



NEW

切槽模块化系列 220

带内冷的基础柄和刀夹

MODULAR GROOVING SYSTEM 220

Basic toolholder and cassettes with internal coolant supply



不同之处： 更多可能

THE DIFFERENCE: MORE POSSIBILITIES

- **„T“型接口的通用基础柄,可配不同的切槽刀夹.**
Universal basic holder with interface „T“ for different grooving cassettes
- **稳定且易重复安装的接口**
Very stable and repeatable interface
- **高效的内冷,为切削刃口提供冷却.**
Highest performance through targeted coolant supply to the cutting edge

概要

Summary



模块化的HORN-PSC基础柄系列 根据标准 ISO 26623, HORN TS 刀柄根据标准 ISO 26622 和 HSK 刀柄, 匹配各种不同的刀夹, 用于切槽, 切断, 和端面槽.

优异的稳定性是通过HORN设计的“T”型接口连接刀夹和基础柄而保证的。刀夹可用于所有标准刀片系统。

Basic toolholder for the modular systems HORN Polygon shank according to ISO 26623, HORN Toolholder TS according to ISO 26622 and HSK with different cassettes are suitable for grooving, parting off and face grooving.

Excellent stability is guaranteed through the HORN designed interface „T“ between the cassette and the basic toolholder. The cassettes are available for all standard insert systems.

模块化刀柄系统 Modular Tooling System

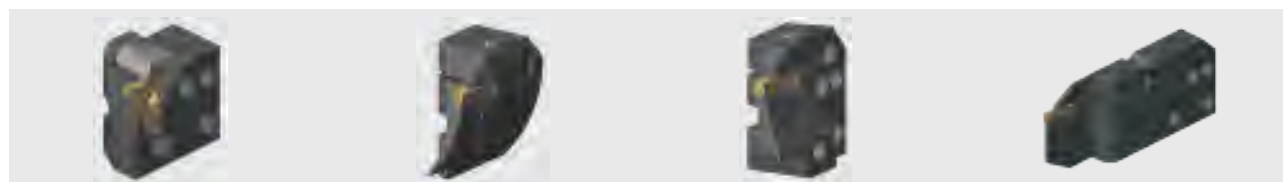
外圆加工 External machining

连接系统 Coupling system	HORN-三棱锥刀杆 HORN Polygon ISO 26623	HORN TS ISO 26623	HSK DIN 69893	方刀杆 Square shank
0° gerade straight				
90° gekröpft cranked				

左右手版本 / Version right and left hand

刀夹系列 Cassette programme

型号 Type	刀片 Insert	R/LNK	R/LIK	R/LAK	刀具长度 Tool length
360	312	•	-	-	
224	S224	•	•	•	
220	S229	•	•	•	
220	S100	•	-	-	
356	315/S315	•	-	-	$l = l_1 + l_K$ (刀夹) (Cassette)
316	S316	•	-	-	
34T	S34T	•	-	-	
64T	S64T	•	-	-	
274	S274	•	-	-	





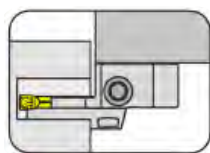
系列/System	页/Page
基础柄 Basic Toolholder	97
外圆加工 Radial Machining	114
端面加工 Axial Machining	126

切槽，切断，端面切槽

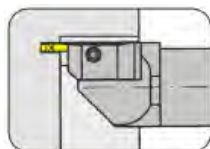
Grooving, Parting off and Face Grooving



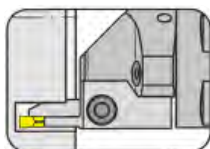
常规刀柄
Basic toolholder
220/B224/220C/
C6/220TS/HSK220/
HSKT63



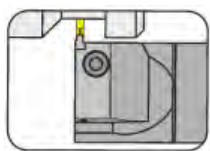
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技术信息
Technical Information

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基础柄

外圆端面加工

Basic toolholder for cassettes

for radial and axial machining

带T形接口的基础柄

Basic holder with interface „T“



HSKT

TS

Polygon

刀柄
Toolholder

带T形接口的刀夹

Cassettes with interface „T“

外圆槽
Grooving radial

刀片
Insert

端面槽
Grooving axial

刀片
Insert



S100



**S15A
S25A**



**S224
S229**



**S224
S229**



S274



S34T

带T形接口的基础柄

Basic holder with interface „T“



HSKT

TS

Polygon

刀柄
Toolholder

带T形接口的刀夹

Cassettes with interface „T“

外圆槽
Grooving radial

刀片
Insert



312



315
S315



64T

端面切槽 Face Grooving

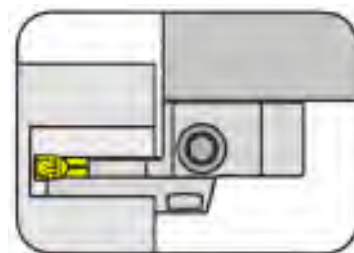


常规刀柄 Basic toolholder

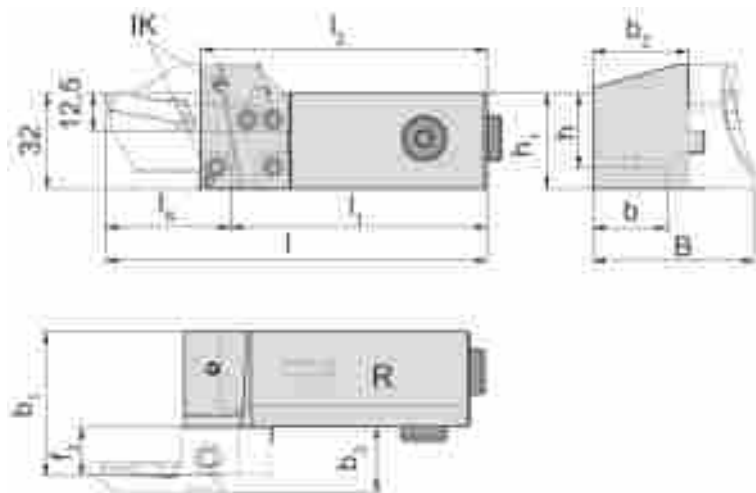
220

无刀夹
without cassette

配合VDI接纳器,提供内冷
suitable for HORN adaptors VDI with integrated through coolant supply



刀杆平行于工件轴线
Shank parallel to the axis of workpiece



配带T形接口的刀夹
for Cassettes with interface „T“

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

带集成内冷
with integrated through
coolant supply

产品型号 Part number	h	h ₁	l ₁	b	b ₁	b ₂	l ₂	l	B
R/L220.2020.2.K1.IK	20	32	l ₂ -10	20	b ₂ +f ₃	27	84	l ₁ +l _K	b ₂ +b ₃
R/L220.2525.2.K1.IK	25	32	l ₂ -10	25	b ₂ +f ₃	32	96	l ₁ +l _K	b ₂ +b ₃

注明R或L型
State R or L version

IK, b₃和 f₃见刀夹
l_K, b₃ and f₃ see cassettes

尺寸单位: mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

右手型刀杆配合右手型刀夹, 左手型刀杆配合左手型刀夹。

Use right hand basic toolholder for right hand cassettes and left hand basic toolholder for left hand cassettes.

配件 Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	密封塞 Sealing plug	销 Threaded Pin	O型圈 O-ring	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	004.00.26	030.0508.0866	12.37.2.62.3601	T20PQ

端面切槽 Face Grooving



常规刀柄 Basic toolholder

220

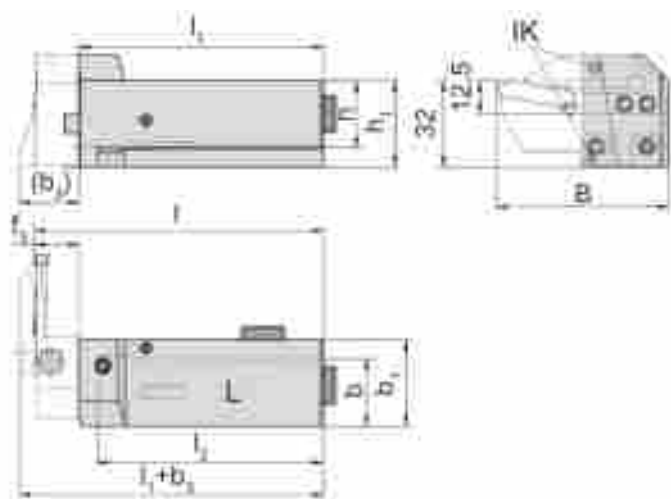
无刀夹
without cassette

配合VDI接纳器,提供内冷
suitable for HORN adaptors VDI with integrated through coolant supply



刀杆90°于工件轴线
Shank 90° to the axis of workpiece

配带T形接口的刀夹
for Cassettes with interface „T“



L=左手型-如图
L = left hand version shown

R=右手型
R = right hand version

带集成内冷
with integrated through
coolant supply

产品型号 Part number	h	h ₁	b	l ₂	l	B	b ₁	l ₁
R/L220.2020.2.K2.IK	20	32	20	69	l ₁ +f ₃	l _k +19	29	79
R/L220.2525.2.K2.IK	25	32	25	84	l ₁ +f ₃	l _k +19	32	91

注明R或L型
State R or L version

IK, b₃和 f₃见刀夹
l_k, b₃ and f₃ see cassettes

尺寸单位: mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

右手型刀杆配合左手型刀夹, 左手型刀杆配合右手型刀夹。

Use right hand basic toolholder for left hand cassettes and left hand basic toolholder for right hand cassettes.

配件 Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	密封塞 Sealing plug	销 Threaded Pin	O型圈 O-ring	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	004.00.26	030.0508.0866	12.37.2.62.3601	T20PQ

端面切槽 Face Grooving



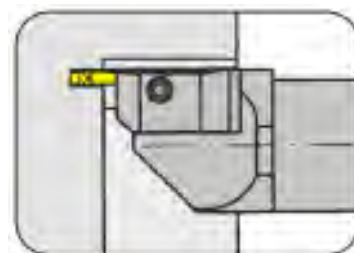
常规刀柄 Basic toolholder

B224

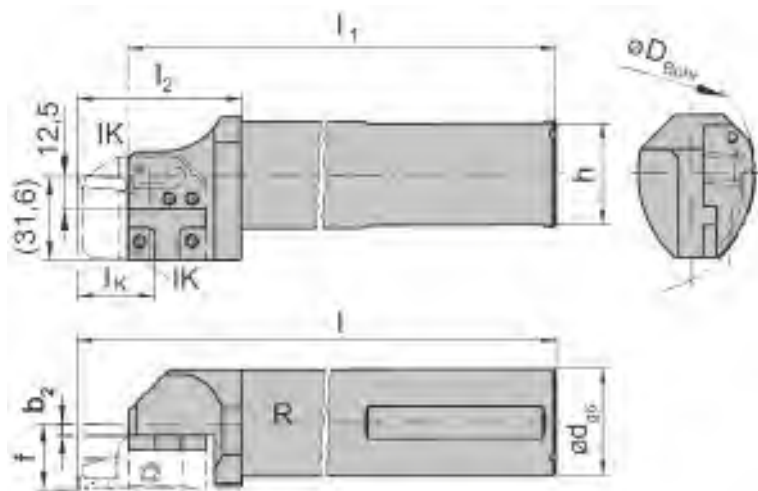
无刀夹
without cassette

配合RIK/LIK224型刀夹的常规刀柄
Basic toolholder for cassettes type RIK/LIK224

直接冷却液供应
with through coolant supply



配带T形接口的刀夹
for Cassettes with interface „T“



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	f	d	l ₁	h	l ₂	b ₂	l	D _{Bohr}
R/LB224.0032.K1.IK	b ₂ +f ₃	32	181	30	59	0.41	200	90
R/LB224.0040.K1.IK	b ₂ +f ₃	40	231	38	59	4.41	250	90

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

D_{a min} / f₃ / l_k 见刀夹
D_{a min} / f₃ / l_k see cassettes

尺寸单位：mm
Dimensions in mm

配件 Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	TORX PLUS®扳手 TORX PLUS® Wrench
R/LB224...	5.12T20P	030.0508.0866	SW2,0 DIN911	T20PQ
R/LB224.0032.K1.IK	5.12T20P	030.0508.0866	SW2,5 DIN911	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

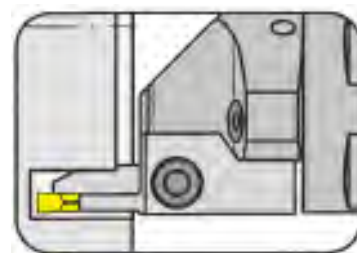


常规刀柄

Basic toolholder

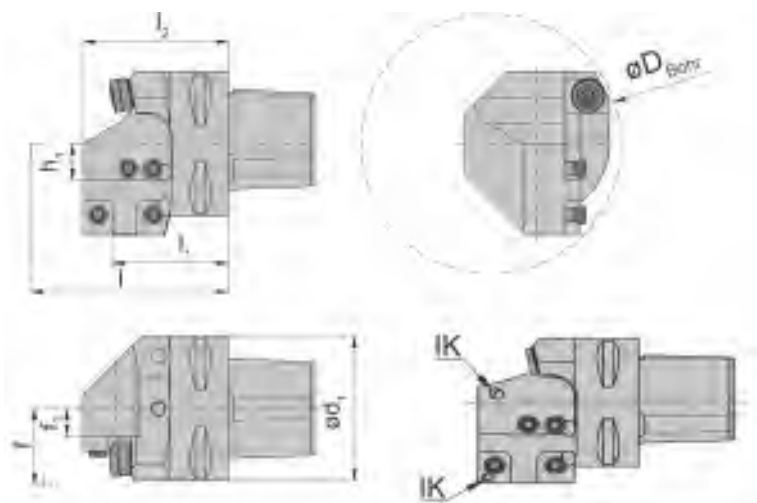
220C

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes type RIK/LIK224

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.00C3.K1.IK	36	$l_1 + l_K$	46	32	12.5	4.6	$f_1 + f_3$
R/L220.00C4.K1.IK	40	$l_1 + l_K$	50	40	12.5	4.6	$f_1 + f_3$
R/L220.00C5.K1.IK	40	$l_1 + l_K$	50	50	12.5	9.6	$f_1 + f_3$
R/L220.00C6.K1.IK	42	$l_1 + l_K$	52	63	12.5	16.1	$f_1 + f_3$
R/L220.00C8.K1.IK	53	$l_1 + l_K$	63	80	12.5	24.6	$f_1 + f_3$

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 D_{Bohr} , f_3 和 l_K 见刀夹
Dimensions for D_{Bohr} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

注意事项：
R/L220...IK 可选择的内冷喷嘴
Note:
R/L220...IK Coolant spray nozzle optional

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	004.00.21	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

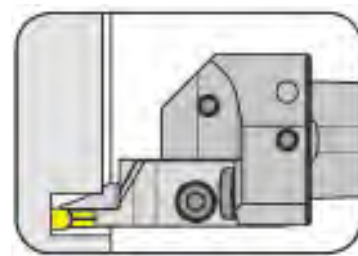


常规刀柄

Basic toolholder

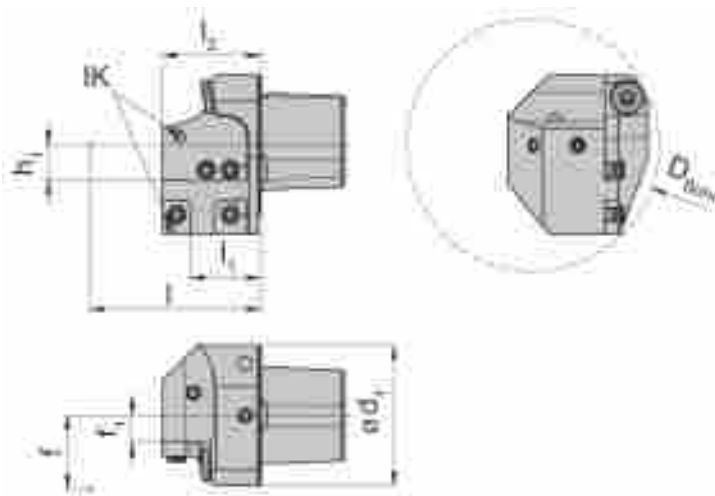
220C

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应 - 不用替换槽刀具
with internal coolant supply - without tool changing groove



