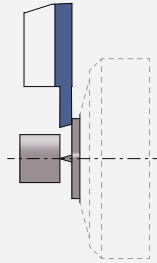
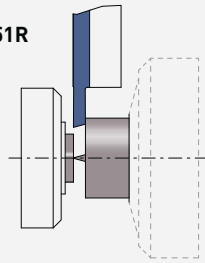




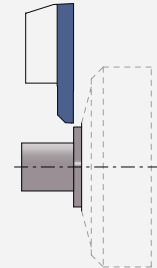
261



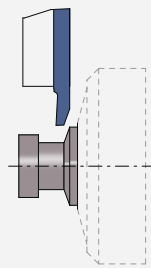
251R



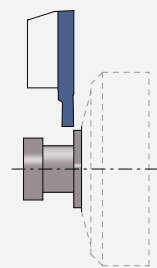
262



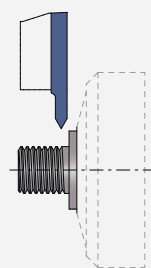
263



264



266



Index

Nuances
Sorten
Grades > 4.02

Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data	Accessoires Zubehör Accessories	> 4.03
--	---------------------------------------	--------

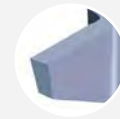
Porte-outils
Halter
Holders



> 4.04

Tronçonnage
Abstechen
Parting off

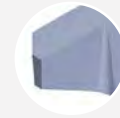
Type 251 / 261



> 4.08

Tournage avant
Vorwärts drehen
Front turning

Type 252 / 262



> 4.10

Tournage arrière
Rückwärts drehen
Back turning

Type 253 / 263



> 4.11

Fonçage-tournage
Einstechen und drehen
Grooving and turning

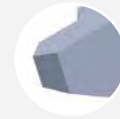
Type 254 / 264



> 4.14

Filetage
Gewinde drehen
Threading

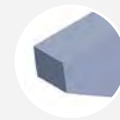
Type 256 / 266



> 4.16

Plaquettes ébauches
WSP-Rohlinge
Blank inserts

Type 251E / 261E



> 4.17

<h3>AP302</h3> <p>μK20 + revêtement PVD μK20 + PVD Beschichtung μK20 + PVD coating</p>	<h3>AP202</h3> <p>μK20 + revêtement PVD μK20 + PVD Beschichtung μK20 + PVD coating</p>	<h3>N (μK20)</h3> <p>non revêtu unbeschichtet uncoated</p>
<ul style="list-style-type: none"> excellente nuance universelle 1^{er} choix pour l'usinage des aciers, aciers inoxydables et alliages de titane très bonne résistance à la température 	<ul style="list-style-type: none"> nuance particulièrement adaptée aux faibles vitesses de coupe 	<ul style="list-style-type: none"> nuance micro-grain tenace supporte les coupes interrompues et autres conditions d'usinage défavorables
<ul style="list-style-type: none"> beste Universalsorte für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bestens geeignet sehr gute Warmfestigkeit 	<ul style="list-style-type: none"> besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten 	<ul style="list-style-type: none"> zähe Feinkornsorte für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen geeignet
<ul style="list-style-type: none"> best universal grade first choice for steel, stainless steel and titanium alloys machining very good heat resistance 	<ul style="list-style-type: none"> grade particularly suitable for low cutting speeds 	<ul style="list-style-type: none"> tough micro-grain grade suitable for interrupted cut and other unfavourable machining conditions

<h3>AH302</h3> <p>μK10 + revêtement PVD μK10 + PVD Beschichtung μK10 + PVD coating</p>	<h3>HN (μK10)</h3> <p>non revêtu unbeschichtet uncoated</p>
<ul style="list-style-type: none"> nuance très résistante à l'usure pour l'usinage en finition dans des conditions favorables des aciers, aciers inoxydables et alliages de titane 	<ul style="list-style-type: none"> 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
<ul style="list-style-type: none"> sehr verschleißfeste Sorte für die Feinbearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bei guten Bearbeitungsbedingungen 	<ul style="list-style-type: none"> verschleißfeste Feinkornsorte für die Bearbeitung von niedrig legiertem Titan empfehlenswert für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen nicht geeignet
<ul style="list-style-type: none"> very wear resistant grade for light machining of steel, stainless steel and titanium alloys under favourable machining conditions 	<ul style="list-style-type: none"> wear resistant micro-grain grade suitable for the machining of low alloyed titanium not suitable for interrupted cut and other unfavourable machining conditions



