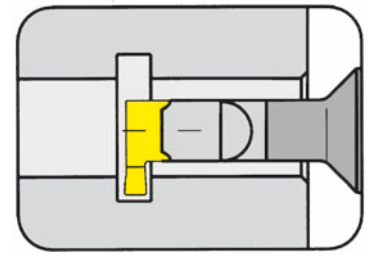


TOOLHOLDER Type

BU114

with through coolant supply

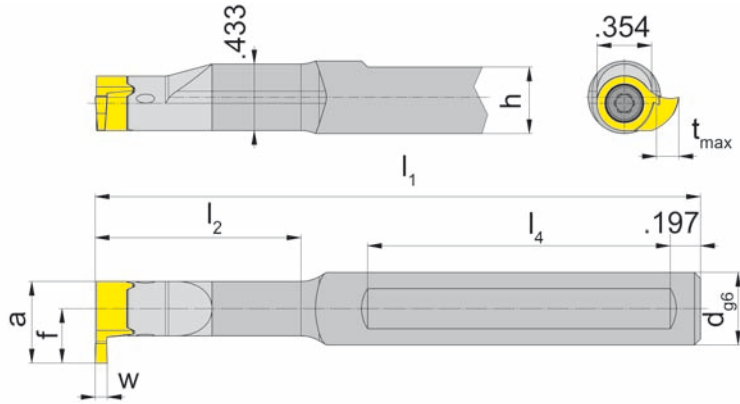


Bore Ø from	.551"
Depth of groove up to	.256"
Width of groove up to	.125"

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 114
S114
U114



Picture = right hand cutting version shown

Part number	d	l ₁	l ₂	h	l ₄	Remark
BU114.ST05.00	.500	2.953	.748	.460	1.570	* Steel toolholder
BU114.0500.01		3.937	1.338			
BU114.0500.02	.500	4.330	1.771	.460	1.970	
BU114.0500.03		5.118	2.520			
BU114.ST06.00	.625	3.150	.748	.585	1.570	* Steel toolholder
BU114.0625.01		3.937	1.338			
BU114.0625.02	.625	4.330	1.771	.585	1.970	
BU114.0625.03		5.118	2.520			

Further sizes upon request

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

Dimensions in inch

Note:

Toolholders can be used in right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

* Steel toolholder is not repairable.

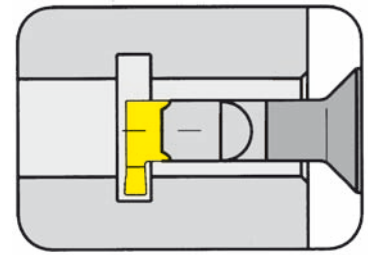
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
BU114....	4.12T15EP	T15PQ

TOOLHOLDER Type

B114

with through coolant supply

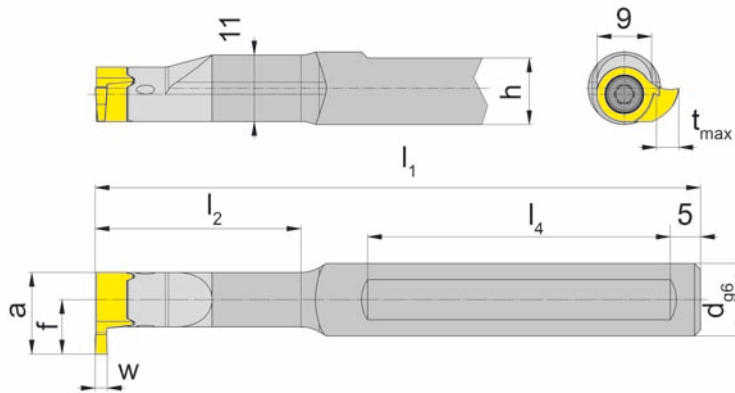


Bore Ø from	.551" (14.0 mm)
Depth of groove up to	.256" (6.5 mm)
Width of groove up to	.125" (3.18 mm)

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 114
S114
U114



Picture = right hand cutting version shown

Part number	d	l ₁	l ₂	h	l ₄
B114.0012.00	12	75	19.5	11	40
B114.0012.01		100	34.0		50
B114.0012.02		110	45.0		50
B114.0012.03		130	64.0		50
B114.0016.00	16	80	19.5	15	40
B114.0016.01		100	34.0		50
B114.0016.02		110	45.0		50
B114.0016.03		130	64.0		50

Further sizes upon request

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

Dimensions in mm

Ordering note:

Toolholders can be used in right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

Spare parts

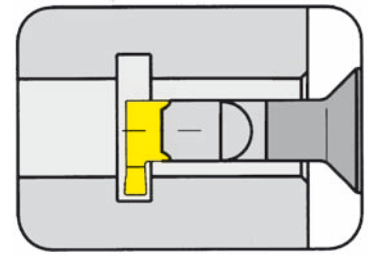
Toolholder	Screw	TORX PLUS® Wrench
B114.001...	4.12T15EP	T15PQ



TOOLHOLDER Type

B114

with through coolant supply

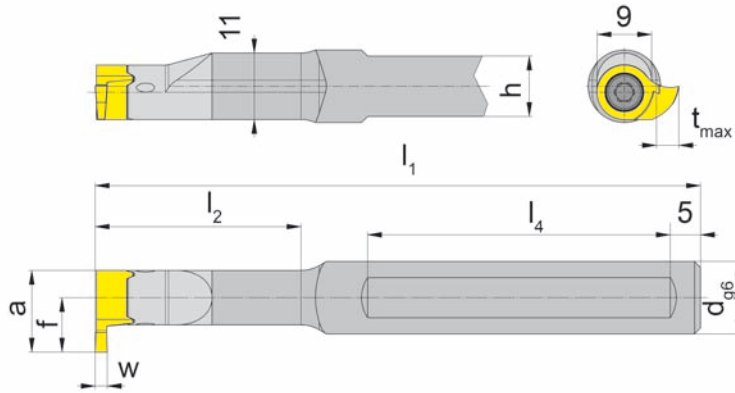


Bore Ø from	.551" (14.0 mm)
Depth of groove up to	.256" (6.5 mm)
Width of groove up to	.125" (3.18 mm)

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 114
S114
U114



Picture = right hand cutting version shown

with 2 clamping flats

Part number	d	l ₁	l ₂	h	l ₄
B114.0012.2.00	12	75	19.5	11	40
B114.0012.2.01		100	34.0		50
B114.0012.2.02		110	45.0		50
B114.0012.2.03		130	64.0		50
B114.0016.2.00	16	80	19.5	15	40
B114.0016.2.01		100	34.0		50
B114.0016.2.02		110	45.0		50
B114.0016.2.03		130	64.0		50

Further sizes upon request

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

Dimensions in mm

Ordering note:

Toolholders can be used in right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.

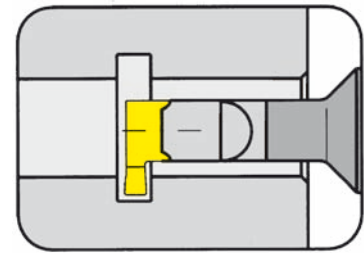
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B114.001...	4.12T15EP	T15PQ

TOOLHOLDER Type

B114

with through coolant supply

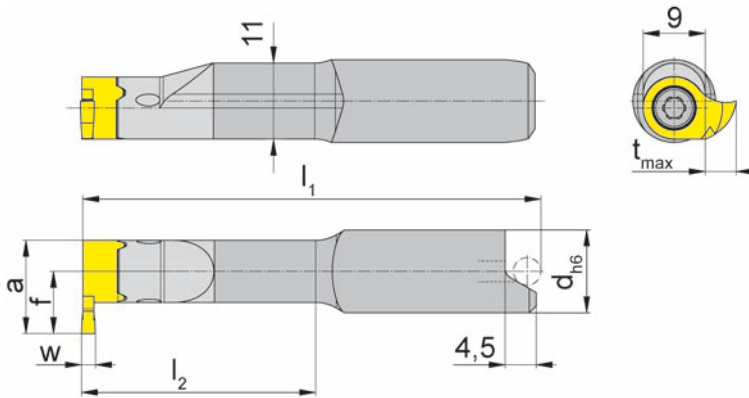


Bore Ø from	.551" (14.0 mm)
Depth of groove up to	.256" (6.5 mm)
Width of groove up to	.125" (3.18 mm)

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 114
S114
U114



Picture = right hand cutting version shown

for shrinkage location
S = orientation



Part number	d	l ₁	l ₂
B114.0012.00S	12	52.7	19.5
B114.0012.01S		66.7	34.0
B114.0012.02S		77.7	45.0
B114.0012.03S		96.7	64.0

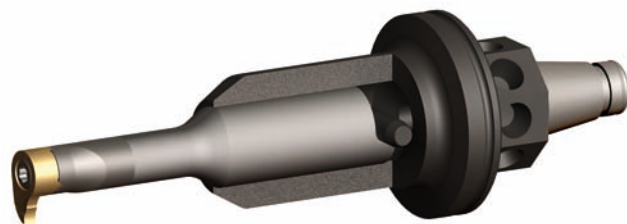
Further sizes upon request

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

Dimensions in mm

Ordering note:

Toolholders can be used in right and left hand inserts.
Toolholders with damaged seating can be repaired by HORN.



