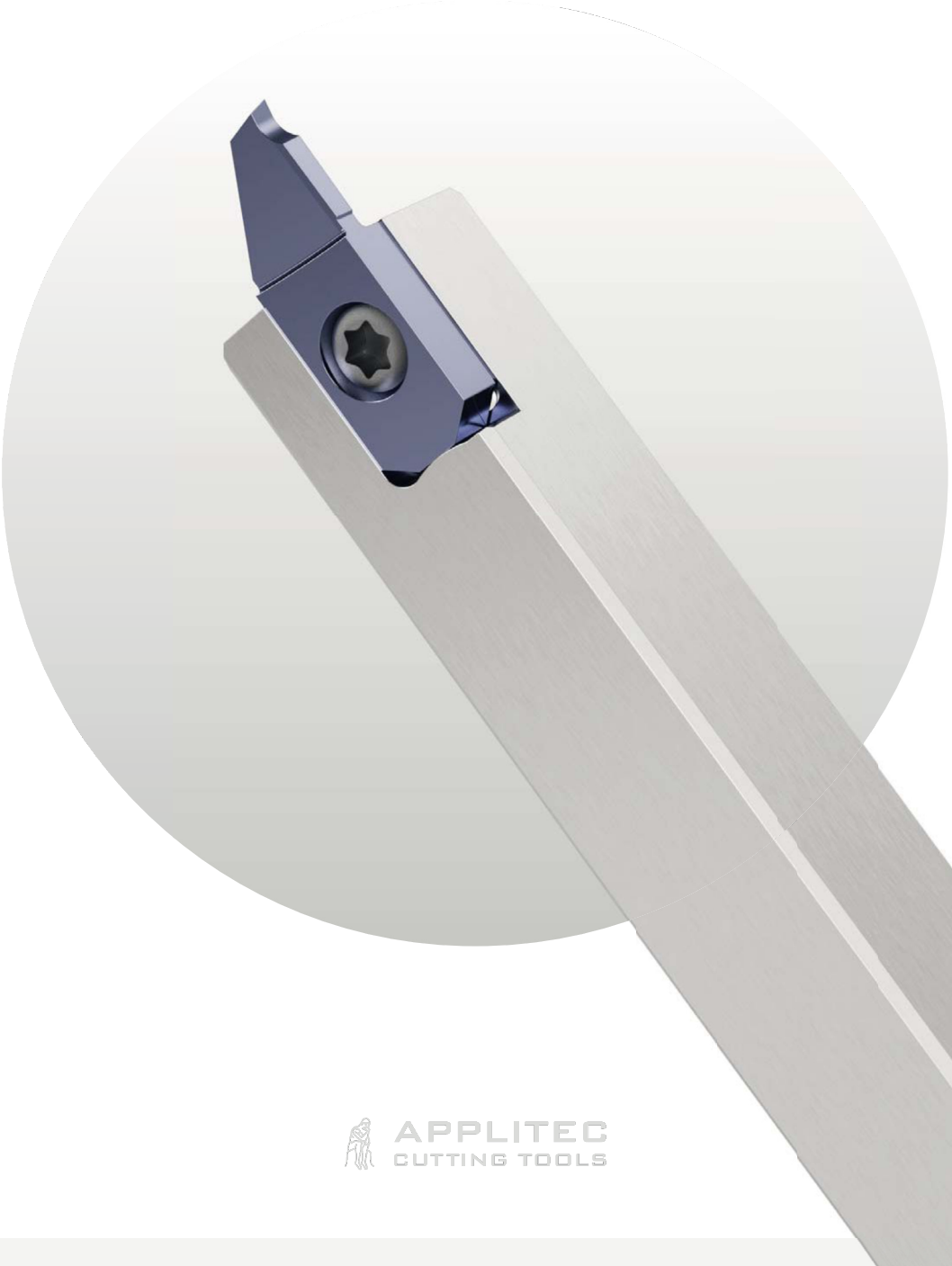
ONE-Line



APPLITEC
CUTTING TOOLS

Codification
Kodifizierung
Coding guide >3.03

Infos et avantages
Infos und Vorteile
Infos and advantages >3.04

Nuances
Sorten
Grades >3.06

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Empfohlene Schnittwerte
Standard machining data >3.07

Porte-outils
Halter
Holder 130 / 140 >3.08

Tronçonnage
Abstechen
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Vorwärts drehen
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Radius Wendeplatten
Radius inserts 147 >3.27

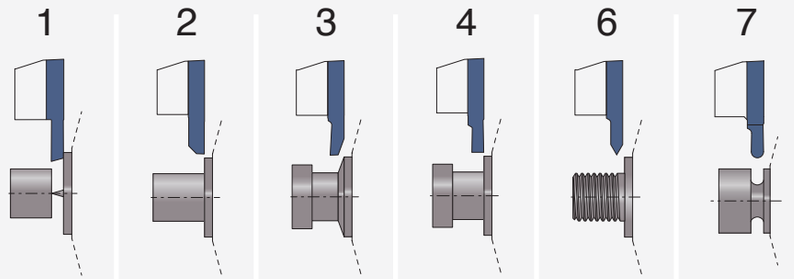
Plaquettes ébauches
WSP-Rohlinge
Blank inserts 131-EP / 141-EP >3.28

