ECO-Line



APPLITEC
CUTTING TOOLS

Codification
Kodifizierung
Coding guide >6.03

Infos et avantages
Infos und Vorteile
Infos and advantages >6.04

Nuances & paramètres de coupe indicatifs
Sorten & empfohlene Schnittwerte
Grades & standard machining data >6.05

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Halter
Holders  >6.08

Tronçonnage
Abstechen
Parting off 251 / 261  >6.12

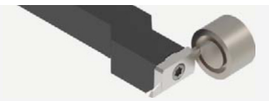
Tournage avant
Vorwärts drehen
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Filetage
Gewinde drehen
Threading 256 / 266  >6.26

Plaquettes ébauches
WSP-Rohlinge
Blank inserts 251E / 261E  >6.28

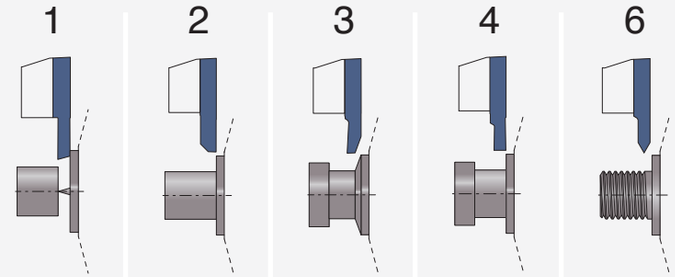
Usinage axial (porte-outils et plaquettes)
Axiale Bearbeitung (Halter und WSP)
Axial machining (holders and inserts) RFG  >6.29

Pièces de rechange et accessoires
Ersatzteile und Zubehöre
Spare parts and accessories >6.31

Zurück zum Kapitelanfang

2	6	4	X	-	2.0	-	R20	-	AP302

- 2.0: Dimension / Abmessung / Dimension
- R20: Rayon / Radius / Radius
- AP302: 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

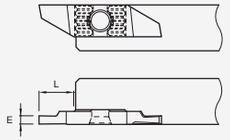


- 6: Gamme de produit / Produktserie / Product series — définit la compatibilité des plaquettes avec le porte-outil / bestimmt die WSP und Halter Kompatibilität / shows the inserts and holder compatibility

L = 5 (chiffre impair / ungerade Zahl / uneven number)

R = 6 (chiffre pair / gerade Zahl / even number)

L	R
250	260

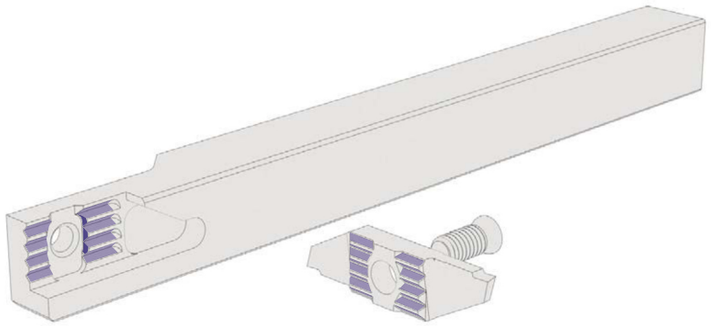


E max = 3.0 mm
L max = 8.5 mm

- Applitec série 200 / Applitec 200 Serie / Applitec 200 series — Système de serrage à denture avec 1 vis de fixation / Spannsystem mit Verzahnung und 1 Schraube / Teeth clamping system with 1 screw

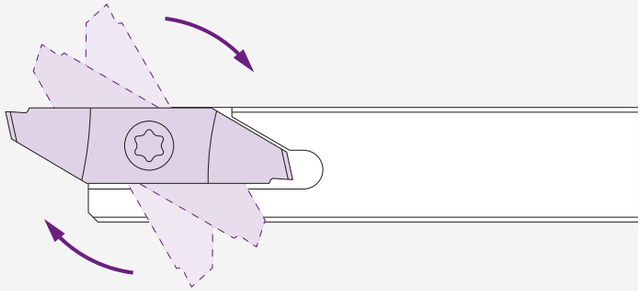
Economic performance!

