
页/Page
B41-B42



页/Page
B31



页/Page
B32



页/Page
B33-B34, B36

108



机夹式刀杆

槽宽0,7 - 2,0 mm

Toolholder with Inserts

Width of groove 0,7 - 2,0 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring



B

刀杆

Toolholder

B108

直接冷却液供应
with through coolant supply

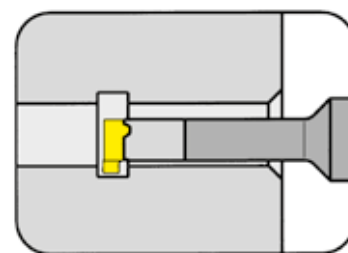
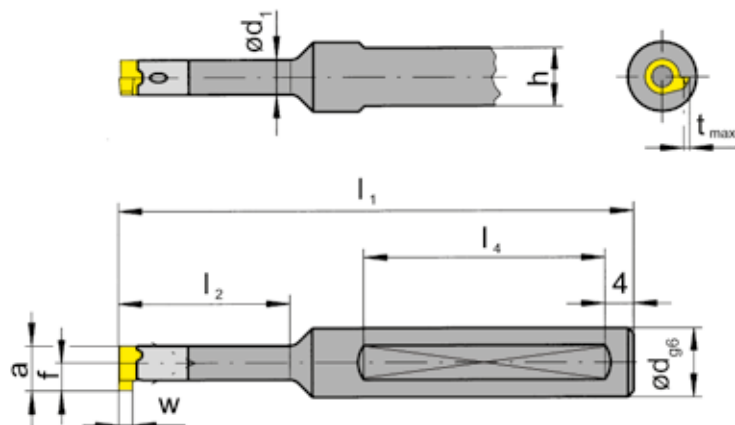
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

8 mm
1 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



配合刀片
for Insert

型号 108
Type S108



图示=右手型

Picture = right hand cutting version

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

按需提供更多尺寸

Further sizes upon request

$w, a, t_{\max}$ 和 f 见刀片

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

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



B

刀杆

Toolholder

B108

直接冷却液供应
with through coolant supply

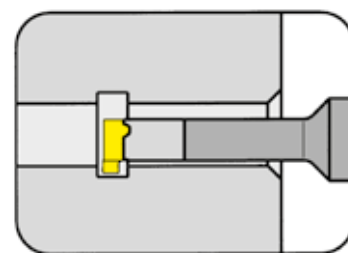
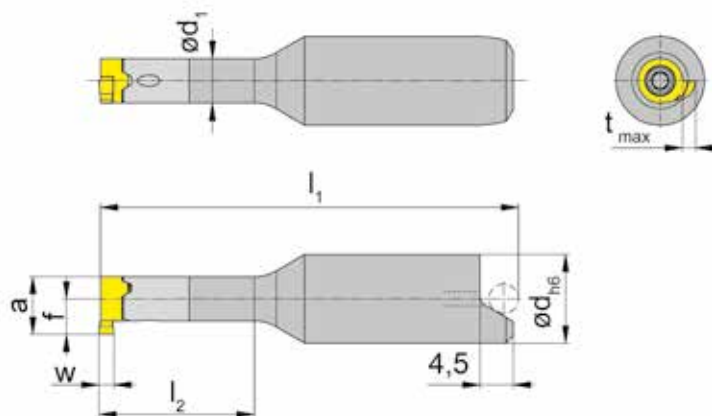
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

8 mm
1 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



配合刀片
for Insert

型号 108
Type S108

用于收缩型定位
for shrinkage location

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	d ₁
B108.0012.00S	12	48.7	12.5	6
B108.0012.01S	12	56.7	21.0	6
B108.0012.02S	12	65.7	30.0	6
B108.0012.03S	12	77.7	42.0	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 (内圆)

Grooving (internal)



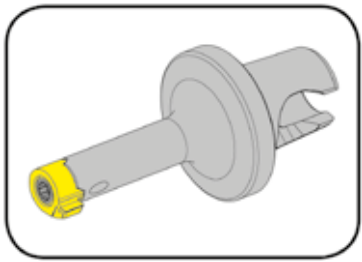
刀杆

Toolholder

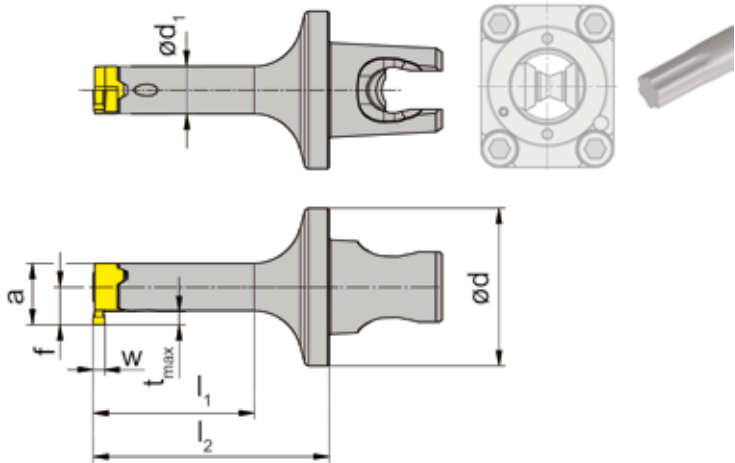
B108KM

直接冷却液供应
with through coolant supply

孔径Ø 自	Bore Ø from	8 mm
-------	-------------	------



B



配合刀片
for Insert

型号 108
Type S1008

Kennametal KM16 Micro
系列
System Kennametal KM16
Micro

产品型号 Part number	d	l_2	d_1	l_1
B108.KM16.01	20	30	6	21
B108.KM16.02	20	35	6	26

按需提供更多尺寸
Further sizes upon request

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

尺寸单位 : mm
Dimensions in mm

螺丝的扭矩规格，详见技术说明。
For torque 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 (内圆)
Grooving (internal)



B

刀杆
Toolholder

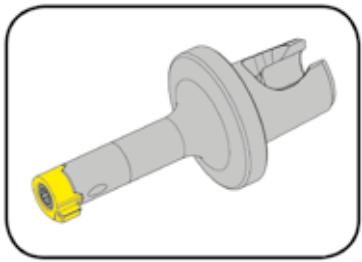
B108KM

直接冷却液供应
with through coolant supply

孔径Ø 自

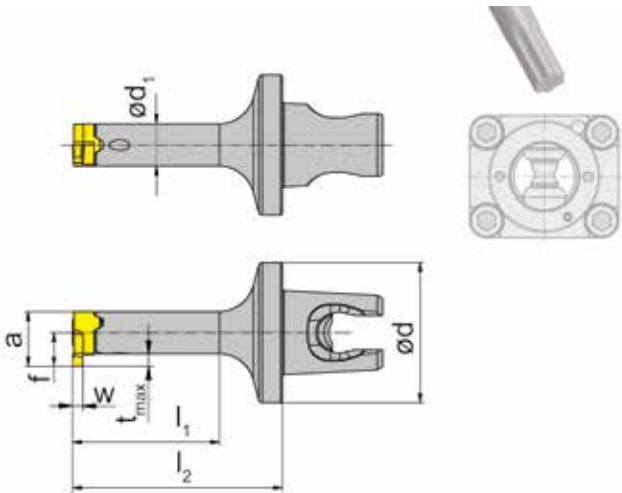
Bore Ø from

8 mm



配合刀片
for Insert

型号 108
Type S108



Kennametal KM16 Micro
系列
System Kennametal KM16
Micro

产品型号 Part number	d	l_2	d_1	l_1
B108.KM16.90.01	20	30	6	21
B108.KM16.90.02	20	35	6	26

按需提供更多尺寸
Further sizes upon request

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

尺寸单位 : mm
Dimensions in mm

螺丝的扭矩规格，详见技术说明。

For torque 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 (内圆)

Grooving (internal)



刀片
Insert

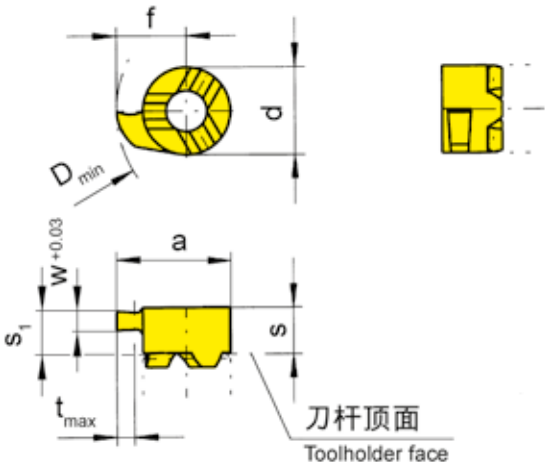
108

孔径Ø 自
卡簧宽度Nw

Bore Ø from
Width of circlip Nw

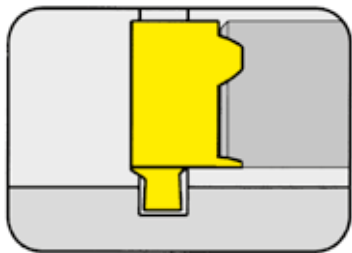
8 mm
0.7-0.9 mm

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



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version



B

配合刀杆
for Toolholder

型号 B108
Type

不能面切削， 有限的切削深度
limited depth of cut

产品型号 Part number	w	Nw	s	s ₁	f	a	d	t _{max}	D _{min}	EG55	TH35	TN35
R/L108.0070.00	0.74	0.7	3.6	3.2	4.8	7.8	6	1	8	▲/△	▲/▲	▲/▲
R/L108.0080.00	0.84	0.8	3.6	3.2	4.8	7.8	6	1	8	▲/△	▲/△	▲/▲
R/L108.0090.00	0.94	0.9	3.6	3.2	4.8	7.8	6	1	8	▲/▲	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

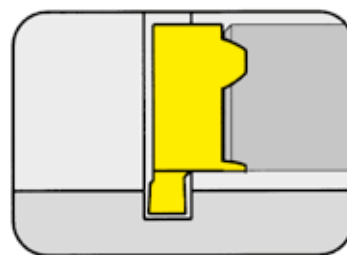
Grooving (internal)



B

刀片
Insert

108



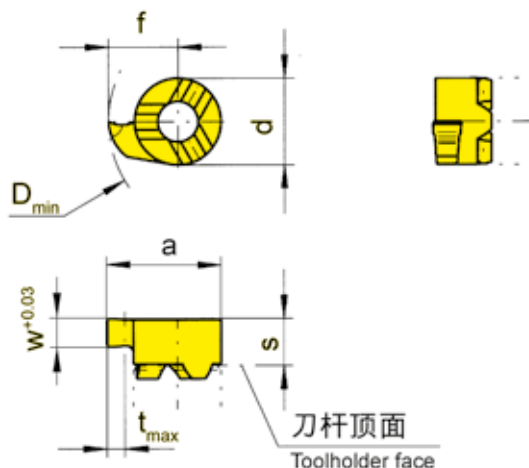
孔径Ø 自
卡簧宽度Nw

Bore Ø from
Width of circlip Nw

8 mm
1.1-1.6 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	Nw	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L108.0110.00	1.19	1.1	3.2	4.8	7.8	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲
R/L108.0130.00	1.39	1.3	3.2	4.8	7.8	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲
R/L108.0160.00	1.69	1.6	3.2	4.8	7.8	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲
										P	o	•	•
										M	•	o	•
										K	•	o	•
										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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

NC-仿形加工 (内圆)

NC-Profiling (internal)



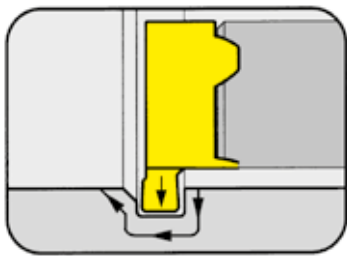
刀片
Insert

108

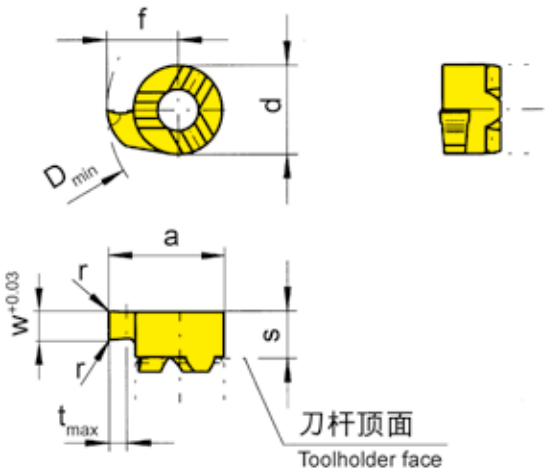
孔径Ø 自
槽深

Bore Ø from
Depth of groove

8 mm
1 mm



B



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}		MG12	EG55	TH35	TI25	TN35
R/L108.0150.02	1.5	3.2	4.8	7.8	0.2	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

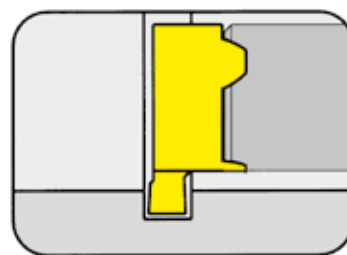
Grooving (internal)



B

刀片
Insert

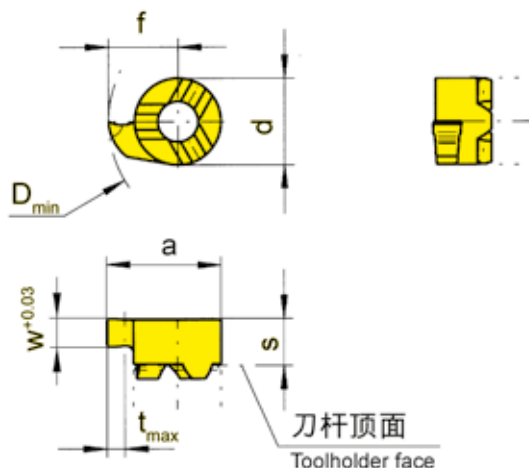
108



孔径Ø 自
槽宽

Bore Ø from
Width of groove

8 mm
1.5-2 mm



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L108.0150.00	1.5	3.2	4.8	7.8	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲
R/L108.0200.00	2.0	3.2	4.8	7.8	6	1	8		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

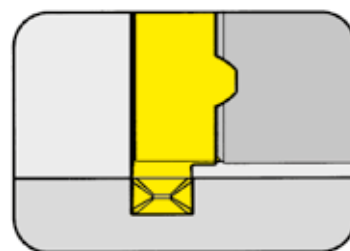
Grooving (internal)



B

刀片
Insert

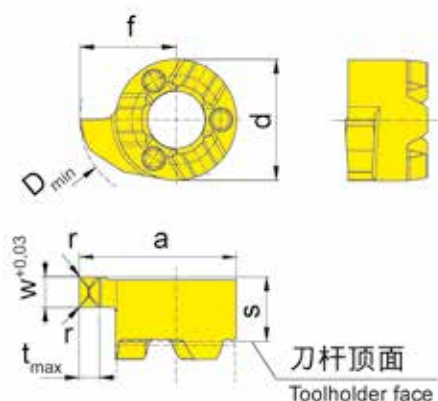
S108



孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

8 mm
1 mm
1-2 mm



刀杆顶面
Toolholder face

配合刀杆
for Toolholder

型号 B108
Type

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS108.0100.D1	1.0	3.2	4.8	7.8	0.1	6	1	8	▲/Δ	▲/▲
R/LS108.0150.D1	1.5	3.2	4.8	7.8	0.1	6	1	8	▲/Δ	▲/Δ
R/LS108.0200.D2	2.0	3.2	4.8	7.8	0.2	6	1	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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

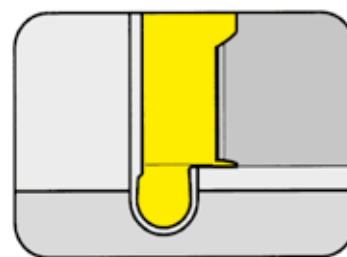
Grooving (internal)



B

刀片
Insert

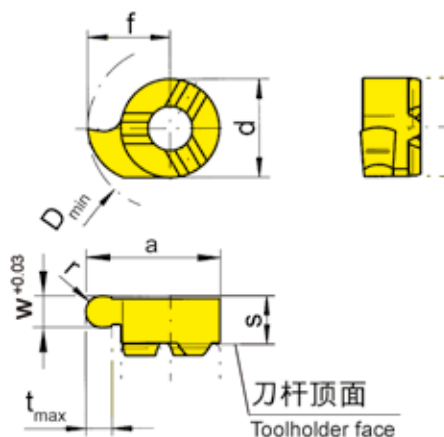
108



孔径Ø 自
圆头

Bore Ø from
Full radius

8 mm
0.4-0.9 mm



配合刀杆
for Toolholder

型号 B108
Type

刀杆顶面
Toolholder face

圆头
Full radius

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	r	t _{max}	D _{min}		MG12	EG55	TH35	TI25	TN35
R/L108.0004.08	0.8	3.2	4.8	7.8	6	0.4	1	8		▲/Δ	▲/▲	▲/▲		▲/▲
R/L108.0006.12	1.2	3.2	4.8	7.8	6	0.6	1	8		▲/▲	▲/▲	▲/▲		▲/▲
R/L108.0009.18	1.8	3.2	4.8	7.8	6	0.9	1	8		▲/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	•	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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

Insert

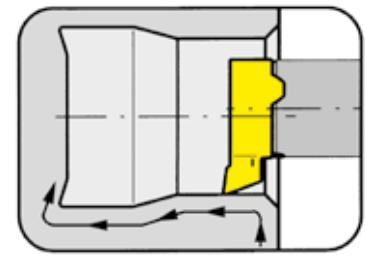
108

B

孔径Ø 自

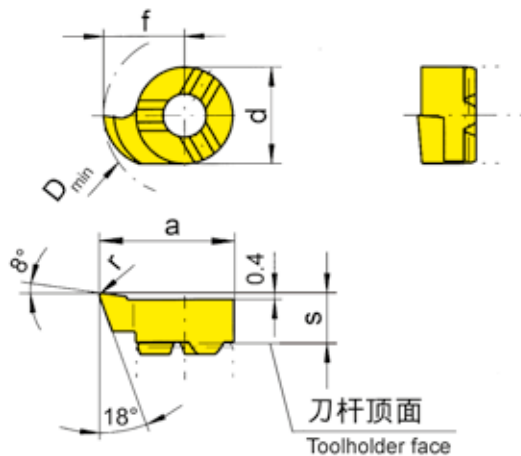
Bore Ø from

7.8 mm



配合刀杆
for Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}		MG12	EG55	TF45	TH35	TI25	TN35
R/L108.1846.02	3.4	4.65	7.65	0.2	6	7.8		▲/▲	▲/▲	Δ/x	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock								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

改进过的几何结构可以镗≥ Ø 7.8 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 7,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

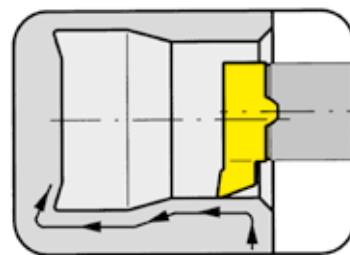
Further sizes upon request

硬质合金牌号
Carbide grades

刀片

Insert

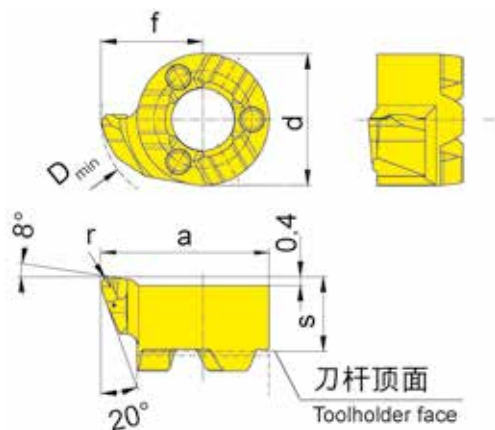
S108



孔径Ø 自

Bore Ø from

7.8 mm



配合刀杆
for Toolholder

型号 B108
Type

R型断屑槽
Geometry .R

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/LS108.1846.R2	3.4	4.65	7.65	0.2	6	7.8		▲/▲	▲/▲
R/LS108.1846.R4	3.4	4.65	7.65	0.4	6	7.8		▲/▲	▲/▲

▲ 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

改进过的几何结构可以镗≥ Ø 7.8 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 7.8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

背镗 (内圆)

Backboring (internal)



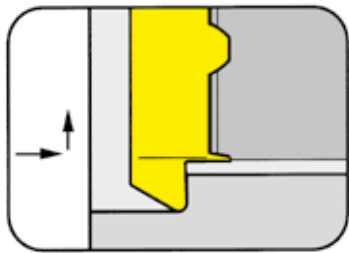
刀片
Insert

108

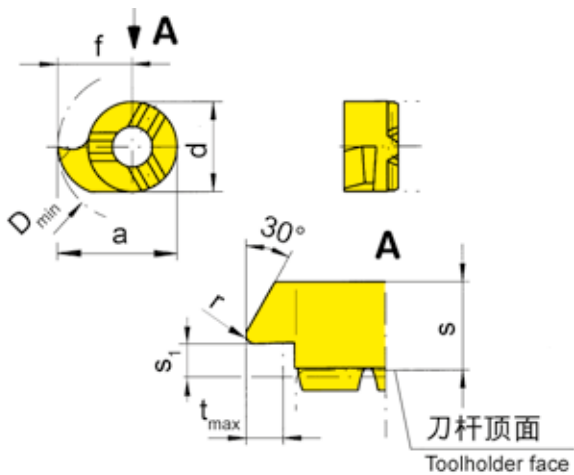
孔径Ø 自
向下切深可达

Bore Ø from
Depth of undercut up to

7.8 mm
1.3 mm



B



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	s ₁	d	t _{max}	D _{min}	EG55	TH35	TN35
R/L108.3046.02	3.6	4.65	7.65	0.2	0.8	6	1.3	7.8	▲/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

硬质合金牌号
Carbide grades

刀片

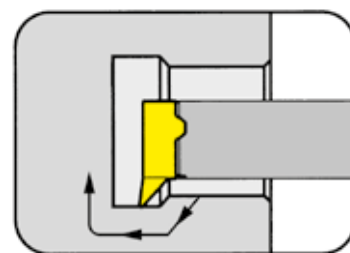
Insert

108

孔径 $\varnothing$ 自
向下切深可达

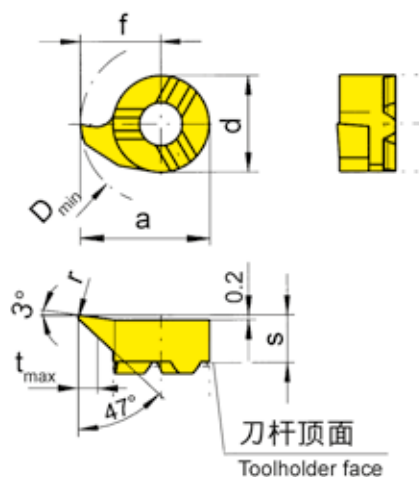
Bore $\varnothing$ from
Depth of undercut up to

7.8 mm
1.2 mm



配合刀杆
for Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L108.4748.01	3.2	4.65	7.65	0.1	6	1.2	7.8			▲/▲	▲/▲	
R/L108.4748.02	3.2	4.65	7.65	0.2	6	1.2	7.8		▲/x	▲/▲	▲/▲	▲/▲
R/L108.4748.04	3.2	4.65	7.65	0.4	6	1.2	7.8			▲/▲	▲/▲	
▲ 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

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

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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

倒角和背镗 (内圆)

Chamfering and Backboring (internal)



刀片

Insert

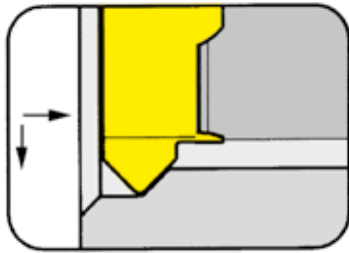
108

B

孔径Ø 自
切深可达

Bore Ø from
Depth of cut up to

7.8 mm
1.4 mm



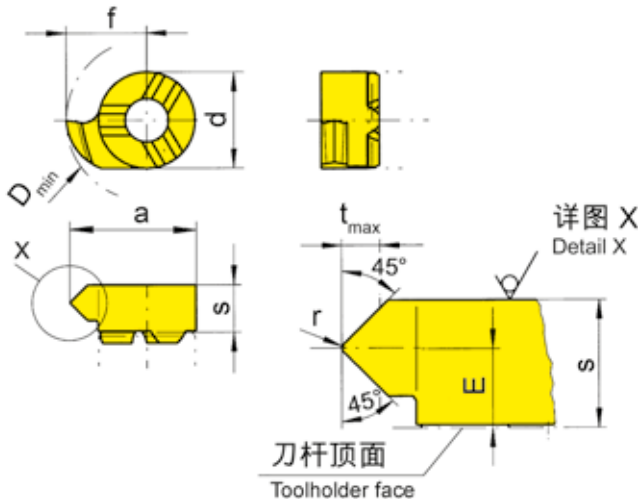
配合刀杆

for Toolholder

型号

B108

Type



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	E	s	f	a	d	r	α	t_{max}	D_{min}		EG55	TA45	TI25	TN35
R/L108.4545.02	1.8	3.6	4.65	7.65	6	0.2	45°	1.4	7.8		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号

Carbide grades

预切槽和倒角 (内圆)

Pregrooving and Chamfering (internal)



B

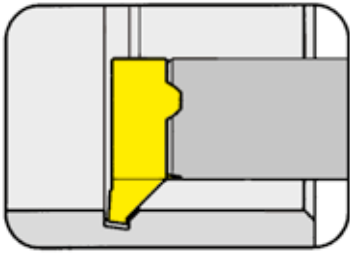
刀片
Insert

108

孔径Ø 自

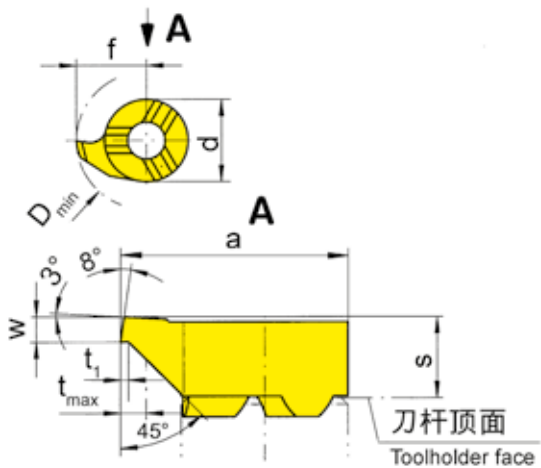
Bore Ø from

8 mm



配合刀杆
for Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	t _i	D _{min}		MG12	EG55	TI25	TN35
R/L108.0810.45	1	3.2	4.8	7.8	6	1.5	0.2	8		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



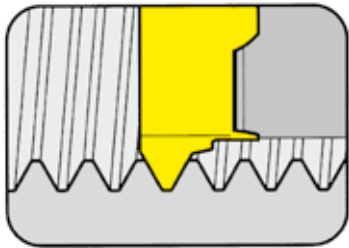
刀片
Insert

107

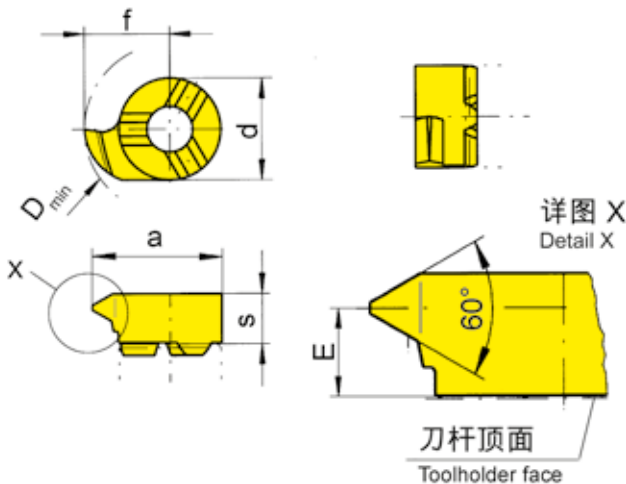
孔径Ø 自
螺距

Bore Ø from
Pitch

8 mm
1.5-1.75 mm



B



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	s	D _{min}		MG12	EG55	TH35	TN35
R/L108.0815.01	1.5	1.75	2.6	4.8	7.8	6	3.6	8		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

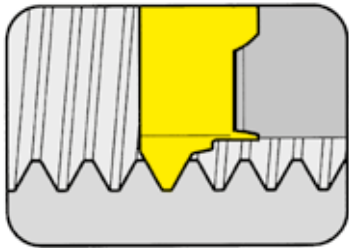
螺纹切削 (内圆) -非全牙型
Threading (internal) Partial profile



B

刀片
Insert

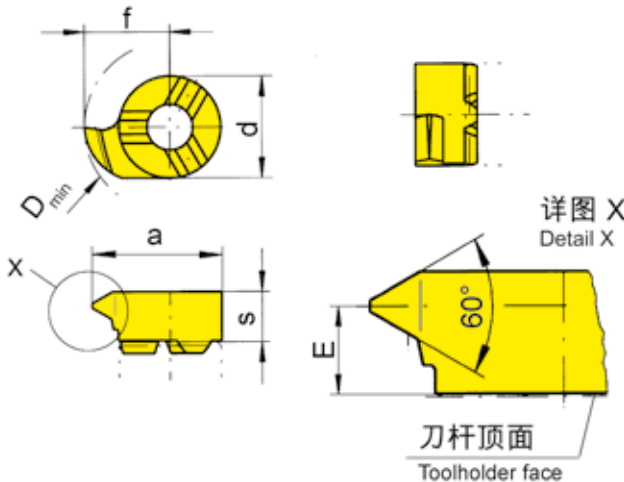
107



孔径Ø 自
螺距

Bore Ø from
Pitch

8 mm
0.5-1.25 mm



配合刀杆
for Toolholder

型号 B108
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	s	D _{min}		MG12	EG55	TH35	TI25	TN35
R/L108.0205.01	0.5	0.75	2.8	4.8	7.8	6	3.6	8		▲/△	▲/▲	▲/▲	▲/▲	▲/▲
R/L108.0510.01	1.0	1.25	2.8	4.8	7.8	6	3.6	8		▲/△	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型 Threading (internal) Full profile



刀片
Insert

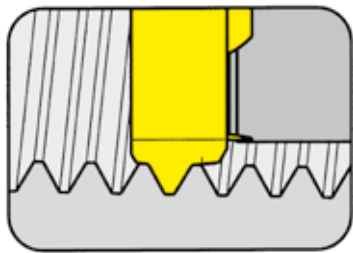
108

B

每英寸牙数

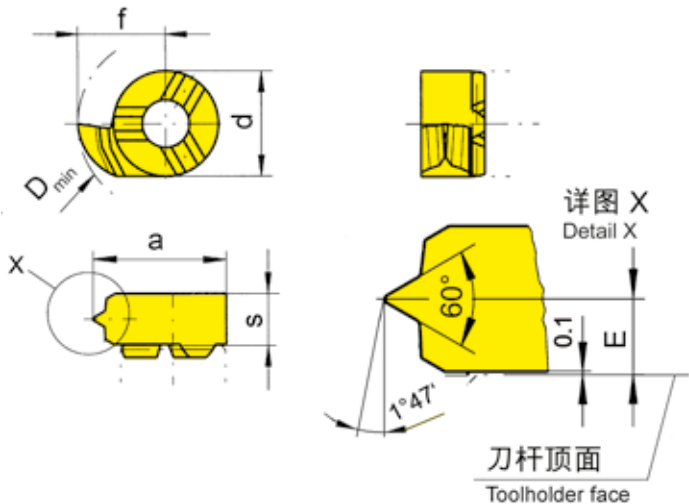
Threads per inch

18-20



配合刀杆
for Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

NPT螺纹
Thread NPT

产品型号 Part number	TPI	E	f	d	s	D _{min}	EG55	Tl25	TN35
R108.NP14.02	14	1.9	4.8	6	3.6	8	▲		▲
R108.NP18.02	18	1.9	4.8	6	3.6	8	▲	x	▲
R108.NP27.02	27	1.9	4.8	6	3.6	8	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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



B

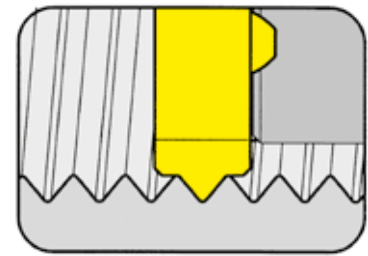
刀片
Insert

108

每英寸牙数

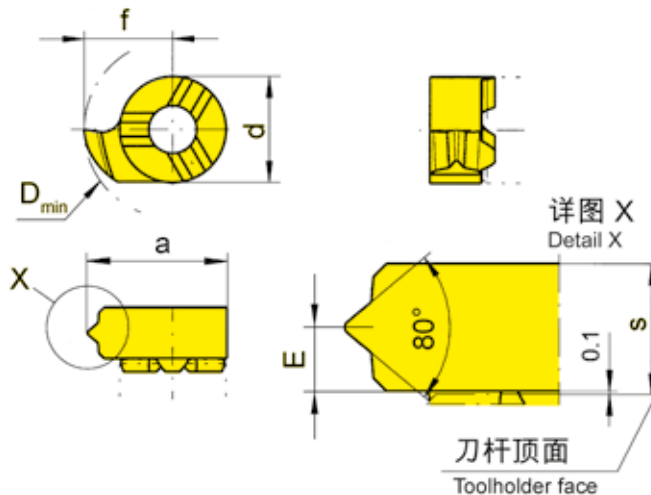
Threads per inch

18-20



配合刀杆
for Toolholder

型号 B108
Type



R=右手型-如图
R = right hand version shown

螺纹轮廓PG
Thread profile PG

产品型号 Part number	TPI	E	f	d	s	D _{min}		EG55	TN35
R108.PG18.02	18	1.9	4.8	6	3.6	8		▲	▲
R108.PG20.02	20	1.9	4.8	6	3.6	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