Pièces de rechange et accessoires
Ersatzteile und Zubehöre
Spare parts and accessories >3.29

Zurück zum Kapitelanfang

1	3	4	X	-	2.0	-	R20	-	KST

- 2.0: Dimension / Abmessung / Dimension
- R20: Rayon / Radius / Radius
- KST: Nuance / Sorte / Grade
- X: Géométrie de coupe / Schneidgeometrie / Cutting geometry — brise-copeaux / Spanbrecher / chip breaker — particularités / Sondereigenschaften / special features
- 4: Géométrie d'usinage / Bearbeitungsgeometrie / Machining geometry

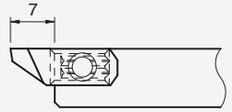


- 3: Gamme de produit / Produktserie / Product series — définit la compatibilité des plaquettes avec le porte-outils / definiert die Kompatibilität der Wendeschneidplatten mit dem Werkzeughalter / define the compatibility of the inserts with the toolholder

L = 3 (chiffre impair / ungerade Zahl / uneven number)

R = 4 (chiffre pair / gerade Zahl / even number)

L	R
130	140



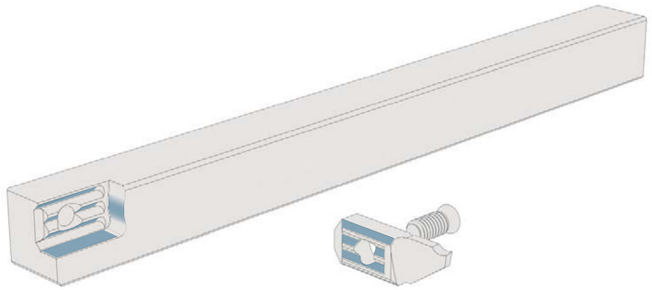
- 1: Applitec série 100 / Applitec 100 Serie / Applitec 100 series — Système de serrage à denture décalée avec 1 vis de fixation / Spannsystem mit 1 Schraube und verschobener Verzahnung / Shifted teeth clamping system with 1 screw

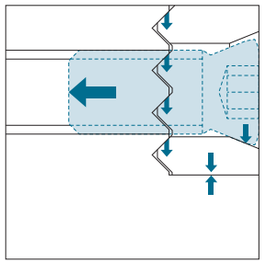
ONE-Line

Infos et avantages
Infos und Vorteile
Infos and advantages

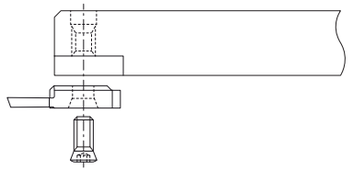
Rigid!

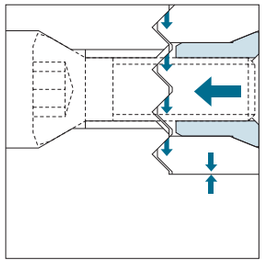
Système de serrage Applitec à denture décalée
Applitec-Spannsystem mit verschobener Verzahnung
Applitec clamping system with shifted teeth





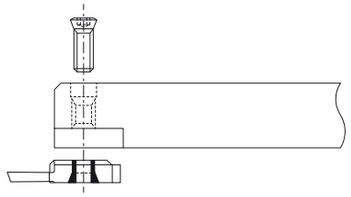
Serrage standard (A)
Standard Spannsystem (A)
Standard clamping system (A)





Serrage type B*
Spannsystem Typ B*
Clamping system type B*

ajouter -B après le numéro d'article
-B nach der Artikelreferenz hinzufügen
add -B after the article number

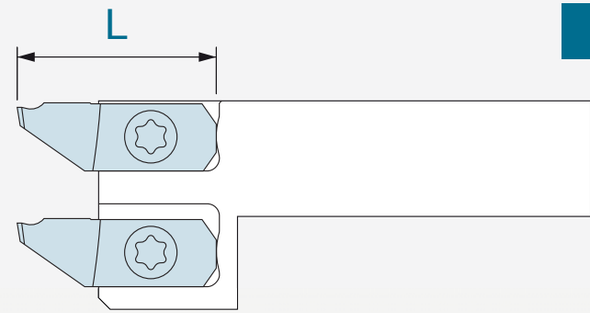


Changement de la plaquette possible dans la machine, sans démontage du porte-outil
WSP-Austauschmöglichkeit in der Maschine ohne Halterausbau
The insert can be changed in the machine without removing the tool holder

