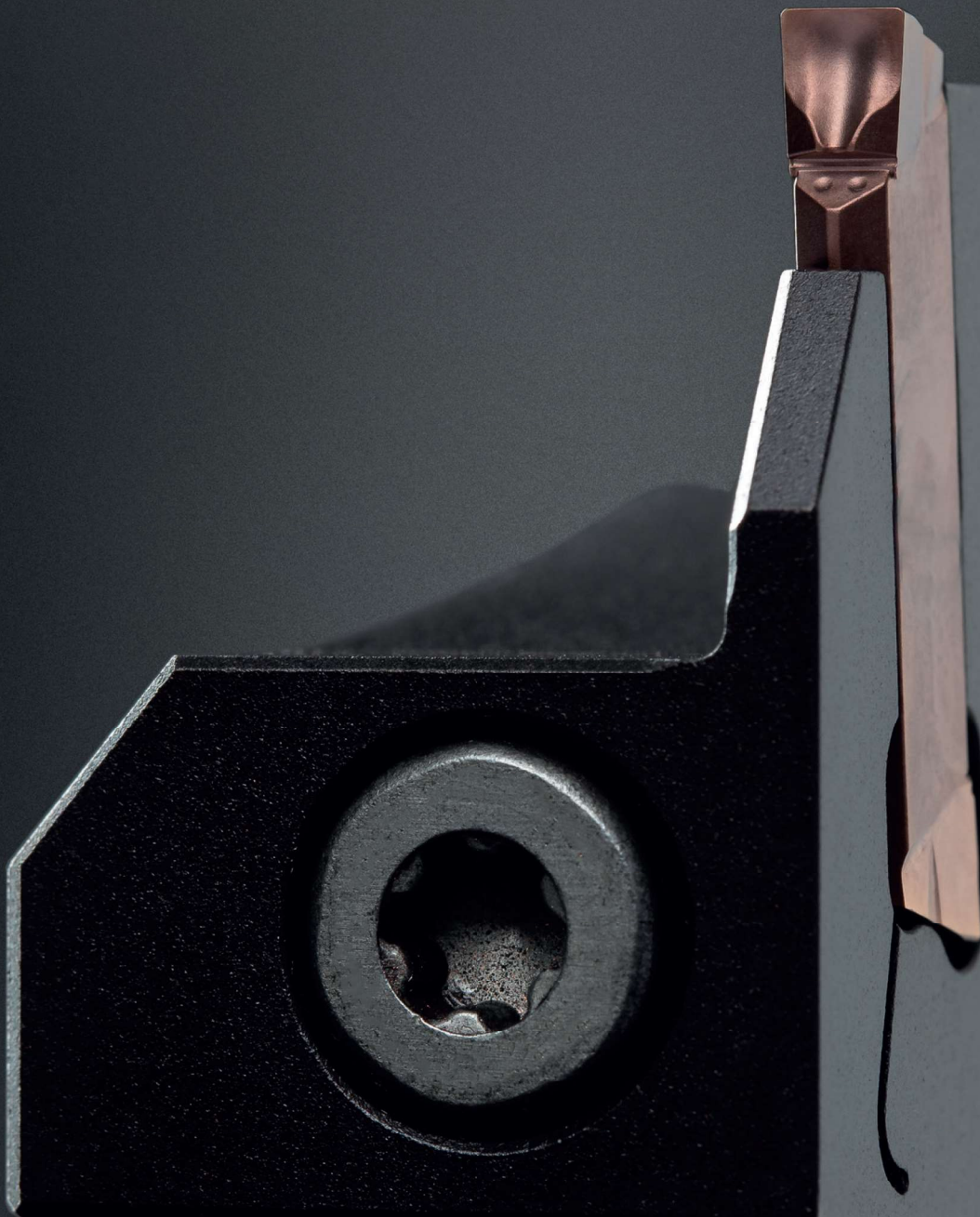


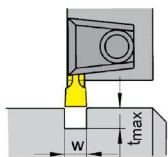


**STECHDREHEN**  
GROOVING

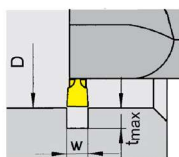
**2020/2021**



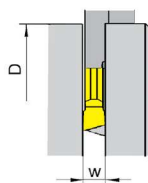
**DAS WERKZEUG  
HORN TOOLS**



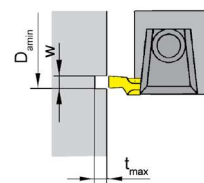
$w = 0,5 - 6,3 \text{ mm}$   
 $t_{\max} = 8,0 \text{ mm}$



$w = 0,5 - 6,3 \text{ mm}$   
 $t_{\max} = 5,5 \text{ mm}$   
 $D \geq 46 \text{ mm}$

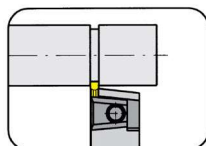


$w = 0,5 - 6,3 \text{ mm}$   
 $D = 12 \text{ mm}$   
 $t_{\max} = 8 \text{ mm}$

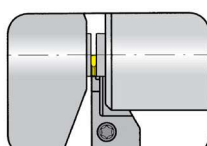


$w = 1,5 - 3 \text{ mm}$   
 $t_{\max} = 3 \text{ mm}$   
 $D_{\min} = 20 \text{ mm}$

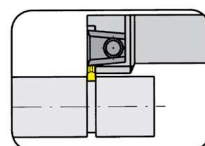
**Klemmhalter**  
Toolholder  
360/361/368/369/64/65/99  
N/390/391/309/340/330



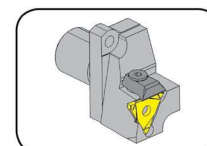
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O4-O8, O16-O17



Seite / Page  
O9-O10



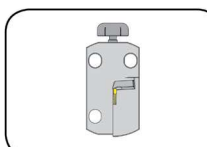
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O11



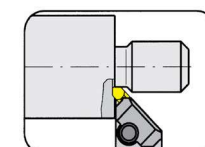
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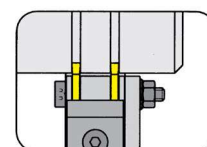
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O13-O14



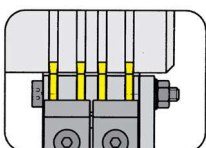
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O15



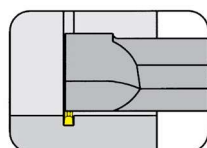
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O18



Seite / Page  
O19

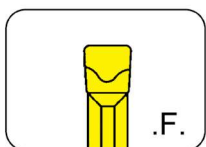


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O20

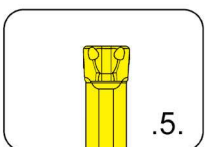


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O21

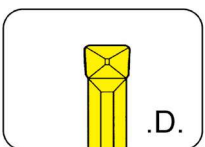
**Wendeschneidplatte**  
Indexable insert  
S312



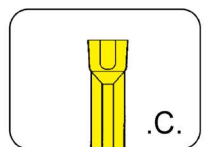
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O22



Seite / Page  
O23

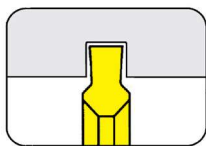


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O24

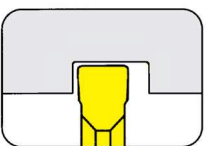


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O25

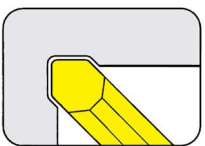
**Wendeschneidplatte**  
Indexable insert  
312



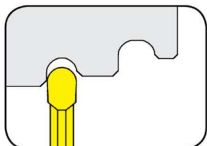
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O26



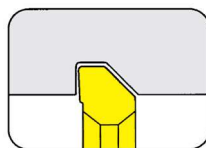
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O27-O32



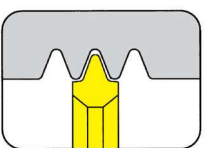
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O33-O34



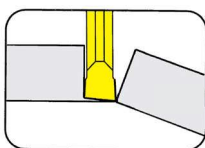
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O35



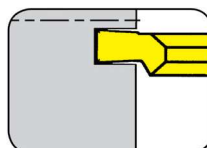
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O36-O37



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O38



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O39-O42



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O43

**312**



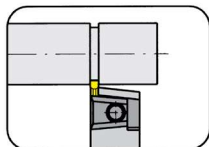
**Klemmhalter mit  
Schneidplatten**

Stechbreite 0,5 - 6,3 mm

**Toolholder with  
Inserts**

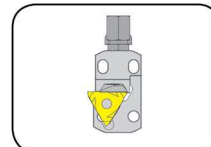
Width of groove 0,5 - 6,3 mm

**Klemmhalter**  
Toolholder  
360/368/369/390/  
391/340/361/309



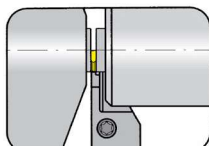
Seite/Page  
O4-O8, O16-O17

**Einbauhalter Graf**  
Cartridge Graf  
64/65/99

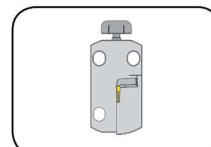


Seite/Page  
O13-O14

**Einstellbare Halter**  
Adjustable holder  
N

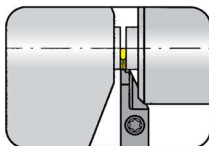


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O9

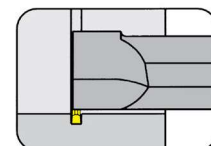


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O15

**Grundhalter**  
Basic toolholder  
330

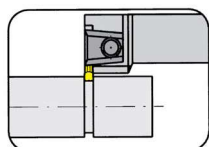


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O10

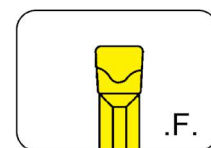


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O21

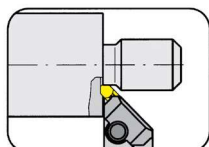
**Wendeschneidplatte**  
Indexable insert  
S312/312



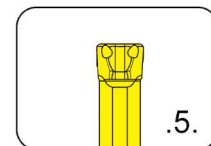
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O11



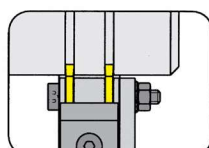
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O22



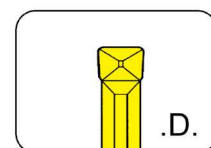
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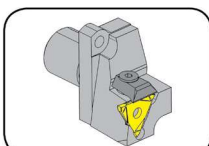
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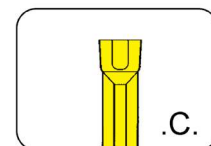
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O19-O20



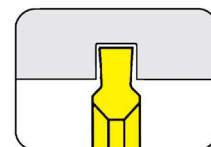
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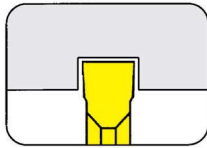
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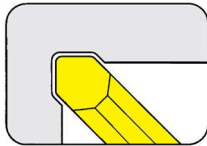
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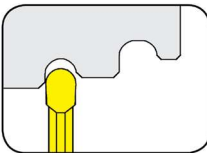
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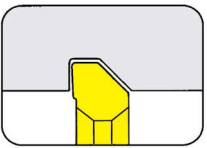
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O27-O32



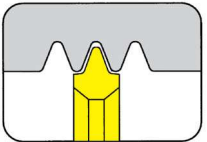
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O33-O34



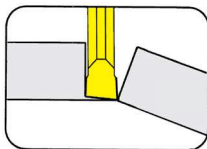
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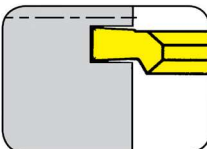
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O36-O37



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O38



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O39-O42



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O43



# Einstecken und Abstechen

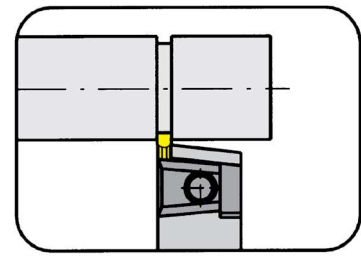
Grooving and Parting Off



## Klemmhalter

Toolholder

# 360



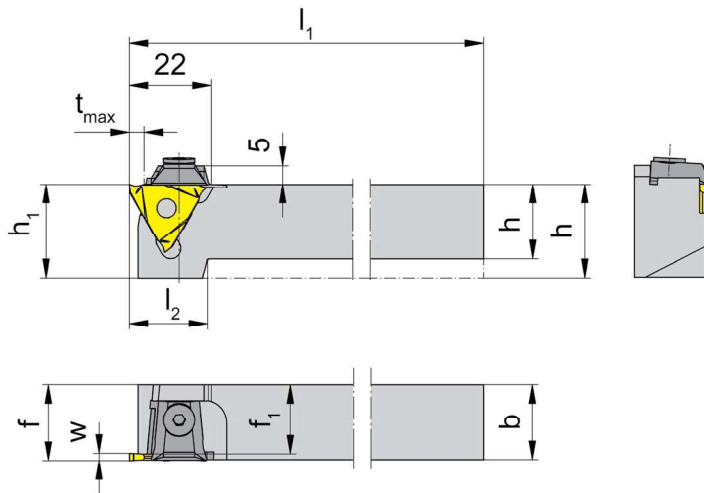
Stechtiefe bis  
Spannbereich

Depth of groove up to  
Clamping range

6 mm  
0,5-2,9 mm

für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f                                | f <sub>1</sub> | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------------------------|----------------|------------------|---------------|--------------------------------|
| R/L360.1212.01               | 12 | 12 | 100            | 24             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 10,5           | 4                | 01            | 0,5-1,9                        |
| R/L360.1616.01               | 16 | 16 | 125            | 22             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 14,5           | 4                | 01            | 0,5-1,9                        |
| R/L360.2020.01               | 20 | 20 | 125            | 21             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 18,5           | 4                | 01            | 0,5-1,9                        |
| R/L360.2525.01               | 25 | 25 | 150            | -              | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 23,5           | 4                | 01            | 0,5-1,9                        |
| R/L360.3232.01               | 32 | 32 | 170            | -              | 32             | f <sub>1</sub> +w-a <sub>1</sub> | 30,5           | 4                | 01            | 0,5-1,9                        |
| R/L360.1212.02               | 12 | 12 | 100            | 24             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 9,5            | 6                | 02            | 1,9-2,9                        |
| R/L360.1616.02               | 16 | 16 | 125            | 22             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 13,5           | 6                | 02            | 1,9-2,9                        |
| R/L360.2020.02               | 20 | 20 | 125            | 21             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 17,5           | 6                | 02            | 1,9-2,9                        |
| R/L360.2525.02               | 25 | 25 | 150            | -              | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 22,5           | 6                | 02            | 1,9-2,9                        |
| R/L360.3232.02               | 32 | 32 | 170            | -              | 32             | f <sub>1</sub> +w-a <sub>1</sub> | 29,5           | 6                | 02            | 1,9-2,9                        |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 40 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| R/L360.1...               | SW3,0 DIN911                    | 11.3                             |
| R/L360...                 | SW3,0 DIN911                    | 16.4                             |

# Einsteichen und Abstechen

Grooving and Parting Off

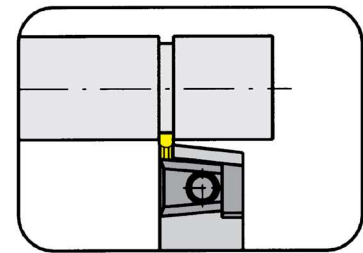


## Klemmhalter

Toolholder

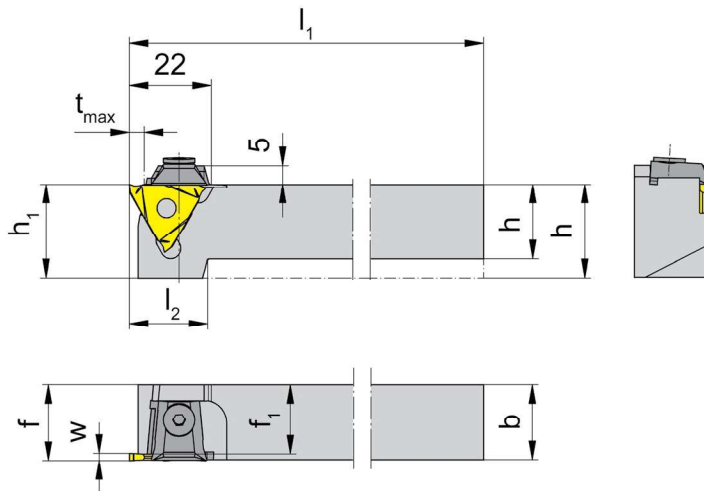
# 360

|                                |                                         |                    |
|--------------------------------|-----------------------------------------|--------------------|
| Stechtiefe bis<br>Spannbereich | Depth of groove up to<br>Clamping range | 6 mm<br>2,9-6,3 mm |
|--------------------------------|-----------------------------------------|--------------------|



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f                                | f <sub>1</sub> | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------------------------|----------------|------------------|---------------|--------------------------------|
| R/L360.1212.03               | 12 | 12 | 100            | 24             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 8,5            | 6                | 03            | 2,9-3,9                        |
| R/L360.1616.03               | 16 | 16 | 125            | 22             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 12,5           | 6                | 03            | 2,9-3,9                        |
| R/L360.2020.03               | 20 | 20 | 125            | 21             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 16,5           | 6                | 03            | 2,9-3,9                        |
| R/L360.2525.03               | 25 | 25 | 150            | -              | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 21,5           | 6                | 03            | 2,9-3,9                        |
| R/L360.3232.03               | 32 | 32 | 170            | -              | 32             | f <sub>1</sub> +w-a <sub>1</sub> | 28,5           | 6                | 03            | 2,9-3,9                        |
| R/L360.1616.04               | 16 | 16 | 125            | 22             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 10,8           | 6                | 04            | 3,9-6,3                        |
| R/L360.2020.04               | 20 | 20 | 125            | 21             | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 14,8           | 6                | 04            | 3,9-6,3                        |
| R/L360.2525.04               | 25 | 25 | 150            | -              | 25             | f <sub>1</sub> +w-a <sub>1</sub> | 19,8           | 6                | 04            | 3,9-6,3                        |
| R/L360.3232.04               | 32 | 32 | 170            | -              | 32             | f <sub>1</sub> +w-a <sub>1</sub> | 26,8           | 6                | 04            | 3,9-6,3                        |

Ausführung R oder L angeben  
State R or L version

w, a, siehe WSP  
w, a, see indexable inserts

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 40 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| R/L360.1212.03/..1616.03  | SW3,0 DIN911                    | 11.3                             |
| R/L360.1616.04            | SW3,0 DIN911                    | 13.4                             |
| R/L360...                 | SW3,0 DIN911                    | 16.4                             |