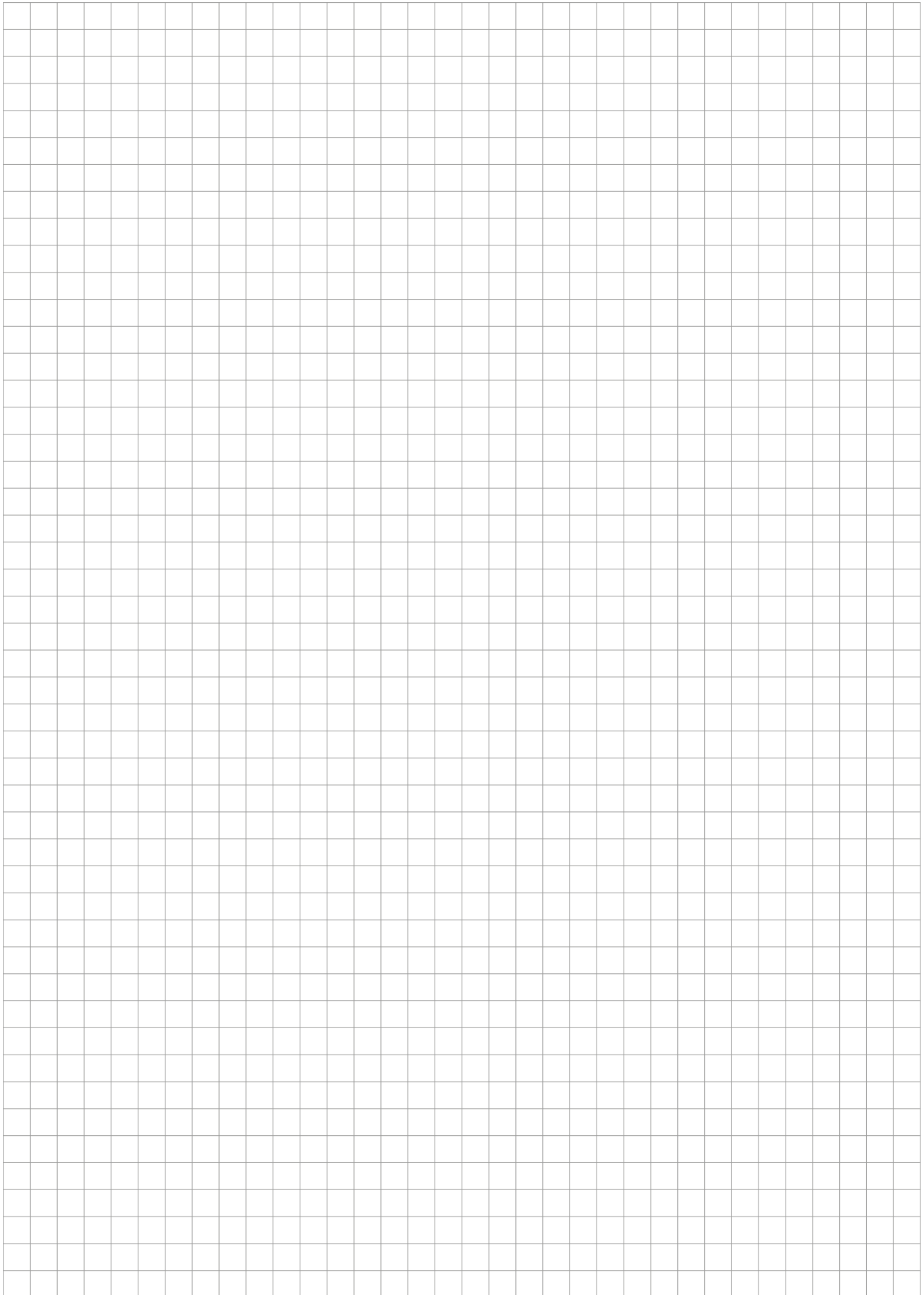
Dimensions in mm

按需提供更多尺寸

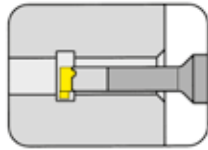
Further sizes upon request

硬质合金牌号
Carbide grades

P	●	●
M	○	●
K	○	●
N	-	●
S	-	●
H	-	-

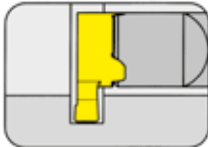


刀杆
Toolholder
B10P



页/Page
B47-B49

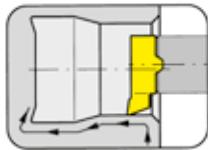
刀片
Insert
10P/S10P



页/Page
B50, B52



页/Page
B51, B53



页/Page
B54

10P



机夹式刀杆

槽宽 1 - 3 mm

Toolholder with Inserts

Width of groove 1 - 3 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring

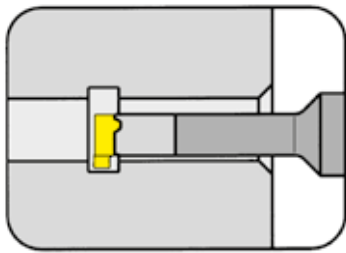


刀杆

Toolholder

B10P

直接冷却液供应
with through coolant supply

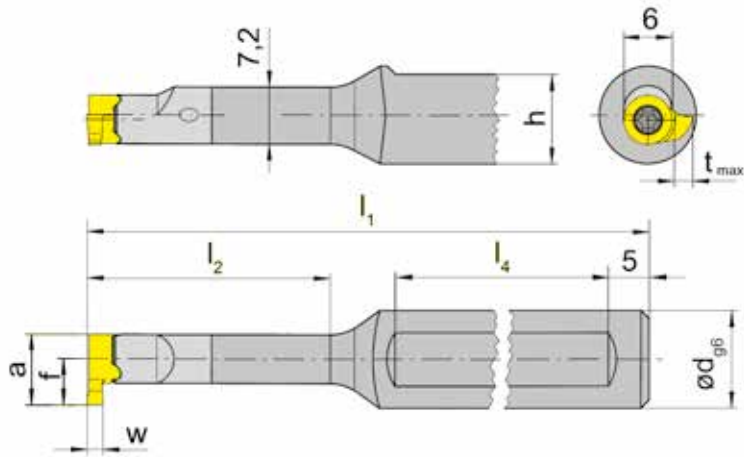


孔径Ø 自	Bore Ø from	9 mm
槽深可达	Depth of groove up to	3 mm
槽宽可达	Width of groove up to	3 mm

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

配合刀片
for Insert

型号 10P
Type S10P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	l ₄
R/LB10P.0012.00	12	70	12.5	11	40
R/LB10P.0012.01	12	80	21.0	11	45
R/LB10P.0012.02	12	90	30.0	11	45
R/LB10P.0012.03	12	100	42.0	11	45

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB10P...	2.6.5T8EP	T8PL

切槽和镗孔

Grooving and Boring



B

刀杆

Toolholder

B10P

直接冷却液供应
with through coolant supply

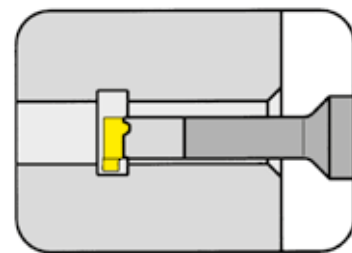
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

9 mm
3 mm
3 mm

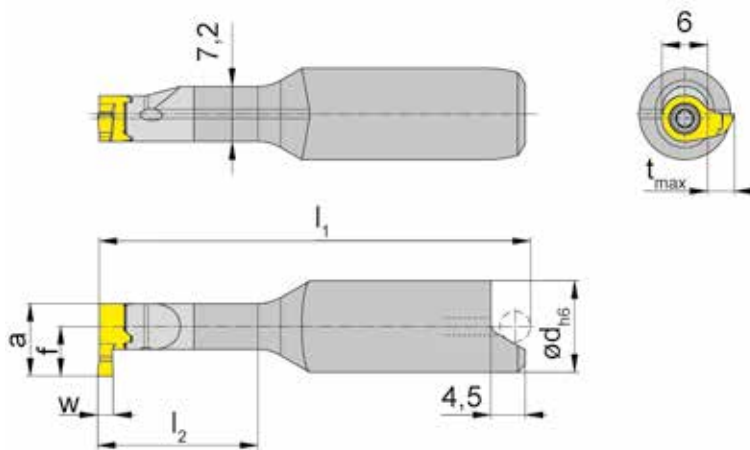
刀杆材质：整体硬质合金 - 良好的抗振性能

Material of shank: Carbide - Giving a good vibration resistance



配合刀片
for Insert

型号 10P
Type S10P



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

用于收缩型定位
for shrinkage location

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

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB10P...	2.6.5T8EP	T8PL

切槽和镗孔

Grooving and Boring

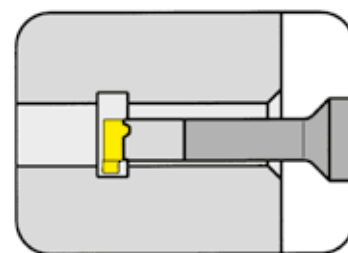


B

刀杆

Toolholder

B10P



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

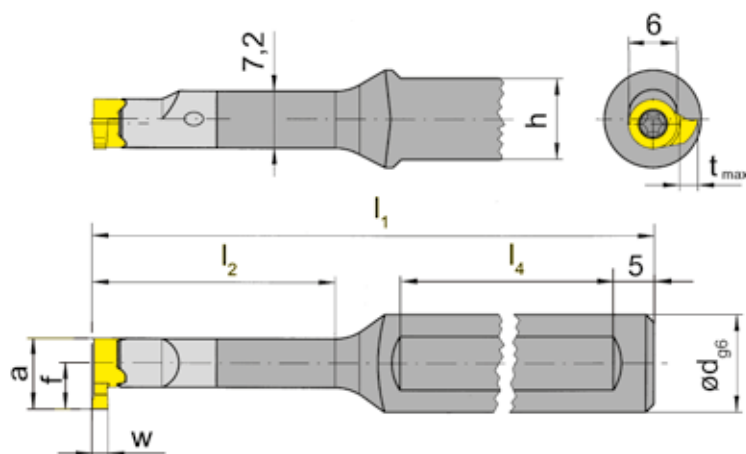
9 mm
3 mm
3 mm

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 10P
Type S10P



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

带2个夹持面
with 2 clamping flats

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

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB10P...	2.6.5T8EP	T8PL

切槽 (内圆)

Grooving (internal)



B

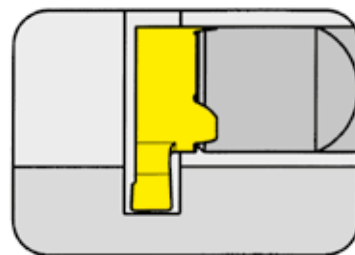
刀片
Insert

10P

孔径Ø 自
槽深可达
槽宽

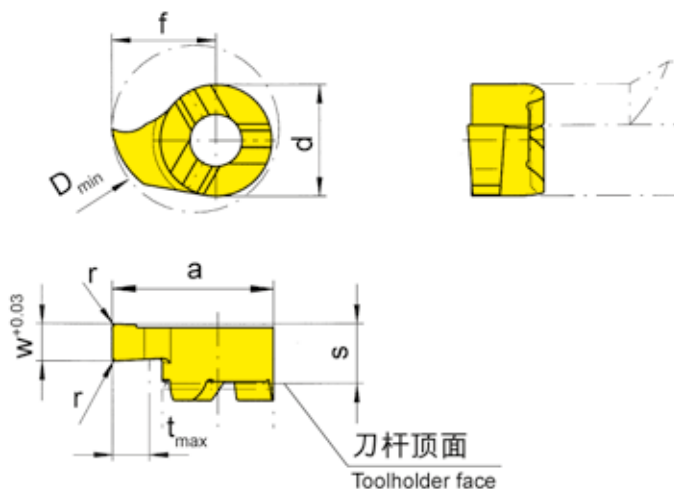
Bore Ø from
Depth of groove up to
Width of groove

9 mm
2 mm
1-3 mm



配合刀杆
for Toolholder

型号 B10P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L10P.0100.1.00	1.0	3.6	5.5	8.5	-	6	2	9	▲/▲	▲/▲
R/L10P.0150.1.00	1.5	3.6	5.5	8.5	-	6	2	9	▲/Δ	▲/▲
R/L10P.0200.1.02	2.0	3.6	5.5	8.5	0.2	6	2	9	▲/▲	▲/▲
R/L10P.0250.1.02	2.5	3.6	5.5	8.5	0.2	6	2	9	▲/Δ	▲/▲
R/L10P.0300.1.02	3.0	3.6	5.5	8.5	0.2	6	2	9	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



刀片
Insert

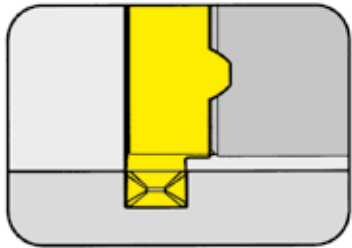
S10P

B

孔径Ø 自
槽深可达
槽宽

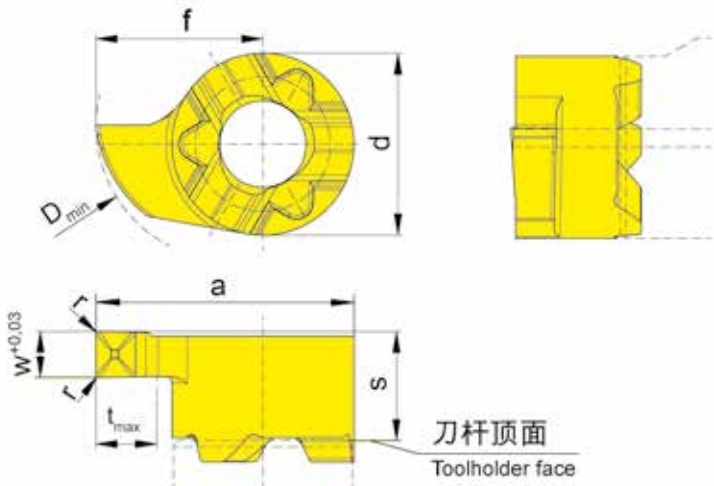
Bore Ø from
Depth of groove up to
Width of groove

9 mm
2 mm
1-2 mm



配合刀杆
for Toolholder

型号 B10P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35
R/LS10P.0100.1.D1	1.0	3.6	5.5	8.5	0.1	6	2	9		▲/Δ	▲/▲
R/LS10P.0150.1.D1	1.5	3.6	5.5	8.5	0.1	6	2	9			▲/▲
R/LS10P.0200.1.D2	2.0	3.6	5.5	8.5	0.2	6	2	9			▲/Δ
										P	•
										M	o
										K	o
										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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

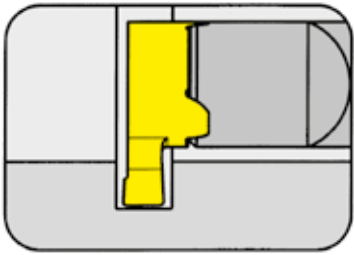
Grooving (internal)



B

刀片
Insert

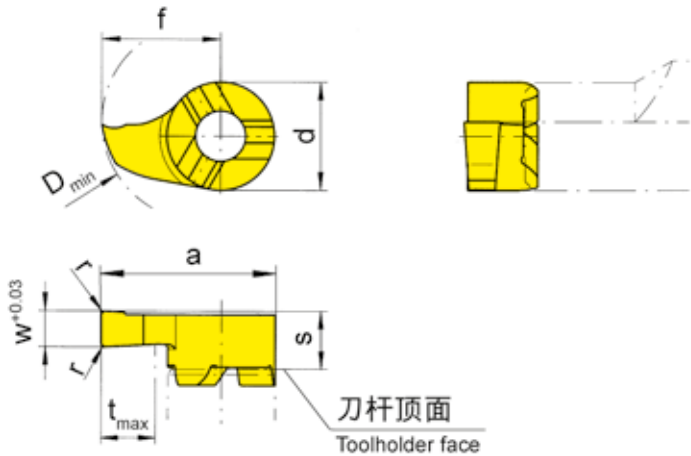
10P



孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

10 mm
3 mm
1-2 mm



配合刀杆
for Toolholder

型号 B10P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L10P.0100.2.00	1.0	3.6	6.5	9.5	-	6	3	10	▲/Δ	▲/▲
R/L10P.0150.2.00	1.5	3.6	6.5	9.5	-	6	3	10	▲/▲	▲/▲
R/L10P.0200.2.02	2.0	3.6	6.5	9.5	0.2	6	3	10	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



刀片
Insert

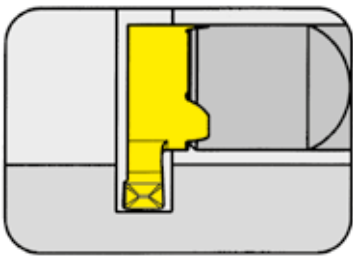
S10P

B

孔径Ø 自
槽深可达
槽宽

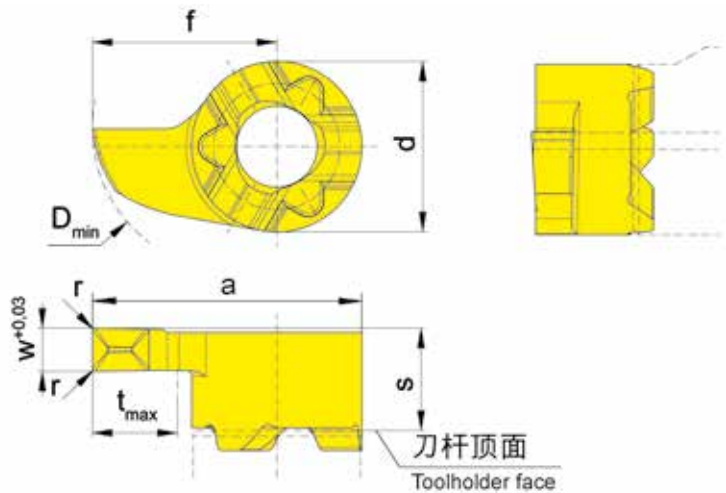
Bore Ø from
Depth of groove up to
Width of groove

10 mm
3 mm
1.5-2 mm



配合刀杆
for Toolholder

型号 B10P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS10P.0150.2.D1	1.5	3.6	6.5	9.5	0.1	6	3	10	▲/▲	▲/▲
R/LS10P.0200.2.D2	2.0	3.6	6.5	9.5	0.2	6	3	10	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

刀片

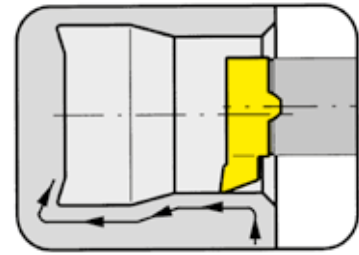
Insert

S10P

孔径Ø 自

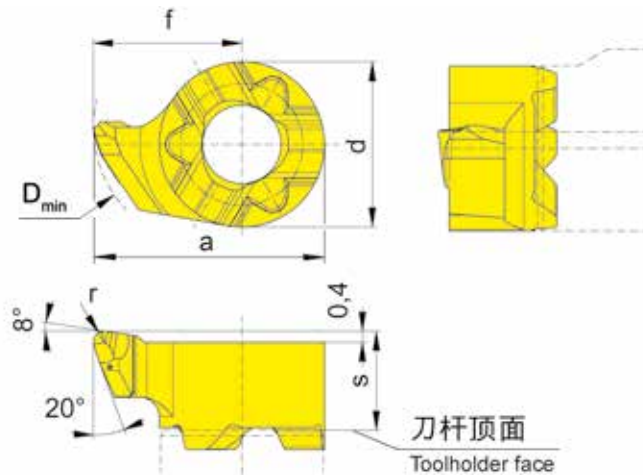
Bore Ø from

8.8 mm



配合刀杆
for Toolholder

型号 B10P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/LS10P.1854.R2	3.6	5.4	8.4	0.2	6	8.8		▲/▲	▲/▲
R/LS10P.1854.R4	3.6	5.4	8.4	0.4	6	8.8		▲/▲	▲/▲

▲ 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

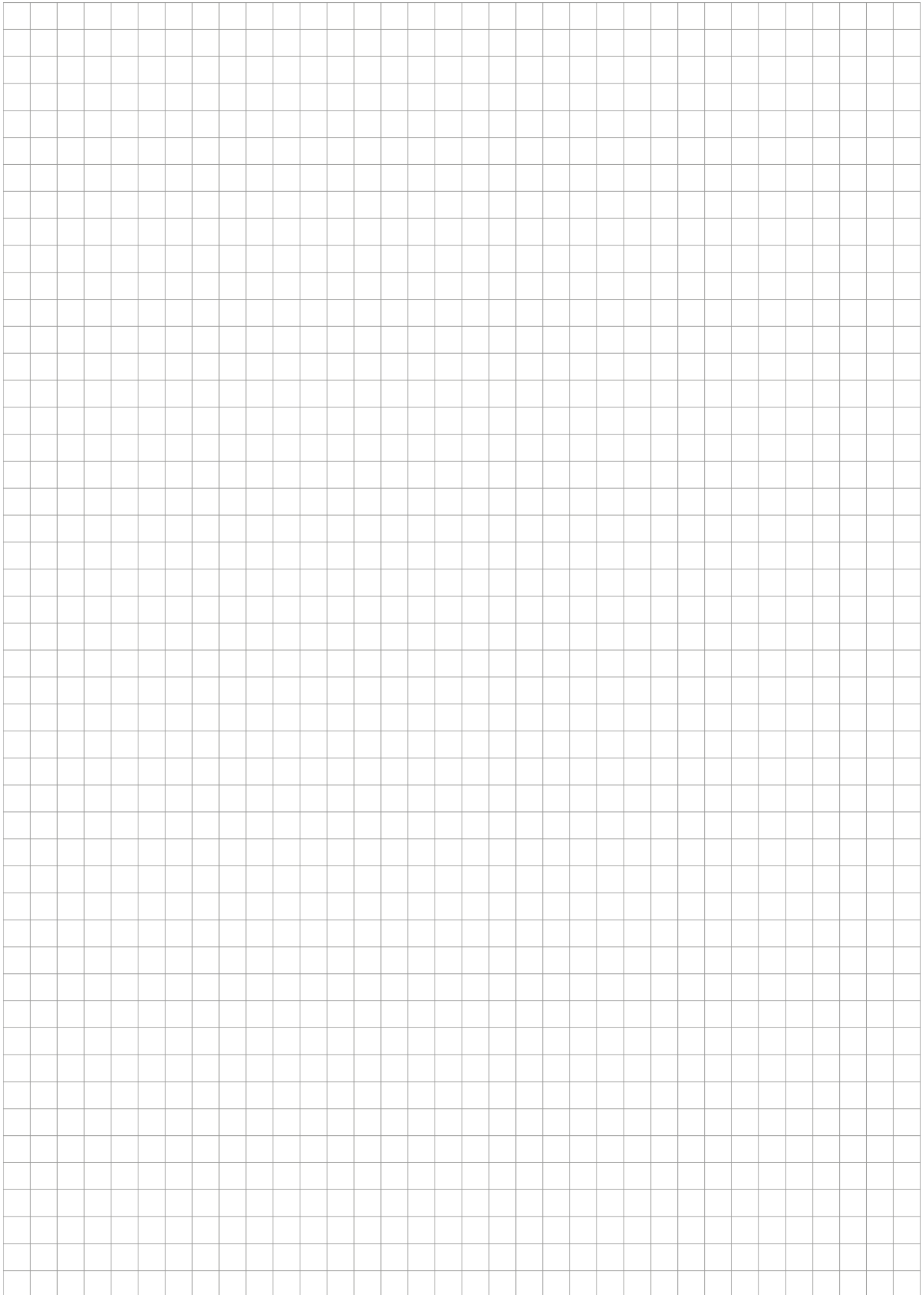
改进后的几何结构可以镗≥Ø8.8mm的孔和仿形加工DIN509E型和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 8.8 mm and profiling of reliefs as per DIN 509 form E and F.

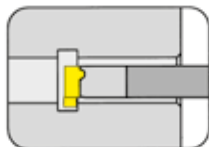
按需提供更多尺寸

Further sizes upon request

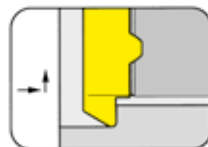
硬质合金牌号
Carbide grades



刀杆
Toolholder
B111

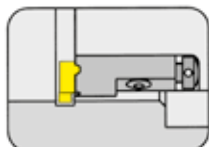


页/Page
B59-B61

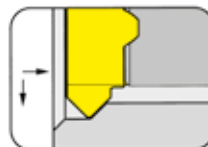


页/Page
B71

刀夹
Cartridge
125



页/Page
B62

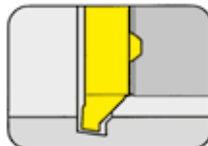


页/Page
B73

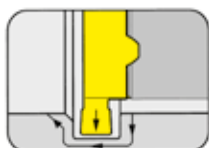
刀片
Insert
111/S111/S111



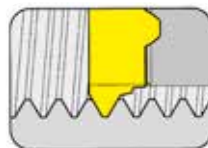
页/Page
B63-B64, B66



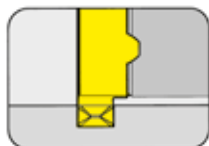
页/Page
B74



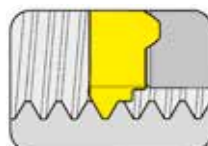
页/Page
B65



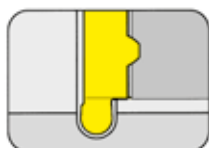
页/Page
B75-B76



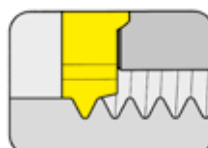
页/Page
B67



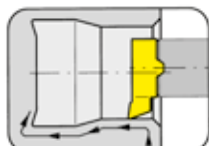
页/Page
B77-B78



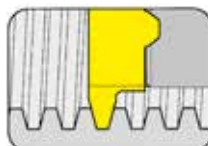
页/Page
B68



页/Page
B79



页/Page
B69-B70, B72



页/Page
B80

111



机夹式刀杆

槽宽0,7 - 3,0 mm

Toolholder with Inserts

Width of groove 0,7 - 3,0 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽和镗孔

Grooving and Boring



刀杆

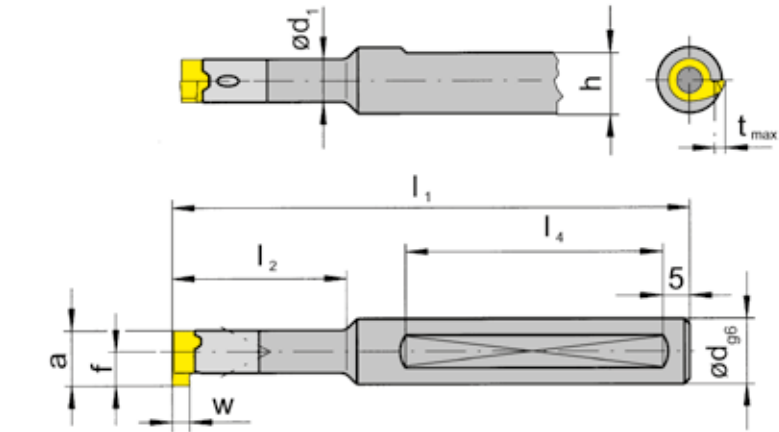
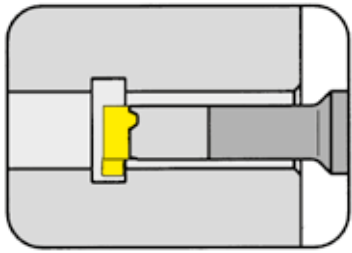
Toolholder

B111

直接冷却液供应
with through coolant supply

孔径Ø 自 槽深可达 槽宽可达	Bore Ø from Depth of groove up to Width of groove up to	11 mm 2,3 mm 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 111
Type S111



图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	l ₄	d ₁
B111.0008.01A	8	80	-	-	-	-
B111.0012.00	12	75	16.5	11	40	8
B111.0012.01	12	95	29.0	11	50	8
B111.0012.02	12	110	42.0	11	50	8
B111.0012.03	12	120	56.0	11	50	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：
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
B111...	3.5.12T10EP	T10PL

切槽和镗孔

Grooving and Boring



B

刀杆

Toolholder

B111

直接冷却液供应
with through coolant supply

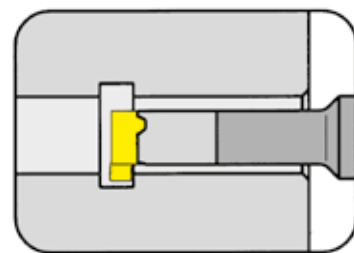
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

11 mm
2,3 mm
3 mm

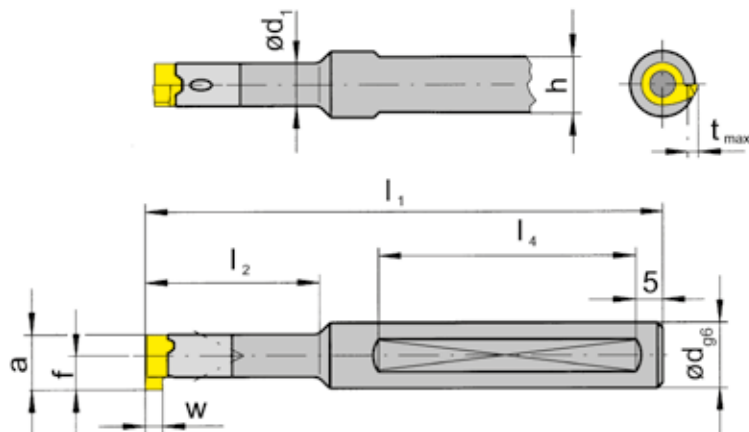
刀杆材质：整体硬质合金 - 良好的抗振性能

Material of shank: Carbide - Giving a good vibration resistance



配合刀片
for Insert

型号 111
Type S111



R=右手型-如图

R = right hand version shown

带2个夹持面
with 2 clamping flats

产品型号 Part number	d	l_1	l_2	h	l_4	d_1
B111.0012.2.00	12	75	16.5	11	40	8
B111.0012.2.01	12	95	29.0	11	50	8
B111.0012.2.02	12	110	42.0	11	50	8
B111.0012.2.03	12	120	56.0	11	50	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：

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
B111...	3.5.12T10EP	T10PL

切槽和镗孔

Grooving and Boring



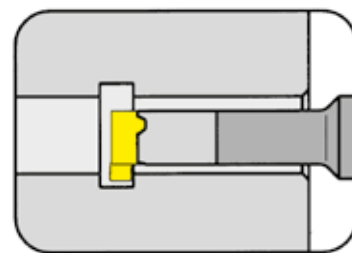
B

刀杆

Toolholder

B111

直接冷却液供应
with through coolant supply



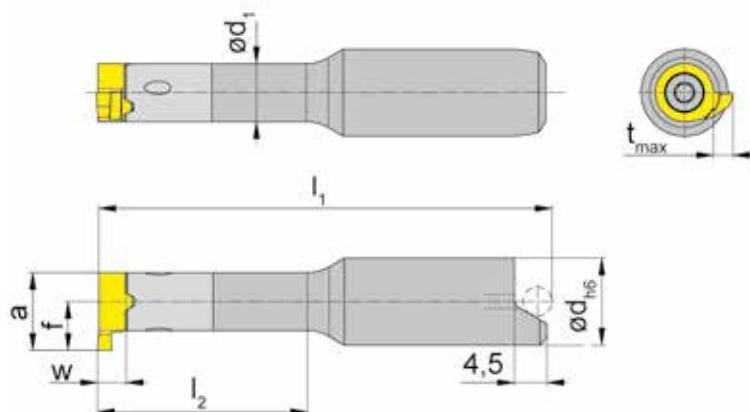
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

11 mm
2,3 mm
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 111
Type S111

用于收缩型定位
for shrinkage location

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2	f	d_1
B111.0012.00S	12	50.7	16.5	6.7	8
B111.0012.01S	12	62.7	29.0	6.7	8
B111.0012.02S	12	75.7	42.0	6.7	8
B111.0012.03S	12	89.7	56.0	6.7	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：

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
B111...	3.5.12T10EP	T10PL

切槽 (内圆)

Grooving (internal)

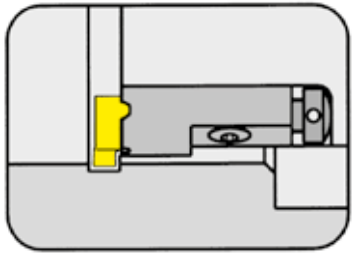


B

刀夹

Cartridge

125
定制化刀具
for customized tools



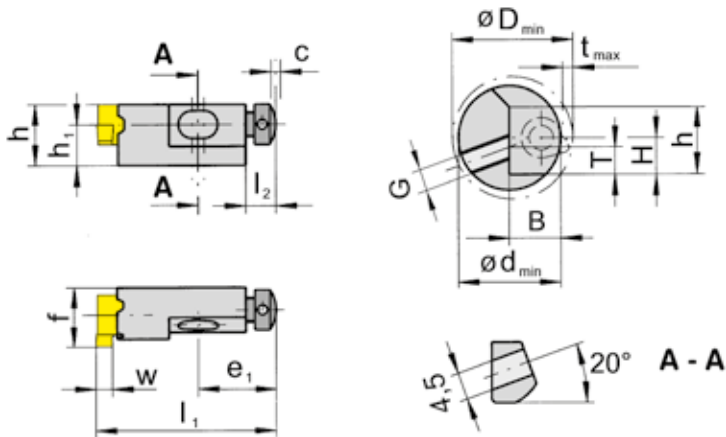
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

20 mm
2.3 mm
3 mm

配合刀片
for Insert

型号 111
Type S111



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	h	l ₁	h ₁	f	E ₁	l ₂	C	D _{min}	t _{max}	夹持范围 Clamping range
R/L125.0608.00	10	30	6	11.2	12.8	5	2	20	2.3	0.5-3.0

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位 : mm
Dimensions in mm

切削刃高度h₁
根据客户需要也可以使高度h₁=5mm

Height of cutting edge h₁
Special height h₁ = 5 mm available 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.

