

APPLITEC

# ECO-Line



**Applitec Moutier S.A.**  
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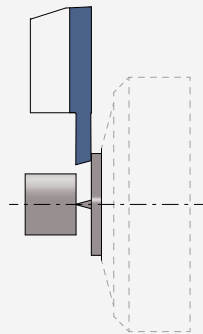


**APPLITEC**  
SWISS TOOLING

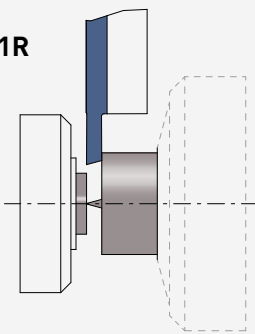
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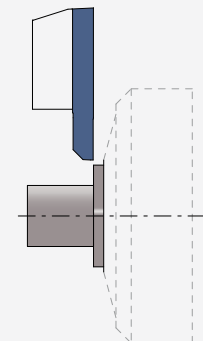
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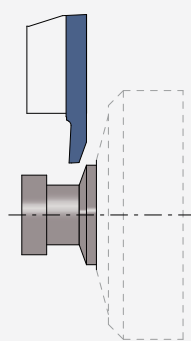
251R



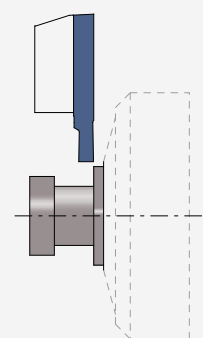
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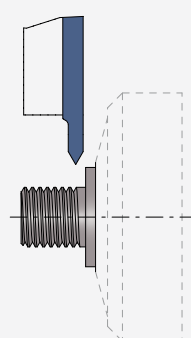
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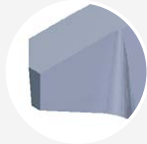




264



266



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## AP302

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

- excellente nuance universelle
- 1<sup>er</sup> 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



## 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



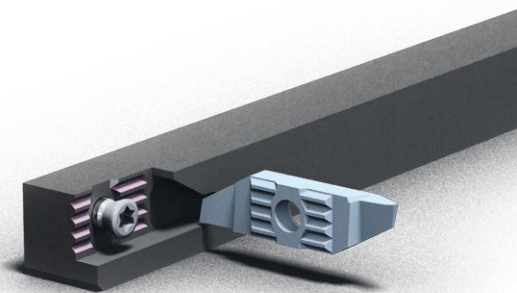
## HN (μK10)

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

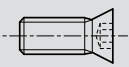
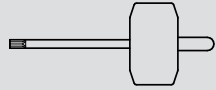
## Standard machining data

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 < 600 N/mm <sup>2</sup> Steel	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl < 800 N/mm <sup>2</sup> Steel	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl < 800 N/mm <sup>2</sup> Steel	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-...	<b>V-M4X9-T15</b>	<b>C-T15</b>	<b>SET-NM-TX15</b>
250-8 / 260-8	<b>V-M3.5X7-T15</b>		
250RC / 260-C	<b>V-M4X7.3-T15</b>		

Recommandation de serrage  
Drehmoment Empfehlung  
Clamping recommendation

3.0 Nm



SET-NM-TX15

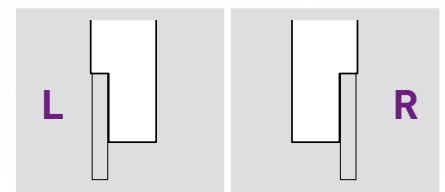
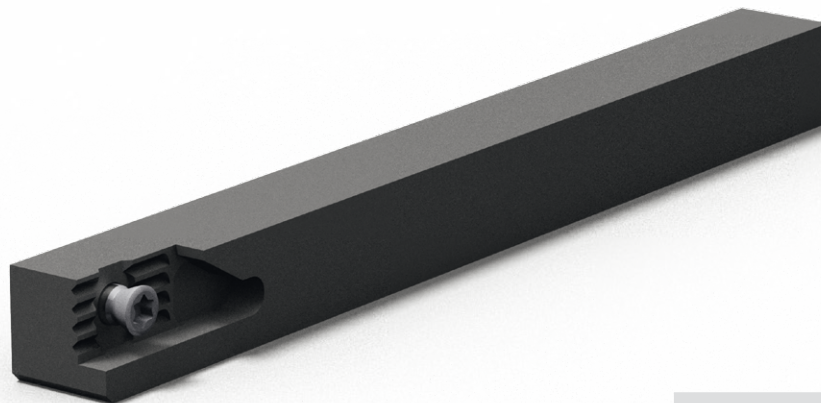
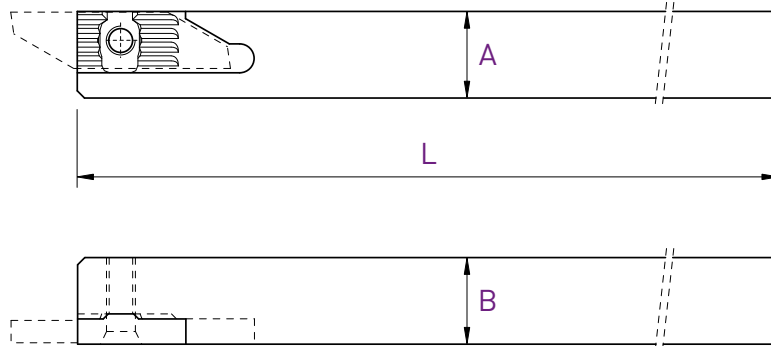
# ECO-Line

