

PRO-Line

**BEST VALUE
HIGH PERFORMANCE
TOOLS**



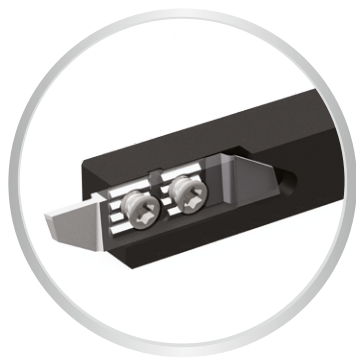
**PATENTED
CLAMPING
SYSTEM**

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

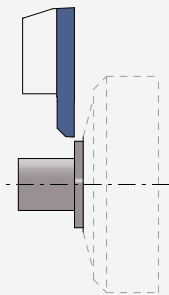


APPLITEC
SWISS TOOLING

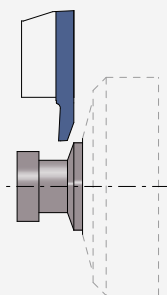
Tél. +41 32 494 60 20
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www.applitec-tools.com



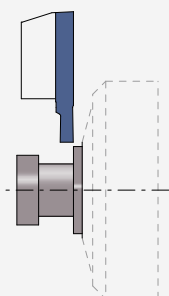
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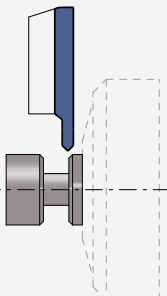
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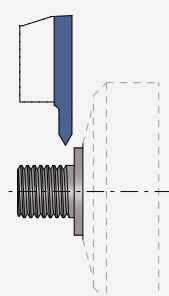
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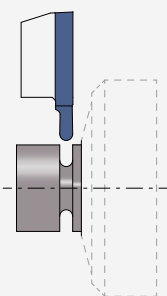
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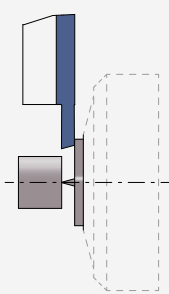
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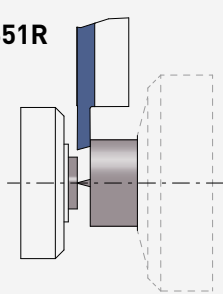
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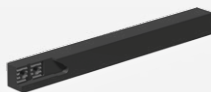


661



651R



INFO	Nuances Sorten Grades	Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data	> 2
SERIES 630 / 640 Tournage et gorges Drehen und Einstechen Turning and grooving	Porte-outils Halter Holders 	630 / 640	> 4
	Tourneur avant Vorwärts drehen Front turning 	632 / 642	> 6
	Tourneur arrière Rückwärts drehen Back turning 	633 / 643	> 8
	Foncer-tourner Einstechen und drehen Grooving and turning 	634 / 644	> 16
	Chamfreiner Anfasen Chamfering 	635 / 645	> 21
	Fileter Gewinde drehen Threading 	636 / 646	> 23
	Plaquettes à rayon Radius Wendeplatten Inserts with radius 	637 / 647	> 25
	Plaquette ébauche WSP-Rohling Blank insert 	631-EP / 641-EP	> 27
SERIES 650 / 660 Tronçonnage Abstechen Parting off	Porte-outils Halter Holders 	650 / 660	> 28
	Tronçonnage Abstechen Parting off 	651 / 661	> 31
	Tronçonnage - coupe déportée Abstechen - versetztes Schneiden Parting off - cut off line 	651R	> 36
	Plaquette ébauche WSP-Rohling Blank insert 	651-EP / 661-EP	> 39
	Pièces de rechange et accessoires Ersatzteile und Zubehör Spare parts and accessories		> 40

PRO-Line

Codification des plaquettes PRO-Line série 600

WSP-Bezeichnungssystem für PRO-Line 600 Serie

Inserts designation key for PRO-Line 600 series

INFO

6	4	4	X	-	2.0	-	R15	-	TiALN
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Dimension
Abmessung
Dimension

Rayon
Radius
Radius

Nuance
Sorte
Grade

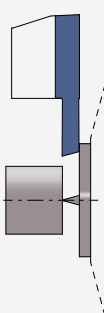
Géométrie de coupe
Schneidgeometrie
Cutting geometry

brise-copeaux
Spanbrecher
chip breaker

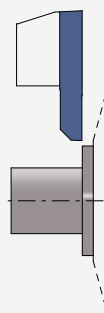
particularités
Sondereigenschaften
special features

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry

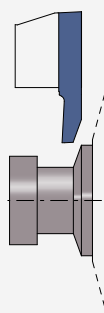
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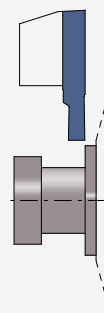
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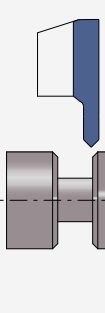
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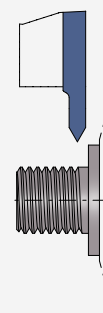
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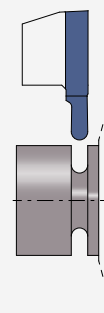
5



6



7



Gamme de produit
Produktserie
Product series

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

L = 3, 5

(chiffre impair / ungerade Zahl / uneven number)

R = 4, 6

(chiffre pair / gerade Zahl / even number)

SERIES

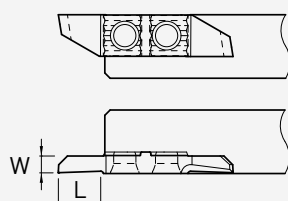
Tournage
et gorges

Drehen und
Einstechen
Turning and
grooving

W max = 3 mm
L max = 8 mm

L
630

R
640



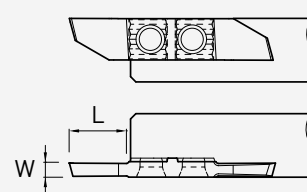
SERIES

Tronçonnage
Abstechen
Parting off

W max = 2.5 mm
L max = 11 mm

L
650

R
660



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

Nuances	Paramètres de coupe indicatifs
Sorten	Empfohlene Schnittwerte
Grades	Standard machining data

TiALN

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

N (μK20)

non revêtu
unbeschichtet
uncoated

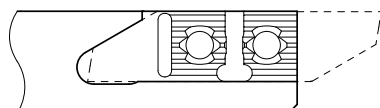
- nuance micro-grain tenace
- supporte les coupes interrompues et autres conditions d'usinage défavorables

- zähe Feinkornsorte
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen geeignet

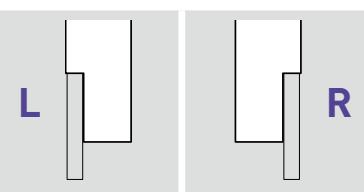
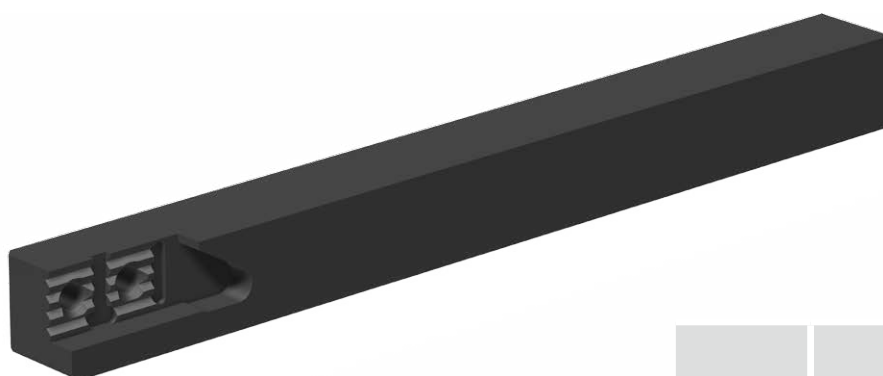
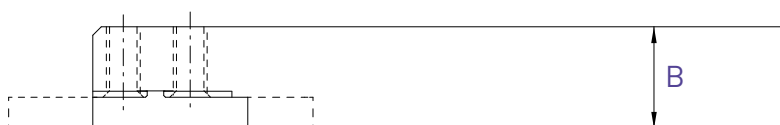
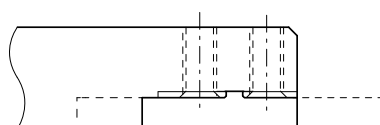
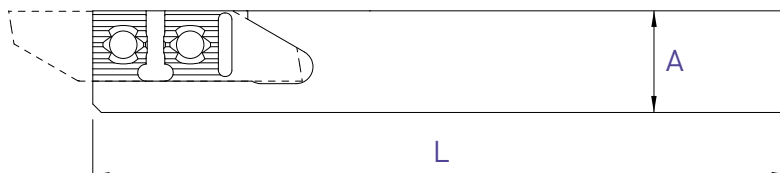
- tough micro-grain grade
- suitable for interrupted cut and other unfavourable machining conditions

Matière Werkstoff Material	Tournage Drehen Turning			Tronçonnage Abstechen Parting off		
	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	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	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	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	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	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%	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%	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
Titane Titan Titanium	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
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	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

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

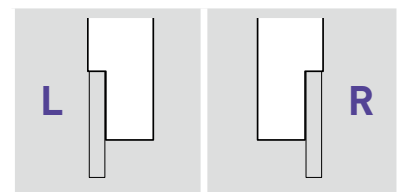
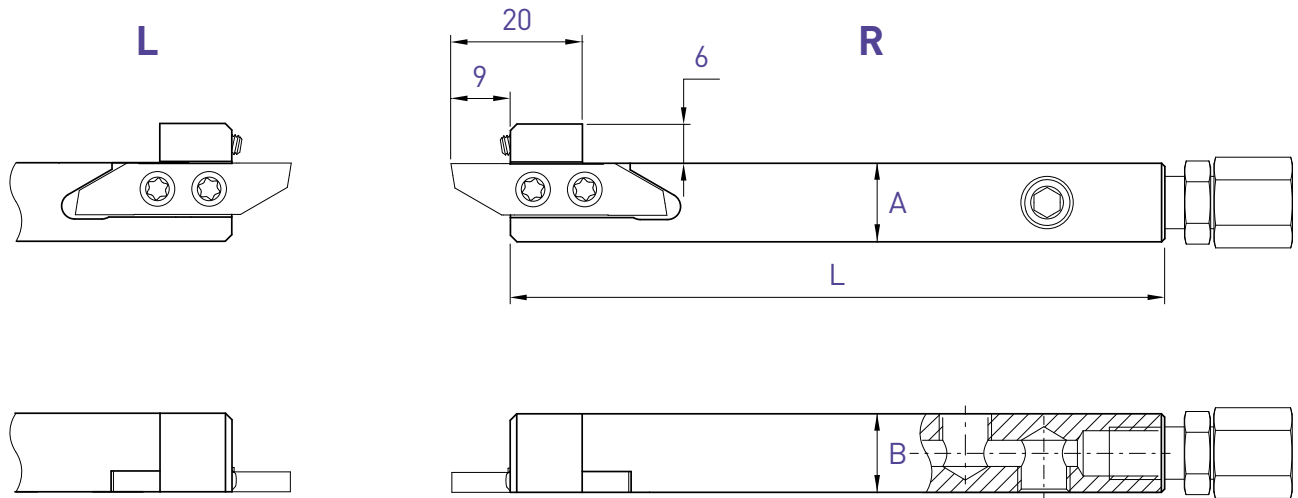
Chaque support est livré avec vis et clé.
Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
Screw(s) and key are included with each tool holder.

