CUT-Line



APPLITEC
CUTTING TOOLS

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Kodifizierung
Coding guide > 11.03

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Infos und Vorteile, Spanformgeometrie
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Holders
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Plaquettes de tronçonnage
Abstechwendeplatten
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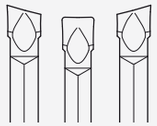
Plaquettes de fonçage, tournage et tronçonnage
WSP zum einstechen, drehen und abstechen
Inserts for grooving, turning and cut off
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Zurück zum Kapitelanfang

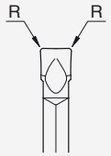
CUT 22 - U R - 8 02 Ou / Oder / Or F - TIALN

Nuance
Sorte
Grade

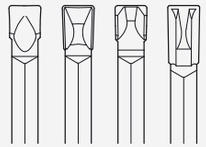
Angle de pointe
Spitzenwinkel
Point angle
L N R



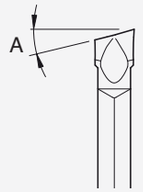
Rayon
Radius
Radius



Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry
U P T G

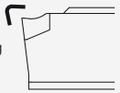


Valeur de l'angle de pointe
Wert des Spitzenwinkels
Value of the point angle



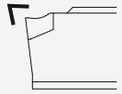
A
0°
8°
15°

Arête de coupe honée
Schneidkantenverrundung
Honed edge

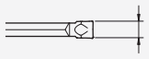
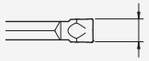
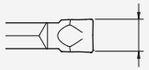


F

Arête de coupe vive
Scharfe Schneidkante
Sharp edge



Epaisseur de coupe
Schnittbreite
Cutting thickness

CUT 16		1.6 mm	Ø max 20 mm
CUT 22		2.2 mm	Ø max 42 mm
CUT 31		3.1 mm	Ø max 65 mm

Applitec CUT-Line Système performant dédié pour le tronçonnage
Applitec CUT-Line Leistungsstarkes System für das Abstechen
Applitec CUT-Line High-performance system for cutting

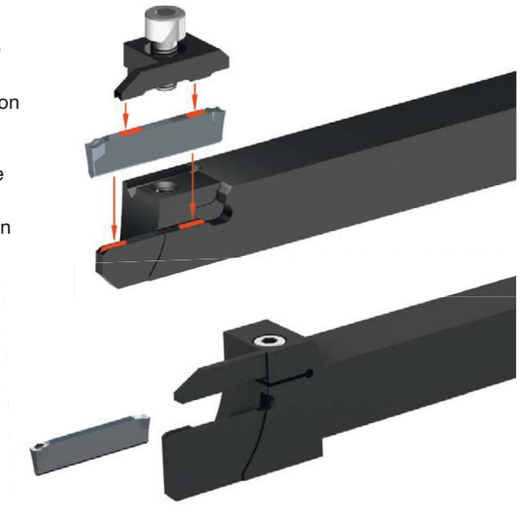
Porte-outils / Halter / Holders

Very rigid clamping system

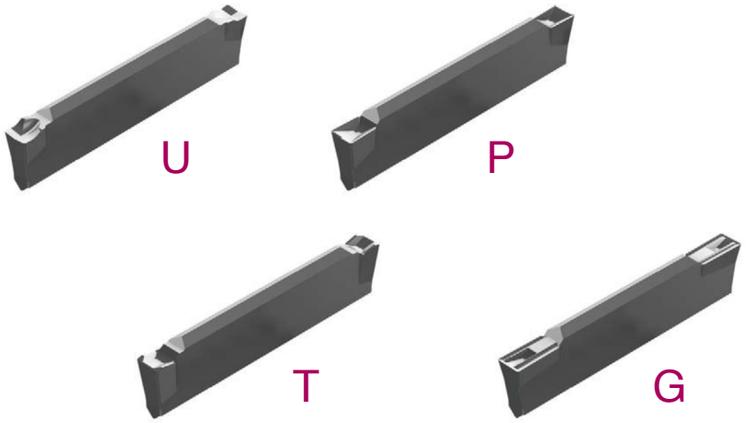
H Système de serrage à bride, version courte
Spann-Klemmsystem, kurze Ausführung
Independent top clamp system, short version

HX Système de serrage à bride, version longue
Spann-Klemmsystem, lange Ausführung
Independent top clamp system, long version

HZ Porte-outils de grande capacité
Klemmhalter mit grosser Kapazität
High capacity tool holders



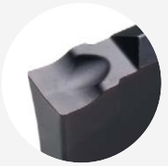
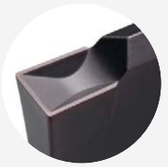
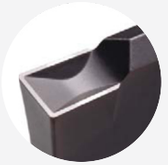
Plaquettes / WSP / Inserts



Toutes les géométries des plaquettes sont conçues pour être entièrement compatibles avec les porte-outils.

Alle Geometrien der Wendeschneidplatten sind so gestaltet, dass sie vollständig mit den Haltern kompatibel sind.

All the geometries of the inserts are designed to be fully compatible with the holders.