* = sur demande / auf Anfrage / on request

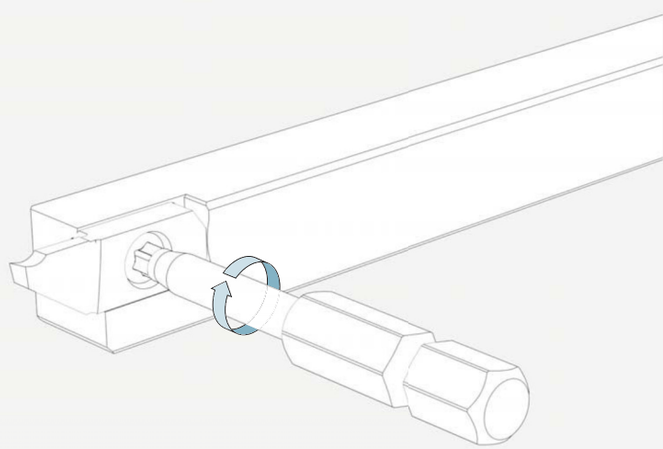
Spacerequirement

Conçu pour maximiser l'efficacité dans les espaces les plus restreints
Entwickelt, um die Effizienz auf engstem Raum zu maximieren
Designed to maximize efficiency in the tightest spaces



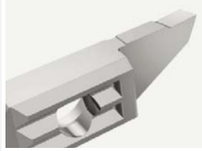
Optimal clamping

Le couple de serrage recommandé est de 2 Nm
Das empfohlene Anzugsdrehmoment beträgt 2 Nm
The recommended tightening torque is 2 Nm



µK10 - µK20

KN



K10 - K20

Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

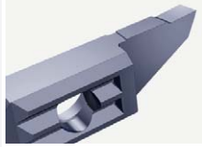
- nuance de base non revêtue micro-grain alliant une très bonne résistance à l'usure et ténacité
- recommandé pour l'usinage des matières ne nécessitant aucun revêtement par exemple le titane pur

- unbeschichtete Basis-Nuance mit feiner Körnung, die eine sehr gute Verschleißfestigkeit und Zähigkeit vereint
- empfohlen für die Bearbeitung von Materialien, die keine Beschichtung erfordern, wie z. B. reines Titan

- uncoated base grade with fine grain, combining excellent wear resistance and toughness
- recommended for machining materials that require no coating, such as pure titanium

µK10 - µK20

KTA



K10 - K20

µK10 - µK20 + revêtement PVD
µK10 - µK20 + PVD Beschichtung
µK10 - µK20 + PVD coating

TF F M E

P ★★★★☆
M ★★★★★
N ★☆☆☆☆
S ★★★★★

- nuance universelle
- 1er choix pour l'usinage des aciers, aciers inoxydables et alliage de titane

- universelle Sorte
- erste Wahl für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen

- universal grade
- first choice for machining steel, stainless steel, and titanium alloys

µK10 - µK20

KST



K10 - K20

µK10 - µK20 + revêtement PVD
µK10 - µK20 + PVD Beschichtung
µK10 - µK20 + PVD coating

TF F M E

P ★★★★☆
M ★★★★★
N ★☆☆☆☆
S ★★★★★

- nuance très résistante à l'usure et à la température
- 1er choix pour les aciers > 50 HRC, les alliages à base de nickel, chrome-cobalt, inox et titane allié

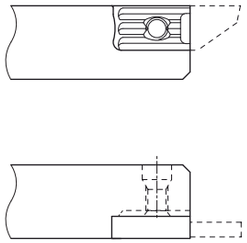
- sehr verschleiß- und temperaturbeständige Sorte
- erste Wahl für Stähle > 50 HRC, Nickelbasislegierungen, Chrom-Kobalt, Edelstahl und legiertes Titan

- highly wear- and temperature-resistant grade
- first choice for steels > 50 HRC, nickel-based alloys, chrome-cobalt, stainless steels, and alloyed titanium

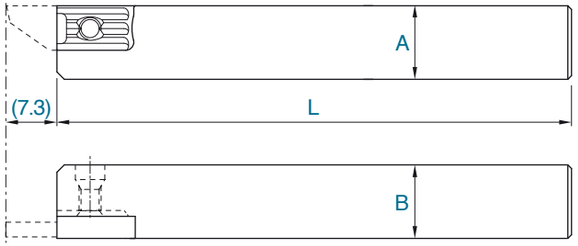
Matière Werkstoff Material		Tournage Drehen Turning			Tronçonnage Abstechen Parting off		
		VC (m/min)	Prof. depasse Schnitttiefe Depth of cut (mm)	Avance Vorschub Feed (mm/U)	VC (m/min)	Largeur decoupe Abstechbreite Cuttingwidth (mm)	Avance Vorschub Feed (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	120 - 200	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25	80 - 150	0.50 - 1.50 1.50 - 2.50	0.01 - 0.08 0.03 - 0.15
Acier Stahl Steel	< 600 N/mm² P	80 - 160	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25	70 - 120	0.50 - 1.50 1.50 - 2.50	0.01 - 0.06 0.03 - 0.12
Acier Stahl Steel	< 800 N/mm² P	60 - 120	0.05 - 1.0 1.0 - 4.0	0.01 - 0.10 0.05 - 0.20	60 - 100	0.50 - 1.50 1.50 - 2.50	0.01 - 0.05 0.03 - 0.10
Acier Stahl Steel	> 800 N/mm² P	50 - 100	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15	40 - 80	0.50 - 1.50 1.50 - 2.50	0.01 - 0.04 0.03 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	M	60 - 120	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15	60 - 100	0.50 - 1.50 1.50 - 2.50	0.01 - 0.04 0.03 - 0.08
Aluminium Si < 12%	N	200 - 1000	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40	180 - 400	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Aluminium Si > 12%	N	180 - 800	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40	150 - 300	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	N	100 - 500	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.35	100 - 300	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Titane Titan Titanium	S	30 - 70	0.05 - 1.0 1.0 - 4.0	0.01 - 0.08 0.05 - 0.15	30 - 50	0.50 - 1.50 1.50 - 2.50	0.01 - 0.03 0.03 - 0.06