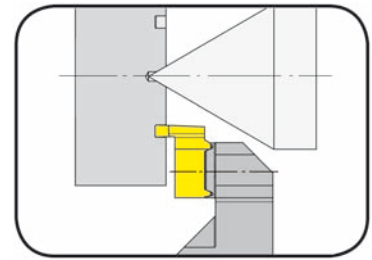
Example of assembly System „W&F“

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B114.0012.0...	4.12T15EP	T15PQ

TOOLHOLDER Type

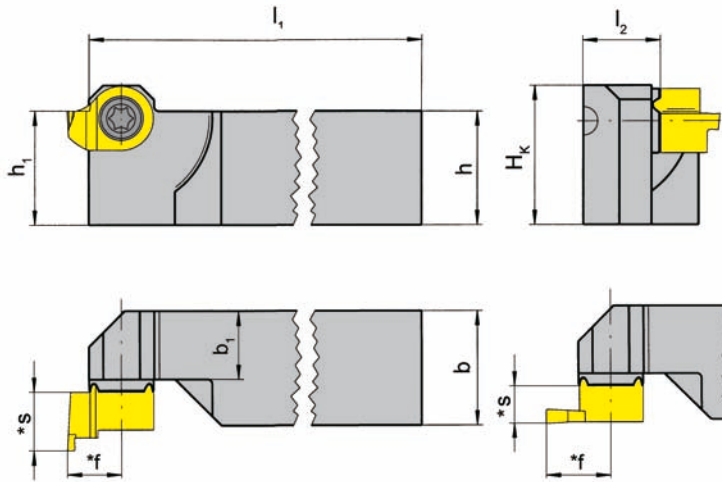
HCU114



from outer groove \varnothing .472"
 Depth of groove up to .236"
 Width of groove up to .125"

for use with Insert

Type 114
 S114
 U114



R = right hand version shown

L = left hand version

axial and radial

Part number	h	h ₁	l ₁	l ₂	b	b ₁	H _k
R/LHCU114.0500.01	.500	.500	3.819	.441	.500	.374	.642
R/LHCU114.0625.01	.625	.625	4.803	.441	.625	.374	.768
R/LHCU114.0750.01	.750	.750	4.803	.559	.750	.492	.894
R/LHCU114.1000.01	1.000	1.000	5.787	.815	1.000	.728	1.142

Further sizes upon request

* see inserts

Dimensions in inch

State R or L version

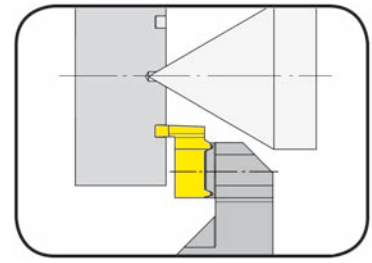
Right hand toolholders use left hand inserts.
 Left hand toolholders use right hand inserts.

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHCU114....	4.12T15EP	T15PQ

TOOLHOLDER Type

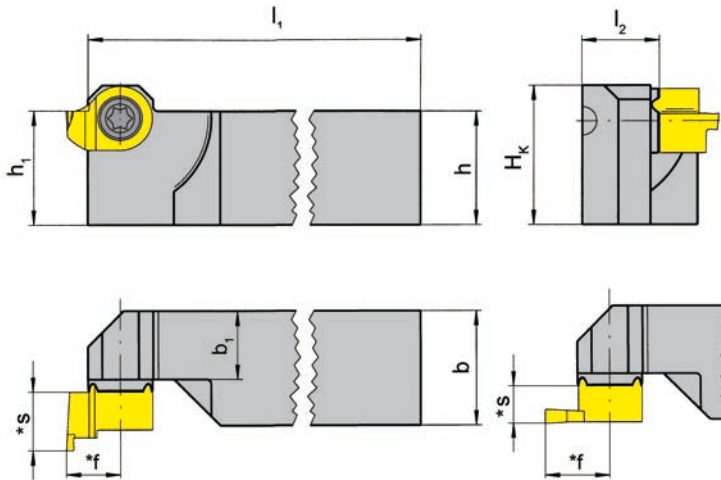
HC114



from outer groove \varnothing .472" (12.0 mm)
 Depth of groove up to .236" (6.0 mm)
 Width of groove up to .125" (3.18 mm)

for use with Insert

Type 114
 S114
 U114



R = right hand version shown

L = left hand version

axial and radial



Part number	h	h ₁	l ₁	l ₂	b	b ₁	H _k
R/LHC114.1212.01	12	12	122	11.2	12	9.5	15.6
R/LHC114.1616.01	16	16	122	11.2	16	9.5	19.6
R/LHC114.2020.01	20	20	122	15.2	20	13.5	23.6
R/LHC114.2525.01	25	25	147	20.2	25	18.5	28.6

Further sizes upon request

* see inserts

Dimensions in mm

State R or L version

Right hand toolholders use left hand inserts.
 Left hand toolholders use right hand inserts.

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHC114....	4.12T15EP	T15PQ

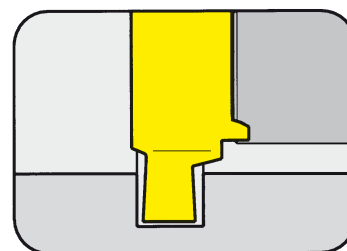
GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

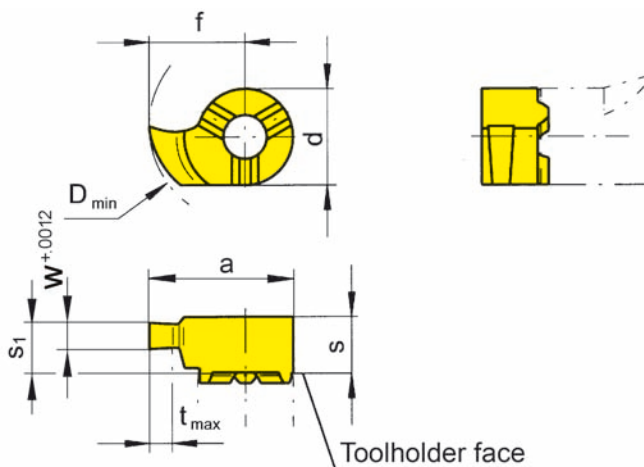
U114

Bore Ø from	.551"
Depth of groove up to	.059"
Width of groove	.031 - .039"



for use with Toolholder

Type B114
BU114



R = right hand version

L = left hand version

not face cutting,
limited depth of cut

Part number	w	s ₁	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/LU114.0031.00	.031	.209	.217	.354	.531	.354	.047	.551		▲/▲				
R/LU114.0039.00	.039	.209	.217	.354	.531	.354	.059	.551		▲/▲				
									P	•				
									M	•				
									K	•				
									S	•				
									N	•				
									H					

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

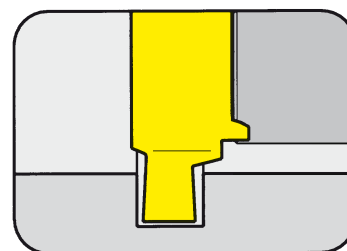
Depth of groove $t_{max} = .059'' \times w$

GROOVING (internal) $\geq \text{Ø} .551''$



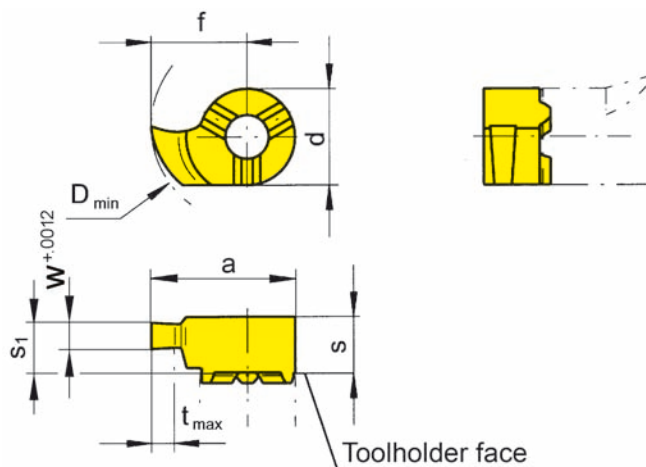
INSERT Type

114



Bore Ø from	.551"
Depth of groove up to	.059"
Width of circlip Nw	.028 - .035"

Widths for circlip grooves DIN 471/472



for use with Toolholder

Type B114
BU114

R = right hand version shown

L = left hand version

not face cutting,
limited depth of cut



Part number	Nw	w	s ₁	s	f	a	d	t _{max}	D _{min}	Carbide grades				
										MG12	TN35	TI25	TF45	TH35
R/L114.0070.00	.028	.029						.047	.551		▲/▲			
R/L114.0080.00	.031	.033	.209	.217	.354	.531	.354	.051	.551		▲/▲			
R/L114.0090.00	.035	.037						.059	.551		▲/▲			
											●			
											●			
											○			
											■			
											■			
											■			
											■			

- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

Depth of groove t_{max} = .059" x w

Carbide grades

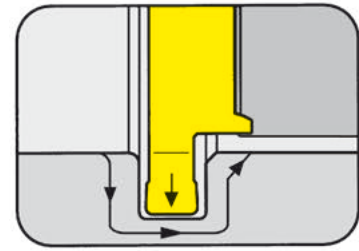
NC-PROFILING (internal) $\geq \text{Ø } .551''$



INSERT Type

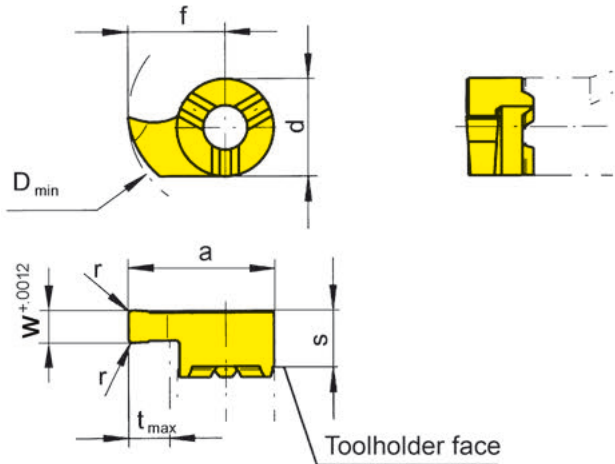
U114

Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.031 - .125"



for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

with corner radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/LU114.0031.08	.031									▲/▲		▲/	
R/LU114.0046.08	.046									▲/▲		▲/	
R/LU114.0062.08	.062	.008	.209	.354	.531	.354	.157	.551		▲/▲		▲/	
R/LU114.0078.08	.078									▲/▲		▲/	
R/LU114.0094.08	.094									▲/▲		▲/	
R/LU114.0125.08	.125								▲/	▲/▲	▲/		
R/LU114.0046.16	.046									▲/			
R/LU114.0062.16	.062									▲/			
R/LU114.0078.16	.078	.016	.209	.354	.531	.354	.157	.551		▲/▲			
R/LU114.0094.16	.094								▲/	▲/▲			
R/LU114.0125.16	.125									▲/▲			

- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

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

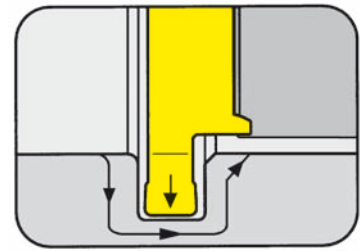
Carbide grades

NC-PROFILING (internal) $\geq \text{Ø} .551''$



INSERT Type

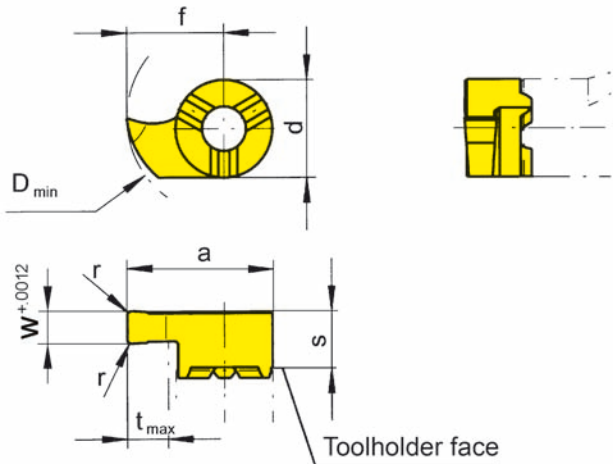
114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.079"

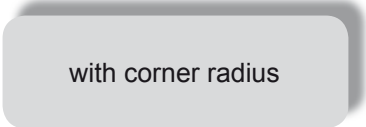
for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version



Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L114.0200.02	.079	.008	.209	.354	.531	.354	.157	.551	▲/▲	▲/▲	▲/▲		
▲ on stock Δ 4 weeks									P	o	•	•	
• main recommendation									M	•	•	•	
o alternative recommendation									K	•	•	•	
□ uncoated grades									S	•	•	•	
■ coated grades									N	•	•	•	
■ brazed/Cermet									H				

Dimensions in inch

State R or L version

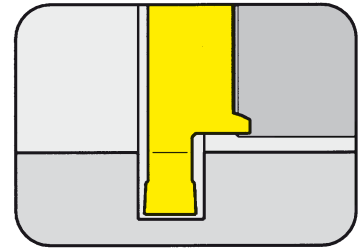
Carbide grades

GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

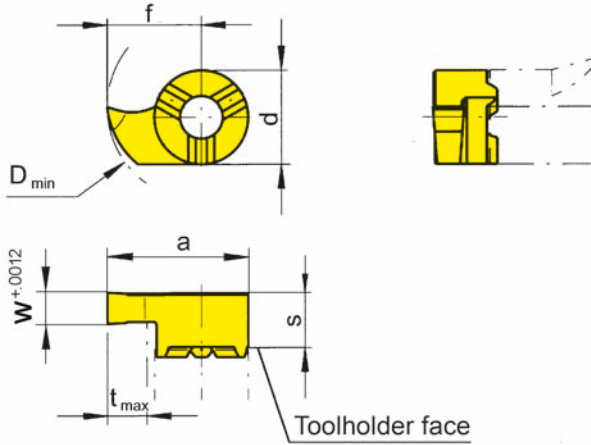
U114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.046 - .125"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	w	s	f	a	d	t _{max}	D _{min}	Carbide grades						
								MG12	TN35	TI25	TF45	TH35		
R/LU114.0046.00	.046								▲/▲					
R/LU114.0056.00	.056								/▲	▲/		Δ/		
R/LU114.0062.00	.062								/Δ	▲/▲	Δ/			
R/LU114.0078.00	.078	.209	.354	.531	.354	.157	.551		Δ/Δ	▲/▲				
R/LU114.0094.00	.094								▲/	▲/▲		▲/		
R/LU114.0125.00	.125									▲/▲				
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet								P	○	●	●	●	●	
								M	●	●	●	●	●	
								K	●	●	●	●	●	
								S	●	●	●	●	●	
								N	●	●	●	●	●	
								H						

Dimensions in inch

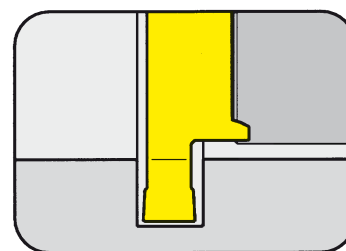
State R or L version

GROOVING (internal) $\geq \text{Ø} .551''$



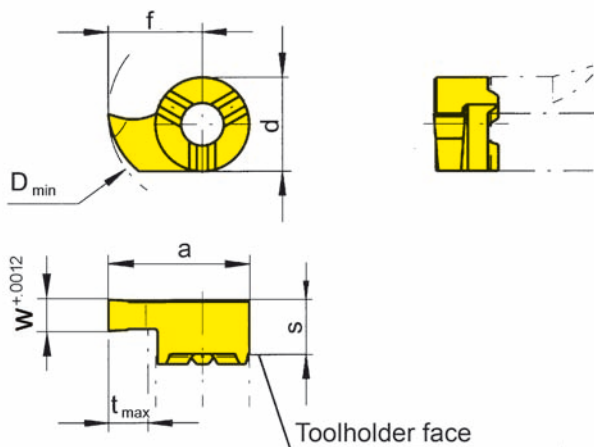
INSERT Type

114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of circlip Nw	.043 - .063"

Widths for circlip grooves DIN 471/472



for use with Toolholder

Type B114
BU114

R = right hand version shown

L = left hand version

Part number	Nw	w	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L114.0110.00	.043	.047								▲/▲			▲/▲
R/L114.0130.00	.051	.055	.209	.354	.531	.354	.157	.551		▲/▲			▲/▲
R/L114.0160.00	.063	.067								▲/▲			▲/▲
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet										P	●		●
										M	●		●
										K	●		●
										S	●		●
										N	●		●
										H			

Dimensions in inch

Carbide grades

State R or L version

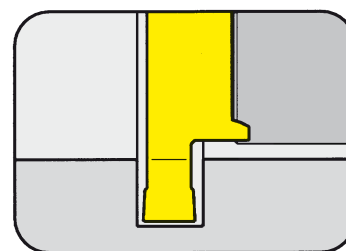


GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

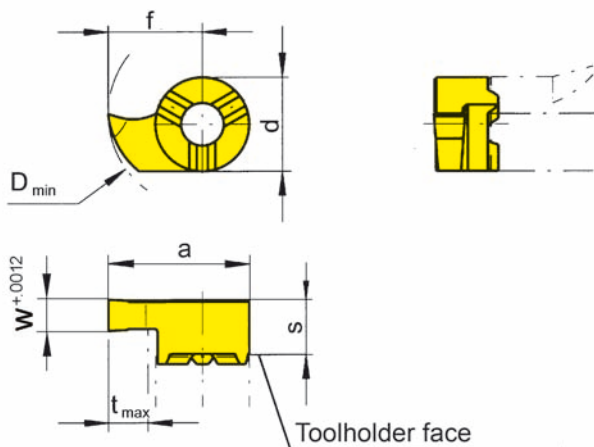
114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.059 - .118"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	w	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L114.0150.00	.059							▲/▲	▲/▲			▲/▲
R/L114.0200.00	.079							▲/▲	▲/▲			▲/▲
R/L114.0250.00	.098	.209	.354	.531	.354	.157	.551	▲/▲	▲/▲			▲/▲
R/L114.0300.00	.118							▲/▲	▲/▲			▲/▲

- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation

- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

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

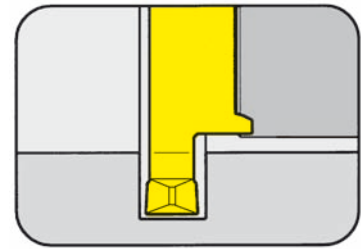
Carbide grades

GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

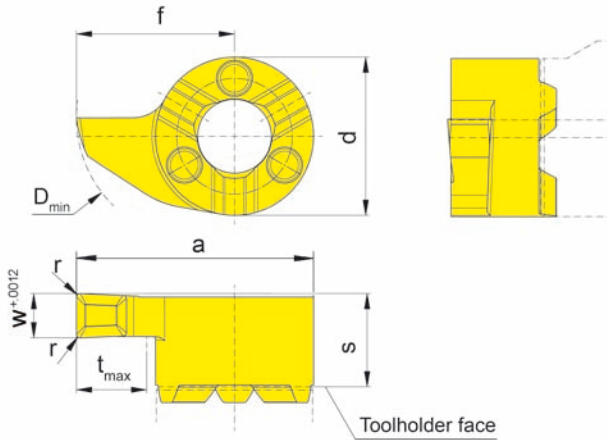
S114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.079"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version



Part number	w	r	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
RS114.0200.D2	.079	.008	.209	.354	.531	.354	.157	.551		▲		▲	▲
									P	•	•	•	•
									M	•	•	•	•
									K	•	•	•	•
									S	•	•	•	•
									N	•	•	•	•
									H				

Carbide grades

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

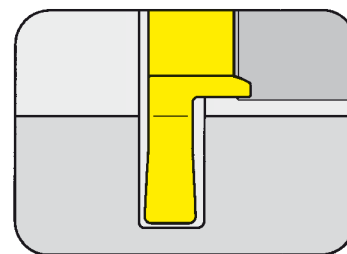
State R or L version

GROOVING (internal) $\geq \text{Ø} .650''$



INSERT Type

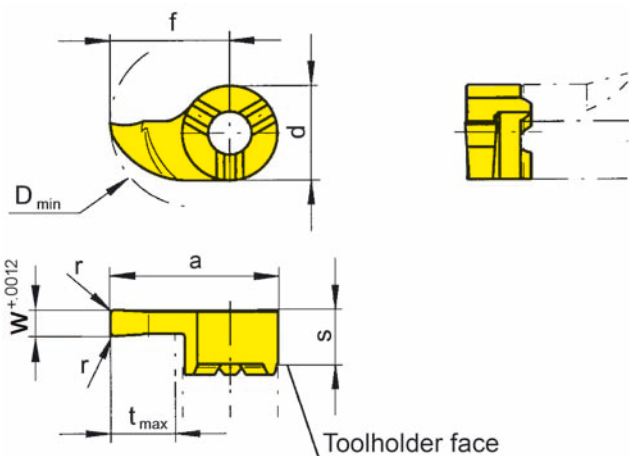
U114



Bore Ø from	.650"
Depth of groove up to	.256"
Width of groove	.062 - .125"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/LU114.0062.1.08	.062									▲/▲				
R/LU114.0078.1.08	.078									▲/▲				
R/LU114.0094.1.08	.094	.008	.209	.445	.622	.354	.256	.650		▲/▲				
R/LU114.0125.1.08	.125									▲/▲				
										P	o	•		
										M	•	•		
										K	•	•		
										S	•	•		
										N	•	•		
										H				

