

Hexa Blade

Grooving and Parting tool with precision 6 corners

- Grooving and Parting tool with high economical 6 corners
- Increased reliability and stability in cutting due to high qualified cutting edge



Hexa Blade

KORLOY has launched the Hexa Blade, a precision insert grooving and cutting processing that provides high economic efficiency with its 6-cornered design.

The uniquely shaped 6-corner Hexa Blade applies precision manufacturing technology, ensuring consistent assembly dimension even when changing corners, thereby guaranteeing stable processing quality.

The **Hexa Blade 19** insert, for automatic lathe, optimizes precision machining with a newly developed coating, delivering excellent precision machining performance and provides superior fracture resistance and surface finish quality.

The **Hexa Blade 27** insert's bumped chip breaker provides outstanding chip control in various machining process.

The wide cutting face and three-sided clamping system of the Hexa Blade holder offer stable clamping and enhance tool life under various machining conditions. One holder can easily mount various inserts on the clamping side with a screw, ensuring excellent user convenience.

The high-pressure coolant hole of the Hexa Blade holder delivers focused spray of coolant on the cutting edge, maximizing cooling effects and chip control which provides outstanding productivity.

» **High cost efficiency**

- 6 cornered insert for Grooving and Parting

» **Excellent Machining Performance**

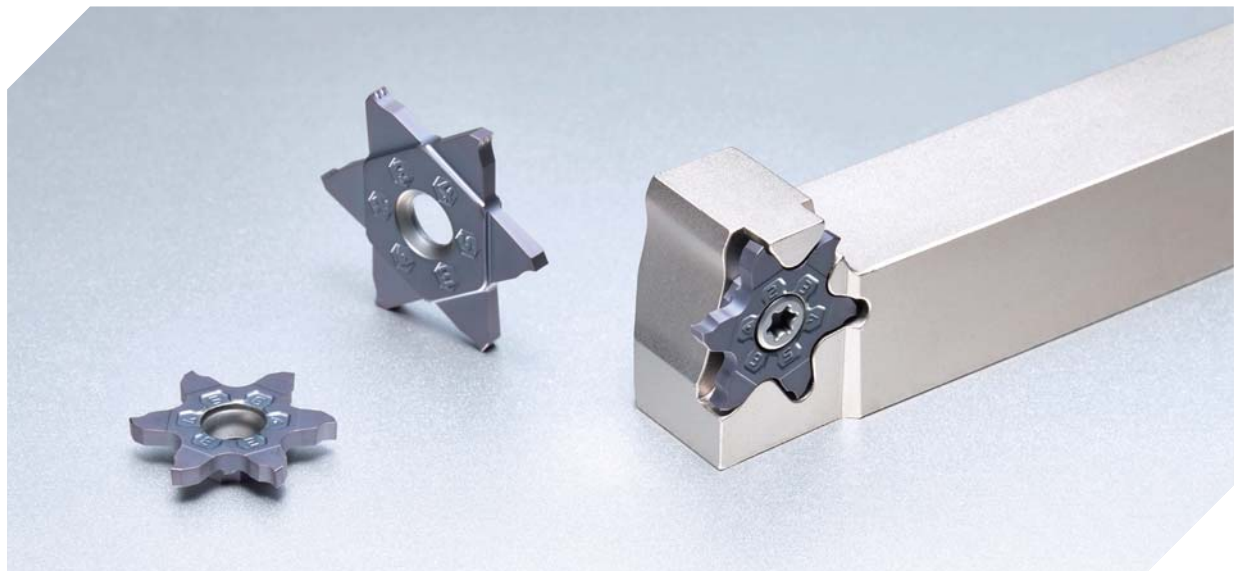
- Achieves superior surface finish with sharp cutting edges (HB19)
- Improves chip control with bumped chip breaker (HB27)

» **Regular cutting quality**

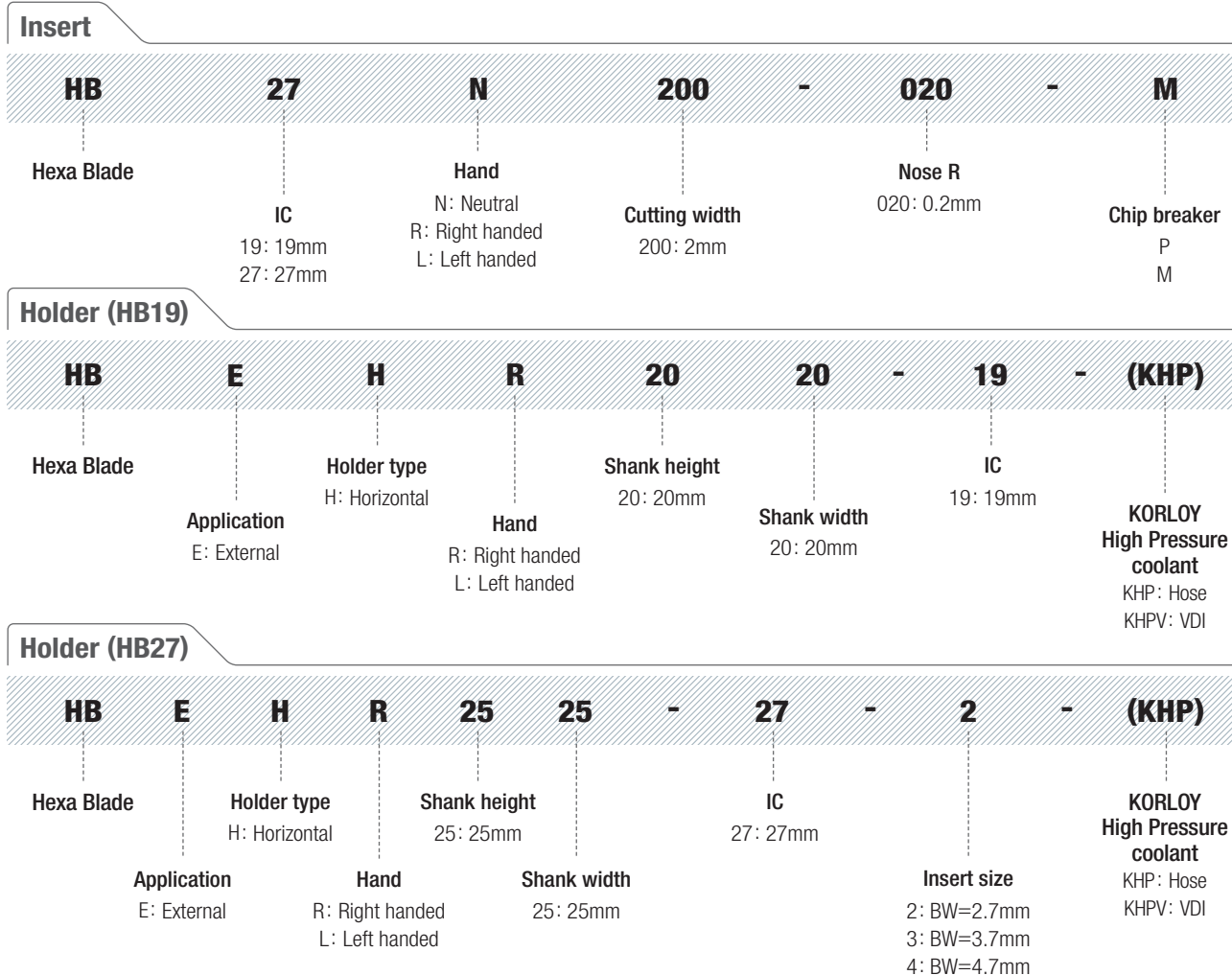
- Excellent corner dimension deviation management from precision manufacturing technology