刀夹型号 Seating sizes	H	T	B	G	d _{min}	h
R/L125.0608.00	6	4,5	8,5	M4	16	10

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	轴向调节螺钉 Setting screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L125.0608.00	3.5.12T10EP	4.06.020	T10PL

切槽 (内圆)

Grooving (internal)



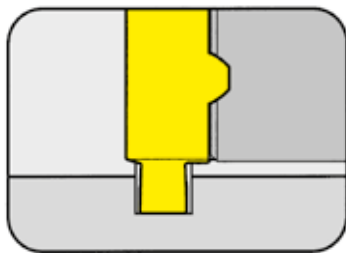
刀片
Insert

111

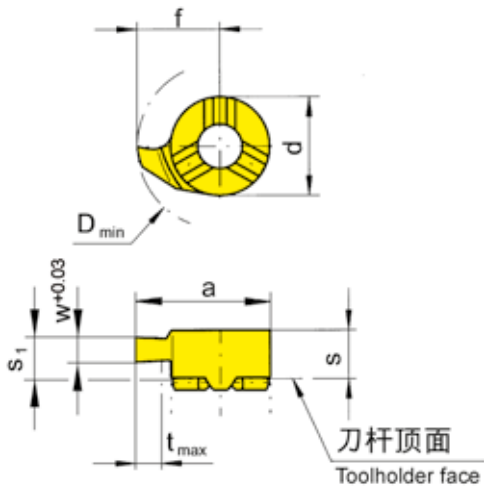
孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11 mm
2.3 mm
2 mm



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



配合刀杆
for Toolholder

型号 B111
Type 125

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

不能面切削， 有限的切削
深度
limited depth of cut

产品型号 Part number	w	Nw	s	s ₁	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L111.0070.00	0.74	0.7	4.15	3.95	6.7	10.7	8	1.2	11			▲/▲	▲/▲	▲/▲
R/L111.0080.00	0.84	0.8	4.15	3.95	6.7	10.7	8	1.3	11			▲/▲	▲/▲	▲/▲
R/L111.0090.00	0.94	0.9	4.15	3.95	6.7	10.7	8	1.5	11		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

切槽 (内圆)

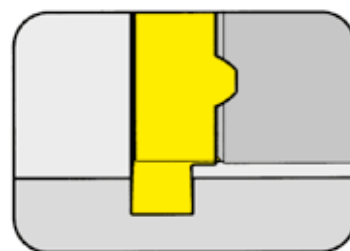
Grooving (internal)



B

刀片
Insert

111



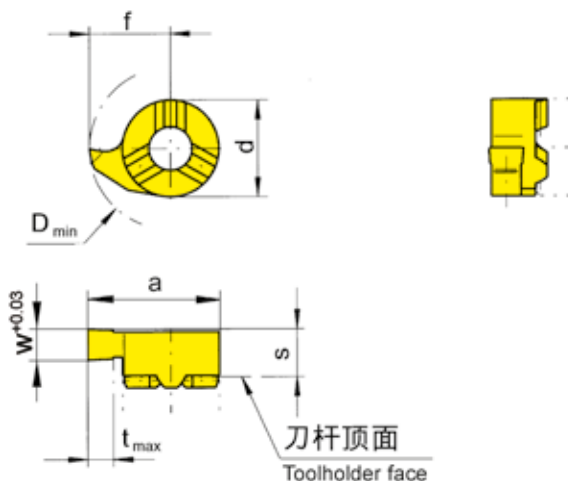
孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11 mm
2.3 mm
2 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B111
Type 125

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	Ds	w	Nw	s	f	a	d	t _{max}	D _{min}	Z		MG12	EG55	TH35	TN35
R/L111.0110.00	13.4	1.19	1.1	3.95	6.7	10.7	8	2.3	11	1		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0130.00	13.4	1.39	1.3	3.95	6.7	10.7	8	2.3	11	1		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0160.00	13.4	1.69	1.6	3.95	6.7	10.7	8	2.3	11	1		▲/▲	▲/▲	▲/▲	▲/▲
												P	o	•	•
												M	•	o	•
												K	•	o	•
												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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

NC-仿形加工 (内圆)

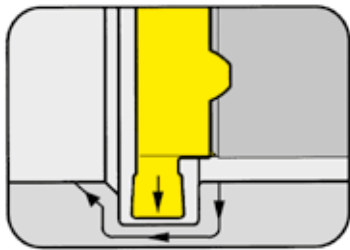
NC-Profiling (internal)



B

刀片
Insert

111



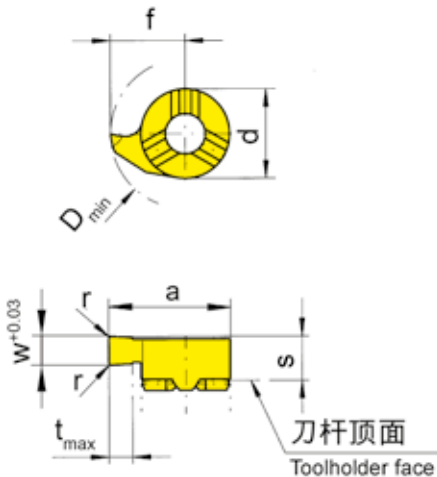
孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11 mm
2.3 mm
2 mm

配合刀杆
for Toolholder

型号 B111
Type 125



R=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	d	t _{max}	D _{min}		MG12	EG55	TH35	TI25	TN35
R/L111.0200.02	2	3.95	6.7	10.7	0.2	8	2.3	11		▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

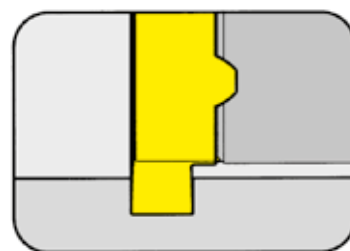
切槽 (内圆) Grooving (internal)



B

刀片 Insert

111



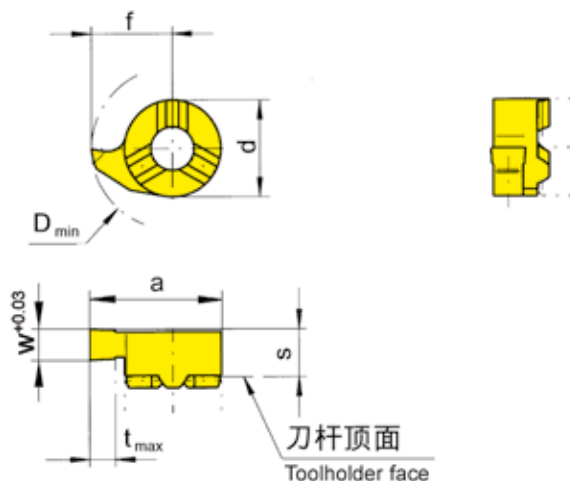
孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11 mm
2.3 mm
1.5-2.5 mm

配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	f	d	s	a	t _{max}	Ds	D _{min}	Z		MG12	EG55	TH35	TN35
R/L111.0100.1.00	1.0	6.7	8	3.95	10.7	2.3	13.4	11	1			Δ/Δ		▲/▲
R/L111.0150.00	1.5	6.7	8	3.95	10.7	2.3	13.4	11	1		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0200.00	2.0	6.7	8	3.95	10.7	2.3	13.4	11	1		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0250.00	2.5	6.7	8	3.95	10.7	2.3	13.4	11	1		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0300.00	3.0	6.7	8	3.95	10.7	2.3	13.4	11	1		▲/▲	▲/▲	▲/▲	▲/▲

▲ 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

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

硬质合金牌号
Carbide grades

切槽 (内圆)

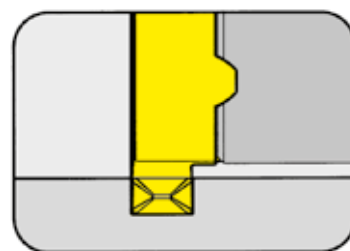
Grooving (internal)



B

刀片
Insert

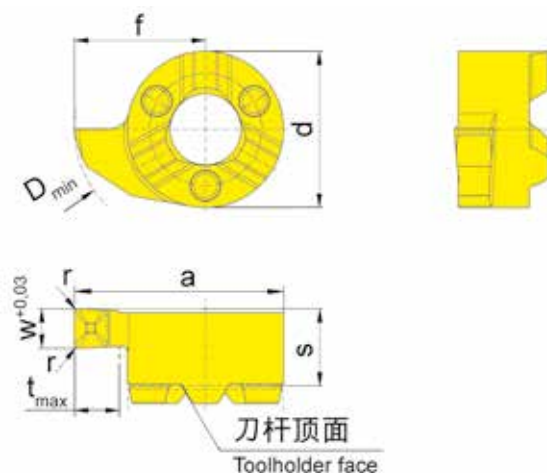
S111



孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11 mm
2.3 mm
1.5-2.5 mm



配合刀杆
for Toolholder

型号 B111
Type 125

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS111.0150.D1	1.5	3.95	6.7	10.7	0.1	8	2.3	11	▲/Δ	▲/▲
R/LS111.0200.D2	2.0	3.95	6.7	10.7	0.2	8	2.3	11	▲/▲	▲/▲
R/LS111.0250.D2	2.5	3.95	6.7	10.7	0.2	8	2.3	11	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

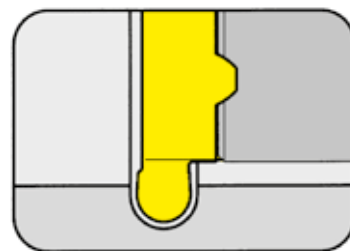
切槽 (内圆) Grooving (internal)



B

刀片
Insert

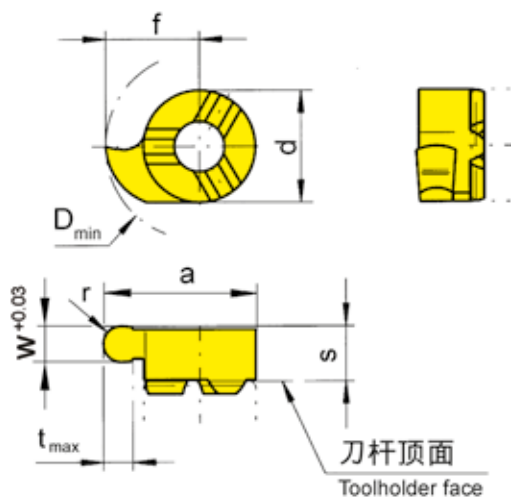
111



孔径Ø 自
槽深可达
圆头

Bore Ø from
Depth of groove up to
Full radius

11 mm
2.3 mm
0.4-1.5 mm



配合刀杆
for Toolholder

型号 B111
Type 125

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	s	f	a	d	r	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L111.0004.08	0.8	3.95	6.7	10.7	8	0.4	2.3	11			▲/▲	▲/▲	▲/▲
R/L111.0006.12	1.2	3.95	6.7	10.7	8	0.6	2.3	11		▲/Δ	▲/▲	▲/▲	▲/▲
R/L111.0009.18	1.8	3.95	6.7	10.7	8	0.9	2.3	11		▲/Δ	▲/▲	▲/▲	▲/▲
R/L111.0010.20	2.0	3.95	6.7	10.7	8	1.0	2.3	11		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.0015.30	3.0	3.95	6.7	10.7	8	1.5	2.3	11		▲/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

按需提供更多尺寸

Further sizes upon request

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

硬质合金牌号
Carbide grades

刀片

Insert

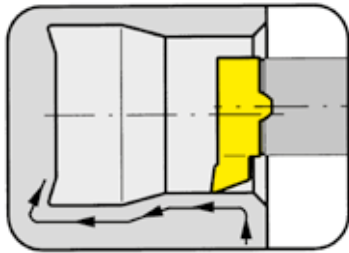
111

B

孔径Ø 自

Bore Ø from

9.8 mm

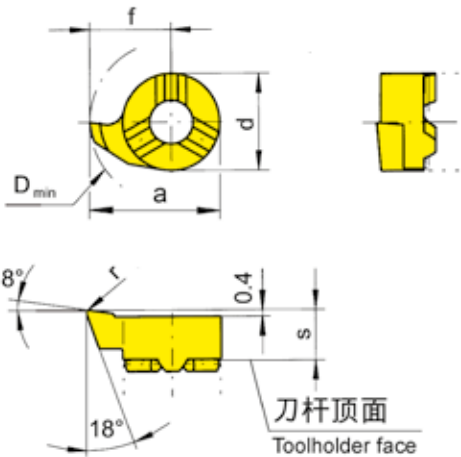


配合刀杆

for Toolholder

型号 B111

Type 125



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	MG12	EG55	TH35	TI25	TN35
R/L/111.1855.02	3.95	5.5	9.5	0.2	8	9.8	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
R/L/111.1867.02	3.95	6.7	10.7	0.2	8	11.0	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

改进过的几何结构可以镗≥ Ø9.8 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 9,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

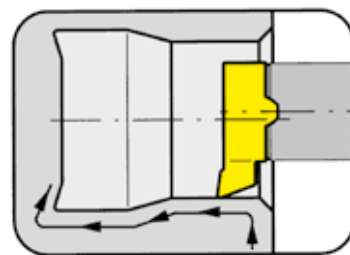
Further sizes upon request

硬质合金牌号

Carbide grades

刀片 Insert

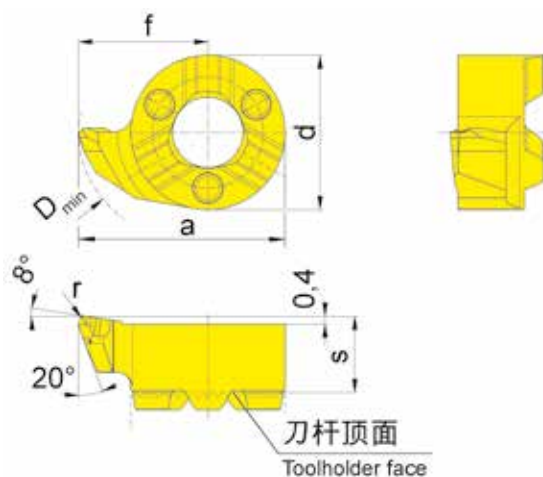
S111



孔径Ø 自

Bore Ø from

11 mm



配合刀杆
for Toolholder

型号 B111
Type 125

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/LS111.1867.R2	3.95	6.7	10.7	0.2	8	11		▲/▲	▲/▲
R/LS111.1867.R4	3.95	6.7	10.7	0.4	8	11		▲/▲	▲/▲
▲ 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

改进过的几何结构可以镗≥ Ø 11 mm的孔，也可以仿形车DIN509标准E和F形式的退刀槽。

The modified geometry allows boring of bores ≥ Ø 11 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

背镗 (内圆)

Backboring (internal)



刀片
Insert

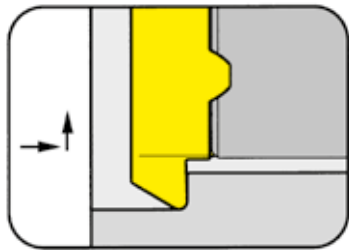
111

B

孔径Ø 自
向下切深可达

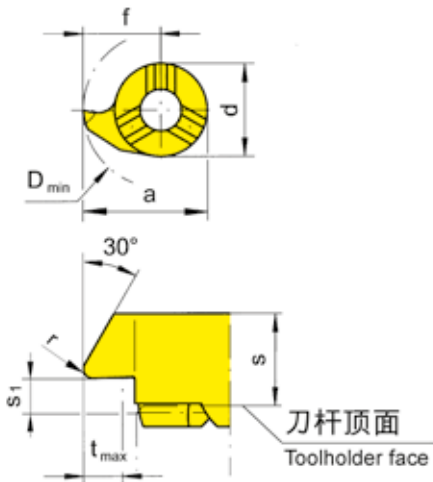
Bore Ø from
Depth of undercut up to

11 mm
2.3 mm



配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	s	f	a	r	s ₁	d	t _{max}	D _{min}	EG55	TH35	TN35
R/L111.3067.02	4.15	6.7	10.7	0.2	1.4	8	2.3	11	▲/▲	▲/▲	▲/▲
R/L111.3067.04	4.15	6.7	10.7	0.4	1.4	8	2.3	11	△/▲	▲/△	△/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling



B

刀片

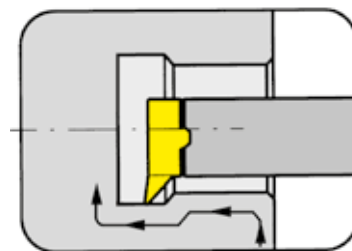
Insert

111

孔径Ø 自
向下切深可达

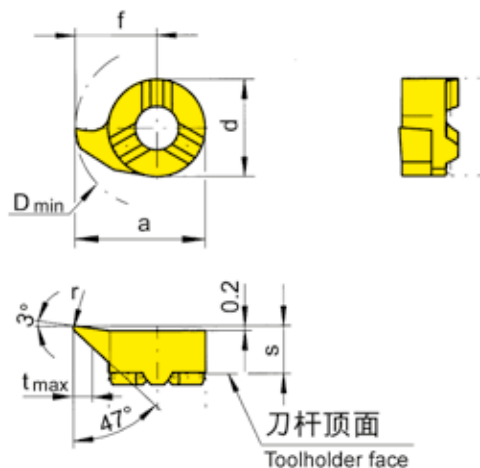
Bore Ø from
Depth of undercut up to

11 mm
2.3 mm



配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35	Ti25	TN35
R/L111.4767.02	3.95	6.7	10.7	0.2	8	2.3	11		▲/▲	▲/▲	▲/▲	▲/▲
R/L111.4767.04	3.95	6.7	10.7	0.4	8	2.3	11		▲/▲	▲/▲	x/Δ	
▲ 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

改进后的几何结构可以镗≥Ø 11.0mm孔和加工DIN509E型退刀槽

The modified geometry allows boring of bores ≥ Ø 11,0 mm and profiling of reliefs as per DIN 509 form E.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

倒角和背镗 (内圆)

Chamfering and Backboring (internal)



刀片

Insert

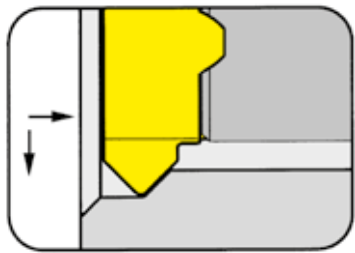
111

B

孔径Ø 自
向下切深可达

Bore Ø from
Depth of undercut up to

11 mm
2.3 mm

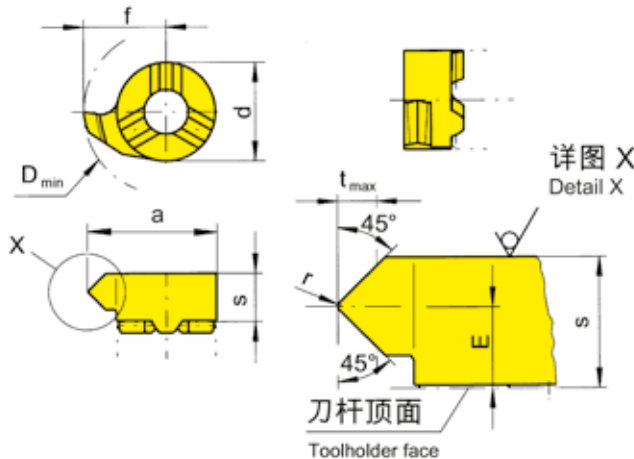


配合刀杆

for Toolholder

型号 B111

Type 125



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	E	s	f	a	d	r	t _{max}	D _{min}	EG55	TN35
R/L111.4545.02	2.4	4.15	6.7	10.7	8	0.2	1.5	11	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

Pregrooving and Chamfering (internal)



B

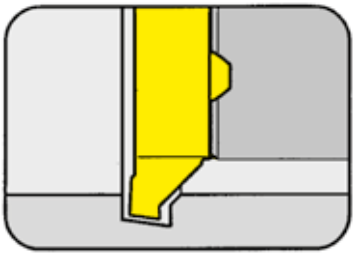
刀片
Insert

111

孔径Ø 自

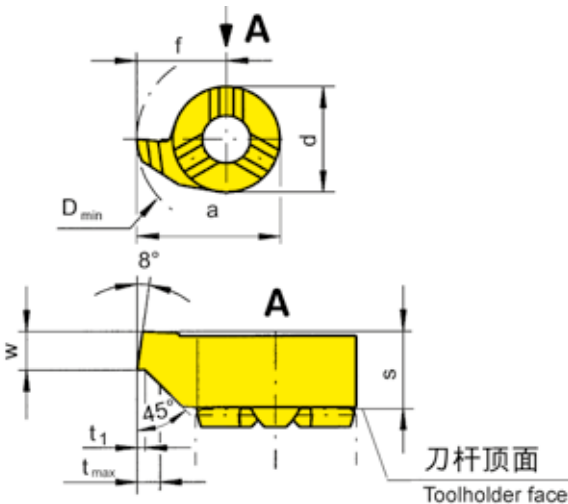
Bore Ø from

11 mm



配合刀杆
for Toolholder

型号 B111
Type 125



R=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	a	f	d	t _{max}	t _{1max}	D _{min}		MG12	EG55	Ti25
R/L111.0810.45	1	3.95	10.7	6.7	8	1.5	0.2	11		▲/△	▲/▲	▲/▲
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



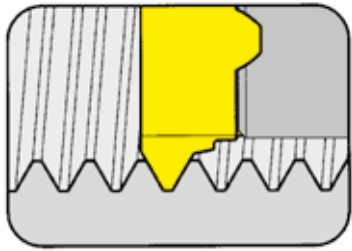
刀片
Insert

111

孔径Ø 自
向下切深可达

Bore Ø from
Depth of undercut up to

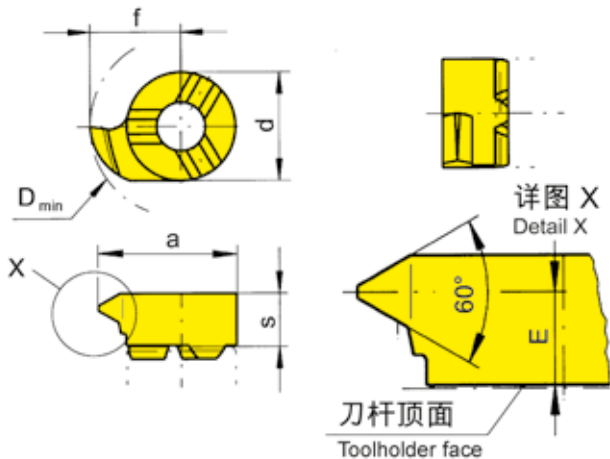
11 mm
2.3 mm



B

配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	s	f	a	d	D _{min}		MG12	EG55	TH35	TN35
R/L111.1020.01	2.0	3.0	4.15	6.7	10.7	8	11			▲/△	▲/△	▲/▲
R/L111.1325.01	2.5	2.8	4.15	6.7	10.7	8	11		△/△	▲/△	▲/△	▲/▲
▲ 库存 / on stock △ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



B

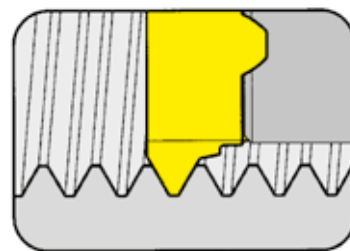
刀片
Insert

111

孔径Ø 自
向下切深可达

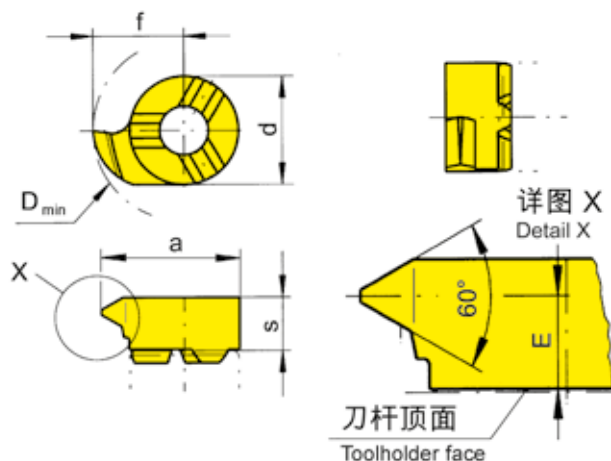
Bore Ø from
Depth of undercut up to

11 mm
2.3 mm



配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	s	f	a	d	D _{min}	EG55	TH35	TN35
R/L111.0205.01	0.5	0.75	3.5	4.15	6.7	10.7	8	11	▲/△	▲/△	▲/▲
R/L111.0510.01	1.0	1.25	3.3	4.15	6.7	10.7	8	11	▲/▲	▲/△	▲/▲
R/L111.0815.01	1.5	1.75	3.3	4.15	6.7	10.7	8	11	▲/▲	▲/△	▲/▲
									P	•	•
									M	○	•
									K	○	•
									N	-	•
									S	-	•
									H	-	-

▲ 库存 / on stock △ 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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



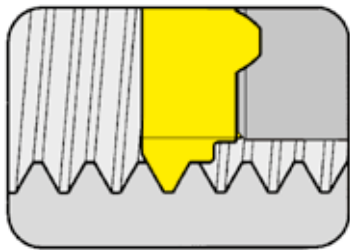
刀片
Insert

111

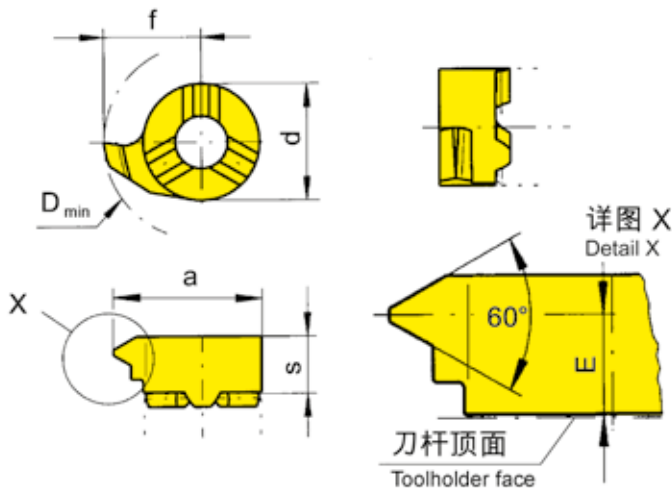
孔径Ø 自
螺距

Bore Ø from
Pitch

11 mm
2-3 mm



B



配合刀杆
for Toolholder

型号 B111
Type 125

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}	EG55	TI25	TN35
R/L111.1020.02	2.0	3.0	6.7	10.7	8	4.15	11	▲/▲	Δ/x	▲/▲
R/L111.1325.02	2.5	2.8	6.7	10.7	8	4.15	11	▲/Δ		▲/Δ
R/L111.1630.02	3.0	2.8	6.7	10.7	8	4.15	11	▲/Δ	Δ/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
注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

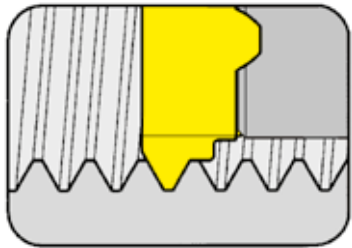
螺纹切削 (内圆) -全牙型
Threading (internal) Full profile



B

刀片
Insert

111



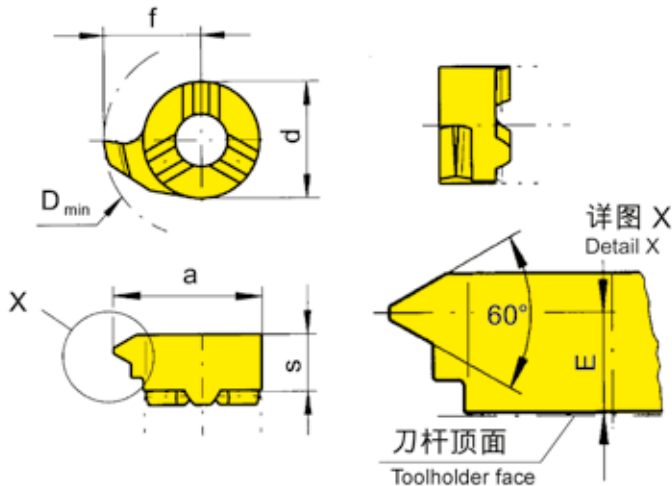
孔径Ø 自
螺距

Bore Ø from
Pitch

11 mm
1-1.5 mm

配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}		MG12	EG55	Ti25	TN35
R/L111.0510.02	1.0	3.3	6.7	10.7	8	4.15	11			▲/Δ		▲/▲
R/L111.0815.02	1.5	3.3	6.7	10.7	8	4.15	11		▲/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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



刀片

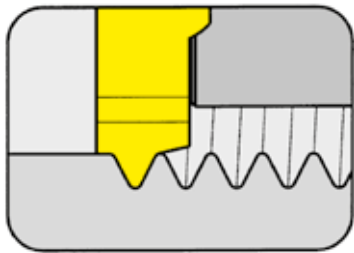
Insert

111

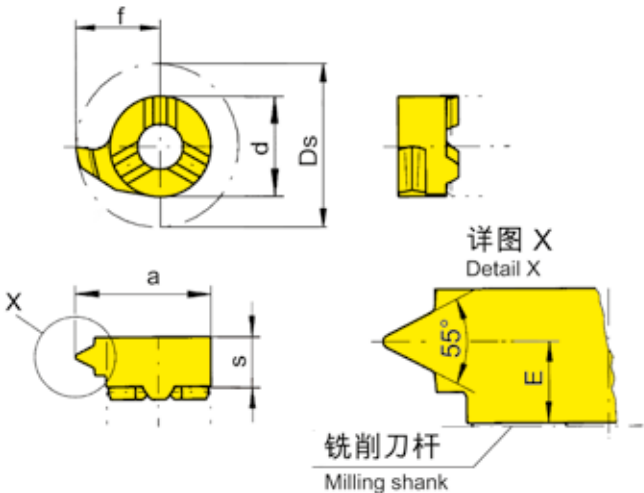
孔径Ø 自
螺距

Bore Ø from
Pitch

11 mm
2-3 mm



B



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 B111
Type 125

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

产品型号 Part number	TPI	E	s	f	a	d	Ds	D _{min}	EG55	TA45	TN35
R/L111.5514.02	14	2.5	4.15	6.7	10.7	8	13.4	11	▲/Δ	▲/Δ	▲/▲
R/L111.5519.02	19	2.9	4.15	6.7	10.7	8	13.4	11	▲/▲	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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



B

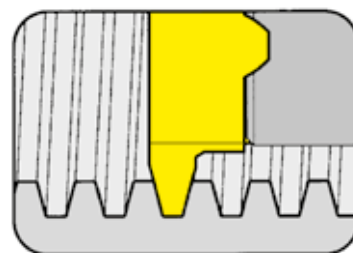
刀片
Insert

111

孔径Ø 自
螺距

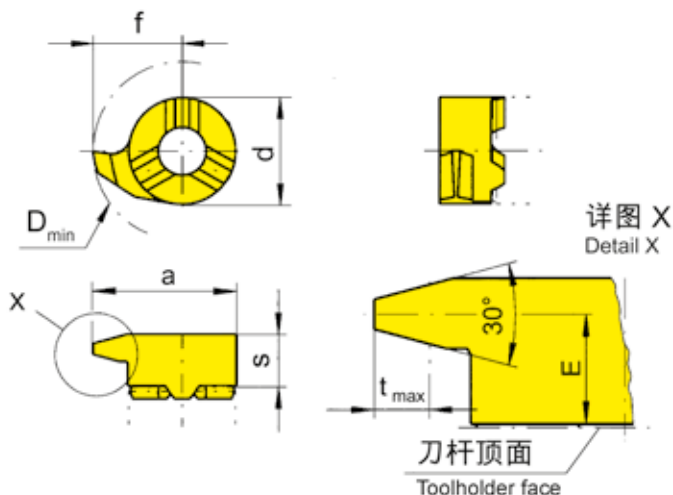
Bore Ø from
Pitch

11 mm
1-1.5 mm



配合刀杆
for Toolholder

型号 B111
Type 125



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	P	E	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TN35
R/L111.1015.01	1.5	3.5	4.15	6.7	10.7	8	0.90	11			▲/Δ	▲/Δ
R/L111.1220.01	2.0	3.3	4.15	6.7	10.7	8	1.25	11			▲/▲	▲/▲
R/L111.1730.01	3.0	3.0	4.15	6.7	10.7	8	1.75	11		Δ/Δ	▲/▲	▲/▲
R/L111.2240.01	4.0	2.5	4.15	6.7	10.7	8	2.25	11			▲/▲	▲/▲
▲ 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

