

APPLITEC

ECO-Line



Applitec Moutier S.A.
Ch. Nicolas-Junker 2
CH-2740 Moutier

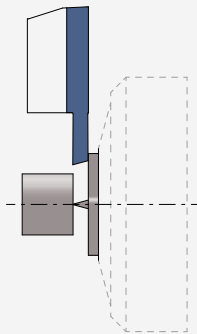


APPLITEC
SWISS TOOLING

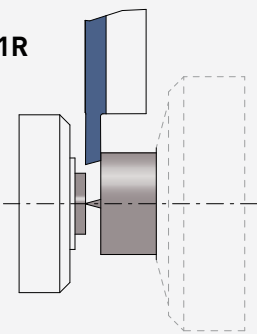
Tél. +41 32 494 60 20
Fax +41 32 493 42 60
www.applitec-tools.com



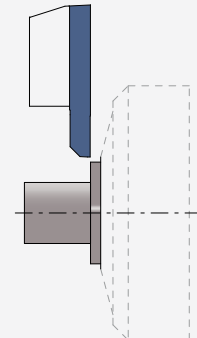
261



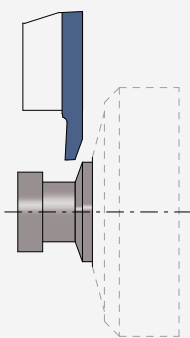
251R



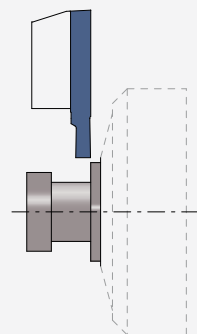
262



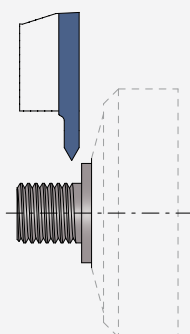
263



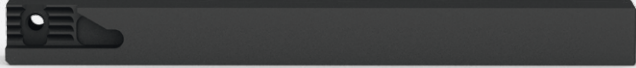
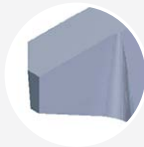
264



266



Index

Nuances Sorten Grades		> 2
Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data	Accessoires Zubehör Accessories	> 3
Porte-outils Halter Holders	 Type 250 / 260 / JET	> 4
Tronçonnage Abstechen Cut off	Type 251 / 261	 > 8
Tourneur avant Vorwärts drehen Front turning	Type 252 / 262	 > 10
Tourneur arrière Rückwärts drehen Back turning	Type 253 / 263	 > 11
Foncer-tourner Einstechen und drehen Grooving and turning	Type 254 / 264	 > 14
Fileter Gewinde drehen Threading	Type 256 / 266	 > 16
Ebauche Rohling Blank	Type 251E / 261E	 > 17

NEW

AP302

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

AP202

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

- nuance particulièrement adaptée aux faibles vitesses de coupe

- besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten

- grade particularly suitable for low cutting speeds

N (μK20)

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 geeignet

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

NEW

AH302

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

- 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

NEW

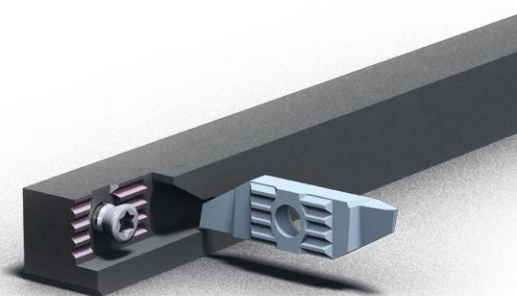
HN (μK10)

non revêtu
unbeschichtet
uncoated

- 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
- empfehlenswert für die Bearbeitung von niedrig legiertem Titan
- 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



Patented rigid clamping system

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

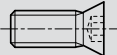
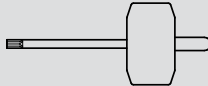
Standard machining data

Matière Werkstoff Material	Tournage Drehen Turning		Tronçonnage Abstechen Cut off	
	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15
Acier Stahl Steel < 600 N/mm ²	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel < 800 N/mm ²	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel < 800 N/mm ²	50 - 100	0.01 - 0.12	40 - 80	0.01 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.08
Aluminium	180 - 800	0.01 - 0.30	150 - 300	0.01 - 0.20
Titane Titan Titanium	30 - 70	0.01 - 0.12	30 - 50	0.01 - 0.06
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	100 - 500	0.01 - 0.30	100 - 300	0.01 - 0.20

Accessoires

Zubehör

Accessories

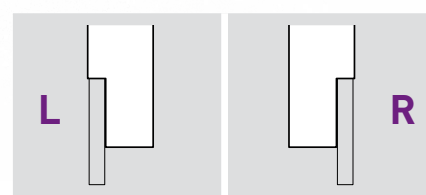
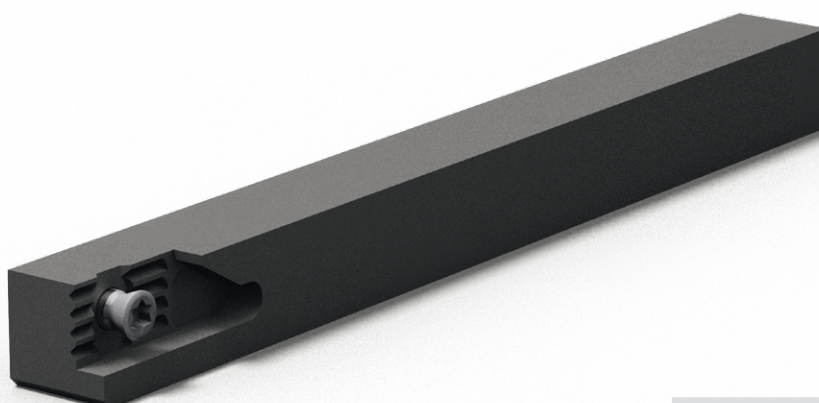
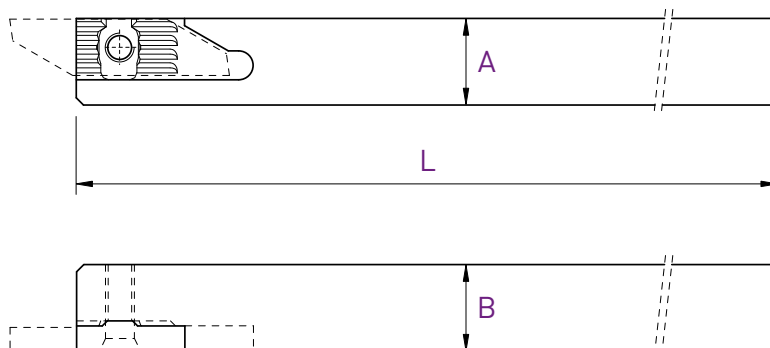
Porte-outils Halter Holders			Option
250-... / 260-...	V-M4X9-T15	C-T15	SET-NM-TX15
250-8 / 260-8	V-M3.5X7-T15		
250RC / 260-C	V-M4X7.3-T15		

