PRO-Line

APPLITEC
CUTTING TOOLS

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SERIES 630 / 640

Tournage et gorge

Drehen und Einstechen

Turning and grooving

Porte-outils Halter Holders		**630 / 640**	> **5.12**
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SERIES 650 / 660

Tronçonnage

Abstechen

Parting off

Porte-outils Halter Holders		**650 / 660**	> **5.37**
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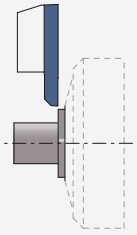
642



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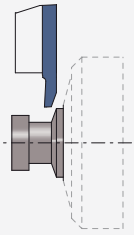

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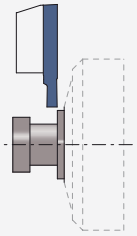

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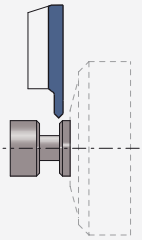

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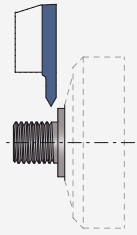

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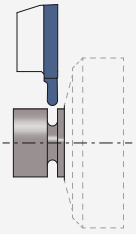

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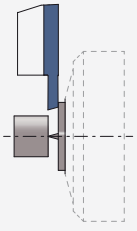
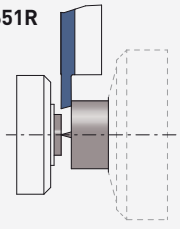


651R

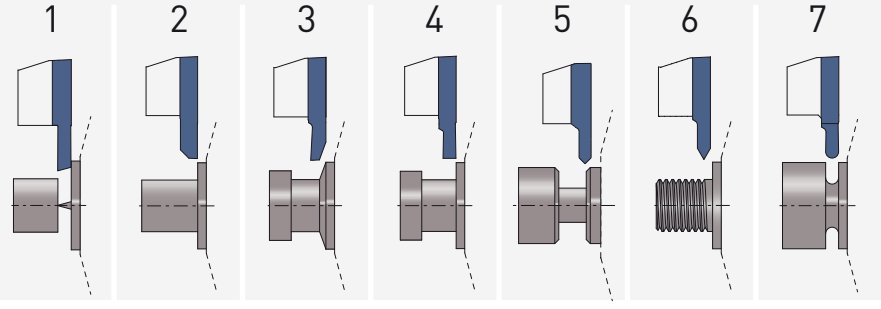


6	4	4	X	–	2.0	–	R15	–	TiAlN
					Dimension **Abmessung** **Dimension**		**Rayon** **Radius** **Radius**		**Nuance** **Sorte** **Grade**

Géométrie de coupe / **Schneidgeometrie** / **Cutting geometry**

brise-copeaux	particularités
Spanbrecher	Sondereigenschaften
chip breaker	special features

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry



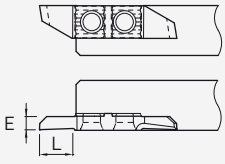
Gamme de produit définit la compatibilité des plaquettes avec le porte-outil
Produktserie bestimmt die WSP und Halter Kompatibilität
Product series shows the inserts and holder compatibility

L = 3, 5 (chiffre impair / ungerade Zahl / uneven number)
R = 4, 6 (chiffre pair / gerade Zahl / even number)

SERIES
Tournage et gorge
Drehen und Einstechen
Turning and grooving

E max = 3 mm
L max = 8 mm

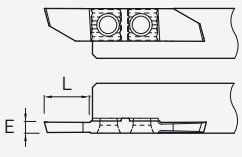
L 630 | R 640



SERIES
Tronçonnage
Abstechen
Parting off

E max = 2.5 mm
L max = 11 mm

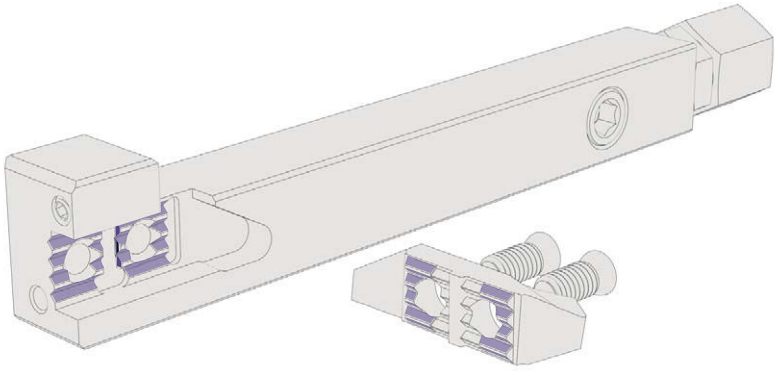
L 650 | R 660



Applitec série 600 Système de serrage à denture avec 2 vis de fixation
Applitec 600 Serie Spannsystem mit Verzahnung und 2 Schrauben
Applitec 600 series Teeth clamping system with 2 screws

