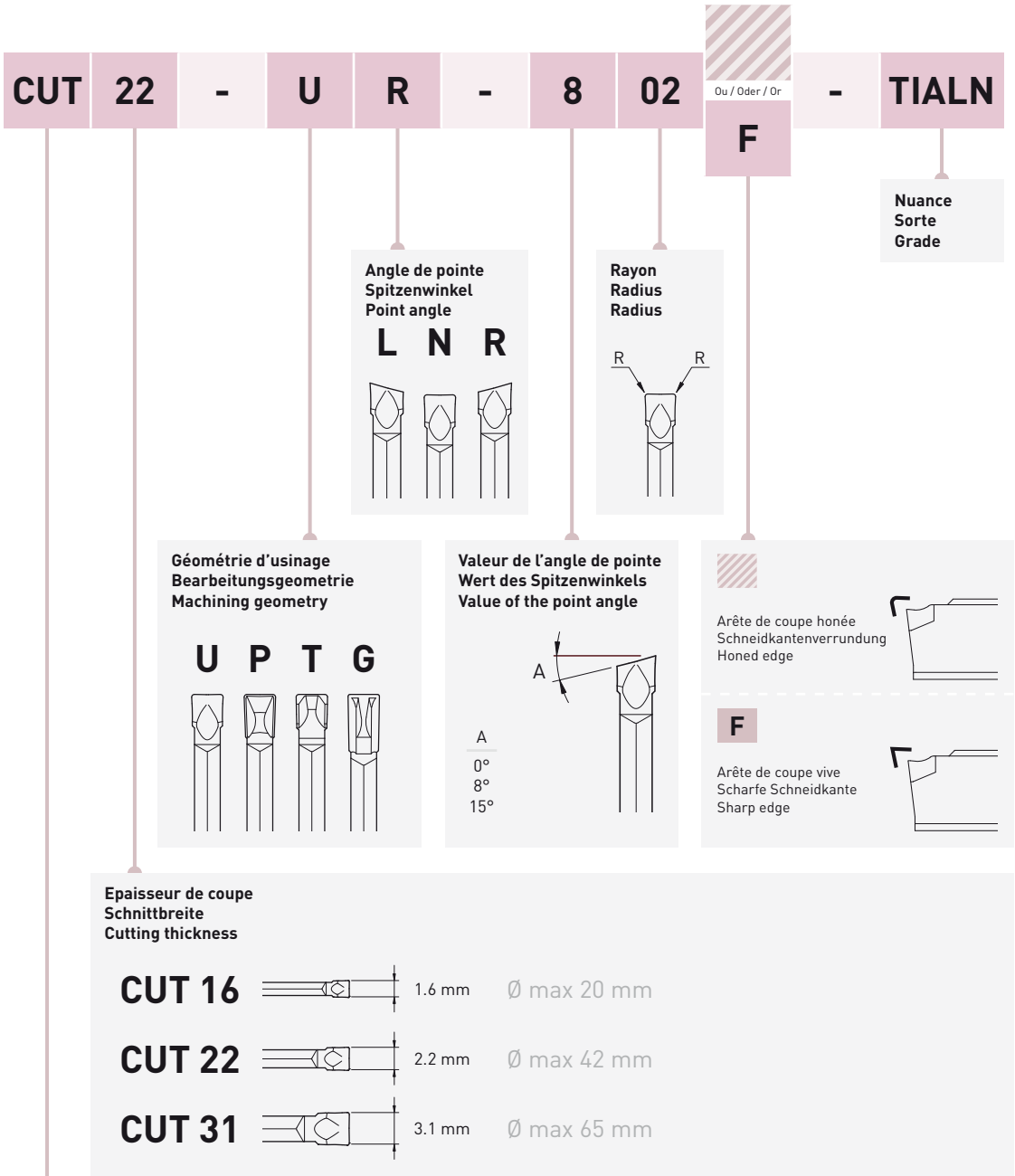


CUT-Line



APPLITEC
CUTTING TOOLS

Codification Kodifizierung Coding guide		> 11.03
Infos et avantages, géométries de coupe Infos und Vorteile, Spanformgeometrie Infos and advantages, cutting geometries		> 11.04
Nuances Sorten Grades		> 11.06
	CUT 16 Ø max 20 mm	> 11.08
Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data	CUT 22 Ø max 42 mm	> 11.10
	CUT 31 Ø max 65 mm	> 11.12
	H	> 11.14
Porte-outils Halter Holders	HX	> 11.15
	HZ	> 11.16
Porte-outils avec arrosage intégré Halter mit integrierter Kühlmittelzufuhr Holders with integrated coolant supply	HZ-JET	> 11.17
	U	> 11.18
Plaquettes de tronçonnage Abstechwendeplatten Cut off inserts	P	> 11.20
	T	> 11.24
Plaquettes de fonçage, tournage et tronçonnage WSP zum einstecken, drehen und abstechen Inserts for grooving, turning and cut off	G	> 11.25



Applitec CUT-Line
Applitec CUT-Line
Applitec CUT-Line

Système performant dédié pour le tronçonnage
Leistungstarkes System für das Abstechen
High-performance system for cutting

CUT-Line

Infos et avantages

Infos und Vorteile

Infos and advantages

Porte-outils / Halter / Holders

H

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

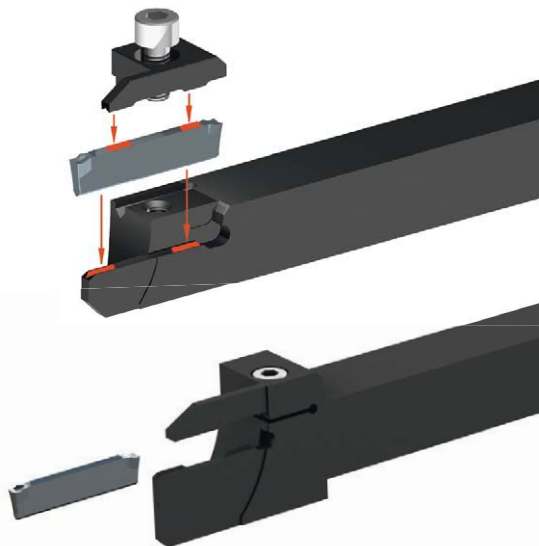
HX

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

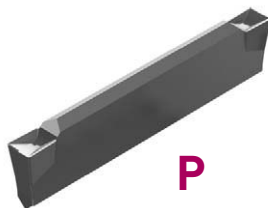
Very rigid clamping system



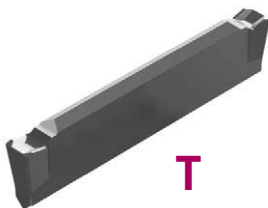
Plaquettes / WSP / Inserts



U



P



T

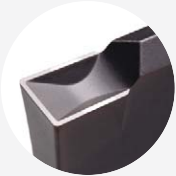


G

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	 • géométrie positive universelle, bonne maîtrise du copeau • Universalgeometrie positive gute Beherrschung der Späne • all-round insert with efficient chip control	
