

# HCG - HORN Catalog Guide

## INTERNAL GROOVING

Bore Ø	Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
.625" (15.87 mm)				•						
.709" ( 18 mm)				•						
.787 - 1.102" (20-28 mm)	•			•						
1.102 - 1.496" (28-38 mm)	•			•	•					
> 1.496" (38 mm)	•			•	•	•	•	•	•	
Operation Type										
Grooving	•			•	•	•	•	•	•	
Threading					•	•			•	
Profiling				•	•		•	•	•	
Width of groove inch	.022-.209			.049-.118	.079-.236	.098-.394	.098-.394	.020-.250	.049-.169	
Width of groove mm	0.56-5.3			1.25-3.0	2.0-6.0	2.5-10.0	2.5-10.0	0.5-6.35	1.25-4.29	
Chapter	A	B	C	D	E	F	G	H	J	K

## EXTERNAL GROOVING

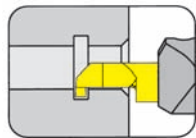
Depth of groove up to	Product line									
	217	264	S274	S223	S224	231	S229/229	S312/312	315	S316
.157" (4 mm)	•	•	•	•	•	•	•	•	•	•
.236" (6 mm)		•	•	•	•	•	•	•	•	•
.315" (8 mm)		•		•	•	•	•	•		•
.394" (10 mm)		•		•	•	•	•			
.433" (11 mm)		•		•	•	•	•			
.551" (14 mm)		•		•	•		•			
.630" (16 mm)		•		•	•		•			
.709" (18 mm)				•	•		•			
.984" (25 mm)				•			•			
1.000" (25.4 mm)							•			
Operation Type										
Grooving	•	•	•	•	•	•	•	•	•	•
Side Turning		•	•	•	•		•	•		
Parting Off	•	•	•	•	•		•	•		•
Threading		•	•			•	•		•	
Profiling			•		•		•	•	•	•
Axial Grooving						•			•	
Width of groove inch	.022-.209	.059-.118	.020-.118	.049-.118	.079-.236	.098-.394	.098-.394	.020-.250	.022-.169	.059-.118
Width of groove mm	0.56-5.3	1.5-3.0	0.5-3.0	1.25-3.0	2.0-6.0	2.5-10.0	2.5-10.0	0.5-6.35	0.56-4.29	1.5-3.0
Chapter	A	B	C	D	E	F	G	H	J	K

Special tools upon request

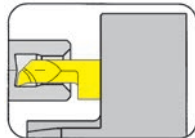
**TOOLS FOR SWISS TYPE MACHINES** L

for Inserts Type

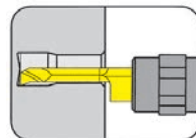
**105**



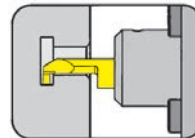
Page L2,L6,L13



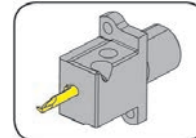
Page L3-L4



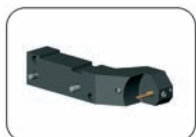
Page L5



Page L7-L11



Page L12



Page L14



Page L15



Page L37-L42

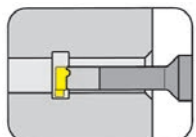


Page L43-L46

**Additional equipment**

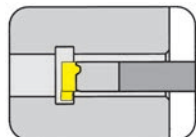
Page L47-L48

**108**



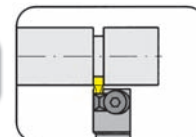
Page L16

**111**



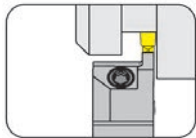
Page L17

**217**



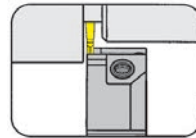
Page L18-L19

**S224**

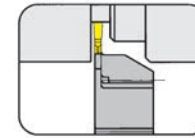


Page L20-L21

**264**

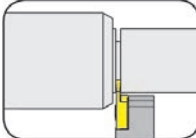


Page L22-L24

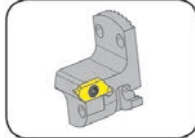


Page L25

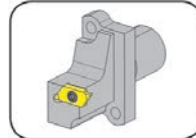
**S274**



Page L26

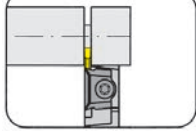


Page L27

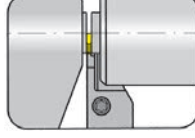


Page L28-L29

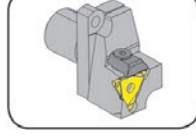
**312**



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Page L31



Page L32



Page L33



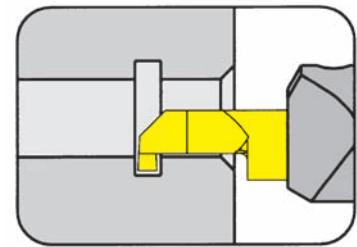
Page L34-L35

Inserts for pages L2-L17 and L41-L42 -  
See the respective chapters in the Supermini® / Mini catalog.

## TOOLHOLDER Type

# H105

with screwed clamping

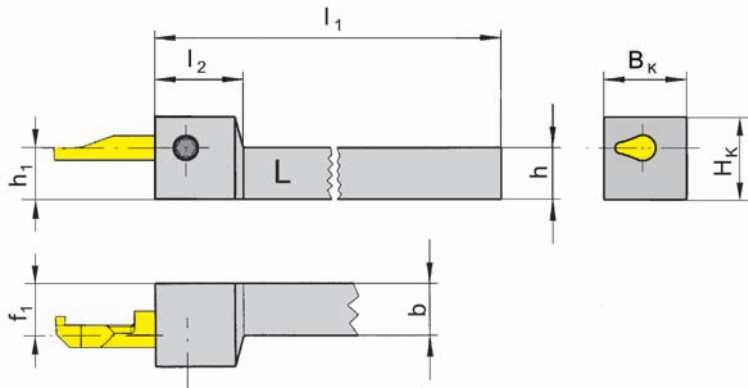


Bore Ø from

.008" (0.2 mm)

for use with Insert

Type 105  
U105



L = left hand version shown

R = right hand version

Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$b$	$B_K$	$H_k$
R/LH105.0808.01	90	17	8	8	7.5	8	16	14
R/LH105.1010.01	90	17	10	10	7.5	10	16	16
R/LH105.1212.01	90	17	12	12	7.5	12	16	18
R/LH105.1616.01	110	17	16	16	7.5	16	16	22

State R or L version

Dimensions in mm

Further sizes upon request

L

### Spare parts

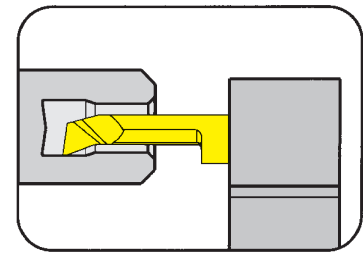
Toolholder	Screw	TORX PLUS® Wrench
R/LH105....	6.075T15P	T15PQ

L2

TOOLHOLDER Type

## HC105

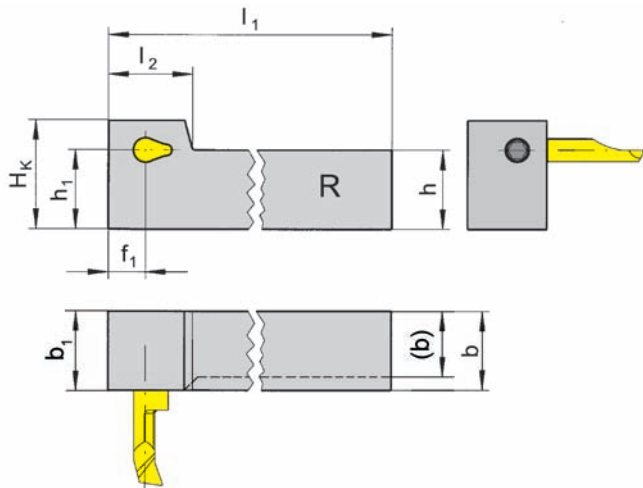
with screwed clamping



Bore Ø from .008" (0.2 mm)

for use with Insert

Type 105  
U105



R = right hand version shown

L = left hand version

Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$b$	$b_1$	$H_k$
R/LHC105.1212.01	90	17	12	12	7.5	12	16	18
R/LHC105.1616.01	130	17	16	16	7.5	16	16	22

State R or L version

Dimensions in mm

Further sizes upon request

### Spare parts

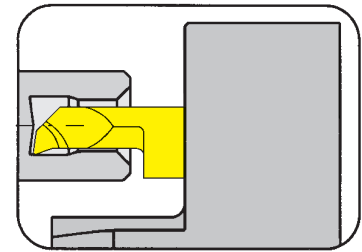
Toolholder	Screw	TORX PLUS® Wrench
R/LHC105.1...	6.075T15P	T15PQ

L

## TOOLHOLDER Type

# HC105

with screwed clamping

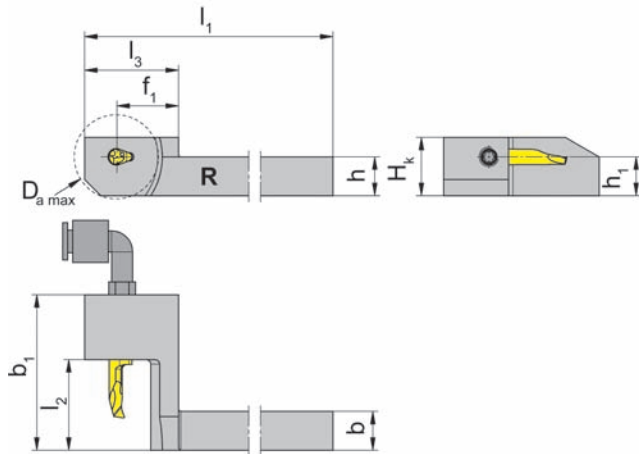


Bore Ø from .008" (0.2 mm)

Coolant supply through cranked fitting

for use with Insert

Type 105  
U105



L = left hand version shown

R = right hand version

Part number	$l_1$	$l_2$	$h$	$h_1$	$f_1$	$l_3$	$b$	$b_1$	$D_{a \max}$	$H_k$	Remark
R/LHC105.0707.21	99	18	7	7	19	29	7	32.0	26	13	*
R/LHC105.0808.21	99	18	8	8	19	29	8	32.0	26	13	*
RHC105.1010.11		8						22.7			*
R/LHC105.1010.21	99	18	10	10	19	29	10	38.0	26	16	
R/LHC105.1010.41		28						48.0			
R/LHC105.1212.21	99	18	12	12	19	29	12	38.0	26	18	
R/LHC105.1212.41		28						48.0			
R/LHC105.1616.21	104	18	16	16	24	34	16	38.0	36	22	
R/LHC105.1616.41		28						48.0			

State R or L version

Dimensions in mm

Further sizes upon request

### Note:

\* = no through coolant supply!

