ECO-Line

APPLITEC
CUTTING TOOLS

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2	6	4	X	-	2.0	-	R20	-	AP302

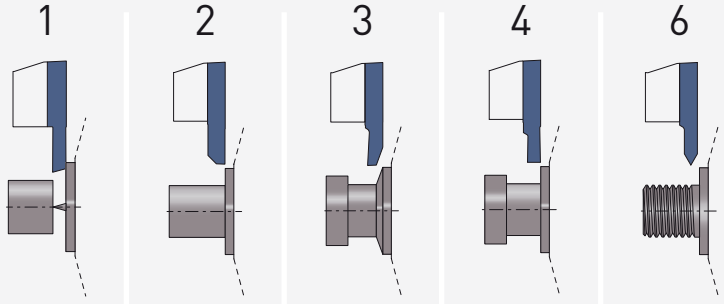
Dimension
Abmessung
Dimension

Rayon
Radius
Radius

Nuance
Sorte
Grade

Géométrie de coupe	brise-copeaux	particularités
Schneidgeometrie	Spanbrecher	Sondereigenschaften
Cutting geometry	chip breaker	special features

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry

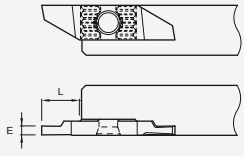


Gamme de produit	définit la compatibilité des plaquettes avec le porte-outil
Produktserie	bestimmt die WSP und Halter Kompatibilität
Product series	shows the inserts and holder compatibility

L = 5 (chiffre impair / ungerade Zahl / uneven number)

R = 6 (chiffre pair / gerade Zahl / even number)

L	R
250	260

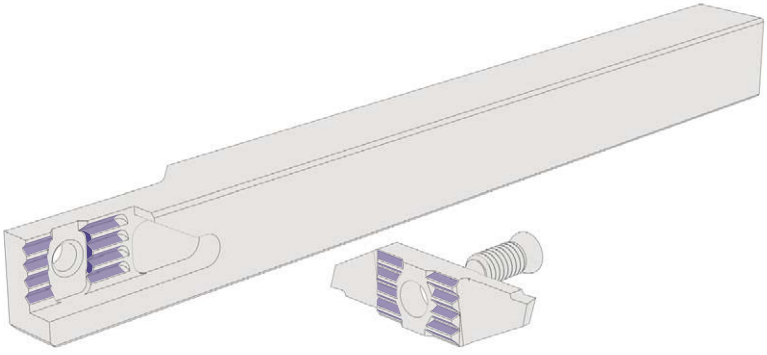


E max = 3.0 mm
L max = 8.5 mm

Applitec série 200	Système de serrage à denture avec 1 vis de fixation
Applitec 200 Serie	Spannsystem mit Verzahnung und 1 Schraube
Applitec 200 series	Teeth clamping system with 1 screw

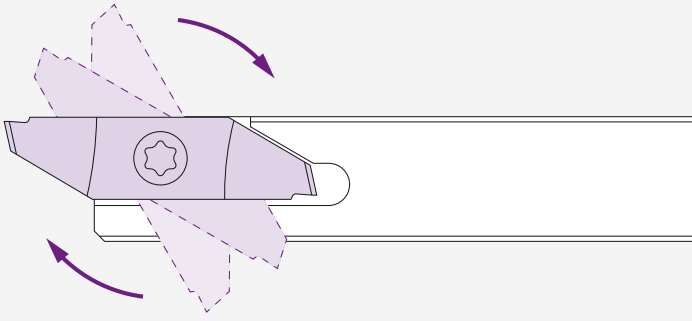
Economic performance!

Système de serrage à denture Applitec avec repositionnement au centre
Applitec-Zahnklemmsystem mit zentraler Neupositionierung
Applitec toothed clamping system with central repositioning



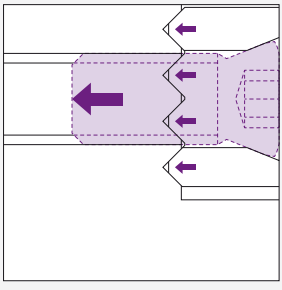
High precision

Grande précision lors du retournement de la plaquette
Hohe Präzision beim Wenden der Platte
High precision when flipping the insert



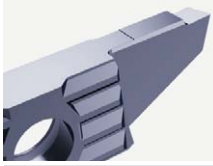
Applitec toothing

Système de serrage en fond de denture
Klemmvorrichtung an der Prothesenbasis
Clamping system at the denture base



µK20

AP302



K20

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

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- excellente nuance universelle
- 1er 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

