

Prices plus VAT, valid until 31.07.2022

 Hoffmann Group

## CLEVER SOLUTIONS IN THE FIELD OF TURNING.

Economical, reliable and sturdy – discover the  
HOLEX turning range.

**HOLEX**





# HOLEX: SIMPLY. CLEVER. TURNING.

HOLEX toolholders, boring bars, inserts and arbors for turning contain numerous clever ideas for day-to-day working life. And all that at an impressively attractive price.

Clever, powerful  
HOLEX Pro Drill

**PAGE 4**



Clever, practical  
screw-on toolholder sets

**PAGE 6**



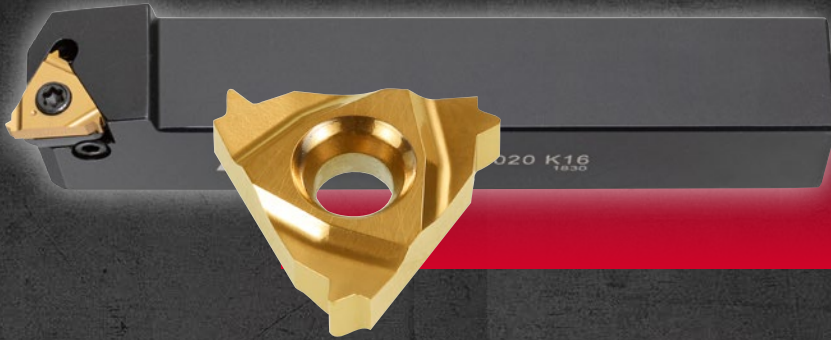
Clever, simple  
boring bar sets

**PAGE 15**



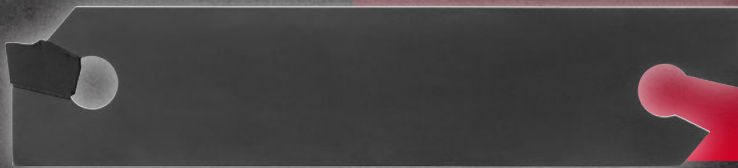


**HOLEX**



Clever threads  
thread turning tools

**PAGE 20**



Clever, efficient  
parting-off tools

**PAGE 21**



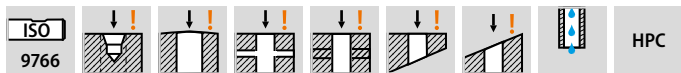
Clever, new  
grooving system

**PAGE 22 – 25**



Clever, powerful  
VDI toolholders

**PAGE 30**



**HOLEX** HOLEX Pro Drill indexable drill for right-hand cutting, plain shank with drive flats

HOLEX Pro Drill indexable drills combine cost efficiency with technically fully developed capability.

For use up to 4xD in challenging drilling applications.

23 5010 – **Bore tolerance:** -0.05 / +0.3 mm

23 5000/5005 – **Bore tolerance:** -0.1 / +0.25 mm

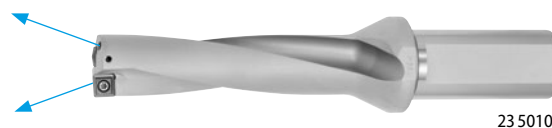
**Application:** With indexable inserts No. 235030 – 235082.

Both SOMT inserts for the outer insert seats and also XOMT inserts for the inner insert seats are required.

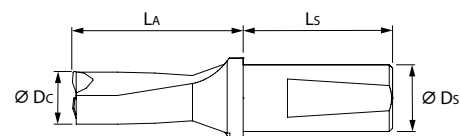
**Supplied with:** With insert screws (supplied without indexable inserts).

**Recommendation:**

23 5010 – When spot-drilling reduce the feed rate by 70 %.



23 5010

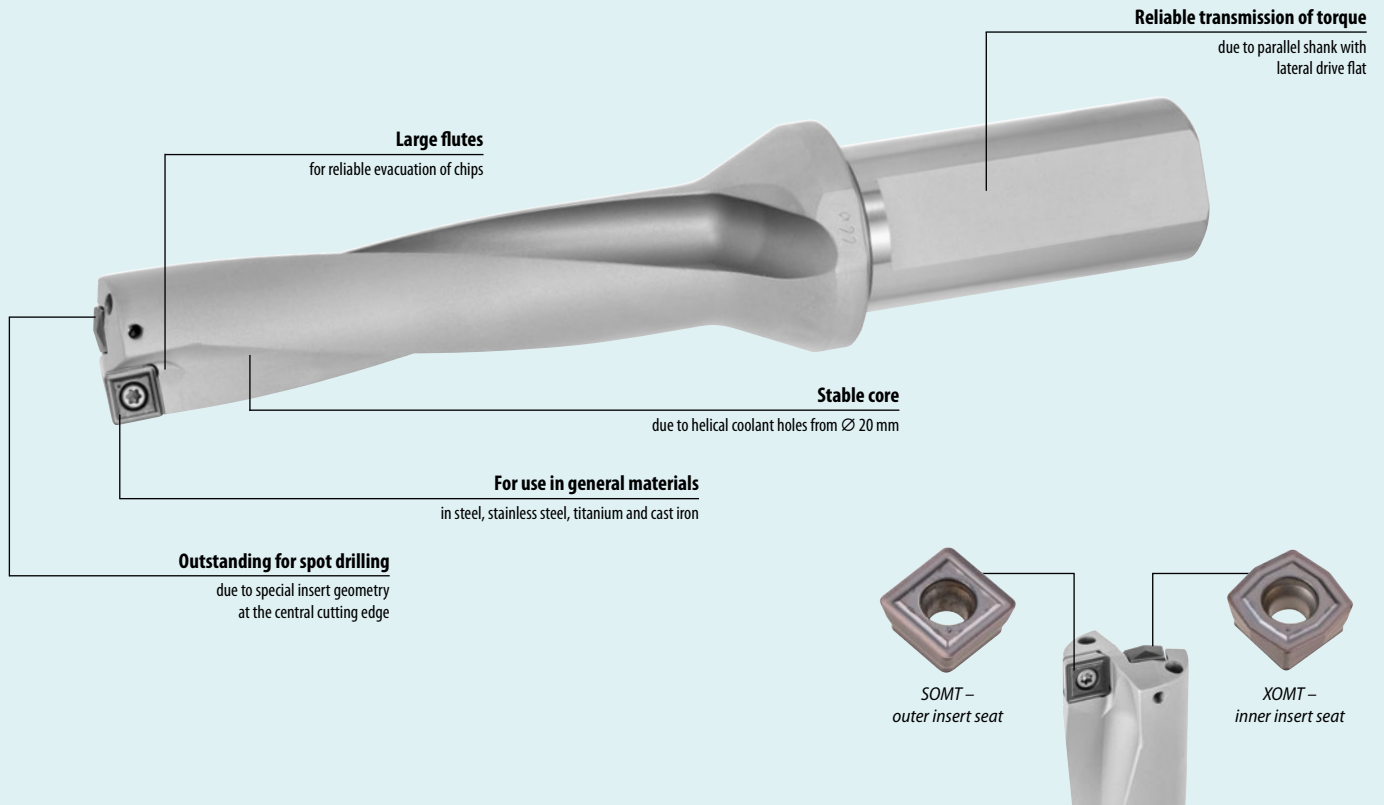


Ø D <sub>c</sub>	HOLEX Pro Drill indexable drill			for inch Ø	L <sub>A</sub>			Ø D <sub>s</sub>	L <sub>s</sub>	ISO code indexable insert	Pack of insert screws
	23 5000	23 5005	23 5010		23 5000	23 5005	23 5010				
	Combination shank										
mm	2xD	3xD	4xD	inch	mm	mm	mm	mm	mm		
14	218.52	230.49	251.55	–	46	60	74	20	50	SOMT05T204 / XOMT05T204	232980 1 (TX6;0.4Nm)
15	218.52	230.49	251.55	19/32	49	64	79	20	50	SOMT05T204 / XOMT05T204	232980 1 (TX6;0.4Nm)
16	218.52	230.49	251.55	–	51	67	83	20	50	SOMT05T204 / XOMT05T204	232980 1 (TX6;0.4Nm)
17	229.50	242.37	257.04	–	53	70	87	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
17,5	–	242.37	257.04	11/16	–	70	87	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
18	229.50	242.37	257.04	–	56	74	92	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
18,5	229.50	242.37	257.04	–	56	74	92	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
19	229.50	242.37	257.04	3/4	58	77	96	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
19,5	–	253.44	273.60	–	–	77	96	25	56	SOMT06T205 / XOMT06T204	232980 2 (TX7;0.8Nm)
20	239.67	253.44	273.60	–	62	82	102	25	56	SOMT070308 / XOMT070305	232980 3 (TX7; 0.8Nm)
21	239.67	253.44	273.60	–	64	85	106	25	56	SOMT070308 / XOMT070305	232980 3 (TX7; 0.8Nm)
22	239.67	253.44	273.60	–	66	88	110	25	56	SOMT070308 / XOMT070305	232980 3 (TX7; 0.8Nm)
22,5	–	253.44	273.60	–	–	88	110	25	56	SOMT070308 / XOMT070305	232980 3 (TX7; 0.8Nm)
23	252.45	265.32	282.78	–	70	93	116	25	56	SOMT070308 / XOMT070305	232980 3 (TX7; 0.8Nm)
24	252.45	265.32	282.78	–	73	97	121	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
24,5	252.45	265.32	282.78	–	73	97	121	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
25	252.45	265.32	282.78	–	75	100	125	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
26	252.45	265.32	282.78	–	77	103	129	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
26,5	252.45	265.32	282.78	–	77	103	129	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
27	266.22	281.88	303.93	11/16	80	107	134	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
28	266.22	281.88	303.93	–	83	111	139	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
29	266.22	281.88	303.93	–	85	114	143	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
29,5	–	281.88	303.93	–	–	114	143	32	60	SOMT093608 / XOMT093605	232980 4 (TX9;1.2Nm)
30	266.22	281.88	303.93	–	90	120	150	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
31	266.22	281.88	303.93	17/32	92	123	154	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
32	281.88	296.55	331.47	–	94	126	158	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
33	281.88	296.55	331.47	–	97	130	163	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
34	281.88	296.55	331.47	–	99	133	167	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
35	300.24	317.70	350.73	13/8	101	136	171	32	60	SOMT110408 / XOMT110406	232980 5 (TX15;3Nm)
36	300.24	317.70	350.73	–	106	142	178	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)
37	300.24	317.70	350.73	–	108	145	182	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)
38	321.30	338.76	369.09	1 1/2	111	149	187	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)
39	321.30	338.76	369.09	–	113	152	191	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)
39,5	–	338.76	369.09	–	–	152	191	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)
40	321.30	338.76	369.09	–	116	156	196	40	70	SOMT13M510 / XOMT13M506	232980 6 (TX15;3Nm)

**HOLEX Pro Drill– Indexable drill**



**Robust. Reliable. Economical.**



**HOLEX HOLEX Pro Drill SOMT.... inserts / XOMT..... for indexable drills**

The central cutting edge centres the drill quickly and reliably. The outer cutting edge offers outstanding chip clearance.