## Spare parts

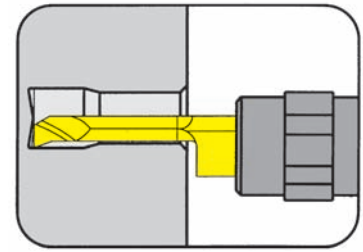
Toolholder	Screw	TORX PLUS® Wrench	Screwed angle fitting
R/LHC105...07./08...	<b>6.075T15P</b>	<b>T15PQ</b>	-
RHC105...11	<b>6.075T15P</b>	<b>T15PQ</b>	-
R/LHC105.1...21/41	<b>6.075T15P</b>	<b>T15PQ</b>	<b>KQ2L06-M5</b>

## TOOLHOLDER Type

# B105

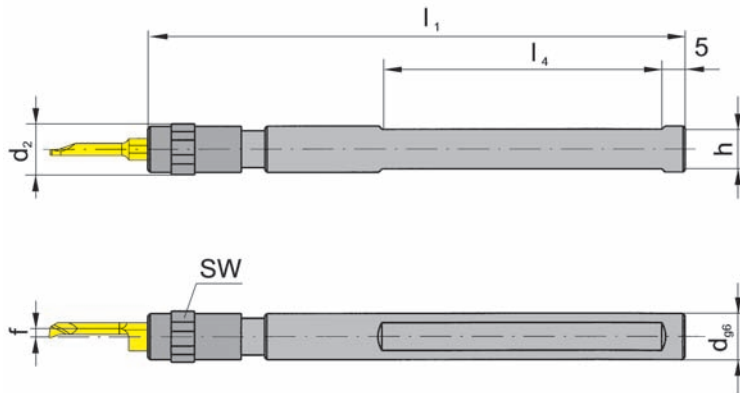
with through coolant supply

Bore Ø from  $\leq .118''(3.0\text{mm})$  or  $\geq .197''(5.0\text{mm})$



for use with Insert

Type 105/U105  
 (Ø ≤ .118"/3.0mm)  
 (Ø ≥ .197"/5.0mm)



Picture = right hand cutting version shown

Part number	d	l <sub>1</sub>	h	d <sub>2</sub>	l <sub>4</sub>	Bore Range	SW
<b>B105.0010.9.01</b>	10	100	9	11	50	* ≤ 3.0	10
<b>B105.0012.11.01</b>	12		11				
<b>B105.0016.11.01</b>	16	100	15	16	50	* ≥ 5.0	13

Further sizes upon request

f see inserts type 105

Dimensions in mm

\* only valid for standard inserts

### Ordering note:

Toolholders can be used with right and left hand inserts.

### Spare parts

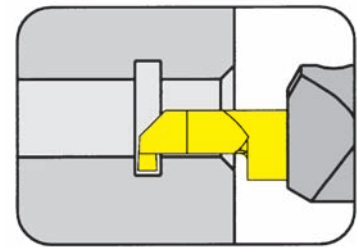
Toolholder	Chucking nut
B105.0010.9.01	<b>020.0010.1719</b>
B105.001...01	<b>020.0016.1999</b>



## TOOLHOLDER Type

# B105

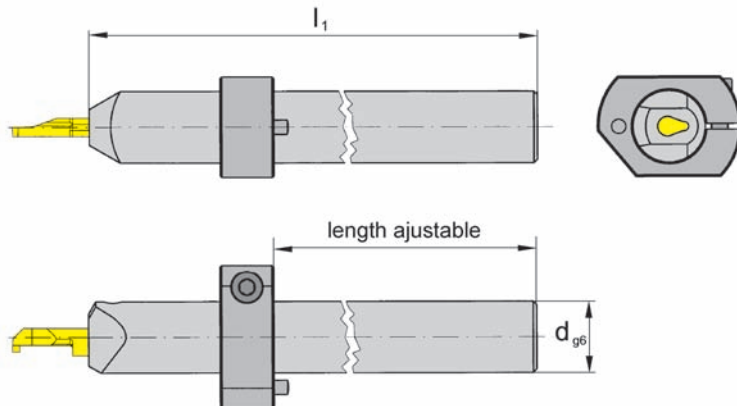
with through coolant supply



Bore Ø from	.008" (0.2 mm)
Depth of groove up to	.098" (2.5 mm)
Width of groove up to	.079" (2.0 mm)

for use with Insert

Type 105  
U105



Picture = right hand cutting version shown

Part number	d	l <sub>1</sub>
B105.0020.2.01	20	150
B105.0025.2.01	25	

Further sizes upon request

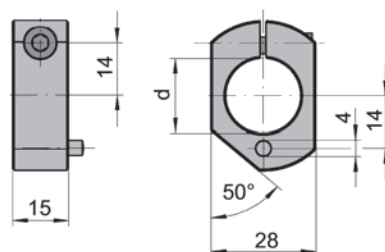
Dimensions in mm

### Ordering note:

Toolholders can be used with right and left hand inserts.

Adjusting ring is not combined with the toolholder - separate order required!

## Adjusting ring



Part number "Adjusting ring"	d	Type of machine
020.0020.1665	20	Tornos DECO
020.0025.2234	25	

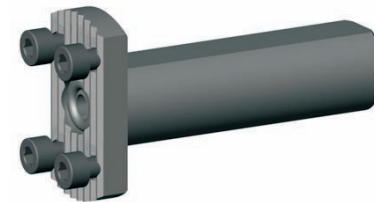
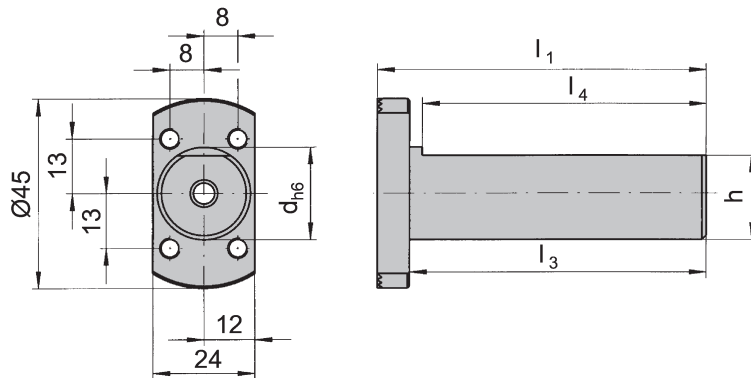
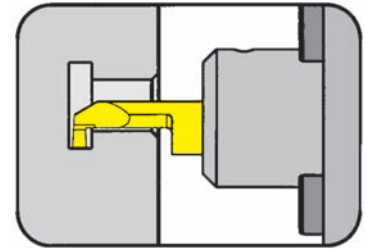
## BASIC TOOLHOLDER Type

## BGT

without cartridge

Adjustable round shanks for toolholder BKT105.2445.01/2

with through coolant supply



Part number	d	l <sub>1</sub>	h	l <sub>3</sub>	l <sub>4</sub>	Machine tool
<b>BGT001.0010.50</b>	10	57.50	9	50	47	
<b>BGT001.0016.21</b> <b>BGT001.0R16.21</b>	16	28.50	14	21	18	Star
<b>BGT001.0020.100</b>	20	107.50	18	100	97	Tornos
<b>BGT001.0022.30</b> <b>BGT001.0022.70</b>	22	36.35 77.50	20	30 70	27 67	Star
<b>BGT001.0025.70</b>	25	77.50	23	70	67	
<b>BGT001.0028.80</b>	28	87.50	26	81	77	Traub

Further sizes upon request

Dimensions in mm

### Note:

BGT001.0022.30 without through coolant supply

### Spare parts

Basic toolholder	Screw	O-ring
BGT001.0...	<b>DIN912M5X10</b>	<b>DIN37707X3</b>

L

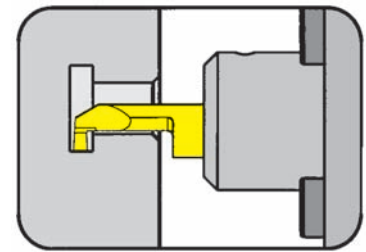


## ADJUSTABLE HOLDER Type

# BKT

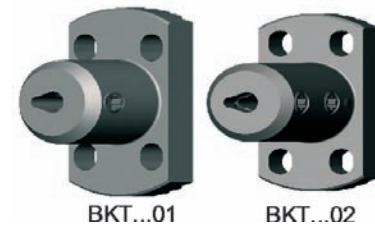
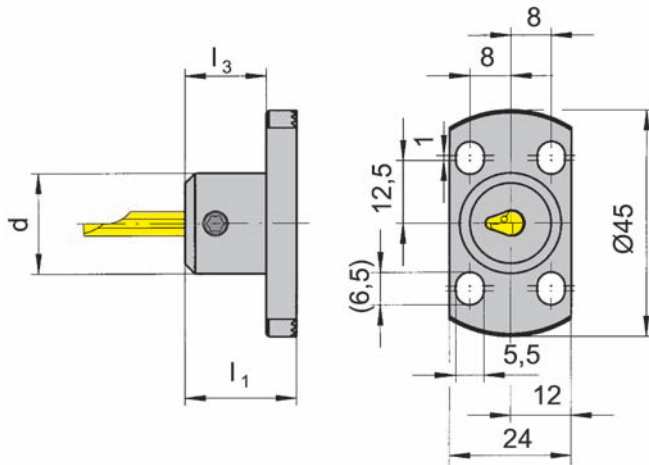
Bore  $\varnothing$  from .008" (0.2 mm)  
 Depth of groove up to .098" (2.5 mm)  
 Width of groove up to .079" (2.0 mm)

with through coolant supply



for use with Insert

Type 105  
 U105



Part number	d	l <sub>1</sub>	l <sub>3</sub>
<b>BKT105.2445.01</b>	20	22	16
<b>BKT105.2445.02</b>	20	32	26

Further sizes upon request

Dimensions in mm

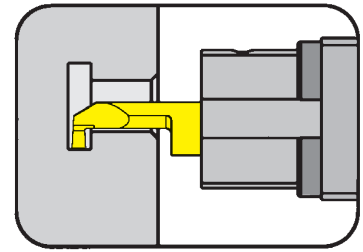
### Spare parts

Adjustable holder	Screw	TORX PLUS® Wrench
BKT105.2445.0...	<b>6.075T15P</b>	<b>T15PQ</b>

## BASIC TOOLHOLDER Type

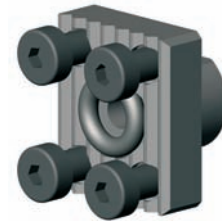
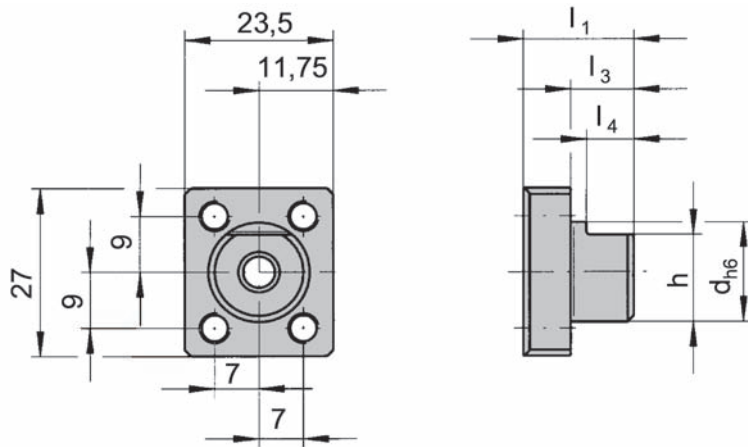
# BGT

without cartridge



Adjustable round shanks for toolholder BKT105.2327.01

with through coolant supply



Part number	d	l <sub>1</sub>	h	l <sub>3</sub>	l <sub>4</sub>	Machine tool
<b>BGT001.1627.10</b>	16	17.5	14	10	7.5	Star

Further sizes upon request

Dimensions in mm

### Spare parts

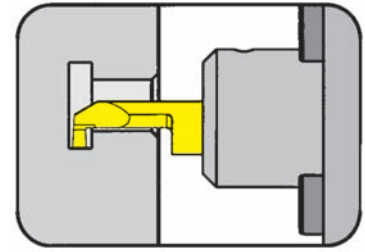
Basic toolholder	Screw	O-ring
BGT001.1627.10	DIN912M5X10	DIN37707X3