UR UL		
PN	 • 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	
PR		
PNW PRW	 • géométrie neutre pour les laitons • neutrale Geometrie für Messing • 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 einstecken-langdrehen, kann auch zum abstechen verwendet werden • all-round insert for grooving and turning, can also be used for parting off	

Nuances

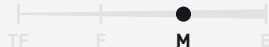
Sorten

Grades

TiAlN



Revêtement PVD
PVD Beschichtung
PVD coating



- pour l'usinage des aciers, aciers inoxydables et alliages de titane
- 1^{er} choix pour les avances faibles à modérées

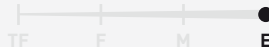
- für die Bearbeitung von Stahl, rostfreien Stahl und Titanlegierungen
- erste Wahl für niedrige bis mittlere Vorschübe

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

Tmax



Revêtement PVD
PVD Beschichtung
PVD coating



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

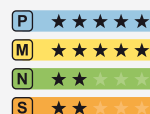
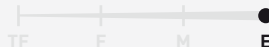
- Sorte für mittlere bis hohe Belastung in Stahl und legierter Stahlbearbeitung
- gute Bearbeitungswarmfestigkeit
- erste Wahl für die Bearbeitung von legiertem Kohlenstahl und hoch legiertem Stahl

- 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



- 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
- 1^{er} choix pour le tronçonnage en 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

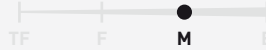
- for machining of steel, stainless steel and titanium alloys in unfavourable machining conditions
- good impact resistance with average to low cutting speed
- first choice for machining in interrupted cut