» **High cutting stability**

- Strong clamping system from wide clamping side and 3-sided clamping








Code system



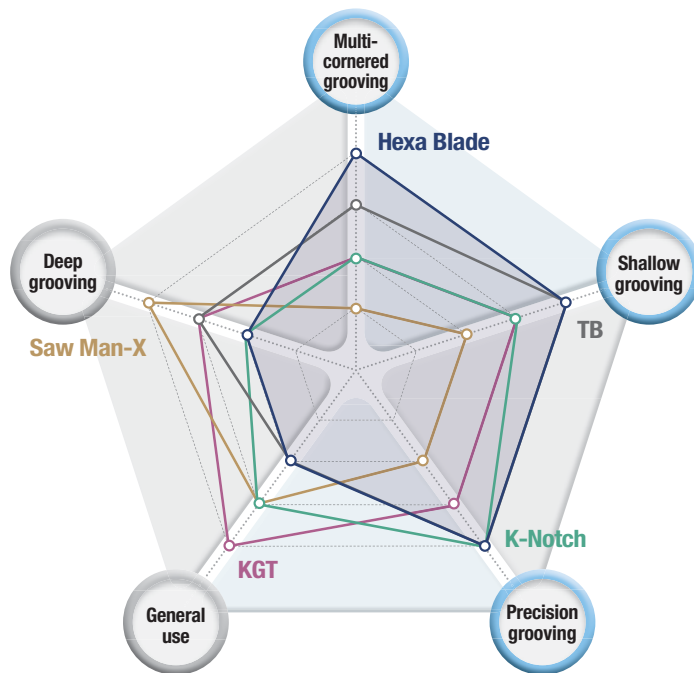
* IC : Inscribed circle diameter

Cutting width and cutting depth by tools

◎: 1st recommendation ○: 2nd recommendation

| Tool | Cutting width (mm) | | | | No. of edges | External cutting | | | | Feature |
|---|----------------------------|------|---|---|--------------|------------------|---------|---------|---------|--|
| | 2 | 4 | 6 | 8 | | Grooving | Cutting | Turning | Copying | |
| | Cutting depth maximum (mm) | | | | | | | | | |
| Hexa Blade 19   | 0.75 | 3.18 | | | 6 | ◎ | ○ | | | <ul style="list-style-type: none"> Precision Grade (Sharp Edge) Offers high economic efficiency Optimized for automated machining |
| Hexa Blade 27  | 1.78 | 4 | | | 6 | ◎ | ○ | ○ | | <ul style="list-style-type: none"> Precision Grade (C/B Type) High economic efficiency Excellent chip control |
| TB 3, 4  | 1.25 | 4.5 | | | 3 | ◎ | ○ | ○ | | <ul style="list-style-type: none"> Precision Grade (Sharp Edge, C/B Type) Optimized for automated machining |
| TB 5  | 1.25 | 4.5 | | | 3 | ◎ | ◎ | ○ | ○ | <ul style="list-style-type: none"> Precision Grade (Sharp Edge, C/B Type) Excellent chip control |

✔ Tool selection guide



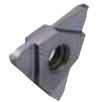
Hexa Blade ^{New}

- Precision typed and 6 cornered insert
- High economic efficiency and optimized for automated machining
- Precision grooving and multi-cornered grooving



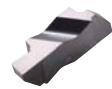
TB

- Precision typed and 3 cornered insert
- Optimal for automatic cutting
- Precision grooving



K-Notch

- Precision typed and 2 cornered insert
- Strong clamping system
- Precision grooving



KGT

- 2 cornered insert
- Various applications
- For general use



Saw Man-X

- 1 cornered insert
- Optimal for interrupted and high feed parting
- Deep grooving

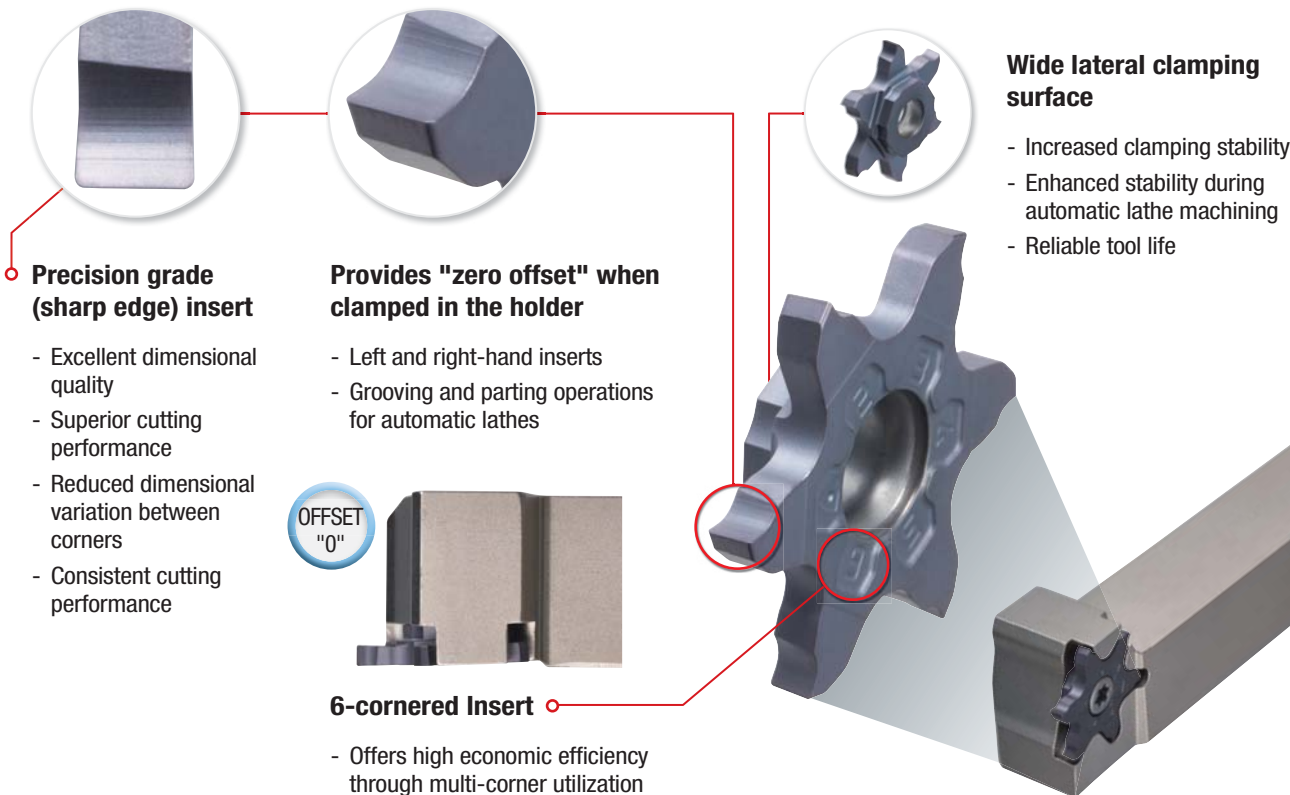


| Tools | Multi-cornered grooving | Shallow grooving | Precision grooving | General use | Deep grooving |
|---------------------------|-------------------------|------------------|--------------------|-------------|---------------|
| Hexa Blade ^{New} | ★★★★★ | ★★★★★ | ★★★★★ | ★★ | ★★ |
| TB | ★★★ | ★★★★★ | ★★★★★ | ★★ | ★★★ |
| K-Notch | ★★ | ★★★ | ★★★★★ | ★★★ | ★★ |
| KGT | ★★ | ★★★ | ★★★ | ★★★★★ | ★★★ |
| Saw Man-X | ★ | ★★ | ★★ | ★★★ | ★★★★★ |