Porte-outils

Halter

Holder

250 / 260



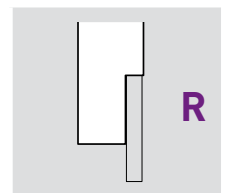
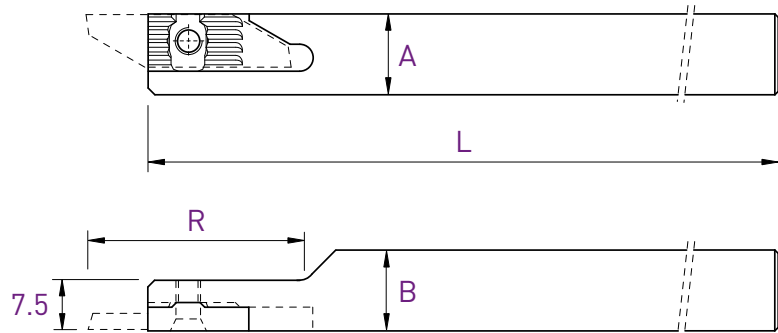
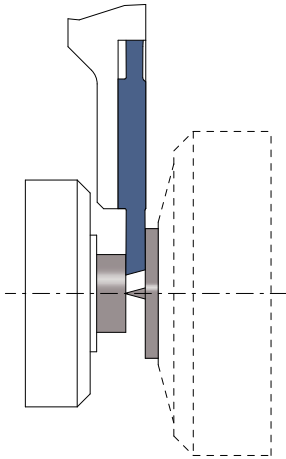
A x B	L	Art. N°	Art. N°
8 x 8	115	<b>250-8</b>	<b>260-8</b>
10 x 10	115	<b>250-10</b>	<b>260-10</b>
12 x 12	130	<b>250-12</b>	<b>260-12</b>
12 x 12	90	<b>250-12-90</b>	<b>260-12-90</b>
12.7 x 12.7	130	<b>250-12.7</b>	<b>260-12.7</b>
16 x 16	130	<b>250-16</b>	<b>260-16</b>
16 x 16	75	<b>250-16-75</b>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

Porte-outils

Halter

Holder

## 260-C



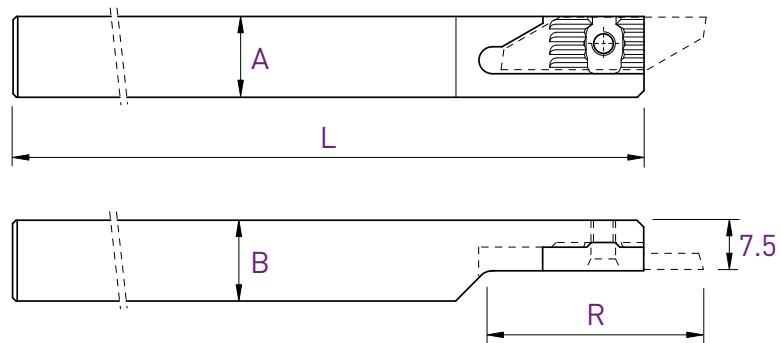
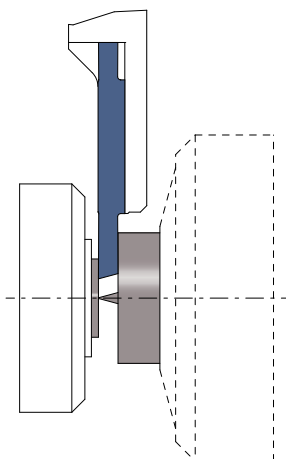
A x B	L	R	Art. N°
12 x 12	130	30	260-C-12

Porte-outils

Halter

Holder

## 250RC



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



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

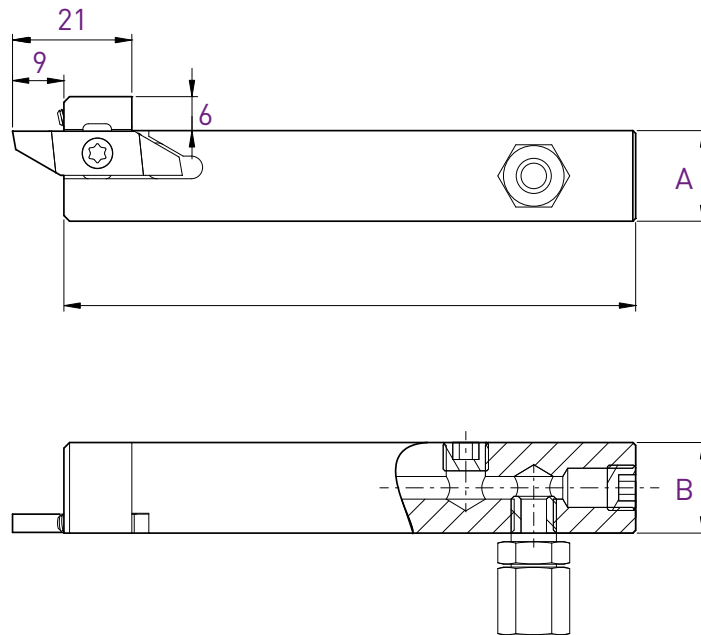
# ECO-Line

Porte-outils

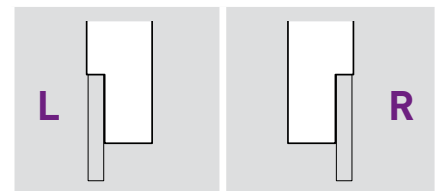
Halter

Holder

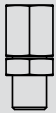

## 250JET / 260JET



**NEW**



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

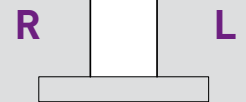
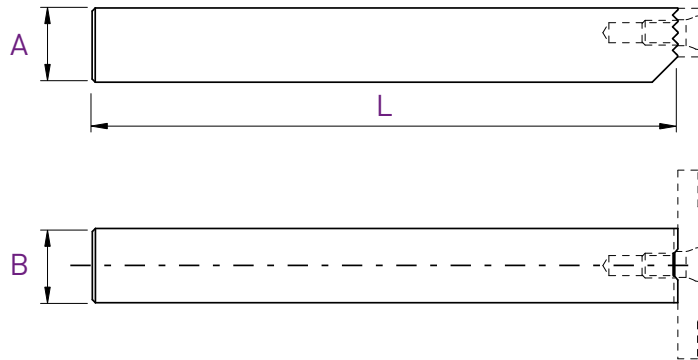