L

## BASIC TOOLHOLDER Type

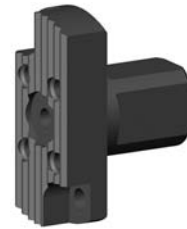
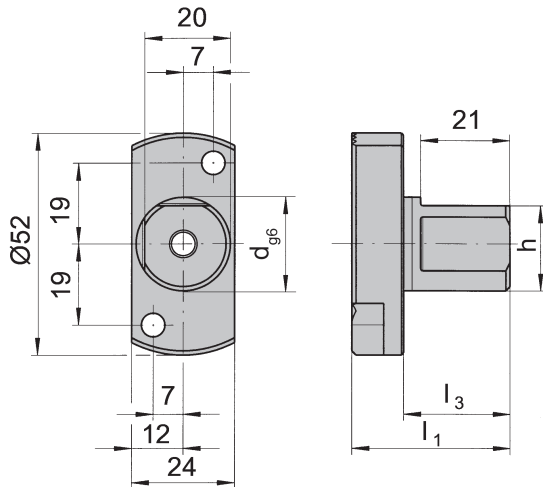
# BGT

without cartridge



Adjustable round shanks for toolholder BKT105.2327.01

with through coolant supply



Part number	d	l <sub>1</sub>	h	l <sub>3</sub>
<b>BGT001.0R22.25</b>	22	37	20	25

Further sizes upon request

Dimensions in mm

### Spare parts

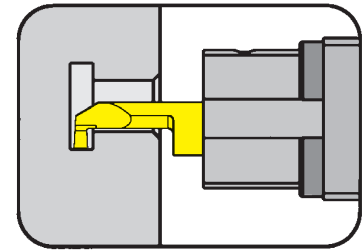
Basic toolholder	Screw
<b>BGT001.0R22.25</b>	<b>DIN912M5X10</b>

## ADJUSTABLE HOLDER Type

## BKT

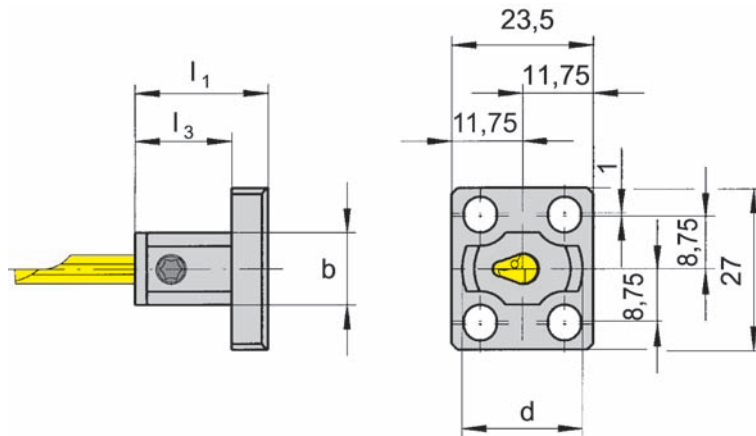
Bore  $\varnothing$  from .008" (0.2 mm)  
 Depth of groove up to .098" (2.5 mm)  
 Width of groove up to .079" (2.0 mm)

with through coolant supply



for use with Insert

Type 105  
 U105



BKT105.2327.01

Part number	d	l <sub>1</sub>	l <sub>3</sub>	b
<b>BKT105.2327.01</b>	20	22	16	12

Further sizes upon request

Dimensions in mm

### Spare parts

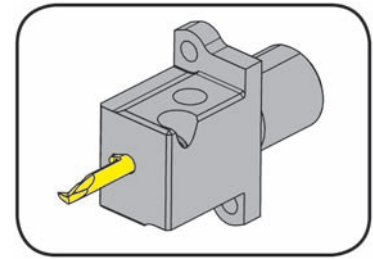
Adjustable holder	Screw	TORX PLUS® Wrench
BKT105.2327.01	<b>6.075T15P</b>	<b>T15PQ</b>



## TOOLHOLDER Type

# B105

with through coolant supply

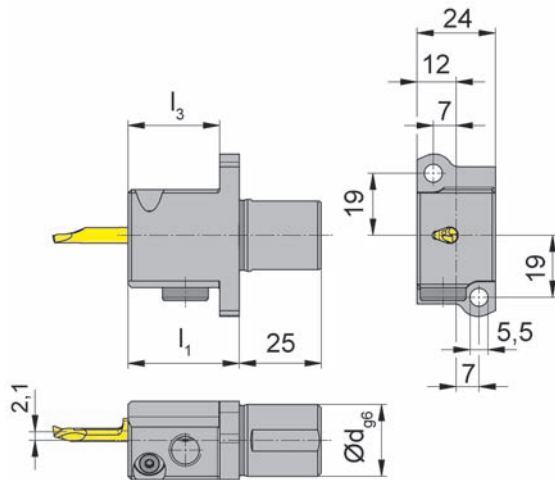


Bore Ø from	.008" (0.2 mm)
Depth of groove	.098" (2.5 mm)
Width of groove	.079" (2.0 mm)

Through coolant supply G1/8"

for use with Insert

Type 105  
U105



Picture = left hand cutting version shown

Star SV 12/20/32  
SR 10/20/32 and SB 16

Part number	d	$l_1$	$l_3$
<b>LB105.A022.26.31</b>	22	34	28

Further sizes upon request

Dimensions in mm

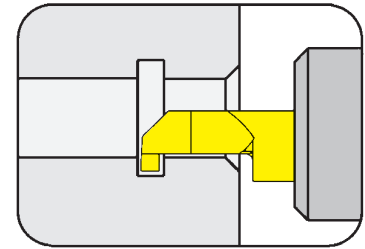
## Spare parts

Toolholder	Tensioning wedge	Screw	TORX PLUS® Wrench
LB105.A022.26.31	<b>070.0010.0118</b>	<b>DIN7984-M5x12</b>	<b>T10PL</b>

## TOOLHOLDER Type

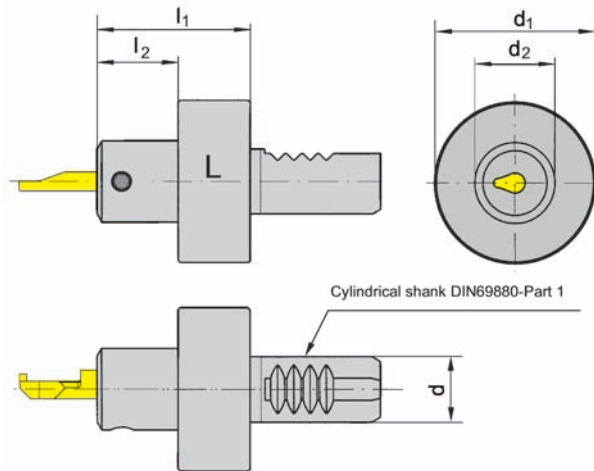
## VDI

with through coolant supply



Bore Ø from

.008" (0.2 mm)



for use with Insert

Type 105  
U105

L = left hand version shown

R = right hand version

Part number	d	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	d <sub>1</sub>
VDI16.R/L105.20.01	16	38	20	20	40
VDI20.R/L105.20.01	20	38	20	20	50
VDI25.R/L105.20.01	25	38	20	20	58
VDI30.R/L105.20.01	30	38	20	20	68
VDI40.R/L105.20.01	40	38	20	20	83

State R or L version

Dimensions in mm

Further sizes upon request

### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
VDI...	6.075T15P	T15PQ

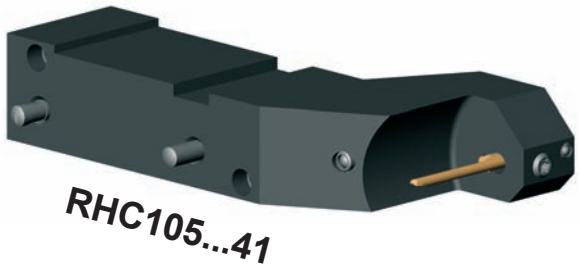
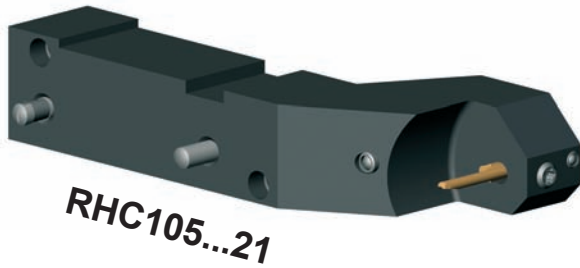
L

## Tools for Tornos DECO2000

for Insert

Type 105 / U105

Bore Ø from .008" (0.2 mm)



Basic toolholder	Insert	Machine
RHC105.0710.21	<b>105...21</b> l <sub>2</sub> up to 15 mm	<b>DECO7/10</b>
RHC105.0710.41	<b>105...41</b> l <sub>2</sub> up to 25 mm	

Dimensions in mm

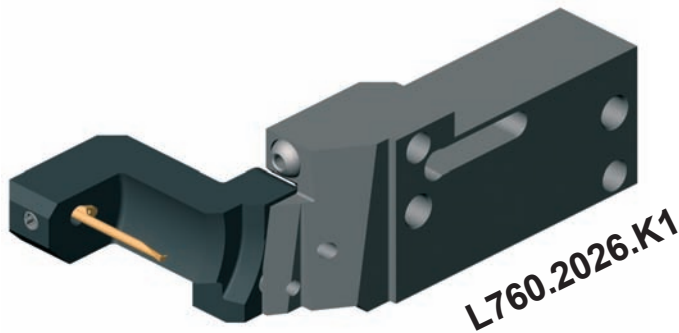
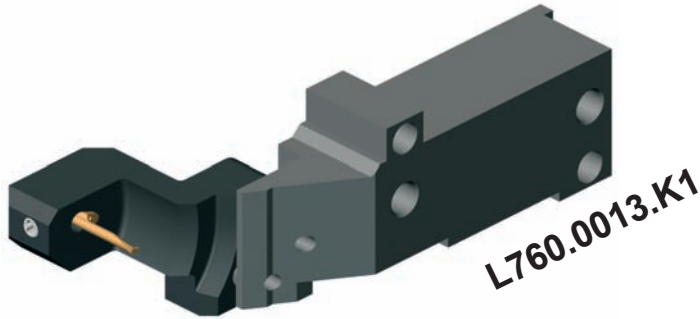
L

## Tools for Tornos DECO2000

for Cassettes

Type RKC760

Bore Ø from .008" (0.2 mm)



Basic toolholder	Cassette	Insert	Machine
L760.0013.K1	RKC760.0105.21	105...21 l <sub>2</sub> up to 15 mm	DECO13
L760.2026.K1	RKC760.0105.41	105...41 l <sub>2</sub> up to 25 mm	DECO20/26

Dimensions in mm

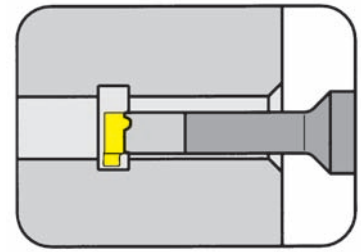
L



## TOOLHOLDER Type

# B108

with through coolant supply

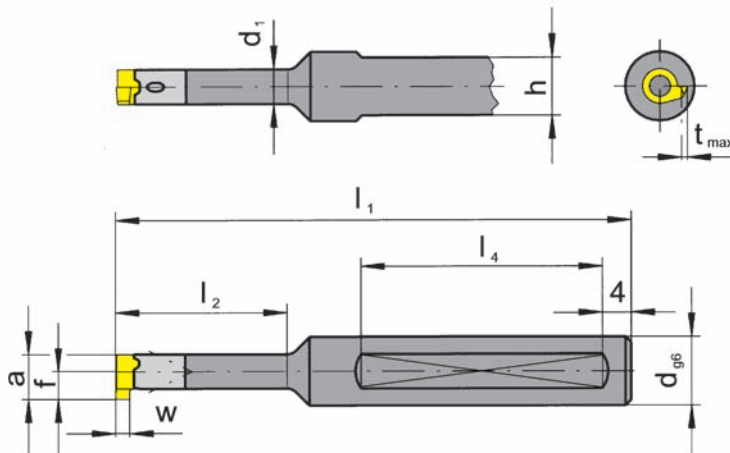


Bore Ø from	.315" (8.0 mm)
Width of groove up to	.079" (2.0 mm)

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 108  
S108  
U108



Picture = right hand cutting version shown

Part number	d	l <sub>1</sub>	l <sub>2</sub>	h	f	t <sub>max</sub>	w	a	l <sub>4</sub>	d <sub>1</sub>
B108.0008.00	8	60	12.5	7	4.8	1	2	7.8	35	6
B108.0008.01	8	70	21.0	7	4.8	1	2	7.8	40	6