 **Features**

Hexa Blade 19 (P chip breaker) 

- Universal chip breaker usable for various work materials
- Excellent cutting performance and superior surface finish achieved through sharp cutting edges



Precision grade (sharp edge) insert

- Excellent dimensional quality
- Superior cutting performance
- Reduced dimensional variation between corners
- Consistent cutting performance

Provides "zero offset" when clamped in the holder

- Left and right-hand inserts
- Grooving and parting operations for automatic lathes

Wide lateral clamping surface

- Increased clamping stability
- Enhanced stability during automatic lathe machining
- Reliable tool life

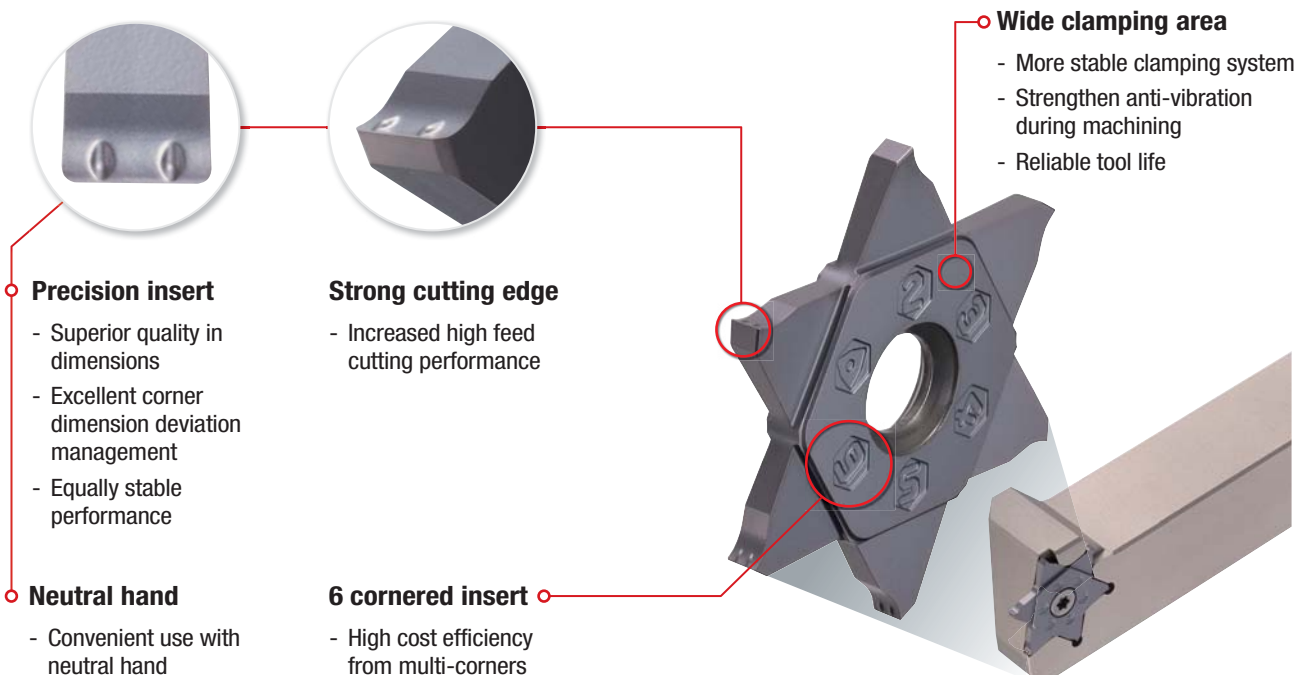
6-cornered Insert

- Offers high economic efficiency through multi-corner utilization

OFFSET "0"

Hexa Blade 27 (M chip breaker)

- Dot-typed chip breaker general cutting for various workpieces
- Good chip control preventing long chip and chip curling
- Stable cutting even in high feed cutting due to strengthened cutting edge structure



Precision insert

- Superior quality in dimensions
- Excellent corner dimension deviation management
- Equally stable performance

Strong cutting edge

- Increased high feed cutting performance

Wide clamping area

- More stable clamping system
- Strengthen anti-vibration during machining
- Reliable tool life

6 cornered insert

- High cost efficiency from multi-corners

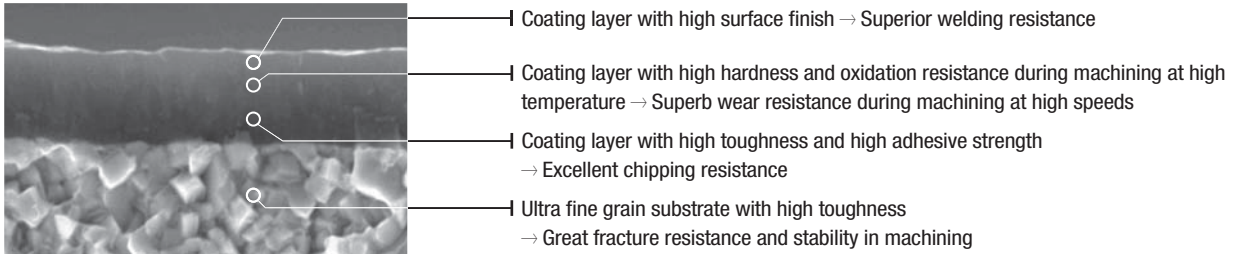
Neutral hand

- Convenient use with neutral hand

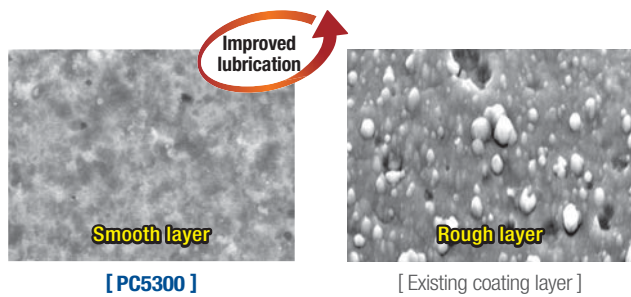
Grade features

PC5300

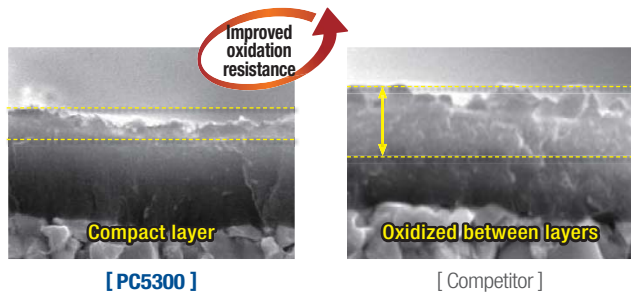
- PVD coating layer with high hardness and oxidation resistance during machining at high temperature
→ Superior oxidation resistance during machining of steel, cast iron, stainless steel, and heat-resistance alloys
- Ultra fine grain substrate with high toughness and special treatment on the surface
→ Improved welding resistance and chipping resistance