UN **UR** **UL**		• géométrie positive universelle, bonne maîtrise du copeau • Universalgeometrie positive gute Beherrschung der Späne • all-round insert with efficient chip control
PN **PR**		• géométrie légèrement positive pour les aciers, aciers au carbone, aciers alliés • leicht positive Geometrie für Stahl, Kohlenstoffstahl, legiertem Stahl • slightly positive geometry for steel, carbon steel, alloyed steel
PNW **PRW**		• géométrie neutre pour les laitons • neutrale Geometrie für Messinge • neutral geometry for brasses
TN		• géométrie négative pour de fortes avances dans des conditions de rigidité favorables • negative Geometrie für hohe Vorschübe in guten Stabilitätsfällen • negative geometry for high feed rate in case of good stability
GN		• géométrie universelle pour fonçage-tournage, peut également être utilisée en tronçonnage • Universalgeometrie zum einstechen-langdrehen, kann auch zum abstechen verwendet werden • all-round insert for grooving and turning, can also be used for parting off

Zurück zum Kapitelanfang

CUT-Line
Nuances
Sorten
Grades

TiAlN



Revêtement PVD
PVD Beschichtung
PVD coating

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- pour l'usinage des aciers, aciers inoxydables et alliages de titane
- 1er choix pour les avancesfaibles à modérées

- für die Bearbeitung von Stahl, rostfreien Stahl und Titanlegierungen
- erste Wahl für niedrige bis mittlere Vorschübe

- for machining of steel, stainless steel and titanium alloys
- first choice for low to average cutting speed

Tmax



Revêtement PVD
PVD Beschichtung
PVD coating

TF F M **E**

P ★★★★★
M ★★★★★
N ★★☆☆☆
S ★★☆☆☆

- nuance pour usinage moyen à lourd des aciers, aciers alliés et inoxydables
- bonne résistance aux températures d'usinage élevées
- 1er choix pour le tronçonnagedes aciers au carbone et des aciers fortement alliés

- Sorte für mittlere bis hohe Belastung in Stahl und legierter Stahlbearbeitung
- gute Bearbeitungswarmfestigkeit
- erste Wahl für die Bearbeitung von legiertem Kohlenstahl und hoch legiertem Stahl

- grade for medium to heavy machining of steel, stainless steel and alloyed steel
- high machining heat resistance
- first choice for the machining of carbon steel and high alloyed steel

Zmax



Revêtement PVD
PVD Beschichtung
PVD coating

TF F M **E**

P ★★★★★
M ★★★★★
N ★★☆☆☆
S ★★☆☆☆

- pour l'usinage des aciers, aciers inoxydables et alliages de titane en conditions défavorables
- bonne résistance aux chocs à des vitesses de coupe moyennes à faibles
- 1er choix pour le tronçonnageen coupe interrompue

- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen in schwierige Bearbeitungsfälle
- gute Bruchfestigkeit mit durchschnittliche bis niedrige Schnittgeschwindigkeit
- erste Wahl für die Bearbeitung in unterbrochenen Schnitte

- for machining of steel, stainless steel and titanium alloys in unfavourable machining conditions
- good impact resistance with average to low cutting speed
- first choice for machining in interrupted cut

HTA



Revêtement PVD
PVD Beschichtung
PVD coating

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- très bonne résistance à l'usure
- pour le tronçonnage des aciers, aciers inoxydables et alliages de titane
- déconseillé en coupe interrompue

- sehr gute Verschleissfestigkeit
- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierung
- für unterbrochene Schnitte ungeeignet

- very good wear resistance
- for steel, stainless steel and titanium alloys machining
- not suitable for interrupted cut

HAC



Revêtement PVD
PVD Beschichtung
PVD coating

TF F **M** E

P ☆☆☆☆☆
M ☆☆☆☆☆
N ★★★★★
S ★★★★★

- nuance pour métaux non ferreux
- très faible coefficient de frottement
- 1er choix pour l'usinage des aluminiums, des cuivres et titanes faiblement alliés

- Sorte für Nichteisenmetalle
- sehr geringer Reibwert
- erste Wahl für die Bearbeitung von Aluminium, Kupfer und niedriglegiertem Titan

- grade for non-ferrous materials
- very low friction ratio
- first choice for Aluminium, copper and low alloyed titanium

N



Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

- idéal pour l'usinage du laiton, uniquement disponible en géométries PNW / PRW

- Ideal für die Bearbeitung von Messing, nur in den Geometrien PNW / PRW erhältlich