Porte-outils

Halter

Holders

## 260/250F



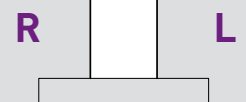
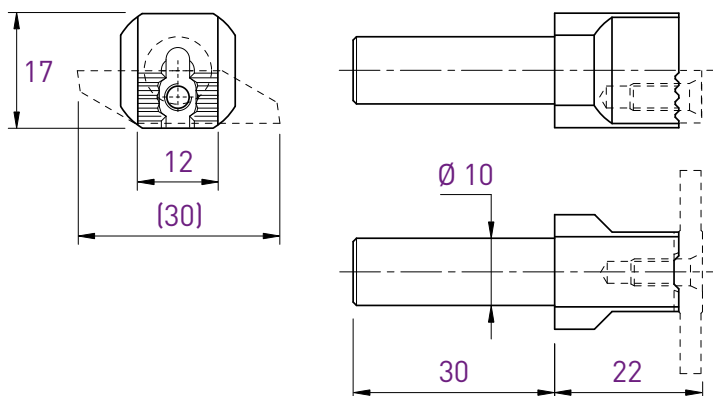
A x B	L	Art. N°
10 x 12	120	260/250F-1012
12 x 12	120	260/250F-1212

Porte-outils

Halter

Holders

## 260/250-D



Art. N°
260/250-D10

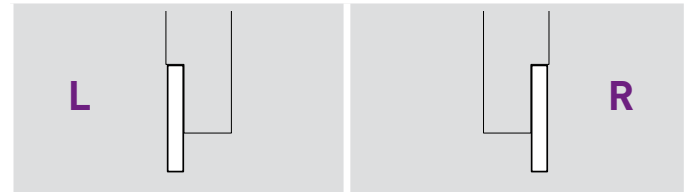
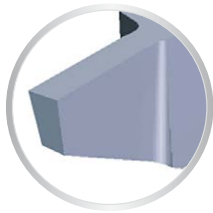
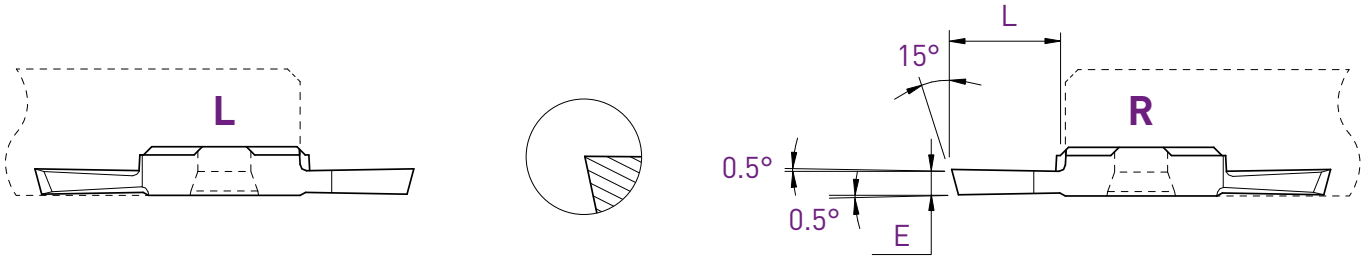
# ECO-Line

Tronçonnage

Abstechen

Cut off

## 251 / 261



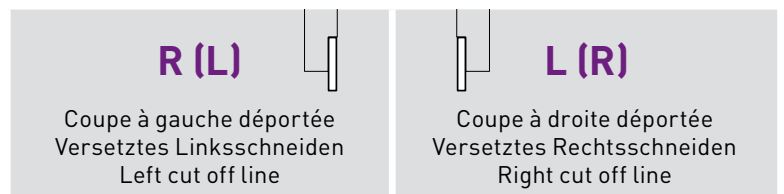
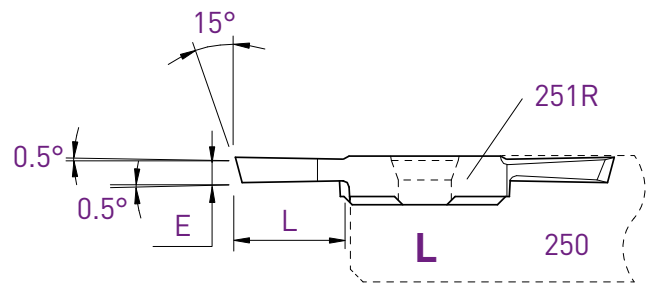
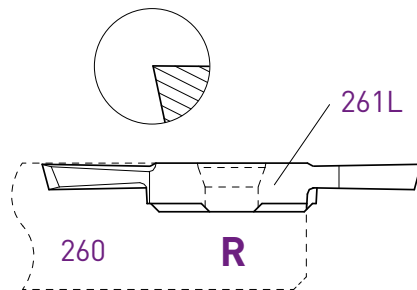
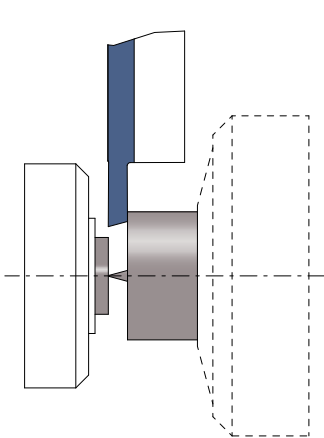
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0.8	4	251-0.8	■	□	■	261-0.8	■	□	■
1.0	5	251-1.0	■	□	■	261-1.0	■	□	■
1.2	5	251-1.2	■	□	■	261-1.2	■	□	■
1.5	7	251-1.5	■	□	■	261-1.5	■	□	■
2.0	8.5	251-2.0	■	□	■	261-2.0	■	□	■
2.5	8.5	251-2.5	■	□	■	261-2.5	■	□	■