HTA



Revêtement PVD

PVD Beschichtung
PVD coating



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

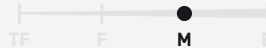
- very good wear resistance
- for steel, stainless steel and titanium alloys machining
- not suitable for interrupted cut

HAC



Revêtement PVD

PVD Beschichtung
PVD coating



P	★★★★★
M	★★★★★
N	★★★★★
S	★★★★★

- nuance pour métaux non ferreux
- très faible coefficient de frottement
- 1^{er} 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

CUT-Line

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

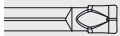
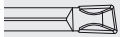
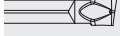
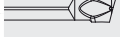
Standard machining data

★★★★★

★★★★

★★★

CUT 16

			P Acier Stahl Steel						M Inox Rostfreistahl Stainless steel	
			Acier de décolletage Automatenstahl Free-cutting steel		Acier faiblement allié Leicht legierter Stahl Low alloyed steel		Acier fortement allié Legierter Stahl High alloyed steel		Austénitique et martensitique Austenitisch und martensitisch Austenitic and martensitic	
			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
		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
		HAC								
	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
		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								
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
		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
		HAC								
	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
		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
		HAC								
	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
		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
		HAC								

* premier choix en cas
de coupe interrompue

** arête de coupe vive

* erste Wahl für
unterbrochener Schnitt

** scharfe Schneidkante

* first choice
for interrupted cut

** sharp cutting edge

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

[N] Alliages d'aluminium et non ferreux Aluminium- und Nichteisenlegierungen Aluminium and non-ferrous alloys								[S] Titane Titan Titanium			
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)
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
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
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
						150-300	0.03-0.10				
						100-500	0.02-0.10				
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
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
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
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
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
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
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
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
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

CUT-Line

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

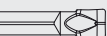
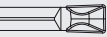
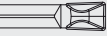
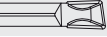
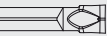
Standard machining data

★★★★★

★★★★

★★★

CUT 22

			P Acier Stahl Steel						M Inox Rostfreistahl Stainless steel	
			Acier de décolletage Automatenstahl Free-cutting steel		Acier faiblement allié Leicht legierter Stahl Low alloyed steel		Acier fortement allié Legierter Stahl High alloyed steel		Austénitique et martensitique Austenitisch und martensitisch Austenitic and martensitic	
			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
		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
		HAC								
	CUT22-PN-002 	TiAlN	90-140	0.04-0.10	60-120	0.04-0.08	50-100	0.04-0.08		
		Tmax	100-170	0.04-0.10	70-150	0.04-0.10	60-120	0.04-0.10		
	CUT22-PNW-002 	N								
	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
		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								
	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
		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
		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
		HAC								
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
		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
		HAC								
	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
		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
		HAC								
	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
		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
		HAC								
	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
		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
		HAC								

* premier choix en cas de coupe interrompue

** arête de coupe vive

*** Pour opérations de fonçage-tournage (évent. tronçonnage)

* erste Wahl für unterbrochener Schnitt

** scharfe Schneidkante

*** Für Stech- und Drehoperationen (event. abstechen)

* first choice for interrupted cut

** sharp cutting edge

*** For grooving and turning operations (event. parting off)

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

[N] Alliages d'aluminium et non ferreux Aluminium- und Nichteisenlegierungen Aluminium and non-ferrous alloys								[S] Titane Titan Titanium			
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)
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
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
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
						150-300	0.03-0.10				
						100-500	0.02-0.10				
						150-300	0.03-0.10				
						100-500	0.02-0.10				
						150-300	0.05-0.20				
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
						100-300	0.03-0.12				
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
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
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
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
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
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
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
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
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
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
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
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
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

CUT-Line

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

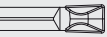
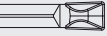
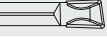
Standard machining data