Recommandation de serrage
Drehmoment Empfehlung
Clamping recommendation

3.0 Nm



SET-NM-TX15



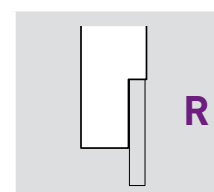
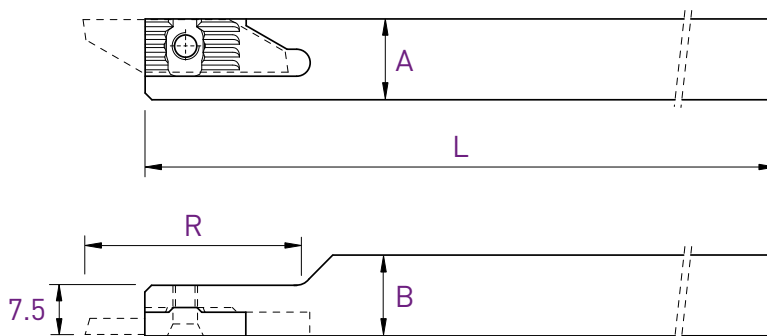
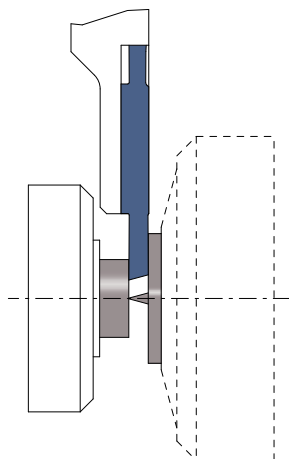
A x B	L	Art. N°	Art. N°
8 x 8	115	250-8	260-8
10 x 10	115	250-10	260-10
12 x 12	130	250-12	260-12
12 x 12	90	250-12-90	260-12-90
12.7 x 12.7	130	250-12.7	260-12.7
16 x 16	130	250-16	260-16
16 x 16	75	250-16-75	260-16-75
20 x 20	120	250-20	260-20

Porte-outils

Halter

Holders

260-C



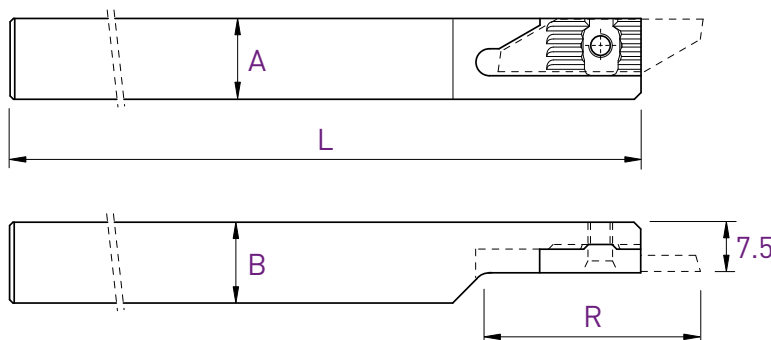
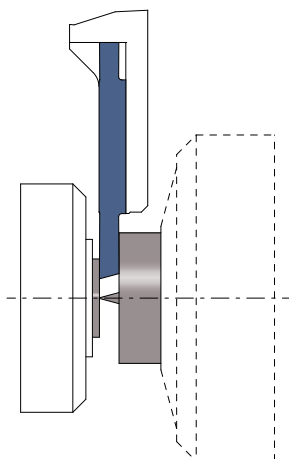
A x B	L	R	Art. N°
12 x 12	130	30	260-C-12

Porte-outils

Halter

Holders

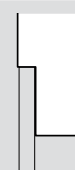
250RC



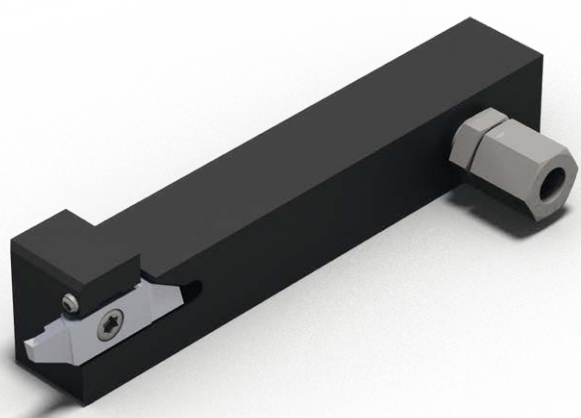
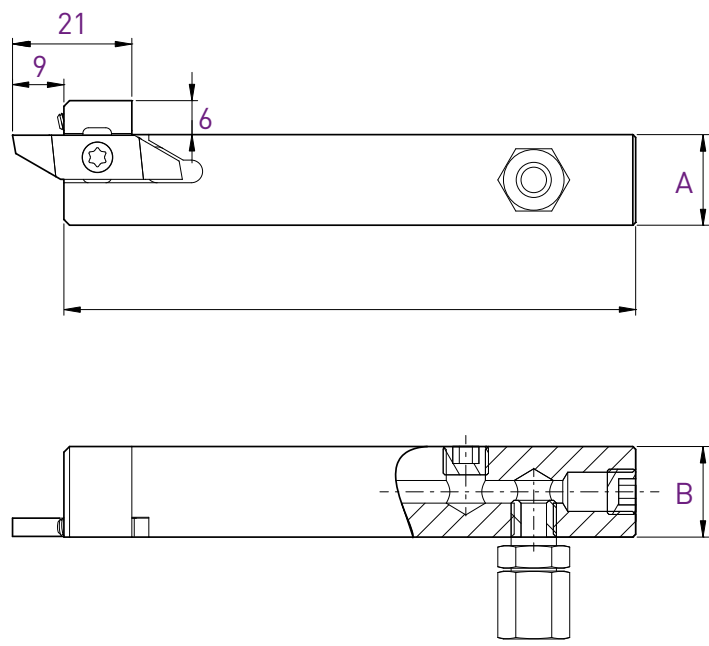
utiliser des plaquettes type 251R
WSP Typ 251R verwenden
use inserts type 251R