- ideal for machining brass, only available in PNW / PRW geometries

Zurück zum Kapitelanfang

CUT-Line

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

CUT 16

			P Acier / Stahl / Steel						M Inox / Rostfreistahl / Stainless steel		N Alliages d'aluminium et non ferreux / Aluminium- und Nichteisenlegierungen / Aluminium and non-ferrous alloys								S Titane / Titan / Titanium			
			Acier dedécolletage / Automatenstahl / Free-cuttingsteel		Acier faiblement allié / Leicht legierter Stahl / Low alloyed steel		Acier fortement allié / Legierter Stahl / High alloyed steel		Austénitiqueet martensitique / Austenitischundmartensitisch / Austeniticandmartensitic		Aluminium		Alu silicium max.5% / Aluminiumsilicium max.5% / Aluminium silicon max.5 %		Cuivre / Kupfer / Copper		Laiton & bronze / Messing& Bronze / Brass& bronze		Gr. 1- 3		Gr. 4- 5	
			VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)
Avance standard / Standard Vorschub / Standard feed rate	CUT16-UN-001	TiAlN	90-140	0.03-0.07	60-120	0.03-0.07	50-100	0.04-0.08	50-120	0.03-0.07	100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			30-60	0.04-0.08
		Tmax	100-170	0.03-0.07	70-150	0.03-0.07	60-120	0.04-0.08	60-150	0.03-0.07												
		Zmax	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.08	50-120*	0.04-0.10												
		HTA	70-120	0.03-0.05	60-100	0.03-0.05	50-90	0.03-0.05	50-100	0.03-0.06	100-300	0.04-0.10	100-250	0.04-0.10	100-300	0.03-0.08	150-300	0.03-0.08			30-60	0.04-0.08
		HAC									150-300	0.04-0.15	100-300	0.04-0.10	100-300	0.04-0.10	150-300	0.02-0.08	30-60	0.04-0.08	30-60	0.04-0.08
	CUT16-PR-801	TiAlN	90-140	0.03-0.07	60-120	0.03-0.07	50-100	0.03-0.07	50-120	0.03-0.07							150-300	0.03-0.10				
		Tmax	100-170	0.03-0.07	70-150	0.03-0.07	60-120	0.03-0.07	60-150	0.03-0.07												
	CUT16-PRW-801	N															100-500	0.02-0.10				
Avance modérée ** / Niedriger Vorschub ** / Low feed rate	CUT16-UN-000F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT16-UL/R-800F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT16-UL/R-1500F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06

* premier choix en cas decoupeinterrompue
** arête de coupe vive

* ersteWahl für unterbrochener Schnitt
** scharfeSchneidkante

* first choice for interrupted cut
** sharp cuttingedge

CUT-Line

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

CUT 22

			P Acier / Stahl / Steel						M Inox / Rostfreistahl / Stainless steel		N Alliages d'aluminium et non ferreux / Aluminium- und Nichteisenlegierungen / Aluminium and non-ferrous alloys								S Titane / Titan / Titanium			
			Acier dedécolletage / Automatenstahl / Free-cuttingsteel		Acier faiblement allié / Leicht legierter Stahl / Low alloyed steel		Acier fortement allié / Legierter Stahl / High alloyed steel		Austénitiqueet martensitique / Austenitischundmartensitisch / Austeniticandmartensitic		Aluminium		Alu silicium max.5% / Aluminiumsilicium max.5% / Aluminium silicon max.5 %		Cuivre / Kupfer / Copper		Laiton & bronze / Messing& Bronze / Brass& bronze		Gr. 1- 3		Gr. 4- 5	
			VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)
Avance standard / Standard Vorschub / Standard feed rate	CUT22-UN-002 CUT22-UR-802	TiAlN	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08	100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			30-60	0.04-0.08
		Tmax	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08												
		Zmax	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.08	50-120*	0.04-0.10												
		HTA	70-120	0.04-0.06	60-100	0.04-0.06	50-90	0.04-0.06	50-100	0.04-0.06	100-300	0.04-0.10	100-250	0.04-0.10	100-300	0.03-0.08	150-300	0.03-0.08			30-60	0.04-0.08
		HAC									150-300	0.04-0.15	100-300	0.04-0.10	100-300	0.04-0.10	150-300	0.02-0.08	30-60	0.04-0.08	30-60	0.04-0.08
	CUT22-PN-002	TiAlN	90-140	0.04-0.10	60-120	0.04-0.08	50-100	0.04-0.08									150-300	0.03-0.10				
		Tmax	100-170	0.04-0.10	70-150	0.04-0.10	60-120	0.04-0.10														
	CUT22-PNW-002	N															100-500	0.02-0.10				
	CUT22-PR-002	TiAlN	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08							150-300	0.03-0.10				
		Tmax	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08												
	CUT22-PRW-002	N															100-500	0.02-0.10				
	CUT22-TN-002	TiAlN	90-140	0.08-0.18	60-120	0.08-0.18	50-100	0.08-0.15	50-120	0.08-0.20							150-300	0.05-0.20				
		Tmax	100-170	0.08-0.18	70-150	0.08-0.18	60-120	0.08-0.15	60-150	0.08-0.20												
		Zmax	80-130*	0.08-0.18	50-110*	0.08-0.18	50-90*	0.08-0.15														
	CUT22-GN-002 ***	TiAlN	90-140	0.03-0.12	60-120	0.03-0.12	50-100	0.03-0.10	50-120	0.03-0.08	100-300	0.03-0.12	100-200	0.03-0.10	100-200	0.03-0.10	100-300	0.03-0.12			30-60	0.04-0.08
		Tmax	100-170	0.03-0.12	70-150	0.03-0.12	60-120	0.03-0.10	70-120	0.03-0.08							100-300	0.03-0.12				
		HAC									100-300	0.03-0.12	100-200	0.03-0.10	100-200	0.03-0.10	100-300	0.03-0.12	30-60	0.04-0.08	30-60	0.04-0.08
Avance modérée / Niedriger Vorschub / Low feed rate **	CUT22-UN-000F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT22-UL/R-800F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT22-UL/R-802F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT22-UL/R-1500F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06

