# ONE-Watch



APPLITEC
CUTTING TOOLS

Codification
Kodifizierung
Coding guide >4.03

Infos et avantages
Infos und Vorteile
Infos and advantages >4.04

Nuances
Sorten
Grades >4.05

Porte-outils
Halter
Holder 130 / 140  >4.07

Tronçonnage
Abstechen
Parting off 131SF / 141SF  >4.10

Tournage avant
Vorwärts drehen
Front turning 142SF  >4.13

Tournage arrière
Rückwärts drehen
Back turning 143SF  >4.16

Filetage
Gewinde drehen
Threading 146SFX3  >4.19

Plaquettes piqûre avant
Fronteinstich WSP
Front grooving inserts 148SF  >4.20

Plaquettes piqûre arrière
Rückeinstich WSP
Back grooving inserts 149SF  >4.21

Plaquettes ébauches
WSP-Rohlinge
Blank inserts 131-ESF / 141-ESF  >4.22

Pièces de rechange et accessoires
Ersatzteile und Zubehöre
Spare parts and accessories >4.23



Zurück zum Kapitelanfang



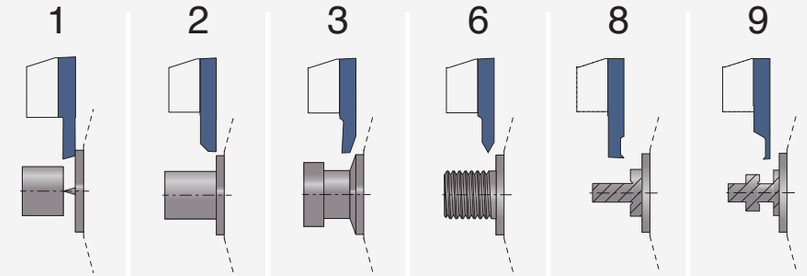
| 1 | 4 | 3 | SF | - | 3/3 | - | 45 | - | KSTF |
|---|---|---|---|---|---|---|---|---|---|

SF: Super finish

3/3: Dimension
Abmessung
Dimension

45: Nuance
Sorte
Grade

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry

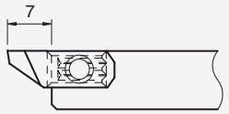



Gamme de produit
Produktserie
Product series

définit la compatibilité des plaquettes avec le porte-outils
bestimmt die WSP und Halter Kompatibilität
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 |

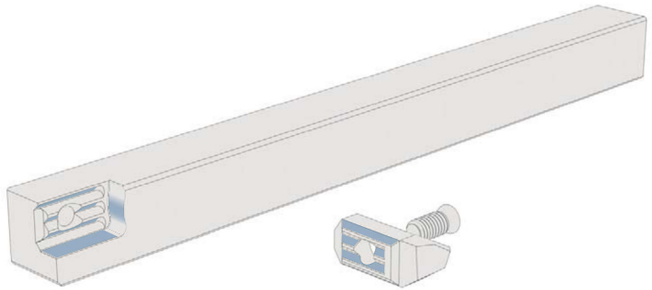


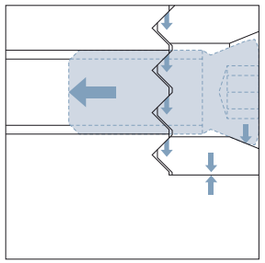

Applitec série 100
Applitec 100 Serie
Applitec 100 series

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

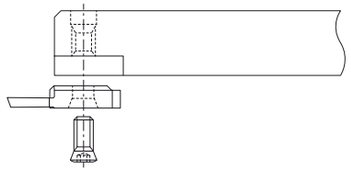
# Rigid!

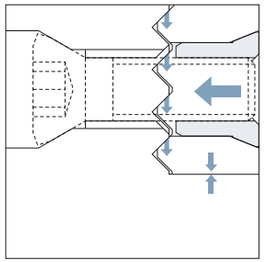
Système de serrage Applitec à denture décalée
Applitec-Spannsystem mit verschobener Verzahnung
Applitec clamping system with shifted teeth





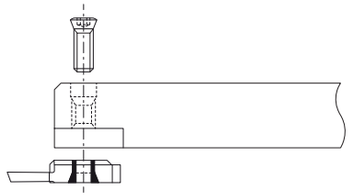
Serrage standard (A)
Standard Spannsystem (A)
Standard clamping system (A)





