

HCG - HORN Catalog Guide

PARTING OFF

Depth of groove up to	Product line									
	217	264	S274	S223	S224		S229/229	S312/312		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	.020-.250		.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	0.5-6.35		1.5-3.0
Chapter	A	B	C	D	E	F	G	H	J	K

PARTING OFF P

Insert type	S274	264	312 S312	S316	S123	S223	S224	229 S229	S100	HCC
Depth of groove										
up to mm	6 mm	16 mm	8 mm	8 mm	25 mm	11 mm	18 mm	25 mm	55 mm	> 50 mm
up to inch	.236"	.630"	.315"	.315"	.984"	.433"	.709"	.984"	2.165"	> 1.968"

Width of groove										
~.057" (~1.44 mm)	•		•							
.059" (1.5 mm)	•	•	•							
.079" (2.0 mm)	•	•	•	•	•	•	•		•	
.098" (2.5 mm)		•	•	•		•	•		•	
.118" (3.0 mm)		•	•	•	•	•	•	•	•	
.158" (4.0 mm)								•	•	
.197" (5.0 mm)								•	•	
.236" (6.0 mm)								•	•	
.315" (8.0 mm)									•	
.394" (10.0 mm)									•	
.472" (12.0 mm)									•	
Page	P2-P5	P8-P13	P16-P28	P30-P31	P34-P38	P34-P36 P39-P41	P44-P58	P60-P72	P74-P107	P108-P109

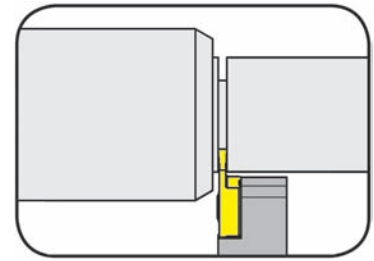
Toolholder type	H274	H264	360 368 391	H316	H223	H224	218 226	H100 NK100 220/300
DIN-Shank	•	•	•	•	•	•	•	•
Reinforced blade					•	•	•	•
Blade							•	•
Circular part-off tool								•
Page	P2-P3	P8-P11	P16-P20	P30	P34-P36	P44-P53	P60-P66	P74-P103

For Technical Information please see chapter Q

TOOLHOLDER Type

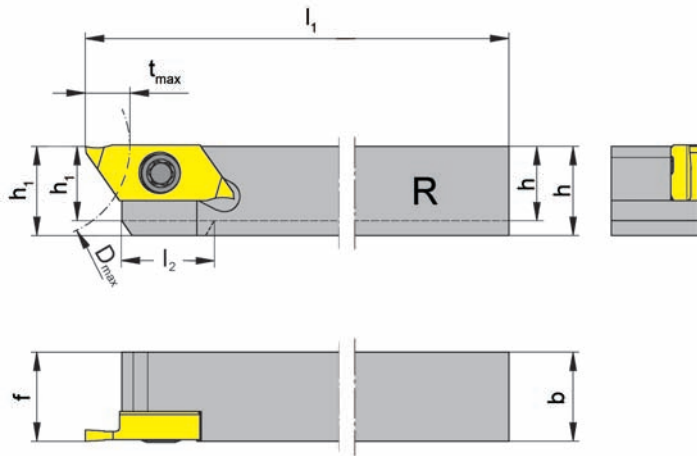
HU274

Depth of groove up to .236"
Width of groove up to .118"



for use with Indexable insert

Type S274



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	Size
R/LHU274.0312.04	.312	.312	3.996	.312	.312	.236	.984	04
R/LHU274.0375.04	.375	.375	3.996	.375	.375			
R/LHU274.0500.04	.500	.500	3.996	.500	.500			
R/LHU274.0625.04	.625	.625	5.118	.625	.625			
R/LHU274.0750.04	.750	.750	5.000	.750	.750			

State R or L version

Dimensions in inch

Further sizes upon request

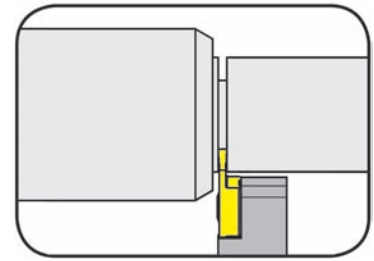
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHU274.0...	030.3509.T15P	T15PQ

TOOLHOLDER Type

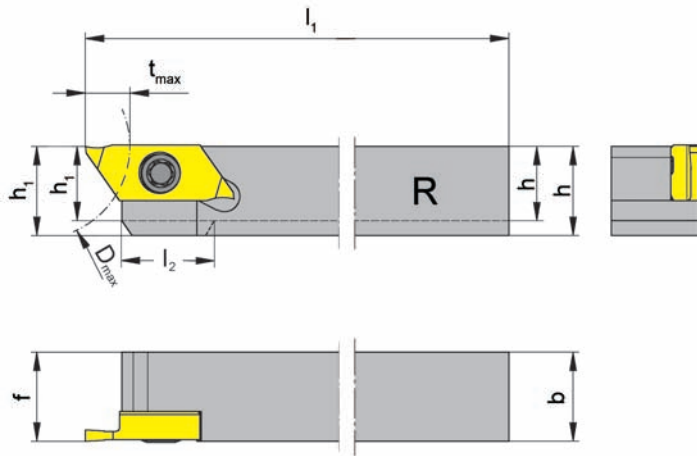
H274

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 ₁	h ₁	f	t _{max}	D _{max}	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

Spare parts

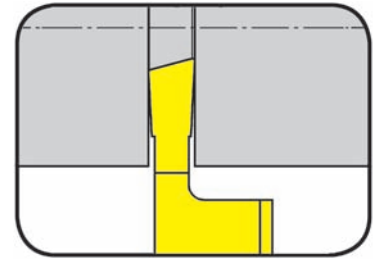
Toolholder	Screw	TORX PLUS® Wrench
R/LH274....	030.3509.T15P	T15PQ

INDEXABLE INSERT Type

S274

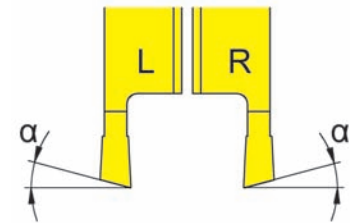
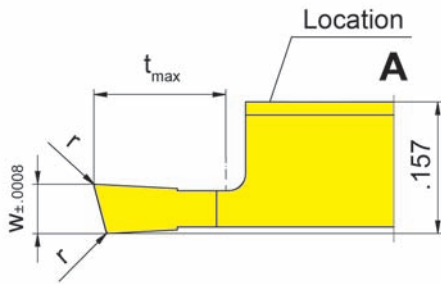
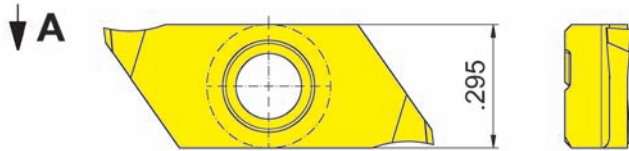
Depth of groove up to .236"
Width of groove .031 - .079"

precision ground



for use with Toolholder

Type H274
HU274



Indexability length
± .0006"

R = right hand version shown

L = left hand version

Part number	w	r	α	t _{max}	Size	Carbide grades					
						MG12	H54	TN35	TI25	TF46	TH35
R/LS274.1508.03.10	.031			.118	04						▲/▲
R/LS274.1510.03.10	.039	.002	15°	.118							▲/▲
R/LS274.1515.04.10	.059			.157							▲/▲
R/LS274.1520.06.10	.079			.236							▲/▲
<ul style="list-style-type: none"> ▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet 						P					●
						M					●
						K					●
						S					●
						N					●
						H					

Dimensions in inch

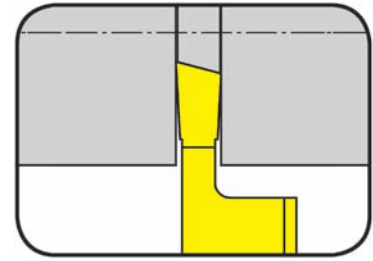
Carbide grades

State R or L version

t_{max} = .236" can be reached only with workpiece Ø ≤ .984"

INDEXABLE INSERT Type

S274

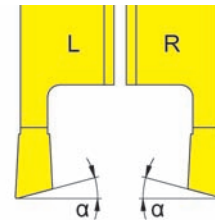
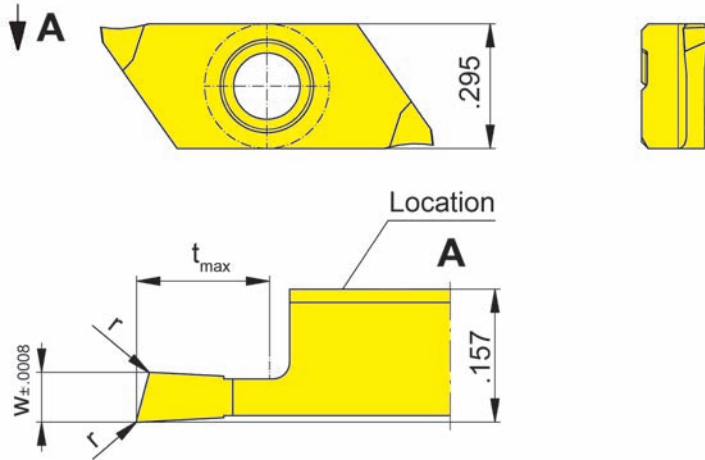


Depth of groove up to .236"
 Width of groove .031 - .079"

precision ground

for use with Toolholder

Type H274
 HU274



Indexability length
± .0006"

R = right hand version shown

L = left hand version

Part number	w	r	α	t _{max}	Size	Carbide grades		
						TN35	TI25	TH35
LS274.1508.03.10R	.031			.118	04			▲
LS274.1510.03.10R	.039			.118				▲
LS274.1515.04.10R	.059	.002	15°	.157				▲
LS274.1520.06.10R	.079			.236				▲
RS274.1508.03.10L	.031			.118	04			▲
RS274.1510.03.10L	.039			.118				▲
RS274.1515.04.10L	.059	.002	15°	.157				▲
RS274.1520.06.10L	.079			.236				▲
▲ 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

Note:

t_{max} = .236" can be reached only with workpiece Ø ≤ .984"

HORN - THE LEADERS IN GROOVING TECHNOLOGY



High Performance Reaming

SYSTEM DR

URMA Licence

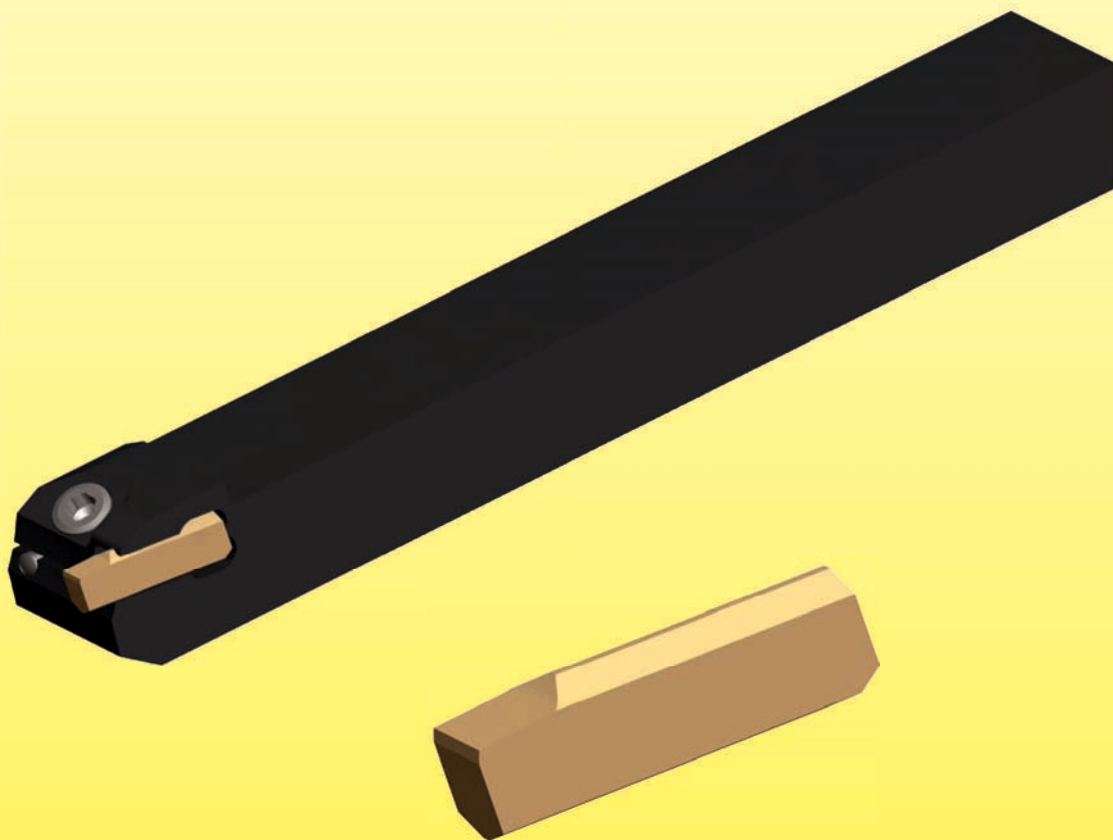
Large selection of base material, coatings and geometries.
High repeatability when replacing inserts
Diameters from 11.9 mm - 140.6 mm.

HORN - INTELLIGENT TOOL DESIGN AT WORK.



For further information, please contact HORN USA.

Grooving and Parting off with Toolholder type H264 and Indexable Inserts type 264

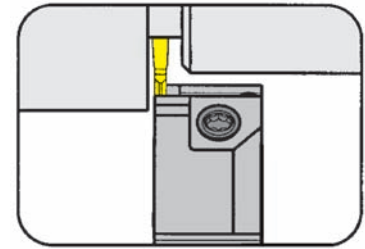


TOOLHOLDER Type

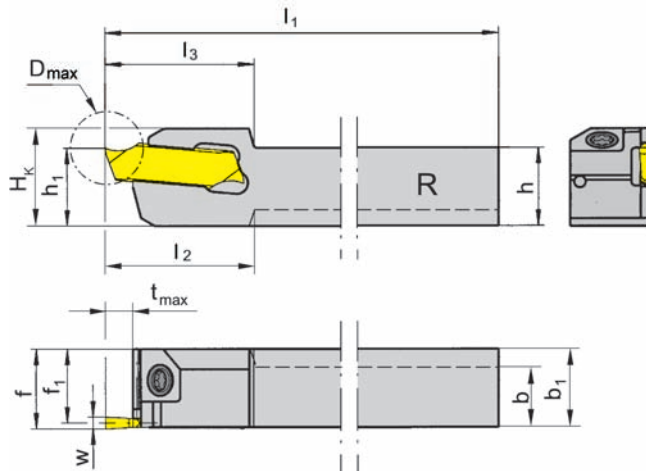
H264

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 ₁	h ₁	b ₁	f ₁	f	l ₂	t _{max}	w	D _{max}	l ₃	H _k	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	-					14.5	02
R/LH264.1616.22	16	16		16	-	15.00	16	-	16	2.0	32	25.0	19.5	

State R or L version

Further sizes upon request

Dimensions in mm

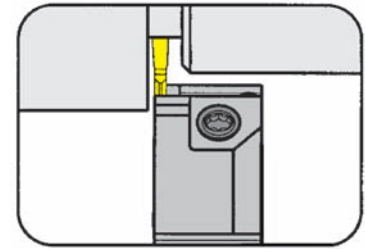
Spare parts

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

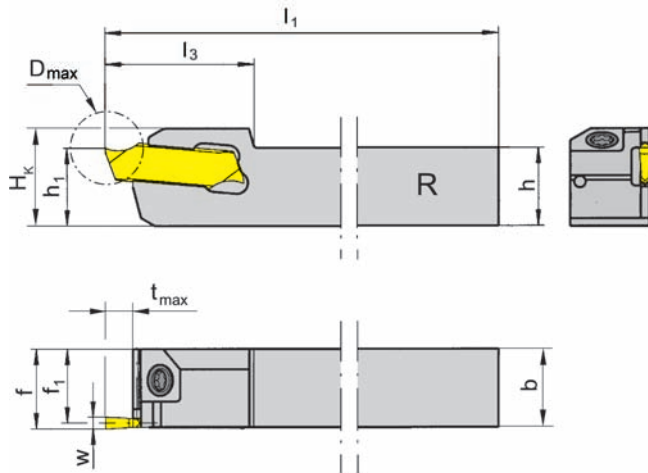
TOOLHOLDER Type

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 ₁	h ₁	f ₁	f	t _{max}	w	D _{max}	l ₃	H _k	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

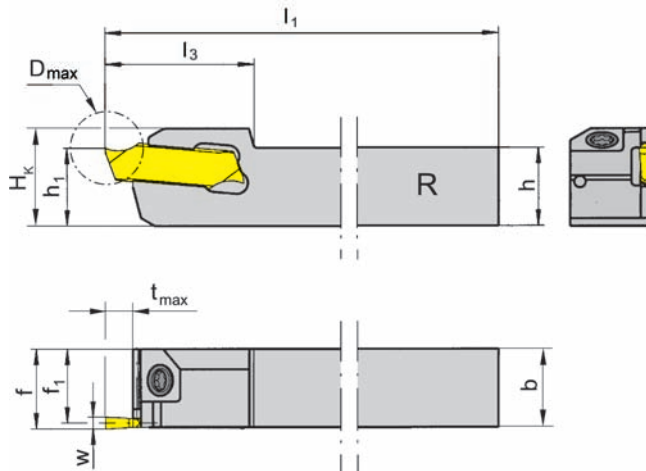
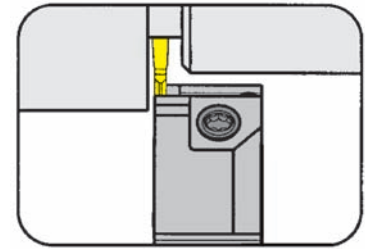
Toolholder	Screw	TORX PLUS® Wrench
R/LH264.1...	3.5.12T10EP	T10PL

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 ₁	h ₁	f ₁	f	t _{max}	w	D _{max}	l ₃	H _k	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

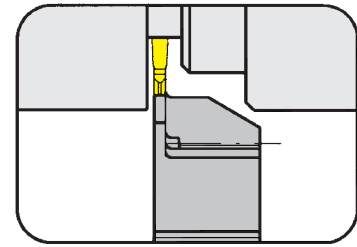
Spare parts

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

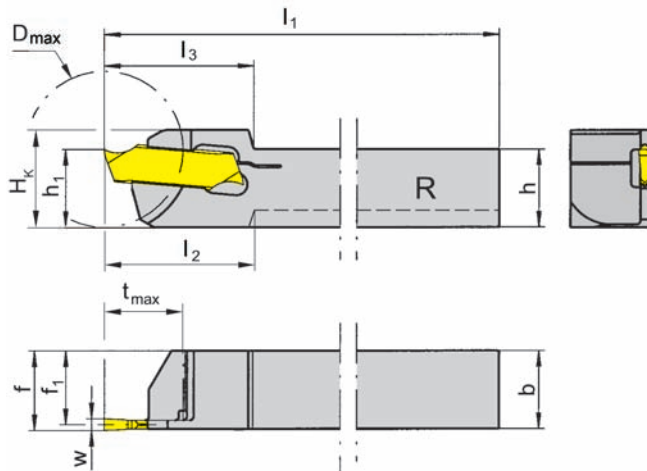
TOOLHOLDER Type

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 ₁	h ₁	f ₁	f	I ₂	t _{max}	w	D _{max}	I ₃	H _k	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

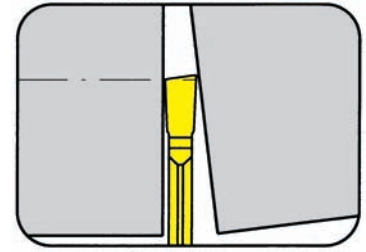
Toolholder	Wrench
R/LH264....	P39L

INDEXABLE INSERT Type

264

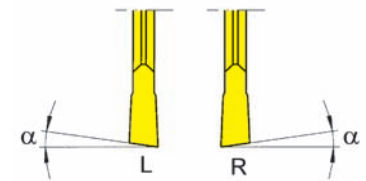
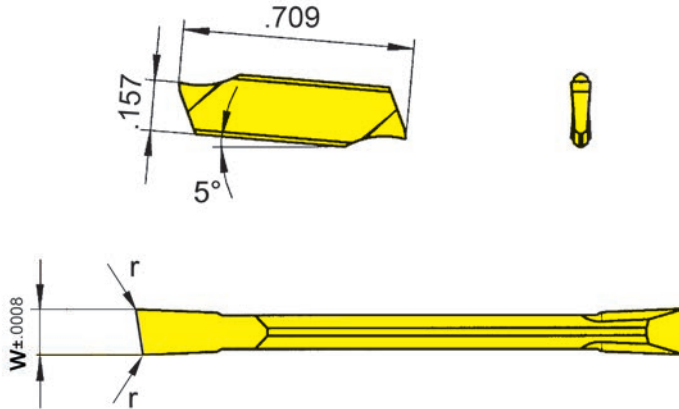
Depth of groove up to .630"
Width of groove .059 - .118"

precision ground



for use with Toolholder

Type H264



R = right hand version shown

L = left hand version

Indexability length
± .0006"

Part number	w	r	α	Size	Carbide grades			
					MG12	TN35	Ti25	TA45
R/L264.0815.10 R/L264.1515.10	.059	.002	15°	01	Δ/▲ ▲/▲	▲/▲ ▲/▲		
R/L264.0820.10 R/L264.1520.10	.079	.002	8° 15°	02	▲/▲ ▲/▲	▲/▲ ▲/▲		
R/L264.0825.10 R/L264.1525.10	.098	.004	8° 15°	03		▲/▲ ▲/▲		
R/L264.0830.10 R/L264.1530.10	.118	.004	8° 15°	04		▲/▲ ▲/▲		
▲ 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

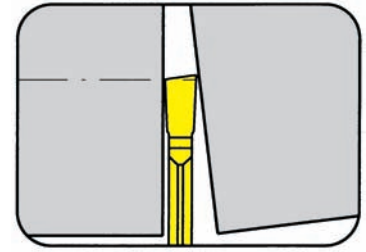
Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

264

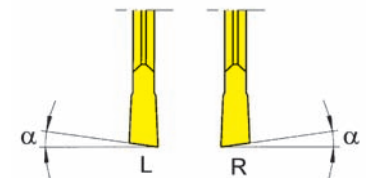
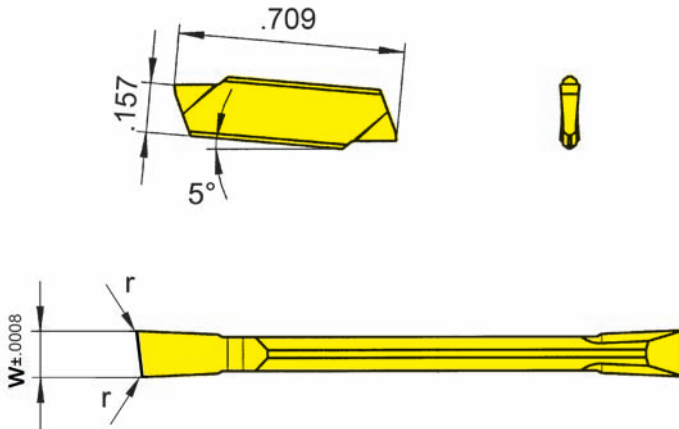
Depth of groove up to .630"
Width of groove .059 - .118"

precision ground



for use with Toolholder

Type H264



R = right hand version shown

L = left hand version

Indexability length
± .0006"

Part number	w	r	α	Size	Carbide grades			
					MG12	TN35	Ti25	TA45
R/L264.0815.M0 R/L264.1515.M0	.059	.002	8° 15°	01	▲/▲ ▲/▲	▲/▲ ▲/▲		
R/L264.0820.M0 R/L264.1520.M0	.079	.002	8° 15°	02	▲/▲ ▲/▲	▲/▲ ▲/▲		
R/L264.0825.M0 R/L264.1525.M0	.098	.004	8° 15°	03	/▲ ▲/▲	▲/▲ ▲/		
R/L264.0830.M0 R/L264.1530.M0	.118	.004	8° 15°	04	/▲ ▲/▲	▲/▲ ▲/▲		
<ul style="list-style-type: none"> ▲ 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

Indexable inserts can be used in **right and left hand** toolholders.

HORN - THE LEADERS IN GROOVING TECHNOLOGY



GROOVE MILLING BY CIRCULAR INTERPOLATION

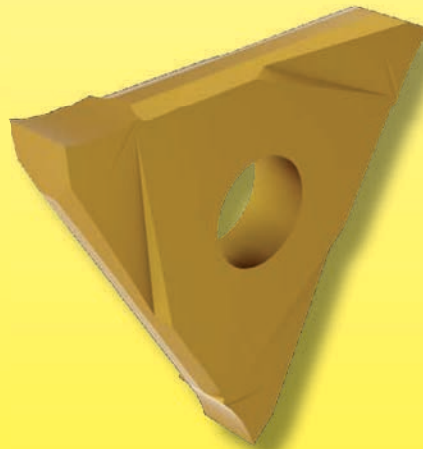
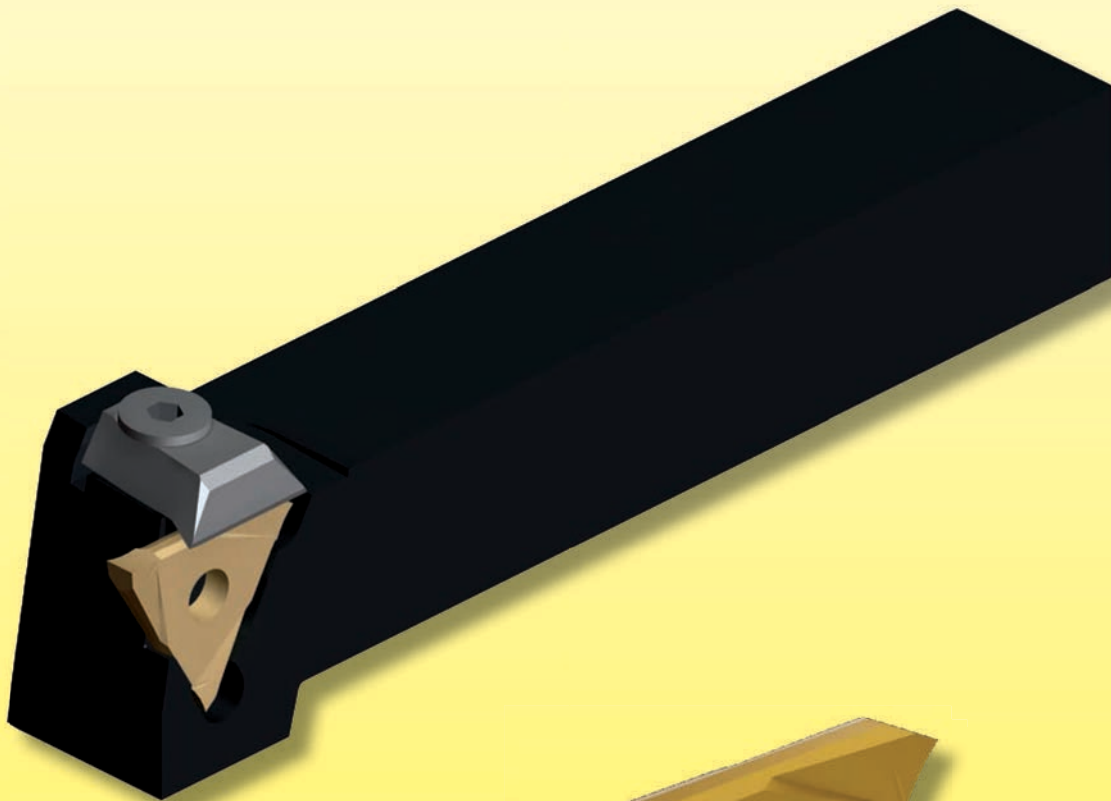
SYSTEM DC

- Thread Milling Partial Profile
- Thread Milling Full Profile
- Groove Milling
- Chamfer Milling

HORN - INTELLIGENT TOOL DESIGN AT WORK.

For further information, please contact HORN USA.