# Einstecken und Abstechen

Grooving and Parting Off

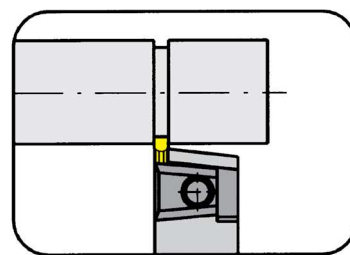


O

## Klemmhalter

Toolholder

# 360



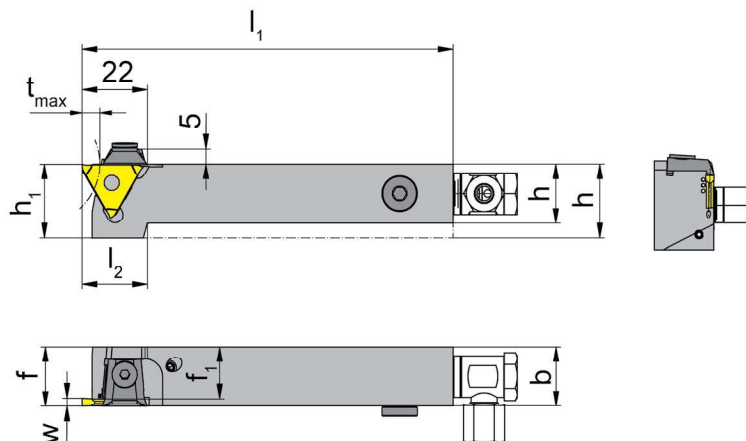
Stechtiefe bis  
Spannbereich

Depth of groove up to  
Clamping range

6 mm  
0,5-2,9 mm

für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

mit innerer  
Kühlmittelzufuhr  
with through coolant supply

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                                | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------|----------------------------------|------------------|---------------|--------------------------------|
| R/L360.1212.01.IK            | 12 | 12 | 100            | 24             | 25             | 10,5           | f <sub>1</sub> +w-a <sub>1</sub> | 4                | 01            | 0,5-1,9                        |
| R/L360.1616.01.IK            | 16 | 16 | 125            | 22             | 25             | 14,5           | f <sub>1</sub> +w-a <sub>1</sub> | 4                | 01            | 0,5-1,9                        |
| R/L360.2020.01.IK            | 20 | 20 | 125            | 21             | 25             | 18,5           | f <sub>1</sub> +w-a <sub>1</sub> | 4                | 01            | 0,5-1,9                        |
| R/L360.2525.01.IK            | 25 | 25 | 150            | -              | 25             | 23,5           | f <sub>1</sub> +w-a <sub>1</sub> | 4                | 01            | 0,5-1,9                        |
| R/L360.1212.02.IK            | 12 | 12 | 100            | 24             | 25             | 9,5            | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 02            | 1,9-2,9                        |
| R/L360.1616.02.IK            | 16 | 16 | 125            | 22             | 25             | 13,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 02            | 1,9-2,9                        |
| R/L360.2020.02.IK            | 20 | 20 | 125            | 21             | 25             | 17,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 02            | 1,9-2,9                        |
| R/L360.2525.02.IK            | 25 | 25 | 150            | -              | 25             | 22,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 02            | 1,9-2,9                        |

Ausführung R oder L angeben  
State R or L version

w, a, siehe WSP  
w, a, see indexable inserts

Abmessungen in mm  
Dimensions in mm

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 40 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Wrench | Kühlmittelanschluss<br>Coolant supply | Spannelement<br>Clamping element | Dichtstopfen<br>Sealing plug | Gewindestift<br>Threaded Pin |
|---------------------------|---------------------------|---------------------------------------|----------------------------------|------------------------------|------------------------------|
| R/L360.1212.01.IK         | SW3,0 DIN911              | 004.00.61                             | 11.3                             |                              | 3.03.913                     |
| R/L360.1616.01.IK         | SW3,0 DIN911              | 004.00.16                             | 11.3                             | 004.00.26                    | 18.05.913                    |
| R/L360....                | SW3,0 DIN911              | 004.00.16                             | 16.4                             | 004.00.26                    | 18.05.913                    |

# Einstecken und Abstechen

Grooving and Parting Off

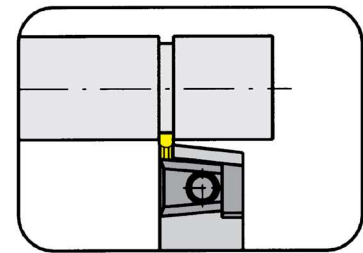


## Klemmhalter

Toolholder

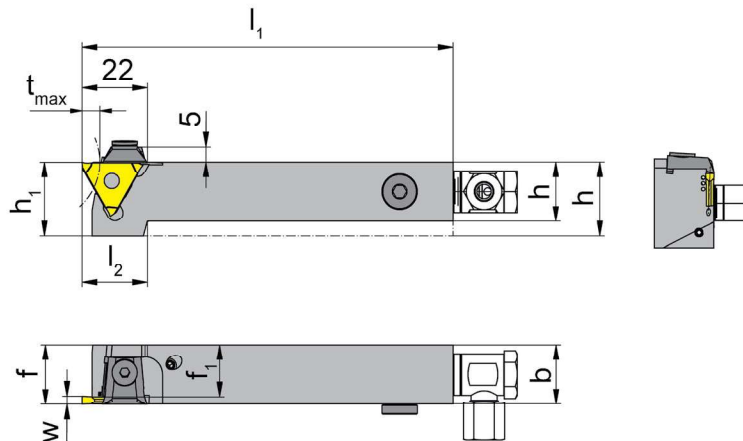
# 360

|                                |                                         |                    |
|--------------------------------|-----------------------------------------|--------------------|
| Stechtiefe bis<br>Spannbereich | Depth of groove up to<br>Clamping range | 6 mm<br>2,9-3,9 mm |
|--------------------------------|-----------------------------------------|--------------------|



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

mit innerer  
Kühlmittelzufuhr  
with through coolant supply

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                                | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------|----------------------------------|------------------|---------------|--------------------------------|
| R/L360.1212.03.IK            | 12 | 12 | 100            | 24             | 25             | 8,5            | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 03            | 2,9-3,9                        |
| R/L360.1616.03.IK            | 16 | 16 | 125            | 22             | 25             | 12,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 03            | 2,9-3,9                        |
| R/L360.2020.03.IK            | 20 | 20 | 125            | 21             | 25             | 16,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 03            | 2,9-3,9                        |
| R/L360.2525.03.IK            | 25 | 25 | 150            | -              | 25             | 21,5           | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 03            | 2,9-3,9                        |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 40 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Wrench | Kühlmittelanschluss<br>Coolant supply | Spannelement<br>Clamping element | Dichtstopfen<br>Sealing plug | Gewindestift<br>Threaded Pin |
|---------------------------|---------------------------|---------------------------------------|----------------------------------|------------------------------|------------------------------|
| R/L360.1212.03.IK         | SW3,0 DIN911              | 004.00.61                             | 11.3                             |                              | 3.03.913                     |
| R/L360.1616.03.IK         | SW3,0 DIN911              | 004.00.16                             | 11.3                             | 004.00.26                    | 18.05.913                    |
| R/L360....                | SW3,0 DIN911              | 004.00.16                             | 16.4                             | 004.00.26                    | 18.05.913                    |

# Einstecken (außen)

Grooving (external)

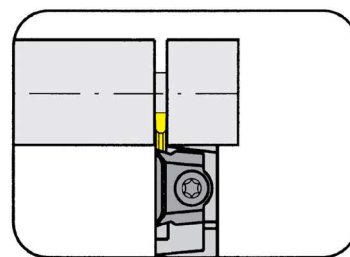


O

## Klemmhalter

Toolholder

361



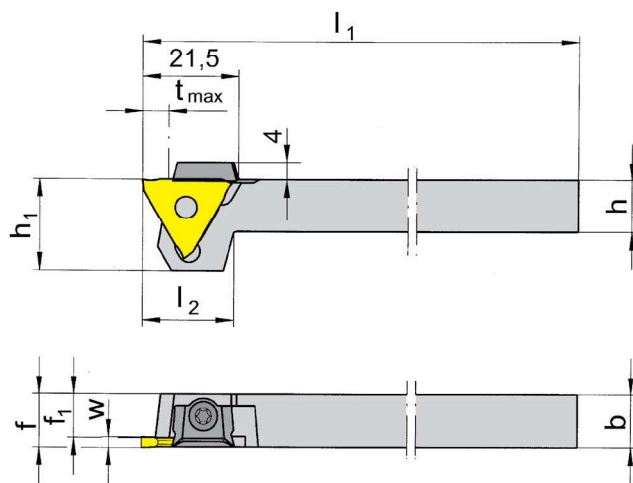
Stechtiefe bis  
Spannbereich

Depth of groove up to  
Clamping range

6 mm  
0,5-3,9 mm

für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                                | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------|----------------------------------|------------------|---------------|--------------------------------|
| <b>R/L361.1212.01</b>        | 12 | 12 | 100            | 17             | 19             | 10,5           | f <sub>1</sub> +w-a <sub>1</sub> | 4                | 01            | 0,5-1,9                        |
| <b>R/L361.1212.02</b>        | 12 | 12 | 100            | 17             | 19             | 9,5            | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 02            | 1,9-2,9                        |
| <b>R/L361.1212.03</b>        | 12 | 12 | 100            | 21             | 21             | 8,5            | f <sub>1</sub> +w-a <sub>1</sub> | 6                | 03            | 2,9-3,9                        |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.

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

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Spannelement<br>Clamping element | Spannschraube<br>Clamping Screw | TORX PLUS®-Schlüssel<br>TORX PLUS® Wrench |
|---------------------------|----------------------------------|---------------------------------|-------------------------------------------|
| R/L361...                 | 12.3                             | 030.0422.T10P                   | T10PL                                     |

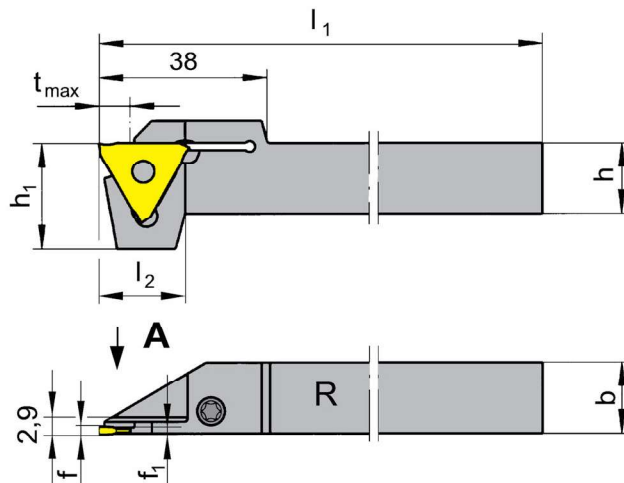
### Klemmhalter

Toolholder

# 368

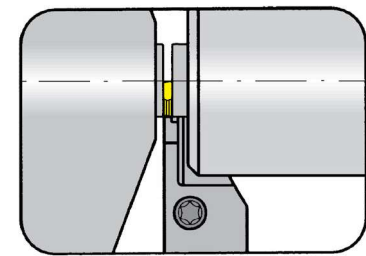
|                               |                                          |                    |
|-------------------------------|------------------------------------------|--------------------|
| Stechtiefe bis<br>Stechbreite | Depth of groove up to<br>Width of groove | 8 mm<br>0,5-1,5 mm |
|-------------------------------|------------------------------------------|--------------------|

für TRAUB-Maschinen (TNL12/7)  
for machines TRAUB (TNL12/7)



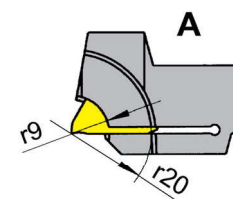
R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version



für Wendeschneidplatte  
for Indexable insert

Typ 312 w < 1,5 mm  
Type



nur für umfangs-  
geschliffene Form-WSP  
only for periferal grounded  
profiled inserts

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                              | t <sub>max</sub> |
|------------------------------|----|----|----------------|----------------|----------------|----------------|--------------------------------|------------------|
| R/L368.1212.08               | 12 | 12 | 95             | 19,5           | 24             | 1,0            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1616.08               | 16 | 16 | 95             | 19,5           | 24             | 1,0            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1212.11               | 12 | 12 | 95             | 19,5           | 24             | 1,3            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1616.11               | 16 | 16 | 95             | 19,5           | 24             | 1,3            | f <sub>1</sub> +a <sub>1</sub> | 8                |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

**Halter R/L368...08 für WSP:**

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

**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...

**Halter R/L368...11 für WSP:**

R/L312.0515... / R/L312.0015...V1

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

R/L312.0515... / R/L312.0015...V1

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

### Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Spannschraube<br>Clamping Screw | TORX PLUS®-Schlüssel<br>TORX PLUS® Wrench |
|---------------------------|---------------------------------|-------------------------------------------|
| R/L368...                 | 4.15T15P                        | T15PQ                                     |

# Abstechen

## Parting Off



### Klemmhalter

#### Toolholder

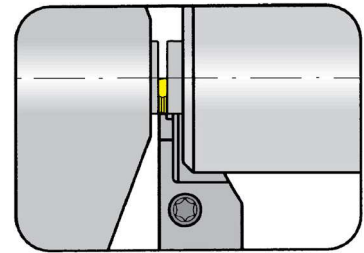
# 368

mit innerer Kühlmittelzufuhr  
with through coolant supply

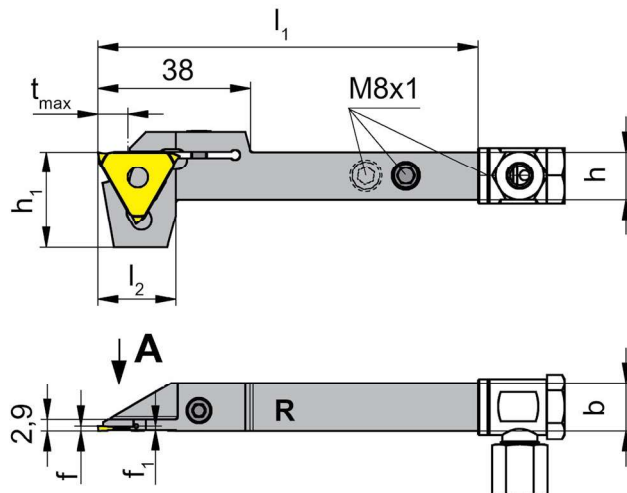
Stechtiefe bis  
Stechbreite

Depth of groove up to  
Width of groove

8 mm  
0,5-1,5 mm



für TRAUB-Maschinen (TNL12/7)  
for machines TRAUB (TNL12/7)

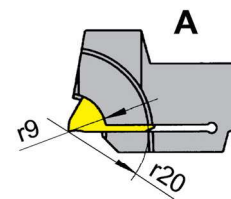


R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

für Wendeschneidplatte  
for Indexable insert

Typ 312 w ≤ 1,5 mm  
Type



nur für umfanga-  
geschliffene Form-WSP  
only for periferal grounded  
profiled inserts

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                              | t <sub>max</sub> |
|------------------------------|----|----|----------------|----------------|----------------|----------------|--------------------------------|------------------|
| R/L368.1212.08.IK            | 12 | 12 | 95             | 19,5           | 24             | 1,0            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1616.08.IK            | 16 | 16 | 95             | 19,5           | 24             | 1,0            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1212.11.IK            | 12 | 12 | 95             | 19,5           | 24             | 1,3            | f <sub>1</sub> +a <sub>1</sub> | 8                |
| R/L368.1616.11.IK            | 16 | 16 | 95             | 19,5           | 24             | 1,3            | f <sub>1</sub> +a <sub>1</sub> | 8                |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

#### Halter R/L368...08.IK für WSP:

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

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

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

#### Halter R/L368...11.IK für WSP:

R/L312.0515... / R/L312.0015...V1

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

R/L312.0515... / R/L312.0015...V1

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

### Ersatzteile

#### Spare Parts

| Klemmhalter<br>Toolholder | Spannschraube<br>Clamping Screw | Gewindestift<br>Threaded Pin | Kühlmittelanschluss<br>Coolant supply | TORX PLUS®-Schlüssel<br>TORX PLUS® Wrench |
|---------------------------|---------------------------------|------------------------------|---------------------------------------|-------------------------------------------|
| R/L368.1212...IK          | 4.15T15P                        | 3.03.913                     | 004.00.61                             | T15PQ                                     |
| R/L368.1616...IK          | 4.15T15P                        | 3.03.913                     | 004.00.16                             | T15PQ                                     |

# Einstecken (außen)

Grooving (external)

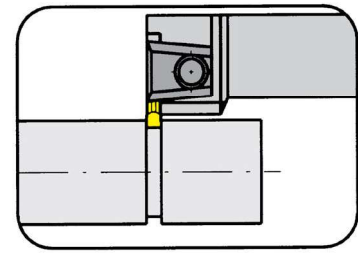


## Klemmhalter

Toolholder

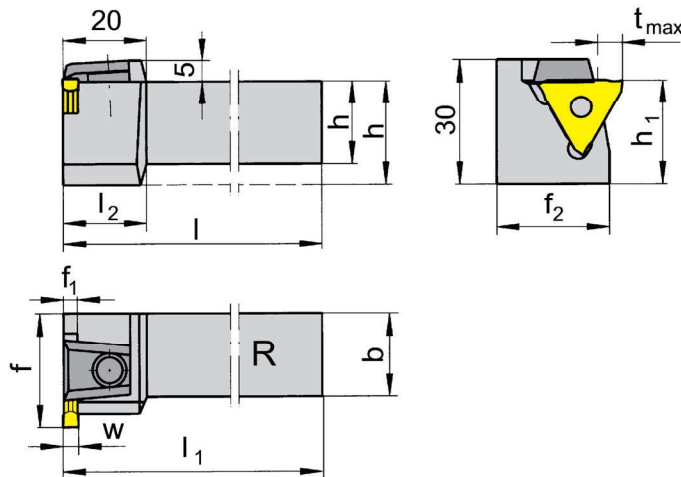
369

|                                |                                         |                    |
|--------------------------------|-----------------------------------------|--------------------|
| Stechtiefe bis<br>Spannbereich | Depth of groove up to<br>Clamping range | 6 mm<br>0,5-6,3 mm |
|--------------------------------|-----------------------------------------|--------------------|



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>2</sub> | h <sub>1</sub> | f  | t <sub>max</sub> | l <sub>1</sub>                     | l   | f <sub>1</sub> | f <sub>2</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----|------------------|------------------------------------|-----|----------------|----------------|---------------|--------------------------------|
| R/L369.2020.01               | 20 | 20 | 20             | 25             | 27 | 4                | l-f <sub>1</sub> +w-a <sub>1</sub> | 125 | 1,5            | 23,5           | 01            | 0,5-1,9                        |
| R/L369.2525.01               | 25 | 25 | -              | 25             | 32 | 4                | l-f <sub>1</sub> +w-a <sub>1</sub> | 150 | 1,5            | 28,5           | 01            | 0,5-1,9                        |
| R/L369.2020.02               | 20 | 20 | 20             | 25             | 27 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 125 | 2,5            | 23,5           | 02            | 1,9-2,9                        |
| R/L369.2525.02               | 25 | 25 | -              | 25             | 32 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 150 | 2,5            | 28,5           | 02            | 1,9-2,9                        |
| R/L369.2020.03               | 20 | 20 | 20             | 25             | 27 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 125 | 3,5            | 23,5           | 03            | 2,9-3,9                        |
| R/L369.2525.03               | 25 | 25 | -              | 25             | 32 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 150 | 3,5            | 28,5           | 03            | 2,9-3,9                        |
| R/L369.2020.04               | 20 | 20 | 20             | 25             | 27 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 125 | 4,5            | 23,5           | 04            | 3,9-6,3                        |
| R/L369.2525.04               | 25 | 25 | -              | 25             | 32 | 6                | l-f <sub>1</sub> +w-a <sub>1</sub> | 150 | 4,5            | 28,5           | 04            | 3,9-6,3                        |

Ausführung R oder L angeben  
State R or L version

w, a, siehe WSP  
w, a, see indexable inserts

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 40 mm erreichbar.

