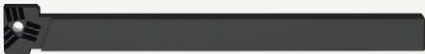


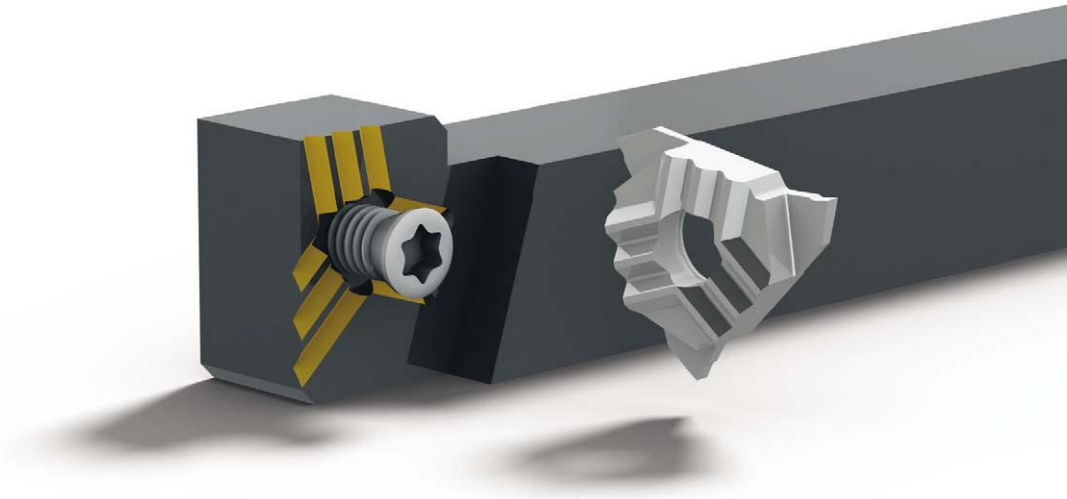
TRIO-Line



APPLITEC
CUTTING TOOLS

	Infos et avantages Infos und Vorteile Infos and advantages				> 7.03
	Codification Bezeichnungssystem Designation system				> 7.04
	Nuances Sorten Grades				> 7.06
	Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data				> 7.07
	Porte-outils Halter Holders				> 7.08
GX	Plaquettes de gorge pour circlips Einstechwendeplatte für Seegerring Grooving inserts for retaining ring	DIN6799 & DIN471			> 7.09
FT	Tournage avant Vorwärts drehen Front turning				> 7.10
GT	Fonçage-tournage Einstechen und drehen Grooving and turning				> 7.11
GTX	Fonçage-tournage avec coupe positive Einstechen und drehen mit positivem Spanwinkel Grooving and turning with positive cut				> 7.12
EP	Plaquettes ébauches WSP-Rohlinge Blank inserts				> 7.13
	Pièces de rechange et accessoires Ersatzteile und Zubehör Spare parts and accessories				> 7.13

*Rigid clamping system with the famous
Applitec teeth clamping*



**Avantages
Vorteile
Advantages**

- dimensions spécifiques
- système de serrage à denture à 1 vis
- pour opération de faible profondeur
- solution optimisée (proportion réduite de carbure pour un équilibre parfait entre coût et performance)

- spezifische Abmessungen
- Spannsystem mit 1 Schraube
- für geringe Tiefenbearbeitung
- optimierte Lösung (reduzierte Hartmetallschicht für ein perfektes Gleichgewicht zwischen Kosten und Leistung)

- specific dimensions
- clamping system with 1 screw
- for shallow operation
- optimized solution [reduced carbide layer for a perfect balance between cost and performance]