Grooving and Parting off with Indexable Inserts type 312

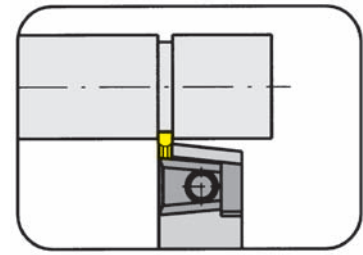


TOOLHOLDER Type

U360

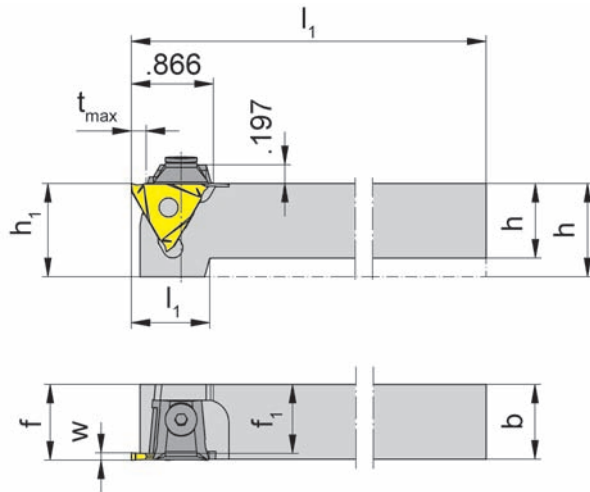
Depth of groove up to
Clamping range

.236"
.075 - .114"



for use with Indexable
insert

Type 312
U312
S312
US312



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	Size	Clamping range
R/LU360.0500.02	.500	.500	4.000	1.000	.402		.944			
R/LU360.0625.02	.625	.625	5.000	1.000	.527		.866			
R/LU360.0750.02	.750	.750	5.000	1.000	.652	f_1+w-a_1	.826	.236	02	.075 - .114
R/LU360.1000.02	1.000	1.000	6.000	1.000	.902		-			
R/LU360.1250.02	1.250	1.250	6.625	1.250	1.152		-			

State R or L version

w, a_1 see indexable inserts

Dimensions in inch

Further sizes upon request

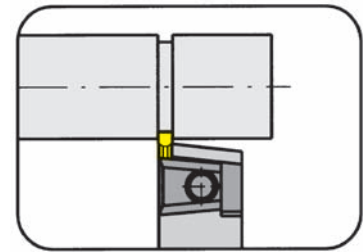
t_{max} can be reached only with workpiece $\varnothing \leq 1.575"$

Spare parts

Toolholder	Clamp	Screw	Wrench
R/LU360.0500...02	11.3	6.25	SW3DIN911
R/LU360.0625...02	11.3	6.25	SW3DIN911
R/LU360....02	16.4	6.25	SW3DIN911

TOOLHOLDER Type

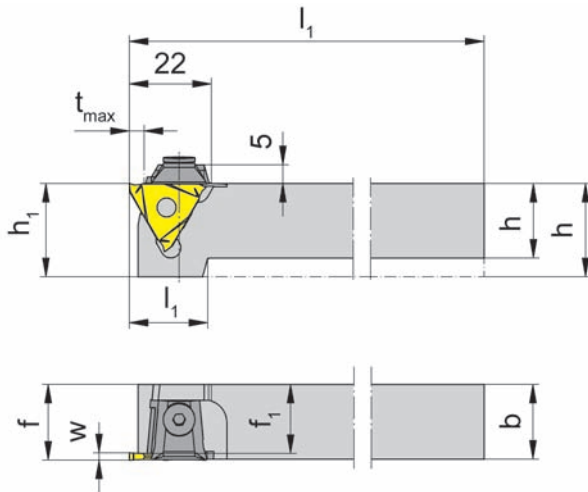
360



Depth of groove up to .236" (6.0 mm)
Clamping range .075 - .114" (1.9 - 2.9 mm)

for use with Indexable insert

Type 312
S312
U312
US312



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	Size	Clamping range
R/L360.1212.02	12	12	100	25	9.5		24			
R/L360.1616.02	16	16	125	25	13.5		22			
R/L360.2020.02	20	20	125	25	17.5	f ₁ +w-a ₁	21	6	02	1.9 - 2.9
R/L360.2525.02	25	25	150	25	22.5		-			
R/L360.3232.02	32	32	170	32	29.5		-			

State R or L version

w, a₁ see indexable inserts

Dimensions in mm

Further sizes upon request

t_{max} can be reached only with workpiece Ø ≤ 40 mm

Spare parts

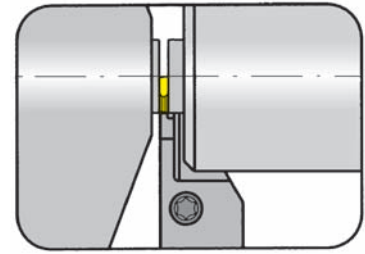
Toolholder	Clamp	Screw	Wrench
R/L360.1212.02	11.3	6.25	SW3DIN911
R/L360.1616.02	11.3	6.25	SW3DIN911
R/L360....02	16.4	6.25	SW3DIN911

TOOLHOLDER Type

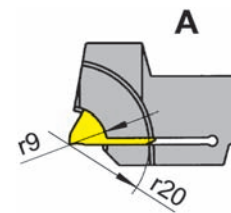
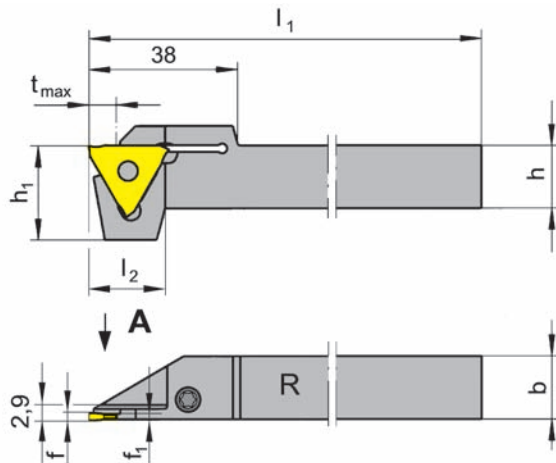
368

Depth of groove up to .315" (8.0 mm)
Clamping range .020 - .059" (0.5 - 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 ₁	h ₁	f ₁	f	l ₂	t _{max}	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 ₁ +a ₁	19.5	8	01	0.5 - 1.9
R/L368.1616.11	16	16			1.3					

State R or L version

a₁ 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

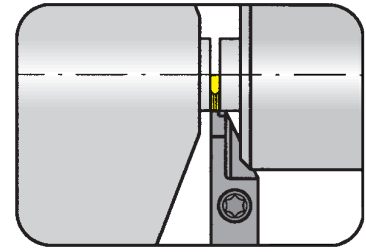
Spare parts

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

TOOLHOLDER Type

368

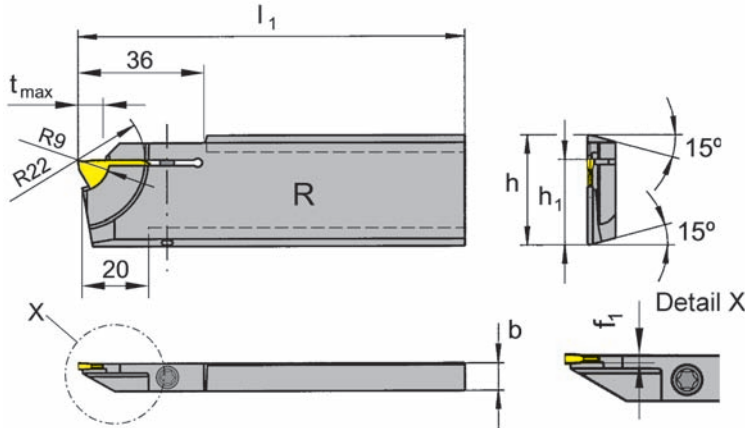
reinforced version



Depth of groove up to .315" (8.0 mm)
Clamping range .020 - .059" (0.5 - 1.5 mm)

for use with Indexable insert

Type 312
U312



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	Size	Clamping range
R/L368.2608.08	26			21.4	1.0			
R/L368.3208.08	32			24.8	1.0			
R/L368.2608.11	26	8	110	21.4	1.3	8	01	0.5 - 1.9
R/L368.3208.11	32			24.8	1.3			

State R or L version

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

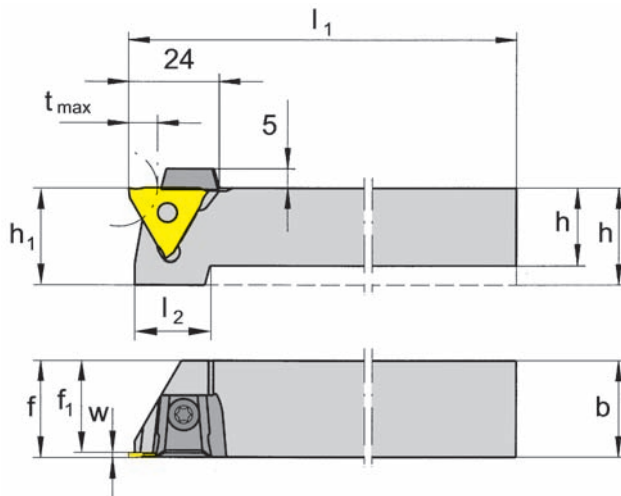
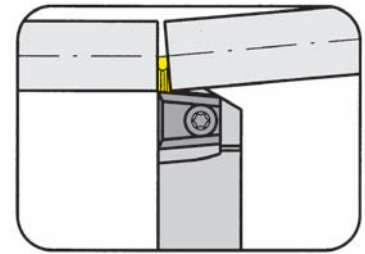
Spare parts

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

TOOLHOLDER Type

391

Depth of groove up to $.315''$ (8.0 mm)
Clamping range $.020 - .075''$ (0.5 - 1.9 mm)



R = right hand version shown

L = left hand version

for use with Indexable insert

Type 312
N312
S312
U312
US312

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	Size	Clamping range
R/L391.1212.01	12	12	100	21	10.5	$f_1 + w - a_1$	21	8	01	0.5-1.9
R/L391.1616.01	16	16	125	21	14.5		21			
R/L391.2020.01	20	20	125	21	18.5		21			
R/L391.2525.01	25	25	150	25	23.8	-	-			

State R or L version

w, a_1 see indexable inserts

Dimensions in mm

Further sizes upon request

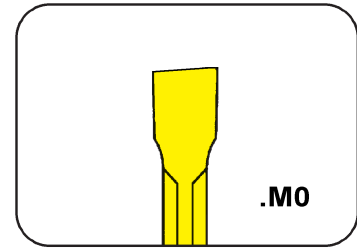
 t_{max} can be reached only with workpiece $\varnothing \leq 20$ mm**Spare parts**

Toolholder	Clamp	Screw	Wrench	TORX PLUS® Wrench
R/L391.1212.01	12.3	030.0422.T10P	SW3DIN911	T10PL
R/L391.1616.01	14.4	5.32.3T15P		T15PQ
R/L391.2...01	16.4	6.25		

INDEXABLE INSERT Type

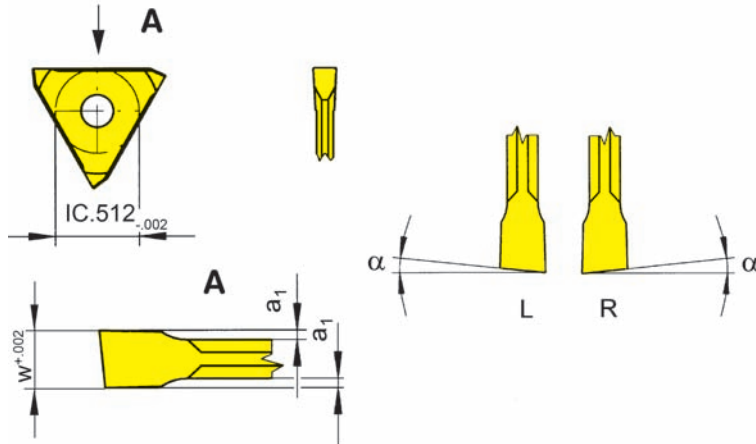
312

Depth of groove up to .315"
Width of groove .047 - .059"



for use with Toolholder

Type 368 / U368



R = right hand version shown

L = left hand version

Part number	w	a ₁	α	Size	Carbide grades			
					K10	TN35	TF45	TC92
R/L312.0512.M0	.047	.008	5°	01	/Δ		▲/Δ	
R/L312.0515.M0	.059	.008	5°	01	▲/		▲/Δ	
					P	•	•	•
					M	○	•	•
					K	•	•	•
					S	○	•	•
					N	•	•	•
					H			

Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

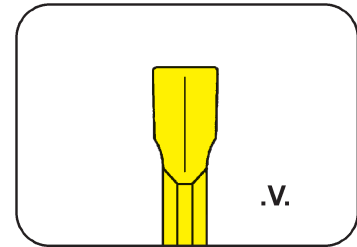
- ▲ on stock Δ 4 weeks
- main recommendation
- alternative recommendation
- uncoated grades
- coated grades
- brazed/Cermet

Carbide grades

INDEXABLE INSERT Type

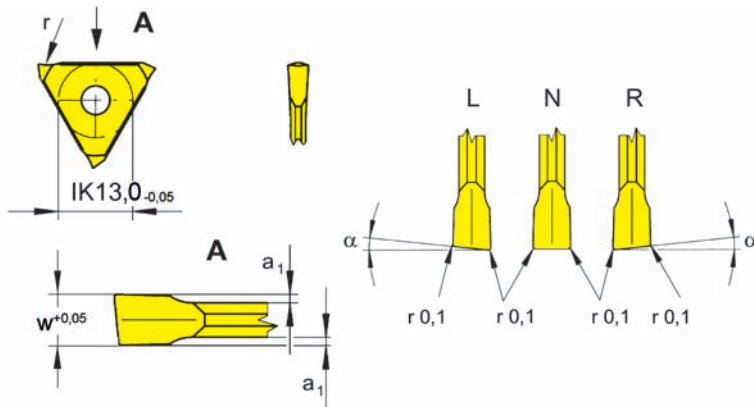
312

Depth of groove up to .315"
 Width of groove .047 - .079"



for use with Toolholder

Type 368



R = right hand version shown

L = left hand version

Part number	w	a ₁	α	Size	TN35	Tl25	TF45	TH35
312.0012.V1 R/L312.0512.V1	.047	.008	0° 5°	01			▲ ▲/Δ	
312.0015.V1 R/L312.0515.V1	.059	.008	0° 5°	01			▲ ▲/▲	
R/L312.0520.V2	.079	.008	5°	01				▲/
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P		●	●
					M		●	●
					K		●	●
					S		●	●
					N		●	●
					H			

Dimensions in mm

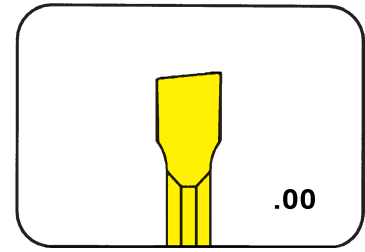
State R or L version

Carbide grades

INDEXABLE INSERT Type

312

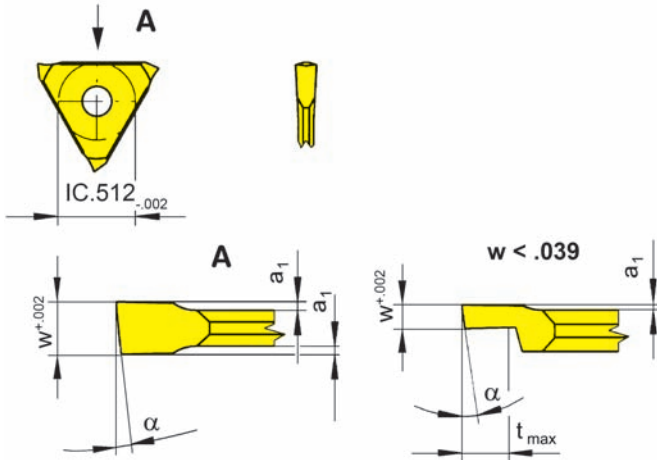
with round chip breaker



Depth of groove up to .315"
Width of groove .020 - .059"

for use with Toolholder

Type 368 / U368



R = right hand version shown

L = left hand version

Part number	w	t _{max}	a ₁	α	Size	Carbide grades			
						K10	TN35	TF45	TC92
R/L312.0805.00	.020	.039	.004	8°	01			▲/▲	
R/L312.0808.00	.031	.059	.004	8°				▲/▲	
R/L312.1210.00	.039	.315	.004	12°			▲/▲	▲/▲	
R/L312.0510.00	.039	.315	.004	5°				▲/▲	
R/L312.0512.00	.047	.315	.008	5°				▲/▲	
R/L312.0515.00	.059	.315	.008	5°				▲/▲	
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet						P	●	●	
						M	●	●	
						K	●	●	
						S	●	●	
						N	●	●	
						H			

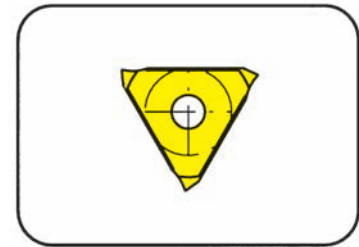
Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

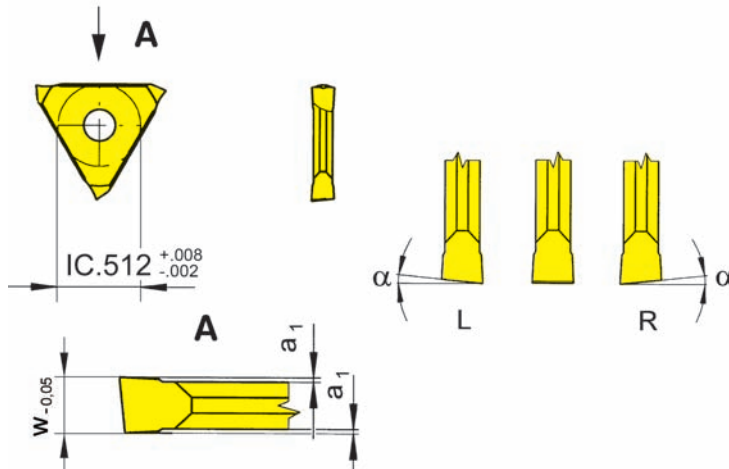
312



Depth of groove up to .197"
 Width of groove .042 - .057"

for use with Toolholder

Type 360 / U360



Part number	w	α	a ₁	Size	Carbide grades									
					K10	MG12	P20	H54	TN32	TN35	TI25	TF45	TF46	TC92
312.0100.00	.042	0°	.004	01 / 02	▲		▲		▲	▲		▲	▲	
312.0130.00	.057	0°	.008	01 / 02	▲		▲		▲	▲		▲	▲	▲
R/L312.0614.00		6°					▲/▲	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲	
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P	●		●	●	●	●	●	●	●
					M	○			●	●	●	●	○	
					K	●			●	●	●	●	●	●
					S	○				●	●	●	○	
					N	●				●	●	●	●	
					H									

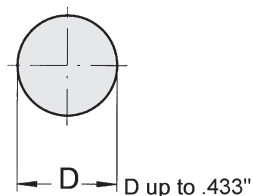
Dimensions in inch

State R or L version

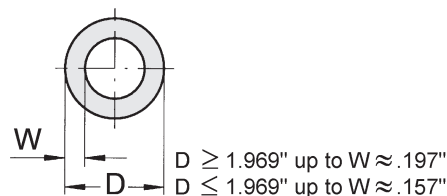
Carbide grades

Indexable inserts can be used in **right and left hand** toolholders.

Parting off solid bars



Parting off tubes

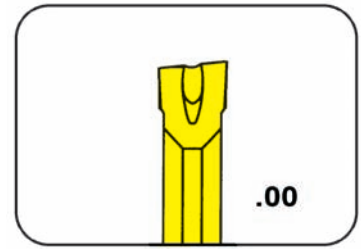


GROOVING and PARTING OFF



INDEXABLE INSERT Type

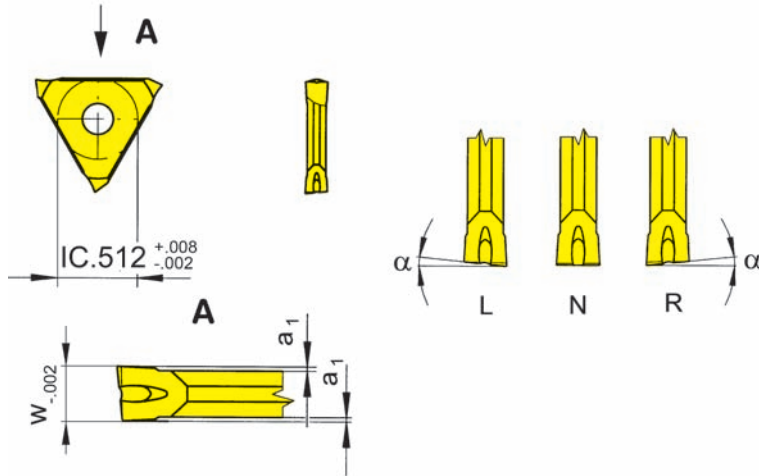
312



Depth of groove up to .197"
Width of groove .057 - .090"

for use with Toolholder

Type 360 / U360



R = right hand version shown

L = left hand version

Part number	w	a ₁	α	Size	Carbide grades								
					K10	P20	TN32	TN35	TI25	TF45	TF46	TC92	
N312.0014.00	.057	.008	0°	01 / 02						▲			
N312.0018.00	.078		0°							▲			▲
R/L312.0518.00	.078		5°		▲▲	▲▲	▲▲	▲▲					
N312.0021.00	.090	.008	0°	02				▲					
R/L312.0521.00	.090		5°		▲▲	▲▲	▲▲	▲▲					
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P	●	●	●		●		●	
					M			●		●			
					K			●		●			
					S			●		●			
					N			●		●			
					H								

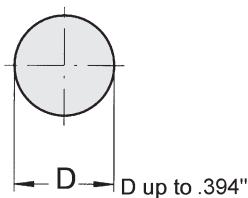
Dimensions in inch

Carbide grades

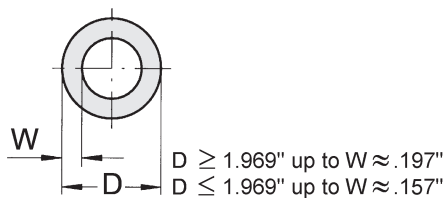
State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

Parting off solid bars



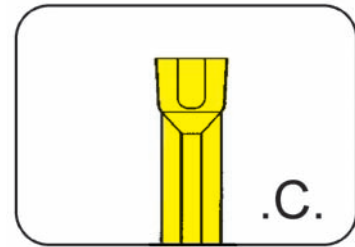
Parting off tubes



INDEXABLE INSERT Type

S312

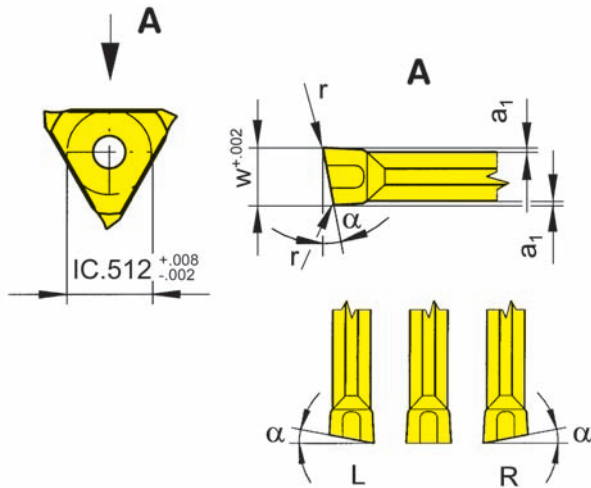
with sintered geometries



Depth of groove up to $.197''$
 Width of groove $.079 - .118''$

for use with Toolholder

Type 360 / U360
 361
 369 / U369



R = right hand version shown

L = left hand version

Geometry .C

Part number	w	r	a ₁	α	Size	Carbide grades						
						K10	P20	TN32	TI25	TF45	TF46	TC92
S312.0200.C2 R/LS312.0520.C2	.079	.008	.010	0° 5°	02				▲		▲	
S312.0250.C2 R/LS312.0525.C2	.098	.008	.010	0° 5°	02				▲		▲	
S312.0300.C2 R/LS312.0530.C2	.118	.008	.010	0° 5°	03				▲		▲	
▲ 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

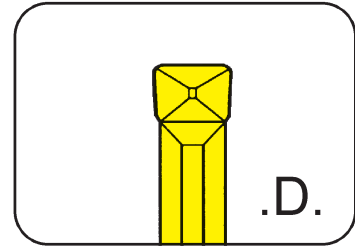
Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

S312

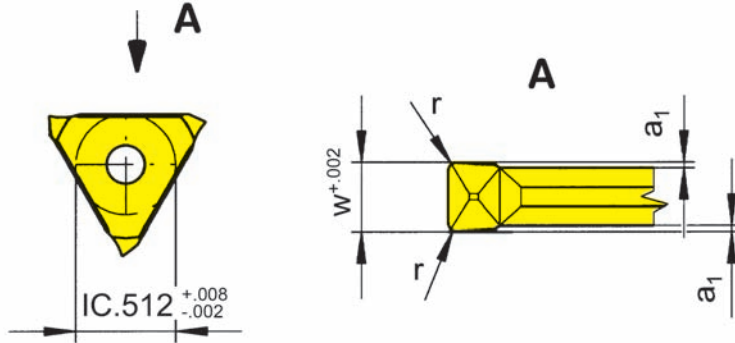
with sintered geometries

Depth of groove up to .197"
Width of groove .079 - .118"



for use with Toolholder

- Type 330 / U330
360 / U360
361
369 / U369
390 / U390



Geometry .D

Part number	w	r	a ₁	Size	Carbide grades													
					TN32	T125	TF45	TF46	TC92	AS62	AS66	P	M	K	S	N	H	
S312.0200.D2 S312.0200.D4	.079	.008 .016	.010	02	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
S312.0250.D2 S312.0250.D4	.098	.008 .016	.010	02	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
S312.0300.D2 S312.0300.D4	.118	.008 .016	.010	03	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P	●	●	●	●	●	●	●	●	●	●	●	●	●
					M	●	●	○	●	●	●	●	●	●	●	●	●	○
					K	●	●	●	●	●	●	●	●	●	●	●	●	●
					S	●	●	○	●	●	●	●	●	●	●	●	●	○
					N	●	●	●	●	●	●	●	●	●	●	●	●	●
					H	●	●	●	●	●	●	●	●	●	●	●	●	●

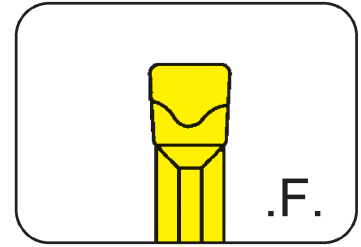
Dimensions in mm

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

S312

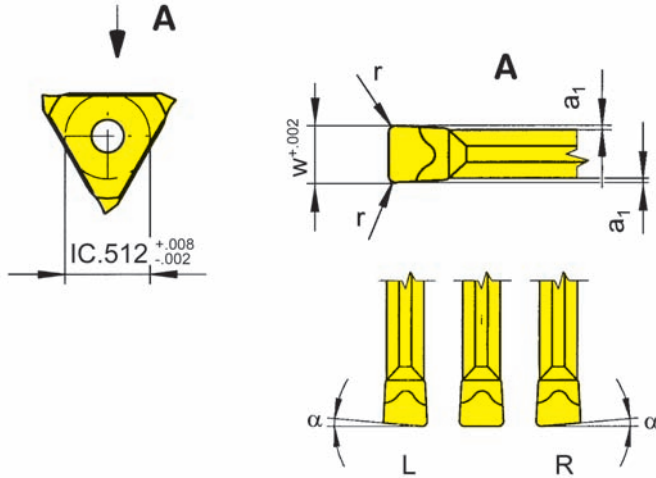
with sintered geometries



Depth of groove up to .197"
Width of groove .079 - .098"

for use with Toolholder

- Type 330 / U330
360 / U360
361
369 / U369
390 / U390



R = right hand version

L = left hand version

Geometry .F.