Porte-outils avec arrosage intégré

Halter mit integrierter Kühlmittelzufuhr

Holders with integrated coolant supply

630-JET / 640-JET



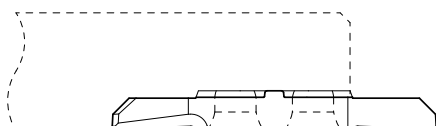
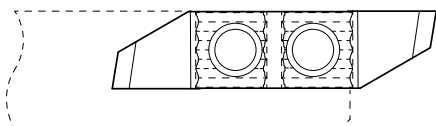
A x B	L	Art. N°	Art. N°
10 x 12	100	630-1012-JET	640-1012-JET
12 x 12	100	630-12-JET	640-12-JET
12.7 x 12.7	100	630-12.7-JET	640-12.7-JET
16 x 16	100	630-16-JET	640-16-JET
20 x 20	100	630-20-JET	640-20-JET

Chaque support est livré avec vis, clé, raccord droit et buse d'arrosage Ø 1.5 mm.

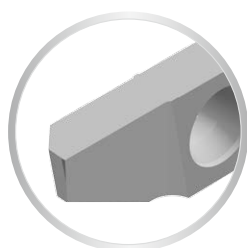
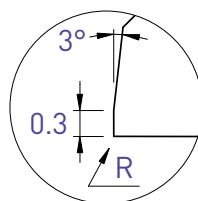
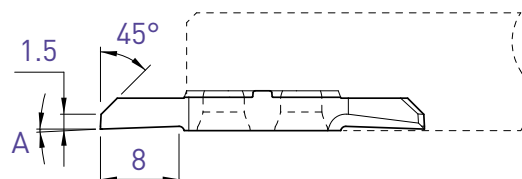
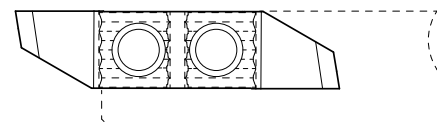
Jeder Halter wird mit Spannschraube(n), Schlüssel, gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert.

Screw(s), key, straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder.

L



R



L

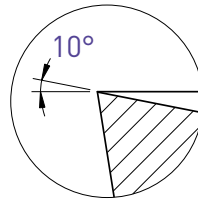
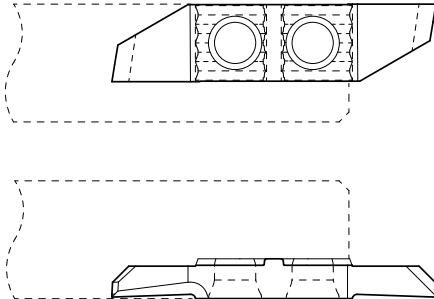
R

A	R	Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
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	■ ■

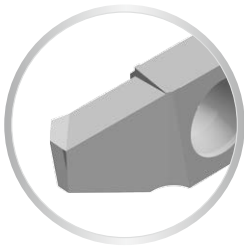
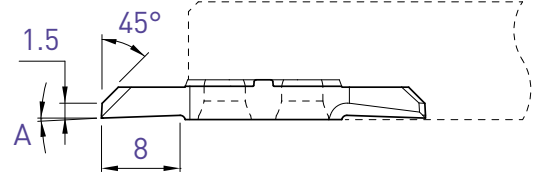
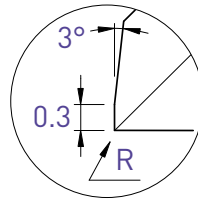
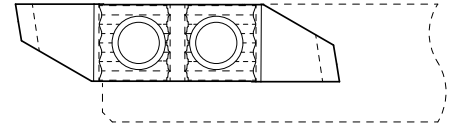
Tourneur avant
Vorwärts drehen
Front turning

632X / 642X

L



R

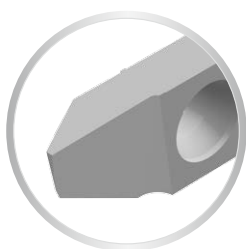
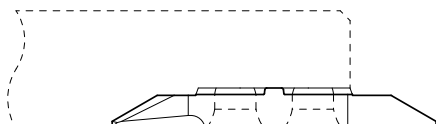
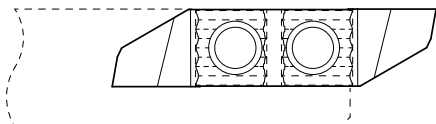


L

R

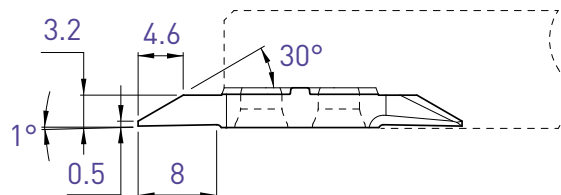
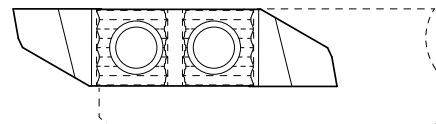
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0°	0	632X10	■ ■	642X10	■ ■
0°	0.08	-		642X10-R08	■ ■
0°	0.15	-		642X10-R15	■ ■
2°	0	632X10-2°	■ ■	642X10-2°	■ ■
2°	0.08	-		642X10-2°-R08	■ ■
2°	0.15	-		642X10-2°-R15	■ ■

L



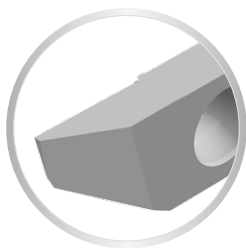
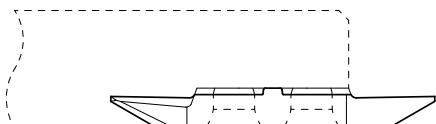
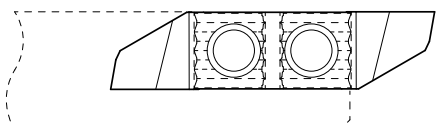
Tourneur avant
Vorwärts drehen
Front turning

R



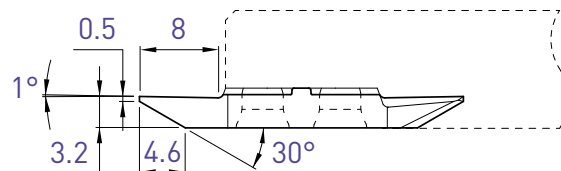
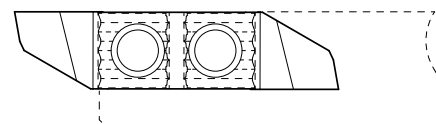
L		R	
Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
632S05	■ ■	642S05	■ ■

L



Tourneur arrière
Rückwärts drehen
Back turning

R

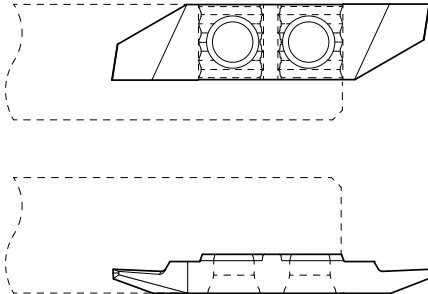


L		R	
Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
633S05	■ ■	643S05	■ ■

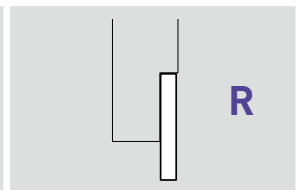
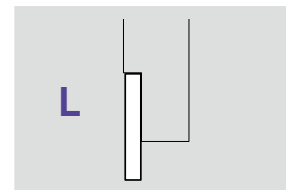
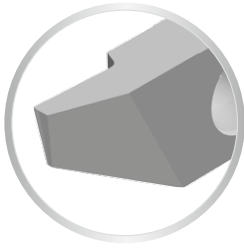
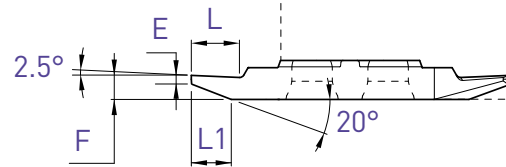
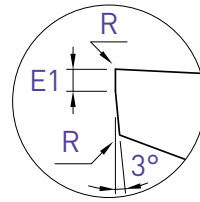
Tourneur arrière
Rückwärts drehen
Back turning

633 / 643

L

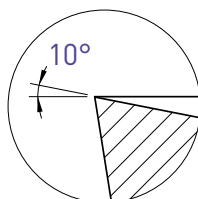
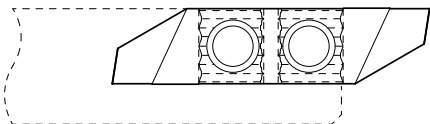


