

HCG - HORN Catalog Guide

Bore Ø	Product line								
	105	110	108	10P	111	11P	114	116	18P
≥ .008" (0.2 mm)	•								
≥ .236" (6.0 mm)	•	•							
≥ .268" (6.8 mm)	•	•							
≥ .307" (7.8 mm)		•	•						
≥ .315" (8.0 mm)		•	•						
≥ .346" (8.8 mm)				•					
≥ .354" (9.0 mm)		•	•	•					
≥ .386" (9.8 mm)					•	•			
≥ .394" (10.0 mm)		•		•	•				
≥ .419" (10.5 mm)						•			
≥ .433" (11.0 mm)					•	•			
≥ .492" (12.5 mm)							•		
≥ .551" (14.0 mm)							•	•	
≥ .630" (16.0 mm)								•	
≥ .650" (16.5 mm)							•		
≥ .689" (17.5 mm)									•

Groove depth ≤ (inch)	.098"	.157"	.039"	.118"	.091"	.138"	.256"	.169"	.315"
Groove depth ≤ (mm)	2.5	4.0	1.0	3.0	2.3	3.5	6.5	4.3	8.0
Width of groove inch	.020"-.079"	.039"-.250"	.029"-.079"	.039"-.118"	.029"-.125"	.039"-.118"	.029"-.125"	.029"-.157"	.071"-.118"
Width of groove mm	0.5 - 2.0	1.0 - 6.35	0.74 - 2.0	1.0 - 3.0	0.74 - 3.18	1.0 - 3.0	0.74 - 3.18	0.74 - 4.0	1.8 - 3.0

Application	Product line								
	105	110	108	10P	111	11P	114	116	18P
Grooving	•	•	•	•	•	•	•	•	•
Boring	•	•	•	•	•	•	•	•	•
Threading	•		•		•		•	•	
Chamfering	•		•		•		•	•	
Face Grooving	•	•					•		
Hard turning	•		•		•		•	•	

Chapter	A	B	C	D	E	F	G	H	J
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Special tools upon request

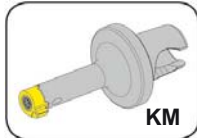
MINI CARBIDE GROOVING TOOLS

C

Toolholder
BU108 / B108

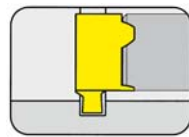


Page C2-C5

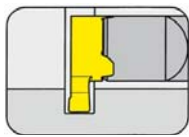


Page C6-C7

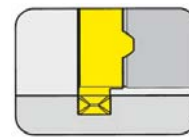
Inserts
U108 / 108 / S108
≥ Ø .315" (8.0 mm)



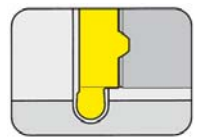
Page C8-C9



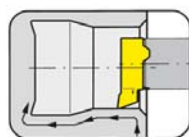
Page C10-C14



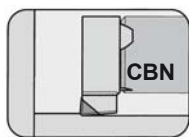
Page C15



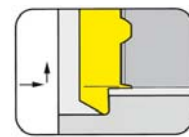
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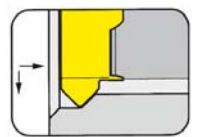
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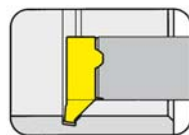
Page C21



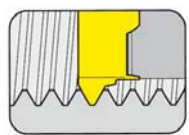
Page C23



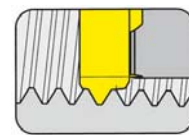
Page C24



Page C25



Page C26-C27



Page C28-C29

Technical Instructions Page L1 - L9

C

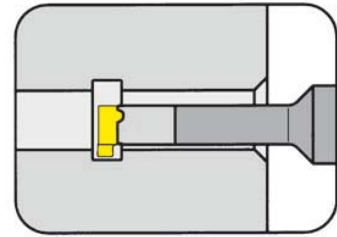
TOOLHOLDER Type

BU108

with through coolant supply

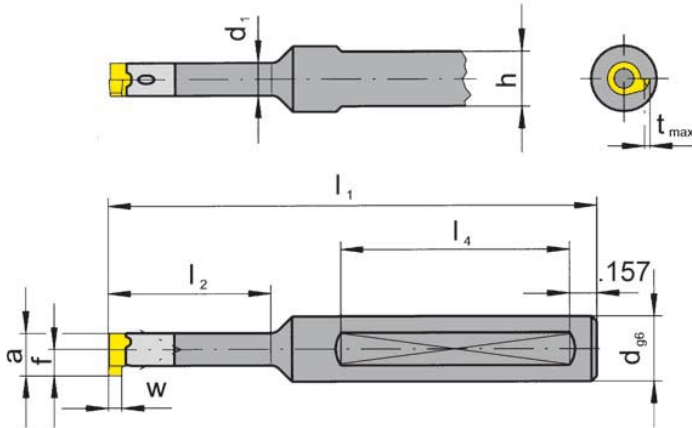
Bore Ø from	.315"
Depth of groove up to	.039"
Width of groove up to	.079"

Material of shank: Carbide - Giving a good vibration resistance



for use with Insert

Type 108
S108
U108



Picture = right hand cutting version shown

Part number	d	l ₁	l ₂	h	l ₄	d ₁	Remark
BU108.ST05.00	.500	2.756	.492	.460	1.570	.236	* Steel Toolholder
BU108.0500.01		3.150	.827				
BU108.0500.02	.500	3.543	1.181	.460	1.770	.236	
BU108.0500.03		3.937	1.654				

Further sizes upon request

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

Dimensions in inch

Ordering note:

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

* Steel toolholder is not repairable.

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
BU108....	2.6.5T8EP	T8PL

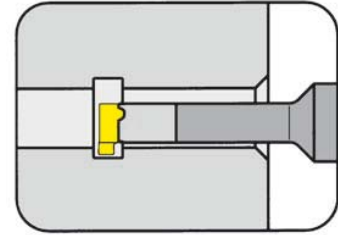
TOOLHOLDER Type

B108

with through coolant supply

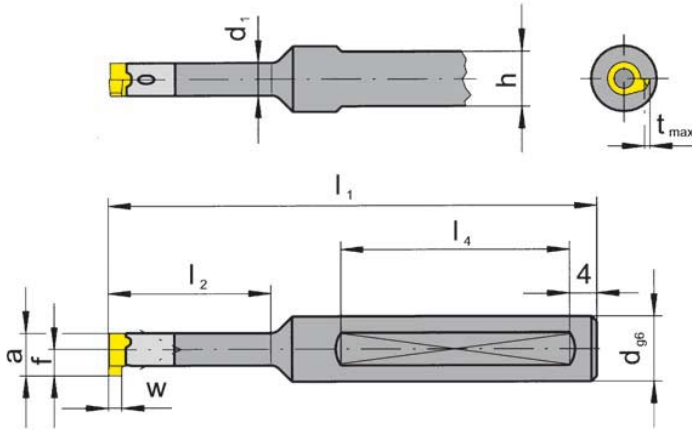
Bore Ø from	.315" (8.0 mm)
Depth of groove up to	.039" (1.0 mm)
Width of groove up to	.079" (2.0 mm)