▲ on stock Δ 4 weeks

• main recommendation

o alternative recommendation

□ uncoated grades

■ coated grades

■ brazed/Cermet

Dimensions in inch

State R or L version

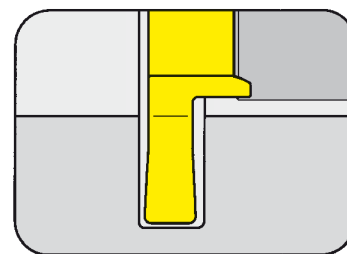
Carbide grades

GROOVING (internal) $\geq \text{Ø} .650''$



INSERT Type

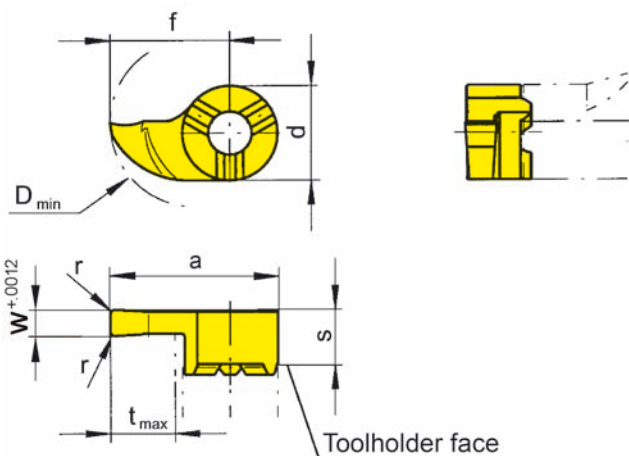
114



Bore Ø from	.650"
Depth of groove up to	.256"
Width of groove	.059 - .118"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L114.0150.1.02	.059									▲/▲			▲/▲
R/L114.0200.1.02	.079									▲/▲	▲/▲		▲/▲
R/L114.0250.1.02	.098	.008	.209	.445	.622	.354	.256	.650		▲/▲	▲/▲		▲/▲
R/L114.0300.1.02	.118									▲/▲			▲/▲
									P	•	•	•	•
									M	•	•	•	•
									K	•	•	•	•
									S	•	•	•	•
									N	•	•	•	•
									H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch
State R or L version

Carbide grades

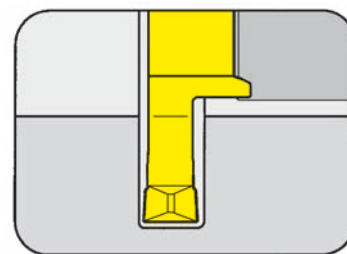


GROOVING (internal) $\geq \text{Ø} .650''$



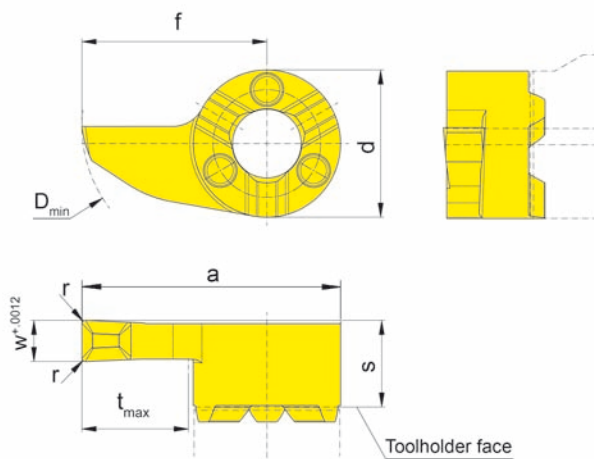
INSERT Type

S114



for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Geometry .D

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/LS114.0200.1.D2	.079												▲▲
R/LS114.0250.1.D2	.098	.008	.209	.445	.622	.354	.256	.650					▲▲
R/LS114.0300.1.D2	.118												▲▲
									P				•
									M				•
									K				•
									S				•
									N				•
									H				•

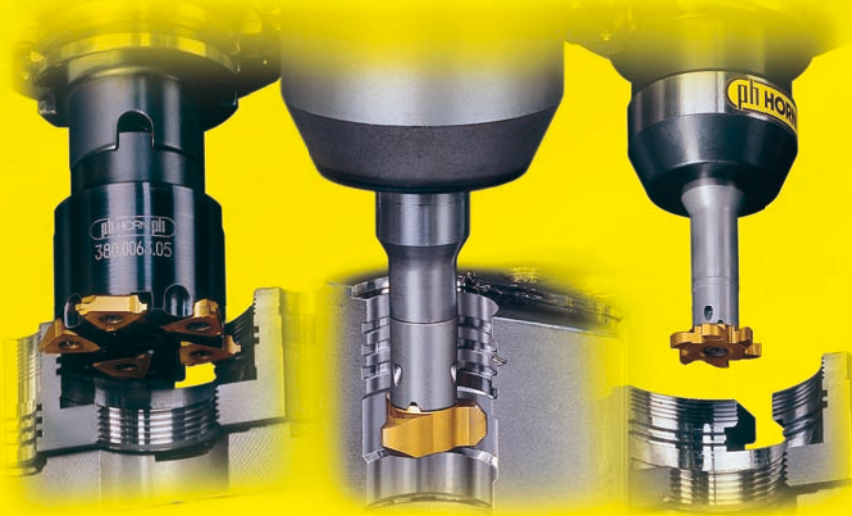
- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

Carbide grades

HORN - THE LEADERS IN GROOVING TECHNOLOGY



G

SETTING THE STANDARD

GROOVE MILLING

HORN groove milling sets the standard.
For productivity, nothing else come close.

HORN - INTELLIGENT TOOL DESIGN AT WORK.



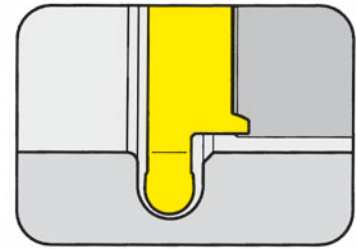
For further information please see HORN catalog "CARBIDE MILLING TOOLS".

GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

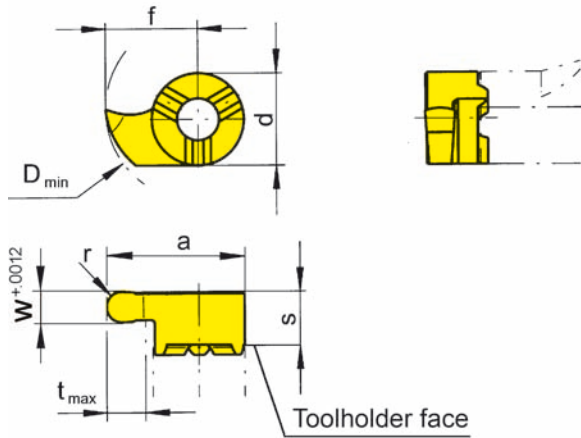
U114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.062 - .125"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Full radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/LU114.0031.62	.062	.031								▲/▲		▲		
R/LU114.0039.78	.078	.039								▲/▲		▲		
R/LU114.0047.94	.094	.047	.209	.354	.531	.354	.157	.551		▲/▲		▲		
R/LU114.0062.12	.125	.062								▲/▲		▲		
										P	•		•	
										M	•		•	
										K	•		•	
										S	•		•	
										N	•		•	
										H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch
State R or L version

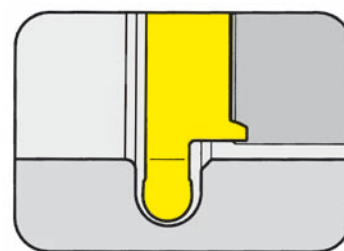
Carbide grades

GROOVING (internal) $\geq \text{Ø} .551''$



INSERT Type

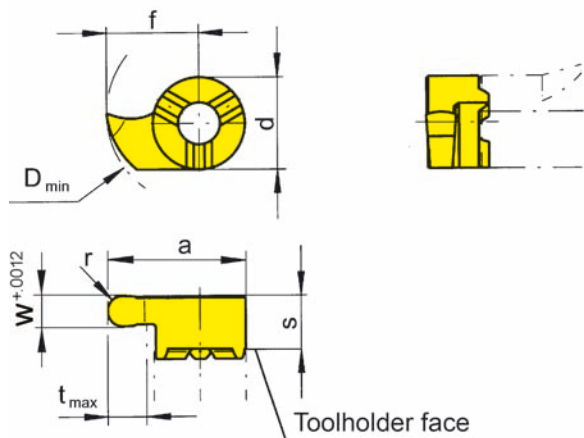
114



Bore Ø from	.551"
Depth of groove up to	.157"
Width of groove	.047 - .118"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Full radius



Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L114.0006.12	.047	.024								▲/▲			▲/▲
R/L114.0009.18	.071	.035								▲/▲			▲/▲
R/L114.0010.20	.079	.039	.209	.354	.531	.354	.157	.551		▲/▲			▲/▲
R/L114.0011.22	.087	.043								▲/▲			▲/▲
R/L114.0015.30	.118	.059								▲/▲			▲/▲
									P	•			•
									M	•			•
									K	•			•
									S	•			•
									N	•			•
									H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

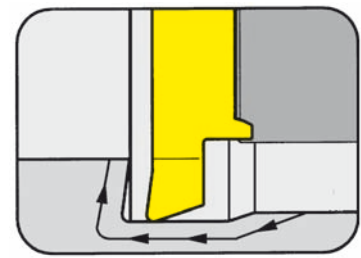
Dimensions in inch

State R or L version

Carbide grades

INSERT Type

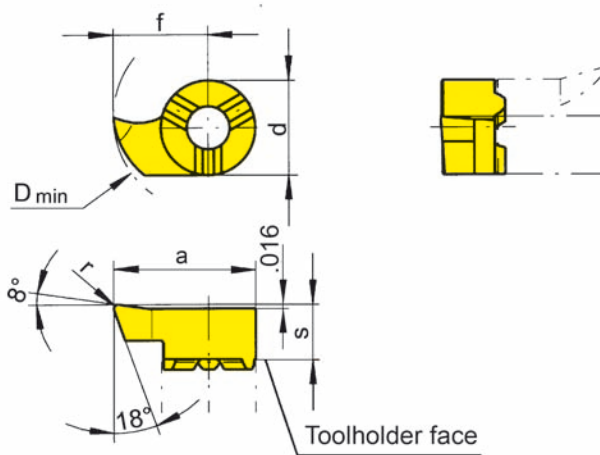
114



Bore Ø from $.543''$
 Depth of undercut up to $.051''$

for use with Toolholder

Type B114
 BU114



R = right hand version shown

L = left hand version

Part number	r	s	f	a	d	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L114.1890.02	.008	.209	.343	.520	.354	.543	▲/▲	▲/▲			▲/▲
▲ on stock Δ 4 weeks							P	o	•		•
• main recommendation							M	•	•		•
o alternative recommendation							K	•	•		•
■ uncoated grades							S	•	•		•
■ coated grades							N	•	•		•
■ brazed/Cermet							H				

Carbide grades

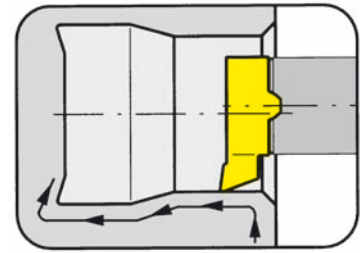
Dimensions in inch

State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .543''$ and profiling of reliefs as per DIN 509 form E and .