Coupe déportée

Versetztes Schneiden

Cut off line

## 261L / 251R



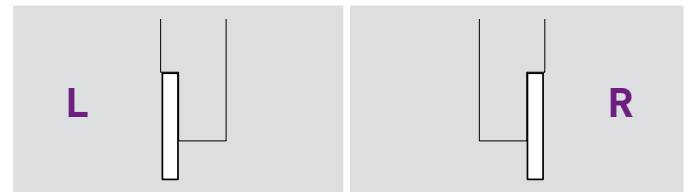
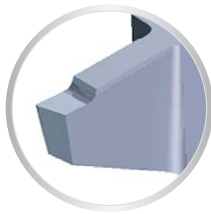
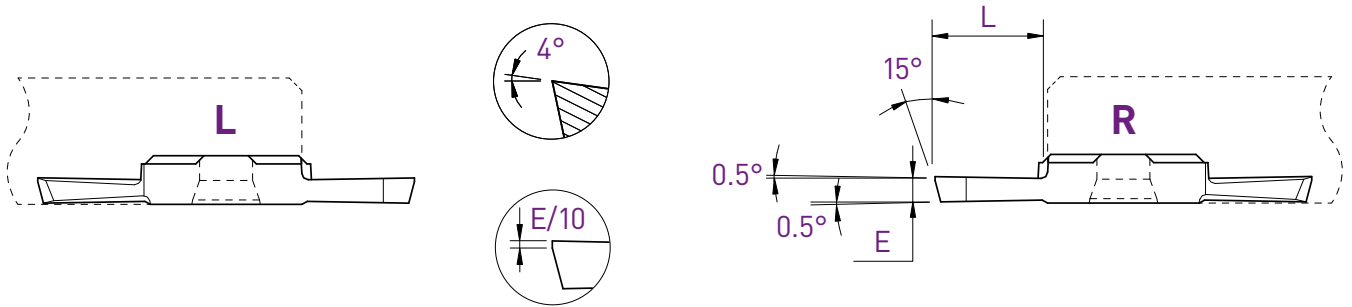
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1.0	5	-	■	□	■	251R-1.0	■	□	■
1.5	7	-	■	□	■	251R-1.5	■	□	■
2.0	8.5	261L-2.0	■	□	■	251R-2.0	■	□	■

Tronçonnage

Abstechen

Cut off

## 251XF / 261XF



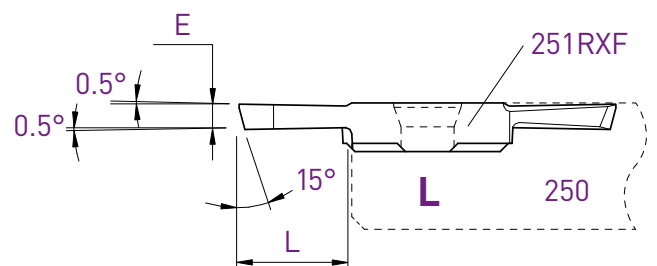
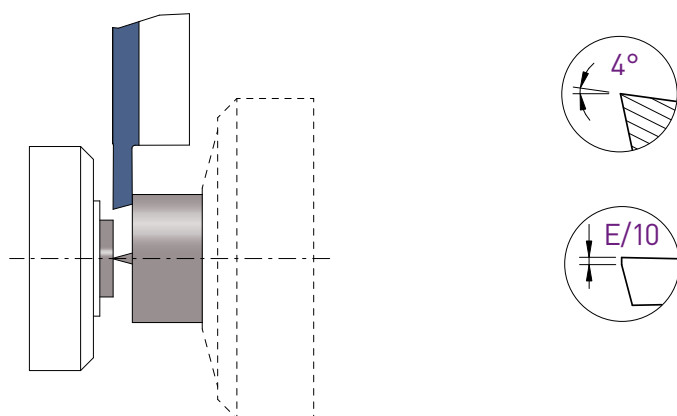
E	L	Art. N°	AP302 AP202 Z			Art. N°	AP302 AP202 Z		
			■	□	■		■	□	■
1.5	7	251XF-1.5	■	□	■	261XF-1.5	■	□	■
2.0	8.5	251XF-2.0	■	□	■	261XF-2.0	■	□	■

