



STECHSYSTEM 66T

EINSTECHEN MIT 6 SCHNEIDEN
BIS EINSTECHTIEFE 9,5 MM

GROOVING SYSTEM 66T

GROOVING WITH 6 CUTTING EDGES
UP TO 9.5 MM CUTTING DEPTH



DER UNTERSCHIED: MEHR MÖGLICHKEITEN

THE DIFFERENCE:
MORE POSSIBILITIES

- **Einsteckplatte mit 6 Schneiden**

Insert with 6 cutting edges

- **Einstehtiefe bis 9,5 mm**

Cutting depth up to 9.5 mm

- **Präziser Plattensitz für hohe
Wechselgenauigkeit**

Precise insert seat for high
indexing accuracy

- Alle Abmessungen sind in mm angegeben, sofern nicht anders vermerkt.
All dimensions in mm, unless otherwise noted.
- Weitere Abmessungen und Ausführungen sind auf Anfrage erhältlich.
Further dimensions and versions are available on request.
- Das Anzugsmoment der Schrauben finden Sie im Kapitel "Technische Hinweise".
For torque specification of the screw, please see "Technical Instructions".
- Lieferzeiten / delivery times
 - ▲ ab Lager / on stock
 - Δ 4 Wochen / 4 weeks
- Einsatz für Werkstoffgruppen / Use for material groups
 - empfohlen / recommended
 - o bedingt einsetzbar / alternative recommended
 - nicht geeignet / not suitable

Die HORN-Trennstellencodierung - wofür wird sie benötigt?

Die Trennstellencodierung stellt sicher, dass Sie immer die zueinander passenden Werkzeuge finden und wird bei Werkzeughaltern und bei Schneidplatten ausgewiesen. Wenn die Codes übereinstimmen, kann die Schneidplatte im entsprechenden Werkzeughalter verwendet werden.
Das gilt auch für unser modulares Haltersystem, hier gibt die Trennstellencodierung die Schnittstelle zwischen Grundhalter und Kassette an.

The HORN connection interface code - what is it needed for?

The connection interface code ensures that you will always find the appropriate tools and is shown on toolholders and inserts. If the codes match, the insert can be used in the corresponding toolholder.
This also applies to our modular holder system, where the connection code indicates the interface between the holder and the cassette.

HORN-Trennstellencodes und mögliche Kombinationen:

HORN connection interface codes and possible combinations:

HIS = Plattensitzgröße / Insert seat
HWS = Trennstelle Werkstückseitig / Interface workpiece side
HMS = Trennstelle Maschinenseitig / Interface machine side

HIS	↔	HWS
HMS	↔	HWS

Beispiel Schneidplatte

Example insert

Bestellnummer Part number	w	r	a ₁	s	HIS	EG55	IG65
S66T.0200.10	2	1	0,1	2,2	66T01N	▲	▲

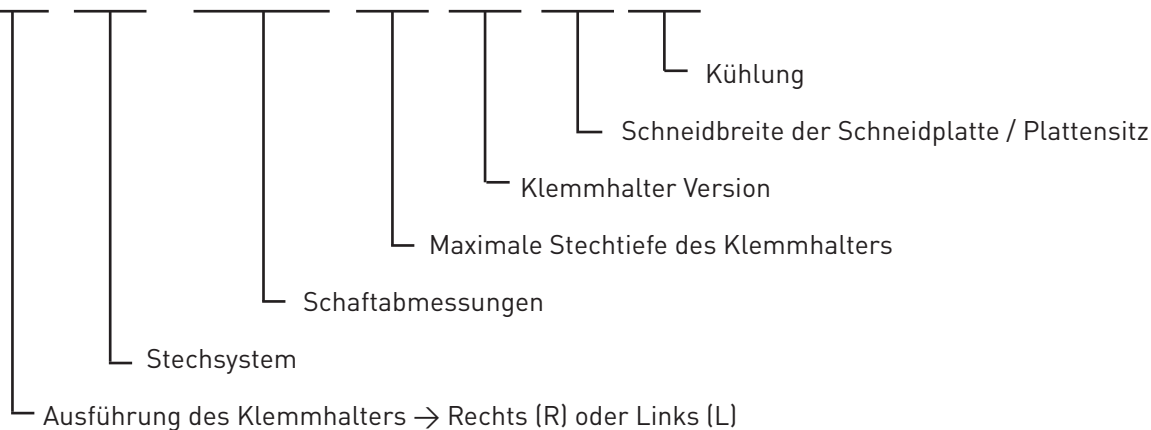
Beispiel Klemmhalter

Example toolholder

Bestellnummer Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	l ₄	HWS
RH66T.2020.08.10	20	20	125	25	32	20	17,8	f ₁ +w+a ₁	2,3	66T01N