Patented rigid clamping system

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

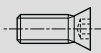

Standard machining data

Matière Werkstoff Material		Tournage Drehen Turning		Tronçonnage Abstechen Parting off	
		VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15
Acier Stahl Steel	P	< 600 N/mm ² 80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel	P	< 800 N/mm ² 60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel	P	> 800 N/mm ² 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

Accessoires

Zubehöre

Accessories

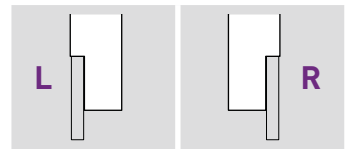
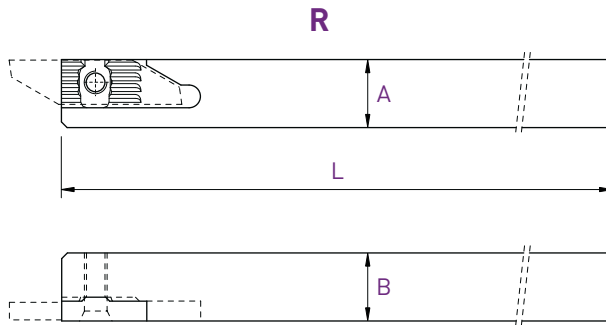
Porte-outils Halter Holders			Option Art. N°
250-8 / 260-8	V-M3.5X7.3-T15	C-T15	SET-NM-TX15
250-... / 260-...	V-M4X9-T15		
250RC / 260-C	V-M4X7.3-T15		

Recommandation de serrage
Drehmoment Empfehlung
Clamping recommendation

3.0 Nm



SET-NM-TX15



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

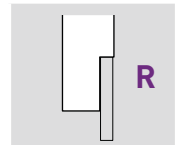
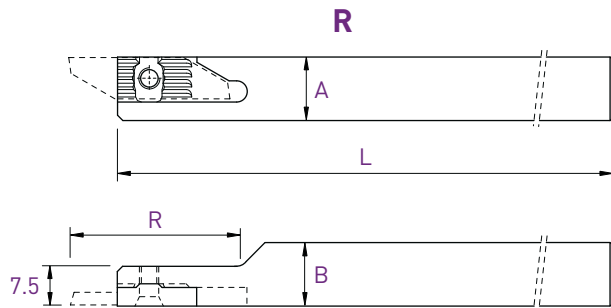
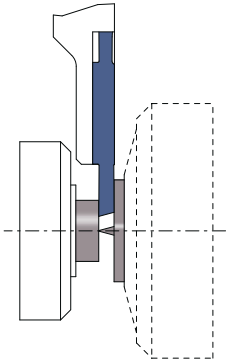
Chaque support est livré avec vis et clé.
 Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
 Screw(s) and key are included with each tool holder.

Porte-outils

Halter

Holders

260-C



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

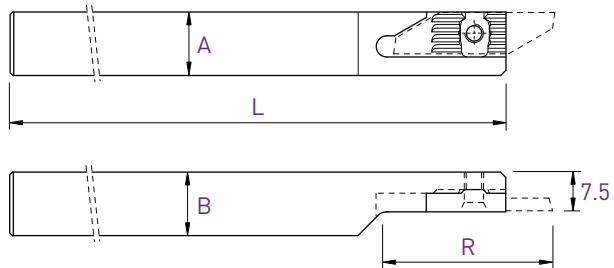
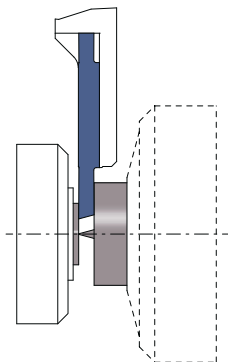
Porte-outils

Halter

Holders

Coupe à droite déportée
Versetzes Rechtsschneiden
Right cut off line

250RC



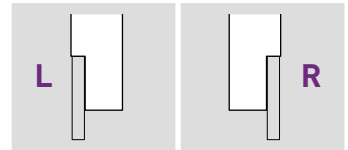
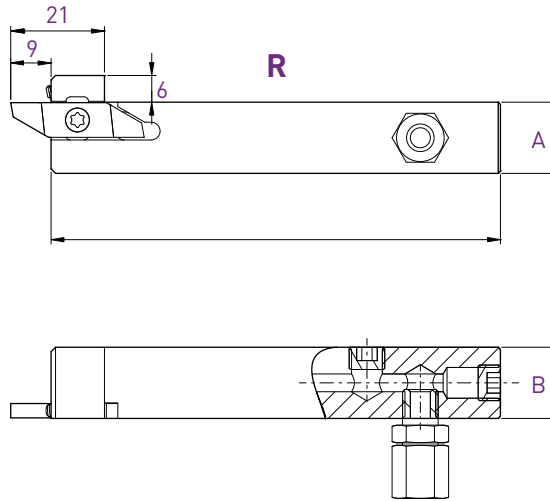
L (R)			Art. N°
A x B	L	R	
12 x 12	130	30	250RC-12
16 x 16	130	40	250RC-16