L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line



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



		L R	
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

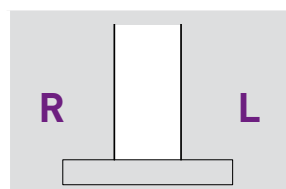
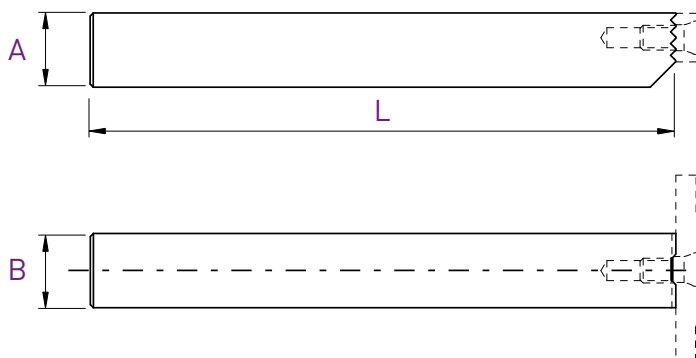
Pièces de rechange Ersatzteile Spare parts		
	Art. N°	Art. N°
250-JET/260-JET	J-M8X1-D6	JB-M8X1

Porte-outils

Halter

Holders

260/250F



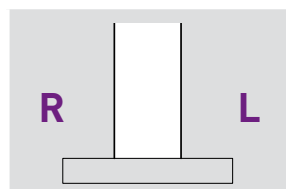
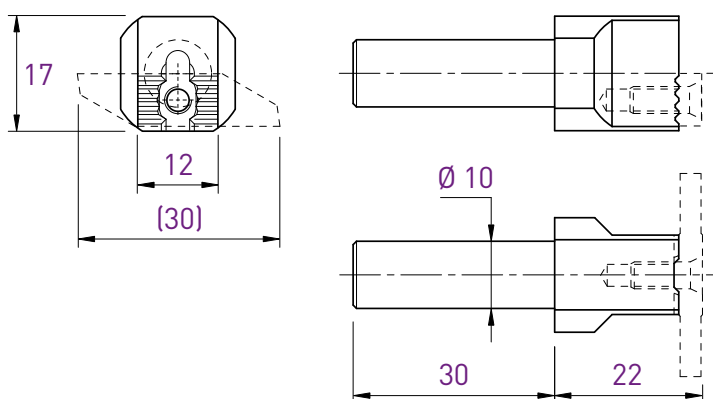
A x B	L	Art. N°
10 x 12	120	260/250F-1012
12 x 12	120	260/250F-1212