Material of shank: Carbide - Giving a good vibration resistance



for use with Insert

Type 108
S108
U108



Picture = right hand cutting version shown

Part number	d	l ₁	l ₂	h	l ₄	d ₁
B108.0008.00	8	60	12.5	7	35	6
B108.0008.01		70	21.0		40	
B108.0012.00	12	70	12.5	11	40	6
B108.0012.01		80	21.0		45	
B108.0012.02		90	30.0		45	
B108.0012.03		100	42.0		45	

Further sizes upon request

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

Dimensions in mm

Ordering note:

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

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B108.00...	2.6.5T8EP	T8PL

C

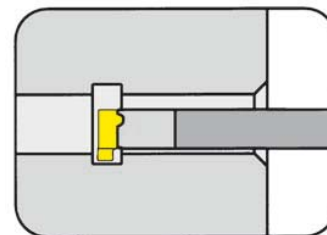
TOOLHOLDER Type

B108

with through coolant supply

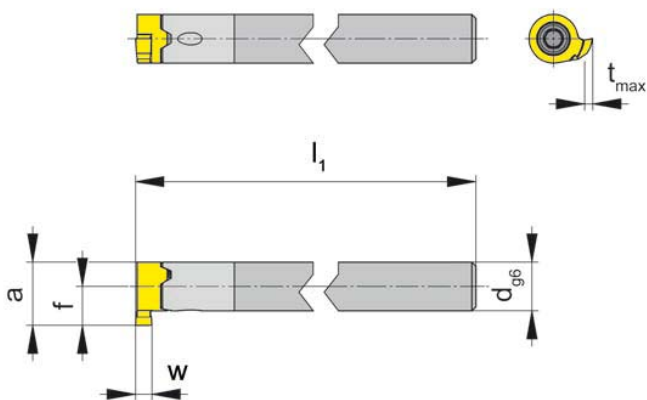
Bore Ø from	.315" (8.0 mm)
Depth of groove up to	.039" (1.0 mm)
Width of groove up to	.079" (2.0 mm)

Material of shank: Carbide - Giving a good vibration resistance



for use with Insert

Type 108
S108
U108



Picture = right hand cutting version shown

Part number	d	l ₁
B108.0006.01A	6	65

Further sizes upon request

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

Dimensions in mm

Ordering note:

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

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B108.0006.01A	2.6.5T8EP	T8PL

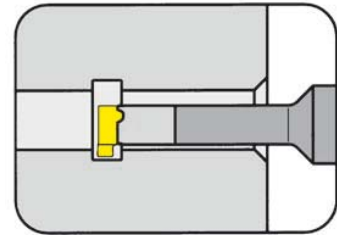
TOOLHOLDER Type

B108

with through coolant supply

Bore Ø from	.315" (8.0 mm)
Depth of groove up to	.039" (1.0 mm)
Width of groove up to	.079" (2.0 mm)

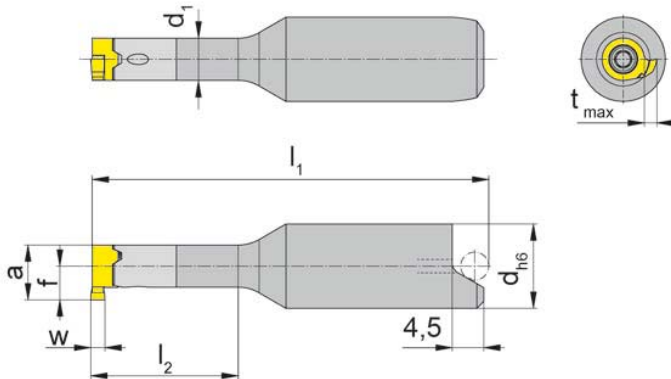
Material of shank: Carbide - Giving a good vibration resistance



C

for use with Insert

Type 108
S108
U108



Picture = right hand cutting version shown

for shrinkage location
S = orientation

Part number	d	l ₁	l ₂	d ₁
B108.0012.00S	12	48.7	12.5	6
B108.0012.01S		56.7	21.0	
B108.0012.02S		65.7	30.0	
B108.0012.03S		77.7	42.0	

Further sizes upon request

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

Dimensions in mm

Ordering note:

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



Example of assembly System „W&F“

Spare parts

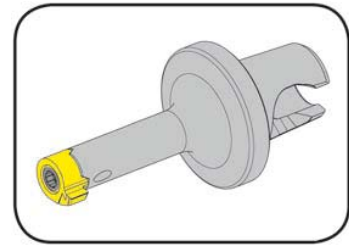
Toolholder	Screw	TORX PLUS® Wrench
B108.0012.0...	2.6.5T8EP	T8PL

C

TOOLHOLDER Type

B108KM

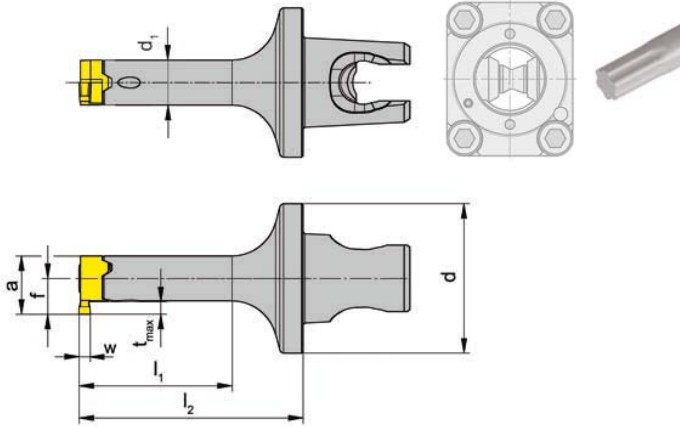
with through coolant supply



Bore Ø from .315" (8.0 mm)

for use with Insert

Type 108
S108
U108



System Kennametal
KM16 Micro

Part number	d	l ₁	l ₂	d ₁
B108.KM16.01	20	21	30	6
B108.KM16.02		26	35	

Further sizes upon request

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

Dimensions in mm

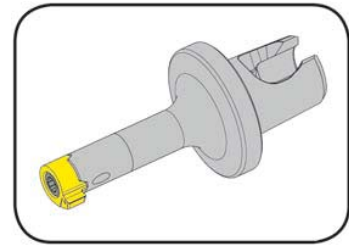
Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B108.KM16.0...	2.6.5T8EP	T8PL