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




Chaque support est livré avec vis et clé.
Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
Screw(s) and key are included with each tool holder.

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

250-JET / 260-JET



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

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

Chaque support est livré avec vis et clé.
 Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
 Screw(s) and key are included with each tool holder.

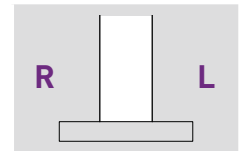
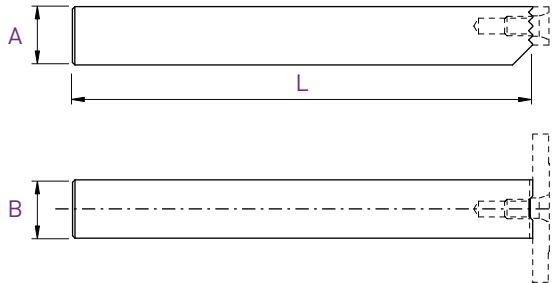
Porte-outils

Halter

Holder

260/250F

L/R



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

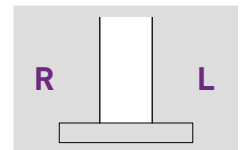
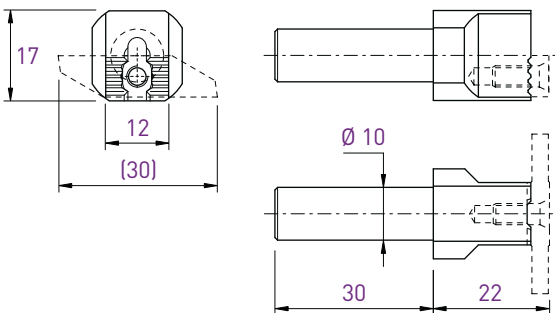
Porte-outils

Halter

Holder

260/250-D

L/R



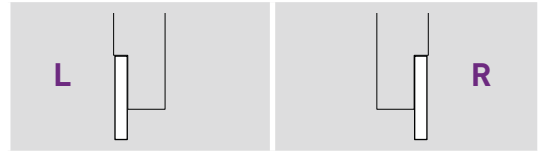
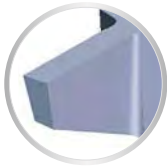
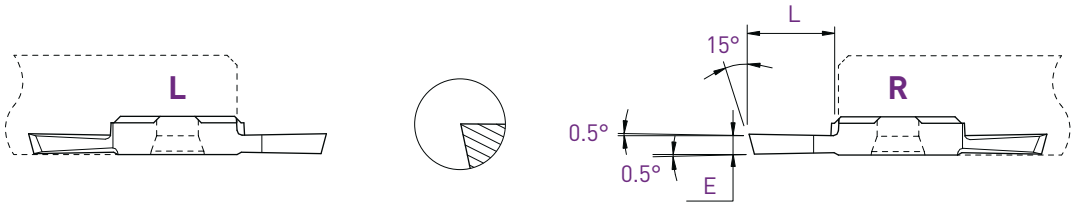
Art. N°
260/250-D10

Chaque support est livré avec vis et clé.
 Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
 Screw(s) and key are included with each tool holder.