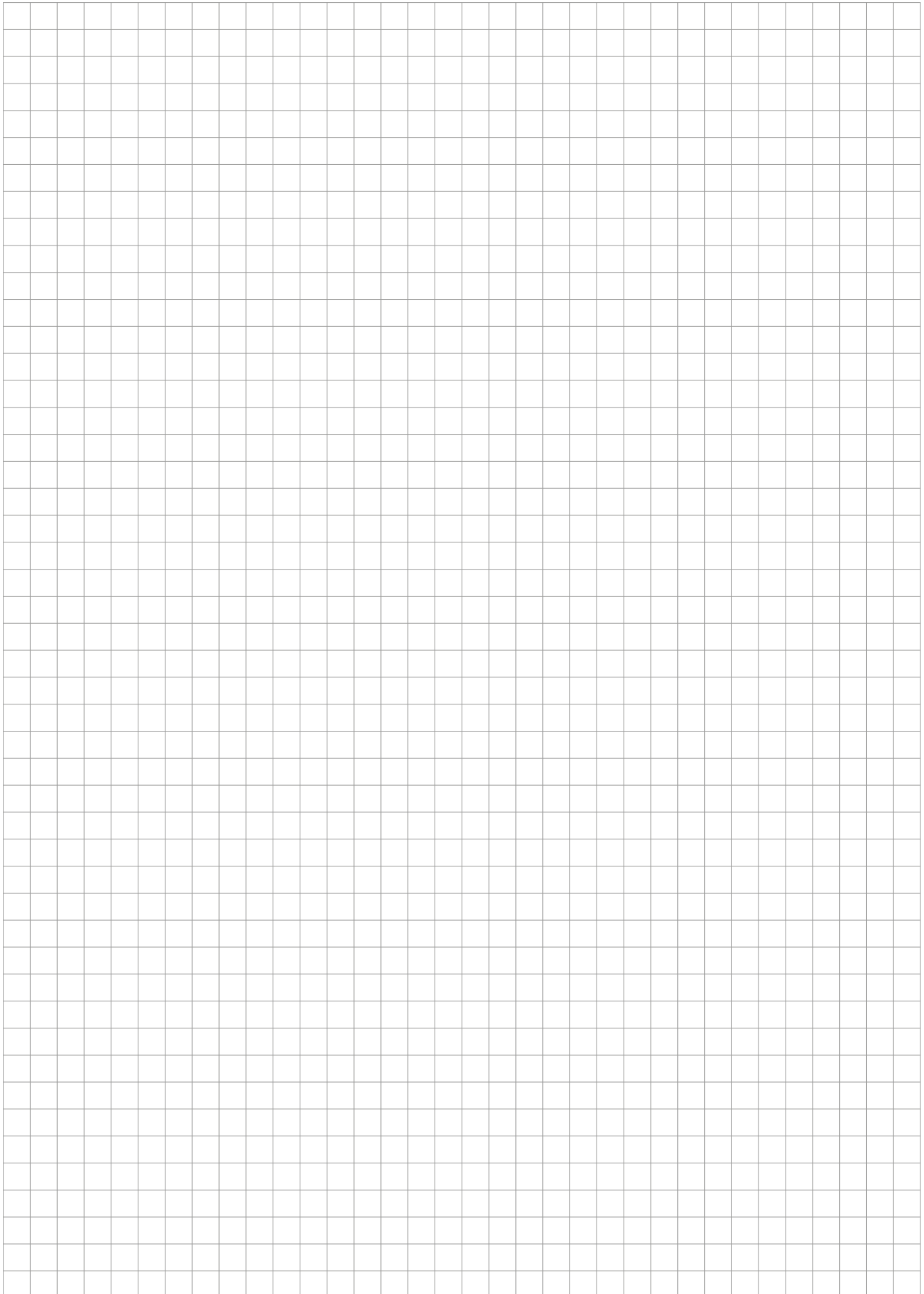
注明R或L型

State R or L version

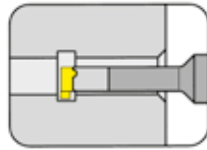
按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

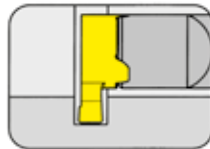


刀杆
Toolholder
B11P



页/Page
B85-B87

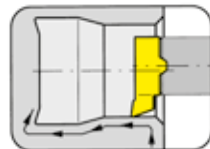
刀片
Insert
11P/S11P



页/Page
B88, B90



页/Page
B89, B91



页/Page
B92-B93

11P



机夹式刀杆

槽宽 1 - 3 mm

Toolholder with Inserts

Width of groove 1 - 3 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽 (内圆)

Grooving (internal)



刀杆

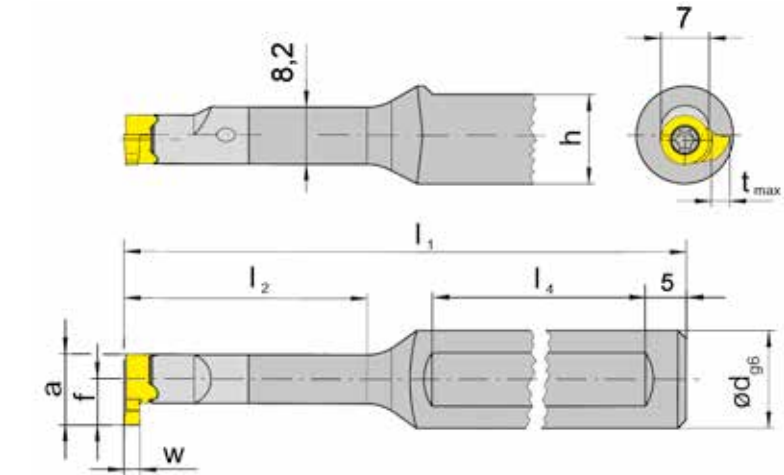
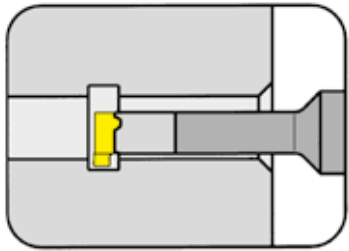
Toolholder

B11P

直接冷却液供应
with through coolant supply

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	10,5 mm 3,5 mm 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



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 11P
Type S11P

产品型号 Part number	d	l ₁	l ₂	h	l ₄
R/LB11P.0012.00	12	75	15	11	40
R/LB11P.0012.01	12	95	26	11	50
R/LB11P.0012.02	12	110	37	11	50
R/LB11P.0012.03	12	120	50	11	50

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB11P...	3.10T9P	T9PL

B

切槽 (内圆)

Grooving (internal)



B

刀杆

Toolholder

B11P

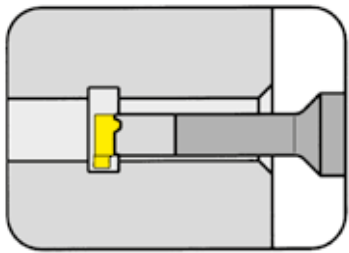
直接冷却液供应
with through coolant supply

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

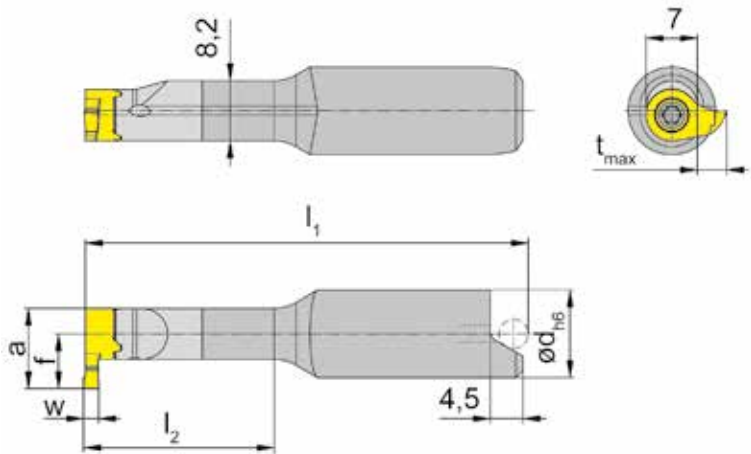
10,5/11,5 mm
3,5 mm
3 mm

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 11P
Type S11P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

用于收缩型定位
for shrinkage location

产品型号 Part number	d	l ₁	l ₂
R/LB11P.0012.00S	12	49.7	15
R/LB11P.0012.01S	12	60.7	26
R/LB11P.0012.02S	12	71.7	37

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB11P...	3.10T9P	T9PL

切槽 (内圆)

Grooving (internal)



刀杆

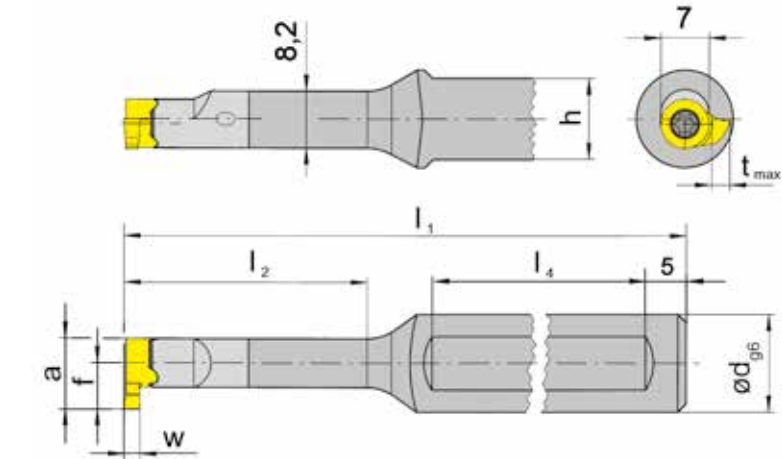
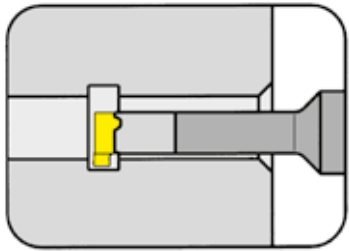
Toolholder

B11P

直接冷却液供应
with through coolant supply

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	10,5 mm 3,5 mm 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



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 11P
Type S11P

带2个夹持面
with 2 clamping flats

产品型号 Part number	d	l ₁	l ₂	h	l ₄
R/LB11P.0012.2.00	12	75	15	11	40
R/LB11P.0012.2.01	12	95	26	11	50
R/LB11P.0012.2.02	12	110	37	11	50
R/LB11P.0012.2.03	12	120	50	11	50

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：

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.

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

配件

Spare Parts

刀杆 Toolholder	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB11P...	3.10T9P	T9PL

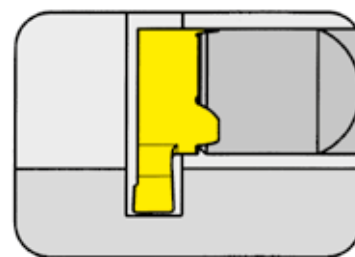
切槽 (内圆) Grooving (internal)



B

刀片
Insert

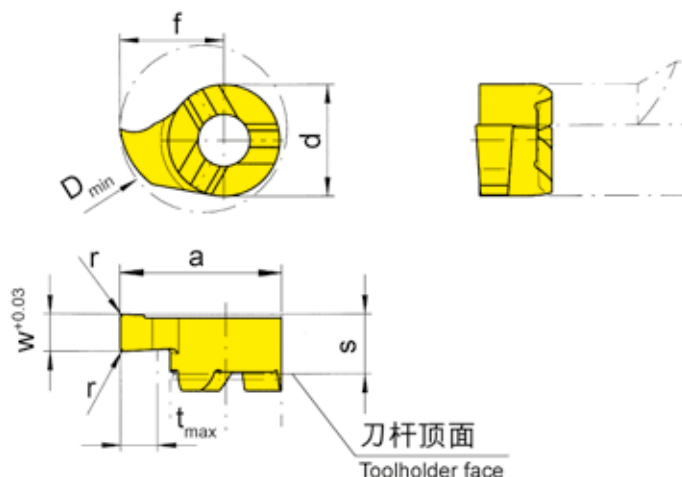
11P



孔径Ø 自
槽深
槽宽可达

Bore Ø from
Depth of groove
Width of groove up to

10.5 mm
2.5 mm
3 mm



配合刀杆
for Toolholder

型号 B11P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L11P.0100.1.00	1.0	4.2	6.5	10	-	7	2.5	10.5	▲/Δ	▲/▲
R/L11P.0150.1.00	1.5	4.2	6.5	10	-	7	2.5	10.5	▲/Δ	▲/Δ
R/L11P.0200.1.02	2.0	4.2	6.5	10	0.2	7	2.5	10.5	▲/▲	▲/▲
R/L11P.0250.1.02	2.5	4.2	6.5	10	0.2	7	2.5	10.5	▲/Δ	▲/▲
R/L11P.0300.1.02	3.0	4.2	6.5	10	0.2	7	2.5	10.5	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



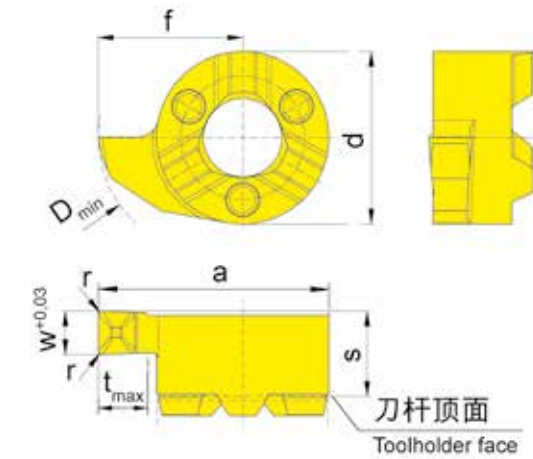
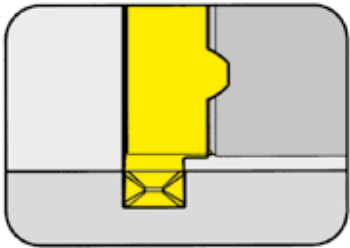
刀片
Insert

S11P

孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

10.5 mm
2.5 mm
1.5-2.5 mm



配合刀杆
for Toolholder

型号 B11P
Type

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS11P.0150.1.D1	1.5	4.2	6.5	10	0.1	7	2.5	10.5	▲/△	▲/▲
R/LS11P.0200.1.D2	2.0	4.2	6.5	10	0.2	7	2.5	10.5	▲/△	▲/▲
R/LS11P.0250.1.D2	2.5	4.2	6.5	10	0.2	7	2.5	10.5	▲/△	▲/△

▲ 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

P	●	●
M	○	●
K	○	●
N	-	●
S	-	●
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

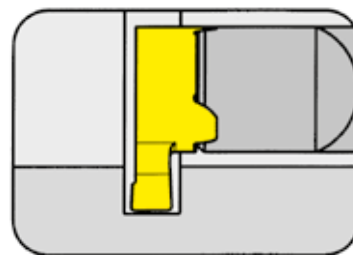
Grooving (internal)



B

刀片
Insert

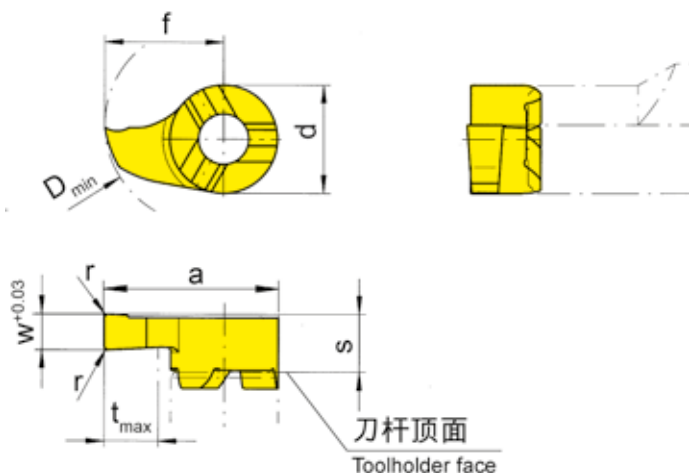
11P



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

11.5 mm
3.5 mm
1-2 mm



配合刀杆
for Toolholder

型号 B11P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/L11P.0100.2.00	1.0	4.2	7.5	11	-	7	3.5	11.5	▲/△	▲/▲
R/L11P.0150.2.00	1.5	4.2	7.5	11	-	7	3.5	11.5	▲/△	▲/▲
R/L11P.0200.2.02	2.0	4.2	7.5	11	0.2	7	3.5	11.5	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



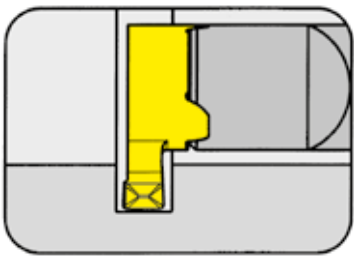
刀片
Insert

S11P

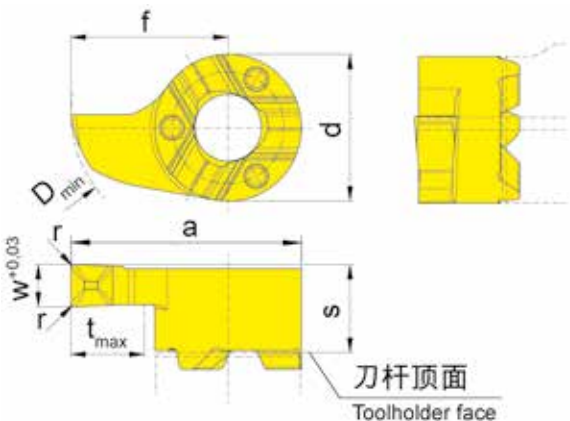
孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

11.5 mm
3.5 mm
1.5-2.5 mm



B



配合刀杆
for Toolholder

型号 B11P
Type

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS11P.0150.2.D1	1.5	4.2	7.5	11	0.1	7	3.5	11.5	▲/Δ	▲/▲
R/LS11P.0200.2.D2	2.0	4.2	7.5	11	0.2	7	3.5	11.5	▲/▲	▲/▲
R/LS11P.0250.2.D2	2.5	4.2	7.5	11	0.2	7	3.5	11.5	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling



B

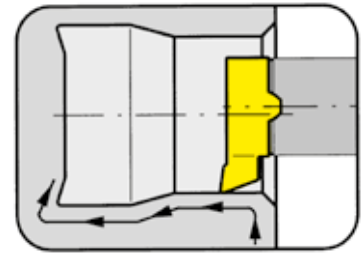
刀片
Insert

11P

孔径Ø 自

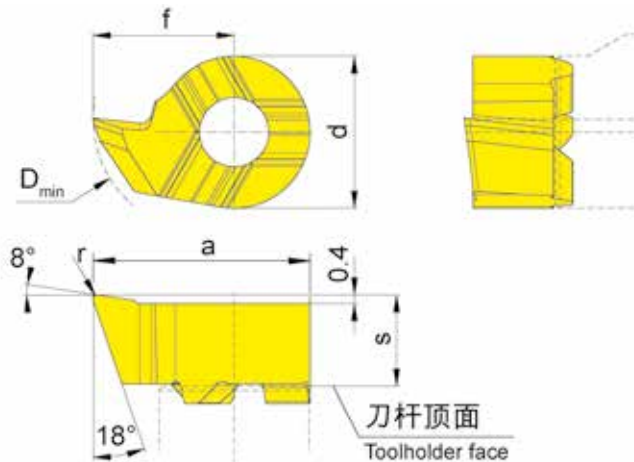
Bore Ø from

10.5 mm



配合刀杆
for Toolholder

型号 B11P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	EG55	TH35
R/L11P.1865.1.02	4.2	6.5	10	0.2	7	10.5	▲/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

改进后的几何结构可镗孔径≥Ø10.3mm和仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 10,3 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

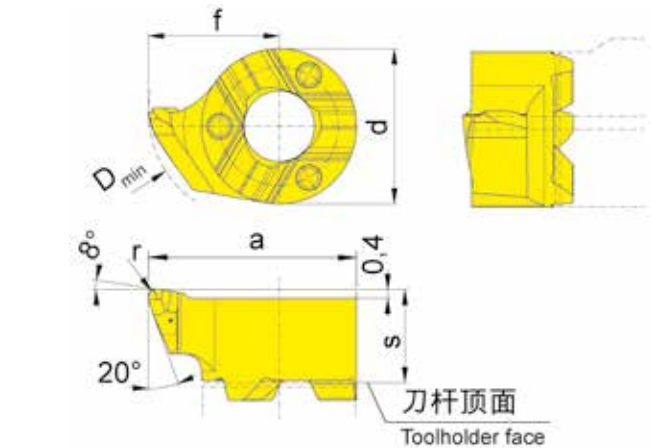
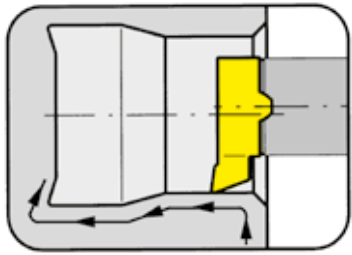
Further sizes upon request

硬质合金牌号
Carbide grades

刀片
Insert

S11P

孔径Ø 自	Bore Ø from	9.8 mm
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配合刀杆
for Toolholder

型号 B11P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/LS11P.1859.R2	4.2	5.9	9.4	0.2	7	9.8		▲/▲	▲/▲
R/LS11P.1859.R4	4.2	5.9	9.4	0.4	7	9.8		▲/▲	▲/▲
▲ 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

改进过的几何结构可以镗≥ Ø9.8 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

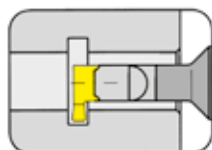
The modified geometry allows boring of bores ≥ Ø 9,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

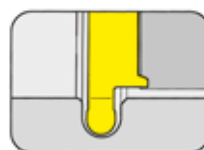
Further sizes upon request

硬质合金牌号
Carbide grades

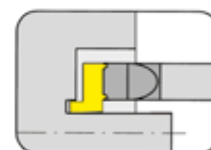
刀杆
Toolholder
B114/H114.WF/
BA114/HC114



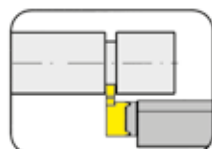
页/Page
B97-B99



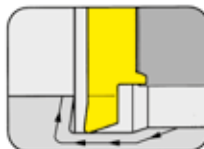
页/Page
B110



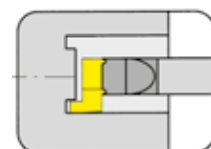
页/Page
B121, B123



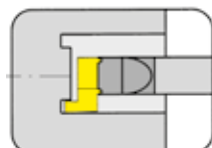
页/Page
B100



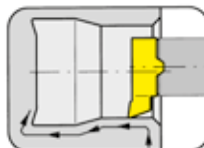
页/Page
B111, B114



页/Page
B122, B124



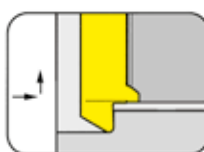
页/Page
B101



页/Page
B112

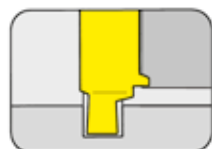


页/Page
B102

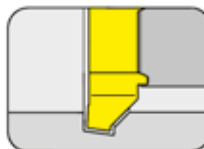


页/Page
B113

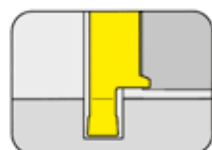
刀片
Insert
114/S114/107/111



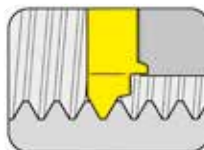
页/Page
B103



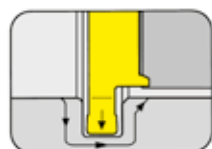
页/Page
B115



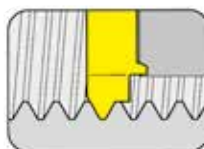
页/Page
B104, B106, B108



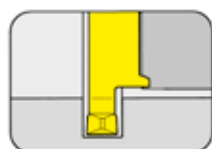
页/Page
B116-B117



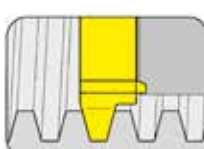
页/Page
B105



页/Page
B118-B119



页/Page
B107, B109



页/Page
B120

114



机夹式刀杆

槽宽0,7 - 3,0 mm

Toolholder with Inserts

Width of groove 0,7 - 3,0 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽 (内圆)

Grooving (internal)

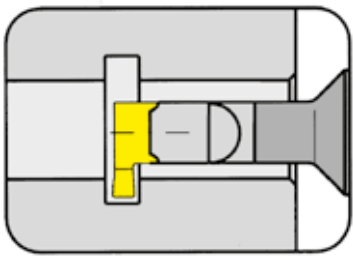


刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply



孔径Ø 自
槽深
槽宽可达

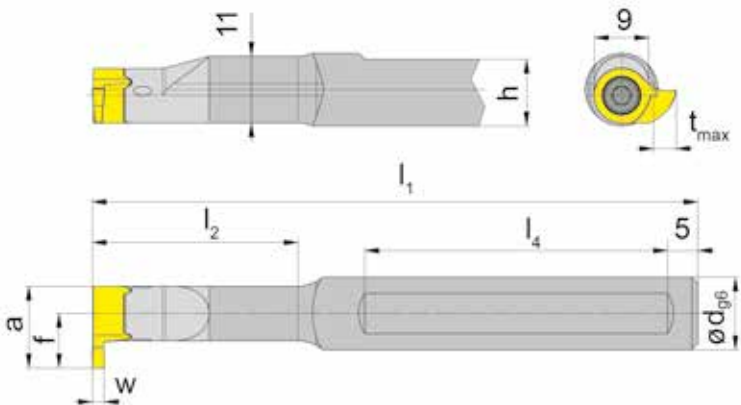
Bore Ø from
Depth of groove
Width of groove up to

14 mm
6,5 mm
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	75	19.5	11	40
B114.0012.01	12	100	34.0	11	50
B114.0012.02	12	110	45.0	11	50
B114.0012.03	12	130	64.0	11	50
B114.0016.00	16	80	19.5	15	40
B114.0016.01	16	100	34.0	15	50
B114.0016.02	16	110	45.0	15	50
B114.0016.03	16	130	64.0	15	50

按需提供更多尺寸
Further sizes upon request

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

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 (内圆)

Grooving (internal)



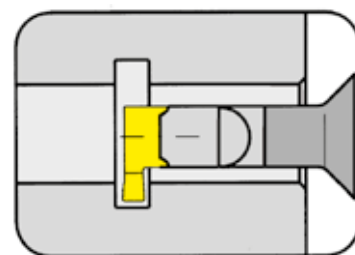
B

刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply



孔径Ø 自
槽深
槽宽可达

Bore Ø from
Depth of groove
Width of groove up to

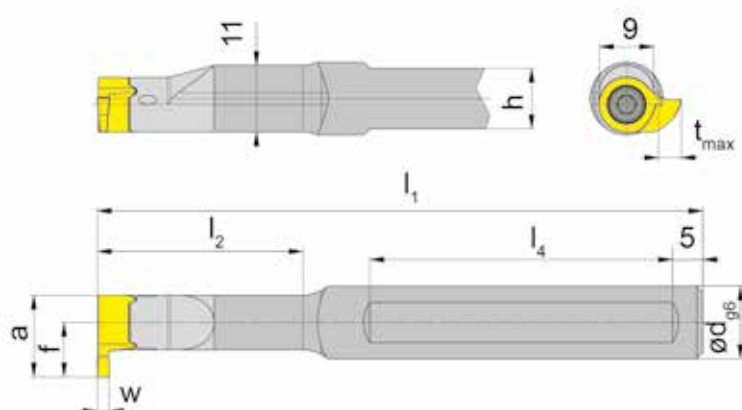
14 mm
6,5 mm
3 mm

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	75	19.5	11	40
B114.0012.2.01	12	100	34.0	11	50
B114.0012.2.02	12	110	45.0	11	50
B114.0012.2.03	12	130	64.0	11	50
B114.0016.2.00	16	80	19.5	14	40
B114.0016.2.01	16	100	34.0	14	50
B114.0016.2.02	16	110	45.0	14	50
B114.0016.2.03	16	130	64.0	14	50

按需提供更多尺寸
Further sizes upon request

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

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 (内圆)

Grooving (internal)



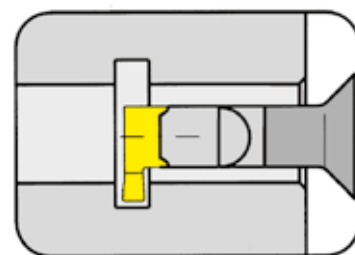
B

刀杆

Toolholder

B114

直接冷却液供应
with through coolant supply



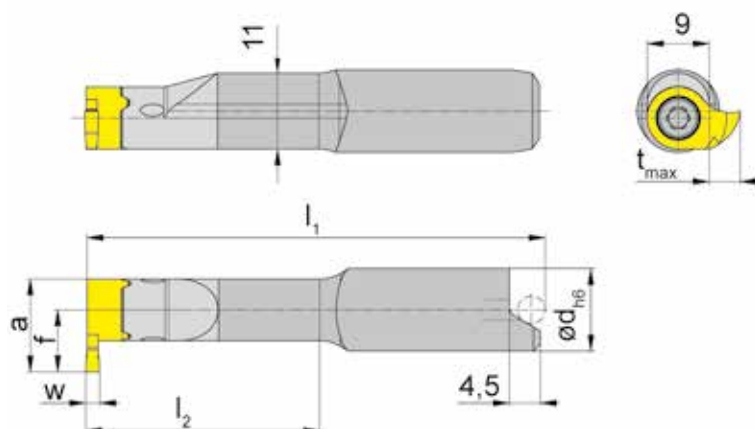
孔径Ø 自
槽深
槽宽可达

Bore Ø from
Depth of groove
Width of groove up to

14 mm
6,5 mm
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

用于收缩型定位
for shrinkage location

图示=右手型

Picture = right hand cutting version

产品型号 Part number	d	l_1	l_2
B114.0012.00S	12	52.7	19.5
B114.0012.01S	12	66.7	34.0
B114.0012.02S	12	77.7	45.0
B114.0012.03S	12	96.7	64.0

按需提供更多尺寸
Further sizes upon request

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

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 (外圆)
Grooving (external)



B

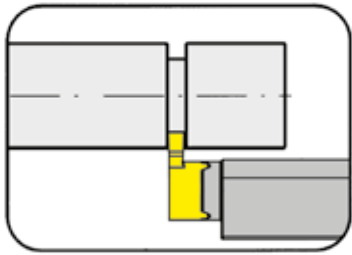
刀杆
Toolholder

H114.WF
直接冷却液供应
with through coolant supply

槽深
槽宽可达

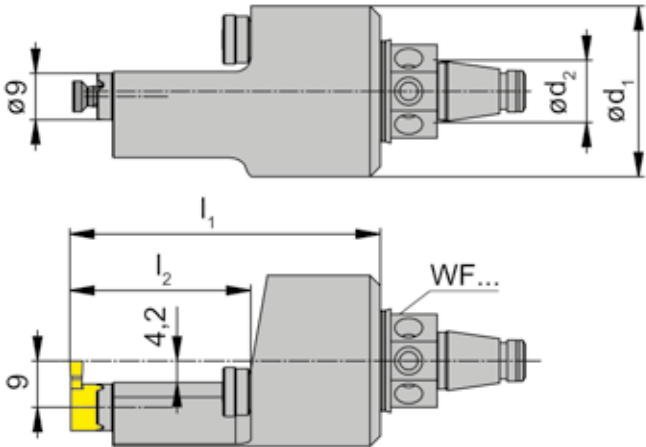
Depth of groove
Width of groove up to

4,2 mm
3 mm



配合刀片
for Insert

型号 114
Type S114



产品型号 Part number	d ₁	l ₁	d ₂	l ₂
RH114.WF20.02	33	60	12	35
RH114.WF24.02	40	80	16	55
RH114.WF32.02	50	80	20	32

按需提供更多尺寸
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

端面切槽

Face Grooving



刀杆

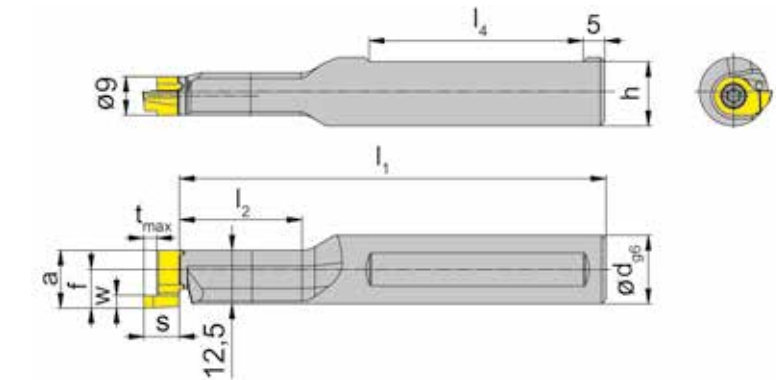
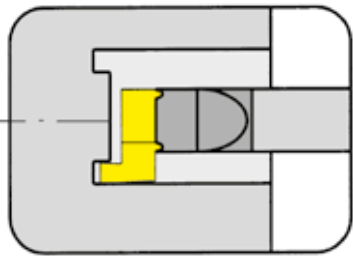
Toolholder

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 R114 (axial)
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
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

B

切槽和端面切槽

Grooving and Face Grooving



B

刀杆

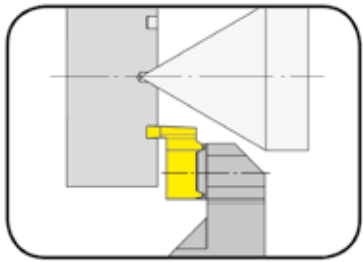
Toolholder

HC114

槽深可达
槽宽可达

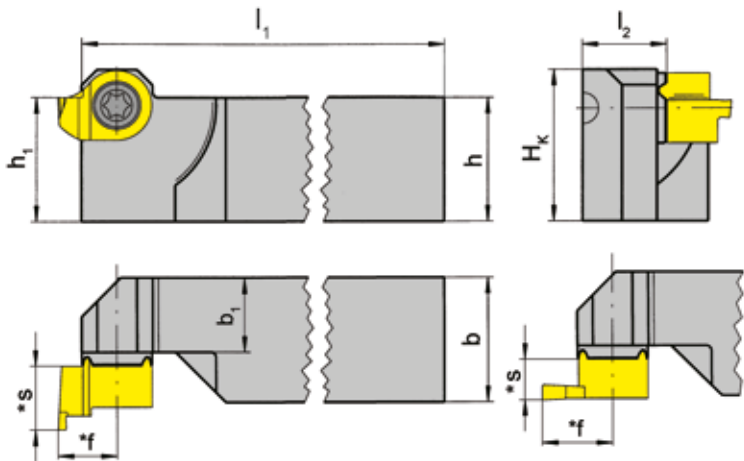
Depth of groove up to
Width of groove up to