Further sizes upon request

Dimensions in mm

### Ordering note:

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

### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B108.0008.0...	2.6.5T8EP	T8PL

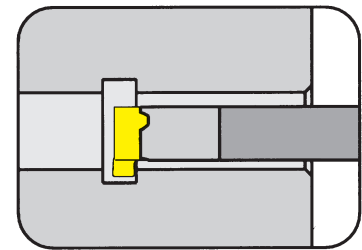
## TOOLHOLDER Type

# B111

with through coolant supply

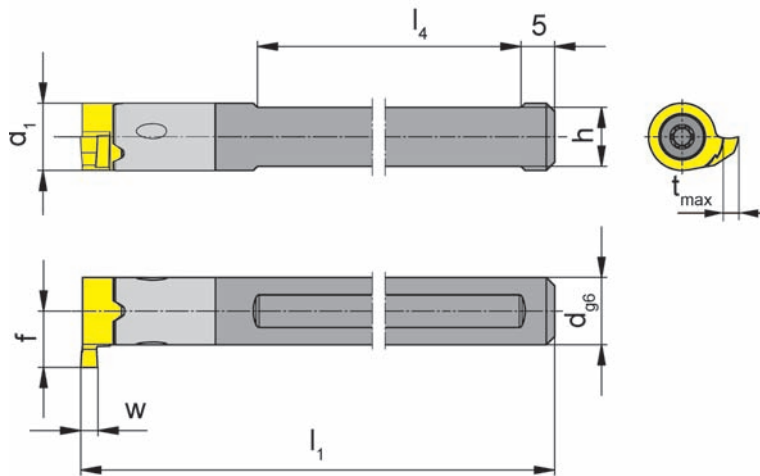
Bore Ø from	.433" (11.0 mm)
Depth of groove	.091" (2.3 mm)
Width of groove up to	.118" (3.0 mm)

Material of shank: Carbide - Giving a good vibration resistance



for use with Insert

Type 111  
S111  
U111



Picture = right hand cutting version shown

Part number	d	l <sub>1</sub>	h	f	t <sub>max</sub>	w	a	l <sub>4</sub>	d <sub>1</sub>
<b>B111.0008.01</b>	8	80	7	6.7	2.3	3	10.7	55	8

Further sizes upon request

Dimensions in mm

### Ordering note:

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

### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B111.0008.01	<b>3.5.12T10EP</b>	<b>T10PL</b>

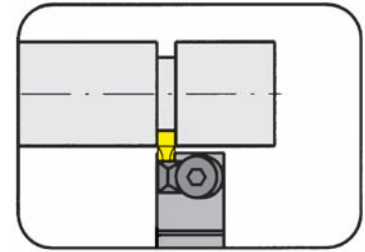
L

# GROOVING (external)



TOOLHOLDER Type

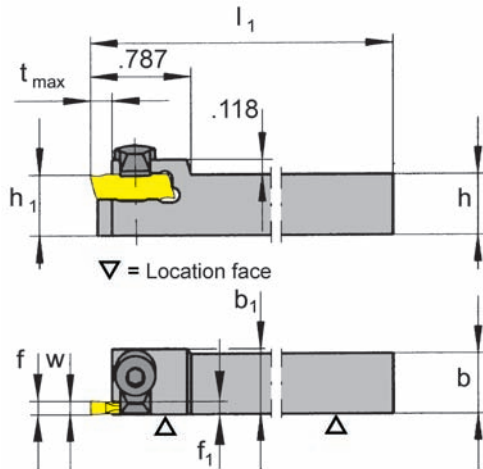
## U248



Depth of groove up to .157"  
Clamping range up to .106"

for use with Indexable insert

Type 217  
U217



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	b <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	Size	Clamping range
R/LU248.0500.01	.500	.500	3.740	.500	.539	.059	f <sub>1</sub> +a <sub>1</sub>	.157	01	.020 - .067
R/LU248.0500.02	.500	.500	3.740	.500	.539	.098	f <sub>1</sub> +a <sub>1</sub>	.157	02	.067 - .106

State R or L version

w, a<sub>1</sub> see indexable inserts

Dimensions in inch

Further sizes upon request

L

### Spare parts

Toolholder	Clamp	Screw	Wrench
R/LU248.0500.0...	8.3	5.14	SW2,5DIN911

L18

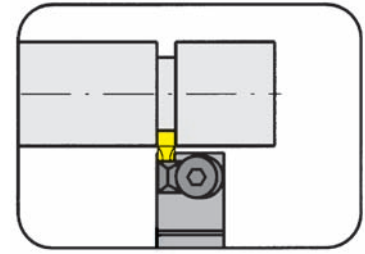
# GROOVING (external)



TOOLHOLDER Type

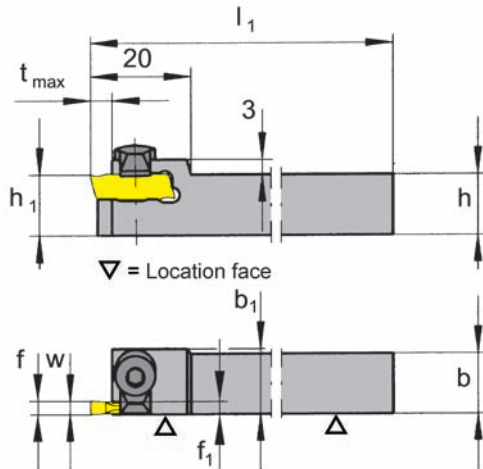
## 248

Depth of groove up to .157" (4.0 mm)  
Clamping range up to .106" (2.7 mm)



for use with Indexable insert

Type 217  
U217



R = right hand version shown

L = left hand version

Part number	h	b	$l_1$	$h_1$	$b_1$	$f_1$	f	$t_{max}$	Size	Clamping range
R/L248.1212.01	12	12	95	12	13	1.5	$f_1+a_1$	4	01	0.5 - 1.7
R/L248.1212.02	12	12	95	12	13	2.5	$f_1+a_1$	4	02	1.7 - 2.7

State R or L version

w,  $a_1$  see indexable inserts

Dimensions in mm

Further sizes upon request

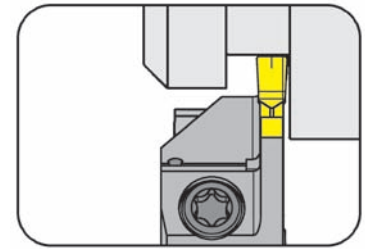
### Spare parts

Toolholder	Clamp	Screw	Wrench
R/L248.1212.0...	8.3	5.14	SW2,5DIN911

L

TOOLHOLDER Type

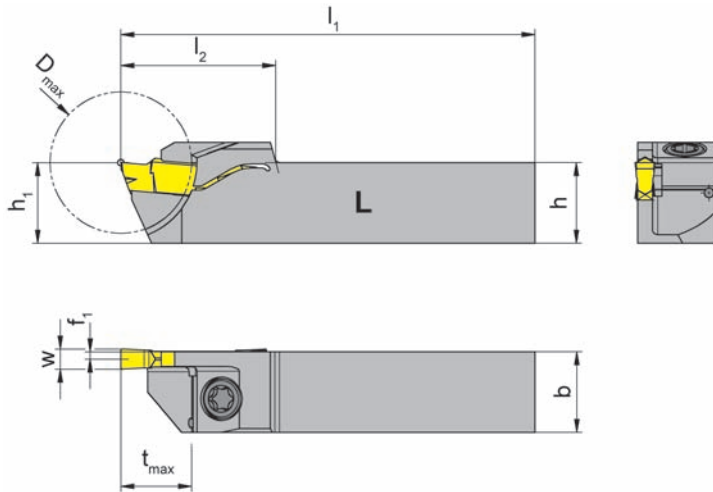
## H224



Depth of groove up to .413" (10.5 mm)  
Clamping range up to .146" (3.7 mm)

for use with Indexable insert

Type S224



L = left hand version shown

R = right hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	l <sub>2</sub>	t <sub>max</sub>	D <sub>max</sub>	Size	Clamping range
R/LH224.1212.20.61	12	12	100	12	0.7	23	10.5	21	01	2.0 - 2.4
R/LH224.1212.20.62	12	12	100	12	0.9	23	10.5	21	02	2.4 - 2.8
R/LH224.1212.20.63	12	12	100	12	1.1	23	10.5	21	03	2.8 - 3.7

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

L

### Spare parts

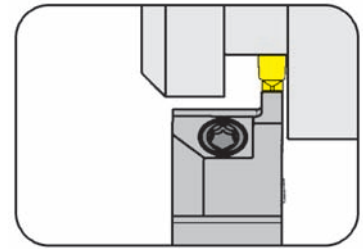
Toolholder	Screw	TORX PLUS® Wrench
R/LH224.1212.20.6...	4.12T15EP	T15PQ

L20

## TOOLHOLDER Type

# H224

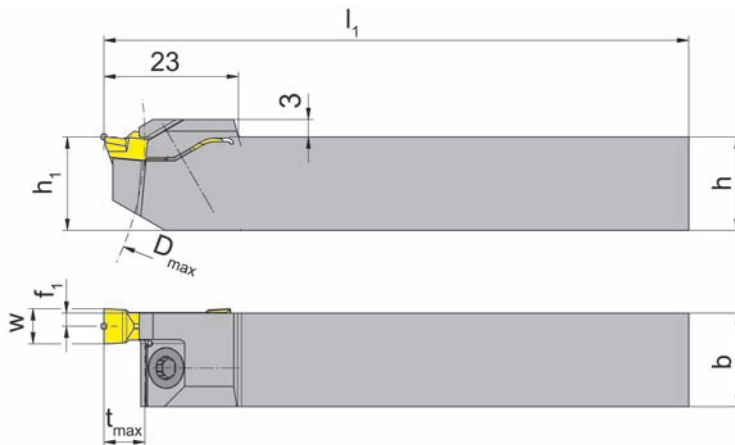
with screwed clamping



Depth of groove up to .276" (7.0 mm)  
Clamping range up to .173" (4.4 mm)

for use with Indexable insert

Type S224



L = left hand version shown

R = right hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	t <sub>max</sub>	D <sub>max</sub>	Size	Clamping range
R/LH224.1212.61	12	12		12					
R/LH224.1616.61	16	16	100	16	0.70	7	100	01	2.0 - 2.4
R/LH224.2020.61	20	20		20					
R/LH224.1212.62	12	12		12					
R/LH224.1616.62	16	16	100	16	0.90	7	100	02	2.4 - 2.8
R/LH224.2020.62	20	20		20					
R/LH224.1212.63	12	12		12					
R/LH224.1616.63	16	16	100	16	1.10	7	100	03	2.8 - 3.7
R/LH224.2020.63	20	20		20					
R/LH224.1212.64	12	12		12					
R/LH224.1616.64	16	16	100	16	1.45	7	100	04	3.7 - 4.4
R/LH224.2020.64	20	20		20					