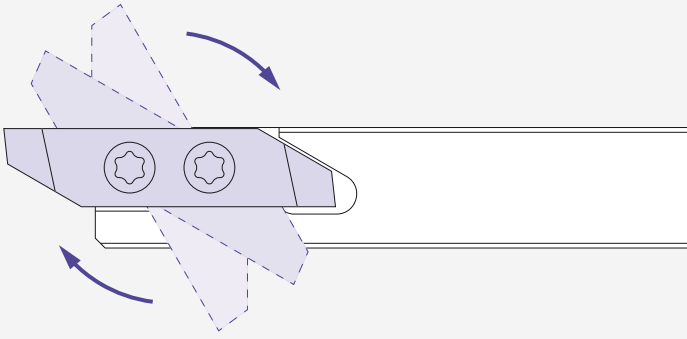
Rigid!

Système de serrage à denture Applitec avec repositionnement sur la nervure centrale.
Applitec-Verzahnungsspannsystem mit Neupositionierung auf der Zentralrippe.
Applitec toothed clamping system with repositioning on the central rib.



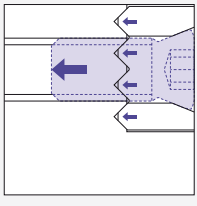
Ultra precision

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



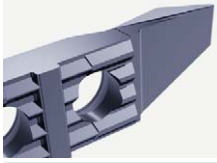
Applitec toothing

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



µK20

TiAlN



K20

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

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

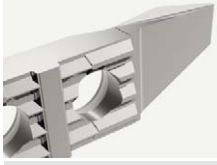
- excellente nuance universelle
- 1er choix pour l'usinage des aciers, aciers inoxydables et alliages de titane
- très bonne résistance à la température

- 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

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

Nuances
Sorten
Grades

µK10

HTA

K10

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

TF F **M** E

P ★★★★★
M ★★★★★
N ★★★★☆
S ★★★★☆

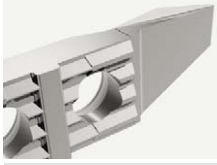
- nuance très résistante à l'usure
- pour l'usinage en finition dans des conditions favorables des aciers, aciers inoxydables et alliages de titane

- 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

µK10

HN



K10

Non revêtu
Unbeschichtet
Uncoated

P ★☆☆☆☆
M ★☆☆☆☆
N ★★★☆☆
S ★★★☆☆

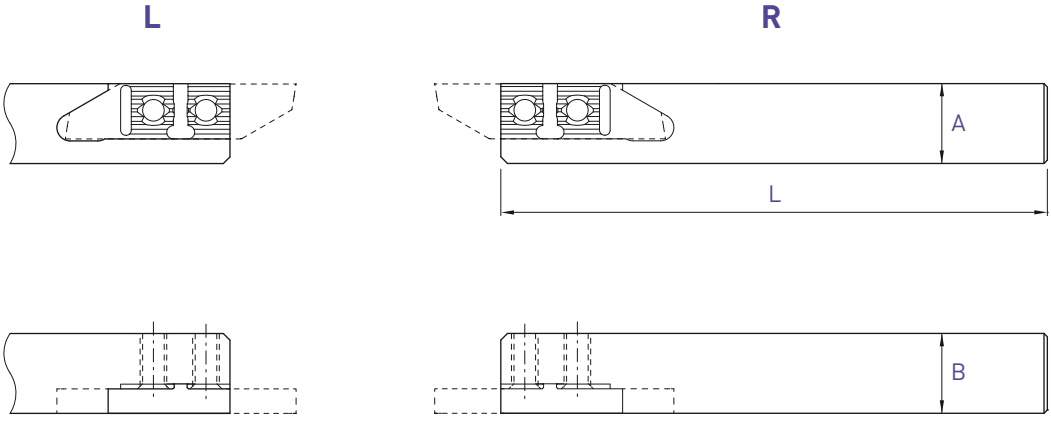
- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du titane faiblement allié
- déconseillé en cas de coupe interrompue et autres conditions d'usinage défavorables

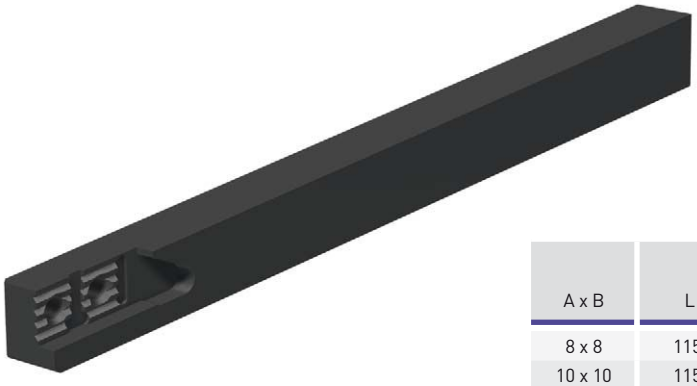
- verschleissfeste Feinkornsorte
- für die Bearbeitung von niedrig legiertem Titan empfehlenswert
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen nicht geeignet