R

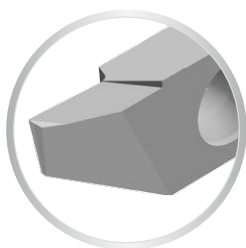
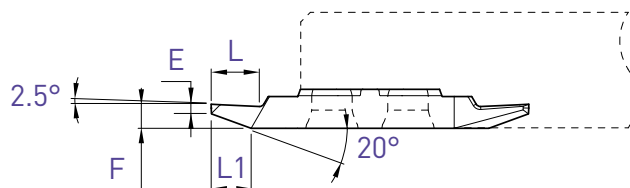
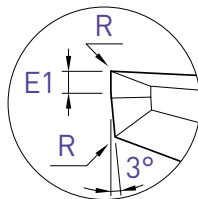
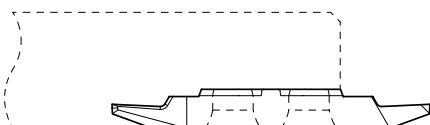
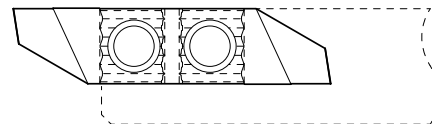


E	E1	L	L1	F	R	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
0.5	0.25	3	2.8	1.5	0	633-0.5	■ ■	643-0.5	■ ■
0.5	0.25	3	2.8	1.5	0.08	-		643-0.5-R08	■ ■
0.8	0.40	4.5	3.3	2.0	0	-		643-0.8	■ ■
0.8	0.40	4.5	3.3	2.0	0.08	-		643-0.8-R08	■ ■
1.0	0.40	5	4.2	2.5	0	-		643-1.0	■ ■
1.0	0.40	5	4.2	2.5	0.08	-		643-1.0-R08	■ ■
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	■ ■

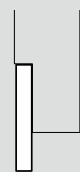
L



R



L



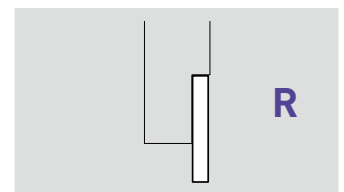
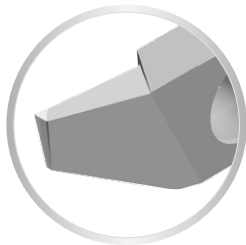
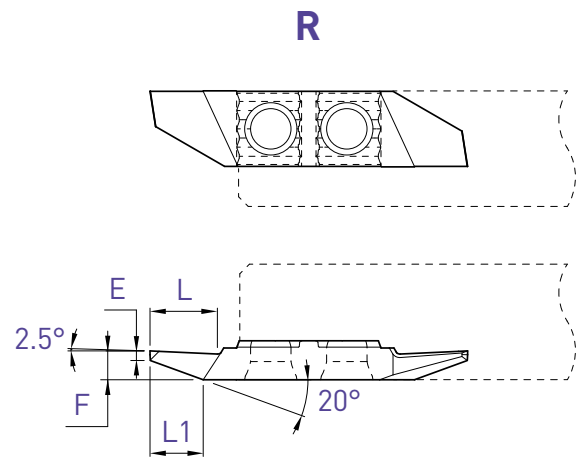
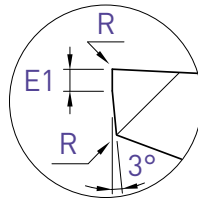
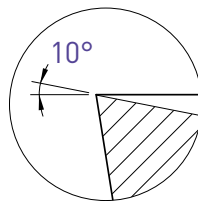
R



E	E1	L	L1	F	R	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
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	■ ■

Tourneur arrière
Rückwärts drehen
Back turning

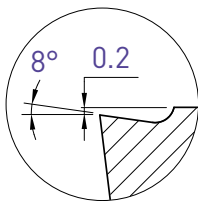
643XS



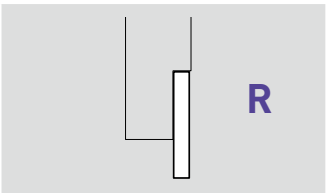
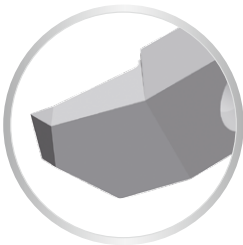
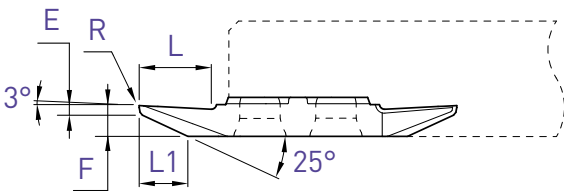
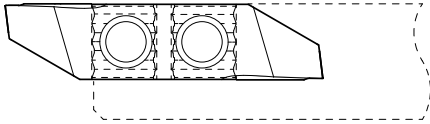
E	E1	L	L1	F	R	Art. N°	TiALN N (μk20)
1.0	0.4	7	5.5	3.0	0	643X10S-1.0	■ ■
1.0	0.4	7	5.5	3.0	0.08	643X10S-1.0-R08	■ ■

- Tourneur arrière
- Rückwärts drehen
- Back turning

643VX8



R

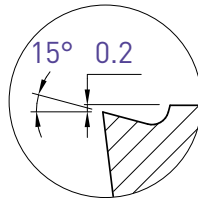
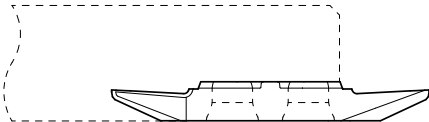
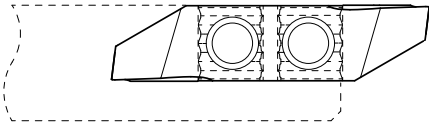


E	L	L1	F	R	Art. N°	TiAlN N (µk20)
~1	7.5	5.0	3.2	0	643VX8	■ ■
~1	7.5	5.0	3.2	0.08	643VX8-R08	■ ■

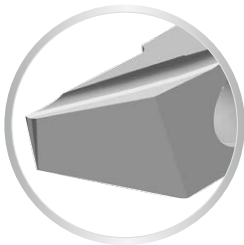
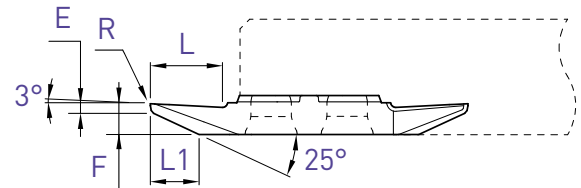
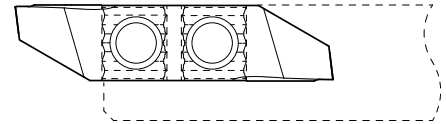
Tourneur arrière
Rückwärts drehen
Back turning

633VX15 / 643VX15

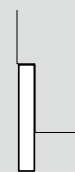
L



R



L



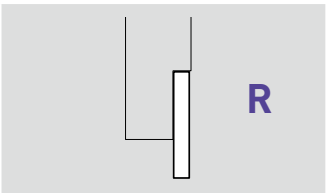
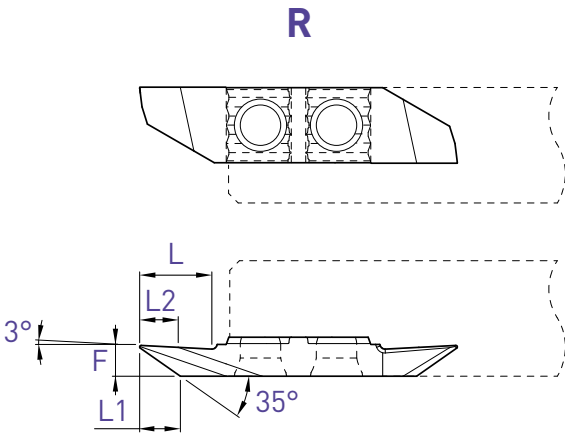
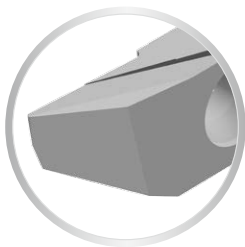
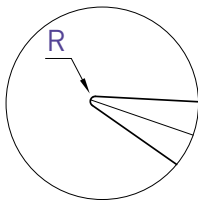
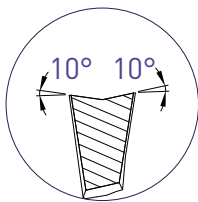
R



E	L	L1	R	Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
0.5	7.5	5.2	0	633VX15	■ ■	643VX15	■ ■
0.5	7.5	5.2	0.08	-		643VX15-R08	■ ■

- Tourneur arrière
- Rückwärts drehen
- Back turning

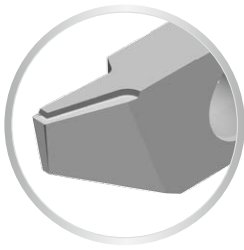
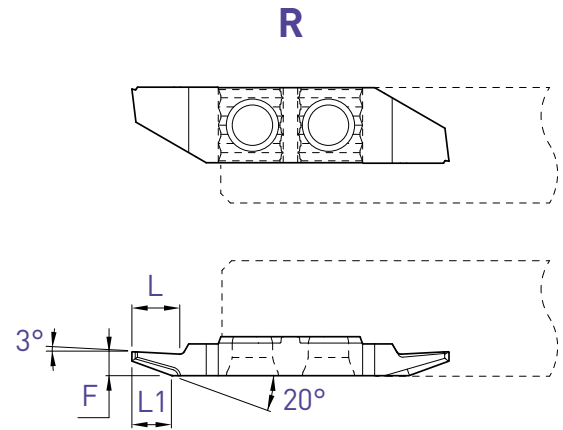
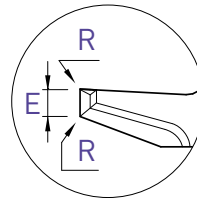
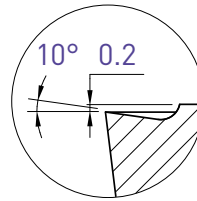
643VUX



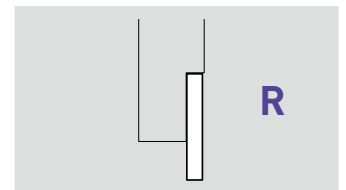
L	L1	L2	F	R	Art. N°	TiAlN N (µk20)
7.5	4.2	4.0	3.2	0.15	643VUX10-R15	■ ■
7.5	3.8	3.8	3.2	0.35	643VUX10-R35	■ ■