6,5 mm
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

切槽 (内圆)

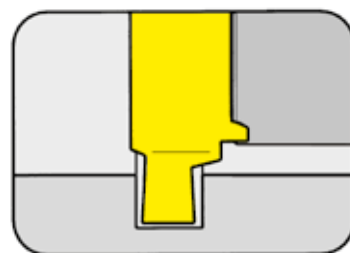
Grooving (internal)



B

刀片
Insert

114



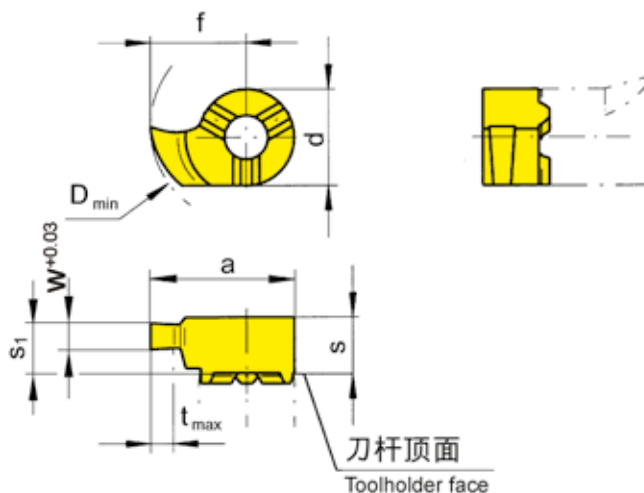
孔径Ø 自
槽深
卡簧宽度Nw

Bore Ø from
Depth of groove
Width of circlip Nw

14 mm
1.2-1.5 mm
0.7-0.9 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

不能面切削， 有限的切削
深度
limited depth of cut

R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	Nw	s	f	a	s ₁	d	t _{max}	D _{min}	EG55	TN35
R/L114.0070.00	0.74	0.7	5.5	9	13.5	5.3	9	1.2	14	▲/▲	▲/▲
R/L114.0080.00	0.84	0.8	5.5	9	13.5	5.3	9	1.3	14	▲/Δ	▲/▲
R/L114.0090.00	0.94	0.9	5.5	9	13.5	5.3	9	1.5	14	▲/▲	▲/▲

▲ 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

切槽深度 $t_{max} = 1.5 \times w$

Depth of groove $t_{max} = 1.5 \times w$

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

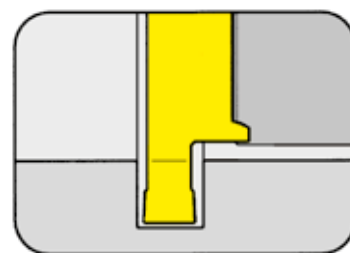
Grooving (internal)



B

刀片
Insert

114



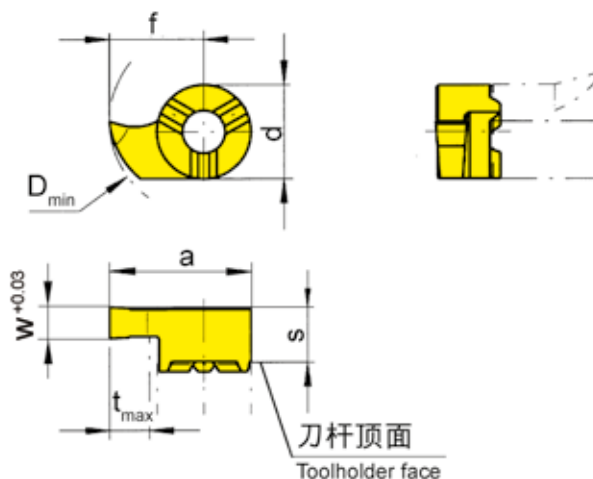
孔径Ø 自
槽深
卡簧宽度Nw

Bore Ø from
Depth of groove
Width of circlip Nw

14 mm
4 mm
1.1-1.6 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=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	s	f	a	d	t _{max}	D _{min}	EG55	TH35	TN35
R/L114.0110.00	1.19	1.1	5.3	9	13.5	9	4	14	▲/▲	▲/▲	▲/▲
R/L114.0130.00	1.39	1.3	5.3	9	13.5	9	4	14	▲/▲	▲/▲	▲/▲
R/L114.0160.00	1.69	1.6	5.3	9	13.5	9	4	14	▲/▲	▲/▲	▲/▲

▲ 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

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

硬质合金牌号
Carbide grades

NC-仿形加工 (内圆)

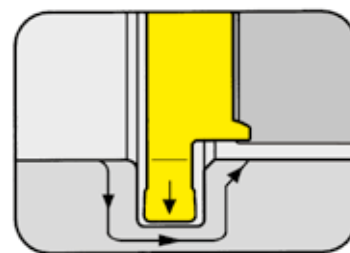
NC-Profiling (internal)



B

刀片
Insert

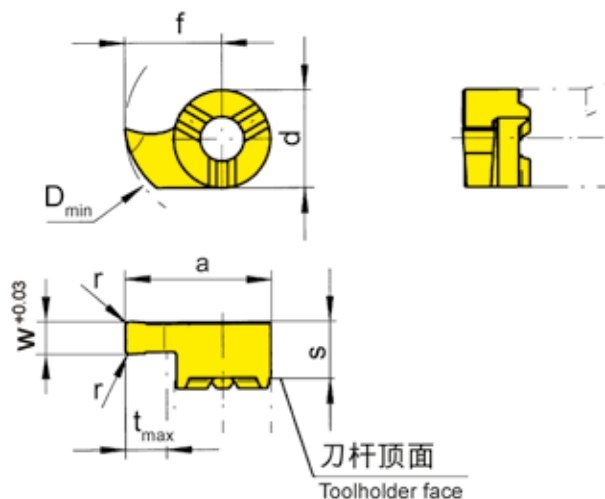
114



孔径Ø 自
槽深

Bore Ø from
Depth of groove

14 mm
4 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=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	d	t _{max}	D _{min}		MG12	EG55	TH35	TI25	TN35
R/L114.0200.02	2	5.3	9	13.5	0.2	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

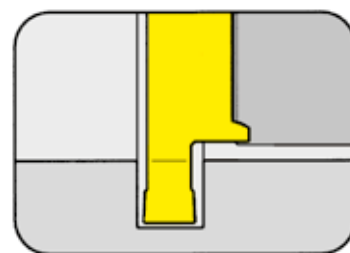
切槽 (内圆) Grooving (internal)



B

刀片
Insert

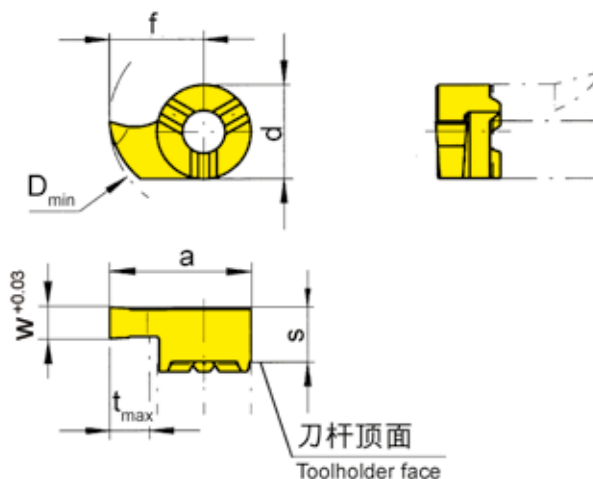
114



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

14 mm
4 mm
1.5-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L114.0150.00	1.5	5.3	9	13.5	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0200.00	2.0	5.3	9	13.5	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0250.00	2.5	5.3	9	13.5	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0300.00	3.0	5.3	9	13.5	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

切槽 (内圆)

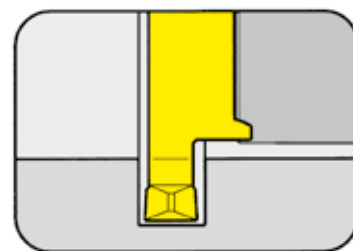
Grooving (internal)



B

刀片
Insert

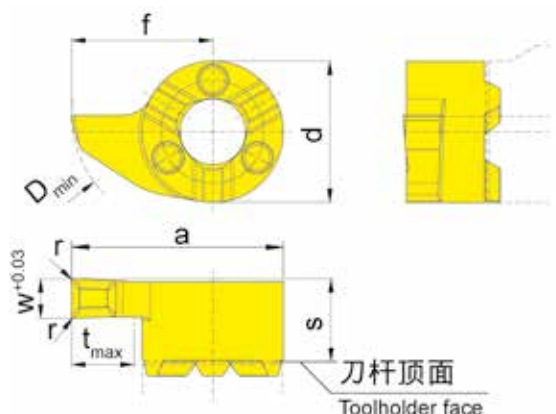
S114



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

14 mm
4 mm
2-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}		EG55	TF45	TH35	TN35
R/LS114.0200.D2	2.0	5.3	9	13.5	0.2	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
R/LS114.0250.D2	2.5	5.3	9	13.5	0.2	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
R/LS114.0300.D2	3.0	5.3	9	13.5	0.2	9	4	14		▲/▲	▲/▲	▲/▲	▲/▲
										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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

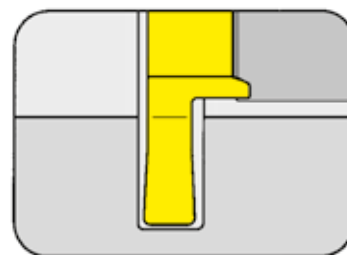
切槽 (内圆) Grooving (internal)



B

刀片
Insert

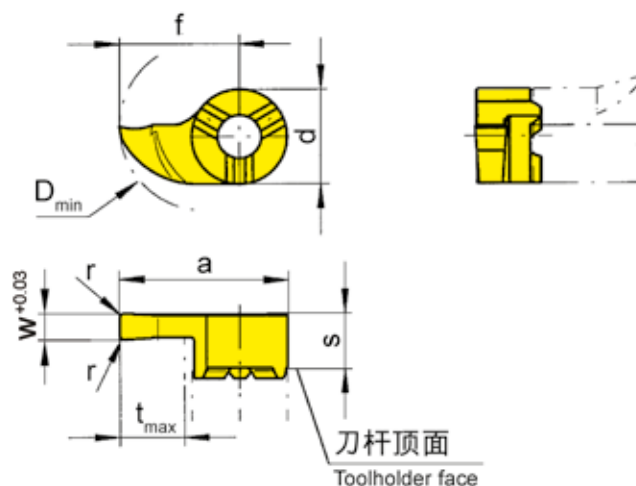
114



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

16.5 mm
6.5 mm
1.5-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=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	d	t _{max}	D _{min}		EG55	TH35	TI25	TN35
R/L114.0150.1.02	1.5	5.3	11.3	15.8	0.2	9	6.5	16.5		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0200.1.02	2.0	5.3	11.3	15.8	0.2	9	6.5	16.5		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0250.1.02	2.5	5.3	11.3	15.8	0.2	9	6.5	16.5		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.0300.1.02	3.0	5.3	11.3	15.8	0.2	9	6.5	16.5		▲/▲	▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

切槽 (内圆)

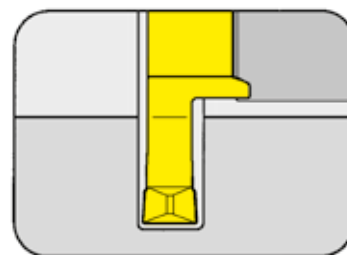
Grooving (internal)



B

刀片
Insert

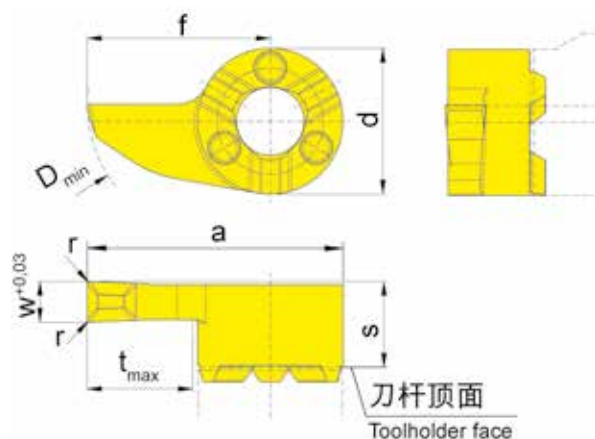
S114



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

16.5 mm
6.5 mm
2-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

槽型.D
Geometry .D

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS114.0200.1.D2	2.0	5.3	11.3	15.8	0.2	9	6.5	16.5	▲/▲	▲/▲
R/LS114.0250.1.D2	2.5	5.3	11.3	15.8	0.2	9	6.5	16.5	▲/Δ	▲/▲
R/LS114.0300.1.D2	3.0	5.3	11.3	15.8	0.2	9	6.5	16.5	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

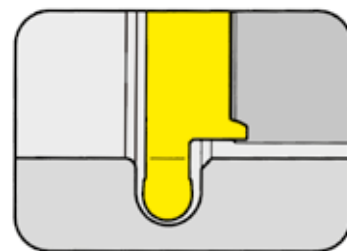
Grooving (internal)



B

刀片
Insert

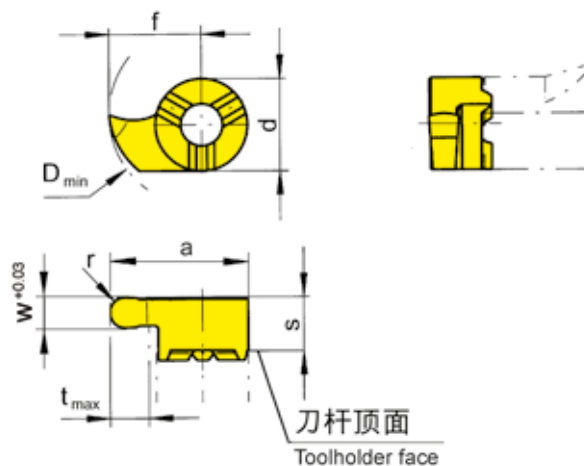
114



孔径Ø 自
圆头

Bore Ø from
Full radius

14 mm
0.4-2 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

圆头
Full radius

R=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	d	t _{max}	D _{min}	EG55	TH35	T125	TN35
R/L114.0004.08	0.8	5.3	9	13.5	0.4	9	4	14			Δ/▲	
R/L114.0006.12	1.2	5.3	9	13.5	0.6	9	4	14	▲/▲	▲/▲		▲/▲
R/L114.0009.18	1.8	5.3	9	13.5	0.9	9	4	14	▲/▲	▲/▲		▲/▲
R/L114.0010.20	2.0	5.3	9	13.5	1.0	9	4	14	▲/▲	▲/▲		▲/▲
R/L114.0011.22	2.2	5.3	9	13.5	1.1	9	4	14	▲/Δ	▲/▲		▲/▲
R/L114.0015.30	3.0	5.3	9	13.5	1.5	9	4	14	▲/▲	▲/▲		▲/▲
R/L114.0020.40	4.0	5.3	9	13.5	2.0	9	4	14	▲/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

按需提供更多尺寸

Further sizes upon request

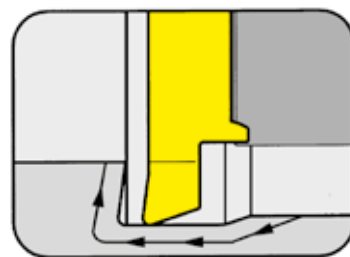
P	•	•	•	•
M	o	•	•	•
K	o	•	•	•
N	-	•	•	•
S	-	•	•	•
H	-	-	-	-

硬质合金牌号
Carbide grades

刀片

Insert

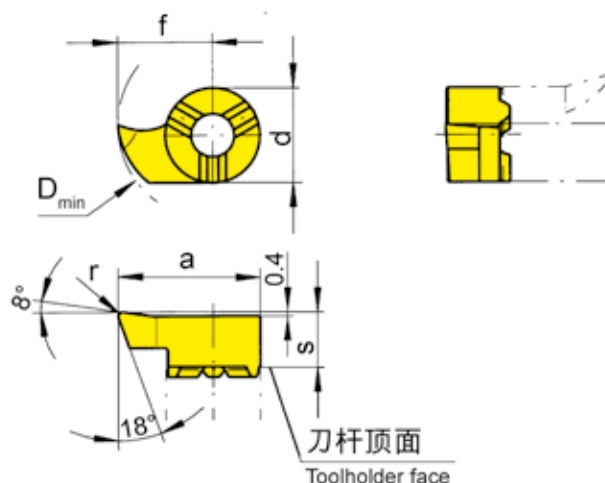
114



孔径Ø 自

Bore Ø from

13.8 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	MG12	EG55	TH35	TI25	TN35
R/L114.1890.02	5.3	8.7	13.2	0.2	9	13.8	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock							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

改进过的几何结构可以镗≥Ø 13.8mm的孔，也可以仿形车DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 13,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

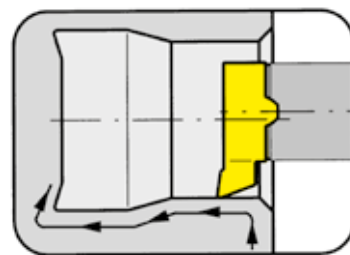
Insert

S114

孔径Ø 自

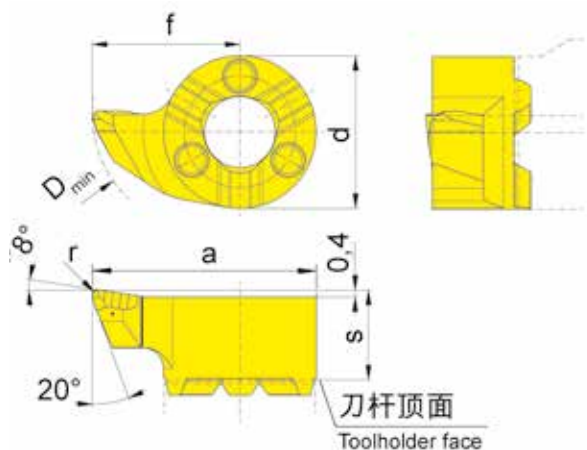
Bore Ø from

13.8 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

R型断屑槽
Geometry .R

产品型号 Part number	s	f	a	r	d	D _{min}		EG55	TH35
R/LS114.1890.R2	5.3	8.7	13.2	0.2	9	13.8		▲/▲	▲/▲
R/LS114.1890.R4	5.3	8.7	13.2	0.4	9	13.8		▲/▲	▲/▲
▲ 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

改进过的几何结构可以镗≥Ø 13.8mm的孔，也可以仿形车DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 13,8 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

背镗 (内圆)

Backboring (internal)



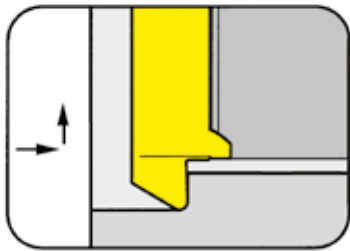
刀片
Insert

114

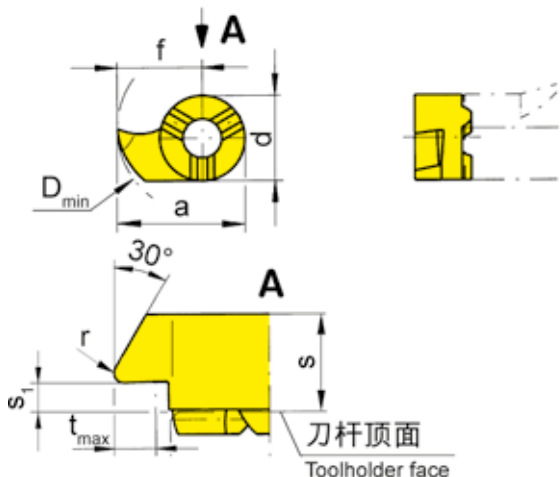
孔径Ø 自
向下切深可达

Bore Ø from
Depth of undercut up to

13.8 mm
3.5 mm



B



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	r	s ₁	d	t _{max}	D _{min}		EG55	TH35	TN35
R/L114.3090.02	5.5	8.7	0.2	2.4	9	3.5	13.8		▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling



B

刀片

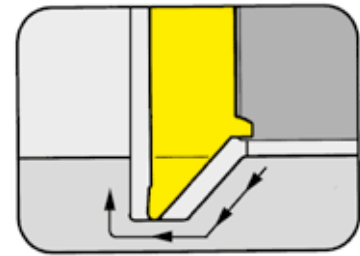
Insert

114

孔径 $\varnothing$ 自
向下切深可达

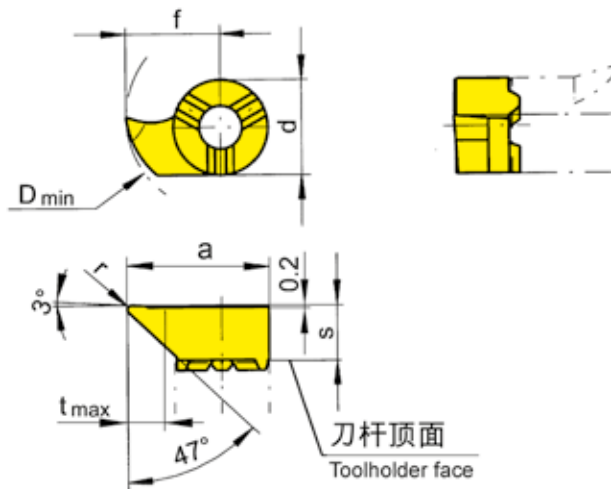
Bore $\varnothing$ from
Depth of undercut up to

13.8 mm
5 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35	TI25	TN35
R/L114.4710.02	5.3	11.0	15.5	0.2	9	5	16.0		▲/▲	▲/▲	▲/▲	▲/▲
R/L114.4787.02	5.3	8.7	13.2	0.2	9	3	13.8		▲/▲	▲/▲	▲/x	▲/▲
R/L114.4787.04	5.3	8.7	13.2	0.4	9	3	13.8		▲/▲	▲/▲	▲/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

改进过的几何结构可以镗 $\geq \varnothing 13.8$ mm的孔，也可以仿形车DIN509E和F型的退刀槽。

The modified geometry allows boring of bores $\geq \varnothing 13.8$ mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

Pregrooving and Chamfering (internal)



刀片

Insert

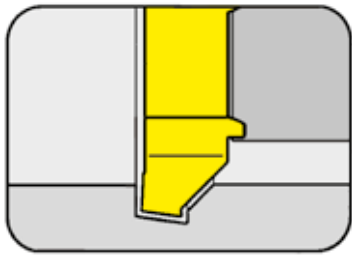
114

B

孔径Ø 自

Bore Ø from

14 mm



配合刀杆

for Toolholder

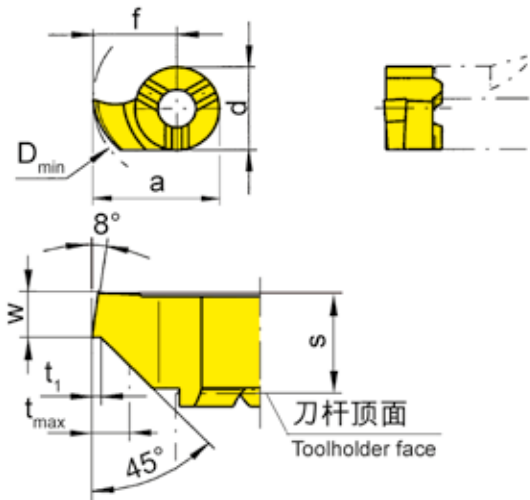
型号

B114

Type

HC114

RBA114



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	t ₁	D _{min}		MG12	EG55	Ti25	TN35
R/L114.0815.45	1.5	5.3	9	13.5	9	1.5	0.2	14		▲/Δ	▲/▲	▲/▲	Δ/x
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号

Carbide grades

螺纹切削 (内圆) -非全牙型

Threading (internal) Partial profile



B

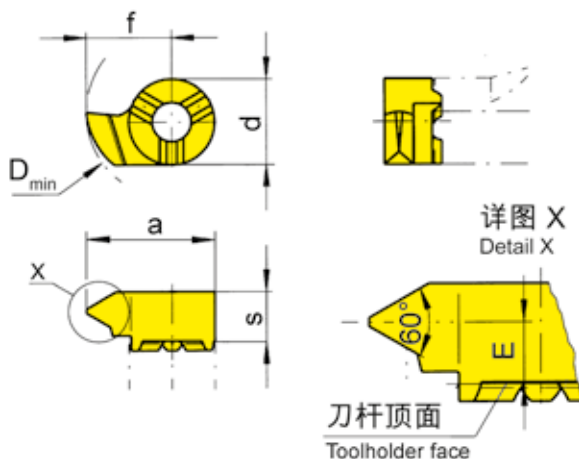
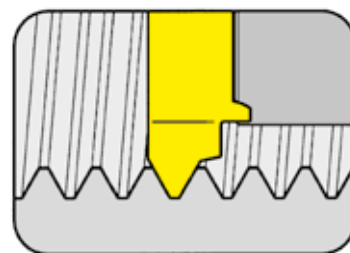
刀片
Insert

107

孔径Ø 自
螺距

Bore Ø from
Pitch

14 mm
2-2.5 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}		EG55	TH35	TN35
R/L114.1020.01	2.0	4.2	9	13.5	9	5.5	14		▲/Δ	▲/Δ	▲/Δ
R/L114.1325.01	2.5	4.2	9	13.5	9	5.5	14		▲/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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -非全牙型

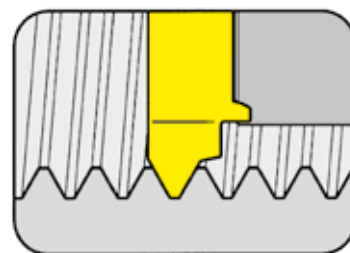
Threading (internal) Partial profile



B

刀片
Insert

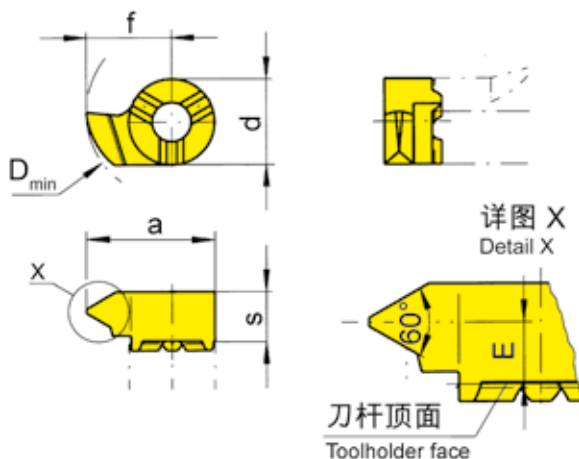
107



孔径Ø 自
螺距

Bore Ø from
Pitch

14 mm
0.5-1.75 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	P _{max}	E	f	a	d	s	D _{min}	EG55	TH35	TN35
R/L114.0205.01	0.5	0.75	4.8	9	13.5	9	5.5	14	▲/Δ	▲/Δ	▲/Δ
R/L114.0510.01	1.0	1.25	4.7	9	13.5	9	5.5	14	▲/Δ	▲/Δ	▲/▲
R/L114.0815.01	1.5	1.75	4.5	9	13.5	9	5.5	14	▲/▲	▲/▲	▲/▲
									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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型
Threading (internal) Full profile



B

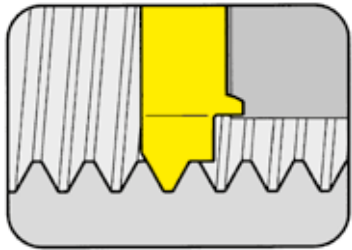
刀片
Insert

111

孔径Ø 自
螺距

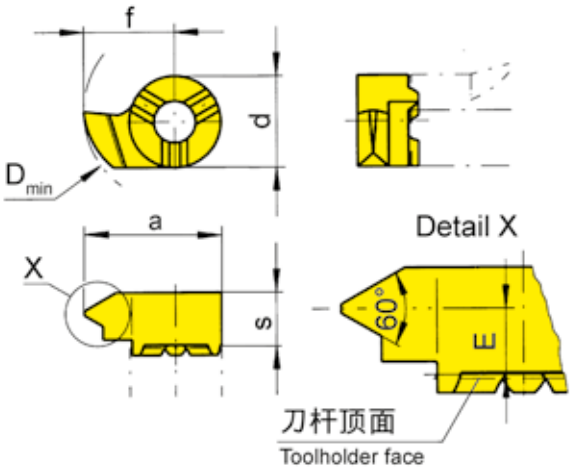
Bore Ø from
Pitch

14 mm
2-2.5 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}		EG55	TN35
R/L/114.1020.02	2.0	4.2	9	13.5	9	5.5	14		▲/△	▲/▲
R/L/114.1325.02	2.5	4.2	9	13.5	9	5.5	14		▲/△	▲/▲
▲ 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										
注明R或L型 State R or L version										
按需提供更多尺寸 Further sizes upon request										

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



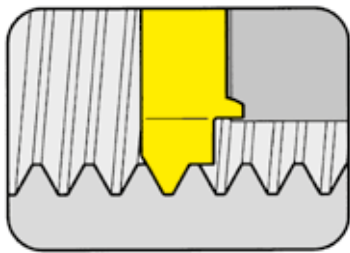
刀片
Insert

111

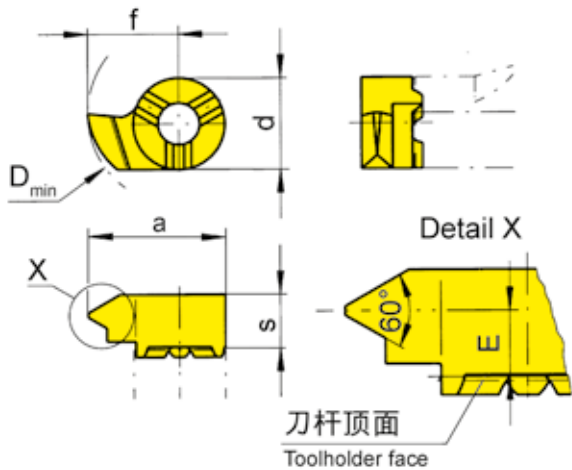
孔径Ø 自
螺距

Bore Ø from
Pitch

14 mm
1-1.5 mm



B



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}	EG55	TN35
R/L/114.0510.02	1.0	4.7	9	13.5	9	5.5	14	▲/△	▲/▲
R/L/114.0815.02	1.5	4.5	9	13.5	9	5.5	14	▲/△	▲/▲

▲ 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

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



B

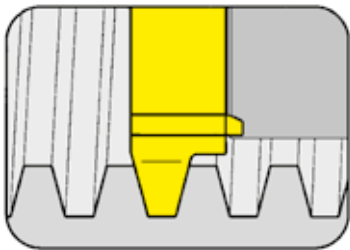
刀片
Insert

107

孔径Ø 自
螺距

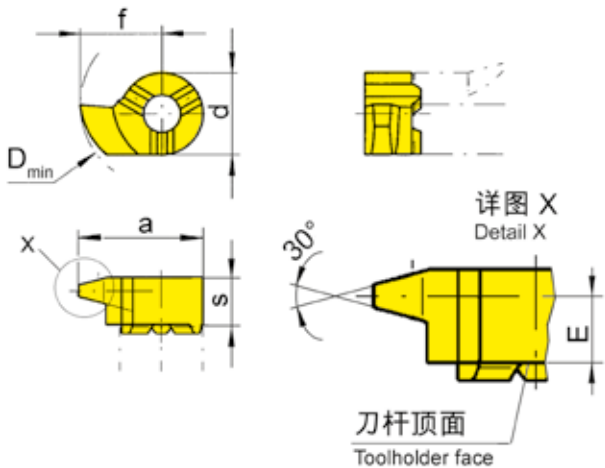
Bore Ø from
Pitch

14 mm
3-5 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



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	f	a	d	s	D _{min}		EG55	TN35	
R114.1730.01	3	4.30	9	13.5	9	5.5	14			Δ	
R/L114.2240.01	4	4.00	9	13.5	9	5.5	14		▲/▲	▲/▲	
R/L/114.2750.01	5	3.55	9	13.5	9	5.5	14		▲/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											

▲ 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

硬质合金牌号
Carbide grades

端面切槽 Face Grooving



刀片 Insert

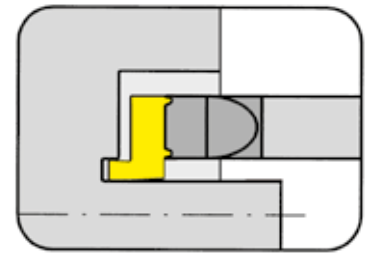
114

B

端面槽起始外径
槽深可达
槽宽

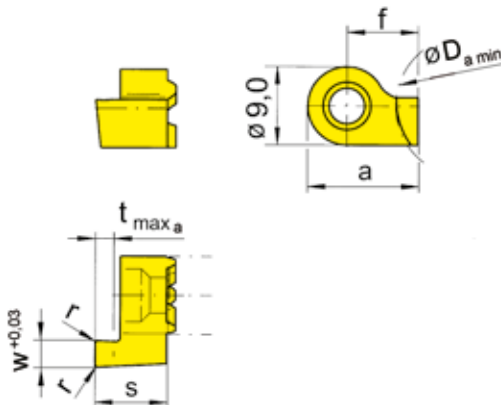
from outer groove $\varnothing$
Depth of groove up to
Width of groove

12 mm
6 mm
0,5-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



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 114.1205.00	0.5	8.3	7.5	12	-	1.0	12	▲/▲	▲/▲
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

○ 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

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=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	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

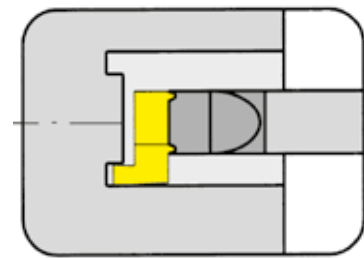
端面切槽 Face Grooving



B

刀片 Insert

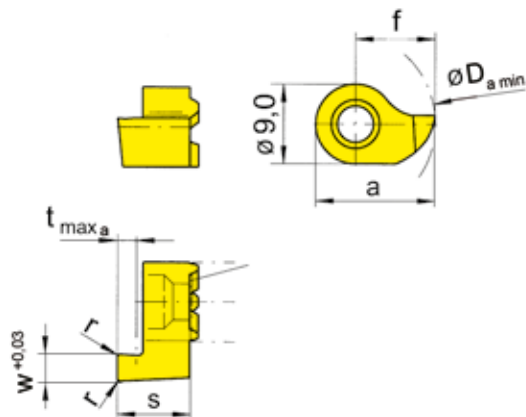
114



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 HC114
RBA114

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

适用于中心线前加工
Machining **IN-FRONT** of
centre line

产品型号 Part number	w	s	f	a	r	t _{max a}	D _{a min}		MG12	EG55	TF45	TN35
R/L 114.1410.00	1.0	8.3	9	13.5	-	1.5	14		Δ/Δ	▲/▲		▲/▲
R/L 114.1415.00	1.5	8.3	9	13.5	0.2	2.5	14			▲/▲		▲/▲
R/L 114.1420.00	2.0	8.3	9	13.5	0.2	3.0	14			▲/▲	x/x	▲/▲
R/L 114.1425.00	2.5	8.3	9	13.5	0.2	3.0	14			▲/▲		▲/▲
R/L 114.1430.00	3.0	8.3	9	13.5	0.2	3.0	14		▲/Δ	▲/▲		▲/▲
R/L 114.1420.5.00	2.0	10.8	9	13.5	0.2	5.0	14			▲/▲		▲/▲
R/L 114.1425.5.00	2.5	10.8	9	13.5	0.2	5.0	14			▲/▲		▲/▲
R/L 114.1430.6.00	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

○ 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

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=顺时针旋转！使用114刀片和B114刀杆时刀杆时， I_1 和 I_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 I_1 and I_2 will be enlarged by 3,0 / 5,5 or 6,5 mm.