Zurück zum Kapitelanfang

L



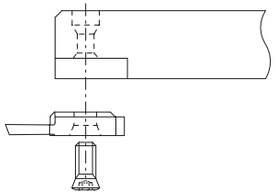
R



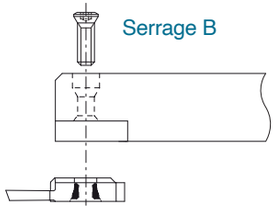


A x B	L	Serrage Spannsystem Clamping	L	R
			Art. N°	Art. N°
8 x 8	115	A+B	130-8	140-8
10 x 10	115	A+B	130-10	140-10
12 x 12	115	A+B	130-12	140-12

Serrage A



Serrage B

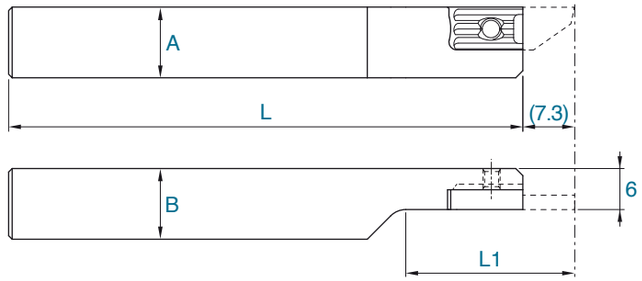


Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schraubengeliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

Zurück zum Kapitelanfang

Utiliser des plaquettes type 131R
WSP Typ 131R verwenden
Use inserts type 131R

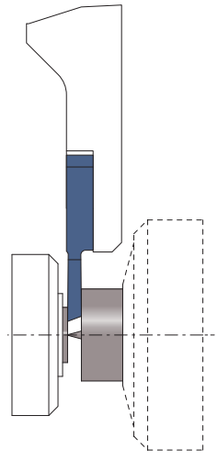
Voir pages 3.11 - 3.14
Siehe Seiten 3.11 - 3.14
See pages 3.11 - 3.14





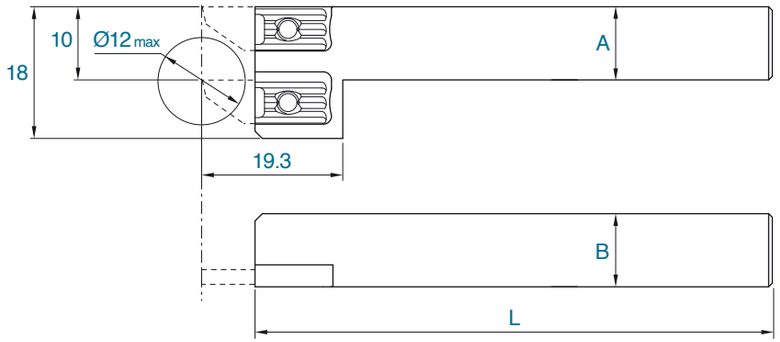
L (R)
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

AxB	L	L1	Serrage Spannsystem Clamping	Art. N°
8 x 8	115	24	A	130RC-8
10 x 10	115	24	A	130RC-10
12 x 12	115	30	A	130RC-12



Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schraubengeliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

R



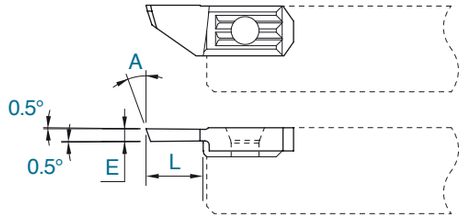




R

A x B	L	Serrage Spannsystem Clamping	Art. N°
8 x 8	115	A+B	140-8-H10-DUO
10 x 10	115	A+B	140-10-H10-DUO
12 x 12	115	A+B	140-12-H10-DUO

Cut R



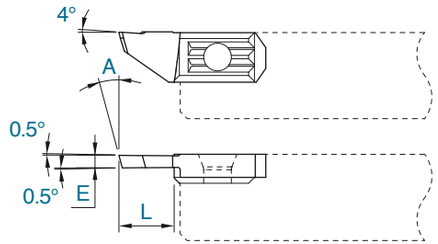
L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	KTA	KST	KN (µk10-20)
1.0	20°	5	131R-1.0-20	●	●	●
1.2	20°	5	131R-1.2-20	●	●	●
1.5	20°	7	131R-1.5-20	●	●	●
2.0	20°	7	131R-2.0-20	●	●	●

Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schrauben geliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