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

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| R/L369...                 | SW3,0 DIN911                    | 16.4                             |

# Einstecken und Drehen

## Grooving and Turning

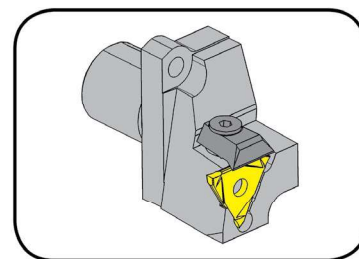


O

### Klemmhalter

Toolholder

369



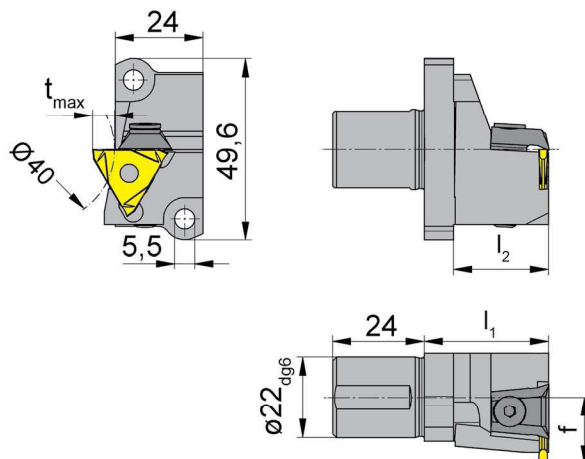
Stechtiefe  
Spannbereich

Depth of groove  
Clamping range

4-6 mm  
0,5-2,9 mm

Lochbild 13,7 x 37,6 mm

Hole pattern 13,7 x 37,6 mm



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312

für Star  
Langdrehautomaten  
for Swiss type machines Star

L = links wie gezeichnet

L = left hand version shown

| Bestellnummer<br>Part number | $l_2$ | f    | $t_{max}$ | $l_1$ | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|-------|------|-----------|-------|---------------|--------------------------------|
| <b>L369.A022.18.01</b>       | 26    | 18,2 | 4         | 34    | 01            | 0,5-1,9                        |
| <b>L369.A022.18.02</b>       | 26    | 18,2 | 6         | 34    | 02            | 1,9-2,9                        |

Weitere Abmessungen auf Anfrage

Further sizes upon request

Abmessungen in mm

Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

For torque specification of the screw, please see Technical Instructions.

**Star Langdrehautomaten:** ECAS-12/20, SB16D/E, SR-20, SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RIII

**Swiss Type Machines Star:** ECAS-12/20, SB16D/E, SR-20, SR20J/JN, RS-20RII, RS-20RIII, RS-20RIV, RS-32J/JN, SW-12RII

### Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| L369...                   | <b>SW3,0 DIN911</b>             | <b>16.4</b>                      |



# Einstechen und Drehen

## Grooving and Turning



### Einbauhalter Graf

#### Cartridge Graf

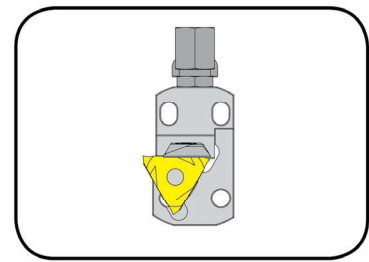
## 64/65

mit innerer Kühlmittelzufuhr  
with through coolant supply

Stechtiefe  
Spannbereich

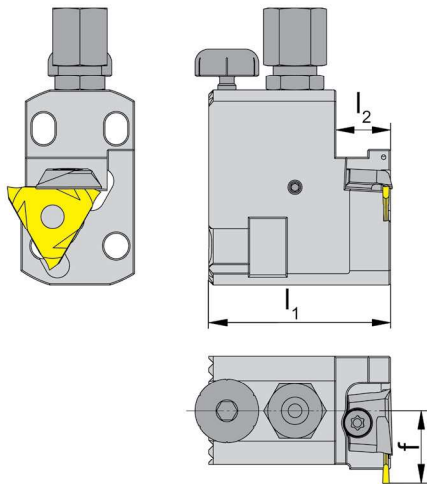
Depth of groove  
Clamping range

4 mm  
0,5-2,9 mm



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | $l_1$ | $l_2$ | f  | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|-------|-------|----|---------------|--------------------------------|
| <b>R/L64IK</b>               | 40    | 12    | 16 | 01            | 0,5-1,9                        |
| <b>R/L65IK</b>               | 40    | 12    | 16 | 02            | 1,9-2,9                        |

Ausführung R oder L angeben  
State R or L version

Weitere Abmessungen auf Anfrage  
Further sizes upon request

Das Kühlmittelrohr ist nicht im Lieferumfang enthalten - bitte separat bestellen!  
Coolant tube is not included - separate order required!

Abmessungen in mm  
Dimensions in mm

### Ersatzteile

#### Spare Parts

| Einbauhalter Graf<br>Cartridge Graf | Höhenverstellungsschraube<br>Screw to adjust the height | Kühlmittelanschluss<br>Coolant supply | Spannelement<br>Clamping element |
|-------------------------------------|---------------------------------------------------------|---------------------------------------|----------------------------------|
| L...                                | <b>002.00.69</b>                                        | <b>004.00.19</b>                      | <b>4.082L</b>                    |
| R...                                | <b>002.00.69</b>                                        | <b>004.00.19</b>                      | <b>4.081R</b>                    |

# Einstecken und Drehen

Grooving and Turning



O

## Einbauhalter Graf

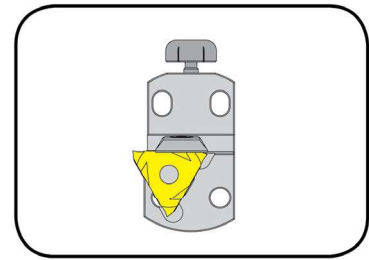
Cartridge Graf

# 64/65/99

Stechtiefe  
Spannbereich

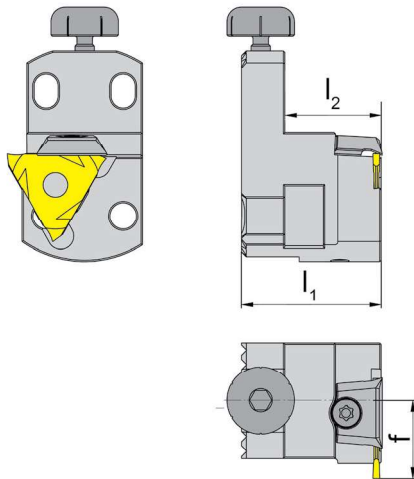
Depth of groove  
Clamping range

4 mm  
0,5-3,9 mm



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | $l_1$ | $l_2$ | f  | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|-------|-------|----|---------------|--------------------------------|
| <b>R/L64</b>                 | 29    | 20    | 16 | 01            | 0,5-1,9                        |
| <b>R/L65</b>                 | 29    | 20    | 16 | 02            | 1,9-2,9                        |
| <b>R/L99</b>                 | 29    | 20    | 16 | 03            | 2,9-3,9                        |

Ausführung R oder L angeben  
State R or L version

Weitere Abmessungen auf Anfrage  
Further sizes upon request

Abmessungen in mm  
Dimensions in mm

## Ersatzteile

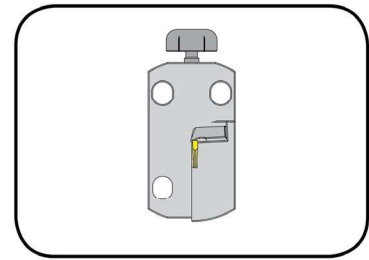
Spare Parts

| Einbauhalter Graf<br>Cartridge Graf | Höhenverstellungsschraube<br>Screw to adjust the height | Spannelement<br>Clamping element |
|-------------------------------------|---------------------------------------------------------|----------------------------------|
| R/L...                              | <b>002.00.69</b>                                        | <b>12.3</b>                      |

### Einstellbare Halter

Adjustable holder

## N67/N68/N98

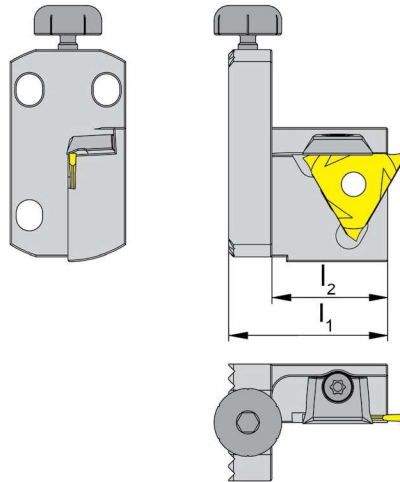


O

Stechtiefe  
Spannbereich

Depth of groove  
Clamping range

4 mm  
0,5-3,9 mm



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312

| Bestellnummer<br>Part number | $l_1$ | $l_2$ | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|-------|-------|---------------|--------------------------------|
| N67                          | 33    | 29    | 01            | 0,5-1,9                        |
| N68                          | 33    | 29    | 02            | 1,9-2,9                        |
| N98                          | 33    | 29    | 02            | 2,9-3,9                        |

Weitere Abmessungen auf Anfrage  
Further sizes upon request

Abmessungen in mm  
Dimensions in mm

### Ersatzteile

Spare Parts

| Einstellbare Halter<br>Adjustable holder | Höhenverstellungsschraube<br>Screw to adjust the height | Spannelement<br>Clamping element |
|------------------------------------------|---------------------------------------------------------|----------------------------------|
| N...                                     | 002.00.69                                               | 12.3                             |

# Einsteichen (außen)

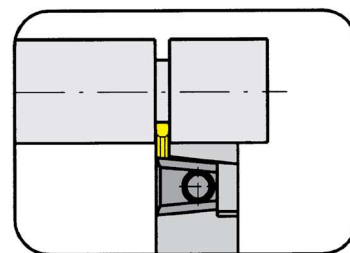
Grooving (external)



## Klemmhalter

Toolholder

# 390



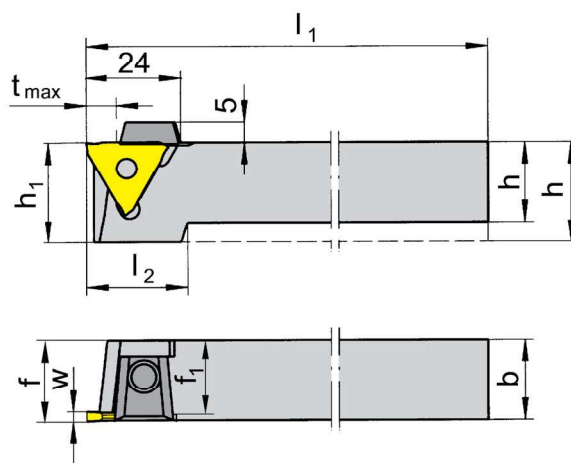
Stechtiefe bis  
Spannbereich

Depth of groove up to  
Clamping range

8 mm  
1,4-5,3 mm

für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                                | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------|----------------------------------|------------------|---------------|--------------------------------|
| R/L390.2020.01               | 20 | 20 | 125            | 22             | 25             | 18,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 1,4-1,9                        |
| R/L390.2525.01               | 25 | 25 | 150            | -              | 25             | 23,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 1,4-1,9                        |
| R/L390.2020.02               | 20 | 20 | 125            | 22             | 25             | 17,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 02            | 1,9-2,9                        |
| R/L390.2525.02               | 25 | 25 | 150            | -              | 25             | 22,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 02            | 1,9-2,9                        |
| R/L390.3232.02               | 32 | 32 | 170            | -              | 32             | 29,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 02            | 1,9-2,9                        |
| R/L390.2020.03               | 20 | 20 | 125            | 22             | 25             | 16,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 03            | 2,9-3,9                        |
| R/L390.2525.03               | 25 | 25 | 150            | -              | 25             | 21,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 03            | 2,9-3,9                        |
| R/L390.3232.03               | 32 | 32 | 170            | -              | 32             | 28,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 03            | 2,9-3,9                        |
| R/L390.2020.04               | 20 | 20 | 125            | 22             | 25             | 14,8           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 04            | 3,9-5,3                        |
| R/L390.2525.04               | 25 | 25 | 150            | -              | 25             | 19,8           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 04            | 3,9-5,3                        |
| R/L390.3232.04               | 32 | 32 | 170            | -              | 32             | 26,8           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 04            | 3,9-5,3                        |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 125 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 125 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| R/L390...                 | SW3,0 DIN911                    | 16.4                             |

# Einstecken (außen)

## Grooving (external)

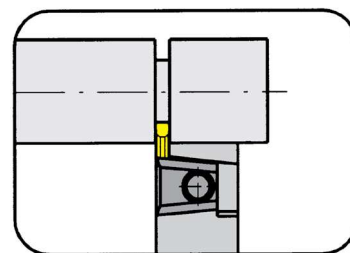


### Klemmhalter

Toolholder

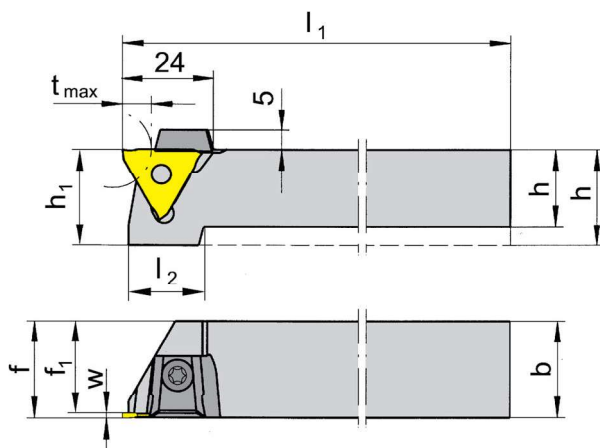
# 391

|                                |                                         |                    |
|--------------------------------|-----------------------------------------|--------------------|
| Stechtiefe bis<br>Spannbereich | Depth of groove up to<br>Clamping range | 8 mm<br>0,5-1,9 mm |
|--------------------------------|-----------------------------------------|--------------------|



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f <sub>1</sub> | f                                | t <sub>max</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|----------------|----------------------------------|------------------|---------------|--------------------------------|
| R/L391.1212.01               | 12 | 12 | 100            | 21             | 21             | 10,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 0,5-1,9                        |
| R/L391.1616.01               | 16 | 16 | 125            | 21             | 21             | 14,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 0,5-1,9                        |
| R/L391.2020.01               | 20 | 20 | 125            | 21             | 21             | 18,5           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 0,5-1,9                        |
| R/L391.2525.01               | 25 | 25 | 150            | -              | 25             | 23,8           | f <sub>1</sub> +w-a <sub>1</sub> | 8                | 01            | 0,5-1,9                        |

Ausführung R oder L angeben  
State R or L version

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

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

t<sub>max</sub> nur bei Werkstück-Ø ≤ 20 mm erreichbar.  
t<sub>max</sub> can be reached only with workpiece Ø ≤ 20 mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

### Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Spannelement<br>Clamping element | TORX PLUS®-Schlüssel<br>TORX PLUS® Wrench | Inbus-Schlüssel<br>Wrench |
|---------------------------|----------------------------------|-------------------------------------------|---------------------------|
| R/L391.1212.01            | 12.3                             | T10PL                                     | -                         |
| R/L391.1616.01            | 14.4                             | T15PQ                                     | -                         |
| R/L391....                | 16.4                             | -                                         | SW3,0 DIN911              |

# Eckenfreistechen (außen)

## Grooving Corner Reliefs (external)

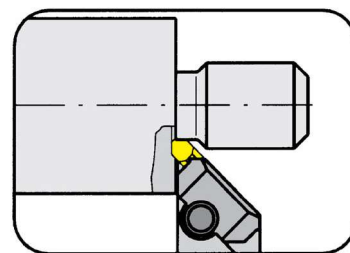


### Klemmhalter

Toolholder

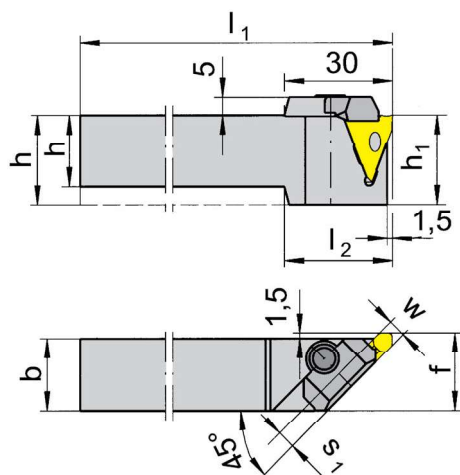
# 309

Eckenfreistriche ähnlich DIN 509 Form „F“  
Corner reliefs similar to DIN 509 form „F“



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | f    | s <sub>1</sub> | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----|----------------|----------------|----------------|------|----------------|---------------|--------------------------------|
| R/L309.1616.01               | 16 | 16 | 125            | 30             | 25             | 21,5 | 1,5            | 01            | 0,5-1,9                        |
| R/L309.2020.02               | 20 | 20 | 125            | 30             | 25             | 21,5 | 2,5            | 02            | 1,9-2,9                        |
| R/L309.2525.02               | 25 | 25 | 150            | -              | 25             | 26,5 | 2,5            | 02            | 1,9-2,9                        |
| R/L309.3232.02               | 32 | 32 | 170            | -              | 32             | 33,5 | 2,5            | 02            | 1,9-2,9                        |
| R/L309.2020.03               | 20 | 20 | 125            | 30             | 25             | 21,5 | 3,5            | 03            | 2,9-3,9                        |
| R/L309.2525.03               | 25 | 25 | 150            | -              | 25             | 26,5 | 3,5            | 03            | 2,9-3,9                        |
| R/L309.3232.03               | 32 | 32 | 170            | -              | 32             | 33,5 | 3,5            | 03            | 2,9-3,9                        |
| R/L309.2020.04               | 20 | 20 | 125            | 30             | 25             | 21,5 | 5,2            | 04            | 3,9-5,3                        |
| R/L309.2525.04               | 25 | 25 | 150            | -              | 25             | 26,5 | 5,2            | 04            | 3,9-5,3                        |
| R/L309.3232.04               | 32 | 32 | 170            | -              | 32             | 33,5 | 5,2            | 04            | 3,9-5,3                        |

Ausführung R oder L angeben  
State R or L version

w siehe WSP  
w see indexable inserts

Abmessungen in mm  
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

### Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Inbus-Schlüssel<br>Allen Wrench | Spannelement<br>Clamping element |
|---------------------------|---------------------------------|----------------------------------|
| R/L309...                 | SW3,0 DIN911                    | 21.4                             |

# Einstecken (außen)

Grooving (external)

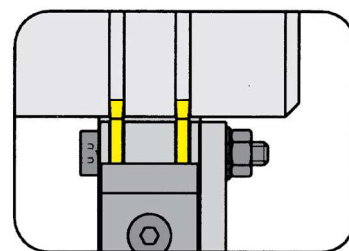


## Klemmhalter

Toolholder

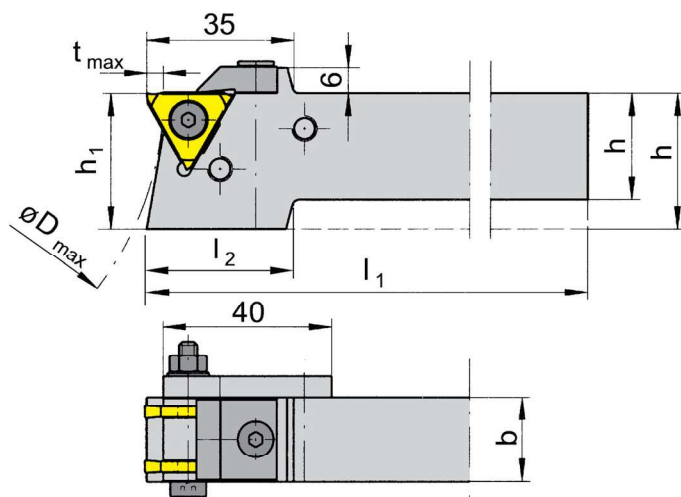
# 340

Mehrere Nuten gleichzeitig  
Multi grooving



für Wendeschneidplatte  
for Indexable insert

Typ 312 Sonder  
Type Special



| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | D <sub>max</sub> | t <sub>max</sub> | Größe<br>Size |
|------------------------------|----|----|----------------|----------------|----------------|------------------|------------------|---------------|
| 340.2020.01                  | 20 | 20 | 170            | 35             | 32             | 160              | 4                | 01            |
| 340.2520.01                  | 25 | 20 | 170            | 35             | 32             | 160              | 4                | 01            |
| 340.3220.01                  | 32 | 20 | 170            | -              | 32             | 160              | 4                | 01            |

Weitere Abmessungen auf Anfrage

Further sizes upon request

Abmessungen in mm

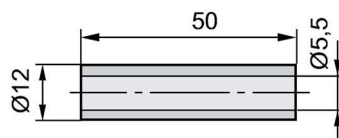
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.