Porte-outils

Halter

Holders

260/250-D



Art. N°
260/250-D10

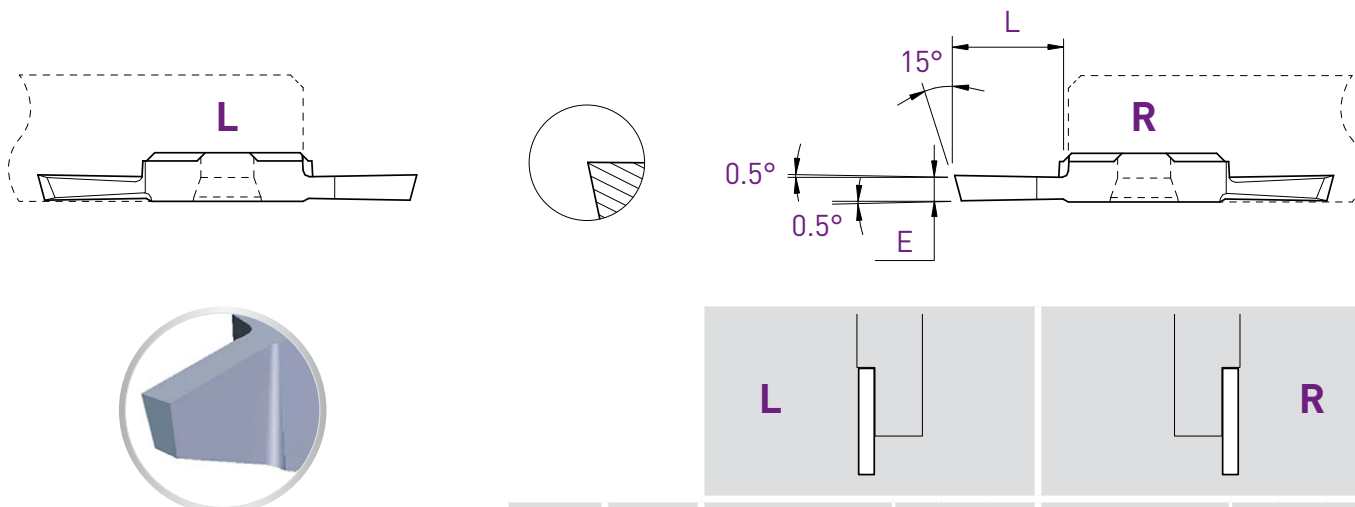
ECO-Line

Tronçonnage

Abstechen

Cut off

251 / 261



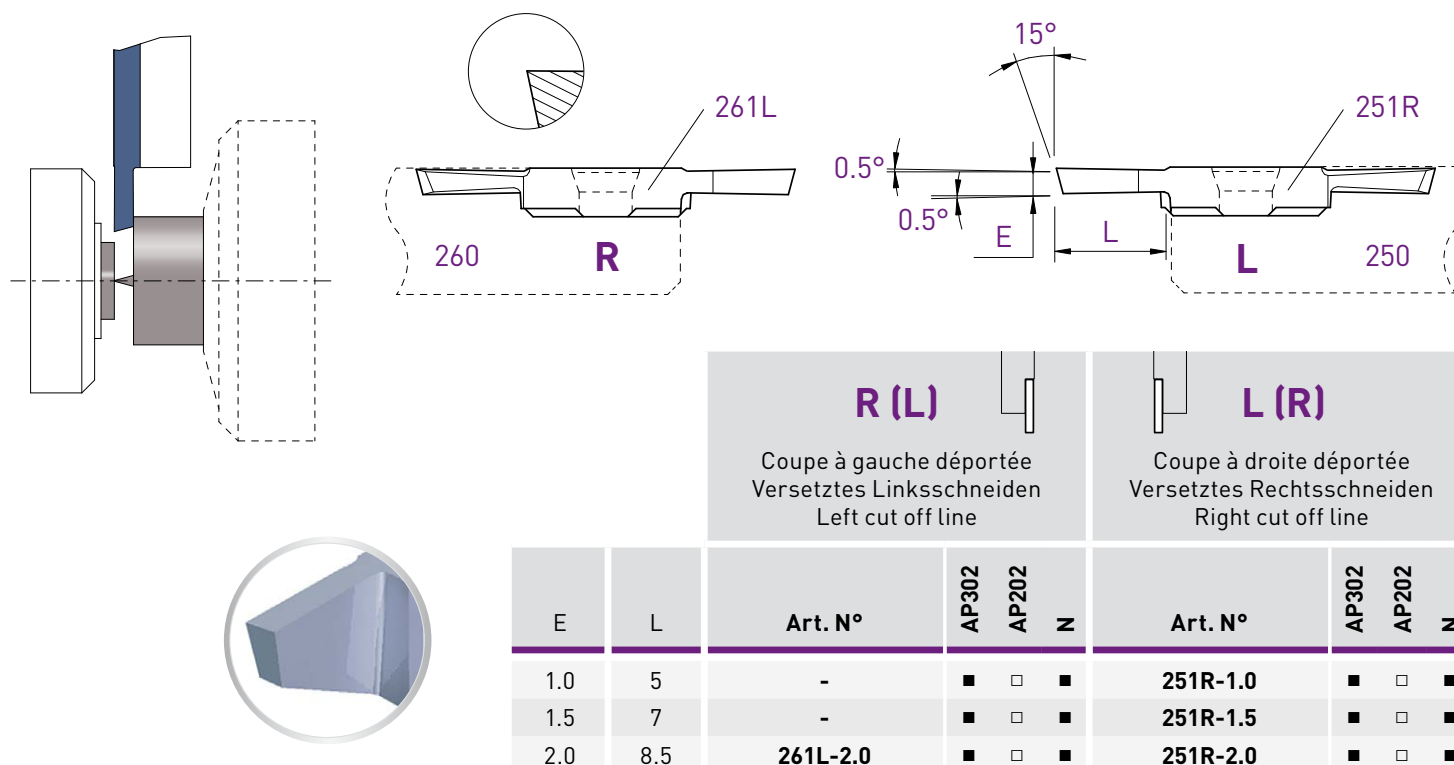
		L			R		
E	L	Art. N°	AP302	AP202	Art. N°	AP302	AP202
0.8	4	251-0.8	■	□	261-0.8	■	□
1.0	5	251-1.0	■	□	261-1.0	■	□
1.2	5	251-1.2	■	□	261-1.2	■	□
1.5	7	251-1.5	■	□	261-1.5	■	□
2.0	8.5	251-2.0	■	□	261-2.0	■	□
2.5	8.5	251-2.5	■	□	261-2.5	■	□

Coupe déportée

Versetztes Schneiden

Cut off line

261L / 251R



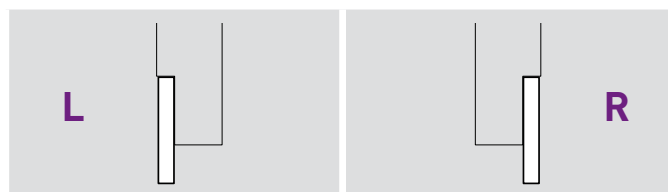
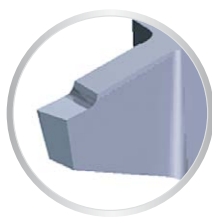
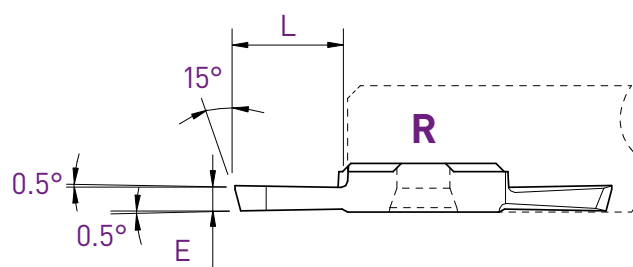
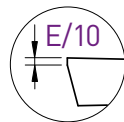
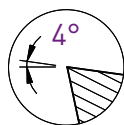
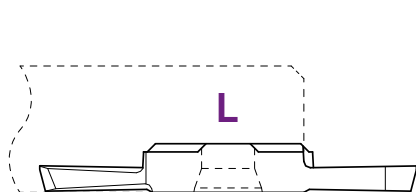
		R (L)			L (R)		
E	L	Art. N°	AP302	AP202	Art. N°	AP302	AP202
1.0	5	-	■	□	251R-1.0	■	□
1.5	7	-	■	□	251R-1.5	■	□
2.0	8.5	261L-2.0	■	□	251R-2.0	■	□