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

## Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH224....	4.12T15EP	T15PQ

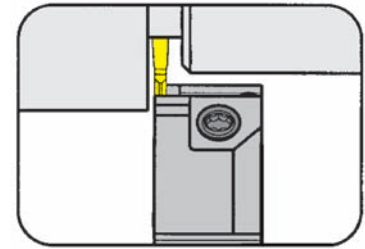
# GROOVING and PARTING OFF



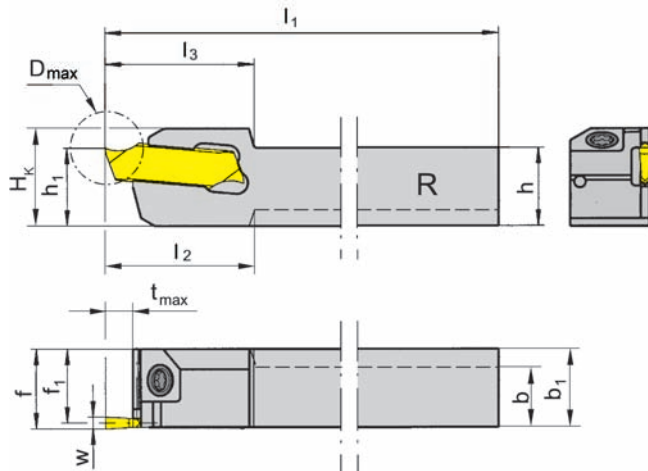
## TOOLHOLDER Type

# H264

with screwed clamping



Depth of groove up to .630" (16.0 mm)  
Width of groove up to .079" (2.0 mm)



for use with Indexable insert

Type 264  
S264



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	b <sub>1</sub>	f <sub>1</sub>	f	l <sub>2</sub>	t <sub>max</sub>	w	D <sub>max</sub>	l <sub>3</sub>	H <sub>k</sub>	Size
R/LH264.0808.01	8	8		8	10	9.25	10	17.5			22		12.5	
R/LH264.1010.01	10	10	120	10	-	9.25	10	-	4	1.5	22	17.5	12.5	01
R/LH264.1212.01	12	12		12	-	11.25	12	-			22		14.5	
R/LH264.1616.01	16	16		16	-	15.25	16	-			32		18.5	
R/LH264.1010.11	10	10		10	-	9.25	10				20		12.5	
R/LH264.1212.11	12	12	120	12	-	11.25	12	-	10	1.5	20	19.0	14.5	01
R/LH264.1616.11	16	16		16		15.25	16				32		18.5	
R/LH264.1212.21	12	12	120	12	-	11.25	12	-			26	22.0	15.5	01
R/LH264.1616.21	16	16		16	-	15.25	16		13	1.5	32		19.5	
R/LH264.1010.02	10	10		10		9.00	10						12.5	
R/LH264.1212.02	12	12	120	12	-	11.00	12	-	4	2.0	32	17.5	14.5	02
R/LH264.1616.02	16	16		16		15.00	16						18.5	
R/LH264.1010.12	10	10		10		9.00	10						12.5	
R/LH264.1212.12	12	12	120	12	-	11.00	12	-	10	2.0	32	19.0	14.5	02
R/LH264.1616.12	16	16		16		15.00	16						18.5	
R/LH264.1212.22	12	12	120	12	-	11.00	12	-			32	25.0	14.5	02
R/LH264.1616.22	16	16		16	-	15.00	16	-	16	2.0			19.5	

State R or L version

Further sizes upon request

Dimensions in mm

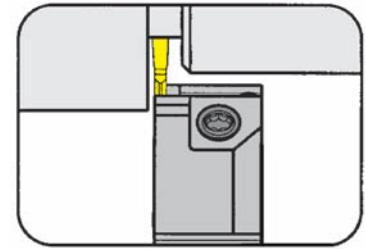
## Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH264....	3.5.12T10EP	T10PL

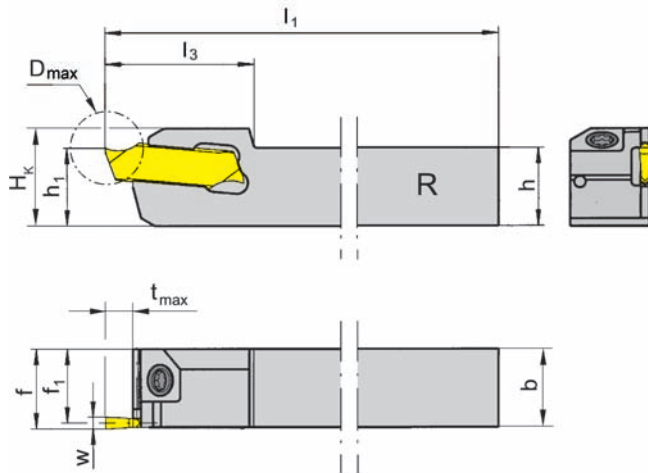
## TOOLHOLDER Type

# H264

with screwed clamping



Depth of groove up to .630" (16.0 mm)  
Width of groove .098" (2.5 mm)



for use with Indexable insert

Type 264  
S264



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	l <sub>3</sub>	H <sub>k</sub>	Size
R/LH264.1212.03	12	12	120	12	10.75	12	4	2.5	32	17.5	14.5	03
R/LH264.1616.03	16	16	120	16	14.75	16	4	2.5	32	17.5	18.5	03
R/LH264.1212.13	12	12	120	12	10.75	12	10	2.5	32	19.0	14.5	03
R/LH264.1616.13	16	16	120	16	14.75	16	10	2.5	32	19.0	18.5	03
R/LH264.1212.23	12	12	120	12	10.75	12	16	2.5	32	25.0	14.5	03
R/LH264.1616.23	16	16	120	16	14.75	16	16	2.5	32	25.0	18.5	03

State R or L version

Dimensions in mm

Further sizes upon request

## Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH264.1...	3.5.12T10EP	T10PL

L



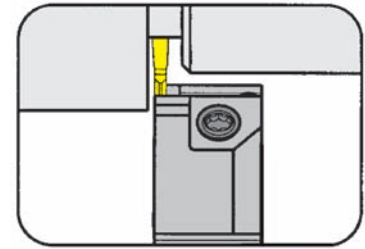
# GROOVING and PARTING OFF



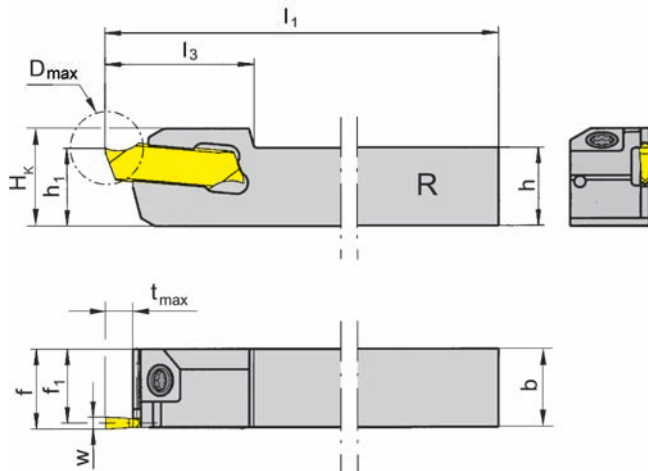
TOOLHOLDER Type

## H264

with screwed clamping



Depth of groove up to .630" (16.0 mm)  
Width of groove .118" (3.0 mm)



for use with Indexable insert

Type 264  
S264



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	f	t <sub>max</sub>	w	D <sub>max</sub>	l <sub>3</sub>	H <sub>k</sub>	Size
R/LH264.1212.04	12	12	120	12	10.5	12	5	3	32	17.5	15	04
R/LH264.1616.04	16	16	120	16	14.5	16	5	3	32	17.5	19	04
R/LH264.1212.14	12	12	120	12	10.5	12	10	3	32	19.0	15	04
R/LH264.1616.14	16	16	120	16	14.5	16	10	3	32	19.0	19	04
R/LH264.1212.24	12	12	120	12	10.5	12	16	3	32	25.0	15	04
R/LH264.1616.24	16	16	120	16	14.5	16	16	3	32	25.0	19	04

State R or L version

Dimensions in mm

Further sizes upon request

L

### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH264.1...	3.5.12T10EP	T10PL

L24

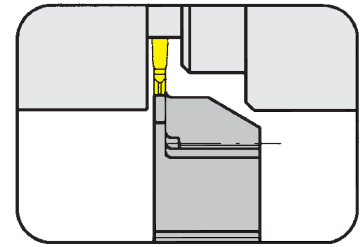
# GROOVING and PARTING OFF



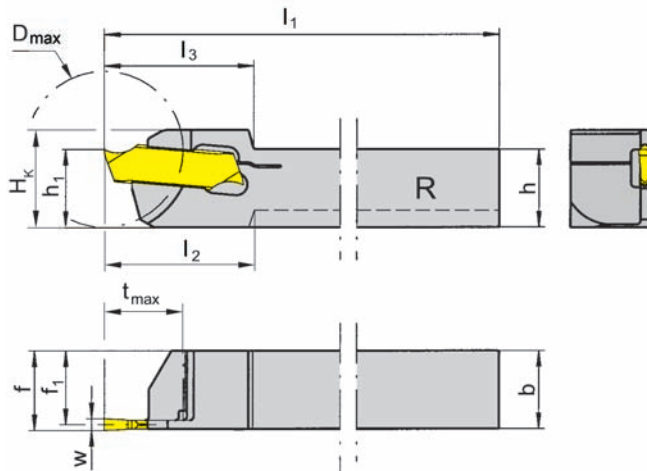
TOOLHOLDER Type

## H264

with self clamping



Depth of groove up to .394" (10.0 mm)  
Width of groove up to .118" (3.0 mm)



for use with Indexable insert

Type 264  
S264



R = right hand version shown

L = left hand version

Part number	h	b	I <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	f	I <sub>2</sub>	t <sub>max</sub>	w	D <sub>max</sub>	I <sub>3</sub>	H <sub>k</sub>	Size
R/LH264.0808.51	8	8	120	10	7.25	8	18	7	1.5	20	18	12.5	01
R/LH264.1010.61	10	10	120	10	9.25	10	-	10	1.5	20	19	12.5	01
R/LH264.1010.62	10	10	120	10	9.00	10	-	10	2.0	20	19	12.5	02
R/LH264.1212.62	12	12	120	12	11.00	12	-	10	2.0	20	19	14.5	02
R/LH264.1212.63	12	12	120	12	10.75	12	-	10	2.5	32	19	14.5	03
R/LH264.1212.64	12	12	120	12	10.50	12	-	10	3.0	32	19	14.5	04

State R or L version

Dimensions in mm

Further sizes upon request

### Spare parts

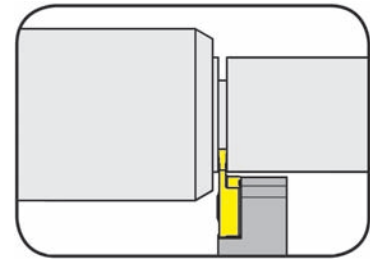
Toolholder	Wrench
R/LH264....	P39L

L

TOOLHOLDER Type

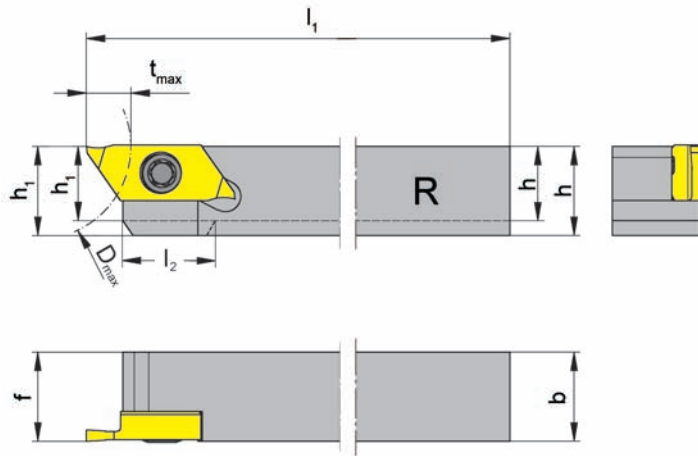
## H274

Depth of groove up to .236" (6.0 mm)  
Width of groove up to .118" (3.0 mm)



for use with Indexable insert

Type S274



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f	t <sub>max</sub>	D <sub>max</sub>	Size
R/LH274.0808.04	8	8	100	8	8	6	25	04
R/LH274.1010.04	10	10	100	10	10			
R/LH274.1212.04	12	12	100	12	12			
R/LH274.1414.04	14	14	100	14	14			
R/LH274.1616.04	16	16	125	16	16			
R/LH274.2020.04	20	20	125	20	20			

State R or L version

Dimensions in mm

Further sizes upon request

L

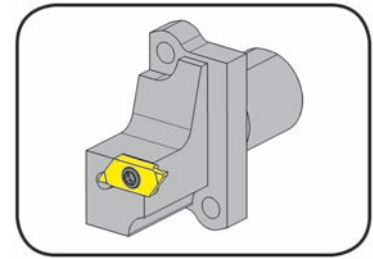
### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