Tourneur arrière
Rückwärts drehen
Back turning

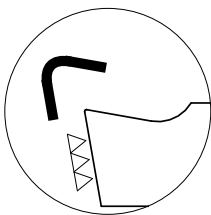
643ZX



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



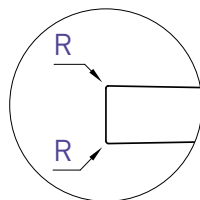
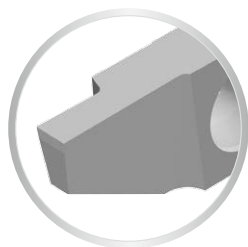
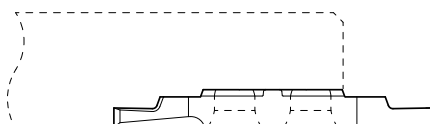
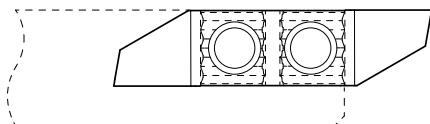
E	L	L1	F	R	Art. N°	TiALN N (µk20)
1.0	5	4	2.5	0.01	643ZX10-1.0	■
1.0	5	4	2.5	0.08	643ZX10-1.0-R08	■



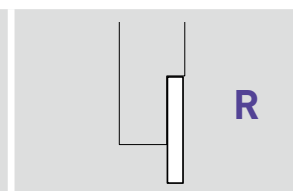
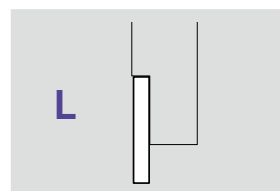
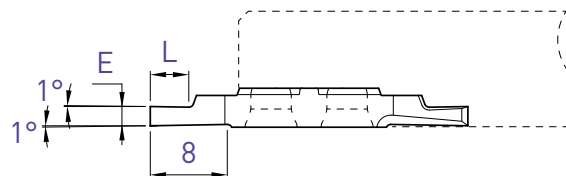
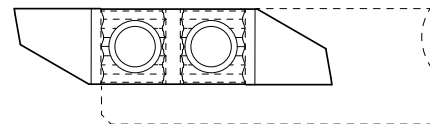
Arête de coupe honée
 Gehonte Schneidkante
 Honed edge

f min: 0.02 mm/U

L



R



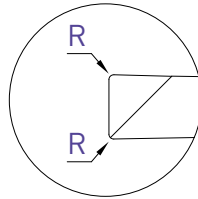
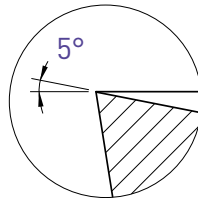
E	L	R	Art. N°	TIALN N (μk20)	Art. N°	TIALN N (μk20)
0.5	1.5	0	634-0.5	■ ■	644-0.5	■ ■
0.6	1.8	0	-		644-0.6	■ ■
0.75	2	0	-		644-0.75	■ ■
0.8	2	0	634-0.8	■ ■	644-0.8	■ ■
0.9	2.5	0	-		644-0.9	■ ■
0.95	3	0	-		644-0.95	■ ■
1.0	2.5	0	634-1.0	■ ■	644-1.0	■ ■
1.0	2.5	0.08	-		644-1.0-R08	■ ■
1.2	3	0	634-1.2	■ ■	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	0.8	-		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	■ ■

Foncer-tourner

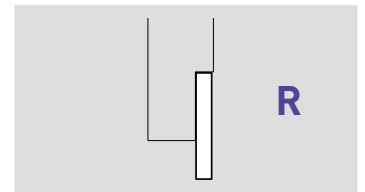
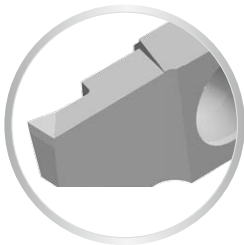
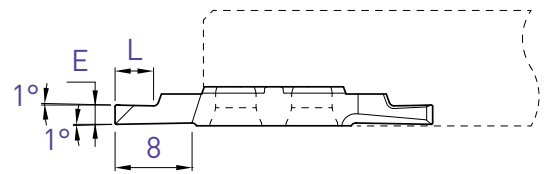
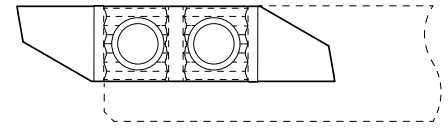
Einstecken und drehen

Grooving and turning

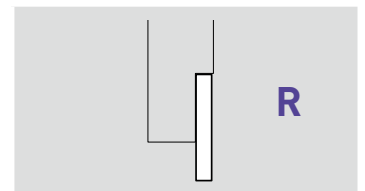
644X5



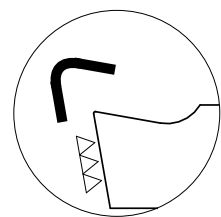
R



E	L	R	Art. N°	TiALN	N (μk20)
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	■	■



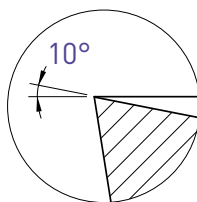
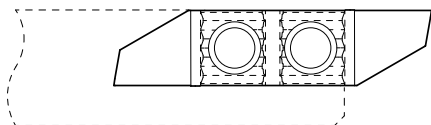
E	L	R	Art. N°	TiALN	N (μk20)
1.5	3	0.08	644X5-1.5-R08-EP	■	■
2	4	0.08	644X5-2.0-R08-EP	■	■
2	4	0.15	644X5-2.0-R15-EP	■	■
2.5	6	0.08	644X5-2.5-R08-EP	■	■
2.5	6	0.15	644X5-2.5-R15-EP	■	■
3	6	0.08	644X5-3.0-R08-EP	■	■
3	6	0.15	644X5-3.0-R15-EP	■	■



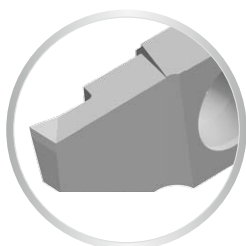
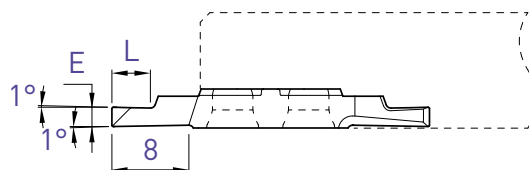
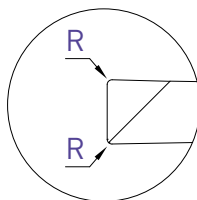
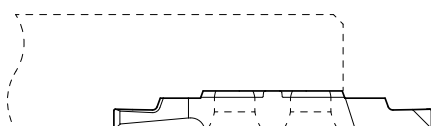
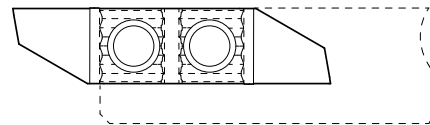
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

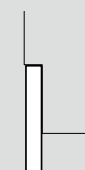
L



R



L



R



E	L	R	Art. N°	TiAlN N (μk20)	Art. N°	TiAlN N (μk20)
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	■ ■

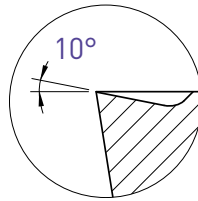
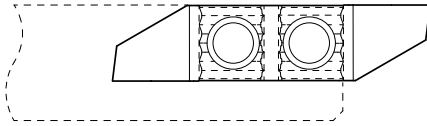
Foncer-tourner

Einstecken und drehen

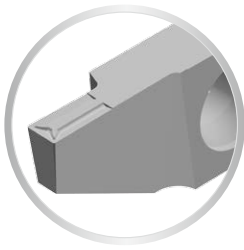
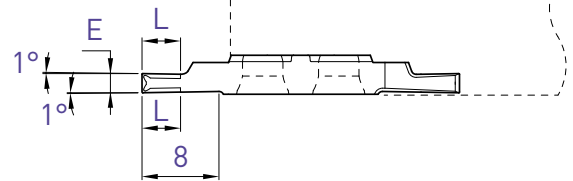
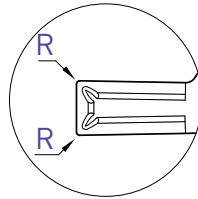
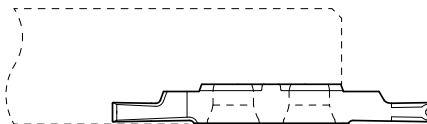
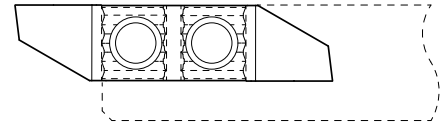
Grooving and turning

634ZXB / 644ZXB

L

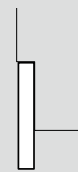


R



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

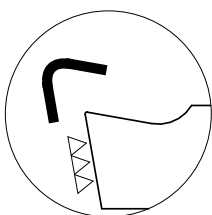
L



R



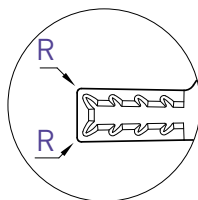
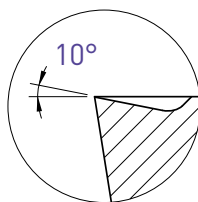
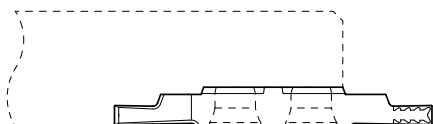
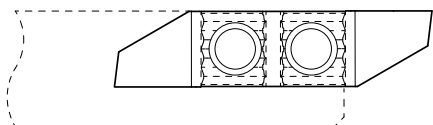
E	L	R	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
1.0	2.5	0.01	634ZXB10-1.0	■	644ZXB10-1.0	■
1.5	4	0.01	634ZXB10-1.5	■	644ZXB10-1.5	■
1.5	4	0.08	634ZXB10-1.5-R08	■	644ZXB10-1.5-R08	■
2.0	4	0.01	634ZXB10-2.0	■	644ZXB10-2.0	■
2.0	4	0.08	634ZXB10-2.0-R08	■	644ZXB10-2.0-R08	■
2.0	4	0.15	634ZXB10-2.0-R15	■	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	■