Codification des porte-outils

Kodifizierung für Halter

Coding guide for holders

T216

-

H

08

10

R

-

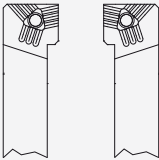
90

Ou / Oder / Or

Porte-outils
Halter
Holders

L

R



Longueur
Länge
Length

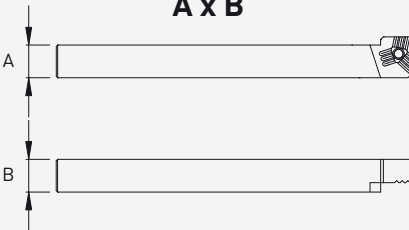
A x B	L
8x10	115
10x10	130
12x12	130
16x16	120
20x20	130



A x B

A

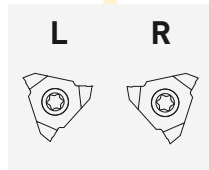
B



Applitec TRIO-Line
Applitec TRIO-Line
Applitec TRIO-Line

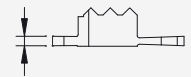
Système de serrage à denture avec 1 vis de fixation
Spannsystem mit Verzahnung mit 1 Spannschraube
Teeth clamping system with 1 screw

T 2 1 6 R - GX 026 - HTA



Nuance
Sorte
Grade

Épaisseur de coupe
Schnittbreite
Cutting thickness



Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry

GX

Grooving



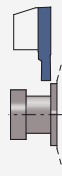
FT

Front turning



GT

Grooving /
turning



GTX

Grooving /
turning positif



EP

Blank



Applitec TRIO-Line
Applitec TRIO-Line
Applitec TRIO-Line

Système de serrage à denture avec 1 vis de fixation
Spannsystem mit Verzahnung mit 1 Spannschraube
Teeth clamping system with 1 screw

Nuances

Sorten

Grades

HN



 K10

Non revêtu
Unbeschichtet
Uncoated

P	★	★	★	★	★
M	★	★	★	★	★
N	★	★	★	★	★
S	★	★	★	★	★

μK10

- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du laiton, de l'aluminium et du titane faiblement allié
- pour pièces fragiles de très petits diamètres

- sehr verschleissfeste Feinkornsorte
- für die Bearbeitung von Messing und niedrig legiertem Aluminium und Titan empfehlenswert
- für empfindliche und sehr kleine Werkstücke

- very wear resistant micro-grain grade
- suitable for the machining of brass and low alloyed aluminium and titanium
- for fragile and very small work pieces

HTA



 K10

μK10 + revêtement PVD
μK10 + PVD Beschichtung
μK10 + PVD coating

TF — F — **M** — E

P	★	★	★	★	★
M	★	★	★	★	★
N	★	★	★	★	★
S	★	★	★	★	★

μK10

- 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

Paramètres de coupe indicatifs

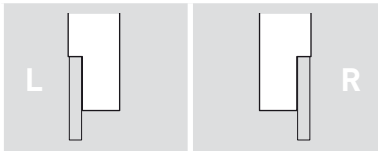
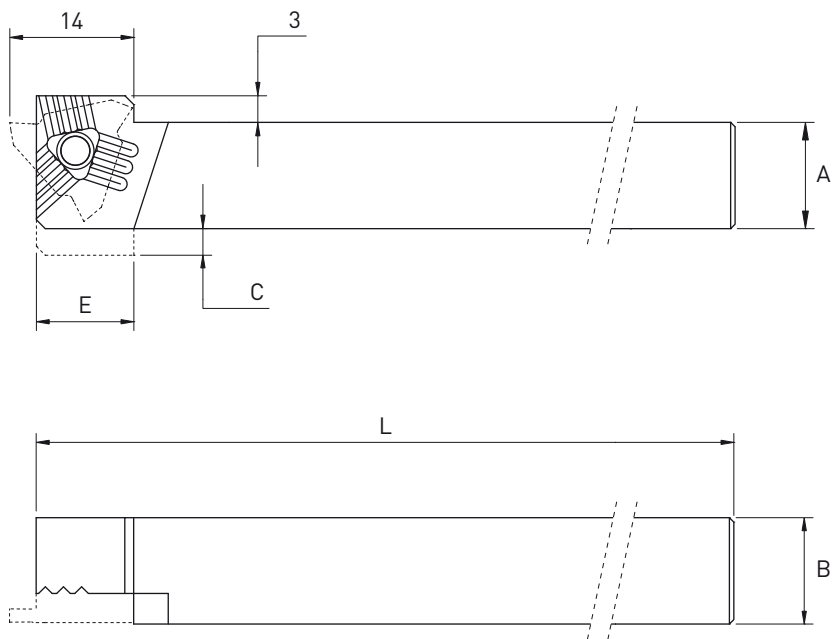
Empfohlene Schnittwerte