L26

## TOOLHOLDER Type

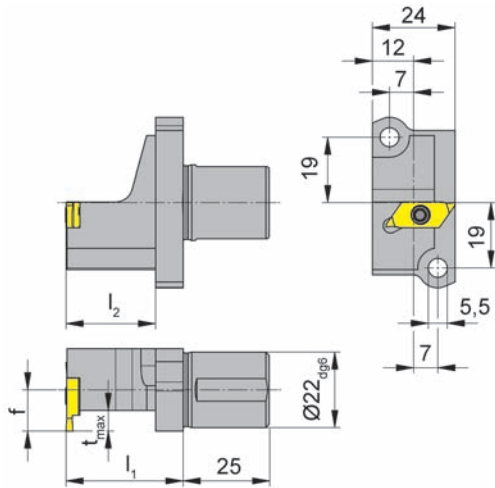
# H274



Depth of groove up to .236" (6.0 mm)  
Width of groove up to .118" (3.0 mm)

for use with Indexable insert

Type S274



R = right hand version shown

L = left hand version

Star SV 12/20/32  
SR 10/20/32 and SB 16

Part number	$l_1$	$l_2$	$f$	$t_{max}$	Size
R/LH274.A022.09.04			9		
R/LH274.A022.12.04	34	26	12	6	04
R/LH274.A022.16.04			16		
R/LH274.A022.09.07	34	26	9	6	07
R/LH274.A022.12.07			12		

State R or L version

Dimensions in mm

Further sizes upon request

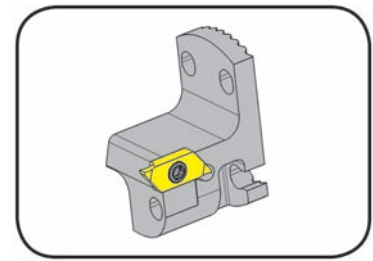
### Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH274.A022....	030.3513.T15P	T15PQ

L

## CARTRIDGE Type

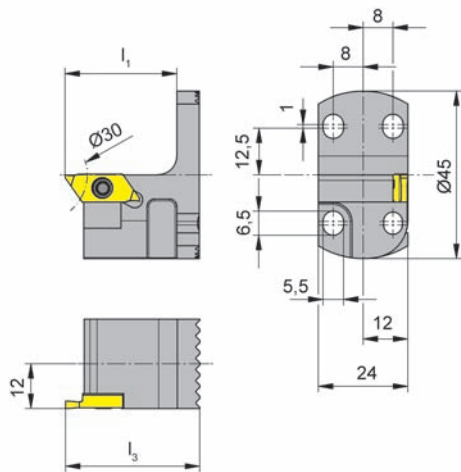
# KT274



Depth of groove up to .236" (6.0 mm)  
Width of groove up to .118" (3.0 mm)

for use with Indexable insert

Type S274



R = right hand version shown

L = left hand version

Part number	$l_1$	$l_3$	Size
R/LKT274.2445.04	30	36	04

State R or L version

Dimensions in mm

Further sizes upon request

### Note:

$t_{max} = .236"$  (6.0 mm) can be reached only when  $D_{max} \leq 1.181"$  (30 mm)

L

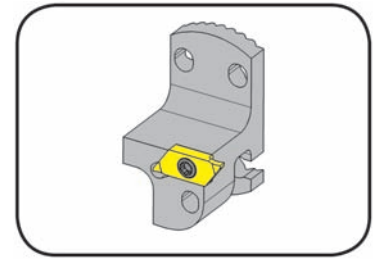
### Spare parts

Cartridge	Screw	TORX PLUS® Wrench
R/LKT274.2445.04	030.3509.T15P	T15PQ

L28

## CARTRIDGE Type

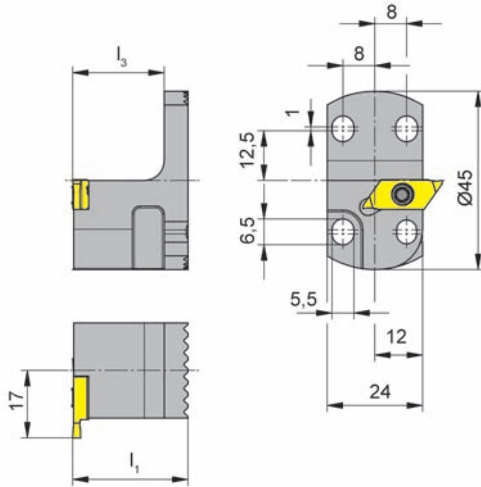
# KTC274



Depth of groove up to .236" (6.0 mm)  
Width of groove up to .118" (3.0 mm)

for use with Indexable insert

Type S274



R = right hand version shown

Part number	$l_1$	$l_3$	Size
<b>RKTC274.2445.04</b>	29	23	04

Further sizes upon request

Dimensions in mm

$t_{max} = .236"$  (6.0 mm) can be reached only when  $D_{max} \leq 1.181"$  (30 mm)

### Spare parts

Cartridge	Screw	TORX PLUS® Wrench
RKTC274.2445.04	<b>030.3509.T15P</b>	<b>T15PQ</b>

L

# GROOVING and PARTING OFF

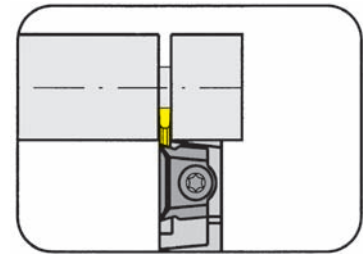


TOOLHOLDER Type

## 361

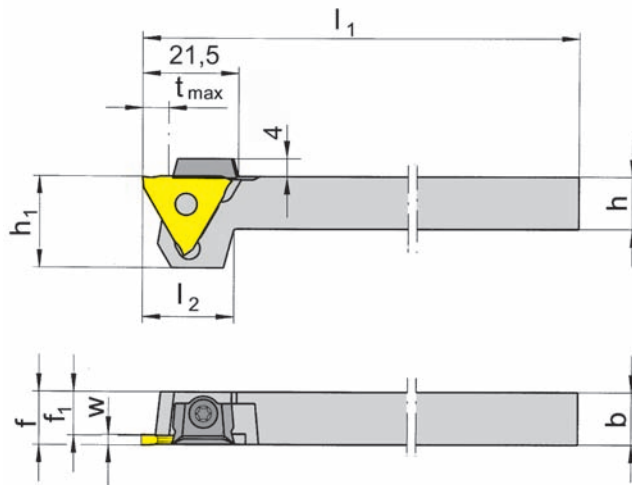
reduced head size

Depth of groove up to .236" (6.0 mm)  
Clamping range .020 - .154" (0.5 - 3.9 mm)



for use with Indexable insert

Type 312  
N312  
S312  
U312  
US312



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	f	l <sub>2</sub>	t <sub>max</sub>	Size	Clamping range
R/L361.1212.01	12	12	100	19	10.5	f <sub>1</sub> +w-a <sub>1</sub>	17	4	01	0.5-1.9
R/L361.1212.02	12	12	100	19	9.5	f <sub>1</sub> +w-a <sub>1</sub>	17	6	02	1.9-2.9
R/L361.1212.03	12	12	100	21	8.5	f <sub>1</sub> +w-a <sub>1</sub>	21	6	03	2.9-3.9

State R or L version

w, a<sub>1</sub> see indexable inserts

Dimensions in mm

Further sizes upon request

t<sub>max</sub> can be reached only with workpiece Ø ≤ 40 mm

L

### Spare parts

Toolholder	Clamp	Screw	TORX PLUS® Wrench
R/L361.1212.0...	12.3	030.0422.T10P	T10PW

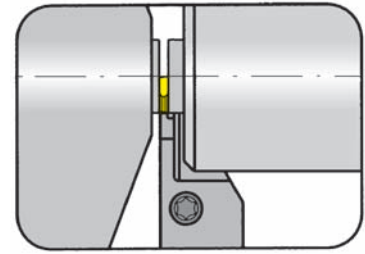
L30

## TOOLHOLDER Type

# 368

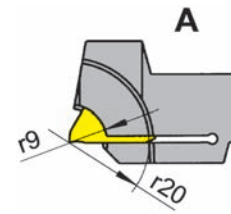
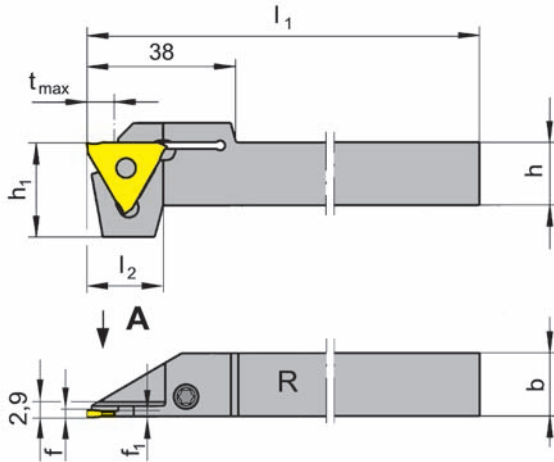
Depth of groove up to .315" (8.0 mm)  
Width of groove up to .059" (1.5 mm)

for machines TRAUB (TNL12/7)



for use with Indexable insert

Type 312  
U312



R = right hand version shown

L = left hand version

Part number	h	b	l <sub>1</sub>	h <sub>1</sub>	f <sub>1</sub>	f	l <sub>2</sub>	t <sub>max</sub>	Size	Clamping range
R/L368.1212.08	12	12			1.0					
R/L368.1212.11	12	12			1.3					
R/L368.1616.08	16	16	95	24	1.0	f <sub>1</sub> +a <sub>1</sub>	19.5	8	01	0.5 - 1.9
R/L368.1616.11	16	16			1.3					

State R or L version

a<sub>1</sub> see indexable inserts

Dimensions in mm

### Toolholder R/L368...08 for indexable inserts:

R/L312.0805... / R/L312.0808... / R/L312.0510...  
R/L312.0512... / R/L312.1210... / R/L312.0012...

### Toolholder R/L368...11 for indexable inserts:

R/L312.0515... / R/L312.0015...

Further sizes upon request

### Spare parts

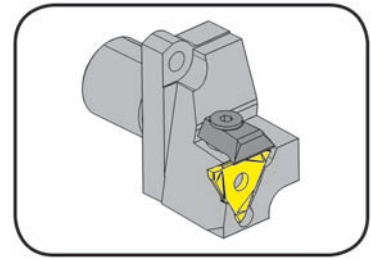
Toolholder	Screw	TORX PLUS® Wrench
R/L368.1...	4.15T15P	T15PQ

L



TOOLHOLDER Type

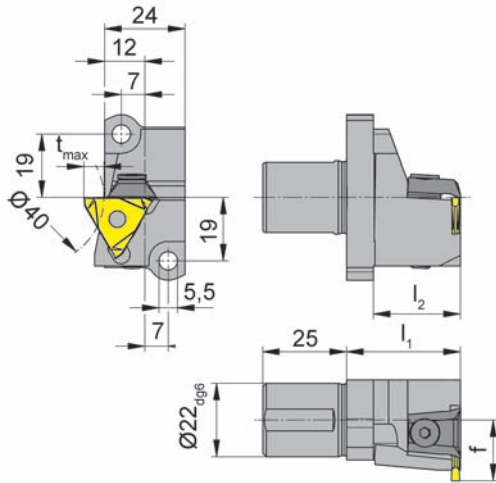
**369**



Depth of groove up to .236" (6.0 mm)  
Clamping range up to .020 - .114" (0.5 - 2.9 mm)

for use with Indexable insert

Type 312  
U312



L = left hand version shown

Star SV 12/20/32  
SR 10/20/32 and SB 16

Part number	$l_1$	$l_2$	f	$t_{max}$	Size	Clamping range
L369.A022.18.01	34	26	18.2	4	01	0.5 - 1.9
L369.A022.18.02	34	26	18.2	6	02	1.9 - 2.9