Part number	w	r	a ₁	α	Size	Carbide grades									
						K10	MG12	P20	TN32	TN35	TI25	TF45	TF46	TC92	AL96
R/LS312.0520.F2 S312.0200.F2	.079	.008	.010	5° 0°	02						▲/▲		▲/▲		
R/LS312.0525.F2 S312.0250.F2	.098	.008	.010	5° 0°	02						▲/▲		▲/▲		
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet						P					●		●		
						M					●		○		
						K					●		●		
						S					●		○		
						N					●		●		
						H									

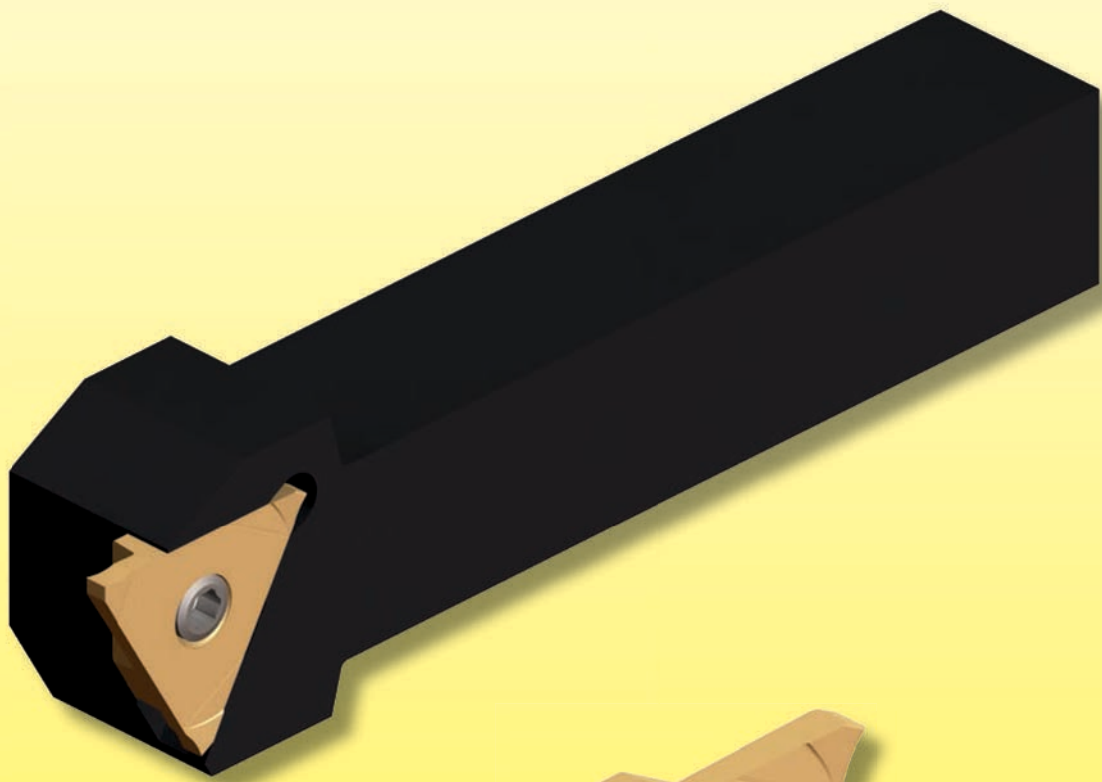
Dimensions in mm

Carbide grades

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

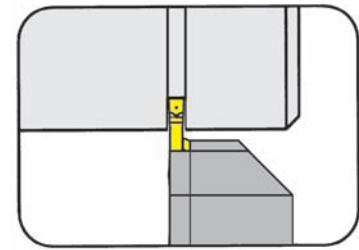
Grooving and Parting off with Indexable Inserts type 316



TOOLHOLDER Type

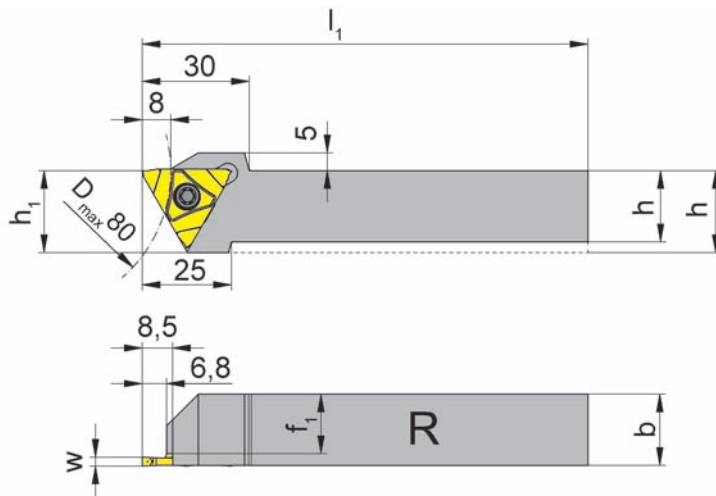
H316

Depth of groove up to .315" (8.0 mm)
 Width of groove up to .059 - .118" (1.5 - 3.0 mm)



for use with Indexable insert

Type S316



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	Size
R/LH316.1616.S3.03	16	16	125	23	12.7	03
R/LH316.2020.S3.03	20	20	125	23	16.7	
R/LH316.2525.S3.03	25	25	150	25	21.7	
R/LH316.3225.S3.03	32	25	150	32	21.7	

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

Spare parts

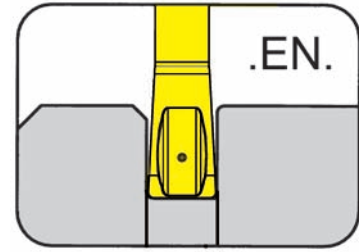
Toolholder	Screw	TORX PLUS® Wrench
R/LH316....	5.12T20P	T20PQ

GROOVING and PARTING OFF



INDEXABLE INSERT Type

S316

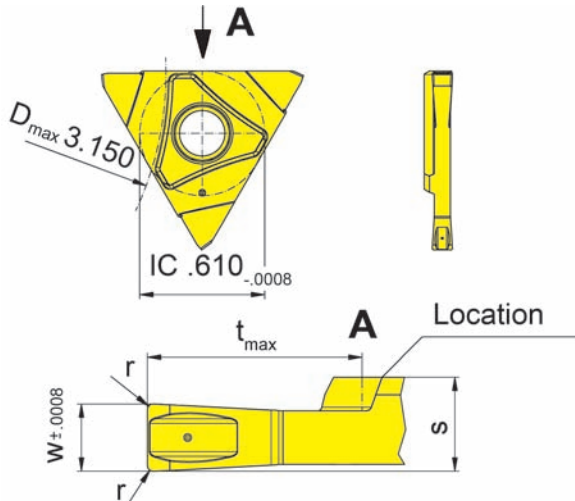


Depth of groove up to .315"
Width of groove .079 - .118"

precision sintered

for use with Toolholder

Type H316...S3.03



R = right hand version shown

L = left hand version

Indexability length
± .001"

Part number	w	r	s	t _{max}	Size	TN35	TI25	TF45	TF46	AS6G
R/LS316.0200.EN2	.079									▲/▲
R/LS316.0250.EN2	.098	.008	.138	.315	03					▲/▲
R/LS316.0300.EN2	.118									▲/▲
						P				•
						M				•
						K				•
						S				•
						N				•
						H				

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

Carbide grades

Dimensions in inch

State R or L version

External machining:

Use right hand inserts in right hand toolholders and left hand inserts in left hand toolholders

HORN - THE LEADERS IN GROOVING TECHNOLOGY



Maximize your milling advantage

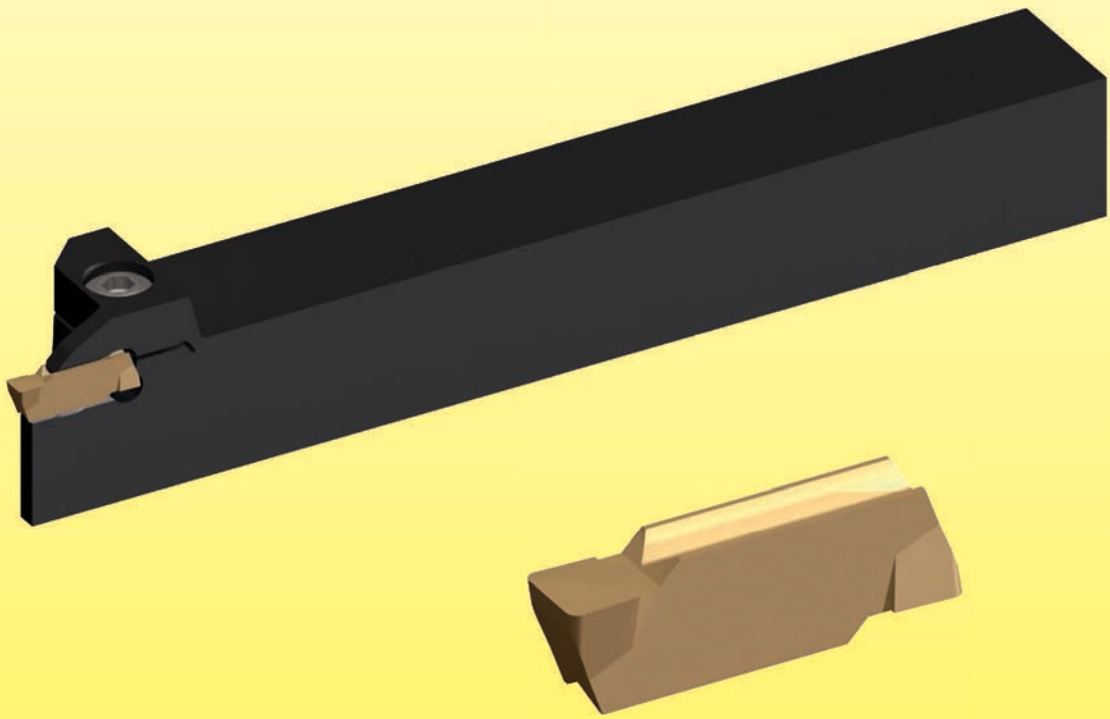
SYSTEM DA

HORN - INTELLIGENT TOOL DESIGN AT WORK.



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

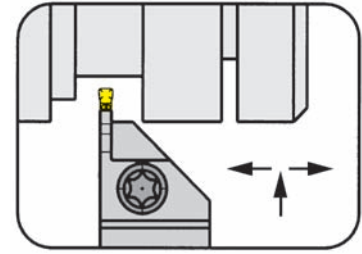
**Indexable Insert type S223 + S123
with chip forming
- precision sintered -**



Width of groove	.079 - .118"
Depth of groove up to	.984"

TOOLHOLDER Type

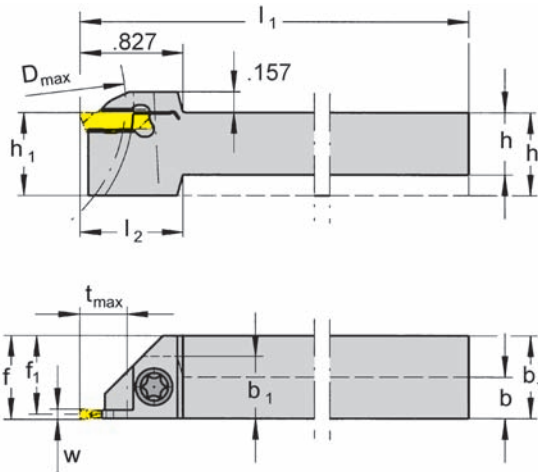
HU223



Depth of groove up to .394"
Clamping range .079 - .118"

for use with Insert

Type S123
S223



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	b ₁	t _{max}	D _{max}	Size	Clamping range
R/LHU223.0375.01	.375	.375	3.125	.500	f ₁ +w/2	.344	.750	.500	.315	.984	01	.079
R/LHU223.0500.01	.500	.500	4.000	.500		.469	-	-	.394	1.968		
R/LHU223.0625.01	.625	.625	5.000	.625		.594	-	-	.394	1.968		
R/LHU223.0750.01	.750	.750	5.000	.750		.719	-	-	.394	1.968		
R/LHU223.1000.01	1.000	1.000	6.000	1.000		.969	-	-	.394	1.968		
R/LHU223.0375.02	.375	.375	3.125	.500	f ₁ +w/2	.344	.750	.500	.315	.984	02	.098
R/LHU223.0500.02	.500	.500	4.000	.500		.469	-	-	.394	1.968		
R/LHU223.0625.02	.625	.625	5.000	.625		.594	-	-	.394	1.968		
R/LHU223.0750.02	.750	.750	5.000	.750		.719	-	-	.394	1.968		
R/LHU223.1000.02	1.000	1.000	6.000	1.000		.969	-	-	.394	1.968		
R/LHU223.0500.03	.500	.500	4.000	.500	f ₁ +w/2	.469	-	-	.394	1.968	03	.118
R/LHU223.0625.03	.625	.625	5.000	.625		.594						
R/LHU223.0750.03	.750	.750	5.000	.750		.719						
R/LHU223.1000.03	1.000	1.000	6.000	1.000		.969						

State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

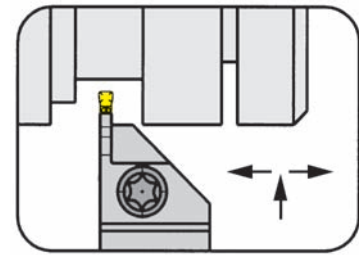
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHU223....	5.11T15P	T15PL

TOOLHOLDER Type

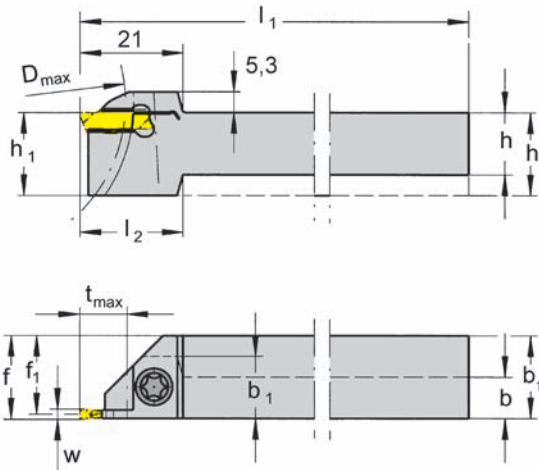
H223

Depth of groove up to .394" (10.0 mm)
Clamping range 2.0 - 3.0 mm



for use with Insert

Type S123
S223



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	b ₁	t _{max}	D _{max}	Size	Clamping range
R/LH223.1010.01	10	10	80	12	f ₁ +w/2	9.20	20	12	8	25	01	2.0
R/LH223.1212.01	12	12	100	16		11.20	21	-	10	50		
R/LH223.1616.01	16	16	125	16		15.20	-	-	10	50		
R/LH223.2020.01	20	20	125	20		19.20	-	-	10	50		
R/LH223.2525.01	25	25	150	25		24.20	-	-	10	50		
R/LH223.1010.02	10	10	80	12	f ₁ +w/2	9.05	20	12	8	25	02	2.5
R/LH223.1212.02	12	12	100	16		11.05	21	-	10	50		
R/LH223.1616.02	16	16	125	16		15.05	-	-	10	50		
R/LH223.2020.02	20	20	125	20		19.05	-	-	10	50		
R/LH223.2525.02	25	25	150	25		24.05	-	-	10	50		
R/LH223.1010.03	10	10	80	12	f ₁ +w/2	8.80	20	12	8	25	03	3.0
R/LH223.1212.03	12	12	100	16		10.80	21	-	10	50		
R/LH223.1616.03	16	16	125	16		14.80	-	-	10	50		
R/LH223.2020.03	20	20	125	20		18.80	-	-	10	50		
R/LH223.2525.03	25	25	150	25		23.80	-	-	10	50		

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

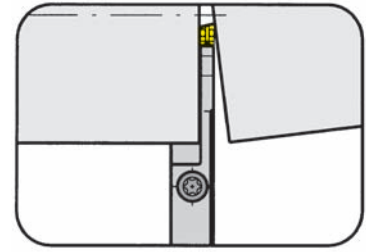
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH223....	5.11T15P	T15PL

TOOLHOLDER Type

H223

reinforced version

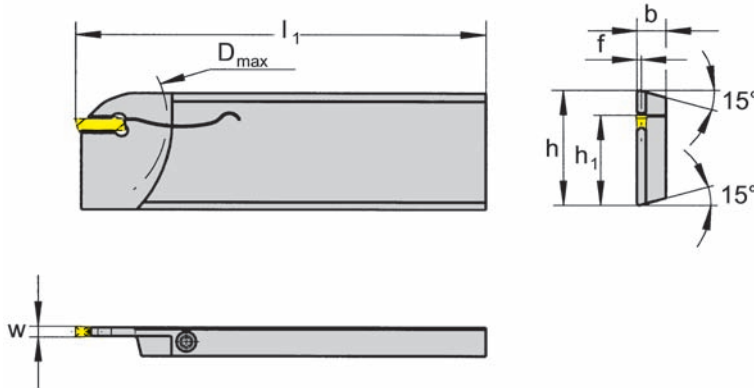


Depth of groove up to
Clamping range up to

.984" (25.0 mm)
.118" (3.0 mm)

for use with Insert

Type S123
S223



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	D _{max}	Size	Clamping range
R/LH223.2608.01 R/LH223.3208.01	26 32	7.9	110	21.4 24.8	0.80	50	01	2.0
R/LH223.2608.02 R/LH223.3208.02	26 32	7.9	110	21.4 24.8	0.95	50	02	2.5
R/LH223.2608.03 R/LH223.3208.03	26 32	7.9	110	21.4 24.8	1.20	50	03	3.0

State R or L version

w see indexable inserts

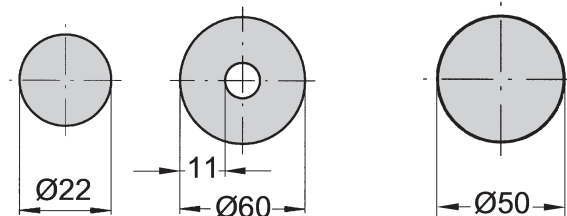
Dimensions in mm

Further sizes upon request

Parting off:

Solid bars or Tubes (S223)

Solid bars (S123)



Spare parts

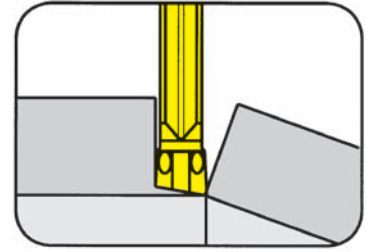
Toolholder	Screw	TORX PLUS® Wrench
R/LH223....	4.15T15P	T15PL

GROOVING and PARTING OFF



INSERT Type

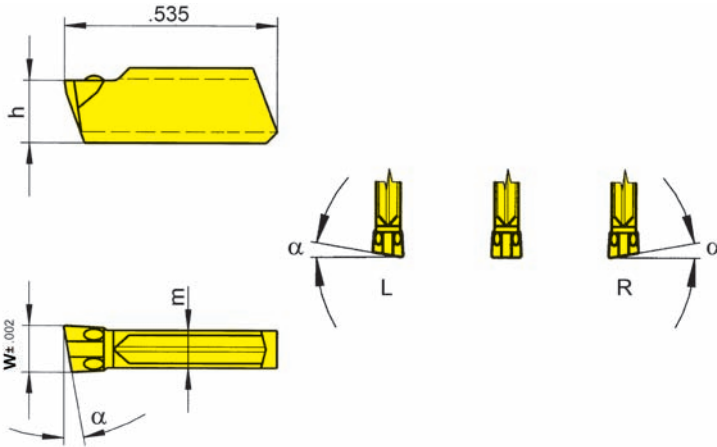
S123



Depth of groove up to .984"
Width of groove .079 - .118"

for use with Toolholder

Type H223
HU223



R = right hand version shown

L = left hand version

Part number	w	α	m	h	Size	Carbide grades			
						MG12	TN35	TI25	TF45
S123.0020.C0 R/LS123.1520.C0 R/LS123.0420.C0 R/LS123.0820.C0	.079	0° 15° 4° 8°	.063	.144	01		Δ Δ/ Δ/Δ Δ/Δ	/Δ Δ/ Δ/Δ	Δ Δ/ Δ/ /Δ
S123.0030.C0 R/LS123.0430.C0	.118	0° 4°	.094	.156	03		Δ	Δ/ Δ/	
<ul style="list-style-type: none"> ▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet 						P	●	●	●
						M	●	●	●
						K	●	●	●
						S	●	●	●
						N	●	●	●
						H			

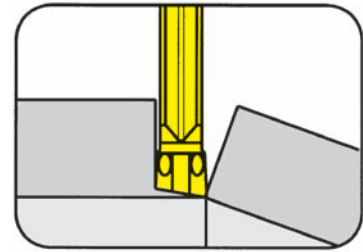
Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left** hand toolholders.

INSERT Type

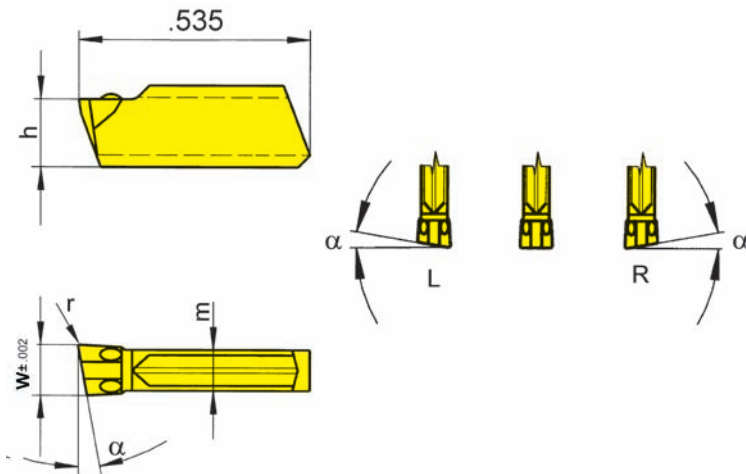
S123



Depth of groove up to .984"
 Width of groove .079 - .118"

for use with Toolholder

Type H223
 HU223



R = right hand version shown

L = left hand version

Part number	w	r	α	m	h	Size	Carbide grades			
							MG12	TN35	TI25	TF45
S123.0020.C1	.079	.006	0°	.063	.144	01		Δ	Δ	Δ
R/LS123.1520.C1			15°				Δ/	Δ/	Δ/	
R/LS123.0420.C1			4°				Δ/	Δ/Δ	Δ/	
R/LS123.0820.C1			8°				Δ/	Δ/		
S123.0030.C1	.118	.006	0°	.094	.156	03		Δ		
R/LS123.0830.C1			8°					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 inch

State R or L version

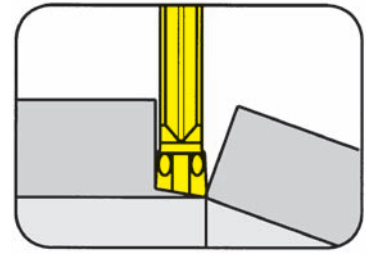
Indexable inserts can be used in **right and left** hand toolholders.

GROOVING and PARTING OFF



INDEXABLE INSERT Type

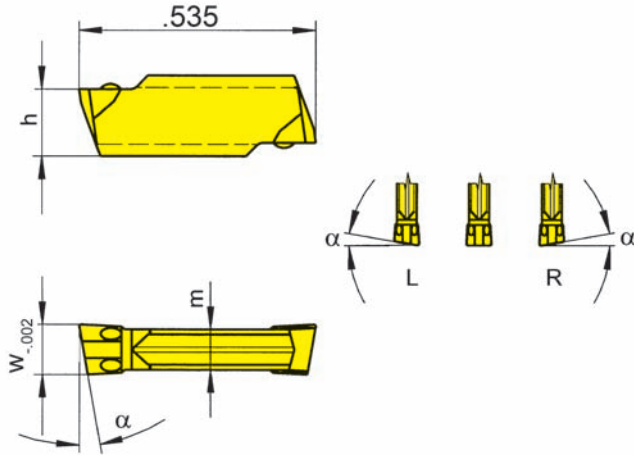
S223



Depth of groove up to .433"
 Width of groove .079 - .118"

for use with Toolholder

Type H223
 HU223



R = right hand version shown

L = left hand version

Part number	w	α	m	h	Size	Carbide grades			
						MG12	TN35	TI25	TF45
S223.0020.C0	.079	0°	.063	.144	01		▲	▲	▲
R/LS223.1520.C0		15°				▲/▲	▲/▲	▲/▲	
R/LS223.0420.C0		4°				▲/▲	▲/▲	▲/▲	
R/LS223.0820.C0		8°				▲/▲	▲/▲	▲/▲	
S223.0025.C0	.098	0°	.075	.148	02			▲	
R/LS223.0425.C0		4°				▲/▲	▲/		
R/LS223.0825.C0		8°				▲/▲	▲/	▲/▲	
S223.0030.C0	.118	0°	.094	.156	03			▲	▲
R/LS223.0430.C0		4°				▲/▲		▲/	
R/LS223.0830.C0		8°				▲/▲	▲/▲	▲/▲	
▲ on stock ▲ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet						P	●	●	●
						M	●	●	●
						K	●	●	●
						S	●	●	●
						N	●	●	●
						H			

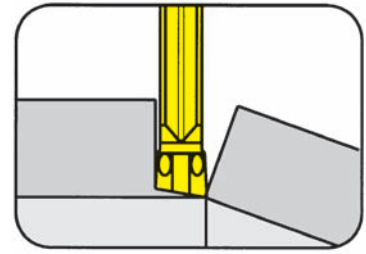
Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

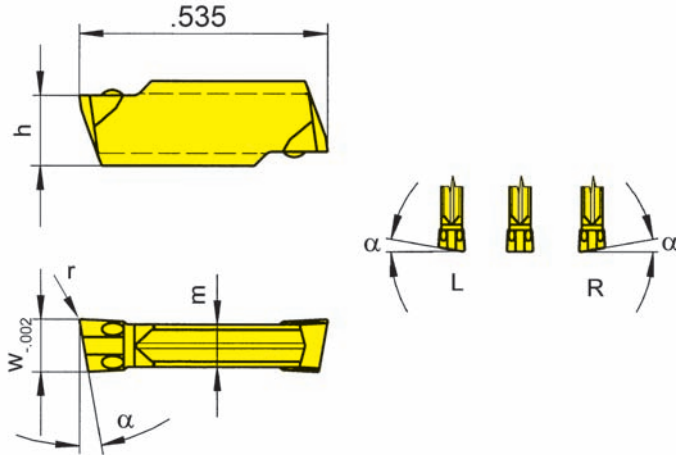
S223



Depth of groove up to .433"
 Width of groove .079 - .118"

for use with Toolholder

Type H223
 HU223



R = right hand version shown

L = left hand version

Part number	w	r	α	m	h	Size	Carbide grades			
							MG12	TN35	TI25	TF45
S223.0020.C1	.079	.006	0°	.063	.144	01		▲	▲	▲
R/LS223.1520.C1			15°				▲/▲	▲/▲	▲/▲	
R/LS223.0420.C1			4°				▲/▲	▲/	▲/	
R/LS223.0820.C1			8°				▲/▲	▲/	▲/▲	
S223.0025.C1	.098	.006	0°	.075	.148	02		▲	▲	▲
R/LS223.0425.C1			4°				/▲	▲/		
R/LS223.0825.C1			8°					▲/	▲/▲	
S223.0030.C1	.118	.006	0°	.094	.156	03		▲	▲	▲
R/LS223.0430.C1			4°				▲/▲	▲/		
R/LS223.0830.C1			8°				▲/	▲/	▲/	

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

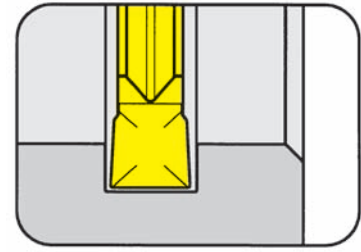
Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

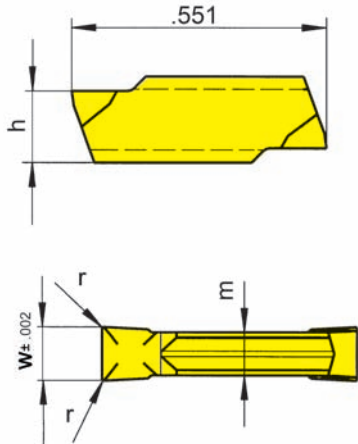
S223



Depth of groove up to .433"
 Width of groove .079 - .118"

for use with Toolholder

Type H223
 HU223



Part number	w	r	m	h	Size	Carbide grades				
						MG12	H54	TN35	TI25	TF45
S223.0200.32	.079	.008	.063	.144	01	▲	▲	▲	▲	
S223.0250.32	.098	.008	.079	.148	02	▲	▲	▲	▲	
S223.0300.32	.118	.008	.094	.156	03	▲	▲	▲	▲	
						P	○	●	●	●
						M	●	●	●	●
						K	●	●	●	●
						S	●	●	●	●
						N	●	●	●	●
						H				

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

Dimensions in inch

Indexable inserts can be used in **right and left hand** toolholders.

Carbide grades

HORN - THE LEADERS IN GROOVING TECHNOLOGY



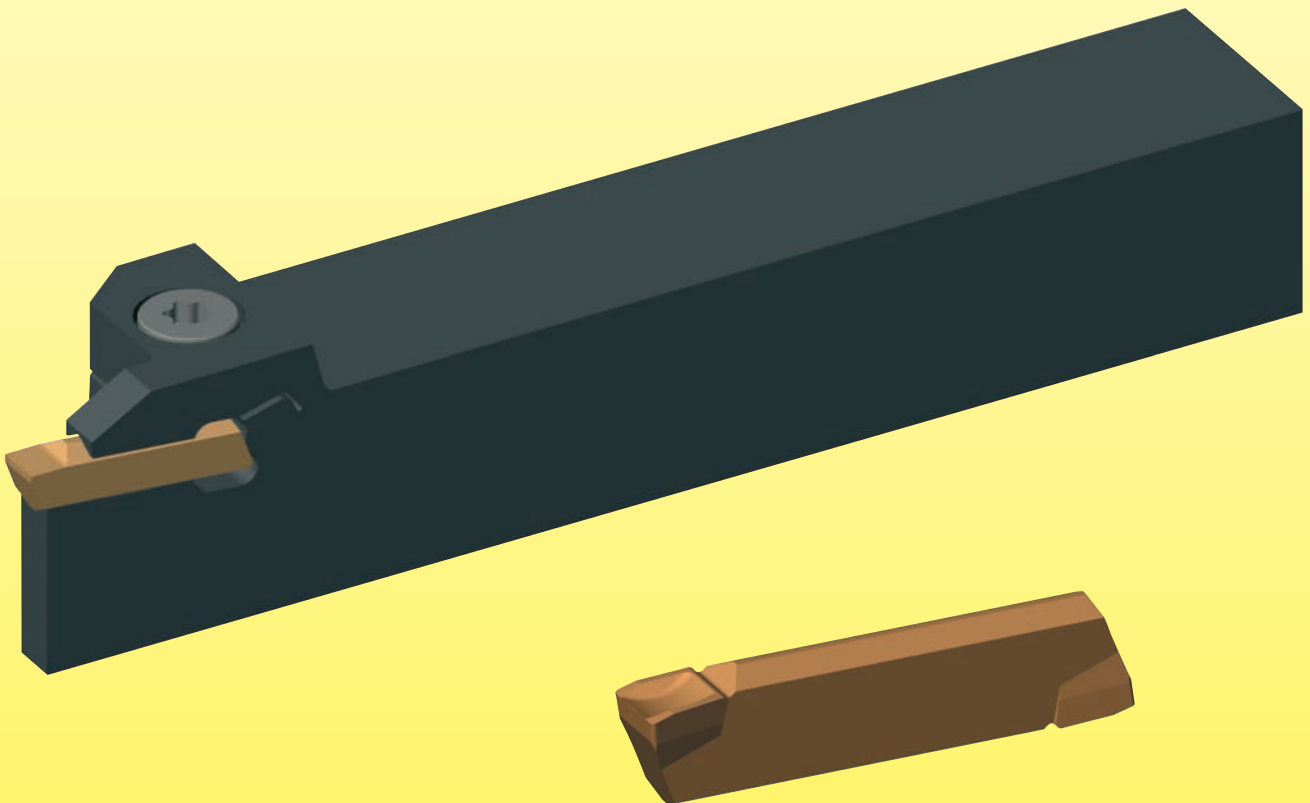
Thread whirling

HORN - INTELLIGENT TOOL DESIGN AT WORK.