For torque specification of the screw, please see Technical Instructions.

Rohr zur individuellen Herstellung von Distanzringen Best.Nr. 340.0012.50

Tube for producing spacing rings Part number 340.0012.50 separate order required



## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Schraube<br>Screw | Federscheibe<br>Spring plate | Flanschplatte<br>Flange | Gewinding<br>Thread-Ring | Inbus-Schlüssel<br>Wrench | Spannelement<br>Clamping element | Unterlegscheibe<br>Washer |
|---------------------------|-------------------|------------------------------|-------------------------|--------------------------|---------------------------|----------------------------------|---------------------------|
| 340...                    | 5.30.7984         | 5.12.03                      | 24.40                   | 12.3.8.5                 | SW3,0 DIN911              | 340.0200                         | B5.3 DIN 125-St           |



# Einstecken (außen)

Grooving (external)



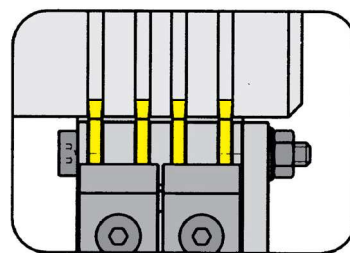
O

## Klemmhalter

Toolholder

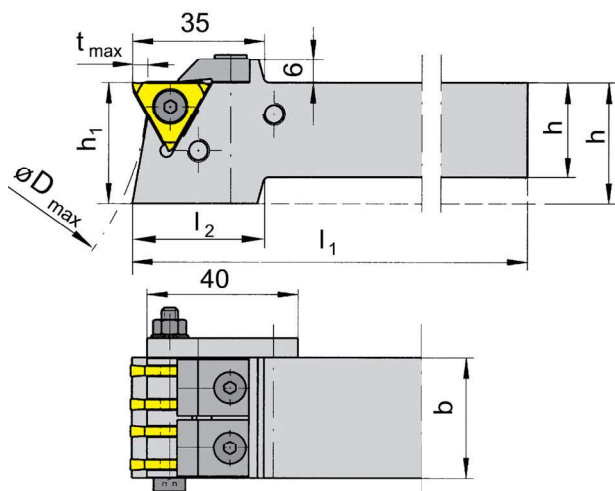
340

Mehrere Nuten gleichzeitig  
Multi grooving



für Wendeschneidplatte  
for Indexable insert

Typ 312 Sonder  
Type Special



Lieferzustand **rechts** montiert  
Right hand mounted

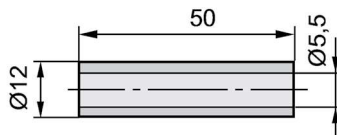
| Bestellnummer<br>Part number | h  | b  | l <sub>1</sub> | l <sub>2</sub> | h <sub>1</sub> | D <sub>max</sub> | t <sub>max</sub> | Größe<br>Size |
|------------------------------|----|----|----------------|----------------|----------------|------------------|------------------|---------------|
| <b>340.2532.02</b>           | 25 | 32 | 170            | 35             | 32             | 160              | 4                | 02            |
| <b>340.3232.02</b>           | 32 | 32 | 170            | -              | 32             | 160              | 4                | 02            |

Weitere Abmessungen auf Anfrage  
Further sizes upon request

Abmessungen in mm  
Dimensions in mm

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

Rohr zur individuellen Herstellung von Distanzringen Best.Nr. 340.0012.50  
Tube for producing spacing rings Part number 340.0012.50 separate order required



## Ersatzteile

Spare Parts

| Klemmhalter<br>Toolholder | Schraube<br>Screw | Federscheibe<br>Spring plate | Flanschplatte<br>Flange | Gewinde-Ring<br>Thread-Ring | Inbus-Schlüssel<br>Wrench | Paketschraube<br>Package screw |
|---------------------------|-------------------|------------------------------|-------------------------|-----------------------------|---------------------------|--------------------------------|
| 340...                    | <b>6.16.7991</b>  | <b>5.12.03</b>               | <b>24.40</b>            | <b>12.3.8.5</b>             | <b>SW3,0 DIN911</b>       | <b>5.40.7984</b>               |

| Klemmhalter<br>Toolholder | Spannelement<br>Clamping element | Unterlegscheibe<br>Washer |
|---------------------------|----------------------------------|---------------------------|
| 340...                    | <b>22.16</b>                     | <b>B5.3 DIN 125-St</b>    |

# Einstecken (innen)

Grooving (internal)

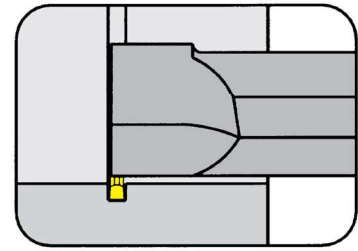


## Grundhalter

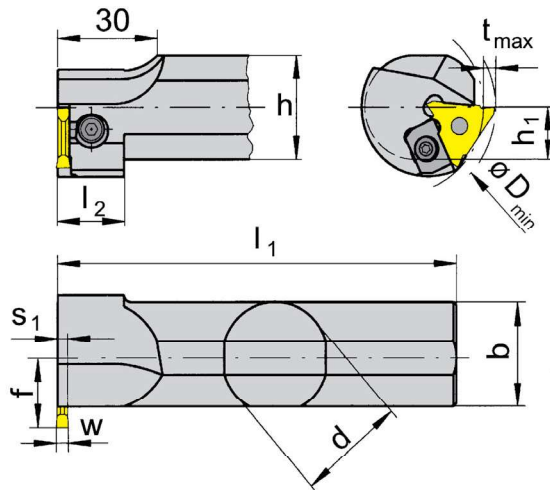
Basic toolholder

# 330

|                               |                               |                     |
|-------------------------------|-------------------------------|---------------------|
| Bohrungs-Ø ab<br>Spannbereich | Bore Ø from<br>Clamping range | 46 mm<br>1,9-6,3 mm |
|-------------------------------|-------------------------------|---------------------|



O



für Wendeschneidplatte  
for Indexable insert

Typ 312  
Type S312  
N312

Stechtiefe in Abhängigkeit des Bohrungs-Ø  
Depth of groove in relation to bore Ø

| D <sub>min</sub> | t <sub>max</sub> |
|------------------|------------------|
| 46               | 2,0              |
| 50               | 3,0              |
| 60               | 4,0              |
| 80               | 4,5              |
| 100              | 5,0              |

R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | d  | l <sub>1</sub> | l <sub>2</sub> | h  | s <sub>1</sub> | h <sub>1</sub> | f  | D <sub>min</sub> | b  | Größe<br>Size | Spannbereich<br>Clamping range |
|------------------------------|----|----------------|----------------|----|----------------|----------------|----|------------------|----|---------------|--------------------------------|
| R/L330.0025.K2               | 25 | 170            | 20             | 23 | 2,5            | 11,5           | 20 | 46               | 25 | 02            | 1,9-2,9                        |
| R/L330.0032.K2               | 32 | 200            | 20             | 30 | 2,5            | 15,0           | 20 | 46               | 30 | 02            | 1,9-2,9                        |
| R/L330.0040.K2               | 40 | 250            | -              | 38 | 2,5            | 19,0           | 24 | 46               | 38 | 02            | 1,9-2,9                        |
| R/L330.0025.K3               | 25 | 170            | 20             | 23 | 3,5            | 11,5           | 20 | 46               | 25 | 03            | 2,9-3,9                        |
| R/L330.0032.K3               | 32 | 200            | 20             | 30 | 3,5            | 15,0           | 20 | 46               | 30 | 03            | 2,9-3,9                        |
| R/L330.0040.K3               | 40 | 250            | -              | 38 | 3,5            | 19,0           | 24 | 46               | 38 | 03            | 2,9-3,9                        |
| R/L330.0025.K4               | 25 | 170            | 20             | 23 | 5,5            | 11,5           | 20 | 46               | 25 | 04            | 3,9-6,3                        |
| R/L330.0032.K4               | 32 | 200            | 20             | 30 | 5,5            | 15,0           | 20 | 46               | 30 | 04            | 3,9-6,3                        |
| R/L330.0040.K4               | 40 | 250            | 20             | 38 | 5,5            | 19,0           | 24 | 46               | 38 | 04            | 3,9-6,3                        |

Ausführung R oder L angeben  
State R or L version

w siehe WSP  
w see indexable inserts

Abmessungen in mm  
Dimensions in mm

Weitere Abmessungen auf Anfrage  
Further sizes upon request

Das Anzugsdrehmoment der Schrauben finden Sie in den Technischen Hinweisen.  
For torque specification of the screw, please see Technical Instructions.

## Ersatzteile

Spare Parts

| Grundhalter<br>Basic toolholder | Anlageleiste<br>Attachment bar | Spannschraube<br>Screw | Inbus-Schlüssel<br>Wrench | Spannelement<br>Clamping element | TORX PLUS®-Schlüssel<br>TORX PLUS® Wrench |
|---------------------------------|--------------------------------|------------------------|---------------------------|----------------------------------|-------------------------------------------|
| R/L330...                       | 020.1025.0170                  | 5.12T20P               | SW3,0 DIN911              | 15.4                             | T20PQ                                     |

# Einstecken und Abstechen

Grooving and Parting Off



## Wendeschneidplatte

Indexable insert

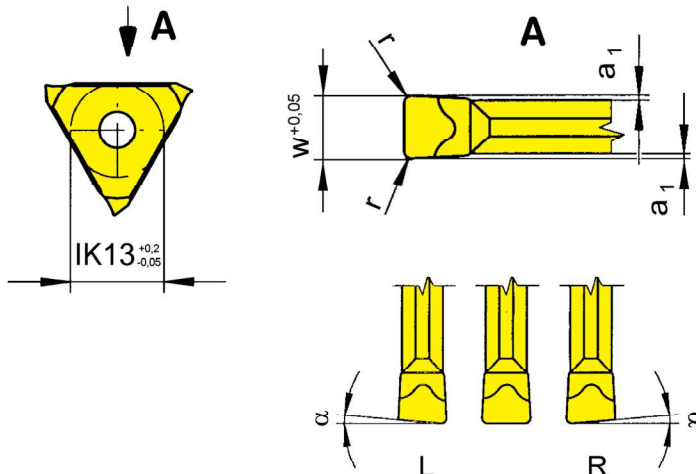
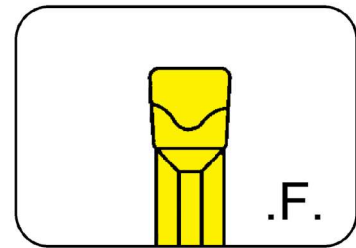
## S312

mit gesinterter Geometrie  
with sintered geometries

Stechbreite

Width of groove

2-5 mm



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Geometrie .F  
Geometry .F

| Bestellnummer<br>Part number | w   | r   | $\alpha$ | $a_1$ | Größe<br>Size | AL96 | EG56 | TC92 | TF45 | TF46 | TI25 |
|------------------------------|-----|-----|----------|-------|---------------|------|------|------|------|------|------|
| R/LS312.0520.F2              | 2,0 | 0,2 | 5°       | 0,25  | 02            |      |      |      |      |      |      |
| S312.0200.F2                 | 2,0 | 0,2 | 0°       | 0,25  | 02            |      |      |      |      |      |      |
| R/LS312.0525.F2              | 2,5 | 0,2 | 5°       | 0,25  | 02            |      |      |      |      |      |      |
| S312.0250.F2                 | 2,5 | 0,2 | 0°       | 0,25  | 02            |      |      |      |      |      |      |
| S312.0400.F2                 | 4,0 | 0,2 | 0°       | 0,25  | 04            |      |      |      |      |      |      |
| S312.0400.F4                 | 4,0 | 0,4 | 0°       | 0,25  | 04            |      |      |      |      |      |      |
| S312.0500.F2                 | 5,0 | 0,2 | 0°       | 0,25  | 04            |      |      |      |      |      |      |
| S312.0500.F4                 | 5,0 | 0,4 | 0°       | 0,25  | 04            |      |      |      |      |      |      |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

|      | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| AL96 | ● | - | ● | ● | - | - |
| EG56 | ● | ○ | ○ | - | - | - |
| TC92 | ● | - | - | - | - | - |
| TF45 | ● | ● | ● | ● | ● | ● |
| TF46 | ● | ○ | ○ | ○ | ○ | ○ |
| TI25 | ● | ● | ● | ● | ● | ● |

HM-Sorten  
Carbide grades

# Einstechen (außen und innen)

Grooving (external and internal)



## Wendeschneidplatte

Indexable insert

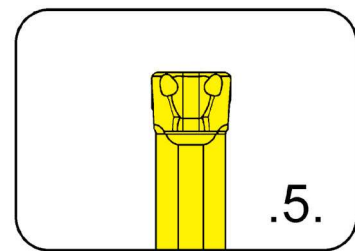
## S312

mit gesinterter Geometrie  
with sintered geometries

Stechbreite

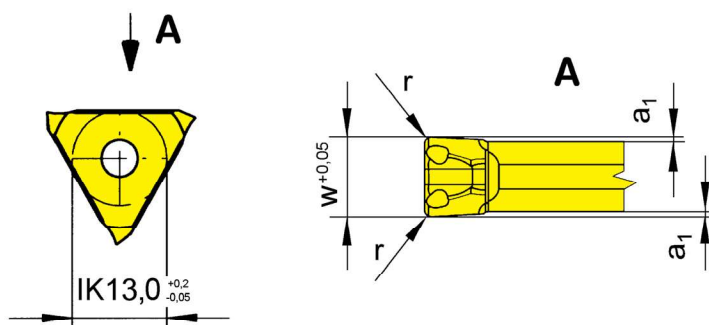
Width of groove

2,5-5 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



Geometrie .5  
Geometry .5

| Bestellnummer<br>Part number                                            | w   | r   | a <sub>1</sub> | Größe<br>Size |   | AL96 | AS62 | AS66 | EG56 | TC92 | TF45 | TF46 | TI25 | TN32 | TN35 |
|-------------------------------------------------------------------------|-----|-----|----------------|---------------|---|------|------|------|------|------|------|------|------|------|------|
| S312.0250.52                                                            | 2,5 | 0,2 | 0,25           | 02            |   | ▲    | ▲    | ▲    | ▲    | Δ    | ▲    | ▲    | ▲    | ▲    |      |
| S312.0250.54                                                            | 2,5 | 0,4 | 0,25           | 02            |   | Δ    | ▲    | ▲    | ▲    | Δ    | ▲    | ▲    | ▲    | ▲    | ▲    |
| S312.0300.52                                                            | 3,0 | 0,2 | 0,25           | 03            |   | Δ    | ▲    | ▲    | ▲    | Δ    | ▲    | ▲    | ▲    | ▲    |      |
| S312.0300.54                                                            | 3,0 | 0,4 | 0,25           | 03            |   | Δ    | ▲    | ▲    | ▲    | Δ    | Δ    | ▲    | ▲    | ▲    |      |
| S312.0400.52                                                            | 4,0 | 0,2 | 0,25           | 04            |   |      | ▲    | ▲    | ▲    |      |      | ▲    | ▲    | Δ    |      |
| S312.0400.54                                                            | 4,0 | 0,4 | 0,25           | 04            |   |      | ▲    | ▲    | ▲    |      |      | ▲    | ▲    | ▲    |      |
| S312.0500.52                                                            | 5,0 | 0,2 | 0,25           | 04            |   |      | ▲    | ▲    | ▲    |      |      | ▲    | Δ    | Δ    |      |
| S312.0500.54                                                            | 5,0 | 0,4 | 0,25           | 04            |   |      | ▲    | ▲    | Δ    |      |      | ▲    | ▲    | Δ    |      |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |     |                |               | P | •    | •    | •    | •    | •    | •    | •    | •    | •    | •    |
| • empfohlen / recommended                                               |     |     |                |               | M | -    | -    | o    | o    | -    | •    | o    | •    | -    | •    |
| o bedingt einsetzbar / alternative recommendation                       |     |     |                |               | K | •    | -    | •    | o    | -    | •    | •    | •    | -    | •    |
| - nicht geeignet / not suitable                                         |     |     |                |               | N | •    | -    | •    | -    | -    | •    | •    | •    | -    | •    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |     |                |               | S | -    | -    | o    | -    | -    | •    | o    | •    | -    | •    |
| beschichtete HM-Sorten / coated grades                                  |     |     |                |               | H | -    | -    | -    | -    | -    | -    | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |     |                |               |   |      |      |      |      |      |      |      |      |      |      |

