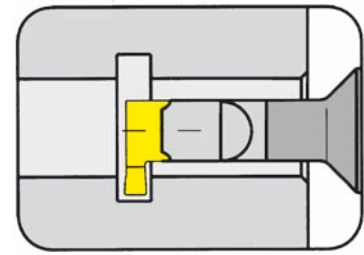


TOOLHOLDER Type

BU18P

with through coolant supply

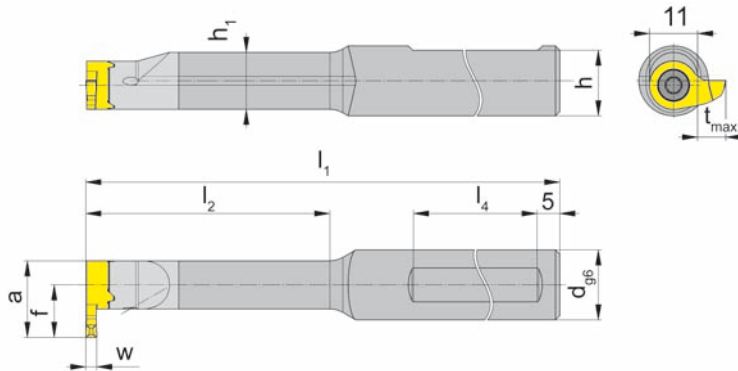


Bore Ø from	.709"
Depth of groove up to	.315"
Width of groove up to	.118"

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 18P
S18P



R = right hand version shown

L = left hand version

Part number	d	l ₁	l ₂	h	h ₁	l ₄
R/LBU18P.0500.00	.500	3.937	.984	.461	.500	1.969
R/LBU18P.0500.01		4.724	1.575			
R/LBU18P.0625.00	.625	3.937	.984	.585	.512	1.969
R/LBU18P.0625.01		4.724	1.575			
R/LBU18P.0625.02		5.118	2.205			
R/LBU18P.0625.03		5.906	3.150			

State R or L version

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

Dimensions in inch

Further sizes upon request

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

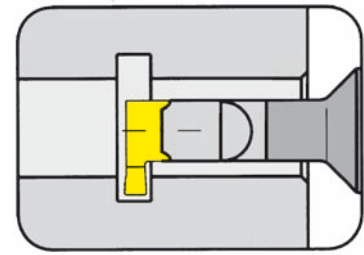
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LBU18P.0...	5.13T20EP	T20PQ

TOOLHOLDER Type

B18P

with through coolant supply

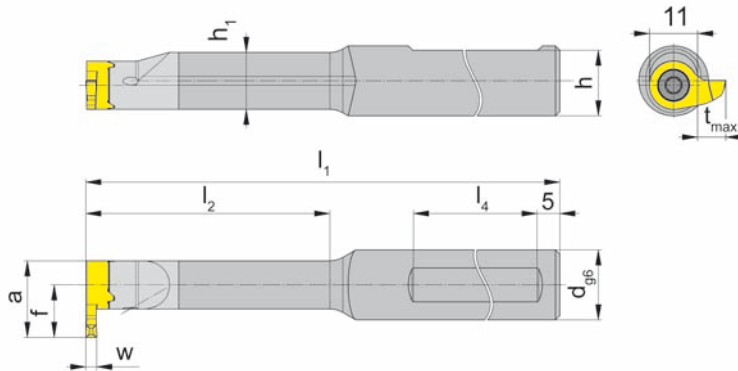


Bore Ø from	.709" (18.0 mm)
Depth of groove up to	.315" (8.0 mm)
Width of groove up to	.118" (3.0 mm)

Material of shank: Carbide - Giving a good vibration resistance

for use with Insert

Type 18P
S18P



R = right hand version shown

L = left hand version

Part number	d	l ₁	l ₂	h	h ₁	l ₄
R/LB18P.0012.00 R/LB18P.0012.01	12	100 120	25 40	11	12.5	50
R/LB18P.0016.00 R/LB18P.0016.01 R/LB18P.0016.02 R/LB18P.0016.03	16	100 120 130 150	25 40 56 80	15	13.0	50

State R or L version

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

Dimensions in mm

Further sizes upon request

Ordering note:

Toolholders with damaged seating can be repaired by HORN.