- Special treatment on the surface
(Attached pictures if surface of coating layer)

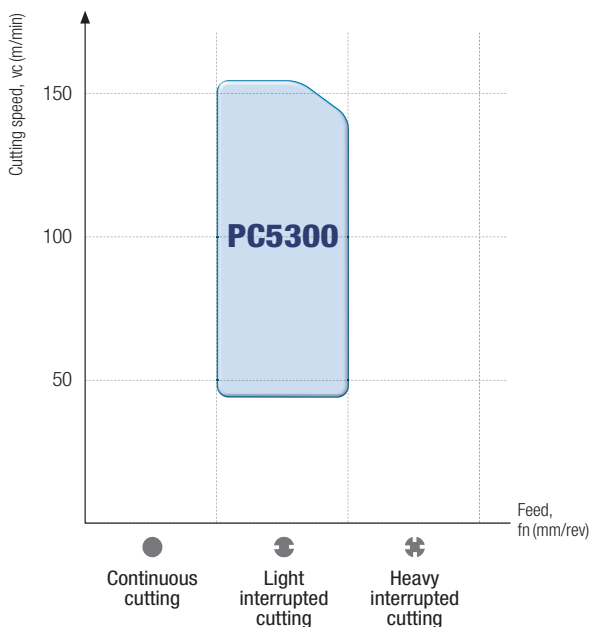


- Coating layer with oxidation resistance during machining at high temperature
(after 900° heat treatment)

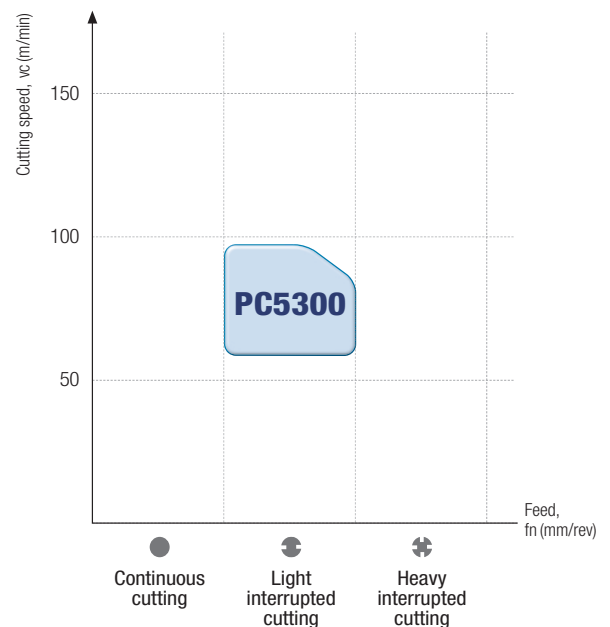


Application range

P Steel



M Stainless steel

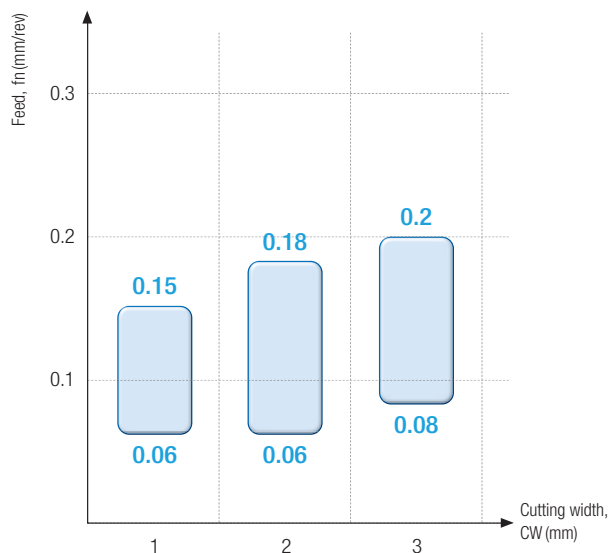
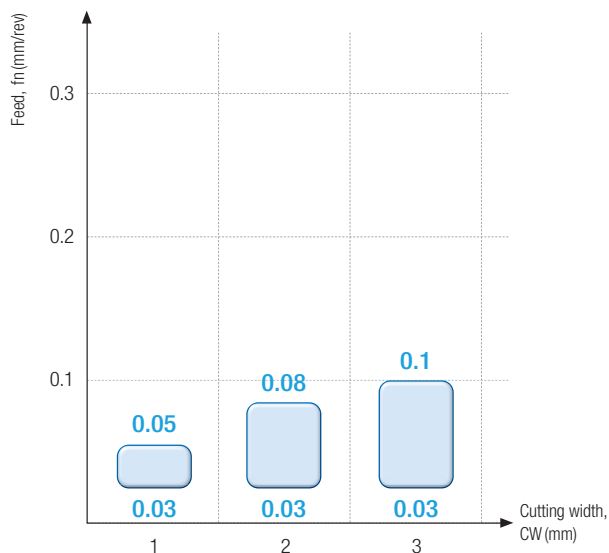


Recommended cutting conditions

* fn, ap: CW = Based on 2mm

| ISO | Workpiece | | | | | | PC5300 | Hexa Blade 19 | Hexa Blade 27 | | | | | |
|------------------|--------------------|-----------------------|---------|--------------|---|-----------------------|------------------|---------------|---------------|-------------|---------|-----------|-------------|-------------|
| | Workpiece material | | ISO | AISI | Specific cutting force (N/mm ²) | Brinell hardness (HB) | vc (m/min) | fn (mm/rev) | ap (mm) | fn (mm/rev) | ap (mm) | | | |
| P | Carbon steel | C = 0.25~0.55% | C35 | 1035 | 1600 | 150 | 110 | 0.08 | ≤4 | 0.15 | ≤5 | | | |
| | | | | | | | 130 | 0.05 | | 0.12 | | | | |
| | | | | | | | 150 | 0.03 | | 0.1 | | | | |
| | | C = 0.55~0.80% | C45 | 1045 1046 | 1700 | 170 | 80 | 0.08 | | 0.15 | | | | |
| | | | | | | | 100 | 0.05 | | 0.12 | | | | |
| | | | | | | | 120 | 0.03 | | 0.1 | | | | |
| | Low-alloy steel | Non-hardened | 43CrMo4 | 4140 | 1700 | 180 | 80 | 0.08 | | 0.15 | | | | |
| | | | | | | | 100 | 0.05 | | 0.12 | | | | |
| | | | | | | | 120 | 0.03 | | 0.1 | | | | |
| | | Hardened and Tempered | - | 4145 | 2050 | 350 | 50 | 0.08 | | 0.15 | | | | |
| | | | | | | | 60 | 0.05 | | 0.12 | | | | |
| | | | | | | | 70 | 0.03 | | 0.1 | | | | |
| High-alloy steel | Annealed | - | D2 | 1950 | 200 | 60 | 0.08 | 0.15 | | | | | | |
| | | | | | | 75 | 0.05 | 0.12 | | | | | | |
| | | | | | | 90 | 0.03 | 0.1 | | | | | | |
| | | | | | | M | Austenite series | X5CrNi18-9 | 304 | 2000 | 180 | 60 | 0.05 | 0.1 |
| | | | | | | | | | | | | 80 | 0.04 | 0.08 |
| | | | | | | | | | | | | 100 | 0.03 | 0.06 |
| X5CrNiMo17-12-2 | 316 | 2000 | 180 | 60 | 0.05 | | | 0.1 | | | | | | |
| | | | | 80 | 0.04 | | | 0.08 | | | | | | |
| | | | | 100 | 0.03 | | | 0.06 | | | | | | |