* premier choix en cas decoupeinterrompue
** arête de coupe vive
*** Pour opérations de fonçage-tournage (évent. tronçonnage)

* ersteWahl für unterbrochener Schnitt
** scharfeSchneidkante
*** Für Stech- und Drehoperationen (event. abstechen)

* first choice for interrupted cut
** sharp cuttingedge
*** For grooving and turning operations (event.parting off)

CUT-Line

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

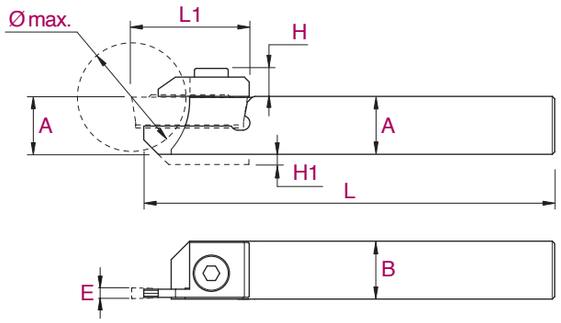
CUT 31

			P Acier / Stahl / Steel						M Inox / Rostfreistahl / Stainless steel		N Alliages d'aluminium et non ferreux / Aluminium- und Nichteisenlegierungen / Aluminium and non-ferrous alloys								S Titane / Titan / Titanium			
			Acier dedécolletage / Automatenstahl / Free-cuttingsteel		Acier faiblement allié / Leicht legierter Stahl / Low alloyed steel		Acier fortement allié / Legierter Stahl / High alloyed steel		Austénitiqueet martensitique / Austenitischundmartensitisch / Austeniticandmartensitic		Aluminium		Alu silicium max.5% / Aluminiumsilicium max.5% / Aluminium silicon max.5 %		Cuivre / Kupfer / Copper		Laiton & bronze / Messing& Bronze / Brass& bronze		Gr. 1- 3		Gr. 4- 5	
			VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)	VC(m/min)	F(mm/U)
Avance standard / Standard Vorschub / Standard feed rate	CUT31-UN-002	TiAlN	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.10	100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			30-60	0.04-0.08
		Tmax	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.10												
		Zmax	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.08	50-120*	0.04-0.10												
		HTA	70-120	0.04-0.06	60-100	0.04-0.06	50-90	0.04-0.06	50-100	0.04-0.06	100-300	0.04-0.10	100-250	0.04-0.10	100-300	0.03-0.08	150-300	0.03-0.08			30-60	0.04-0.08
		HAC									150-300	0.04-0.15	100-300	0.04-0.10	100-300	0.04-0.10	150-300	0.02-0.08	30-60	0.04-0.08	30-60	0.04-0.08
	CUT31-PN-002	TiAlN	90-140	0.04-0.10	60-120	0.04-0.08	50-100	0.04-0.08									150-300	0.03-0.10				
		Tmax	100-170	0.04-0.10	70-150	0.04-0.10	60-120	0.04-0.10														
	CUT31-PNW-002	N															100-500	0.02-0.15				
	CUT31-PR-802	TiAlN	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08							150-300	0.03-0.10				
		Tmax	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08												
	CUT31-PRW-802	N															100-500	0.02-0.15				
	CUT31-TN-002	TiAlN	90-140	0.08-0.20	60-120	0.08-0.20	50-100	0.08-0.15	50-120	0.08-0.20							150-300	0.05-0.20				
		Tmax	100-170	0.08-0.20	70-150	0.08-0.20	60-120	0.08-0.15	60-150	0.08-0.20												
		Zmax	80-130*	0.08-0.20	50-110*	0.08-0.20	50-90*	0.08-0.15														
	CUT31-GN-002 ***	TiAlN	90-140	0.04-0.15	60-120	0.04-0.15	50-100	0.04-0.10	50-120	0.04-0.10	100-300	0.04-0.15	100-200	0.04-0.10	100-200	0.04-0.10	100-300	0.04-0.15			30-60	0.04-0.08
		Tmax	100-170	0.04-0.15	70-150	0.04-0.15	60-120	0.04-0.10	70-120	0.04-0.10							100-300	0.04-0.15				
		HAC									100-300	0.04-0.15	100-200	0.04-0.10	100-200	0.04-0.10	100-300	0.04-0.15	30-60	0.04-0.08	30-60	0.04-0.08
Avance modérée / Niedriger Vorschub / Low feed rate **	CUT31-UN-000F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT31-UL/R-800F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT31-UL/R-802F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06
	CUT31-UL/R-1500F	TiAlN	80-130	0.02-0.05	50-110	0.02-0.05	50-90	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.01-0.04	100-250	0.01-0.04	100-300	0.02-0.05			30-60	0.01-0.04
		HTA	60-100	0.01-0.04	50-90	0.01-0.04	50-80	0.02-0.05	50-80	0.02-0.05	100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05			30-60	0.02-0.06
		HAC									100-300	0.02-0.05	100-250	0.02-0.05	100-250	0.02-0.05	100-300	0.02-0.05	30-60	0.02-0.06	30-60	0.02-0.06