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

HM-Sorten  
Carbide grades

# Einstecken und Abstechen

Grooving and Parting Off



O

## Wendeschneidplatte

Indexable insert

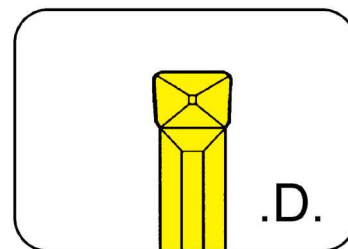
## S312

mit gesinterter Geometrie  
with sintered geometries

Stechbreite

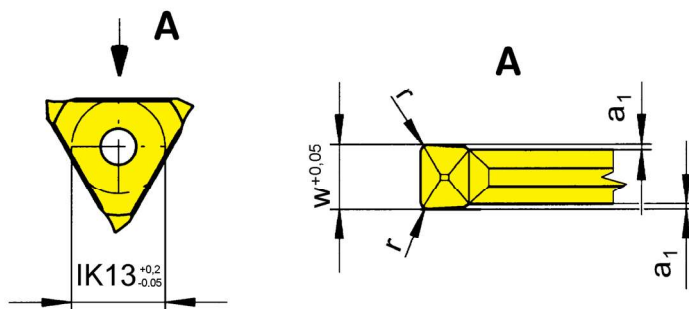
Width of groove

2-3 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



Geometrie .D  
Geometry .D

| Bestellnummer<br>Part number                                            | w   | r   | a <sub>1</sub> | Größe<br>Size | AL96 | AS62 | AS66 | EG56 | TC92 | TF45 | TF46 | TI25 | TN32 |
|-------------------------------------------------------------------------|-----|-----|----------------|---------------|------|------|------|------|------|------|------|------|------|
| S312.0200.D2                                                            | 2,0 | 0,2 | 0,25           | 02            | Δ    | ▲    | ▲    | ▲    | Δ    | Δ    | ▲    | ▲    | ▲    |
| S312.0200.D4                                                            | 2,0 | 0,4 | 0,25           | 02            | Δ    | ▲    | ▲    | ▲    | Δ    | Δ    | Δ    | ▲    | Δ    |
| S312.0250.D2                                                            | 2,5 | 0,2 | 0,25           | 02            | Δ    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    |
| S312.0250.D4                                                            | 2,5 | 0,4 | 0,25           | 02            | Δ    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    |
| S312.0300.D2                                                            | 3,0 | 0,2 | 0,25           | 03            | Δ    | Δ    | ▲    | ▲    | Δ    | ▲    | ▲    | ▲    | ▲    |
| S312.0300.D4                                                            | 3,0 | 0,4 | 0,25           | 03            | Δ    | ▲    | ▲    | ▲    | Δ    | Δ    | Δ    | Δ    | Δ    |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |     |                |               | P    | ●    | ●    | ●    | ●    | ●    | ●    | ●    | ●    |
| ● empfohlen / recommended                                               |     |     |                |               | M    | -    | -    | ○    | ○    | -    | ○    | ●    | -    |
| ○ bedingt einsetzbar / alternative recommendation                       |     |     |                |               | K    | ●    | -    | ●    | ○    | -    | ●    | ●    | -    |
| - nicht geeignet / not suitable                                         |     |     |                |               | N    | ●    | -    | ●    | -    | -    | ●    | ●    | -    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |     |                |               | S    | -    | -    | ○    | -    | -    | ○    | ●    | -    |
| beschichtete HM-Sorten / coated grades                                  |     |     |                |               | H    | -    | -    | -    | -    | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |     |                |               |      |      |      |      |      |      |      |      |      |

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

HM-Sorten  
Carbide grades

### Wendeschneidplatte

#### Indexable insert

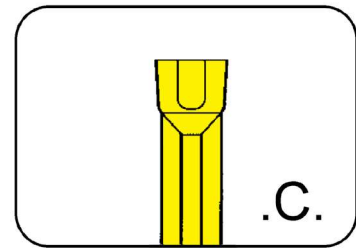
## S312

mit gesinterter Geometrie  
with sintered geometries

Stechtiefe bis  
Stechbreite

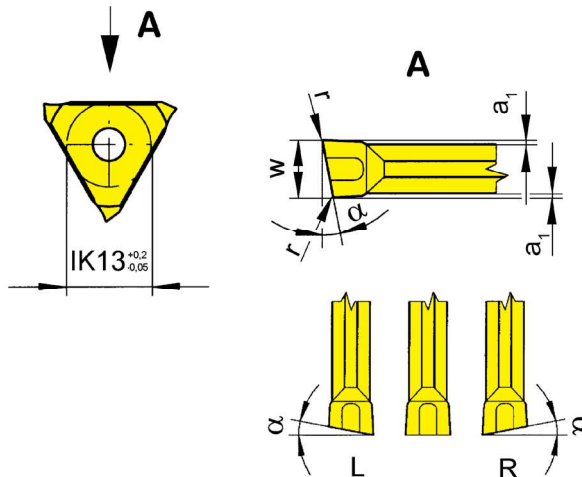
Depth of groove up to  
Width of groove

5 mm  
2-3 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

Geometrie .C.  
Geometry .C

| Bestellnummer<br>Part number                                            | w   | r   | $\alpha$ | $a_1$ | Größe<br>Size | EG55 | TF46 | TI25 |
|-------------------------------------------------------------------------|-----|-----|----------|-------|---------------|------|------|------|
| <b>S312.0200.C2</b>                                                     | 2,0 | 0,2 | 0°       | 0,25  | 02            | ▲    | ▲    | ▲    |
| <b>R/LS312.0520.C2</b>                                                  | 2,0 | 0,2 | 5°       | 0,25  | 02            | ▲/▲  | ▲/Δ  | ▲/▲  |
| <b>S312.0250.C2</b>                                                     | 2,5 | 0,2 | 0°       | 0,25  | 02            | ▲    | Δ    | ▲    |
| <b>R/LS312.0525.C2</b>                                                  | 2,5 | 0,2 | 5°       | 0,25  | 02            | Δ/▲  | ▲/Δ  | ▲/▲  |
| <b>S312.0300.C2</b>                                                     | 3,0 | 0,2 | 0°       | 0,25  | 03            | Δ    | Δ    | Δ    |
| <b>R/LS312.0530.C2</b>                                                  | 3,0 | 0,2 | 5°       | 0,25  | 03            | Δ/Δ  | Δ/Δ  | ▲/Δ  |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |     |          |       |               | P    | •    | •    |
| ● empfohlen / recommended                                               |     |     |          |       |               | M    | ○    | ○    |
| ○ bedingt einsetzbar / alternative recommendation                       |     |     |          |       |               | K    | ○    | •    |
| - nicht geeignet / not suitable                                         |     |     |          |       |               | N    | -    | •    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |     |          |       |               | S    | -    | ○    |
| beschichtete HM-Sorten / coated grades                                  |     |     |          |       |               | H    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |     |          |       |               |      |      |      |

Abmessungen in mm  
Dimensions in mm

Ausführung R oder L angeben  
State R or L version

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.  
Indexable inserts can be used in right and left hand toolholders.

HM-Sorten  
Carbide grades

# Einstecken (außen)

## Grooving (external)



### Wendeschneidplatte

Indexable insert

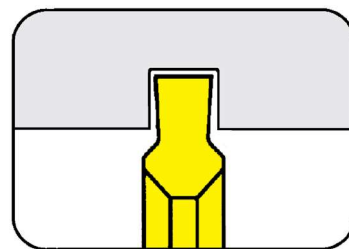
# 312

mit runder Spanleitstufe  
with round chip breaker

Seegerringnuten  
Nutnennbreite Nw

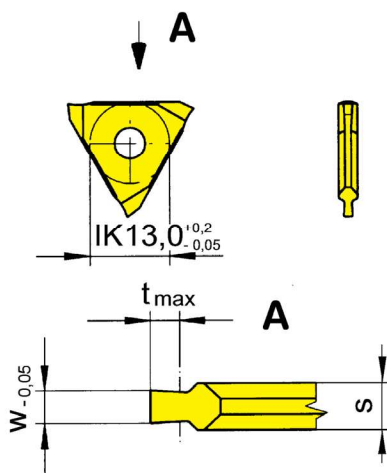
Circlip grooves  
Width of circlip Nw

DIN 471/472  
0,34-1 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | w    | Nw   | t <sub>max</sub> | s   | Größe<br>Size | EG35 | EG52 | TN32 |
|------------------------------|------|------|------------------|-----|---------------|------|------|------|
| 312.0034.15                  | 0,38 | 0,34 | 0,6              | 1,5 | 01            | Δ    |      |      |
| 312.0044.15                  | 0,44 | 0,40 | 0,7              | 1,5 | 01            | Δ    |      |      |
| 312.0050.15                  | 0,57 | 0,50 | 0,7              | 1,5 | 01            |      | ▲    | ▲    |
| 312.0060.15                  | 0,67 | 0,60 | 0,8              | 1,5 | 01            |      | ▲    | ▲    |
| 312.0070.15                  | 0,77 | 0,70 | 1,1              | 1,5 | 01            |      | ▲    | ▲    |
| 312.0080.15                  | 0,87 | 0,80 | 1,2              | 1,5 | 01            |      | ▲    | ▲    |
| 312.0090.15                  | 0,97 | 0,90 | 1,4              | 1,5 | 01            |      | ▲    | ▲    |
| 312.0100.15                  | 1,07 | 1,00 | 1,6              | 1,5 | 01            |      | ▲    | ▲    |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

Weitere Abmessungen auf Anfrage

Further sizes upon request

|      | P | M | K | N | S | H |
|------|---|---|---|---|---|---|
| EG35 | ● | ● | ● | - | - | - |
| EG52 | ● | ○ | - | - | - | - |
| TN32 | ● | - | - | - | - | - |

HM-Sorten  
Carbide grades

# Einstecken (außen und innen)

Grooving (external and internal)

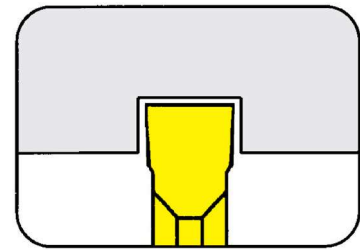


## Wendeschneidplatte

Indexable insert

# 312

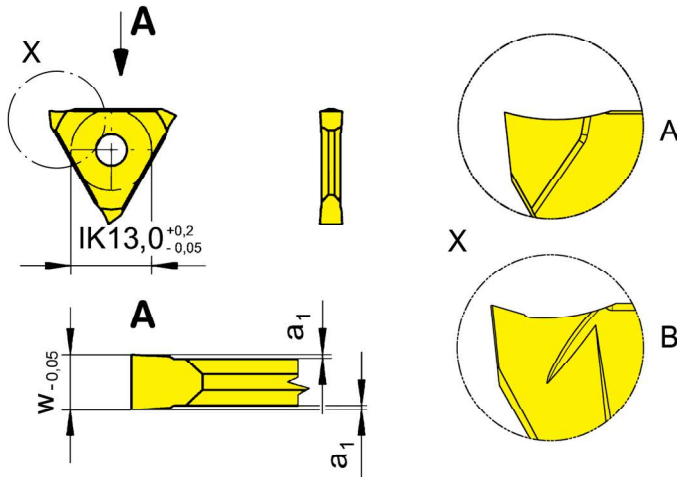
mit runder Spanleitstufe  
with round chip breaker



Seegerringnuten  
Nutnennbreite Nw

Circlip grooves  
Width of circlip Nw

DIN 471/472  
0,5-5, 15 mm



Form A = komplett geschliffen  
Form A = completely ground

Form B = teilgeschliffen  
Form B = partially ground

für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number                      | w    | Nw   | a <sub>1</sub> | Form<br>Form | Größe<br>Size | K10 | MG12 | EG35 | EG55 | EG56 | H20 | HS32 | HS36 | P20 | TA45 | TC92 | TF45 | TF46 | TI25 | TN32 | TN35 |
|---------------------------------------------------|------|------|----------------|--------------|---------------|-----|------|------|------|------|-----|------|------|-----|------|------|------|------|------|------|------|
| 312.0050.00                                       | 0,57 | 0,50 | 0,07           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0060.00                                       | 0,67 | 0,60 | 0,07           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0070.00                                       | 0,77 | 0,70 | 0,08           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0080.00                                       | 0,87 | 0,80 | 0,08           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0090.00                                       | 0,97 | 0,90 | 0,08           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0100.00                                       | 1,07 | 1,00 | 0,09           | A            | 01            | ▲   |      |      | ▲    |      | Δ   |      |      | ▲   |      |      | ▲    | ▲    |      | ▲    |      |
| 312.0110.00                                       | 1,24 | 1,10 | 0,20           | A            | 01            | ▲   |      |      | ▲    |      |     | Δ    | Δ    | ▲   |      | ▲    | ▲    | ▲    |      | ▲    |      |
| 312.0130.00                                       | 1,44 | 1,30 | 0,20           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      | ▲    | ▲    | ▲    |      | ▲    |      |
| 312.0160.00                                       | 1,74 | 1,60 | 0,20           | A            | 01            | ▲   |      |      | ▲    |      |     |      |      | ▲   |      | ▲    | ▲    | ▲    |      | ▲    |      |
| 312.0185.00                                       | 1,99 | 1,85 | 0,20           | B            | 01            | ▲   | ▲    |      | ▲    | Δ    | ▲   |      |      | ▲   |      | ▲    | ▲    | ▲    | ▲    | ▲    | ▲    |
| 312.0215.00                                       | 2,29 | 2,15 | 0,20           | B            | 02            | ▲   | ▲    |      | ▲    |      | ▲   |      |      | ▲   | ▲    | ▲    | ▲    | ▲    |      | ▲    | ▲    |
| 312.0265.00                                       | 2,79 | 2,65 | 0,20           | B            | 02            | ▲   | ▲    |      | ▲    |      | ▲   |      |      | ▲   | Δ    | ▲    | ▲    | ▲    |      | ▲    | ▲    |
| 312.0315.00                                       | 3,29 | 3,15 | 0,20           | B            | 03            | ▲   |      |      | ▲    |      | ▲   |      |      | ▲   |      | ▲    | ▲    | ▲    |      | ▲    | ▲    |
| 312.0415.00                                       | 4,29 | 4,15 | 0,20           | B            | 04            | ▲   |      |      | ▲    |      | ▲   |      |      | ▲   |      | ▲    | ▲    | ▲    |      | ▲    | ▲    |
| 312.0515.00                                       | 5,29 | 5,15 | 0,20           | B            | 04            | ▲   |      | ▲    | ▲    |      | Δ   |      |      | ▲   |      | Δ    | ▲    | ▲    |      | ▲    | ▲    |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks        |      |      |                |              |               | P   | ●    | ○    | ●    | ●    | ●   | ○    | -    | ●   | ●    | ●    | ●    | ●    | ●    | ●    | ●    |
| x auf Anfrage / upon request                      |      |      |                |              |               | M   | ○    | ●    | ●    | ○    | ○   | ○    | -    | -   | ●    | -    | ●    | ○    | ●    | -    | ●    |
| ● empfohlen / recommended                         |      |      |                |              |               | K   | ●    | ●    | ○    | ○    | ○   | -    | -    | -   | ●    | ●    | ●    | ●    | ●    | -    | ●    |
| ○ bedingt einsetzbar / alternative recommendation |      |      |                |              |               | N   | ●    | ●    | -    | -    | -   | -    | -    | -   | ●    | -    | ●    | ●    | -    | -    | ●    |
| - nicht geeignet / not suitable                   |      |      |                |              |               | S   | ○    | ●    | -    | -    | -   | -    | -    | -   | ●    | -    | ○    | ○    | ●    | -    | ●    |
| unbeschichtete HM-Sorten / uncoated grades        |      |      |                |              |               | H   | -    | -    | -    | -    | -   | ●    | ●    | -   | -    | -    | -    | -    | -    | -    | -    |
| beschichtete HM-Sorten / coated grades            |      |      |                |              |               |     |      |      |      |      |     |      |      |     |      |      |      |      |      |      |      |
| bestückt/Cermet / brazed/Cermet                   |      |      |                |              |               |     |      |      |      |      |     |      |      |     |      |      |      |      |      |      |      |

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

HM-Sorten  
Carbide grades



# Einstechen (außen und innen)

Grooving (external and internal)



## Wendeschneidplatte

Indexable insert

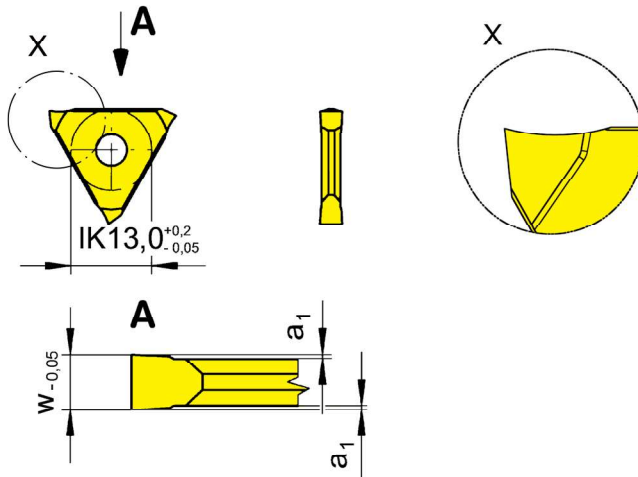
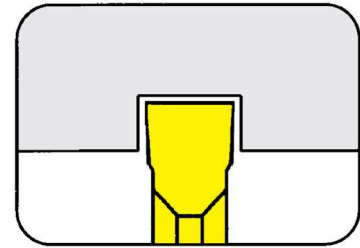
# 312

mit runder Spanleitstufe  
with round chip breaker

Seegerringnuten  
Nutnennbreite Nw

Circlip grooves  
Width of circlip Nw

DIN 471/472  
1,85-5,15 mm



komplett geschliffen  
completely ground

für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | w    | Nw   | a <sub>1</sub> | Größe<br>Size |   | K10 | EG56 | P20 | TN32 |
|------------------------------|------|------|----------------|---------------|---|-----|------|-----|------|
| 312.0185.10                  | 1,99 | 1,85 | 0,2            | 01            |   | Δ   |      | ▲   | ▲    |
| 312.0215.10                  | 2,29 | 2,15 | 0,2            | 02            |   | ▲   | ▲    | Δ   |      |
| 312.0265.10                  | 2,79 | 2,65 | 0,2            | 02            |   | ▲   | Δ    | ▲   |      |
| 312.0315.10                  | 3,29 | 3,15 | 0,2            | 03            |   | ▲   | Δ    | Δ   |      |
| 312.0415.10                  | 4,29 | 4,15 | 0,2            | 04            |   | ▲   | ▲    | ▲   |      |
| 312.0515.10                  | 5,29 | 5,15 | 0,2            | 04            |   | ▲   | ▲    | ▲   |      |
|                              |      |      |                |               | P | •   | •    | •   | •    |
|                              |      |      |                |               | M | ○   | ○    | -   | -    |
|                              |      |      |                |               | K | •   | ○    | -   | -    |
|                              |      |      |                |               | N | •   | -    | -   | -    |
|                              |      |      |                |               | S | ○   | -    | -   | -    |
|                              |      |      |                |               | H | -   | -    | -   | -    |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

• empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

HM-Sorten  
Carbide grades

# Einstecken (außen)

Grooving (external)



