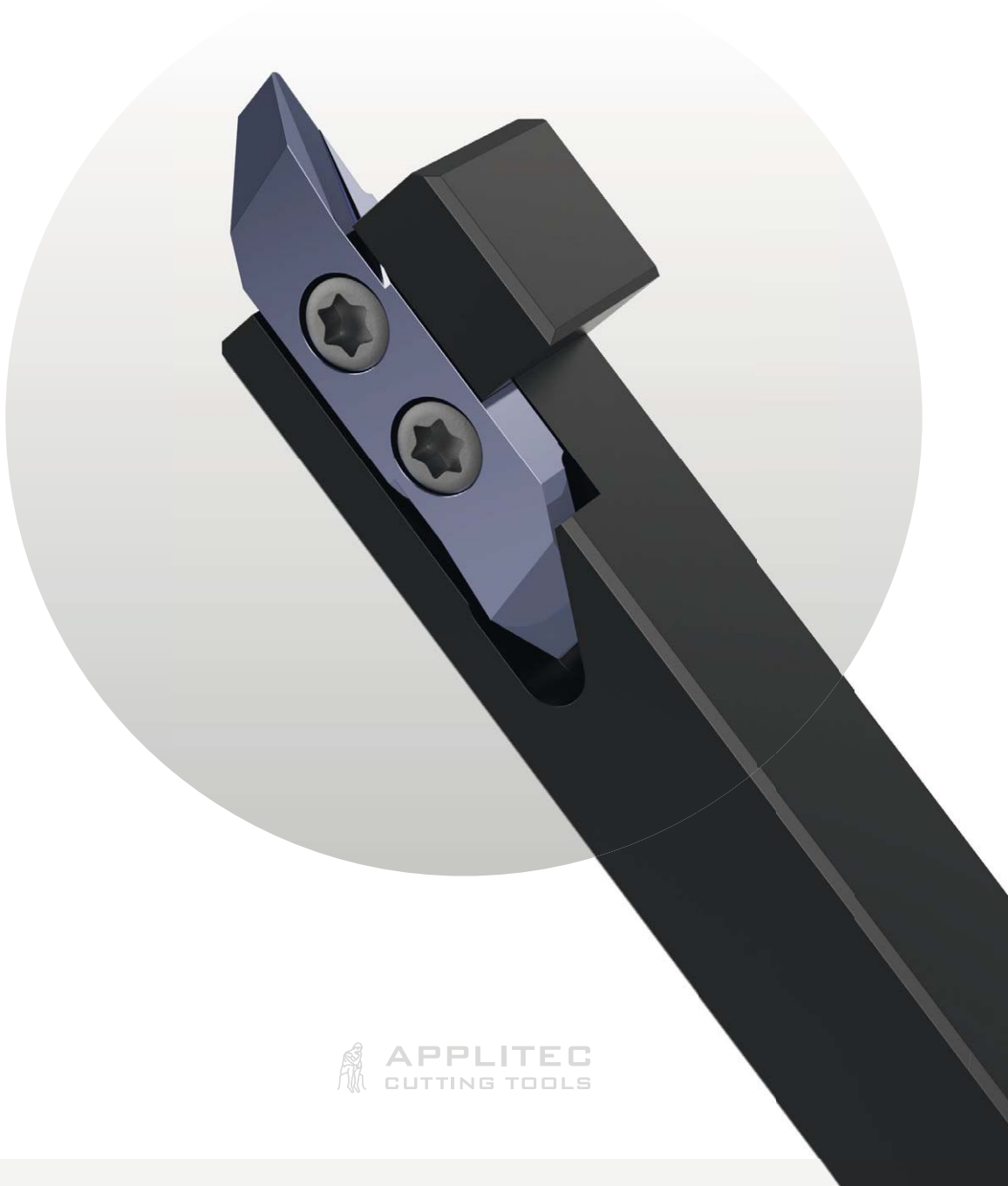


PRO-Line



APPLITEC
CUTTING TOOLS

Codification Kodifizierung Coding guide			> 5.06
Infos et avantages Infos und Vorteile Infos and advantages			> 5.08
Nuances Sorten Grades			> 5.09
Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data			> 5.11
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	Tournage avant Vorwärts drehen Front turning		632 / 642  > 5.14
	Tournage arrière Rückwärts drehen Back turning		633 / 643  > 5.17
	Fonçage-tournage Einstecken und drehen Grooving and turning		634 / 644  > 5.25
	Chanfreinage Anfasen Chamfering		635 / 645  > 5.30
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	Plaquettes ébauches WSP-Rohlinge Blank inserts		631-EP / 641-EP  > 5.36

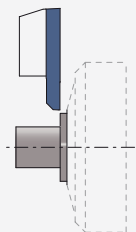
SERIES 650 / 660 Tronçonnage Abstechen Parting off	Porte-outils Halter Holders		650 / 660	> 5.37
	Tronçonnage Abstechen Parting off		651 / 661	 > 5.40
	Tronçonnage - coupe déportée Abstechen - versetztes Schneiden Parting off - cut off line		651R	 > 5.45
	Plaquettes ébauches WSP-Rohlinge Blank inserts		651-EP / 661-EP	 > 5.50
	Pièces de rechange et accessoires Ersatzteile und Zubehör Spare parts and accessories			> 5.51

Codification des usinages

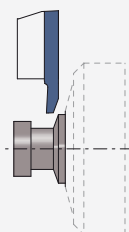
Bearbeitung Kodifizierung

Machining coding guide

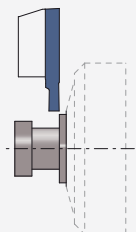
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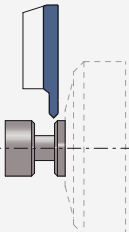
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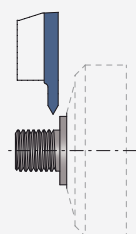
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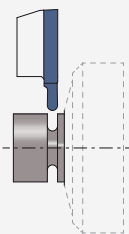
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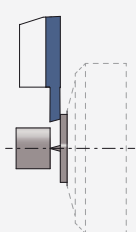
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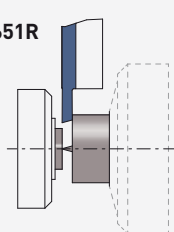
647



661



651R



6	4	4	X	-	2.0	-	R15	-	TiAlN
---	---	---	---	---	-----	---	-----	---	-------

Dimension
Abmessung
Dimension

Rayon
Radius
Radius

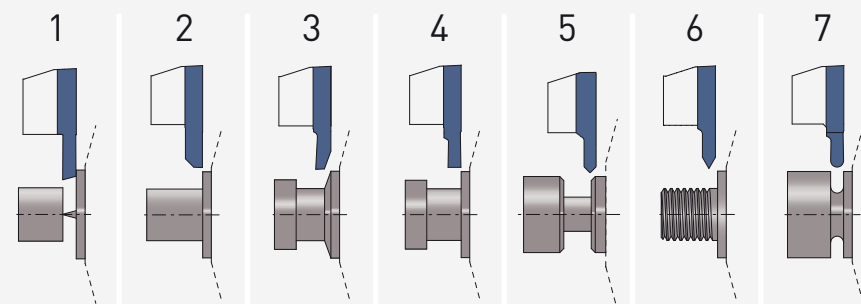
Nuance
Sorte
Grade

Géométrie de coupe
Schneidgeometrie
Cutting geometry

brise-copeaux
Spanbrecher
chip breaker

particularités
Sondereigenschaften
special features

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry



Gamme de produit
Produktsérie
Product series

définit la compatibilité des plaquettes avec le porte-outil
bestimmt die WSP und Halter Kompatibilität
shows the inserts and holder compatibility

L = 3, 5

(chiffre impair / ungerade Zahl / uneven number)

R = 4, 6

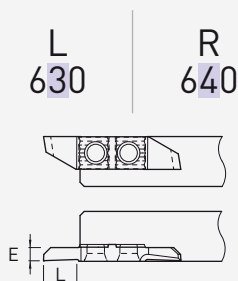
(chiffre pair / gerade Zahl / even number)

SERIES

Tournage
et gorge

Drehen
und
Einstechen
Turning
and
grooving

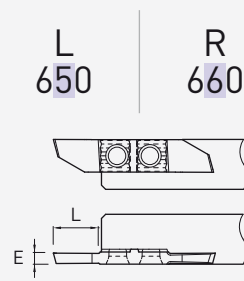
E max = 3 mm
L max = 8 mm



SERIES

Tronçonnage
Abstechen
Parting off

E max = 2.5 mm
L max = 11 mm



Applitec série 600
Applitec 600 Serie
Applitec 600 series

Système de serrage à denture avec 2 vis de fixation
Spannsystem mit Verzahnung und 2 Schrauben
Teeth clamping system with 2 screws

PRO-Line

Infos et avantages

Infos und Vorteile

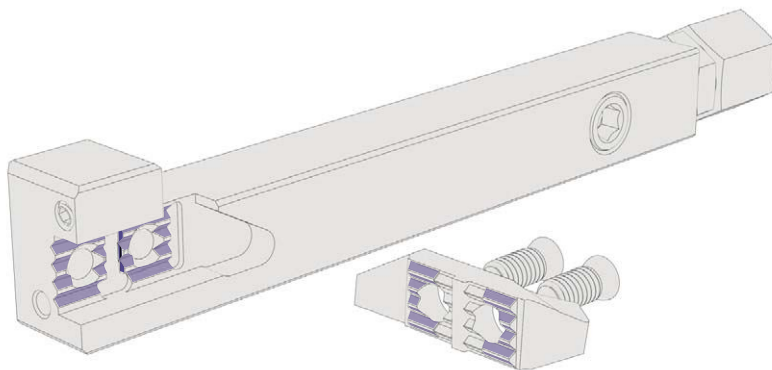
Infos and advantages

Rigid!

Système de serrage à denture Applitec avec repositionnement sur la nervure centrale.

Applitec-Verzahnungsspannsystem mit Neupositionierung auf der Zentralrippe.

Applitec toothed clamping system with repositioning on the central rib.