★★★★★

★★★★

★★★

CUT 31

			P Acier Stahl Steel						M Inox Rostfreistahl Stainless steel	
			Acier de décolletage Automatenstahl Free-cutting steel		Acier faiblement allié Leicht legierter Stahl Low alloyed steel		Acier fortement allié Legierter Stahl High alloyed steel		Austénitique et martensitique Austenitisch und martensitisch Austenitic and martensitic	
			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
		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
		HAC								
	CUT31-PN-002 	TiAlN	90-140	0.04-0.10	60-120	0.04-0.08	50-100	0.04-0.08		
		Tmax	100-170	0.04-0.10	70-150	0.04-0.10	60-120	0.04-0.10		
	CUT31-PNW-002 	N								
	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
		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								
	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
		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
		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
		HAC								
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
		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
		HAC								
	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
		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
		HAC								
	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
		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
		HAC								
	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
		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
		HAC								

* premier choix en cas de coupe interrompue

** arête de coupe vive

*** Pour opérations de fonçage-tournage (évent. tronçonnage)

* erste Wahl für unterbrochener Schnitt

** scharfe Schneidkante

*** Für Stech- und Drehoperationen (event. abstechen)

* first choice

for interrupted cut

** sharp cutting edge

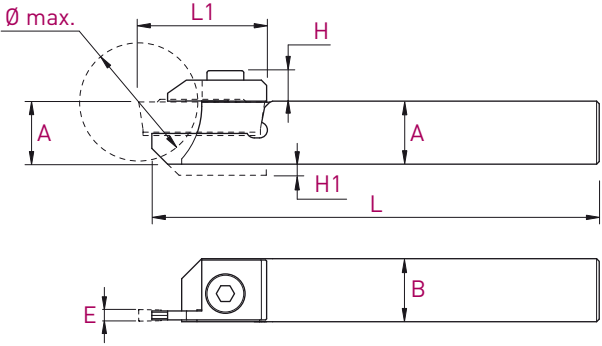
*** For grooving and turning operations (event. parting off)

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

[N] Alliages d'aluminium et non ferreux Aluminium- und Nichteisenlegierungen Aluminium and non-ferrous alloys								[S] Titane Titan Titanium			
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)
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
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
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
						150-300	0.03-0.10				
						100-500	0.02-0.15				
						150-300	0.03-0.10				
						100-500	0.02-0.15				
						150-300	0.05-0.20				
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
						100-300	0.04-0.15				
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
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
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
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
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
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
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
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
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
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
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
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
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



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L R	
							Art. N°	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
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

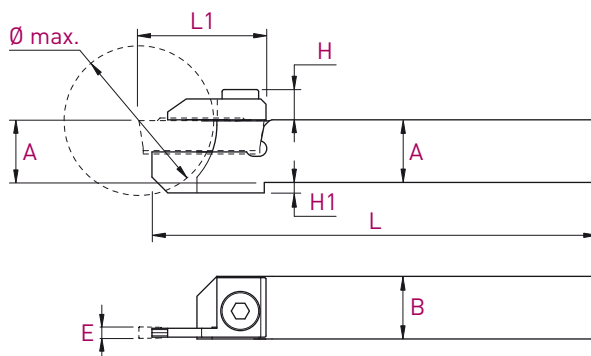
Pièces de rechange Ersatzteile Spare parts	L R		Serrage Anzug Torque
	Art. N°	Art. N°	
CUT 16	CUT16L-SET	CUT16R-SET	V-M4X10-BN7 3.5 Nm
CUT 22	CUT22L-SET	CUT22R-SET	V-M4X10-BN7 3.5 Nm
CUT 31	CUT31L-SET	CUT31R-SET	V-M5X10-BN7 4.5 Nm

Porte-outils

Halter
Holders

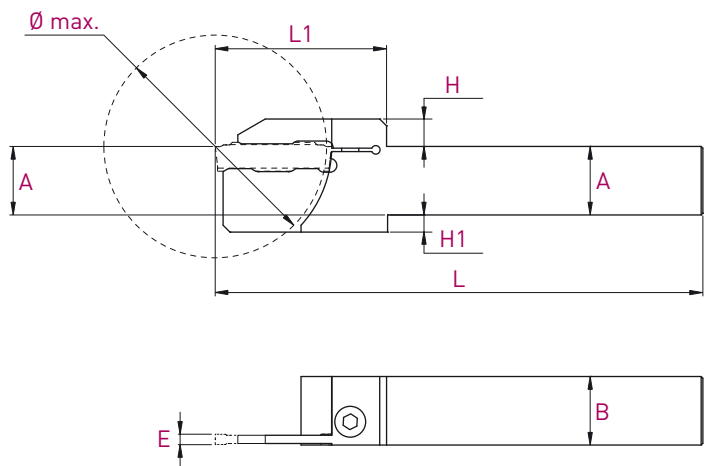
Ø max 42 mm

HX



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	H1	L R	
							Art. N°	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 R			Serrage Anzug Torque
	Art. N°	Art. N°	Art. N°	
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	Art. N°	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