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
R/LB18P.001...	5.13T20EP	T20PQ

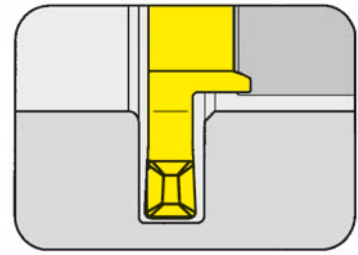


GROOVING (internal) $\geq \text{Ø} .709''$



INSERT Type

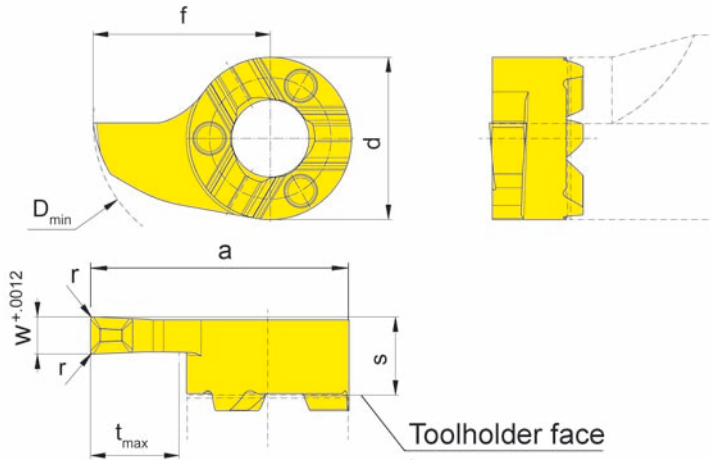
S18P



Bore Ø from	.709"
Depth of groove up to	.236"
Width of groove	.079 - .118"

for use with Toolholder

Type B18P
BU18P



R = right hand version shown

L = left hand version

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades			
									MG12	TN35	TI25	TH35
R/LS18P.0200.1.D2	.079											▲▲
R/LS18P.0250.1.D2	.098	.008	.209	.472	.689	.433	.236	.709				▲▲
R/LS18P.0300.1.D2	.118											▲▲
									P			•
									M			•
									K			•
									S			•
									N			•
									H			•

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

Dimensions in inch

State R or L version

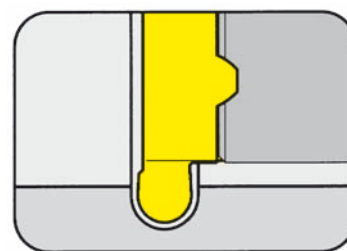
Carbide grades

GROOVING (internal) $\geq \text{Ø} .709''$



INSERT Type

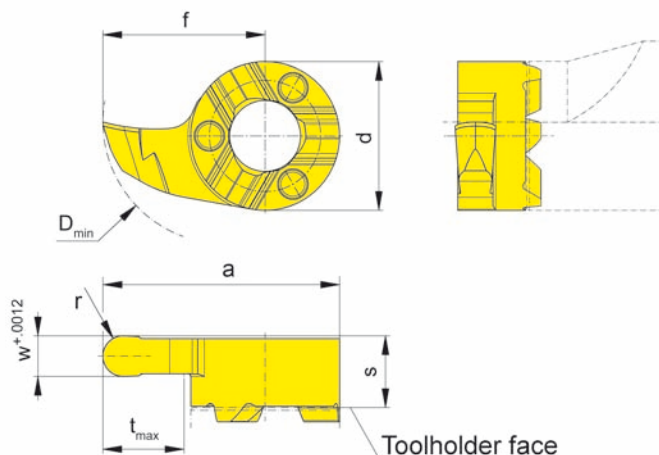
18P



Bore Ø from	.709"
Depth of groove up to	.236"
Width of groove	.071 - .118"

for use with Toolholder

Type B18P
BU18P



R = right hand version shown

L = left hand version

Full radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades			
									MG12	TN35	TI25	TH35
R/L18P.0009.1.18	.071	.035										▲▲
R/L18P.0011.1.22	.087	.043	.209	.472	.689	.433	.236	.709				▲▲
R/L18P.0015.1.30	.118	.059										▲▲
									P			•
									M			•
									K			•
									S			•
									N			•
									H			•