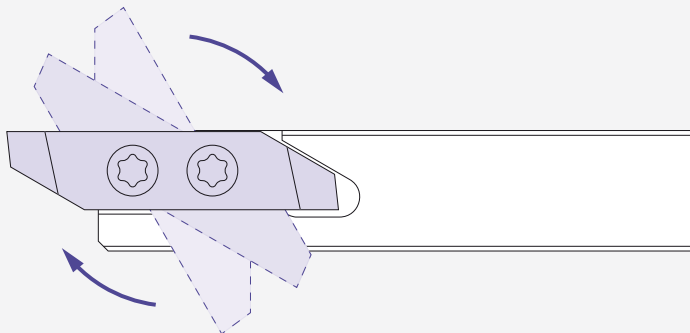


Ultra precision

Grande précision lors du retournement de la plaquette

Hohe Präzision beim Wenden der Platte

High precision when flipping the insert

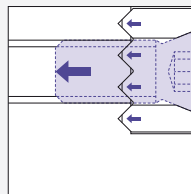


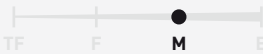
Applitec toothting

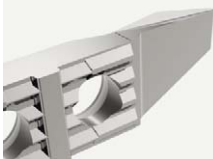
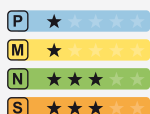
Système de serrage en fond de denture

Klemmvorrichtung an der Prothesenbasis

Clamping system at the denture base



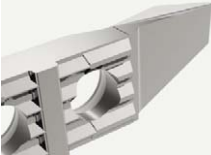
μK20	 TiAlN	 K20 μK20 + revêtement PVD μK20 + PVD Beschichtung μK20 + PVD coating 	
	• excellente nuance universelle • 1^{er} choix pour l'usinage des aciers, aciers inoxydables et alliages de titane • très bonne résistance à la température	• beste Universalsorte • für die Bearbeitung von Stahl, rostfreiem 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	 N	 K20 Non revêtu Unbeschichtet Uncoated	
	• 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

Nuances

Sorten

Grades

μK10	HTA 	● K10 μK10 + revêtement PVD μK10 + PVD Beschichtung μK10 + 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 titane	• 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
	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

Paramètres de coupe indicatifs

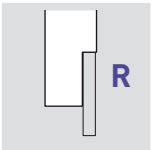
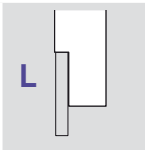
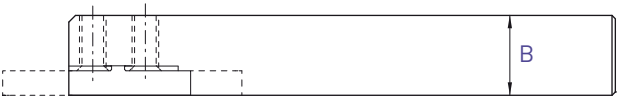
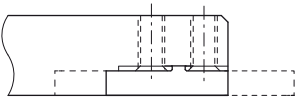
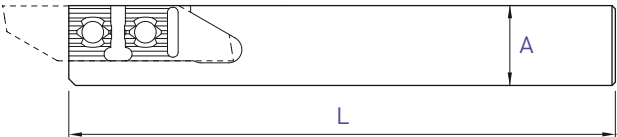
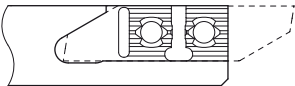
Empfohlene Schnittwerte

Standard machining data

Matière Werkstoff Material		Tournage Drehen Turning 630/640			Tronçonnage Abstechen Parting off 650/660		
		VC	Prof. de passe Schnitttiefe Depth of cut	Avance Vorschub Feed	VC	Largeur de coupe Abstechbreite Cutting width	Avance Vorschub Feed
		(m/min)	(mm)	(mm/U)	(m/min)	(mm)	(mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	120 - 200	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25	80 - 150	0.50 - 1.50 1.50 - 2.50	0.01 - 0.08 0.03 - 0.15
Acier Stahl Steel < 600 N/mm ²	P	80 - 160	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25	70 - 120	0.50 - 1.50 1.50 - 2.50	0.01 - 0.06 0.03 - 0.12
Acier Stahl Steel < 800 N/mm ²	P	60 - 120	0.05 - 1.0 1.0 - 4.0	0.01 - 0.10 0.05 - 0.20	60 - 100	0.50 - 1.50 1.50 - 2.50	0.01 - 0.05 0.03 - 0.10
Acier Stahl Steel > 800 N/mm ²	P	50 - 100	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15	40 - 80	0.50 - 1.50 1.50 - 2.50	0.01 - 0.04 0.03 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	M	60 - 120	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15	60 - 100	0.50 - 1.50 1.50 - 2.50	0.01 - 0.04 0.03 - 0.08
Aluminium Si <12%	N	200 - 1000	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40	180 - 400	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Aluminium Si >12%	N	180 - 800	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40	150 - 300	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	N	100 - 500	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.35	100 - 300	0.50 - 1.50 1.50 - 2.50	0.01 - 0.10 0.03 - 0.20
Titane Titan Titanium	S	30 - 70	0.05 - 1.0 1.0 - 4.0	0.01 - 0.08 0.05 - 0.15	30 - 50	0.50 - 1.50 1.50 - 2.50	0.01 - 0.03 0.03 - 0.06

L

R

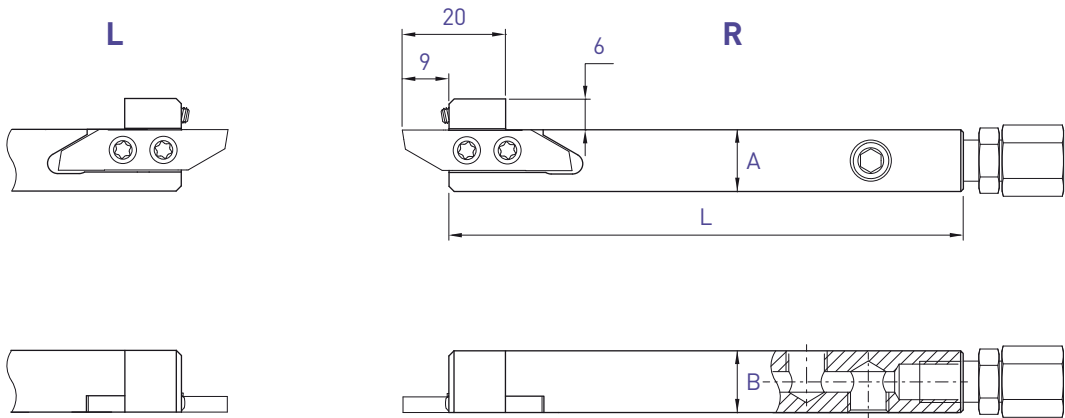


A x B	L	Art. N°	Art. N°
8 x 8	115	630-8	640-8
10 x 10	115	630-10	640-10
10 x 10	50	630-10-50	640-10-50
12 x 12	130	630-12	640-12
12 x 12	90	630-12-90	640-12-90
12.7 x 12.7	130	630-12.7	640-12.7
16 x 16	130	630-16	640-16
16 x 16	75	630-16-75	640-16-75
20 x 20	120	630-20	640-20

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.

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

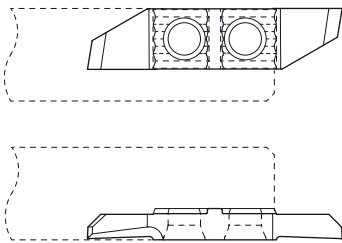
630-JET / 640-JET



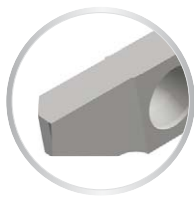
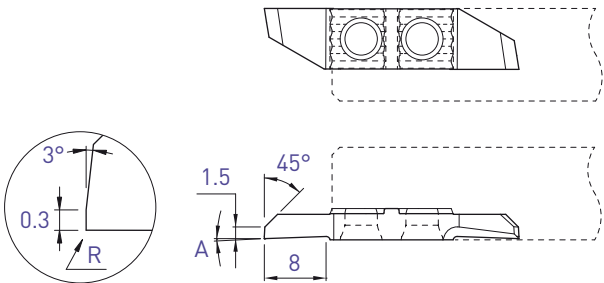
		L R	
A x B	L	Art. N°	Art. N°
10 x 12	100	630-1012-JET	640-1012-JET
12 x 12	100	630-12-JET	640-12-JET
12.7 x 12.7	100	630-12.7-JET	640-12.7-JET
16 x 16	100	630-16-JET	640-16-JET
20 x 20	100	630-20-JET	640-20-JET

Chaque support est livré avec vis, raccord droit et buse d'arrosage Ø 1.5 mm. Les clés sont à commander séparément.
Jeder Halter wird mit Spannschraube(n), gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert. Die Schlüssel sind separat zu bestellen.
Screw(s), straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder. The keys must be ordered separately.

L



R



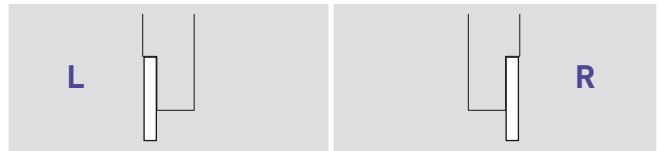
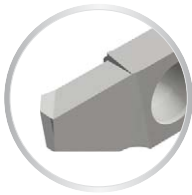
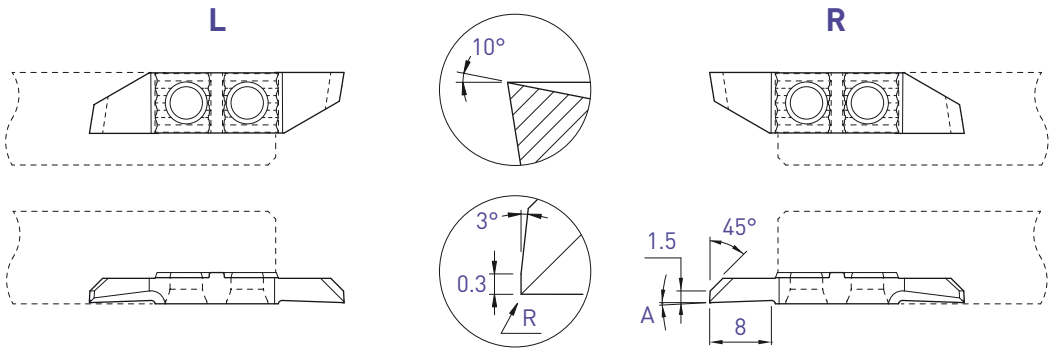
L