Système de serrage à denture Applitec avec repositionnement au centre
Applitec-Zahnklemmsystem mit zentraler Neupositionierung
Applitec toothed clamping system with central repositioning



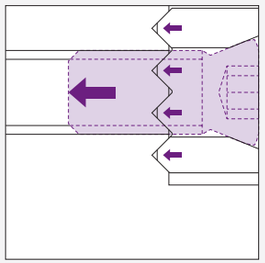
High precision

Grande précision lors du retournement de la plaquette
Hohe Präzision beim Wenden der Platte
High precision when flipping the insert



Applitec toothing

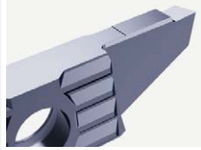
Système de serrage en fond de denture
Klemmvorrichtung an der Prothesenbasis
Clamping system at the denture base



Zurück zum Kapitelanfang

µK20

AP302



K20

µK20 + revêtement PVD
µK20 + PVD Beschichtung
µK20 + PVD coating

TF F M E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- excellente nuance universelle
- 1er choix pour l'usinage des aciers, aciers inoxydables et alliages de titane
- très bonne résistance à la température

- beste Universalsorte
- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bestens geeignet
- sehr gute Warmfestigkeit

- best universal grade
- first choice for steel, stainless steel and titanium alloys machining
- very good heat resistance

µK20

AP202



K20

µK20 + revêtement PVD
µK20 + PVD Beschichtung
µK20 + PVD coating

TF F M E

P ★★★★☆
M ★★★★☆
N ★★★☆☆
S ★★★☆☆

- nuance particulièrement adaptée aux faibles vitesses de coupe
- ancienne nuance, disponible uniquement sur demande

- besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten
- ältere Sorte, nur auf Anfrage erhältlich

- grade particularly suitable for low cutting speeds
- previous grade, available on request only

µK20

N



K20

Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

- nuance micro-grain tenace
- supporte les coupes interrompues et autres conditions d'usinage défavorables

- zähe Feinkornsorte
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen

- tough micro-grain grade
- suitable for interrupted cut and other unfavourable machining conditions

µK10

AH302



K10

µK20 + revêtement PVD
µK20 + PVD Beschichtung
µK20 + PVD coating

TF — F — M — E

P ★★★★★
M ★★★★★
N ★★★★
S ★★★★

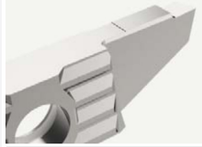
- nuance très résistante à l'usure
- pour l'usinage en finition dans des conditions favorables des aciers, aciers inoxydables et alliages de titanes

- sehr verschleissfeste Sorte
- für die Feinbearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bei guten Bearbeitungsbedingungen

- very wear resistant grade
- for light machining of steel, stainless steel and titanium alloys under favourable machining conditions

µK10

HN



K10

Non revêtu
Unbeschichtet
Uncoated

P ★
M ★
N ★★★
S ★★★

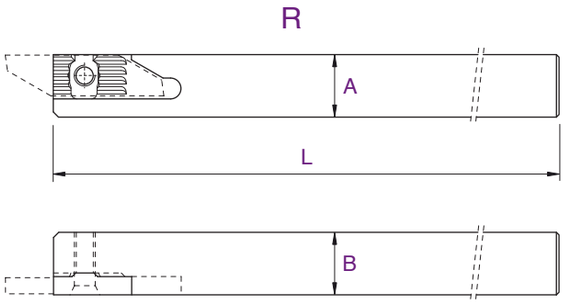
- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du titane faiblement allié
- déconseillé en cas de coupe interrompue et autres conditions d'usinage défavorables

- verschleissfeste Feinkornsorte
- für die Bearbeitung von niedrig legiertem Titan empfehlenswert
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen nicht geeignet

- wear resistant micro-grain grade
- suitable for the machining of low alloyed titanium
- not suitable for interrupted cut and other unfavourable machining conditions

Matière Werkstoff Material		Tournage Drehen Turning		Tronçonnage Abstechen Parting off	
		VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15
Acier Stahl Steel <600 N/mm²	P	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel <800 N/mm²	P	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel >800 N/mm²	P	50 - 100	0.01 - 0.12	40 - 80	0.01 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	M	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.08
Aluminium	N	180 - 800	0.01 - 0.30	150 - 300	0.01 - 0.20
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	N	100 - 500	0.01 - 0.30	100 - 300	0.01 - 0.20
Titane Titan Titanium	S	30 - 70	0.01 - 0.12	30 - 50	0.01 - 0.06

