

HCG - HORN Catalog Guide

INTERNAL GROOVING

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

EXTERNAL GROOVING

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

Special tools upon request

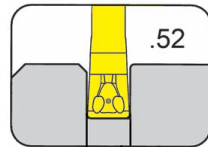
TOOLING SYSTEMS S316 **K**

Grooving
- external -

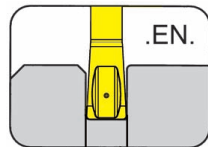


Page K2

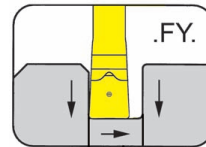
Indexable inserts
Type
S316



Page K3



Page K4



Page K5

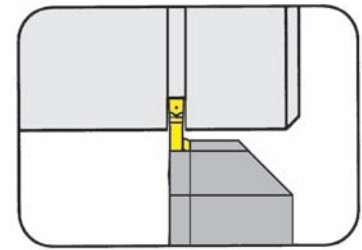
For Technical Information please see chapter Q

GROOVING (external)



TOOLHOLDER Type

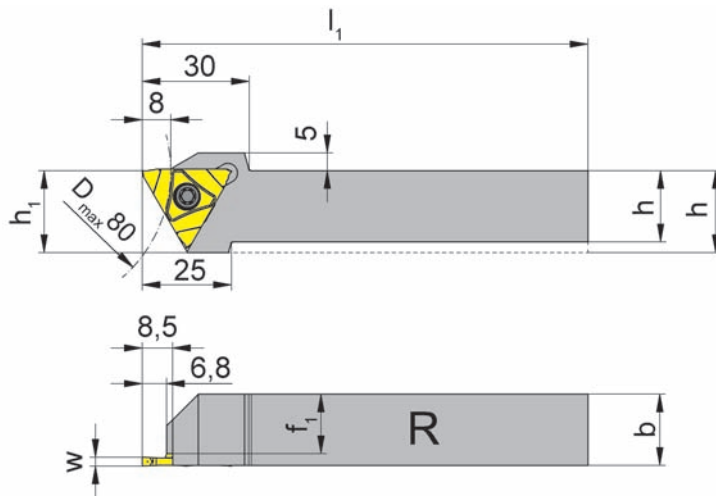
H316



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

K

Spare parts

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

K2

GROOVING (external)

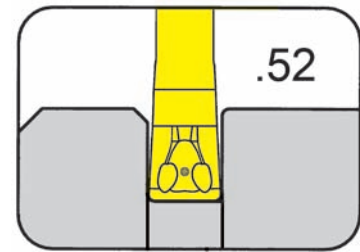


INDEXABLE INSERT Type

S316

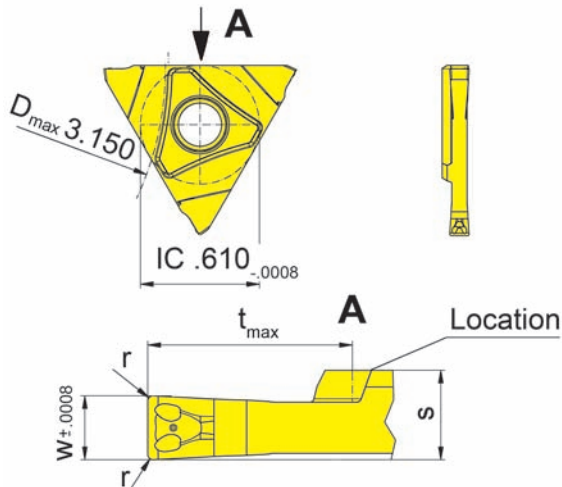
Depth of groove up to	.315"
Width of groove	.079 - .118"

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	Carbide grades				
						TN35	TI25	TF45	TF46	AS45
R/LS316.0200.52	.079									▲/▲
R/LS316.0250.52	.098	.008	.138	.315	03					▲/▲
R/LS316.0300.52	.118									▲/▲
<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

External machining:

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

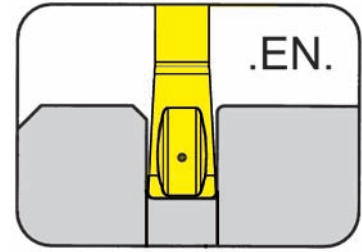


GROOVING (external)



INDEXABLE INSERT Type

S316

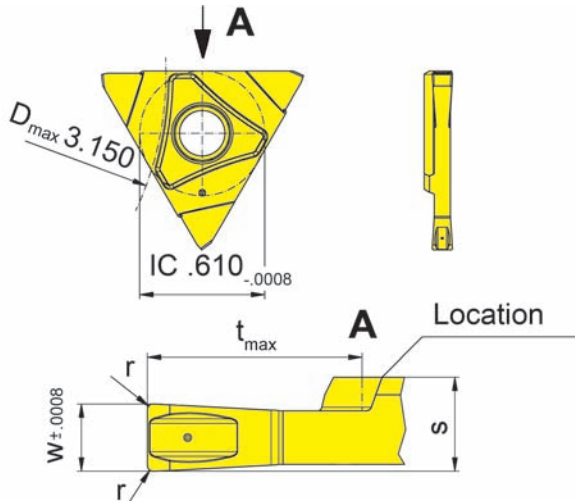


Depth of groove up to .315"
Width of groove .079 - .118"

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	Carbide grades				
						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

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

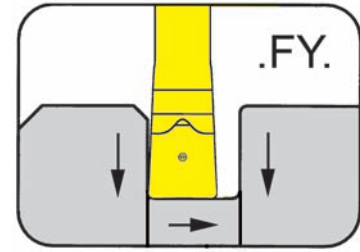


INDEXABLE INSERT Type

S316

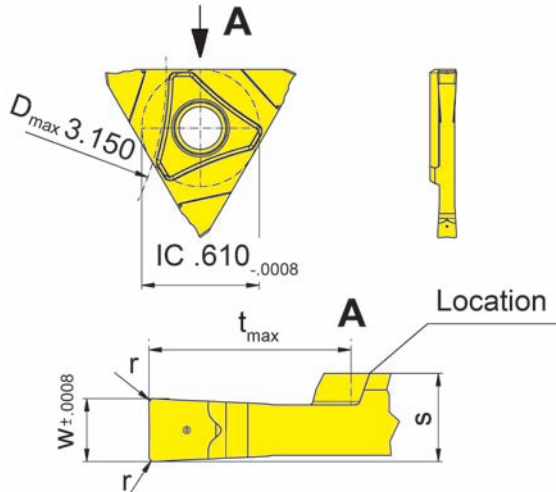
Depth of groove up to .315"
 Width of groove .059 - .118"

precision sintered



for use with Toolholder

Type H316



R = right hand version shown

L = left hand version

Indexability length
± .001"

Part number	w	r	s	t _{max}	Size	Carbide grades			
						TN35	TI25	TF45	TF46
R/LS316.0150.FY1	.059	.004	.130	.315	03		▲/▲		
R/LS316.0200.FY2	.079	.008	.138			▲/▲			
R/LS316.0250.FY2	.098	.008	.138			▲/▲			
R/LS316.0300.FY2	.118	.008	.138			▲/▲			
						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

External machining:

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