Coupe déportée

Versetztes Schneiden

Cut off line

## 251RXF

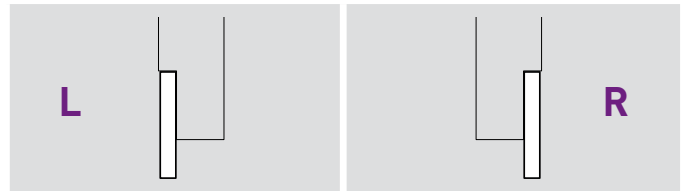
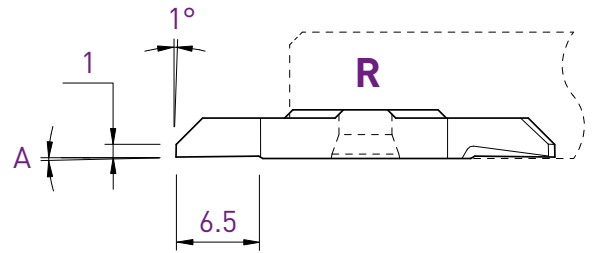
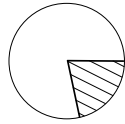
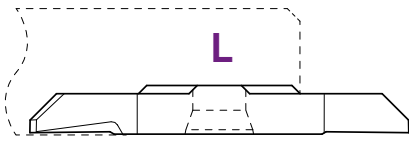


L (R)											
Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line											
E	L	Art. N°	AP302 AP202 Z			E	L	Art. N°	AP302 AP202 Z		
			■	□	■				■	□	■
1.5	7	251RXF-1.5	■	□	■	1.5	7	251RXF-1.5	■	□	■
2.0	8.5	251RXF-2.0	■	□	■	2.0	8.5	251RXF-2.0	■	□	■

# ECO-Line

Tourneur avant  
Vorwärts drehen  
Front turning

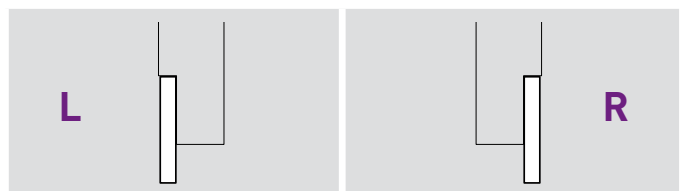
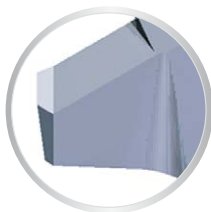
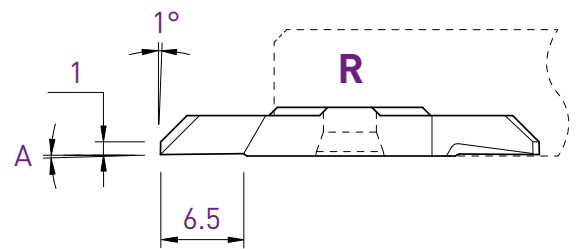
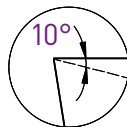
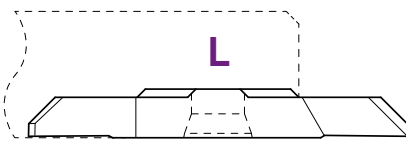
252 / 262



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

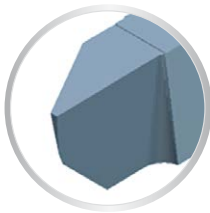
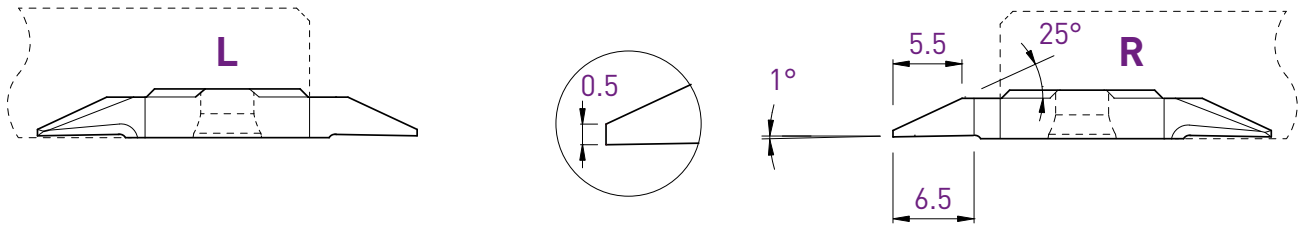


A	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
0°	252X	■	□	■	262X	■	□	■
2°	252X-2°	■	□	■	262X-2°	■	□	■

**Tourneur avant**  
**Vorwärts drehen**  
**Front turning**

**NEW**

**252S / 262S**

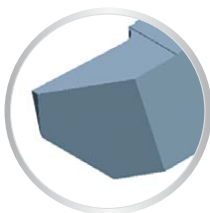
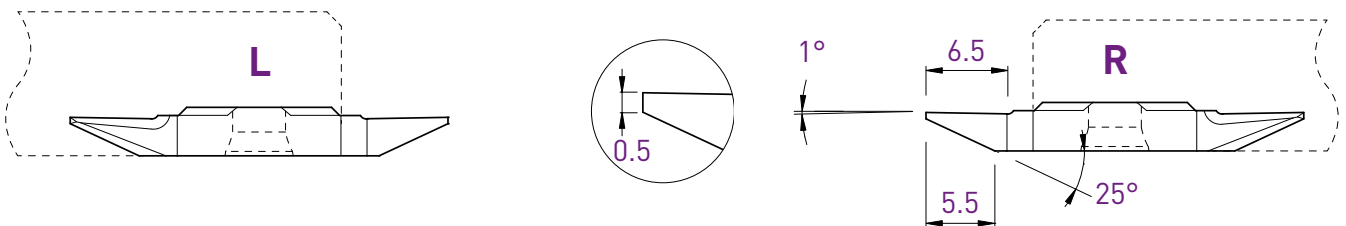