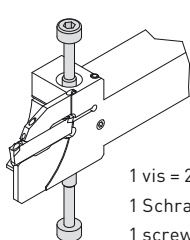
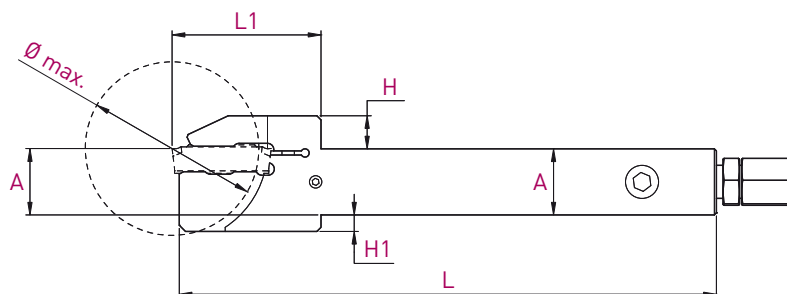
Pièces de rechange Ersatzteile Spare parts		Serrage Anzug Torque
	Art. N°	
CUT 22	V-M4X10-BN7	3.5 Nm
CUT 31	V-M5X10-BN7	4.5 Nm

Porte-outils avec arrosage intégré

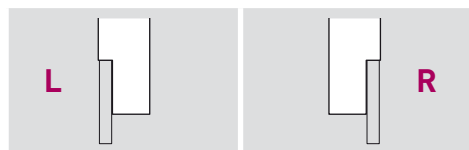
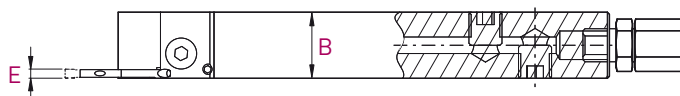
Halter mit integrierter Kühlmittelzufuhr
 Holders with integrated coolant supply

Ø max 65 mm

HZ-JET

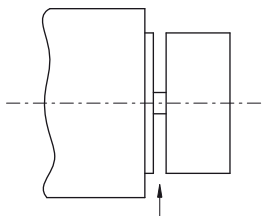
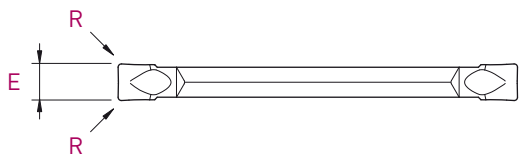
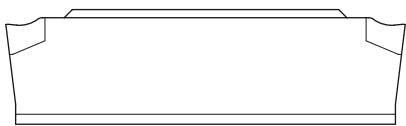


1 vis = 2 possibilités de serrage
 1 Schraube = 2 Spannmöglichkeiten
 1 screw = 2 clamp possibilities



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



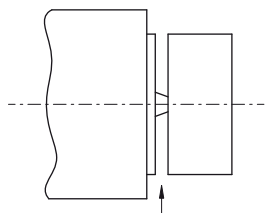
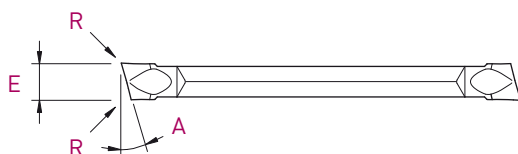
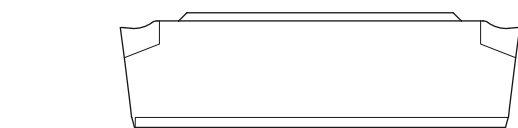
Type	E ± 0.1	R	Art. N°	P M N S	P M M M	P M M M	P M N S	P M N S	P M N S
				TiAlN	Tmax	Zmax	HTA	HAC	
CUT16	1.6	0.02	CUT16-UN-000F	•			•	•	
	1.6	0.10	CUT16-UN-001	•	•	•	•	•	
CUT22	2.2	0.02	CUT22-UN-000F	•			•	•	
	2.2	0.20	CUT22-UN-002	•	•	•	•	•	
CUT31	3.1	0.02	CUT31-UN-000F	•			•	•	
	3.1	0.20	CUT31-UN-002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