TOOLHOLDER Type

B108KM

with through coolant supply

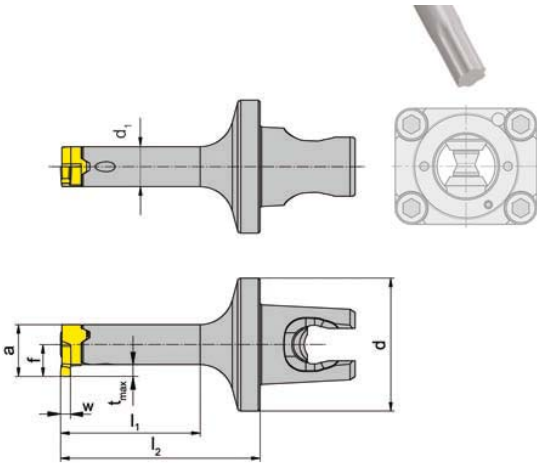


C

Bore Ø from .315" (8.0 mm)

for use with Insert

Type 108
S108
U108



System Kennametal
KM16 Micro

Part number	d	l ₁	l ₂	d ₁
B108.KM16.90.01	20	21	30	6
B108.KM16.90.02	20	26	35	6

Further sizes upon request

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

Dimensions in mm

Spare parts

Toolholder	Screw	TORX PLUS® Wrench
B108.KM16.90.0...	2.6.5T8EP	T8PL

GROOVING (internal) $\geq \text{Ø} .315''$

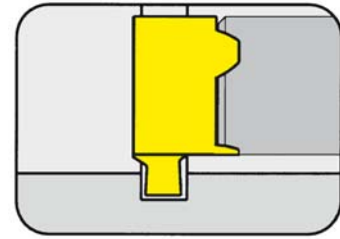


INSERT Type

U108

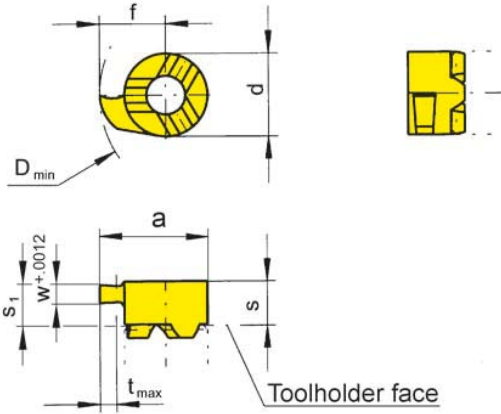
C

Bore Ø from	.315"
Depth of groove up to	.039"
Width of groove	.031 - .039"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version

L = left hand version

not face cutting,
limited depth of cut

Part number	w	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/LU108.0031.00	.031	.126	.142	.189	.307	.236	.039	.315	Δ	▲/▲			
R/LU108.0039.00	.039									▲/▲			
									P	o	•	•	•
									M	•	•	•	•
									K	•	•	•	•
									S	•	•	•	•
									N	•	•	•	•
									H				

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

Dimensions in inch

State R or L version

Carbide grades

GROOVING (internal) $\geq \varnothing .315''$

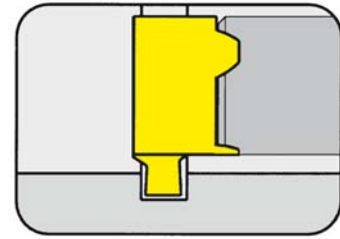
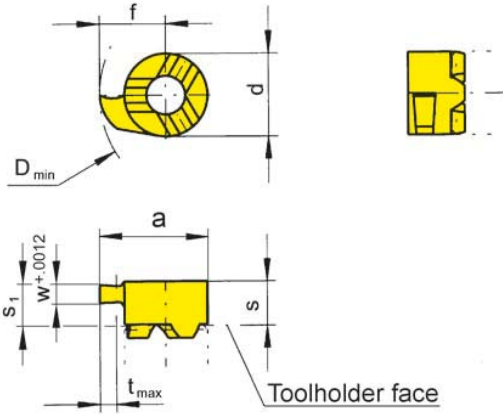


INSERT Type

108

Bore \varnothing from	.315"
Depth of groove up to	.039"
Width of circlip Nw	.028 - .035"

Widths for circlip grooves DIN 471/472



for use with Toolholder

Type B108
B108KM
BU108

R = right hand version shown

L = left hand version

not face cutting,
limited depth of cut

Part number	Nw	w	s ₁	s	f	a	d	t _{max}	D _{min}	Carbide grades									
										MG12	TN35	TI25	TF45	TH35					
R/L108.0070.00	.028	.029																	
R/L108.0080.00	.031	.033	.126	.142	.189	.307	.236	.039	.315		▲/▲				▲/▲				
R/L108.0090.00	.035	.037									▲/▲				▲/▲				
											P	•			•				
											M	•			•				
											K	•			•				
											S	•			•				
											N	•			•				
											H								

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

Dimensions in inch

State R or L version

Carbide grades

GROOVING (external) $\geq \text{Ø} .315''$

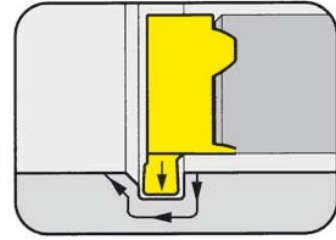


INSERT Type

U108

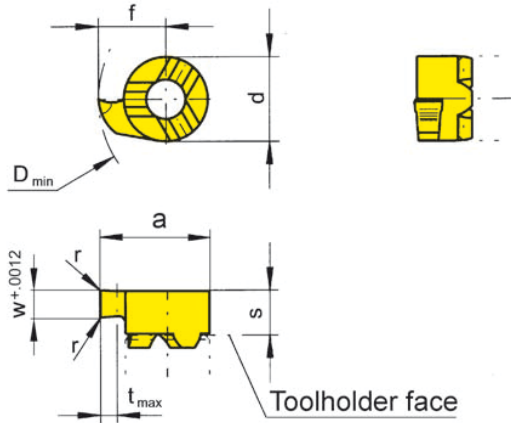
C

Bore Ø from	.315"
Depth of groove up to	.039"
Width of groove	.031 - .078"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

with corner radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/LU108.0031.08	.031								▲/	▲/				
R/LU108.0046.08	.046								▲/▲	▲/▲				
R/LU108.0062.08	.062	.008	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲	▲/			
R/LU108.0078.08	.078								▲/▲	▲/▲				
									P	o	•	•		
									M	•	•	•		
									K	•	•	•		
									S	•	•	•		
									N	•	•	•		
									H					