ECO-LINE

Tronçonnage
Abstechen
Parting off

251 / 261

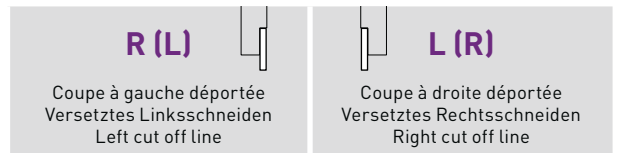
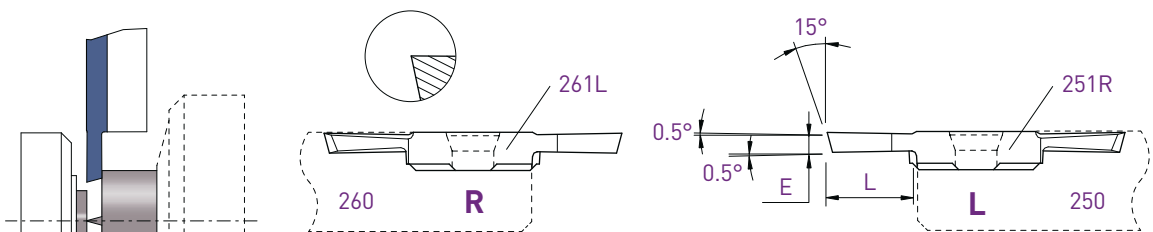


E	L	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
0.8	4	251-0.8	■	□	■	261-0.8	■	□	■
1.0	5	251-1.0	■	□	■	261-1.0	■	□	■
1.2	5	251-1.2	■	□	■	261-1.2	■	□	■
1.5	7	251-1.5	■	□	■	261-1.5	■	□	■
2.0	8.5	251-2.0	■	□	■	261-2.0	■	□	■
2.5	8.5	251-2.5	■	□	■	261-2.5	■	□	■

Tronçonnage
Abstechen
Parting off

Coupe déportée
Versetztes Schneiden
Cut off line

261L / 251R



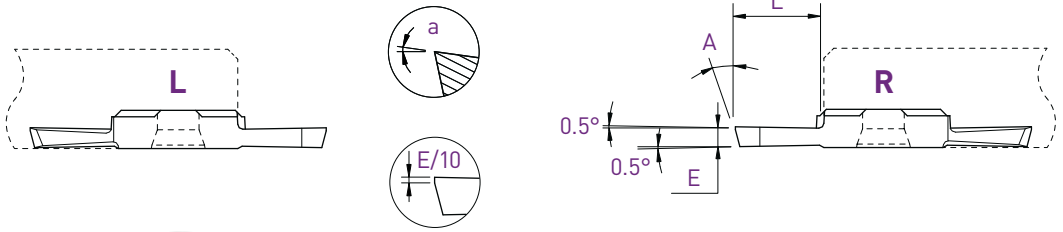
E	L	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
1.0	5	-				251R-1.0	■	□	■
1.5	7	-				251R-1.5	■	□	■
2.0	8.5	261L-2.0	■	□	■	251R-2.0	■	□	■

Tronçonnage

Abstechen

Parting off

251XF / 261XF



a	E	L	A	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
4°	1.0	4	15°	-				261XF-1.0	■	■	NEW
6°	1.0	4	8°	-				261XF6°-1.0-8°	■	■	NEW
4°	1.5	7	15°	251XF-1.5	■	□	■	261XF-1.5	■	□	■
4°	2.0	8.5	15°	251XF-2.0	■	□	■	261XF-2.0	■	□	■

Tronçonnage

Abstechen

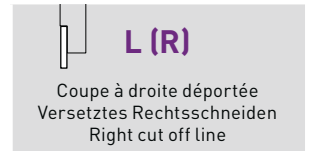
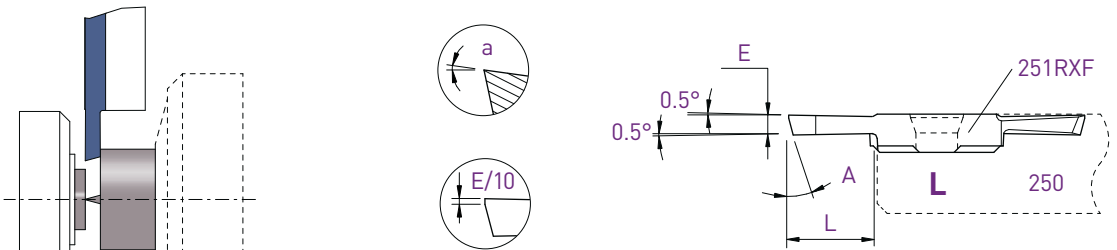
Parting off