* premier choix en cas decoupeinterrompue
** arête de coupe vive
*** Pour opérations de fonçage-tournage (évent. tronçonnage)

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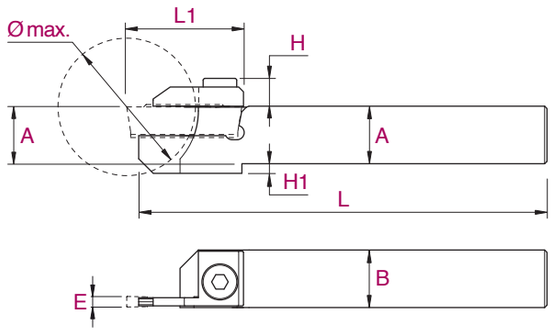
* first choice for interrupted cut
** sharp cuttingedge
*** For grooving and turning operations (event.parting off)



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L Art. N°	R Art. N°
E 1.6 mm Type CUT16	8 x 10	115	16	19.5	6.2	2	CUT16-H0810L	CUT16-H0810R
	10 x 10	115	16	19.5	6.2	-	CUT16-H1010L	CUT16-H1010R
	12 x 12	130	16	19.5	6.2	-	CUT16-H1212L	CUT16-H1212R
	12 x 12	90	16	19.5	6.2	-	CUT16-H1212L-90	CUT16-H1212R-90
	12.7 x 12.7	130	16	19.5	6.2	-	CUT16-H127127L	CUT16-H127127R
	16 x 16	130	16	19.5	6.2	-	CUT16-H1616L	CUT16-H1616R
	20 x 20	120	16	19.5	6.2	-	CUT16-H2020L	CUT16-H2020R
E 2.2 mm Type CUT22	10 x 12	115	20	24	6.4	-	CUT22-H1012L	CUT22-H1012R
	12 x 12	130	20	24	6.4	-	CUT22-H1212L	CUT22-H1212R
	12 x 12	90	20	24	6.4	-	CUT22-H1212L-90	CUT22-H1212R-90
	12.7 x 12.7	130	20	24	6.4	-	CUT22-H127127L	CUT22-H127127R
	16 x 16	130	20	24	6.4	-	CUT22-H1616L	CUT22-H1616R
	20 x 20	120	20	24	6.4	-	CUT22-H2020L	CUT22-H2020R
E 3.1 mm Type CUT31	16 x 16	130	34	35	7.8	-	CUT31-H1616L	CUT31-H1616R
	20 x 20	120	34	35	7.8	-	CUT31-H2020L	CUT31-H2020R
	25 x 25	140	34	35	7.8	-	CUT31-H2525L	CUT31-H2525R

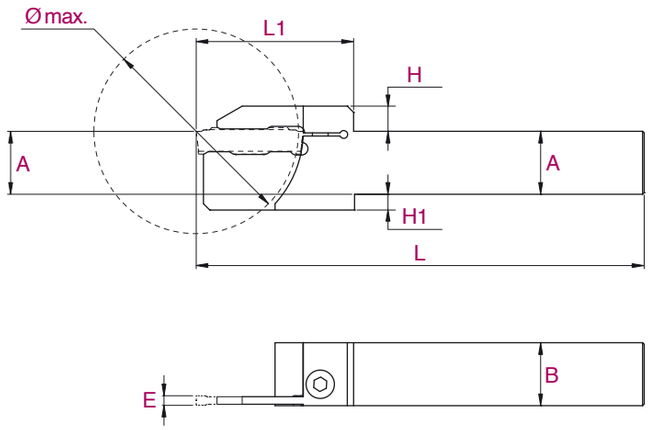
Pièces de rechange Ersatzteile Spare parts	L Art. N°	R Art. N°	Art. N°	Serrage Anzug Torque
CUT 16	CUT16L-SET	CUT16R-SET	V-M4X10-BN7	3.5 Nm
CUT 22	CUT22L-SET	CUT22R-SET	V-M4X10-BN7	3.5 Nm
CUT 31	CUT31L-SET	CUT31R-SET	V-M5X10-BN7	4.5 Nm

Zurück zum Kapitelanfang



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L Art. N°	R Art. N°
E 1.6 mm Type CUT16	10 x 12	115	20	21	6.2	2	CUT16-H1012LX	CUT16-H1012RX
	12 x 12	130	20	21	6.2	-	CUT16-H1212LX	CUT16-H1212RX
	12 x 12	90	20	21	6.2	-	CUT16-H1212LX-90	CUT16-H1212RX-90
	12.7 x 12.7	130	20	21	6.2	-	CUT16-H127127LX	CUT16-H127127RX
	16 x 16	130	20	21	6.2	-	CUT16-H1616LX	CUT16-H1616RX
	20 x 20	120	20	21	6.2	-	CUT16-H2020LX	CUT16-H2020RX
E 2.2 mm Type CUT22	10 x 12	115	26	25	6.4	4	CUT22-H1012LX	CUT22-H1012RX
	12 x 12	130	26	25	6.4	2	CUT22-H1212LX	CUT22-H1212RX
	12 x 12	90	26	25	6.4	2	CUT22-H1212LX-90	CUT22-H1212RX-90
	12.7 x 12.7	130	26	25	6.4	-	CUT22-H127127LX	CUT22-H127127RX
	16 x 16	130	26	25	6.4	-	CUT22-H1616LX	CUT22-H1616RX
	20 x 20	120	26	25	6.4	-	CUT22-H2020LX	CUT22-H2020RX
	25 x 25	140	26	25	6.4	-	CUT22-H2525LX	CUT22-H2525RX
E 3.1 mm Type CUT31	16 x 16	120	42	37	7.8	4	CUT31-H1616LX	CUT31-H1616RX
	20 x 20	120	42	37	7.8	-	CUT31-H2020LX	CUT31-H2020RX
	25 x 25	140	42	37	7.8	-	CUT31-H2525LX	CUT31-H2525RX