## Wendeschneidplatte

Indexable insert

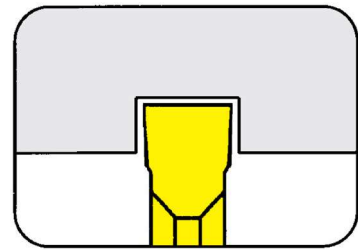
# 312

mit runder Spanleitstufe  
with round chip breaker

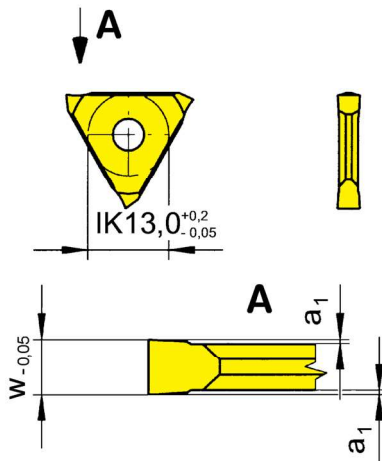
Seegerringnuten  
Nutnennbreite Nw

Circlip grooves  
Width of circlip Nw

DIN 471/472  
1,1-5,15 mm



besonders geeignet für unterbrochenen Schnitt  
recommended for interrupted cut



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | w    | Nw   | a <sub>1</sub> | Größe<br>Size | EG55 | TN35 |
|------------------------------|------|------|----------------|---------------|------|------|
| 312.0110.80                  | 1,24 | 1,10 | 0,2            | 01            | ▲    | ▲    |
| 312.0130.80                  | 1,44 | 1,30 | 0,2            | 01            | ▲    | ▲    |
| 312.0160.80                  | 1,74 | 1,60 | 0,2            | 01            | ▲    | ▲    |
| 312.0185.80                  | 1,99 | 1,85 | 0,2            | 01            | ▲    | ▲    |
| 312.0215.80                  | 2,29 | 2,15 | 0,2            | 02            | ▲    | ▲    |
| 312.0265.80                  | 2,79 | 2,65 | 0,2            | 02            | ▲    | ▲    |
| 312.0315.80                  | 3,29 | 3,15 | 0,2            | 03            | ▲    | ▲    |
| 312.0415.80                  | 4,29 | 4,15 | 0,2            | 04            | ▲    | ▲    |
| 312.0515.80                  | 5,29 | 5,15 | 0,2            | 04            | ▲    | ▲    |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

|   |   |   |
|---|---|---|
| P | • | • |
| M | o | • |
| K | o | • |
| N | - | • |
| S | - | • |
| H | - | - |

HM-Sorten  
Carbide grades

# Einstecken (außen und innen)

Grooving (external and internal)



## Wendeschneidplatte

Indexable insert

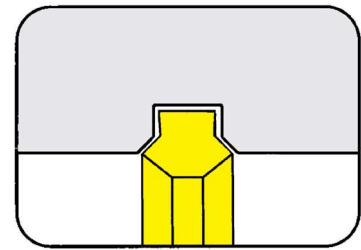
# 312

mit runder Spanleitstufe  
with round chip breaker

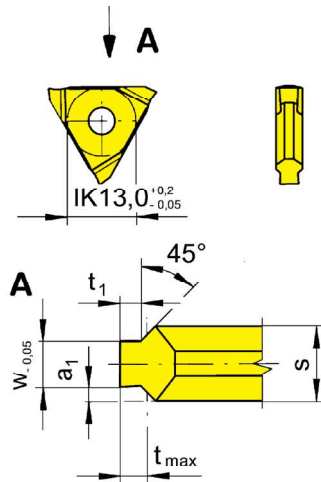
Seegerringnuten  
Nutnennbreite Nw

Circlip grooves  
Width of circlip Nw

DIN 471/472  
1,1-5,15 mm



mit Nutaußenkantenfasung  
with chamfer



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | w    | Nw   | t <sub>max</sub> | a <sub>1</sub> | s   | t <sub>1</sub> | Größe<br>Size | EG52 | P20 | TN32 | TN35 |
|------------------------------|------|------|------------------|----------------|-----|----------------|---------------|------|-----|------|------|
| 312.1101.25                  | 1,24 | 1,10 | 0,20             | 0,64           | 2,5 | 0,19           | 02            | Δ    |     | Δ    |      |
| 312.1102.25                  | 1,24 | 1,10 | 0,25             | 0,64           | 2,5 | 0,24           | 02            | ▲    |     | ▲    |      |
| 312.1103.25                  | 1,24 | 1,10 | 0,30             | 0,64           | 2,5 | 0,29           | 02            | ▲    |     | ▲    |      |
| 312.1104.25                  | 1,24 | 1,10 | 0,35             | 0,64           | 2,5 | 0,33           | 02            | Δ    |     | ▲    |      |
| 312.1105.25                  | 1,24 | 1,10 | 0,40             | 0,64           | 2,5 | 0,36           | 02            | ▲    | ▲   | ▲    | Δ    |
| 312.1306.25                  | 1,44 | 1,30 | 0,55             | 0,54           | 2,5 | 0,45           | 02            | ▲    | Δ   | ▲    |      |
| 312.1607.33                  | 1,74 | 1,60 | 0,70             | 0,79           | 3,3 | 0,60           | 03            | ▲    |     | ▲    |      |
| 312.1608.33                  | 1,74 | 1,60 | 0,85             | 0,79           | 3,3 | 0,75           | 03            | ▲    | Δ   | ▲    |      |
| 312.1609.33                  | 1,74 | 1,60 | 1,00             | 0,79           | 3,3 | 0,85           | 03            | ▲    |     | ▲    |      |
| 312.1810.33                  | 1,99 | 1,85 | 1,00             | 0,67           | 3,3 | 0,85           | 03            | ▲    |     | ▲    |      |
| 312.1812.33                  | 1,99 | 1,85 | 1,25             | 0,67           | 3,3 | 1,10           | 03            | ▲    | Δ   | ▲    |      |
| 312.2115.43                  | 2,29 | 2,15 | 1,50             | 1,02           | 4,3 | 1,35           | 04            | ▲    | ▲   | ▲    |      |
| 312.2616.43                  | 2,79 | 2,65 | 1,50             | 0,77           | 4,3 | 1,35           | 04            | ▲    | Δ   | ▲    |      |
| 312.2617.43                  | 2,79 | 2,65 | 1,75             | 0,77           | 4,3 | 1,60           | 04            | ▲    | Δ   | ▲    |      |
| 312.3118.53                  | 3,29 | 3,15 | 1,75             | 1,02           | 5,3 | 1,60           | 04            | ▲    | Δ   | ▲    |      |
| 312.4120.53                  | 4,29 | 4,15 | 2,00             | 0,52           | 5,3 | 1,85           | 04            | ▲    |     | ▲    |      |
| 312.4125.53                  | 4,29 | 4,15 | 2,50             | 0,52           | 5,3 | 2,35           | 04            | Δ    |     | ▲    |      |
| 312.5130.63                  | 5,29 | 5,15 | 3,00             | 0,52           | 6,3 | 2,85           | 04            | Δ    |     | ▲    |      |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

|   |   |   |   |   |
|---|---|---|---|---|
| P | • | • | • | • |
| M | o | - | - | • |
| K | - | - | - | • |
| N | - | - | - | • |
| S | - | - | - | • |
| H | - | - | - | - |

HM-Sorten  
Carbide grades

### Wendeschneidplatte

Indexable insert

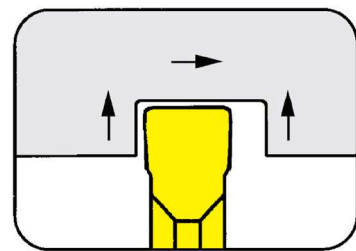
# 312

mit runder Spanleitstufe  
with round chip breaker

Stechtiefe bis  
Stechbreite

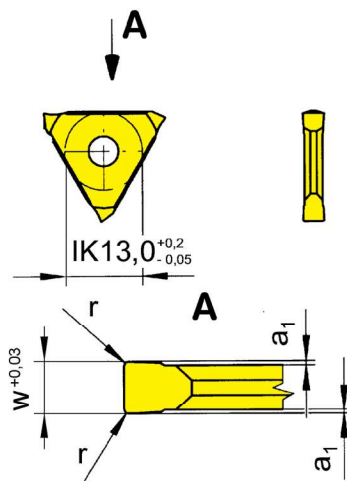
Depth of groove up to  
Width of groove

6 mm  
1-4 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number                                            | w   | r   | a <sub>1</sub> | Größe<br>Size | K10 | AS62 | EG52 | H20 | P20 | TF45 | TI22 | TI25 | TN32 | TN35 | TN38 |
|-------------------------------------------------------------------------|-----|-----|----------------|---------------|-----|------|------|-----|-----|------|------|------|------|------|------|
| 312.0100.02                                                             | 1,0 | 0,2 | 0,10           | 01            |     |      | ▲    |     |     |      |      | ▲    | ▲    |      |      |
| 312.0150.02                                                             | 1,5 | 0,2 | 0,25           | 01            | Δ   |      | ▲    |     | ▲   |      |      | ▲    | ▲    | ▲    |      |
| 312.0200.02                                                             | 2,0 | 0,2 | 0,25           | 02            | ▲   |      | ▲    | ▲   | ▲   | ▲    | ▲    | ▲    | ▲    | ▲    |      |
| 312.0200.04                                                             | 2,0 | 0,4 | 0,25           | 02            |     | ▲    | ▲    | ▲   | ▲   |      |      |      | ▲    |      |      |
| 312.0300.02                                                             | 3,0 | 0,2 | 0,25           | 03            | Δ   |      | ▲    | ▲   | ▲   |      |      | ▲    | ▲    |      |      |
| 312.0300.06                                                             | 3,0 | 0,6 | 0,25           | 03            |     |      | ▲    |     | ▲   |      |      |      | ▲    |      |      |
| 312.0300.08                                                             | 3,0 | 0,8 | 0,25           | 03            |     |      | ▲    |     | Δ   |      |      |      | ▲    |      | Δ    |
| 312.0400.02                                                             | 4,0 | 0,2 | 0,25           | 04            |     |      | ▲    | ▲   | ▲   |      |      |      | ▲    |      |      |
| 312.0400.08                                                             | 4,0 | 0,8 | 0,25           | 04            |     |      | ▲    |     | Δ   |      |      |      | ▲    |      |      |
| 312.0400.12                                                             | 4,0 | 1,2 | 0,25           | 04            |     |      | Δ    |     | Δ   |      |      |      |      |      |      |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |     |                |               | P   | •    | •    | •   | •   | •    | •    | •    | •    | •    | •    |
| • empfohlen / recommended                                               |     |     |                |               | M   | o    | -    | o   | o   | -    | •    | -    | •    | -    | •    |
| o bedingt einsetzbar / alternative recommendation                       |     |     |                |               | K   | •    | -    | -   | -   | -    | •    | -    | -    | •    | -    |
| - nicht geeignet / not suitable                                         |     |     |                |               | N   | •    | -    | -   | -   | -    | •    | -    | -    | •    | -    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |     |                |               | S   | o    | -    | -   | -   | -    | •    | -    | -    | •    | -    |
| beschichtete HM-Sorten / coated grades                                  |     |     |                |               | H   | -    | -    | -   | -   | -    | -    | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |     |                |               |     |      |      |     |     |      |      |      |      |      |      |

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

HM-Sorten  
Carbide grades

# Einstecken und Längsdrehen

Grooving and Side Turning



## Wendeschneidplatte

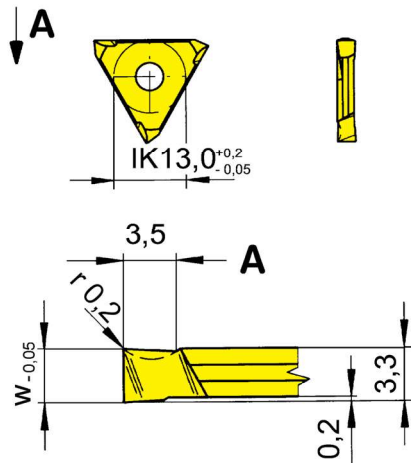
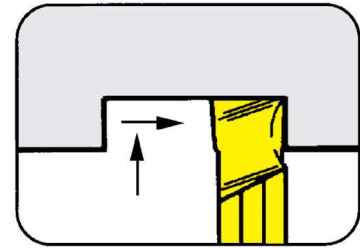
Indexable insert

# 312

Schnitttiefe bis

Depth of cut up to

3,5 mm



L = links wie gezeichnet  
L = left hand version shown

R = rechts spiegelbildlich  
R = right hand version

für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number                      | w                    | Größe<br>Size                | EG52 | P20 | TC92 | TN32 |
|---------------------------------------------------|----------------------|------------------------------|------|-----|------|------|
| <b>R/L312.3031.33</b>                             | 3,29                 | 03                           | ▲/▲  | ▲/▲ | ▲/▲  | ▲/▲  |
| ▲ ab Lager / on stock                             | Δ 4 Wochen / 4 weeks | x auf Anfrage / upon request | P    | •   | •    | •    |
| ● empfohlen / recommended                         |                      |                              | M    | o   | -    | -    |
| o bedingt einsetzbar / alternative recommendation |                      |                              | K    | -   | -    | -    |
| - nicht geeignet / not suitable                   |                      |                              | N    | -   | -    | -    |
| unbeschichtete HM-Sorten / uncoated grades        |                      |                              | S    | -   | -    | -    |
| beschichtete HM-Sorten / coated grades            |                      |                              | H    | -   | -    | -    |
| bestückt/Cermet / brazed/Cermet                   |                      |                              |      |     |      |      |

Abmessungen in mm  
Dimensions in mm

Ausführung R oder L angeben  
State R or L version

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.  
Indexable inserts can be used in right and left hand toolholders.

Die besondere Schneidengeometrie erlaubt unter Beibehaltung einer geraden und rechtwinkligen Hauptschneide sowohl in radialer als auch in axialer Richtung positive Spanwinkel.

The special cutting geometry permits a positive chip breaking angle when keeping a straight and right angled cutting edge.

HM-Sorten  
Carbide grades

# Eckenfreistechen (außen)

## Grooving Corner Reliefs (external)



O

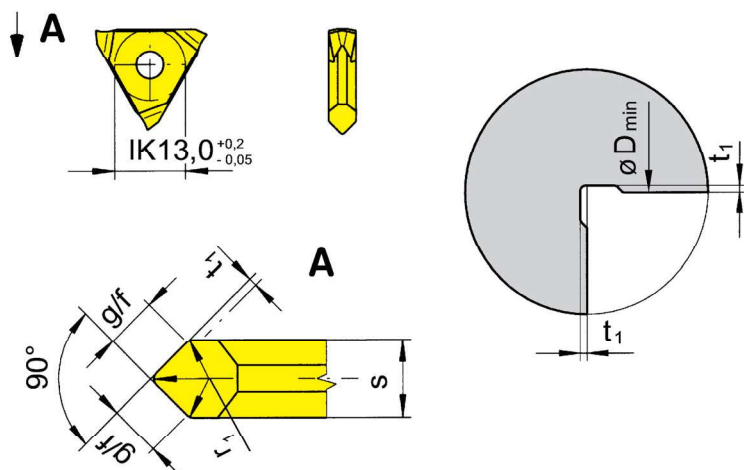
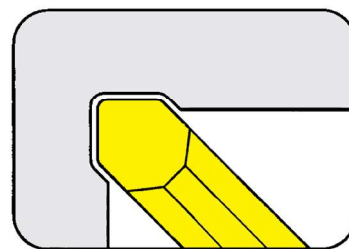
### Wendeschnidplatte

Indexable insert

# 312

mit runder Spanleitstufe  
with round chip breaker

Eckenfreistriche ähnlich DIN 509 Form „F“  
Corner reliefs similar to DIN 509 form „F“



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge ± 0,02 mm  
Indexability length ± 0,02 mm

| Bestellnummer<br>Part number                                                | D <sub>min</sub> | t <sub>1</sub> | s   | g/f | r <sub>1</sub> | Größe<br>Size |   | AS62 | EG52 | P20 | TC92 |
|-----------------------------------------------------------------------------|------------------|----------------|-----|-----|----------------|---------------|---|------|------|-----|------|
| 312.0602.24                                                                 | 19               | 0,2            | 2,4 | 1,7 | 0,6            | 02            |   | ▲    | ▲    | ▲   | ▲    |
| 312.0603.33                                                                 | 23               | 0,3            | 3,3 | 2,3 | 0,6            | 03            |   |      | ▲    | ▲   |      |
| 312.1002.30                                                                 | 20               | 0,2            | 3,0 | 2,1 | 1,0            | 03            |   |      | Δ    | ▲   |      |
| 312.1004.50                                                                 | 29               | 0,4            | 5,0 | 3,6 | 1,0            | 04            |   |      | ▲    | ▲   |      |
| 312.1603.50                                                                 | 25               | 0,3            | 5,0 | 3,6 | 1,6            | 04            |   |      | Δ    | Δ   |      |
| ▲ ab Lager / on stock   Δ 4 Wochen / 4 weeks   x auf Anfrage / upon request |                  |                |     |     |                |               | P | •    | •    | •   | •    |
| ● empfohlen / recommended                                                   |                  |                |     |     |                |               | M | -    | o    | -   | -    |
| o bedingt einsetzbar / alternative recommendation                           |                  |                |     |     |                |               | K | -    | -    | -   | -    |
| - nicht geeignet / not suitable                                             |                  |                |     |     |                |               | N | -    | -    | -   | -    |
| ■ unbeschichtete HM-Sorten / uncoated grades                                |                  |                |     |     |                |               | S | -    | -    | -   | -    |
| ■ beschichtete HM-Sorten / coated grades                                    |                  |                |     |     |                |               | H | -    | -    | -   | -    |
| ■ bestückt/Cermet / brazed/Cermet                                           |                  |                |     |     |                |               |   |      |      |     |      |

HM-Sorten  
Carbide grades

Abmessungen in mm  
Dimensions in mm

Wendeschnidplatten sind in rechten und linken Klemmhaltern verwendbar.  
Indexable inserts can be used in right and left hand toolholders.