- Suitable for:** HOLEX Pro Drill No. 235000 – 235010.
- Application:** SOMT inserts exclusively as the outer cutting edges. XOMT inserts exclusively as the centre cutting edge.

Suitable for/ v <sub>c</sub> [m/min]	Alu plastics	Alu	Alu cast > 10% Si										INOX	INOX	Ti	GG(G)	CuZn	Uni					
ISO code	N	N	N	P	P	P	P	P	P	H	H	H	H	M	M	S	K	N					
23 5030–23 5082				160	150	140	120	100					110	90	50	130	220	●	●				

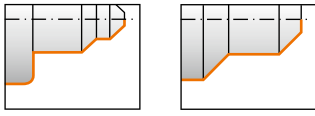


Type	UNI				
22K 23 5030	SOMT05T204		HBD30	8.91	10 0.05 – 0.1
22K 23 5032	XOMT05T204		HBD30	8.91	10 0.05 – 0.1
22K 23 5040	SOMT06T205		HBD30	9.09	10 0.06 – 0.12
22K 23 5042	XOMT06T204		HBD30	9.09	10 0.06 – 0.12
22K 23 5050	SOMT070308		HBD30	9.36	10 0.06 – 0.12
22K 23 5052	XOMT070305		HBD30	9.36	10 0.06 – 0.12
22K 23 5060	SOMT093608		HBD30	9.81	10 0.06 – 0.14
22K 23 5062	XOMT093605		HBD30	9.81	10 0.06 – 0.14
22K 23 5070	SOMT110408		HBD30	10.62	10 0.06 – 0.16
22K 23 5072	XOMT110406		HBD30	10.62	10 0.06 – 0.16
22K 23 5080	SOMT13M510		HBD30	11.16	10 0.06 – 0.16
22K 23 5082	XOMT13M506		HBD30	11.16	10 0.06 – 0.16

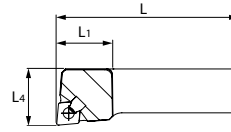


DIN ISO 5610

**HOLEX** Screw-on toolholder sets for indexable inserts CN..



PCLNR/L PCSNR/L

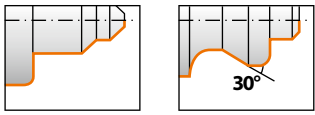


25 5110

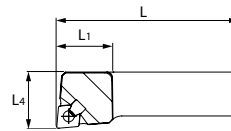
Shank size mm	Screw-on toolholder set		ISO code toolholder		suitable indexable insert	L <sub>4</sub> mm	L <sub>1</sub> mm	L mm	Spare part
	29W 25 5110 right-hand	29W 25 5111 left-hand	25 5110	25 5111					
16	81.68	81.68	PCLNR 1616H09; PCSNR 1616H09	PCLNL 1616H09; PCSNL 1616H09	CN.. 09T3..	20	22; 25	100	259981 4
20	86.63	86.63	PCLNR 2020K12; PCSNR 2020K12	PCLNL 2020K12; PCSNL 2020K12	CN.. 1204..	25	28	125	259981 5
25	92.07	92.07	PCLNR 2525M16; PCSNR 2525M16	PCLNL 2525M16; PCSNL 2525M16	CN.. 1606..	32	33	150	259981 6

DIN ISO 5610

**HOLEX** Screw-on toolholder sets for indexable inserts CN../DN..



PCLNR/L PDJNR/L

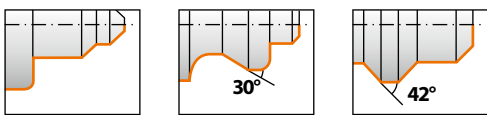


25 5120

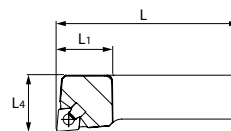
Shank size mm	Screw-on toolholder set		ISO code toolholder		suitable indexable insert	L <sub>4</sub> mm	L <sub>1</sub> mm	L mm	Spare part
	29W 25 5120 right-hand	29W 25 5121 left-hand	25 5120	25 5121					
16	81.68	81.68	PCLNR 1616H09; PDJNR 1616H11;	PCLNL 1616H09; PDJNL 1616H11;	CN.. 09T3..; DN.. 1104..	20	22; 25	100	259981 7
20	86.63	86.63	PCLNR 2020K12; PDJNR 2020K11;	PCLNL 2020K12; PDJNL 2020K11;	CN.. 1204..; DN.. 1104..	25	28	125	259981 8
25	92.07	92.07	PCLNR 2525M16; PDJNR 2525M15;	PCLNL 2525M16; PDJNL 2525M15;	CN.. 1606..; DN.. 1506..	32	33	150	259981 9
32	117.81	117.81	PCLNR 3232P16; PDJNR 3232P15	PCLNL 3232P16; PDJNL 3232P15	CN.. 1606..; DN.. 1506..	40	35	170	259981 9

DIN ISO 5610

**HOLEX** Screw-on toolholder sets for indexable inserts CN../DN../SN..



PCLNR/L PDJNR/L PSSNR/L



25 5130

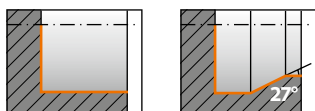
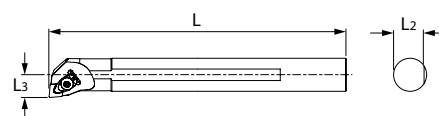
Shank / insert size mm	Screw-on toolholder set		ISO code toolholder		suitable indexable insert	L <sub>4</sub> mm	L <sub>1</sub> mm	L mm	Spare part
	29W 25 5130 right-hand	29W 25 5131 left-hand	25 5130	25 5131					
16	123.26	123.26	PCLNR 1616H09; PDJNR 1616H11; PSSNR 1616H12	PCLNL 1616H09; PDJNL 1616H11; PSSNL 1616H12	CN.. 09T3..; DN.. 1104..; SN.. 1204..	20	22; 25; 25	100	259981 1
20	130.68	130.68	PCLNR 2020K12; PDJNR 2020K11; PSSNR 2020K12	PCLNL 2020K12; PDJNL 2020K11; PSSNL 2020K12	CN.. 1204..; DN.. 1104..; SN.. 1204..	25	25	125	259981 2
25	139.10	139.10	PCLNR 2525M16; PDJNR 2525M15; PSSNR 2525M12	PCLNL 2525M16; PDJNL 2525M15; PSSNL 2525M12	CN.. 1606..; DN.. 1506..; SN.. 1204..	32	25	150	259981 3
32	177.21	177.21	PCLNR 3232P16; PDJNR 3232P15; PSSNR 3232P12	PCLNL 3232P16; PDJNL 3232P15; PSSNL 3232P12	CN.. 1606..; DN.. 1506..; SN.. 1204..	40	35	170	259981 3



**HOLEX** Boring bar sets for indexable inserts CN../DN../WN..



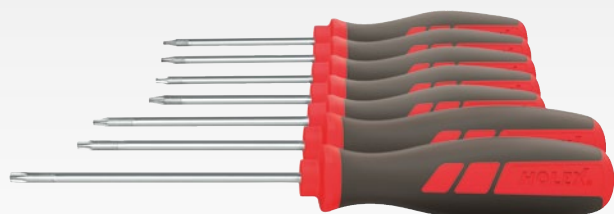
25 5160



Type	25 5160		25 5161		ISO code toolholder	suitable indexable insert	∅ D <sub>min</sub>	L <sub>3</sub>	L <sub>2</sub>	L	Spare part
	right-hand	left-hand	right-hand	left-hand							
	Boring bar set, steel, without IC						mm	mm	mm	mm	
1	187.11	187.11			S16R PCLNR/L09; S20S PDUNR/L11; S16M PWLNR/L06	CN.. 0903..; DN.. 1104..; WN.. 0604..	20; 25; 20	11; 13; 11	15.25; 19; 15.25	200; 250; 150	259981 10
2	216.81	216.81			S25S PCLNR/L12; S32S PDUNR/L15; S25R PWLNR/L08	CN.. 0903..; DN.. 1104..; WN.. 0604..	25; 32; 25	13; 17; 13	19; 24; 19	250; 250; 180	259981 11
3	246.51	246.51			S25S PCLNR/L12; S32S PDUNR/L15; S25R PWLNR/L08	CN.. 1204..; DN.. 1506..; WN.. 0804..	32; 40; 32	17; 22; 17	24; 31; 24	250; 250; 200	259981 12



# WELL IN HAND: ASSEMBLY TOOLS FROM HOLEX.



625751\_7



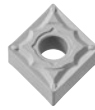
625241\_7



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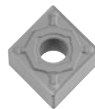
**HOLEX** Indexable inserts CN..

**CNMG Finishing**



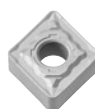
Grade		HBT020	HBT130	
<sup>220</sup> 25 0090	CNMG 09T304	4.32	4.32	10
<sup>220</sup> 25 0092	CNMG 120404	5.18	5.18	10
<sup>220</sup> 25 0093	CNMG 120408	5.18	5.18	10
		P	M	
Chip breaker		PF	MF	
a <sub>p</sub>	mm	0.5 – 2	0.5 – 2.5	
f	mm/rev.	0.1 – 0.4	0.15 – 0.45	
v <sub>c</sub> main application	m/min	120 – 330	40 – 220	

**CN.G Medium machining**



Grade		HBT020	HBT130	
<sup>220</sup> 25 0188	CNMG 09T304	4.32	4.32	10
<sup>220</sup> 25 0196	CNMG 120404	4.32	4.32	10
<sup>220</sup> 25 0197	CNMG 120408	5.18	5.18	10
<sup>220</sup> 25 0198	CNMG 120412	5.18	5.18	10
<sup>220</sup> 25 0204	CNMG 160608	10.04	10.04	10
		P	M	
Chip breaker		PM	MM	
a <sub>p</sub>	mm	0.8 – 5	0.5 – 5	
f	mm/rev.	0.1 – 0.45	0.12 – 0.45	
v <sub>c</sub> main application	m/min	100 – 280	40 – 220	

**CNMG Roughing**



Grade		HBT020	HBT130	
<sup>220</sup> 25 0218	CNMG 120408	5.18	5.18	10
<sup>220</sup> 25 0219	CNMG 120412	5.18	5.18	10
<sup>220</sup> 25 0220	CNMG 160608	10.04	10.04	10
<sup>220</sup> 25 0221	CNMG 160612	10.04	10.04	10
		P	M	
Chip breaker		PR	MR	
a <sub>p</sub>	mm	1.8 – 6	2 – 6	
f	mm/rev.	0.2 – 0.6	0.15 – 0.55	
v <sub>c</sub> main application	m/min	80 – 260	40 – 220	



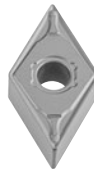
**HOLEX** Indexable inserts DN..