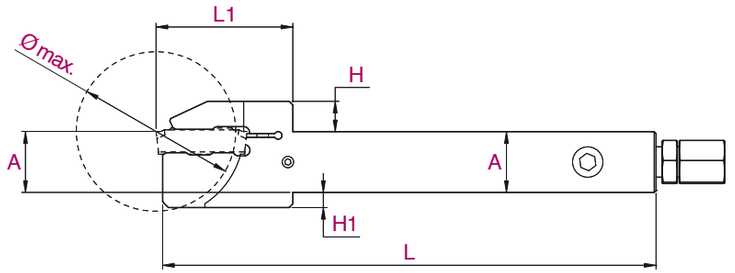
Pièces de rechange Ersatzteile Spare parts	L Art. N°	R Art. N°	Art. N°	Serrage Anzug Torque
CUT 16	CUT16LX-SET	CUT16RX-SET	V-M4X10-BN7	3.5 Nm
CUT 22	CUT22LX-SET	CUT22RX-SET	V-M4X10-BN7	3.5 Nm
CUT 31	CUT31LX-SET	CUT31RX-SET	V-M5X10-BN7	4.5 Nm

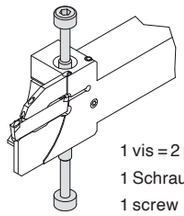


Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L Art. N°	R Art. N°
E 2.2 mm Type CUT22	16 x 16	130	32	30	7	-	CUT22-H1616LZ-D32	CUT22-H1616RZ-D32
	20 x 20	130	32	30	7	-	CUT22-H2020LZ-D32	CUT22-H2020RZ-D32
	16 x 16	130	42	35	7	4	CUT22-H1616LZ-D42	CUT22-H1616RZ-D42
	20 x 20	130	42	35	7	-	CUT22-H2020LZ-D42	CUT22-H2020RZ-D42
E 3.1 mm Type CUT31	20 x 20	140	52	44	8	5	CUT31-H2020LZ-D52	CUT31-H2020RZ-D52
	25 x 25	140	52	44	8	-	CUT31-H2525LZ-D52	CUT31-H2525RZ-D52
	20 x 20	140	65	50	8	5	CUT31-H2020LZ-D65	CUT31-H2020RZ-D65
	25 x 25	140	65	50	8	-	CUT31-H2525LZ-D65	CUT31-H2525RZ-D65

Pièces de rechange Ersatzteile Spare parts	Art. N°	Serrage Anzug Torque
CUT 22	V-M4X10-BN7	3.5 Nm
CUT 31	V-M5X10-BN7	4.5 Nm

Zurück zum Kapitelanfang

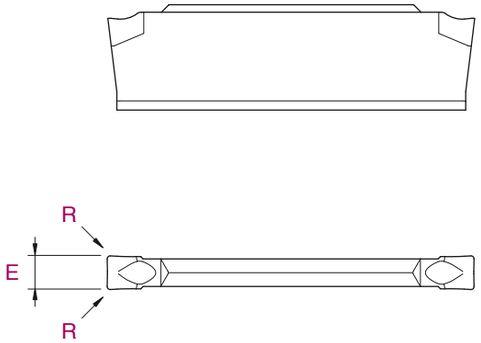




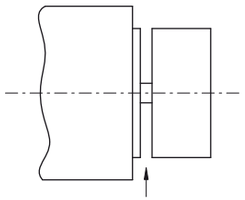
1 vis = 2 possibilités de serrage
1 Schraube = 2 Spannmöglichkeiten
1 screw = 2 clamp possibilities

Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L Art. N°	R Art. N°
E 2.2 mm Type CUT22	16 x 16	130	42	36	8	4	CUT22-H1616LZ-JET42	CUT22-H1616RZ-JET42
	20 x 20	130	42	36	8	-	CUT22-H2020LZ-JET42	CUT22-H2020RZ-JET42
E 3.1 mm Type CUT31	16 x 16	140	65	49	9	9	CUT31-H1616LZ-JET65	CUT31-H1616RZ-JET65
	20 x 20	140	65	51	9	5	CUT31-H2020LZ-JET65	CUT31-H2020RZ-JET65
	25 x 25	140	65	51	9	-	CUT31-H2525LZ-JET65	CUT31-H2525RZ-JET65