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.00C4.K10.IK	25	l_1+l_k	35	40	12.5	4.6	f_1+f_3
R/L220.00C5.K10.IK	25	l_1+l_k	35	50	12.5	9.6	f_1+f_3

注明R或L型
State R or L version

尺寸 D_{Bohr} , f_3 and l_k 见刀夹
Dimensions for D_{Bohr} , f_3 and l_k see cassettes

尺寸单位: mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

R/L220...IK 可选择的内冷喷嘴
R/L220...IK Coolant spray nozzle optional

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	004.00.21	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

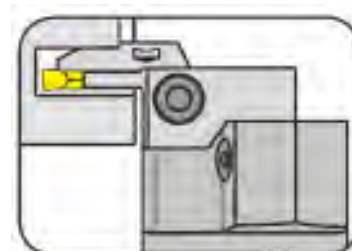


常规刀柄

Basic toolholder

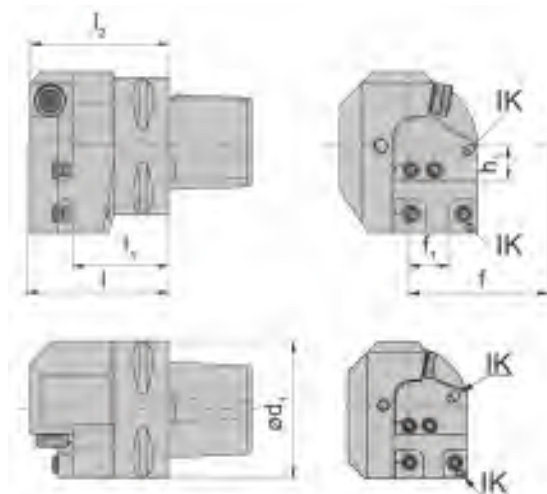
220C

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.00C3.K2.IK	31.2	l_1+f_3	46.5	32	12.5	10.0	f_1+l_K
R/L220.00C4.K2.IK	35.2	l_1+f_3	50.5	40	12.5	10.0	f_1+l_K
R/L220.00C5.K2.IK	35.2	l_1+f_3	50.5	50	12.5	15.0	f_1+l_K
R/L220.00C6.K2.IK	37.2	l_1+f_3	52.5	63	12.5	21.5	f_1+l_K
R/L220.00C8.K2.IK	48.2	l_1+f_3	63.5	80	12.5	30.0	f_1+l_K

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： D_{min} , f_3 and l_K 见刀夹
Dimensions for D_{min} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

注意事项：
R/L220...IK 可选择的内冷喷嘴
Note:
R/L220...IK Coolant spray nozzle optional

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	004.00.21	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

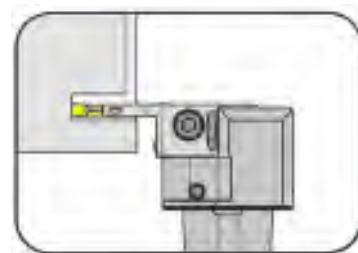


常规刀柄

Basic toolholder

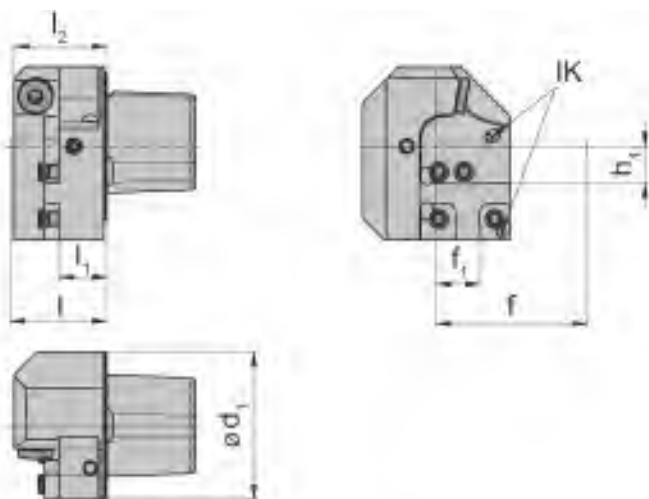
220C

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应 - 不用替换槽刀具
with internal coolant supply - without tool changing groove



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.00C4.K20.IK	16.2	l_1+f_3	31.5	40	12.5	10	f_1+l_K
R/L220.00C5.K20.IK	16.2	l_1+f_3	31.5	50	12.5	15	f_1+l_K

注明R或L型
State R or L version
按需提供更多尺寸
Further sizes upon request
R/L220...IK 可选择的内冷喷嘴
R/L220...IK Coolant spray nozzle optional

尺寸： D_{min} , f_3 and l_K 见刀夹
Dimensions for D_{min} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	004.00.21	T20PQ

切槽，切断，端面切槽

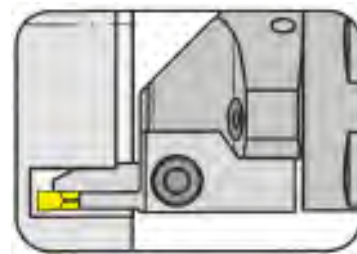
Grooving, Parting off and Face Grooving



常规刀柄

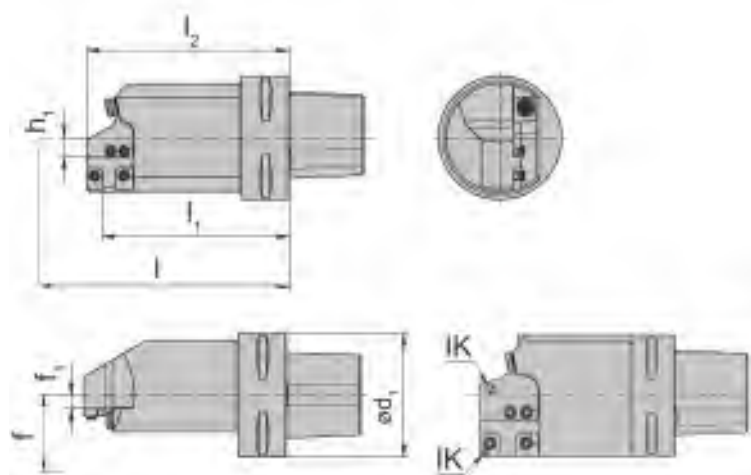
Basic toolholder

C6
无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes wit interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
C6.L220.120.K1.IK	91	l_1+l_k	101	63	12.5	0.6	f_1+f_3
C6.L220.150.K1.IK	121	l_1+l_k	131	63	12.5	0.6	f_1+f_3
C6.R220.120.K1.IK	91	l_1+l_k	101	63	12.5	0.6	f_1+f_3
C6.R220.150.K1.IK	121	l_1+l_k	131	63	12.5	0.6	f_1+f_3

注明R或L型
State R or L version

尺寸： f_3 和IK见刀夹
Dimensions for f_3 and IK see cassettes

尺寸单位：mm
Dimensions in mm

按需提供更多尺寸
Further sizes upon request

注意事项：
C6.R/L220...IK 可选择的内冷喷嘴

Note:
C6.R/L220...IK Coolant spray nozzle optional

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	螺钉 Screw	TORX PLUS®扳手 TORX PLUS® Wrench
C6...	5.12T20P	030.0508.0866	SW2,5 DIN911	004.00.21	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

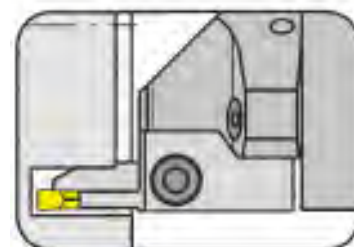


常规刀柄

Basic toolholder

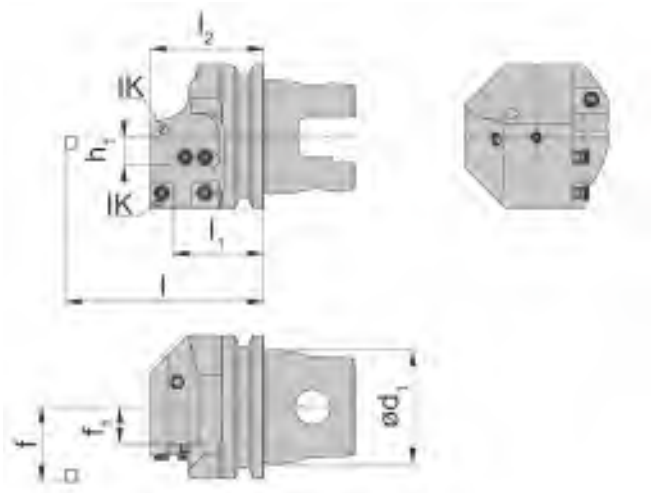
220TS

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.TS40.K1.IK	40	$l_1 + l_K$	50	40	12.5	4.6	$f_1 + f_3$
R/L220.TS50.K1.IK	40	$l_1 + l_K$	50	50	12.5	9.6	$f_1 + f_3$
R/L220.TS63.K1.IK	40	$l_1 + l_K$	50	63	12.5	16.1	$f_1 + f_3$

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 D_{Bohr} , f_3 和 l_K 见刀夹
Dimensions for D_{Bohr} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Allen Wrench
R/L220.TS40.K1.IK	5.12T20P		020.1008.2977	T20PQ	
R/L220.TS50.K1.IK	5.12T20P	030.0508.0866	020.1008.2977	T20PQ	
R/L220.TS63.K1.IK	5.12T20P	030.0508.0866	020.1008.2977	T20PQ	SW2,5 DIN911

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

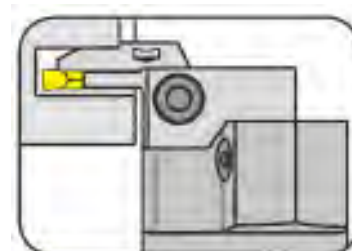


常规刀柄

Basic toolholder

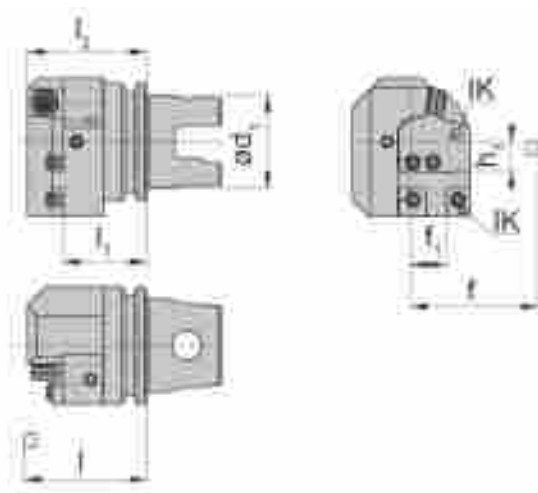
220TS

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	l	l_2	d_1	h_1	f_1	f
R/L220.TS40.K2.IK	35.2	l_1+f_3	50.5	40	12.5	10.0	f_1+l_K
R/L220.TS50.K2.IK	35.2	l_1+f_3	50.5	50	12.5	15.0	f_1+l_K
L220.TS63.K2.IK	35.2	l_1+f_3	50.5	63	12.5	21.5	f_1+l_K

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 D_{Bohr} , f_3 和 l_K 见刀夹
Dimensions for D_{Bohr} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench	扳手 Allen Wrench
R/L220.T...	5.12T20P	030.0508.0866	020.1008.2977	T20PQ	
L220.TS63.K2.IK	5.12T20P	030.0508.0866	020.1008.2977	T20PQ	SW2,5 DIN911

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

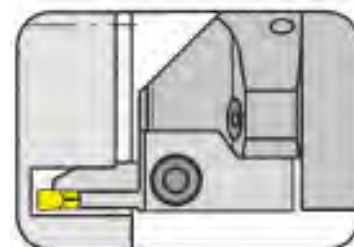


常规刀柄

Basic toolholder

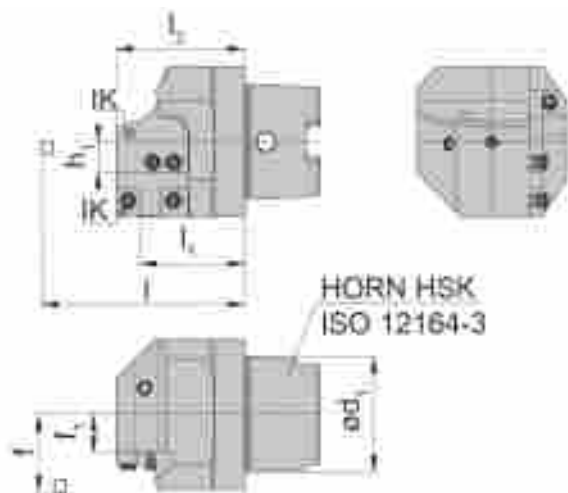
HSK220

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

用于手动换刀，直接冷却液供应
for manual tool change, with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	d_1	f_1	l	l_2	f	h_1
HSK-L220.0063.K1.IK	44	63	16.1	l_1+l_K	54	f_1+f_3	12.5
HSK-R220.0063.K1.IK	44	63	16.1	l_1+l_K	54	f_1+f_3	12.5

注明R或L型
State R or L version

尺寸： D_{min} , f_3 and l_K 见刀夹
Dimensions for D_{min} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

具体尺寸及版本(如:HSK-B50等)根据要求
Further sizes and versions (e.g. HSK-B50 etc.) upon request

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench
HSK-R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	020.1008.2977	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

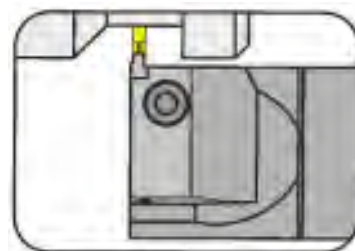


常规刀柄

Basic toolholder

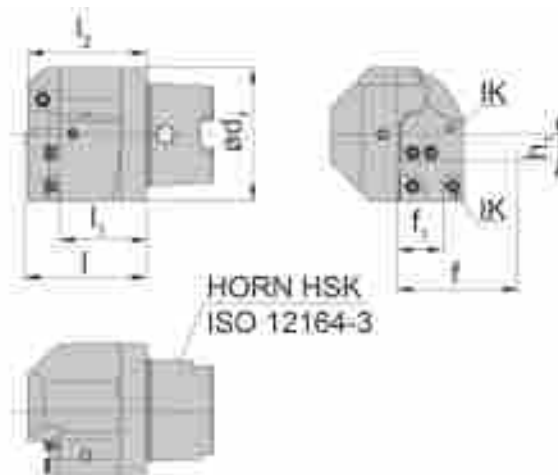
HSK220

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

用于手动换刀，直接冷却液供应
for manual tool change, with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	l_1	d_1	f_1	l	l_2	f	h_1
HSK-L220.0063.K2.IK	41.2	63	21.5	l_1+f_3	56.5	f_1+l_K	12.5
HSK-R220.0063.K2.IK	41.2	63	21.5	l_1+f_3	56.5	f_1+l_K	12.5

注明R或L型
State R or L version

尺寸： D_{min} , f_3 and l_K 见刀夹
Dimensions for D_{min} , f_3 and l_K see cassettes

尺寸单位：mm
Dimensions in mm

具体尺寸及版本(如:HSK-B50等)根据要求
Further sizes and versions (e.g. HSK-B50 etc.) upon request

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench
HSK-R/L220...	5.12T20P	030.0508.0866	SW2,5 DIN911	020.1008.2977	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