- 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 **630/640**			Tronçonnage Abstechen Parting off **650/660**		
		VC (m/min)	Prof. de passe Schnitttiefe Depth of cut (mm)	Avance Vorschub Feed (mm/U)	VC (m/min)	Largeur de coupe Abstechbreite Cutting width (mm)	Avance Vorschub Feed (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	P	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/mm²	P	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/mm²	P	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/mm²	P	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	M	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%	N	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%	N	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
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	N	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
Titane Titan Titanium	S	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



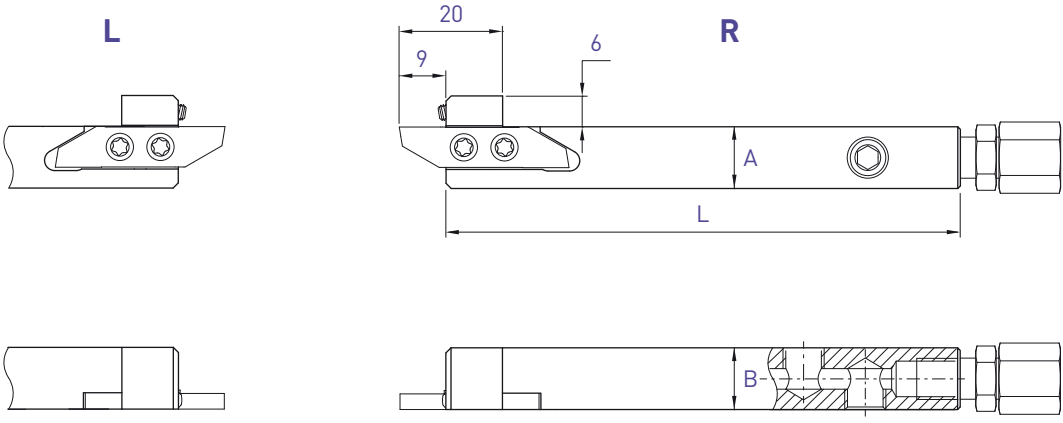


A x B	L	L Art. N°	R Art. N°
8 x 8	115	**630-8**	**640-8**
10 x 10	115	**630-10**	**640-10**
10 x 10	50	**630-10-50**	**640-10-50**
12 x 12	130	**630-12**	**640-12**
12 x 12	90	**630-12-90**	**640-12-90**
12.7 x 12.7	130	**630-12.7**	**640-12.7**
16 x 16	130	**630-16**	**640-16**
16 x 16	75	**630-16-75**	**640-16-75**
20 x 20	120	**630-20**	**640-20**

Chaque support est livré avec 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 avec arrosage intégré
Halter mit integrierter Kühlmittelzufuhr
Holders with integrated coolant supply

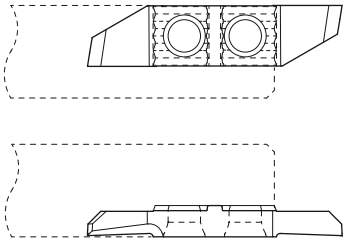
630-JET / 640-JET



A x B	L	L Art. N°	R 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, raccord droit et buse d'arrosage Ø 1.5 mm. Les clés sont à commander séparément.
Jeder Halter wird mit Spannschraube(n), gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert. Die Schlüssel sind separat zu bestellen.
Screw(s), straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder. The keys must be ordered separately.

L



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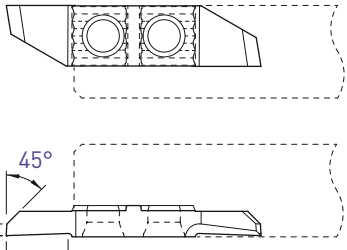
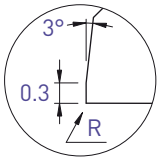
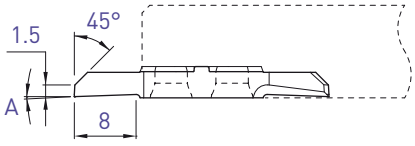
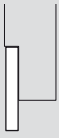
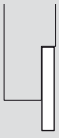