Pièces de rechange Ersatzteile Spare parts	Art. N°	Serrage Anzug Torque	Art. N°	Art. N°
CUT 22	V-M4X22-CUT	3.5 Nm	J-M8X1-D6	JB-M8X1
CUT 31	V-M5X25-CUT	4.5 Nm	J-M8X1-D6	JB-M8X1

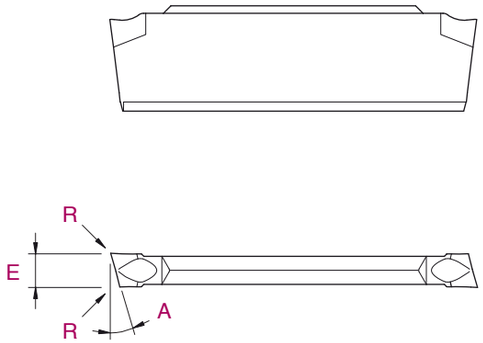




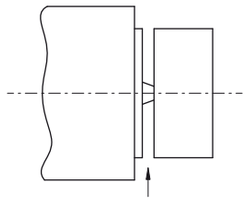


UN

Type	E ±0.1	R	Art. N°	TiAlN	Tmax	Zmax	HTA	HAC
CUT16	1.6	0.02	CUT16-UN-000F	●			●	●
	1.6	0.10	CUT16-UN-001	●	●	●	●	●
CUT22	2.2	0.02	CUT22-UN-000F	●			●	●
	2.2	0.20	CUT22-UN-002	●	●	●	●	●
CUT31	3.1	0.02	CUT31-UN-000F	●			●	●
	3.1	0.20	CUT31-UN-002	●	●	●	●	●



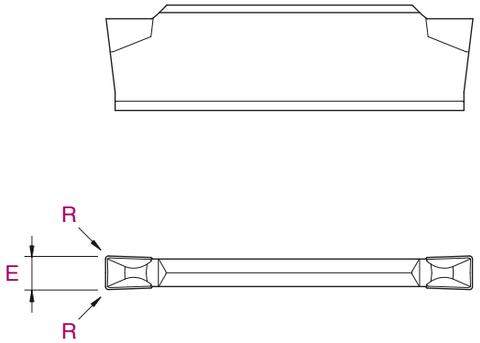




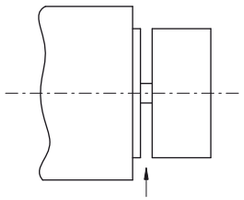
UL

UR

Type	E ±0.1	A	R	Art. N°	TiAlN	HTA	HAC	Art. N°	TiAlN	Tmax	Zmax	HTA	HAC
CUT16	1.6	8°	0.02	CUT16-UL-800F	●	●	●	CUT16-UR-800F	●			●	●
	1.6	15°	0.02	CUT16-UL-1500F	●	●	●	CUT16-UR-1500F	●			●	●
CUT22	2.2	8°	0.02	CUT22-UL-800F	●	●	●	CUT22-UR-800F	●			●	●
	2.2	8°	0.20	–				CUT22-UR-802		●	●		
	2.2	8°	0.20	CUT22-UL-802F	●	●	●	CUT22-UR-802F	●			●	●
	2.2	15°	0.02	CUT22-UL-1500F	●	●	●	CUT22-UR-1500F	●			●	●
CUT31	3.1	8°	0.02	CUT31-UL-800F	●	●	●	CUT31-UR-800F	●			●	●
	3.1	8°	0.20	CUT31-UL-802F	●	●	●	CUT31-UR-802F	●			●	●
	3.1	15°	0.02	CUT31-UL-1500F	●	●	●	CUT31-UR-1500F	●			●	●



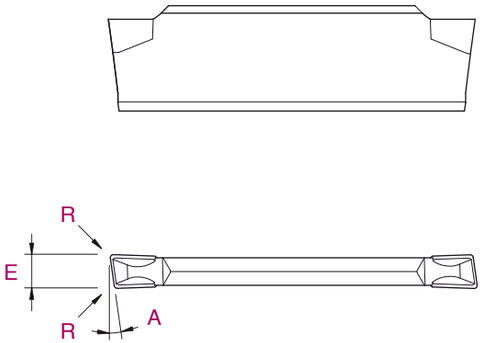




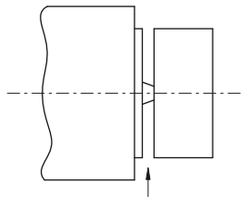
PN

Type	E ±0.1	R	Art. N°	TiAlN	Tmax
CUT22	2.2	0.20	CUT22-PN-002	●	●
CUT31	3.1	0.20	CUT31-PN-002	●	●