**DNMG Finishing**



Grade		HBT020	HBT130	
<b>25 0666</b>	DNMG 110404	7.11	7.11	10
<b>25 0668</b>	DNMG 150604	8.55	8.55	10
<b>25 0669</b>	DNMG 150608	8.55	8.55	10
		P	M	
Chip breaker		PF	MF	
$a_p$	mm	0.5 – 2		
$f$	mm/rev.	0.1 – 0.4	0.15 – 0.45	
$v_c$ main application	m/min	120 – 330	40 – 220	

**DN.G Medium machining**



Grade		HBT020	HBT130	
<b>25 0780</b>	DNMG 110404	7.11	7.11	10
<b>25 0781</b>	DNMG 110408	7.11	7.11	10
<b>25 0783</b>	DNMG 150604	8.55	8.55	10
<b>25 0784</b>	DNMG 150608	8.55	8.55	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.8 – 5	0.5 – 5	
$f$	mm/rev.	0.1 – 0.45	0.12 – 0.45	
$v_c$ main application	m/min	100 – 280	40 – 220	

**DNMG Rough machining**



Grade		HBT020	HBT130	
<b>25 0786</b>	DNMG 150608	8.55	8.55	10
<b>25 0787</b>	DNMG 150612	8.55	8.55	10
		P	M	
Chip breaker		PR	MR	
$a_p$	mm	1.8 – 6	2 – 6	
$f$	mm/rev.	0.2 – 0.6	0.15 – 0.55	
$v_c$ main application	m/min	80 – 260	40 – 220	

**HOLEX** Indexable inserts SNMG

**SNMG Finish machining**



Grade		HBT020	HBT130	
<b>25 1160</b>	SNMG 120404	5.18	5.18	<b>10</b>
		P	M	
		PF	MF	
Chip breaker				
$a_p$	mm		0.5 – 2	
$f$	mm/rev.	0.1 – 4	0.15 – 0.45	
$v_c$ main application	m/min	120 – 330	40 – 220	

**SNMG Medium machining**



Grade		HBT020	HBT130	
<b>25 1266</b>	SNMG 120404	5.18	5.18	<b>10</b>
<b>25 1267</b>	SNMG 120408	5.18	5.18	<b>10</b>
		P	M	
		PM	MM	
Chip breaker				
$a_p$	mm	0.8 – 5	0.5 – 5	
$f$	mm/rev.	0.1 – 0.45	0.12 – 0.45	
$v_c$ main application	m/min	100 – 280	40 – 220	

**SNMG Rough machining**



Grade		HBT020	HBT130	
<b>25 1396</b>	SNMG 120408	5.18	5.18	<b>10</b>
		P	M	
		PR	MR	
Chip breaker				
$a_p$	mm	1.8 – 6	2 – 6	
$f$	mm/rev.	0.2 – 0.6	0.15 – 0.55	
$v_c$ main application	m/min	80 – 260	40 – 220	

**HOLEX** Radius turning inserts SNMX

**Suitable for:** eco lever lock toolholder PSSN.  
For example eco lever lock toolholders No. 251102; 251103; 251112; 251113.

**Note:** The insert pocket must be modified when using indexable inserts with a radius  $\geq 3$  mm.



25 1398\_1-4

Radius		mm	1	2	3	4	1-4
<b>25 1398</b>	SNMX 1204	<b>HUT2S</b>	41.48	41.48	41.48	41.48	41.48
			P	P	P	P	P
			M	M	M	M	M
$a_p$	mm				1 – 4		
$f$	mm/rev.				0.1 – 0.2		
$v_c$ main application	m/min				50 – 120		
$v_c$ secondary application	m/min				30 – 80		

**HOLEX** Indexable inserts TN.G

**TNMG Finish machining**



Grade		HBT020	HBT130	
<sup>2D</sup> 25 1414	TNMG 160404	6.26	6.26	10
●		P	M	
⚙				
Chip breaker		PF	MF	
$a_p$	mm	0.5 – 2		
$f$	mm/rev.	0.1 – 0.4	0.15 – 0.45	
$v_c$ main application	m/min	120 – 330	40 – 220	

**TN.G Medium machining**



Grade		HBT020	HBT130	
<sup>2D</sup> 25 1564	TNMG 160404	6.26	6.26	10
<sup>2D</sup> 25 1565	TNMG 160408	6.26	6.26	10
●		P	M	
⚙				
Chip breaker		PM	MM	
$a_p$	mm	0.8 – 5		
$f$	mm/rev.	0.1 – 0.45	0.12 – 0.45	
$v_c$ main application	m/min	100 – 280	40 – 220	

**HOLEX** Indexable inserts VN.G

**VNMG Finish machining**



Grade		HBT020	HBT130	
<sup>2D</sup> 25 1772	VNMG 160404	7.11	7.11	10
●		P	M	
⚙				
Chip breaker		PF	M	
$a_p$	mm	0.5 – 2		
$f$	mm/rev.	0.1 – 0.4	0.15 – 0.45	
$v_c$ main application	m/min	120 – 330	40 – 220	

**VN.G Medium machining**

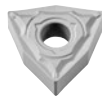


Grade		HBT020	HBT130	
<sup>2D</sup> 25 1828	VNMG 160404	7.11	7.11	10
<sup>2D</sup> 25 1829	VNMG 160408	7.11	7.11	10
●		P	M	
⚙				
Chip breaker		PM	MM	
$a_p$	mm	0.8 – 4		
$f$	mm/rev.	0.1 – 0.45	0.12 – 0.45	
$v_c$ main application	m/min	100 – 280	40 – 220	



**HOLEX** Indexable inserts WN.G

**WNMG Finish machining**



Grade		HBT020	HBT130	
25 1938	WNMG 060404	5.90	5.90	10
25 1939	WNMG 080404	6.26	6.26	10
		P	M	
Chip breaker		PF	M	
$a_p$	mm	0.5 – 2		
$f$	mm/rev.	0.1 – 0.4	0.15 – 0.45	
$v_c$ main application	m/min	120 – 330	40 – 220	

**WN.G Medium machining**



Grade		HBT020	HBT130	
25 2092	WNMG 060404	5.90	5.90	10
25 2093	WNMG 060408	5.90	5.90	10
25 2094	WNMG 080404	6.26	6.26	10
25 2095	WNMG 080408	6.26	6.26	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.8 – 5	0.5 – 5	
$f$	mm/rev.	0.1 – 0.45	0.12 – 0.45	
$v_c$ main application	m/min	100 – 280	40 – 220	

**WNMG Rough machining**

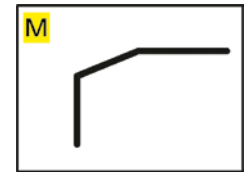
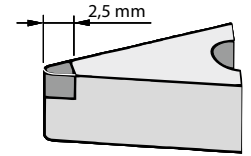


Grade		HBT020	HBT130	
25 2224	WNMG 080408	6.26	6.26	10
25 2226	WNMG 080412	6.26	6.26	10
		P	M	
Chip breaker		PR	MR	
$a_p$	mm	1.8 – 6	2 – 6	
$f$	mm/rev.	0.2 – 0.6	0.15 – 0.55	
$v_c$ main application	m/min	80 – 260	40 – 220	

**HOLEX** Indexable inserts CBN (0°)

- Disposable insert.
- Single cutting edge.

**Note:** Further indexable insert shapes, sizes and corner radii available on request.



Cutting edge (chamfered).  
Chamfering even for slightly interrupted cutting.



Cutting edge version			M	
21	<b>25 5578</b>	CNMA 120404	<b>BUX220</b>	19.53
21	<b>25 5580</b>	CNMA 120408	<b>BUX220</b>	19.53
21	<b>25 5582</b>	CNMA 120412	<b>BUX220</b>	19.53
21	<b>25 5584</b>	DNMA 150604	<b>BUX220</b>	19.53
21	<b>25 5586</b>	DNMA 150608	<b>BUX220</b>	19.53
21	<b>25 5588</b>	DNMA 150612	<b>BUX220</b>	19.53
21	<b>25 5590</b>	TNMA 160404	<b>BUX220</b>	19.53
21	<b>25 5592</b>	TNMA 160408	<b>BUX220</b>	19.53
21	<b>25 5594</b>	TNMA 160412	<b>BUX220</b>	19.53
21	<b>25 5596</b>	VNMA 160404	<b>BUX220</b>	19.53
21	<b>25 5598</b>	VNMA 160408	<b>BUX220</b>	19.53
a <sub>p</sub> (25 5578, 25 5580, 25 5582, 25 5584, 25 5586, 25 5588, 25 5590, 25 5592, 25 5594)			mm	0.1 – 0.5
a <sub>p</sub> (25 5596, 25 5598)			mm	0.1 – 0.25
f			mm/rev.	0.1 – 0.2
v <sub>c</sub> main application			m/min	80 – 200

**HOLEX**

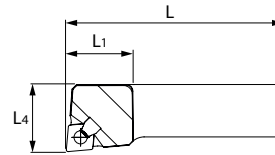
**DO YOURSELF A GOOD TURN:  
HCT TORQUE WRENCH  
FROM HOLEX.**



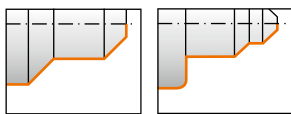
65 5025

DIN  
ISO 5610

**HOLEX** Screw-on toolholder sets for indexable inserts CC..



26 5110



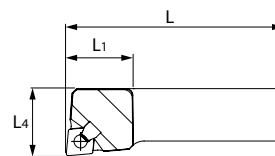
SCSCR/L

SCLCR/L

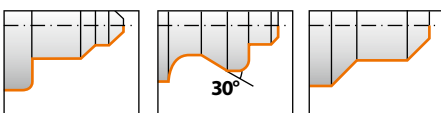
Shank / insert size	Screw-on toolholder set		ISO code toolholder		suitable indexable insert	L <sub>4</sub>	L <sub>1</sub>	L	Spare part
	29W 26 5110	29W 26 5111	26 5110	26 5111					
mm	<b>right-hand</b>	<b>left-hand</b>				mm	mm	mm	
16	78.71	78.71	SCLCR 1616H09; SCSCR 1616H09	SCLCL 1616H09; SCSCL 1616H09	CC.. 09T3..	20	17	100	269981 4
20	82.67	82.67	SCLCR 2020K09; SCSCR 2020K09	SCLCL 2020K09; SCSCL 2020K09	CC.. 09T3..	25	17	125	269981 4
25	86.63	86.63	SCLCR 2525M12; SCSCR 2525M12	SCLCL 2525M12; SCSCL 2525M12	CC.. 1204..	32	20	150	269981 5