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

硬质合金牌号
Carbide grades

端面切槽

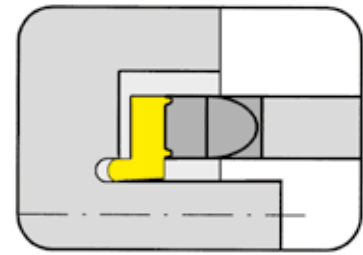
Face Grooving



B

刀片
Insert

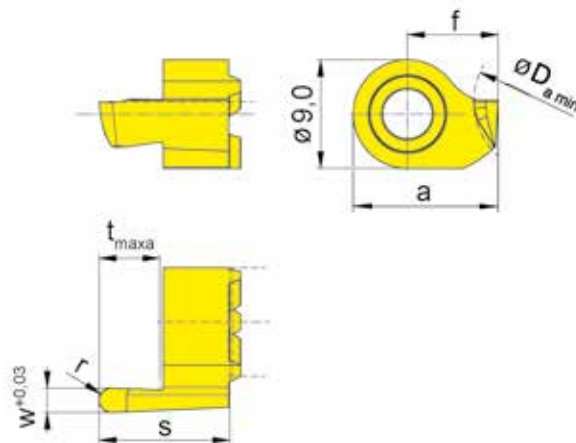
114



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
2-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114

圆头刀片 适用于中心
线后加工
Full radius Machining
BEHIND centre line

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	t _{max a}	Da 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 △ 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 = 顺时针旋转! 使用114系列端面槽刀片和B114刀杆时, l1和l2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 l1 and l2 will be enlarged by 5,5 mm or 6,5 mm.

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

端面切槽

Face Grooving



B

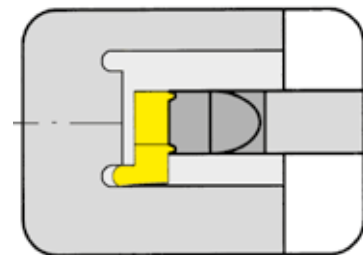
刀片
Insert

114

端面槽起始外径
槽深可达
槽宽

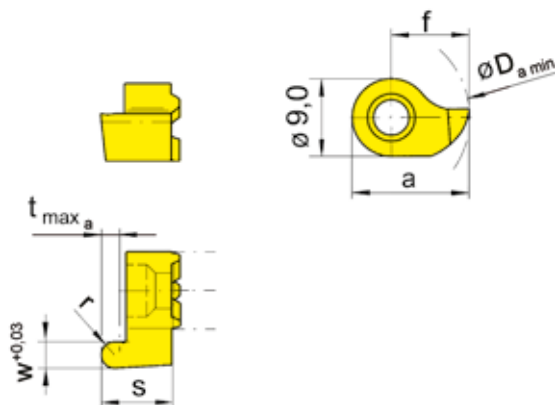
from outer groove $\varnothing$
Depth of groove up to
Width of groove

14 mm
3 mm
1-3 mm



配合刀杆
for Toolholder

型号 B114
Type HC114
RBA114



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}	Da 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 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=逆时针旋转 使用114系列端面槽刀片和B114刀杆时, I1和I2会增大3.0 mm。

Note:

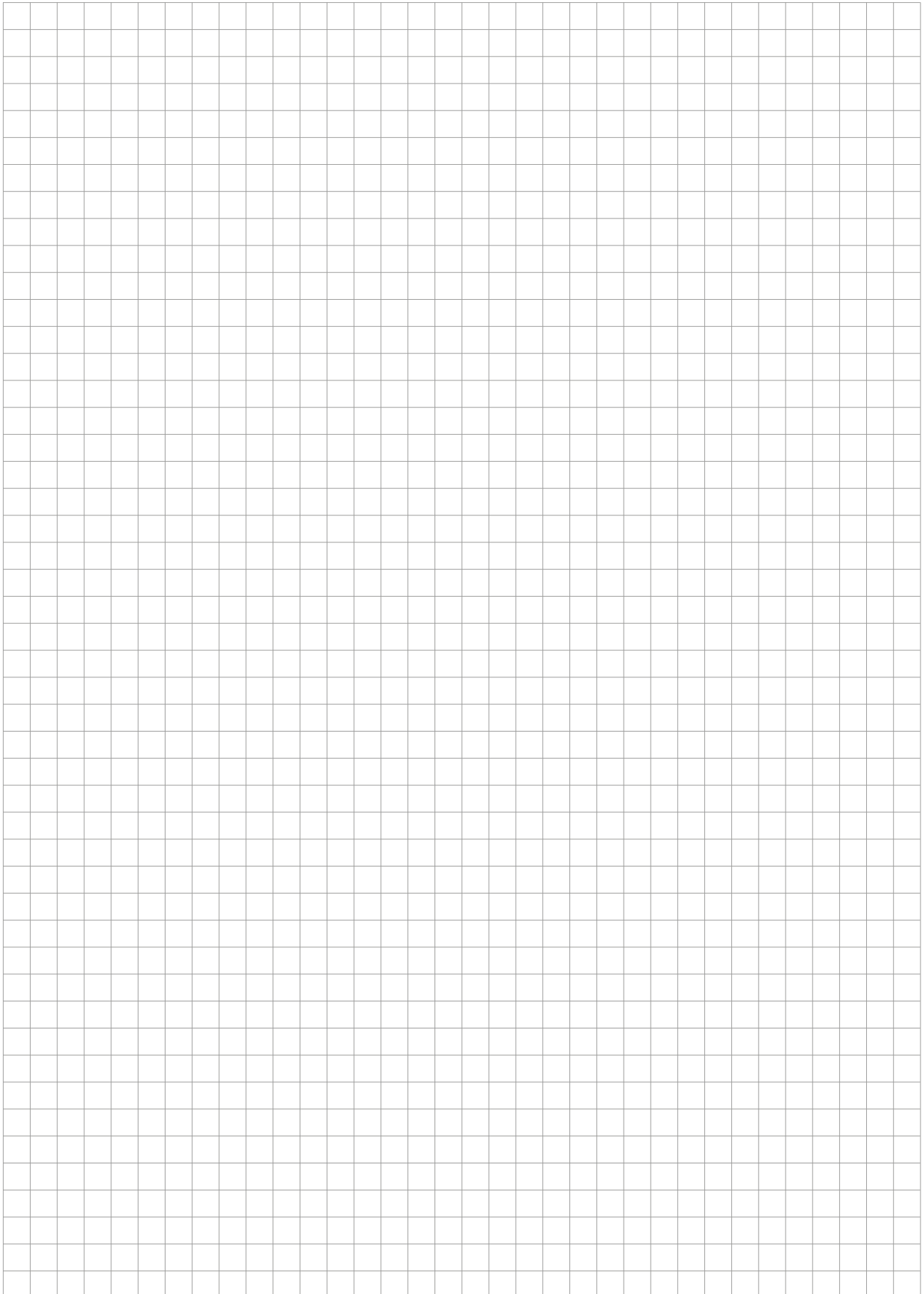
R = rotation clockwise! Using the face grooving insert type 114 on toolholder type B114 the size I1 and I2 will be enlarged by 3,0 mm.

按需提供更多尺寸

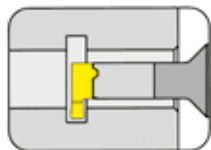
Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

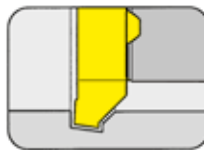
硬质合金牌号
Carbide grades



刀杆
Toolholder
B116

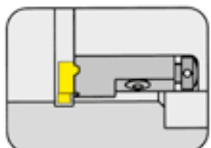


页/Page
B129-B130

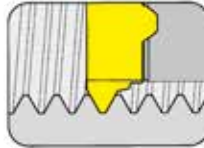


页/Page
B141

刀夹
Cartridge
145

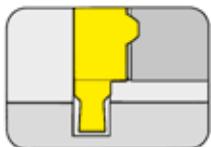


页/Page
B131

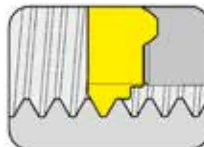


页/Page
B142-B143

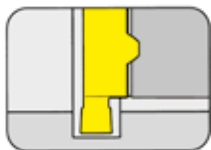
刀片
Insert
116/S116/107/111



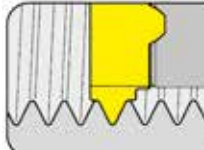
页/Page
B132



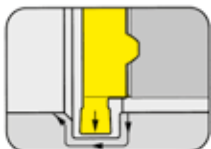
页/Page
B144-B145



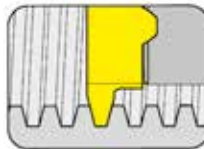
页/Page
B133, B135, B140



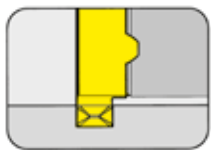
页/Page
B146



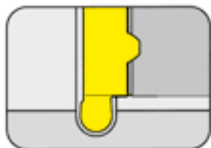
页/Page
B134



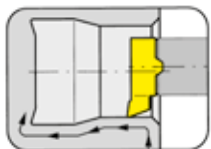
页/Page
B147



页/Page
B136



页/Page
B137



页/Page
B138-B140

116



机夹式刀杆

槽宽0,5 - 4 mm

Toolholder with Inserts

Width of groove 0,5 - 4 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽 (内圆)

Grooving (internal)



刀杆

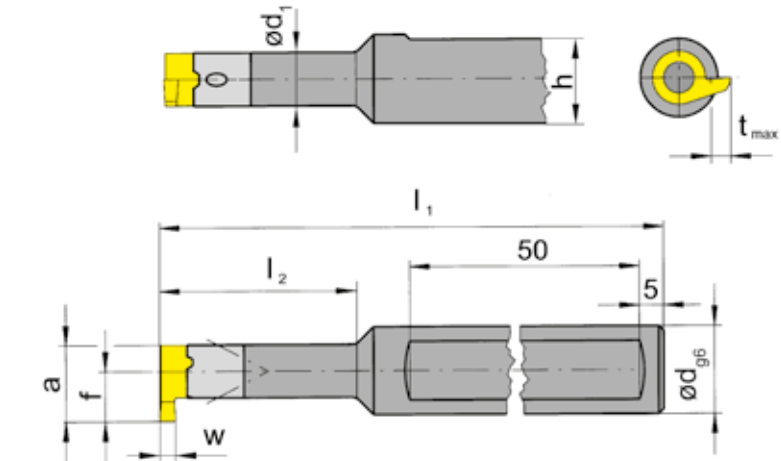
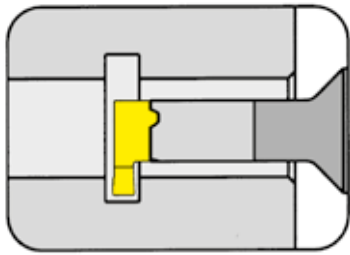
Toolholder

B116

直接冷却液供应
with through coolant supply

孔径Ø 自	Bore Ø from	16 mm
槽深	Depth of groove	4,3 mm
槽宽可达	Width of groove up to	4 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 116
Type S116

图示=右手型
Picture = right hand cutting version

产品型号 Part number	d	l ₁	l ₂	h	d ₁
B116.0012.01	12	130	40	11	11
B116.0012.02	12	130	56	11	11
B116.0012.03	12	150	80	11	11
B116.0016.01	16	130	40	15	11
B116.0016.02	16	130	56	15	11
B116.0016.03	16	150	80	15	11

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
B116...	5.13T20EP	T20PQ

切槽 (内圆)

Grooving (internal)



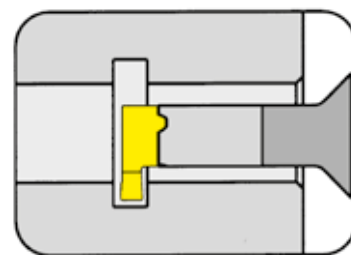
B

刀杆

Toolholder

B116

直接冷却液供应
with through coolant supply



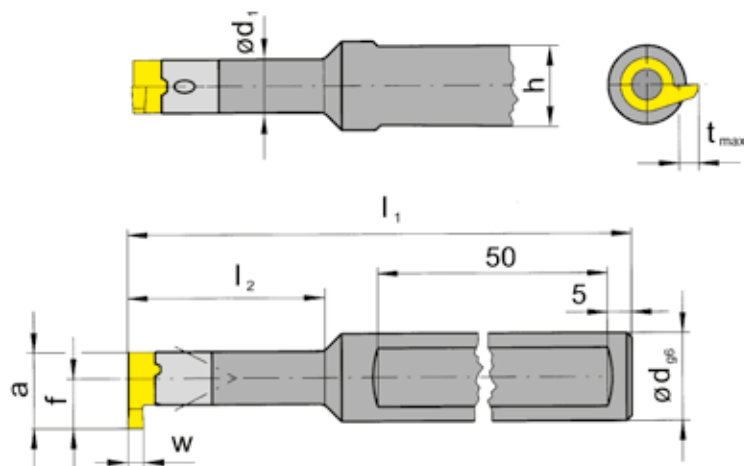
孔径Ø 自
槽深
槽宽可达

Bore Ø from
Depth of groove
Width of groove up to

16 mm
4,3 mm
4 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 116
Type S116

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	d_1
B116.0012.2.01	12	130	40	11	11
B116.0012.2.02	12	130	56	11	11
B116.0012.2.03	12	150	80	11	11
B116.0016.2.01	16	130	40	14	11
B116.0016.2.02	16	130	56	14	11
B116.0016.2.03	16	150	80	14	11

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
B116...	5.13T20EP	T20PQ

切槽 (内圆)

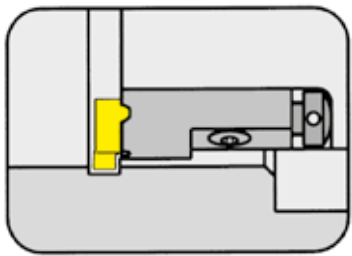
Grooving (internal)



刀夹

Cartridge

145
定制化刀具
for customized tools



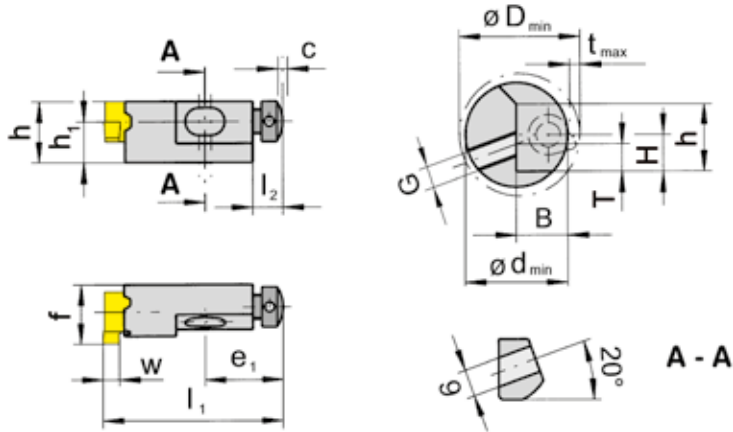
孔径Ø 自
槽深可达
槽宽可达

Bore Ø from
Depth of groove up to
Width of groove up to

32 mm
4.3 mm
4 mm

配合刀片
for Insert

型号 116
Type S116



产品型号 Part number	h	l ₁	h ₁	f	E ₁	l ₂	C	D _{min}	t _{max}	夹持范围 Clamping range
R/L145.1012.00	17	36	10	16.7	13.8	5	1	32	4.3	0.5-4.0

注明R或L型
State R or L version

w见刀片
w see inserts

尺寸单位：mm
Dimensions in mm

切削刃高度h₁
可以非标定制特殊高度h₁=6或7mm。
Height of cutting edge h₁
Special height h₁ = 6 or 7 mm available 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.

刀夹型号 seating sizes	H	T	B	G	d _{min}	h
R/L145.1012.00	10	9,0	12,0	M6	26	17

配件

Spare Parts

刀夹 Cartridge	锁紧螺钉 Clamping Screw	轴向调节螺钉 Setting screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L145.1012.00	5.13T20EP	4.06.020	T20PQ

切槽 (内圆)

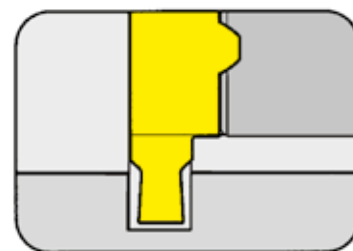
Grooving (internal)



B

刀片
Insert

116



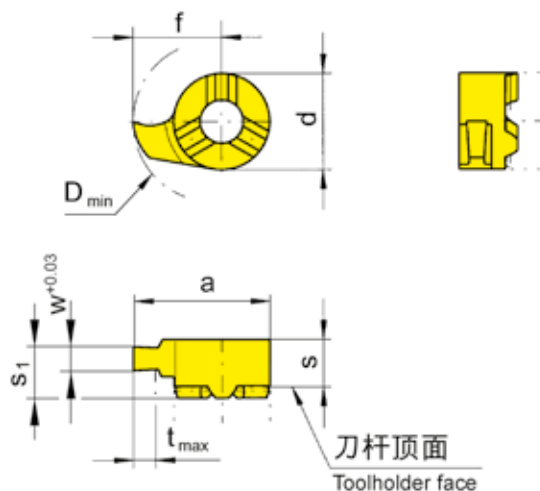
孔径Ø 自
槽深
卡簧宽度Nw

Bore Ø from
Depth of groove
Width of circlip Nw

16 mm
1.2-1.5 mm
0.7-0.9 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B116
Type 145

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

不能面切削， 有限的切削
深度
limited depth of cut

产品型号 Part number	w	Nw	s	f	a	s ₁	d	t _{max}	D _{min}	EG55	TN35
R/L116.0070.00	0.74	0.7	5.5	10.2	15.7	5.3	11	1.2	16	▲/△	▲/▲
R/L116.0080.00	0.84	0.8	5.5	10.2	15.7	5.3	11	1.3	16	▲/△	▲/△
R/L116.0090.00	0.94	0.9	5.5	10.2	15.7	5.3	11	1.5	16	▲/△	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

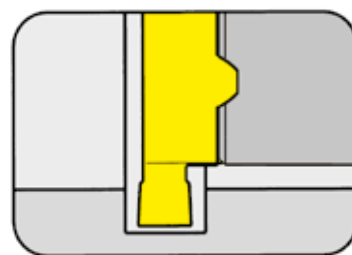
Grooving (internal)



B

刀片
Insert

116



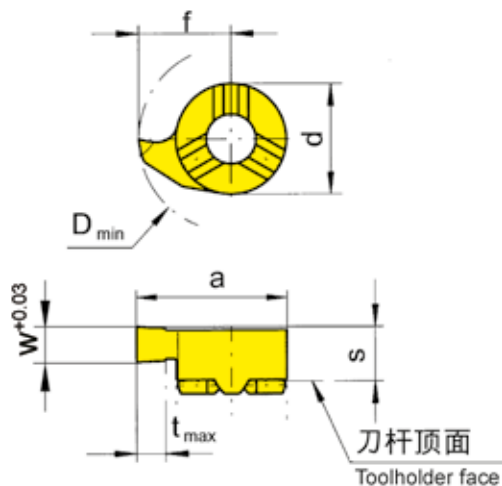
孔径Ø 自
卡簧宽度Nw

Bore Ø from
Width of circlip Nw

16 mm
1.1-1.6 mm

卡簧槽宽度DIN471/472

Widths for circlip grooves DIN 471/472



配合刀杆
for Toolholder

型号 B116
Type 145

R=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	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L116.0110.00	1.19	1.1	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0130.00	1.39	1.3	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0160.00	1.69	1.6	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
										P	o	•	•
										M	•	o	•
										K	•	o	•
										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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

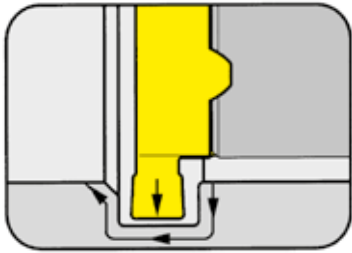
NC-仿形加工 (内圆)
NC-Profiling (internal)



B

刀片
Insert

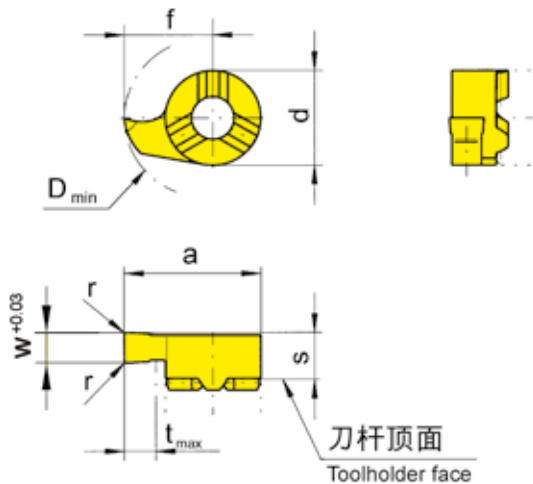
116



孔径Ø 自
槽深

Bore Ø from
Depth of groove

16 mm
4.3 mm



配合刀杆
for Toolholder

型号 B116
Type 145

R=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	d	t _{max}	D _{min}		EG55	TH35	TN35
R/L116.0200.02	2	5.3	10.2	15.7	0.2	11	4.3	16		▲/▲	▲/▲	▲/▲
▲ 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

硬质合金牌号
Carbide grades

切槽 (内圆)

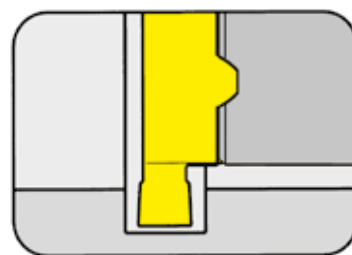
Grooving (internal)



B

刀片
Insert

116



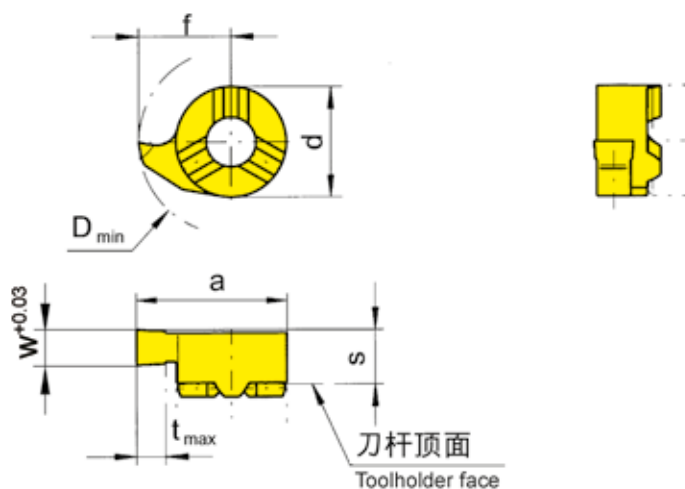
孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

16 mm
4.3 mm
2-4 mm

配合刀杆
for Toolholder

型号 B116
Type 145



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L116.0200.00	2.0	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0250.00	2.5	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0300.00	3.0	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲
R/L116.0350.00	3.5	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/x	▲/▲	▲/▲
R/L116.0400.00	4.0	5.3	10.2	15.7	11	4.3	16		▲/▲	▲/▲	▲/▲	▲/▲

▲ 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

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

硬质合金牌号
Carbide grades

切槽 (内圆)

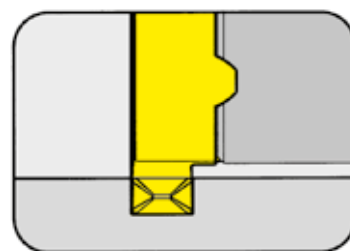
Grooving (internal)



B

刀片
Insert

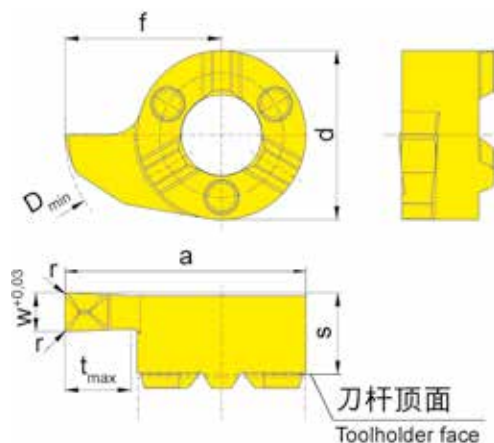
S116



孔径Ø 自
槽深可达
槽宽

Bore Ø from
Depth of groove up to
Width of groove

16 mm
4.3 mm
2-3 mm



配合刀杆
for Toolholder

型号 B116
Type 145

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

槽型.D
Geometry .D

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS116.0200.D2	2.0	5.3	10.2	15.7	0.2	11	4.3	16	▲/▲	▲/▲
R/LS116.0250.D2	2.5	5.3	10.2	15.7	0.2	11	4.3	16	▲/Δ	▲/▲
R/LS116.0300.D2	3.0	5.3	10.2	15.7	0.2	11	4.3	16	▲/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

按需提供更多尺寸

Further sizes upon request

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

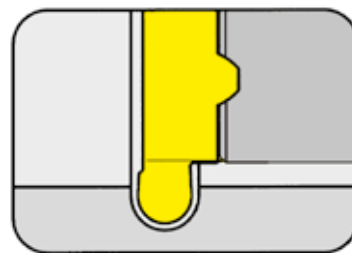
Grooving (internal)



B

刀片
Insert

116



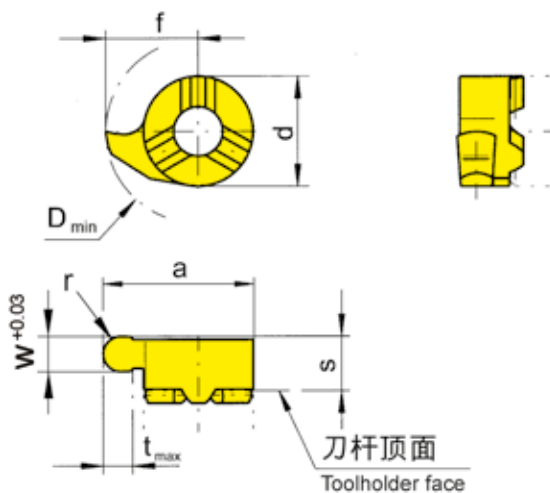
孔径Ø 自
圆头

Bore Ø from
Full radius

16 mm
0.9-2 mm

配合刀杆
for Toolholder

型号 B116
Type 145



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	s	f	a	d	r	t _{max}	D _{min}		MG12	EG55	TH35	TN35
R/L116.0009.18	1.8	5.3	10.2	15.7	11	0.9	4.3	16		▲/△	▲/▲	▲/▲	▲/▲
R/L116.0011.22	2.2	5.3	10.2	15.7	11	1.1	4.3	16		▲/△	▲/▲	▲/▲	▲/▲
R/L116.0015.30	3.0	5.3	10.2	15.7	11	1.5	4.3	16		▲/△	▲/▲	▲/▲	▲/▲
R/L116.0020.40	4.0	5.3	10.2	15.7	11	2.0	4.3	16		△/△	▲/▲	▲/▲	▲/▲
▲ 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

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片

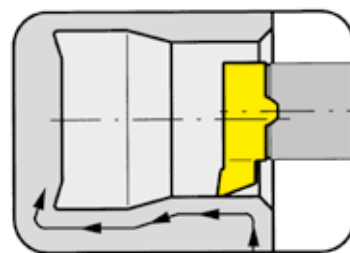
Insert

116

孔径Ø 自

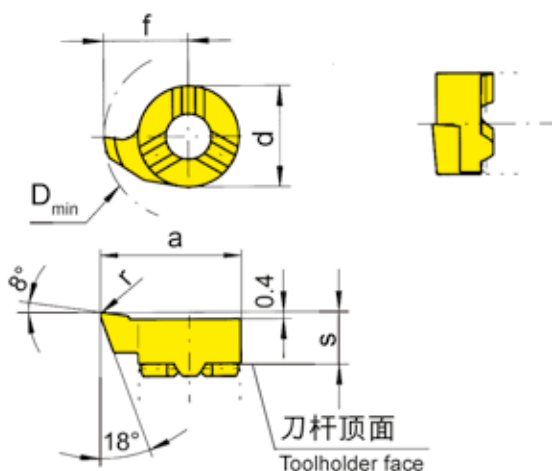
Bore Ø from

15.5 mm



配合刀杆
for Toolholder

型号 B116
Type 145



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	EG55	TH35	TN35
R/L/116.1897.02	5.3	9.7	15.2	0.2	11	15.5	▲/▲	▲/▲	▲/▲
▲ 库存 / on stock							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

改进过的几何结构可以镗≥ Ø15.5 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 15,5 mm and profiling of reliefs as per DIN 509 form E and F.