R

A	R	Art. N°	P M N S		P M N S		Art. N°	P M N S		P M N S	
			TiAlN	N (µk20)	HTA	HN (µk10)		TiAlN	N (µk20)	HTA	HN (µk10)
0°	0	632	•	•			642	•	•		
0°	0.08	-					642-R08	•	•		
0°	0.15	-					642-R15	•	•	•	
2°	0	632-2°	•	•			642-2°	•	•	•	
2°	0.08	-					642-2°-R08	•	•		
2°	0.15	-					642-2°-R15	•	•		

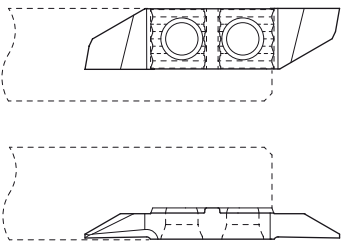
Tournage avant
Vorwärts drehen
Front turning

632X / 642X

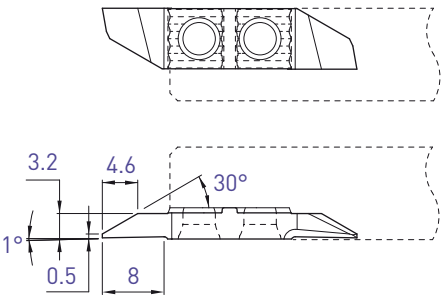


A	R	Art. N°	P		P	
			M	N	M	N
A	R	Art. N°	S		S	
			N (µk20)		HN (µk10)	
A	R	Art. N°	TiAlN		HTA	
			N (µk20)		HN (µk10)	
0°	0	632X10	•	•		
0°	0.08	-				
0°	0.15	-				
2°	0	632X10-2°	•	•		
2°	0.08	-				
2°	0.15	-				
A	R	Art. N°	P		P	
			M	N	M	N
A	R	Art. N°	S		S	
			N (µk20)		HN (µk10)	
A	R	Art. N°	TiAlN		HTA	
			N (µk20)		HN (µk10)	
0°	0	642X10	•	•		
0°	0.08	642X10-R08	•	•		
0°	0.15	642X10-R15	•	•		
2°	0	642X10-2°	•	•		
2°	0.08	642X10-2°-R08	•	•		•
2°	0.15	642X10-2°-R15	•	•	•	•

L



R



Tournage avant
Vorwärts drehen
Front turning

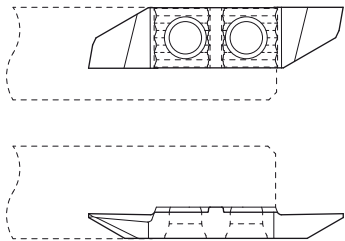
L				R			
Art. N°				Art. N°			
632S05	●	●		642S05	●	●	●

Tournage multifonction

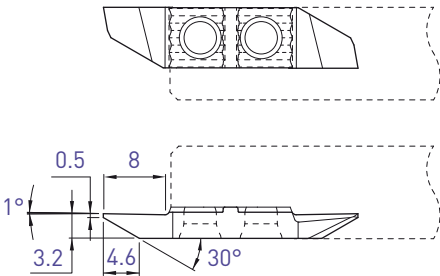
Mehrweck drehen
Multifunction turning

633S / 643S

L



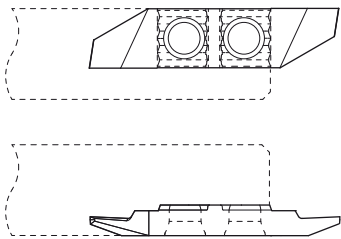
R



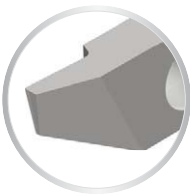
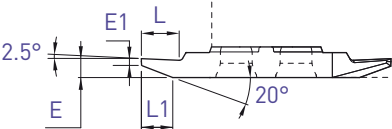
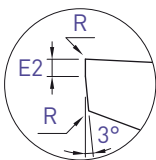
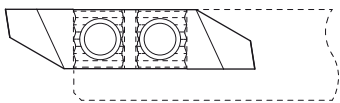
Tournage arrière
Rückwärts drehen
Back turning

L					R				
Art. N°	P				P				
	M				M				
	N	N			N	N			
	S				S				
Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	TiAlN	N (µk20)	HTA	HN (µk10)	
	633S05	• •			643S05	• •		•	

L



R



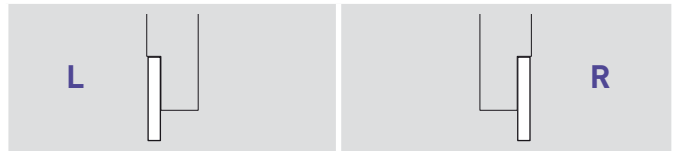
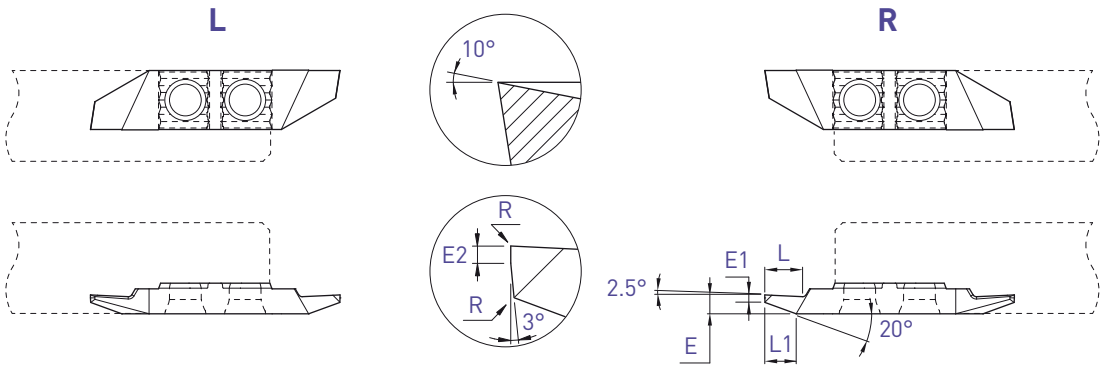
L

R

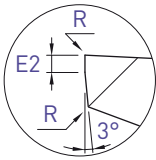
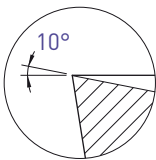
E1	E2	L	L1	E	R	Art. N°	P M N S TiAlN		P M N S HTA		Art. N°	P M N S TiAlN		P M N S HTA	
							N [µk20]		HN [µk10]			N [µk20]		HN [µk10]	
0.5	0.25	3	2.8	1.5	0	633-0.5	•	•			643-0.5	•	•		•
0.5	0.25	3	2.8	1.5	0.08	-					643-0.5-R08	•	•		
0.8	0.40	4.5	3.3	2.0	0	-					643-0.8	•	•		
0.8	0.40	4.5	3.3	2.0	0.08	-					643-0.8-R08	•	•		
1.0	0.40	5	4.2	2.5	0	-					643-1.0	•	•		
1.0	0.40	5	4.2	2.5	0.08	-					643-1.0-R08	•	•		
1.5	0.50	6	4.2	3.0	0	-					643-1.5	•	•		
1.5	0.50	6	4.2	3.0	0.08	-					643-1.5-R08	•	•		

Tournage arrière
Rückwärts drehen
Back turning

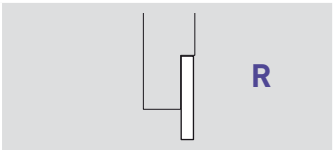
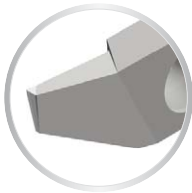
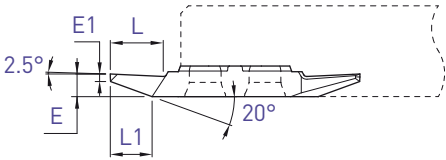
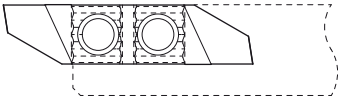
633X / 643X



E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.5	0.25	3	2.8	1.5	0	633X10-0.5	●	●			643X10-0.5	●	●	●	●
0.5	0.25	3	2.8	1.5	0.08	-					643X10-0.5-R08	●	●		
0.8	0.40	4.5	3.3	2.0	0	-					643X10-0.8	●	●		
0.8	0.40	4.5	3.3	2.0	0.08	-					643X10-0.8-R08	●	●		
1.0	0.40	5	4.2	2.5	0	-					643X10-1.0	●	●		
1.0	0.40	5	4.2	2.5	0.08	-					643X10-1.0-R08	●	●		
1.5	0.50	6	4.2	3.0	0	-					643X10-1.5	●	●		
1.5	0.50	6	4.2	3.0	0.08	-					643X10-1.5-R08	●	●		



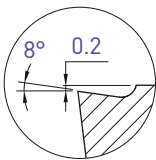
R



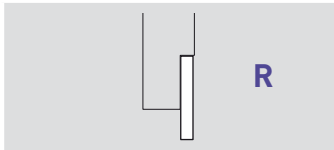
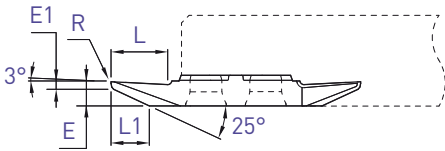
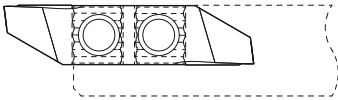
E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.0	0.4	7	5.5	3.0	0	643X10S-1.0	●	●		
1.0	0.4	7	5.5	3.0	0.08	643X10S-1.0-R08	●	●		

Tournage arrière
Rückwärts drehen
Back turning

643VX8



R



E1	L	L1	E	R	Art. N°	TiAlN	N [µk20]	HTA	HN [µk10]
1.0	7.5	5.0	3.2	0	643VX8	●	●		
1.0	7.5	5.0	3.2	0.08	643VX8-R08	●	●		

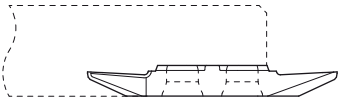
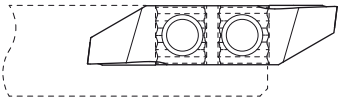
633VX15 / 643VX15

Tournage arrière

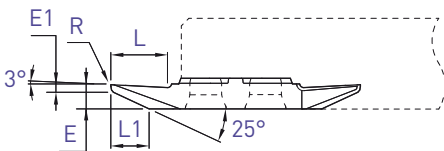
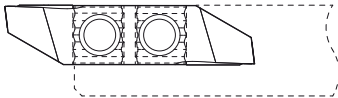
Rückwärts drehen