DIN  
ISO 5610

**HOLEX** Screw-on toolholder sets for indexable inserts CC.. /DC.. /SC..



26 5130



SCLCR/L

SDJCR/L

SSSCR/L

Shank / insert size	Screw-on toolholder set		ISO code toolholder		suitable indexable insert	L <sub>4</sub>	L <sub>1</sub>	L	Spare part
	29W 26 5130	29W 26 5131	26 5130	26 5131					
mm	<b>right-hand</b>	<b>left-hand</b>				mm	mm	mm	
10	105.44	105.44	SCLCR 1010E06; SDJCR 1010E07; SSSCR 1010E09	SCLCL 1010E06; SDJCL 1010E07; SSSCL 1010E09	CC.. 0602..; DC.. 0702..; SC.. 09T3	12	10; 13; 21	70	269981 6
12	107.91	107.91	SCLCR 1212F09; SDJCR 1212F07; SSSCR 1212F09	SCLCL 1212F09; SDJCL 1212F07; SSSCL 1212F09	CC.. 09T3..; DC.. 0702..; SC.. 09T3	16	13; 17; 20	80	269981 1
16	118.31	118.31	SCLCR 1616H09; SDJCR 1616H11; SSSCR 1616H12	SCLCL 1616H09; SDJCL 1616H11; SSSCL 1616H12	CC.. 09T3..; DC.. 11T3..; SC.. 1204	20	17; 20; 27	100	269981 2
20	123.26	123.26	SCLCR 2020K09; SDJCR 2020K11; SSSCR 2020K12	SCLCL 2020K09; SDJCL 2020K11; SSSCL 2020K12	CC.. 09T3..; DC.. 11T3..; SC.. 1204	25	17; 20.5; 27	125	269981 2
25	128.70	128.70	SCLCR 2525M12; SDJCR 2525M11; SSSCR 2525M12	SCLCL 2525M12; SDJCL 2525M11; SSSCL 2525M12	CC.. 1204..; DC.. 11T3..; SC.. 1204	32	20; 21.5; 25	150	269981 3



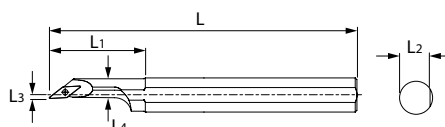
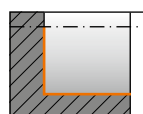


**HOLEX** ..SCLC 95° boring bar sets for indexable inserts CC..

26 0038 – Without through-coolant feed.

**Supplied with:**

- Size SET06 – Plastic case
- Size SET09 – Plastic case



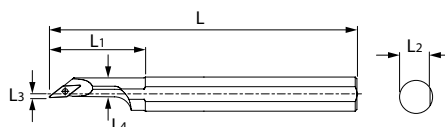
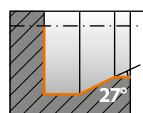
26 0036

Type	26 0036		26 0037		26 0038		ISO code toolholder	suitable indexable insert	∅ D <sub>min</sub>	L <sub>3</sub>	L <sub>2</sub>	L <sub>4</sub>	L <sub>1</sub>	L	Pack of insert screws	
	right-hand	left-hand	right-hand	left-hand	right-hand	left-hand										
	Boring bar set, steel, with IC				Boring bar set, steel, without IC		26 0036 26 0037	26 0038	mm	mm	mm	mm	mm	mm		
SET06	206.91		206.91		174.24		A0608H SCLCR/L06; A0810J SCLCR/L06; A1012K SCLCR/L06; A1216M SCLCR/L06	S0608H SCLCR06; S0810J SCLCR06; S1012K SCLCR06; S1216M SCLCR06	CC.. 0602..	8; 11; 13; 16	4; 6; 7; 9	7; 9; 11; 15	6; 8; 10; 12	22; 27; 33; 42	100; 110; 125; 150	269028 7
SET09	186.12		186.12		158.40		A16Q SCLCR/L09; A20R SCLCR/L09; A25R SCLCR/L09	S16Q SCLCR09; S20R SCLCR09; S25R SCLCR09	CC.. 09T3..	20; 25; 28	10.7; 10.5; 14.5	15; 18; 23	– – –	180; 200; 200	269028 14	



**HOLEX** SDUC 93° boring bar sets for indexable inserts DC..

26 0348 – Without through-coolant feed.

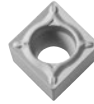


26 0346

Type	26 0346		26 0347		26 0348		ISO code toolholder	suitable indexable insert	∅ D <sub>min</sub>	L <sub>3</sub>	L <sub>2</sub>	L <sub>4</sub>	L <sub>1</sub>	L	Pack of insert screws	
	right-hand	left-hand	right-hand	left-hand	right-hand	left-hand										
	Boring bar set, steel, with IC				Boring bar set, steel, without IC		26 0346 26 0347	26 0348	mm	mm	mm	mm	mm	mm		
SET07	192.06		192.06		160.38		A0810H SDUCR/L07; A1012K SDUCR/L07; A1216M SDUCR/L07	S0810H SDUCR07; S1012K SDUCR07; S1216M SDUCR07	DC.. 0702..	12; 15.5; 18	6.5; 9; 11	9; 11; 15	8; 10; 12	22.5; 27.5; 40.5	100; 125; 150	269028 7
SET11	195.03		195.03		–		A16Q SDUCR/L11; A20R SDUCR/L11; A25R SDUCR/L11	–	DC.. 11T3..	25; 27; 32	13.6; 16; 18.5	15; 18; 23	– – –	180; 200; 200	269028 14	

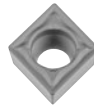
**HOLEX** Indexable inserts CC..

**CC.T finishing**



Grade		HBT020	HBT130	
<b>26 0084</b>	CCMT 060204	4.32	4.32	10
<b>26 0086</b>	CCMT 09T304	5.18	5.18	10
<b>26 0088</b>	CCMT 120404	6.08	6.08	10
●		P	M	
⊗				
Chip breaker		PF	M	
$a_p$	mm	0.4 – 2	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**CC.T Medium machining**



Grade		HBT020	HBT130	
<b>26 0210</b>	CCMT 060204	4.32	4.32	10
<b>26 0211</b>	CCMT 09T304	5.18	5.18	10
<b>26 0213</b>	CCMT 09T308	5.18	5.18	10
<b>26 0219</b>	CCMT 120404	6.08	6.08	10
<b>26 0221</b>	CCMT 120408	6.08	6.08	10
●		P	M	
⊗				
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 3	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	

**HOLEX** Indexable inserts DC..

**DC.. Finishing**



Grade		HBT020	HBT130	
<b>26 0376</b>	DCMT 070204	5.09	5.09	10
<b>26 0378</b>	DCMT 11T304	5.63	5.63	10
●		P	M	
⊗				
Chip breaker		PF	M	
$a_p$	mm	0.4 – 1.5	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**DC.T Medium machining**



Grade		HBT020	HBT130	
<b>26 0500</b>	DCMT 070204	5.09	5.09	10
<b>26 0503</b>	DCMT 11T302	5.63	5.63	10
<b>26 0507</b>	DCMT 11T304	5.63	5.63	10
<b>26 0508</b>	DCMT 11T308	5.63	5.63	10
●		P	M	
⊗				
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 2.5	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	

**HOLEX** Indexable inserts SC..

**SCMT Finish machining**



Grade		HBT020	HBT130	
<b>26 0758</b>	SCMT 09T304	4.32	4.32	10
		P	M	
Chip breaker		PF	M	
$a_p$	mm	0.4 – 1.5	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**SC.T Medium machining**



Grade		HBT020	HBT130	
<b>26 0791</b>	SCMT 09T304	4.32	4.32	10
<b>26 0793</b>	SCMT 120404	6.08	6.08	10
<b>26 0795</b>	SCMT 120408	6.08	6.08	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 2.5	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	

**HOLEX** Indexable inserts TC..

**TCMT Finish machining**



Grade		HBT020	HBT130	
<b>26 0966</b>	TCMT 110204	4.55	4.55	10
<b>26 0968</b>	TCMT 16T304	5.90	5.90	10
		P	M	
Chip breaker		PF	M	
$a_p$	mm	0.4 – 1.5	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**TC.T Medium machining**



Grade		HBT020	HBT130	
<b>26 1012</b>	TCMT 110204	4.55	4.55	10
<b>26 1018</b>	TCMT 16T304	5.90	5.90	10
<b>26 1019</b>	TCMT 16T308	5.90	5.90	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 2.5	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	



**HOLEX** Indexable inserts VB. T

**VBMT Finish machining**



Grade		HBT020	HBT130	
<sup>220</sup> 26 1186	VBMT 110304	8.69	8.69	10
<sup>220</sup> 26 1188	VBMT 160404	10.49	10.49	10
		P	M	
Chip breaker		PF	M	
$a_p$	mm	0.4 – 1.5	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**VBMT Medium machining**



Grade		HBT020	HBT130	
<sup>220</sup> 26 1252	VBMT 110304	8.69	8.69	10
<sup>220</sup> 26 1257	VBMT 160404	10.49	10.49	10
<sup>220</sup> 26 1259	VBMT 160408	10.49	10.49	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 2.5	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	

**HOLEX** Indexable inserts VC..

**VC.. Finishing**



Grade		HBT020	HBT130	
<sup>220</sup> 26 1386	VCMT 110304	8.69	8.69	10
<sup>220</sup> 26 1388	VCMT 160404	10.49	10.49	10
		P	M	
Chip breaker		PF	M	
$a_p$	mm	0.4 – 1.5	0.1 – 1	
$f$	mm/rev.	0.1 – 0.3	0.05 – 0.2	
$v_c$ main application	m/min	70 – 250	40 – 220	

**VC.T Medium machining**

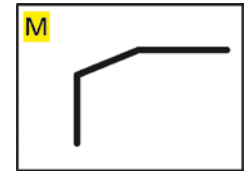
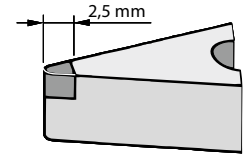


Grade		HBT020	HBT130	
<sup>220</sup> 26 1472	VCMT 110304	8.69	8.69	10
<sup>220</sup> 26 1474	VCMT 160404	10.49	10.49	10
<sup>220</sup> 26 1476	VCMT 160408	10.49	10.49	10
		P	M	
Chip breaker		PM	MM	
$a_p$	mm	0.5 – 2.5	0.3 – 2.5	
$f$	mm/rev.	0.12 – 0.3	0.05 – 0.35	
$v_c$ main application	m/min	70 – 250	40 – 220	

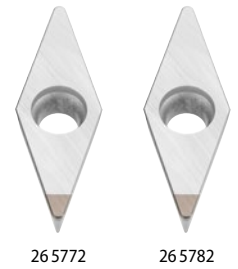
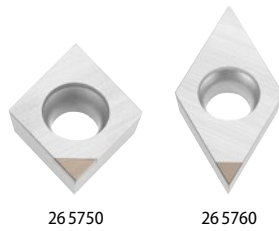
**HOLEX** Indexable inserts CBN (5° / 7°)

- Disposable insert.
- Single cutting edge.