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

**Indexable Insert Type S224
with chip forming
- precision sintered -**



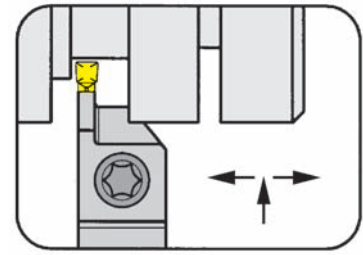
Width of groove .079 - .118"
Depth of groove up to .709"

TOOLHOLDER Type

HU224

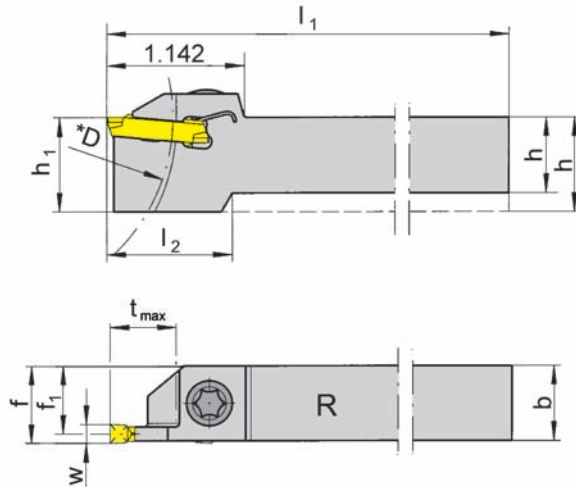
Depth of groove up to
Clamping range up to

.551"
.146"



for use with Indexable
insert

Type S224



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/LHU224.0625.01	.625	.625	5.000	.750		.595	1.000			
R/LHU224.0750.01	.750	.750	5.000	.750	f ₁ +w/2	.720	-	.551	01	.079 - .094
R/LHU224.1000.01	1.000	1.000	6.000	1.000		.970	-			
R/LHU224.0625.02	.625	.625	5.000	.750		.588	1.000			
R/LHU224.0750.02	.750	.750	5.000	.750	f ₁ +w/2	.713	-	.551	02	.094 - .110
R/LHU224.1000.02	1.000	1.000	6.000	1.000		.963	-			
R/LHU224.0625.03	.625	.625	5.000	.750		.580	1.000			
R/LHU224.0750.03	.750	.750	5.000	.750	f ₁ +w/2	.705	-	.551	03	.110 - .146
R/LHU224.1000.03	1.000	1.000	6.000	1.000		.955	-			

State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

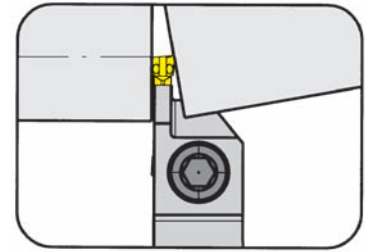
* t_{max} up to D = 3.150"

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHU224....	6.23T25P	T25PQ

TOOLHOLDER Type

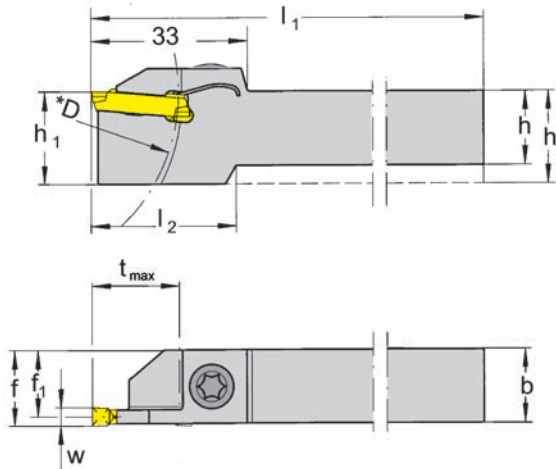
H224



Depth of groove up to .551" (14.0 mm)
Clamping range up to .146" (3.7 mm)

for use with Indexable insert

Type S224



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/LH224.1616.01	16	16	125	20		15.3	25			
R/LH224.2020.01	20	20	125	20	f ₁ +w/2	19.3	-	14	01	2.0 - 2.4
R/LH224.2525.01	25	25	150	25		24.3	-			
R/LH224.1616.02	16	16	125	20		15.1	25			
R/LH224.2020.02	20	20	125	20	f ₁ +w/2	19.1	-	14	02	2.4 - 2.8
R/LH224.2525.02	25	25	150	25		24.1	-			
R/LH224.1616.03	16	16	125	20		14.9	25			
R/LH224.2020.03	20	20	125	20	f ₁ +w/2	18.9	-	14	03	2.8 - 3.7
R/LH224.2525.03	25	25	150	25		23.9	-			

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

* t_{max} up to D = 80 mm

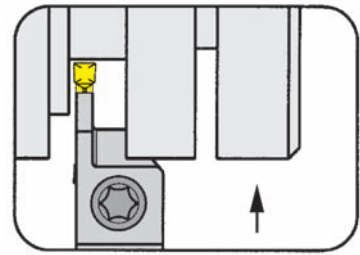
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH224....	6.23T25P	T25PQ

TOOLHOLDER Type

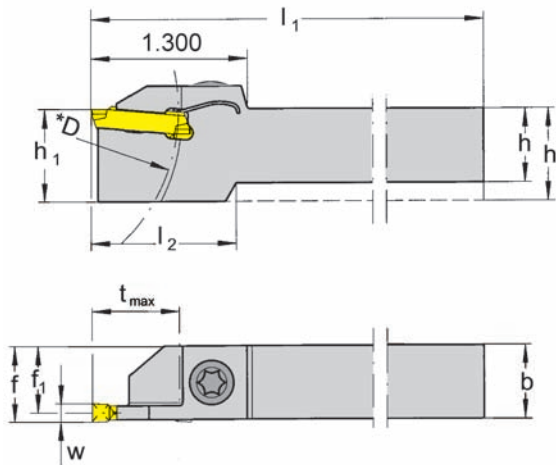
HU224

Depth of groove up to .709"
Clamping range up to .146"



for use with Indexable
insert

Type S224



R = right hand version shown

L = left hand version

Part number	h	b	f ₁	f	l ₂	t _{max}	Size	Clamping range
R/LHU224.0625.21	.625	.625	.595		1.125			
R/LHU224.0750.21	.750	.750	.720	f ₁ +w/2	-	.709	01	.079 - .094
R/LHU224.1000.21	1.000	1.000	.970		-			
R/LHU224.0625.22	.625	.625	.588		1.125			
R/LHU224.0750.22	.750	.750	.713	f ₁ +w/2	-	.709	02	.094 - .110
R/LHU224.1000.22	1.000	1.000	.963		-			
R/LHU224.0625.23	.625	.625	.580		1.125			
R/LHU224.0750.23	.750	.750	.705	f ₁ +w/2	-	.709	03	.110 - .146
R/LHU224.1000.23	1.000	1.000	.955		-			

State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

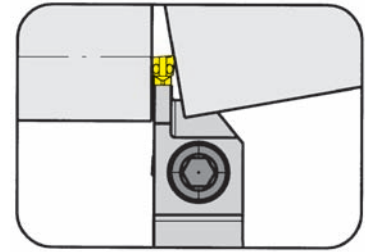
* t_{max} up to D = 3.150"

Spare parts

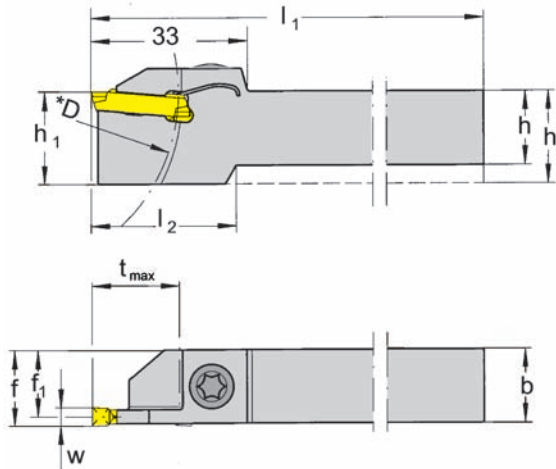
Toolholder	Screw	TORX PLUS® Wrench
R/LHU224....	6.23T25P	T25PQ

TOOLHOLDER Type

H224



Depth of groove up to .709" (18.0 mm)
Clamping range up to .146" (3.7 mm)



for use with Indexable insert

Type S224

R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	Size	Clamping range
R/LH224.1616.21	16	16	125	20	15.3	f ₁ +w/2	30	18	01	2.0 - 2.4
R/LH224.2020.21	20	20	125	20	19.3		-			
R/LH224.2525.21	25	25	150	25	24.3		-			
R/LH224.1616.22	16	16	125	20	15.1	f ₁ +w/2	30	18	02	2.4 - 2.8
R/LH224.2020.22	20	20	125	20	19.1		-			
R/LH224.2525.22	25	25	150	25	24.1		-			
R/LH224.1608.23	16	8	100	20	6.9	f ₁ +w/2	-	18	03	2.8 - 3.7
R/LH224.1616.23	16	16	125	20	14.9		30			
R/LH224.2020.23	20	20	125	20	18.9		-			
R/LH224.2525.23	25	25	150	25	23.9		-			

State R or L version

w see indexable inserts

Dimensions in mm

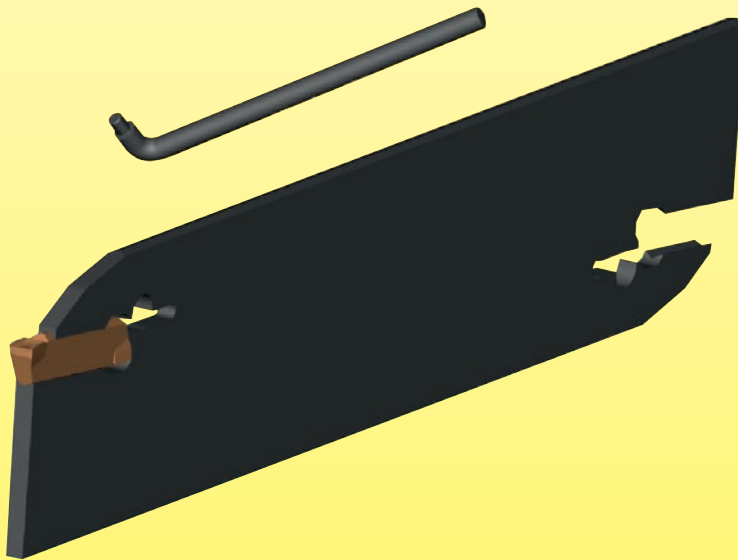
Further sizes upon request

* t_{max} up to D = 80 mm

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH224.1608.23	4.15T15P	T15PQ
R/LH224.....21/22/23	6.23T25P	T25PQ

CUTTER BODY Type H224 with self clamping, double seatings

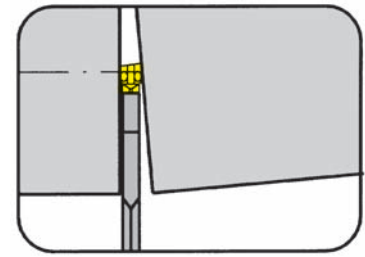


Width of groove	.118"
Depth of groove up to	.709"

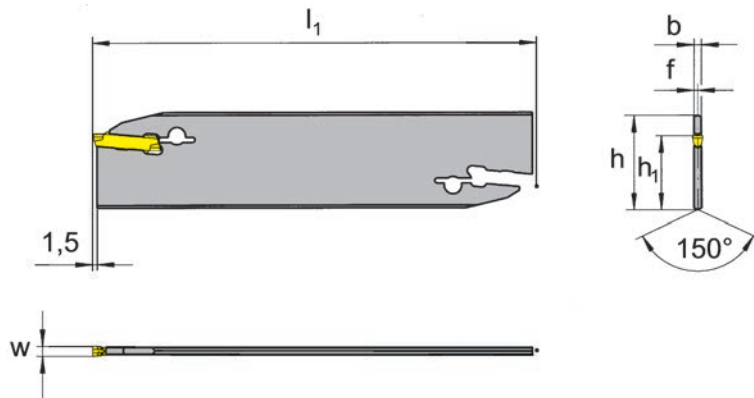
TOOLHOLDER Type

H224

with self clamping



Depth of groove up to .709" (18.0 mm)
Clamping range up to .146" (3.7 mm)



for use with Indexable insert

Type S224

Part number	h	b	l ₁	h ₁	f	t _{max}	Size	Clamping range
H224.2602.02	26	1.9	110	21.4	0.95	18	02	2.4 - 2.8
H224.2603.03	26	2.3	110	21.4	1.15	18	03	2.8 - 3.7
H224.3203.03	32	2.3	150	24.8	1.15	18	03	2.8 - 3.7

Further sizes upon request

w see indexable inserts

Dimensions in mm

Spare parts

Toolholder	Wrench
H224....	P39L

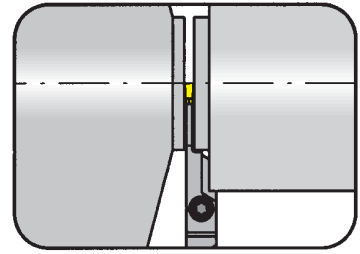
TOOLHOLDER Type

H224

reinforced version

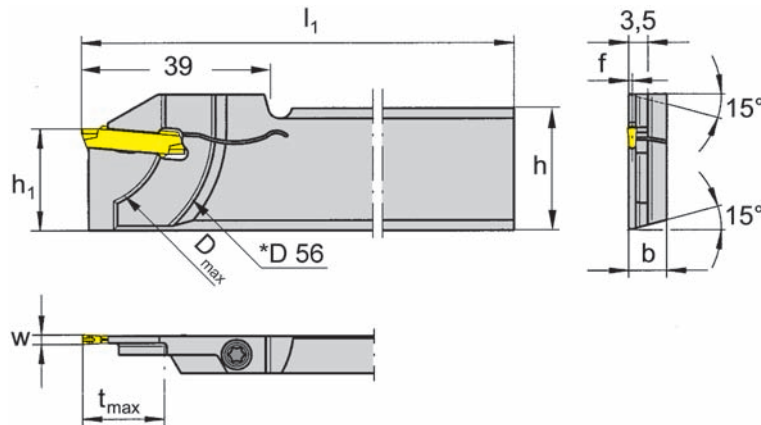
Depth of groove up to .709" (18.0 mm)
Clamping range up to .146" (3.7 mm)

for machines TRAUB (TNK28/TNK36/TNL26)



for use with Indexable insert

Type S224



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f	t_{max}	D_{max}	Size	Clamping range
R/LH224.2608.81	26	7.9	110	21.4	0.75	18	36	01	2.0 - 2.4
R/LH224.2608.82	26	7.9	110	21.4	0.95	18	36	02	2.4 - 2.8
R/LH224.2608.83	26	7.9	110	21.4	1.10	18	36	03	2.8 - 3.7

State R or L version

w see indexable inserts

Dimensions in mm

*D 56 = D_{max} of the subspindle

Further sizes upon request

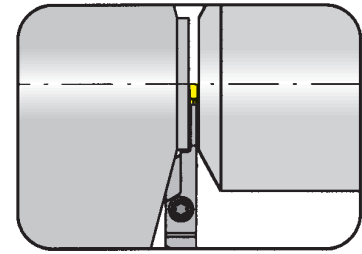
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH224.2608.8...	4.15T15P	T15PL

TOOLHOLDER Type

H224

reinforced version

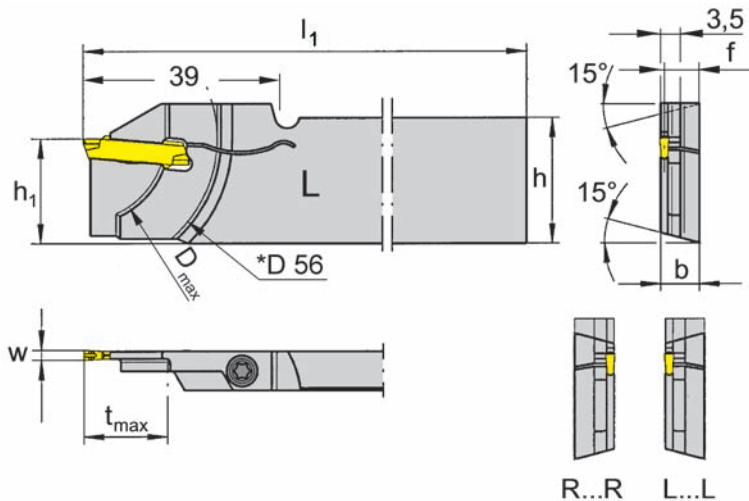


Depth of groove up to .827" (21.0 mm)
Clamping range up to .110" (2.8 mm)

for machines TRAUB (TNK28/TNK36/TNL26)

for use with Indexable insert

Type S224



L = left hand version shown

R = right hand version

Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	Size	Clamping range
R/LH224.2608.81R/L	26	7.9	110	21.4	7.15	18	36	01	2.0 - 2.4
R/LH224.2608.82R/L	26	7.9	110	21.4	6.95	18	36	02	2.4 - 2.8
R/LH224.2608.83R/L	26	7.9	110	21.4	6.75	18	36	03	2.8 - 3.7
RH224.3208.83R	28	7.9	110	24.8	6.80	21	42		

State R or L version

w see indexable inserts

Dimensions in mm

*D 56 = D_{max} of the subspindle

* For specific clamping device on subspindle (e.g. HAINBUCH Axfixchuck)

Further sizes upon request

Spare parts

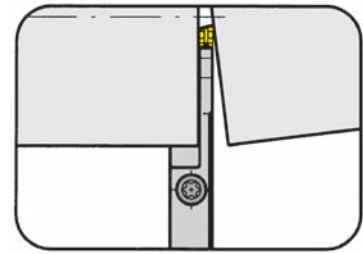
Toolholder	Screw	TORX PLUS® Wrench
R/LH224.2608.81R/L/82R/L/83R/L	4.15T15P	T15PL
RH224.3208.83R	5.13T20P	T20PQ

TOOLHOLDER Type

H224

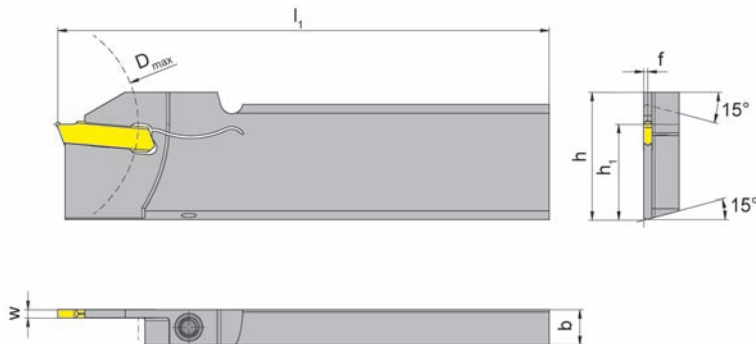
reinforced version

Depth of groove up to .709" (18.0 mm)
Clamping range up to .146" (3.7 mm)



for use with Indexable insert

Type S224



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	t _{max}	D _{max}	Size	Clamping range
R/LH224.2608.01 R/LH224.3208.01	26 32	7.9	110	21.4 24.8	0.7	18	50	01	2.0 - 2.4
R/LH224.2608.02 R/LH224.3208.02	26 32	7.9	110	21.4 24.8	0.9	18	50	02	2.4 - 2.8
R/LH224.2608.03 R/LH224.3208.03	26 32	7.9	110	21.4 24.8	1.1	18	50	03	2.8 - 3.7

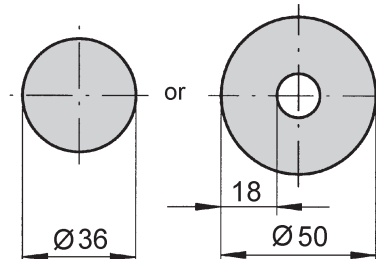
State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

Parting off solid bars Parting off tubes



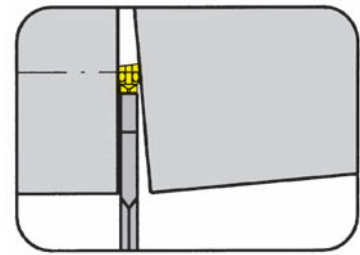
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH224....	4.20T15P	T15PL

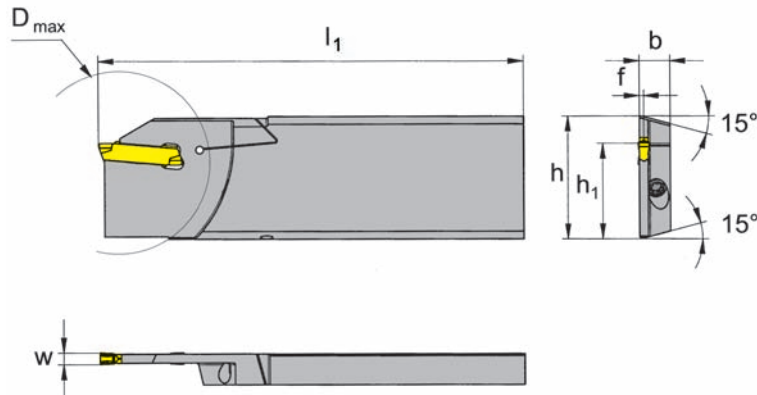
TOOLHOLDER Type

H224

with screwed clamping



Depth of groove up to .709" (18.0 mm)
Clamping range up to .146" (3.7 mm)



for use with Indexable insert

Type S224

R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f	t_{max}	D_{max}	Size	Clamping range
R/LH224.3208.93	32	8	112	24.8	1.15	18	50	03	2.8 - 3.7

State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

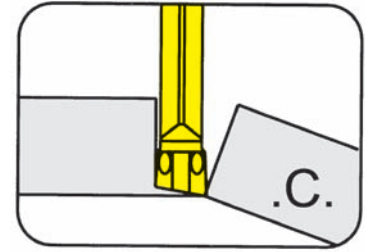
Spare parts

Toolholder	Screw	TORX PLUS® Wrench	Pin
R/LH224.3208.93	030.0413.T15P	T15PQ	020.0040.0999

INDEXABLE INSERT Type

S224

with chip forming

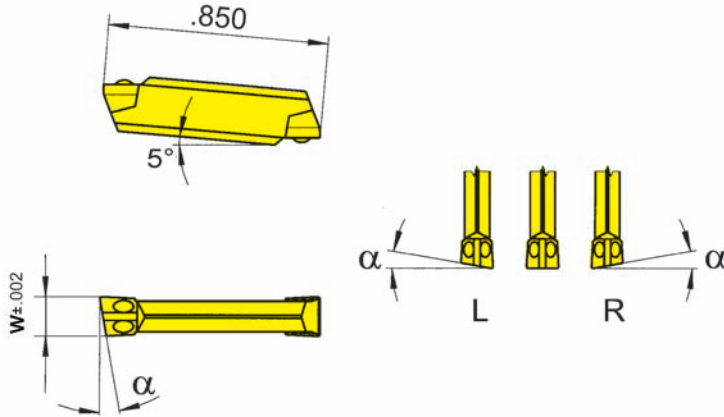


Depth of groove up to	.709"
Width of groove	.079 - .118"

precision sintered

for use with Toolholder

Type H224
HU224



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	α	Size	TN35	TI25	TF45	TC92
S224.0020.C0	.079	0°	01	▲	▲	▲	
R/LS224.1520.C0		15°		▲/▲		▲/▲	Δ/Δ
R/LS224.0520.C0		5°		▲/▲		▲/▲	
R/LS224.0820.C0		8°		▲/▲		▲/▲	
S224.0025.C0	.098	0°	02	▲	▲	▲	
R/LS224.0525.C0		5°		▲/▲	▲/	▲/Δ	
R/LS224.0825.C0		8°		▲/▲		Δ/	
S224.0030.C0	.118	0°	03	▲	▲	▲	
R/LS224.0530.C0		5°		▲/▲		▲/▲	▲/Δ
R/LS224.0830.C0		8°		▲/▲		▲/▲	
▲ 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

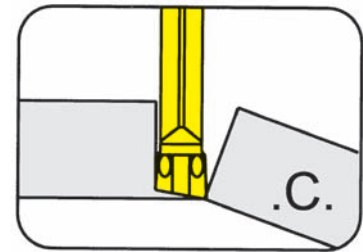
Further sizes upon request

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

S224

with chip forming

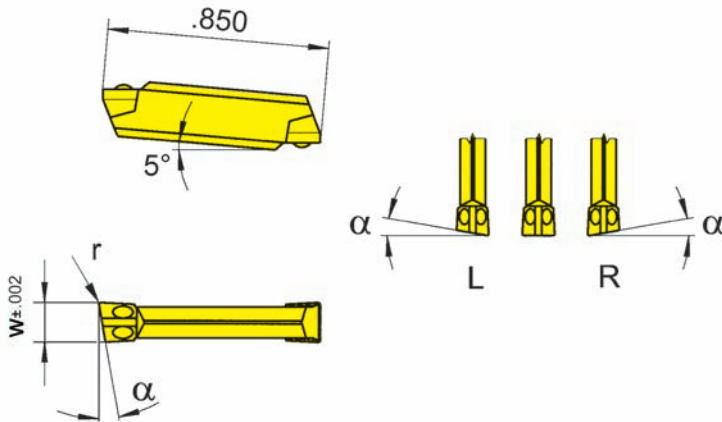


Depth of groove up to	.709"
Width of groove	.079 - .118"

precision sintered

for use with Toolholder

Type H224
HU224



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	r	α	Size	TN35	TI25	TF45	TC92
S224.0020.C1	.079	.006	0°	01	▲	▲	▲	▲
R/LS224.1520.C1			▲/▲			▲/▲		
R/LS224.0520.C1			▲/▲			▲/▲		
R/LS224.0820.C1						▲/▲		
S224.0025.C1	.098	.006	0°	02	▲	▲	▲	
R/LS224.0525.C1			▲/▲			▲/▲	Δ	
R/LS224.0825.C1						▲/▲		
S224.0030.C1	.118	.006	0°	03	▲	▲	▲	▲
R/LS224.0530.C1			▲/▲			▲/▲		
R/LS224.0830.C1			▲/▲			▲/▲		
▲ 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

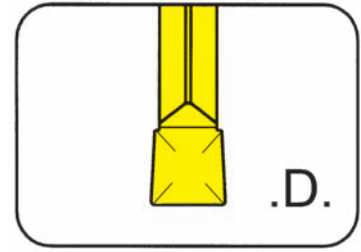
Further sizes upon request

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

S224

with chip forming

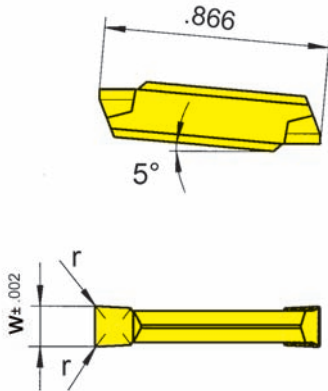


Depth of groove up to	.709"
Width of groove	.079 - .118"

D2 precision sintered / D2.G precision ground

for use with Toolholder

Type H224
HU224



Indexability length
± .002"

Part number	w	r	Size	K10	H54	TN32	TN35	TI22	TI25	TF45	TF46	TC92
S224.0200.D2.G S224.0200.D2	.079	.008	01		▲	▲	▲	▲	▲	▲	▲	
S224.0250.D2.G S224.0250.D2	.098	.008	02			▲	▲	▲	▲	▲	▲	
S224.0300.D2.G S224.0300.D2	.118	.008	03		▲	▲	▲	▲	▲	▲	▲	
▲ 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

Indexable inserts can be used in **right and left hand** toolholders.