µK20

AP202

K20

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

TF F **M** E

P ★★★★☆
M ★★★★☆
N ★★★☆☆
S ★★★☆☆

- nuance particulièrement adaptée aux faibles vitesses de coupe
- ancienne nuance, disponible uniquement sur demande

- besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten
- ältere Sorte, nur auf Anfrage erhältlich

- grade particularly suitable for low cutting speeds
- previous grade, available on request only

µK20

N

K20

Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

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

- zähe Feinkornsorte
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen

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

µK10

AH302

K10

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

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

- nuance très résistante à l'usure
- pour l'usinage en finition dans des conditions favorables des aciers, aciers inoxydables et alliages de titanes

- 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

µK10

HN

K10

Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

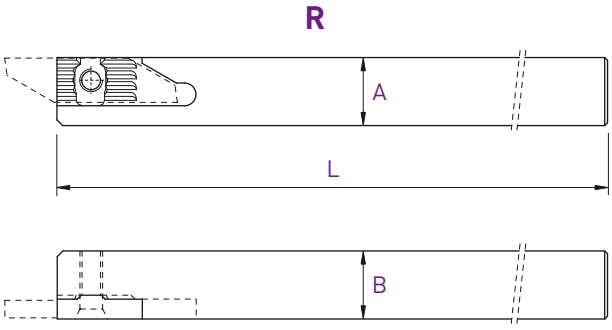
- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du titane faiblement allié
- déconseillé en cas de coupe interrompue et autres conditions d'usinage défavorables

- verschleissfeste Feinkornsorte
- für die Bearbeitung von niedrig legiertem Titan empfehlenswert
- 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

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

Matière Werkstoff Material		Tournage Drehen Turning		Tronçonnage Abstechen Parting off	
		VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15
Acier Stahl Steel < 600 N/mm²	P	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel < 800 N/mm²	P	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel > 800 N/mm²	P	50 - 100	0.01 - 0.12	40 - 80	0.01 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	M	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.08
Aluminium	N	180 - 800	0.01 - 0.30	150 - 300	0.01 - 0.20
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	N	100 - 500	0.01 - 0.30	100 - 300	0.01 - 0.20
Titane Titan Titanium	S	30 - 70	0.01 - 0.12	30 - 50	0.01 - 0.06



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

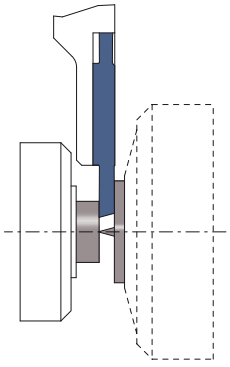
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

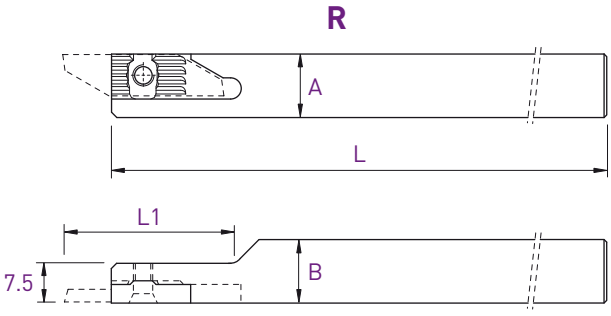
Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

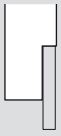
Each holder is supplied with one or more screws.
The keys must be ordered separately.

Porte-outils
Halter
Holders

260-C





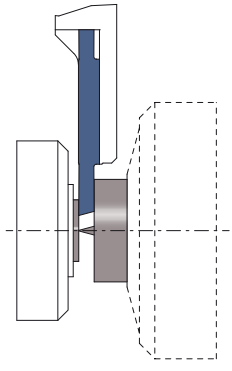


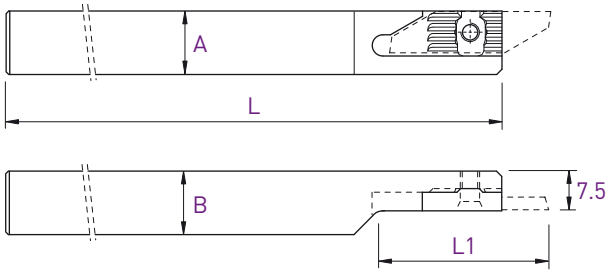
A x B	L	L1	Art. N°
12 x 12	130	30	**260-C-12**

Porte-outils
Halter
Holders

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

250RC





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

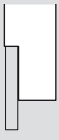
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

Each holder is supplied with one or more screws.
The keys must be ordered separately.