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

Dimensions in inch

State R or L version

Carbide grades

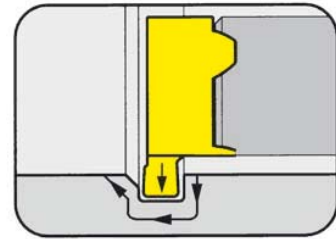
NC-PROFILING (internal) $\geq \text{Ø} .315''$



INSERT Type

108

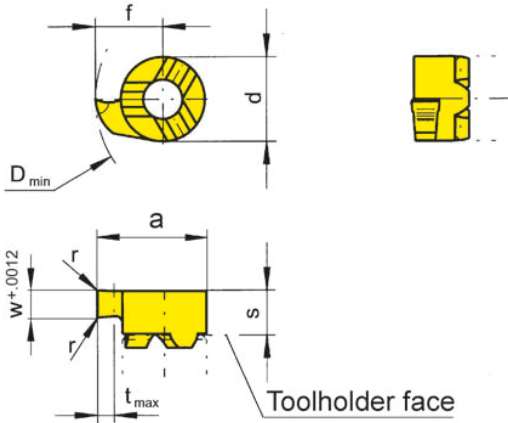
Bore Ø from .315"
 Depth of groove up to .039"
 Width of groove .059"



C

for use with Toolholder

Type B108
 B108KM
 BU108



R = right hand version shown

L = left hand version

with corner radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L108.0150.02	.059	.008	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ on stock Δ 4 weeks													
● main recommendation													
○ alternative recommendation													
■ uncoated grades													
■ coated grades													
■ brazed/Cermet													
P	○	●	●	●	●	●	●	●	●	●	●	●	●
M	●	●	●	●	●	●	●	●	●	●	●	●	●
K	●	●	●	●	●	●	●	●	●	●	●	●	●
S	●	●	●	●	●	●	●	●	●	●	●	●	●
N	●	●	●	●	●	●	●	●	●	●	●	●	●
H	●	●	●	●	●	●	●	●	●	●	●	●	●

Dimensions in inch

State R or L version

Carbide grades

GROOVING (internal) $\geq \text{Ø} .315''$

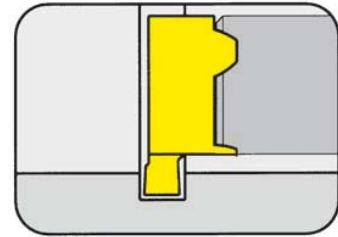


INSERT Type

U108

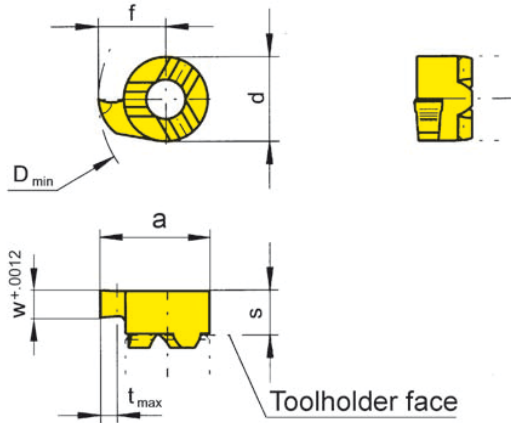
C

Bore Ø from	.315"
Depth of groove up to	.039"
Width of groove	.046 - .078"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	w	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/LU108.0046.00	.046							▲/	▲/			
R/LU108.0056.00	.056							▲/▲	▲/▲			
R/LU108.0062.00	.062	.126	.189	.307	.236	.039	.315	▲/	▲/▲			
R/LU108.0078.00	.078							▲/	▲/▲			
								P	o	•		
								M	•	•		
								K	•	•		
								S	•	•		
								N	•	•		
								H				

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

Dimensions in inch

State R or L version

Carbide grades

GROOVING (internal) $\geq \varnothing .315''$

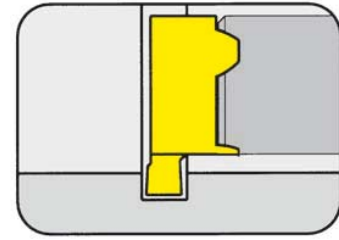
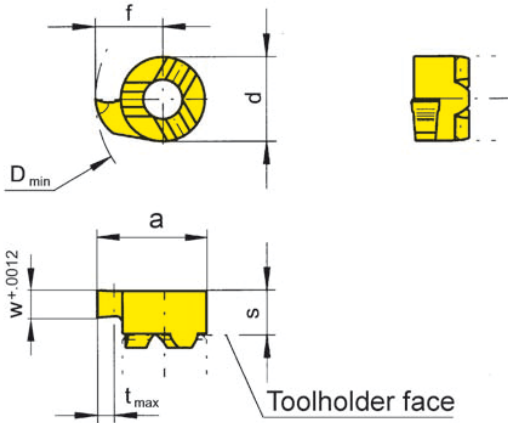


INSERT Type

108

Bore \varnothing from	.315"
Depth of groove up to	.039"
Width of circlip Nw	.043 - .063"

Widths for circlip grooves DIN 471/472



for use with Toolholder

Type B108
B108KM
BU108

R = right hand version shown

L = left hand version

Part number	Nw	w	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L108.0110.00	.043	.047						.315	▲/▲	▲/▲			▲/▲
R/L108.0130.00	.051	.055	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲			▲/▲
R/L108.0160.00	.063	.067						.315	▲/▲	▲/▲			▲/▲
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation □ uncoated grades ■ coated grades ■ brazed/Cermet									P	○	●	■	■
									M	●	●	■	■
									K	●	●	■	■
									S	●	●	■	■
									N	●	●	■	■
									H			■	■

Dimensions in inch

State R or L version

Carbide grades

GROOVING (internal) $\geq \varnothing .315''$

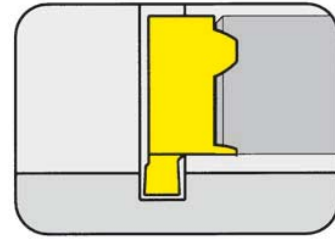


INSERT Type

108

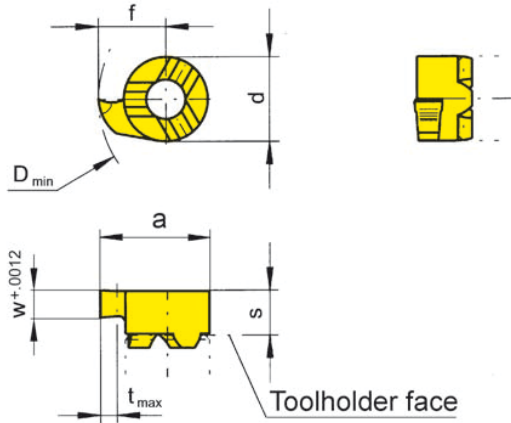
C

Bore \varnothing from	.315"
Depth of groove up to	.039"
Width of groove	.059 - .079"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	w	s	f	a	d	t _{max}	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L108.0150.00	.059	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲			▲/▲
R/L108.0200.00	.079	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲			▲/▲
								P	o	•		•
								M	•	•		•
								K	•	•		•
								S	•	•		•
								N	•	•		•
								H				