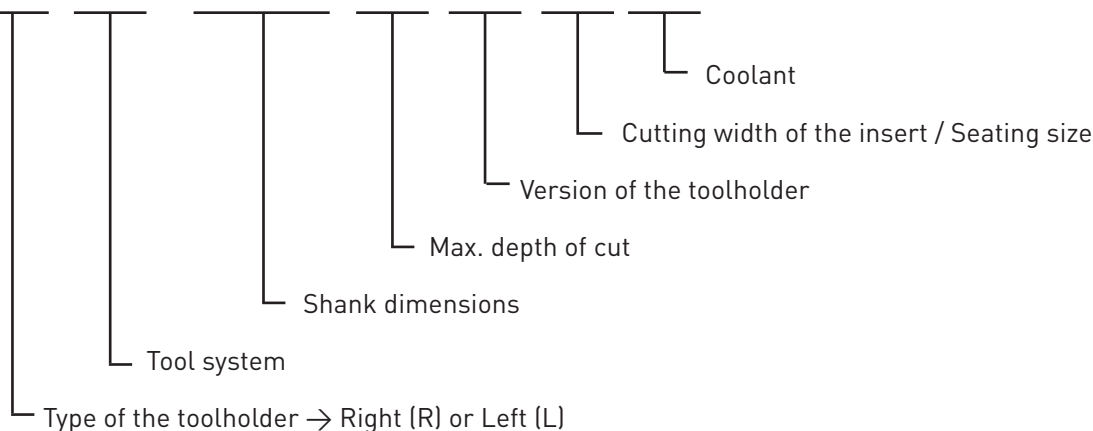
Nummernschlüssel der Klemmhalter:

RH66T.2020.08.0A.20.IK



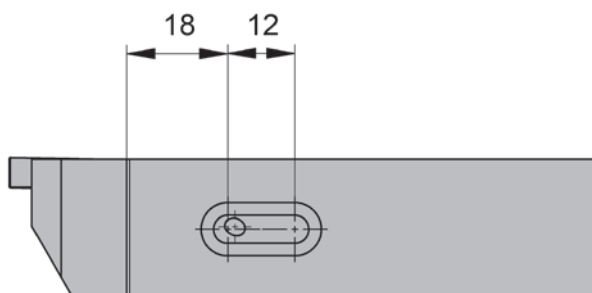
Number code of the toolholder:

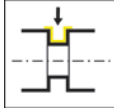
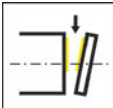
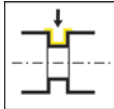
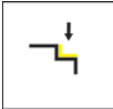
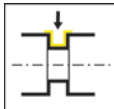
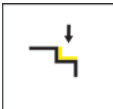
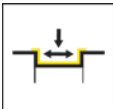
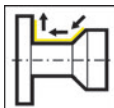
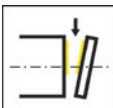
RH66T.2020.08.0A.20.IK

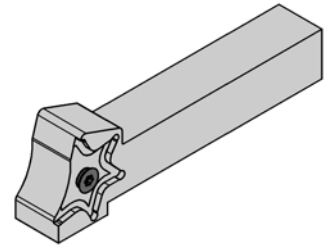
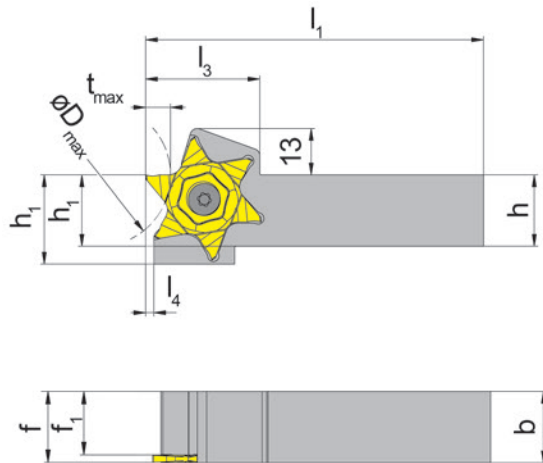
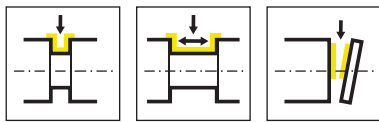