Back turning

L



R



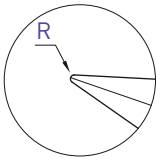
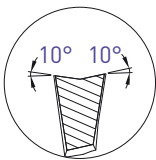
L

R

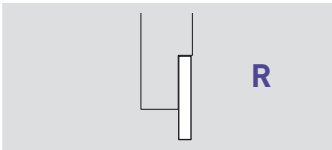
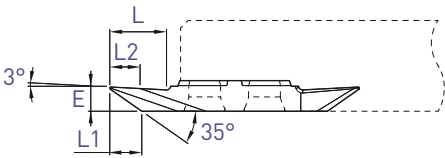
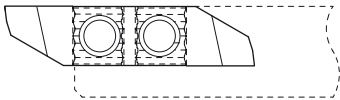
E1	L	L1	E	R	Art. N°	TiAlN N (µk20)	HTA HN (µk10)	Art. N°	TiAlN N (µk20)	HTA HN (µk10)
0.6	7.5	5.2	3.2	0	633VX15	•	•	643VX15	•	•
0.6	7.5	5.2	3.2	0.08	-			643VX15-R08	•	•

Tournage arrière
Rückwärts drehen
Back turning

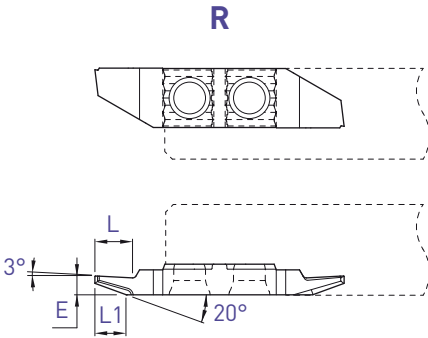
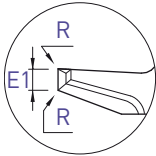
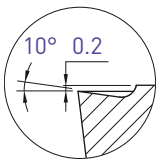
643VUX



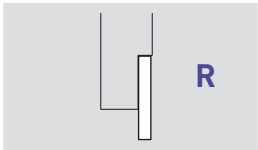
R



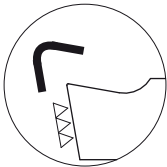
L	L1	L2	E	R	Art. N°	P		P	
						M		M	
						N	N	N	N
						S		S	
						TiAlN	N [µk20]	HTA	HN [µk10]
7.5	4.2	4.0	3.2	0.15	643VUX10-R15	●	●	●	●
7.5	3.8	3.8	3.2	0.35	643VUX10-R35	●	●		



Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



E1	L	L1	E	R	Art. N°	P M N S TiAlN N [µk20]
1.0	5	4	2.5	0.01	643ZX10-1.0	●
1.0	5	4	2.5	0.08	643ZX10-1.0-R08	●



Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

Fonçage-tournage

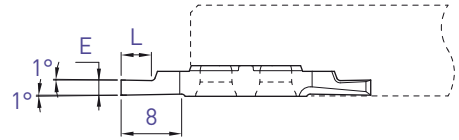
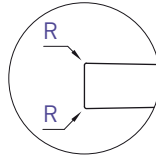
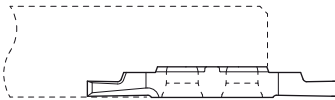
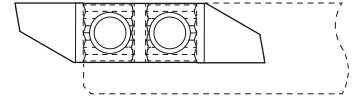
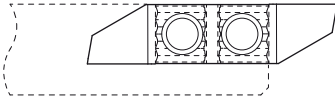
Einstechen und drehen

Grooving and turning

634 / 644

L

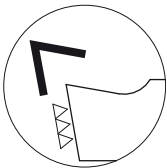
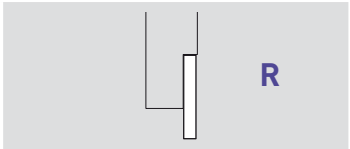
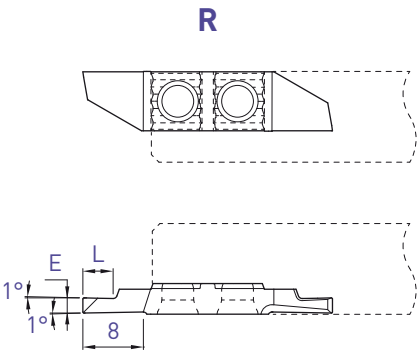
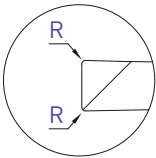
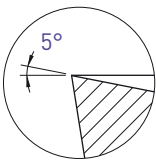
R



L

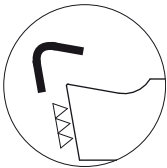
R

E	L	R	Art. N°	L				R			
				TIALN	N (µk20)	HTA	HN (µk10)	TIALN	N (µk20)	HTA	HN (µk10)
0.5	1.5	0	634-0.5	●	●			644-0.5	●	●	
0.6	1.8	0	-					644-0.6	●	●	
0.75	2	0	-					644-0.75	●	●	●
0.8	2	0	634-0.8	●	●			644-0.8	●	●	
0.9	2.5	0	-					644-0.9	●	●	
0.95	3	0	-					644-0.95	●	●	
1.0	2.5	0	634-1.0	●	●			644-1.0	●	●	●
1.0	2.5	0.08	-					644-1.0-R08	●	●	●
1.2	3	0	634-1.2	●	●			644-1.2	●	●	
1.2	3	0.08	-					644-1.2-R08	●	●	●
1.5	3	0	634-1.5	●	●			644-1.5	●	●	●
1.5	3	0.08	-					644-1.5-R08	●	●	●
1.5	3	0.15	-					644-1.5-R15	●	●	
1.8	4	0	-					644-1.8	●	●	●
2.0	4	0	634-2.0	●	●			644-2.0	●	●	
2.0	4	0.08	-					644-2.0-R08	●	●	●
2.0	4	0.15	-					644-2.0-R15	●	●	●
2.5	6	0	634-2.5	●	●			644-2.5	●	●	
2.5	6	0.08	-					644-2.5-R08	●	●	
2.5	6	0.15	-					644-2.5-R15	●	●	
3	6	0	634-3.0	●	●			644-3.0	●	●	●
3	6	0.08	-					644-3.0-R08	●	●	●
3	6	0.15	-					644-3.0-R15	●	●	



Arête de coupe vive
Scharfe Schneidkante
Sharp edge

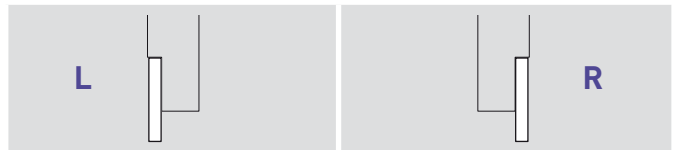
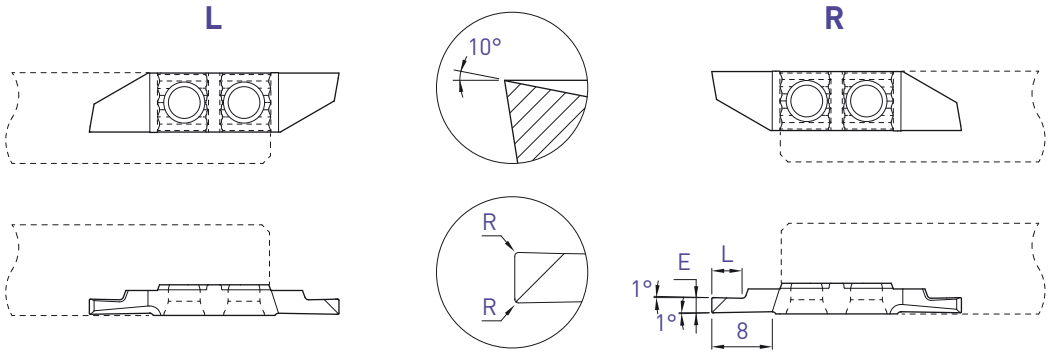
E	L	R	Art. N°	P☐ M☐ N☐ S☐				P☐ M☐ N☐ S☐			
				TiAlN	N (µk20)	HTA	HN (µk10)				
1.5	3	0.08	644X5-1.5-R08	•	•						
2	4	0.08	644X5-2.0-R08	•	•						
2	4	0.15	644X5-2.0-R15	•	•						
2.5	6	0.08	644X5-2.5-R08	•	•						
2.5	6	0.15	644X5-2.5-R15	•	•						
3	6	0.08	644X5-3.0-R08	•	•						
3	6	0.15	644X5-3.0-R15	•	•						



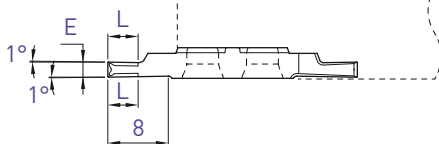
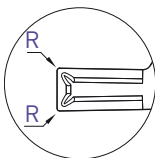
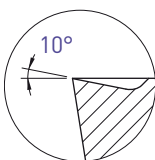
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

E	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.5	3	0.08	644X5-1.5-R08-EP	•	•		
2	4	0.08	644X5-2.0-R08-EP	•	•		
2	4	0.15	644X5-2.0-R15-EP	•	•		
2.5	6	0.08	644X5-2.5-R08-EP	•	•		
2.5	6	0.15	644X5-2.5-R15-EP	•	•		
3	6	0.08	644X5-3.0-R08-EP	•	•		
3	6	0.15	644X5-3.0-R15-EP	•	•		