L (R)

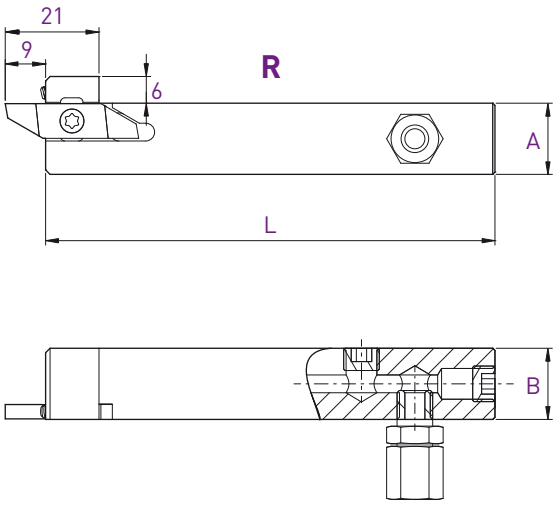
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

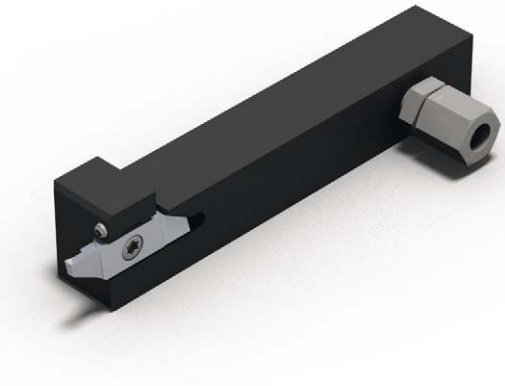


A x B	L	L1	Art. N°
12 x 12	130	30	**250RC-12**
16 x 16	130	40	**250RC-16**

250-JET / 260-JET

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



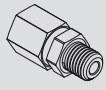


		L	R
A x B	L	Art. N°	Art. N°
10 x 12	100	**250-1012-JET**	**260-1012-JET**
12 x 12	100	**250-12-JET**	**260-12-JET**
16 x 16	100	**250-16-JET**	**260-16-JET**
20 x 20	100	**250-20-JET**	**260-20-JET**

Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

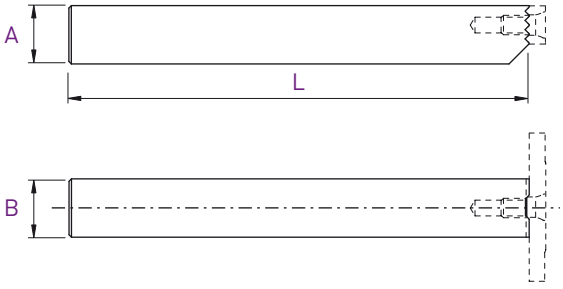
Each holder is supplied with one or more screws.
The keys must be ordered separately.

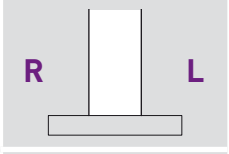
Pièces de rechange Ersatzteile Spare parts			Buse Düse Nozzle
	Art. N°	Art. N°	Art. N°
250-JET / 260-JET	**J-M8X1-D6**	**JB-M8X1**	**JJ-M3X6-D1.5**

Porte-outils
Halter
Holders

260/250F

L / R



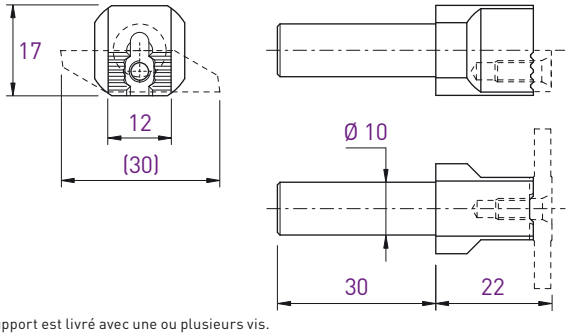


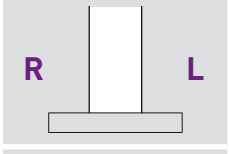
A x B	L	Art. N°
10 x 12	120	**260/250F-1012**
12 x 12	120	**260/250F-1212**

Porte-outils
Halter
Holders

260/250-D

L / R



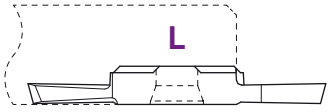


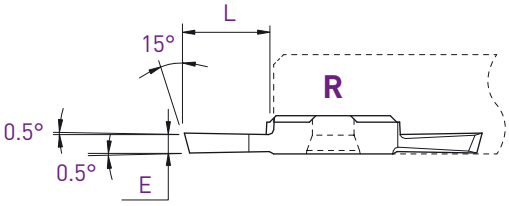
Art. N°
260/250-D10

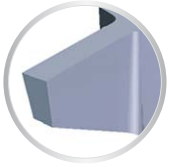
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

Each holder is supplied with one or more screws.
The keys must be ordered separately.