Plaquettes de tronçonnage
Abstechwendeplatten
Cut off inserts

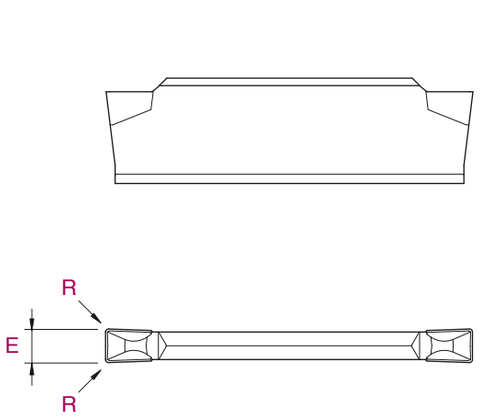




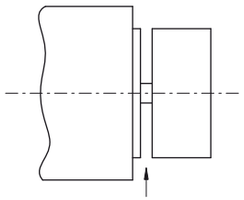


PR

Type	E ±0.1	A	R	Art. N°	TiAlN	Tmax
CUT16	1.6	8°	0.10	CUT16-PR-801	●	●
CUT22	2.2	8°	0.20	CUT22-PR-802	●	●
CUT31	3.1	8°	0.20	CUT31-PR-802	●	●

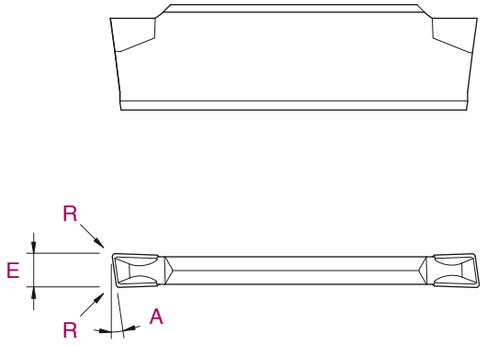




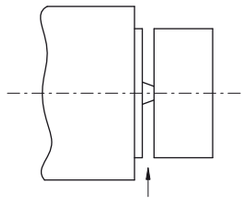


PNW

Type	E ±0.1	R	Art. N°	N S Z
CUT22	2.2	0.20	CUT22-PNW-002	●
CUT31	3.1	0.20	CUT31-PNW-002	●

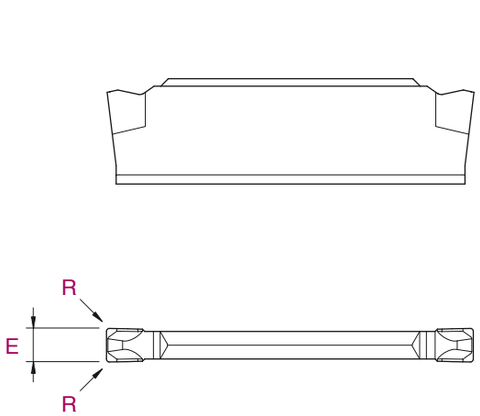




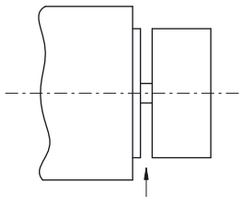


PRW

Type	E ±0.1	A	R	Art. N°	N S Z
CUT16	1.6	8°	0.10	CUT16-PRW-801	●
CUT22	2.2	8°	0.20	CUT22-PRW-802	●
CUT31	3.1	8°	0.20	CUT31-PRW-802	●



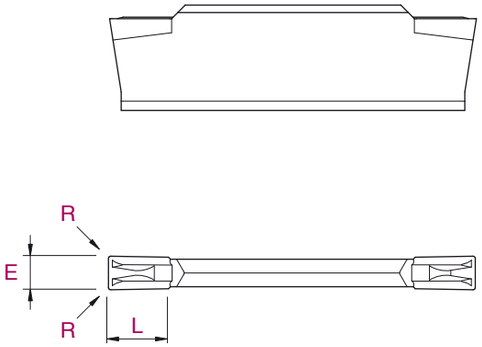




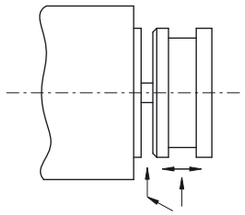
TN

Type	E ±0.1	R	Art. N°	TiAlN	Tmax	Zmax
CUT22	2.2	0.20	CUT22-TN-002	●	●	●
CUT31	3.1	0.20	CUT31-TN-002	●	●	●

Zurück zum Kapitelanfang



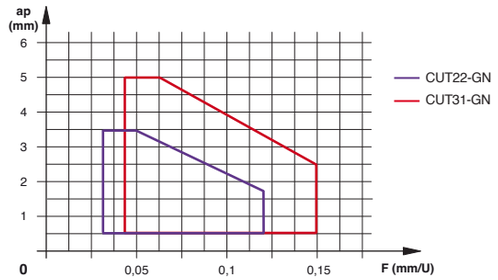


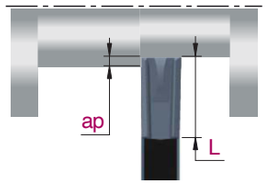


GN

Type	E ±0.1	L	R	Art. N°	TiAlN	Tmax	HAC
CUT22	2.2	3.5	0.15	CUT22-GN-002	●	●	●
CUT31	3.1	5.0	0.15	CUT31-GN-002	●	●	●

Conseils d'utilisation pour plaquettes type GN
Anwendungsempfehlungen für GN-Wendeplatten
Application recommendations for GN inserts





ap max =L dans matière à bonne usinabilité
ap max =L in Werkstoffe mit gute Zerspanbarkeit
ap max =L in material with good machinability