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

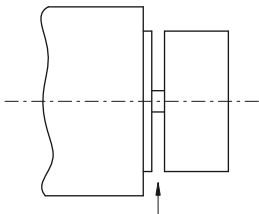
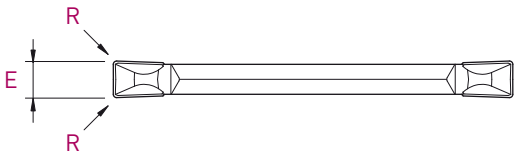
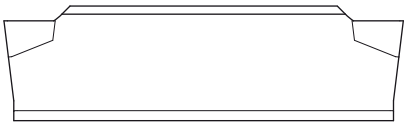
UL-UR



UL

UR

Type	E ± 0.1	A	R	Art. N°	P	P		Art. N°	P	P	P	P	
					M	M			M	M	M	M	
					N	N	N		N	N	N	N	N
					S	S	S		S			S	S
					TiAlN	HTA	HAC		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	•			•	•



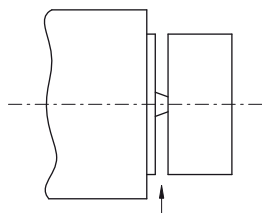
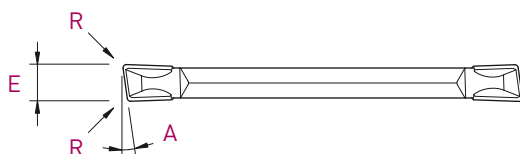
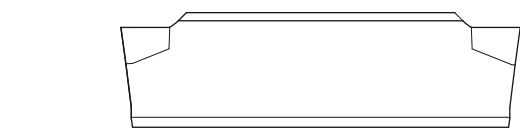
Type	E ± 0.1	R	Art. N°	P M N S TiAlN	P M Tmax
CUT22	2.2	0.20	CUT22-PN-002	●	●
CUT31	3.1	0.20	CUT31-PN-002	●	●

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

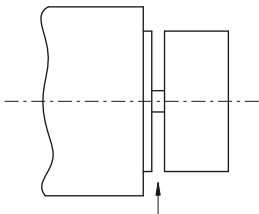
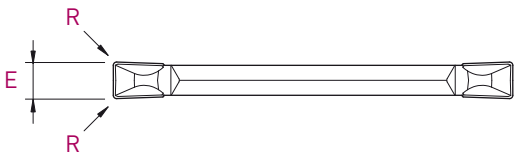
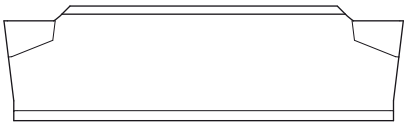
PR



PR



Type	E ± 0.1	A	R	Art. N°	TiAlN	P	M	N	S	P	M	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	•	•						



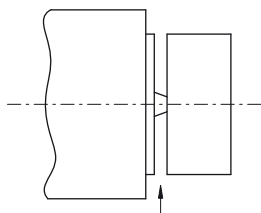
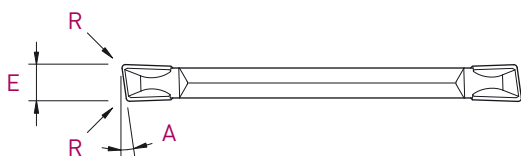
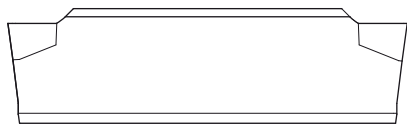
Type	E ± 0.1	R	Art. N°	☐ ☒ N ☒ S z
CUT22	2.2	0.20	CUT22-PNW-002	•
CUT31	3.1	0.20	CUT31-PNW-002	•

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

PRW



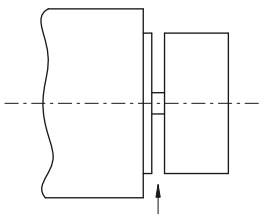
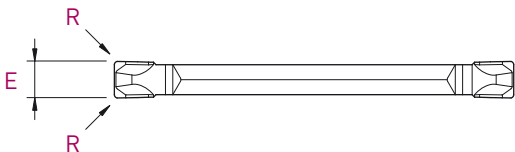
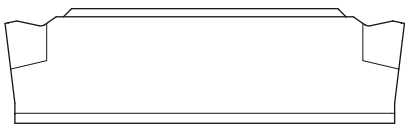
PRW