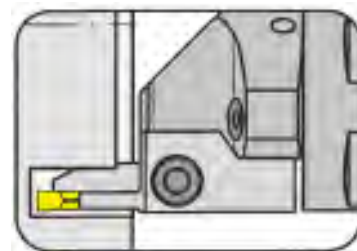


常规刀柄

Basic toolholder

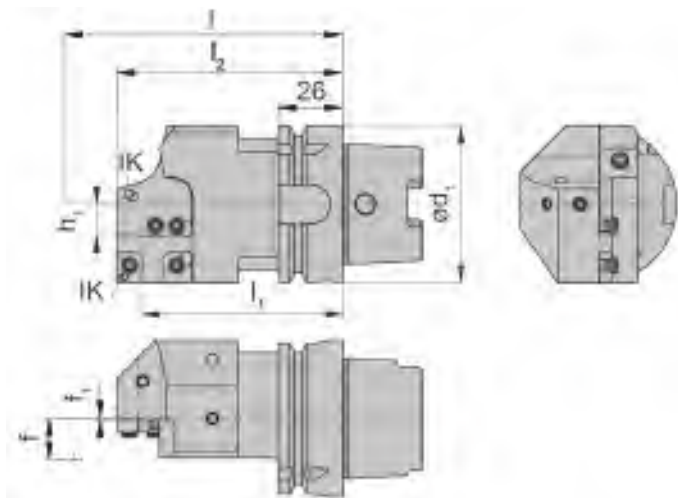
HSKT63

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

220系列刀座
Pocket seat system 220

产品型号 Part number	l_1	d	f_1	l	l_2	f	h_1
HSKT63.L220.110.K1.IK	81	63	0.6	l_1+l_k	91	f_1+f_3	12.5
HSKT63.L220.120.K1.IK	91	63	0.6	l_1+l_k	101	f_1+f_3	12.5
HSKT63.L220.130.K1.IK	101	63	0.6	l_1+l_k	111	f_1+f_3	12.5
HSKT63.L220.150.K1.IK	121	63	0.6	l_1+l_k	131	f_1+f_3	12.5
HSKT63.L220.175.K1.IK	146	63	0.6	l_1+l_k	156	f_1+f_3	12.5
HSKT63.R220.110.K1.IK	81	63	0.6	l_1+l_k	91	f_1+f_3	12.5
HSKT63.R220.120.K1.IK	91	63	0.6	l_1+l_k	101	f_1+f_3	12.5
HSKT63.R220.130.K1.IK	101	63	0.6	l_1+l_k	111	f_1+f_3	12.5
HSKT63.R220.150.K1.IK	121	63	0.6	l_1+l_k	131	f_1+f_3	12.5
HSKT63.R220.175.K1.IK	146	63	0.6	l_1+l_k	156	f_1+f_3	12.5

按需提供更多尺寸
Further sizes upon request

l_k 和 f_3 见刀夹
 l_k and f_3 see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench
HSKT63...	5.12T20P	030.0508.0866	SW2,5 DIN911	020.1008.2977	T20PQ

切槽，切断，端面切槽

Grooving, Parting off and Face Grooving

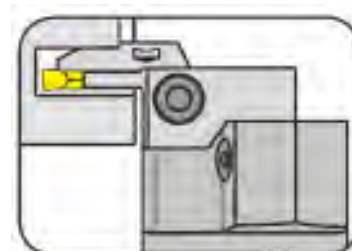


常规刀柄

Basic toolholder

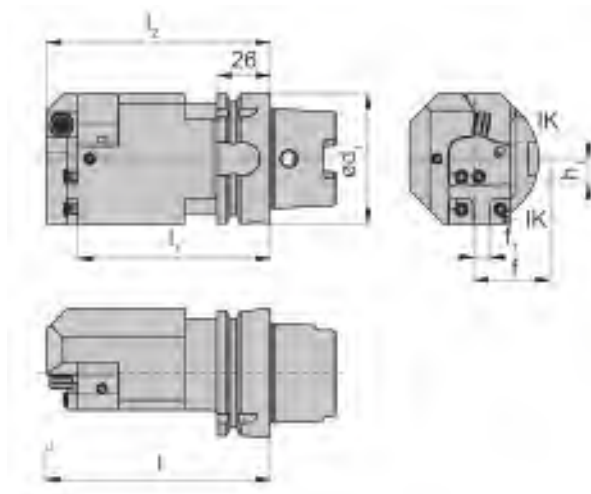
HSKT63

无刀夹
without cassette



基础柄配带T形接口的刀夹
Basic toolholder for cassettes with interface „T“

直接冷却液供应
with through coolant supply



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

220系列刀座
Pocket seat system 220

产品型号 Part number	l_1	d	f_1	l	l_2	f	h_1
HSKT63.L220.110.K2.IK	93.6	63	8.0	l_1+l_k	108.8	f_1+l_k	12.5
HSKT63.L220.130.K2.IK	101.0	63	0.6	l_1+l_k	111.0	f_1+f_3	12.5
HSKT63.L220.150.K2.IK	133.6	63	8.0	l_1+l_k	148.8	f_1+l_k	12.5
HSKT63.L220.175.K2.IK	158.6	63	8.0	l_1+l_k	173.8	f_1+l_k	12.5
HSKT63.R220.110.K2.IK	93.6	63	8.0	l_1+l_k	108.8	f_1+l_k	12.5
HSKT63.R220.130.K2.IK	113.6	63	8.0	l_1+l_k	128.8	f_1+l_k	12.5
HSKT63.R220.150.K2.IK	133.6	63	8.0	l_1+l_k	148.8	f_1+l_k	12.5
HSKT63.R220.175.K2.IK	158.6	63	8.0	l_1+l_k	173.8	f_1+l_k	12.5

按需提供更多尺寸
Further sizes upon request

l_k 见刀夹
 l_k see cassettes

尺寸单位：mm
Dimensions in mm

配件

Spare Parts

常规刀柄 Basic toolholder	锁紧螺钉 Clamping Screw	销 Threaded Pin	扳手 Allen Wrench	冷却液喷嘴 Coolant spray nozzle	TORX PLUS®扳手 TORX PLUS® Wrench
HSKT63...	5.12T20P	030.0508.0866	SW2,5 DIN911	020.1008.2977	T20PQ

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK100/NK224/

NK220/NK274/

NK34T/NK360/

NK368/NK356/

NK316/NK64T



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技术信息

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切槽 (外圆)
Grooving (external)



刀夹
外圆槽

带内冷却水孔

Cassettes for
radial machining

with through coolant supply

切槽 (外圆)

Grooving (external)



刀夹

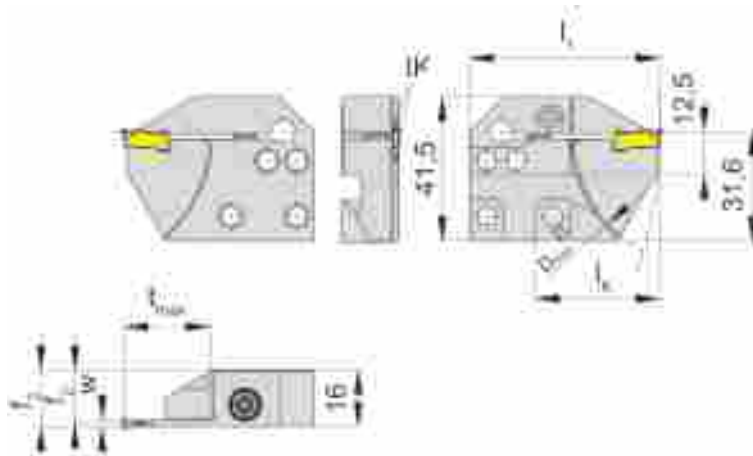
Cassette

NK100

直接冷却液供应
with through coolant supply



槽深可达	Depth of groove up to	25 mm
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配合刀片
for Insert

型号 S100
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t_{max}	f_2	f_3	w	D_{max}	l_1	l_k
R/LNK100.3215.4.21.IK	25	15.40	$f_2+w/2$	2.0	80	55	36
R/LNK100.3215.4.22.IK	25	15.15	$f_2+w/2$	2.5	80	55	36
R/LNK100.3215.4.23.IK	25	14.90	$f_2+w/2$	3.0	80	55	36
R/LNK100.3215.4.24.IK	25	14.40	$f_2+w/2$	4.0	80	55	36

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	销 Threaded Pin
R/LNK100.3215.4...	6.23T25P	T25PQ	
R/LNK100.3215.4.24.IK	6.23T25P	T25PQ	2.025.913

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK224

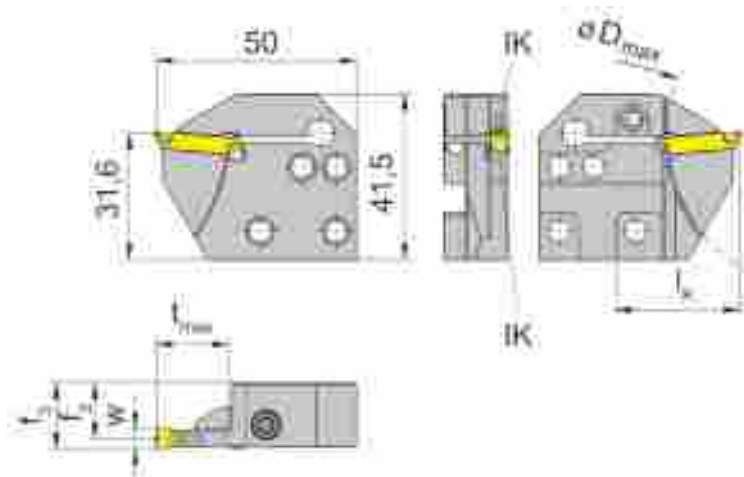
直接冷却液供应
with through coolant supply



槽深可达
夹持范围

Depth of groove up to
Clamping range

18 mm
2,8-6 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t_{max}	f_2	f_3	D_{max}	l_k	夹持范围 Clamping range
R/LNK224.3215.2.01.IK	18	15.40	$f_2 + w/2$	80	31	2.0-2.4
R/LNK224.3215.2.02.IK	18	15.15	$f_2 + w/2$	80	31	2.4-2.8
R/LNK224.3215.4.03.IK	18	14.90	$f_2 + w/2$	80	31	2.8-3.7
R/LNK224.3215.4.04.IK	18	14.40	$f_2 + w/2$	80	31	3.7-4.4
R/LNK224.3215.4.05.IK	18	13.90	$f_2 + w/2$	80	31	4.4-5.1
R/LNK224.3215.4.06.IK	18	13.40	$f_2 + w/2$	80	31	5.1-6.1

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

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

- .2. = 通过刀片提供
- .4. = 通过刀夹和刀片提供

Coolant outlet:

- .2. = Through insert support
- .4. = Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	销 Threaded Pin
R/LNK224.3215...	5.13T20P	T20PQ	
R/LNK224.3215.4....	5.13T20P	T20PQ	2.025.913

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK220

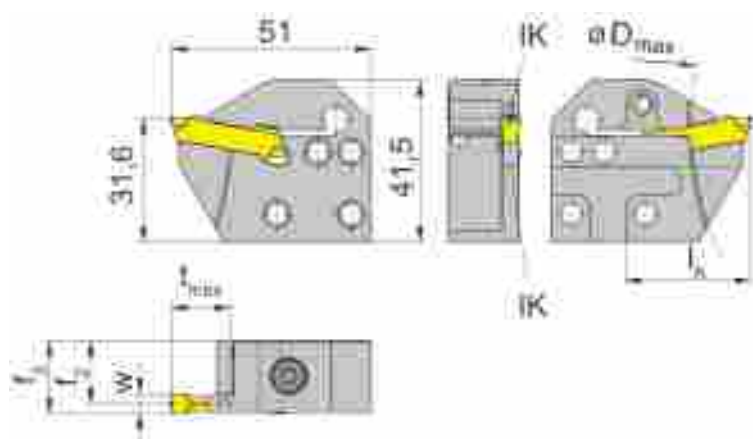
直接冷却液供应
with through coolant supply



槽深可达
夹持范围

Depth of groove up to
Clamping range

25 mm
3-6,9 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	f ₂	f ₃	D _{max}	l _k	夹持范围 Clamping range
R/LNK220.3218.4.13.IK	15	17.1	f ₂ +w/2	180	32	3.00-3.80
R/LNK220.3218.4.14.IK	15	16.6	f ₂ +w/2	180	32	3.80-4.40
R/LNK220.3218.4.15.IK	15	16.1	f ₂ +w/2	180	32	4.40-5.09
R/LNK220.3218.4.16.IK	15	15.6	f ₂ +w/2	180	32	5.10-6.09
R/LNK220.3215.4.03.IK	25	14.9	f ₂ +w/2	-	38	3.00-3.80
R/LNK220.3215.4.04.IK	25	14.4	f ₂ +w/2	-	38	3.80-4.40
R/LNK220.3215.4.05.IK	25	13.9	f ₂ +w/2	-	38	4.40-5.09
R/LNK220.3215.4.06.IK	25	13.4	f ₂ +w/2	-	38	5.10-6.09

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

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK220.32...	6.23T25P	T25PQ

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK274

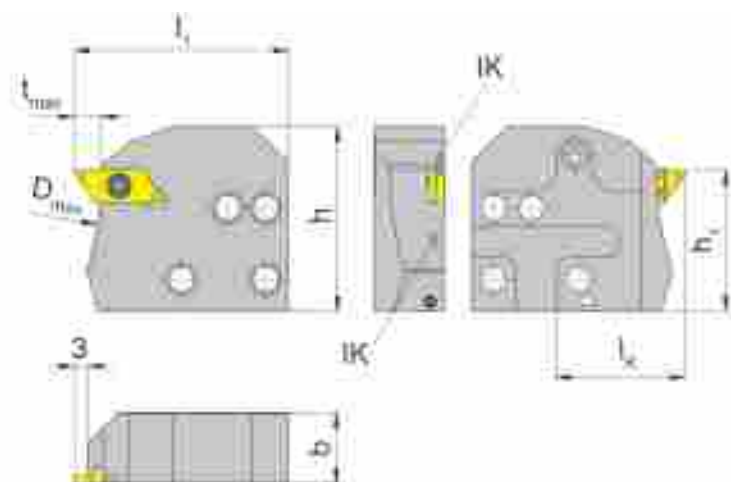
直接冷却液供应
with through coolant supply



槽深可达
夹持范围

Depth of groove up to
Clamping range

6 mm
4 mm



配合可转位刀片
for Indexable insert

型号 S274
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t_{max}	b	f_2	D_{max}	l_1	h	h_1	l_k	夹持范围 Clamping range
R/LNK274.0220.4.04.IK	6	15.8	16	150	48	41.4	31.65	29	4

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	销 Threaded Pin	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK274.0220.4.04.IK	3.03.913	030.3509.T15P	T15PQ

切槽 (外圆)

Grooving (external)