Cut R





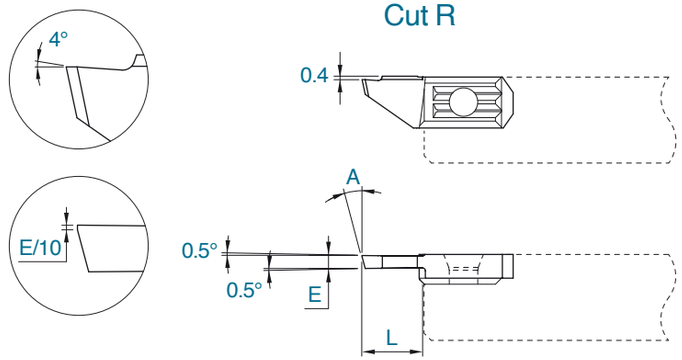
L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	KTA	KST	KN (µx10-20)
1.0	15°	5	131RX4-1.0	●	●	●
1.5	15°	7	131RX4-1.5	●	●	●

Zurück zum Kapitelanfang

Cut R



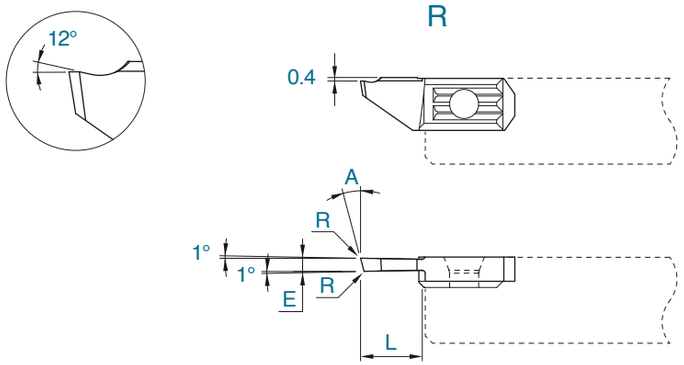


L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	KTA	KST	KN (µx10-20)
1.0	15°	5	131RXF-1.0	●	●	●
1.5	15°	7	131RXF-1.5	●	●	●

Tronçonnage
Abstechen
Parting off

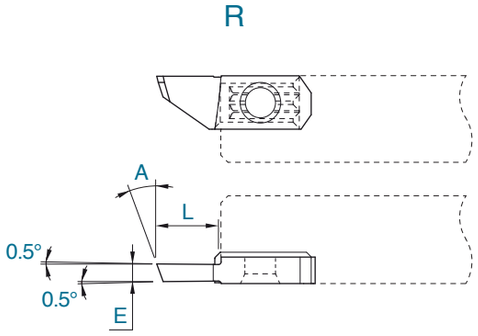


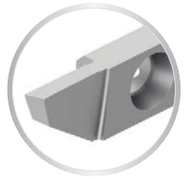


L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

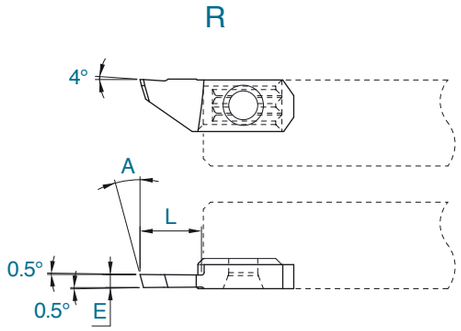
E	A	L	R	Art. N°	KTA	KST	KN (µx10-20)
1.0	15°	5	0.03	131RX12-1.0	●	●	●
1.5	15°	7	0.03	131RX12-1.5	●	●	●

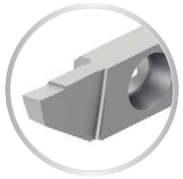




R

E	A	L	Art. N°	KTA	KST	KN (µx10-20)
0.6	20°	3	141-0.6-20	●	●	●
0.8	20°	5	141-0.8-20	●	●	●
1.0	20°	5	141-1.0-20	●	●	●
1.2	20°	5	141-1.2-20	●	●	●
1.5	20°	7	141-1.5-20	●	●	●
2.0	20°	7	141-2.0-20	●	●	●
2.5	20°	7	141-2.5-20	●	●	●



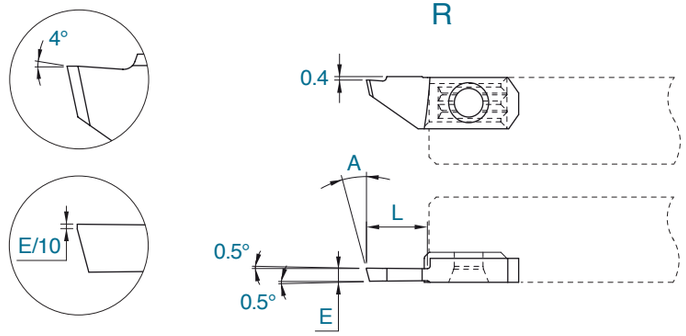


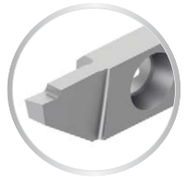
E	A	L	Art. N°	KTA	KST	KN (µx10-20)
				R		
0.8	15°	5	141X4-0.8	●	●	●
1.0	15°	5	141X4-1.0	●	●	●
1.5	15°	7	141X4-1.5	●	●	●
2.0	15°	7	141X4-2.0	●	●	●