Zurück zum Kapitelanfang





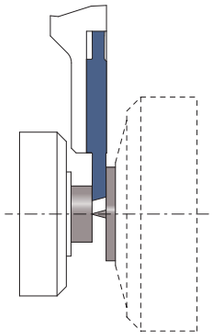
A x B	L	L	R
		Art. N°	Art. N°
8 x 8	115	250-8	260-8
10 x 10	115	250-10	260-10
12 x 12	130	250-12	260-12
12 x 12	90	250-12-90	260-12-90
12.7 x 12.7	130	250-12.7	260-12.7
16 x 16	130	250-16	260-16
16 x 16	75	250-16-75	260-16-75
20 x 20	120	250-20	260-20

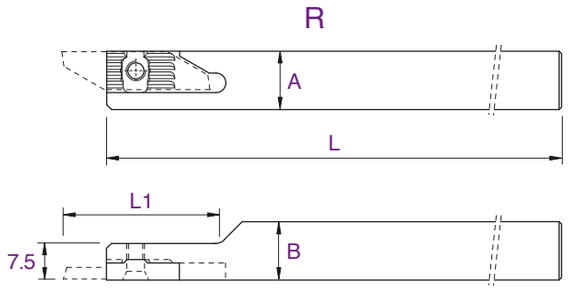
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

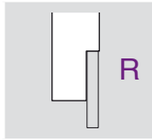
Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

Each holder is supplied with one or more screws.
The keys must be ordered separately.

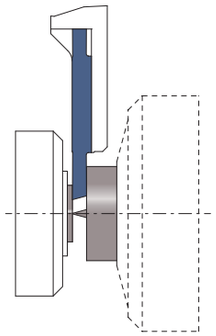
Zurück zum Kapitelanfang

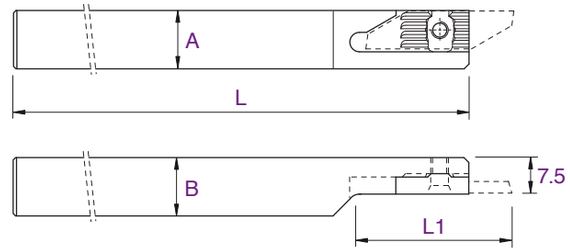






A x B	L	L1	Art. N°
12 x 12	130	30	260-C-12

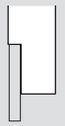




Utiliser des plaquettes type 251R
WSP Typ 251R verwenden
Use inserts type 251R

L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line



A x B	L	L1	Art. N°
12 x 12	130	30	250RC-12
16 x 16	130	40	250RC-16

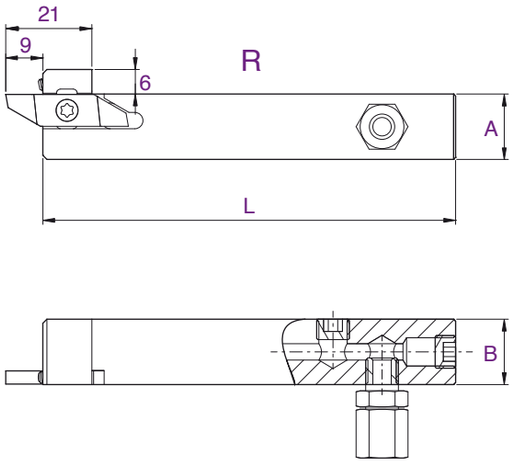
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
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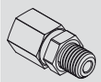
250-JET / 260-JET

Porte-outils avec arrosage intégré
Halter mit integrierter Kühlmittelzufuhr
Holders with integrated coolant supply





A x B	L	L Art. N°	R Art. N°
10 x 12	100	250-1012-JET	260-1012-JET
12 x 12	100	250-12-JET	260-12-JET
16 x 16	100	250-16-JET	260-16-JET
20 x 20	100	250-20-JET	260-20-JET

Pièces de rechange Ersatzteile Spare parts			Buse Düse Nozzle 
	Art. N°	Art. N°	Art. N°
250-JET / 260-JET	J-M8X1-D6	JB-M8X1	JJ-M3X6-D1.5

Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

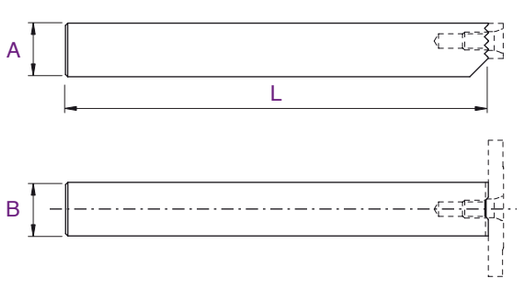
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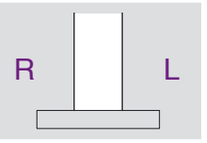
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Zurück zum Kapitelanfang

Porte-outils
Halter
Holders

260/250F

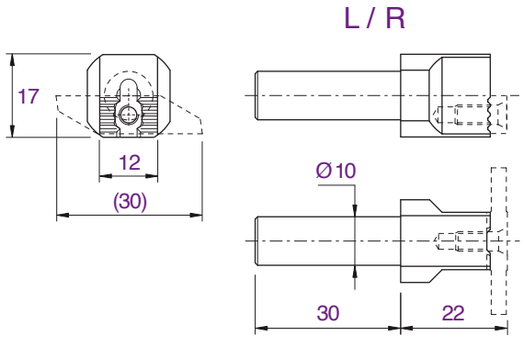


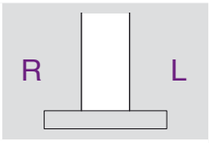


A x B	L	Art. N°
10 x 12	120	260/250F-1012
12 x 12	120	260/250F-1212

Porte-outils
Halter
Holders

260/250-D



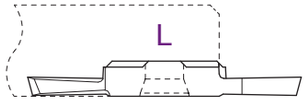


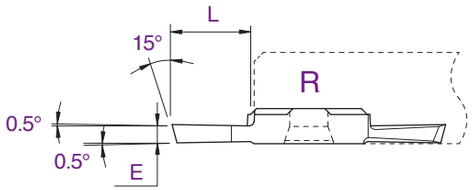
Art. N°
260/250-D10

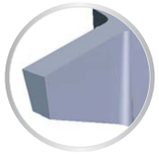
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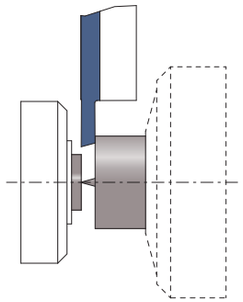
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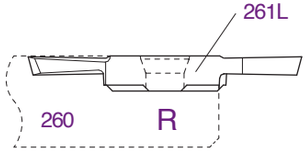


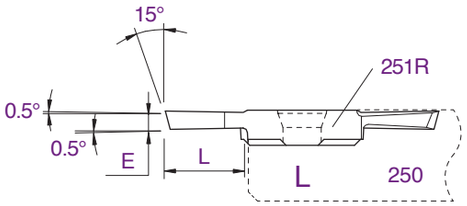




E	L	L Art. N°	AP302	AP202	N (µk20)	R Art. N°	AP302	AP202	N (µk20)
0.8	4	251-0.8	●	●	●	261-0.8	●	●	●
1.0	5	251-1.0	●	●	●	261-1.0	●		●
1.2	5	251-1.2	●	●	●	261-1.2	●	●	●
1.5	7	251-1.5	●		●	261-1.5	●		●
2.0	8.5	251-2.0	●		●	261-2.0	●		●
2.5	8.5	251-2.5	●	●	●	261-2.5	●		●