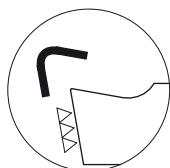
E	L	R	Art. N°					Art. N°				
				TiAlN	N (µk20)	HTA	HN (µk10)		TiAlN	N (µk20)	HTA	HN (µk10)
0.8	2	0	634X10-0.8	●	●			644X10-0.8	●	●		●
1.0	2.5	0	634X10-1.0	●	●			644X10-1.0	●	●		
1.0	2.5	0.08	634X10-1.0-R08	●	●			644X10-1.0-R08	●	●		
1.2	3	0	-					644X10-1.2	●	●		●
1.2	3	0.08	-					644X10-1.2-R08	●	●		
1.5	3	0	634X10-1.5	●	●			644X10-1.5	●	●		●
1.5	3	0.08	634X10-1.5-R08	●	●			644X10-1.5-R08	●	●		●
1.5	3	0.15	634X10-1.5-R15	●	●			644X10-1.5-R15	●	●		
1.8	4	0	-					644X10-1.8	●	●		
2	4	0	634X10-2.0	●	●			644X10-2.0	●	●		
2	4	0.08	634X10-2.0-R08	●	●			644X10-2.0-R08	●	●		
2	4	0.15	634X10-2.0-R15	●	●			644X10-2.0-R15	●	●		
2.5	6	0	634X10-2.5	●	●			644X10-2.5	●	●		
2.5	6	0.08	634X10-2.5-R08	●	●			644X10-2.5-R08	●	●		
2.5	6	0.15	634X10-2.5-R15	●	●			644X10-2.5-R15	●	●		
3	6	0	634X10-3.0	●	●			644X10-3.0	●	●		
3	6	0.08	634X10-3.0-R08	●	●			644X10-3.0-R08	●	●		
3	6	0.15	634X10-3.0-R15	●	●			644X10-3.0-R15	●	●		



Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



E	L	R	Art. N°	P M N S N		Art. N°	P M N S N	
				TiAlN	N (µk20)		TiAlN	N (µk20)
1.0	2.5	0.01	634ZXB10-1.0	●	644ZXB10-1.0	●		
1.5	4	0.01	634ZXB10-1.5	●	644ZXB10-1.5	●		
1.5	4	0.08	634ZXB10-1.5-R08	●	644ZXB10-1.5-R08	●		
2.0	4	0.01	634ZXB10-2.0	●	644ZXB10-2.0	●		
2.0	4	0.08	634ZXB10-2.0-R08	●	644ZXB10-2.0-R08	●		
2.0	4	0.15	634ZXB10-2.0-R15	●	644ZXB10-2.0-R15	●		
2.5	5	0.08	634ZXB10-2.5-R08	●	644ZXB10-2.5-R08	●		
2.5	5	0.15	634ZXB10-2.5-R15	●	644ZXB10-2.5-R15	●		
3.0	6	0.08	634ZXB10-3.0-R08	●	644ZXB10-3.0-R08	●		
3.0	6	0.15	634ZXB10-3.0-R15	●	644ZXB10-3.0-R15	●		
3.0	6	0.35	634ZXB10-3.0-R35	●	644ZXB10-3.0-R35	●		



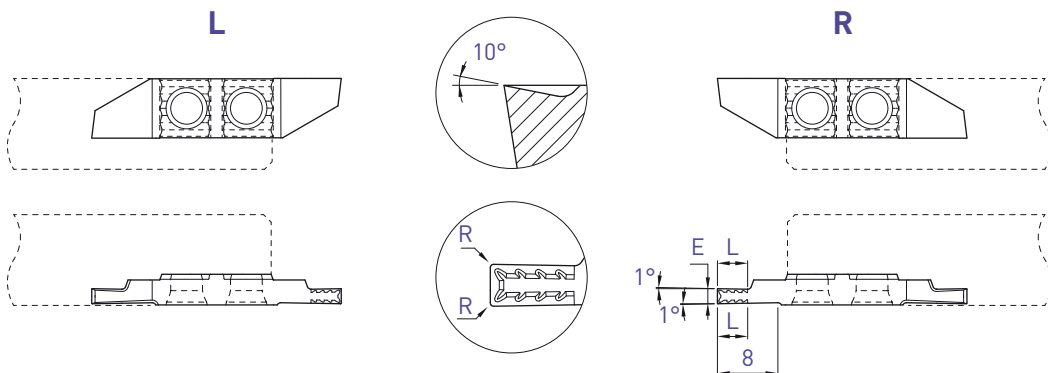
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

Fonçage-tournage

Einstechen und drehen
Grooving and turning

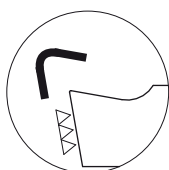
634ZXT / 644ZXT



Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



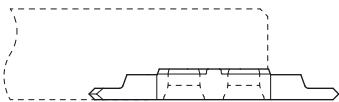
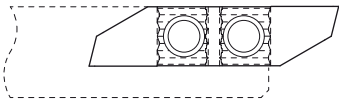
E	L	R	Art. N°	P M N S TiAlN N (µk20)	Art. N°	P M N S TiAlN N (µk20)
1.0	2.5	0.01	634ZXT10-1.0	●	644ZXT10-1.0	●
1.5	4	0.01	634ZXT10-1.5	●	644ZXT10-1.5	●
1.5	4	0.08	634ZXT10-1.5-R08	●	644ZXT10-1.5-R08	●
2.0	4	0.01	634ZXT10-2.0	●	644ZXT10-2.0	●
2.0	4	0.08	634ZXT10-2.0-R08	●	644ZXT10-2.0-R08	●
2.0	4	0.15	634ZXT10-2.0-R15	●	644ZXT10-2.0-R15	●
2.5	5	0.08	634ZXT10-2.5-R08	●	644ZXT10-2.5-R08	●
2.5	5	0.15	634ZXT10-2.5-R15	●	644ZXT10-2.5-R15	●
3.0	6	0.08	634ZXT10-3.0-R08	●	644ZXT10-3.0-R08	●
3.0	6	0.15	634ZXT10-3.0-R15	●	644ZXT10-3.0-R15	●
3.0	6	0.35	-		644ZXT10-3.0-R35	●



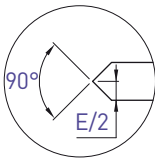
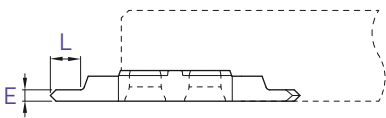
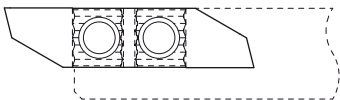
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

L



R



L



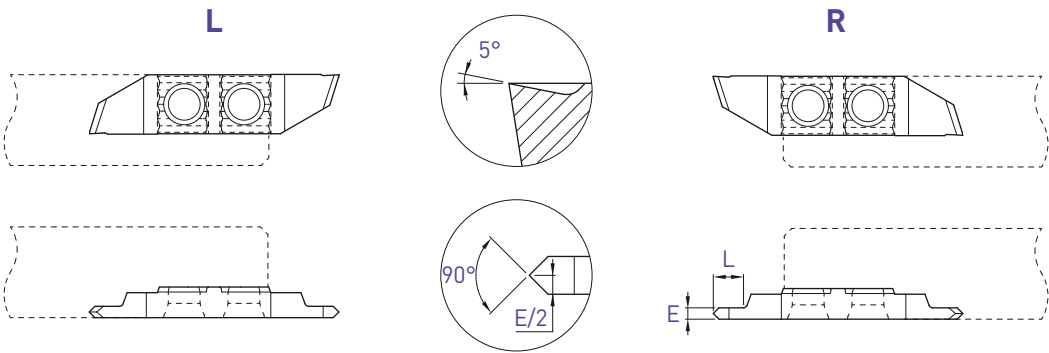
R



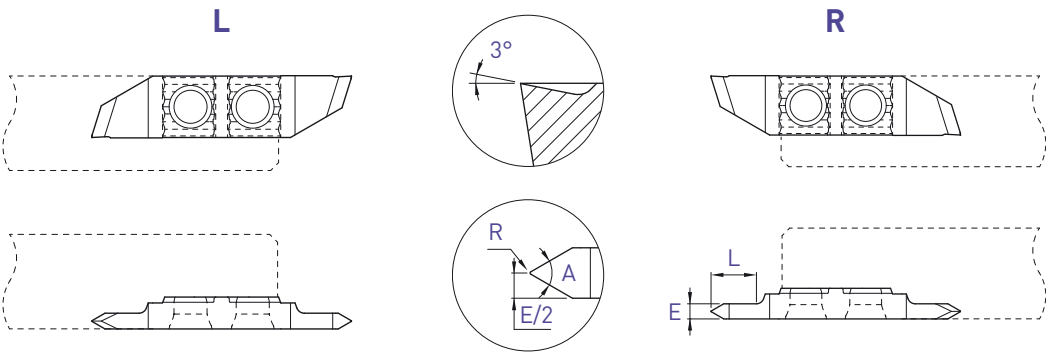
E	L	Art. N°	P	M	N	S	TAIN	N (µk20)	Art. N°	P	M	N	S	TAIN	N (µk20)
1.5	4	635-90-1.5	•	•					645-90-1.5	•	•				

Chanfreinage
Anfasen
Chamfering

635X-90 / 645X-90



		L				R			
E	L	Art. N°	TiAlN		N [µk20]	Art. N°	TiAlN		N [µk20]
			P	M			P	M	
1.5	4	635X5-90-1.5	N	S	● ●	645X5-90-1.5	N	S	● ●
			☐	☐			☐	☐	



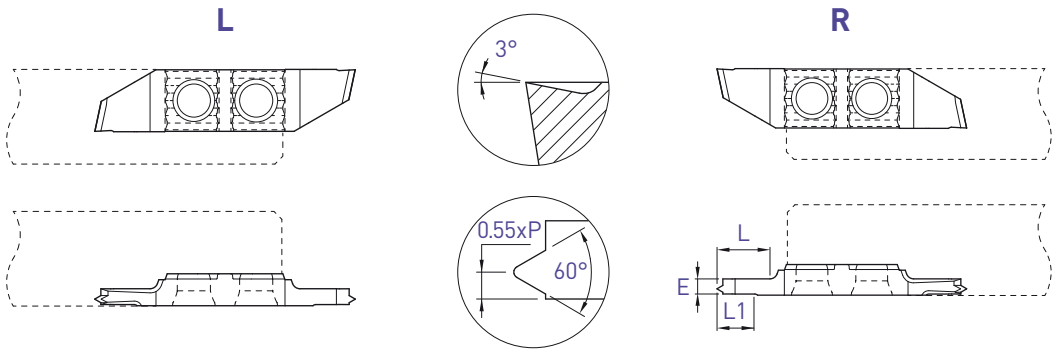
Profil partiel
Teilprofil
Partial profile