Standard machining data

		FTGTGTX  Tournage Drehen Turning			GXGTGTX  Foncer Einstechen Grooving		
Matière Werkstoff Material		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		

T216-L/R

Porte-outils
Halter
Holders

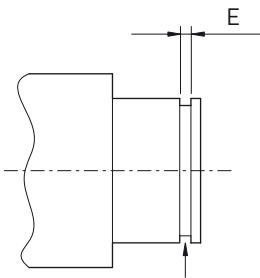
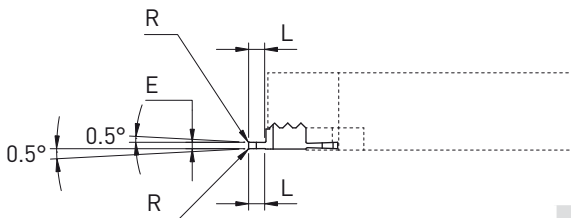
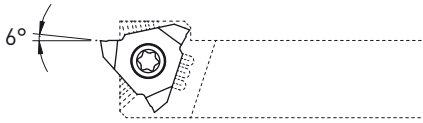


AxB	C	E	L	Art. N°	Art. N°
8x10	4	11	115	T216-H0810L	T216-H0810R
10x10	2	8	130	T216-H1010L	T216-H1010R
12x12	-	-	130	T216-H1212L	T216-H1212R
12x12	-	-	90	T216-H1212L-90	T216-H1212R-90
16x16	-	-	120	T216-H1616L	T216-H1616R
20x20	-	-	130	T216-H2020L	T216-H2020R

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.

Plaquettes de gorge pour circlips
 Einstechwendeplatte für Seegerring
 Grooving inserts for retaining ring

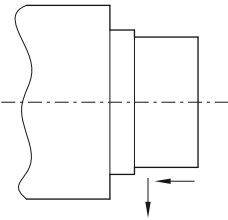
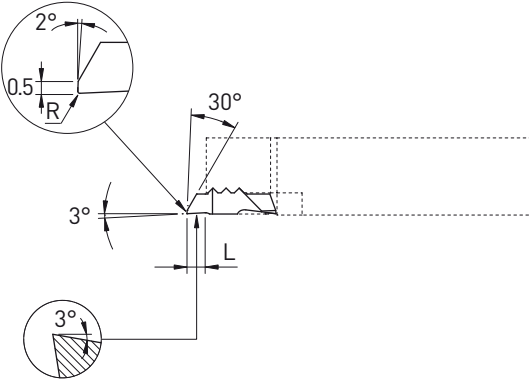
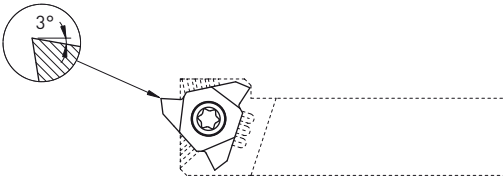
GX



Selon DIN6799 et DIN471
 Gemäss DIN6799 und DIN471
 According to DIN6799 and DIN471