Recommended range



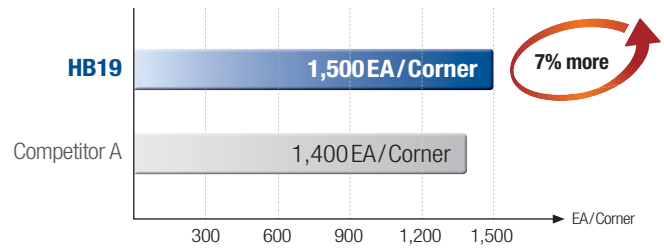
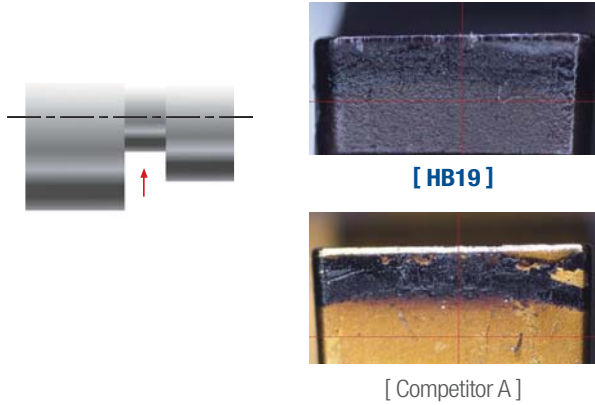
Performance evaluation

Wear resistance

Workpiece Alloy steel (SUSJ2)

Cutting condition $vc(m/min) = 25\sim75$ (RPM=4,000), $fn(mm/rev) = 0.08$, $ap(mm) = 3.0$, Wet

Tool **Insert** HB19R200-020-P (PC5300) **Holder** HBEHR1212-19

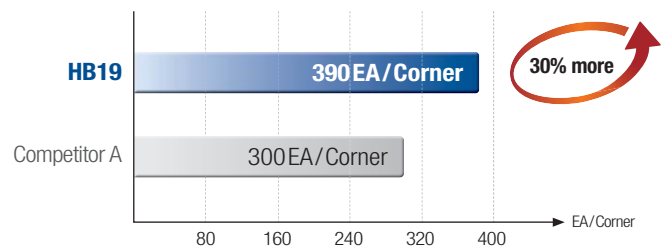
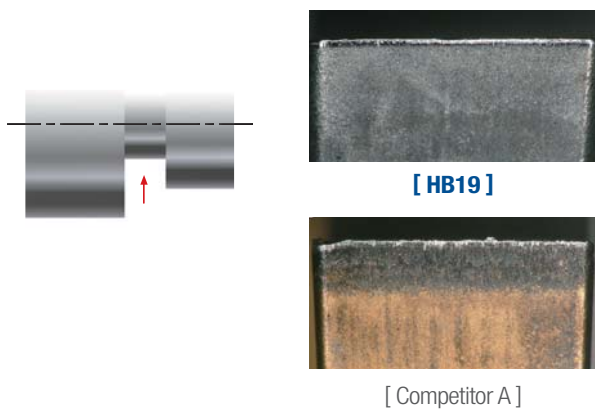


Wear resistance

Workpiece Stainless steel (STS316L)

Cutting condition $vc(m/min) = 25\sim75$ (RPM=4,000), $fn(mm/rev) = 0.08$, $ap(mm) = 3.0$, Wet

Tool **Insert** HB19R200-020-M (PC5300) **Holder** HBEHR2525-19



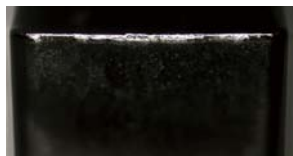
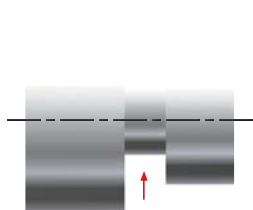
Performance evaluation

Grooving

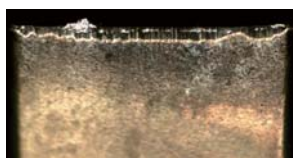
Workpiece Alloy steel (SCM440)

Cutting condition $vc(m/min) = 100$, $fn(mm/rev) = 0.1$, $ap(mm) = 2.5$, Wet

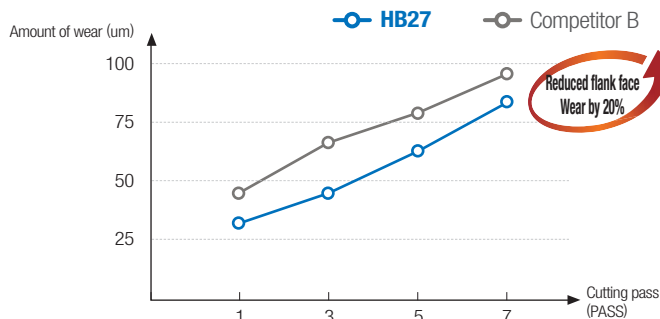
Tool **Insert** HB27N200-020-M (PC5300) **Holder** HBEHR2525-27-2



[HB27]



[Competitor B]

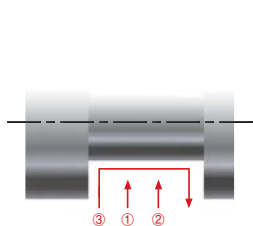


Grooving and Turning

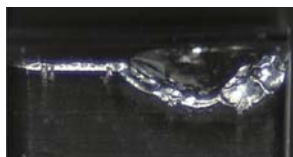
Workpiece Carbon steel (SM10C)

Cutting condition $vc(m/min) = 120$, $fn(mm/rev) = 0.1$, $ap(mm) = 3$, Wet

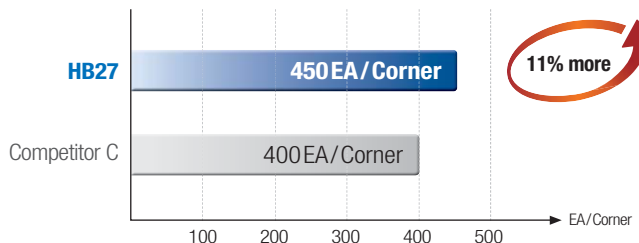
Tool **Insert** HB27N300-040-M (PC5300) **Holder** HBEHR2525-27-3



[HB27]



[Competitor C]

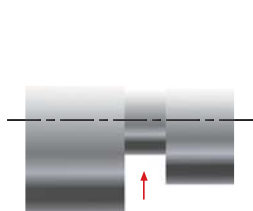


Grooving

Workpiece Alloy steel (SM20C)

Cutting condition $vc(m/min) = 172$, $fn(mm/rev) = 0.08$, $ap(mm) = 3$, Wet

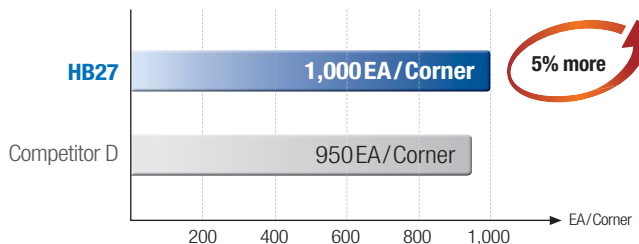
Tool **Insert** HB27N196-015-M (PC5300) **Holder** HBEHR2525-27-2