				L						R	
				P M N S N						P M N S N	
Art. N°				TiAlN	N [µk20]	Art. N°				TiAlN	N [µk20]
636X3-55-1.5				●	●	646X3-55-1.5				●	●
636X3-55-2.0-R03				●	●	646X3-55-2.0-R03				●	●
636X3-60-1.5				●	●	646X3-60-1.5				●	●
636X3-60-2.0-R03				●	●	646X3-60-2.0-R03				●	●
636X3-60-2.0-R06				●	●	646X3-60-2.0-R06				●	●
636X3-60-3.0-R06				●	●	646X3-60-3.0-R06				●	●
636X3-60-3.0-R12				●	●	646X3-60-3.0-R12				●	●

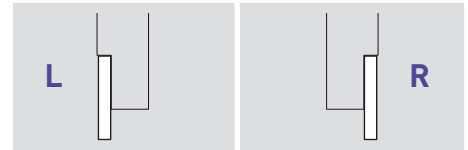
Filetage

Gewinde drehen
Threading

636X-M / 646X-M

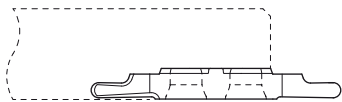
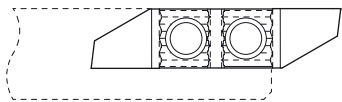


Profil complet métrique
Metrisches Vollprofil
Metric full profile

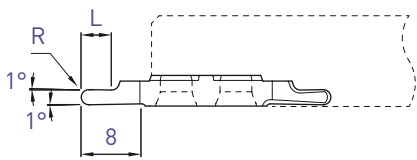
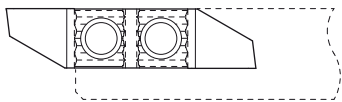


E	L	L1	Pas Steigung Pitch P	Art. N°	P M N S N		Art. N°	P M N S N	
					TiAIN	N [µk20]		TiAIN	N [µk20]
1.0	3	3	0.25	636X3-M-0.25	●	●	646X3-M-0.25	●	●
1.0	3	3	0.30	636X3-M-0.30	●	●	646X3-M-0.30	●	●
1.0	3	3	0.35	636X3-M-0.35	●	●	646X3-M-0.35	●	●
1.0	3	3	0.40	636X3-M-0.40	●	●	646X3-M-0.40	●	●
1.0	3	3	0.45	636X3-M-0.45	●	●	646X3-M-0.45	●	●
1.0	3	3	0.50	636X3-M-0.50	●	●	646X3-M-0.50	●	●
1.5	5	5	0.60	636X3-M-0.60	●	●	646X3-M-0.60	●	●
1.5	5	5	0.70	636X3-M-0.70	●	●	646X3-M-0.70	●	●
1.5	5	5	0.75	636X3-M-0.75	●	●	646X3-M-0.75	●	●
1.5	5	5	0.80	636X3-M-0.80	●	●	646X3-M-0.80	●	●
2.0	7	5	1.00	636X3-M-1.00	●	●	646X3-M-1.00	●	●
2.0	7	5	1.25	636X3-M-1.25	●	●	646X3-M-1.25	●	●
2.0	7	5	1.50	636X3-M-1.50	●	●	646X3-M-1.50	●	●

L



R



L



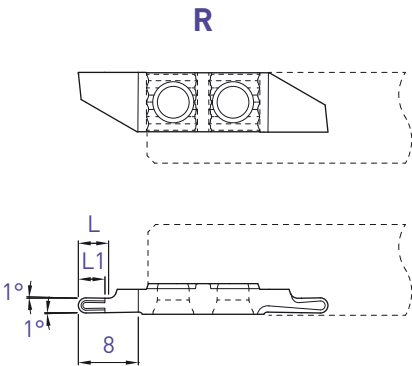
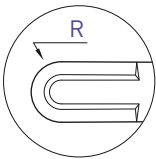
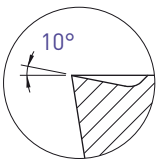
R



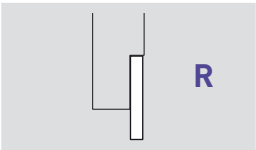
R	L	Art. N°	P M N S		P M N S		Art. N°	P M N S		P M N S	
			TiAlN	N [µk20]	HTA	HN [µk10]		TiAlN	N [µk20]	HTA	HN [µk10]
0.25	1.5	-					647-R0.25	•	•		
0.4	2	-					647-R0.4	•	•		
0.5	2.5	637-R0.5	•	•			647-R0.5	•	•	•	•
0.6	2.5	-					647-R0.6	•	•		
0.75	3	-					647-R0.75	•	•		
0.8	3	-					647-R0.8	•	•		
1.0	4	637-R1.0	•	•			647-R1.0	•	•		
1.5	6	-					647-R1.5	•	•		

Plaquettes à rayon
Radius Wendeplatten
Radius inserts

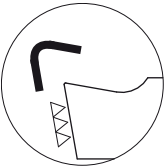
647ZX10



Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



R	L	L1	Art. N°	TiAlN	N [µk20]
1.0	4	3.5	647ZX10-R1.0	●	
1.5	6	4	647ZX10-R1.5	●	



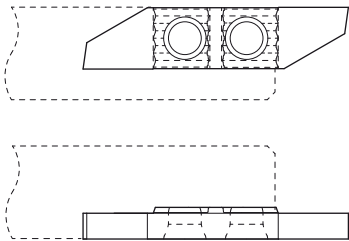
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

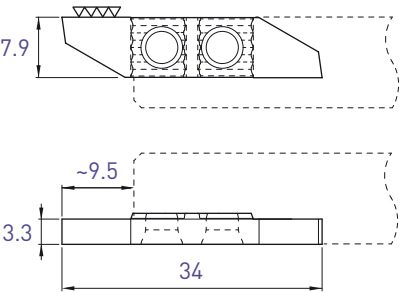
631-EP / 641-EP

Plaquettes ébauches
WSP-Rohlinge
Blank inserts

L



R



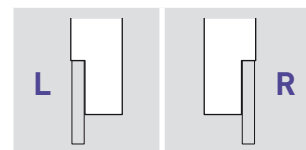
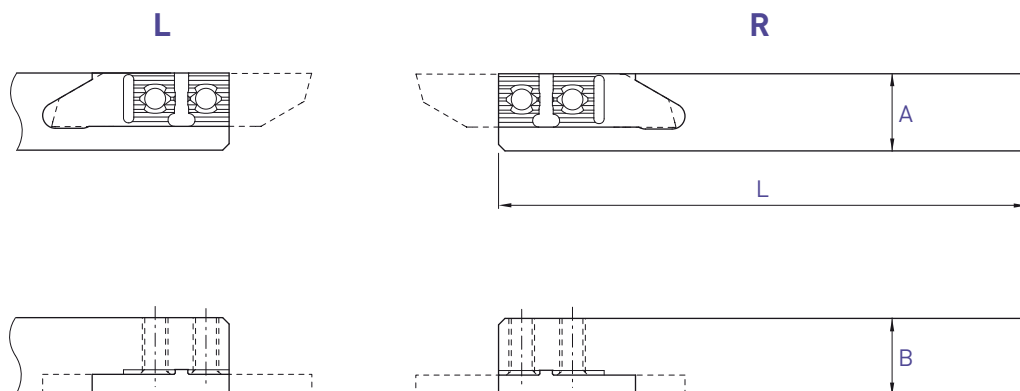
Face de coupe polie
Polierte Schneidfläche
Polished cutting face

L					R				
Art. N°	P		P		Art. N°	P		P	
	M		M			M		M	
	N	N	N	N		N	N	N	N
	S		S			S		S	
	TiAlN	N (µk20)	HTA	HN (µk10)		TiAlN	N (µk20)	HTA	HN (µk10)
631-EP	•	•	•	•	641-EP	•	•	•	•

Porte-outils

Halter
Holders

650 / 660



A x B	L	Art. N°	Art. N°
8 x 8	115	650-8	660-8
10 x 10	115	650-10	660-10
10 x 10	50	650-10-50	660-10-50
12 x 12	130	650-12	660-12
12 x 12	90	650-12-90	660-12-90
12.7 x 12.7	130	650-12.7	660-12.7
16 x 16	130	650-16	660-16
16 x 16	75	650-16-75	660-16-75
20 x 20	120	650-20	660-20

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.

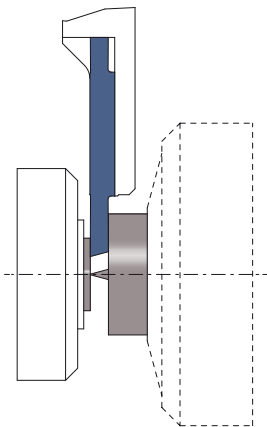
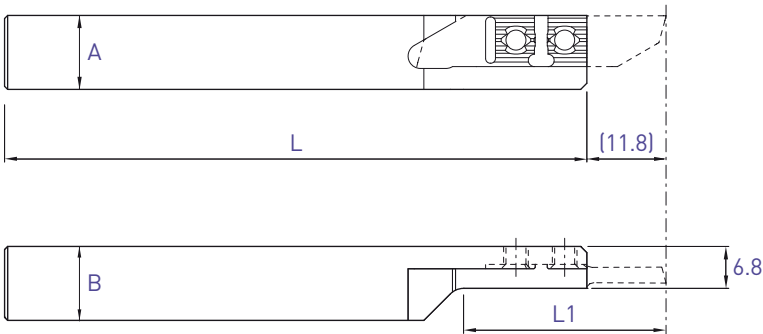
650 RC