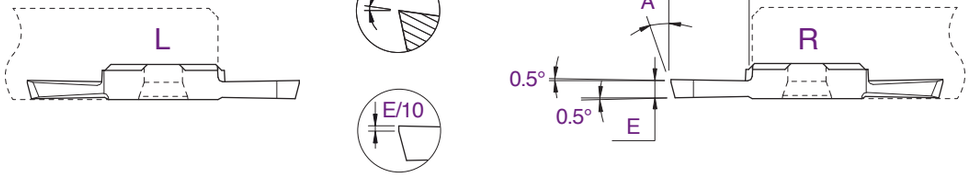






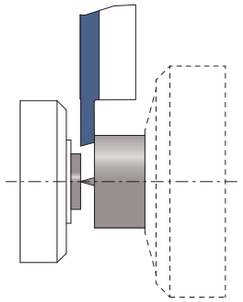


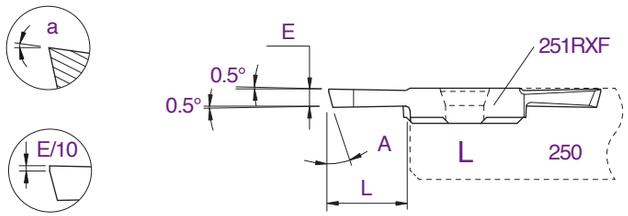
E	L	R (L) Coupe à gauche déportée Versetztes Linksschneiden Left cut off line Art. N°	AP302	AP202	N (µk20)	L (R) Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line Art. N°	AP302	AP202	N (µk20)
1.0	5	-				251R-1.0	●		●
1.5	7	-				251R-1.5	●	●	●
2.0	8.5	261L-2.0	●	●	●	251R-2.0	●		●





a	E	L	A	L Art. N°	L AP302	L AP202	L N (µk20)	R Art. N°	R AP302	R AP202	R N (µk20)
4°	1.0	4	15°	-				261XF-1.0	●		●
6°	1.0	4	8°	-				261XF6°-1.0-8°	●		●
4°	1.5	7	15°	251XF-1.5	●		●	261XF-1.5	●	●	●
4°	2.0	8.5	15°	251XF-2.0	●	●	●	261XF-2.0	●	●	●



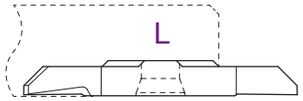


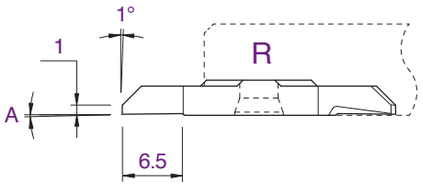


L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

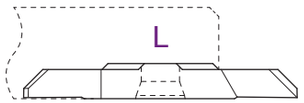
a	E	L	A	Art. N°	AP302	AP202	N (µk20)
6°	1.0	4	8°	251RXF6°-1.0-8°	●		●
4°	1.5	7	15°	251RXF-1.5	●	●	●
4°	2.0	8.5	15°	251RXF-2.0	●		●



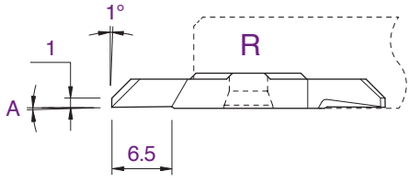




	L				R			
A	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
0°	252	●	●	●	262	●		●
2°	252-2°	●	●	●	262-2°	●	●	●

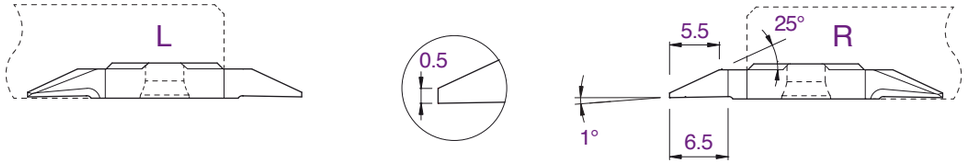






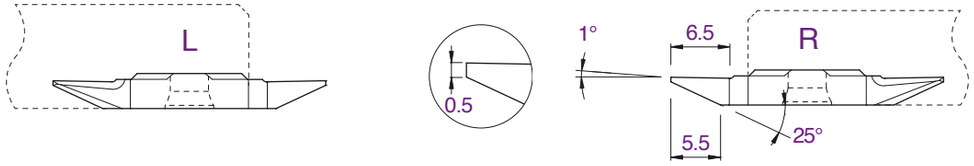


	L				R			
A	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
0°	252X	●	●	●	262X	●		●
2°	252X-2°	●	●	●	262X-2°	●	●	●



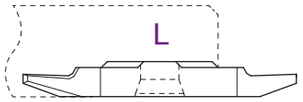


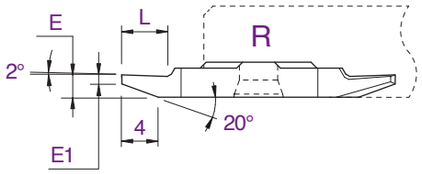
L				R			
Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
252S05	●	●	●	262S05	●	●	●





