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**Six-edged inserts with a new grooving depth**

With the 66T grooving system, Horn is expanding its tool portfolio in the area of six-edged indexable inserts. With six cutting edges, the insert offers an attractive price per cutting edge. The maximum grooving depth is 9.5 mm (0.374"). This is around 4 mm (0.157") more than the sister system, 64T. Depending on the application, Horn offers inserts with two geometries and a version without geometry. The available geometries ensure reliable chip removal during machining. The IG65 carbide grade is used for machining stainless materials and difficult-to-cut materials. For general steels, Horn recommends the EG55 carbide grade for the 66T system.

The available cutting widths are 2.5 mm (0.098") and 3 mm (0.118"). The corner radius is 0.2 mm (0.008"). The 1A geometry is suitable for pure groove turning operations, while the DL geometry is suitable for longitudinal turning in addition to grooving. The DL geometry is therefore also available with a corner radius of 0.4 mm (0.016"). The effective chip control of the chip breaking geometries ensures high surface quality on the groove flanks and the straight main cutting edge produces a cleanly finished base. Designed as neutral grooving inserts, they can be clamped in square shanks with internal cooling on both the left and the right side. Holder dimensions are 20 x 20 mm (0.787 x 0.787") and 25 x 25 mm (0.984 x 0.984"). A clamping screw fixes the grooving insert precisely and securely in the central insert seat. Horn also offers type 220 clamping cassettes for the modular holder system.

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**photo caption:** Depending on the application, Horn offers inserts for the 66T grooving system with two geometries and a version without geometry.

Source: Horn/Sauermann

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Source: Horn/Sauermann

Contact person for enquiries:

Hartmetall-Werkzeugfabrik Paul Horn GmbH

Christian Thiele

Press Officer

Horn-Straße 1, 72072 Tübingen

Tel.: +49 7071 7004-1820, Fax: +49 7071 72893

Email: [Christian.Thiele@de.horn-group.com](mailto:Christian.Thiele@de.horn-group.com), [horn-group.com](http://www.horn-group.com)