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

Porte-outils
Halter
Holders

Utiliser des plaquettes type 651R
WSP Typ 651R verwenden
Use inserts type 651R

Voir dès page 5.39
Siehe ab Seite 5.39
See from page 5.39

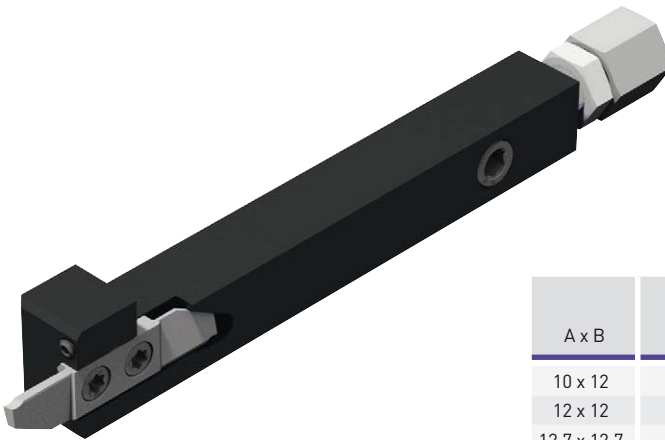
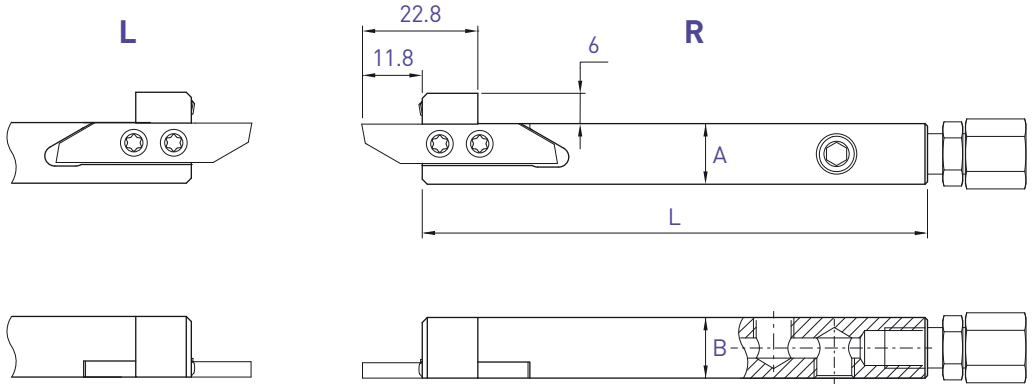


 L (R) Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line			
A x B	L	L1	Art. N°
10 x 10	115	32	650RC-10
12 x 12	130	32	650RC-12
16 x 16	130	42	650RC-16

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

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

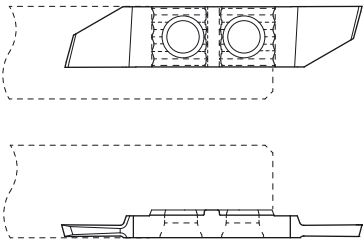
650-JET / 660-JET



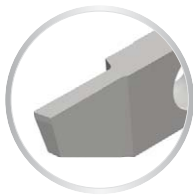
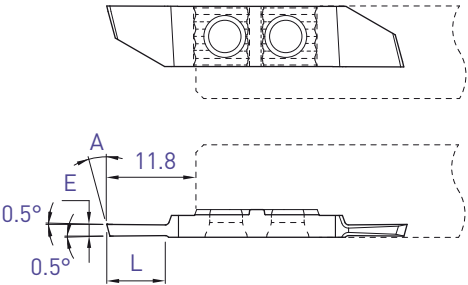
		L R	
A x B	L	Art. N°	Art. N°
10 x 12	100	650-1012-JET	660-1012-JET
12 x 12	100	650-12-JET	660-12-JET
12.7 x 12.7	100	650-12.7-JET	660-12.7-JET
16 x 16	100	650-16-JET	660-16-JET
20 x 20	100	650-20-JET	660-20-JET

Chaque support est livré avec vis, raccord droit et buse d'arrosage Ø 1.5 mm. Les clés sont à commander séparément.
Jeder Halter wird mit Spannschraube(n), gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert. Die Schlüssel sind separat zu bestellen.
Screw(s), straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder. The keys must be ordered separately.

L



R



L

R

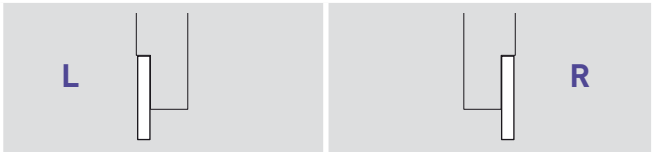
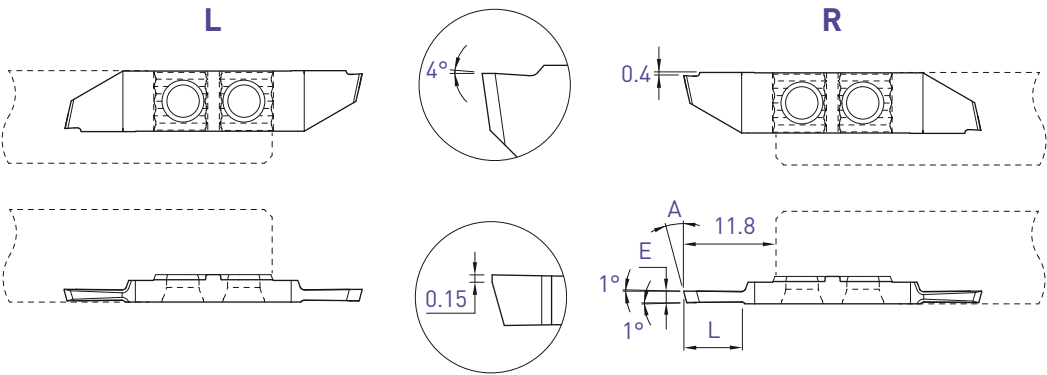
E	A	L	Art. N°	P M N S TiAlN N (µk20) HTA HN (µk10)				Art. N°	P M N S TiAlN N (µk20) HTA HN (µk10)			
0.8	20°	5	651-0.8-20°	●	●			661-0.8-20°	●	●	●	●
1.0	15°	5	-					661-1.0-15°	●	●		
1.0	20°	5	651-1.0-20°	●	●			661-1.0-20°	●	●		
1.2	15°	5	-					661-1.2-15°	●	●		
1.2	20°	5	651-1.2-20°	●	●			661-1.2-20°	●	●		
1.5	15°	7.5	651-1.5-15°	●	●			661-1.5-15°	●	●		
1.5	20°	7.5	-					661-1.5-20°	●	●		
1.8	15°	9	651-1.8-15°	●	●			661-1.8-15°	●	●		
2.0	15°	11	651-2.0-15°	●	●	●		661-2.0-15°	●	●	●	●
2.5	15°	11	651-2.5-15°	●	●			661-2.5-15°	●	●		

Tronçonnage

Abstechen

Parting off

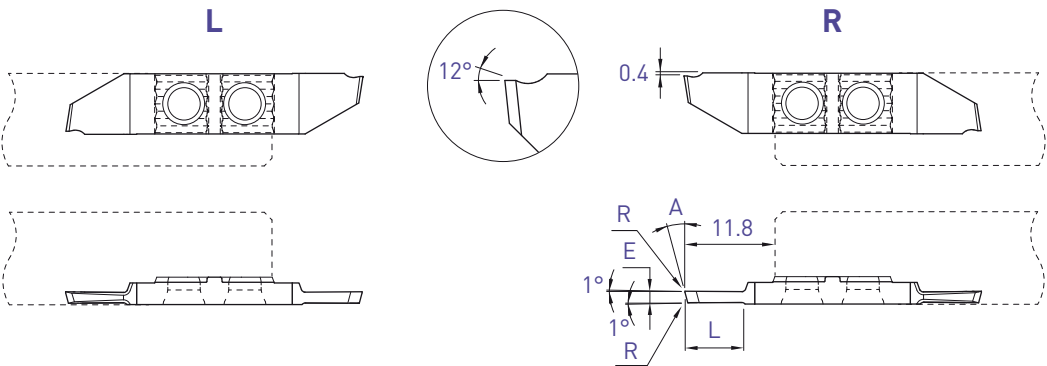
651XF / 661XF



E	A	L	Art. N°	TiAlN		HTA		Art. N°	TiAlN		HTA	
				P	M	N	S		P	M	N	S
1.5	15°	7.5	651XF-1.5	•	•			661XF-1.5	•	•		
2.0	15°	11	651XF-2.0	•	•			661XF-2.0	•	•		

651X12 / 661X12

Tronçonnage
Abstechen
Parting off



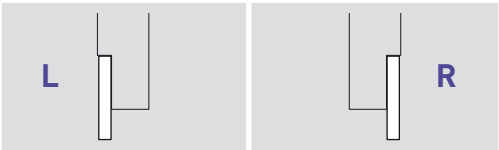
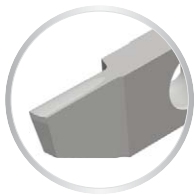
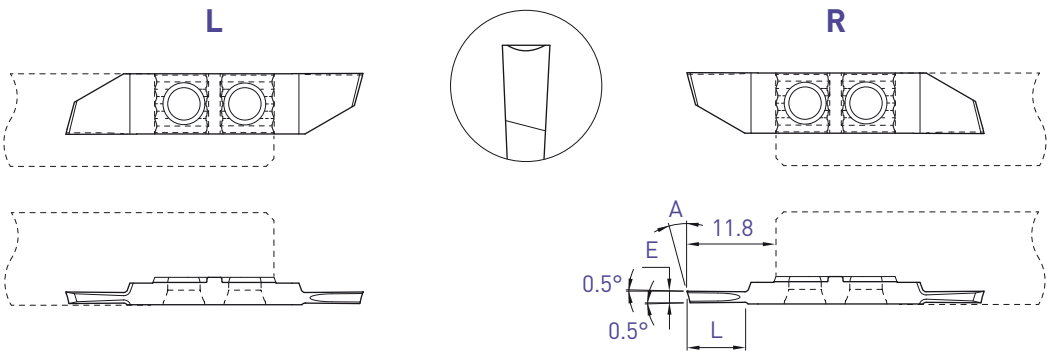
				L				R			
				Art. N°				Art. N°			
				TiAlN				TiAlN			
				N (µk20)				N (µk20)			
				HTA				HTA			
				HN (µk10)				HN (µk10)			
				Art. N°				Art. N°			
				651X12-1.0				661X12-1.0			
				651X12-1.5				661X12-1.5			
				651X12-2.0				661X12-2.0			

Tronçonnage

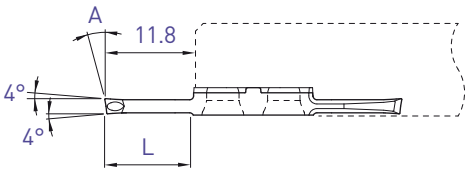
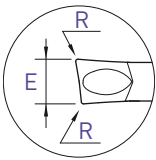
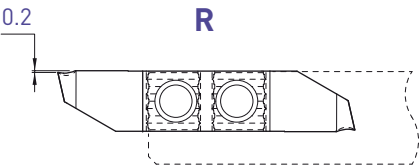
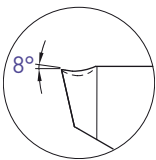
Abstechen