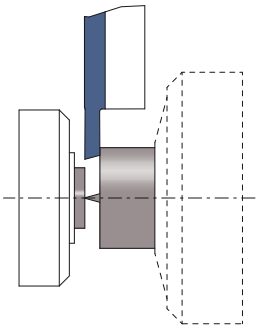


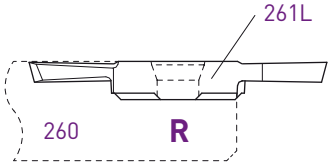
		L				R			
E	L	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
0.8	4	**251-0.8**	●	●	●	**261-0.8**	●	●	●
1.0	5	**251-1.0**	●	●	●	**261-1.0**	●		●
1.2	5	**251-1.2**	●	●	●	**261-1.2**	●	●	●
1.5	7	**251-1.5**	●		●	**261-1.5**	●		●
2.0	8.5	**251-2.0**	●		●	**261-2.0**	●		●
2.5	8.5	**251-2.5**	●	●	●	**261-2.5**	●		●

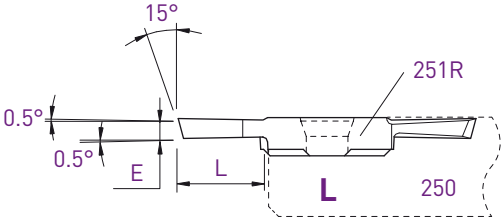
Tronçonnage
Abstechen
Parting off

Coupe déportée
Versetztes Schneiden
Cut off line

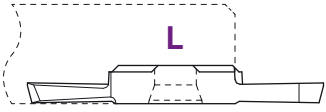
261L / 251R

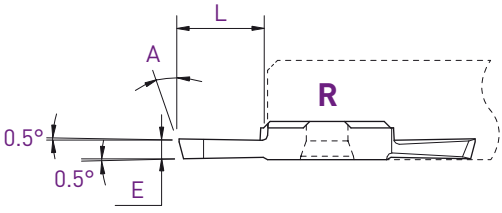


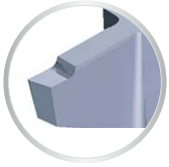




		R (L) Coupe à gauche déportée Versetztes Linksschneiden Left cut off line				L (R) Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line			
E	L	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
1.0	5	-				**251R-1.0**	●		●
1.5	7	-				**251R-1.5**	●	●	●
2.0	8.5	**261L-2.0**	●	●	●	**251R-2.0**	●		●





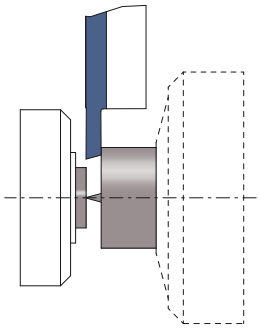


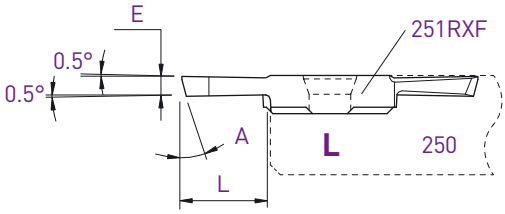
				L				R			
a	E	L	A	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
4°	1.0	4	15°	-				261XF-1.0	●		●
6°	1.0	4	8°	-				261XF6°-1.0-8°	●		●
4°	1.5	7	15°	251XF-1.5	●		●	261XF-1.5	●	●	●
4°	2.0	8.5	15°	251XF-2.0	●	●	●	261XF-2.0	●	●	●

Tronçonnage
Abstechen
Parting off

Coupe déportée
Versetztes Schneiden
Cut off line

251RXF





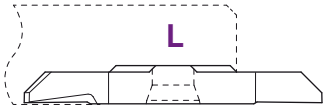
L (R)

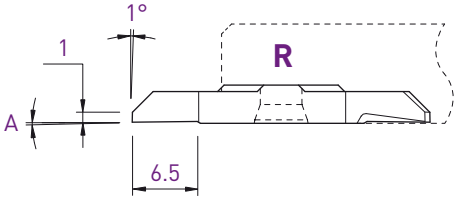
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