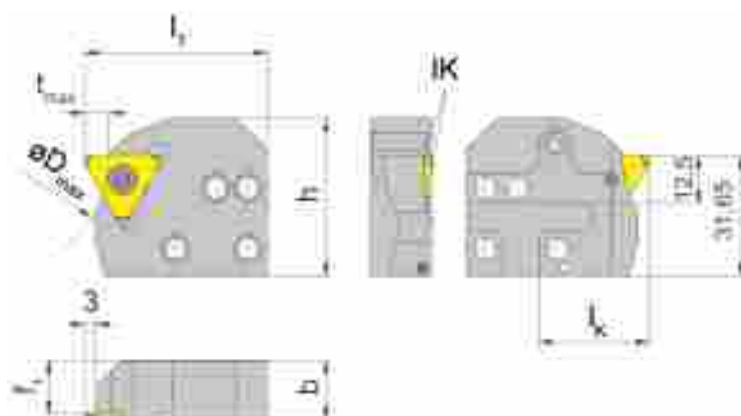
刀夹
Cassette

NK34T

直接冷却液供应
with through coolant supply



槽深可达 Depth of groove up to 6.5 mm



配合可转位刀片
for Indexable insert

型号 S34T
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	b	f	f ₁	D _{max}	l ₁	h	l _k	尺寸规格 Size	夹持范围 Clamping range
R/LNK34T.0220.4.00.IK	6.5	15.8	f ₁ +w+a ₁	15.0	60	48	41.4	29	01	1.03-1.03
R/LNK34T.0220.4.10.IK	6.5	15.8	f ₁ +w+a ₁	14.3	60	48	41.4	29	01	2.00-2.00
R/LNK34T.0220.4.20.IK	6.5	15.8	f ₁ +w+a ₁	13.3	60	48	41.4	29	02	2.01-3.00
R/LNK34T.0220.4.30.IK	6.5	15.8	f ₁ +w+a ₁	12.3	60	48	41.4	29	03	3.01-4.00

注明R或L型
State R or L version

w, a₁见刀片
w, a₁ see indexable inserts

尺寸单位: mm
Dimensions in mm

订货须知:

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	销 Threaded Pin	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK34T.0220.4...	3.03.913	030.4093.T15P	T15PQ
R/LNK34T.0220.4.20.IK	3.03.913	030.4010.T15P	T15PQ
R/LNK34T.0220.4.30.IK		030.5012.T15P	T15PQ

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK360

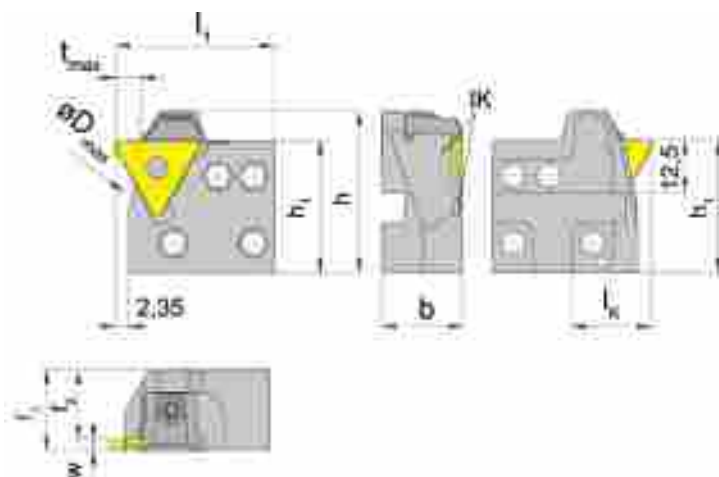
直接冷却液供应
with through coolant supply



槽深可达
夹持范围

Depth of groove up to
Clamping range

6 mm
0,5-6,3 mm



配合可转位刀片
for Indexable insert

型号 312
Type S312

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	b	f ₂	f ₃	D _{max}	l ₁	h	h ₁	l _K	尺寸规格 Size	夹持范围 Clamping range
R/LNK360.0220.5.01.IK	4	19.2	17.7	f ₂ +w-a ₁	40	38	38.65	31.65	19	01	0.5-1.9
R/LNK360.0220.5.02.IK	6	19.2	16.7	f ₂ +w-a ₁	40	38	38.65	31.65	19	02	1.9-2.9
R/LNK360.0220.5.03.IK	6	19.2	15.7	f ₂ +w-a ₁	40	38	38.65	31.65	19	03	2.9-3.9
R/LNK360.0220.5.04.IK	6	19.2	14.0	f ₂ +w-a ₁	40	38	38.65	31.65	19	04	3.9-6.3

注明R或L型
State R or L version

w, a₁见刀片
w, a₁ see indexable inserts

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK360...	14.4	T15PQ

切槽 (外圆)

Grooving (external)



刀夹

Cassette

NK368

直接冷却液供应
with through coolant supply



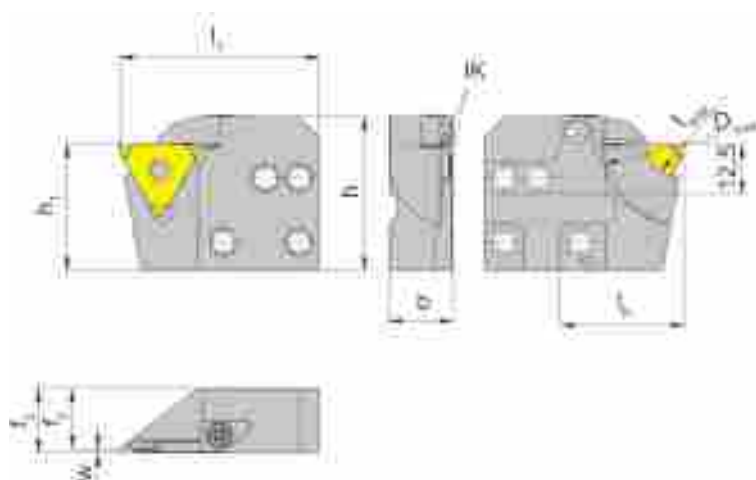
槽深可达
夹持范围

Depth of groove up to
Clamping range

8 mm
0,5-1,5 mm

配合可转位刀片
for Indexable insert

型号 312
S312



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t_{max}	b	f_2	f_3	D_{max}	h	h_1	l_k	尺寸规格 Size	夹持范围 Clamping range
R/LNK368.0220.4.01.IK	8	16	15.0	f_2+w-a_1	40	38.5	31.65	31	01	0.5-1.2
R/LNK368.0220.4.02.IK	8	16	14.7	f_2+w-a_1	40	38.5	31.65	31	02	1.2-1.5

注明R或L型
State R or L version

w, a_1 见刀片
 w, a_1 see indexable inserts

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	压板 Clamping element	TORX PLUS®扳手 TORX PLUS® Wrench
LNK368.0220.4....	010.0004.0586	T10PL
RNK368.0220.4....	010.0004.0620	T10PL

切槽 (外圆)

Grooving (external)



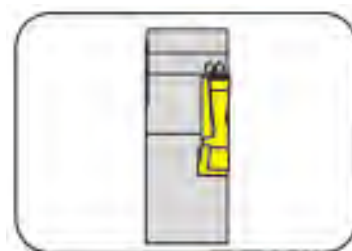
刀夹

Cassette

NK356

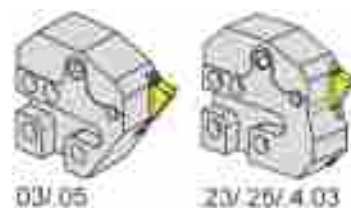
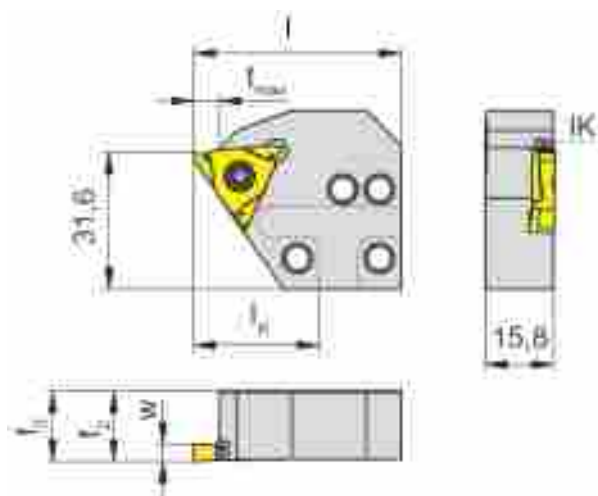
直接冷却液供应
with through coolant supply

槽深可达 Depth of groove up to 6 mm



配合可转位刀片
for Indexable insert

型号 315
Type S315



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	f ₂	f ₃	D _{max}	l	l _k	尺寸规格 Size
R/LNK356.0220.03.IK	5	16.1	f ₃ =f ₂	-	48	29	03
R/LNK356.0220.05.IK	5	16.3	f ₃ =f ₂	-	48	29	05
R/LNK356.0220.4.23.IK	5	16.3	f ₃ =f ₂	150	48	29	03
R/LNK356.0220.4.25.IK	5	16.3	f ₃ =f ₂	150	48	29	05
R/LNK356.0220.S.4.03.IK	6	16.1	f ₃ =f ₂	150	48	29	03

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench	销 Threaded Pin
R/LNK356.0220....	5.12T20P	T20PQ	
R/LNK356...	5.12T20P	T20PQ	3.03.913

切槽 (外圆)

Grooving (external)



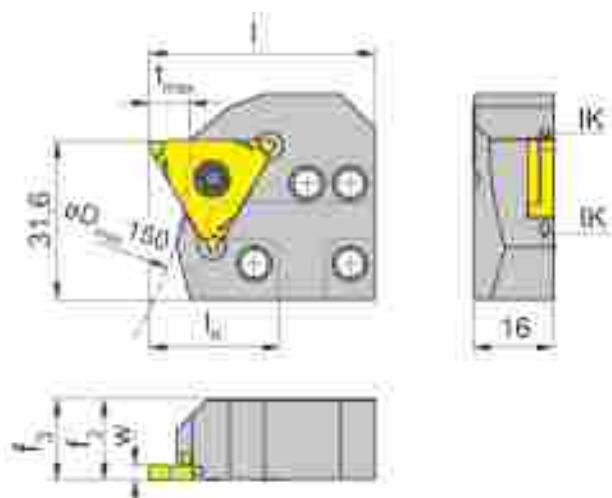
刀夹
Cassette

NK316

直接冷却液供应
with through coolant supply



槽深可达 Depth of groove up to 8 mm



配合可转位刀片
for Indexable insert

型号 S316
Type

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t _{max}	f ₂	f ₃	D _{max}	l	l _k	尺寸规格 Size
R/LNK316.0220.4.03.IK	8	18.1	f ₃ =f ₂	150	45	26	03
R/LNK316.0220.4.05.IK	8	16.2	f ₃ =f ₂	150	45	26	05
R/LNK316.0220.S3.4.03.IK	8	16.2	f ₃ =f ₂	150	45	26	03

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

通过刀夹和刀片提供

Coolant outlet:

Through clamping finger and insert support

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK316...	5.12T20P	T20PQ

切槽 (外圆)

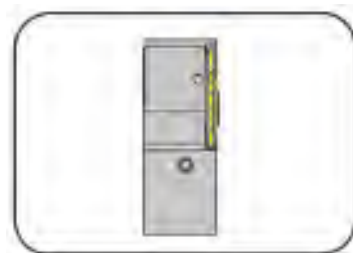
Grooving (external)



刀夹
Cassette

NK64T

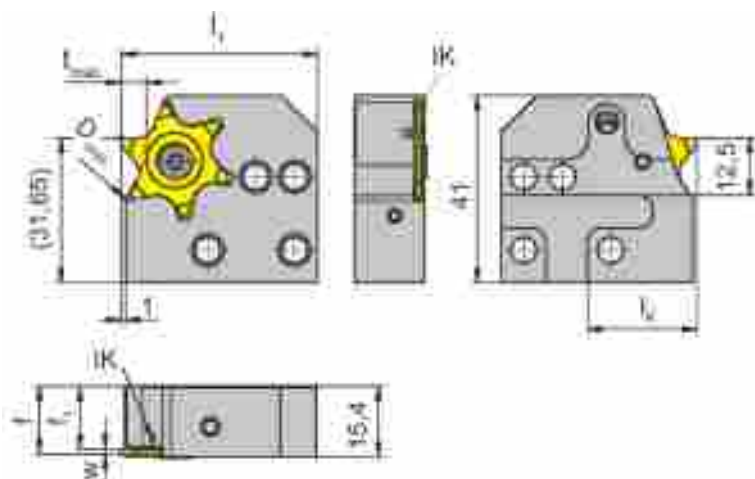
直接冷却液供应
with through coolant supply



槽深可达

Depth of groove up to

5.5 mm



配合可转位刀片
for Indexable insert

型号 S64T
Type



R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	t_{max}	f	f_1	D_{max}	l_1	l_k	尺寸规格 Size
R/LNK64T.0220.01.IK	5.5	f_1+w+a_1	13.2	100	43	24	01
R/LNK64T.0220.02.IK	5.5	f_1+w+a_1	12.7	100	43	24	02

注明R或L型
State R or L version

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

冷却方式:

在刀片侧边

Coolant outlet:

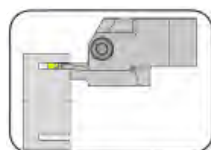
At the side of the insert

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LNK64T...	030.4010.T15P	T15PQ

刀夹
Cassette
K25A/LAK224/
RAK224/LIK224/
RIK224/LIK220/
RIK220/LAK220/
RAK220



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刀夹
端面槽
直接冷却液供应

Cassettes for
face grooving
with through coolant supply

端面切槽

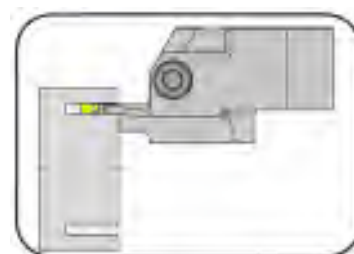
Face Grooving



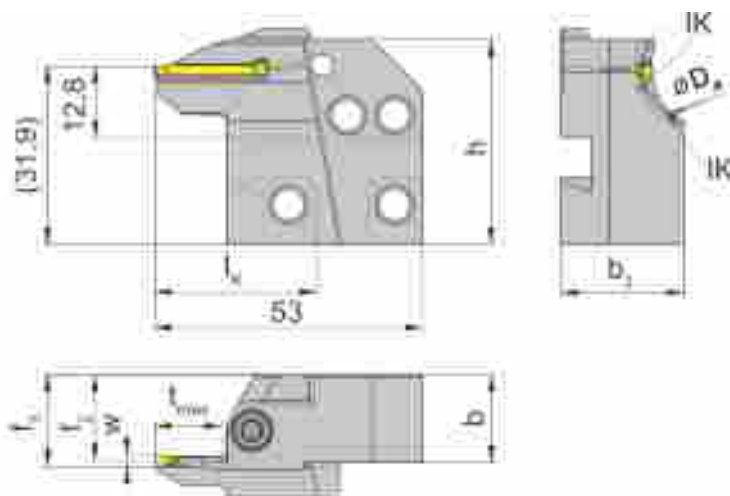
刀夹

Cassette

K25A



端面槽起始外径	from outer groove \varnothing	15 mm
槽深可达	Depth of groove up to	20 mm
槽宽	Width of groove	2-4 mm



配合可转位刀片
for Indexable insert

型号 S15A
Type S25A

切削刃高度设定需高于中心
高0.3mm
The cutting edge is above
0,3 mm the centre height

R=右手型-如图
R = right hand version shown

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	h	l_k	尺寸规格 Size
R/LAK25A.1520.02.IK	15	20	12	15.7	21	15.4	$f_2+w/2$	38.6	34	02
R/LAK25A.2025.02.IK	20	25	12	15.7	22	15.4	$f_2+w/2$	38.6	34	02
R/LAK25A.2530.02.IK	25	30	13	15.7	23	15.4	$f_2+w/2$	38.6	34	02
R/LAK25A.2025.03.IK	20	25	14	15.7	24	14.9	$f_2+w/2$	38.6	34	03
R/LAK25A.2530.03.IK	25	30	15	15.7	25	14.9	$f_2+w/2$	38.6	34	03
R/LAK25A.3040.03.IK	30	40	16	15.7	23	14.9	$f_2+w/2$	38.6	34	03
R/LAK25A.4050.03.IK	40	50	18	15.7	24	14.9	$f_2+w/2$	38.6	34	03
R/LAK25A.2025.04.IK	20	25	16	15.7	24	15.1	$f_2+w/2$	38.6	34	04
R/LAK25A.2530.04.IK	25	30	17	15.7	24	15.1	$f_2+w/2$	38.6	34	04
R/LAK25A.3040.04.IK	30	40	18	15.7	24	15.1	$f_2+w/2$	38.6	34	04
R/LAK25A.4050.04.IK	40	50	20	15.7	24	15.1	$f_2+w/2$	39.2	34	04

按需提供更多尺寸
Further sizes upon request

w见刀片
w see indexable inserts

尺寸单位 : mm
Dimensions in mm

w=2.0mm的螺丝扭矩规格为2.5Nm
w=3.0mm的螺丝扭矩规格为3.0Nm
w=4.0mm的螺丝扭矩规格为3.5Nm

Torque specification of the screw for w = 2,0 mm is 2,5 Nm
Torque specification of the screw for w = 3,0 mm is 3,0 Nm
Torque specification of the screw for w = 4,0 mm is 3,5 Nm

注意事项 :

配220系统接口

Note:

for use with pocket seat system 220!