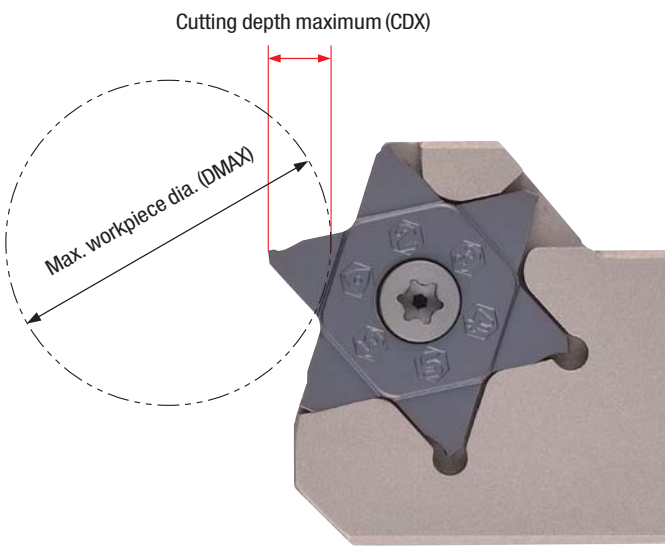
[HB27]



[Competitor D]




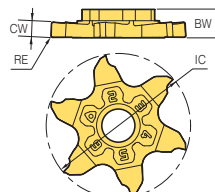
Product using guide

| Cutting depth maximum and max. workpiece dia. (mm) | | | | | | |
|--|----------------------------|------------|------------|---------|---------------|---|
| Cutting depth maximum (CDX) | Max. workpiece dia. (DMAX) | | | | | Using guide |
| | Hexa Blade 19 | | | | Hexa Blade 27 | |
| | CW ≤0.5 | CW 0.6~0.8 | CW 0.9~1.4 | CW ≥1.5 | | |
| 5.0 | - | - | - | - | ≤30 |  <p>The diagram shows a hexagonal blade with a central hole. A red double-headed arrow indicates the 'Cutting depth maximum (CDX)' from the top surface to the bottom edge. A dashed circle with an arrow indicates the 'Max. workpiece dia. (DMAX)' across the widest part of the blade.</p> |
| 4.9 | - | - | - | - | ≤34 | |
| 4.8 | - | - | - | - | ≤38 | |
| 4.7 | - | - | - | - | ≤42 | |
| 4.6 | - | - | - | - | ≤46 | |
| 4.5 | - | - | - | - | ≤58 | |
| 4.4 | - | - | - | - | ≤62 | |
| 4.3 | - | - | - | - | ≤66 | |
| 4.2 | - | - | - | - | ≤70 | |
| 4.1 | - | - | - | - | ≤74 | |
| 4.0 | - | - | - | ≤40 | ≤89 | |
| 3.9 | - | - | - | ≤47 | ≤93 | |
| 3.8 | - | - | - | ≤50 | ≤97 | |
| 3.7 | - | - | - | ≤55 | ≤101 | |
| 3.6 | - | - | - | ≤58 | ≤105 | |
| 3.5 | - | - | - | ≤60 | ≤109 | |
| 3.4 | - | - | - | ≤65 | ≤123 | |
| 3.3 | - | - | - | ≤75 | ≤127 | |
| 3.2 | - | - | - | ≤82 | ≤131 | |
| 3.1 | - | - | - | ≤95 | ≤135 | |
| 3.0 | - | - | ≤40 | ≤105 | ≤147 | |
| 2.9 | - | - | ≤60 | ≤125 | ≤151 | |
| 2.8 | - | - | ≤100 | ≤150 | ≤155 | |
| 2.7 | - | - | ≤140 | ≤185 | ≤159 | |
| 2.6 | - | - | ≤170 | ≤200 | ≤163 | |
| 2.5 | - | ≤100 | ≤200 | ≤200 | ≤200 | |
| 2.4 | - | ∞ | ∞ | ∞ | ≤200 | |
| 2.3 | - | ∞ | ∞ | ∞ | ≤200 | |
| 2.2 | - | ∞ | ∞ | ∞ | ≤200 | |
| 2.1 | - | ∞ | ∞ | ∞ | ≤200 | |
| 2.0 | ∞ | ∞ | ∞ | ∞ | ∞ | |

- ① Hexa Blade 19 offers a maximum cutting depth of 4.0mm. In this case, the maximum machinable workpiece diameter is 40mm.
- ② When Hexa Blade 19 is used with a cutting depth of 2.4mm, it can be utilized regardless of the workpiece diameter. If the cutting depth exceeds this, the machinable workpiece diameter will vary according to the cutting depth.
- ③ Hexa Blade 27 provides a maximum cutting depth of 5.0mm. At this depth, the maximum machinable workpiece diameter is 30mm.
- ④ When Hexa Blade 27 is used with a cutting depth of 2.0mm, it can be utilized regardless of the workpiece diameter. If the cutting depth exceeds this, the machinable workpiece diameter will vary according to the cutting depth.
- ⑤ If the workpiece diameter is 65mm, the maximum cutting depth for Hexa Blade 27 is 4.3mm. Machining with a greater cutting depth may cause contact between the workpiece and the holder, potentially leading to issues during operation.
- ⑥ If the cutting depth is 3.5mm, the maximum machinable workpiece diameter with Hexa Blade 27 is 109mm. Machining workpieces with a diameter larger than this may cause contact between the workpiece and the holder, leading to potential operational problems.

※ Cutting depth maximum and max. workpiece dia. on the chart could be different up to cutting environment.

Hexa Blade 19 New

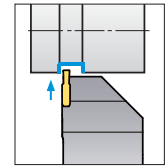
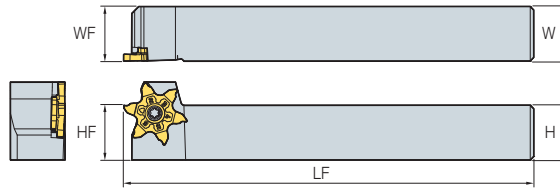
| Picture | Designation | Coated | Dimension (mm) | | | | | | Geometry |
|---|------------------------|--------|----------------|------|------|------|----|------|---|
| | | PC5300 | CW | RE | CDX | BW | IC | HAND | |
|  | HB 19R050-000-P | ○ | 0.5 | 0 | 2 | 3.75 | 19 | R |  |
| | 19R075-000-P | ○ | 0.75 | 0 | 2.5 | 3.75 | 19 | R | |
| | 19R080-000-P | ○ | 0.8 | 0 | 2.5 | 3.75 | 19 | R | |
| | 19R080-040-P | ○ | 0.8 | 0.4 | 2.5 | 3.75 | 19 | R | |
| | 19R095-000-P | ○ | 0.95 | 0 | 3 | 3.75 | 19 | R | |
| | 19R100-010-P | ○ | 1 | 0.1 | 3 | 3.75 | 19 | R | |
| | 19R100-050-P | ○ | 1 | 0.5 | 3 | 3.75 | 19 | R | |
| | 19R120-010-P | ○ | 1.2 | 0.1 | 3 | 3.75 | 19 | R | |
| | 19R140-010-P | ○ | 1.4 | 0.1 | 3 | 3.75 | 19 | R | |
| | 19R150-010-P | ○ | 1.5 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R157-010-P | ○ | 1.57 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R157-079-P | ○ | 1.57 | 0.79 | 4 | 3.75 | 19 | R | |
| | 19R170-010-P | ○ | 1.7 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R175-010-P | ○ | 1.75 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R196-010-P | ● | 1.96 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R200-010-P | ● | 2 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R200-020-P | ● | 2 | 0.2 | 4 | 3.75 | 19 | R | |
| | 19R200-100-P | ● | 2 | 1 | 4 | 3.75 | 19 | R | |
| | 19R222-010-P | ● | 2.22 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R230-010-P | ● | 2.3 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R239-010-P | ● | 2.39 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R239-120-P | ● | 2.39 | 1.2 | 4 | 3.75 | 19 | R | |
| | 19R247-010-P | ● | 2.47 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R250-010-P | ● | 2.5 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R250-020-P | ● | 2.5 | 0.2 | 4 | 3.75 | 19 | R | |
| | 19R270-010-P | ● | 2.7 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R287-010-P | ● | 2.87 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R300-010-P | ● | 3 | 0.1 | 4 | 3.75 | 19 | R | |
| | 19R300-020-P | ● | 3 | 0.2 | 4 | 3.75 | 19 | R | |
| | 19R300-150-P | ● | 3 | 1.5 | 4 | 3.75 | 19 | R | |
| 19R318-010-P | ● | 3.18 | 0.1 | 4 | 3.75 | 19 | R | | |