Tronçonnage

Abstechen

Cut off

251XF / 261XF



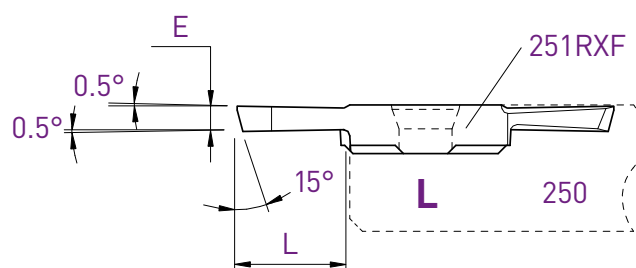
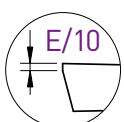
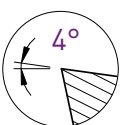
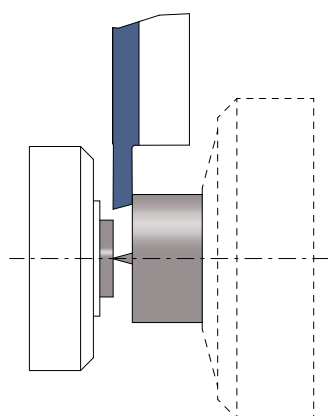
E	L	Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
1.5	7	251XF-1.5	■	□	■	261XF-1.5	■	□	■
2.0	8.5	251XF-2.0	■	□	■	261XF-2.0	■	□	■

Coupe déportée

Versetztes Schneiden

Cut off line

251RXF

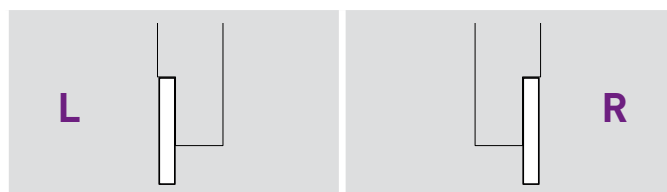
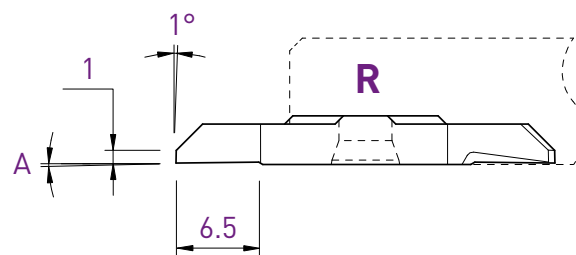
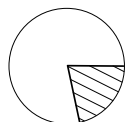
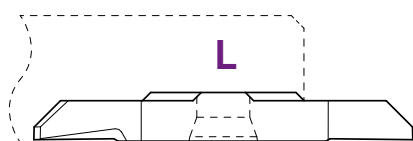


L (R)									
Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line									
E	L	Art. N°	AP302	AP202	z				
1.5	7	251RXF-1.5	■	□	■				
2.0	8.5	251RXF-2.0	■	□	■				

ECO-Line

Tourneur avant
Vorwärts drehen
Front turning

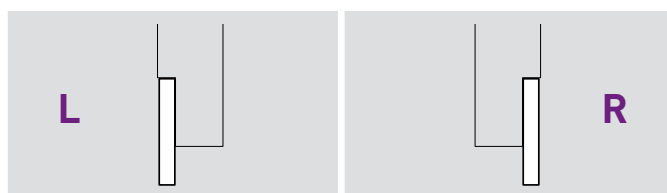
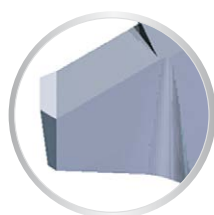
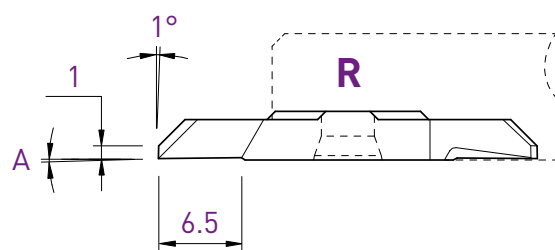
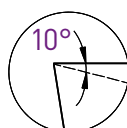
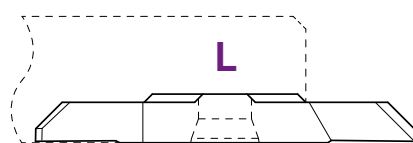
252 / 262



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

Tourneur avant
Vorwärts drehen
Front turning

252X / 262X

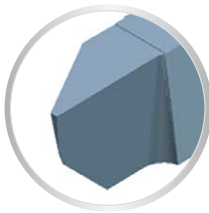
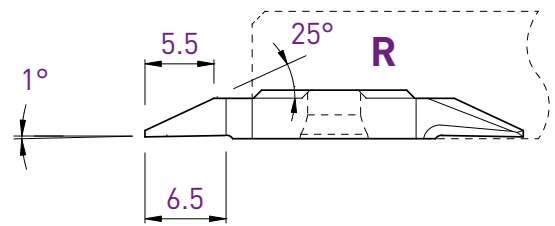
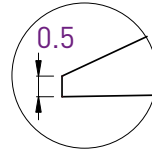
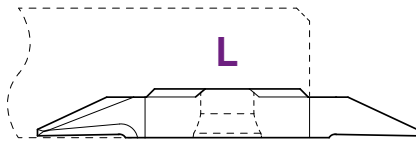