INSERT Type

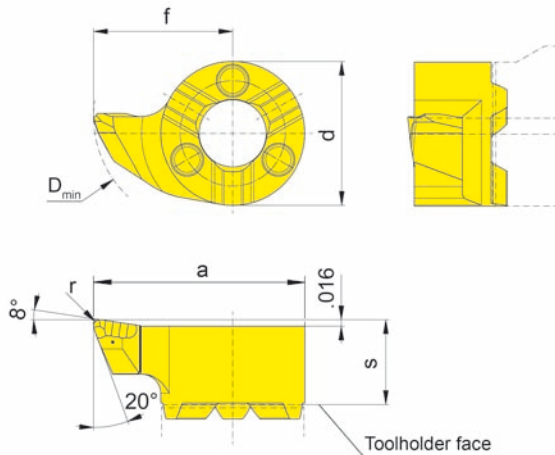
S114



Bore Ø from .543''
 Depth of undercut up to .051''

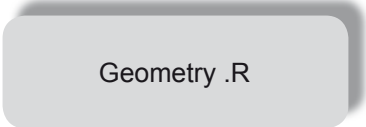
for use with Toolholder

Type B114
 BU114



R = right hand version shown

L = left hand version



Part number	r	s	f	a	d	D _{min}	Carbide grades				
							MG12	TN35	TI25	TF45	TH35
LS114.1890.R2	.008										▲
RS114.1890.R2	.008					.543					▲
LS114.1890.R4	.016	.209	.343	.520	.354						▲
RS114.1890.R4	.016										▲
							P				•
							M				•
							K				•
							S				•
							N				•
							H				•

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

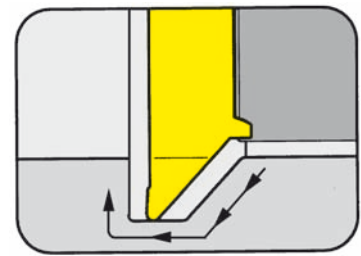
Dimensions in mm

State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .543''$ and profiling of reliefs as per DIN 509 form E and F.

INSERT Type

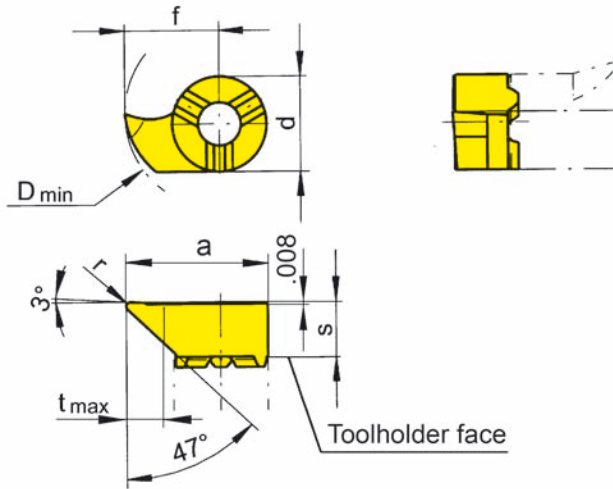
114



Bore Ø from .543''

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L114.4787.02	.008	.209	.343	.520	.354	.118	.543		▲/▲			▲/▲
R/L114.4787.04	.016	.209	.343	.520	.354	.118	.543		▲/▲			▲/▲
R/L114.4710.02	.008	.209	.433	.610	.354	.197	.630		▲/▲			▲/▲
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet								P	●			●
								M	●			●
								K	●			●
								S	●			●
								N	●			●
								H				

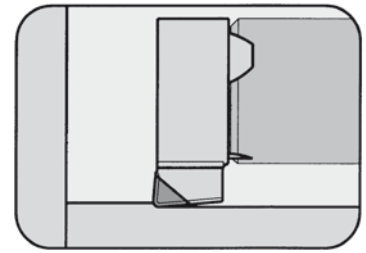
Dimensions in inch

State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .543''$ and profiling of reliefs as per DIN 509 form E and .

INSERT Type

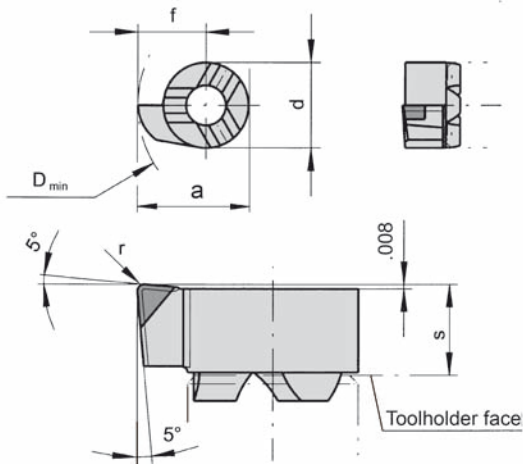
114



for use with Toolholder

Type B114

Bore Ø from .492"



R = right hand version shown

CBN tipped



Part number	r	s	f	a	d	D _{min}		CB10
R114.0572.04.B	.016	.209	.285	.463	.354	.492		▲
								P
								M
								K
								S
								N
								H •

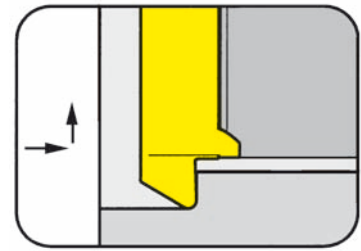
- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

Carbide grades

INSERT Type

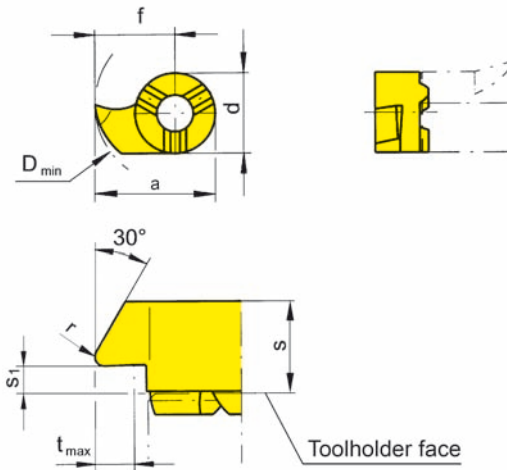
114



Bore Ø from .543"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Part number	r	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L114.3090.02	.008	.094	.217	.343	.520	.354	.138	.543		▲/▲			▲/▲
▲ on stock Δ 4 weeks									P	•	•	•	•
• main recommendation									M	•	•	•	•
o alternative recommendation									K	•	•	•	•
■ uncoated grades									S	•	•	•	•
■ coated grades									N	•	•	•	•
■ brazed/Cermet									H	•	•	•	•

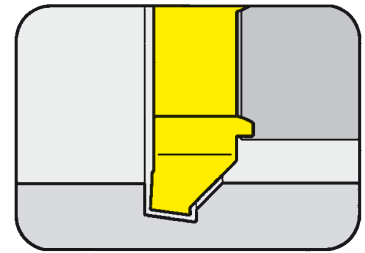
Carbide grades

Dimensions in inch

State R or L version

INSERT Type

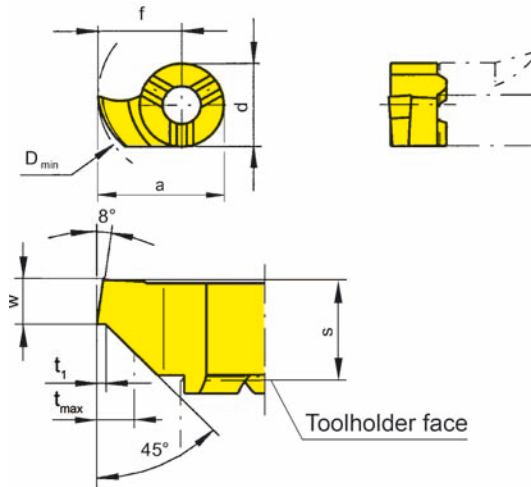
114



Bore Ø from .551"

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version



Part number	w	s	f	a	d	t ₁	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L114.0815.45	.059	.209	.354	.531	.354	.008	.059	.551	▲/▲		▲/▲		
									P	○	●		
									M	●	●		
									K	●	●		
									S	●	●		
									N	●	●		
									H				