Type	E ± 0.1	A	R	Art. N°	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	●



z



TN

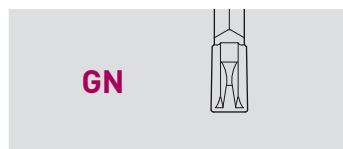
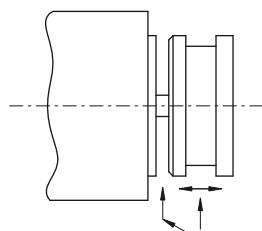
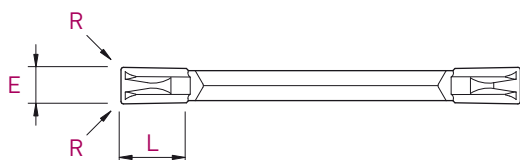
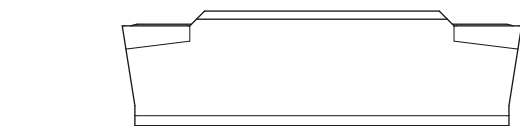


Type	E ± 0.1	R	Art. N°	T:AlN	Tmax	Zmax
CUT22	2.2	0.20	CUT22-TN-002	●	●	●
CUT31	3.1	0.20	CUT31-TN-002	●	●	●

Plaquettes de fonçage, tournage et tronçonnage

WSP zum einstecken, drehen und abstechen

Solid carbide inserts for grooving, turning and cut off

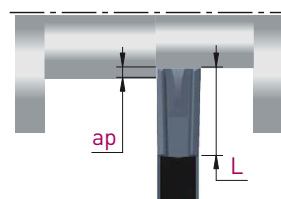
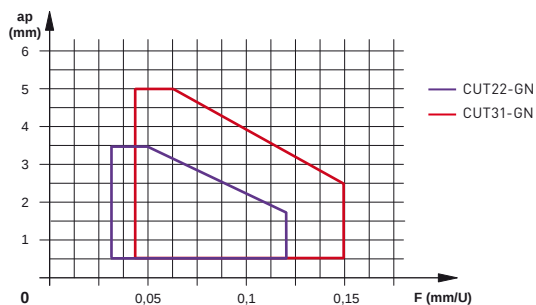


Type	E ± 0.1	L	R	Art. N°	P	M	N	S	TiAlN	Tmax	HAC
CUT22	2.2	3.5	0.15	CUT22-GN-002	●	●	●	●	●	●	●
CUT31	3.1	5.0	0.15	CUT31-GN-002	●	●	●	●	●	●	●

Conseils d'utilisation pour plaquettes type GN

Anwendungsempfehlungen für GN-Wendelplatten

Application recommendations for GN inserts



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

SYMBOL

Légende des symboles

Symbollegende

Symbol Legend

E	L	Art. N°	TiAlN	TiN	N (µK20)	HTA	HTiN	HN (µK10)
1.0	5	731RU-1.0	•	•				
1.2	5	731RU-1.2	•	•				
1.5	7	731RU-1.5	•	•	•	•	•	•
2.0	7	731RU-2.0	•	•				

• Article standart
Standardartikel
Standard item

P

Acier
Stahl
Steel

M

Inox
Rostfreistahl
Stainless steel

N

Alliages d'aluminium et non ferreux
Aluminium- und Nichtisenlegierungen
Aluminium and non-ferrous alloys

S

Titane et superalliages
Titan und Superlegierungen
Titanium and superalloys

H

Acier trempé
Gehärteter Stahl
Hardened steel

K

Fonte
Gusseisen
Cast iron

O

Matière exotique
Exotisches material
Exotic material



Carbure
Hartmetall
Carbide



TiAlN

K20

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

P	★★★★★
M	★★★★★
N	★★★★★
S	★★★★★

TF F M E

Épaisseur du revêtement
Dicken der Beschichtung
Thickness of the coating

TF

Très fin
Sehr dünn
Very thin

F

Fin
Dünn
Thin

M

Moyen
Mittel
Medium

E

Épais
Dick
Thick