L			R				
Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
252S05	■	□	■	262S05	■	□	■

**Tourneur arrière**  
**Rückwärts drehen**  
**Back turning**

**NEW**

**253S / 263S**

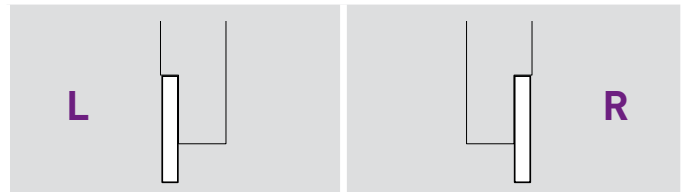
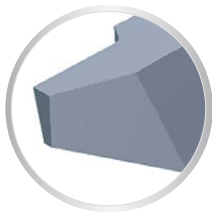
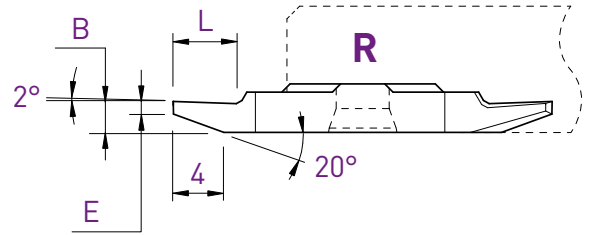
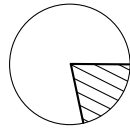
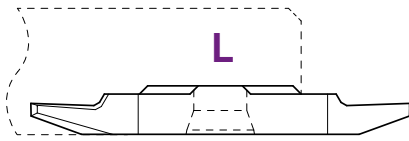


L			R				
Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
253S05	■	□	■	263S05	■	□	■

# ECO-Line

Tourneur arrière  
Rückwärts drehen  
Back turning

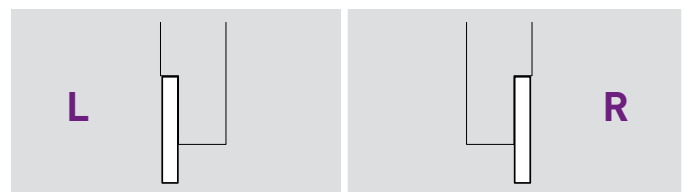
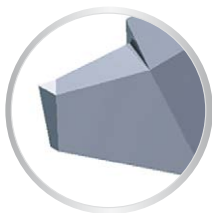
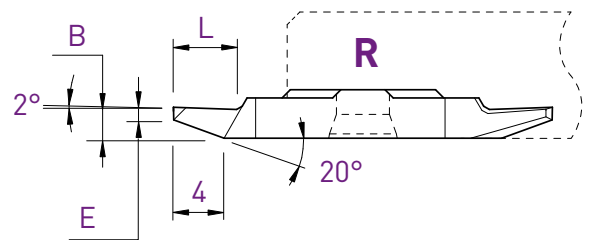
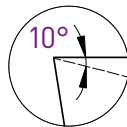
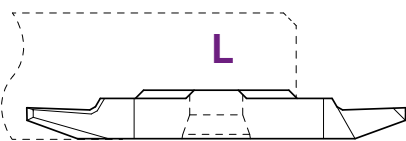
253 / 263



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

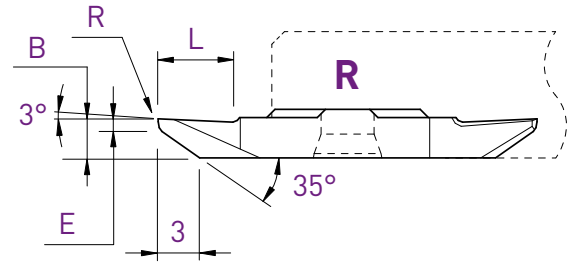
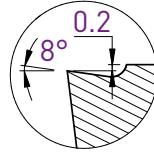
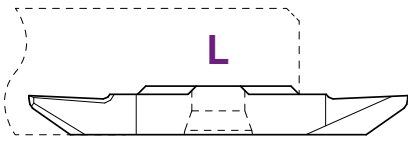
253X / 263X



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

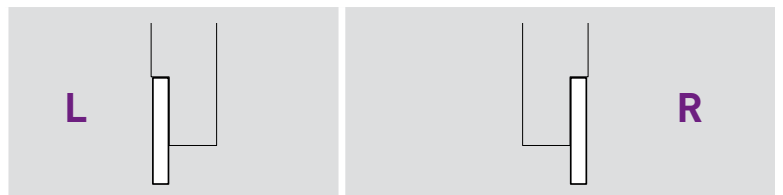
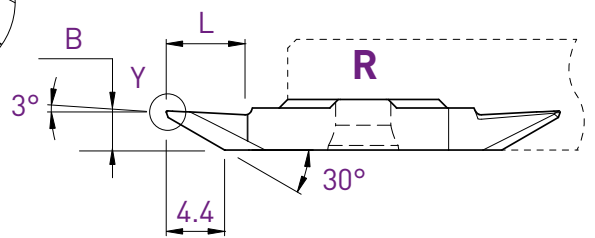
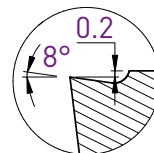
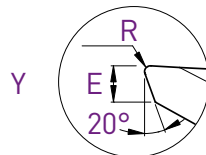
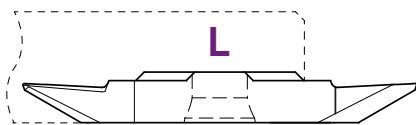
## 253VX-8° / 263VX-8°