**Note:** Further indexable insert shapes, sizes and corner radii available on request.



Cutting edge (chamfered). Chamfering even for slightly interrupted cutting.



Cutting edge version			M
26 5750	CCMW 060202	BUX220	19.53
26 5752	CCMW 060204	BUX220	19.53
26 5754	CCMW 09T302	BUX220	19.53
26 5756	CCMW 09T304	BUX220	19.53
26 5758	CCMW 09T308	BUX220	19.53
26 5760	DCMW 070202	BUX220	19.53
26 5762	DCMW 070204	BUX220	19.53
26 5764	DCMW 070208	BUX220	19.53
26 5766	DCMW 11T302	BUX220	19.53
26 5768	DCMW 11T304	BUX220	19.53
26 5770	DCMW 11T308	BUX220	19.53
$a_p$	mm		0.1 – 0.5
$f$	mm/rev.		0.1 – 0.2
$v_c$ main application	m/min		80 – 200

Cutting edge version			M
26 5772	VBMW 110302	BUX220	19.53
26 5774	VBMW 110304	BUX220	19.53
26 5776	VBMW 160402	BUX220	19.53
26 5778	VBMW 160404	BUX220	19.53
26 5780	VBMW 160408	BUX220	19.53
26 5782	VCMW 110302	BUX220	19.53
26 5784	VCMW 110304	BUX220	19.53
26 5786	VCMW 160402	BUX220	19.53
26 5788	VCMW 160404	BUX220	19.53
26 5790	VCMW 160408	BUX220	19.53
$a_p$ (26 5772, 26 5774, 26 5776, 26 5778, 26 5780)	mm		0.1 – 0.5
$a_p$ (26 5782, 26 5784, 26 5786, 26 5788, 26 5790)	mm		0.1 – 0.25
$f$	mm/rev.		0.1 – 0.2
$v_c$ main application	m/min		80 – 200

**HOLEX**

# SAFETY COMES FIRST: PERSONAL PROTECTIVE EQUIPMENT FROM HOLEX.



Modern safety glasses with foam frame for an excellent fit.

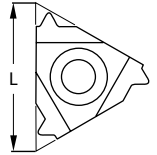


Fold-away ear defenders with padded headband.



Breathable assembly gloves for the highest demands when it comes to precision, flexibility and touch sensitivity.

**HOLEX** Threading inserts



Suitable for/ v <sub>c</sub> [m/min]	Alu plastics	Alu	Alu cast > 10% Si									INOX	INOX	Ti	GG(G)	CuZn	Graphite GRP CRP	Uni					
ISO code	N	N	N	P	P	P	P	P	H	H	H	M	M	S	K	N	N		●			●	○
27 0736–27 0817		220	150	130	130	110	85	75	35			85	85	40	110	130							

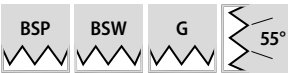
**Metric thread**



Pitch	mm	1	1,5	2	2,5	3	Thickness mm	Insert size L mm		
<b>27 0736</b>	Full profile insert 60°, external, right-hand	<b>HBX820</b>	9.18	9.18	9.18	9.36	9.36	10	3.6	16
<b>27 0784</b>	Full profile insert 60°, internal, right-hand	<b>HBX820</b>	9.18	9.18	9.18	9.36	9.36	10	3.6	16
Pitch	mm	0,5-3				Thickness mm	Insert size L mm			
<b>27 0748</b>	Partial profile insert 60°, external, right-hand	<b>HBX820</b>	9.36				10	3.6	16	
<b>27 0798</b>	Partial profile insert 60°, internal, right-hand	<b>HBX820</b>	9.36				10	3.6	16	



**Imperial thread**



TPI	14	11	Thickness mm	Insert size L mm			
<b>27 0807</b>	Full profile insert 55°, external, right-hand	<b>HBX820</b>	9.18	9.18	10	3.6	16
<b>27 0817</b>	Full profile insert 55°, internal, right-hand	<b>HBX820</b>	9.18	9.18	10	3.6	16



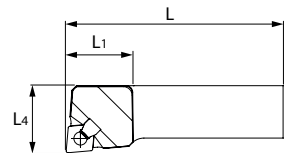
DIN 4984

**HOLEX** Screw-on toolholders for threading inserts

**External grooving**

Supplied with: With shim 1.5°.

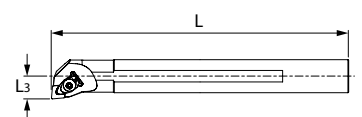
Shank / insert size	27 2015	L <sub>4</sub>	L <sub>1</sub>	L	Spare parts set
mm	<b>right-hand</b>	mm	mm	mm	
16/16	47.16	16	22	125	279981 1
20/16	48.96	20	22	125	279981 1
25/16	52.74	25	27	150	279981 1



**Internal grooving**

With fixed 1.5° inclination angle.

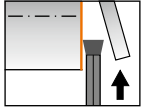
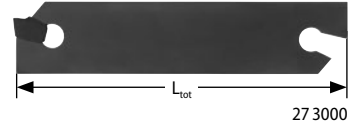
Shank Ø / insert size	27 2185	Ø D <sub>min</sub>	L <sub>3</sub>	L	Spare parts set
mm	<b>right-hand</b>	mm	mm	mm	
16/16	51.84	20	10.25	150	279981 2
20/16	53.64	25	13.3	180	279981 2
25/16	59.40	30	16.3	200	279981 2



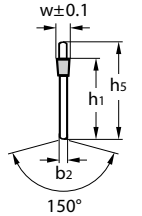


### HOLEX Parting-off tools for parting-off inserts No. 273010

**Suitable for:** Toolholder No. 273896 – 273898 or No. 319132; 319133 (VDI toolholder).  
**Application:** Only in conjunction with parting-off inserts No. 273010.  
**Supplied with:** Including key for changing inserts.



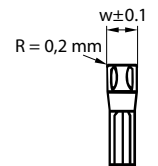
Blade height $h_s$ / groove width $w$	mm	19/2,2	19/3,1	26/2,2	26/3,1	32/2,2	32/3,1
<b>27 3000</b> Steel parting-off tool	neutral	49.86	49.86	53.28	53.28	56.34	56.34
for maximum workpiece $\varnothing$	mm	40	40	75	75	100	100
Width $b_2$	mm	1.6	2.4	1.6	2.4	1.6	2.4
Height $h_1$	mm	15.5	15.4	21.2	21.1	24.8	24.7
Overall length $L_{tot}$	mm	86	86	110	110	150	150



### HOLEX Parting-off inserts for parting-off tools No. 273000

**Application:** Only in conjunction with parting-off tool No. 273000.

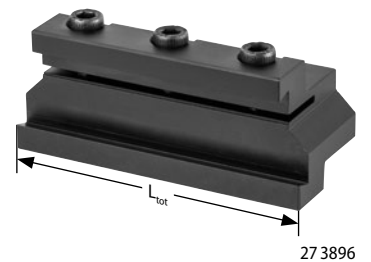
Suitable for/ $v_c$ [m/min]	Alu plastics	Alu	Alu cast > 10% Si								INOX	INOX	Ti	GG(G)	CuZn	Graphite GRP CRP	Uni						
ISO code	N	N	N	P	P	P	P	P	H	H	H	M	M	S	K	N	N						
27 3010				120	100	90	80					80	60		80								



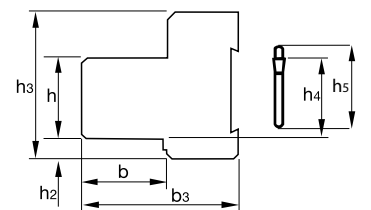
Groove width $w$	mm	2,2	3,1		
<b>27 3010</b> Parting-off insert	neutral	HBX25	6.30	6.53	10
Feed $f$ in steel < 900 N/mm <sup>2</sup>	mm/rev.	0.07	0.1		

### HOLEX Toolholders for parting-off tools No. 273000

**Application:** In conjunction with parting-off tool No. 273000.  
 Can also be used for many standard parting-off tools from other manufacturers.



Shank height $h$	mm	16	20	25	For blade height $h_s$ mm	Clamping screw
<b>27 3896</b>		93.15	–	–	19	279816 8
<b>27 3897</b>		–	97.20	97.20	26	279816 8
<b>27 3898</b>		–	107.55	107.55	32	279816 8
$h_4$	mm	16	20	25		
$h_2$ (27 3896, 27 3897)	mm	4	8	8		
$h_2$ (27 3898)	mm	–	13	8		
$h_3$ (27 3896, 27 3897)	mm	32	38	43		
$h_3$ (27 3898)	mm	–	48	48		
$b$	mm		20			
$b_3$	mm		36			
$L_{tot}$ (27 3896, 27 3897)	mm	80	90	100		
$L_{tot}$ (27 3898)	mm	–	100	100		



# SIMPLY. CLEVER. EFFICIENT. NEW. HOLEX GROOVING SYSTEM

## Simple:

**For all standard applications** in steel, stainless steel and cast iron, the new HOLEX grooving system impresses with a brilliant modular principle: The grooving inserts (neutral and full radius) simply fit everywhere – regardless of whether they are groove width 3 mm or 4 mm. Precise guidance and a clever clamping principle guarantee maximum process reliability and repetition accuracy.

## Clever:

**The clamping principle provides several advantages:**

- Double Vee guides ensure precise clamping.
- Clamp grooving inserts with width 3 mm or 4 mm using the same toolholder.

### One insert seat for two groove widths

Groove widths 3 mm and 4 mm.

### 45° stop

Ensures optimum clamping force.

### Double Vee guides

Optimum position and repetition accuracy.

### Special clamping

Precise fixing.

### No stop on the cutting edge

Guaranteed operational capability of the second cutting edge.