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





## µK10 - µK20

### KTC



K10 - K20

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

TF F M E

P ★★★★★
M ★★★☆☆
N ★★★★☆
S ★★★☆☆

- nuance résistante à l'usure, faible coefficient de frottement, recommandée pour des opérations d'ébauche et de finition
- conseillé pour l'usinage de la matière 20AP + aciers de décolletage

- verschleissfeste Sorte, geringer Reibwert, für Schruppen und Schlichtbearbeitung empfohlen
- empfohlen für die Bearbeitung von Material 20AP + Automatenstahl

- wear resistant grade, low friction ratio, recommended for roughing and finishing
- recommended for suitable for machining of 20AP material + Free-cutting steel

## µK10 - µK20

### KTC-RE



K10 - K20

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

TF F M E

P ★★★★★
M ★★★☆☆
N ★★★★☆
S ★★★☆☆

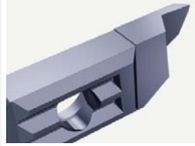
- nuance identique à KTC avec dépouilles rectifiées après revêtement pour des opérations de finition
- conseillé pour l'usinage de la matière 20AP + aciers de décolletage

- gleiche Sorte wie KTC nach der Beschichtung geschliffener Freiwinkel, für Schlichtbearbeitung empfohlen
- empfohlen für die Bearbeitung von Material 20AP + Automatenstahl

- same grade as KTC, after coating grounded clearance, recommended for finishing
- recommended for suitable for machining of 20AP material + Free-cutting steel

## µK10 - µK20

### KTAF



K10 - K20

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

TF F M E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

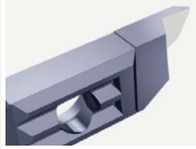
- nuance résistante à l'usure, recommandée pour des opérations d'ébauche et de finition
- conseillé pour l'usinage des matières Finemac et inox 4c27a

- verschleissfeste Sorte, für Schruppen und Schlichtbearbeitung empfohlen
- empfohlen für die Bearbeitung von Finemac und Inox 4c27a rostfreiem Stahl

- wear resistant grade, recommended for roughing and finishing
- recommended for suitable for machining of Finemac and 4c27a stainless steel

µK10 - µK20

## KTAF-RE



K10 - K20

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

TF F M E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- nuance identique à KTAF avec dépouilles rectifiées après revêtement pour des opérations de finition
- recommandé pour les matières Finemac et inox 4c27a

- gleiche Sorte wie KTAF nach der Beschichtung geschliffener Freiwinkel, für Schlichtbearbeitung empfohlen
- empfohlen für die Bearbeitung von Finemac und Inox 4c27a rostfreiem Stahl

- same grade as KTAF, with clearance angles rectify after coating, recommended for finishing
- recommended for suitable for machining of Finemac and 4c27a stainless steel

µK10 - µK20

## KSTF



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 aciers à base de nickel, chrome-cobalt, inox et titane allié

- verschleißfeste Sorte, beständig gegen hohe Temperaturen
- erste Wahl für Stähle > 50 HRC, Nickelbasislegierungen, Chrom-Kobalt, rostfreien Stahl und legiertes Titan

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

µK10 - µK20

## KN



K10 - K20

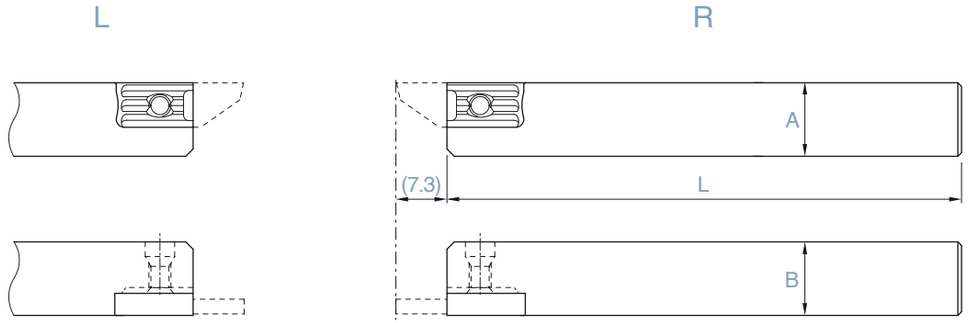
Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

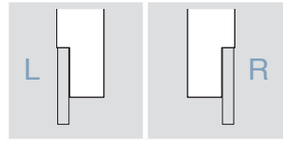
- nuance de base non revêtue micro-grain, alliant une très bonne résistance à l'usure et une bonne ténacité
- recommandé pour l'usinage des matières ne nécessitant aucun revêtement, par exemple le titane pur