1XX-XX-B

Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04

Zurück zum Kapitelanfang

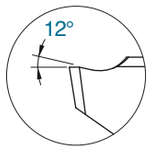


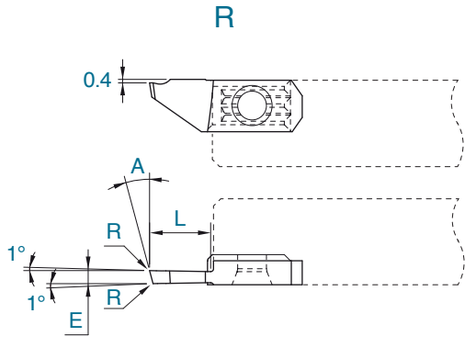


E	A	L	Art. N°	KTA	KST	KN (µx10-20)
				R		
1.0	15°	5	141XF-1.0	●	●	●
1.2	15°	5	141XF-1.2	●	●	●
1.5	15°	7	141XF-1.5	●	●	●

1XX-XX-B

Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04





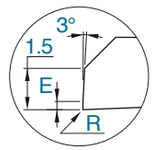


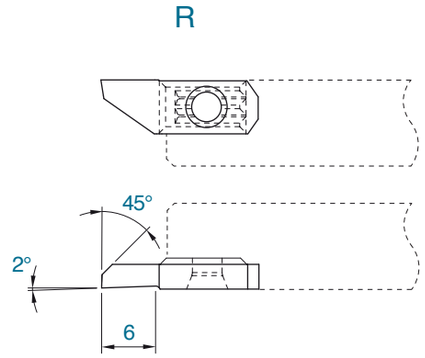
E	A	L	R	Art. N°	KTA	KST	KN (µK10-20)
0.5	15°	3	0.03	141X12-0.5	●	●	●
1.0	15°	5	0.03	141X12-1.0	●	●	●
1.5	15°	7	0.03	141X12-1.5	●	●	●

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Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04

Zurück zum Kapitelanfang



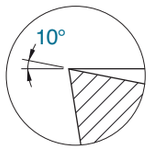


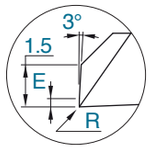


E	R	Art. N°	KTA	KST	KN (µK10-20)
0.3	0	142-2	●	●	●
0	0-0.01	142-2-R01	●	●	●
0	0.08	142-2-R08	●	●	●

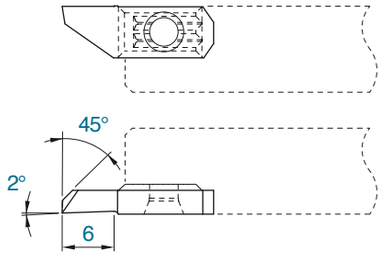
1XX-XX-B

Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
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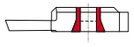
R





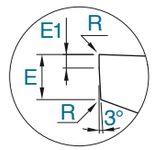
E	R	Art. N°	KTA	KST	KN (µx10-20)
0.3	0	142X10-2	●	●	●
0	0-0.01	142X10-2-R01	●	●	●
0	0.08	142X10-2-R08	●	●	●

1XX-XX-B

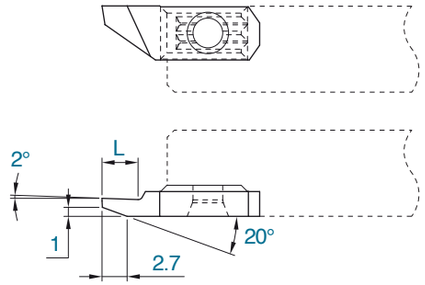


Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
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Zurück zum Kapitelanfang



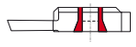
R



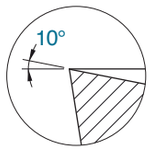


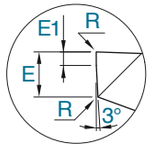
E	E1	L	R	Art. N°	KTA	KST	KN (µx10-20)
0.5	0.15	3	0	143-0.5	●	●	●
0.5	0	3	0-0.01	143-0.5-R01	●	●	●
0.5	0	3	0.08	143-0.5-R08	●	●	●
1.0	0.3	4	0	143-1.0	●	●	●
1.0	0	4	0	143-1.0-R01	●	●	●
1.0	0	4	0.08	143-1.0-R08	●	●	●