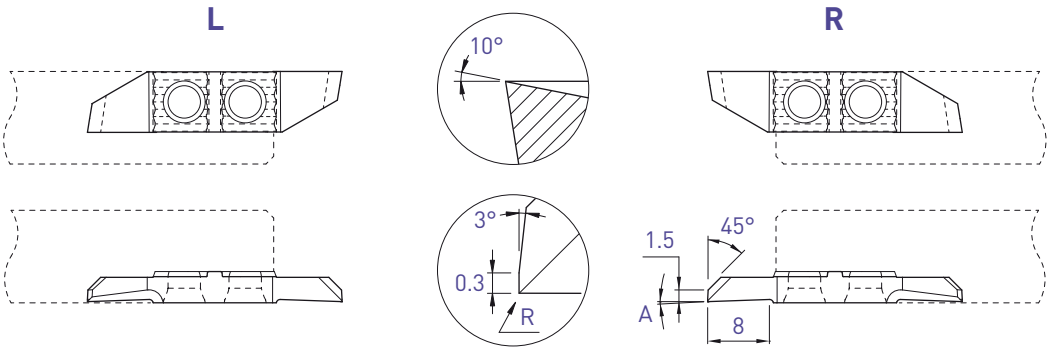


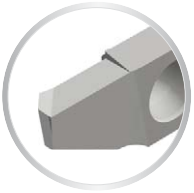


		L 					R 				
A	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0°	0	**632**	●	●			**642**	●	●		
0°	0.08	**–**					**642-R08**	●	●		
0°	0.15	**–**					**642-R15**	●	●	●	
2°	0	**632-2°**	●	●			**642-2°**	●	●	●	
2°	0.08	**–**					**642-2°-R08**	●	●		
2°	0.15	**–**					**642-2°-R15**	●	●		

Tournage avant
Vorwärts drehen
Front turning

632X / 642X



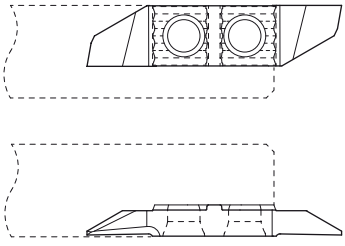


L							R					
A	R	Art. N°	P M N S TiAlN	N N (µk20)	P M N S HTA	N HN (µk10)	Art. N°	P M N S TiAlN	N N (µk20)	P M N S HTA	N HN (µk10)
0°	0	**632X10**	●	●			**642X10**	●	●		
0°	0.08	–					**642X10-R08**	●	●		
0°	0.15	–					**642X10-R15**	●	●		
2°	0	**632X10-2°**	●	●			**642X10-2°**	●	●		
2°	0.08	–					**642X10-2°-R08**	●	●		●
2°	0.15	–					**642X10-2°-R15**	●	●	●	●

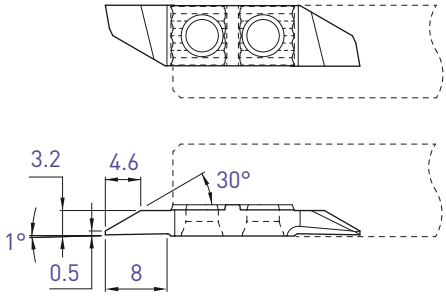
632S / 642S

Tournage multifonction
Mehrweck drehen
Multifunction turning

L



R



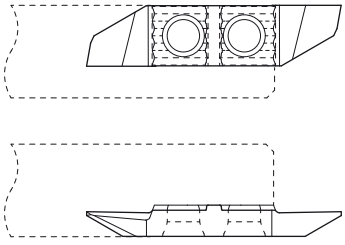
Tournage avant
Vorwärts drehen
Front turning

L					R				
Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
632S05	●	●			642S05	●	●	●	●

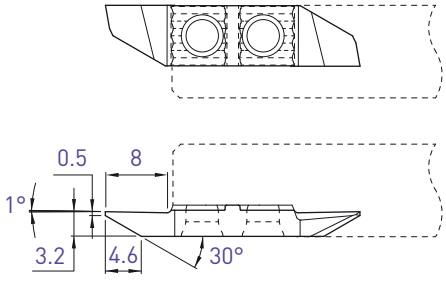
Tournage multifonction
Mehrweck drehen
Multifunction turning

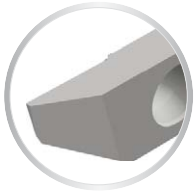
633S / 643S

L



R

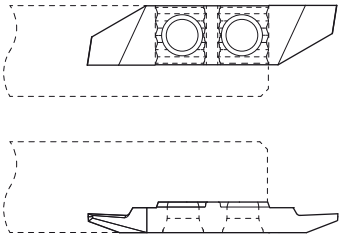




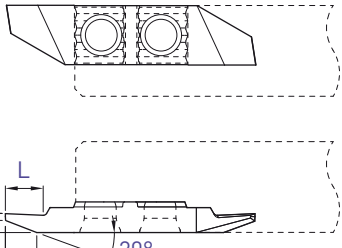
Tournage arrière
Rückwärts drehen
Back turning

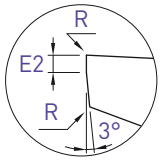
L						R					
Art. N°	P M N S	TiAlN	N (µk20)	P M N S	HTA	HN (µk10)	Art. N°	P M N S	TiAlN	N (µk20)	P M N S	HTA	HN (µk10)
633S05		●	●				643S05		●	●			●