- verschleißfeste Feinkornsorte, unbeschichtet, mit hoher Zähigkeit und guter Widerstandsfähigkeit
- empfohlen für die Bearbeitung von Werkstoffen, die keine Beschichtung erfordern, zum Beispiel reines Titan

- wear-resistant micro-grain grade, uncoated, with high toughness and good resistance
- recommended for machining materials that do not require coating, such as pure titanium

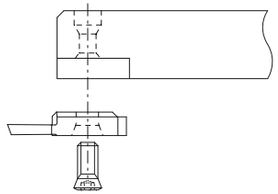




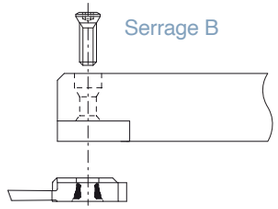




| A x B | L | Serrage Spannsystem Clamping | Art. N° | Art. N° |
|---|---|---|---|---|
| 8 x 8 | 115 | A+B | 130-8 | 140-8 |
| 10 x 10 | 115 | A+B | 130-10 | 140-10 |
| 12 x 12 | 115 | A+B | 130-12 | 140-12 |

Serrage A



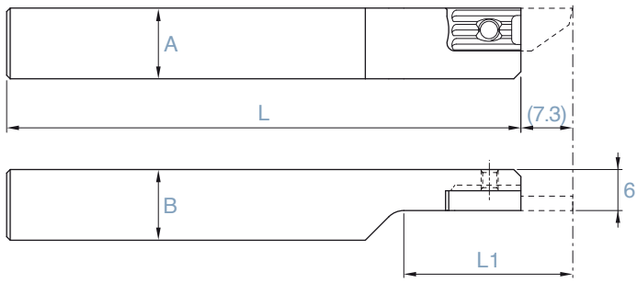
Serrage B



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.

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

Voir pages 4.10 - 4.11
Siehe Seiten 4.10 - 4.11
See pages 4.10 - 4.11

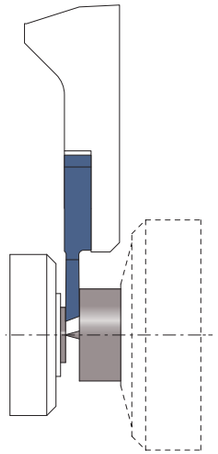





L (R)

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 |



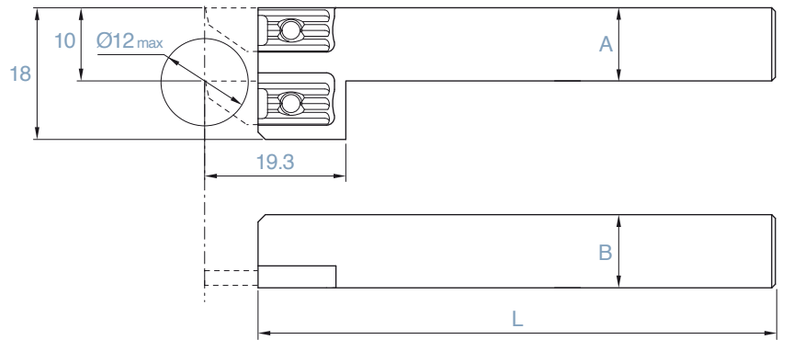
Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schraubengeliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.



Zurück zum Kapitelanfang



R






R

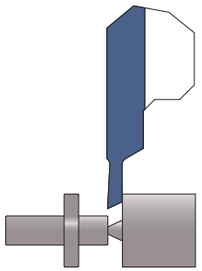
| A x B | L | Serrage Spannsystem Clamping | Art. N° |
|---|---|---|---|
| 8 x 8 | 115 | A+B | 140-8-H10-DUO |
| 10 x 10 | 115 | A+B | 140-10-H10-DUO |
| 12 x 12 | 115 | A+B | 140-12-H10-DUO |

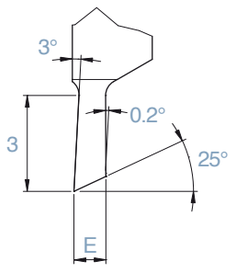
Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schraubengeliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

131RSF

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

Tronçonnage
Abstechen
Parting off








L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

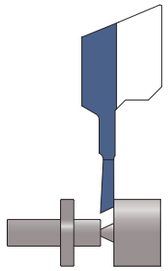
| E | Art. N° | KTAF | KSTF | KN (µk10-20) |
|---|---|---|---|---|
| 1.0 | 131RSF-1.0-25 | ● | ● | ● |