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	■	□	■	■	■

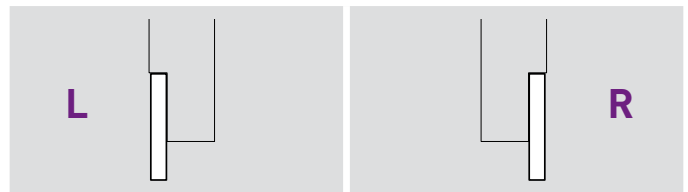
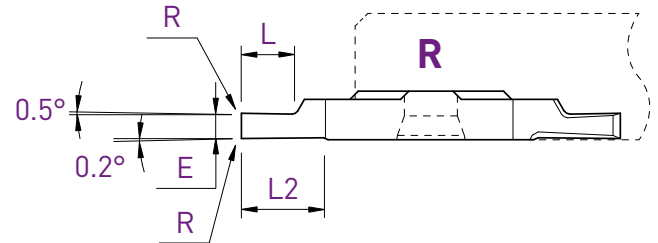
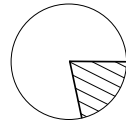
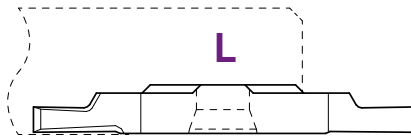
# ECO-Line

Foncer-tourner

Einstecken und drehen

Grooving and turning

254 / 264



E	L	L2	R	L			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	■	□	■

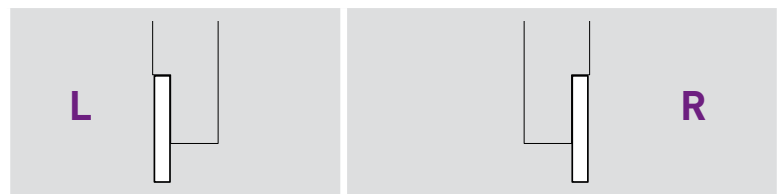
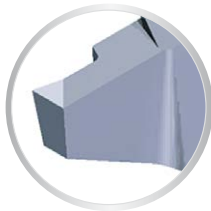
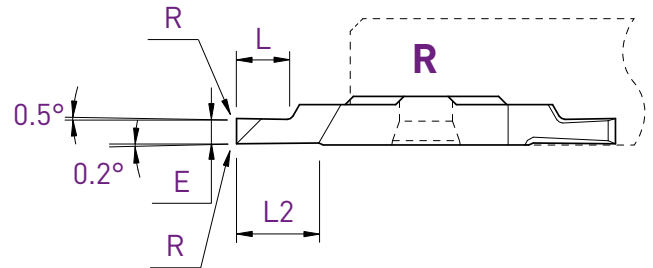
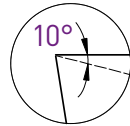
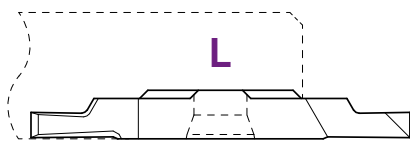


Foncer-tourner

Einstecken und drehen

Grooving and turning

## 254X / 264X



E	L	L2	R	L			R						
				Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z	AH302	HN
0.8	2	4	0	<b>254X-0.8</b>	■	□	■	<b>264X-0.8</b>	■	□	■		
1.0	2.5	4	0	<b>254X-1.0</b>	■	□	■	<b>264X-1.0</b>	■	□	■		
1.0	2.5	4	0.08	-				<b>264X-1.0-R08</b>	■	□	■	■	■
1.2	3	4	0	<b>254X-1.2</b>	■	□	■	<b>264X-1.2</b>	■	□	■		
1.5	3	4	0	<b>254X-1.5</b>	■	□	■	<b>264X-1.5</b>	■	□	■		
1.5	3	4	0.08	-				<b>264X-1.5-R08</b>	■	□	■	■	■
1.5	3	4	0.2	-				<b>264X-1.5-R20</b>	■	□	■	■	■
2.0	4	6.5	0	<b>254X-2.0</b>	■	□	■	<b>264X-2.0</b>	■	□	■		
2.0	4	6.5	0.08	-				<b>264X-2.0-R08</b>	■	□	■	■	■
2.0	4	6.5	0.2	-				<b>264X-2.0-R20</b>	■	□	■	■	■
2.5	6	6.5	0	<b>254X-2.5</b>	■	□	■	<b>264X-2.5</b>	■	□	■		
2.5	6.5	6.5	0.08	-				<b>264X-2.5-R08</b>	■	□	■	■	■
2.5	6.5	6.5	0.2	-				<b>264X-2.5-R20</b>	■	□	■	■	■
3.0	6.5	6.5	0	<b>254X-3.0</b>	■	□	■	<b>264X-3.0</b>	■	□	■		
3.0	6.5	6.5	0.08	-				<b>264X-3.0-R08</b>	■	□	■	■	■
3.0	6.5	6.5	0.2	-				<b>264X-3.0-R20</b>	■	□	■	■	■