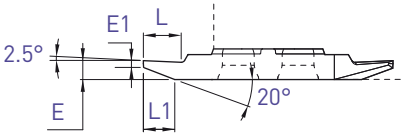
L



R



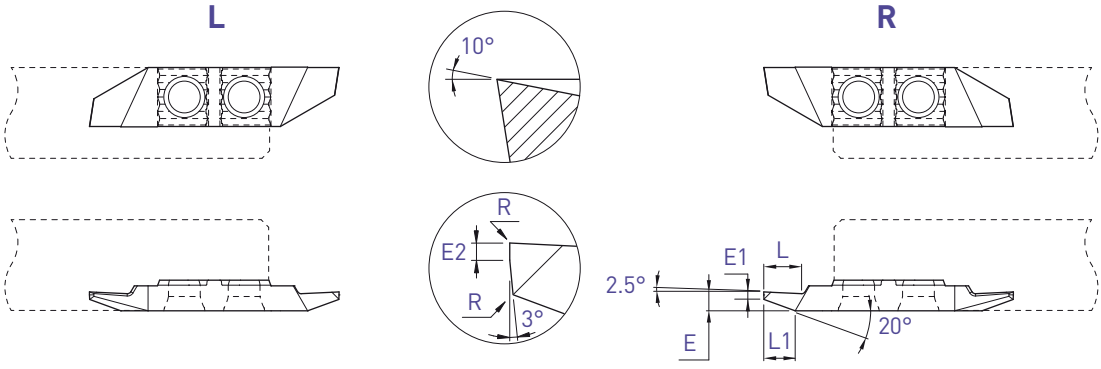




L											R				
E1	E2	L	L1	E	R	Art. N°	P M N S TiAlN	N (µk20)	P M N S HTA	N HN (µk10)	Art. N°	P M N S TiAlN	N (µk20)	P M N S HTA	N HN (µk10)
0.5	0.25	3	2.8	1.5	0	**633-0.5**	●	●			**643-0.5**	●	●		●
0.5	0.25	3	2.8	1.5	0.08	-					**643-0.5-R08**	●	●		
0.8	0.40	4.5	3.3	2.0	0	-					**643-0.8**	●	●		
0.8	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**	●	●		

Tournage arrière
Rückwärts drehen
Back turning

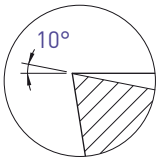
633X / 643X

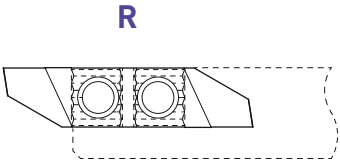


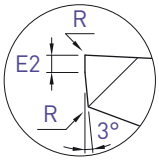
L										R				
E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.5	0.25	3	2.8	1.5	0	**633X10-0.5**	●	●			**643X10-0.5**	●	●	●	●
0.5	0.25	3	2.8	1.5	0.08	-					**643X10-0.5-R08**	●	●		
0.8	0.40	4.5	3.3	2.0	0	-					**643X10-0.8**	●	●		
0.8	0.40	4.5	3.3	2.0	0.08	-					**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**	●	●		

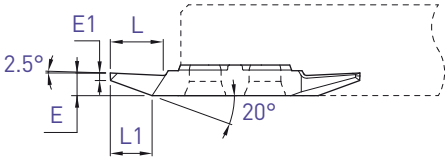
643XS

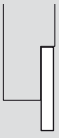
Tournage arrière
Rückwärts drehen
Back turning







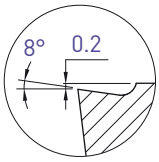


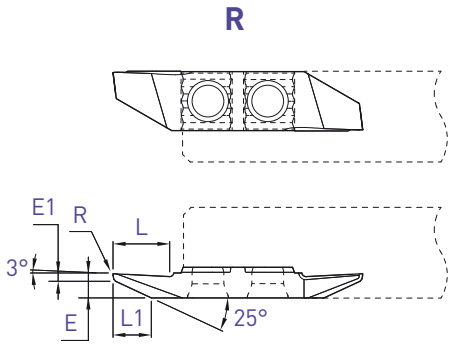


E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.0	0.4	7	5.5	3.0	0	**643X10S-1.0**	●	●		
1.0	0.4	7	5.5	3.0	0.08	**643X10S-1.0-R08**	●	●		

Tournage arrière
Rückwärts drehen
Back turning

643VX8



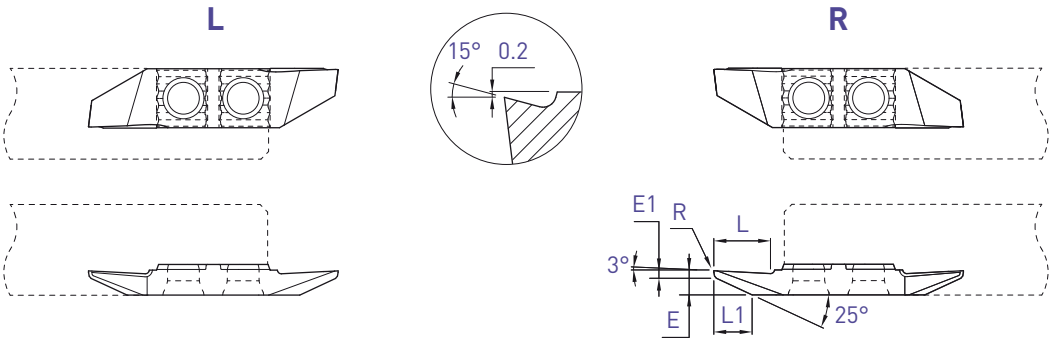


R

E1	L	L1	E	R	Art. N°	TiAlN	N (μk20)	HTA	HN (μk10)
1.0	7.5	5.0	3.2	0	**643VX8**	●	●		
1.0	7.5	5.0	3.2	0.08	**643VX8-R08**	●	●		