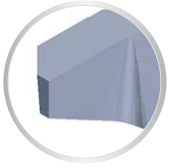
a	E	L	A	Art. N°	AP302	AP202	N (µK20)
6°	1.0	4	8°	**251RXF6°-1.0-8°**	●		●
4°	1.5	7	15°	**251RXF-1.5**	●	●	●
4°	2.0	8.5	15°	**251RXF-2.0**	●		●

252 / 262

Tournage avant
Vorwärts drehen
Front turning



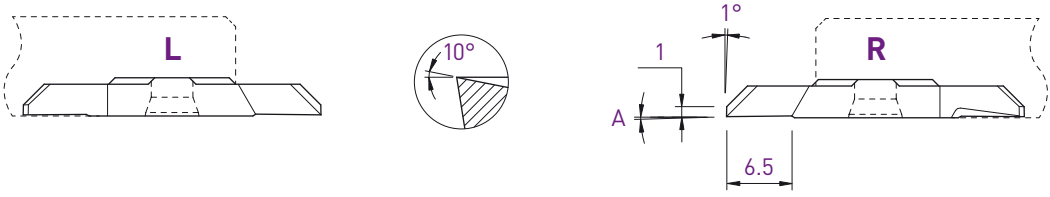


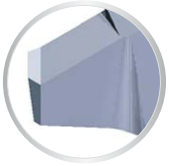


	L				R			
A	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)
0°	252	●	●	●	262	●		●
2°	252-2°	●	●	●	262-2°	●	●	●

Tournage avant
Vorwärts drehen
Front turning

252X / 262X

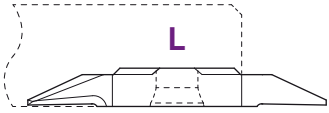


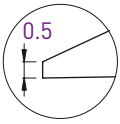


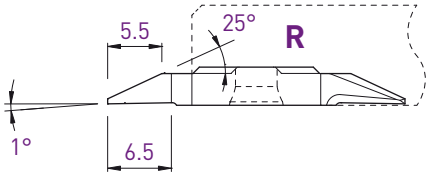
	L			R		
A	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
0°	252X	●	●	●	262X	●		●
2°	252X-2°	●	●	●	262X-2°	●	●	●

252S / 262S

Tournage avant
Vorwärts drehen
Front turning



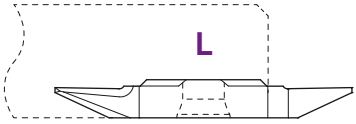


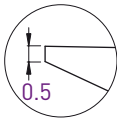


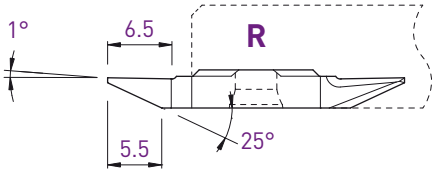
L				R			
Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
252S05	●	●	●	262S05	●	●	●

Tournage arrière
Rückwärts drehen
Back turning

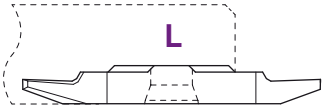
253S / 263S

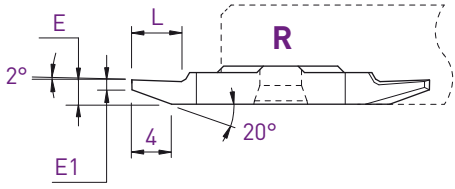






L				R			
Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
253S05	●	●	●	263S05	●	●	●

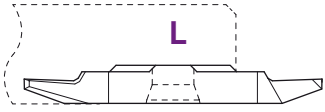


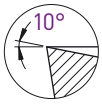


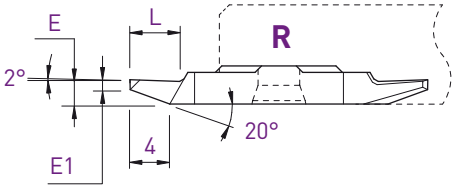
			L				R			
E	E1	L	Art. N°	P M N S AP302	P M N S AP202	N N (µk20)	Art. N°	P M N S AP302	P M N S AP202	N N (µk20)
2.0	0.5	4	**253-0.5**	●	●	●	**263-0.5**	●		●
2.5	1.0	5	**253-1.0**	●	●	●	**263-1.0**	●		●

Tournage arrière
Rückwärts drehen
Back turning

253X / 263X



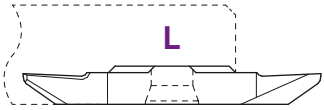


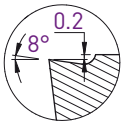


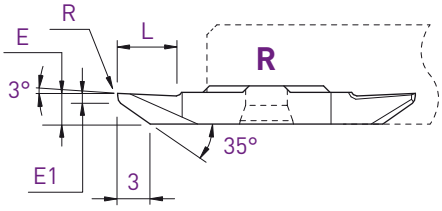
			L				R			
E	E1	L	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
2.0	0.5	5	**253X-0.5**	●	●	●	**263X-0.5**	●	●	●
2.5	1.0	5	**253X-1.0**	●	●	●	**263X-1.0**	●		●