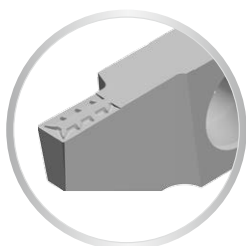
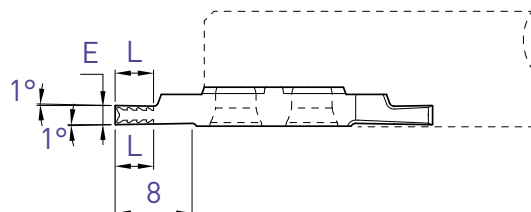
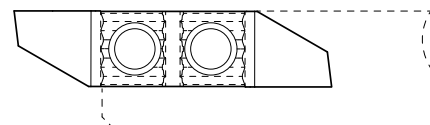
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

L

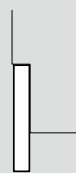


R



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

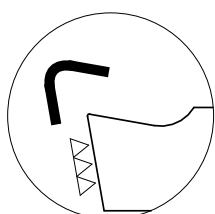
L



R



E	L	R	Art. N°	TiAlN N (µk20)	Art. N°	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

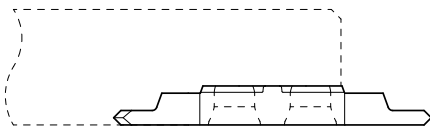
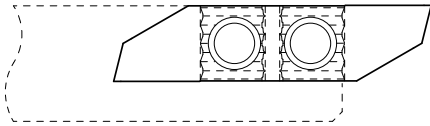
Chamfreiner

Anfasen

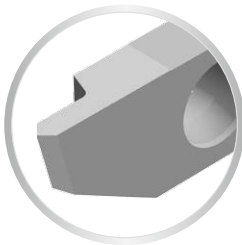
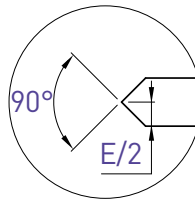
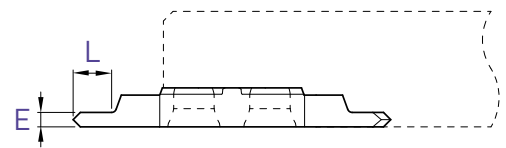
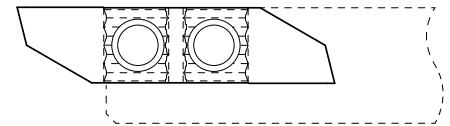
Chamfering

635 / 645

L



R



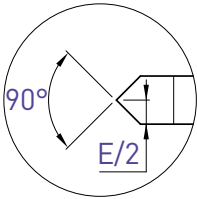
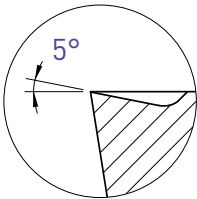
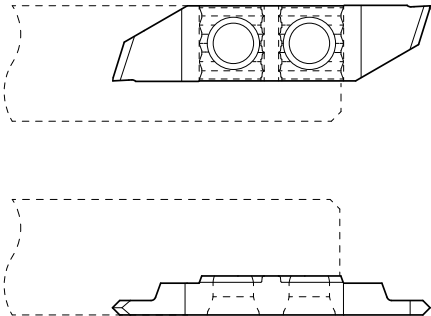
L

R

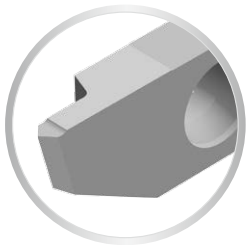
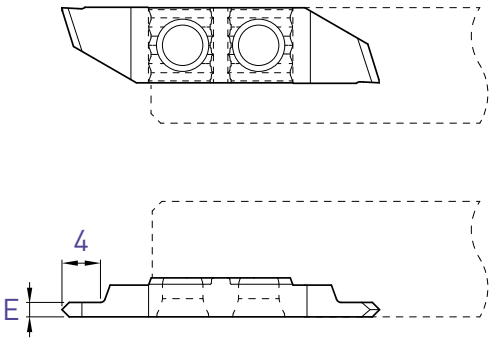
E	L	Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
1.5	4	635-90-1.5	■ ■	645-90-1.5	■ ■

PRO-Line

L



R



L

R

		L		R	
E	L	Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
1.5	4	635X5-90-1.5	■ ■	645X5-90-1.5	■ ■

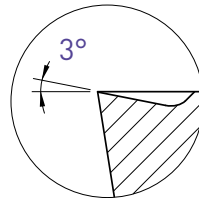
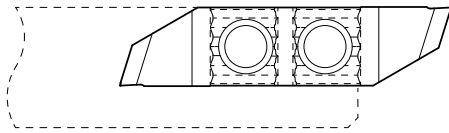
Fileter

Gewinde drehen

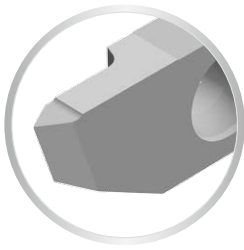
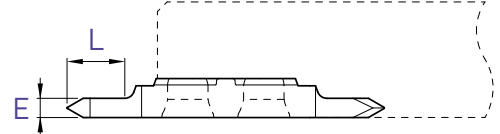
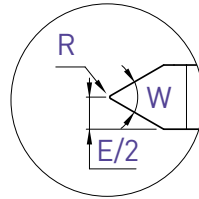
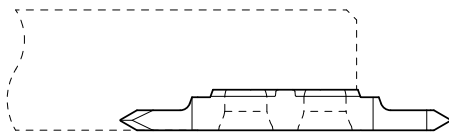
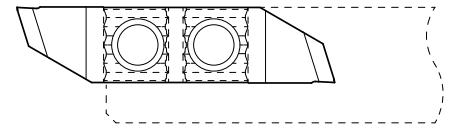
Threading

636X / 646X

L

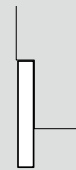


R



Profil partiel
Teilprofil
Partial profile

L

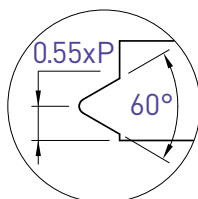
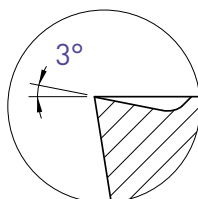
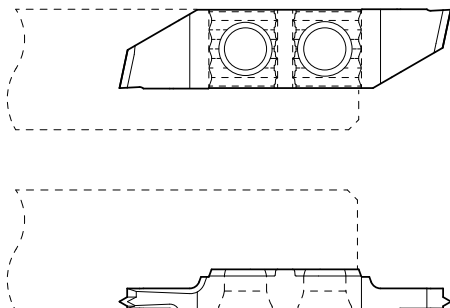


R

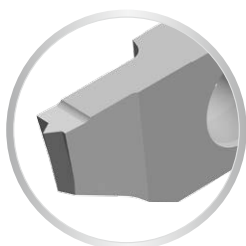
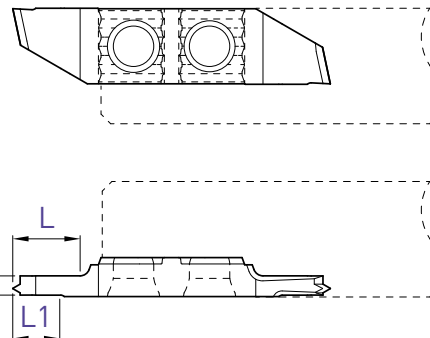


W	E	L	R	Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
55°	1.5	4	0	636X3-55-1.5	■ ■	646X3-55-1.5	■ ■
55°	2.0	6	0.03	636X3-55-2.0-R03	■ ■	646X3-55-2.0-R03	■ ■
60°	1.5	4	0	636X3-60-1.5	■ ■	646X3-60-1.5	■ ■
60°	2.0	6	0.03	636X3-60-2.0-R03	■ ■	646X3-60-2.0-R03	■ ■
60°	2.0	6	0.06	636X3-60-2.0-R06	■ ■	646X3-60-2.0-R06	■ ■
60°	3.0	8	0.06	636X3-60-3.0-R06	■ ■	646X3-60-3.0-R06	■ ■
60°	3.0	8	0.12	636X3-60-3.0-R12	■ ■	646X3-60-3.0-R12	■ ■

L



R



Profil complet métrique
Vollprofil metrisch
Full profile metric

L

R

E	L	L1	Pas Steigung Pitch P	Art. N°	TiALN N (µk20)	Art. N°	TiALN 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	■ ■

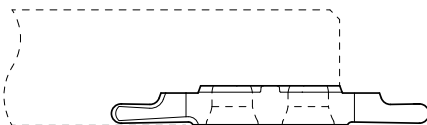
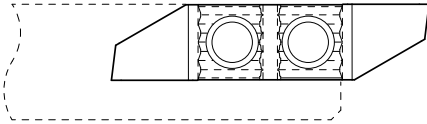
Plaquettes à rayon

Radius-Wendeplatten

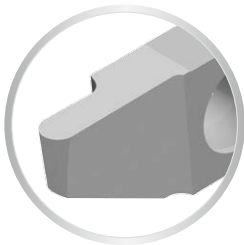
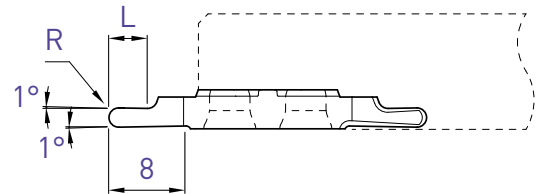
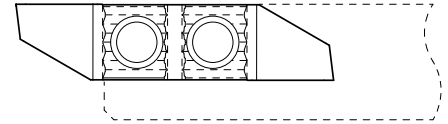
Inserts with radius