●: Stock item
○: Coming soon

HBEHR



HB19



• R type holder

(mm)

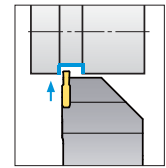
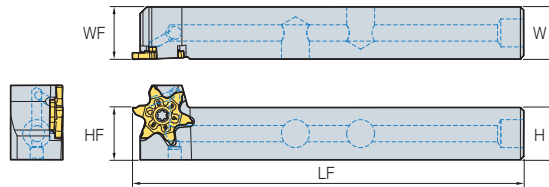
| Designation | Stock | CW | H | W | LF | HF | WF | Screw | Wrench |
|---------------|-------|-------------|----|----|-----|----|----|-----------|--------|
| HBEHR 1212-19 | ● | 0.75 ~ 3.18 | 12 | 12 | 120 | 12 | 12 | PTMA0512D | TW15P |
| 1616-19 | ● | 0.75 ~ 3.18 | 16 | 16 | 120 | 16 | 16 | | |

●: Stock item

HBEHR-KHP



HB19



• R type holder

(mm)

Recommended pressure: 70 bar

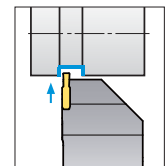
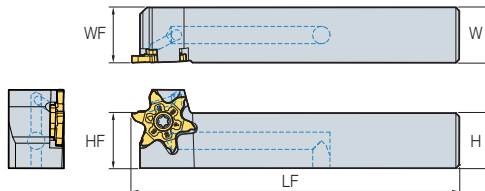
| Designation | Stock | CW | H | W | LF | HF | WF | Screw | Wrench | Plug |
|-------------------|-------|-------------|----|----|-----|----|----|-----------|----------------|------------------------------------|
| HBEHR 1212-19-KHP | ● | 0.75 ~ 3.18 | 12 | 12 | 120 | 12 | 12 | PTMA0512D | TW15P HW50L | KHA0404-NYLOCK KHA516UNF-NYLOCK |
| 1616-19-KHP | ● | 0.75 ~ 3.18 | 16 | 16 | 120 | 16 | 16 | PTMA0512D | TW15P HW50L | KHA0404-NYLOCK KHA1075-W28 |

●: Stock item

HBEHR-KHPV



HB19



• R type holder


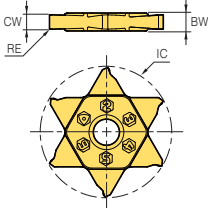
(mm)

Recommended pressure: 70 bar

| Designation | Stock | CW | H | W | LF | HF | WF | Screw | Wrench | Plug |
|--------------------|-------|-------------|----|----|----|----|----|-----------|--------|-------------------------------|
| HBEHR 1616-19-KHPV | ● | 0.75 ~ 3.18 | 16 | 16 | 95 | 16 | 16 | PTMA0512D | TW15P | KHA0404-NYLOCK KHA1075-W28 |

●: Stock item

Hexa Blade 27

| Picture | Designation | Coated | Dimension (mm) | | | | | Geometry |
|---|------------------------|--------|----------------|------|-----|----|------|---|
| | | PC5300 | CW | RE | BW | IC | HAND | |
|  | HB 27N178-018-M | ● | 1.78 | 0.18 | 2.7 | 27 | N |  |
| | 27N185-015-M | ● | 1.85 | 0.15 | 2.7 | 27 | N | |
| | 27N196-015-M | ● | 1.96 | 0.15 | 2.7 | 27 | N | |
| | 27N200-020-M | ● | 2 | 0.2 | 2.7 | 27 | N | |
| | 27N200-040-M | ● | 2 | 0.4 | 2.7 | 27 | N | |
| | 27N270-010-M | ● | 2.7 | 0.1 | 3.7 | 27 | N | |
| | 27N287-020-M | ● | 2.87 | 0.2 | 3.7 | 27 | N | |
| | 27N300-000-M | ● | 3 | 0 | 3.7 | 27 | N | |
| | 27N300-020-M | ● | 3 | 0.2 | 3.7 | 27 | N | |
| | 27N300-040-M | ● | 3 | 0.4 | 3.7 | 27 | N | |
| | 27N374-020-M | ● | 3.74 | 0.2 | 4.7 | 27 | N | |
| | 27N398-020-M | ● | 3.98 | 0.2 | 4.7 | 27 | N | |
| | 27N400-040-M | ● | 4 | 0.4 | 4.7 | 27 | N | |

●: Stock item

HBEHR/L



HB27

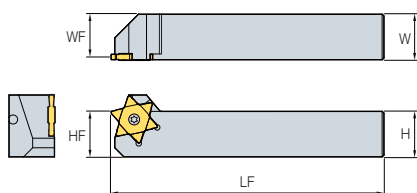


Fig. 1

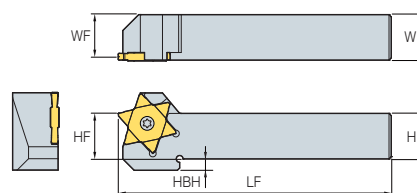
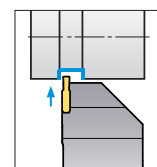