Coupe déportée

Versetztes Schneiden

Cut off line

251RXF



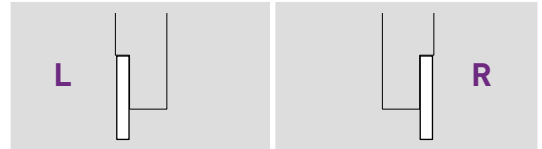
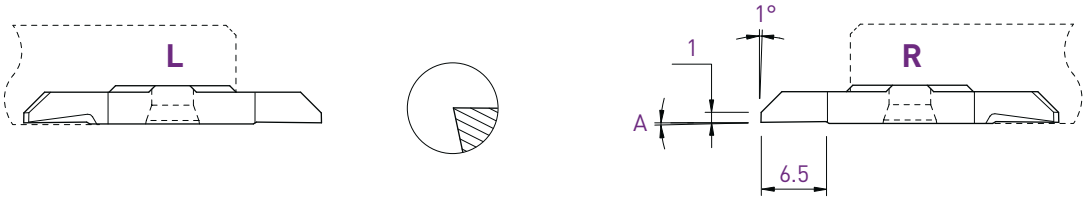
a	E	L	A	Art. N°	AP302	AP202	Z
6°	1.0	4	8°	251RXF6°-1.0-8°	■	■	NEW
4°	1.5	7	15°	251RXF-1.5	■	□	■
4°	2.0	8.5	15°	251RXF-2.0	■	□	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

ECO-LINE

Tournage avant
Vorwärts drehen
Front turning

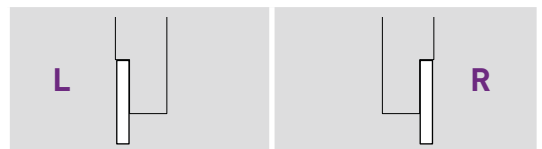
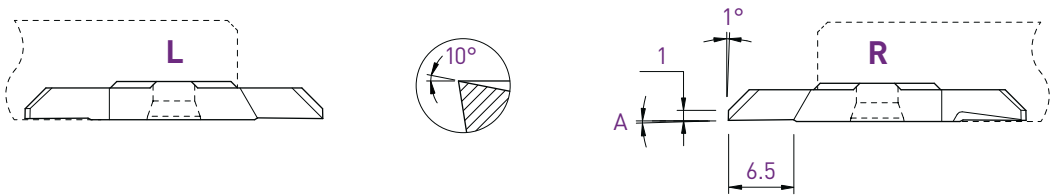
252 / 262



A	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
0°	252	■	□	■	262	■	□	■
2°	252-2°	■	□	■	262-2°	■	□	■

Tournage avant
Vorwärts drehen
Front turning

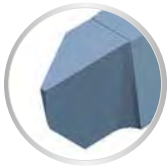
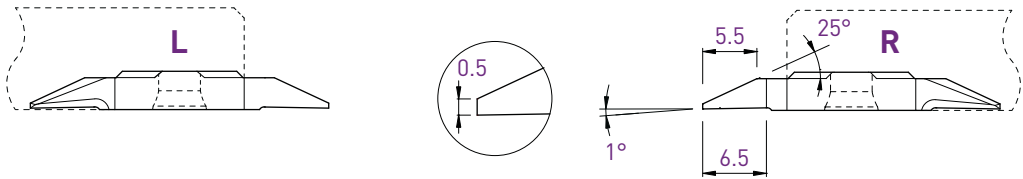
252X / 262X



A	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
0°	252X	■	□	■	262X	■	□	■
2°	252X-2°	■	□	■	262X-2°	■	□	■

Tournage avant
Vorwärts drehen
Front turning

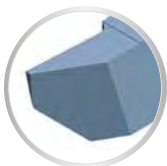
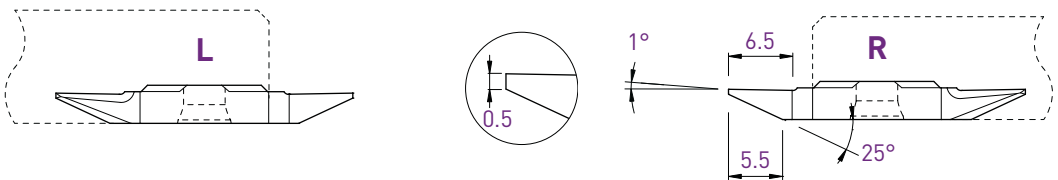
252S / 262S



L				R			
Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
252S05	■	□	■	262S05	■	□	■