A	Art. N°	AP302 AP202 Z			Art. N°	AP302 AP202 Z		
		■	□	■		■	□	■
0°	252X	■	□	■	262X	■	□	■
2°	252X-2°	■	□	■	262X-2°	■	□	■

Tourneur avant
Vorwärts drehen
Front turning



252S / 262S

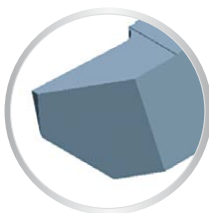
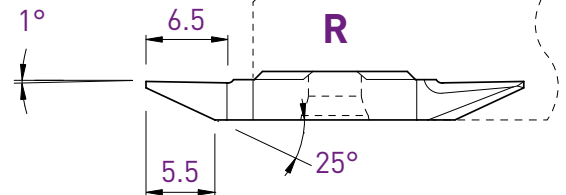
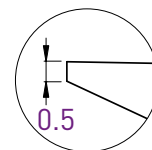
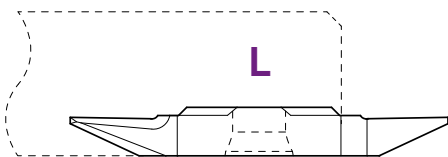


L				R			
Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
252S05	■	□	■	262S05	■	□	■

Tourneur arrière
Rückwärts drehen
Back turning



253S / 263S

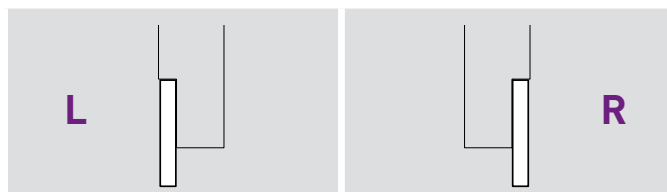
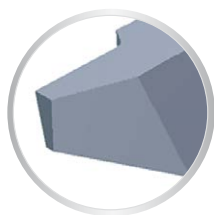
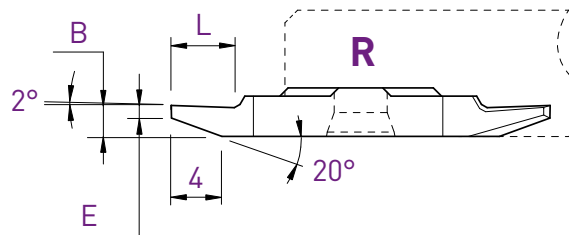
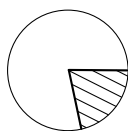
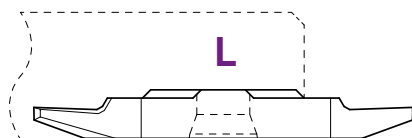


L				R			
Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
253S05	■	□	■	263S05	■	□	■

ECO-Line

Tourneur arrière
Rückwärts drehen
Back turning

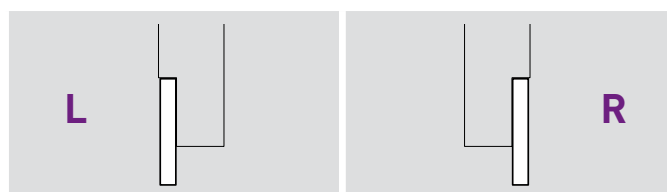
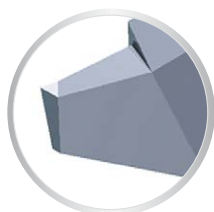
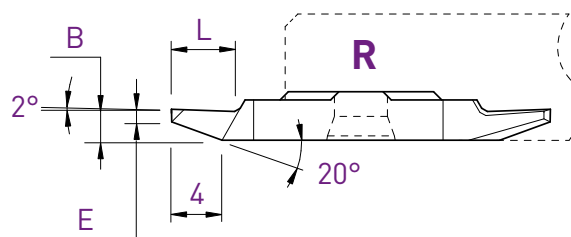
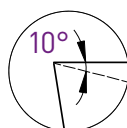
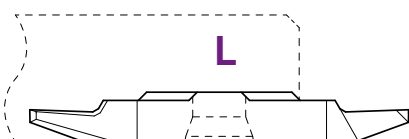
253 / 263



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	■	□	■

Tourneur arrière
Rückwärts drehen
Back turning

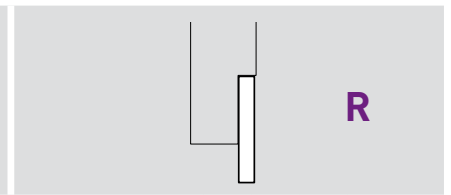
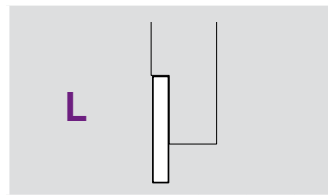
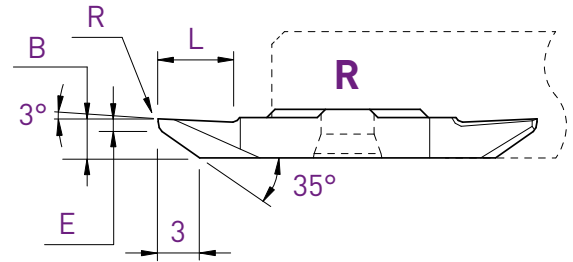
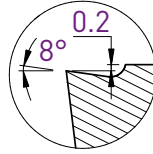
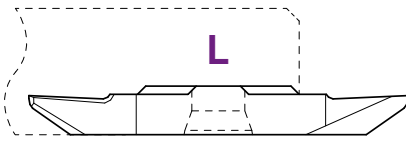
253X / 263X