Dimensions in inch

State R or L version

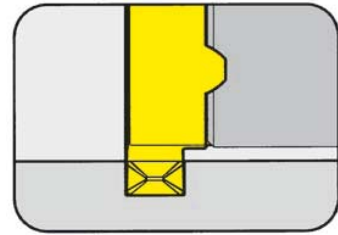
GROOVING (internal) $\geq \text{Ø} .315''$



INSERT Type

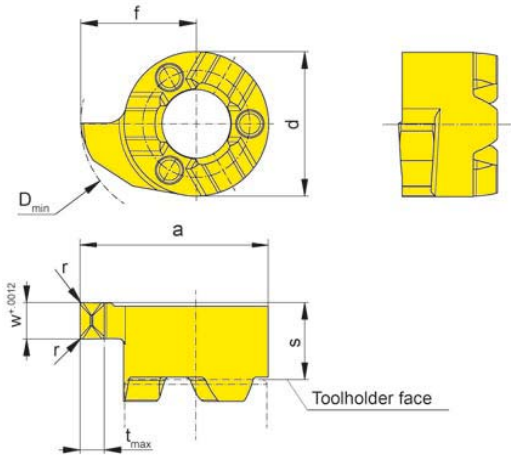
S108

Bore Ø from .315"
 Depth of groove up to .039"
 Width of groove .039 - .079"



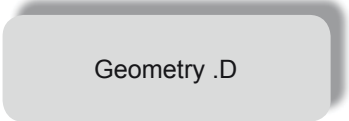
for use with Toolholder

Type B108
 B108KM
 BU108



R = right hand version shown

L = left hand version



Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/LS108.0100.D1	.039	.004						.315					▲▲
R/LS108.0150.D1	.059	.004	.126	.189	.307	.236	.039	.315					▲▲▲
R/LS108.0200.D2	.079	.008											▲▲▲
									P				•
									M				•
									K				•
									S				•
									N				•
									H				•

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

Dimensions in inch

State R or L version

Carbide grades

GROOVING (internal) $\geq \text{Ø} .315''$

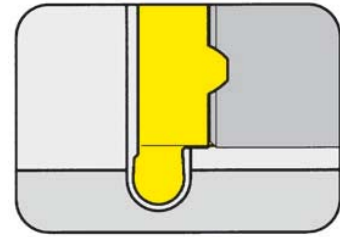


INSERT Type

U108

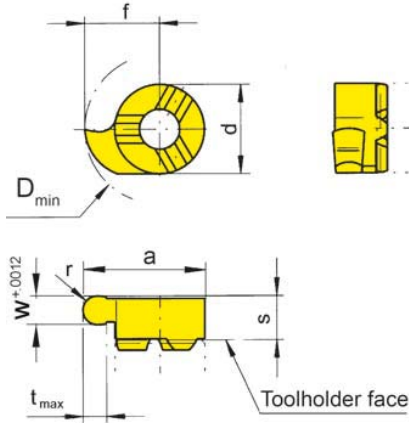
C

Bore Ø from	.315"
Depth of groove up to	.039"
Width of groove	.031 - .078"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Full radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/LU108.0015.31	.031	.015								▲/▲	▲/			
R/LU108.0023.46	.046	.023								▲/▲				
R/LU108.0031.62	.062	.031	.126	.189	.307	.236	.039	.315		▲/				
R/LU108.0039.78	.078	.039								▲/▲			▲/	
										P	o	•	•	•
										M	•	•	•	•
										K	•	•	•	•
										S	•	•	•	•
										N	•	•	•	•
										H				

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

Dimensions in inch

State R or L version

Carbide grades

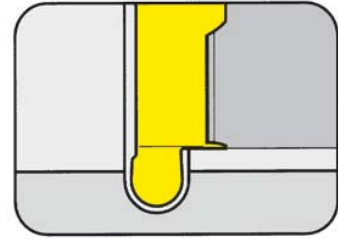
GROOVING (internal) $\geq \varnothing .315''$



INSERT Type

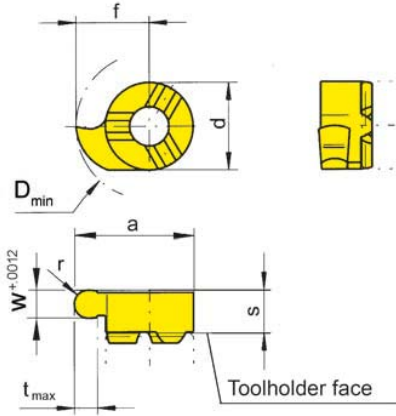
108

Bore \varnothing from .315"
 Depth of groove up to .039"
 Width of groove .031 - .071"



for use with Toolholder

Type B108
 B108KM
 BU108



R = right hand version shown

L = left hand version

Full radius

Part number	w	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L108.0004.08	.031	.016						.315	▲/▲	▲/▲			▲/▲
R/L108.0006.12	.047	.024	.126	.189	.307	.236	.039	.315	▲/▲	▲/▲			▲/▲
R/L108.0009.18	.071	.035						.315	▲/▲	▲/▲	▲/▲		▲/▲
									P	o	•	•	•
									M	•	•	•	•
									K	•	•	•	•
									S	•	•	•	•
									N	•	•	•	•
									H				

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

Dimensions in inch

State R or L version

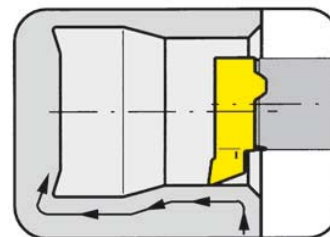
Carbide grades

INSERT Type

108

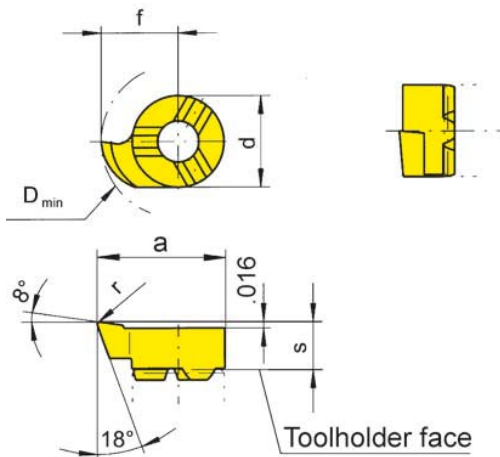
C

Bore Ø from	.307"
Depth of undercut up to	.051"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	r	s	f	a	d	D _{min}	Carbide grades				
							MG12	TN35	TI25	TF45	TH35
R/L108.1846.02	.008	.134	.183	.301	.236	.307	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
▲ on stock Δ 4 weeks							P	o	•	•	•
● main recommendation							M	•	•	•	•
o alternative recommendation							K	•	•	•	•
■ uncoated grades							S	•	•	•	•
■ coated grades							N	•	•	•	•
■ brazed/Cermet							H				