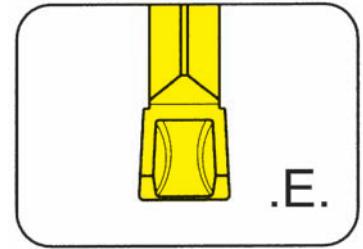
GROOVING and PARTING OFF



INDEXABLE INSERT Type

S224

with chip former

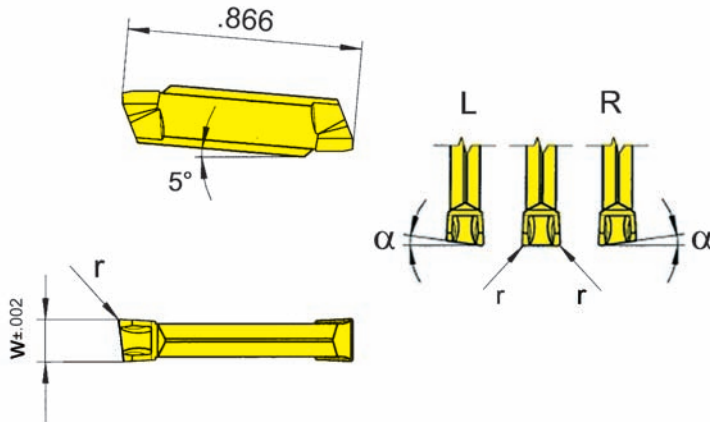


Depth of groove up to	.709"
Width of groove	.079 - .118"

precision sintered

for use with Toolholder

Type H224
HU224



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	r	α	Size	Tl22	Tl25	TF43	TF45	TC92	TC93	AS62
S224.0200.E2 R/LS224.0520.E2	.079	.008	0° 5°	01			▲	▲	▲	▲	▲/▲
S224.0250.E2 R/LS224.0525.E2	.098	.008	0° 5°	02			▲	▲	▲		▲/▲
S224.0300.E2 S224.0300.E4 R/LS224.0530.E2	.118	.008 .016 .008	0° 0° 5°	03	▲	▲	▲	▲	▲	▲	▲

▲ on stock	Δ 4 weeks
● main recommendation	○ alternative recommendation
■ uncoated grades	■ coated grades
■ brazed/Cermet	

Dimensions in inch

State R or L version

Further sizes upon request

Indexable inserts can be used in **right and left hand** toolholders.

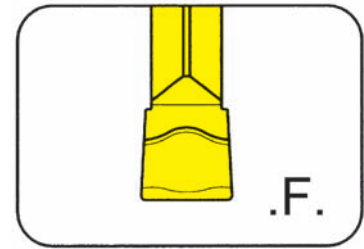
P	●	●	●	●	●	●
M		●		●		
K		●		●		
S		●		●		
N		●		●		
H						

Carbide grades

INDEXABLE INSERT Type

S224

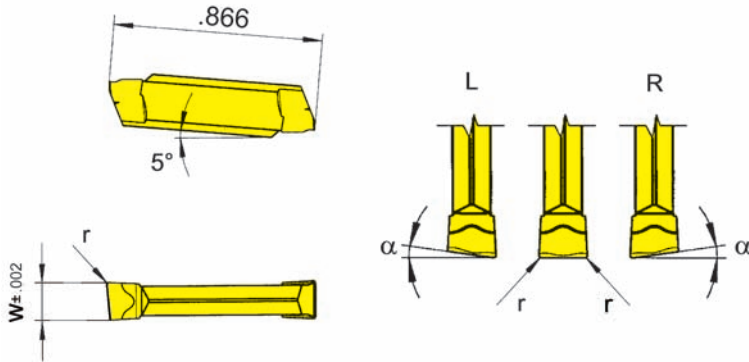
with chip forming



Depth of groove up to .709"
 Width of groove .079 - .118"

for use with Toolholder

Type H224
 HU224



R = right hand version shown

L = left hand version

Indexability length
 ± .002"

Part number	w	r	α	Size	T122	T125	TF42	TF43	TF45	TF46
S224.0200.F2 R/LS224.0520.F2	.079	.008	0° 5°	01	▲	▲		▲	▲	▲
S224.0250.F2 R/LS224.0525.F2	.098	.008	0° 5°	02	▲			▲	▲	▲
S224.0300.F2 R/LS224.0530.F2	.118	.008	0° 5°	03	▲/▲	▲		▲	▲	▲
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P	●	●	●	●	●
					M	●	●	●	○	○
					K	●	●	●	●	●
					S	●	●	●	○	○
					N	●	●	●	●	●
					H					

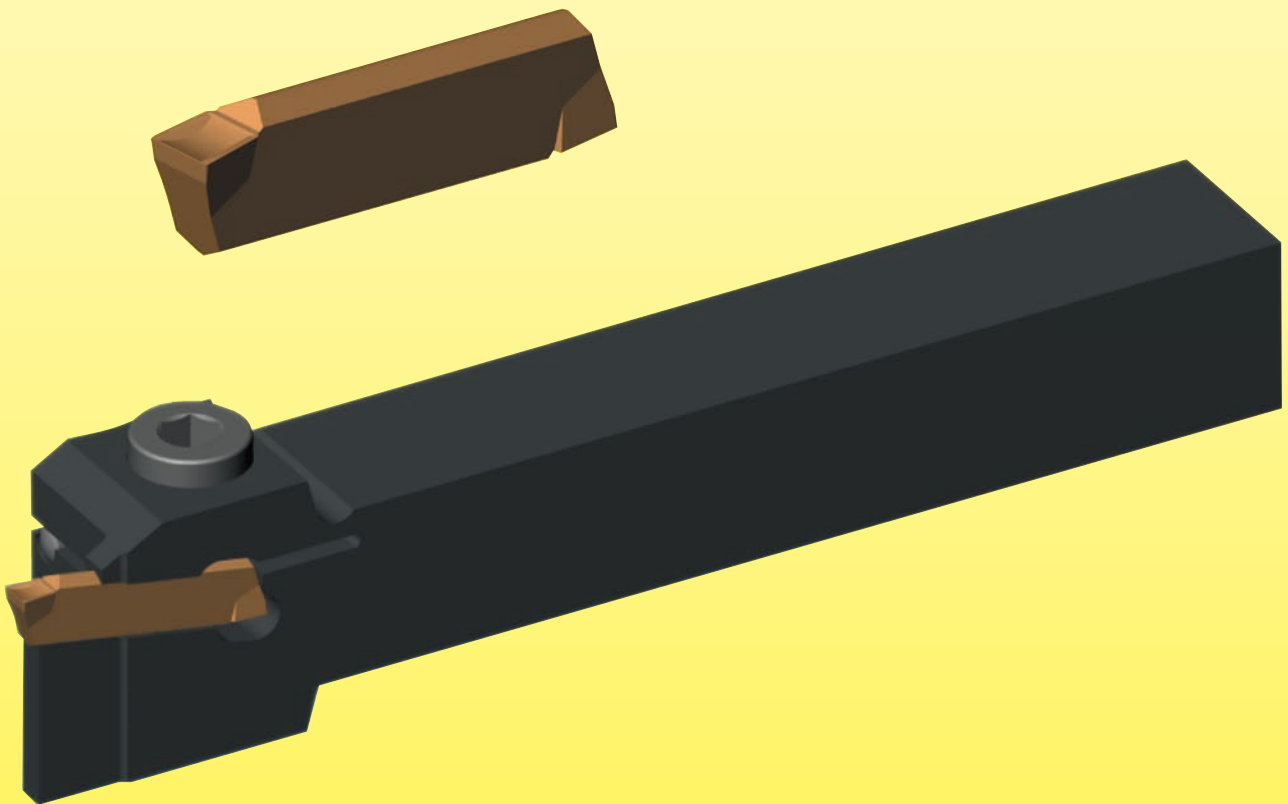
Dimensions in inch

State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

Carbide grades

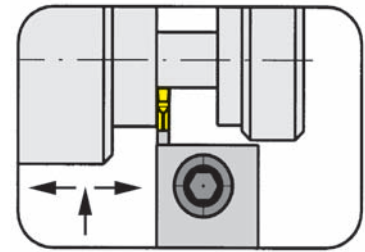
**Indexable Insert Type S229
with chip forming
- precision sintered -**



Width of groove .118 - .197"
Depth of groove up to .984"

TOOLHOLDER Type

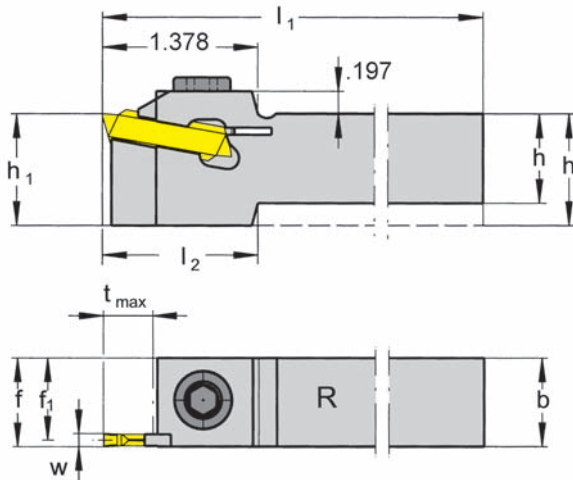
U210



Depth of groove up to **.433"**
Clamping range **.118 - .197"**

for use with Indexable insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/LU210.0625.03	.625	.625	6.000	1.000	f ₁ +w/2	.568	1.750	.433	03	.118 - .157
R/LU210.0750.03	.750	.750	6.000	1.000		.693	1.375			
R/LU210.1000.03	1.000	1.000	6.000	1.000		.943	-			
R/LU210.1250.03	1.250	1.000	6.625	1.250	.943	-	-	-	-	-
R/LU210.0750.04	.750	.750	6.000	1.000	f ₁ +w/2	.659	1.375	.433	04	.157 - .197
R/LU210.1000.04	1.000	1.000	6.000	1.000		.909	-			
R/LU210.1250.04	1.250	1.000	6.625	1.250		.909	-			

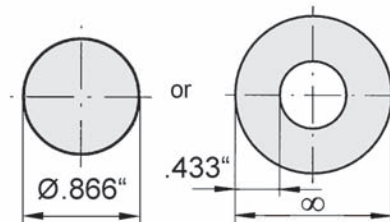
State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

Parting off solid bars Parting off tubes



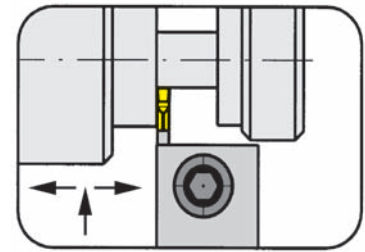
Spare parts

Toolholder	Screw	Wrench
R/LU210....	218.3	SW6DIN911

TOOLHOLDER Type

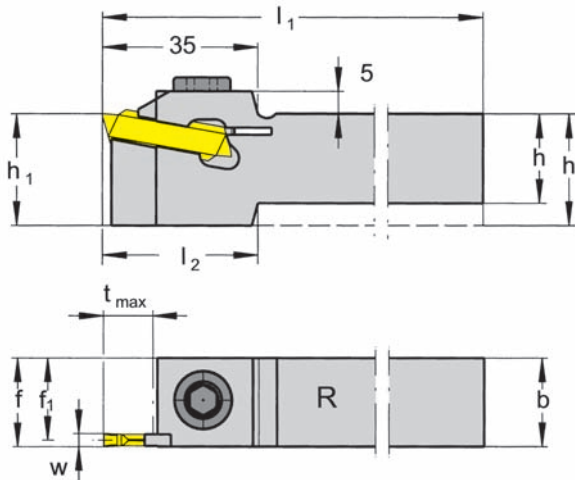
210

Depth of groove up to .433" (11.0 mm)
Clamping range .118 - .197" (3.0 - 5.0 mm)



for use with Indexable insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f	f_1	l_2	t_{max}	Size	Clamping range
R/L210.1616.03	16	16	150	25	$f_1 + w/2$	14.55	45	11	03	3.0 - 4.0
R/L210.2020.03	20	20	150	25		18.55	35			
R/L210.2525.03	25	25	150	25		23.55	-			
R/L210.3225.03	32	25	170	32	23.55	-	-	-	-	-
R/L210.2020.04	20	20	150	25	$f_1 + w/2$	17.70	35	11	04	4.0 - 5.0
R/L210.2525.04	25	25	150	25		22.70	-			
R/L210.3225.04	32	25	170	32		22.70	-			

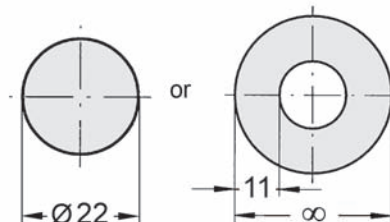
State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

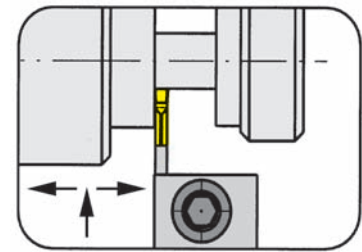
Parting off solid bars Parting off tubes



Spare parts

Toolholder	Screw	Wrench
R/L210....	218.3	SW6DIN911

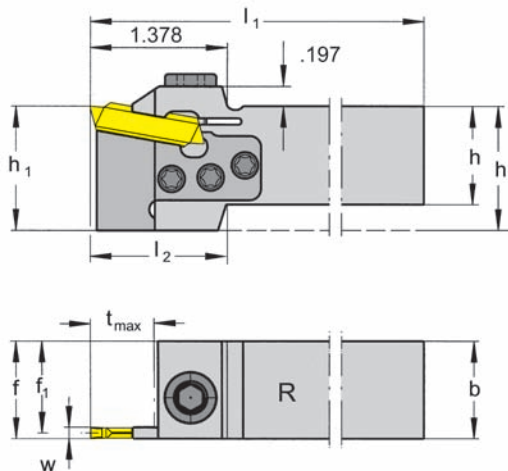
BASIC TOOLHOLDER Type **U218**



Depth of groove up to **.709"**
 Width of groove **.118 - .197"**

for use with Indexable Insert

Type 229
 S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/LU218.1000.K3	1.000	1.000	6.000	1.250	f ₁ +w/2	.943	2.000	.709	03	.118 - .157
R/LU218.1250.K3	1.250	1.000	6.625	1.250	f ₁ +w/2	.943	-	.709	03	.118 - .157
R/LU218.1000.K4	1.000	1.000	6.000	1.250	f ₁ +w/2	.909	2.000	.709	04	.157 - .197
R/LU218.1250.K4	1.250	1.000	6.625	1.250	f ₁ +w/2	.909	-	.709	04	.157 - .197

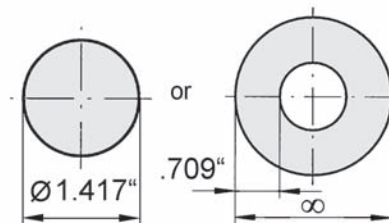
State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

Parting off solid bars Parting off tubes



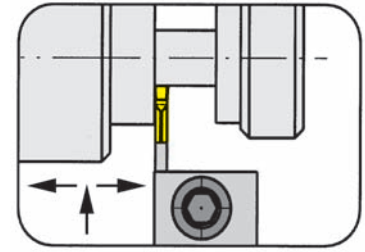
Spare parts

Basic toolholder	Cassette	Screw	Screw	Wrench	TORX PLUS® Wrench
R/LU218.1...K3	NK218.32.03	030.0518.T20P	218.3	SW6DIN911	T20PQ
R/LU218.1...K4	NK218.32.04	030.0518.T20P	218.3	SW6DIN911	T20PQ

BASIC TOOLHOLDER Type

218

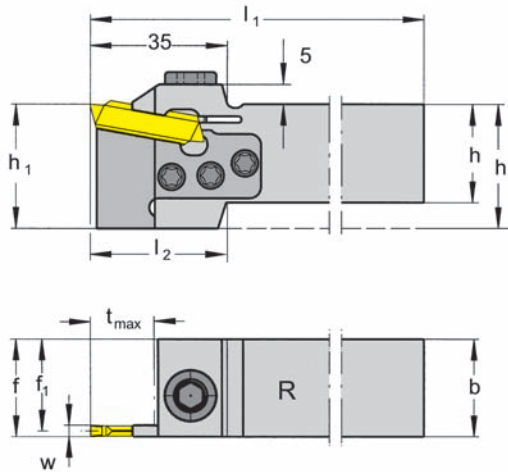
with changeable cassette



Depth of groove up to .709" (18.0 mm)
Width of groove .118 - .197" (3.0 - 5.0 mm)

for use with Indexable insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/L218.2525.K3	25	25	150	32	f ₁ +w/2	23.55	35	18	03	3.0 - 4.0
R/L218.3225.K3	32	25	170	32	f ₁ +w/2	23.55	-	18	03	3.0 - 4.0
R/L218.2525.K4	25	25	150	32	f ₁ +w/2	22.70	35	18	04	4.0 - 5.0
R/L218.3225.K4	32	25	170	32	f ₁ +w/2	22.70	-	18	04	4.0 - 5.0

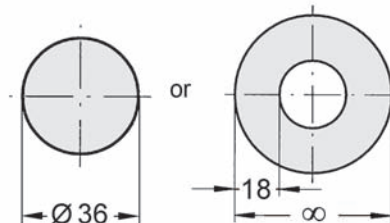
State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

Parting off solid bars Parting off tubes

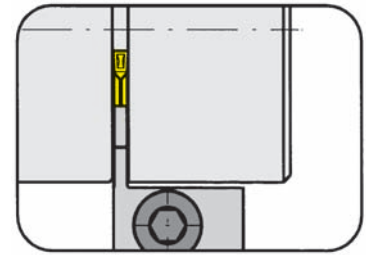


Spare parts

Basic toolholder	Cassette	Screw	Screw	Wrench	TORX PLUS® Wrench
R/L218....K3	NK218.32.03	030.0518.T20P	218.3	SW6DIN911	T20PQ
R/L218....K4	NK218.32.04	030.0518.T20P	218.3	SW6DIN911	T20PQ

TOOLHOLDER Type

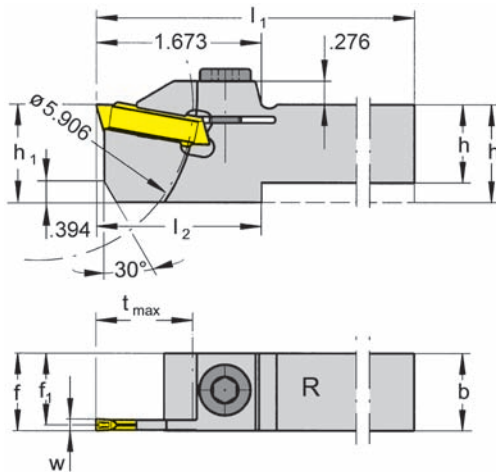
U226



Depth of groove up to 1.000"
Clamping range .118 - .197"

for use with Insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/LU226.0625.03	.625	.625	6.000			.568	2.000			
R/LU226.0750.03	.750	.750	6.000	1.250	f ₁ +w/2	.693	1.675	1.000	03	.118 - .157
R/LU226.1000.03	1.000	1.000	6.000			.943	1.675			
R/LU226.1250.03	1.250	1.000	6.625			.943	-			
R/LU226.0625.04	.625	.625	6.000			.534	2.000			
R/LU226.0750.04	.750	.750	6.000	1.250	f ₁ +w/2	.659	1.675	1.000	04	.157 - .197
R/LU226.1000.04	1.000	1.000	6.000			.909	1.675			
R/LU226.1250.04	1.250	1.000	6.625			.909	-			

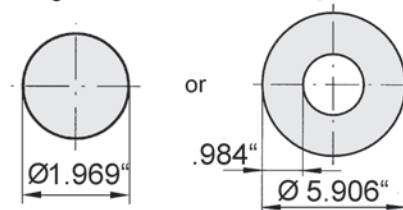
State R or L version

w see indexable inserts

Dimensions in inch

Further sizes upon request

Parting off solid bars Parting off tubes

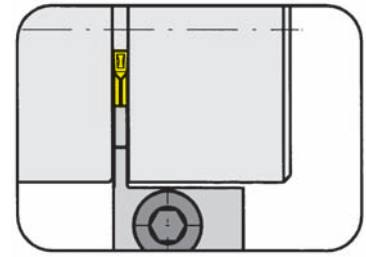


Spare parts

Toolholder	Screw	Wrench
R/LU226....	218.3	SW6DIN911

TOOLHOLDER Type

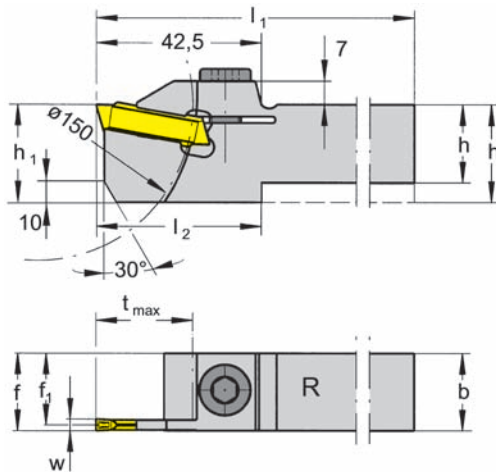
226



Depth of groove up to .984" (25.0 mm)
Clamping range .118 - .197" (3.0 - 5.0 mm)

for use with Indexable insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f	f ₁	l ₂	t _{max}	Size	Clamping range
R/L226.1616.03	16	16	150			18.55	52.5			
R/L226.2020.03	20	20	150	32	f ₁ +w/2	18.55	42.5	25	03	3.0 - 4.0
R/L226.2525.03	25	25	150			23.55	-			
R/L226.3225.03	32	25	170			23.55	-			
R/L226.1616.04	16	16	150			13.70	52.5			
R/L226.2020.04	20	20	150	32	f ₁ +w/2	17.70	42.5	25	04	4.0 - 5.0
R/L226.2525.04	25	25	150			22.70	-			
R/L226.3225.04	32	25	170			22.70	-			

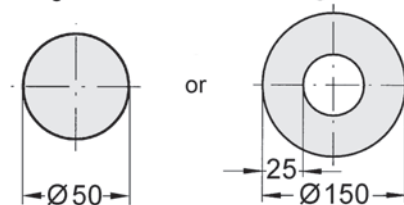
State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

Parting off solid bars Parting off tubes



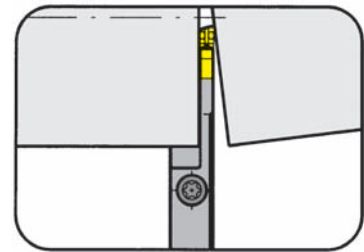
Spare parts

Toolholder	Screw	Wrench
R/L226....	218.3	SW6DIN911

TOOLHOLDER Type

226

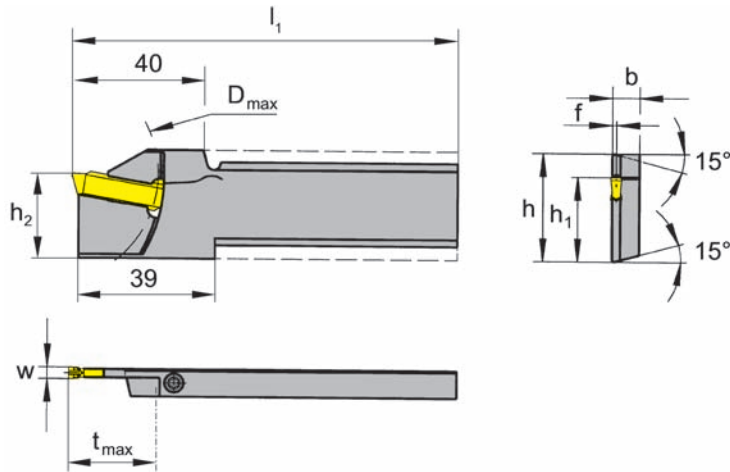
reinforced version



Depth of groove up to .984" (25.0 mm)
Clamping range .118 - .157" (3.0 - 4.0 mm)

for use with Indexable insert

Type 229
S229



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	h ₂	f	t _{max}	D _{max}	Size	Clamping range
R/L226.2608.03	26	8	110	21.4	24.8	1.2	25	150	03	3
R/L226.3208.03	32	8	110	24.8	24.8	1.2	25	150	03	3
R/L226.2608.04	26	8	110	21.4	24.8	1.7	25	150	04	4
R/L226.3208.04	32	8	110	24.8	24.8	1.7	25	150	04	4

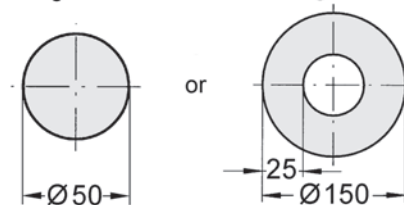
State R or L version

w see indexable inserts

Dimensions in mm

Further sizes upon request

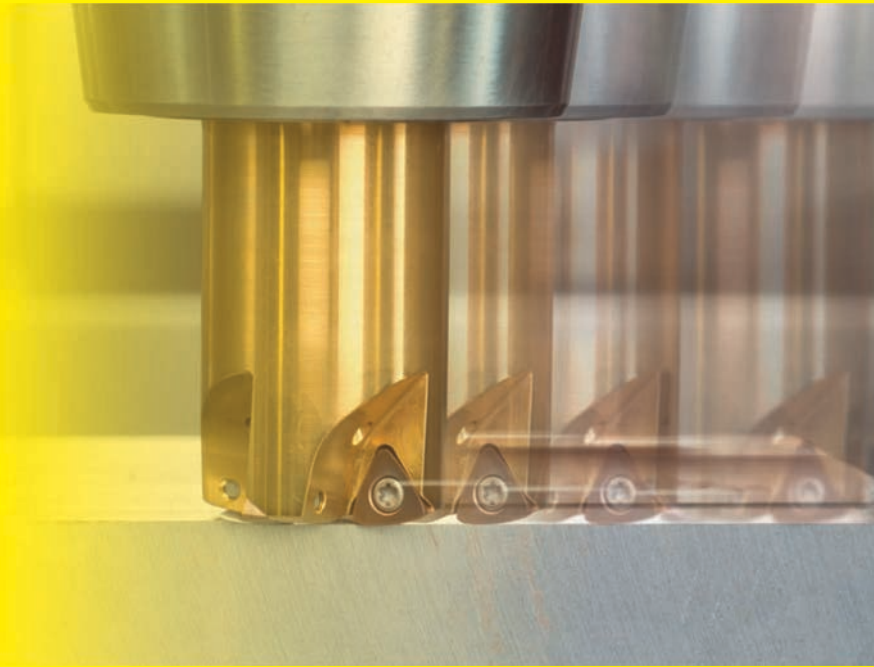
Parting off solid bars Parting off tubes



Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/L226....	4.15T15P	T15PQ

HORN - THE LEADERS IN GROOVING TECHNOLOGY



EXTREME FEED RATES

SYSTEM DAH

Remove material fast through high feed milling.
Not only for the stamping and mold industry.

HORN - INTELLIGENT TOOL DESIGN AT WORK.

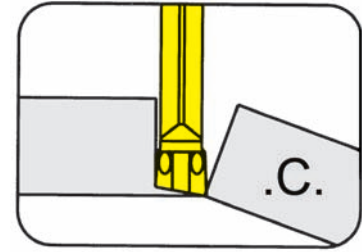


For further information, please see HORN catalog "CARBIDE MILLING TOOLS".

INDEXABLE INSERT Type

S229

with chip forming

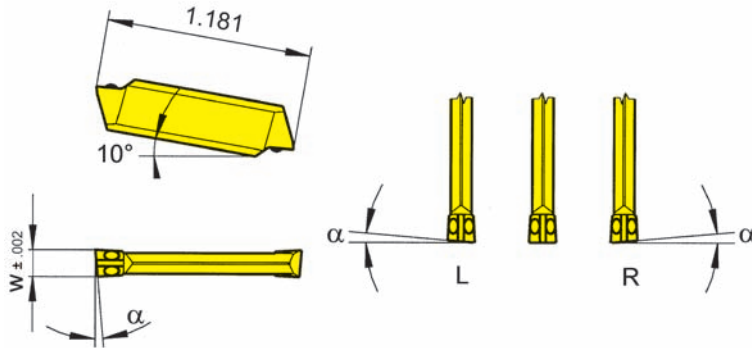


Depth of groove up to	1.000"
Width of groove	.118 - .157"

precision sintered

for use with Toolholder

- Type
- 210
 - 218
 - 226
 - U210
 - U218
 - U226



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	α	Size	Carbide grades						
				TN32	TN35	T122	T125	TA45	TF45	TC92
R/LS229.0530.C0	.118	5°	03		▲/▲		▲/▲		▲/▲	
R/LS229.0830.C0		8°		▲/▲		▲/▲		▲/▲	▲/▲	
S229.0030.C0		0°		▲		▲		▲		
R/LS229.0540.C0	.157	5°	03 / 04		▲/▲		Δ/			
R/LS229.0840.C0		8°		▲/Δ		▲/			Δ/	
S229.0040.C0		0°		▲		▲				
				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

Indexable inserts can be used in **right and left hand** toolholders.