27 8044

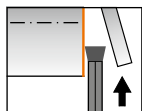
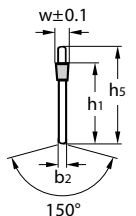
27 8015\_20

## **HOLEX** Parting off tools for parting-off inserts No. 278029 - 278036

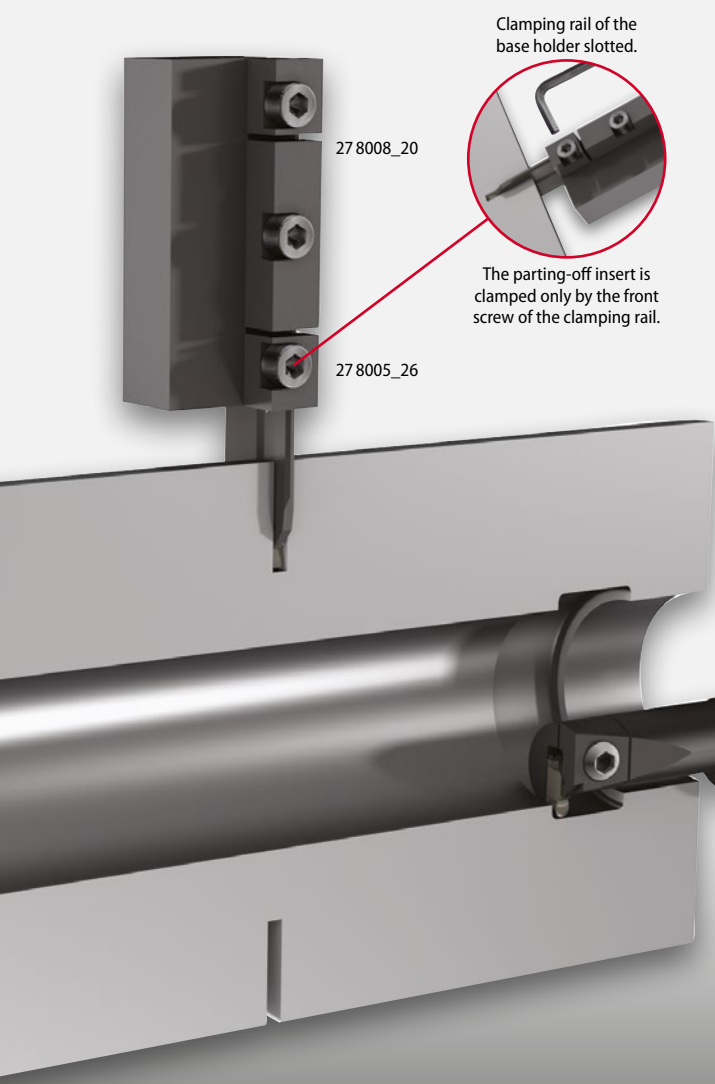
All sizes with just one insert seat for two groove widths (3 mm and 4 mm).

**Attention:** Parting-off insert can be clamped only in combination with base holders No. 278008 and 278009. The parting-off insert is easily replaced by releasing the front screw on the clamping strip of the base holder.

**Note:** From 14 mm groove depth onwards the second cutter comes into contact with the workpiece. This can lead to scoring.



Blade height $h_s$	mm	26	32
<b>27 8005</b> Parting-off tool		<b>53.10</b>	<b>57.60</b>
for maximum workpiece $\varnothing$	mm	60	65
Width $b_2$	mm		2.6
Height $h_1$	mm	21.4	25
Overall length $L_{tot}$	mm	110	150



Clamping rail of the base holder slotted.

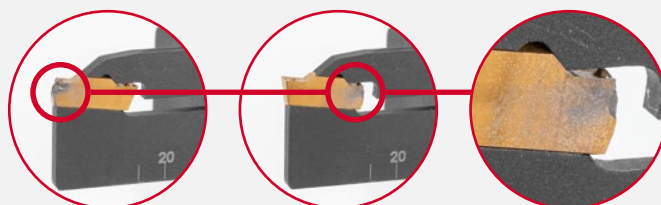
27 8008\_20

The parting-off insert is clamped only by the front screw of the clamping rail.

27 8005\_26

## Efficiency:

You can precisely clamp grooving inserts damaged on one side, since the positioning is not based on the second cutter being pushed through to the end. This means that the second cutting edge of the HOLEX grooving insert can always be used completely.

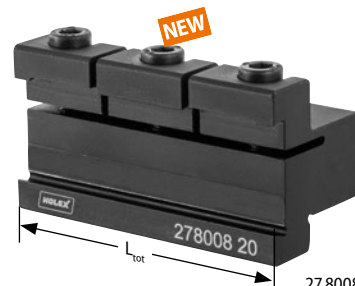
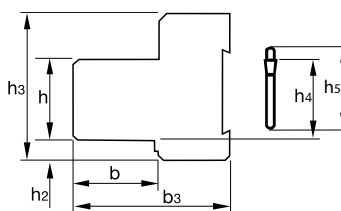


27 8023\_25



### HOLEX Toolholders for parting-off tools No. 278005

The slotted clamping strip allows the parting-off insert to be clamped in combination with grooving tool No. 278005. Can also be used for many standard grooving tools from other manufacturers (with other insert clamping).



27 8008

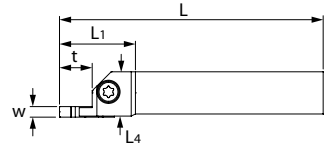
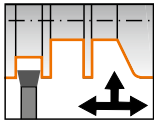
Shank height h	mm	16	20	25	For blade height h <sub>5</sub> mm	Clamping screw
27 8008		93.60	98.10	—	26	279816 1
27 8009		—	—	102.60	32	279816 2
h <sub>4</sub>	mm	16	20	25		
h <sub>2</sub>	mm	12	8	8		
h <sub>3</sub>	mm	39	39	48		
b	mm	16	20	20		
b <sub>3</sub>	mm	29	33	36		
L <sub>tot</sub>	mm	78	78	98		

**HOLEX** Grooving toolholder with groove depth  $t_{max} \leq 21$  mm

All sizes with just one insert seat for two groove widths (3 mm and 4 mm).



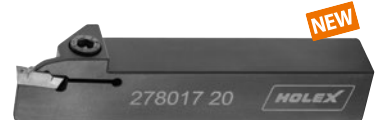
278015



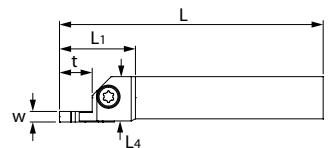
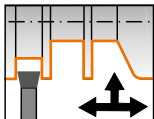
Shank size	278015	278016	Groove width w	$t_{max}$	$L_4$	$L_1$	L	Screw
mm	right-hand	left-hand	mm	mm	mm	mm	mm	
16	84.60	84.60	3; 4	21	16	39	109	279816 3 (SW5; 5 Nm)
20	89.10	89.10	3; 4	21	20	39	129	279816 4 (SW5; 5 Nm)
25	93.60	93.60	3; 4	21	25	39	129	279816 4 (SW5; 5 Nm)

**HOLEX** Grooving toolholder with groove depth  $t_{max} \leq 12$  mm

All sizes with just one insert seat for two groove widths (3 mm and 4 mm).



278017



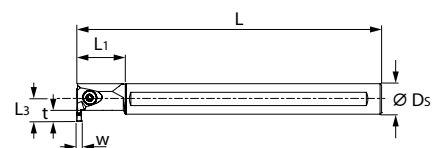
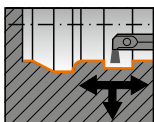
Shank size	278017	278018	Groove width w	$t_{max}$	$L_4$	$L_1$	L	Screw
mm	right-hand	left-hand	mm	mm	mm	mm	mm	
16	75.60	75.60	3; 4	12	16	30	100	279816 3 (SW5; 5 Nm)
20	80.10	80.10	3; 4	12	20	30	120	279816 4 (SW5; 5 Nm)
25	84.60	84.60	3; 4	12	25	30	120	279816 4 (SW5; 5 Nm)

**HOLEX** Grooving toolholder – boring bar

All sizes with just one insert seat for two groove widths (3 mm and 4 mm).



278023



Shank $\varnothing D_s$	278023	278024	Groove width w	$t_{max}$ internal machining	$\varnothing D_{min}$	$L_3$	$L_1$	L	Screw
mm	right-hand	left-hand	mm	mm	mm	mm	mm	mm	
20	93.60	93.60	3; 4	5	16.5	8	30	200	279816 5 (TX20; 5 Nm)
25	98.10	98.10	3; 4	5	25	12	50	200	279816 6 (SW5; 5 Nm)
32	116.10	116.10	3; 4	5	30	14.5	60	250	279816 7 (SW5; 5 Nm)



## HOLEX Mono grooving toolholder for face grooving

All sizes with just one insert seat for two groove widths (3 mm and 4 mm).  
For cutter inserts No. 278029 – 278036.

**Note:**  $D_1$  = minimum  $\varnothing$  for the first groove /  $D_2$  = maximum  $\varnothing$  for the first cut.  
Technology values should be reduced by 30 – 50% depending on the clamping situation and material.  
 $D_2 = 999$  in the size designation corresponds to theoretically infinite.

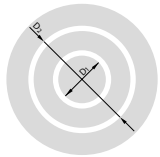
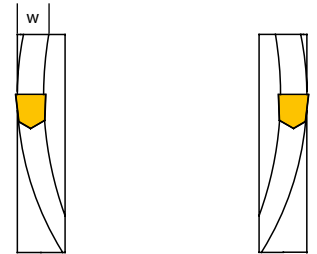
Available from October 2021



278041



278042



Groove range $\varnothing$ $D_1 / D_2$	Mono grooving toolholder for face grooving						$t_{max}$ mm	Shank width b			
	278041 right-hand	278042 left-hand	278043 right-hand	278044 left-hand	278045 right-hand	278046 left-hand		278041 278042 mm	278043 278044 mm	278045 278046 mm	
mm											
35/50	107.10	107.10	111.60	111.60	116.10	116.10	14	16×16	20×20	25×25	
50/75	107.10	107.10	111.60	111.60	116.10	116.10	14	16×16	20×20	25×25	
65/100	107.10	107.10	111.60	111.60	116.10	116.10	14	16×16	20×20	25×25	
90/130	–	–	111.60	111.60	116.10	116.10	14	–	20×20	25×25	
110/170	–	–	111.60	111.60	116.10	116.10	14	–	20×20	25×25	
160/250	–	–	111.60	111.60	116.10	116.10	14	–	20×20	25×25	
240/350	–	–	111.60	111.60	116.10	116.10	14	–	20×20	25×25	
340/999	–	–	111.60	111.60	116.10	116.10	14	–	20×20	25×25	
Groove width w mm	3;4	3;4	3;4	3;4	3;4	3;4					

## HOLEX Parting-off / grooving inserts

Suitable for: Holders No. 278005 and 278015 – 278046.