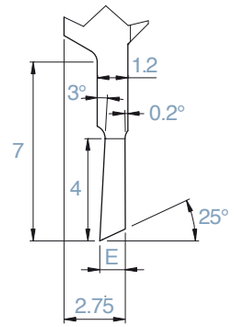


131RDSF

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

Tronçonnage
Abstechen
Parting off



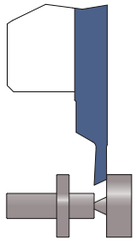


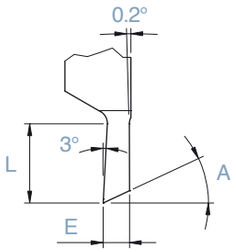


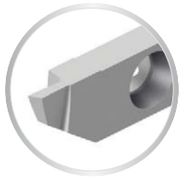

L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

| E | Art. N° | KTAF | KN (µk10-20) |
|---|---|---|---|
| 1.0 | 131RDSF-1.0-25 | ● | ● |





| A | E | L | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KSTF | KN (µK10-20) |
|---|---|---|---|---|---|---|---|---|---|
| 25° | 0.5 | 2 | 141SF-0.5-25 | ● | ● | ● | ● | ● | ● |
| | 0.8 | 3 | 141SF-0.8-25 | ● | ● | ● | ● | ● | ● |
| | 1.0 | 3 | 141SF-1.0-25 | ● | ● | ● | ● | ● | ● |
| 22° | 1.2 | 5 | 141SF-1.2-22 | ● | ● | ● | ● | ● | ● |

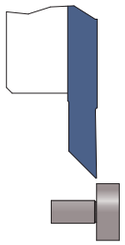
1XX-XX-B

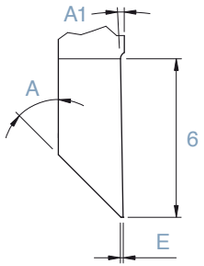
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04



Zurück zum Kapitelanfang





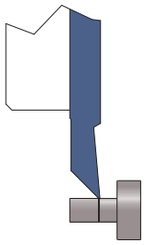


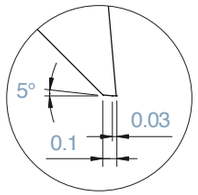


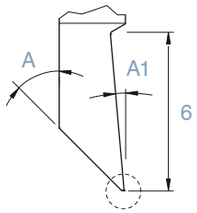

| E | A | A1 | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KSTF | KN (µK10-20) |
|---|---|---|---|---|---|---|---|---|---|
| 0.03 | 45° | 3° | 142SF-3/3-45 | ● | ● | ● | ● | ● | ● |
| 0.05 | 45° | 3° | 142SF-5/5-45 | ● | ● | ● | ● | ● | ● |
| 0.08 | 45° | 1° | 142SF-8/8-45 | ● | ● | ● | ● | ● | ● |

1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04








| A | A1 | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KSTF | KN (µk10-20) |
|---|---|---|---|---|---|---|---|---|
| | | | | | | | | |
| 45° | 5° | 142SF-10/3 | ● | ● | ● | ● | ● | ● |

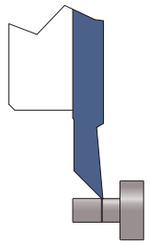
R

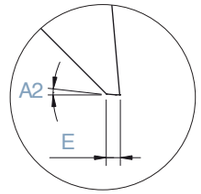
1XX-XX-B Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

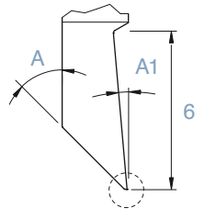


Zurück zum Kapitelanfang









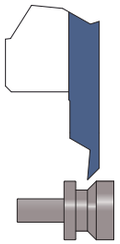

| E | A | A1 | A2 | Art. N° | KTAF-RE | KSTF | KN (µk10-20) |
|---|---|---|---|---|---|---|---|
| | | | | | | | |
| 0.1 | 45° | 5° | 5° | 142SF-10/0-5-45 | ● | ● | ● |
| 0.15 | 30° | 3° | 2° | 142SF-15/0-2-30 | ● | ● | ● |

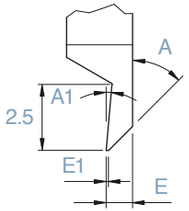
R

1XX-XX-B Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Tournage arrière
Rückwärts drehen
Back turning