637 / 647

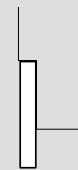
L



R



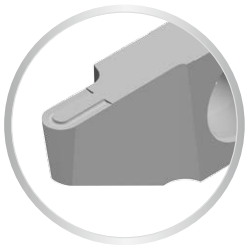
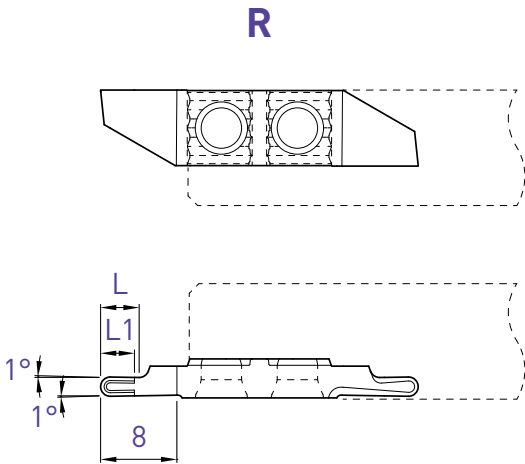
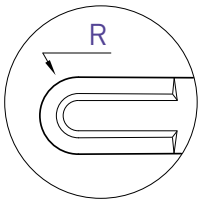
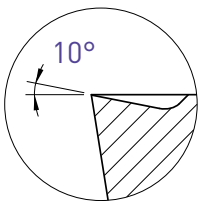
L



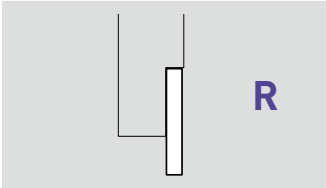
R



R	L	L		R	
		Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
0.25	1.5	-		647-R0.25	■ ■
0.40	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	■ ■



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	■

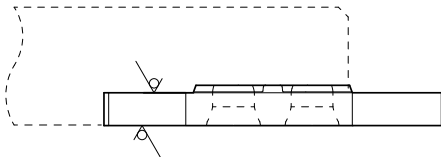
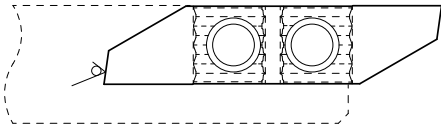
Plaquette ébauche

WSP-Rohling

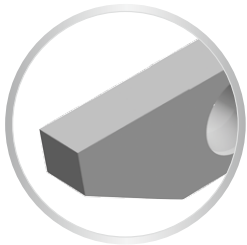
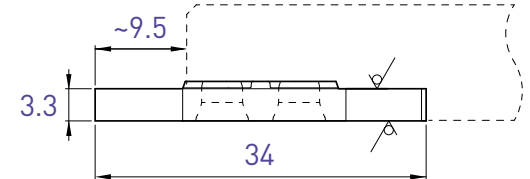
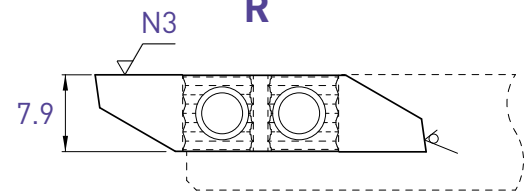
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631-EP / 641-EP

L

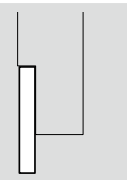


R

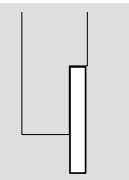


Face de coupe polie
Polierte Schneidfläche
Cutting face polished

L

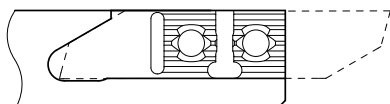


R

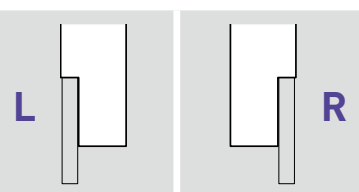
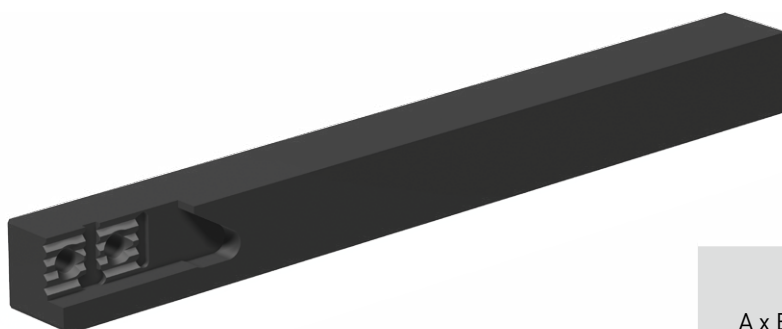
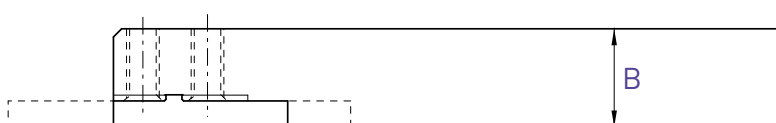
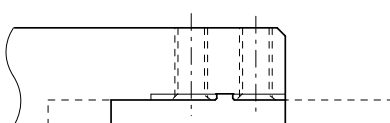
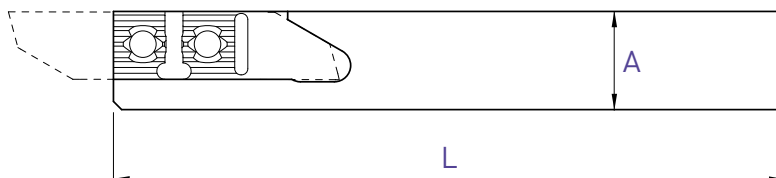


Art. N°	TiALN	N (µk20)	Art. N°	TiALN	N (µk20)
631-EP	□	■	641-EP	□	■

L



R



R

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 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

Coupe à droite déportée

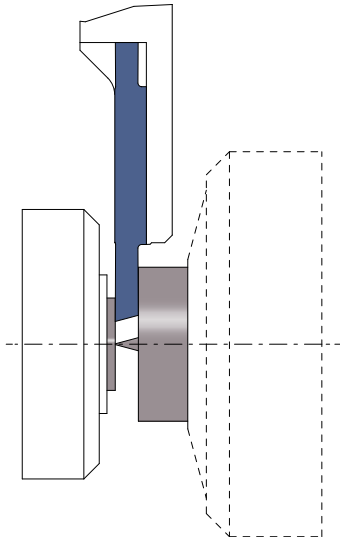
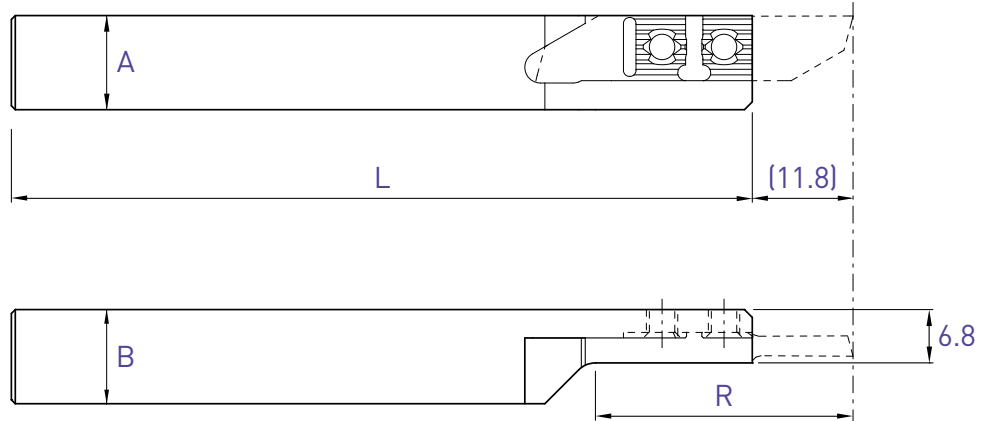
Versetztes Rechtsschneiden

Right cut off line

650-RC

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

Voir dès page 36
Siehe ab Seite 36
See from page 36



L (R)

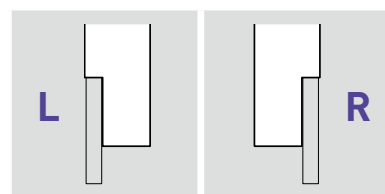
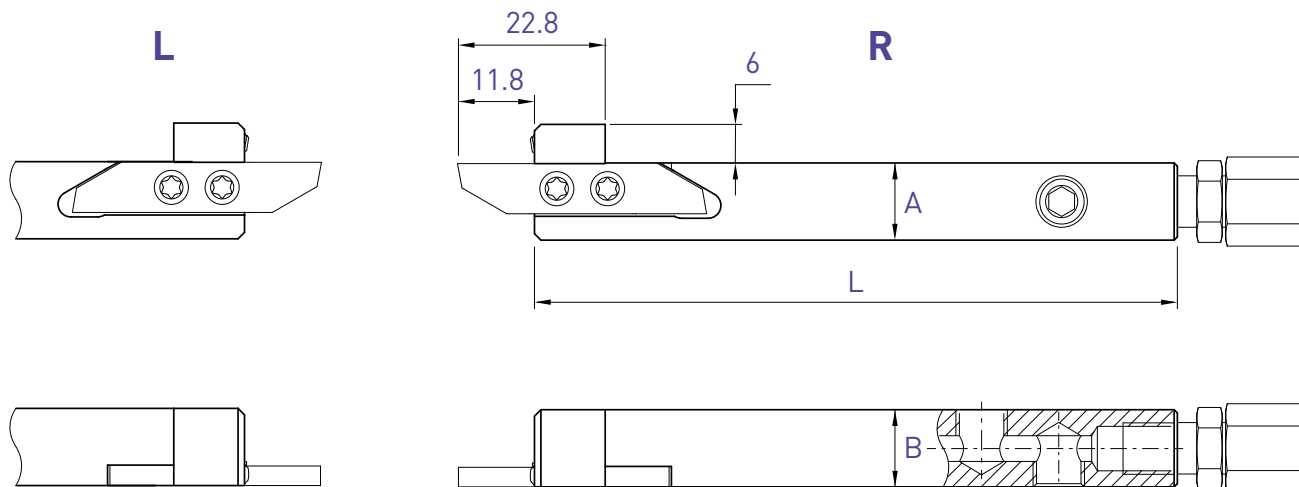
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

A x B	R	L	Art. N°
10 x 10	32	115	650RC-10
12 x 12	32	130	650RC-12
16 x 16	42	130	650RC-16

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

650-JET / 660-JET



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, clé, raccord droit et buse d'arrosage Ø 1.5 mm.
 Jeder Halter wird mit Spannschraube(n), Schlüssel, gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert.
 Screw(s), key, straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder.