Dimensions in inch

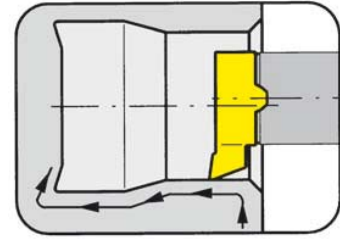
Carbide grades

State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .307''$ and profiling of reliefs as per DIN 509 form E and F.

INSERT Type

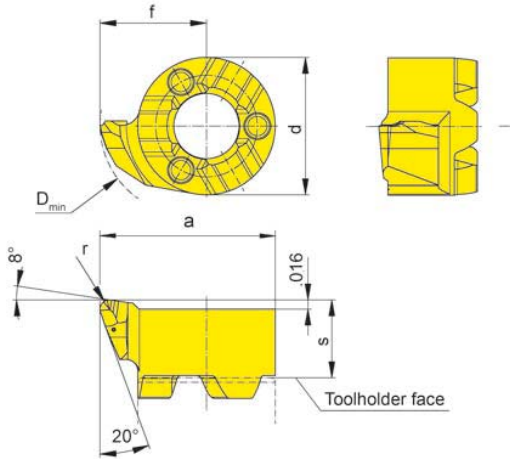
S108



Bore Ø from	.307"
Depth of undercut up to	.051"

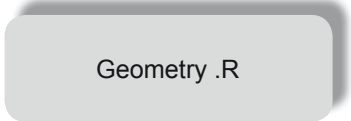
for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version



Part number	r	s	f	a	d	D _{min}	Carbide grades				
							MG12	TN35	TI25	TF45	TH35
LS108.1846.R2	.008										▲
RS108.1846.R2	.008										▲
LS108.1846.R4	.016	.134	.183	.301	.236	.307					▲
RS108.1846.R4	.016										▲
							P				•
							M				•
							K				•
							S				•
							N				•
							H				•

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

Dimensions in inch

State R or L version

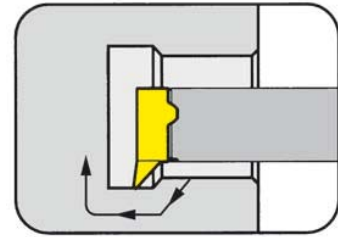
The modified geometry allows boring of bores $\geq \text{Ø} .307''$ and profiling of reliefs as per DIN 509 form E and F.

INSERT Type

108

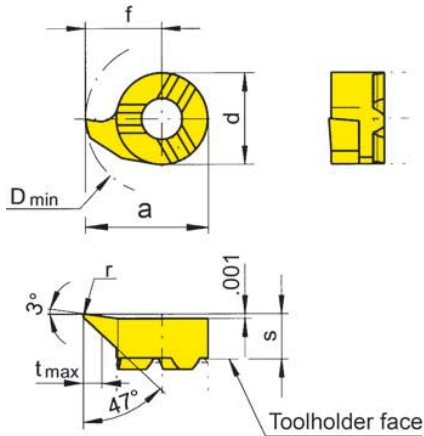
C

Bore Ø from $.307''$
 Depth of undercut up to $.047''$



for use with Toolholder

Type B108
 B108KM
 BU108



R = right hand version shown

L = left hand version

Part number	r	s	f	a	d	t _{max}	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R/L108.4748.01	.004	.126	.183	.301	.236	.047	.307					▲/△
R/L108.4748.02	.008							▲/▲			▲/▲	
								P	•	•	•	•
								M	•	•	•	•
								K	•	•	•	•
								S	•	•	•	•
								N	•	•	•	•
								H				

Dimensions in inch

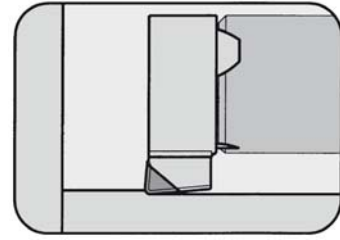
State R or L version

The modified geometry allows boring of bores $\geq \text{Ø} .307''$ and profiling of reliefs as per DIN 509 form E.

INSERT Type

108

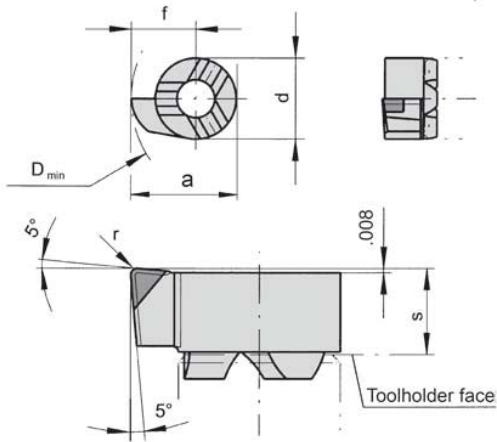
Bore Ø from .307"



C

for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

CBN tipped

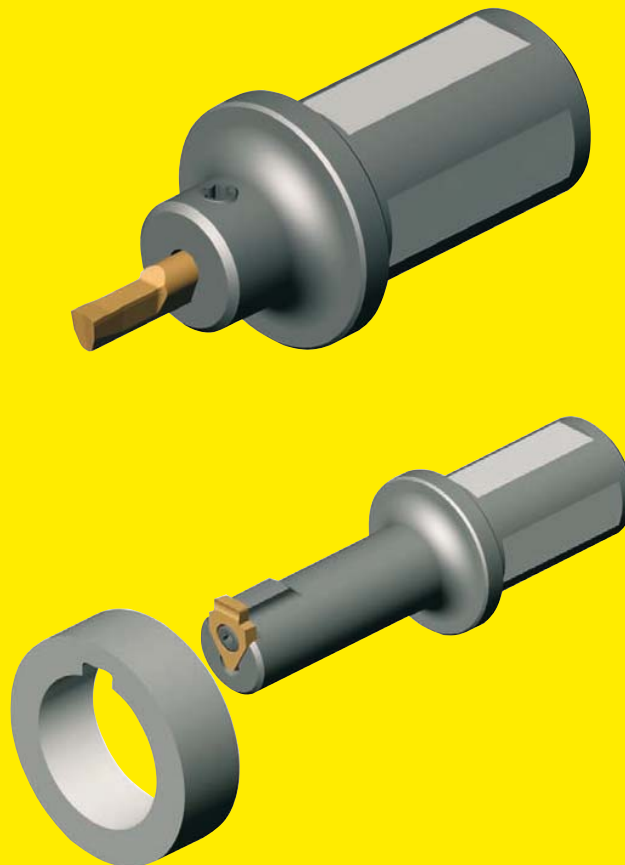
Part number	r	s	f	a	d	D _{min}	CB10
R108.0547.03.B	.012	.138	.183	.301	.236	.307	▲
▲ on stock Δ 4 weeks							P
● main recommendation							M
○ alternative recommendation							K
■ uncoated grades							S
■ coated grades							N
■ brazed/Cermet							H