Further sizes upon request

Dimensions in mm

L

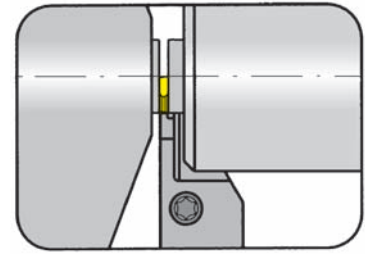
### Spare parts

Toolholder	Clamp	Screw	Wrench
L369.A022.18.0...	16.4	6.25	SW3DIN911

L32

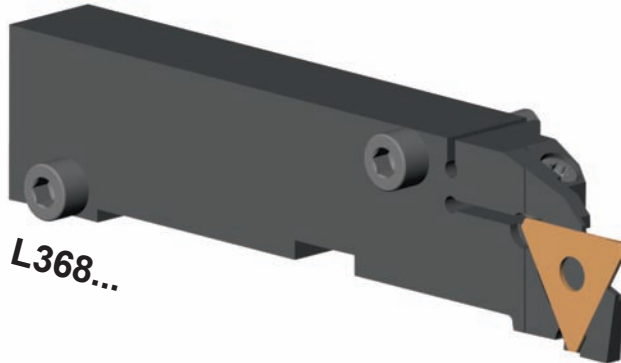
## Tools for Tornos DECO2000

Depth of groove up to .315" (8.0 mm)  
 Width of groove up to .059" (1.5 mm)



for use with Indexable insert

Type 312  
 U312



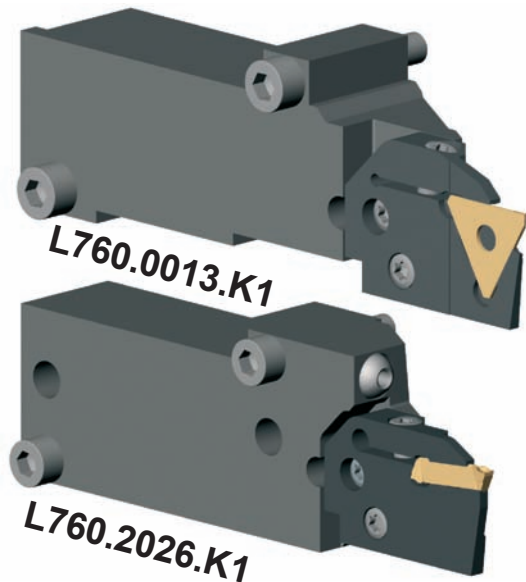
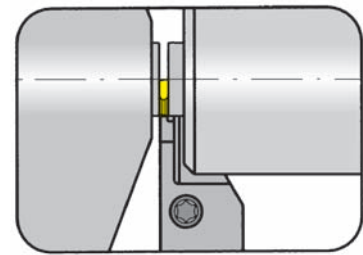
Basic toolholder	t <sub>max</sub>	w	Indexable inserts	Machine
L368.0710.08	8	0.5 - 1.2	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...	DECO7/10
L368.0710.11	8	1.5	R/L312.0515... 312.0015...	

Dimensions in mm



## Tools for Tornos DECO2000

Depth of groove up to .591" (15.0 mm)  
Width of groove up to .146" (3.7 mm)



for Cassettes

Type LNK368  
LNK760

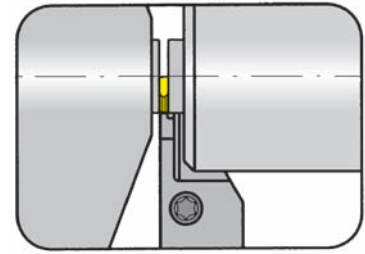


Basic toolholder	Cassette	t <sub>max</sub>	w	Indexable inserts	Machine
L760.0013.K1	LNK368.0760.08	8	0.5 - 1.2	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...	DECO13
	LNK368.0760.11	8	1.5	R/L312.0515... 312.0015...	
L760.2026.K1	LNK760.0224.01 LNK760.0224.02 LNK760.0224.03	15	2.0 - 2.4 2.4 - 2.8 2.8 - 3.7	S224...	DECO20/26

Dimensions in mm

## Tools for Tornos DECO2000

Depth of groove up to .591" (15.0 mm)  
 Width of groove up to .146" (3.7 mm)



for Basic toolholder

Type L760.0013.K1  
 L760.2026.K1



Cassette	t <sub>max</sub>	w	Indexable inserts	Machine
LNK368.0760.08	9	0.5 - 1.2	R/L312.0805... R/L312.0808... R/L312.0510... R/L312.0512... R/L312.1210... 312.0012...	DECO13 DECO20/26
LNK368.0760.11	9	1.5	R/L312.0515... 312.0015...	
LNK760.0224.01 LNK760.0224.02 LNK760.0224.03	15	2.0 - 2.4 2.4 - 2.8 2.8 - 3.7	S224...	

Dimensions in mm





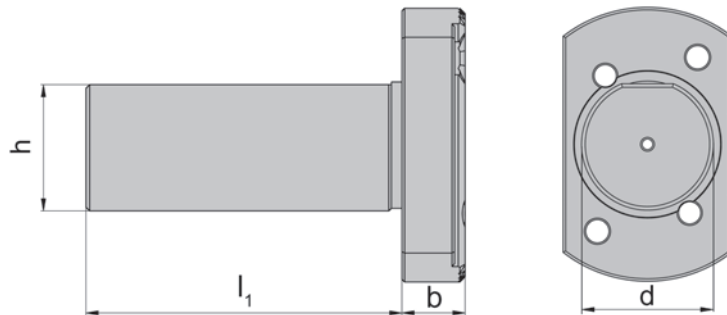
L

## BASIC TOOLHOLDER Type

# G

without cartridge

for adjustable holder Graf type N and HORN  
BKT105.2445.01/2



Part number	d	l <sub>1</sub>	h	b	Machine tool	
G016021	16,00	21	14	6	Star	
G016040		40			Traub/Manurhin	
G034040	3/4"	40	18	6	Citizen	
G034050		50				
G034120		120				
G020030	20,00	30	18	6	Citizen	
G020040		40			Hanwha	
G020100		100			Tornos	
G020150		150			Manurhin/Tornos	
G022023	22,00	23	20	6	Star	
G022025SR16/20R		25				12
G022030		30				6
G022030SR32		30				12
G022070		70				6

Further sizes upon request

Dimensions in mm and inch

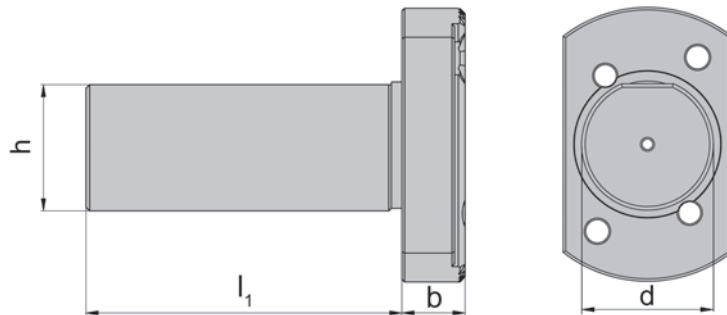
L

## BASIC TOOLHOLDER Type

# G

without cartridge

for adjustable holder Graf type N and HORN  
BKT105.2445.01/2



Part number	d	l <sub>1</sub>	h	b	Machine tool
G025060	25,0	60	23	12	Hanwha
G025070		70		6	Manurhin/Tornos
G025100		100		6	Manurhin/Tornos
G025160		160		6	Manurhin/Tornos
G010060	1"	60	23	6	Citizen
G010100		100			
G028006	28,0	6	26	12	Hanwha
G028080		80			Traub
G030045	30,0	45	27	12	Maier
G033040	33,0	40	31	12	Hanwha
G034020	34,0	20	32	12	Maier
G034044		44			Maier/Hanwha

Further sizes upon request

Dimensions in mm and inch

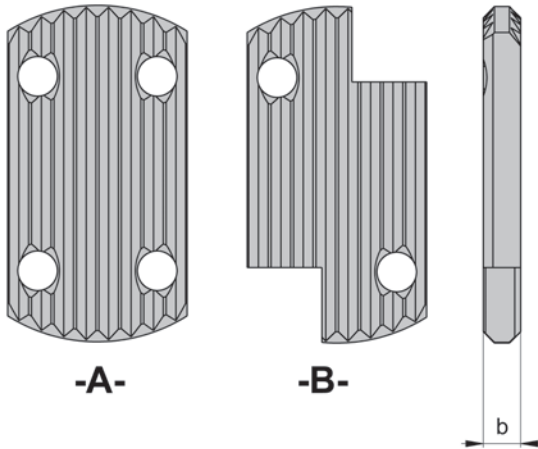
L

ADAPTOR Type

## Z

without cartridge

for adjustable holder Graf type N and HORN  
BKT105.2445.01/2



Part number	b	Form
Z5	5	A
Z10	10	
Z15	15	
Z20	20	
Z25	25	
Z30	30	
Z5SR16/20R	5	B
Z10SR16/20R	10	
Z15SR16/20R	15	
Z20SR16/20R	20	
Z25SR16/20R	25	
Z30SR16/20R	30	

Further sizes upon request

Dimensions in mm





## PLATE BETWEEN GRAF Type

# N

without Cartridge

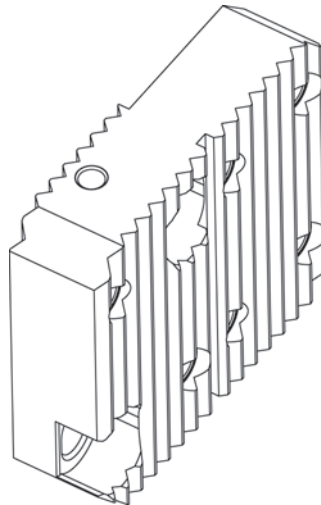


for adjustable holder Graf type N and HORN BKT105.2445.01/2

for back working

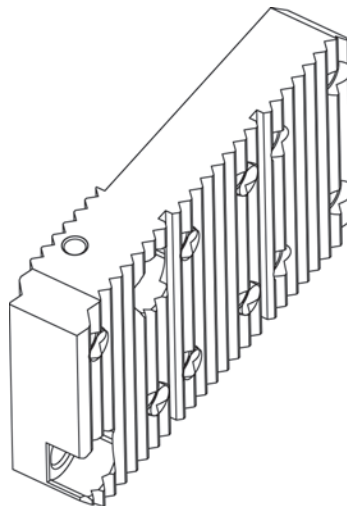
### Part number N11

For alternatively 2 cartridges



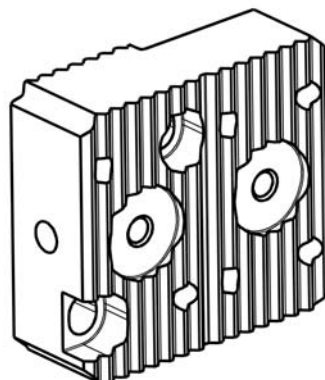
### Part number N12

For alternatively 3 cartridges



### Part number N93IK

with through coolant supply



L

## ADJUSTABLE HOLDER Type **N**

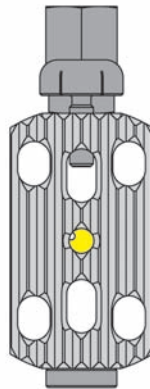
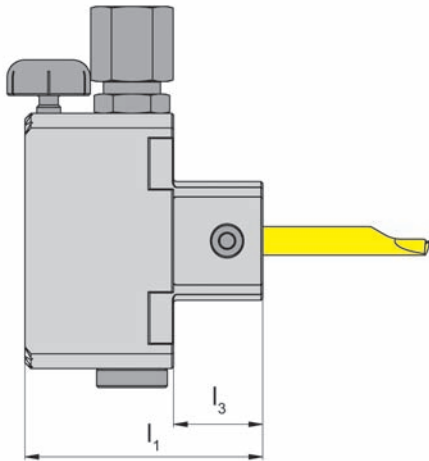