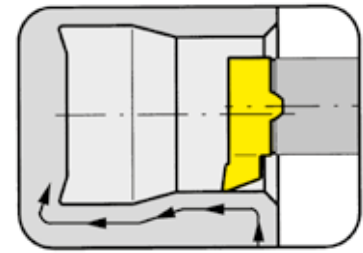
按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

刀片 Insert

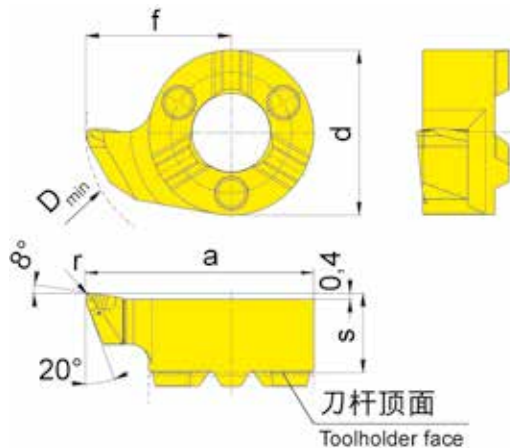
S116



孔径Ø 自

Bore Ø from

15.5 mm



配合刀杆
for Toolholder

型号 B116
Type 145

R型断屑槽
Geometry .R

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	EG55	TH35
R/LS116.1897.R2	5.3	9.7	15.2	0.2	11	15.5	▲/▲	▲/▲
R/LS116.1897.R4	5.3	9.7	15.2	0.4	11	15.5	▲/▲	▲/▲

▲ 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

改进过的几何结构可以镗≥ Ø15.5 mm的孔，也可以仿形加工DIN509E和F型的退刀槽。

The modified geometry allows boring of bores ≥ Ø 15,5 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

镗孔和仿形加工

Boring and Profiling

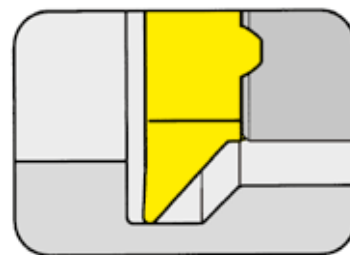


B

刀片

Insert

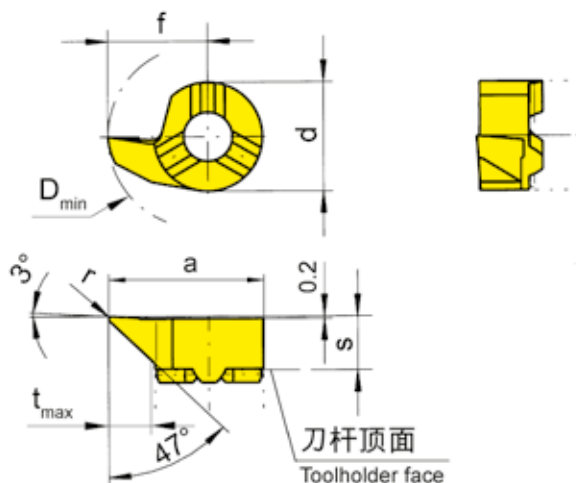
116



孔径 $\varnothing$ 自
向下切深可达

Bore $\varnothing$ from
Depth of undercut up to

16 mm
4.3 mm



配合刀杆
for Toolholder

型号 B116
Type 145

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35	TN35
R/L116.4702.02	5.3	10.2	15.7	0.2	11	4.3	16		▲/▲	▲/▲	▲/▲
R/L116.4702.04	5.3	10.2	15.7	0.4	11	4.3	16		▲/▲	▲/▲	▲/▲
▲ 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

改进后的几何结构可以镗 $\geq \varnothing 16$ mm的孔和仿形加工DIN509E型和F型的退刀槽。

The modified geometry allows boring of bores $\geq \varnothing 16$ mm and profiling of reliefs as per DIN 509 form E.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

预切槽和倒角 (内圆)

Pregrooving and Chamfering (internal)



刀片

Insert

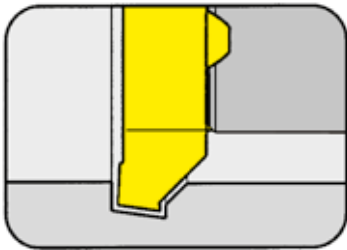
116

B

孔径Ø 自

Bore Ø from

16 mm

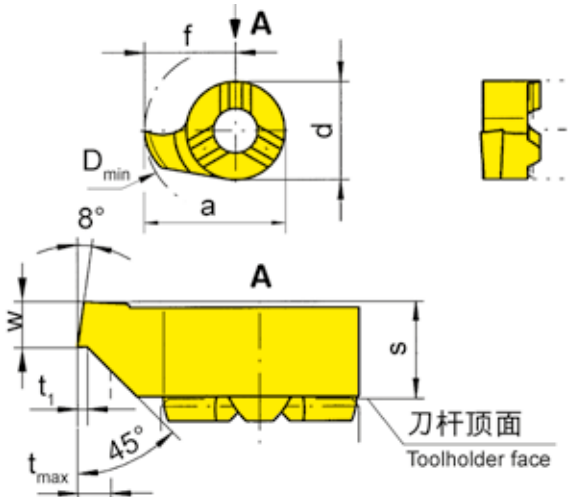


配合刀杆

for Toolholder

型号 B116

Type 145



R=右手型-如图

R = right hand version shown

L=左手型

L = left hand version

产品型号 Part number	w	s	f	a	d	t _{max}	t ₁	D _{min}	MG12	EG55	TI25
R/L116.0815.45	1.5	5.3	10.2	15.7	11	1.5	0.2	16	▲/△	▲/▲	▲/▲
▲ 库存 / on stock △ 4周 / 4 weeks × 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

硬质合金牌号

Carbide grades

螺纹切削 (内圆) -非全牙型
Threading (internal) Partial profile



B

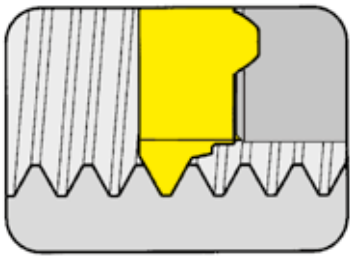
刀片
Insert

107

孔径Ø 自
螺距

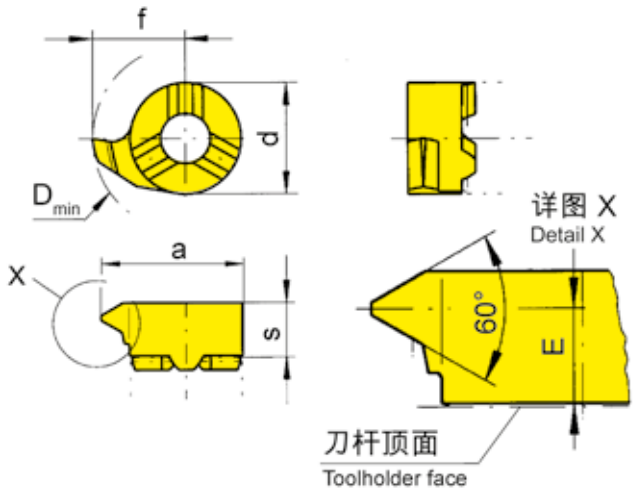
Bore Ø from
Pitch

16 mm
2-2.5 mm



配合刀杆
for Toolholder

型号 B116
Type 145



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}		EG55	TH35	TN35
R/L116.1020.01	2.0	4.3	10.2	15.7	11	5.5	16		▲/Δ	▲/Δ	▲/▲
R/L116.1325.01	2.5	4.2	10.2	15.7	11	5.5	16		▲/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

硬质合金牌号
Carbide grades

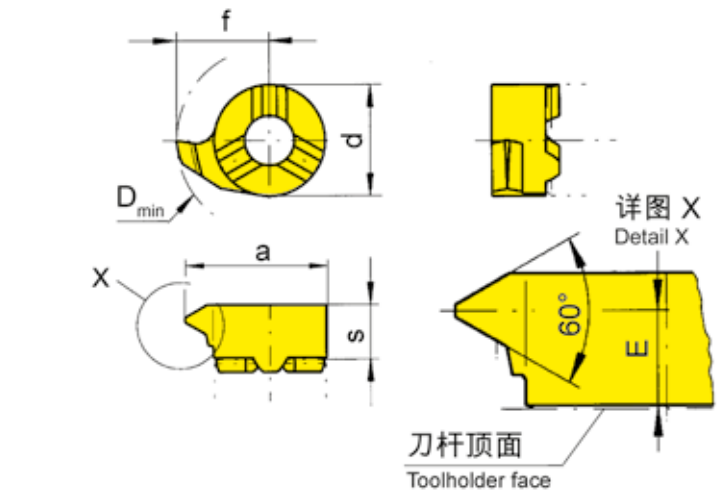
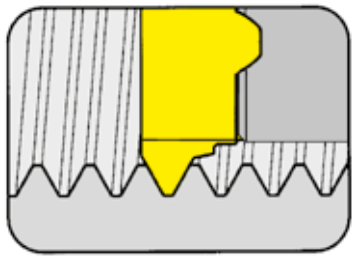
螺纹切削 (内圆) -非全牙型 Threading (internal) Partial profile



刀片
Insert

107

孔径Ø 自 螺距	Bore Ø from Pitch	16 mm 1-1,75 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 B116
Type 145

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}		EG55	TH35	TN35
R/L116.0510.01	1.0	4.7	10.2	15.7	11	5.5	16		▲/△	▲/△	▲/△
R/L116.0815.01	1.5	4.5	10.2	15.7	11	5.5	16		▲/△	▲/△	▲/△
▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

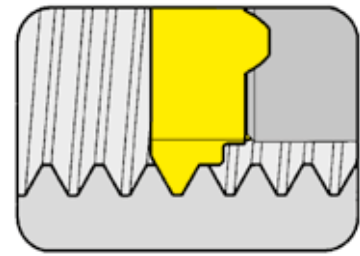
Threading (internal) Full profile



B

刀片
Insert

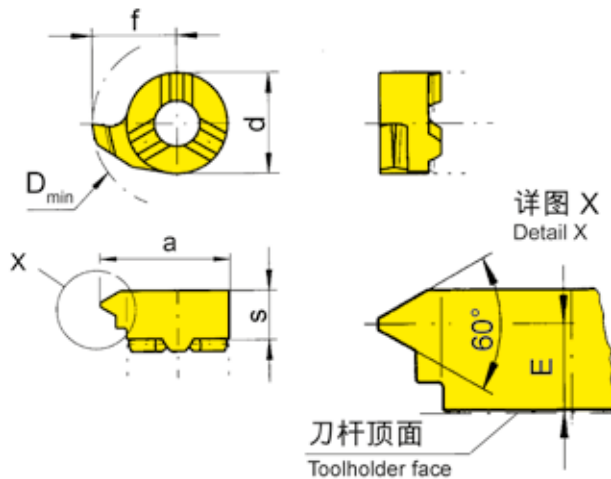
111



孔径Ø 自
螺距

Bore Ø from
Pitch

16 mm
2.5-4 mm



配合刀杆
for Toolholder

型号 B116
Type 145

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}	EG55	T125	TN35
R/L116.1325.02	2.5	4.2	10.2	15.7	11	5.5	16	▲/Δ	x/x	▲/▲
R/L116.1630.02	3.0	4.0	10.2	15.7	11	5.5	16	▲/▲		▲/▲
R/L116.1835.02	3.5	3.8	10.2	15.7	11	5.5	16	▲/Δ		▲/▲
R/L116.2140.02	4.0	3.6	10.2	15.7	11	5.5	16	▲/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	-	-	-

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

硬质合金牌号
Carbide grades

螺纹切削 (内圆) -全牙型

Threading (internal) Full profile



刀片
Insert

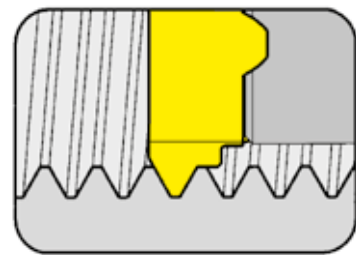
111

B

孔径Ø 自
螺距

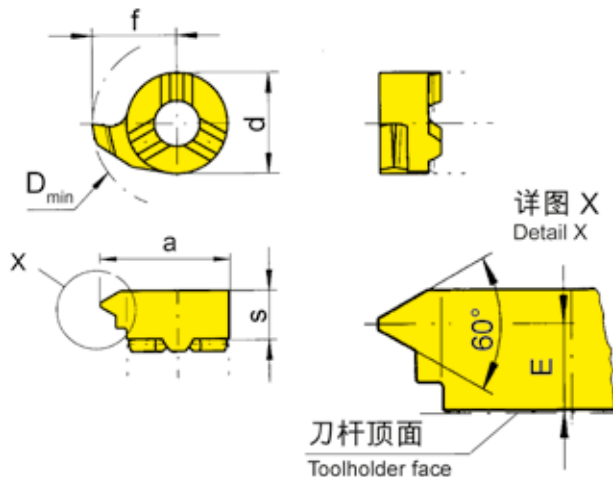
Bore Ø from
Pitch

16 mm
1-2 mm



配合刀杆
for Toolholder

型号 B116
Type 145



刀杆顶面
Toolholder face

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

ISO米制螺纹
Metric ISO thread

产品型号 Part number	P	E	f	a	d	s	D _{min}	EG55	Ti25	TN35
R/L116.0510.02	1.0	4.7	10.2	15.7	11	5.5	16	▲/▲	Δ/x	▲/Δ
R/L116.0815.02	1.5	4.5	10.2	15.7	11	5.5	16	▲/Δ	Δ/x	▲/▲
R/L116.1020.02	2.0	4.3	10.2	15.7	11	5.5	16	▲/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

硬质合金牌号
Carbide grades

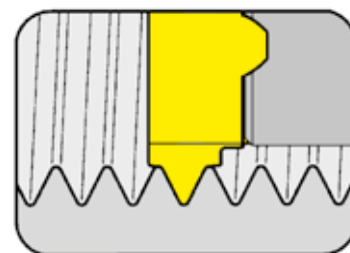
螺纹切削 (内圆) -全牙型 Threading (internal) Full profile



B

刀片
Insert

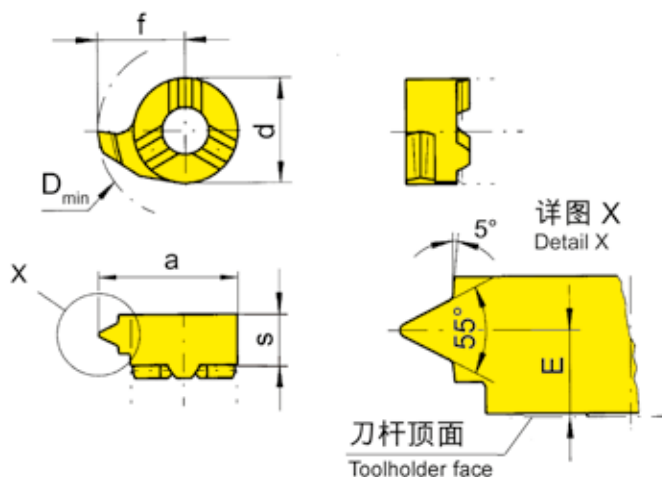
116



孔径Ø 自
每英寸牙数

Bore Ø from
Threads per inch

16 mm
11-14



配合刀杆
for Toolholder

型号 B116
Type 145

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

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

产品型号 Part number	TPI	E	f	d	s	D _{min}	EG55	TN35
R/L116.5511.02	11	3.5	10.2	11	5.5	16	▲/△	▲/△
R/L116.5514.02	14	3.9	10.2	11	5.5	16	▲/△	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

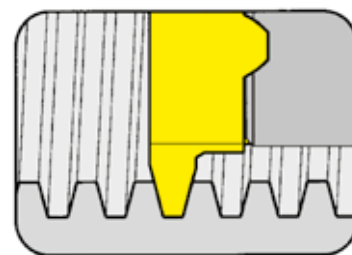
螺纹切削 (内圆) -非全牙型 Threading (internal) Partial profile



B

刀片
Insert

107



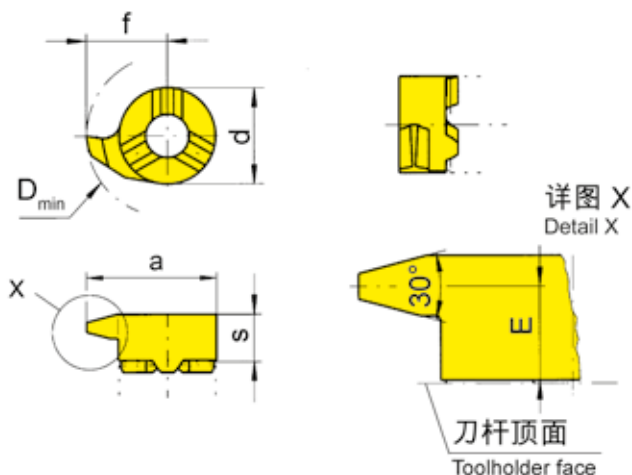
孔径Ø 自
螺距

Bore Ø from
Pitch

16 mm
2-6 mm

配合刀杆
for Toolholder

型号 B116
Type 145



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	f	a	d	s	D _{min}	螺纹 Thread	EG55	T125	TN35
R/L116.1220.01	2	4.50	9.7	15.2	11	5.5	16	Tr 20x2	▲/Δ		▲/Δ
R/L116.1730.01	3	4.30	9.7	15.2	11	5.5	16	Tr 22x3	▲/▲		▲/▲
R/L116.2240.01	4	4.00	9.7	15.2	11	5.5	16	Tr 22x4	▲/▲		▲/▲
R/L116.2750.01	5	3.55	10.2	15.7	11	5.5	16	Tr 24x5	▲/▲		▲/▲
R/L116.3560.01	6	3.30	10.2	15.7	11	5.5	16	Tr 30x6	▲/▲	▲/▲	

▲ 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

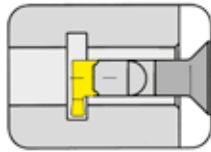
按需提供更多尺寸

Further sizes upon request

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

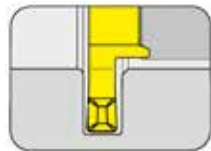
硬质合金牌号
Carbide grades

刀杆
Toolholder
18P

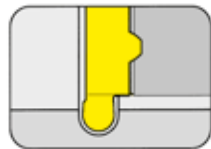


页/Page
B151

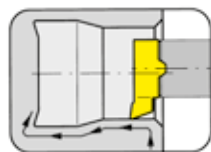
刀片
Insert
S18P/18P



页/Page
B152, B154



页/Page
B153



页/Page
B155

18P



机夹式刀杆

槽宽 2 - 3 mm

Toolholder with Inserts

Width of groove 2 - 3 mm

HCG - HORN Catalogue Guide

内圆切槽 / INTERNAL GROOVING

孔径 Bore Ø	产品线 / Product line											
	105	109	110	106	107	108	10P	111	11P	114	116	18P
≥ 0.2	•											
≥ 0.5	•											
≥ 0.7	•											
≥ 1.0	•											
≥ 1.5	•											
≥ 2.0	•											
≥ 3.0	•											
≥ 4.0	•											
≥ 5.0	•											
≥ 6.0	•	•	•	•								
≥ 6.8		•	•	•								
≥ 7.0		•			•							
≥ 7.8			•		•	•						
≥ 8.0			•		•	•						
≥ 9.0			•		•	•	•					
≥ 10.0			•				•	•	•			
≥ 10.5									•			
≥ 11.0								•	•			
≥ 11.5									•			
≥ 13.8										•		
≥ 14.0										•	•	
≥ 16.0											•	
≥ 16.5										(•)		
≥ 18.0												•

槽深 Depth of groove	2.5	2.5	4.0	0.8	2.0	1.0	3.0	2.3	3.5	4.0 (6.5)	4.3	8.0
-----------------------	-----	-----	-----	-----	-----	-----	-----	-----	-----	--------------	-----	-----

槽宽 Width of groove	0.5-2.0	1.0-2.0	1.0-3.0	0.7-1.5	1.0-2.0	0.7-2.0	1.0-3.0	0.7-3.0	1.0-3.0	0.7-3.0	0.7-4.0	2.0-3.0
-----------------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

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

可应要求提供非标刀具
Special tools upon request

尺寸单位 : mm
Dimensions in mm

切槽 (内圆)

Grooving (internal)

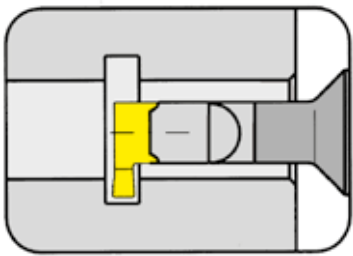


刀杆

Toolholder

18P

直接冷却液供应
with through coolant supply

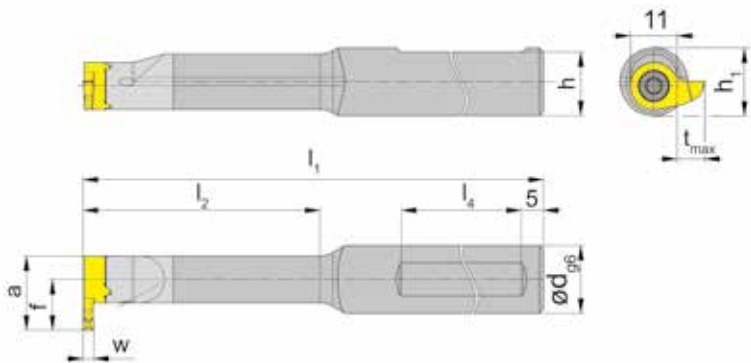


孔径Ø 自	Bore Ø from	18 mm
槽深可达	Depth of groove up to	8 mm
槽宽	Width of groove	2-3 mm

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 18P
Type S18P



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	d	l ₁	l ₂	h	l ₄	h ₁
R/LB18P.0012.00	12	100	25	11	50	12.5
R/LB18P.0012.01	12	120	40	11	50	12.5
R/LB18P.0016.00	16	100	25	15	50	13.0
R/LB18P.0016.01	16	120	40	15	50	13.0
R/LB18P.0016.02	16	130	56	15	50	13.0
R/LB18P.0016.03	16	150	80	15	50	13.0

注明R或L型
State R or L version
w, a, t_{max} 和 f 见刀片
w, a, t_{max} and f see inserts

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

订货须知：
HORN可以返修损坏的刀杆基座。

Ordering note:
Toolholders with damaged seating can be repaired by HORN.

螺丝的扭矩规格，详见技术说明。
For torque 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/LB18P...	5.13T20EP	T20PQ

切槽 (内圆)

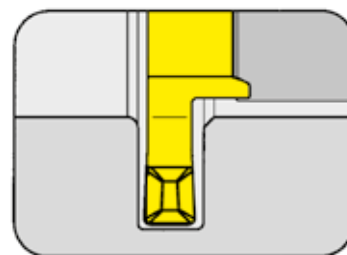
Grooving (internal)



B

刀片
Insert

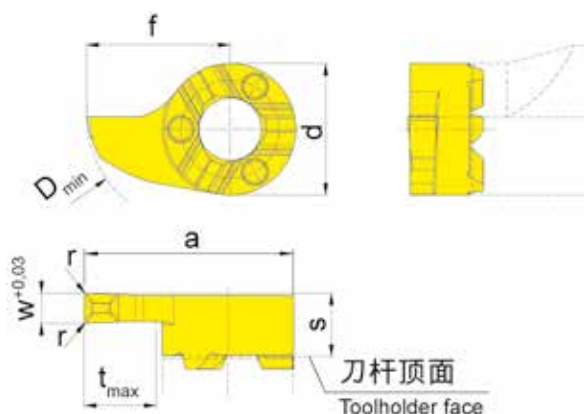
S18P



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

18 mm
6 mm
2-3 mm



配合刀杆
for Toolholder

型号 B18P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}	EG55	TH35
R/LS18P.0200.1.D2	2.0	5.3	12	17.5	0.2	11	6	18	▲/▲	▲/▲
R/LS18P.0250.1.D2	2.5	5.3	12	17.5	0.2	11	6	18	▲/▲	▲/▲
R/LS18P.0300.1.D2	3.0	5.3	12	17.5	0.2	11	6	18	▲/▲	▲/▲

▲ 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

P	•	•
M	○	•
K	○	•
N	-	•
S	-	•
H	-	-

硬质合金牌号
Carbide grades

切槽 (内圆)

Grooving (internal)



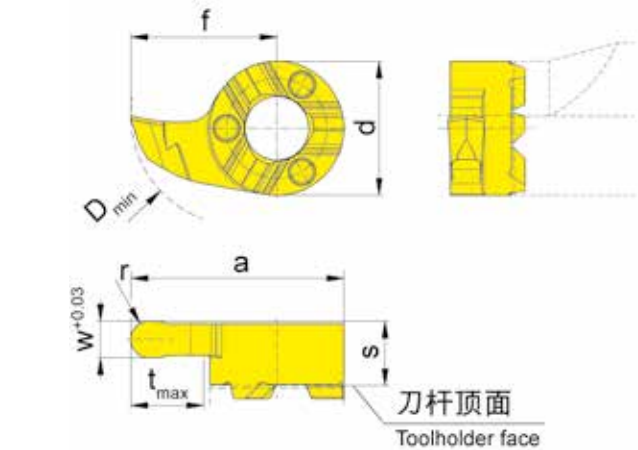
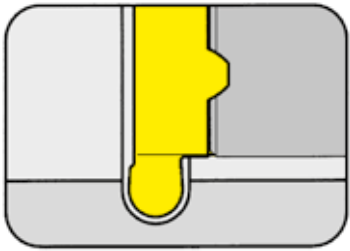
刀片
Insert

18P

孔径Ø 自
圆头

Bore Ø from
Full radius

18 mm
0.9-1.5 mm



配合刀杆
for Toolholder

型号 B18P
Type

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	s	f	a	r	d	t _{max}	D _{min}	EG55 ▲/△ ▲/▲	TH35 ▲/▲ ▲/▲	
R/L18P.0009.1.18	1.8	5.3	12	17.5	0.9	11	6	18			
R/L18P.0011.1.22	2.2	5.3	12	17.5	1.1	11	6	18			
R/L18P.0015.1.30	3.0	5.3	12	17.5	1.5	11	6	18			
▲ 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

切槽 (内圆)

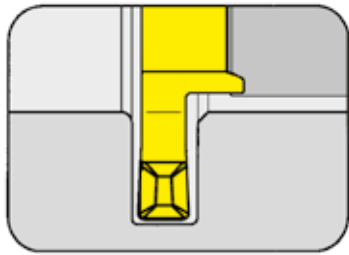
Grooving (internal)



B

刀片
Insert

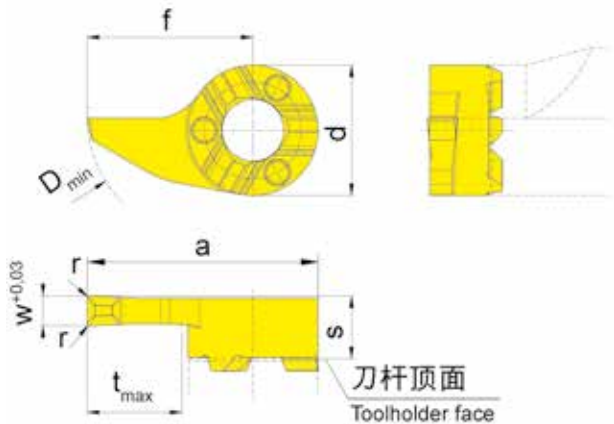
S18P



孔径Ø 自
槽深
槽宽

Bore Ø from
Depth of groove
Width of groove

20 mm
8 mm
2-3 mm



配合刀杆
for Toolholder

型号 B18P
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	w	s	f	a	r	d	t _{max}	D _{min}		EG55	TH35	
R/LS18P.0200.2.D2	2.0	5.3	14	19.5	0.2	11	8	20		▲/▲	▲/▲	
R/LS18P.0250.2.D2	2.5	5.3	14	19.5	0.2	11	8	20		▲/▲	▲/▲	
R/LS18P.0300.2.D2	3.0	5.3	14	19.5	0.2	11	8	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	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												

▲ 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
按需提供更多尺寸
Further sizes upon request

硬质合金牌号
Carbide grades

刀片

Insert

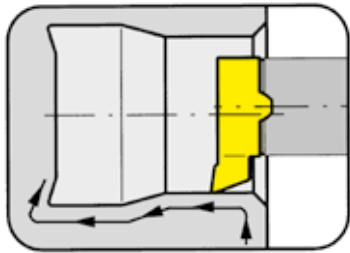
S18P

B

孔径Ø 自

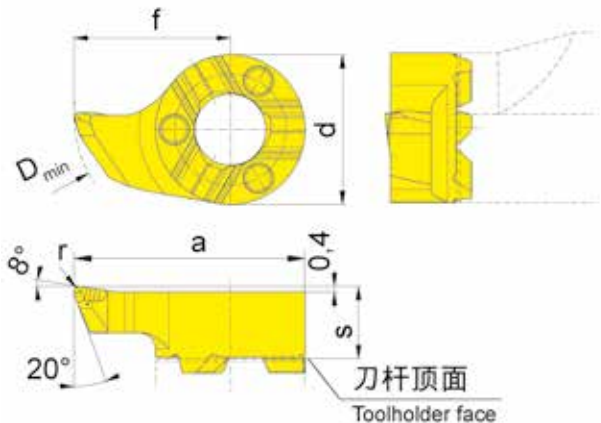
Bore Ø from

17.5 mm



配合刀杆
for Toolholder

型号 B18P
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	s	f	a	r	d	D _{min}	EG55	TH35
R/LS18P.1815.R2	5.3	11.5	17	0.2	11	17.5	Δ/Δ	▲/Δ
R/LS18P.1815.R4	5.3	11.5	17	0.4	11	17.5	▲/▲	▲/▲
▲ 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

改进型的几何结构可以镗≥Ø17.5mm的孔和仿形加工DIN509E型和F型的退刀槽。

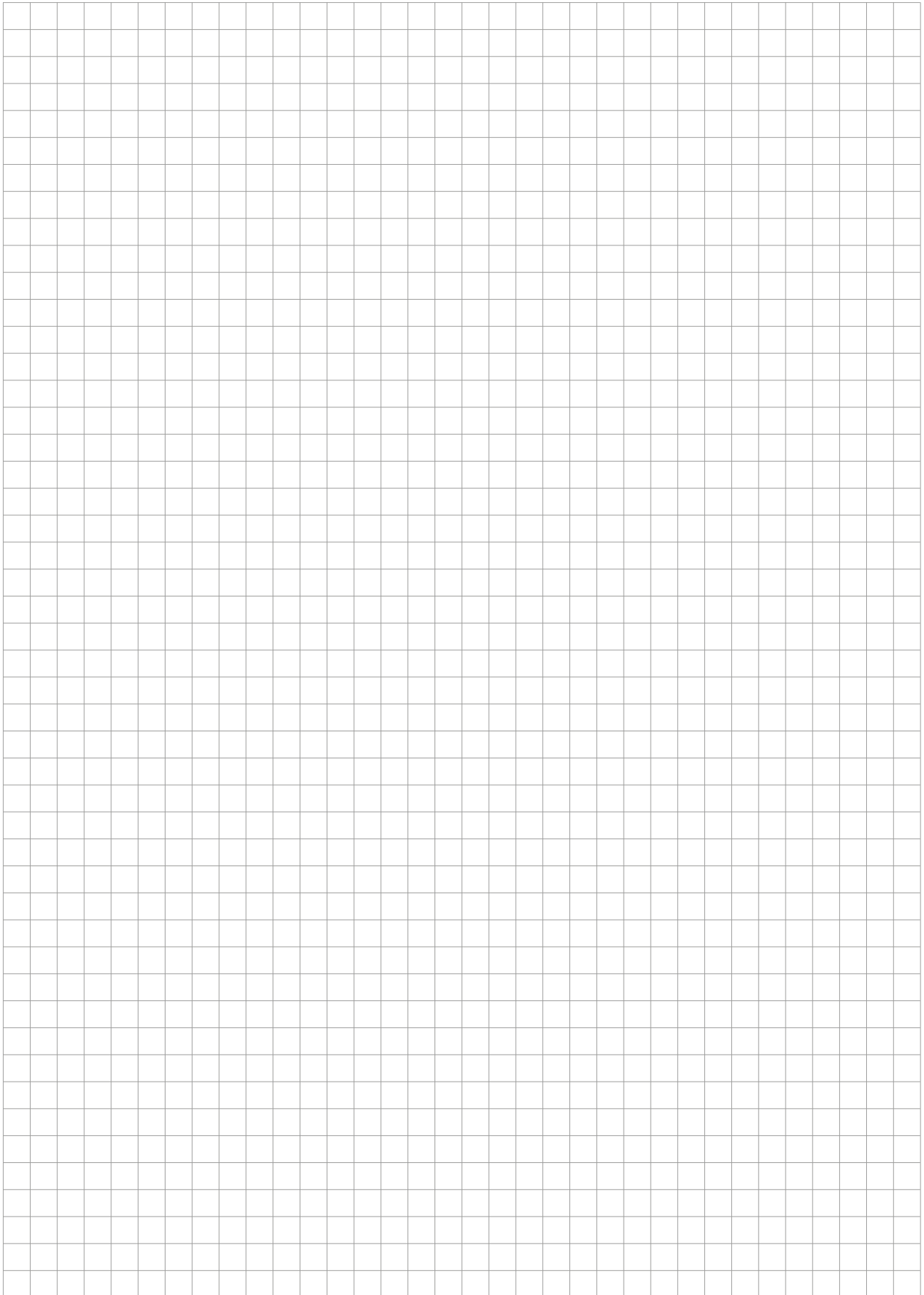
The modified geometry allows boring of bores ≥ Ø 17,5 mm and profiling of reliefs as per DIN 509 form E and F.