253VX-8° / 263VX-8°

Tournage arrière
Rückwärts drehen
Back turning



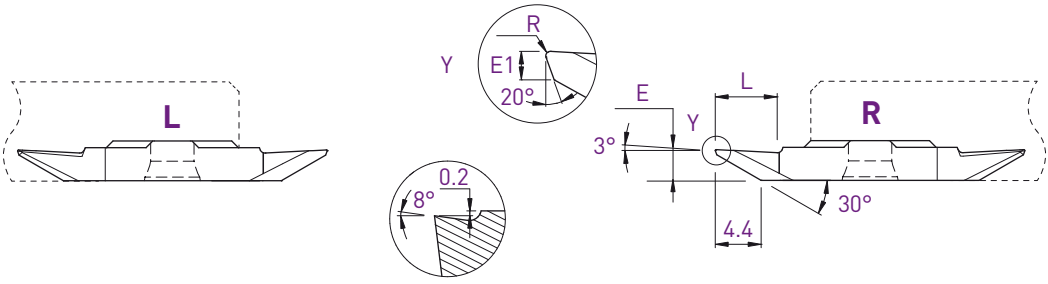




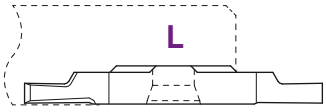
L								R						
E	E1	L	R	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)	AH302	HN (µK10)
3.1	1.0	6	0	**253VX-8°**	●	●	●	**263VX-8°**	●		●		
3.1	1.0	6	0.08	-				**263VX-8°-R08**	●	●	●	●	●
3.1	1.0	6	0.20	-				**263VX-8°-R20**	●		●	●	●

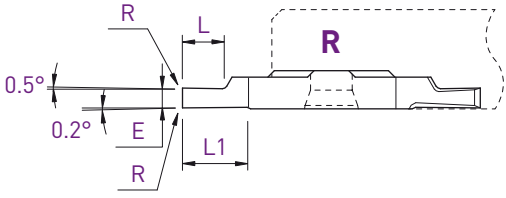
Tournage arrière
Rückwärts drehen
Back turning

253VX-805 / 263VX-805

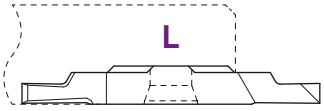


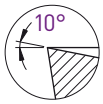
				L				R					
E	E1	L	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)	AH302	HN (µk10)
3.0	0.5	6	0.08	**253VX-805-R08**	●	●	●	**263VX-805-R08**	●		●	●	●

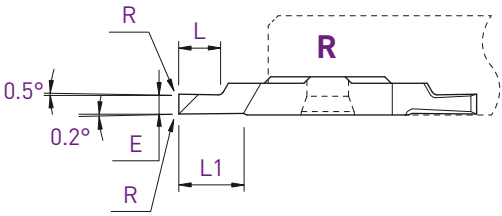


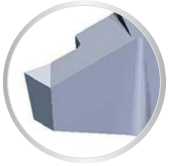


				L				R			
E	L	L1	R	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
0.8	2	4	0	**254-0.8**	●		●	**264-0.8**	●		●
1.0	2.5	4	0	**254-1.0**	●	●	●	**264-1.0**	●		●
1.2	3	4	0	**254-1.2**	●	●	●	**264-1.2**	●	●	●
1.5	3	4	0	**254-1.5**	●	●	●	**264-1.5**	●		●
1.8	4	6.5	0	-				**264-1.8**	●	●	●
2.0	4	6.5	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**	●	●	●