Dimensions in inch

Carbide grades

BROACHING on CNC lathes

BROACHING TOOLS TYPE SB105/SB110 and SH117



KEYWAYS ACCORDING DIN138 and DIN6885

For further information please see HORN catalog "CARBIDE GROOVING TOOLS".

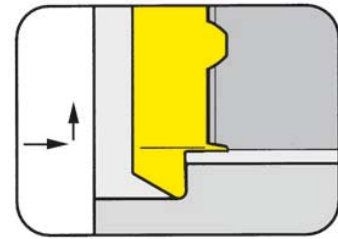
BACKBORING (internal)



INSERT Type

108

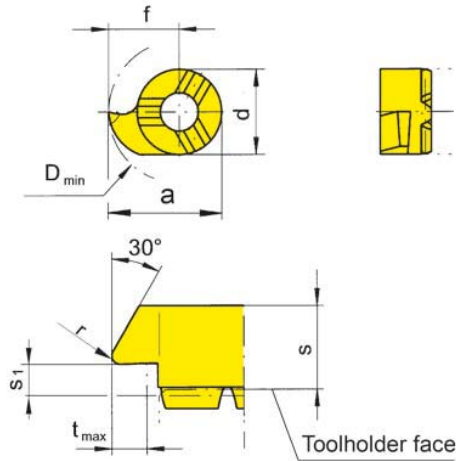
Bore Ø from .307"



C

for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	r	s ₁	s	f	a	d	t _{max}	D _{min}	MG12	TN35	TI25	TF45	TH35
R/L108.3046.02	.008	.031	.142	.183	.301	.236	.051	.307		▲/▲			▲/▲
▲ on stock Δ 4 weeks									P	•	•	•	•
● main recommendation									M	•	•	•	•
○ alternative recommendation									K	•	•	•	•
■ uncoated grades									S	•	•	•	•
■ coated grades									N	•	•	•	•
■ brazed/Cermet									H				

Dimensions in inch

Carbide grades

State R or L version

CHAMFERING and BACKBORING (internal)

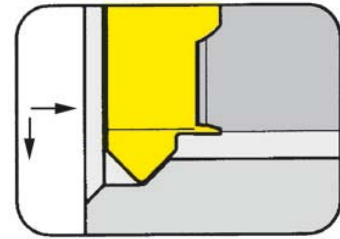


C

INSERT Type

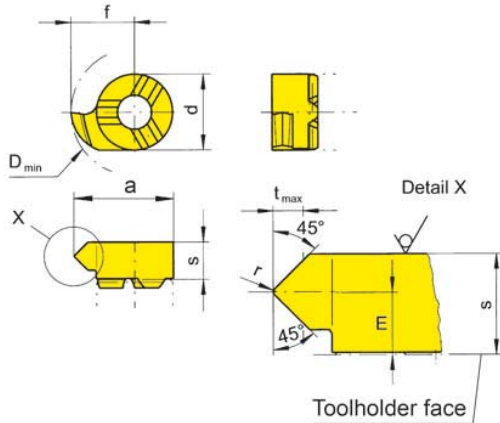
108

Bore Ø from .307"



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	E	r	s	f	a	d	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TA45	TH35	
R/L108.4545.02	.071	.008	.142	.183	.301	.236	.055	.307		▲/▲	▲/▲	▲/		
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet										P	●	●	●	
										M	●	●	●	
										K	●	●	●	
										S	●	●	●	
										N	●	●	●	
										H				

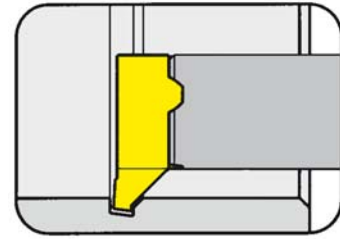
Dimensions in inch

State R or L version

INSERT Type

108

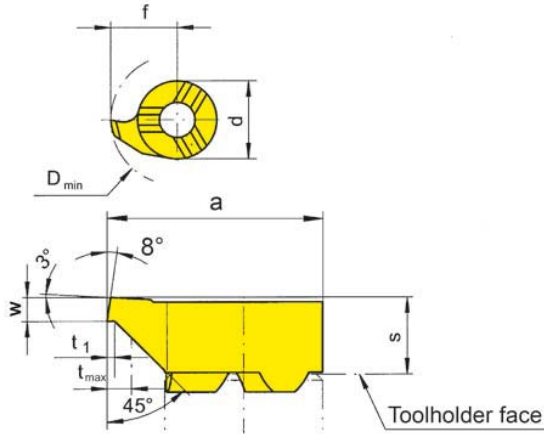
Bore Ø from .315"



C

for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Part number	w	s	f	a	d	t ₁	t _{max}	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/L108.0810.45	.039	.126	.189	.307	.236	.008	.059	.315	▲/▲	▲/▲	▲/▲			
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet										P	○	●	●	
										M	●	●	●	
										K	●	●	●	
										S	●	●	●	
										N	●	●	●	
										H				

Dimensions in inch

State R or L version

Carbide grades

THREADING (internal) Partial profile

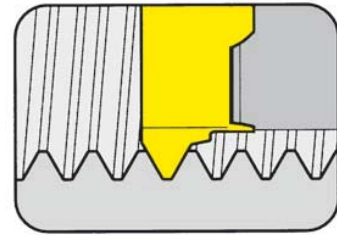


INSERT Type

108

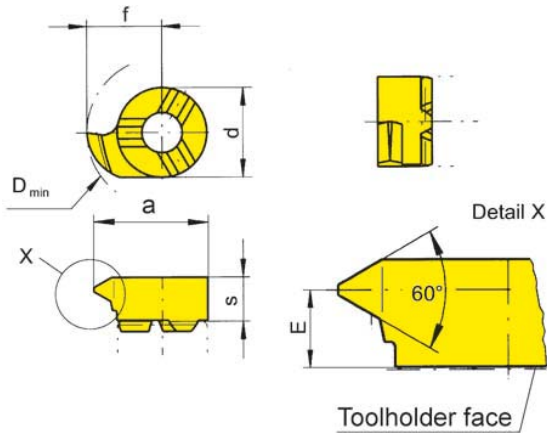
C

Bore Ø from Pitch .315" (8.0 mm)
1.50 - 1.75



for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Metric ISO standard thread