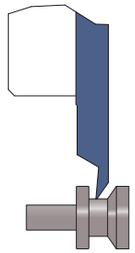


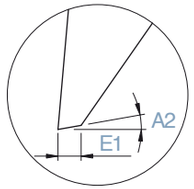

R

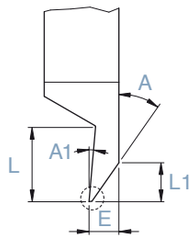
| E1 | E | A | A1 | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KSTF | KN (µk10-20) |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | P | P | P | P | P | P |
| | | | | | | | M | M | M | M |
| | | | | | | | N | N | N | N |
| | | | | | | | S | S | S | S |
| 0.03 | 1.0 | 45° | 5° | 143SF-3/3-45-1.0 | ● | ● | ● | ● | ● | ● |
| 0.03 | 1.2 | 45° | 5° | 143SF-3/3-45-1.2 | ● | ● | ● | ● | ● | ● |
| 0.10 | 1.0 | 45° | 5° | 143SF-10/10-45-1.0 | ● | ● | ● | ● | ● | ● |
| 0.05 | 0.8 | 30° | 3° | 143SF-5/5-30-0.8 | | | | ● | | |

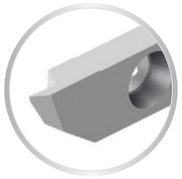
1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04





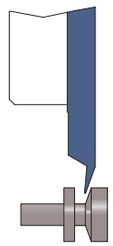



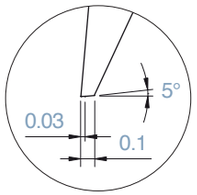
R

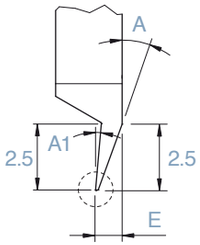
| E1 | E | L1 | L | A | A1 | A2 | Art. N° | KTAF-RE | KN (µk10-20) |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | P | P |
| | | | | | | | | M | M |
| | | | | | | | | N | N |
| | | | | | | | | S | S |
| 0.08 | 1.0 | 1.6 | 2.5 | 30° | 5° | 2° | 143SF-8/0-2-30-1.0 | ● | ● |
| 0.15 | 1.2 | 1.8 | 4.0 | 30° | 3° | 2° | 143SF-15/0-2-30-1.2 | ● | ● |
| 0.10 | 1.0 | 1.3 | 2.5 | 35° | 5° | 10° | 143SF-10/0-10-35-1.0 | ● | ● |

1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04








R

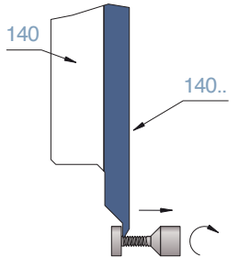
| E | A | A1 | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KN (µK10-20) |
|---|---|---|---|---|---|---|---|---|
| | | | | P | P | P M N S | P M N S | P M N S |
| 1.0 | 20° | 5° | 143SF-10/3 | | ● | ● | ● | ● |

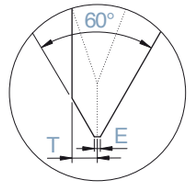
1XX-XX-B Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