Suitable for/ $v_c$ [m/min]	Alu plastics	Alu	Alu cast > 10% Si	$< 500 N$	$< 750 N$	$< 900 N$	$< 1100 N$	$< 1400 N$	$< 55 HRC$	$< 60 HRC$	$< 67 HRC$	INOX $< 900 N$	INOX $> 900 N$	Ti $> 850 N$	GG(G)	CuZn	Graphite GRP CRP	Uni					
ISO code	N	N	N	P	P	P	P	P	H	H	H	M	M	S	K	N	N		●	●	○	●	
278029/8036				150	130	120	100					100	80		140				●	●	○	●	



278029



278036

Groove width w		mm	3	4		●	○
278029	Parting-off / grooving insert neutral	HBG25	11.25	12.15	10	P	M
278036	Parting-off / grooving insert Full radius	HBG25	11.25	12.15	10	P	M
Corner radius (278029)		mm	0.3				
Tolerance groove width w		mm	$\pm 0.04$				
f		mm/rev.	0.07 – 0.2	0.1 – 0.26			

**HOLEX** Tool bits

Tool bits with straight-cut square ends.

29 5000 – **Square tool bits to DIN 4964 form B. Width: Tolerance h12.** Ends chamfered.

29 5020 – **Tool bits to DIN 4964 form A.** Precision ground within tolerance h14.

29 5030 – **Solid carbide.** Precision round tool bits. Ground within tolerance h6.

29 5060 – **Rectangular tool bits to DIN 4964 form D.**

29 5080 – **Trapezoidal tool bits to DIN 4964 form E.**

29 5000/5020 – **HSS Co 10** (10 % cobalt, 67 HRC).

29 5060/5080 – Height and width: Tolerance **h14. HSS Co 10** (10 % cobalt).

**Application:** For turning, boring out, grooving etc.; particularly for production of blanks for profile cutters.



HSS Co 10 29 5000



HSS Co 10 29 5020



Solid carbide 29 5030



HSS-Co 10



HSS-Co 10

DxLength	29 5000		29 5020		29 5030	
	Square tool bit		Round tool bit			Length
	HSS Co 10		HSS Co 10		Solid carbide	
2x40	—		3.83		—	
3x63	—		4.59		—	
3x100	—		—		7.43	
4x63	—		4.15		—	
4x80	4.95		5.27		—	
4x100	—		—		9.77	
5x63	—		4.82		—	
5x80	5.18		5.49		—	
5x100	—		—		13.50	
6x63	—		6.08		—	
6x80	7.07		7.47		—	
6x100	8.69		9.27		16.34	
8x63	8.06		9.09		—	
8x80	—		10.44		—	
8x100	13.05		11.25		25.38	
8x125	15.80		13.23		—	
8x160	20.70		—		—	
10x63	9.32		7.79		—	
10x80	12.60		10.35		—	
10x100	15.66		12.56		37.08	
10x125	19.53		—		—	
10x160	24.93		19.53		—	
10x200	31.95		—		—	
12x63	12.47		—		—	
12x80	16.43		14.67		—	
12x100	20.52		18.54		45.36	
12x125	25.83		22.86		—	
12x160	32.94		29.34		—	
12x200	41.04		—		—	
14x100	26.28		—		63.00	
14x125	32.67		—		—	
14x160	41.40		34.11		—	
14x200	52.02		—		—	
16x100	29.43		—		80.10	
16x125	36.90		30.69		—	
16x160	47.16		38.88		—	
16x200	59.04		—		—	
20x100	—		—		119.25	
20x160	61.38		60.12		—	
20x200	76.86		74.52		—	
25x160	108.90		—		—	
25x200	136.35		—		—	

Heightx width	29 5060		29 5080		Length	
	Square tool bit		Trapezoidal tool bit		29 5060	29 5080
	HSS Co 10		HSS Co 10			
8x4	8.55		—		100	—
10x2,5	—		14.40		—	80
10x2,5L	—		17.78		—	125
10x5	18.90		—		160	—
10x6	18.90		—		160	—
12x3	—		20.79		—	160
12x6	23.04		—		160	—
12x8	30.87		—		160	—
16x4	12.60		19.71		80	100
16x4L	14.67		29.61		100	160
16x4XL	21.51		—		160	—
16x10	27.63		—		100	—
16x10L	40.23		—		160	—
16x10XL	50.94		—		200	—
20x5	—		45.18		—	160
20x5L	—		52.38		—	200
20x12	57.24		—		160	—
25x6	51.48		55.26		200	160
25x12	91.35		—		200	—

**HOLEX** HSS/E turning tool

All dimensions **welded**.

**Application:** Universally applicable, medium cutting speeds.

Shank square	mm	12	16	20	
<b>2ZE 29 6100</b>	Turning tool right-hand similar to DIN 4952	HSS E	28.62	38.88	43.47
Overall length	mm	110	140	160	



Shank Ø	mm	8	10	12	16	
<b>2ZE 29 6300</b>	Internal turning tool right-hand similar to DIN 4953	HSS E	21.33	26.19	30.42	35.55
Overall length	mm	140	160	180	220	
for bores from Ø	mm	18	20	22	30	



Shank Ø	mm	6R	8R	10R	12R	16R	
<b>2ZE 29 6400</b>	Internal corner turning tool right-hand similar to DIN 4954	HSS E	17.19	20.25	23.13	27.81	32.49
Overall length	mm	125	140	160	180	220	
for bores from Ø	mm	16	18	20	22	30	



Shank square	mm	12	16	20	
<b>2ZE 29 6500</b>	Pointed turning tool, straight neutral similar to DIN 4955	HSS E	29.61	40.95	52.02
<b>2ZE 29 6750</b>	Corner turning tool cranked right-hand similar to DIN 4965	HSS E	30.42	37.62	46.08
Overall length	mm	110	140	160	



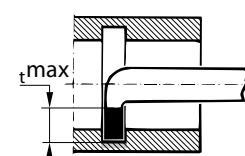
Shank square	mm	12	16	20	
<b>2ZE 29 6800</b>	Side turning tool right-hand similar to DIN 4960	HSS E	27.99	35.55	42.48
Overall length	mm	110	140	160	



Shank height	mm	12	16	20	
<b>2ZE 29 7000</b>	Parting off tool right-hand similar to DIN 4961	HSS E	29.88	33.93	35.91
Overall length	mm	110	125	140	
Shank width	mm	8	10	12	
Blade width	mm	3	3	4	



Shank Ø	mm	6	8	10	12	16	20	
<b>2ZE 29 7120</b>	Hook turning tool right-hand similar to DIN 4963	HSS E	32.85	35.82	40.95	47.34	50.76	66.78
Overall length	mm	125	140	160	180	210	250	
Blade width	mm	2	2	3	3	4	5	
for bores from Ø	mm	13	16	20	25	32	40	
maximum grooving depth t <sub>max</sub>	mm	3	4	6	8	10	14	



**HOLEX** Carbide tipped turning tool

**Turning tool**

Fitted with diamond ground carbide inserts.

**Application:** P20/K25 for machining steel and cast iron.  
M20 for machining stainless steels.

**Attention:** For rough and interrupted machining the cutting edges should be sharpened with a boron carbide hand lapper (No. 558812).

Shank square	mm	10	12	16	20	25	
<sup>2/E</sup> 29 6025	Turning tool right-hand, similar to DIN 4971 (ISO 1)	P20/K25	5.54	6.62	7.88	10.17	14.67
<sup>2/E</sup> 29 6030		M20	5.54	6.62	7.88	10.17	14.67
Overall length	mm	90	100	110	125	140	



Shank square	mm	10	12	16	20	25	32	
<sup>2/E</sup> 29 6125	Turning tool right-hand, similar to DIN 4972 (ISO 2)	P20/K25	5.54	6.98	8.15	10.31	14.72	24.57
<sup>2/E</sup> 29 6130		M20	5.54	6.98	8.15	10.31	14.72	24.57
<sup>2/E</sup> 29 6225	Turning tool left-hand, similar to DIN 4972 (ISO 2)	P20/K25	5.54	6.98	8.15	10.31	14.72	–
Overall length	mm	100	100	110	125	140	170	



Shank square	mm	10	12	16	20	25	
<sup>2/E</sup> 29 6325	Internal turning tool right-hand, similar to DIN 4973 (ISO 8)	P20/K25	7.83	8.19	10.17	12.42	18.81
<sup>2/E</sup> 29 6330		M20	7.83	8.19	10.17	12.42	18.81
Overall length for bores from Ø	mm	150	180	210	250	300	
	mm	18	21	27	34	43	



Shank square	mm	10	12	16	20	25	
<sup>2/E</sup> 29 6425	Internal corner turning tool right-hand, similar to DIN 4974 (ISO 9)	P20/K25	7.74	8.19	10.17	12.42	17.01
<sup>2/E</sup> 29 6430		M20	7.74	8.19	10.17	12.42	17.01
<sup>2/E</sup> 29 6455	Internal corner turning tool left-hand, similar to DIN 4974 (ISO 9)	P20/K25	7.74	8.19	10.17	12.42	17.01
Overall length for bores from Ø	mm	150	180	210	250	300	
	mm	18	21	27	34	43	



Shank height	mm	16	20	25	
<sup>2/E</sup> 29 6525	Turning tool neutral, similar to DIN 4975 (ISO 10)	P20/K25	6.57	7.74	9.27
Overall length	mm	110	125	140	
Shank width	mm	10	12	16	



Shank height	mm	10	12	16	20	25	
<sup>2/E</sup> 29 6605	Turning tool, wide neutral, similar to DIN 4976 (ISO 4)	P20/K25	6.84	8.28	10.04	8.60	11.43
Overall length	mm	90	100	110	125	140	
Shank width	mm	10	12	16	12	16	
Blade width	mm	10	12	16	12	16	

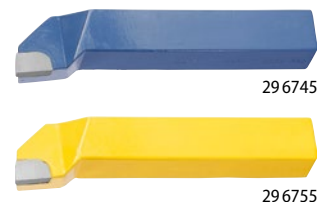


Shank square	mm	10	12	16	20	25	
<sup>2/E</sup> 29 6705	Face turning tool right-hand, similar to DIN 4977 (ISO 5)	P20/K25	5.72	6.98	8.28	10.89	14.99
<sup>2/E</sup> 29 6715		M20	5.72	6.98	8.28	10.89	14.99
Overall length	mm	90	100	110	125	140	