Carbide grades

- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

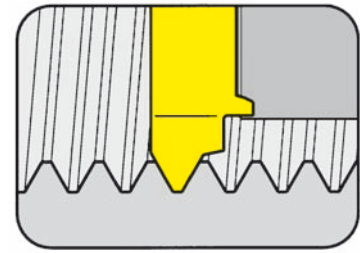
State R or L version

THREADING (internal) Partial profile



INSERT Type

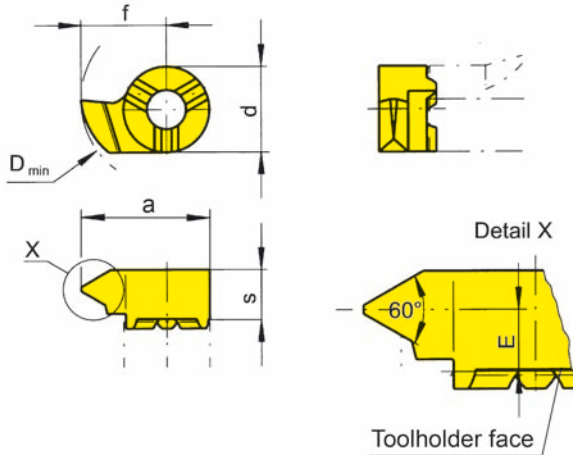
114



Bore Ø from Pitch .551" (14.0 mm)
2.0 - 2.5 mm

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Metric ISO standard thread

Part number	P	E	s	f	a	d	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L114.1020.01	2.0	4.2	5.5	9	13.5	9	14		▲/▲			▲/▲
R/L114.1325.01	2.5							▲/Δ		▲/▲		
								P	•	•	•	•
								M	•	•	•	•
								K	•	•	•	•
								S	•	•	•	•
								N	•	•	•	•
								H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

State R or L version

Carbide grades

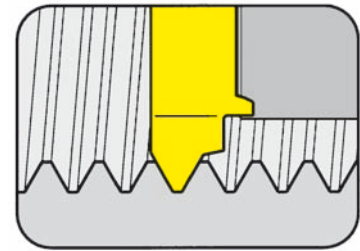


THREADING (internal) Partial profile



INSERT Type

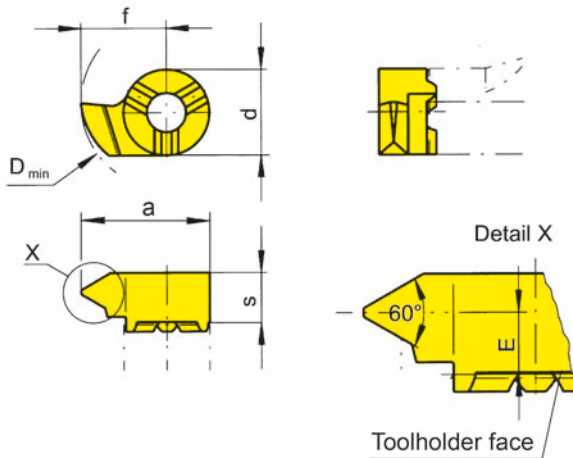
114



Bore Ø from Pitch .551" (14.0 mm)
0.5 - 1.5 mm

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Metric ISO fine thread



Part number	P	P _{max}	E	s	f	a	d	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/L114.0205.01	0.5	0.75	4.8							▲/▲				▲/▲
R/L114.0510.01	1.0	1.25	4.7	5.5	9	13.5	9	14		▲/▲				▲/▲
R/L114.0815.01	1.5	1.75	4.5							▲/▲				▲/▲
										P	•			•
										M	•			•
										K	•			•
										S	•			•
										N	•			•
										H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

State R or L version

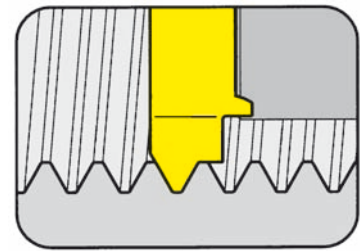
Carbide grades

THREADING (internal) Full profile



INSERT Type

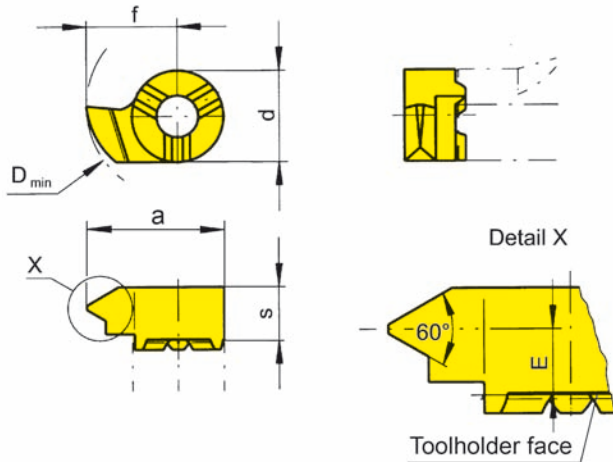
114



Bore Ø from Pitch .551" (14.0 mm)
2.0 - 2.5 mm

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Metric ISO standard thread

Part number	P	E	s	f	a	d	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L114.1020.02	2.0	4.2	5.5	9	13.5	9	14		▲/▲			
R/L114.1325.02	2.5							▲/▲				
								P	•			
								M	•			
								K	•			
								S	•			
								N	•			
								H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

State R or L version

Carbide grades

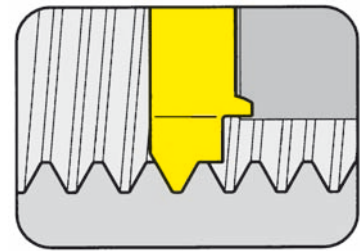


THREADING (internal) Full profile



INSERT Type

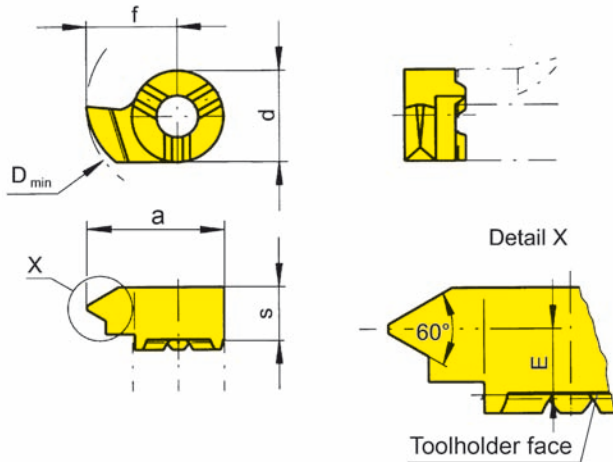
114



Bore Ø from Pitch .551" (14.0 mm)
1.0 - 1.5 mm

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Metric ISO fine thread



Part number	P	E	s	f	a	d	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L114.0510.02	1.0	4.7	5.5	9	13.5	9	14		▲/▲			
R/L114.0815.02	1.5	4.5	5.5	9	13.5	9	14		▲/▲			
								P	•			
								M	•			
								K	•			
								S	•			
								N	•			
								H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

State R or L version

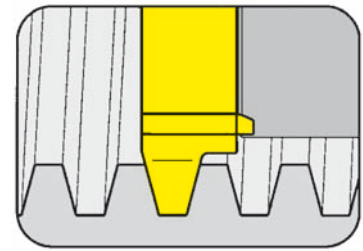
Carbide grades

THREADING (internal) Partial profile



INSERT Type

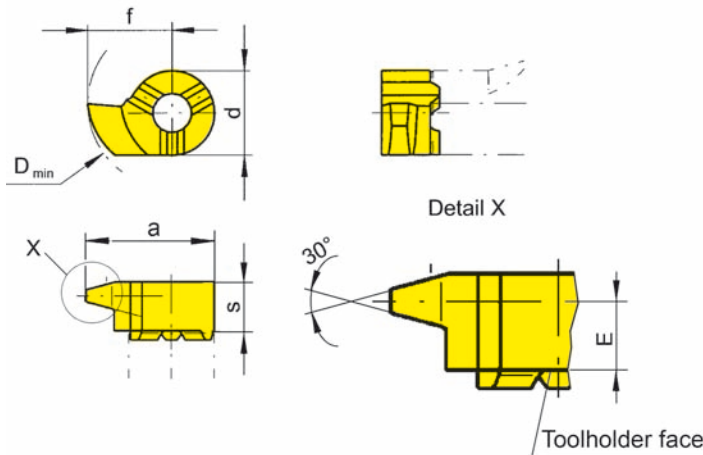
114



Bore Ø from Pitch .551" (14.0 mm)
4.0 - 5.0 mm

for use with Toolholder

Type B114
BU114



R = right hand version shown

L = left hand version

Metric ISO trapezoidal thread DIN 103

Part number	P	E	s	f	a	d	D _{min}	Carbide grades					
								MG12	TN35	TI25	TF45	TH35	
R/L114.2240.01	4	4.00	5.5	9	13.5	9	14		▲/▲				
R/L114.2750.01	5	3.55	5.5	9	13.5	9	14		▲/▲				
								●					
								○					
								■					
								■					
								■					
								■					
								■					

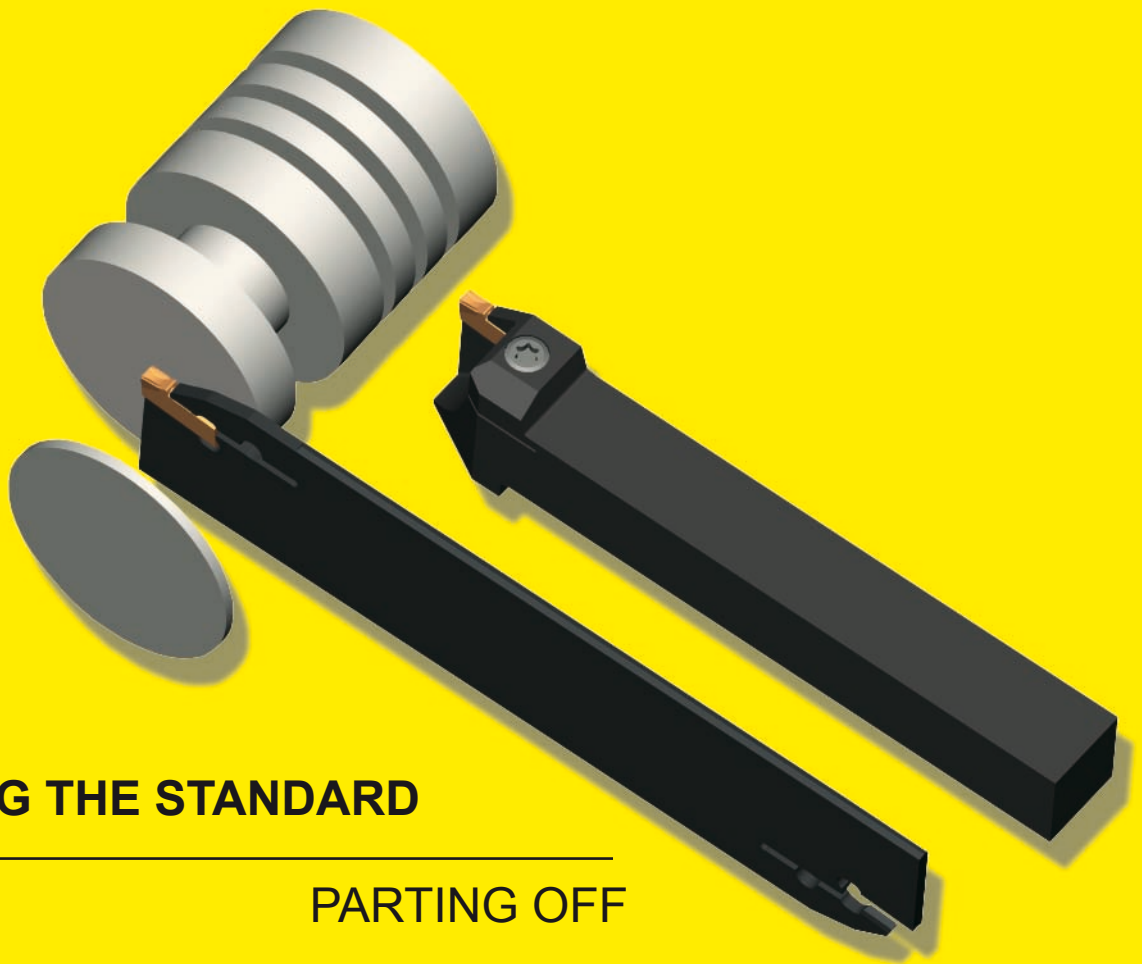
- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in mm