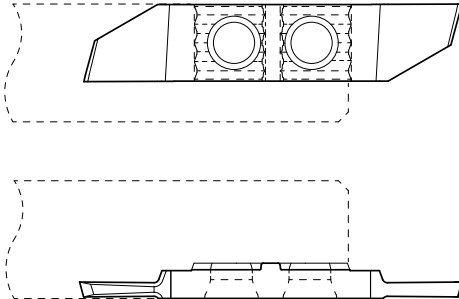
Tronçonnage

Abstechen

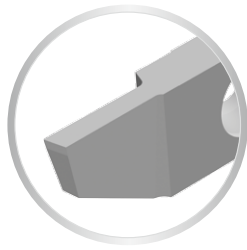
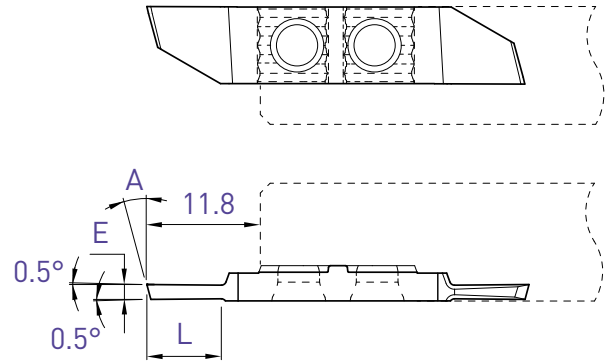
Parting off

651 / 661

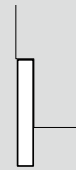
L



R



L

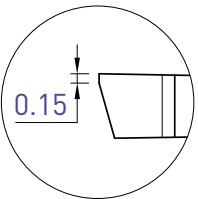
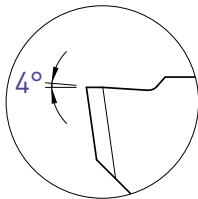
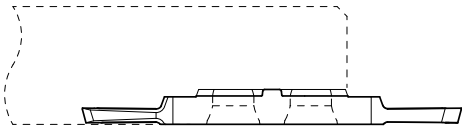
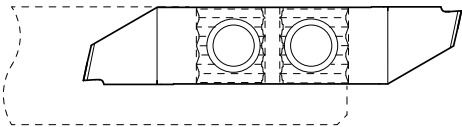


R

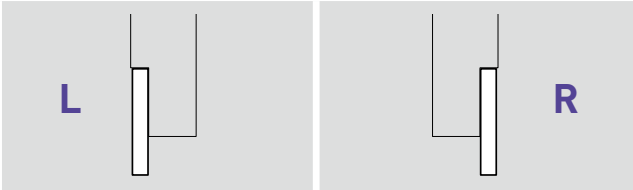
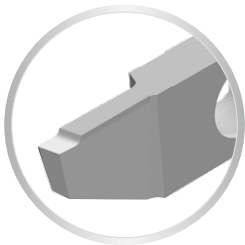
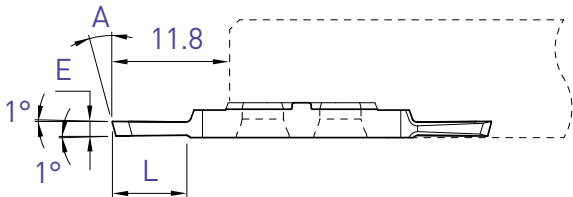
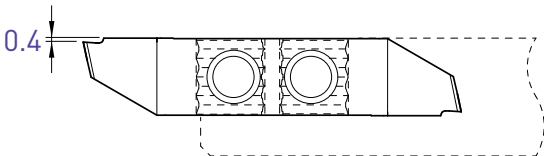


E	A	L	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
0.8	20°	5	651-0.8-20°	■ ■	661-0.8-20°	■ ■
1.0	15°	5	-		661-1.0-15°	■ ■
1.0	20°	5	651-1.0-20°	■ ■	661-1.0-20°	■ ■
1.2	15°	5	-		661-1.2-15°	■ ■
1.2	20°	5	651-1.2-20°	■ ■	661-1.2-20°	■ ■
1.5	15°	7.5	651-1.5-15°	■ ■	661-1.5-15°	■ ■
1.5	20°	7.5	-		661-1.5-20°	■ ■
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°	■ ■

L



R



E	A	L	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
1.5	15°	7.5	651XF-1.5	■ ■	661XF-1.5	■ ■
2.0	15°	11	651XF-2.0	■ ■	661XF-2.0	■ ■

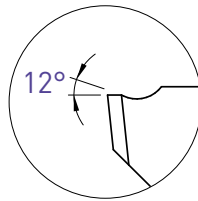
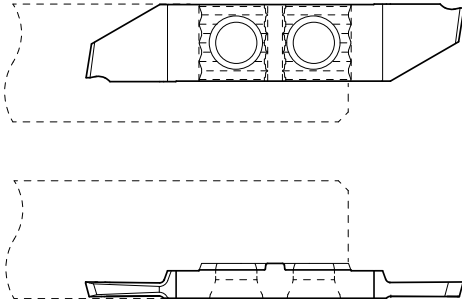
Tronçonnage

Abstechen

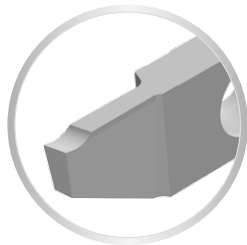
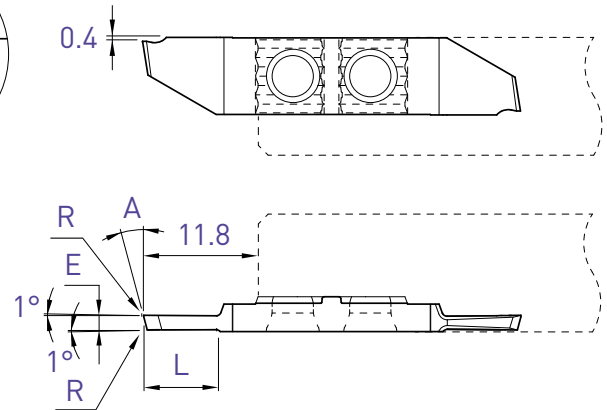
Parting off

651X12 / 661X12

L



R



L

R

E	A	L	R	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
1.0	15°	5	0.03	651X12-1.0	■ ■	661X12-1.0	■ ■
1.5	15°	7.5	0.03	651X12-1.5	■ ■	661X12-1.5	■ ■
2.0	15°	11	0.03	651X12-2.0	■ ■	661X12-2.0	■ ■

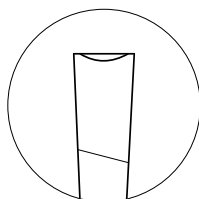
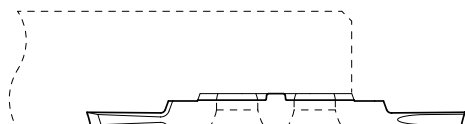
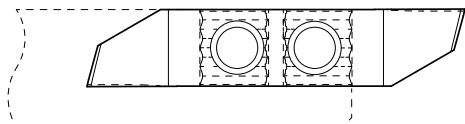
Tronçonnage

Abstechen

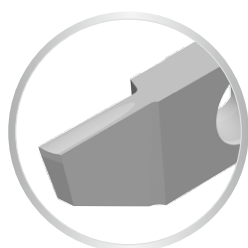
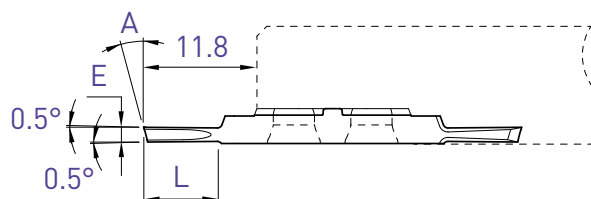
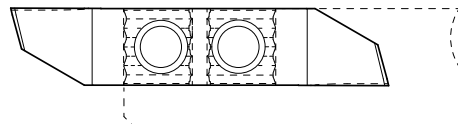
Parting off

651U / 661U

L



R



L

R

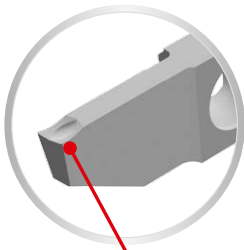
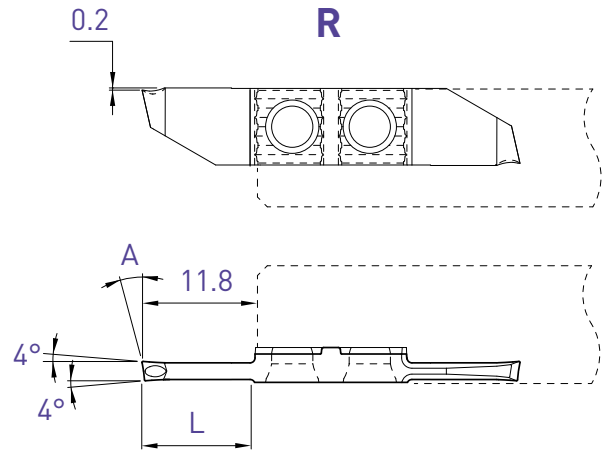
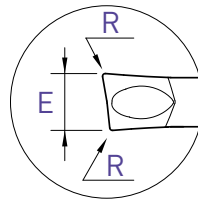
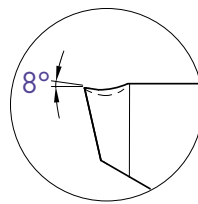
E	A	L	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
1.5	15°	7.5	651U-1.5	■ ■	661U-1.5	■ ■
2.0	15°	11	651U-2.0	■ ■	661U-2.0	■ ■

Tronçonnage

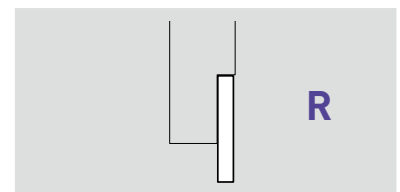
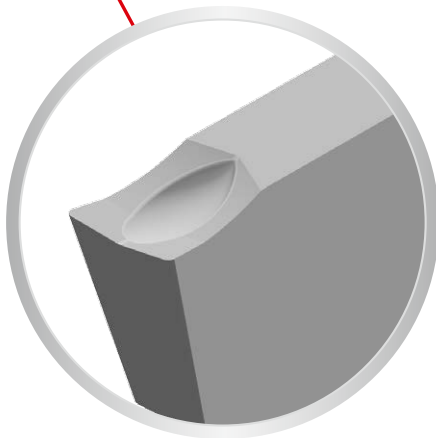
Abstechen