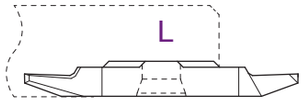
L				R			
Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
253S05	●	●	●	263S05	●	●	●



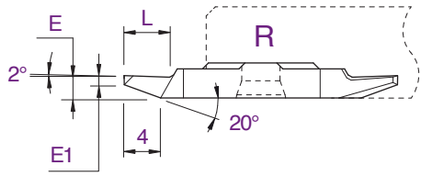




E	E1	L	L Art. N°	L AP302	L AP202	L N (µk20)	R Art. N°	R AP302	R AP202	R N (µk20)
2.0	0.5	4	253-0.5	●	●	●	263-0.5	●		●
2.5	1.0	5	253-1.0	●	●	●	263-1.0	●		●

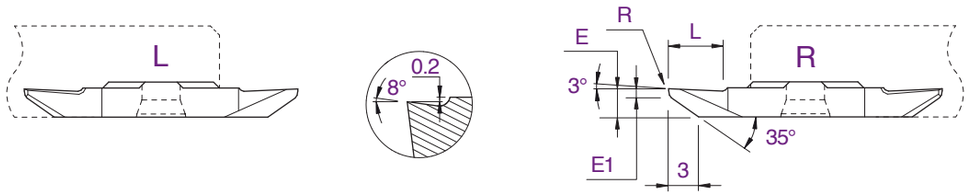






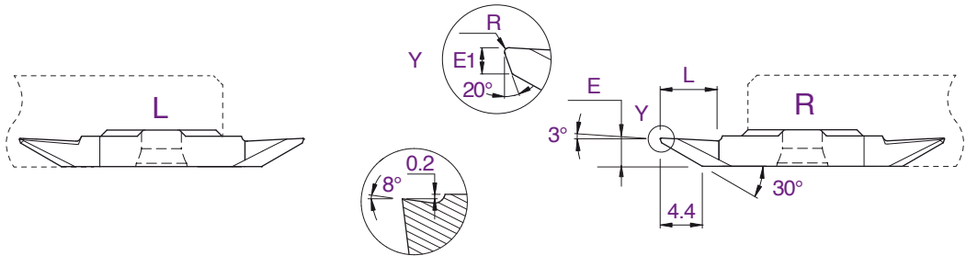


E	E1	L	L Art. N°	L AP302	L AP202	L N (µk20)	R Art. N°	R AP302	R AP202	R N (µk20)
2.0	0.5	5	253X-0.5	●	●	●	263X-0.5	●	●	●
2.5	1.0	5	253X-1.0	●	●	●	263X-1.0	●		●



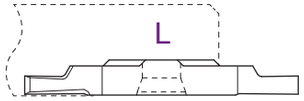


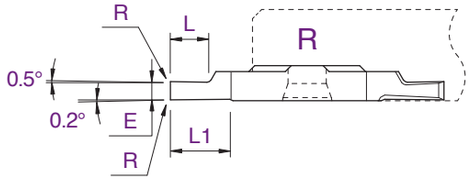
E	E1	L	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)	AH302	HN (µk10)
3.1	1.0	6	0	253VX-8°	●	●	●	263VX-8°	●		●		
3.1	1.0	6	0.08	-				263VX-8°-R08	●	●	●	●	●
3.1	1.0	6	0.20	-				263VX-8°-R20	●		●	●	●





E	E1	L	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)	AH302	HN (µk10)
3.0	0.5	6	0.08	253VX-805-R08	●	●	●	263VX-805-R08	●		●	●	●

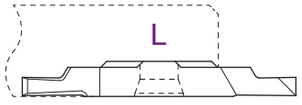


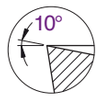


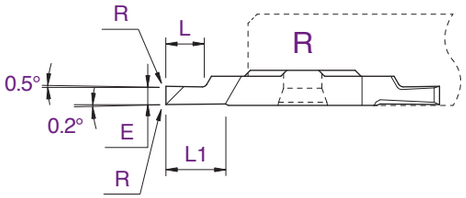


E	L	L1	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
					L				R		
0.8	2	4	0	254-0.8	●		●	264-0.8	●		●
1.0	2.5	4	0	254-1.0	●	●	●	264-1.0	●		●
1.2	3	4	0	254-1.2	●	●	●	264-1.2	●	●	●
1.5	3	4	0	254-1.5	●	●	●	264-1.5	●		●
1.8	4	6.5	0	-				264-1.8	●	●	●
2.0	4	6.5	0	254-2.0	●	●	●	264-2.0	●	●	●
2.5	6	6.5	0	254-2.5	●	●	●	264-2.5	●	●	●
3.0	6.5	6.5	0	254-3.0	●	●	●	264-3.0	●	●	●