1XX-XX-B

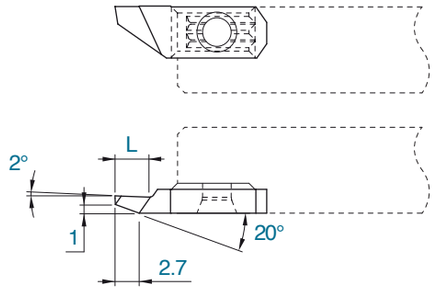


Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04





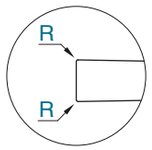
R



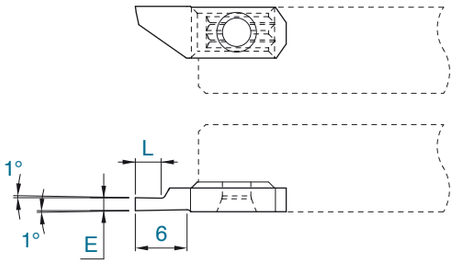


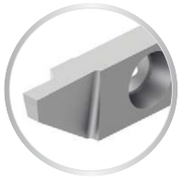
E	E1	L	R	Art. N°	KTA	KST	KN (µK10-20)
0.5	0.15	3	0	143X10-0.5	●	●	●
0.5	0	3	0-0.01	143X10-0.5-R01	●	●	●
0.5	0	3	0.08	143X10-0.5-R08	●	●	●
1.0	0.3	4	0	143X10-1.0	●	●	●
1.0	0	4	0-0.01	143X10-1.0-R01	●	●	●
1.0	0	4	0.08	143X10-1.0-R08	●	●	●



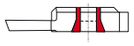


R

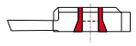




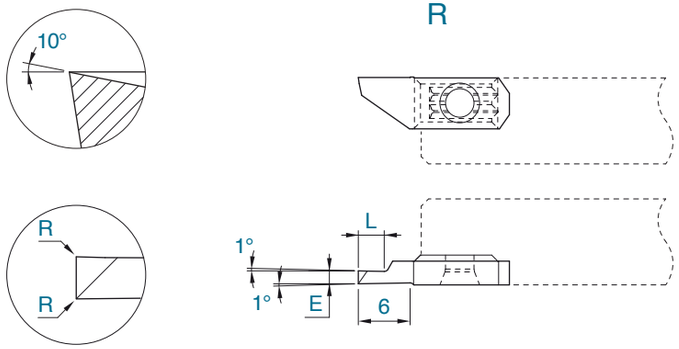
E	L	R	Art. N°	KTA	KST	KN (µK10-20)
0.5	1.5	0	144-0.5	●	●	●
0.6	1.8	0	144-0.6	●	●	●
0.8	2	0	144-0.8	●	●	●
1.0	2.5	0	144-1.0	●	●	●
1.0	3	0.08	144-1.0-R08	●	●	●
1.5	3	0	144-1.5	●	●	●
1.5	3	0.08	144-1.5-R08	●	●	●

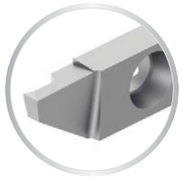


Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04



Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04



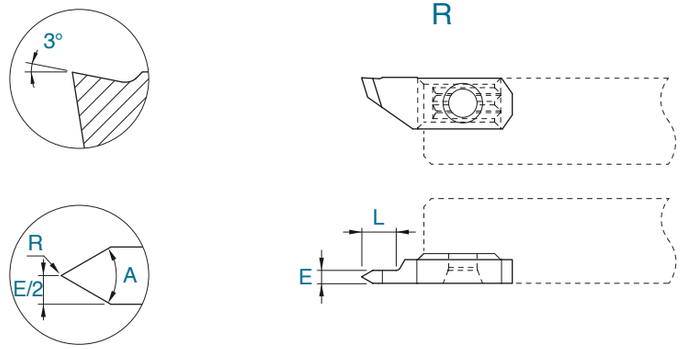


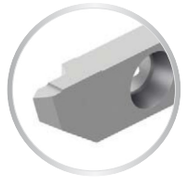
E	L	R	Art. N°	R KTA	R KST	R KN (µx10-20)
0.8	2	0	144X10-0.8	●	●	●
1.0	2.5	0	144X10-1.0	●	●	●
1.0	2.5	0.08	144X10-1.0-R08	●	●	●
1.5	3	0	144X10-1.5	●	●	●
1.5	3	0.08	144X10-1.5-R08	●	●	●

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Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04

Zurück zum Kapitelanfang





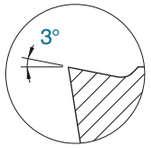
Profil partiel
Teilprofil
Partial profile

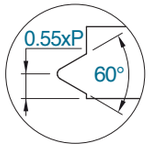
A	E	L	R	Pas mm Steigung mm Pitch mm P	Art. N°	R KTA	R KST	R KN (µx10-20)
60°	1.5	4	0	-	146X3-60-1.5	●	●	●
60°	1.5	4	0.03	0.25-0.35	146X3-60-1.5-R03	●	●	●
60°	2.0	6	0.06	0.40-0.70	146X3-60-2.0-R06	●	●	●
60°	2.0	6	0.12	0.8-1.25	146X3-60-2.0-R12	●	●	●

A	E	L	R	Pas TPI Steigung TPI Pitch TPI P	Art. N°	KTA	KST	KN (µx10-20)
55°	1.5	4	0	-	146X3-55-1.5	●	●	●
55°	1.5	4	0.06	32-48	146X3-55-1.5-R06	●	●	●
55°	2.0	6	0.12	18-26	146X3-55-2.0-R12	●	●	●