# Eckenfreistechen (außen)

## Grooving Corner Reliefs (external)



### Wendeschneidplatte

Indexable insert

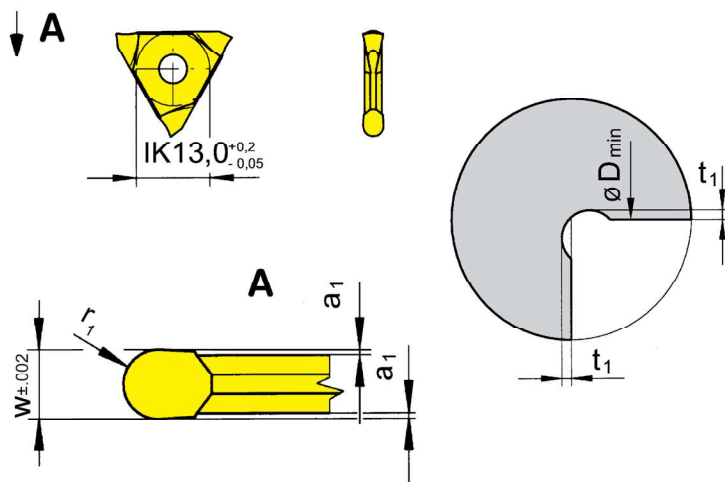
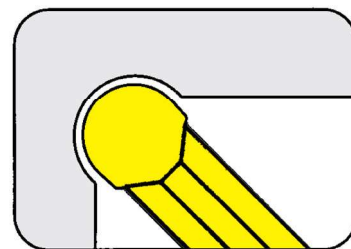
# 312

mit runder Spanleitstufe  
with round chip breaker

Vollradius

Full radius

1-2,5 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number                                                                                                                                                                                                                                                                                                | w | a <sub>1</sub> | r <sub>1</sub> | D <sub>min</sub> | t <sub>1</sub> | Größe<br>Size | K10 | EG52 | P20 | TC92 | TF45 | TN32 | TN35 |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---|----------------|----------------|------------------|----------------|---------------|-----|------|-----|------|------|------|------|
| 312.0010.20                                                                                                                                                                                                                                                                                                                 | 2 | 0,2            | 1,0            | 22               | 0,7            | 02            | ▲   | ▲    | ▲   | ▲    | Δ    | ▲    | ▲    |
| 312.0015.30                                                                                                                                                                                                                                                                                                                 | 3 | 0,2            | 1,5            | 27               | 1,0            | 02            | ▲   | ▲    | ▲   | ▲    |      | ▲    |      |
| 312.0020.40                                                                                                                                                                                                                                                                                                                 | 4 | 0,2            | 2,0            | 30               | 1,2            | 04            | ▲   | ▲    | ▲   | ▲    |      | ▲    |      |
| 312.0025.50                                                                                                                                                                                                                                                                                                                 | 5 | 0,2            | 2,5            | 35               | 1,5            | 04            | Δ   | ▲    | ▲   | Δ    |      | ▲    |      |
| ▲ ab Lager / on stock   Δ 4 Wochen / 4 weeks   x auf Anfrage / upon request<br>● empfohlen / recommended<br>o bedingt einsetzbar / alternative recommendation<br>- nicht geeignet / not suitable<br>unbeschichtete HM-Sorten / uncoated grades<br>beschichtete HM-Sorten / coated grades<br>bestückt/Cermet / brazed/Cermet |   |                |                |                  |                |               | P   | •    | •   | •    | •    | •    | •    |
|                                                                                                                                                                                                                                                                                                                             |   |                |                |                  |                |               | M   | o    | o   | -    | -    | •    | •    |
|                                                                                                                                                                                                                                                                                                                             |   |                |                |                  |                |               | K   | •    | -   | -    | -    | •    | •    |
|                                                                                                                                                                                                                                                                                                                             |   |                |                |                  |                |               | N   | •    | -   | -    | -    | •    | •    |
|                                                                                                                                                                                                                                                                                                                             |   |                |                |                  |                |               | S   | o    | -   | -    | -    | •    | •    |
|                                                                                                                                                                                                                                                                                                                             |   |                |                |                  |                |               | H   | -    | -   | -    | -    | -    | -    |

HM-Sorten  
Carbide grades

Abmessungen in mm

Dimensions in mm

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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

# Einstecken/Profildrehen (Vollradius)

Grooving and Profiling (Full radius)

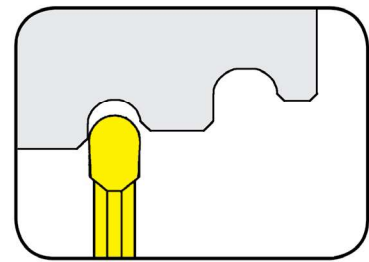


## Wendeschneidplatte

Indexable insert

# 312

mit runder Spanleitstufe  
with round chip breaker

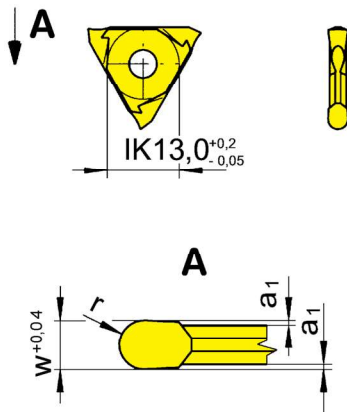


O

Stechtiefe bis  
Vollradius

Depth of groove up to  
Full radius

6 mm  
0,25-2 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge ± 0,02 mm  
Indexability length ± 0,02 mm

| Bestellnummer<br>Part number | w   | a <sub>1</sub> | r    | Größe<br>Size | AS45 | EG35 | EG55 | P20 | TF45 | TH35 | TI25 | TN32 | TN35 |
|------------------------------|-----|----------------|------|---------------|------|------|------|-----|------|------|------|------|------|
| 312.0050.02                  | 0,5 | 0,07           | 0,25 | 01            | ▲    | ▲    |      | ▲   |      |      |      | ▲    |      |
| 312.0100.05                  | 1,0 | 0,09           | 0,50 | 01            | ▲    | ▲    |      | ▲   |      | Δ    |      | ▲    | Δ    |
| 312.0110.05                  | 1,1 | 0,09           | 0,55 | 01            | ▲    |      | Δ    |     |      |      |      |      |      |
| 312.0120.06                  | 1,2 | 0,20           | 0,60 | 01            | ▲    |      | ▲    | ▲   |      |      |      | ▲    |      |
| 312.0140.07                  | 1,4 | 0,20           | 0,70 | 01            | ▲    |      | ▲    | ▲   |      |      |      |      |      |
| 312.0160.08                  | 1,6 | 0,25           | 0,80 | 01            | ▲    |      | ▲    | ▲   |      |      |      | ▲    |      |
| 312.0180.09                  | 1,8 | 0,25           | 0,90 | 01            | ▲    |      | ▲    | ▲   |      |      |      |      |      |
| 312.0200.10                  | 2,0 | 0,25           | 1,00 | 01            | ▲    |      | ▲    | ▲   | Δ    |      | Δ    | ▲    |      |
| 312.0220.11                  | 2,2 | 0,25           | 1,10 | 02            | ▲    |      | ▲    | ▲   |      |      |      |      |      |
| 312.0250.12                  | 2,5 | 0,25           | 1,25 | 02            | ▲    |      | Δ    | ▲   |      |      |      | ▲    |      |
| 312.0280.14                  | 2,8 | 0,25           | 1,40 | 02            | ▲    |      | Δ    |     |      |      |      |      |      |
| 312.0300.15                  | 3,0 | 0,25           | 1,50 | 02            | ▲    |      | ▲    | ▲   |      |      |      | ▲    |      |
| 312.0360.18                  | 3,6 | 0,25           | 1,80 | 03            | ▲    |      | Δ    |     |      |      |      |      |      |
| 312.0400.20                  | 4,0 | 0,25           | 2,00 | 03            | ▲    |      | Δ    | ▲   |      |      |      | ▲    |      |
|                              |     |                |      |               | P    | •    | •    | •   | •    | •    | •    | •    | •    |
|                              |     |                |      |               | M    | •    | •    | ○   | -    | •    | •    | -    | •    |
|                              |     |                |      |               | K    | •    | ○    | ○   | -    | •    | •    | -    | •    |
|                              |     |                |      |               | N    | ○    | -    | -   | -    | •    | •    | -    | •    |
|                              |     |                |      |               | S    | •    | -    | -   | -    | •    | •    | -    | •    |
|                              |     |                |      |               | H    | -    | -    | -   | -    | -    | -    | -    | -    |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

• empfohlen / recommended

○ bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Weitere Radien auf Anfrage

Further radii upon request

Abmessungen in mm

Dimensions in mm

HM-Sorten

Carbide grades

### Bearbeitungshinweis:

Nutbreiten bis 1,6 mm nur zum Nutenstechdrehen empfohlen

Note:

Width of groove up to 1,6 mm recommend only for grooving

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

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



# Einstecken (außen)

Grooving (external)



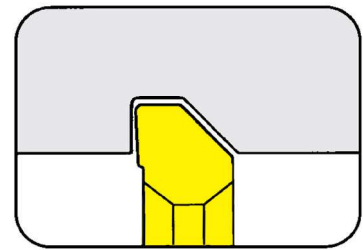
## Wendeschneidplatte

Indexable insert

# 312

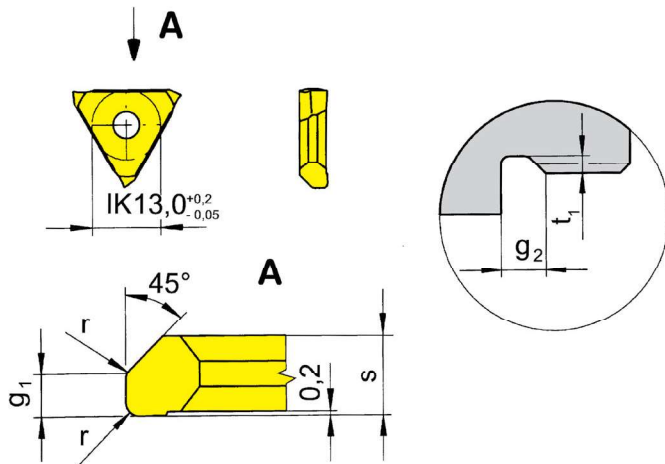
mit runder Spanleitstufe  
with round chip breaker

Gewindefreistiche DIN 76 „Kurzausführung“  
Thread relief DIN 76 „Short form“



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | P    | r   | $t_1$ | s   | $g_1$ | $g_2$ | Größe<br>Size | EG55 | P20 | TN35 |
|------------------------------|------|-----|-------|-----|-------|-------|---------------|------|-----|------|
| R/L312.1050.17               | 0,50 | 0,2 | 0,40  | 1,7 | 0,60  | 1,0   | 01            | ▲/Δ  | Δ/Δ | ▲/Δ  |
| R/L312.1060.17               | 0,60 | 0,4 | 0,50  | 1,7 | 0,70  | 1,2   | 01            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.1070.17               | 0,70 | 0,4 | 0,55  | 1,7 | 0,85  | 1,4   | 01            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.1080.27               | 0,80 | 0,4 | 0,65  | 2,7 | 0,95  | 1,6   | 02            | ▲/Δ  | Δ/Δ | ▲/▲  |
| R/L312.1100.27               | 1,00 | 0,6 | 0,80  | 2,7 | 1,20  | 2,0   | 02            | ▲/Δ  | Δ/Δ | ▲/Δ  |
| R/L312.1125.27               | 1,25 | 0,6 | 1,00  | 2,7 | 1,50  | 2,5   | 02            | ▲/Δ  | Δ/Δ | ▲/▲  |
| R/L312.1150.37               | 1,50 | 0,8 | 1,15  | 3,7 | 1,85  | 3,0   | 03            | ▲/Δ  | Δ/Δ | ▲/Δ  |
| R/L312.1175.37               | 1,75 | 1,0 | 1,30  | 3,7 | 2,20  | 3,5   | 03            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.1200.53               | 2,00 | 1,0 | 1,50  | 5,3 | 2,50  | 4,0   | 04            | Δ/Δ  | ▲/Δ | Δ/Δ  |
| R/L312.1250.53               | 2,50 | 1,2 | 1,80  | 5,3 | 3,20  | 5,0   | 04            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.1300.63               | 3,00 | 1,6 | 2,20  | 6,3 | 3,80  | 6,0   | 04            | Δ/Δ  | Δ/Δ | Δ/Δ  |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Rechte WSP in rechten, linke WSP in linken Klemmhaltern verwenden.

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

| P | • | • | • |
|---|---|---|---|
| M | o | - | • |
| K | o | - | • |
| N | - | - | • |
| S | - | - | • |
| H | - | - | - |

HM-Sorten  
Carbide grades

# Einstecken (außen)

Grooving (external)



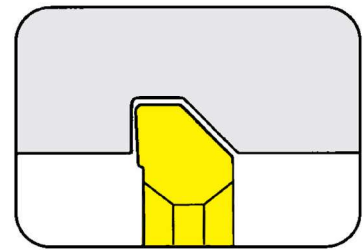
## Wendeschneidplatte

Indexable insert

# 312

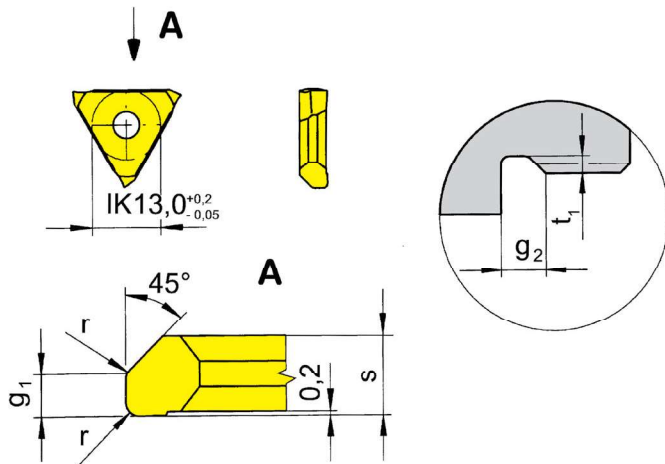
mit runder Spanleitstufe  
with round chip breaker

Gewindefreistiche DIN 76 „Regelausführung“  
Thread relief DIN 76 „Standard form“



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | P    | r   | t <sub>1</sub> | s   | g <sub>1</sub> | g <sub>2</sub> | Größe<br>Size | EG55 | P20 | TN35 |
|------------------------------|------|-----|----------------|-----|----------------|----------------|---------------|------|-----|------|
| R/L312.3050.17               | 0,50 | 0,2 | 0,40           | 1,7 | 1,10           | 1,5            | 01            | Δ/Δ  | x/Δ | Δ/Δ  |
| R/L312.3060.27               | 0,60 | 0,4 | 0,50           | 2,7 | 1,30           | 1,8            | 02            | ▲/▲  | Δ/Δ | ▲/Δ  |
| R/L312.3070.27               | 0,70 | 0,4 | 0,55           | 2,7 | 1,55           | 2,1            | 02            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.3080.27               | 0,80 | 0,4 | 0,65           | 2,7 | 1,75           | 2,4            | 02            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.3100.37               | 1,00 | 0,6 | 0,80           | 3,7 | 2,20           | 3,0            | 03            | ▲/Δ  | Δ/Δ | ▲/Δ  |
| R/L312.3125.53               | 1,25 | 0,6 | 1,00           | 5,3 | 2,80           | 3,8            | 04            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.3150.53               | 1,50 | 0,8 | 1,15           | 5,3 | 3,35           | 4,5            | 04            | ▲/Δ  | Δ/Δ | ▲/Δ  |
| R/L312.3175.56               | 1,75 | 1,0 | 1,30           | 5,6 | 4,00           | 5,3            | 04            | Δ/Δ  | Δ/Δ | Δ/Δ  |
| R/L312.3200.63               | 2,00 | 1,0 | 1,50           | 6,3 | 4,50           | 6,0            | 04            | Δ/Δ  | Δ/Δ | Δ/Δ  |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

Rechte WSP in rechten, linke WSP in linken Klemmhaltern verwenden.

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

| P | • | • | • |
|---|---|---|---|
| M | o | - | • |
| K | o | - | • |
| N | - | - | • |
| S | - | - | • |
| H | - | - | - |

HM-Sorten  
Carbide grades

# Einstecken (außen)

Grooving (external)



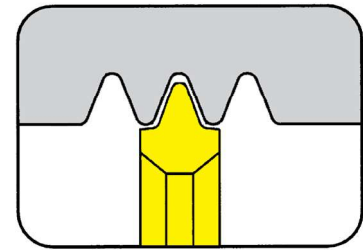
O

## Wendeschneidplatte

Indexable insert

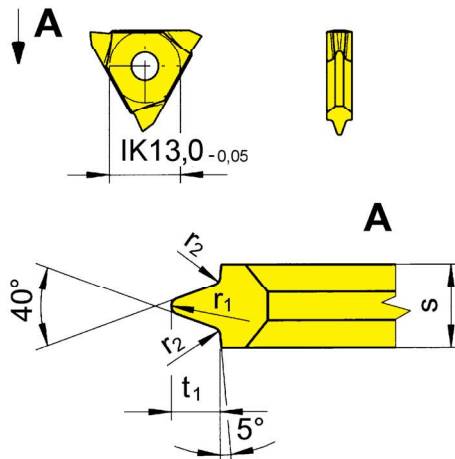
# 312

Poly-V-Riemennuten Profil „J“  
Poly-V-belt grooves profile „J“



für Klemmhalter  
for Toolholder

Typ ...23 = 340  
Type ...30 = 360/369



Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

| Bestellnummer<br>Part number | $r_2$ | $t_1$ | s    | $r_1$ | Größe<br>Size | EG52 | P20 | TN32 |
|------------------------------|-------|-------|------|-------|---------------|------|-----|------|
| 312.0223.23                  | 0,2   | 2,3   | 2,34 | 0,25  | 02            | ▲    | ▲   | ▲    |
| 312.0223.30                  | 0,2   | 2,3   | 3,00 | 0,25  | 03            | ▲    | ▲   | ▲    |
|                              |       |       |      |       |               | P    | •   | •    |
|                              |       |       |      |       |               | M    | o   | -    |
|                              |       |       |      |       |               | K    | -   | -    |
|                              |       |       |      |       |               | N    | -   | -    |
|                              |       |       |      |       |               | S    | -   | -    |
|                              |       |       |      |       |               | H    | -   | -    |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

WSP 312.0223.23 für Paket-Bestückung WSP 312.0223.30 für Einzel-Bestückung

Insert 312.0223.23 for multi grooving Insert 312.0223.30 for single grooving

Wendeschneidplatten sind in rechten und linken Klemmhaltern verwendbar.

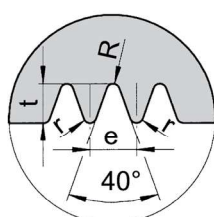
Indexable inserts can be used in right and left hand toolholders.