Position der Kühlmittelübergabe

Position of the coolant transfer



Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
	P M K N S H	↓ 0,02-0,12	    
	P M K N S H	↓ 0,03-0,12	    
	P M K N S H	↓ 0,05-0,15 ↔ 0,05-0,20	    



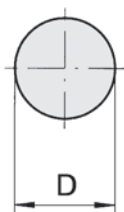
R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	l ₄	HWS
RH66T.2020.08.20	20	20	125	25	32	20	17,3	f ₁ +w+a ₁	2,3	66T02N
RH66T.2525.08.20	25	25	125	25	32	25	22,3	f ₁ +w+a ₁	2,3	66T02N
LH66T.2020.08.20	20	20	125	25	32	20	17,3	f ₁ +w+a ₁	2,3	66T02N
LH66T.2525.08.20	25	25	125	25	32	25	22,3	f ₁ +w+a ₁	2,3	66T02N

w siehe WSP
w see indexable inserts

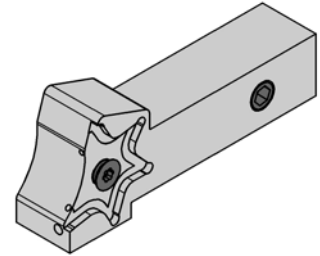
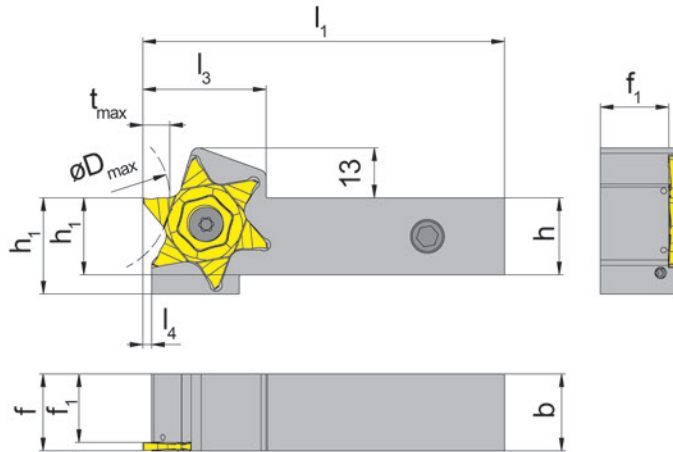
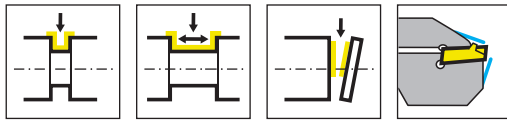
Ein- und Abstechen von Wellen
Grooving and parting off solid bars



Dmin	tmax
40	9,5
45	9,0
50	8,0
55	7,5
65	6,5
70	6,0
80	5,5
100	4,5

Ersatzteile
Spare Parts

Klemmhalter Toolholder	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
R/LH66T...	030.6014.T20P	T20PQ

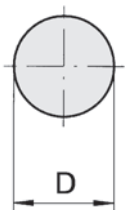


R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	h	b	l ₁	l ₂	l ₃	h ₁	f ₁	f	l ₄	HWS
RH66T.2020.08.0A.20.IK	20	20	94	25	32	20	17,3	f ₁ +w+a ₁	2,3	66T02N
RH66T.2525.08.0A.20.IK	25	25	109	25	32	25	22,3	f ₁ +w+a ₁	2,3	66T02N
LH66T.2020.08.0A.20.IK	20	20	94	25	32	20	17,3	f ₁ +w+a ₁	2,3	66T02N
LH66T.2525.08.0A.20.IK	25	25	109	25	32	25	22,3	f ₁ +w+a ₁	2,3	66T02N