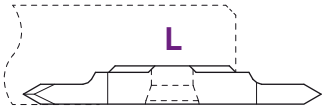


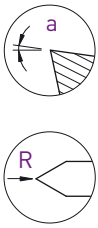


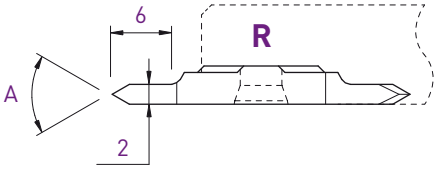




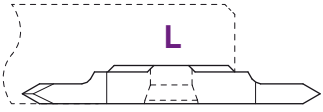
				L				R					
E	L	L1	R	Art. N°	AP302	AP202	N (µk20)	Art. N°	AP302	AP202	N (µk20)	AH302	HN (µk10)
0.8	2	4	0	**254X-0.8**	●	●	●	**264X-0.8**	●	●	●		
1.0	2.5	4	0	**254X-1.0**	●	●	●	**264X-1.0**	●	●	●		
1.0	2.5	4	0.08	-				**264X-1.0-R08**	●	●	●	●	●
1.2	3	4	0	**254X-1.2**	●	●	●	**264X-1.2**	●	●	●		
1.5	3	4	0	**254X-1.5**	●	●	●	**264X-1.5**	●		●		
1.5	3	4	0.08	-				**264X-1.5-R08**	●	●	●	●	●
1.5	3	4	0.20	-				**264X-1.5-R20**	●	●	●	●	●
2.0	4	6.5	0	**254X-2.0**	●		●	**264X-2.0**	●	●	●		
2.0	4	6.5	0.08	-				**264X-2.0-R08**	●	●	●	●	●
2.0	4	6.5	0.20	-				**264X-2.0-R20**	●		●	●	●
2.5	6	6.5	0	**254X-2.5**	●	●	●	**264X-2.5**	●	●	●		
2.5	6.5	6.5	0.08	-				**264X-2.5-R08**	●	●	●	●	●
2.5	6.5	6.5	0.20	-				**264X-2.5-R20**	●	●	●	●	●
3.0	6.5	6.5	0	**254X-3.0**	●	●	●	**264X-3.0**	●		●		
3.0	6.5	6.5	0.08	-				**264X-3.0-R08**	●	●	●	●	●
3.0	6.5	6.5	0.20	-				**264X-3.0-R20**	●	●	●	●	●

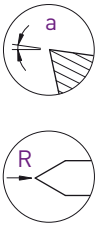


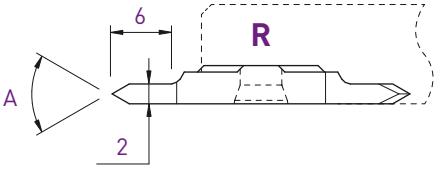




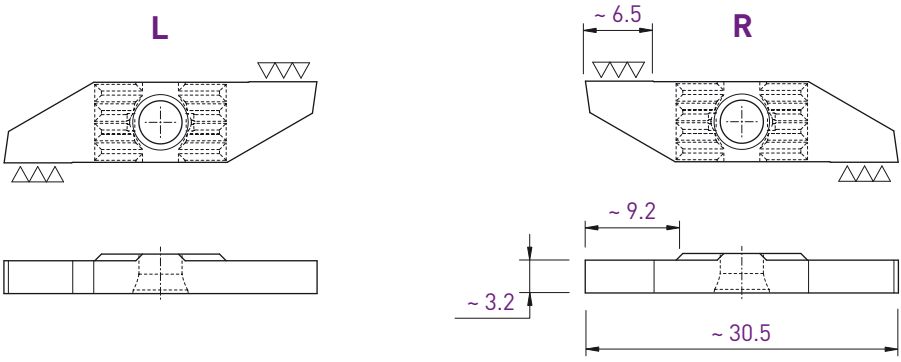
			L				R			
A	R	a	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
60°	0	0°	**256-60-2.0**	●		●	**266-60-2.0**	●		●
60°	0.06	3°	**256-AG60°**	●	●	●	**266-AG60°**	●		●