			L		R	
			P M N S		P M N S	
			HTA		HTA	
			HN (μk10)		HN (μk10)	
E ±0.01	L	R	Art. N°		Art. N°	
0.26	0.8	0.03	T216L-GX026		T216R-GX026	
0.36	0.8	0.03	T216L-GX036		T216R-GX036	
0.46	0.8	0.03	T216L-GX046		T216R-GX046	
0.50	1.5	0.03	T216L-GX050		T216R-GX050	
0.57	1.5	0.03	T216L-GX057		T216R-GX057	
0.67	1.5	0.03	T216L-GX067		T216R-GX067	
0.77	2.0	0.03	T216L-GX077		T216R-GX077	
0.87	2.0	0.03	T216L-GX087		T216R-GX087	
0.97	2.5	0.03	T216L-GX097		T216R-GX097	
1.00	2.5	0.03	T216L-GX100		T216R-GX100	
1.10	2.5	0.03	T216L-GX110		T216R-GX110	
1.20	2.5	0.03	T216L-GX120		T216R-GX120	
1.30	2.5	0.03	T216L-GX130		T216R-GX130	
1.50	2.5	0.03	T216L-GX150		T216R-GX150	
1.60	2.5	0.03	T216L-GX160		T216R-GX160	
1.85	2.5	0.03	T216L-GX185		T216R-GX185	
2.00	2.5	0.03	T216L-GX200		T216R-GX200	
2.50	2.5	0.03	T216L-GX250		T216R-GX250	



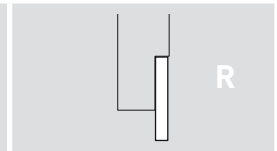
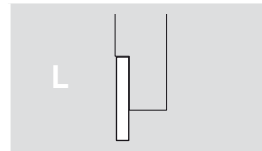
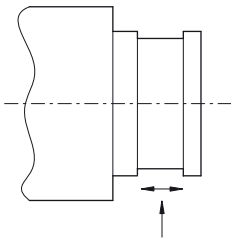
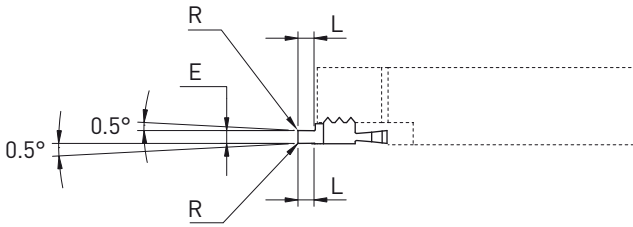
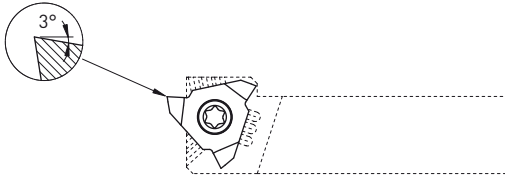
		L		R	
		Art. N°		Art. N°	
		HTA	HN (µk10)	HTA	HN (µk10)
L	R	3.0	0.03	T216L-FT	• •
L	R	3.0	0.08	T216L-FT-R08	• •

Fonçage-tournage

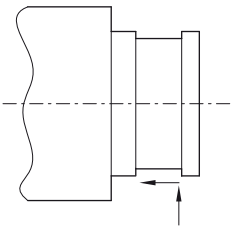
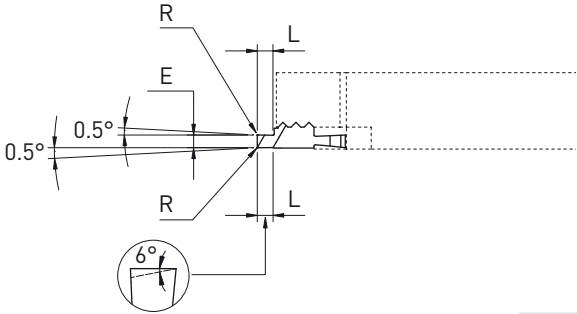
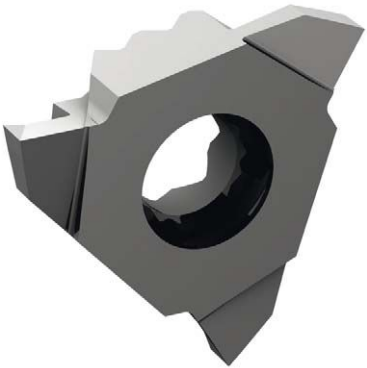
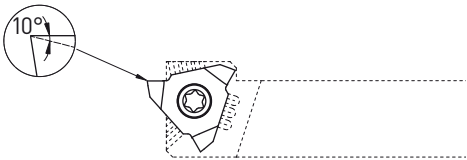
Einstecken und drehen