Parting off

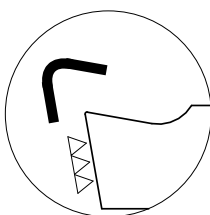
661ZU



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	■



Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

Tronçonnage

Abstechen

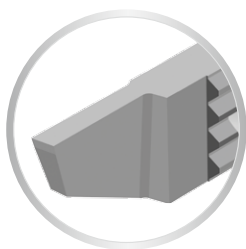
Parting off

Coupe déportée

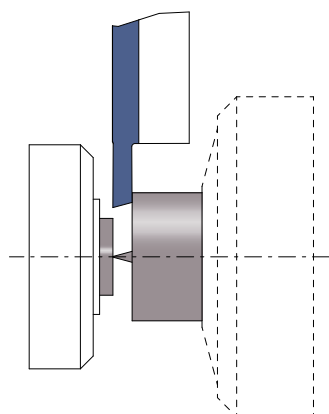
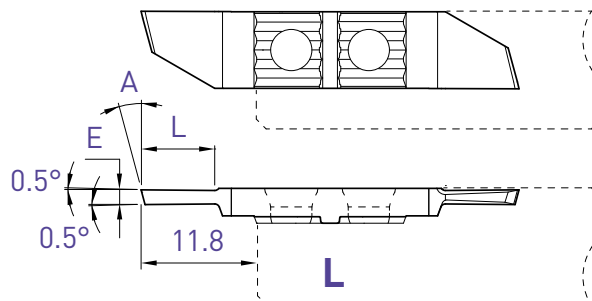
Versetztes Schneiden

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)
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°	■	■

Tronçonnage

Abstechen

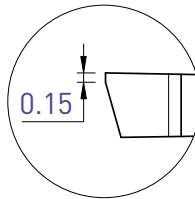
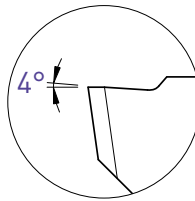
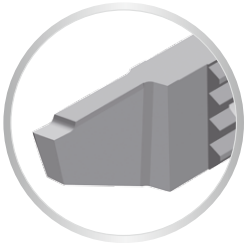
Parting off

Coupe déportée

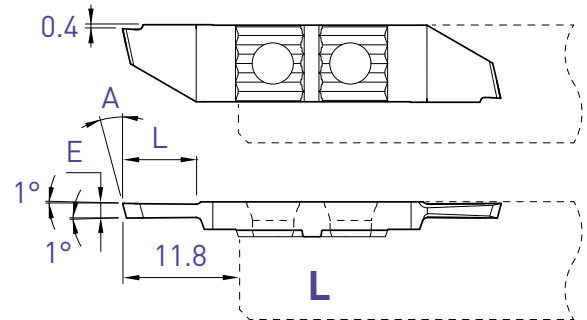
Versetztes Schneiden

Cut off line

651RXF



Cut R



L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	TiALN	N (µk20)
1.5	15°	7.5	651RXF-1.5	■	■
2.0	15°	11	651RXF-2.0	■	■

Tronçonnage

Abstechen

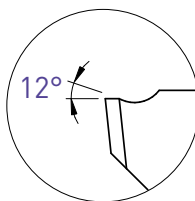
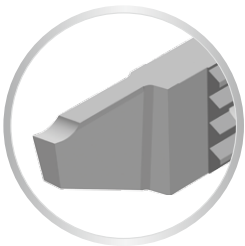
Parting off

Coupe déportée

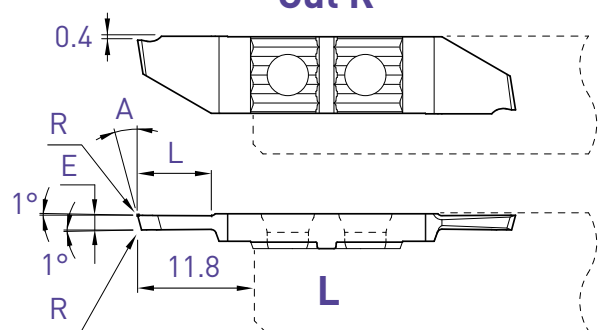
Versetztes Schneiden

Cut off line

651RX12



Cut R



L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	R	Art. N°	TiALN	N (µk20)
1.5	15°	7.5	0.03	651RX12-1.5	■	■
2.0	15°	11	0.03	651RX12-2.0	■	■

PRO-Line

Tronçonnage

Abstechen

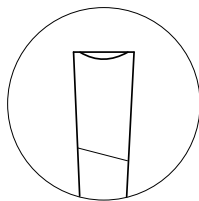
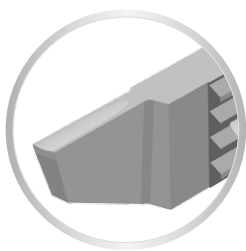
Parting off

Coupe déportée

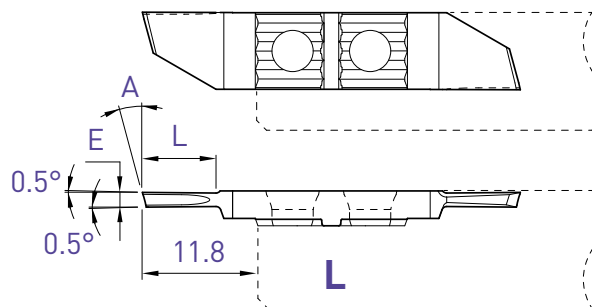
Versetztes Schneiden

Cut off line

651RU



Cut R



L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	TiALN N (µk20)
1.5	15°	7.5	651RU-1.5	■ ■
2.0	15°	11	651RU-2.0	■ ■

Tronçonnage

Abstechen

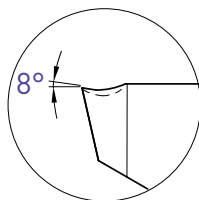
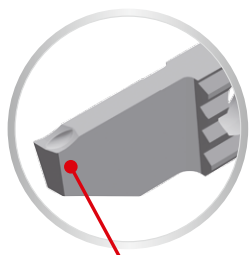
Parting off

Coupe déportée

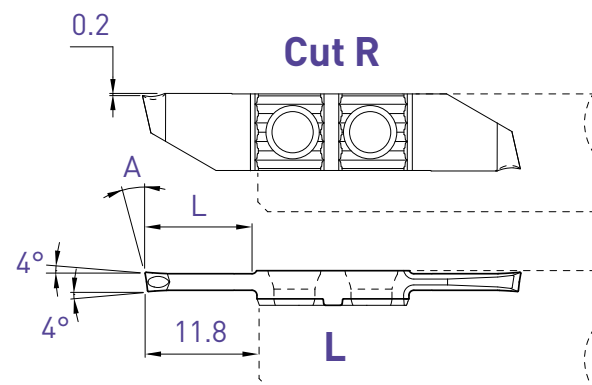
Versetztes Schneiden

Cut off line

651RZU



Cut R

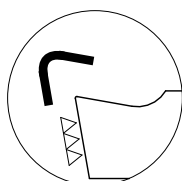


L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	R	Art. N°	TiALN N (µk20)
2.0	8°	11	0.10	651RZU8-2.0-8°-R10	■

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



Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

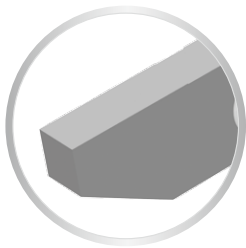
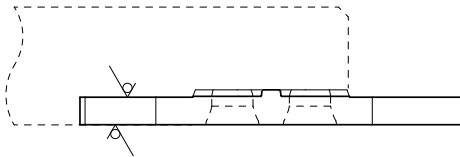
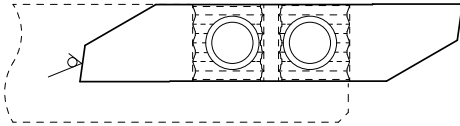
Plaquette ébauche

WSP-Rohling

Blank insert

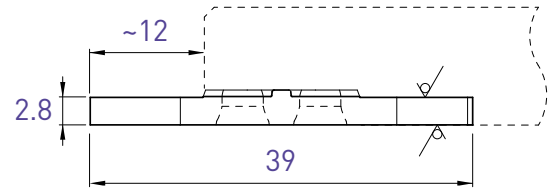
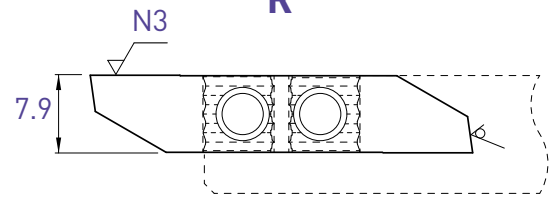
651-EP / 661-EP

L

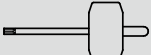
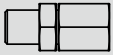


Face de coupe polie
Polierte Schneidfläche
Cutting face polished

R



L		R	
Art. N°	TiALN N (µk20)	Art. N°	TiALN N (µk20)
651-EP	□ ■	661-EP	□ ■

Pièces de rechange Ersatzteile Spare parts						Accessoires Zubehöre Accessories	
Porte-outils Halter Holders			 	 		Option Art. N°	Recommandation de serrage Drehmoment Empfehlung Clamping recommendation
630 640	V-M4X9-T15	C-T15	-	-	-	SET-NM-TX15	3 Nm
630-JET 640-JET	V-M4X9-T15	C-T15	J-M8X1-D6	JB-M8X1	JJ-M3X6-D1.5	SET-NM-TX15	3 Nm
650 660	V-M4X9-T15	C-T15	-	-	-	SET-NM-TX15	3 Nm
650-RC	V-M4X6.5-T15	C-T15	-	-	-	SET-NM-TX15	3 Nm
650-JET 660-JET	V-M4X9-T15	C-T15	J-M8X1-D6	JB-M8X1	JJ-M3X6-D1.5	SET-NM-TX15	3 Nm



SET-NM-TX15

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