**Preliminary report**

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**32T system**

Paul Horn GmbH presents the new 32T system for grooving and parting off on Swiss-type lathes and smaller fixed-head lathes. With a precision-sintered grooving insert and central clamping screw, the tool system offers high indexability of the cutting insert and direct entry into the insert seat of the tool carrier. Additionally, there is no need for clamping elements, which may have a detrimental effect on chip flow. The screw head of the clamping bolt does not introduce interfering contours and therefore permits both grooving on a collar and parting off directly at the spindle. The grooving insert can be used as a neutral insert and as both a left-hand and a right-hand insert. The 32T system completes Horn's portfolio of triple-edge cutting inserts by offering a solution for smaller-scale applications. By adding the new system to its range, the tool manufacturer is responding to customer requests for a triple-edge cutting insert system for Swiss-type lathes and other smaller turning machines, in particular in applications where space is at a premium.

The maximum groove depth of the system is 4 mm with a groove width of 2 mm or 2.5 mm. For grooving operations, the inserts are available with both straight and full radius cutting edges. Horn offers the indexable insert with a 15-degree chamfer for parting off. A cylindrically ground chip breaker geometry makes for reliable chip removal. The tool carrier is designed as a square shank of 10 x 10 mm or 12 x 12 mm cross section. Each version features an internal coolant supply and is available in both left-hand and right-hand designs.

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**Image captions:**

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**Image 1:** The new 32T system is designed for use on Swiss-type lathes and smaller fixed-head lathes.

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