633VX15 / 643VX15

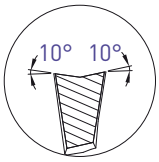
Tournage arrière
Rückwärts drehen
Back turning

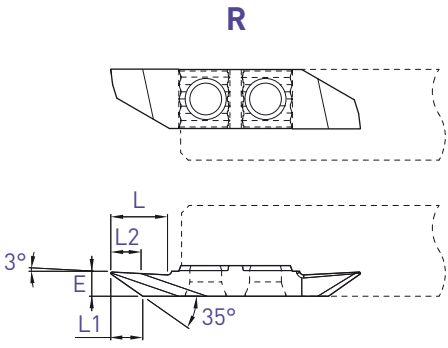


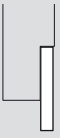
					L					R				
E1	L	L1	E	R	Art. N°	TiAlN	N (μk20)	HTA	HN (μk10)	Art. N°	TiAlN	N (μk20)	HTA	HN (μk10)
0.6	7.5	5.2	3.2	0	**633VX15**	●	●			**643VX15**	●	●		●
0.6	7.5	5.2	3.2	0.08	-					**643VX15-R08**	●	●		

Tournage arrière
Rückwärts drehen
Back turning

643VUX



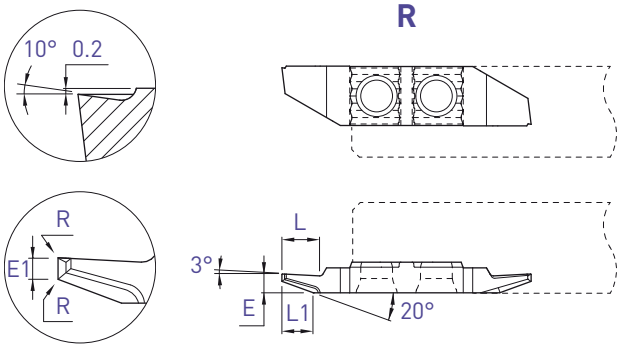




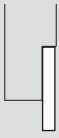
L	L1	L2	E	R	Art. N°	TiAlN	N (μk20)	HTA	HN (μk10)
7.5	4.2	4.0	3.2	0.15	**643VUX10-R15**	●	●	●	●
7.5	3.8	3.8	3.2	0.35	**643VUX10-R35**	●	●		

643ZX

Tournage arrière
Rückwärts drehen
Back turning

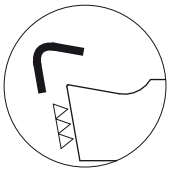


Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



R

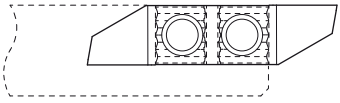
E1	L	L1	E	R	Art. N°	P M N S TiAlN	N N (µK20)
1.0	5	4	2.5	0.01	**643ZX10-1.0**	●	
1.0	5	4	2.5	0.08	**643ZX10-1.0-R08**	●	



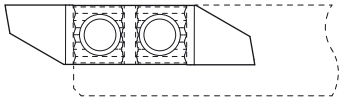
Arête de coupe honée
Gehonte Schneidkante
Honed edge

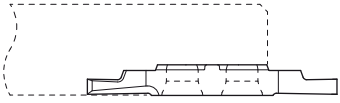
f min: 0.02 mm/U

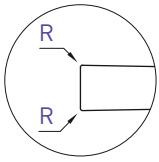
L

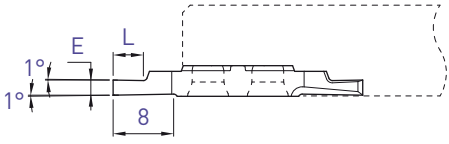


R

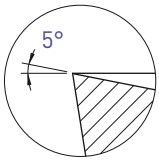


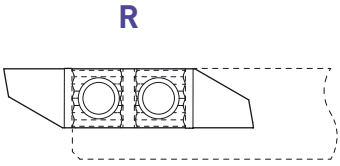


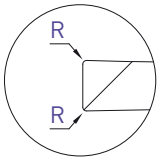


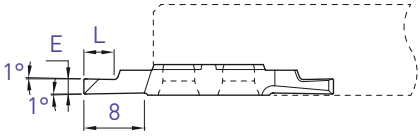


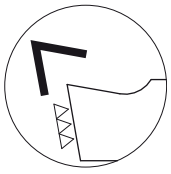
L							R			
E	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.5	1.5	0	**634-0.5**	●	●			**644-0.5**	●	●		
0.6	1.8	0	-					**644-0.6**	●	●		
0.75	2	0	-					**644-0.75**	●	●		●
0.8	2	0	**634-0.8**	●	●			**644-0.8**	●	●		
0.9	2.5	0	-					**644-0.9**	●	●		
0.95	3	0	-					**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	0.08	-					**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**	●	●		