按需提供更多尺寸

Further sizes upon request

硬质合金牌号
Carbide grades

B



技术说明
Technical Instructions

C2-C8

加工实例
Examples for machining

C10-C14

附加设备
Additional equipment

C16-C19

C

无涂层牌号

MG12 - 一种具有良好耐磨性的牌号，用于中低速加工钢件，铸铁和非铁材料。

涂层牌号

TN35 - 一种非常受欢迎的涂层TiN,用于中低速切削，推荐用于加工不锈钢和特种合金。

TI25 - TiCN涂层具有很高的耐磨性，推荐用于中速加工钢和有色金属材料

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

TH35 - 新的标准牌号-出色的热稳定性和高硬度，并且有非常低的摩擦系数。

EG35 - AlTiN和TiN涂层牌号。这种涂层推荐使用用于钢件和铸钢。也是奥氏体不锈钢,铁素体
EG55 不锈钢,铸钢,铸铁(灰铁,铸铁,可锻铸铁)

Uncoated Grades

MG12 - a universal grade with good wear resistance. Used at low or medium cutting speeds for machining steel, cast iron and non ferrous materials

Coated Grades

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

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

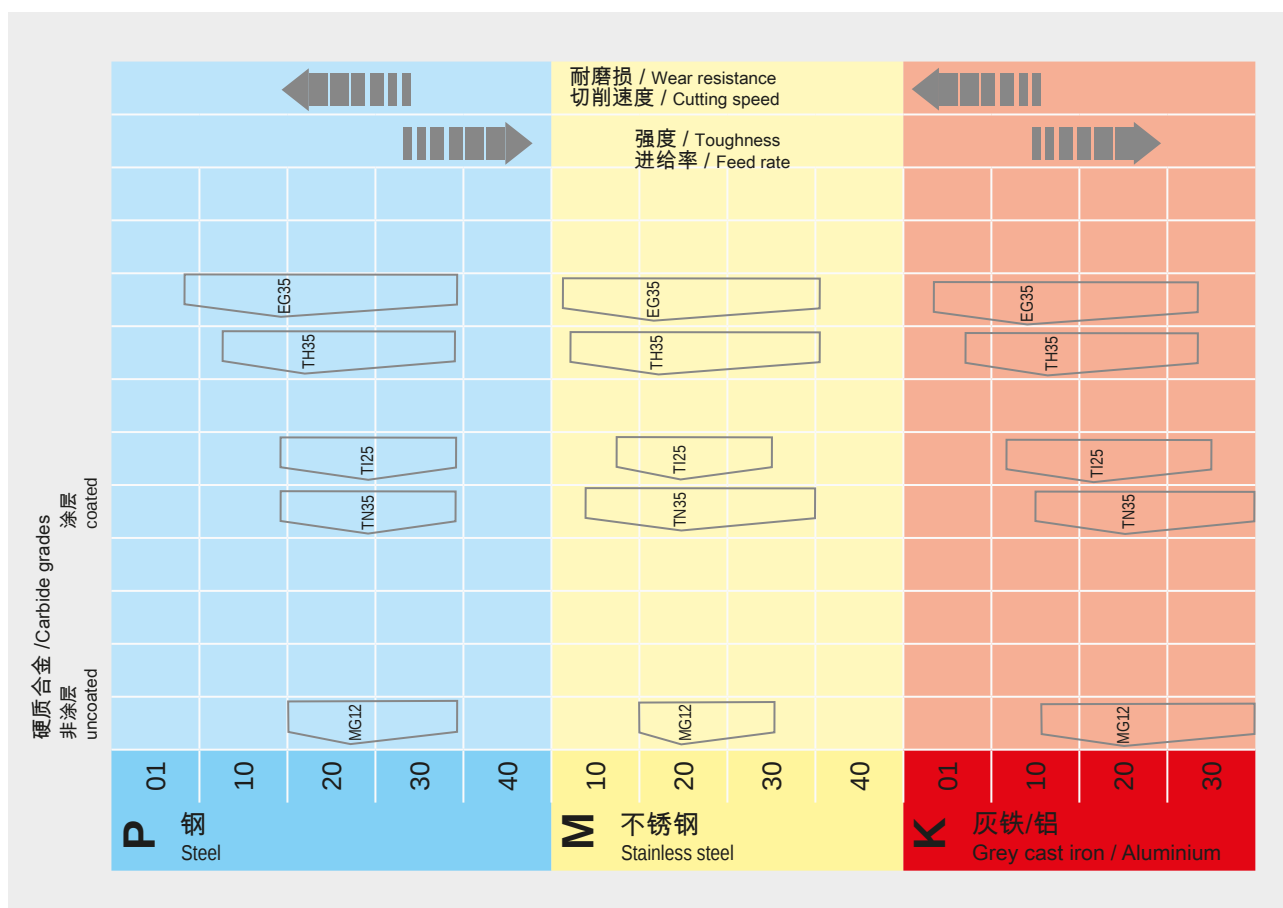
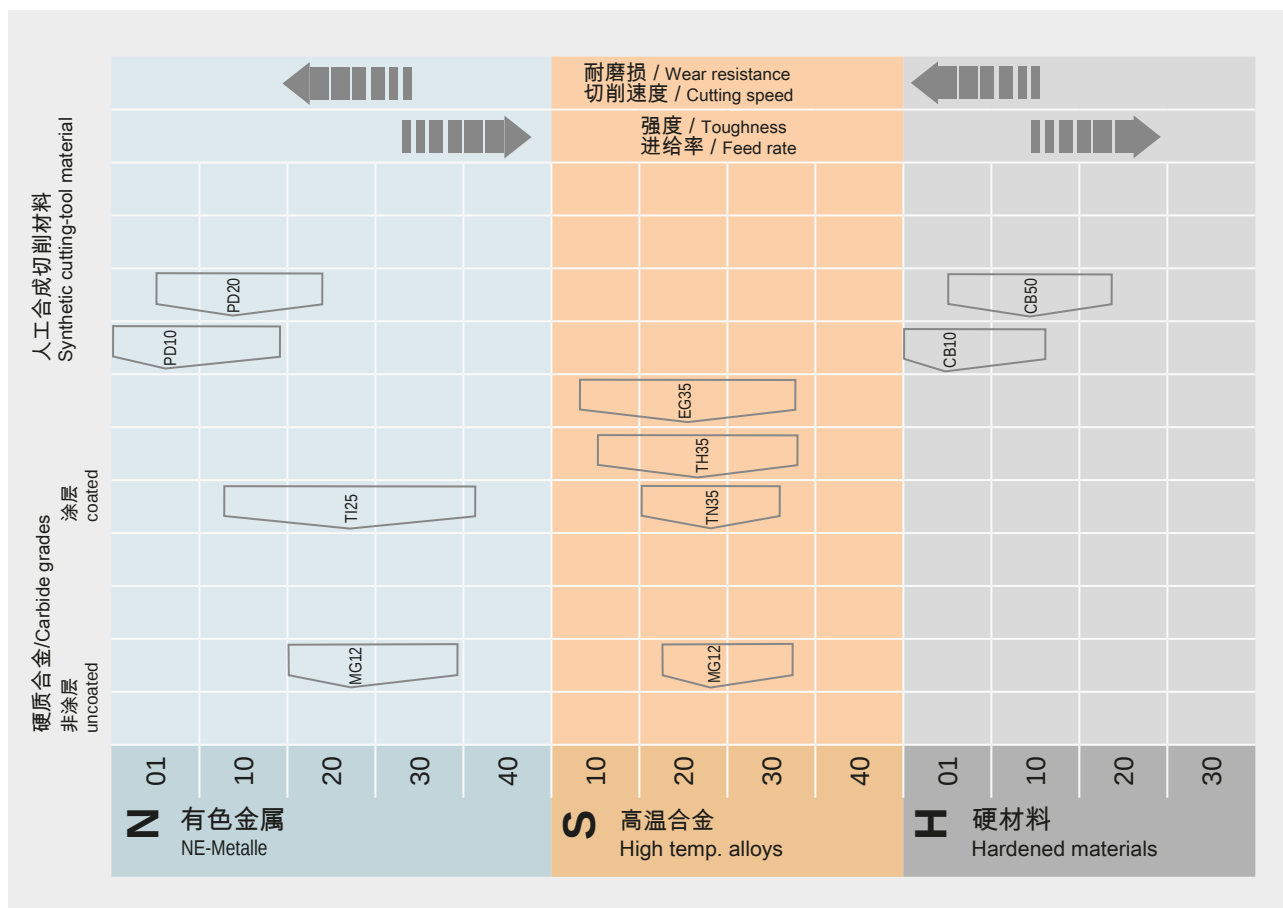
TF45 - a TiAlN coated grade. This coating has a very high temperature stability and high hardness and is
TA45 only used for special applications.

TH35 - a TiAlN coated grade. This coating has an extreme Oxidation resistance with high hardness and very good coefficient of friction.

EG35 - a AlTiN and TiN coated grade. This coating is recommended for all types of steel and cast steel.
EG55 Alternative recommended for austenitic stainless steel, austenitic ferritic steel, cast steel, cast iron with lamellas and spheroidal graphite as well as malleable cast iron.

硬质合金牌号的选择

Choice of Carbide Grades



HORN各种刀具材质的推荐切削速度

Nominal cutting speeds with HORN grades

			进给率 f (mm/U) / Feed rate f (mm/rev)					
			硬度 Brinell Hardness Brinell	Supermini®		Mini		切削速度 / Cutting speed *v _c m/min
					0,01 - 0,02		0,01 - 0,03	
					0,02 - 0,05		0,03 - 0,10	
					0,02 - 0,05		0,01 - 0,08	
ISO	材料 Material		HB	MG12	TN35	TI25	TH35	EG35 EG55
P	碳钢 Carbon steel	C < 0,4%	125	14-110	14-180	14-180	14-180	14-200
		C > 0,4% < 0,6 %	150					
		C > 0,4% < 0,6 %	200					
	低合金钢 low alloyed steel	退火 annealed	180	16-90	16-150	16-150	16-180	16-200
		调质 quenched	275					
		调质 quenched	300					
	高合金钢 high alloyed steel	退火 annealed	200		19-90	19-90	19-120	19-140
		调质 quenched	325					
	铸钢 Cast steel	非合金 unalloyed	180	19-110	19-180	19-180	19-180	19-200
		低合金 low alloyed	220					
		高合金 high alloyed	225					
M	不锈钢 Stainless steel	马氏体，铁素体 martensitic, ferritic	200		19-90	19-90	19-90	19-90
		奥氏体 austenitic	180		16-80		16-80	16-80
K	灰铸铁 Grey cast iron		180-260	16-90	16-150	16-150	16-150	16-160
	球墨铸铁 Spheroidal graphite cast iron		180-260	16-90	16-130	16-130	16-150	16-160
	可锻铸铁 Malleable cast iron		130-230		16-130	16-130	16-150	16-160
S	耐热合金 Heat resistant alloy	NiFe				18-75	18-75	
		NiCo				18-40	18-40	
N	铝合金 Al-alloys			14-220	16-600	16-600	16-600	
	铜和黄铜合金类 Copper and brass alloys			14-220	14-700	14-700	14-700	
H	硬化材料 hardened material	> 54 HRC						

v_c 决定于刀具直径和机床的最大转速。

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

螺纹

所有螺旋升角不大于4.5°的螺纹可以被HORN的标准品加工. 不需要特殊的刀垫.

安装

Mini 和 Supermini 都可以保证精确的中心高. 即便如此,也请每次检查刀具中心高度,尤其是加工小直径零件时.

排屑

请选择小宽度的刀片,这样可以帮助铁屑排出和切屑流出孔. 避免夹屑可以使用分步切槽.

冷却

使用过滤的切削液帮助带走切屑和冷却刀具. 冷却液推荐至少5BAR

Threading

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

Seatings

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

Removal of Chips

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

Coolant

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

推荐切削参数
Recommended number of passes

硬质合金牌号 / Carbide grade		钢 (拉伸强度 N/mm2) 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 P		走刀次数 / Number of passes							
mm	Gg/'' / tpi								
0,8	32	5	5	5	5	8	8	5	5
1,0	24	6	6	6	6	8	8	6	6
1,25	20 - 19	7	7	7	7	8	8	7	7
1,5	16	8	8	8	8	10	10	8	8
1,75	14	10	10	10	10	12	12	10	10
2,0	12 - 11	12	12	12	12	14	14	12	12
2,5	10	13	13	13	13	15	15	13	13
3,0 - 3,5	8	15	15	16	16	18	18	16	15

表中的推荐切削行程数为近似值

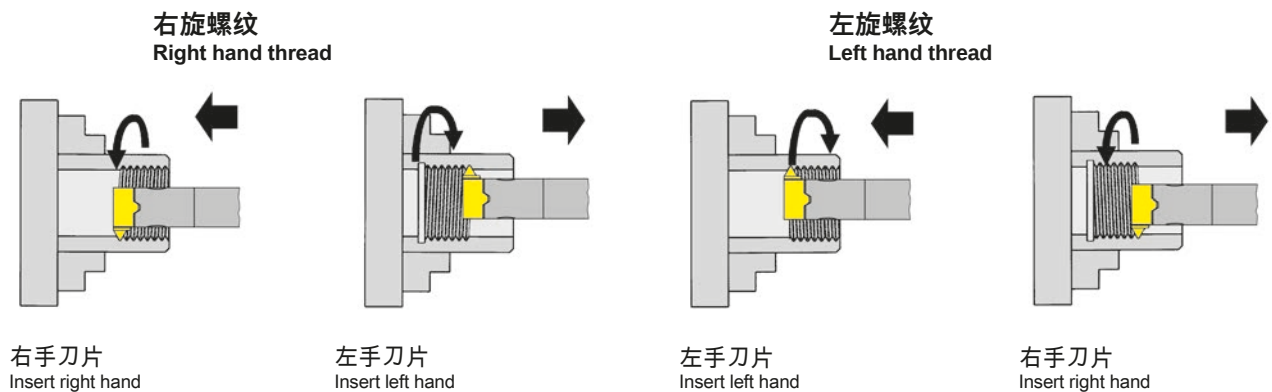
请注意：
- 为了避免切削刃的损坏，首行程切深不宜过大
- 最后零切深的精修在表内未考虑

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

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

进给率 内螺纹加工

Feed direction internal threading



进给

In-Feed

径向进给

同时切削刀片两边的材料，这是加工螺纹时最普通的方法。

Radial In-Feed

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



改进的侧刃进给

更小的后刀面磨损和相应的工件侧面上的更好的表面光洁度。

Modified Flank In-Feed

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



变化的后刀面进给

两个刃都被充分利用，意味着刀片寿命更长。

Alternating Flank In-Feed

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



后刀面进给

更好的断屑和散热

Flank In-Feed

More easily formed chip and better heat dissipation.



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

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

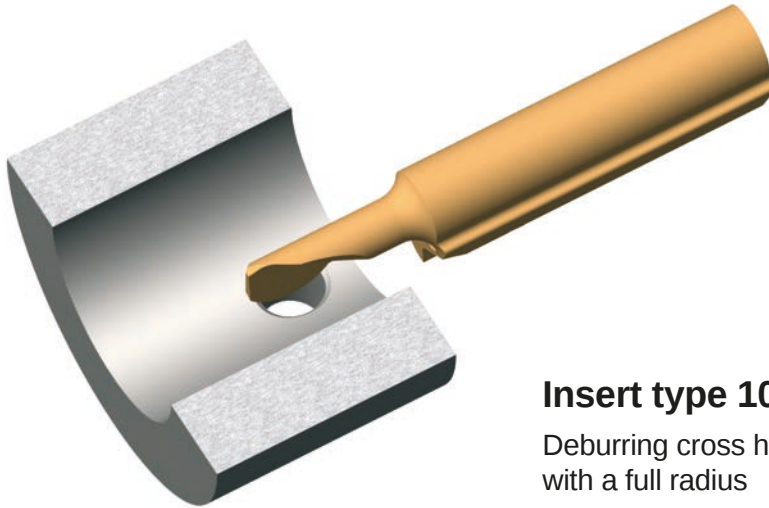
型号 type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
AIH	030.3509.T15P 6.075T15P	2,5 5,0	T10PL T15PQ	DT10PK DT15PK
B105	6.075T15P	5,0	T15PQ	DT15PK
B105.00...S...03/04/05	030.0000.0991	2,0	T15PL	DT15PK
B106	1.8.4T6EP	0,9	T6PL	DT6PK
B107	2.2.5T7EP	1,1	T7PL	DT7PK
B108	2.6.5T8EP	1,2	T8PL	DT8PK
B109	6.075T15P	5,0	T15PQ	DT15PK
B10P	2.6.5T8EP	1,2	T8PL	DT8PK
B110	6.075T15P	5,0	T15PQ	DT15PK
B111	3.512T10EP	3,0	T10PL	DT10PK
B114	4.12T15EP	5,0	T15PQ	DT15PK
B116	5.13T20EP	6,5	T20PQ	DT20PK / DT20PQ
B11P	3.10T9P	1,8	T9PL	DT9PK
B18P	5.13T20EP	6,0	T20PQ	DT20PK / DT20PQ
BGT001...	DIN912M5x10	5,0	SW4DIN911	DSW40K
BGT001.C...	DIN912M5x14	5,0	SW4DIN911	DSW40K
BKT	6.075T15P	5,0	T15PQ	DT15PK
BKT105.24...S...03/04/05	030.0000.0991	2,0	T15PL	DT15PK
BU105	6.075T15P	5,0	T15PQ	DT15PK
H105	6.075T15P	5,0	T15PQ	DT15PK
HC105	6.075T15P	5,0	T15PQ	DT15PK
HC114	4.12T15EP	5,0	T15PQ	DT15PK
IR105	6.075T15P	5,0	T15PQ	DT15PK
LB105.A022.26.31	030.0422.T10P	2,0	T10PL	DT10PK
KM16NC...	KM16-NSPKG	10,0	D515QL	DT27PQ
KM2016NC...	KM16-NAPKG	10,0	D515QL	DT27PK
N...	6.075T15P	5,0	T15PQ	DT15PK
RBA114	4.12.T15P	5,0	T15PQ	DT15PK
VDI	6.075T15P	5,0	T15PQ	DT15PK
001	DIN1835B-M8x7,5	5,0	SW4DIN911	DSW40K
125	3.512T10EP	3,0	T10PL	DT10PK
145	5.13T20EP	6,5	T20PQ	DT20PK / DT20PQ
962	6.075T15P	5,0	T15PQ	DT15PK
963	6.075T15P	5,0	T15PQ	DT15PK

加工实例
Examples for machining

C10-C14

刀片 型号 105

使用旋转刀片去除交叉孔毛刺

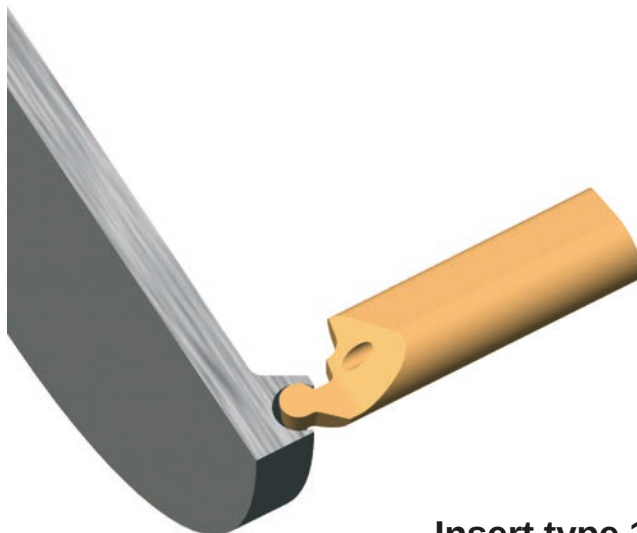


Insert type 105

Deburring cross holes using a rotating insert with a full radius

刀片 型号 105

端面成型槽 (圆头刀片)

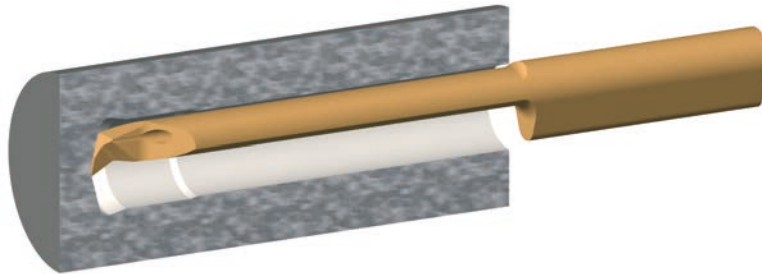


Insert type 105

Profiling a face groove (full radius insert)

刀片 型号 105

加工孔底退刀槽

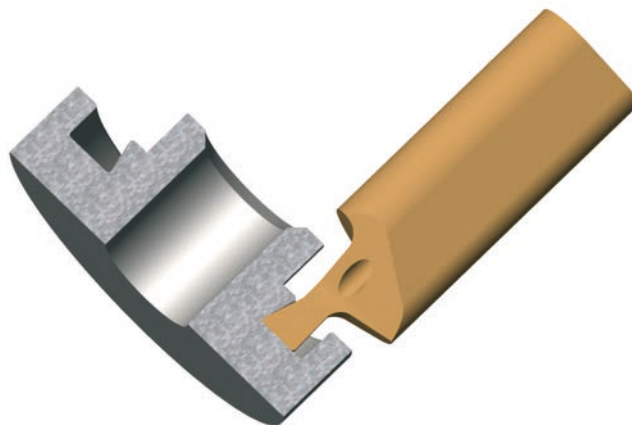


Insert type 105

Machining a flat bottom hole with an undercut

刀片 型号 105

加工端面燕尾槽



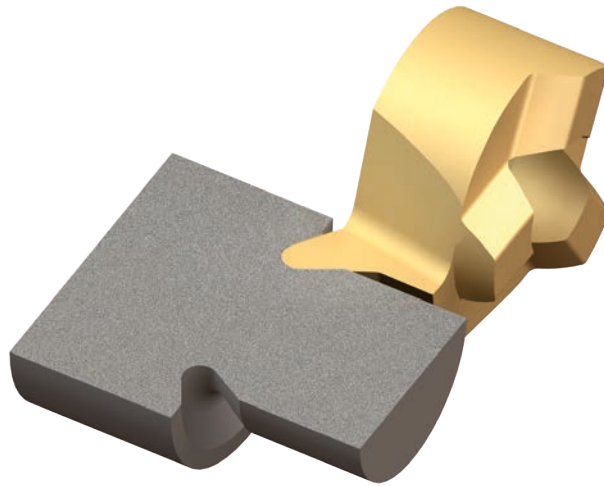
Insert type 105

Machining of a dovetail face groove

C

刀片 型号 108

特殊角度的退刀槽

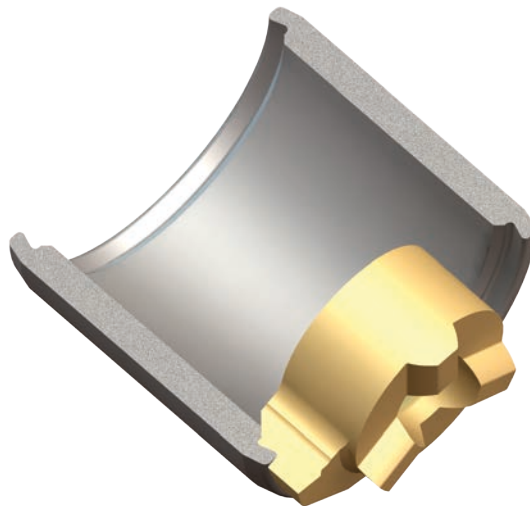


Insert type 108

Special angled under-cut relief

刀片 型号 111

特殊槽轮廓和端面轮廓



Insert type 111

Special ID form groove and facing

刀片 型号 11P

非标多头大升角内螺纹

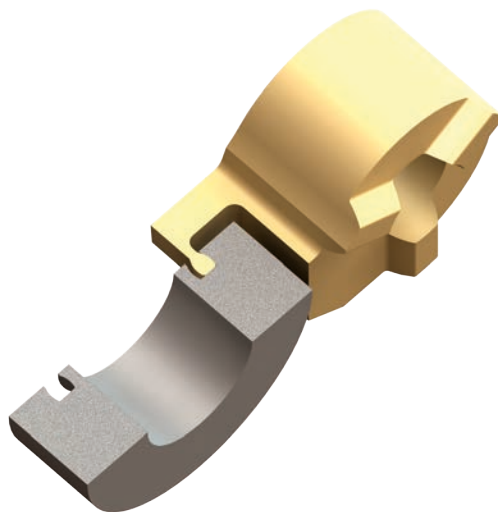


Insert type 11P

Special internal multi-start
high helix thread

刀片 型号 114

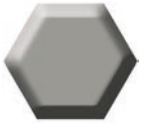
特殊背面槽和O型圈槽轮廓



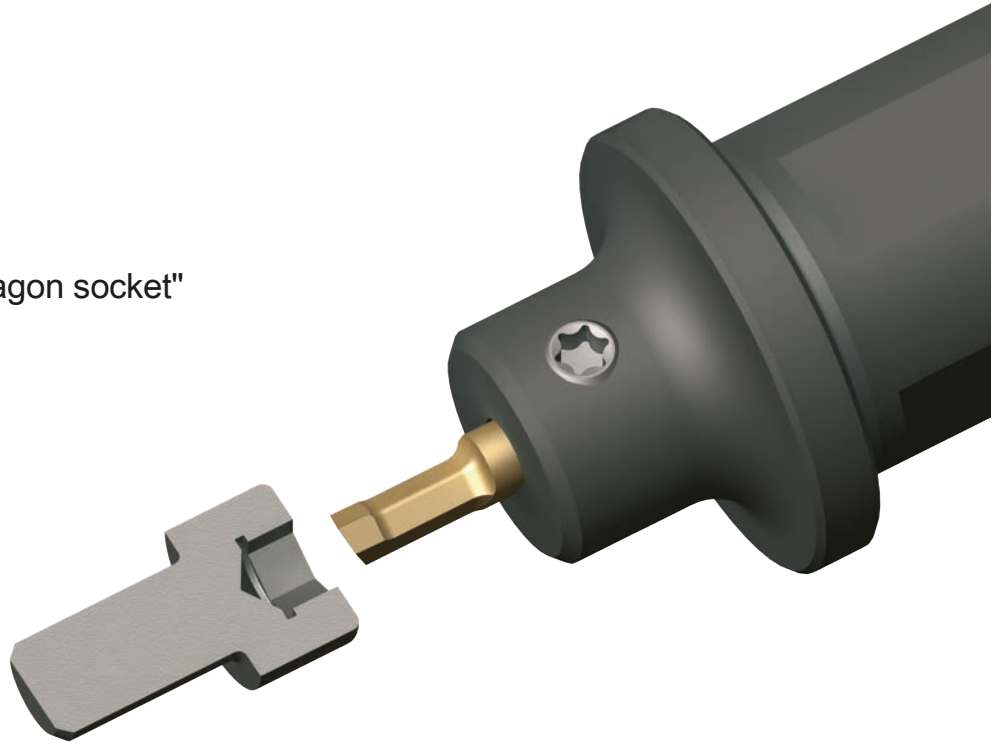
Insert type 114

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

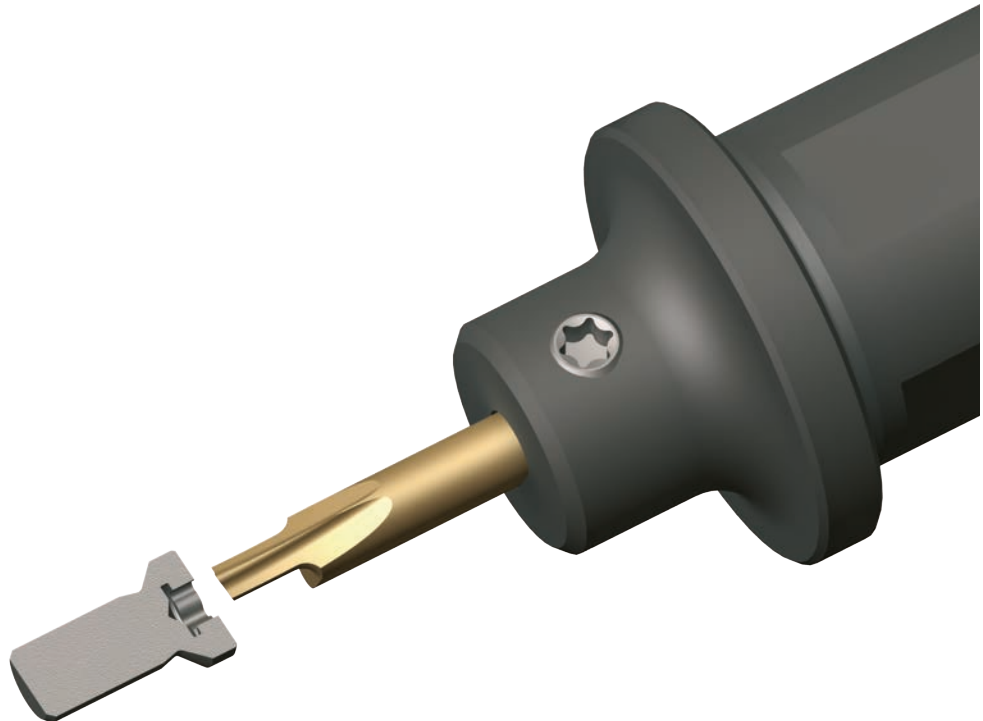
C



插削“内六角”
Broaching "Hexagon socket"



插削 "Torx"
Broaching "Torx"



更多信息见HORN样本“硬质合金槽刀”
For further information please see the HORN catalogue "Grooving"

附加设备 / Index

附加设备
Additional equipment

C16-C19

C



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
2-8 Nm



ED 28 VL

配 / for
D041VL / D15VL / D28VL

扭矩设定器

设定扭矩的设备

柄部：醋酸纤维材质，表面为细微结构

刃部：八角形，硬化处理，镀锌

Device for setting the required torque.

Handle: Celluloseacetat with micro structured surface

Blade: Octogonal (8 flats) blade, hardened galvanized



DT6PK
DT7PK
DT8PK
DT9PK
DT10PK
DT15PK
DT20PK
DT25PK
DT27PK

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.



T6PW
T7PW
T8PW
T9PW
T10PW
T15PW
T20PW

配 / for
D041VL / D15VL / D28VL



Plus

刀头-TORX PLUS®螺钉

用途： 适合所有的TORX PLUS®螺钉. 注意:不能用于Torx螺钉

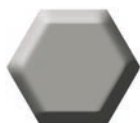
Wrench for TORX PLUS® Screws

Utilization: For all kind of using TORX PLUS® Screws Attention: TORX PLUS®-Wrench does NOT fit for Torx-Screws



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： 使用给定的扭紧扭矩，结合一个Wiha扭矩扳手。

Blade for allen screws

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.
Wiha Chrome Blade guarantees maximum precision.
Colored code red

Utilization: Controlled screw setting with definite torque in combination with Wiha torque screw driver handle



D14ZBK

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

5-15 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

刀头-TORX PLUS® 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.



D14ZBQ

für / 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.

通用T型刀柄的钻套

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



14ZQK

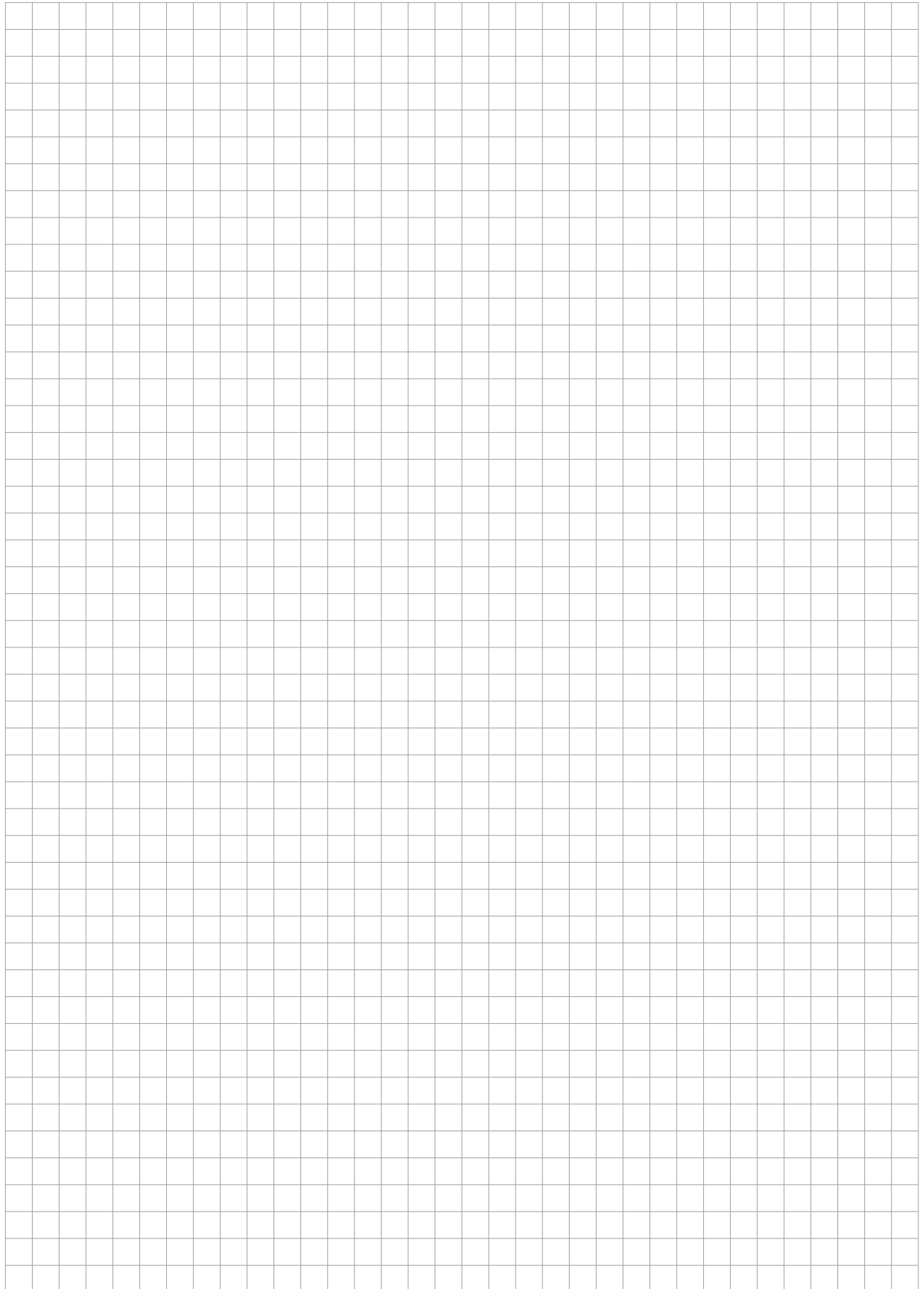
Universal Bitholder with T-handle for C6,3 and E6,3 (1/4") Bits

Blade: High quality Chrome-Vanadium steel, through hardened, chrome plated.

Collar: Stainless steel

Utilization: For controlled opening

C



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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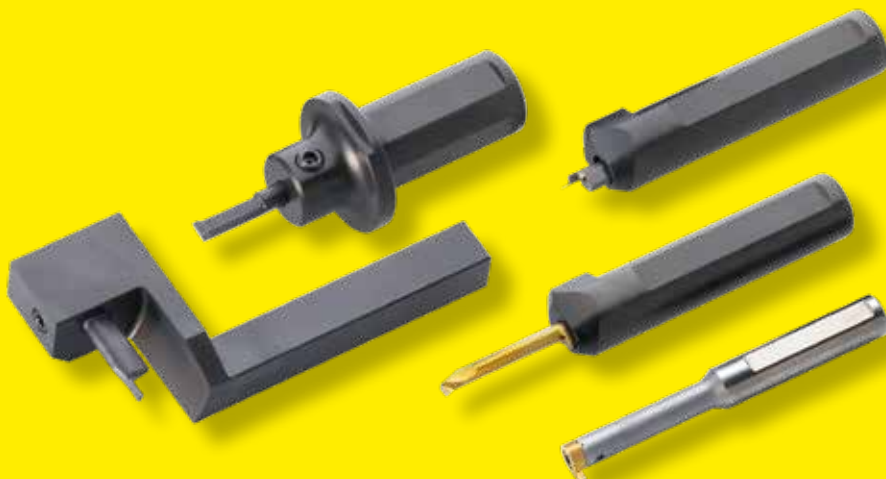
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