Part number	P	P _{max}	E	s	f	a	d	D _{min}	Carbide grades					
									MG12	TN35	TI25	TF45	TH35	
R/L108.0815.01	1.5	1.75	2.6	3.6	4.8	7.8	6	8	▲/▲	▲/▲			▲/▲	
▲ on stock Δ 4 weeks ● main recommendation ○ alternative recommendation ■ uncoated grades ■ coated grades ■ brazed/Cermet										P	○	●		●
										M	●	●		●
										K	●	●		●
										S	●	●		●
										N	●	●		●
										H				

Dimensions in mm

State R or L version

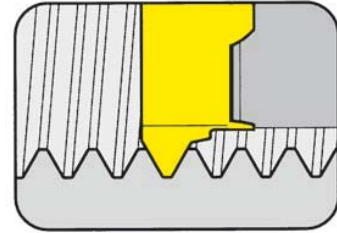
THREADING (internal) Partial profile



INSERT Type

108

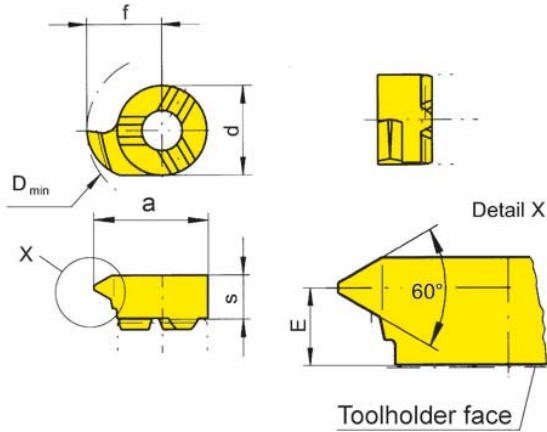
Bore Ø from Pitch .315" (8.0 mm)
0.50 - 1.25 mm



C

for use with Toolholder

Type B108
B108KM
BU108



R = right hand version shown

L = left hand version

Metric ISO fine thread

Part number	P	P _{max}	E	s	f	a	d	D _{min}	Carbide grades				
									MG12	TN35	TI25	TF45	TH35
R/L108.0205.01	0.5	0.75	2.8	3.6	4.8	7.8	6	8	▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
R/L108.0510.01	1.0	1.25							▲/▲	▲/▲	▲/▲	▲/▲	▲/▲
									P	•	•	•	•
									M	•	•	•	•
									K	•	•	•	•
									S	•	•	•	•
									N	•	•	•	•
									H	•	•	•	•

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

Dimensions in mm

State R or L version

Carbide grades

THREADING (internal) Full profile

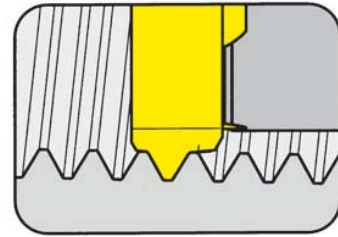


INSERT Type

108

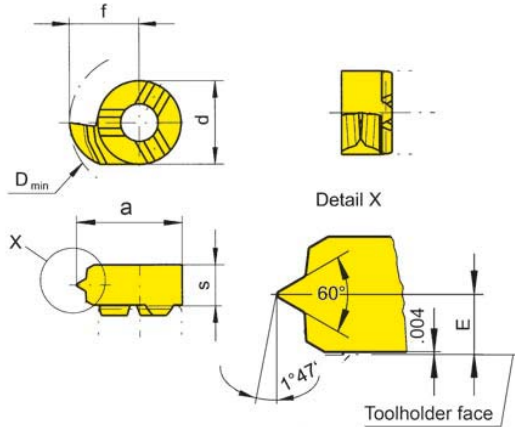
C

Threads per inch 14 / 18 / 27



for use with Toolholder

Type B108
BU108



R = right hand version shown

Thread NPT

Part number	Threads per Inch	E	s	f	a	d	D _{min}	Carbide grades							
								MG12	TN35	TI25	TF45	TH35			
R108.NP14.02	14														
R108.NP18.02	18	.075	.142	.189	.307	.236	.315		▲						
R108.NP27.02	27								▲						
									△						
									P	•					
									M	•					
									K	•					
									S	•					
									N	•					
									H						

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

Dimensions in inch

Carbide grades

THREADING (internal) Full profile

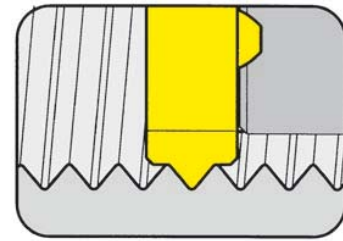


INSERT Type

108

Threads per inch

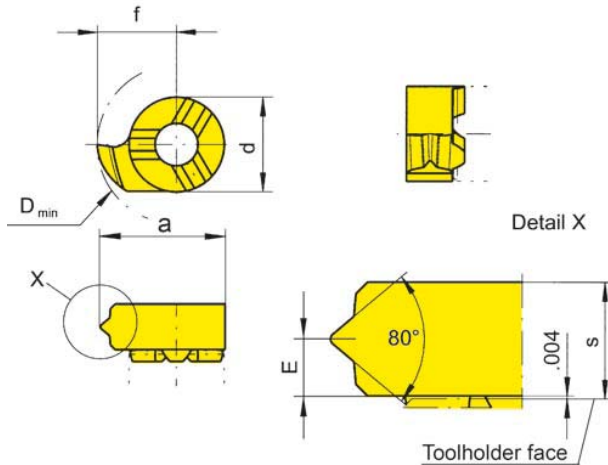
18 / 20



C

for use with Toolholder

Type B108
BU108



R = right hand version shown

Thread profile PG

Part number	Threads per Inch	E	s	f	a	d	D _{min}	Carbide grades				
								MG12	TN35	TI25	TF45	TH35
R108.PG18.02	18	.075	.142	.189	.307	.236	.315		▲			
R108.PG20.02	20							▲				
								P	•	•	•	•
								M	•	•	•	•
								K	•	•	•	•
								S	•	•	•	•
								N	•	•	•	•
								H				

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

Dimensions in inch

Carbide grades