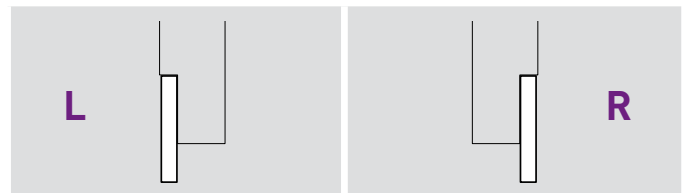
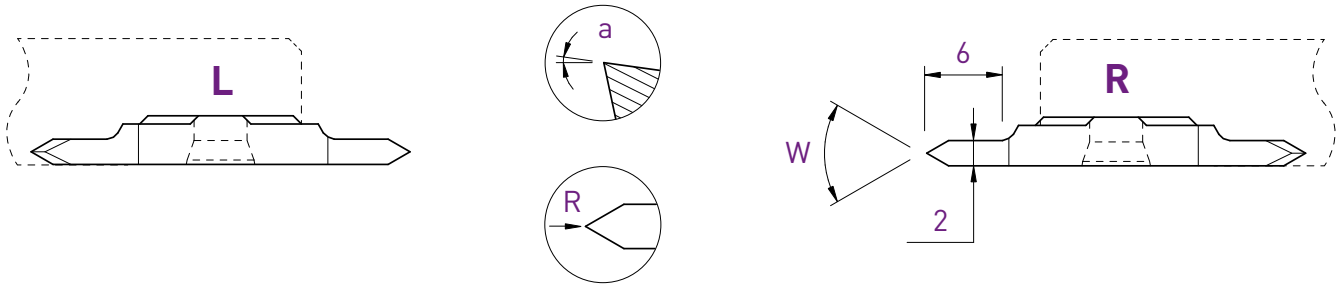
# ECO-Line

Fileter

Gewinde drehen

Threading

## Partial profil 60° – 256-60 / 266-60



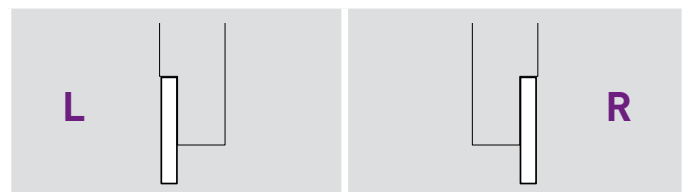
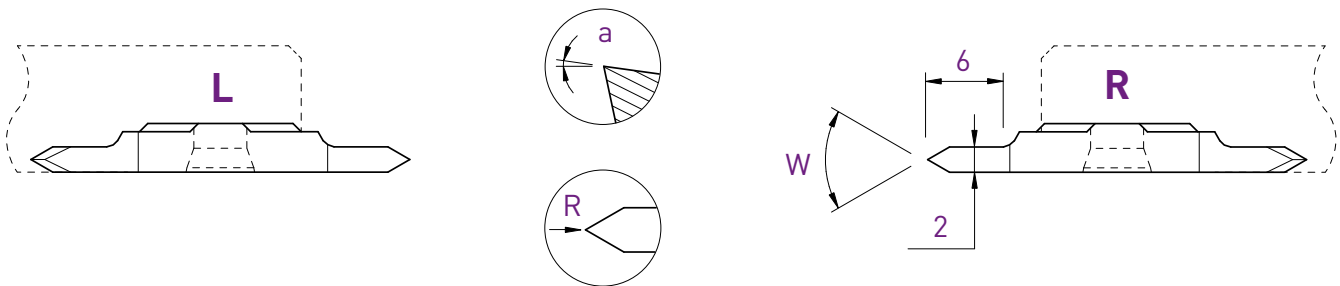
W	R	a	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
60°	0	0°	256-60-2	■	□	■	266-60-2	■	□	■
60°	0.06	3°	256-AG60	■	□	■	266-AG60	■	□	■

Fileter

Gewinde drehen

Threading

## Partial profil 55° – 256-55 / 266-55



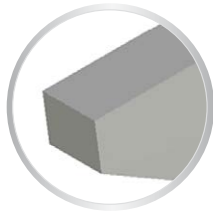
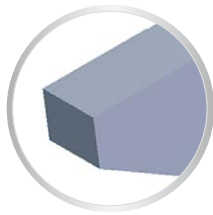
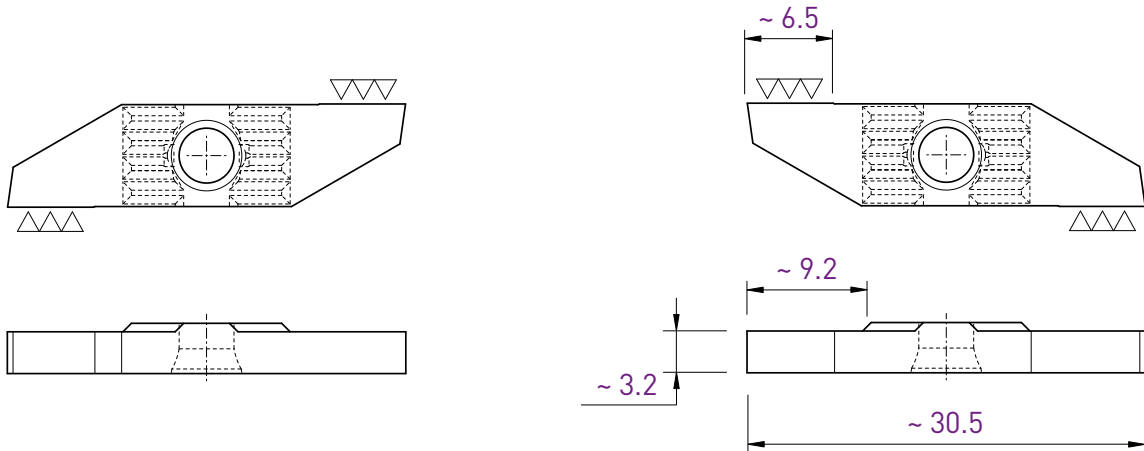
W	R	a	Art. N°	AP302	AP202	Z	Art. N°	AP302	AP202	Z
55°	0	0°	256-55-2	■	□	■	266-55-2	■	□	■
55°	0.06	3°	256-AG55	■	□	■	266-AG55	■	□	■

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



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