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

Dimensions in inch

State R or L version

Carbide grades

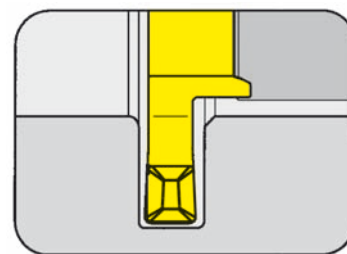


GROOVING (internal) $\geq \text{Ø} .787''$



INSERT Type

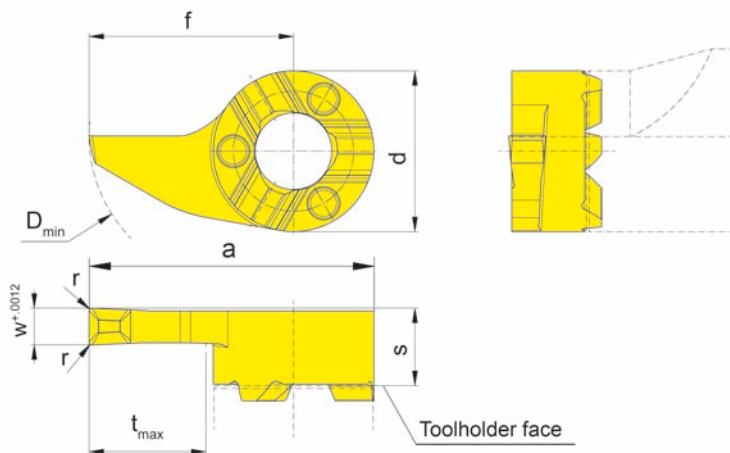
S18P



Bore Ø from	.787"
Depth of groove up to	.315"
Width of groove	.079 - .118"

for use with Toolholder

Type B18P
BU18P



R = right hand version shown

L = left hand version

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TH35	
R/LS18P.0200.2.D2	.079											▲▲	▲▲
R/LS18P.0250.2.D2	.098	.008	.209	.551	.768	.433	.315	.787				▲▲	▲▲
R/LS18P.0300.2.D2	.118											▲▲	▲▲
										P			•
										M			•
										K			•
										S			•
										N			•
										H			•

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

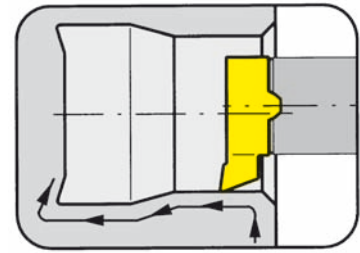
Dimensions in inch

State R or L version

Carbide grades

INSERT Type

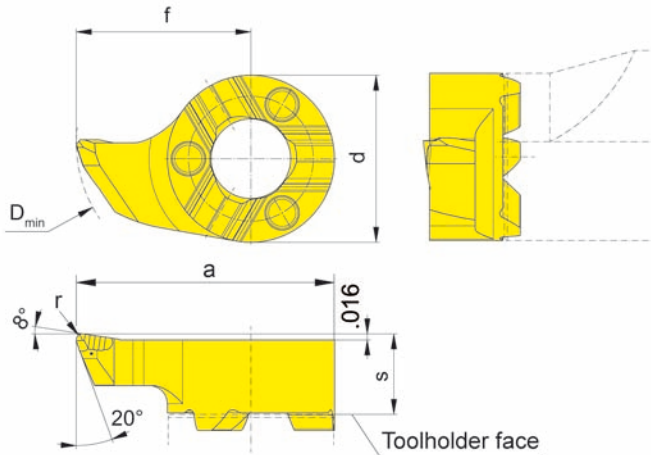
S18P



Bore Ø from .689"
 Depth of undercut up to .217"

for use with Toolholder

Type B18P
 BU18P



R = right hand version shown

L = left hand version

Part number	r	s	f	a	d	D _{min}	Carbide grades			
							MG12	TN35	Ti25	TH35
LS18P.1815.R2	.008									▲
RS18P.1815.R2	.008					.689				▲
LS18P.1815.R4	.016	.209	.453	.669	.433					▲
RS18P.1815.R4	.016									▲
							P			•
							M			•
							K			•
							S			•
							N			•
							H			•

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

Dimensions in inch

State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .689''$ and profiling of reliefs as per DIN 509 form E and .