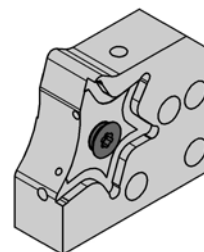
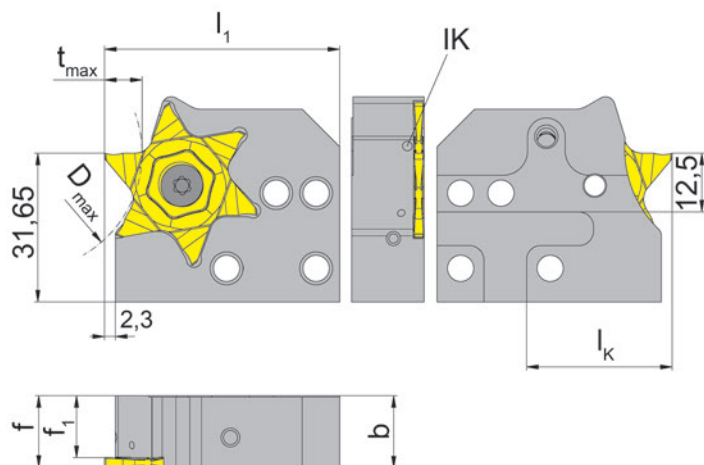
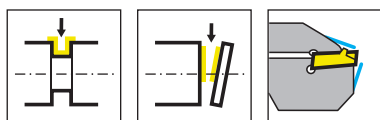
Ein- und Abstechen von Wellen
Grooving and parting off solid bars



Dmin	tmax
40	9,5
45	9,0
50	8,0
55	7,5
65	6,5
70	6,0
80	5,5
100	4,5

Ersatzteile
Spare Parts

Klemmhalter Toolholder	Kühlmittelanschluss Coolant supply	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
R/LH66T...	004.00.16	030.6014.T20P	T20PQ

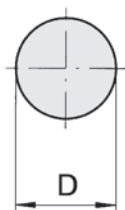


R = rechts wie gezeichnet
R = right hand version shown

L = links spiegelbildlich
L = left hand version

Bestellnummer Part number	t _{max}	b	f	f ₁	D _{max}	l ₁	l _k	HWS	HMS
RNK66T.0220.08.20.IK	9,5	15,4	f ₁ +w+a ₁	12,7	100	50	31	66T02N	220001
LNK66T.0220.08.20.IK	9,5	15,4	f ₁ +w+a ₁	12,7	100	50	31	66T02N	220002

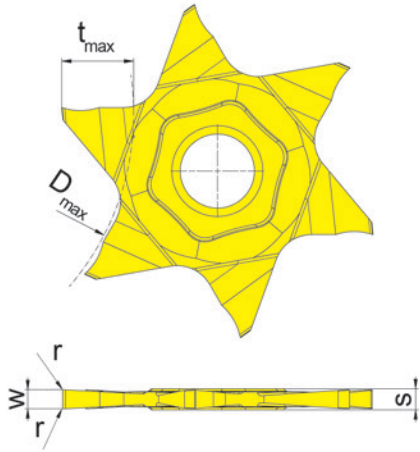
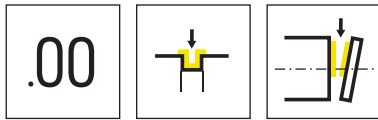
Ein- und Abstechen von Wellen
Grooving and parting off solid bars



Dmin	tmax
40	9,5
45	9,0
50	8,0
55	7,5
65	6,5
70	6,0
80	5,5
100	4,5

Ersatzteile
Spare Parts

Klemmhalter Toolholder	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
R/LNK66T...	030.6014.T20P	T20PQ

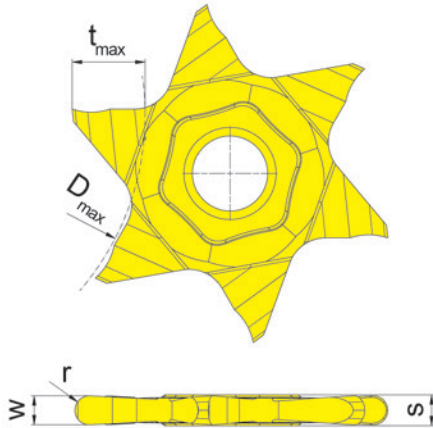
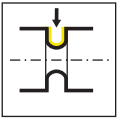