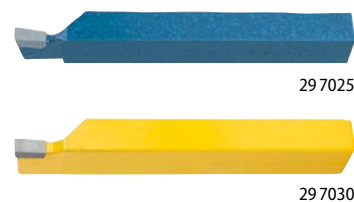
Shank square		mm	10	12	16	20	25
<sup>2ZE</sup> 29 6745	Corner turning tool right-hand, similar to DIN 4978 (ISO 3)	P20/K25	5.72	6.98	8.28	10.89	14.99
<sup>2ZE</sup> 29 6755		M20	5.72	6.98	8.28	10.89	14.99
Overall length		mm	90	100	110	125	150



Shank square		mm	10	12	16	20	25
<sup>2ZE</sup> 29 6825	Turning tool right-hand, similar to DIN 4980 (ISO 6)	P20/K25	6.39	6.84	8.19	10.26	14.13
<sup>2ZE</sup> 29 6830		M20	6.39	6.84	8.19	10.26	14.13
<sup>2ZE</sup> 29 6925	Turning tool left-hand, similar to DIN 4980 (ISO 6)	P20/K25	6.39	6.84	8.19	10.26	14.13
Overall length		mm	90	100	110	125	140



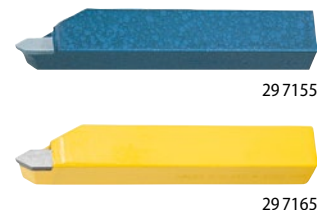
Shank height		mm	12	16	20	25	32
<sup>2ZE</sup> 29 7025	Grooving tool right-hand, similar to DIN 4981 (ISO 7)	P20/K25	6.03	6.71	8.10	10.31	14.36
<sup>2ZE</sup> 29 7030		M20	6.03	6.71	8.10	10.31	14.36
<sup>2ZE</sup> 29 7105	Grooving tool left-hand, similar to DIN 4981 (ISO 7)	P20/K25	6.03	6.71	8.10	10.31	14.36
Overall length		mm	100	110	125	140	170
Shank width		mm	8	10	12	16	20
Blade width		mm	3	4	5	6	8



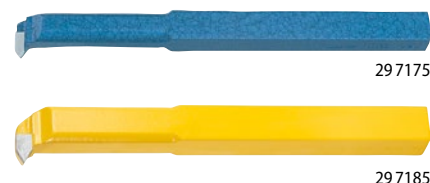
Shank square		mm	10	12	16	20	25
<sup>2ZE</sup> 29 7135	Hook turning tool right-hand, similar to DIN 263 (ISO 11)	P20/K25	10.71	13.05	15.12	17.01	22.95
<sup>2ZE</sup> 29 7145		M20	10.71	13.05	15.12	17.01	22.95
Overall length		mm	150	160	180	210	250
Blade width		mm	3	4	5	6	8
for bores from Ø		mm	25	30	40	50	60
maximum grooving depth t <sub>max</sub>		mm	6	10	12	16	20



Shank square		mm	10	12	16	20	25
<sup>2ZE</sup> 29 7155	Thread turning tool right-hand, similar to DIN 282 (ISO 12)	P20/K25	10.53	12.65	15.12	18.99	22.14
<sup>2ZE</sup> 29 7165		M20	10.53	12.65	15.12	18.99	22.14
Overall length		mm	90	110	125	140	140



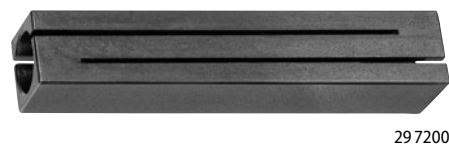
Shank square		mm	10	12	16	20	25
<sup>2ZE</sup> 29 7175	Internal thread turning tool right-hand, similar to DIN 283 (ISO 13)	P20/K25	13.23	16.02	20.34	23.04	29.70
<sup>2ZE</sup> 29 7185		M20	13.23	16.02	20.34	23.04	29.70
Overall length		mm	150	160	180	210	250
for bores from Ø		mm	20	30	36	45	55



### Turning toolholder with bore

Slotted in opposite direction; the round boring bar shank is clamped firmly and securely with only little pressure. All external surfaces are machined square.

**Application:** For holding turning tools with a round shank No. 296300, 296400, 297120 and for round tool bits No. 295020.



Bore Ø		mm	6	8	10	12	16	20
<sup>2ZE</sup> 29 7200	Turning toolholder with bore		41.58	44.01	46.62	54.90	65.16	80.82
Height		mm	10	12	14	16	20	25
Overall length		mm	70	80	85	90	100	110

**HOLEX VDI toolholders**

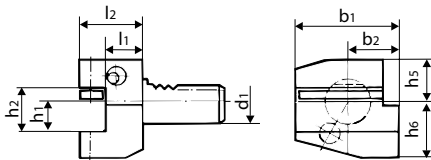
- Case-hardened HRC 58 ±2.
- All functional faces ground.
- With ball type coolant nozzles.

Standard: ISO 10889 / DIN 69880 / VDI 3425, sheet 2.

**Form B1, B2, B3, B4, B5, B6, B7 and B8**

Form B

Application: Mainly for external machining.



Size 20 – 40:  
With screw-in coolant  
nozzle up to 80 bar.



31 9000



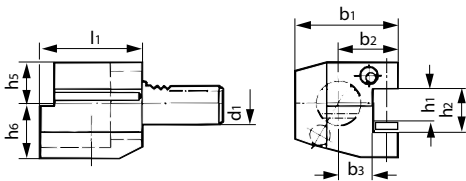
31 9010

Shank Ø d <sub>1</sub>	mm	16	20	30	40	50
<b>31 9000</b>	<b>Toolholder form B1 radial right-hand, short</b>	71.10	60.48	68.31	81.72	143.55
<b>31 9010</b>	<b>Toolholder form B2 radial left-hand, short</b>	70.74	66.96	73.08	88.56	142.65
h <sub>1</sub>	mm	12	16	20	25	32
h <sub>2</sub>	mm	17	22	29	34	41
b <sub>1</sub>	mm	42	55	70	85	100
b <sub>2</sub>	mm	25	30	35	42.5	50
h <sub>5</sub>	mm	20	30	38	48	35
h <sub>6</sub>	mm	22	25	35	42.5	60
l <sub>1</sub>	mm	13	16	22	22	30
l <sub>2</sub>	mm	24	30	40	44	55
Colour code for VDI shanks						

**Form C1, C2, C3, and C4**

Form C

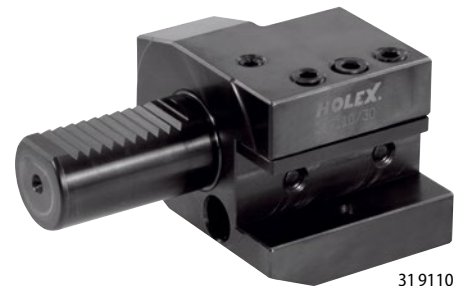
Application: For plane cutting in.



Size 20 – 40:  
With screw-in coolant  
nozzle up to 80 bar.



31 9100



31 9110

Shank Ø d <sub>1</sub>	mm	16	20	30	40	50
<b>31 9100</b>	<b>Toolholder form C1 axial, right hand</b>	75.60	78.48	81.18	103.05	159.30
h <sub>1</sub>	mm	12	16	20	25	32
h <sub>2</sub>	mm	17	22	29	34	41
b <sub>1</sub>	mm	43	52	70	85	100
b <sub>2</sub>	mm	24	27	35	42.5	50
b <sub>3</sub>	mm	13	13	17	20.5	26
h <sub>5</sub>	mm	20	25	28	32.5	50
h <sub>6</sub>	mm	22	30	38	48	60
l <sub>1</sub>	mm	44	55	70	85	100
Colour code for VDI shanks						

Shank Ø d <sub>1</sub>	mm	16	20	30	40	50
<b>31 9110</b>	<b>Toolholder form C2 axial, left-hand</b>	76.68	82.44	89.64	111.15	158.40
h <sub>1</sub>	mm	12	16	20	25	32
h <sub>2</sub>	mm	17	22	29	34	41
b <sub>1</sub>	mm	43	52	70	85	100
b <sub>2</sub>	mm	24	27	35	42.5	50
b <sub>3</sub>	mm	13	13	17	20.5	26
h <sub>5</sub>	mm	20	25	28	32.5	50
h <sub>6</sub>	mm	22	30	38	48	60
l <sub>1</sub>	mm	44	55	70	85	100
Colour code for VDI shanks						

Colour code: VDI 16 VDI 20 VDI 30 VDI 40 VDI 50

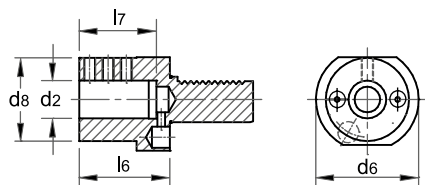
Form E

**HOLEX** VDI toolholders

Standard: DIN 69880 / VDI 3425, sheet 2.

**Form E1**

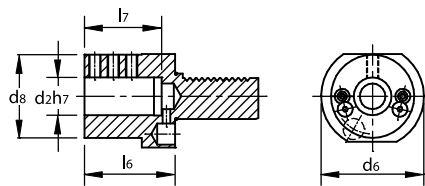
**Application:** For drilling with indexable drill with internal coolant supply.



Bore d <sub>2</sub> (H6)	mm	16	20	25	32	40	d <sub>6</sub> mm	Colour code for VDI shanks
<sup>32V</sup> 31 9200	Indexable drill holder	VDI 30	79.74	79.74	79.74	79.74	68	■
<sup>32V</sup> 31 9250	Form E1	VDI 40	(87.48)	87.48	83.16	83.16	83	■
∅ d <sub>3</sub>	mm	36	40	45	52	65		
l <sub>1</sub> -0.2	mm	67	67	75	71	90		
l <sub>2</sub>	mm	54	54	59	63	73		

**Form E2**

**Application:** For internal machining with boring bar holder.



Bore d <sub>2</sub> (H7)	mm	8	10	12	16	20	25	32	40	50	d <sub>6</sub> mm	Colour code for VDI shanks
<sup>32V</sup> 31 9350	Boring bar holder	VDI 30	70.74	70.74	70.74	70.74	70.74	70.74	70.74	—	68	■
<sup>32V</sup> 31 9400	Form E2	VDI 40	72.72	72.72	72.72	72.72	72.72	72.72	72.72	130.95	83	■
l <sub>6</sub> (31 9350)	mm	61	60	60	60	60	60	75	—	—		
l <sub>6</sub> (31 9400)	mm	75	75	75	75	75	75	75	90	90		
l <sub>7</sub> (31 9350)	mm	51	51	51	51	51	51	61	—	—		
l <sub>7</sub> (31 9400)	mm	61	61	61	61	61	61	61	76	76		

Colour code: ■ VDI 30 ■ VDI 40



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