Zurück zum Kapitelanfang

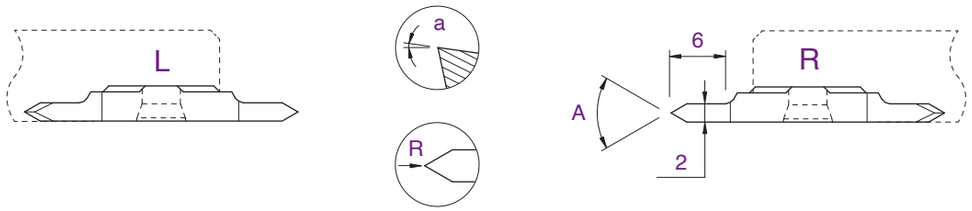








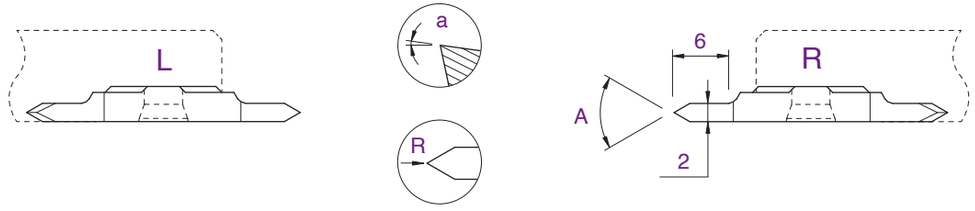
E	L	L1	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)	AH302	HN (µk10)
					L				R				
0.8	2	4	0	254X-0.8	●	●	●	264X-0.8	●	●	●		
1.0	2.5	4	0	254X-1.0	●	●	●	264X-1.0	●	●	●		
1.0	2.5	4	0.08	-				264X-1.0-R08	●	●	●	●	●
1.2	3	4	0	254X-1.2	●	●	●	264X-1.2	●	●	●		
1.5	3	4	0	254X-1.5	●	●	●	264X-1.5	●		●		
1.5	3	4	0.08	-				264X-1.5-R08	●	●	●	●	●
1.5	3	4	0.20	-				264X-1.5-R20	●	●	●	●	●
2.0	4	6.5	0	254X-2.0	●		●	264X-2.0	●	●	●		
2.0	4	6.5	0.08	-				264X-2.0-R08	●	●	●	●	●
2.0	4	6.5	0.20	-				264X-2.0-R20	●		●	●	●
2.5	6	6.5	0	254X-2.5	●	●	●	264X-2.5	●	●	●		
2.5	6.5	6.5	0.08	-				264X-2.5-R08	●	●	●	●	●
2.5	6.5	6.5	0.20	-				264X-2.5-R20	●	●	●	●	●
3.0	6.5	6.5	0	254X-3.0	●	●	●	264X-3.0	●		●		
3.0	6.5	6.5	0.08	-				264X-3.0-R08	●	●	●	●	●
3.0	6.5	6.5	0.20	-				264X-3.0-R20	●	●	●	●	●





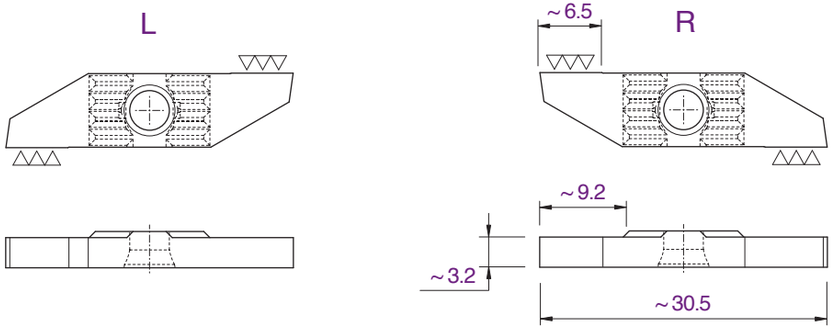
A	R	a	L Art. N°	AP302	AP202	N (µk20)	R Art. N°	AP302	AP202	N (µk20)
60°	0	0°	256-60-2.0	●		●	266-60-2.0	●		●
60°	0.06	3°	256-AG60°	●	●	●	266-AG60°	●		●