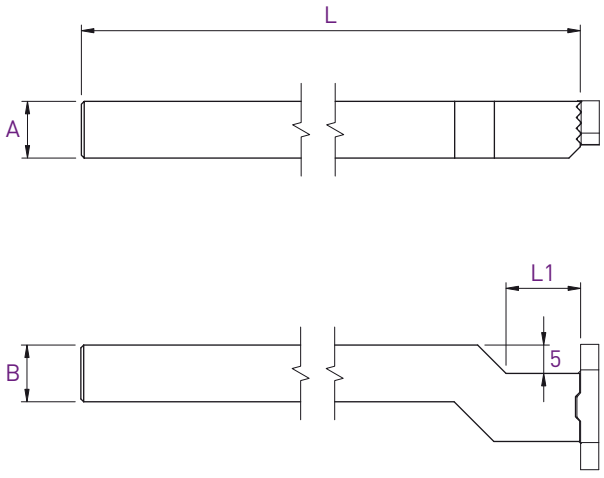


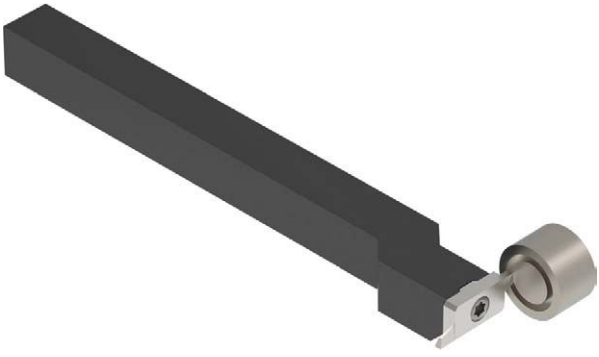


			L				R			
A	R	a	Art. N°	AP302	AP202	N (µK20)	Art. N°	AP302	AP202	N (µK20)
55°	0	0°	**256-55-2.0**	●	●	●	**266-55-2.0**	●	●	●
55°	0.06	3°	**256-AG55°**	●	●	●	**266-AG55°**	●	●	●



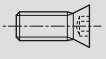
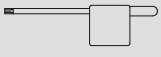
L						R					
Art. N°	P M N S AP302	P M N S AP202	N (µk20)	P M N S AH302	N HN (µk10)	Art. N°	P M N S AP302	P M N S AP202	N (µk20)	P M N S AH302	N HN (µk10)
251-E	●	●	●	●	●	261-E	●		●	●	●





R

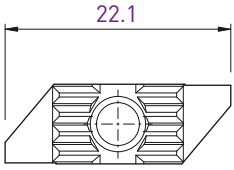
A x B	L	L1	Art. N°
8x10	130	13	**250RFG-0810**
10x10	130	13	**250RFG-1010**
12x12	130	13	**250RFG-1212**
16x16	130	16	**250RFG-1616**

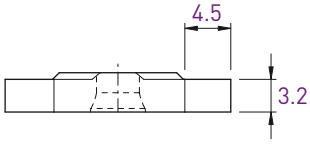
Pièces de rechange Ersatzteile Spare parts	Options
	
Art. N°	**Art. N°**
V-M4X9-T15	**C-T15**

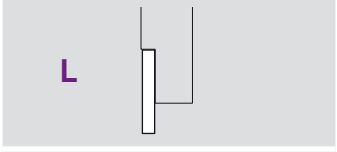
Chaque support est livré avec une ou plusieurs vis.
Les clés sont à commander séparément.

Jeder Halter wird mit einer oder mehreren Schrauben geliefert.
Die Schlüssel sind separat zu bestellen.

Each holder is supplied with one or more screws.
The keys must be ordered separately.



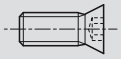
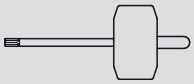




Art. N°	AP302 (P, M, N, S)	N (μk20) (N)
251RFG-EP	●	●

Plaquette ébauche pour porte-outils axial RFG (p. 6.29)
WSP-Rohling für axialen Halter RFG (S. 6.29)
Blank insert for axial holder RFG (p. 6.29)

Pièces de rechange et accessoires
Ersatzteile und Zubehöre
Spare parts and accessories

Porte-outils Halter Holders		Options		
			**Option** **Art. N°**	Recommandation de serrage Drehmoment Empfehlung Clamping recommendation
250-8 / 260-8	**V-M3.5X7.3-T15**			
250-... / 260-...				
260/250-...	**V-M4X9-T15**	**C-T15**	**SET-NM3.0-TX15**	3 Nm
250RFG				
250RC / 260-C	**V-M4X7.3-T15**			

Légende des symboles
Symbollegende
Symbol Legend

E	L	Art. N°	TiAlN	TiN	N (µK20)	HTA	HTiN	HN (µK10)
1.0	5	**731RU-1.0**	●		●			
1.2	5	**731RU-1.2**	●		●			
1.5	7	**731RU-1.5**	●		●	●		●
2.0	7	**731RU-2.0**	●		●			

● Article standard
Standardartikel
Standard item

P Acier
Stahl
Steel

M Inox
Rostfreistahl
Stainless steel

N Alliages d'aluminium et non ferreux
Aluminium- und Nichteisenlegierungen
Aluminium and non-ferrous alloys

S Titane et superalliages
Titan und Superlegierungen
Titanium and superalloys

H Acier trempé
Gehärteter Stahl
Hardened steel

K Fonte
Gusseisen
Cast iron

O Matière exotique
Exotisches material
Exotic material

Carbure
Hartmetall
Carbide

TiAlN

K20

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

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

TF — F — M — E

Épaisseur du revêtement
Dicken der Beschichtung
Thickness of the coating

TF Très fin
Sehr dünn
Very thin

F Fin
Dünn
Thin

M Moyen
Mittel
Medium

E Épais
Dick
Thick