注明R或L型

State R or L version

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
R/LAK25A...	5.13T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

LAK224



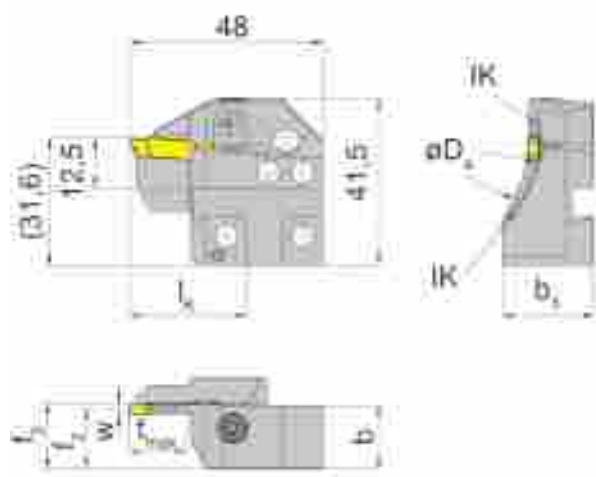
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
LAK224.5060.03.IK	50	60	14	15.7	23.7	14.9	$f_2+w/2$	3	29
LAK224.6075.03.IK	60	75	14	15.7	22.7	14.9	$f_2+w/2$	3	29
LAK224.7590.03.IK	75	90	14	15.7	22.7	14.9	$f_2+w/2$	3	29
LAK224.9011.03.IK	90	110	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1113.03.IK	110	130	14	15.7	21.0	14.9	$f_2+w/2$	3	29
LAK224.1318.03.IK	130	180	14	15.7	20.0	14.9	$f_2+w/2$	3	29
LAK224.1830.03.IK	180	300	14	15.7	19.0	14.9	$f_2+w/2$	3	29
LAK224.3000.03.IK	300	1000	14	15.7	16.9	14.9	$f_2+w/2$	3	29
LAK224.3847.04.IK	38	47	14	15.7	24.2	14.4	$f_2+w/2$	4	29
LAK224.4760.04.IK	47	60	14	15.7	23.7	14.4	$f_2+w/2$	4	29
LAK224.6075.04.IK	60	75	14	15.7	23.7	14.4	$f_2+w/2$	4	29
LAK224.7590.04.IK	75	90	14	15.7	22.7	14.4	$f_2+w/2$	4	29
LAK224.9013.04.IK	90	130	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1318.04.IK	130	180	14	15.7	21.0	14.4	$f_2+w/2$	4	29
LAK224.1830.04.IK	180	300	14	15.7	19.0	14.4	$f_2+w/2$	4	29
LAK224.3000.04.IK	300	1000	14	15.7	16.7	14.4	$f_2+w/2$	4	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK224...	5.13T20P	T20PQ

端面切槽 Face Grooving



刀夹 Cassette

LAK224



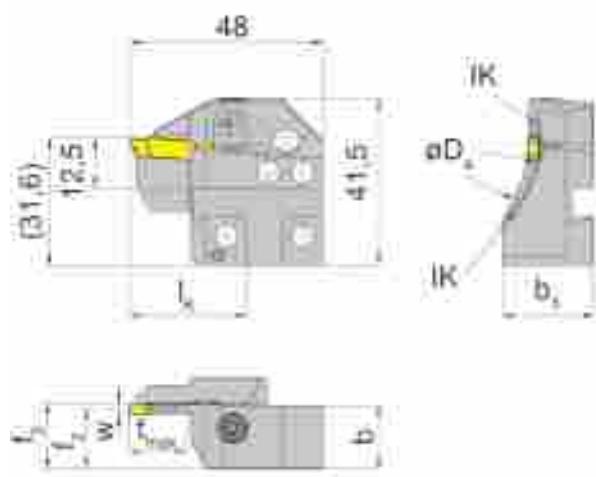
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
LAK224.3847.05.IK	38	47	14	15.7	23.7	13.9	$f_2+w/2$	5	29
LAK224.4760.05.IK	47	60	14	15.7	23.7	13.9	$f_2+w/2$	5	29
LAK224.6075.05.IK	60	75	14	15.7	23.7	13.9	$f_2+w/2$	5	29
LAK224.7590.05.IK	75	90	14	15.7	22.0	13.9	$f_2+w/2$	5	29
LAK224.9013.05.IK	90	130	14	15.7	22.0	13.9	$f_2+w/2$	5	29
LAK224.1318.05.IK	130	180	14	15.7	21.0	13.9	$f_2+w/2$	5	29
LAK224.1830.05.IK	180	300	14	15.7	19.0	13.9	$f_2+w/2$	5	29
LAK224.3000.05.IK	300	1000	14	15.7	16.7	13.9	$f_2+w/2$	5	29
LAK224.6075.06.IK	60	75	14	15.7	23.0	13.4	$f_2+w/2$	6	29
LAK224.7590.06.IK	75	90	14	15.7	23.0	13.4	$f_2+w/2$	6	29
LAK224.9013.06.IK	90	130	14	15.7	21.0	13.4	$f_2+w/2$	6	29
LAK224.1318.06.IK	130	180	14	15.7	21.0	13.4	$f_2+w/2$	6	29
LAK224.1830.06.IK	180	300	14	15.7	19.0	13.4	$f_2+w/2$	6	29
LAK224.3000.06.IK	300	1000	14	15.7	16.7	13.4	$f_2+w/2$	6	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK224...	5.13T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

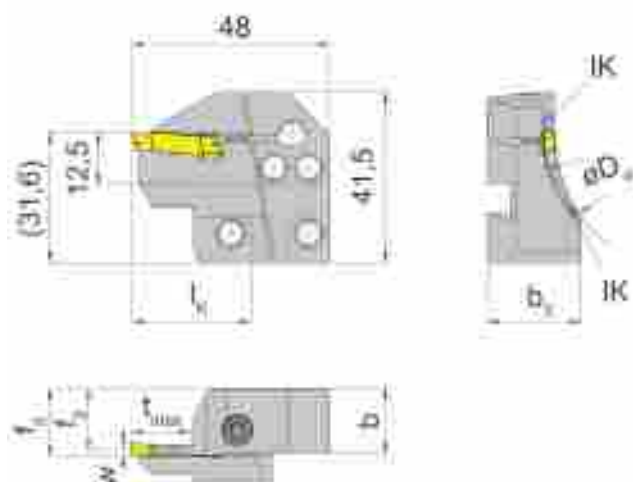
RAK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK224.5060.03.IK	50	60	14	15.7	23.7	14.9	f ₂ +w/2	3	29
RAK224.6075.03.IK	60	75	14	15.7	22.7	14.9	f ₂ +w/2	3	29
RAK224.7590.03.IK	75	90	14	15.7	22.7	14.9	f ₂ +w/2	3	29
RAK224.9011.03.IK	90	110	14	15.7	21.0	14.9	f ₂ +w/2	3	29
RAK224.1113.03.IK	110	130	14	15.7	21.0	14.9	f ₂ +w/2	3	29
RAK224.1318.03.IK	130	180	14	15.7	20.0	14.9	f ₂ +w/2	3	29
RAK224.1830.03.IK	180	300	14	15.7	19.0	14.9	f ₂ +w/2	3	29
RAK224.3000.03.IK	300	1000	14	15.7	16.9	14.9	f ₂ +w/2	3	29
RAK224.3847.04.IK	38	47	14	15.7	24.2	14.4	f ₂ +w/2	4	29
RAK224.4760.04.IK	47	60	14	15.7	23.7	14.4	f ₂ +w/2	4	29
RAK224.6075.04.IK	60	75	14	15.7	23.7	14.4	f ₂ +w/2	4	29
RAK224.7590.04.IK	75	90	14	15.7	22.7	14.4	f ₂ +w/2	4	29
RAK224.9013.04.IK	90	130	14	15.7	21.0	14.4	f ₂ +w/2	4	29
RAK224.1318.04.IK	130	180	14	15.7	21.0	14.4	f ₂ +w/2	4	29
RAK224.1830.04.IK	180	300	14	15.7	19.0	14.4	f ₂ +w/2	4	29
RAK224.3000.04.IK	300	1000	14	15.7	16.7	14.4	f ₂ +w/2	4	29

按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

订货须知：
锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:
The fastening screw is combined with the basic toolholder - no separate order required.
螺丝的扭矩规格, 详见技术说明。
For torque specification of the screw, please see Technical Instructions.

配件
Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK224...	5.13T20P	T20PQ

端面切槽

Face Grooving



刀夹
Cassette

RAK224



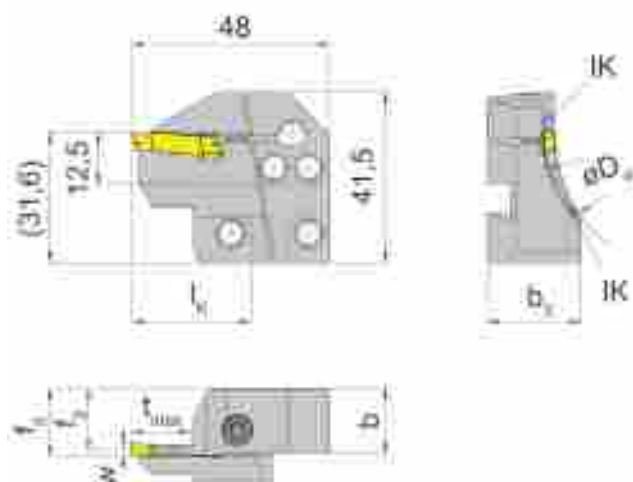
槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm

配合可转位刀片
for Indexable insert

型号 S224
Type



R=右手型
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
RAK224.3847.05.IK	38	47	14	15.7	23.7	13.9	$f_2+w/2$	5	29
RAK224.4760.05.IK	47	60	14	15.7	23.7	13.9	$f_2+w/2$	5	29
RAK224.6075.05.IK	60	75	14	15.7	23.7	13.9	$f_2+w/2$	5	29
RAK224.7590.05.IK	75	90	14	15.7	22.0	13.9	$f_2+w/2$	5	29
RAK224.9013.05.IK	90	130	14	15.7	22.0	13.9	$f_2+w/2$	5	29
RAK224.1318.05.IK	130	180	14	15.7	21.0	13.9	$f_2+w/2$	5	29
RAK224.1830.05.IK	180	300	14	15.7	19.0	13.9	$f_2+w/2$	5	29
RAK224.3000.05.IK	300	1000	14	15.7	16.7	13.9	$f_2+w/2$	5	29
RAK224.6075.06.IK	60	75	14	15.7	23.0	13.4	$f_2+w/2$	6	29
RAK224.7590.06.IK	75	90	14	15.7	23.0	13.4	$f_2+w/2$	6	29
RAK224.9013.06.IK	90	130	14	15.7	21.0	13.4	$f_2+w/2$	6	29
RAK224.1318.06.IK	130	180	14	15.7	21.0	13.4	$f_2+w/2$	6	29
RAK224.1830.06.IK	180	300	14	15.7	19.0	13.4	$f_2+w/2$	6	29
RAK224.3000.06.IK	300	1000	14	15.7	16.7	13.4	$f_2+w/2$	6	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK224...	5.13T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

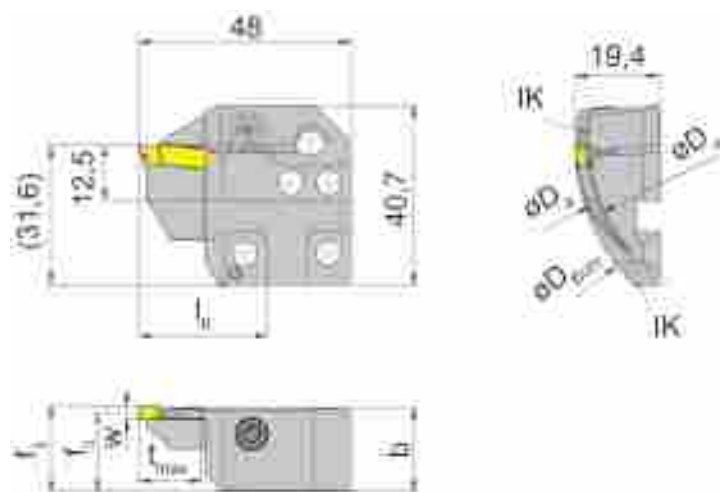
LIK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

L=左手型
L = left hand version

产品型号 Part number	D_{Bohr}	$D_{a \text{ min}}$	$D_{a \text{ max}}$	t_{max}	b	f_2	f_3	w	l_K
LIK224.5060.03.IK	90	50	60	14	19	17.9	$f_2+w/2$	3	29
LIK224.6075.03.IK	90	60	75	14	19	17.9	$f_2+w/2$	3	29
LIK224.7590.03.IK	90	75	90	14	19	17.9	$f_2+w/2$	3	29
LIK224.9011.03.IK	90	90	110	14	19	17.9	$f_2+w/2$	3	29
LIK224.1113.03.IK	110	110	130	14	19	17.9	$f_2+w/2$	3	29
LIK224.1318.03.IK	130	130	180	14	19	17.9	$f_2+w/2$	3	29
LIK224.1830.03.IK	180	180	300	14	19	17.9	$f_2+w/2$	3	29
LIK224.3847.04.IK	90	38	47	14	19	17.4	$f_2+w/2$	4	29
LIK224.4760.04.IK	90	47	60	14	19	17.4	$f_2+w/2$	4	29
LIK224.6075.04.IK	90	60	75	14	19	17.4	$f_2+w/2$	4	29
LIK224.7590.04.IK	90	75	90	14	19	17.4	$f_2+w/2$	4	29
LIK224.9013.04.IK	90	90	130	14	19	17.4	$f_2+w/2$	4	29
LIK224.1318.04.IK	130	130	180	14	19	17.4	$f_2+w/2$	4	29
LIK224.3000.04.IK	300	300	1000	14	19	17.4	$f_2+w/2$	4	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK224...	5.13T20P	T20PQ

端面切槽 Face Grooving



刀夹 Cassette

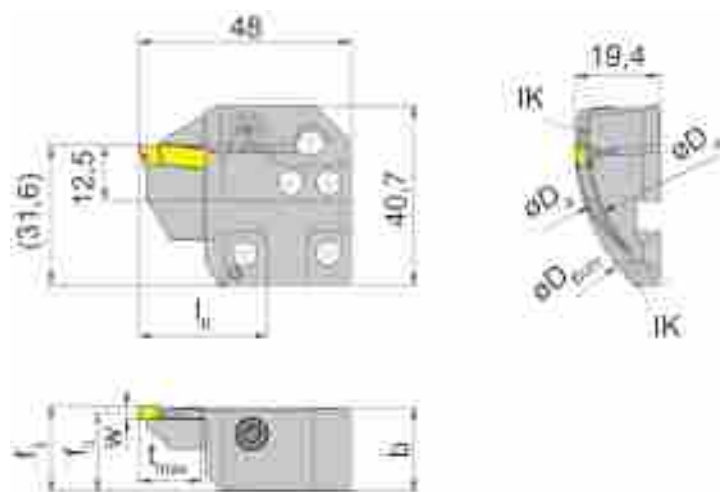
LIK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