Parting off

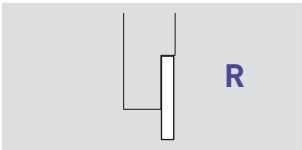
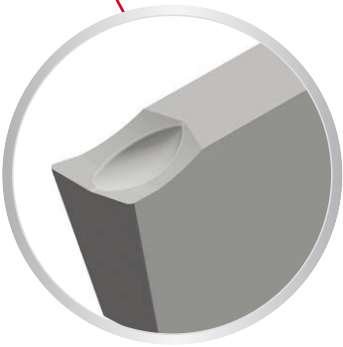
651U / 661U



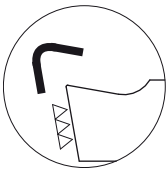
E	A	L	Art. N°	TiAlN N (µk20)	P M N S	Art. N°	TiAlN N (µk20)	P M N S
1.5	15°	7.5	651U-1.5	• •	• •	661U-1.5	• •	• •
2.0	15°	11	651U-2.0	• •	• •	661U-2.0	• •	• •



Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



E	A	L	R	Art. N°	TiAlN N (µk20)
2.0	8°	11	0.10	661ZU8-2.0-8°-R10	P M N S TiAlN N (µk20)
					●



Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

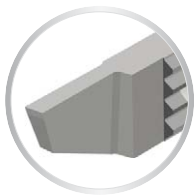
Tronçonnage

Abstechen
Parting off

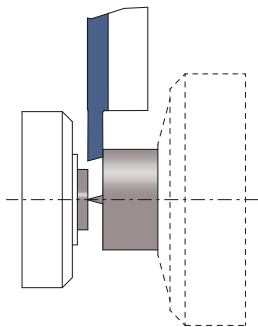
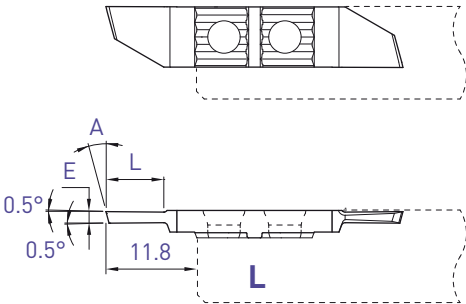
Coupe déportée

Versetztes Schneiden
Cut off line

651R



Cut R



L (R)

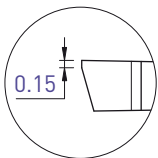
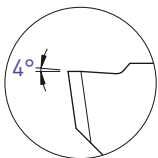
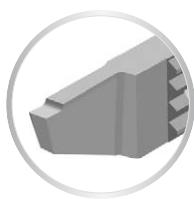
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	TiAlN		N (µk20)		HTA		HN (µk10)	
				P M N S		P M N S		P M N S			
1.0	15°	5	651R-1.0-15°	●	●						
1.2	15°	5	651R-1.2-15°	●	●						
1.5	15°	7.5	651R-1.5-15°	●	●						
2.0	15°	11	651R-2.0-15°	●	●						
2.5	15°	11	651R-2.5-15°	●	●						

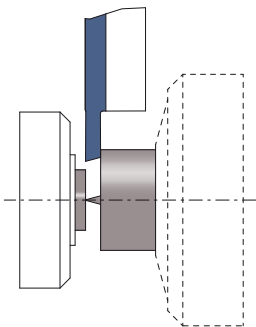
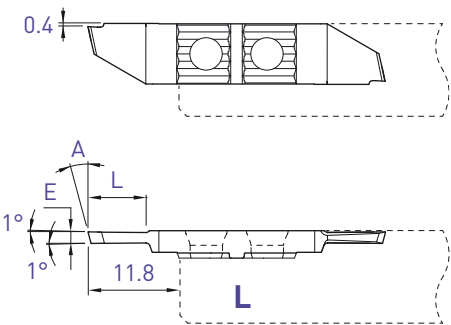
651RXF

Coupe déportée
Versetztes Schneiden
Cut off line

Tronçonnage
Abstechen
Parting off



Cut R



L (R)

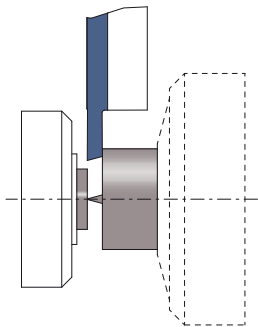
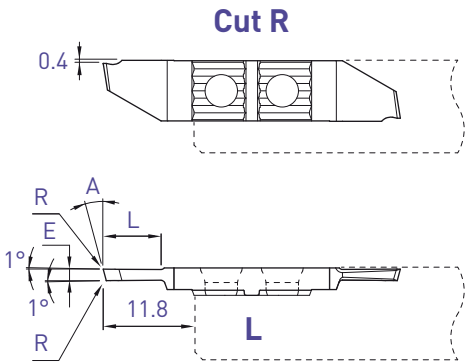
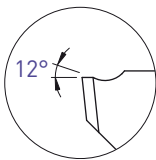
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	TiAlN N (µk20)	HTA HN (µk10)
1.5	15°	7.5	651RXF-1.5	● ●	
2.0	15°	11	651RXF-2.0	● ●	

Tronçonnage
Abstechen
Parting off

Coupe déportée
Versetztes Schneiden
Cut off line

651RX12

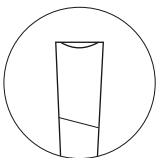


		L (R)					
Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line							
Art. N°					☐		☐
					☐		☐
							☐
					☐		☐
				TiAlN	N [µk20]	HTA	HN [µk10]
651RX12-1.5				●	●		
651RX12-2.0				●	●		

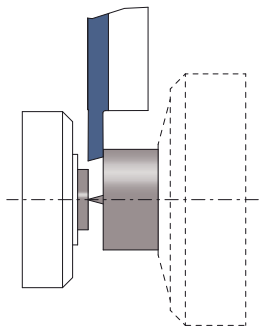
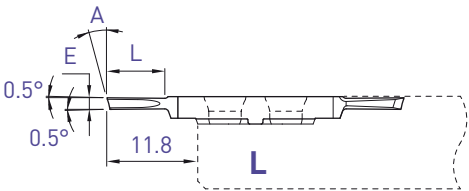
651RU

Coupe déportée
Versetztes Schneiden
Cut off line

Tronçonnage
Abstechen
Parting off



Cut R



L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	P M N S TiAlN	N (µk20)
1.5	15°	7.5	651RU-1.5	●	●
2.0	15°	11	651RU-2.0	●	●

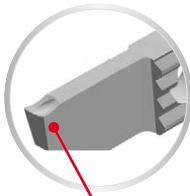
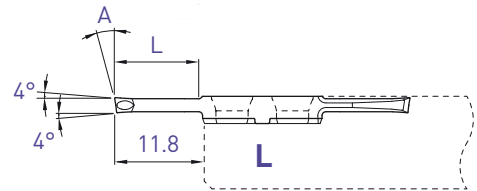
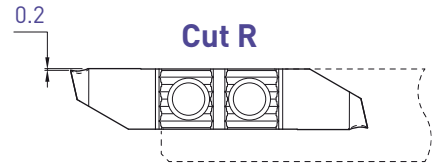
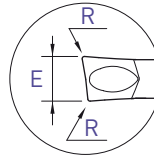
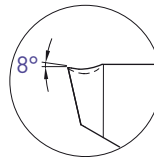
Tronçonnage

Abstechen
Parting off

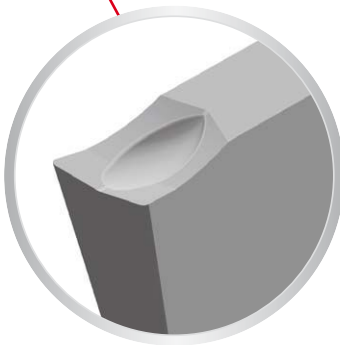
Coupe déportée

Versetztes Schneiden
Cut off line

651RZU



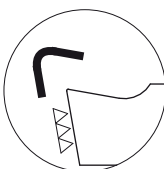
Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



L (R)

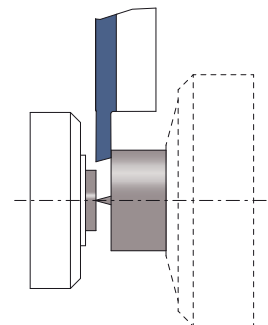
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	R	Art. N°	P	M	N	S	TiAIN	N (µk20)
2.0	8°	11	0.10	651RZU8-2.0-8°-R10	☐	☐	☒	☐	•	

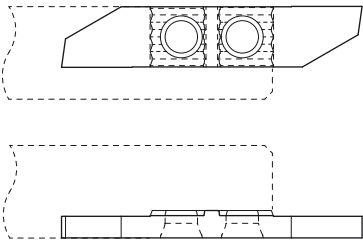


Arête de coupe honée
Gehonte Schneidkante
Honed edge

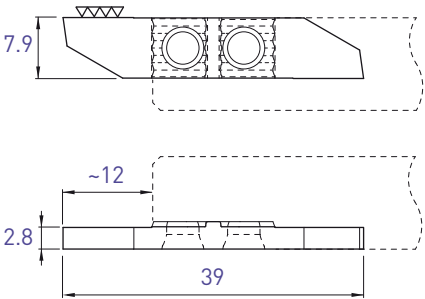
f min: 0.02 mm/U



L



R



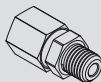
Face de coupe polie
Polierte Schneidfläche
Polished cutting face

L				R			
Art. N°		TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	
651-EP		●	●	●	●	661-EP	

Pièces de rechange et accessoires

Ersatzteile und Zubehör

Spare parts and accessories

Porte-outils Halter Holders					Options		
							
					Art. N°	Recommandation de serrage Empfehlung zum Spannen Clamping recommendation	
630 640		-	-	-		SET- NM3.0-TX15	3 Nm
630-JET 640-JET	V-M4X9-T15	J-M8X1-D6	JB-M8X1	JJ-M3X6-D1.5			
650 660		-	-	-			
650-RC	V-M4X6.5-T15	-	-	-			
650-JET 660-JET	V-M4X9-T15	J-M8X1-D6	JB-M8X1	JJ-M3X6-D1.5			

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 standard
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