Zurück zum Kapitelanfang



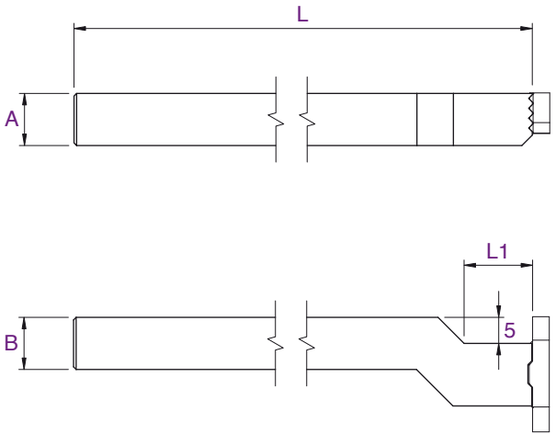


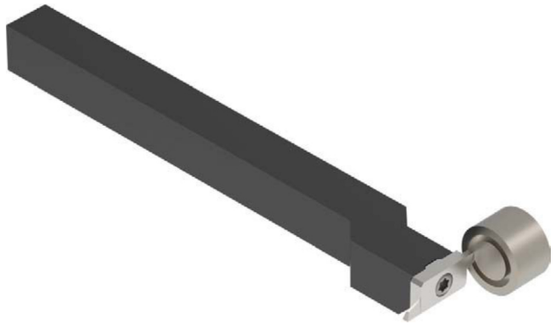
A	R	a	L Art. N°	AP302	AP202	N (µk20)	R Art. N°	AP302	AP202	N (µk20)
55°	0	0°	256-55-2.0	●	●	●	266-55-2.0	●	●	●
55°	0.06	3°	256-AG55°	●	●	●	266-AG55°	●	●	●





L						R					
Art. N°	AP302	AP202	N (µK20)	AH302	HN (µK10)	Art. N°	AP302	AP202	N (µK20)	AH302	HN (µK10)
251-E	●	●	●	●	●	261-E	●		●	●	●



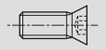


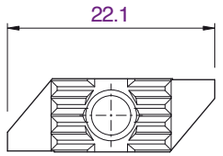
A x B	L	L1	R Art. N°
8x10	130	13	250RFG-0810
10x10	130	13	250RFG-1010
12x12	130	13	250RFG-1212
16x16	130	16	250RFG-1616

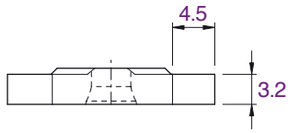
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schraubengeliefert.
Die Schlüssel sind separat zu bestellen.

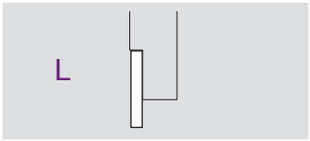
Each holder is supplied with one or more screws.
The keys must be ordered separately.

Pièces de rechange Ersatzteile Spare parts	Options
	
Art. N°	Art. N°
V-M4X9-T15	C-T15



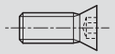
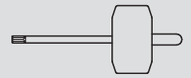






Art. N°	AP302	N (µK20)
251RFG-EP	●	●

Plaquette ébauche pour porte-outils axial RFG(p. 6.29)
WSP-Rohling für axialen Halter RFG(S. 6.29)
Blank insert for axial holder RFG(p. 6.29)

Porte-outils Halter Holders		Options 	 Option Art. N°	Recommandation de serrage Drehmoment Empfehlung Clamping recommendation
250-8 / 260-8	V-M3.5X7.3-T15	C-T15	SET-NM3.0-TX15	3 Nm
250-…/ 260-…	V-M4X9-T15			
260/250-…				
250RFG				
250RC/ 260-C	V-M4X7.3-T15			