Tournage arrière
Rückwärts drehen
Back turning

253S / 263S

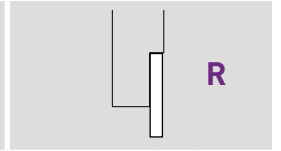
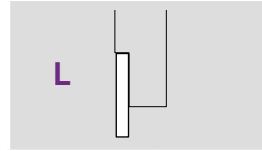
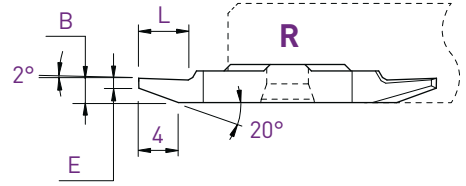
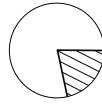
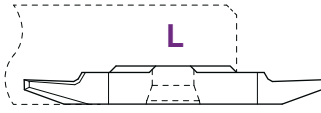


L				R			
Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
253S05	■	□	■	263S05	■	□	■

ECO-LINE

Tournage arrière
Rückwärts drehen
Back turning

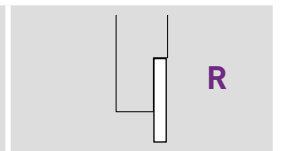
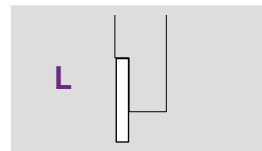
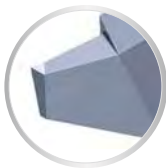
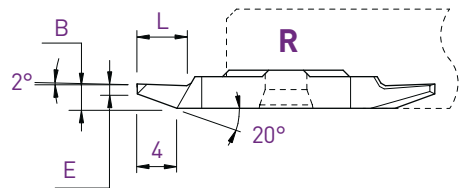
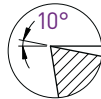
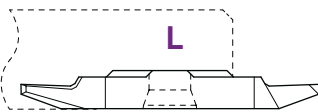
253 / 263



B	E	L	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
2.0	0.5	4	253-0.5	■	□	■	263-0.5	■	□	■
2.5	1.0	5	253-1.0	■	□	■	263-1.0	■	□	■

Tournage arrière
Rückwärts drehen
Back turning

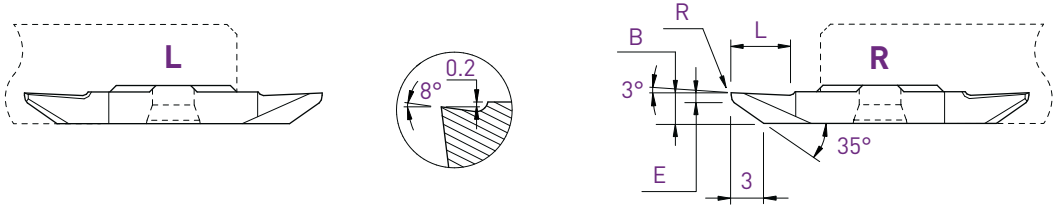
253X / 263X



B	E	L	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
2.0	0.5	5	253X-0.5	■	□	■	263X-0.5	■	□	■
2.5	1.0	5	253X-1.0	■	□	■	263X-1.0	■	□	■

Tournage arrière
Rückwärts drehen
Back turning

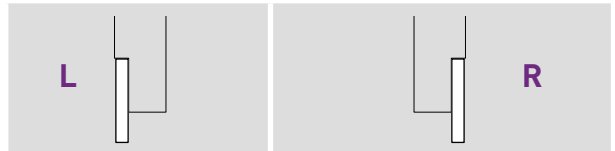
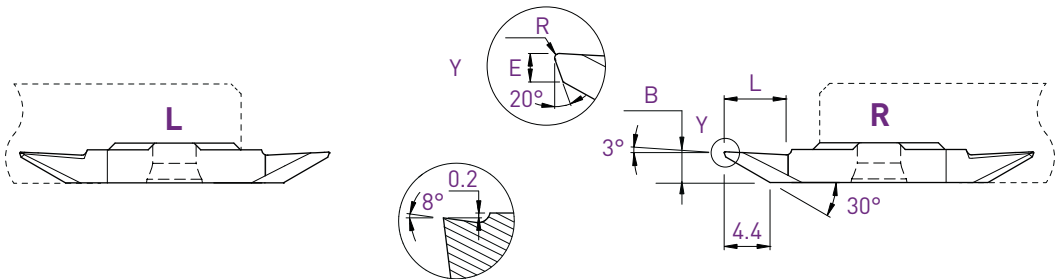
253VX-8° / 263VX-8°



B	E	L	R	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z	AH302	HN
3.1	1.0	6	0	253VX-8°	■	□	■	263VX-8°	■	□	■		
3.1	1.0	6	0.08	-				263VX-8°-R08	■	□	■	■	■
3.1	1.0	6	0.20	-				263VX-8°-R20	■	□	■	■	■