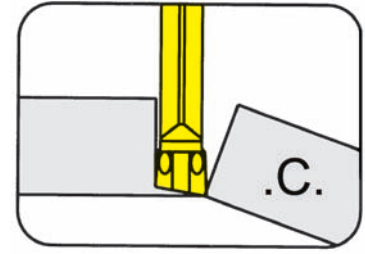
PARTING OFF



INDEXABLE INSERT Type

S229

with chip forming

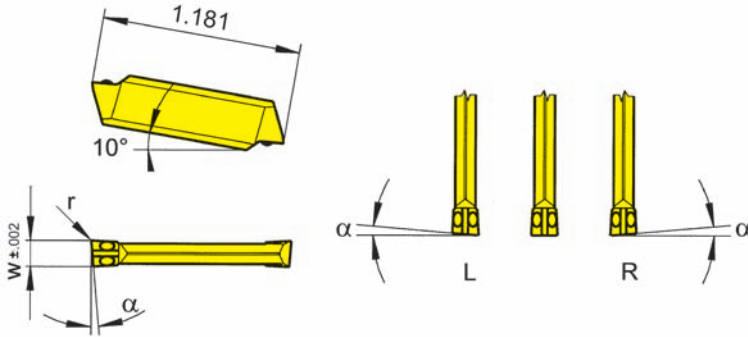


Depth of groove up to	1.000"
Width of groove	.118 - .157"

precision sintered

for use with Toolholder

- Type
- 210
 - 218
 - 226
 - U210
 - U218
 - U226



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	r	α	Size	TN32	TN35	TI22	TI25	TF45	TC92
					R/LS229.0530.C1 R/LS229.0830.C1 S229.0030.C1	.118	.006	5° 8° 0°	03	
R/LS229.0540.C1 R/LS229.0840.C1 S229.0040.C1	.157	.006	5° 8° 0°	03 / 04		▲/▲ ▲/▲		▲/▲ ▲/▲	▲	▲/▲ ▲
▲ 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

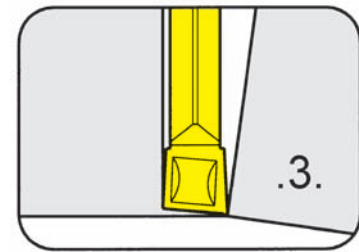
State R or L version

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

229/S229

with chip former

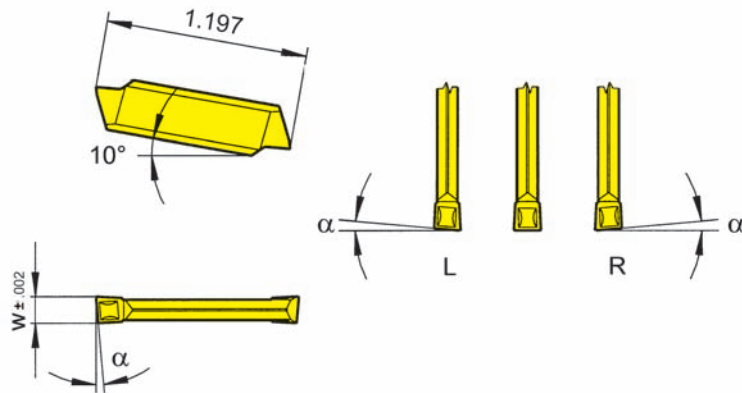


Depth of groove up to	1.000"
Width of groove	.118 - .157"

precision sintered

for use with Toolholder

- Type 210
218
226
U210
U218
U226



R = right hand version shown

L = left hand version

Indexability length
± .002"

Part number	w	α	Size	MG12	P20	H54	TN32	TN35	Ti22	Ti25	TA45	TF45	TC92	AL96	AS62
R/L229.5300.31	.118	5°	03	▲/▲			▲/▲	▲/▲		▲/▲			Δ/Δ		▲/▲
R/LS229.0530.32		5°		▲/▲			▲/▲	▲/▲		▲/▲		▲/▲	Δ/Δ		▲/▲
S229.0300.32		0°		▲		▲		▲	▲	▲	▲		▲	Δ	▲
R/LS229.0540.32	.157	5°	03 / 04				▲/▲			▲/▲		▲/▲			▲/▲
S229.0400.32		0°				▲		▲	▲	▲		▲	Δ	▲	▲
				P	o	•	•	•	•	•	•	•	•	•	•
				M	•	•	•	•	•	•	•	•	•	•	•
				K	•	•	•	•	•	•	•	•	•	•	•
				S	•	•	•	•	•	•	•	•	•	•	•
				N	•	•	•	•	•	•	•	•	•	•	•
				H											

Dimensions in inch

Carbide grades

State R or L version

Note:
R/L229.5300.31 **precision ground**, length 1.181"

Indexable inserts can be used in **right and left hand** toolholders.

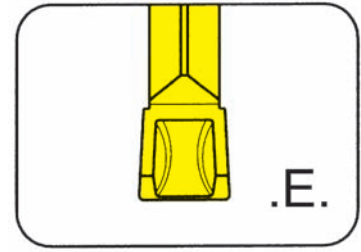
GROOVING and PARTING OFF



INDEXABLE INSERT Type

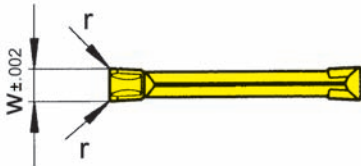
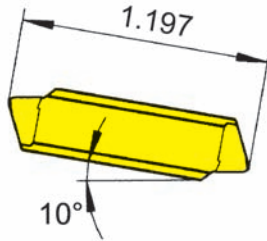
S229

with chip former



Depth of groove up to	1.000"
Width of groove	.118 - .157"

precision sintered



for use with Toolholder

- Type
- 210
 - 218
 - 226
 - U210
 - U218
 - U226

Indexability length
± .002"

Part number	w	r	Size	Carbide grades									
				MG12	P20	TN32	TN35	T122	T125	TF45	TF46	TC92	AS62
S229.0300.E2	.118	.008	03						▲	▲	▲	▲	▲
S229.0300.E4		.016								▲	▲	▲	▲
S229.0400.E2	.157	.008	03 / 04						▲	▲			▲
S229.0400.E4		.016								▲			
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet				P					●	●	●	●	●
				M					●	●	○		
				K					●	●	●		
				S					●	●	○		
				N					●	●	●		
				H									

Dimensions in inch

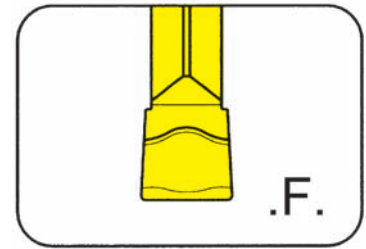
Carbide grades

Indexable inserts can be used in **right and left hand** toolholders.

INDEXABLE INSERT Type

S229

with chip forming

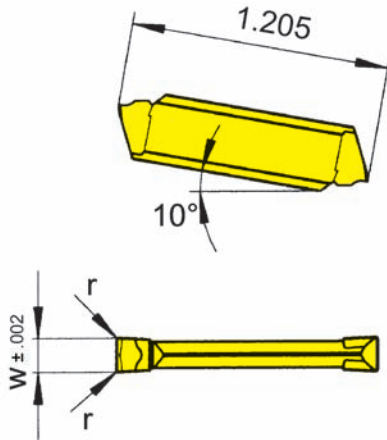


Depth of groove up to	1.000"
Width of groove	.118 - .157"

precision sintered

for use with Toolholder

- Type
- 210
 - 218
 - 226
 - U210
 - U218
 - U226



Indexability length
± .002"

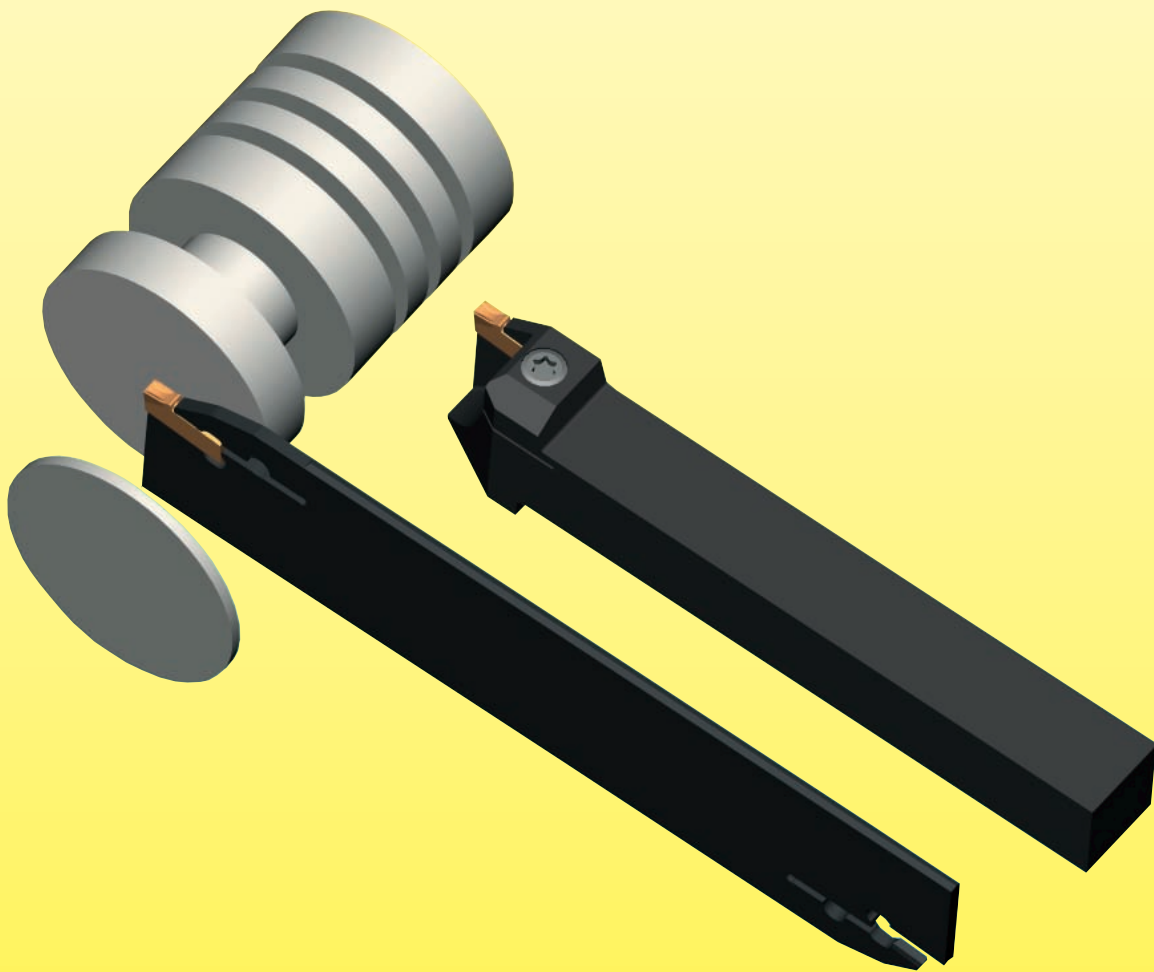
Part number	w	r	Size	Carbide grades								
				K10	MG12	P20	T122	T125	TF43	TF45	TF46	AS62
S229.0300.F2	.118	.008	03				▲		▲	▲	▲	
S229.0300.F4		.016								▲	▲	
S229.0400.F2	.157	.008	03 / 04							▲	▲	
S229.0400.F4		.016								▲		
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet				P			●		●	●	●	
				M						●	○	
				K						●	●	
				S						●	○	
				N						●	●	
				H								

Dimensions in inch

Carbide grades

Indexable inserts can be used in **right and left hand** toolholders.

CUTTER BODY Type H100 - with screwed or self clamping -



Width of groove	.079 - .197"
Depth of groove up to	2.165"

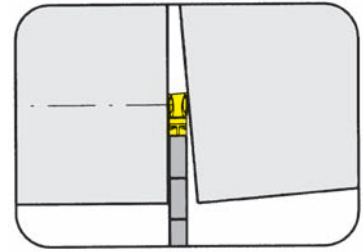
TOOLHOLDER Type

H100

with self clamping

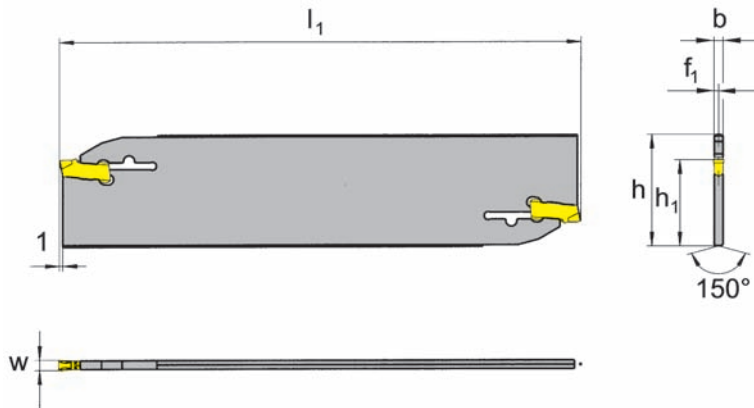
Depth of groove up to
Width of groove

2.165" (55.0 mm)
.079 - .197" (2.0 - 5.0 mm)



for use with Insert

Type S100



Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	Size
H100.2601.01	26	1.5	110	21.4	0.75	25.0	50	01
H100.3201.01	32		150	24.8				
H100.2602.02	26	1.9	110	21.4	0.95	37.5	75	02
H100.3202.02	32		150	24.8				
H100.2603.03	26	2.3	110	21.4	1.15	37.5	75	03
H100.3203.03	32		150	24.8				
H100.2604.04	26	3.1	110	21.8	1.65	40.0	80	04
H100.3204.04	32		160	24.8				
H100.3205.05	32	3.9	160	24.8	2.00	55.0	110	05

Further sizes upon request

w see inserts

Dimensions in mm

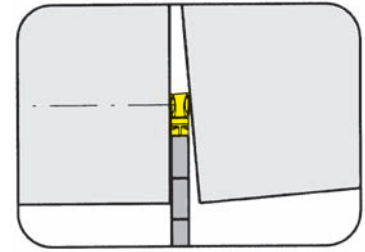
Spare parts

Toolholder	Wrench
H100....	P39L

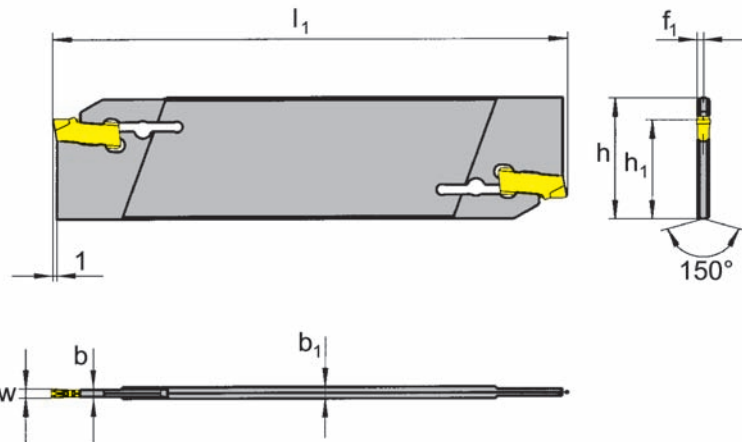
TOOLHOLDER Type

H100

with self clamping



Depth of groove up to .984" (25.0 mm)
Width of groove .079 - .098" (2.0 - 2.5 mm)



for use with Insert

Type S100

Part number	h	b	l ₁	h ₁	b ₁	f ₁	t _{max}	D _{max}	Size
H100.2603.01	26	1.5	110	21.4	2.3	1.15	21	42	01
H100.3203.01	32		150	24.8			25	50	
H100.2603.02	26	1.9	110	21.4	2.3	1.15	21	42	02
H100.3203.02	32		150	24.8			25	50	

Further sizes upon request

w see inserts

Dimensions in mm

Spare parts

Toolholder	Wrench
H100....	P39L

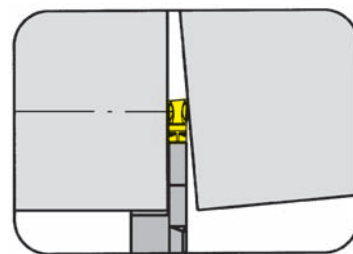
TOOLHOLDER Type

H100

with self clamping

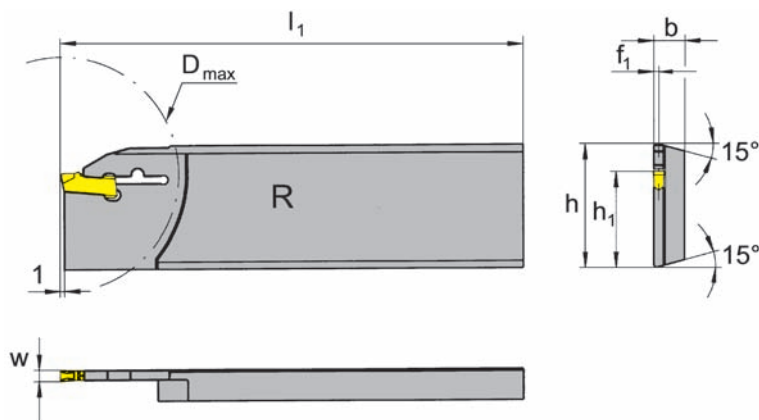
Depth of groove up to
Width of groove

1.280" (32.5 mm)
.079 - .157" (2.0 - 4.0 mm)



for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	t_{max}	D_{max}	Size
R/LH100.2608.31	26	7.9	110	21.4	0.75	21.0	42	01
R/LH100.3208.31	32		112	24.8		25.0	50	
R/LH100.2608.32	26	7.9	110	21.4	0.95	25.0	50	02
R/LH100.3208.32	32		112	24.8		32.5	65	
R/LH100.2608.33	26	7.9	110	21.4	1.15	25.0	50	03
R/LH100.3208.33	32		112	24.8		32.5	65	
R/LH100.2608.34	26	7.9	110	21.4	1.55	25.0	50	04
R/LH100.3208.34	32		112	24.8		32.5	65	

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Wrench
R/LH100....	P39L

Recommended for Traub machines type:

R/L100.2608.31-34	R/LH100.3208.31-34
TNC 30	TNC 42/65
TNM 28	TNM 42/65
TNS 26	TNS 65
TNS 30/42	TNS 60
TNA 300	TNA 400
TNK 28/36	TNA 300
TNL 26	

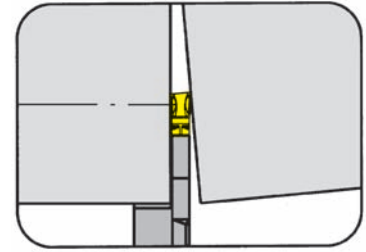
GROOVING and PARTING OFF



TOOLHOLDER Type

H100

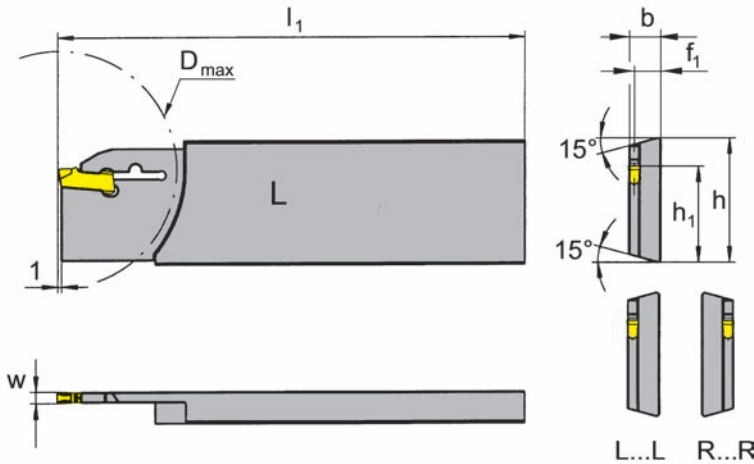
with self clamping



Depth of groove up to 1.280" (32.5 mm)
Width of groove .079 - .157" (2.0 - 4.0 mm)

for use with Insert

Type S100



L = left hand version shown

R = right hand version

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	Size
R/LH100.2608.31R/L	26	7.9	110	21.4	7.15	21.0	42	01
R/LH100.3208.31R/L	32		112	24.8		25.0	50	
R/LH100.2608.32R/L	26	7.9	110	21.4	6.95	25.0	50	02
R/LH100.3208.32R/L	32		112	24.8		32.5	65	
R/LH100.2608.33R/L	26	7.9	110	21.4	6.75	25.0	50	03
R/LH100.3208.33R/L	32		112	24.8		32.5	65	
R/LH100.2608.34R/L	26	7.9	110	21.4	6.35	25.0	50	04
R/LH100.3208.34R/L	32		112	24.8		32.5	65	

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Wrench
R/LH100....	P39L

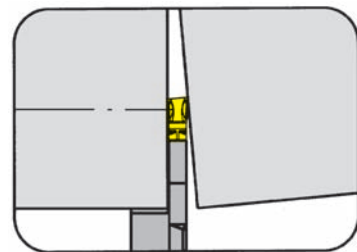
TOOLHOLDER Type

H100

with self clamping

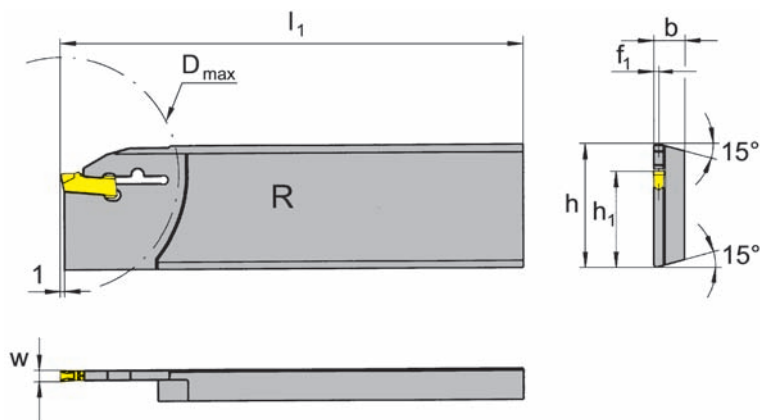
Depth of groove up to
Width of groove

1.614" (41.0 mm)
.157" (4.0 mm)



for use with Insert

Type S100



R = right hand version

Part number	h	b	l_1	h_1	f_1	t_{max}	D_{max}	Size
RH100.3208.2.44	32	7.9	160	24.8	1.55	41	80	04
RH100.3208.44			130					

Further sizes upon request

w see inserts

Dimensions in mm

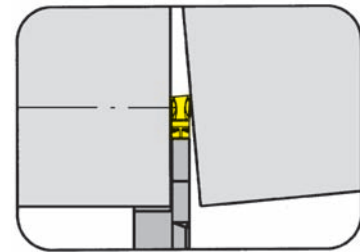
Spare parts

Toolholder	Wrench
RH100.3208....	P39L

TOOLHOLDER Type

H100

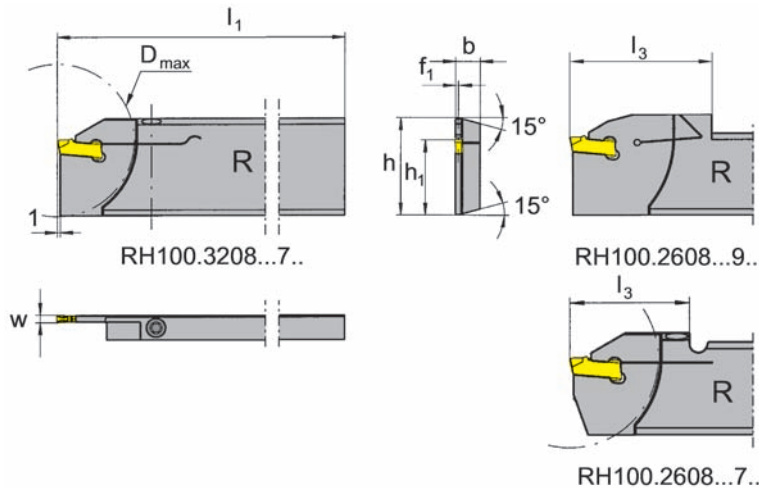
with screwed clamping



Depth of groove up to 1.280" (32.5 mm)
Width of groove .079 - .118" (2.0 - 3.0 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	l ₃	Size
R/LH100.2608.71	26	7.9	110	21.4	0.75	25.0	50	33.8	01
R/LH100.3208.71	32		112	24.8					
R/LH100.2608.72	26	7.9	110	21.4	0.95	25.0	50	33.8	02
R/LH100.3208.72	32		112	24.8					
R/LH100.2608.93	26	8.0	112	21.4	1.15	25.0	50	40.0	03
R/LH100.3208.93	32								

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS®-Wrench	Pin
R/LH100....71/72	4.15T15P	T15PQ	020.0040.0999
R/LH100....93	030.0413.T15P	T15PQ	

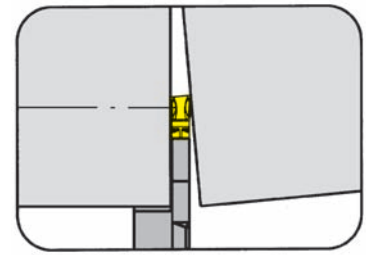
TOOLHOLDER Type

H100

with screwed clamping

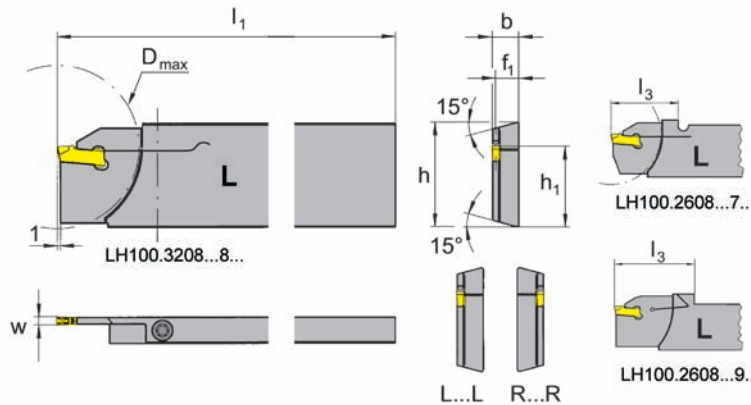
Depth of groove up to
Width of groove

1.280" (32.5 mm)
.079 - .118" (2.0 - 3.0 mm)



for use with Insert

Type S100



L = left hand version shown

R = right hand version

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	l ₃	Size
R/LH100.2608.71R/L R/LH100.3208.71R/L	26 32	7.9	110 112	21.4 24.8	7.15	25.0	50	33.8	01
R/LH100.2608.72R/L R/LH100.3208.72R/L	26 32	7.9	110 112	21.4 24.8	6.95	25.0	50	33.8	02
R/LH100.2608.93R/L R/LH100.3208.93R/L	26 32	8.0	115	21.4 24.8	6.85	25.0 32.5	50 65	40.0 42.0	03

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

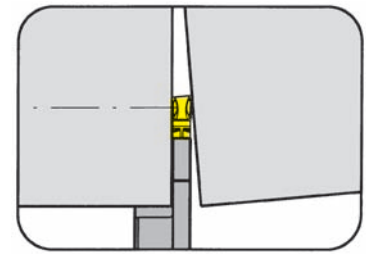
Toolholder	Screw	TORX PLUS®-Wrench	Pin
R/LH100....71R/L/72R/L R/LH100....93R/L	4.15T15P 030.0413.T15P	T15PQ T15PQ	020.0040.0999

TOOLHOLDER Type

H100

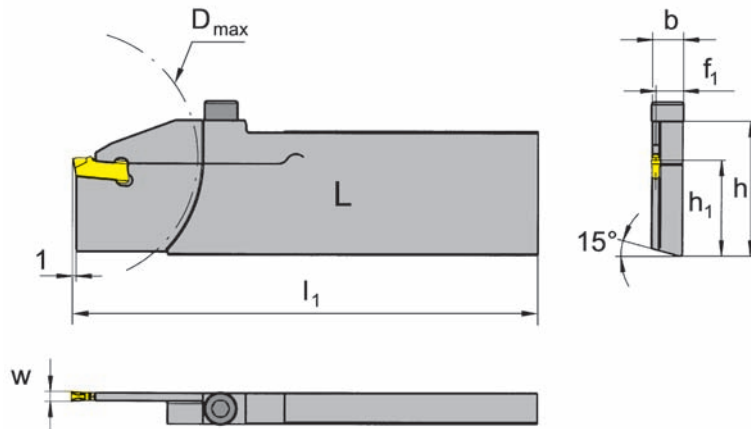
Depth of groove up to 1.280" (32.5 mm)
Width of groove .118 - .157" (3.0 - 4.0 mm)

for machines TRAUB (TNX65)



for use with Insert

Type S100



L = left hand version shown

R = right hand version

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	Size
R/LH100.3280.73R/L	32	7.9	130	24.8	6.75	32.5	65	03
R/LH100.3280.74R/L	32	7.9	130	24.8	6.35	32.5	65	04

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Screw	Wrench
R/LH100.3280.7...	DIN912-M5x20	SW4DIN911

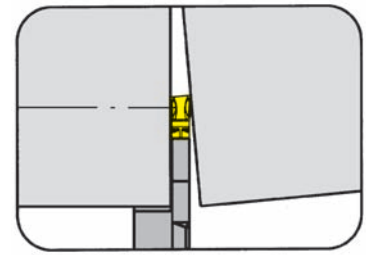
TOOLHOLDER Type

H100

with screwed clamping

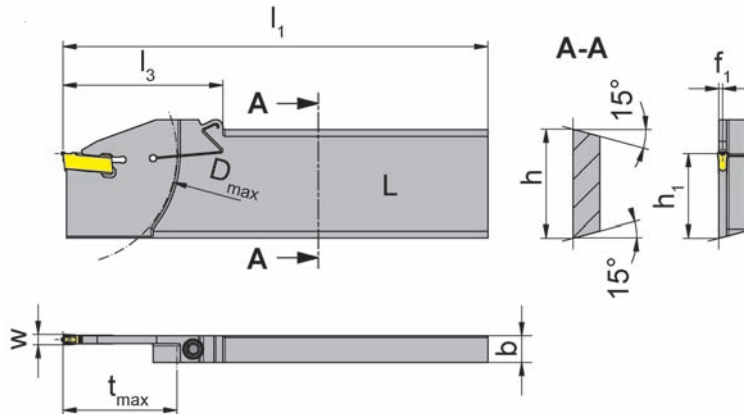
Depth of groove up to
Width of groove

1.319" (33.5 mm)
.118 - .157" (3.0 - 4.0 mm)



for use with Insert

Type S100



R = right hand version shown

L = left hand version

for machines TRAUB and
INDEX

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	l ₃	Size	Type of machine
R/LH100.3208.83	32	8	125	24.8	1.15	33.5	65	47	03	TraubTNX65/42.IndexC65
R/LH100.3208.84	32	8	125	24.8	1.50	33.5	65	47	04	TraubTNX65/42.IndexC65