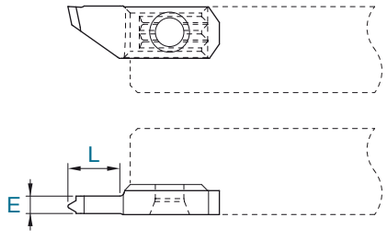
1XX-XX-B

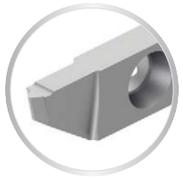
Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04



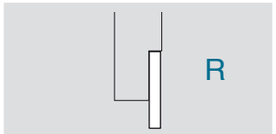


R





Profil complet métrique
Metrisches Vollprofil
Metric full profile

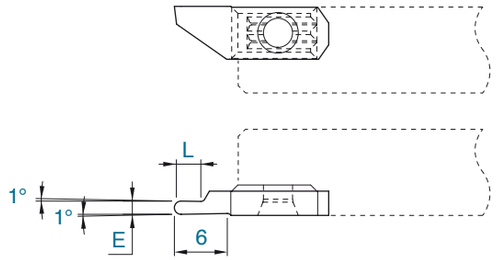


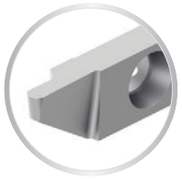
Pas Steigung Pitch P	E	L	Art. N°	KTA	KST	KN (µx10-20)
0.25	1.0	3	146X3-M-0.25	●	●	●
0.30	1.0	3	146X3-M-0.30	●	●	●
0.35	1.0	3	146X3-M-0.35	●	●	●
0.40	1.0	3	146X3-M-0.40	●	●	●
0.45	1.0	3	146X3-M-0.45	●	●	●
0.50	1.0	3	146X3-M-0.50	●	●	●
0.60	1.0	3	146X3-M-0.60	●	●	●
0.70	1.0	3	146X3-M-0.70	●	●	●
0.75	1.0	3	146X3-M-0.75	●	●	●
0.80	1.5	4.5	146X3-M-0.80	●	●	●
1.00	1.5	4.5	146X3-M-1.00	●	●	●
1.25	1.5	4.5	146X3-M-1.25	●	●	●
1.50	2.0	6	146X3-M-1.50	●	●	●
1.75	2.0	6	146X3-M-1.75	●	●	●

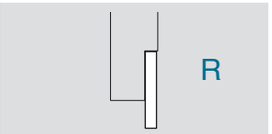
1XX-XX-B

Sur demande pour serrage type B, voir page 3.04
Auf Anfrage für B-Spannsystem, siehe Seite 3.04
On request for B clamping system, see page 3.04

R



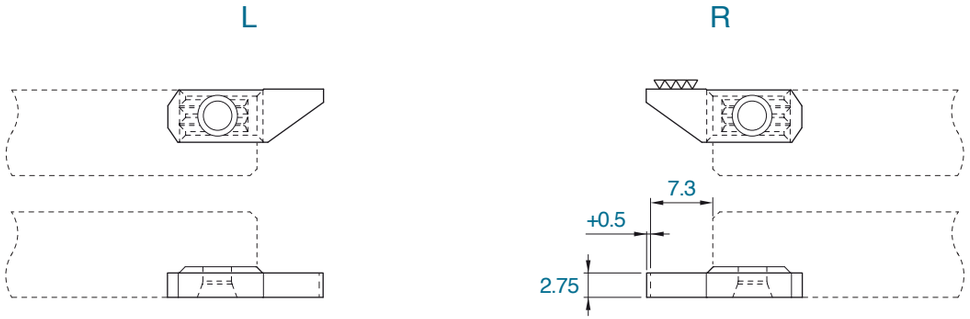




R	L	Art. N°	KTA	KST	KN (µx10-20)
0.25	1.5	147-R0.25	●	●	●
0.40	2	147-R0.4	●	●	●
0.50	2.5	147-R0.5	●	●	●
0.60	2.5	147-R0.6	●	●	●
0.75	3	147-R0.75	●	●	●
0.80	3	147-R0.8	●	●	●
1.0	4	147-R1.0	●	●	●

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Sur demande pour serrage type B, voir page 3.04
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Face de coupe polie
Polierte Schnittfläche
Polished cutting face

L				R			
Art. N°	KTA	KST	KN (µk10-20)	Art. N°	KTA	KST	KN (µk10-20)
131-EP	●	●	●	141-EP	●	●	●

	Porte-outils Halter Holders	Serrage standard (A) Standard Spannsystem (A) Standard clamping system (A)	Options	Serrage type B Spannsystem Typ B Clamping system type B	Options
130	130-8	V-M3x7-T8	C-T8	V-M2.5X7.8-T8	C-T8
	130-10				
	130-12				
	130RC-8	V-M3x5.5-T8		-	
	130RC-10				
	130RC-12				
140	140-8	V-M3x7-T8	C-T8	V-M2.5X7.8-T8	C-T8
	140-10				
	140-12				
	140-8-H10-DUO				
	140-10-H10-DUO				
	140-12-H10-DUO				

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Sur demande pour serrage type B, voir page 3.04
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On request for B clamping system, see page 3.04