Bore Ø from	.008" (0.2 mm)
Depth of groove up to	.098" (2.5 mm)
Width of groove up to	.079" (2.0 mm)

with through coolant supply

for use with Insert

Type 105  
U105



Part number	$l_1$
<b>N09IK</b>	40

Further sizes upon request

Dimensions in mm

### Spare parts

Adjustable holder	Screw	Height adjustment screw	Coolant supply
N09IK	6.075T15P	002.00.69	004.00.19



## ADJUSTABLE HOLDER Type **N**

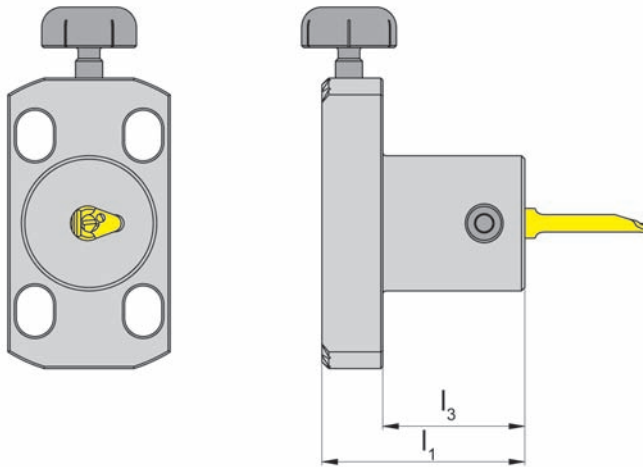


Bore Ø from	.008" (0.2 mm)
Depth of groove up to	.098" (2.5 mm)
Width of groove up to	.079" (2.0 mm)

no through coolant supply

for use with Insert

Type 105  
U105



Part number	$l_1$
<b>N09</b>	30

Further sizes upon request

Dimensions in mm

L

### Spare parts

Adjustable holder	Screw	Height adjustment screw
N09	<b>6.075T15P</b>	<b>002.00.69</b>

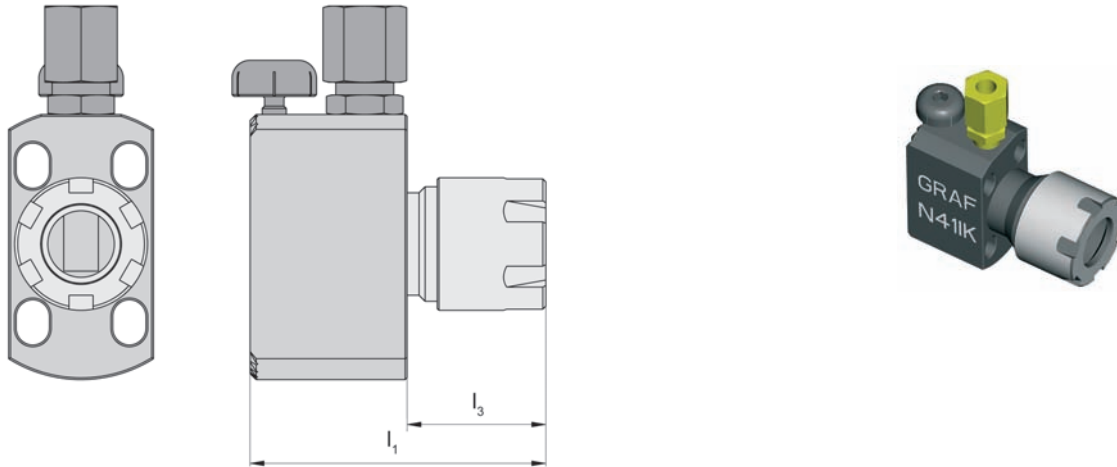
L42

## ADJUSTABLE HOLDER Type **N**



with chucking nut ER16 / E20 system Graf

with through coolant supply



Part number	$l_1$	Remark
N07IK	54	ER16
N41IK	64	ER20

Further sizes upon request

Dimensions in mm

### Spare parts

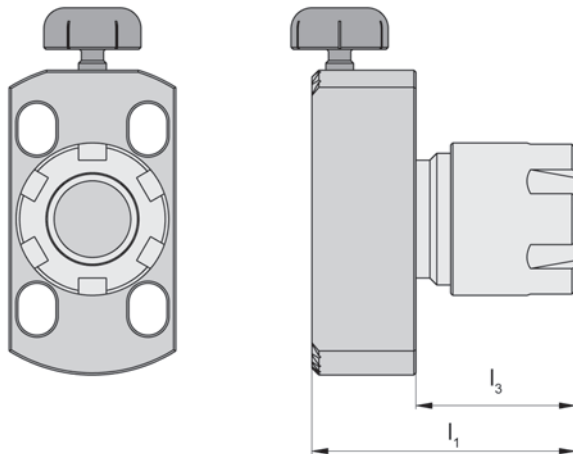
Adjustable holder	Chucking nut	Height adjustment screw	Coolant supply	Set of seals D3
N07IK	62.000.16	002.00.69	004.00.19	64.600.16.3-10
N41IK	62.000.20	002.00.69	004.00.19	64.600.20.3-13



## ADJUSTABLE HOLDER Type **N**



with chucking nut ER16 system Graf



for use with Basic toolholder

Type Horn BGT  
Graf G



Part number	$l_1$	Remark
<b>N07</b>	37	ER16

Further sizes upon request

Dimensions in mm

L

### Spare parts

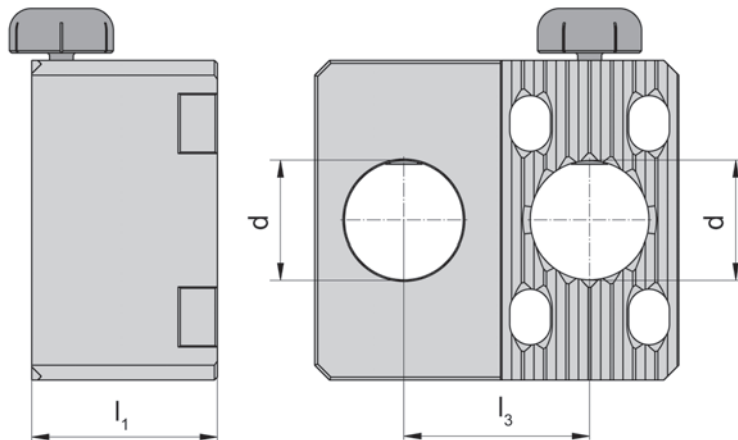
Adjustable holder	Chucking nut	Height adjustment screw
N07	62.000.16	002.00.69

L44

## ADJUSTABLE HOLDER Type **N**

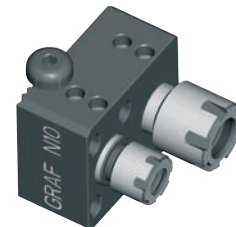


for collet holders ER11 / ER16 system Graf



for use with Basic toolholder

Type Horn BGT  
Graf G



Part number	$l_1$
N10	25

Further sizes upon request

Dimensions in mm

### Spare parts

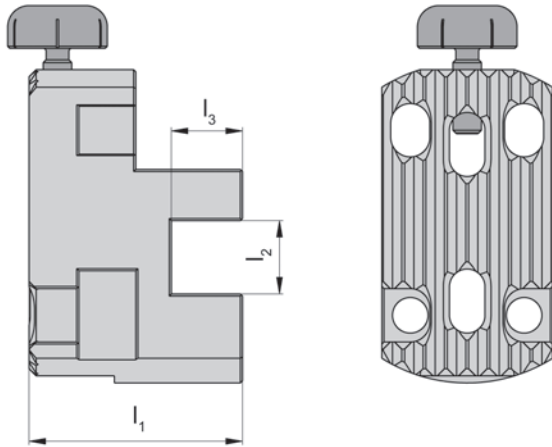
Adjustable holder	Threaded pin	Height adjustment screw	Collet holder
N10	002.00.11	002.00.69	GZ66.1620.11ER11



## ADJUSTABLE HOLDER Type **N**



for square shank system Graf



for use with Basic toolholder

Type Horn BGT  
Graf G



<b>Part number</b>	$l_1$
<b>N06</b>	10

Further sizes upon request

Dimensions in mm

L

### Spare parts

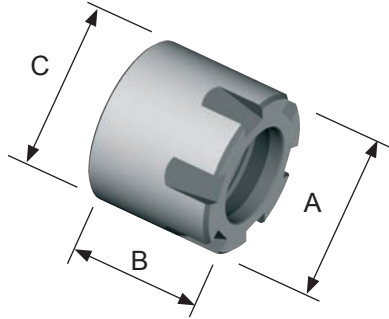
Adjustable holder	Threaded pin	Height adjustment screw
N06	002.00.11	002.00.69

L46

## Chucking nut

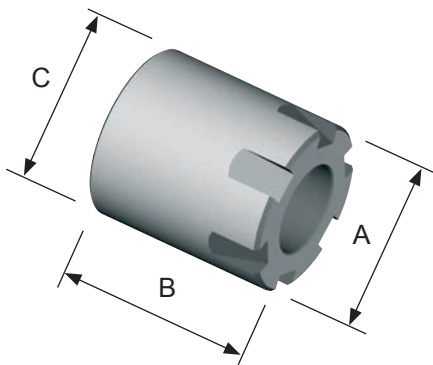


### ER-M



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

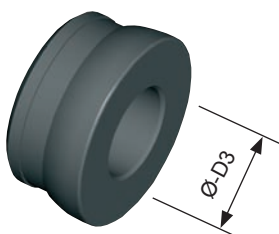
### ER-MA sealed



ER-MA	A	B	C
62 600 16-ER 16	22	24.5	M19x1
62 600 20-ER 20	28	26.5	M24x1
62 600 25-ER 25	35	27.5	M30x1

Dimensions in mm

## Sealing rings for chucking nuts ER-MA...



completed set:

Part number	Ø D3
64 600 16-ER 16	3.0-3.5...9.5-10.0 mm
64 600 20-ER 20	3.0-3.5...12.5-13.0 mm
64 600 25-ER 25	3.0-3.5...15.5-16.0 mm

Dimensions in mm

The sealing rings can be ordered separately.

Example:

Part number	Diameter range	possible from-up to
ER 16 64 600 16 <u>30</u>	3.01 - 3.50	3 - 10
ER 20 64 600 20 <u>45</u>	4.51 - 5.00	3 - 13
ER 25 64 600 25 <u>80</u>	8.01 - 8.50	3 - 16

Dimensions in mm

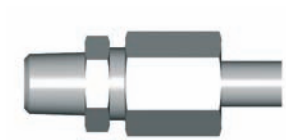


## Standard connection for through cooling

for pipe Ø 6 mm

Connection for through cooling  
004.00.19

M8 x 1



for pipe Ø 6 mm

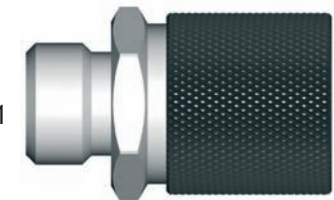


Connection for through cooling  
004.00.22

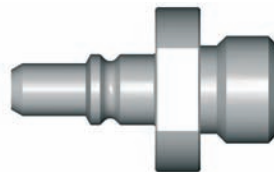
M8 x 1

## Clip connection for through cooling

M10 x 1

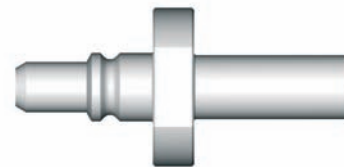


Clip connection  
004.00.49



Plug

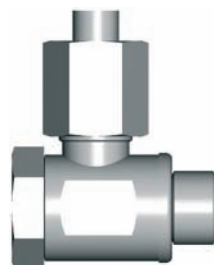
M8 x 1 - 004.00.56  
G1/8" - 004.00.57



Plug

Ø 6 mm - 004.00.59

for pipe Ø 6 mm



Coupling

M8 x 1 - 004.00.61  
G1/8" - 004.00.16

L