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	■	□	■

Tourneur arrière
Rückwärts drehen
Back turning

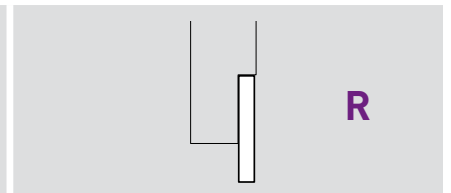
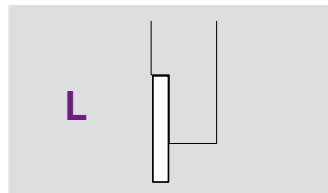
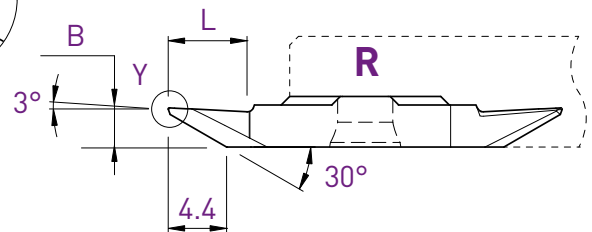
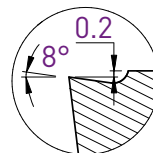
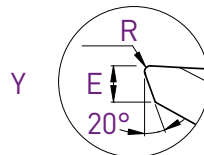
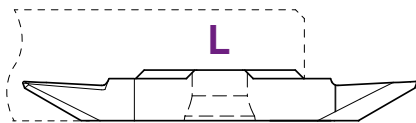
253VX-8° / 263VX-8°



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	0.2	-				263VX-8°-R20	■	□	■	■	■

Tourneur 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	■	□	■	■	■

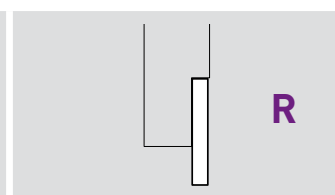
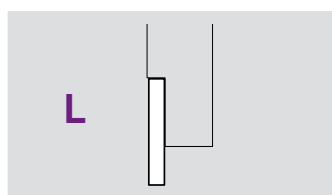
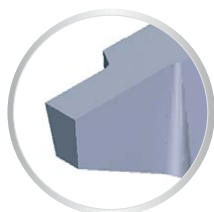
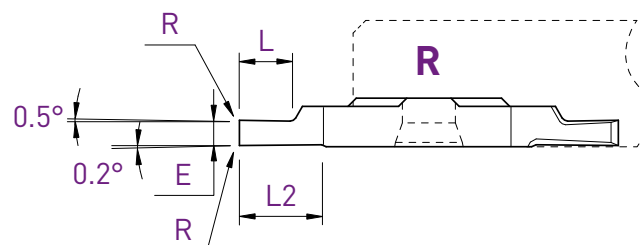
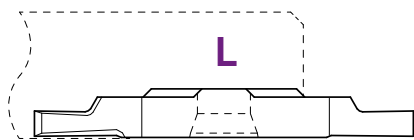
ECO-Line

Foncer-tourner

Einstecken und drehen

Grooving and turning

254 / 264



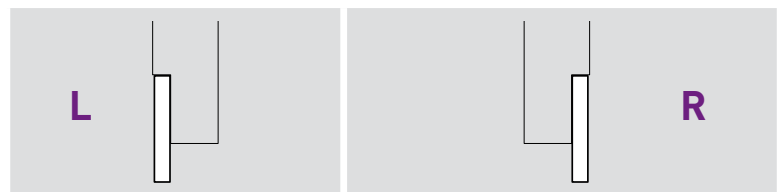
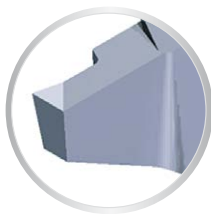
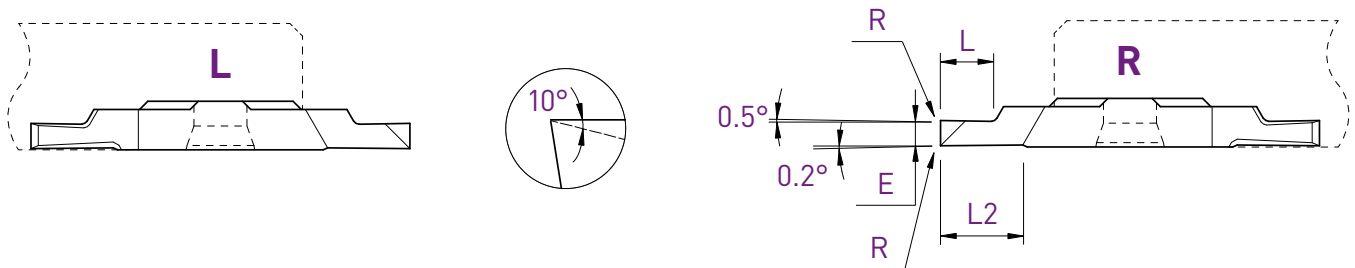
E	L	L2	R	Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
0.8	2	4	0	254-0.8	■	□	■	264-0.8	■	□	■
1.0	2.5	4	0	254-1.0	■	□	■	264-1.0	■	□	■
1.2	3	4	0	254-1.2	■	□	■	264-1.2	■	□	■
1.5	3	4	0	254-1.5	■	□	■	264-1.5	■	□	■
1.8	4	6.5	0	-				264-1.8	■	□	■
2.0	4	6.5	0	254-2.0	■	□	■	264-2.0	■	□	■
2.5	6	6.5	0	254-2.5	■	□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

Foncer-tourner

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	0.2	-				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	0.2	-				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	0.2	-				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	0.2	-				264X-3.0-R20	■	□	■	■	■