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LH100.3208.8...	030.505P.0718	T15PQ

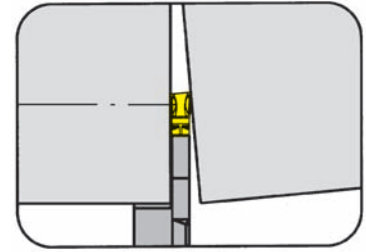
GROOVING and PARTING OFF



TOOLHOLDER Type

H100

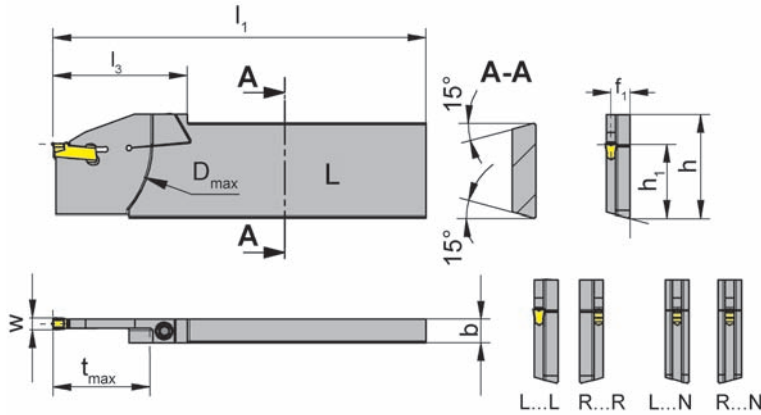
with screwed clamping



Depth of groove up to 1.614" (41.0 mm)
Width of groove .118 - .157" (3.0 - 4.0 mm)

for use with Insert

Type S100



L = left hand version shown

R = right hand version

for machines TRAUB and INDEX

Part number	h	b	l ₁	h ₁	f ₁	t _{max}	D _{max}	l ₃	Size	Type of machine
R/LH100.3208.83R/L	32	8	125	24.8	6.75	33.5	65	47.0	03	TraubTNX65/42.IndexC65
R/LH100.3208.84R/L	32	8	125	24.8	6.35	33.5	65	47.0	04	TraubTNX65/42.IndexC65
R/LH100.3208.84N	32	8	134	24.8	4.00	41.0	80	54.5	04	TraubTNX80/65

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS®-Wrench
R/LH100.3208.8...	030.505P.0660	T15PQ

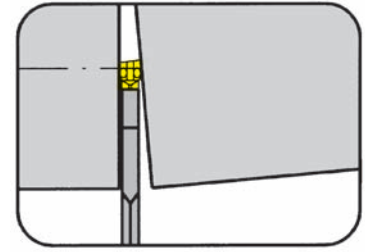
TOOLHOLDER Type

H100

with self clamping

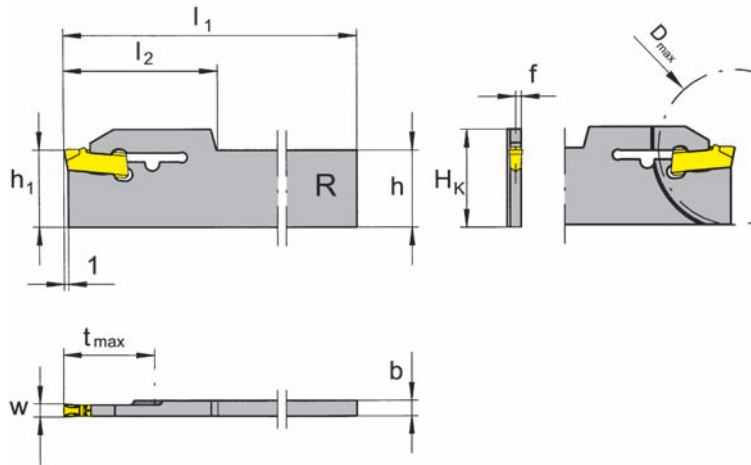
Depth of groove up to
Width of groove

1.496" (38.0 mm)
.079 - .118" (2.0 - 3.0 mm)



for use with Insert

Type S100



R = right hand version

Part number	h	b	l ₁	h ₁	f	l ₂	t _{max}	D _{max}	H _k	Size
RH100.1703.21	17.4	3.2	110	17.4	0.75	32.0	17.5	35	22.1	01
RH100.2203.21	22.1		150	22.2			38.0	50	26.9	
RH100.1703.33	17.4	3.2	110	17.4	1.15	34.5	30.0	60	22.1	03
RH100.2203.33	22.1		150	22.2			38.0	76	26.9	

Further sizes upon request

w see inserts

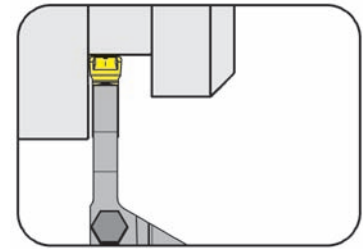
Dimensions in mm

Spare parts

Toolholder	Wrench
RH100....	P39L

TOOLHOLDER Type

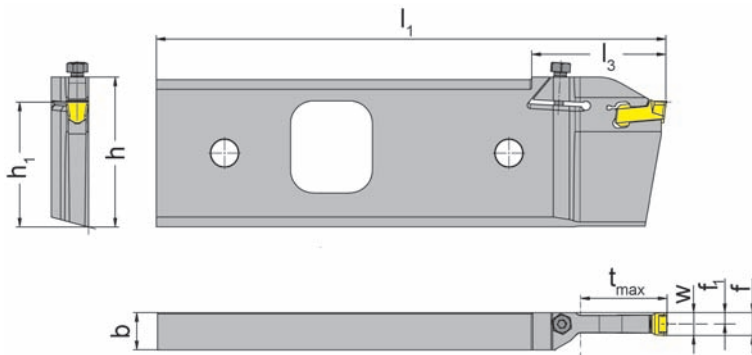
H100



Depth of groove up to 2.559" (65.0 mm)
Width of groove .315 - .472" (8.0 - 12.0 mm)

for use with Insert

Type S100



L = left hand version shown

Part number	h	b	l ₁	h ₁	f ₁	f	t _{max}	l ₃	Size
LH100.5517.38.8.08 LH100.5517.54.8.08	65	16.4	224	55	4	f ₁ +w/2	38 54	59 75	08
LH100.5517.38.8.10 LH100.5517.54.8.10	65	16.4	224	55	5	f ₁ +w/2	38 54	59 75	10
LH100.5517.44.8.12 LH100.5517.65.8.12	65	16.4	224	55	6	f ₁ +w/2	44 65	65 86	12

Further sizes upon request

w see inserts

Dimensions in mm

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
LH100.5517....	030.6075.T20P	T20PQ

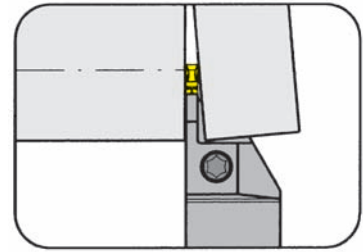
TOOLHOLDER Type

HU100

with screwed clamping

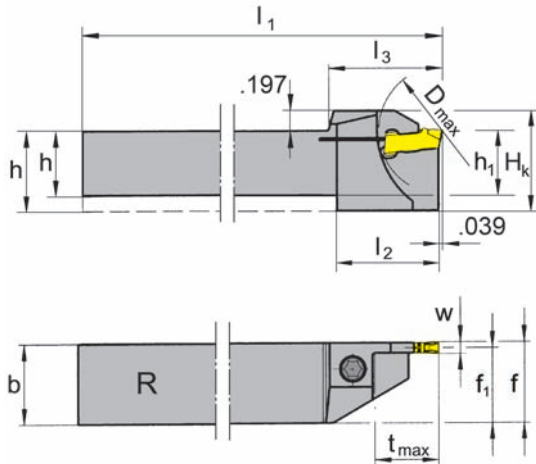
Depth of groove up to
Width of groove

.827"
.079"



for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size
R/LHU100.0500.01	.500	.500	5.125	.500	.470	$f_1+w/2$.827	.512	1.024	.906	.822	01
R/LHU100.0500.11	.500	.500	5.125	.500	.470	$f_1+w/2$.827	.630	1.654	1.024	.822	01
R/LHU100.0625.11	.625	.625	5.125	.625	.595	$f_1+w/2$.945	.630	1.654	1.024	.947	01
R/LHU100.0625.21	.625	.625	5.125	.625	.595	$f_1+w/2$	1.181	.827	1.654	1.319	.947	01
R/LHU100.0750.11	.750	.750	5.125	.750	.720	$f_1+w/2$	-	.630	1.654	1.024	.947	01
R/LHU100.0750.21	.750	.750	5.125	.750	.720	$f_1+w/2$	-	.827	1.654	1.319	.947	01

State R or L version

w see inserts

Dimensions in inch

Further sizes upon request

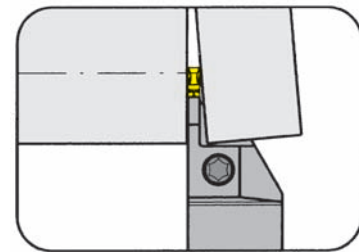
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LHU100.0...	4.15T15P	T15PQ

TOOLHOLDER Type

H100

with screwed clamping

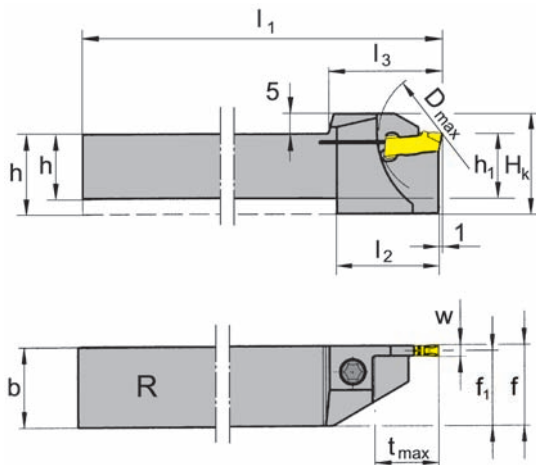


Depth of groove up to
Width of groove

.827" (21.0 mm)
.079" (2.0 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size
R/LH100.1010.01 R/LH100.1010.11	10	10	125	10	9.25	$f_1+w/2$	19 21	10.5 13.0	21 42	21.0 23.0	18 21	01
R/LH100.1212.01 R/LH100.1212.11	12	12	125	12	11.25	$f_1+w/2$	21	13.0 16.0	26 42	23.0 26.0	21	01
R/LH100.1616.11 R/LH100.1616.21	16	16	125	16	15.25	$f_1+w/2$	24 30	16.0 21.0	42	26.0 33.5	25	01
R/LH100.2020.11 R/LH100.2020.21	20	20	125	20	19.25	$f_1+w/2$	-	16.0 21.0	42	33.5	25	01
R/LH100.2525.21	25	25	150	25	24.30	$f_1+w/2$	-	21.0	42	33.5	30	01

State R or L version

w see inserts

Dimensions in mm

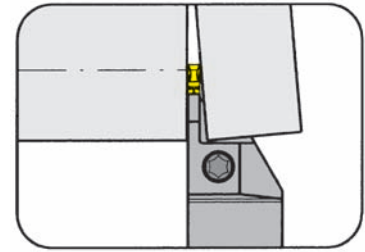
Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS®-Wrench
R/LH100....	4.15T15P	T15PQ

TOOLHOLDER Type

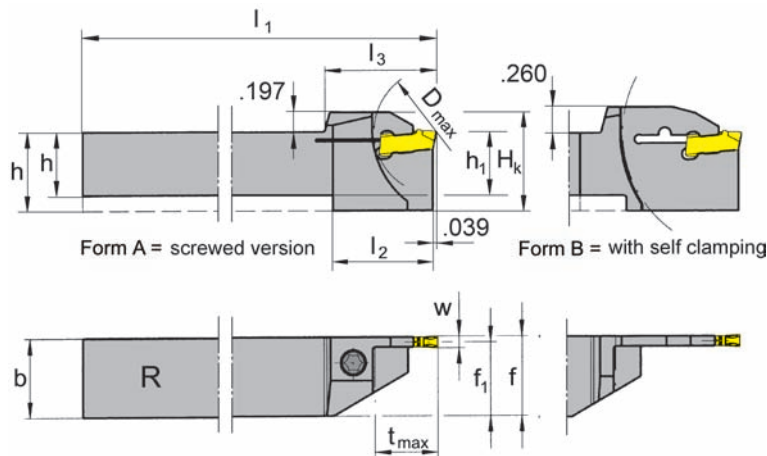
HU100



Depth of groove up to 1.280"
Width of groove .098"

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	D _{max}	l ₃	H _k	Size	Form
R/LHU100.0625.02	.625	.625	5.125	.625	.588	f ₁ +w/2	.748	.413	1.654	.827	.947	02	A
R/LHU100.0500.02	.500	.500		.500	.463	f ₁ +w/2	.827	.512	.984	.906	.823		
R/LHU100.0500.12	.500	.500	5.125	.500	.463	f ₁ +w/2	.945	.630	1.654	1.024	.947	02	A
R/LHU100.0625.12	.625	.625		.625	.588	f ₁ +w/2	.945						
R/LHU100.0750.12	.750	.750	5.125	.750	.713	f ₁ +w/2	-	.827	1.654	1.319	.947	02	A
R/LHU100.0625.22	.625	.625		.625	.588	f ₁ +w/2	1.181						
R/LHU100.0750.22	.750	.750	.750	.713	f ₁ +w/2	-	1.378	1.280	2.559	1.516	1.260	02	B
R/LHU100.0750.32	.750	.750	.750	.713	f ₁ +w/2								

State R or L version

w see inserts

Dimensions in inch

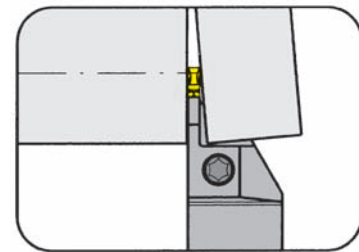
Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS® Wrench	Wrench
R/LHU100.0...02/12/22 R/LHU100.0750.32	4.15T15P	T15PQ	P39L

TOOLHOLDER Type

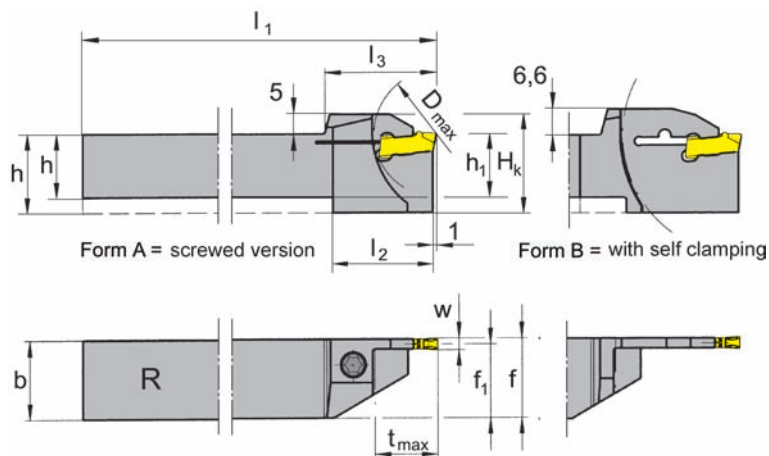
H100



Depth of groove up to 1.280" (32.5 mm)
Width of groove .098" (2.5 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size	Form	
R/LH100.1212.02	12	12	125	16	11.05	$f_1+w/2$	21	13.0	25	23.0	21.0	02	A	
R/LH100.1616.02	16	16		20	15.05	$f_1+w/2$	19	10.5	42	21.0	25.0			
R/LH100.1212.12	12	12	125	16	11.05	$f_1+w/2$	24	-	42	26.0	25.0	02	A	
R/LH100.1616.12	16	16		20	15.05		24							16.0
R/LH100.2020.12	20	20		20	19.05		-							-
R/LH100.1616.22	16	16	125	20	15.05	$f_1+w/2$	30	21.0	42	33.5	25.0	02	A	
R/LH100.2020.22	20	20	125	20	19.05		-				21.0			25.0
R/LH100.2525.22	25	25	150	25	24.05		-				-			30.0
R/LH100.2020.32	20	20	125	25	19.05	$f_1+w/2$	35	32.5	65	38.5	31.6	02	B	

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

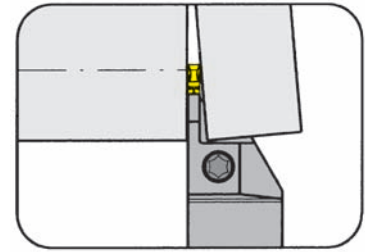
Toolholder	Screw	TORX PLUS®-Wrench	Wrench
R/LH100....02/12/22 R/LH100.2020.32	4.15T15P	T15PQ	P39L

TOOLHOLDER Type

HU100

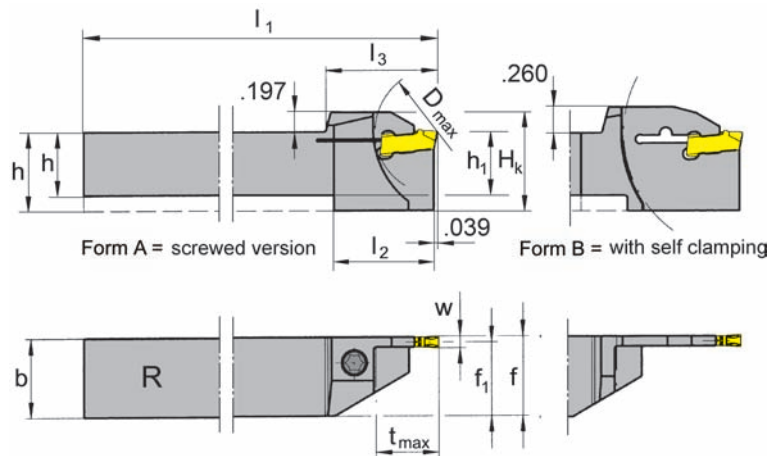
Depth of groove up to
Width of groove

1.280"
.118"



for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size	Form
RHU100.0500.03	.500	.500	5.125	.500	.455	$f_1+w/2$.827	.512	1.024	.906	.822	03	A
RHU100.0625.03	.625	.625	5.125	.625	.580	$f_1+w/2$.768	.413	1.654	.906	.947	03	A
RHU100.0625.13	.625	.625	5.125	.625	.580	$f_1+w/2$.984	-	1.654	1.122	.947	03	A
RHU100.0750.13	.750	.750	5.125	.750	.705	$f_1+w/2$	-	.630	1.654	1.122	.947	03	A
RHU100.1000.13	1.000	1.000	6.000	1.000	.955	$f_1+w/2$	-	-	1.654	1.122	1.197	03	A
RHU100.0625.23	.625	.625	5.125	.625	.580	$f_1+w/2$	1.181	-	1.654	1.319	.947	03	A
RHU100.0750.23	.750	.750	5.125	.750	.705	$f_1+w/2$	-	.827	1.654	1.319	.947	03	A
RHU100.0750.33	.750	.750	5.125	.750	.705	$f_1+w/2$	1.378	-	2.559	1.516	1.260	03	B
RHU100.1000.33	1.000	1.000	6.000	1.000	.955	$f_1+w/2$	-	1.280	2.559	1.516	1.260	03	B

State R or L version

w see inserts

Dimensions in inch

Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS® Wrench	Wrench
RHU100....03/13/23 RHU100....33	5.17T20P	T20PQ	P39L

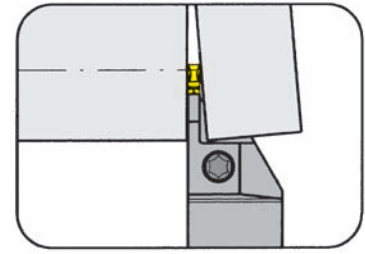
P90

GROOVING and PARTING OFF



TOOLHOLDER Type

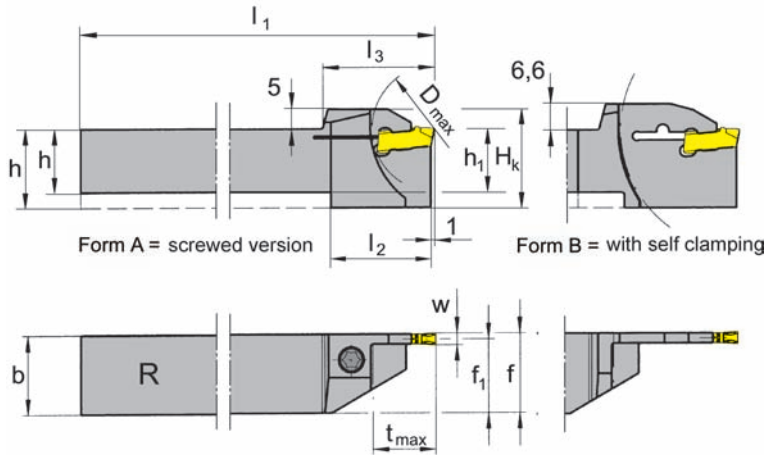
H100



Depth of groove up to 1.280" (32.5 mm)
Width of groove .118" (3.0 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	D _{max}	l ₃	H _k	Size	Form
R/LH100.1616.03	16	16	125	20	14.85	f ₁ +w/2	19.5	10.5	42	23.0	25.0	03	A
R/LH100.1212.03	12	12	125	16	10.85	f ₁ +w/2	21.0	13.0	26	23.0	25.0	03	A
R/LH100.1616.13	16	16	125	20	14.85	f ₁ +w/2	25.0	-	42	28.5	25.0	03	A
R/LH100.2020.13	20	20	125	20	18.85	f ₁ +w/2	-	16.0	42	28.5	25.0	03	A
R/LH100.2525.13	25	25	150	25	23.85	f ₁ +w/2	-	-	42	30.0	30.0	03	A
R/LH100.1616.23	16	16	125	20	14.85	f ₁ +w/2	30.0	21.0	42	33.5	25.0	03	A
R/LH100.2020.23	20	20	125	20	18.85	f ₁ +w/2	-	21.0	42	33.5	25.0	03	A
R/LH100.2020.33	20	20	125	25	18.85	f ₁ +w/2	35.0	32.5	65	38.5	31.6	03	B
R/LH100.2525.33	25	25	150	25	23.85	f ₁ +w/2	-	32.5	65	38.5	31.6	03	B

State R or L version

w see inserts

Dimensions in mm

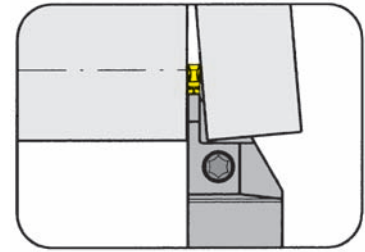
Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS®-Wrench	Wrench
R/LH100....03/13/23 R/LH100.2...33	5.17T20P	T20PQ	P39L

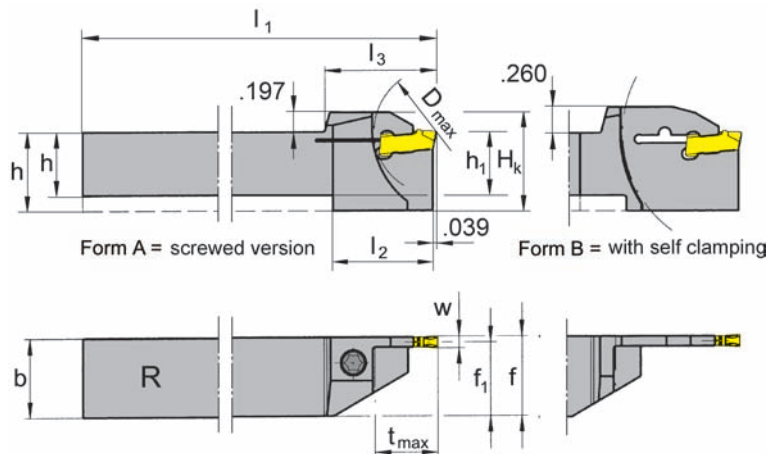
TOOLHOLDER Type

HU100
 Depth of groove up to
 Width of groove

 1.594"
 .157"


for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size	Form
R/LHU100.0625.04	.625	.625	5.125	.625	.564	$f_1+w/2$.768	.413	1.654	.906	.947	04	A
R/LHU100.0750.14	.750	.750	5.125	.750	.685	$f_1+w/2$	-	.630	1.654	1.122	.947	04	A
R/LHU100.1000.14	1.000	1.000	6.000	1.000	.939	$f_1+w/2$	-	.630	1.654	1.122	1.197	04	A
R/LHU100.0625.24	.625	.625	5.125	.625	.564	$f_1+w/2$	1.181	.827	1.654	1.319	.947	04	A
R/LHU100.0750.34	.750	.750	5.125	.750	.689	$f_1+w/2$	1.378	1.280	2.559	1.516	1.260	04	B
R/LHU100.1000.34	1.000	1.000	6.000	1.000	.939	$f_1+w/2$	1.575	1.594	3.189	1.831	1.510	04	B

State R or L version

w see inserts

Dimensions in inch

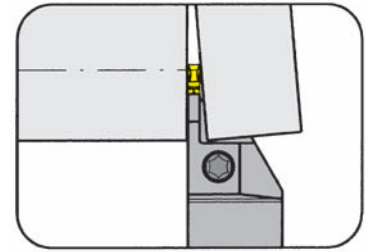
Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS® Wrench	Wrench
R/LHU100....04/14/24 R/LHU100....34	5.17T20P	T20PQ	P39L

TOOLHOLDER Type

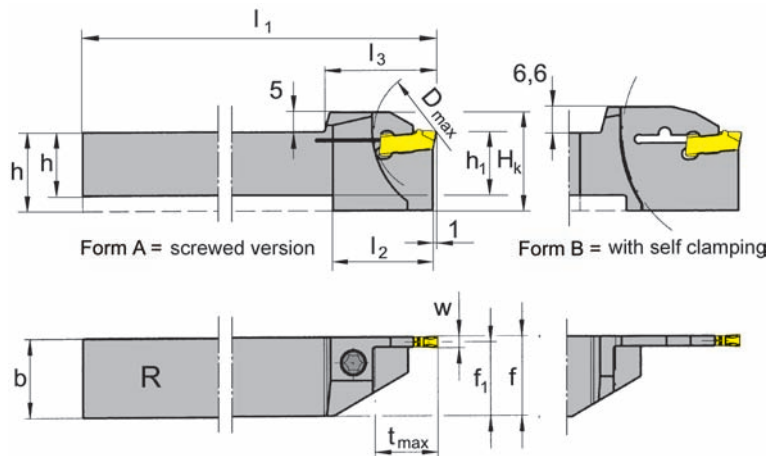
H100



Depth of groove up to 1.594" (40.5 mm)
Width of groove .157" (4.0 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	D _{max}	l ₃	H _k	Size	Form
R/LH100.1616.04	16	16	125	20	14.45	f ₁ +w/2	19.5	10.5	42	23.0	25.0	04	A
R/LH100.1616.14	16	16	125	20	14.45	f ₁ +w/2	25.0				25.0		
R/LH100.2020.14	20	20	125	20	18.45	f ₁ +w/2	-	16.0	42	28.5	25.0	04	A
R/LH100.2525.14	25	25	150	25	23.45	f ₁ +w/2	-				30.0		
R/LH100.1616.24	16	16	125	20	14.45	f ₁ +w/2	30.0	21.0	42	33.5	25.0	04	A
R/LH100.2020.34	20	20	125	25	18.45	f ₁ +w/2	35.0	32.5	65	38.5			
R/LH100.2525.34	25	25	150	32	23.45	f ₁ +w/2	40.0	40.5	81	46.5	31.6	04	B

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

Spare parts

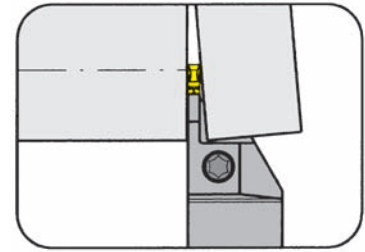
Toolholder	Screw	TORX PLUS®-Wrench	Wrench
R/LH100....04/14/24 R/LH100.2...34	5.17T20P	T20PQ	P39L