HM-Sorten
Carbide grades

▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	w	r	s	α	HIS		EG55	IG65
S66T.0250.00	2,5	-	2,7	0°	66T02N		▲	▲
S66T.0250.01	2,5	0,1	2,7	0°	66T02N		▲	▲
S66T.0300.00	3	-	3,2	0°	66T02N		▲	▲
S66T.0300.01	3	0,1	3,2	0°	66T02N		▲	▲
						P	●	●
						M	○	●
						K	○	-
						N	-	-
						S	-	○
						H	-	-

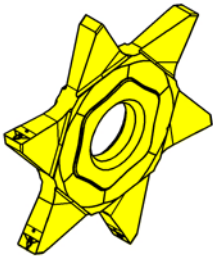
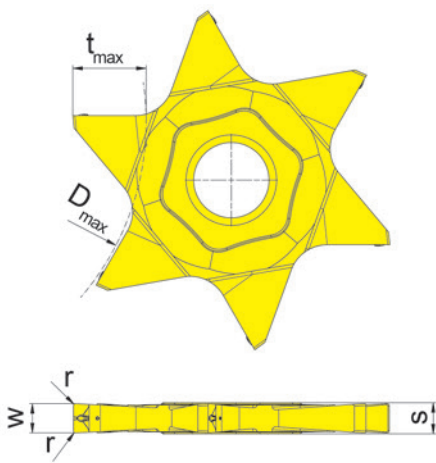
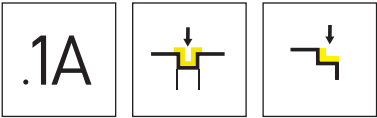


HM-Sorten
Carbide grades

▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	w	r	a _i	s	HIS		EG55	IG65
S66T.0250.12	2,5	1,25	0,1	2,7	66T02N		▲	▲
S66T.0300.15	3	1,5	0,1	3,2	66T02N		▲	▲
						P	●	●
						M	o	●
						K	o	-
						N	-	-
						S	-	o
						H	-	-

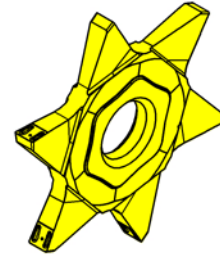
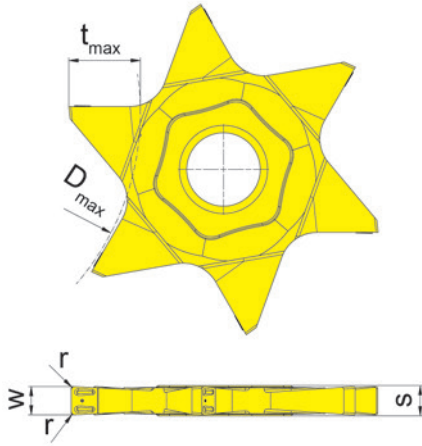
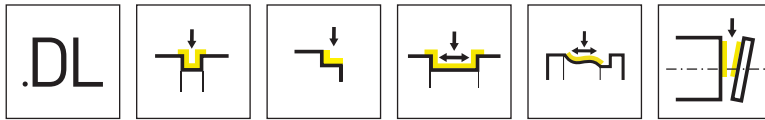


HM-Sorten
Carbide grades

▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	w	r	s	HIS	EG55	IG65
S66T.0250.1A2	2,5	0,2	2,7	66T02N	▲	▲
S66T.0300.1A2	3	0,2	3,2	66T02N	▲	▲
					P	●
					M	○
					K	○
					N	-
					S	-
					H	-