State R or L version

Carbide grades

HORN - THE LEADERS IN GROOVING TECHNOLOGY



G

SETTING THE STANDARD

PARTING OFF

HORN Toolholder and blades -
with screw or self clamping.

HORN - INTELLIGENT TOOL DESIGN AT WORK.



For further information, please see HORN catalog "CARBIDE GROOVING TOOLS".

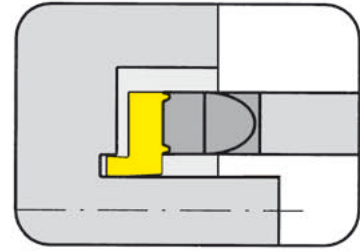
FACE GROOVING



INSERT Type

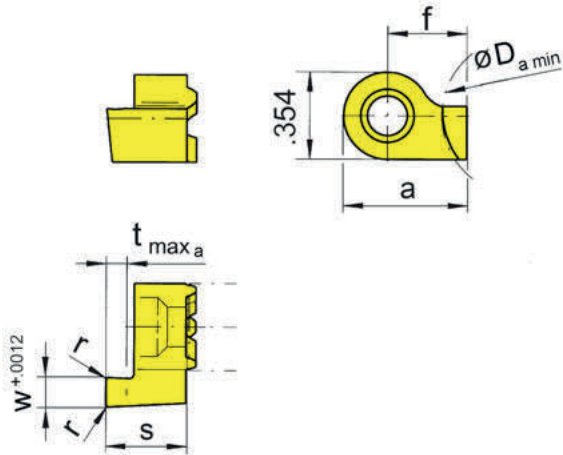
U114

from outer groove \varnothing	.472"
Depth of groove up to	.118"
Width of groove	.046 - .125"



for use with Toolholder

Type B114
BU114
HC114
HCU114



R = right hand version shown

L = left hand version

Machining **BEHIND**
centerline

Part number	w	r	s	f	a	t _{max a}	D _{a min}	Carbide grades					
								MG12	TN35	TI25	TF45	TH35	
R/LU114.1246.00	.046	-				.059			▲/▲				
R/LU114.1262.00	.062	.008				.098			▲/▲				
R/LU114.1278.00	.078	.008	.327	.295	.472	.118	.472		▲/▲				
R/LU114.1294.00	.094	.008				.118			▲/▲				
R/LU114.1225.00	.125	.008				.118			▲/▲				
								P	•				
								M	•				
								K	•				
								S	•				
								N	•				
								H					

Dimensions in inch

Carbide grades

State R or L version

Note:

R = rotation counter clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be extended by .118".

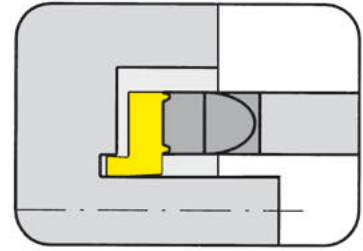
G

FACE GROOVING



INSERT Type

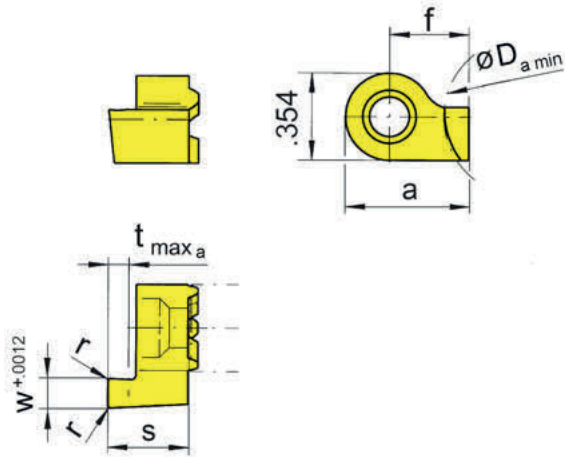
114



from outer groove \varnothing .472"
 Depth of groove up to .236"
 Width of groove .039 - .118"

for use with Toolholder

Type B114
 BU114
 HC114
 HCU114



R = right hand version shown

L = left hand version

Machining **BEHIND**
 centerline



Part number	w	r	s	f	a	t _{max a}	D _{a min}	MG12	TN35	Ti25	TF45	TH35
R/L114.1210.00	.039	-				.059			▲/▲			
R/L114.1215.00	.059	.008				.098			▲/▲			
R/L114.1220.00	.079	.008	.327	.295	.472	.118	.472		▲/▲			
R/L114.1225.00	.098	.008				.118			▲/▲			
R/L114.1230.00	.118	.008				.118			▲/▲			
R/L114.1220.5.00	.079	.008	.425	.295	.472	.197	.472		▲/▲			
R/L114.1225.5.00	.098	.008							▲/▲			
R/L114.1230.6.00	.118	.008	.465	.295	.472	.236	.472		▲/▲			
								P	•			
								M	•			
								K	•			
								S	•			
								N	•			
								H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

Note:

R = rotation counter clockwise!

Using face grooving insert type 114 on toolholder type B114, the size l_1 and l_2 will be extended by:

- .118" for inserts R/L114...00
- .217" for inserts R/L114...5.00
- .256" for inserts R/L114...6.00

Carbide grades

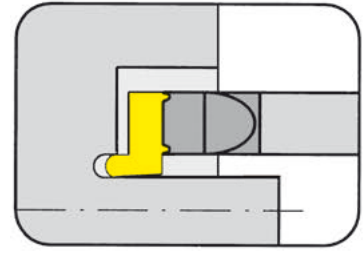
FACE GROOVING



INSERT Type

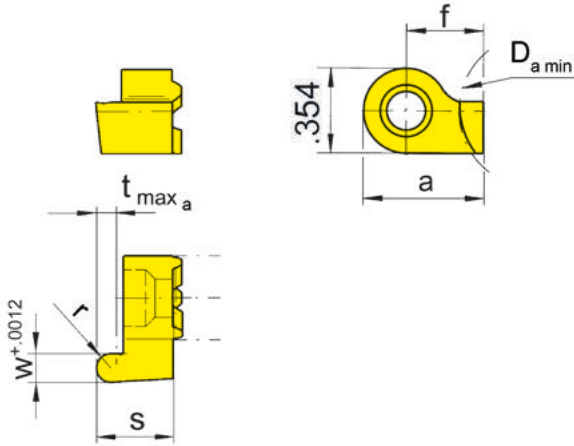
U114

from outer groove \varnothing	.472"
Depth of groove up to	.118"
Depth of groove	.046 - .125"



for use with Toolholder

- Type B114
 BU114
 HC114
 HCU114



R = right hand version shown

L = left hand version

Full radius
 Machining **BEHIND**
 centerline

Part number	w	r	s	f	a	t _{max a}	D _{a min}		MG12	TN35	TI25	TF45	TH35
R/LU114.1223.46	.046	.023				.059				▲/▲			
R/LU114.1231.62	.062	.031				.098				▲/▲			
R/LU114.1239.78	.078	.039	.327	.295	.472	.118	.472			▲/▲			
R/LU114.1247.94	.094	.047				.118				▲/▲			
R/LU114.1262.12	.125	.062				.118				▲/▲			
									P	•			
									M	•			
									K	•			
									S	•			
									N	•			
									H				

Dimensions in inch

Carbide grades

State R or L version

Note:

R = rotation counter clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be extended by .118".

G

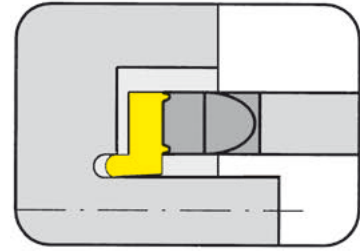
FACE GROOVING



INSERT Type

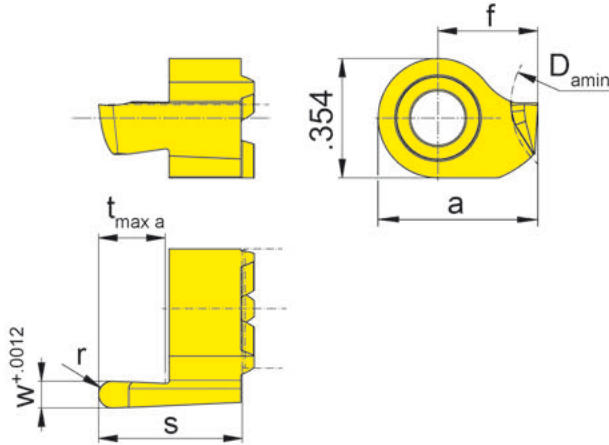
114

from outer groove \varnothing	.472"
Depth of groove up to	.236"
Width of groove	.079 - .118"



for use with Toolholder

Type B114
BU114
HC114
HCU114



R = right hand version shown

L = left hand version

Full radius
Machining **BEHIND**
centerline



Part number	w	r	s	f	a	t _{max a}	D _{a min}		MG12	TN35	T125	TF45	TH35
R/L114.1220.5.10	.079	.039	.425			.197				▲/▲			
R/L114.1225.5.12	.098	.049	.425	.295	.472	.197	.472			▲/▲			
R/L114.1230.6.15	.118	.059	.465			.236				▲/▲			
									P	•			
									M	•			
									K	•			
									S	•			
									N	•			
									H				

- ▲ on stock Δ 4 weeks
- main recommendation
- o alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Dimensions in inch

State R or L version

Note:

R = rotation counter clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size I₁ and I₂ will be extended by .217" or .256".