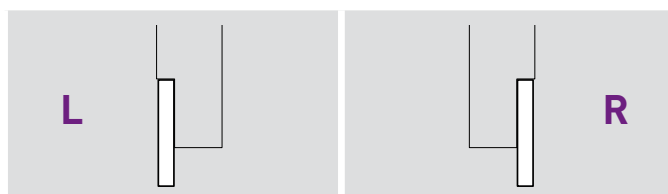
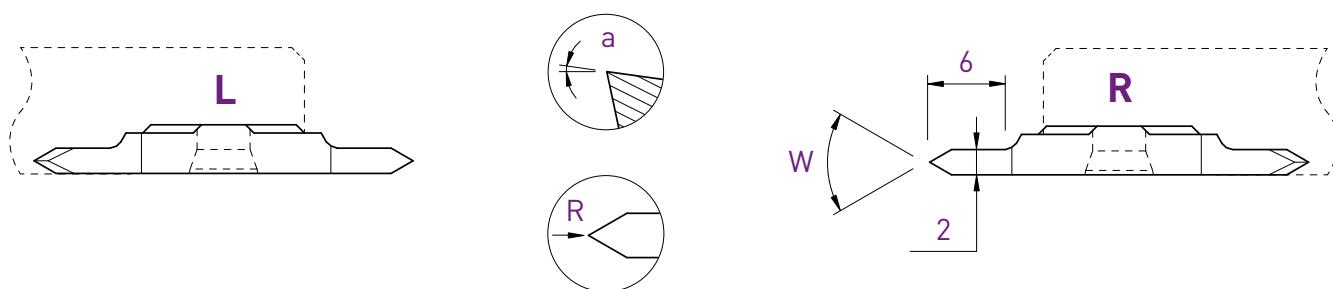
ECO-Line

Fileter

Gewinde drehen

Threading

Partial profil 60° – 256-60 / 266-60



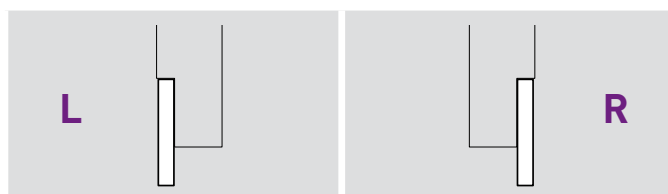
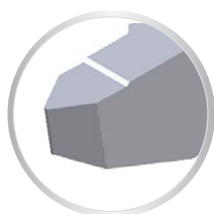
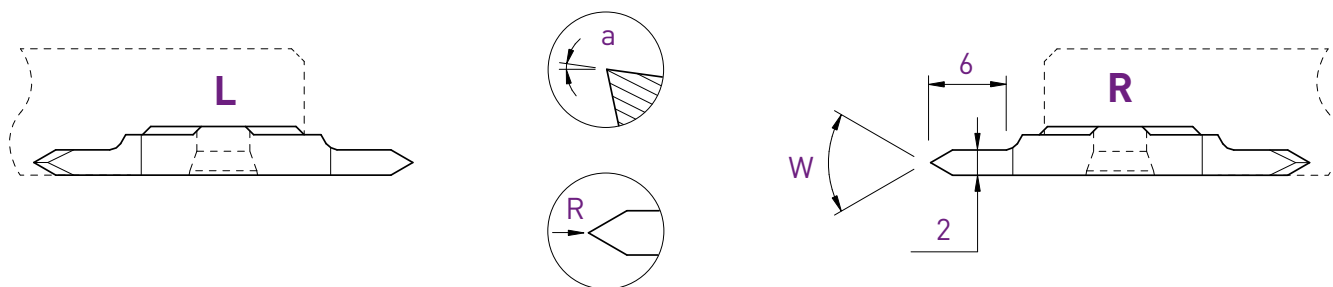
W	R	a	Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
60°	0	0°	256-60-2	■	□	■	266-60-2	■	□	■
60°	0.06	3°	256-AG60	■	□	■	266-AG60	■	□	■

Fileter

Gewinde drehen

Threading

Partial profil 55° – 256-55 / 266-55



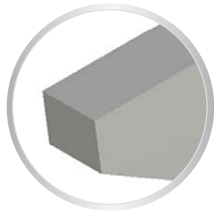
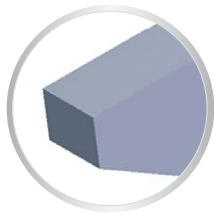
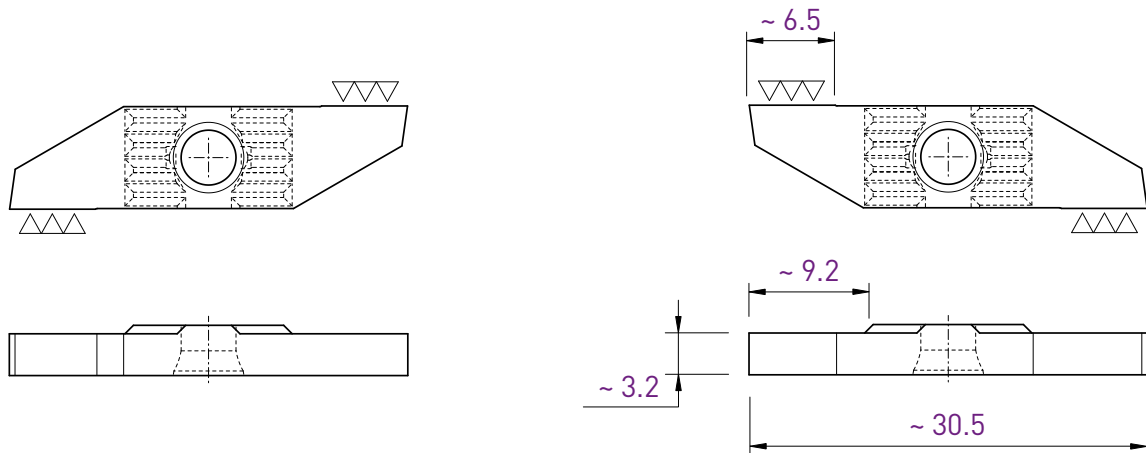
W	R	a	Art. N°	AP302	AP202	z	Art. N°	AP302	AP202	z
55°	0	0°	256-55-2	■	□	■	266-55-2	■	□	■
55°	0.06	3°	256-AG55	■	□	■	266-AG55	■	□	■

Ebauche

Rohling

Blank

251-E / 261-E



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

PERFORMANCE | PRECISION | RIGIDITY



SWISS MADE



APPLITEC
SWISS TOOLING

Applitec Moutier S.A.
Ch. Nicolas-Junker 2
CH-2740 Moutier

Tél. +41 32 494 60 20
Fax +41 32 493 42 60
www.applitec-tools.com