Grooving and turning

GT



				P M N S N S			P M N S N S	
E	L	R	Art. N°	HTA	HN [µk10]	Art. N°	HTA	HN [µk10]
0.5	1.5	0.03	T216L-GT050	●	●	T216R-GT050	●	●
1.0	2.5	0.03	T216L-GT100	●	●	T216R-GT100	●	●
1.0	2.5	0.08	T216L-GT100-R08	●	●	T216R-GT100-R08	●	●
1.5	2.5	0.03	T216L-GT150	●	●	T216R-GT150	●	●
1.5	2.5	0.08	T216L-GT150-R08	●	●	T216R-GT150-R08	●	●
1.5	2.5	0.15	T216L-GT150-R15	●	●	T216R-GT150-R15	●	●
2.0	2.5	0.03	T216L-GT200	●	●	T216R-GT200	●	●
2.0	2.5	0.08	T216L-GT200-R08	●	●	T216R-GT200-R08	●	●
2.0	2.5	0.15	T216L-GT200-R15	●	●	T216R-GT200-R15	●	●
2.5	2.5	0.15	T216L-GT250-R15	●	●	T216R-GT250-R15	●	●



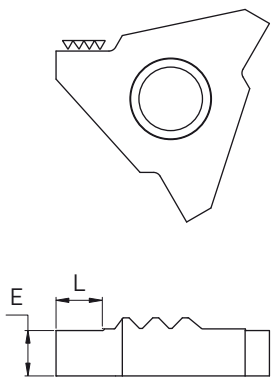
			L		R	
			P M N S		P M N S	
			HTA		HTA	
			HN (µk10)		HN (µk10)	
E	L	R	Art. N°		Art. N°	
1.0	2.5	0.03	T216L-GTX100		T216R-GTX100	
1.0	2.5	0.08	T216L-GTX100-R08		T216R-GTX100-R08	
1.5	2.5	0.03	T216L-GTX150		T216R-GTX150	
1.5	2.5	0.08	T216L-GTX150-R08		T216R-GTX150-R08	
1.5	2.5	0.15	T216L-GTX150-R15		T216R-GTX150-R15	
2.0	2.5	0.03	T216L-GTX200		T216R-GTX200	
2.0	2.5	0.08	T216L-GTX200-R08		T216R-GTX200-R08	
2.0	2.5	0.15	T216L-GTX200-R15		T216R-GTX200-R15	
2.5	2.5	0.15	T216L-GTX250-R15		T216R-GTX250-R15	

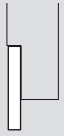
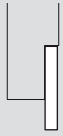
Plaquettes ébauches

WSP-Rohlinge

Blank inserts

EP

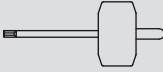


		L		R	
					
E	L	Art. N°	HTA PMNS HN (µk10)	Art. N°	HTA PMNS HN (µk10)
~3	3	T216L-EP	●	T216R-EP	●

Pièces de rechange et accessoires

Ersatzteile und Zubehör

Spare parts and accessories

Porte-outils Halter Holders		Options	
			
T216-H...	V-M4X9-T15	C-T15	SET-NM3.0-TX15

Recommandation de serrage

Drehmoment Empfehlung

Clamping recommendation

3.0 Nm

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