**Nutform:**

Poly-V-Riemennut Profil „J“

**Shape of groove:**

Poly-V-belt grooves profile „J“



| e           | t    | R    | r    |
|-------------|------|------|------|
| $\pm 0,025$ | max  | min  | max  |
| 2,34        | 2,34 | 2,08 | 0,38 |
|             |      | 0,25 | 0,2  |

HM-Sorten  
Carbide grades

# Einstechen und Abstechen

Grooving and Parting Off

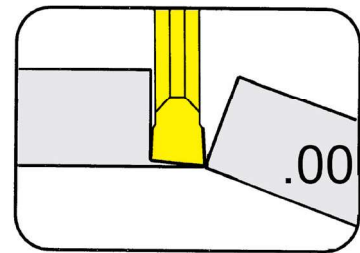


## Wendeschneidplatte

Indexable insert

# 312

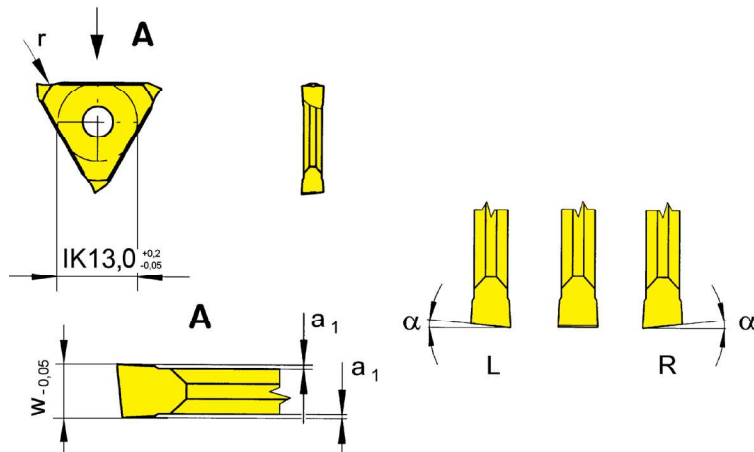
mit runder Spanleitstufe  
with round chip breaker



Stechtiefe bis  
Stechbreite

Depth of groove up to  
Width of groove

5,00 mm  
1,44 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number                                                | w    | $\alpha$ | $a_1$ | Größe<br>Size | EG35 | TF45 | TF46 | TI25 | TN35 |
|-----------------------------------------------------------------------------|------|----------|-------|---------------|------|------|------|------|------|
| <b>R/L312.0614.00</b>                                                       | 1,44 | 6°       | 0,2   | 01            | ▲/▲  | ▲/▲  | ▲/▲  | ▲/▲  | ▲/▲  |
| ▲ ab Lager / on stock   Δ 4 Wochen / 4 weeks   x auf Anfrage / upon request |      |          |       |               | P    | •    | •    | •    | •    |
| ● empfohlen / recommended                                                   |      |          |       |               | M    | •    | •    | •    | •    |
| o bedingt einsetzbar / alternative recommendation                           |      |          |       |               | K    | o    | •    | •    | •    |
| - nicht geeignet / not suitable                                             |      |          |       |               | N    | -    | •    | •    | •    |
| unbeschichtete HM-Sorten / uncoated grades                                  |      |          |       |               | S    | -    | •    | •    | •    |
| beschichtete HM-Sorten / coated grades                                      |      |          |       |               | H    | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                             |      |          |       |               |      |      |      |      |      |

Abmessungen in mm  
Dimensions in mm

Ausführung R oder L angeben  
State R or L version

HM-Sorten  
Carbide grades

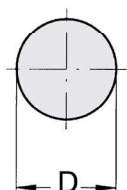
### Außenbearbeitung:

für Klemmhalter Typ 360 rechte WSP in linken, linke WSP in rechten Klemmhaltern verwenden.

### External machining:

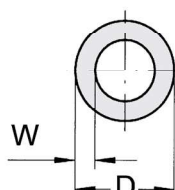
for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

Abstechen von Wellen  
parting off solid bars



D bis 11 mm  
D up to 11 mm

Abstechen von Ringen  
parting off tubes



$D \geq 50$  mm bis  $W \approx 5$  mm  
 $D \leq 50$  mm bis  $W \approx 4$  mm  
 $D \geq 50$  mm up to  $W \approx 5$  mm  
 $D \leq 50$  mm up to  $W \approx 4$  mm

# Abstechen

Parting Off

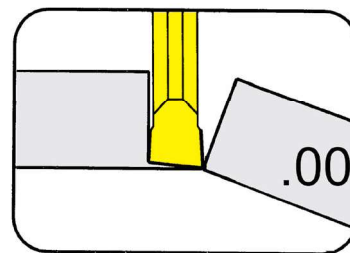


## Wendeschneidplatte

Indexable insert

# 312

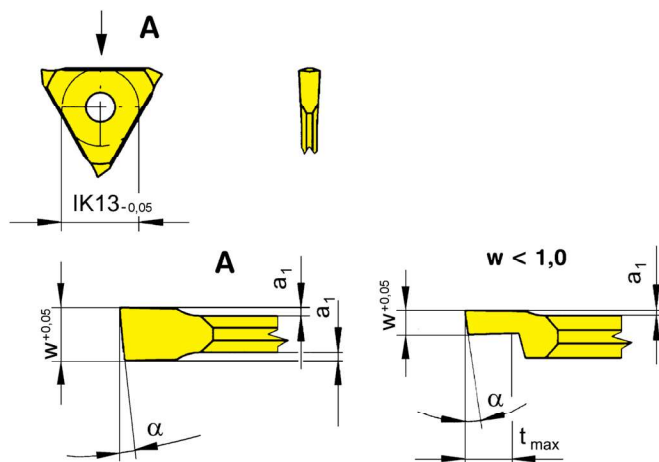
mit runder Spanleitstufe  
with round chip breaker



Stechtiefe bis  
Stechbreite

Depth of groove up to  
Width of groove

8 mm  
0,5-1,5 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
368  
390  
391  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number                                            | w   | t <sub>max</sub> | α   | a <sub>1</sub> | Größe<br>Size | K10 | EG35 | EG55 | H20 | P20 | TC92 | TF45 | TF46 | TI25 | TN32 | TN35 |
|-------------------------------------------------------------------------|-----|------------------|-----|----------------|---------------|-----|------|------|-----|-----|------|------|------|------|------|------|
| R/L312.0805.00                                                          | 0,5 | 1,0              | 8°  | 0,1            | 01            |     | ▲/▲  |      |     |     |      | ▲/▲  |      |      |      |      |
| R/L312.0808.00                                                          | 0,8 | 1,5              | 8°  | 0,1            | 01            |     | ▲/▲  |      |     |     |      | ▲/▲  |      |      |      |      |
| R/L312.0510.00                                                          | 1,0 | 8,0              | 5°  | 0,1            | 01            |     | ▲/▲  |      |     |     |      | ▲/▲  |      |      |      |      |
| R/L312.1210.00                                                          | 1,0 | 8,0              | 12° | 0,1            | 01            |     | ▲/▲  |      |     |     |      | ▲/▲  |      | Δ/Δ  |      | ▲/▲  |
| R/L312.0512.00                                                          | 1,2 | 8,0              | 5°  | 0,2            | 01            |     | ▲/▲  |      |     |     |      | ▲/▲  |      |      |      |      |
| R/L312.0515.00                                                          | 1,5 | 8,0              | 5°  | 0,2            | 01            | ▲/x | ▲/▲  | ▲/x  | ▲/x | ▲/x | Δ/x  | ▲/▲  | ▲/x  |      | ▲/x  |      |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |                  |     |                |               | P   | •    | •    | •   | •   | •    | •    | •    | •    | •    | •    |
| ● empfohlen / recommended                                               |     |                  |     |                |               | M   | ○    | •    | ○   | ○   | -    | •    | ○    | •    | -    | •    |
| ○ bedingt einsetzbar / alternative recommendation                       |     |                  |     |                |               | K   | •    | ○    | ○   | -   | -    | •    | •    | •    | -    | •    |
| - nicht geeignet / not suitable                                         |     |                  |     |                |               | N   | •    | -    | -   | -   | -    | •    | •    | •    | -    | •    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |                  |     |                |               | S   | ○    | -    | -   | -   | -    | •    | ○    | •    | -    | •    |
| beschichtete HM-Sorten / coated grades                                  |     |                  |     |                |               | H   | -    | -    | -   | -   | -    | -    | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |                  |     |                |               |     |      |      |     |     |      |      |      |      |      |      |

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

HM-Sorten  
Carbide grades

# Abstechen

## Parting Off

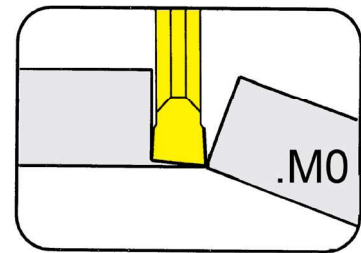


### Wendeschneidplatte

#### Indexable insert

# 312

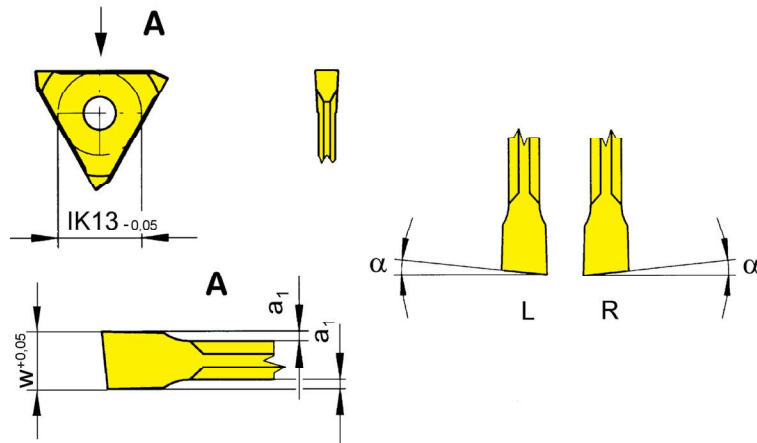
|                               |                                          |                    |
|-------------------------------|------------------------------------------|--------------------|
| Stechtiefe bis<br>Stechbreite | Depth of groove up to<br>Width of groove | 8 mm<br>1,2-1,5 mm |
|-------------------------------|------------------------------------------|--------------------|



O

für Klemmhalter  
for Toolholder

|      |             |
|------|-------------|
| Typ  | 309         |
| Type | 360         |
|      | 361         |
|      | 368         |
|      | 390         |
|      | 391         |
|      | 369         |
|      | 330         |
|      | 360C        |
|      | 360TS       |
|      | 64/65/99    |
|      | N67/N68/N98 |



R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number                                            | w   | t <sub>max</sub> | α  | a <sub>1</sub> | Größe<br>Size |  | K10 | EG35 | TF45 |
|-------------------------------------------------------------------------|-----|------------------|----|----------------|---------------|--|-----|------|------|
| R/L312.0512.M0                                                          | 1,2 | 8                | 5° | 0,2            | 01            |  | Δ/Δ | ▲/▲  | ▲/▲  |
| R/L312.0515.M0                                                          | 1,5 | 8                | 5° | 0,2            | 01            |  | ▲/Δ | ▲/▲  | ▲/▲  |
| ▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request |     |                  |    |                |               |  | P   | •    | •    |
| ● empfohlen / recommended                                               |     |                  |    |                |               |  | M   | ○    | •    |
| ○ bedingt einsetzbar / alternative recommendation                       |     |                  |    |                |               |  | K   | •    | ○    |
| - nicht geeignet / not suitable                                         |     |                  |    |                |               |  | N   | •    | -    |
| unbeschichtete HM-Sorten / uncoated grades                              |     |                  |    |                |               |  | S   | ○    | •    |
| beschichtete HM-Sorten / coated grades                                  |     |                  |    |                |               |  | H   | -    | -    |
| bestückt/Cermet / brazed/Cermet                                         |     |                  |    |                |               |  |     |      |      |

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

HM-Sorten  
Carbide grades

# Einstechen und Abstechen

Grooving and Parting Off

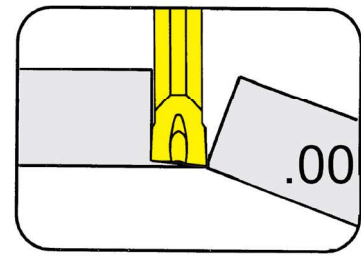


## Wendeschneidplatte

Indexable insert

# 312

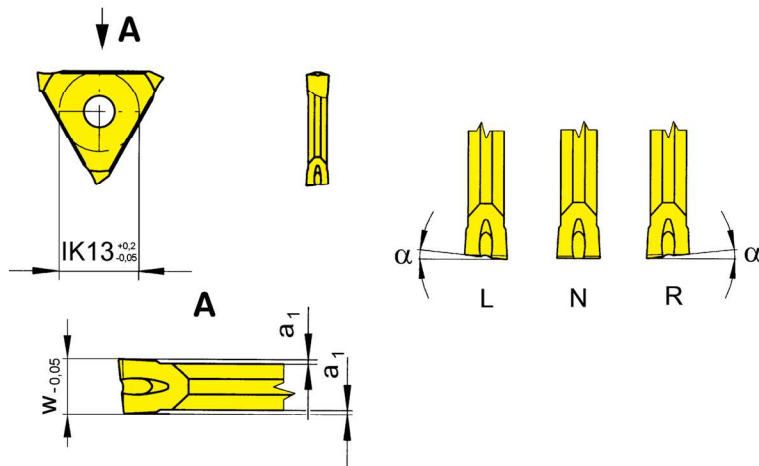
mit runder Spanleitstufe  
with round chip breaker



Stechtiefe bis  
Stechbreite

Depth of groove up to  
Width of groove

5 mm  
1,44-2,29 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
330  
360C  
360TS  
64/65/99  
N67/N68/N98

R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number                                                  | w    | $\alpha$ | $a_1$ | Größe<br>Size | MG12 | EG55 | P20 | TC92 | TF45 | TN32 | TN35 |
|-------------------------------------------------------------------------------|------|----------|-------|---------------|------|------|-----|------|------|------|------|
| N312.0014.00                                                                  | 1,44 | 0°       | 0,2   | 01/02         |      | ▲    |     | ▲    | ▲    |      |      |
| N312.0018.00                                                                  | 1,99 | 0°       | 0,2   | 02            |      | ▲    |     | ▲    | ▲    | ▲    | ▲    |
| N312.0021.00                                                                  | 2,29 | 0°       | 0,2   | 02            |      | ▲    | ▲   | ▲    |      |      | ▲    |
| R/L312.0514.00                                                                | 1,44 | 5°       | 0,2   | 01/02         |      | ▲/▲  | ▲/▲ |      | ▲/▲  |      |      |
| R/L312.0518.00                                                                | 1,99 | 5°       | 0,2   | 02            |      | ▲/▲  | ▲/▲ | ▲/▲  |      | ▲/▲  | ▲/▲  |
| R/L312.0521.00                                                                | 2,29 | 5°       | 0,2   | 02            | ▲/▲  | ▲/▲  | ▲/▲ | ▲/▲  |      | ▲/▲  | ▲/▲  |
| ▲ ab Lager / on stock    Δ 4 Wochen / 4 weeks    x auf Anfrage / upon request |      |          |       |               | P    | o    | •   | •    | •    | •    | •    |
| • empfohlen / recommended                                                     |      |          |       |               | M    | -    | o   | -    | •    | -    | •    |
| o bedingt einsetzbar / alternative recommendation                             |      |          |       |               | K    | -    | o   | -    | •    | -    | •    |
| - nicht geeignet / not suitable                                               |      |          |       |               | N    | -    | -   | -    | •    | -    | •    |
| unbeschichtete HM-Sorten / uncoated grades                                    |      |          |       |               | S    | -    | -   | -    | •    | -    | •    |
| beschichtete HM-Sorten / coated grades                                        |      |          |       |               | H    | -    | -   | -    | -    | -    | -    |
| bestückt/Cermet / brazed/Cermet                                               |      |          |       |               |      |      |     |      |      |      |      |

Abmessungen in mm  
Dimensions in mm

Ausführung R oder L angeben  
State R or L version

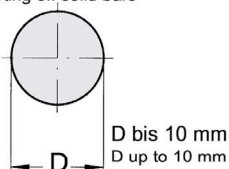
### Außenbearbeitung:

für Klemmhalter Typ 360 rechte WSP in linken, linke WSP in rechten Klemmhaltern verwenden.

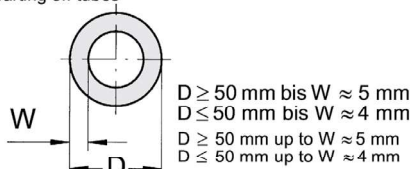
### External machining:

for Toolholder type 360 use right hand inserts in left hand toolholders and left hand inserts in right hand toolholders

Abstechen von Wellen  
parting off solid bars



Abstechen von Rohren  
parting off tubes



$D \geq 50$  mm bis  $W \approx 5$  mm  
 $D \leq 50$  mm bis  $W \approx 4$  mm  
 $D \geq 50$  mm up to  $W \approx 5$  mm  
 $D \leq 50$  mm up to  $W \approx 4$  mm

HM-Sorten  
Carbide grades

# Axialeinstechen

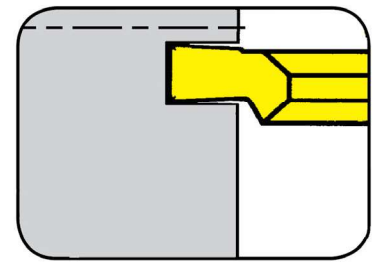
## Face Grooving



### Wendeschneidplatte

#### Indexable insert

# 312

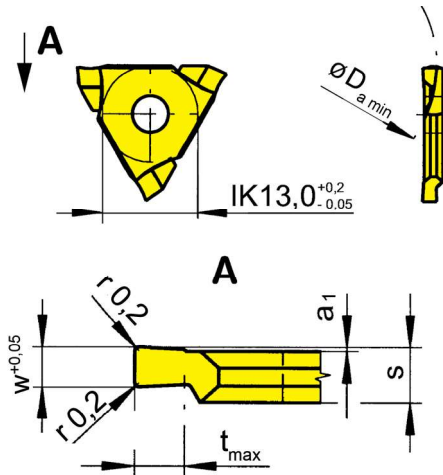


O

Nutaußen-Ø ab  
Stechtiefe bis  
Stechbreite

from outer groove Ø  
Depth of groove up to  
Width of groove

20 mm  
3 mm  
1,5-3 mm



für Klemmhalter  
for Toolholder

Typ 309  
Type 360  
361  
390  
369  
360C  
360TS  
64/65/99  
N67/N68/N98

Wechselgenauigkeit  
Länge  $\pm 0,02$  mm  
Indexability length  $\pm 0,02$  mm

R = rechts wie gezeichnet  
R = right hand version shown

L = links spiegelbildlich  
L = left hand version

| Bestellnummer<br>Part number | w   | t <sub>max</sub> | a <sub>1</sub> | s   | D <sub>a min</sub> | Größe<br>Size | MG12 | EG55 | TN35 |
|------------------------------|-----|------------------|----------------|-----|--------------------|---------------|------|------|------|
| R/L312.2015.02               | 1,5 | 2,0              | 0,2            | 2,7 | 20                 | 02            |      | ▲/▲  | ▲/▲  |
| R/L312.3020.02               | 2,0 | 3,0              | 0,2            | 2,7 | 30                 | 02            | x/Δ  | ▲/▲  | ▲/▲  |
| R/L312.3030.02               | 3,0 | 3,0              | 0,2            | 3,7 | 30                 | 03            |      | ▲/▲  | ▲/▲  |
| R/L312.3040.02               | 4,0 | 3,5              | 0,2            | 4,3 | 30                 | 04            |      | Δ/Δ  |      |
| R/L312.3050.02               | 5,0 | 3,5              | 0,2            | 5,3 | 30                 | 05            |      | Δ/Δ  |      |

▲ ab Lager / on stock Δ 4 Wochen / 4 weeks x auf Anfrage / upon request

● empfohlen / recommended

o bedingt einsetzbar / alternative recommendation

- nicht geeignet / not suitable

unbeschichtete HM-Sorten / uncoated grades

beschichtete HM-Sorten / coated grades

bestückt/Cermet / brazed/Cermet

Abmessungen in mm

Dimensions in mm

Ausführung R oder L angeben

State R or L version

**Hinweis für Klemmhalter Typ 360**

Rechte WSP in linken, linke WSP in rechten Klemmhaltern verwenden.

**Note for toolholder type 360**

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

**Hinweis für Klemmhalter Typ 369**

Rechte WSP in rechten, linke WSP in linken Klemmhaltern verwenden.

**Note for toolholder type 369**

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

|   |   |   |   |
|---|---|---|---|
| P | o | • | • |
| M | - | o | • |
| K | - | o | • |
| N | - | - | • |
| S | - | - | • |
| H | - | - | - |

HM-Sorten  
Carbide grades