L=左手型
L = left hand version

产品型号 Part number	D_{Bohr}	$D_{\text{a min}}$	$D_{\text{a max}}$	t_{max}	b	f_2	f_3	w	l_k
LIK224.3847.05.IK	90	38	47	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.4760.05.IK	90	47	60	14	19.00	17.4	$f_2+w/2$	5	29
LIK224.6075.05.IK	90	60	75	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.7590.05.IK	90	75	90	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.9013.05.IK	90	90	130	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.1318.05.IK	130	130	180	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.1830.05.IK	180	180	300	14	19.00	16.9	$f_2+w/2$	5	29
LIK224.3000.05.IK	300	300	1000	14	18.90	16.9	$f_2+w/2$	5	29
LIK224.6075.06.IK	90	60	75	14	19.00	16.4	$f_2+w/2$	6	29
LIK224.7590.06.IK	90	75	90	14	19.00	16.4	$f_2+w/2$	6	29
LIK224.9013.06.IK	90	90	130	14	19.00	16.4	$f_2+w/2$	6	29
LIK224.1318.06.IK	130	130	180	14	19.00	16.4	$f_2+w/2$	6	29
LIK224.1830.06.IK	180	180	300	14	19.00	16.4	$f_2+w/2$	6	29
LIK224.3000.06.IK	300	300	1000	14	18.75	16.4	$f_2+w/2$	6	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK224...	5.13T20P	T20PQ

端面切槽 Face Grooving



刀夹 Cassette

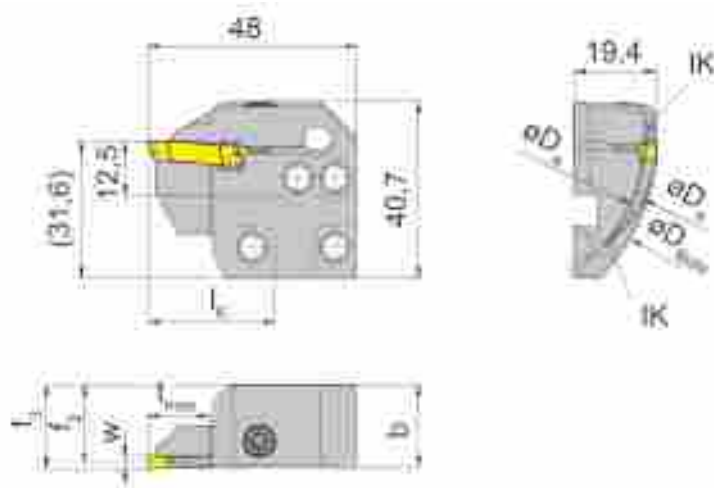
RIK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
3-4 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型
R = right hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
RIK224.5060.03.IK	90	50	60	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.6075.03.IK	90	60	75	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.7590.03.IK	90	75	90	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.9011.03.IK	90	90	110	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.1113.03.IK	110	110	130	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.1318.03.IK	130	130	180	14	19.05	17.9	f ₂ +w/2	3	29
RIK224.1830.03.IK	180	180	300	14	19.00	17.9	f ₂ +w/2	3	29
RIK224.3847.04.IK	90	38	47	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.4760.04.IK	90	47	60	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.6075.04.IK	90	60	75	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.7590.04.IK	90	75	90	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.9013.04.IK	90	90	130	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.1318.04.IK	130	130	180	14	19.00	17.4	f ₂ +w/2	4	29
RIK224.3000.04.IK	300	300	1000	14	19.00	17.4	f ₂ +w/2	4	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK224...	5.13T20P	T20PQ

端面切槽

Face Grooving



刀夹

Cassette

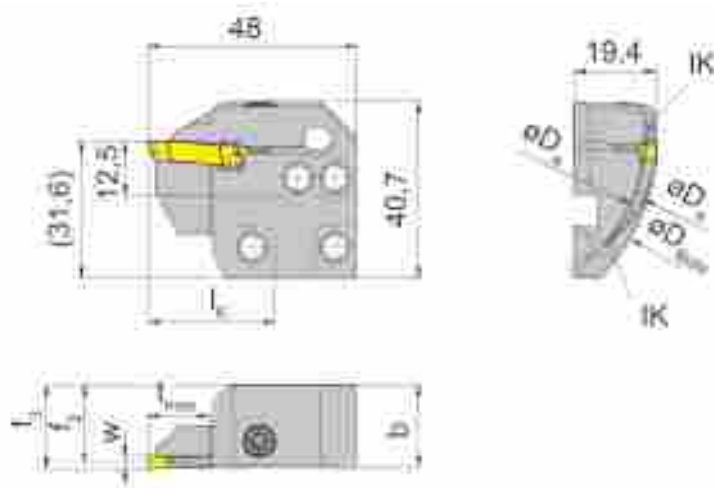
RIK224



槽深可达
槽宽

Depth of groove up to
Width of groove

14 mm
5-6 mm



配合可转位刀片
for Indexable insert

型号 S224
Type

R=右手型
R = right hand version

产品型号 Part number	D _{Bohr}	D _{a min}	D _{a max}	t _{max}	b	f ₂	f ₃	w	l _k
RIK224.3847.05.IK	90	38	47	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.4760.05.IK	90	47	60	14	19.00	17.4	f ₂ +w/2	5	29
RIK224.6075.05.IK	90	60	75	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.7590.05.IK	90	75	90	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.9013.05.IK	90	90	130	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.1318.05.IK	130	130	180	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.1830.05.IK	180	180	300	14	19.00	16.9	f ₂ +w/2	5	29
RIK224.3000.05.IK	300	300	1000	14	18.90	16.9	f ₂ +w/2	5	29
RIK224.6075.06.IK	90	60	75	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.7590.06.IK	90	75	90	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.9013.06.IK	90	90	130	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.1318.06.IK	130	130	180	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.1830.06.IK	180	180	300	14	19.00	16.4	f ₂ +w/2	6	29
RIK224.3000.06.IK	300	300	1000	14	18.75	16.4	f ₂ +w/2	6	29

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK224...	5.13T20P	T20PQ

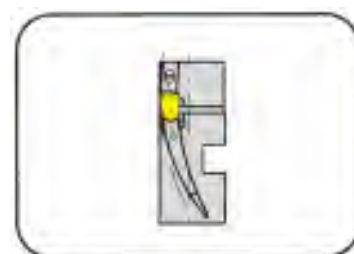
端面切槽 Face Grooving



刀夹 Cassette

LAK220

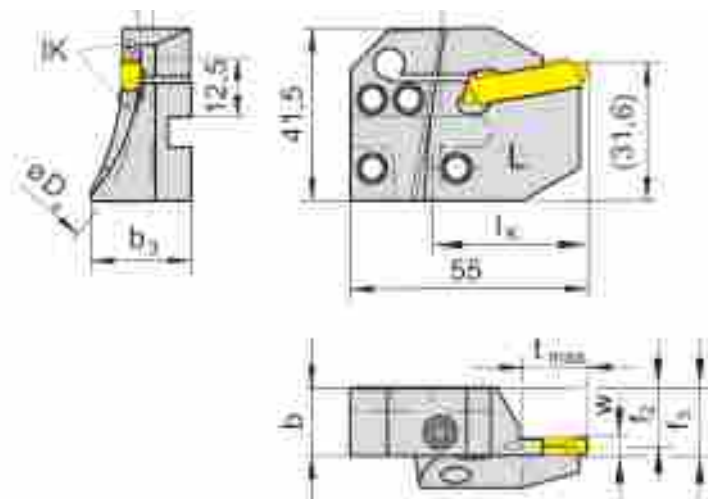
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK220.6575.04.IK	65	75	10-15	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.7595.04.IK	75	95	15-25	15.7	23.0	14.4	f ₂ +w/2	4	36
LAK220.9513.04.IK	95	122	25	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1318.04.IK	130	180	25	15.7	21.2	14.4	f ₂ +w/2	4	36
LAK220.1830.04.IK	180	300	25	15.7	19.0	14.4	f ₂ +w/2	4	36
LAK220.3000.04.IK	300	1000	25	15.7	16.8	14.4	f ₂ +w/2	4	36
LAK220.6075.05.IK	60	75	10-17	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.7595.05.IK	75	95	17-25	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.9513.05.IK	95	120	25	15.7	23.0	13.9	f ₂ +w/2	5	36
LAK220.1318.05.IK	130	180	25	15.7	21.2	13.9	f ₂ +w/2	5	36
LAK220.1830.05.IK	180	300	25	15.7	19.0	13.9	f ₂ +w/2	5	36
LAK220.3000.05.IK	300	1000	25	15.7	16.8	13.9	f ₂ +w/2	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

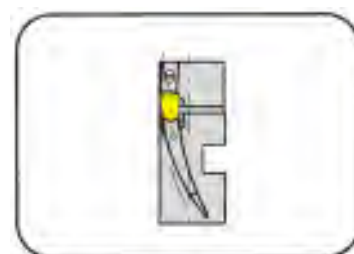
端面切槽 Face Grooving



刀夹 Cassette

LAK220

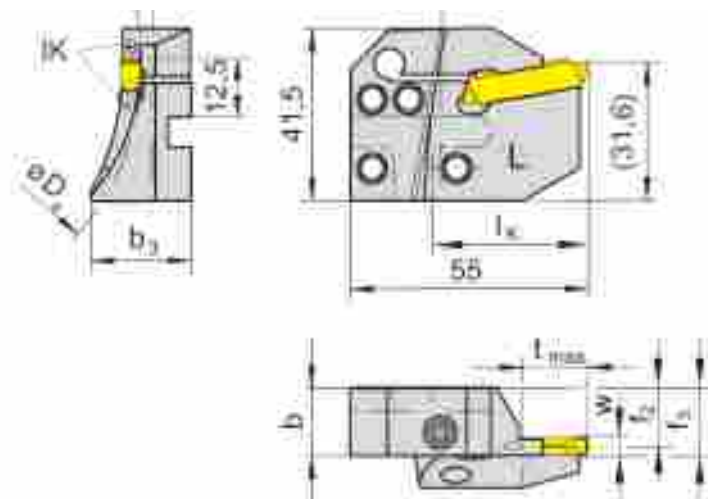
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
LAK220.6075.06.IK	60	75	10	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.7595.06.IK	75	95	17	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.9513.06.IK	95	130	25	15.7	23.0	13.4	f ₂ +w/2	6	36
LAK220.1318.06.IK	130	180	25	15.7	21.2	13.4	f ₂ +w/2	6	36
LAK220.1830.06.IK	180	300	25	15.7	19.0	13.4	f ₂ +w/2	6	36
LAK220.3000.06.IK	300	1000	25	15.7	16.8	13.4	f ₂ +w/2	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

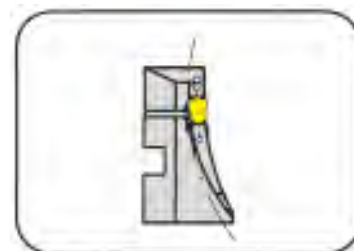
端面切槽 Face Grooving



刀夹 Cassette

LAK220

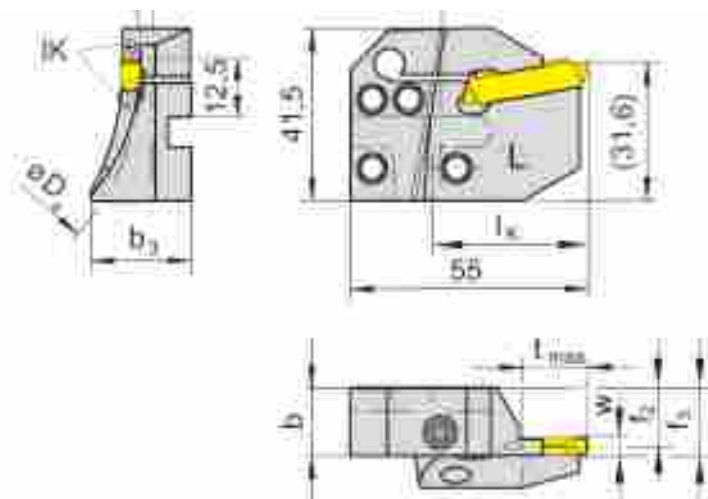
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
LAK220.6575.14.IK	65	75	10	15.7	23.0	14.4	$f_2+w/2$	4	36
LAK220.7595.14.IK	75	95	15	15.7	23.0	14.4	$f_2+w/2$	4	36
LAK220.9513.14.IK	95	130	15	15.7	21.2	14.4	$f_2+w/2$	4	36
LAK220.1318.14.IK	130	180	15	15.7	21.2	14.4	$f_2+w/2$	4	36
LAK220.1830.14.IK	180	300	15	15.7	19.0	14.4	$f_2+w/2$	4	36
LAK220.6075.15.IK	60	75	10	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.7595.15.IK	75	95	15	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.9513.15.IK	95	130	15	15.7	23.0	13.9	$f_2+w/2$	5	36
LAK220.1318.15.IK	130	180	15	15.7	21.2	13.9	$f_2+w/2$	5	36
LAK220.1830.15.IK	180	300	15	15.7	19.0	13.9	$f_2+w/2$	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	6.23T25P	T25PQ

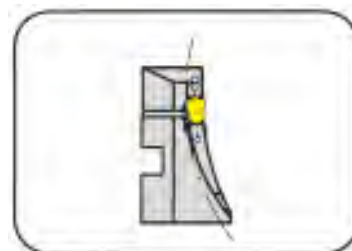
端面切槽 Face Grooving



刀夹 Cassette

LAK220

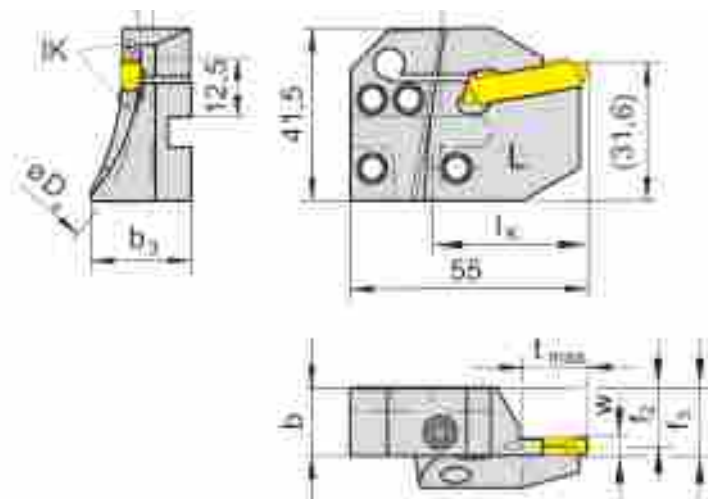
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
LAK220.6075.16.IK	60	75	10	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.7595.16.IK	75	95	15	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.9513.16.IK	95	130	15	15.7	23.0	13.4	$f_2+w/2$	6	36
LAK220.1318.16.IK	130	180	15	15.7	21.2	13.4	$f_2+w/2$	6	36
LAK220.1830.16.IK	180	300	15	15.7	19.0	13.4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	销 Threaded Pin	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LAK220...	3.03.913	6.23T25P	T25PQ