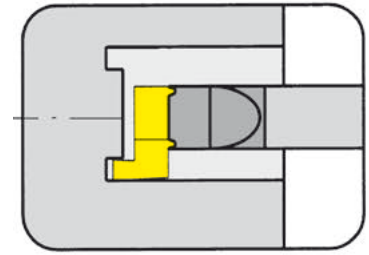
Carbide grades

FACE GROOVING



INSERT Type

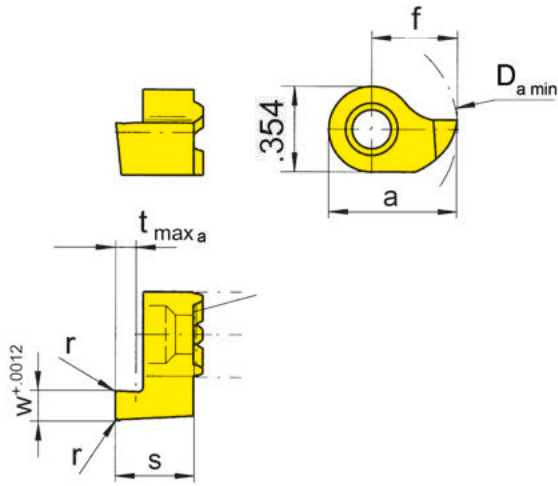
U114



from outer groove \varnothing	.551"
Depth of groove up to	.118"
Width of groove	.046 - .125"

for use with Toolholder

Type B114
BU114
HC114
HCU114



R = right hand version shown

L = left hand version

Machining **IN-FRONT**
of centerline

Part number	w	r	s	f	a	t _{max a}	D _{a min}		MG12	TN35	TI25	TF45	TH35
R/LU114.1446.00	.046	-				.059				▲/▲			
R/LU114.1462.00	.062	.008				.098				▲/▲			
R/LU114.1478.00	.078	.008	.327	.354	.531	.118	.551			▲/▲			
R/LU114.1494.00	.094	.008				.118				▲/▲			
R/LU114.1425.00	.125	.008				.118				▲/▲			
									P	•			
									M	•			
									K	•			
									S	•			
									N	•			
									H				

Dimensions in inch

Carbide grades

State R or L version

Note:

R = rotation clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be extended by .118".

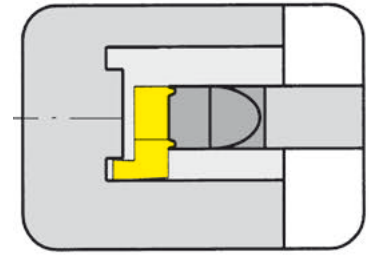
G

FACE GROOVING



INSERT Type

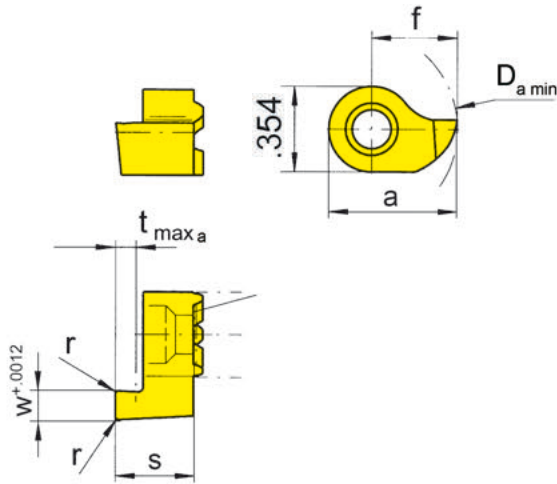
114



from outer groove \varnothing .551"
 Depth of groove up to .236"
 Width of groove .039 - .118"

for use with Toolholder

Type B114
 BU114
 HC114
 HCU114



R = right hand version shown

L = left hand version

Machining **IN-FRONT**
 of centerline



Part number	w	r	s	f	a	t _{max a}	D _{a min}		MG12	TN35	Ti25	TF45	TH35
R/L114.1410.00	.039	-				.059			▲/	▲/▲			
R/L114.1415.00	.059	.008				.098				▲/▲			
R/L114.1420.00	.079	.008	.327	.354	.531	.118	.551			▲/▲			
R/L114.1425.00	.098	.008				.118				▲/▲			
R/L114.1430.00	.118	.008				.118			▲/	▲/▲			
R/L114.1420.5.00	.079	.008	.425	.354	.531	.197	.551			▲/▲			
R/L114.1425.5.00	.098	.008								▲/▲			
R/L114.1430.6.00	.118	.008	.465	.354	.531	.236	.551			▲/▲			

- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

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

Carbide grades

Dimensions in inch

State R or L version

Note:

R = rotation clockwise!

Using face grooving insert type 114 on toolholder type B114, the size l_1 and l_2 will be extended by:

- .118" for inserts R/L114...00
- .217" for inserts R/L114...5.00
- .256" for inserts R/L114...6.00

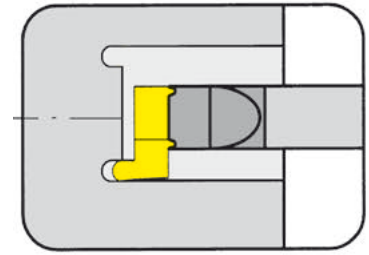
FACE GROOVING



INSERT Type

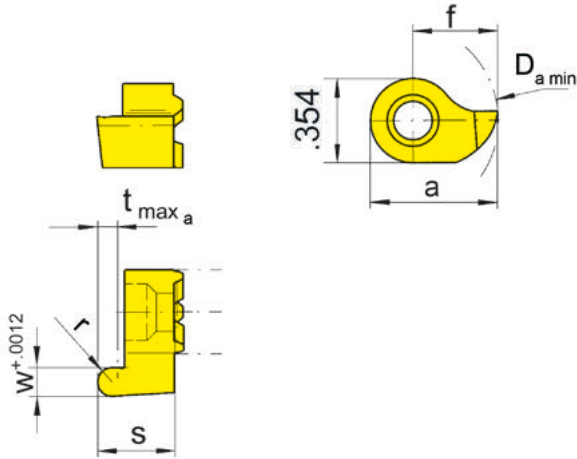
U114

from outer groove \emptyset .551"
 Depth of groove up to .118"
 Width of groove .046 - .125"



for use with Toolholder

Type B114
 BU114
 HC114
 HCU114



R = right hand version shown

L = left hand version

Full radius
 Machining **IN-FRONT**
 of centerline

Part number	w	r	s	f	a	t _{max a}	D _{a min}	Carbide grades						
								MG12	TN35	TI25	TF45	TH35		
R/LU114.1423.46	.046	.023				.059			▲/					
R/LU114.1431.62	.062	.031				.098			▲/▲					
R/LU114.1439.78	.078	.039	.327	.354	.531	.118	.551		▲/▲					
R/LU114.1447.94	.094	.047				.118			▲/▲					
R/LU114.1462.12	.125	.062				.118			▲/▲					
									P	•				
									M	•				
									K	•				
									S	•				
									N	•				
									H					

Dimensions in inch

Carbide grades

State R or L version

Note:

R = rotation clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be extended by .118".

G

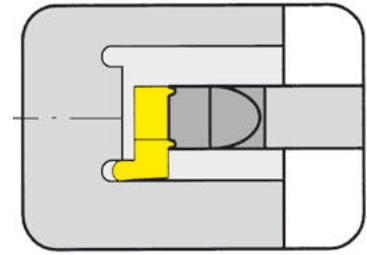
FACE GROOVING



INSERT Type

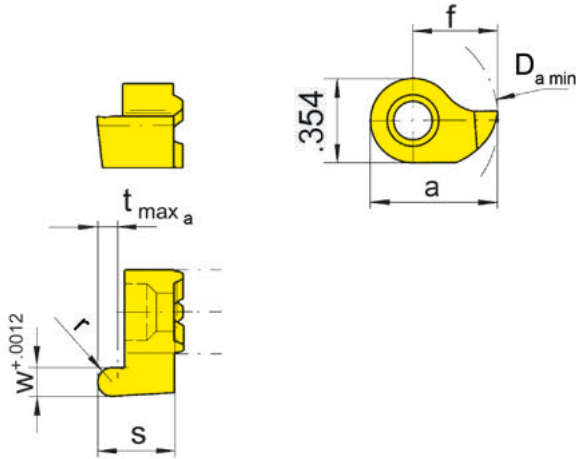
114

from outer groove \varnothing	.551"
Depth of groove up to	.118"
Width of groove	.039 - .118"



for use with Toolholder

Type B114
BU114
HC114
HCU114



R = right hand version shown

L = left hand version

Full radius
Machining **IN-FRONT**
of centerline



Part number	w	r	s	f	a	t _{max a}	D _{a min}		MG12	TN35	TI25	TF45	TH35
R/L114.1410.05	.039	.020				.059				▲/▲			
R/L114.1416.08	.063	.031				.098				▲/▲			
R/L114.1420.10	.079	.039	.327	.354	.531	.118	.551			▲/▲			
R/L114.1425.12	.098	.049				.118				▲/▲			
R/L114.1430.15	.118	.059				.118				▲/▲			
									P	•			
									M	•			
									K	•			
									S	•			
									N	•			
									H				

Dimensions in inch

Carbide grades

State R or L version

Note:

R = rotation clockwise!

Using the face grooving insert type 114 on toolholder type B114 the size l_1 and l_2 will be extended by .118".