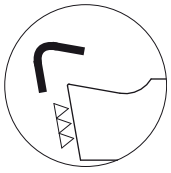






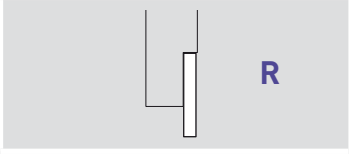


Arête de coupe vive
Scharfe Schneidkante
Sharp edge



Arête de coupe honée
Gehonte Schneidkante
Honed edge

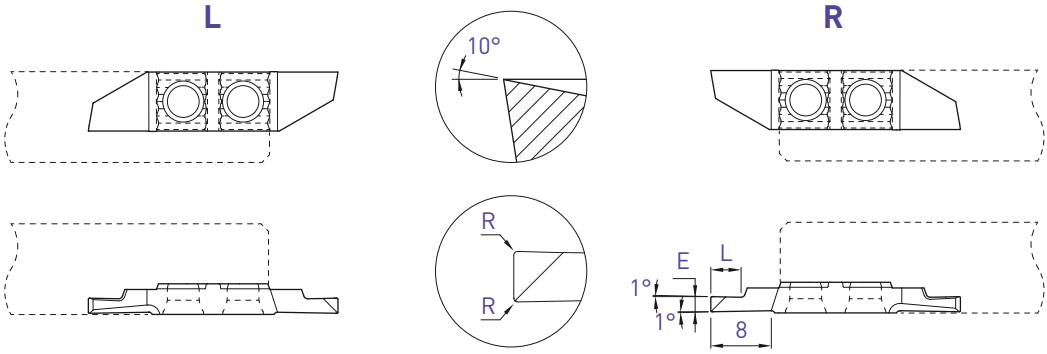
f min: 0.02 mm/U



E	L	R	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
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**	●	●		
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**	●	●		

Fonçage-tournage
Einstechen und drehen
Grooving and turning

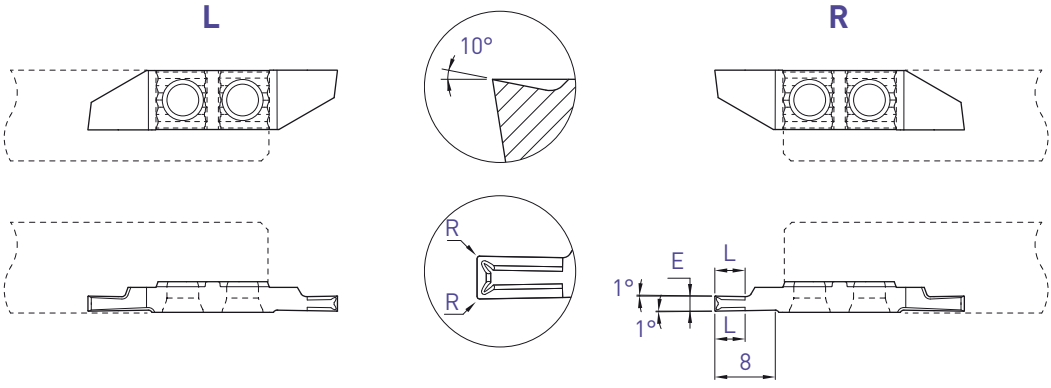
634X10 / 644X10



L							R				
E	L	R	Art. N°	P M N S TiAlN	N N (µK20)	P M N S HTA	N HN (µK10)	Art. N°	P M N S TiAlN	N N (µK20)	P M N S HTA	N HN (µK10)
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	●	●		

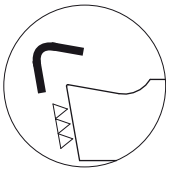
634ZXB / 644ZXB

Fonçage-tournage
Einstechen und drehen
Grooving and turning



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	●	

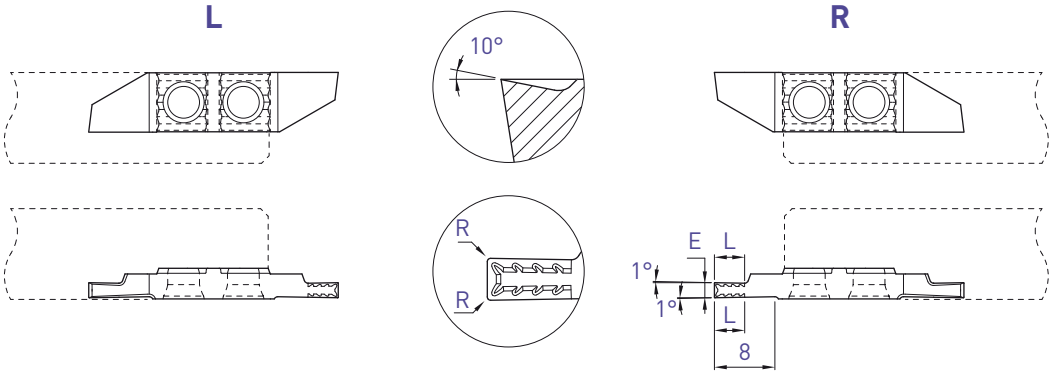


Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

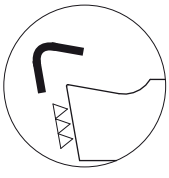
Fonçage-tournage
Einstechen und drehen
Grooving and turning