TOOLHOLDER Type

HU100

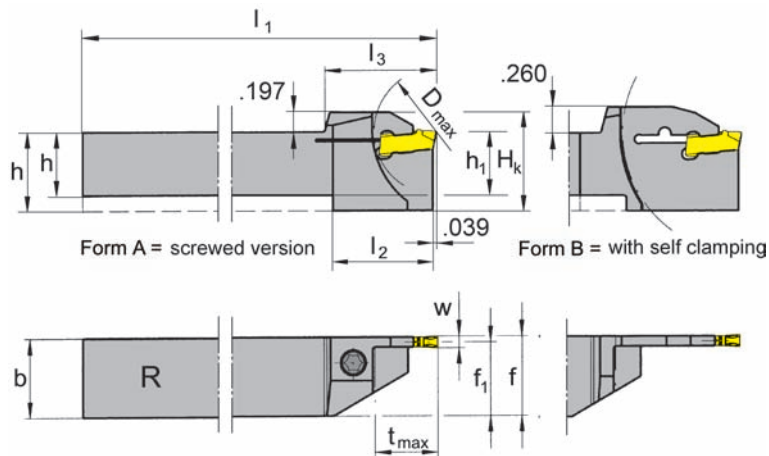
Depth of groove up to
Width of groove

1.594"
.197"



for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	D_{max}	l_3	H_k	Size	Form
R/LHU100.0750.15	.750	.750	5.125	.750	.673	$f_1+w/2$	-	.630	1.654	1.122	.947	05	A
R/LHU100.1000.15	1.000	1.000	6.000	1.000	.923	$f_1+w/2$	-	.630	1.654	1.122	1.197	05	A
R/LHU100.0750.35	.750	.750	5.125	.750	.673	$f_1+w/2$	1.378	1.280	2.559	1.516	1.260	05	B
R/LHU100.1000.35	1.000	1.000	6.000	1.000	.923	$f_1+w/2$	1.575	1.594	3.189	1.831	1.510	05	B

State R or L version

w see inserts

Dimensions in inch

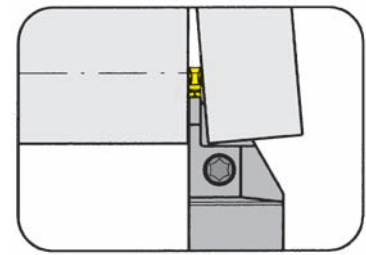
Further sizes upon request

Spare parts

Toolholder	Screw	TORX PLUS® Wrench	Wrench
R/LHU100....15 R/LHU100....35	5.17T20P	T20PQ	P39L

TOOLHOLDER Type

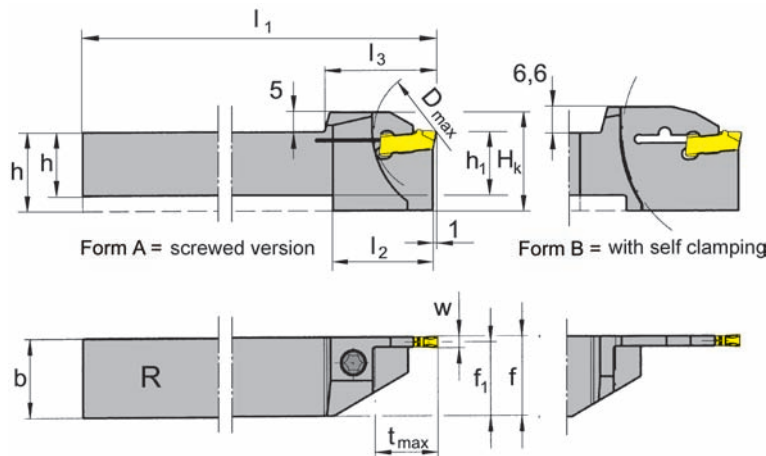
H100



Depth of groove up to 1.594" (40.5 mm)
Width of groove .197" (5.0 mm)

for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l ₁	h ₁	f ₁	f	l ₂	t _{max}	D _{max}	l ₃	H _k	Size	Form
R/LH100.2020.15	20	20	125	20	18.05	f ₁ +w/2	-	16.0	42	28.5	25.0	05	A
R/LH100.2525.15	25	25	150	25	23.05	f ₁ +w/2	-	16.0	42	28.5	30.0	05	A
R/LH100.2020.35	20	20	125	25	18.05	f ₁ +w/2	35	32.5	65	38.5	31.6	05	B
R/LH100.2525.35	25	25	150	32	23.05	f ₁ +w/2	40	40.5	81	46.5	38.6	05	B

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

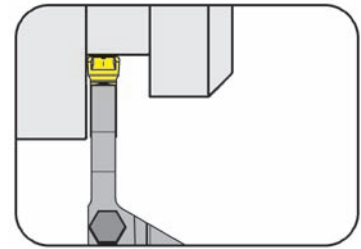
Spare parts

Toolholder	Screw	TORX PLUS®-Wrench	Wrench
R/LH100.2...15 R/LH100.2...35	5.17T20P	T20PQ	P39L

TOOLHOLDER Type

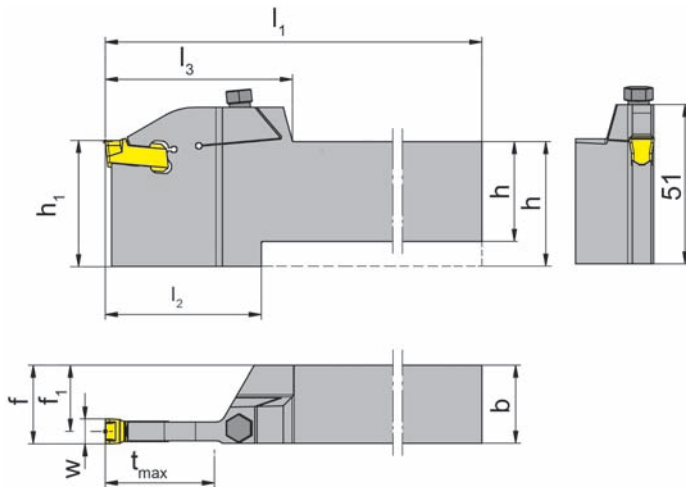
H100

Depth of groove up to 1.575" (40.0 mm)
Width of groove .236 - .472" (6.0 - 12.0 mm)



for use with Insert

Type S100



R = right hand version shown

L = left hand version

Part number	h	b	l_1	h_1	f_1	f	l_2	t_{max}	l_3	Size
R/LH100.2525.36	25	25	150	40	22.2	$f_1+w/2$	50	33	60	06
R/LH100.3225.36	32	25	170	40	22.2	$f_1+w/2$	50	33	60	06
R/LH100.3225.38	32	25	170	40	21.2	$f_1+w/2$	50	35	60	08
R/LH100.3225.4.10	32	25	170	40	20.3	$f_1+w/2$	55	41	65	10
R/LH100.3225.4.12	32	25	170	40	19.3	$f_1+w/2$	55	41	65	12

State R or L version

w see inserts

Dimensions in mm

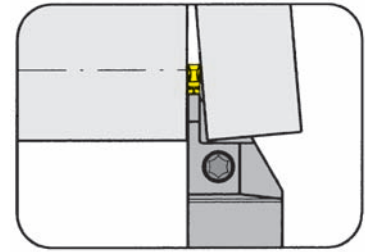
Further sizes upon request

Spare parts

Toolholder	Screw
R/LH100....	030.6075.T20P

TOOLHOLDER Type

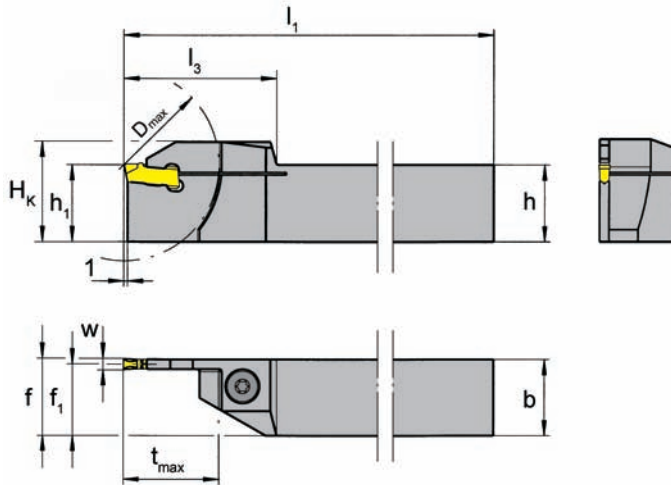
H100



Depth of groove up to .984" (25.0 mm)
Width of groove .118 - .157" (3.0 - 4.0 mm)

for use with Insert

Type S100



L = left hand version shown

R = right hand version

Part number	h	b	l ₁	h ₁	f ₁	f	t _{max}	D _{max}	l ₃	H _k	Size
R/LH100.2020.73	20	20	125	20	18.85	f ₁ +w/2	25	50	40	26	03
R/LH100.2525.73	25	25	150	25	23.85	f ₁ +w/2	25	50	40	31	03
R/LH100.2020.74	20	20	125	20	18.85	f ₁ +w/2	25	50	40	26	04

State R or L version

w see inserts

Dimensions in mm

Further sizes upon request

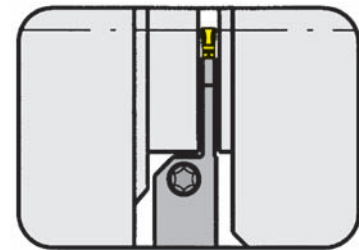
Spare parts

Toolholder	Screw	TORX PLUS®-Wrench
R/LH100.2...	6.23T25P	T25PQ

BASIC TOOLHOLDER Type

220

without cassette

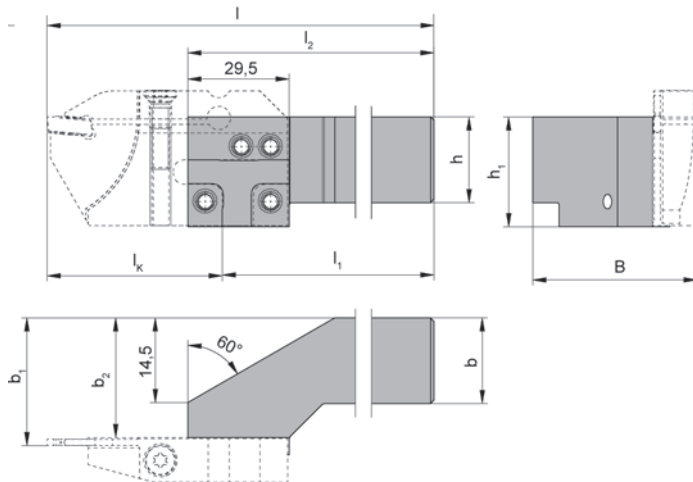


Basic adapter for cassettes type RNK100

Shank parallel to the axis of workpiece

for use with Cassette

Type RNK100



Multi spindle system
MS52

R = right hand version

Part number	h	l ₁	h ₁	b	b ₁	b ₂	l ₂	l	B
R220.2529.60.K1	25	l ₂ -10	32	25	b ₂ +f ₃	29.5	160	l ₁ +l _K	b ₂ +b ₃
R220.2535.60.K1						34.9			

Further sizes upon request

l_K, b₃ and f₃ see cassettes

Dimensions in mm

Spare parts

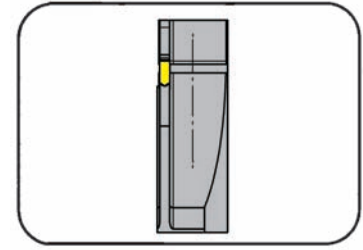
Basic toolholder	Screw	TORX PLUS®-Wrench
R220.25...	5.12T20P	T20PQ

GROOVING and PARTING OFF (external)



CASSETTE Type

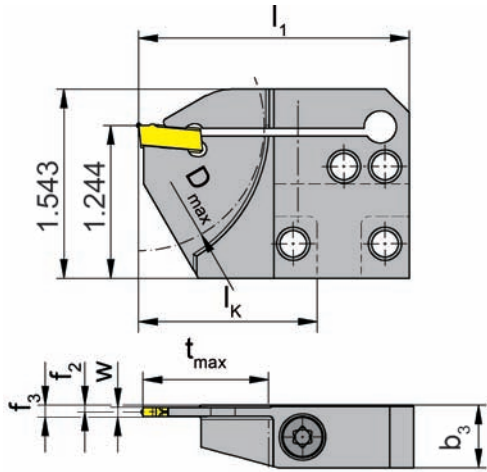
NK100



Depth of groove up to 1.024"
Width of groove .098 - .118"

for use with Insert

Type S100



R = right hand version shown

Part number	l_1	t_{max}	D_{max}	b_3	f_2	f_3	l_k
RNK100.5625.02L RNK100.5625.03L	2.205	1.024	2.047	.512	.055 .065	$f_2+w/2$	1.457
RNK100.7025.02L RNK100.7025.03L	2.756	1.024	2.047	.512	.055 .065	$f_2+w/2$	2.008

For basic toolholder R...K1 and L...K2

w see inserts

Dimensions in inch

Ordering note:

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

Further sizes upon request

Spare parts

Cassette	Screw	TORX PLUS® Wrench
RNK100....	5.13T20P	T20PQ

Machine examples - Multispindle machines

- ▶ INDEX
- ▶ Gildemeister
- ▶ Wickmann
- ▶ Schütte
- ▶ Tornos



Further types upon request.

Machine examples - high production lathes

- ▶ INDEX
- ▶ Gildemeister
- ▶ Tornos
- ▶ Traub
- ▶ Miyano
- ▶ MORI SEIKI

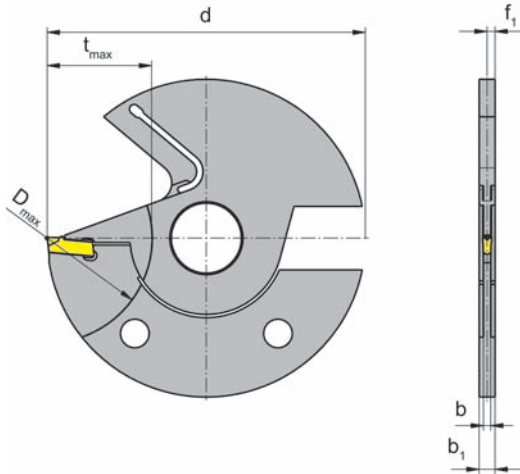


Further types upon request.

CIRCULAR PART-OFF TOOL Type 300.2...

with through coolant supply

Depth of groove .512 / .709" (13 / 18 mm)
 Width of groove .079 - .197" (2.0 - 5.0 mm)



for use with Insert

Type S100

Part number	b	b ₁	f ₁	t _{max}	w	D _{max}	d	Size
300.20.20.00 300.21.20.00	5	1.5	2.5	13 18	2.0/2.2	26 36	50 63	01
300.20.25.00 300.21.25.00	5	1.9	2.5	13 18	2.5	26 36	50 63	02
300.20.30.00 300.21.30.00	5	2.3	2.5	13 18	3.0	26 36	50 63	03
300.20.40.00 300.21.40.00	5	3.1	2.5	13 18	4.0	26 36	50 63	04
300.20.50.00 300.21.50.00	5	3.9	2.5	13 18	5.0	26 36	50 63	05

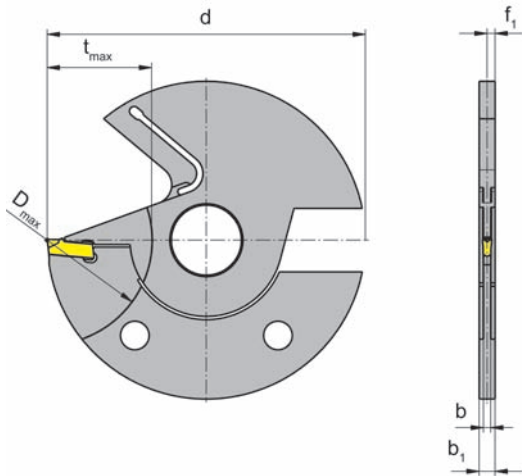
Further sizes upon request

Dimensions in mm

CIRCULAR PART-OFF TOOL Type **300.2...**

with through coolant supply

Depth of groove 1.102 / 1.299" (28 / 33 mm)
 Width of groove .079 - .197" (2.0 - 5.0 mm)



for use with Insert

Type S100

Part number	b	b ₁	f ₁	t _{max}	w	D _{max}	d	Size
300.22.20.00 300.23.20.00	5	1.5	2.5	28 33	2.0/2.2	56 66	80 100	01
300.22.25.00 300.23.25.00	5	1.9	2.5	28 33	2.5	56 66	80 100	02
300.22.30.00 300.23.30.00	5	2.3	2.5	28 33	3.0	56 66	80 100	03
300.22.40.00 300.23.40.00	5	3.1	2.5	28 33	4.0	56 66	80 100	04
300.22.50.00 300.23.50.00	5	3.9	2.5	28 33	5.0	56 66	80 100	05

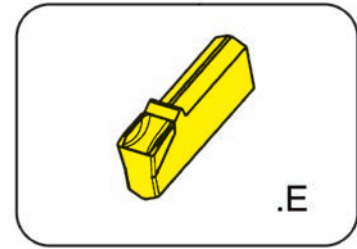
Further sizes upon request

Dimensions in mm

INSERT Type

S100

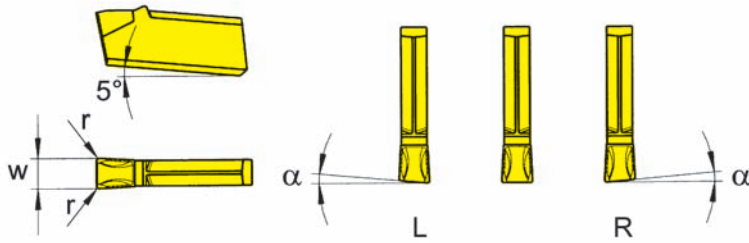
with chip former



Width of groove .079 - .157"

for use with Toolholder

Type 300.2...
H100
HU100
NK100



R = right hand version

L = left hand version

Part number	w	r	α	Size	Ti22	TF42	TF43	TF45	TF46	TC92	ALX2	ALX3	AS6G
S100.0200.E2 R/LS100.0520.E2	.079	.008	0° 5°	01	▲		▲	▲	▲	▲			
S100.0250.E2 R/LS100.0525.E2	.098	.008	0° 5°	02	▲		▲	▲	▲				
S100.0300.E2 R/LS100.0530.E2	.118	.008	0° 5°	03	▲	▲	▲	▲	▲	▲	▲	▲	
R/LS100.0540.E2	.157	.008	5°	04	▲/▲		▲	▲	▲				

P	•	•	•	•	•	•	•	•	•	•	•	•	•
M				•	○								
K				•	•								
S				•	○								
N				•	•								
H													

▲ 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

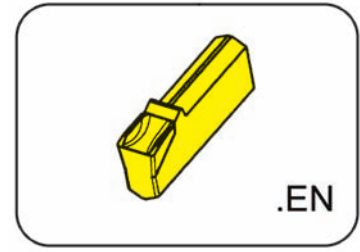
GROOVING and PARTING OFF



INSERT Type

S100

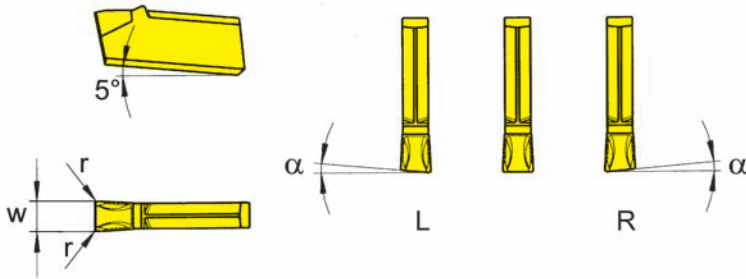
with chip former



Width of groove .079 - .472"

for use with Toolholder

Type 300.2...
H100
HU100
NK100



R = right hand version

L = left hand version

Part number	w	r	α	Size	Carbide grades					
					T122	TA45	ALX3	AS6G	AS62	AS66
S100.0200.EN2	.079	.008	0°	01			▲	▲		
S100.0220.EN2	.087	.008	0°				▲	▲		
S100.0250.EN2	.098	.008	0°	02			▲	▲		
S100.0300.EN2	.118	.008	0°	03			▲	▲		Δ
RS100.0530.EN2	.118	.008	5°						Δ	Δ
S100.0400.EN3	.157	.012	0°	04			▲	▲		
R/LS100.0540.EN2	.157	.008	5°				▲/▲			
S100.0500.EN3	.197	.012	0°	05			▲			
S100.0600.EN6	.236	.031	0°	06				▲		
S100.0800.EN8	.315	.031	0°	08				▲		
S100.1000.EN8	.394	.031	0°	10				▲		
S100.1200.EN8	.472	.031	0°	12				▲		
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet					P		●	●		●
					M			●		○
					K			●		●
					S			●		○
					N			●		●
					H					

Dimensions in mm

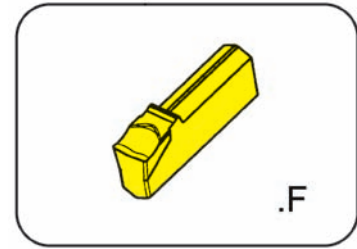
Carbide grades

State R or L version

INSERT Type

S100

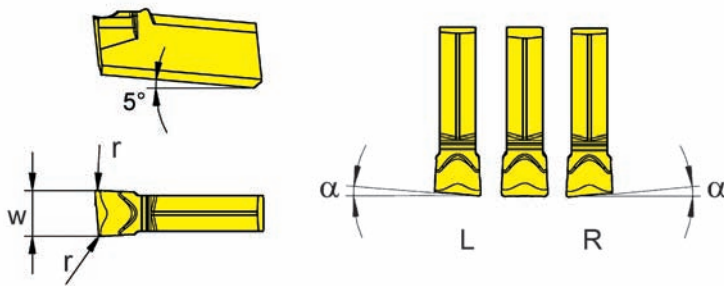
with chip forming



Width of groove	.079 - .197"
-----------------	--------------

for use with Toolholder

Type 300.2...
H100
HU100
NK100



R = right hand version shown

L = left hand version

Part number	w	r	α	Size	Tl22	TF42	TF43	TF45	TF46	TC92	AS6G
S100.0200.F2 R/LS100.0520.F2	.079	.008	0° 5°	01	▲		▲	▲	▲	▲	
S100.0250.F2 R/LS100.0525.F2	.098	.008	0° 5°	02	▲		▲	▲	▲	▲	
S100.0300.F2 R/LS100.0530.F2	.118	.008	0° 5°	03	▲ ▲▲	▲	▲	▲	▲	▲	▲
S100.0400.F3 R/LS100.0540.F2	.157	.012 .008	0° 5°	04	▲		▲	▲	▲		
S100.0500.F3	.197	.012	0°	05	▲		▲	▲	▲		
▲ on stock Δ 4 weeks					P	•	•	•	•	•	•
• main recommendation					M			•	o		
o alternative recommendation					K			•	•		
uncoated grades					S			•	o		
coated grades					N			•	•		
brazed/Cermet					H						

Dimensions in mm

State R or L version

Carbide grades

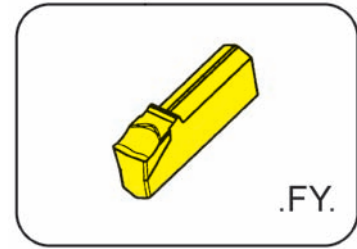
GROOVING and PARTING OFF



INSERT Type

S100

with chip forming

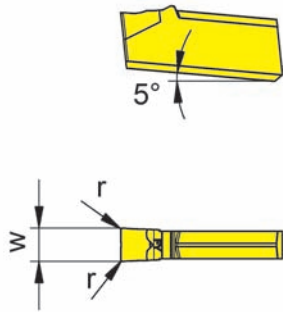


Width of groove .079 - .157" (2.0 - 4.0 mm)

precision sintered

for use with Toolholder

Type 300.2...
H100
HU100
NK100



Part number	w	r	Size	Carbide grades			
				Tl25	TF45	TF46	AS45
S100.0200.FY2	2.0	0.2	01	▲			
S100.0220.FY2	2.2			▲			
S100.0250.FY2	2.5	0.2	02	▲			
S100.0300.FY2	3.0	0.2	03	▲			
S100.0400.FY3	4.0	0.3	04	▲			
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet				P	●	●	●
				M	●	●	●
				K	●	●	●
				S	●	●	●
				N	●	●	●
				H	●	●	●

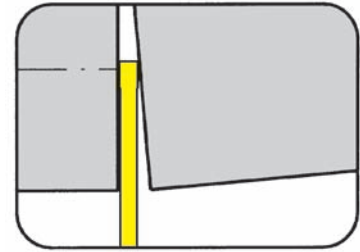
Dimensions in mm

Carbide grades

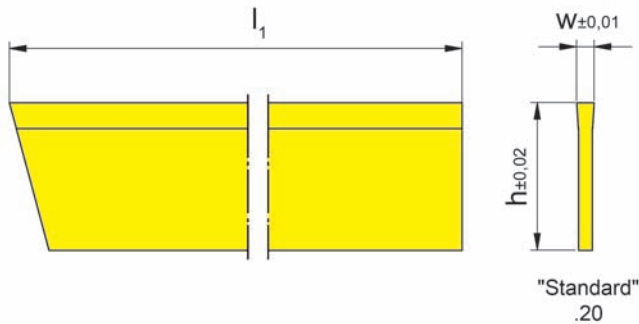
Indexable inserts can be used in **right and left** hand toolholders.

BLADE Type

HCC...20



Width of groove	.020 - .197" (0.5 - 5.0 mm)
Length of blade	2.756 - 6.496" (70 - 165 mm)



for use with all attachments

Part number	w	h	l ₁	MG12	TN35	TH35
HCC.0050.05.01.20	0.5	5.00	70	▲	▲	▲
HCC.0100.12.05.20	1.0	12.09	90	▲	▲	▲
HCC.0100.17.12.20	1.0	17.17	125	▲	▲	▲
HCC.0130.17.12.20	1.3	17.17	125	▲	▲	▲
HCC.0150.17.12.20	1.5	17.17	125	▲	▲	▲
HCC.0160.12.10.20	1.6	12.09	115	▲	▲	▲
HCC.0160.17.12.20	1.6	17.17	125	▲	▲	▲
HCC.0200.12.10.20	2.0	12.09	115	▲	▲	▲
HCC.0200.17.12.20	2.0	17.17	125	▲	▲	▲
HCC.0250.12.10.20	2.5	12.09	115	▲	▲	▲
HCC.0250.17.12.20	2.5	17.17	125	▲	▲	▲
HCC.0300.12.10.20	3.0	12.09	115	▲	▲	▲
HCC.0300.17.12.20	3.0	17.17	125	▲	▲	▲
HCC.0320.22.17.20	3.2	22.00	150	▲	▲	▲
HCC.0320.28.20.20	3.2	28.00	165	▲	▲	▲
HCC.0400.17.12.20	4.0	17.17	125	▲	▲	▲
HCC.0400.22.17.20	4.0	22.00	150	▲	▲	▲
HCC.0400.28.20.20	4.0	28.00	165	▲	▲	▲
HCC.0480.22.17.20	4.8	22.00	150	▲	▲	▲
HCC.0500.17.12.20	5.0	17.17	125	▲	▲	▲
HCC.0500.28.20.20	5.0	28.00	165	▲	▲	▲

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

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

Carbide grades

All blades are manufactured in a neutral version

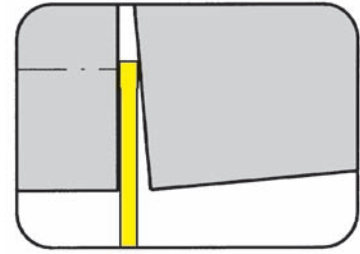
Further sizes upon request

GROOVING and PARTING OFF

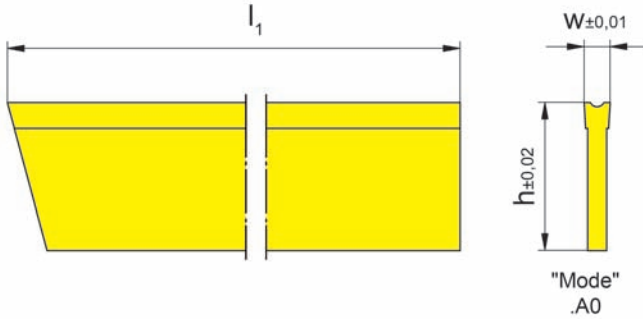


BLADE Type

HCC...A0



Width of groove	.059 - .197" (1.5 - 5.0 mm)
Length of blade	4.528 - 4.921" (115 - 125 mm)



for use with all attachments

Part number	w	h	l ₁	MG12	TN35	TH35
HCC.0150.17.12.A0	1.5	17.17	125	▲	▲	▲
HCC.0160.12.10.A0	1.6	12.09	115	▲	▲	▲
HCC.0160.17.12.A0	1.6	17.17	125	▲	▲	▲
HCC.0200.12.10.A0	2.0	12.09	115	▲	▲	▲
HCC.0200.17.12.A0	2.0	17.17	125	▲	▲	▲
HCC.0250.12.10.A0	2.5	12.09	115	▲	▲	▲
HCC.0250.17.12.A0	2.5	17.17	125	▲	▲	▲
HCC.0300.12.10.A0	3.0	12.09	115	▲	▲	▲
HCC.0300.17.12.A0	3.0	17.17	125	▲	▲	▲
HCC.0400.17.12.A0	4.0	17.17	125	▲	▲	▲
HCC.0500.17.12.A0	5.0	17.17	125	▲	▲	▲

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

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

Carbide grades

All blades are manufactured in a neutral version

Further sizes upon request