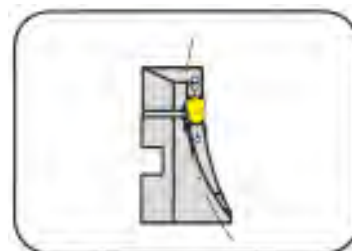
端面切槽 Face Grooving



刀夹 Cassette

RAK220

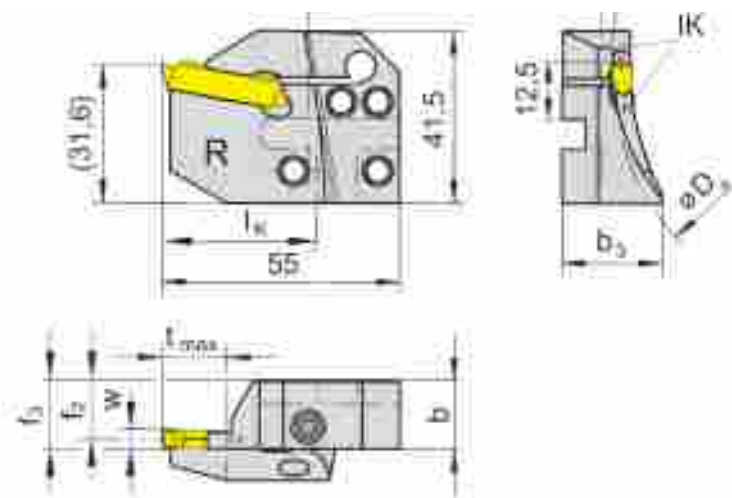
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6575.04.IK	65	75	10-15	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.7595.04.IK	75	95	15-25	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.9513.04.IK	95	130	25	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1318.04.IK	130	180	25	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1830.04.IK	180	300	25	15.7	19.0	14.4	f ₂ +w/2	4	36
RAK220.3000.04.IK	300	1000	25	15.7	16.8	14.4	f ₂ +w/2	4	36
RAK220.6075.05.IK	60	75	10-17	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.7595.05.IK	75	95	17-25	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.9513.05.IK	95	130	25	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.1318.05.IK	130	180	25	15.7	21.2	13.9	f ₂ +w/2	5	36
RAK220.1830.05.IK	180	300	25	15.7	19.0	13.9	f ₂ +w/2	5	36
RAK220.3000.05.IK	300	1000	25	15.7	16.8	13.9	f ₂ +w/2	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

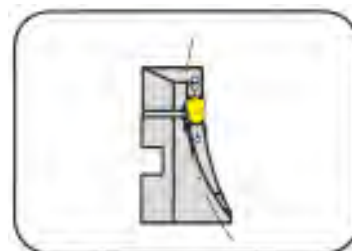


刀夹

Cassette

RAK220

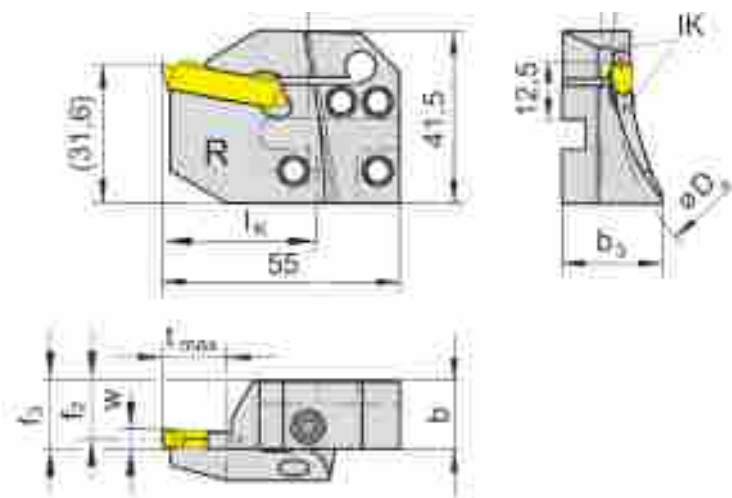
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	b_3	f_2	f_3	w	l_k
RAK220.6075.06.IK	60	75	10-17	15.7	23.0	13.4	$f_2+w/2$	6	36
RAK220.7595.06.IK	75	95	17-25	15.7	23.0	13.4	$f_2+w/2$	6	36
RAK220.9513.06.IK	95	130	25	15.7	23.0	13.4	$f_2+w/2$	6	36
RAK220.1318.06.IK	130	180	25	15.7	21.2	13.4	$f_2+w/2$	6	36
RAK220.1830.06.IK	180	300	25	15.7	19.0	13.4	$f_2+w/2$	6	36
RAK220.3000.06.IK	300	1000	25	15.7	16.8	13.4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

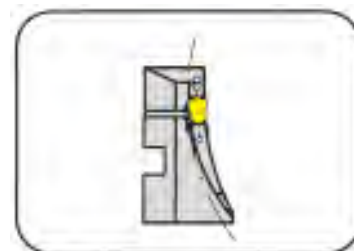


刀夹

Cassette

RAK220

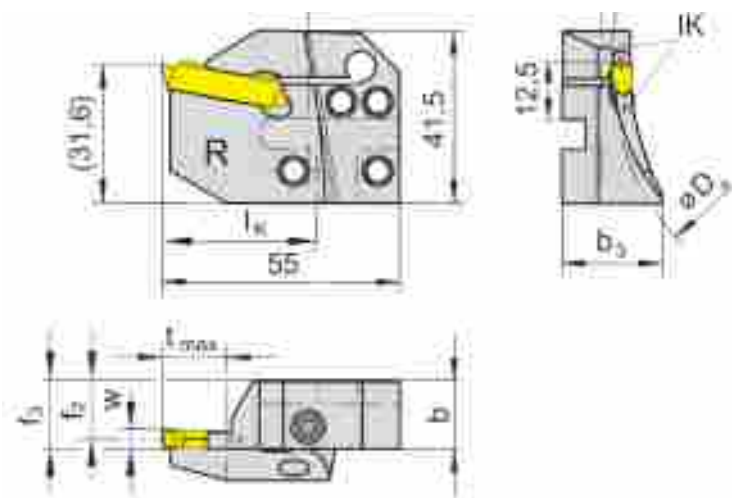
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6575.14.IK	65	75	10	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.7595.14.IK	75	95	15	15.7	23.0	14.4	f ₂ +w/2	4	36
RAK220.9513.14.IK	95	130	15	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1318.14.IK	130	180	15	15.7	21.2	14.4	f ₂ +w/2	4	36
RAK220.1830.14.IK	180	300	15	15.7	19.0	14.4	f ₂ +w/2	4	36
RAK220.6075.15.IK	60	75	10	15.7	23.0	13.4	f ₂ +w/2	5	36
RAK220.7595.15.IK	75	95	15	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.9513.15.IK	95	130	15	15.7	23.0	13.9	f ₂ +w/2	5	36
RAK220.1318.15.IK	130	180	15	15.7	21.2	13.9	f ₂ +w/2	5	36
RAK220.1830.15.IK	180	300	15	15.7	19.0	13.9	f ₂ +w/2	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位 : mm
Dimensions in mm

订货须知 :

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

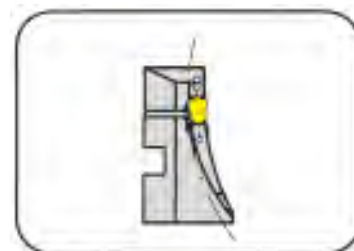


刀夹

Cassette

RAK220

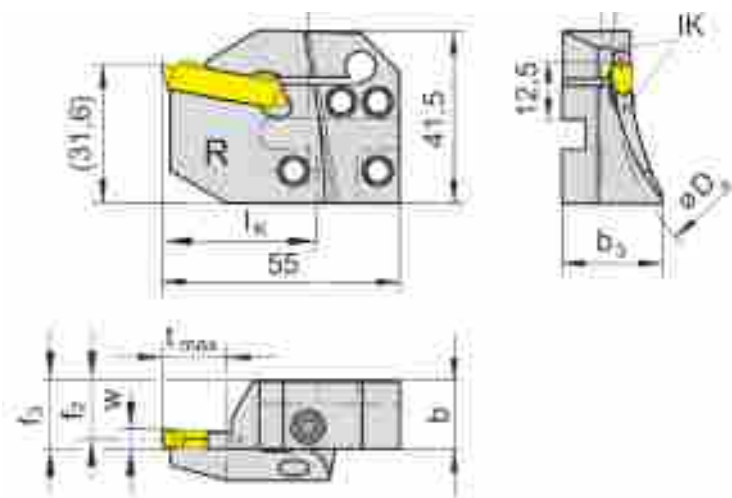
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

Bestellnummer Part number	D _{a min}	D _{a max}	t _{max}	b	b ₃	f ₂	f ₃	w	l _k
RAK220.6075.16.IK	60	75	10	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.7595.16.IK	75	95	15	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.9513.16.IK	95	130	15	15.7	23.0	13.4	f ₂ +w/2	6	36
RAK220.1318.16.IK	130	180	15	15.7	21.2	13.4	f ₂ +w/2	6	36
RAK220.1830.16.IK	180	300	15	15.7	19.0	13.4	f ₂ +w/2	6	36

按需提供更多尺寸

Further sizes upon request

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

尺寸单位：mm

Dimensions in mm

配件

Spare Parts

刀夹 Cassette	销 Threaded Pin	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RAK220...	3.03.913	6.23T25P	T25PQ

端面切槽

Face Grooving

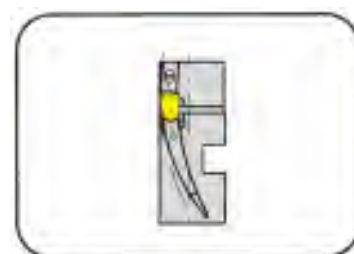


刀夹

Cassette

LIK220

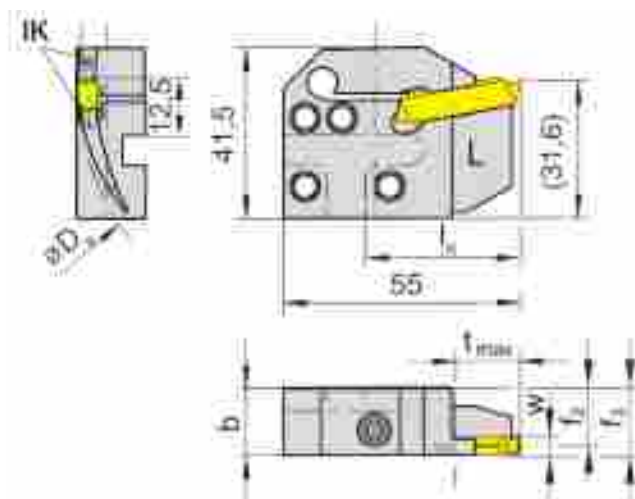
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	f_2	f_3	w	l_K
LIK220.6575.04.IK	65	75	10-15	15.7	14.4	$f_2+w/2$	4	36
LIK220.7595.04.IK	75	95	15-25	15.7	14.4	$f_2+w/2$	4	36
LIK220.9513.04.IK	95	130	25	15.7	14.4	$f_2+w/2$	4	36
LIK220.1318.04.IK	130	180	25	15.7	14.4	$f_2+w/2$	4	36
LIK220.1830.04.IK	180	300	25	15.7	14.4	$f_2+w/2$	4	36
LIK220.3000.04.IK	300	1000	25	15.7	14.4	$f_2+w/2$	4	36
LIK220.6075.05.IK	60	75	10-17	15.7	13.9	$f_2+w/2$	5	36
LIK220.7595.05.IK	75	95	17-25	15.7	13.9	$f_2+w/2$	5	36
LIK220.9513.05.IK	95	130	25	15.7	13.9	$f_2+w/2$	5	36
LIK220.1318.05.IK	130	180	25	15.7	13.9	$f_2+w/2$	5	36
LIK220.1830.05.IK	180	300	25	15.7	13.9	$f_2+w/2$	5	36
LIK220.3000.05.IK	300	1000	25	15.7	13.9	$f_2+w/2$	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

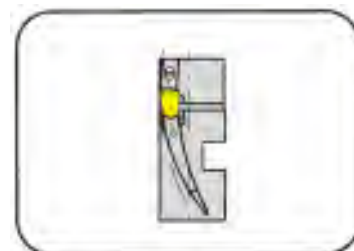


刀夹

Cassette

LIK220

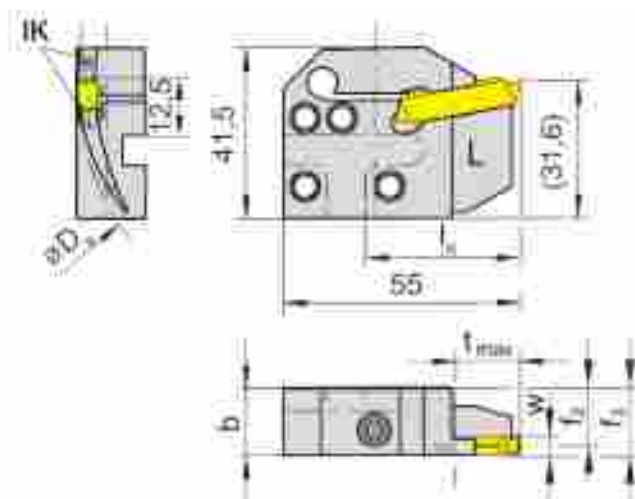
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	f_2	f_3	w	l_K
LIK220.6075.06.IK	60	75	10-17	15.7	13.4	$f_2+w/2$	6	36
LIK220.7595.06.IK	75	95	17-25	15.7	13.4	$f_2+w/2$	6	36
LIK220.9513.06.IK	95	130	25	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.06.IK	130	180	25	15.7	13.4	$f_2+w/2$	6	36
LIK220.1830.06.IK	180	300	25	15.7	13.4	$f_2+w/2$	6	36
LIK220.3000.06.IK	300	1000	25	15.7	13.4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving



刀夹

Cassette

LIK220

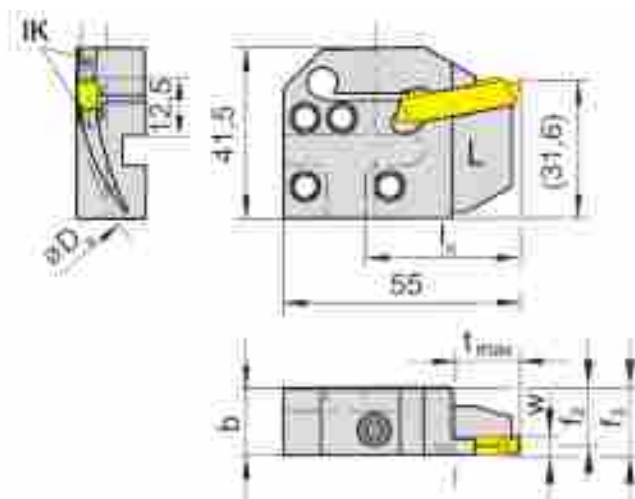
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	f_2	f_3	w	l_k
LIK220.6575.14.IK	65	75	10	15.7	14.4	$f_2+w/2$	4	36
LIK220.7595.14.IK	75	95	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.9513.14.IK	95	130	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.1318.14.IK	130	180	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.1830.14.IK	180	300	15	15.7	14.4	$f_2+w/2$	4	36
LIK220.6075.15.IK	60	75	10	15.7	13.9	$f_2+w/2$	5	36
LIK220.7595.15.IK	75	95	15	15.7	13.9	$f_2+w/2$	5	36
LIK220.9513.15.IK	95	130	15	15.7	13.9	$f_2+w/2$	5	36
LIK220.1318.15.IK	130	180	15	15.7	13.9	$f_2+w/2$	5	36
LIK220.1830.15.IK	130	180	15	15.7	13.9	$f_2+w/2$	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