Tournage arrière
Rückwärts drehen
Back turning

253VX-805 / 263VX-805



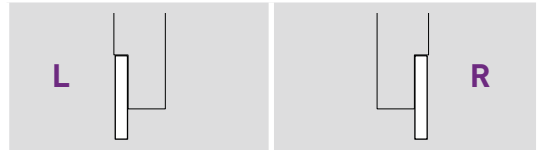
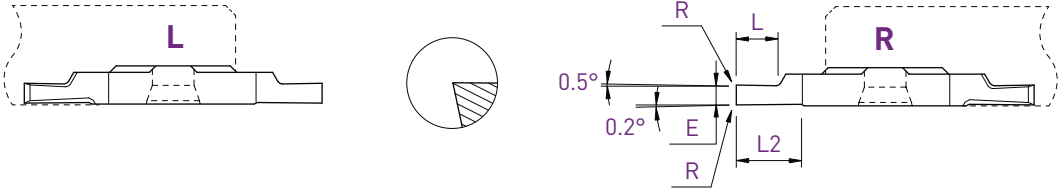
B	E	L	R	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z	AH302	HN
3.0	0.5	6	0.08	253VX-805-R08	■	□	■	263VX-805-R08	■	□	■	■	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

ECO-LINE

Fonçage-tournage
 Einstechen und drehen
 Grooving and turning

254 / 264



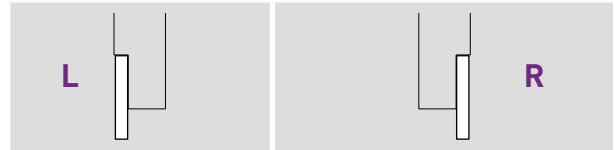
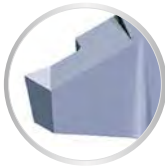
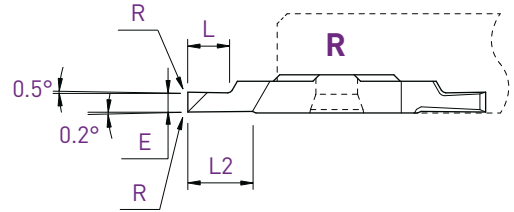
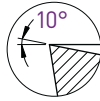
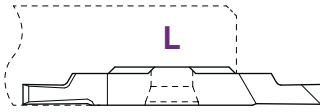
E	L	L2	R	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
0.8	2	4	0	254-0.8	■	□	■	264-0.8	■	□	■
1.0	2.5	4	0	254-1.0	■	□	■	264-1.0	■	□	■
1.2	3	4	0	254-1.2	■	□	■	264-1.2	■	□	■
1.5	3	4	0	254-1.5	■	□	■	264-1.5	■	□	■
1.8	4	6.5	0	-				264-1.8	■	□	■
2.0	4	6.5	0	254-2.0	■	□	■	264-2.0	■	□	■
2.5	6	6.5	0	254-2.5	■	□	■	264-2.5	■	□	■
3.0	6.5	6.5	0	254-3.0	■	□	■	264-3.0	■	□	■

Fonçage-tournage

Einstecken und drehen

Grooving and turning

254X / 264X

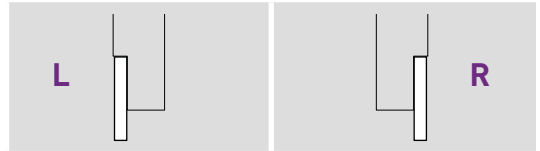
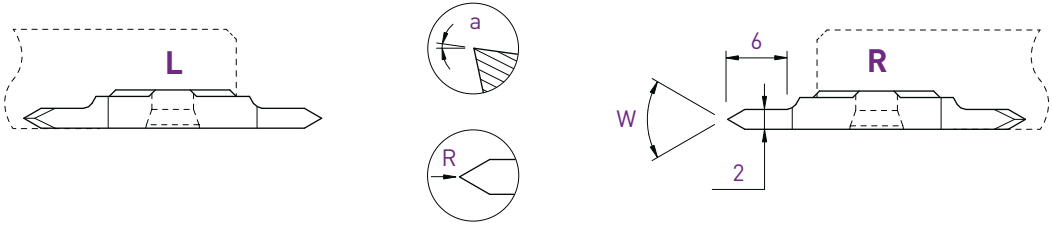