Fig. 2




• R type holder

(mm)

| Designation | Stock | | CW | H | W | LF | HF | WF | HBH | Screw | Wrench | Fig. |
|--------------------------|-------|---|----------|----|----|-----|----|------|-----|-----------|--------|------|
| | R | L | | | | | | | | | | |
| HBEHR/L 1616-27-2 | ● | | 1.78 ~ 2 | 16 | 16 | 100 | 16 | 15 | 9 | PTMA0512D | TW15P | 2 |
| 1616-27-3 | ● | | 2.7 ~ 3 | 16 | 16 | 100 | 16 | 14.5 | 9 | | | 2 |
| 1616-27-4 | ● | | 3.74 ~ 4 | 16 | 16 | 100 | 16 | 14 | 9 | | | 2 |
| 2020-27-2 | ● | | 1.78 ~ 2 | 20 | 20 | 120 | 20 | 19 | 5 | | | 2 |
| 2020-27-3 | ● | | 2.7 ~ 3 | 20 | 20 | 120 | 20 | 18.5 | 5 | | | 2 |
| 2020-27-4 | ● | | 3.74 ~ 4 | 20 | 20 | 120 | 20 | 18 | 5 | | | 2 |
| 2525-27-2 | ● | | 1.78 ~ 2 | 25 | 25 | 150 | 25 | 24 | - | | | 1 |
| 2525-27-3 | ● | | 2.7 ~ 3 | 25 | 25 | 150 | 25 | 23.5 | - | | | 1 |
| 2525-27-4 | ● | | 3.74 ~ 4 | 25 | 25 | 150 | 25 | 23 | - | | | 1 |

●: Stock item

HBEHR/L-KHP

Recommended pressure: 70 bar 



HB27

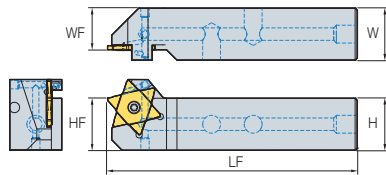


Fig. 1

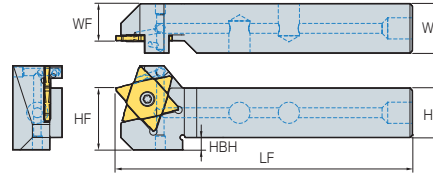
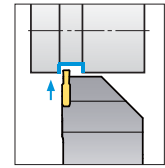


Fig. 2



• R type holder

(mm)

| Designation | Stock | | CW | H | W | LF | HF | WF | HBH | Screw | Wrench | Plug | Fig. |
|-----------------------|-------|---|----------|----|----|-----|----|----|-----|-----------|----------------|-------------------------------|------|
| | R | L | | | | | | | | | | | |
| HBEHR/L 2020-27-2-KHP | | | 1.78 ~ 2 | 20 | 20 | 120 | 20 | 14 | 5 | PTMA0512D | TW15P HW50L | KHA0404-NYLOCK KHA1075-W28 | 2 |
| 2020-27-3-KHP | | | 2.7 ~ 3 | 20 | 20 | 120 | 20 | 14 | 5 | | | | 2 |
| 2020-27-4-KHP | | | 3.74 ~ 4 | 20 | 20 | 120 | 20 | 14 | 5 | | | | 2 |
| 2525-27-2-KHP | | | 1.78 ~ 2 | 25 | 25 | 120 | 25 | 19 | - | | | | 1 |
| 2525-27-3-KHP | | | 2.7 ~ 3 | 25 | 25 | 120 | 25 | 19 | - | | | | 1 |
| 2525-27-4-KHP | | | 3.74 ~ 4 | 25 | 25 | 120 | 25 | 19 | - | | | | 1 |

●: Stock item

HBEHR/L-KHPV

Recommended pressure: 70 bar 



HB27

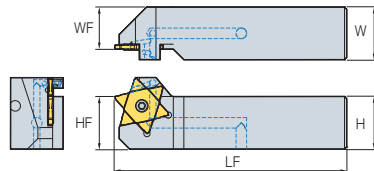


Fig. 1

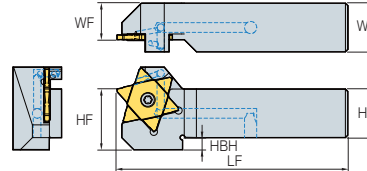
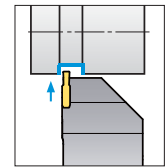


Fig. 2




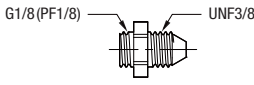

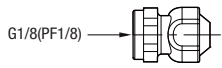

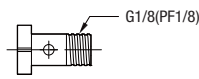



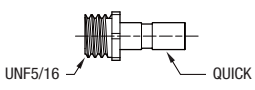
• R type holder

(mm)



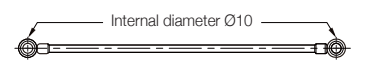
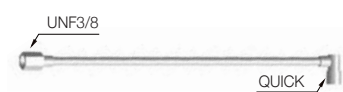
| Designation | Stock | | CW | H | W | LF | HF | WF | Screw | Wrench | Plug | Fig. |
|------------------------|-------|---|----------|----|----|----|----|----|-----------|--------|-------------------------------|------|
| | R | L | | | | | | | | | | |
| HBEHR/L 2020-27-2-KHPV | | | 1.78 ~ 2 | 20 | 20 | 95 | 20 | 14 | PTMA0512D | TW15P | KHA0404-NYLOCK KHA1075-W28 | 2 |
| 2020-27-3-KHPV | | | 2.7 ~ 3 | 20 | 20 | 95 | 20 | 14 | | | | 2 |
| 2020-27-4-KHPV | | | 3.74 ~ 4 | 20 | 20 | 95 | 20 | 14 | | | | 2 |
| 2525-27-2-KHPV | | | 1.78 ~ 2 | 25 | 25 | 95 | 25 | 19 | | | | 1 |
| 2525-27-3-KHPV | | | 2.7 ~ 3 | 25 | 25 | 95 | 25 | 19 | | | | 1 |
| 2525-27-4-KHPV | | | 3.74 ~ 4 | 25 | 25 | 95 | 25 | 19 | | | | 1 |

●: Stock item

Connecting parts

| Parts | Designation | Shape of parts | |
|---------------|----------------|---|---|
| Adaptor | HPA3/8UNF1/8PF |  |  |
| Blank | HPB1/8PF |  |  |
| Banjo screw | HPZ1/8PF |  |  |
| Copper washer | HPW1/8PF |  |  |
| Quick adaptor | HPAQ5/16UNF |  |  |

High pressure hose

| The shape of the high pressure hose | | Length | Standard S | Standard B | Standard Q |
|---|---|--------|------------|-----------------------|------------|
| Straight to straight (HPH3/8UNF) | S  S | 200mm | UNF3/8 | - | - |
| | | 250mm | | | |
| Straight to banjo (HPH3/8UNF1/8PF) | S  B | 200mm | UNF3/8 | Internal diameter Ø10 | - |
| | | 250mm | | | |
| Banjo to banjo (HPH1/8PF) | B  B | 200mm | - | Internal diameter Ø10 | - |
| | | 250mm | | | |
| Quick straight (HPHZ5/16UNF3/8UNF-500) | Q  S | 500mm | - | - | UNF5/16 |

Notice

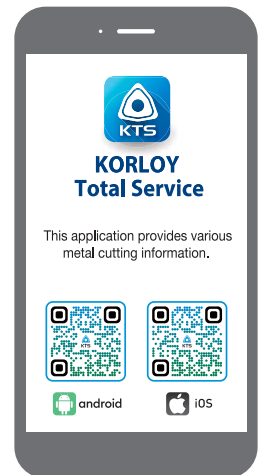
- Use a proper spanner for clamping up to the specs.
- Be careful of coolant injection by the residual pressure while using high pressure coolant.
- Clamp the parts completely before usage.
- Clean the turning machine before clamping.
- The O-ring is included in the parts. Don't have to purchase it separately.

⚠ For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.
- Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threat the operator's safety.
- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.
- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the tools can be pulled out due to centrifugal force while high speed machining.



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