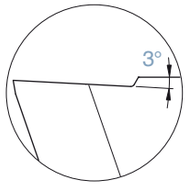


Zurück zum Kapitelanfang





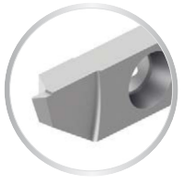




Filetageàdroite
sens rotation machine M3

RechtgewindeDrehrichtung
der Maschine M3

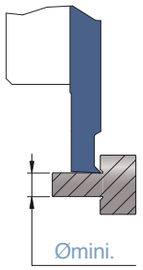
Right-hand thread rotating
machineryM3

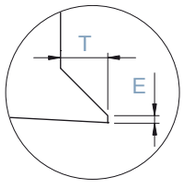


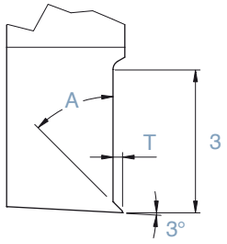
R

| Filetage Gewindedrehen Threading | Pas Steigung Pitch P | T | E 0/-0.01 | Art. N° | KTAF | KN (µK10-20) |
|---|---|---|---|---|---|---|
| | | | | | P M N S | P M N S |
| S0.50 | 0.125 | 0.07 | 0.025 | 146SFX3-A60-S0.50-AR | ● | ● |
| S0.60 | 0.150 | 0.09 | 0.030 | 146SFX3-A60-S0.60-AR | ● | ● |
| S0.70 | 0.175 | 0.10 | 0.035 | 146SFX3-A60-S0.70-AR | ● | ● |
| S0.80 | 0.200 | 0.12 | 0.040 | 146SFX3-A60-S0.80-AR | ● | ● |
| S0.90 | 0.225 | 0.13 | 0.045 | 146SFX3-A60-S0.90-AR | ● | ● |
| S1.00 | 0.250 | 0.15 | 0.050 | 146SFX3-A60-S1.00-AR | ● | ● |

1XX-XX-B Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04






| E | A | T | Ømini. | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KN (µK10-20) |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | P M N S | P M N S | P M N S | P M N S | P M N S |
| 0.03 | 46° | 0.2 | 0.3 | 148SF-E03-A46-L20 | ● | ● | ● | ● | ● |
| 0.05 | 46° | 0.3 | 0.4 | 148SF-E05-A46-L30 | ● | ● | ● | ● | ● |
| 0.08 | 46° | 0.5 | 0.5 | 148SF-E08-A46-L50 | ● | ● | ● | ● | ● |

R

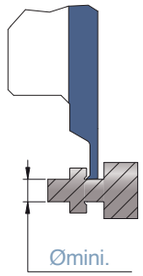
1XX-XX-B

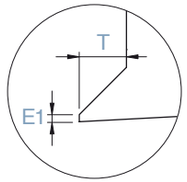
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

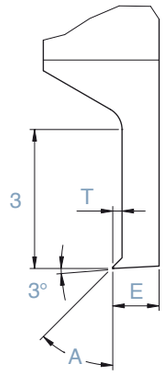


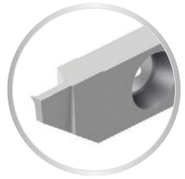
Zurück zum Kapitelanfang





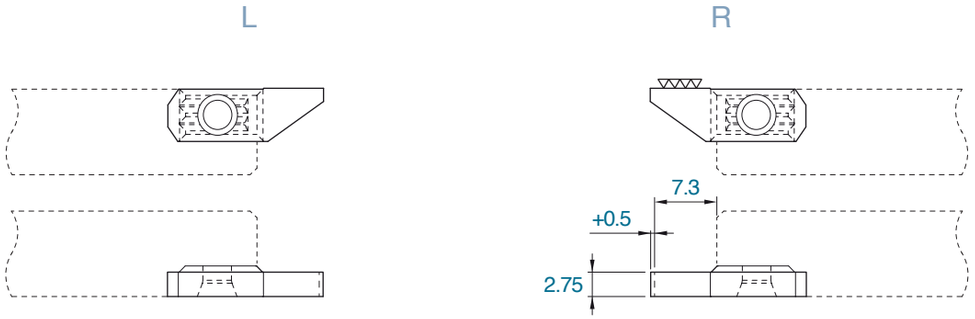



| E1 | A | T | E | Ømini. | Art. N° | KTC | KTC-RE | KTAF | KTAF-RE | KN (µK10-20) |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | P M N S | P M N S | P M N S | P M N S | P M N S |
| 0.03 | 46° | 0.2 | 1.0 | 0.3 | 149SF-E03-A46-L20-B100 | ● | ● | ● | ● | ● |
| 0.05 | 46° | 0.3 | 1.0 | 0.4 | 149SF-E05-A46-L30-B100 | ● | ● | ● | ● | ● |
| 0.08 | 46° | 0.5 | 1.2 | 0.5 | 149SF-E08-A46-L50-B120 | ● | ● | ● | ● | ● |

R

1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

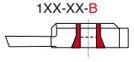





Face de coupe polie
Polierte Schnittfläche
Polished cutting face

| L | | | | | | R | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Art. N° | KTC | KTAF | KSTF | KCR-TF | KN (µk10-20) | Art. N° | KTC | KTAF | KSTF | KCR-TF | KN (µk10-20) |
| 131-ESF | ● | ● | ● | ● | ● | 141-ESF | ● | ● | ● | ● | ● |

| | Porte-outils<br>Halter<br>Holders | Serrage standard (A)<br>Standard Spannsystem (A)<br>Standard clamping system (A) | Options | Serrage type B<br>Spannsystem Typ B<br>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 | | | | |




Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04