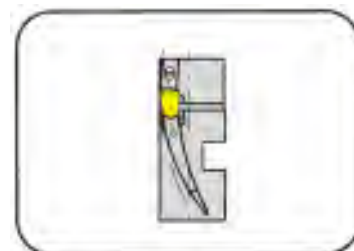


刀夹

Cassette

LIK220

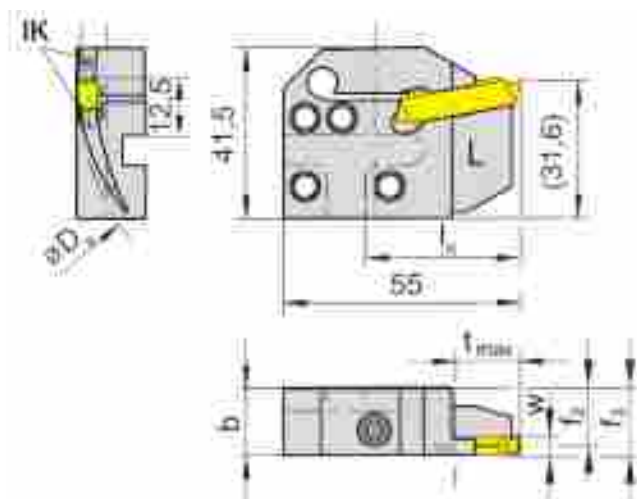
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

L=左手型
L = left hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b	f_2	f_3	w	l_k
LIK220.6075.16.IK	130	180	10	15.7	13.4	$f_2+w/2$	6	36
LIK220.7595.16.IK	75	95	15	15.7	13.4	$f_2+w/2$	6	36
LIK220.9513.16.IK	95	130	15	15.7	13.4	$f_2+w/2$	6	36
LIK220.1318.16.IK	130	180	15	15.7	13.4	$f_2+w/2$	6	36
LIK220.1830.16.IK	180	300	15	15.7	13.4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
LIK220...	6.23T25P	T25PQ

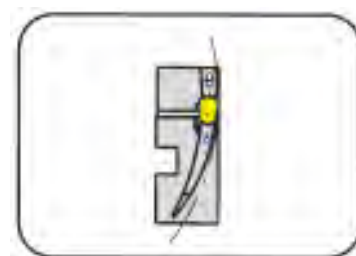
端面切槽 Face Grooving



刀夹 Cassette

RIK220

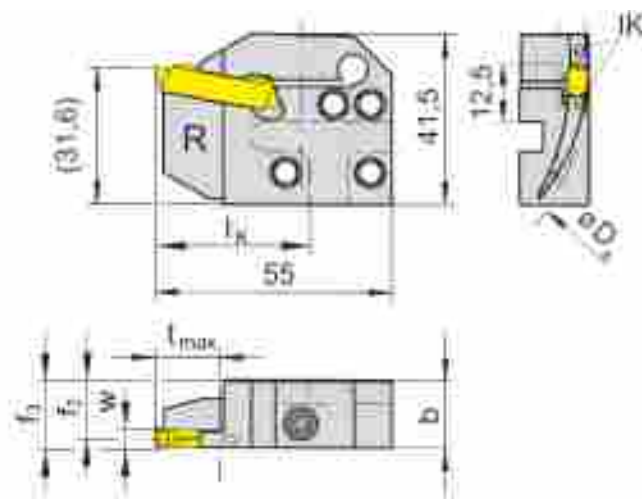
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

25 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	D _{a min}	D _{a max}	t _{max}	b ₃	f ₂	f ₃	w	l _k
RIK220.6575.04.IK	65	75	10-15	15.7	14.4	f ₂ +w/2	4	36
RIK220.7595.04.IK	75	95	15-25	15.7	14.4	f ₂ +w/2	4	36
RIK220.9513.04.IK	95	130	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.1318.04.IK	130	180	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.1830.04.IK	180	300	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.3000.04.IK	300	1000	25	15.7	14.4	f ₂ +w/2	4	36
RIK220.6075.05.IK	60	75	10-17	15.7	13.9	f ₂ +w/2	5	36
RIK220.7595.05.IK	75	95	17-25	15.7	13.9	f ₂ +w/2	5	36
RIK220.9513.05.IK	95	130	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.1318.05.IK	130	180	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.1830.05.IK	180	300	25	15.7	13.9	f ₂ +w/2	5	36
RIK220.3000.05.IK	300	1000	25	15.7	13.9	f ₂ +w/2	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格, 详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

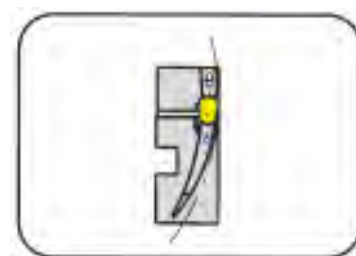


刀夹

Cassette

RIK220

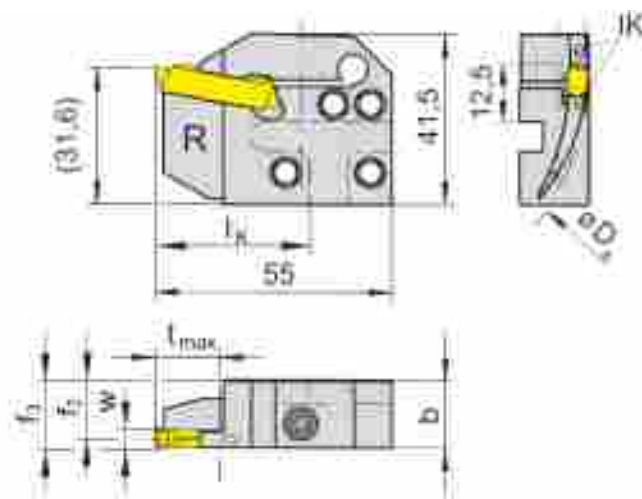
直接冷却液供应
with through coolant supply



槽深
槽宽

Depth of groove
Width of groove

10 - 25 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b_3	f_2	f_3	w	l_K
RIK220.6075.06.IK	60	75	10-17	15,7	13,4	$f_2+w/2$	6	36
RIK220.7595.06.IK	75	95	17-24	15,7	13,4	$f_2+w/2$	6	36
RIK220.9513.06.IK	95	130	25	15,7	13,4	$f_2+w/2$	6	36
RIK220.1318.06.IK	130	180	25	15,7	13,4	$f_2+w/2$	6	36
RIK220.1830.06.IK	180	300	25	15,7	13,4	$f_2+w/2$	6	36
RIK220.3000.06.IK	300	1000	25	15,7	13,4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

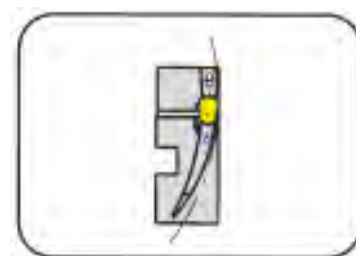


刀夹

Cassette

RIK220

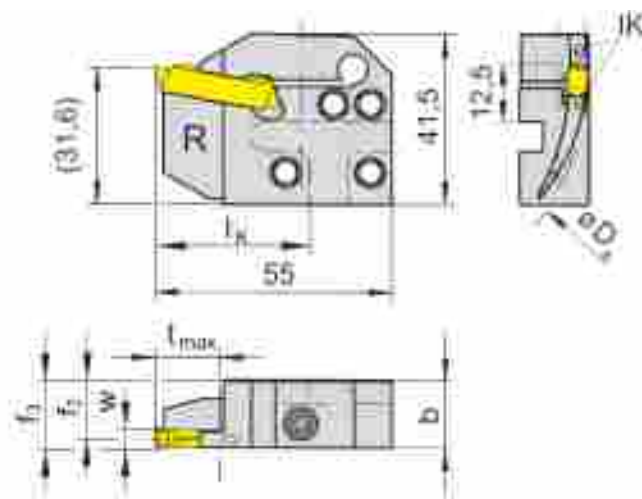
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
4-5 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b_3	f_2	f_3	w	l_k
RIK220.6575.14.IK	65	75	10	15.7	14.4	$f_2+w/2$	4	36
RIK220.7595.14.IK	75	95	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.9513.14.IK	95	130	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.1318.14.IK	130	180	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.1830.14.IK	180	300	15	15.7	14.4	$f_2+w/2$	4	36
RIK220.6075.15.IK	60	75	10	15.7	13.9	$f_2+w/2$	5	36
RIK220.7595.15.IK	75	95	15	15.7	13.9	$f_2+w/2$	5	36
RIK220.9513.15.IK	95	130	15	15.7	13.9	$f_2+w/2$	5	36
RIK220.1318.15.IK	130	180	15	15.7	13.9	$f_2+w/2$	5	36
RIK220.1830.15.IK	130	180	15	15.7	13.9	$f_2+w/2$	5	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

端面切槽

Face Grooving

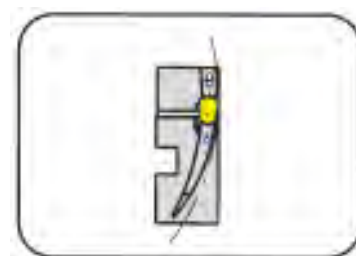


刀夹

Cassette

RIK220

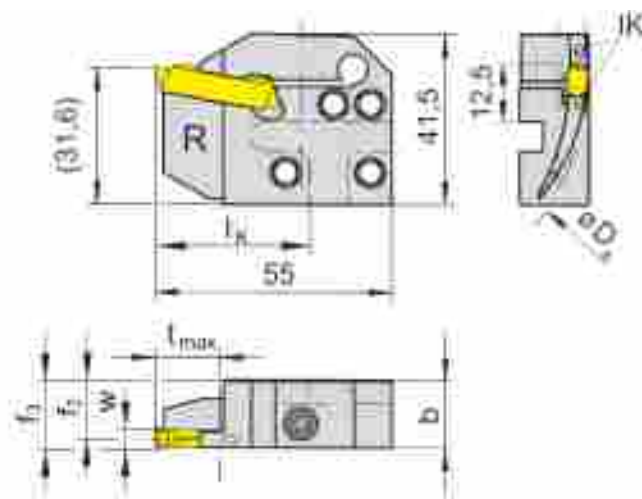
直接冷却液供应
with through coolant supply



槽深可达
槽宽

Depth of groove up to
Width of groove

15 mm
6 mm



配合可转位刀片
for Indexable insert

型号 S229
Type

R=右手型
R = right hand version

产品型号 Part number	$D_{a \min}$	$D_{a \max}$	t_{\max}	b_3	f_2	f_3	w	l_k
RIK220.6075.16.IK	60	75	10	15.7	13.4	$f_2+w/2$	6	36
RIK220.7595.16.IK	75	95	15	15.7	13.4	$f_2+w/2$	6	36
RIK220.9513.16.IK	95	130	15	15.7	13.4	$f_2+w/2$	6	36
RIK220.1318.16.IK	130	180	15	15.7	13.4	$f_2+w/2$	6	36
RIK220.1830.16.IK	180	300	15	15.7	13.4	$f_2+w/2$	6	36

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

订货须知：

锁紧螺钉包含在刀杆内,不需要单独订购

Ordering note:

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

螺丝的扭矩规格，详见技术说明。

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

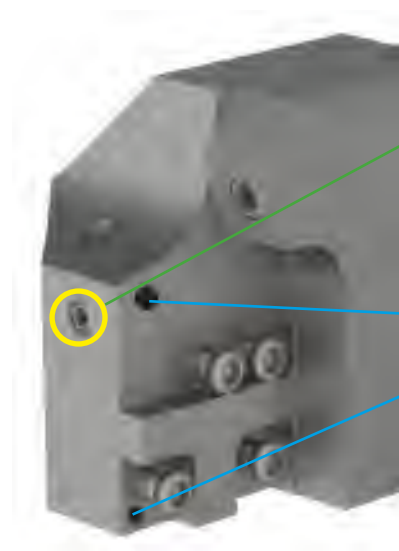
配件

Spare Parts

刀夹 Cassette	锁紧螺钉 Clamping Screw	TORX PLUS®扳手 TORX PLUS® Wrench
RIK220...	6.23T25P	T25PQ

接口220的基础柄

Basic body Interface 220

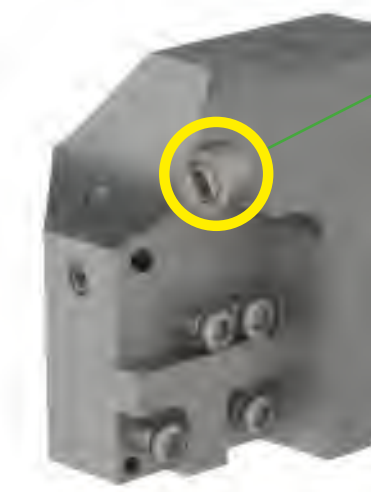


通过螺钉关闭刀夹上端冷却供应

Closure of the upper coolant supply to the cassette by cylinder head screw

冷却液供应

Coolant supply



使用冷却液喷嘴实现代替刀夹内冷

通过螺钉关闭刀夹上端冷却供应

Use of cassettes without internal coolant supply using the coolant spray nozzle

Closure of the upper coolant supply to the cassette by cylinder head screw

以下扭矩适用于刀片的螺钉,我们建议对螺钉不要额外使用润滑剂(如铜膏)

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

型号 Type	螺钉 Screw	M _d Nm	夹紧扳手 Clamping wrench	刀板 Blade
NK100.3215...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK220.3218...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK316.0220...	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
NK356	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	5,0	T15PQ	DT15PK
LAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK34T...00	030.4093T15P	1,5	T15PQ	DT15PK
NK34T...10	030.4093T15P	3,0	T15PQ	DT15PK
NK34T...20	030.4010T15P	5,0	T15PQ	DT15PK
NK34T...30	030.5012T15P	6,0	T15PQ	DT15PK
NK34T...40	030.5012T15P	6,0	T15PQ	DT15PK
NK64T...10	030.4010T15P	4,0	T15PQ	DT15PK
NK64T...20	030.4010T15P	5,0	T15PQ	DT15PK
NK274	030.3509T15P	3,0	T15PQ	DT15PK
AK25A...02	5.13T20P	2,5	T20PQ	DT20PK
AK25A...03	5.13T20P	3,0	T20PQ	DT20PK
AK25A...04	5.13T20P	3,5	T20PQ	DT20PK
NK220.3215	6.23T25P	7,0	T25PQ	DT25PK
NK368...01	010.0004.0586	4,0	T10PL	DT10PK
NK368...02	010.0004.0620	4,0	T10PL	DT10PK

端面切槽

Face Grooving

刀夹的选择

选择适合加工的端面槽大径的刀夹

Cassette Selection

Select the cassette to suit the major diameter of the face groove to be cut.

稳定设置

刀具应该使用允许的最小悬伸以达到最大的稳定性.

Stable Setup

The tool should be set to give the minimum overhang to achieve maximum stability.

实践

当车端面槽时加工方向是由大径 \varnothing -向小径 \varnothing .

Working Practice

When turning to open up the face groove the cut should be taken from the major \varnothing towards the minor \varnothing .

刀具设置

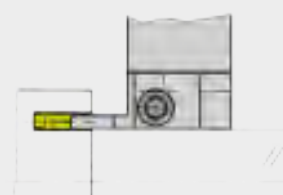
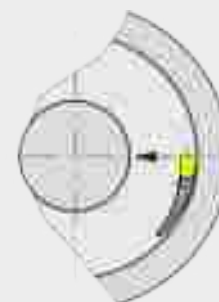
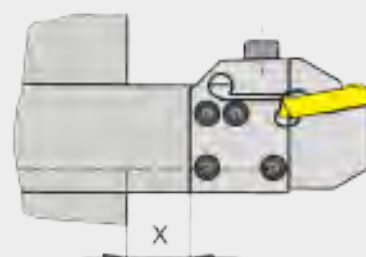
刀具应设定至中心高,确保正确的切削和支撑间隙.

Tool Setup

The tool should be set to centre height to ensure correct cutting and support clearance.

刀具必须平行于工件旋转轴.

The tool must be set parallel to the rotation axis of the workpiece.



您可以通过切槽样本找到合适的刀片和进一步信息.

You will find the right inserts and further information in our catalogue „GROOVING“.

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