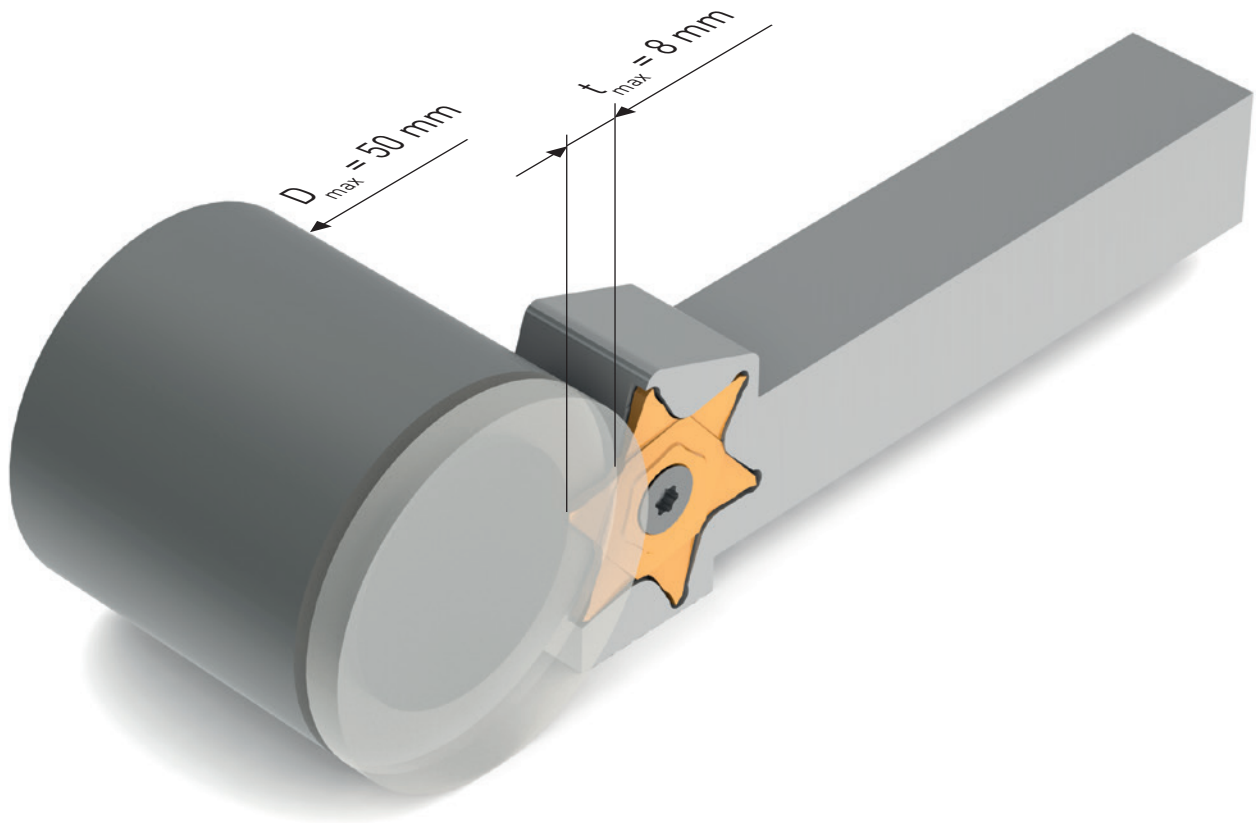
HM-Sorten
Carbide grades

▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	w	r	s	HIS		EG55	IG65
S66T.0250.DL2	2,5	0,2	2,7	66T02N	▲	▲	▲
S66T.0250.DL4	2,5	0,4	2,7	66T02N	▲	▲	▲
S66T.0300.DL2	3	0,2	3,2	66T02N	▲	▲	▲
S66T.0300.DL4	3	0,4	3,2	66T02N	▲	▲	▲
					P	●	●
					M	○	●
					K	○	-
					N	-	-
					S	-	○
					H	-	-

Abstehtiefe $t_{\max}$ in Abhängigkeit vom Werkstückdurchmesser $D_{\max}$
Cutting depth $t_{\max}$ in relation to workpiece diameter $D_{\max}$



$D_{\min}$	$t_{\max}$
40	9,5
45	9,0
50	8,0
55	7,5
65	6,5
70	6,0
80	5,5
100	4,5





**FINDEN SIE JETZT IHRE
PASSENDE WERKZEUGLÖSUNG.**

FIND YOUR RIGHT
TOOLING SOLUTION NOW.

horn-group.com

DEUTSCHLAND, STAMMSITZ

GERMANY, HEADQUARTERS

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