E	L	L2	R	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z	AH302	HN
0.8	2	4	0	254X-0.8	■	□	■	264X-0.8	■	□	■		
1.0	2.5	4	0	254X-1.0	■	□	■	264X-1.0	■	□	■		
1.0	2.5	4	0.08	-				264X-1.0-R08	■	□	■	■	■
1.2	3	4	0	254X-1.2	■	□	■	264X-1.2	■	□	■		
1.5	3	4	0	254X-1.5	■	□	■	264X-1.5	■	□	■		
1.5	3	4	0.08	-				264X-1.5-R08	■	□	■	■	■
1.5	3	4	0.20	-				264X-1.5-R20	■	□	■	■	■
2.0	4	6.5	0	254X-2.0	■	□	■	264X-2.0	■	□	■		
2.0	4	6.5	0.08	-				264X-2.0-R08	■	□	■	■	■
2.0	4	6.5	0.20	-				264X-2.0-R20	■	□	■	■	■
2.5	6	6.5	0	254X-2.5	■	□	■	264X-2.5	■	□	■		
2.5	6.5	6.5	0.08	-				264X-2.5-R08	■	□	■	■	■
2.5	6.5	6.5	0.20	-				264X-2.5-R20	■	□	■	■	■
3.0	6.5	6.5	0	254X-3.0	■	□	■	264X-3.0	■	□	■		
3.0	6.5	6.5	0.08	-				264X-3.0-R08	■	□	■	■	■
3.0	6.5	6.5	0.20	-				264X-3.0-R20	■	□	■	■	■

Filetage
Gewinde drehen
Threading

Partial profile 60°

256-60 / 266-60

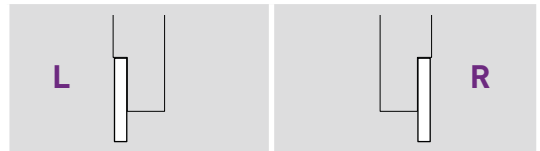
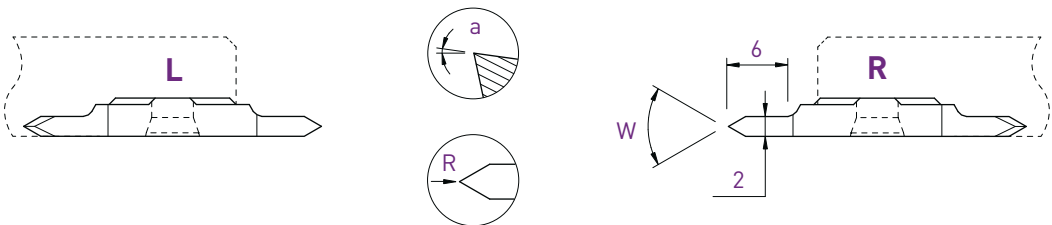


W	R	a	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
60°	0	0°	256-60-2.0	■	□	■	266-60-2.0	■	□	■
60°	0.06	3°	256-AG60°	■	□	■	266-AG60°	■	□	■

Filetage
Gewinde drehen
Threading

Partial profile 55°

256-55 / 266-55



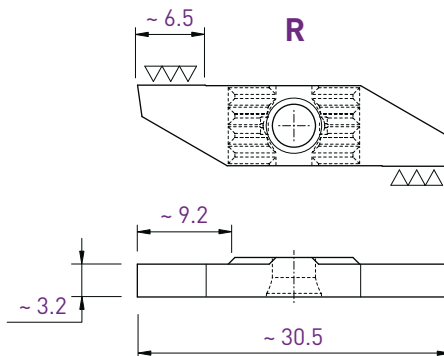
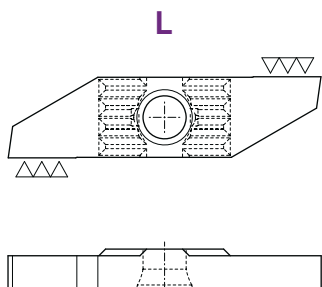
W	R	a	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
55°	0	0°	256-55-2.0	■	□	■	266-55-2.0	■	□	■
55°	0.06	3°	256-AG55°	■	□	■	266-AG55°	■	□	■

Plaquettes ébauches

WSP-Rohlinge

Blank inserts

251-E / 261-E



L					R						
Art. N°	AP302	AP202	N	AH302	HN	Art. N°	AP302	AP202	N	AH302	HN
251-E	■	□	■	■	■	261-E	■	□	■	■	■