634ZXT / 644ZXT



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

			L			R		
E	L	R	Art. N°	P M N S TiAlN	N N N (µk20)	Art. N°	P M N S TiAlN	N N 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**	●	

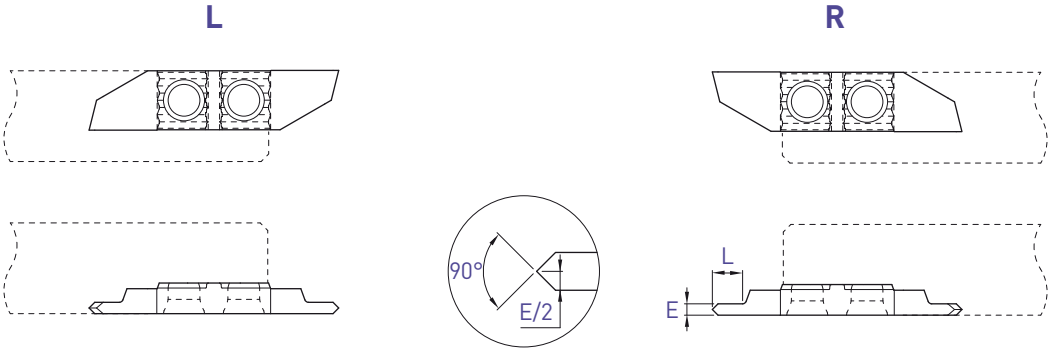


Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

635-90 / 645-90

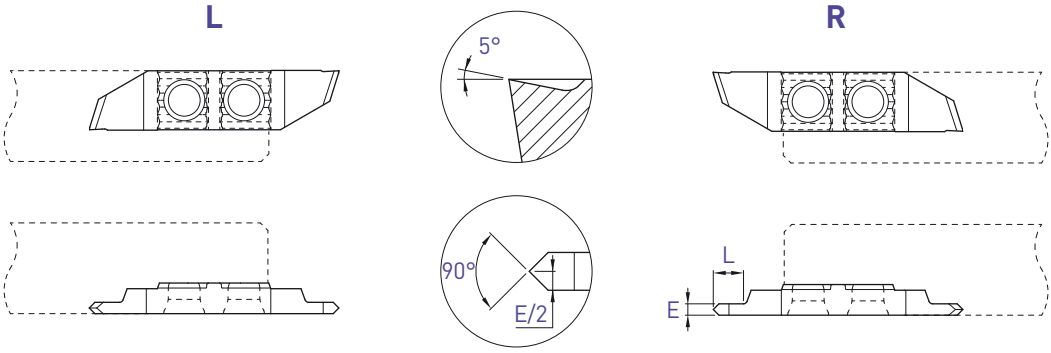
Chanfreinage
Anfasen
Chamfering



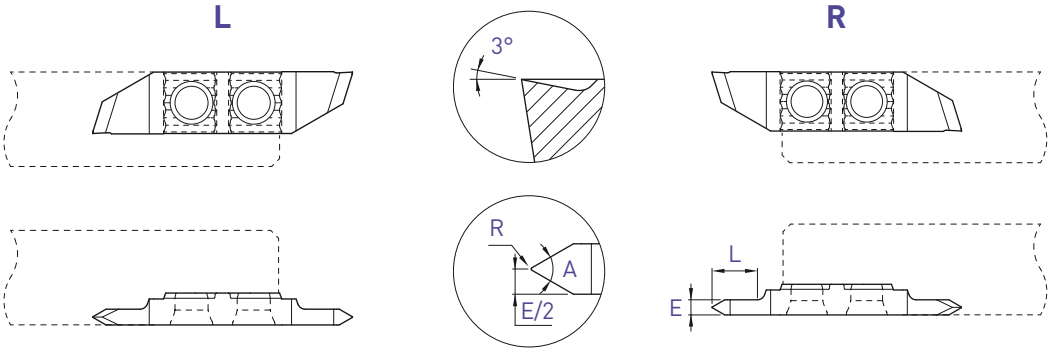
		L			R		
E	L	Art. N°	TiAlN	N (µk20)	Art. N°	TiAlN	N (µk20)
1.5	4	**635-90-1.5**	●	●	**645-90-1.5**	●	●

Chanfreinage
Anfasen
Chamfering

635X-90 / 645X-90

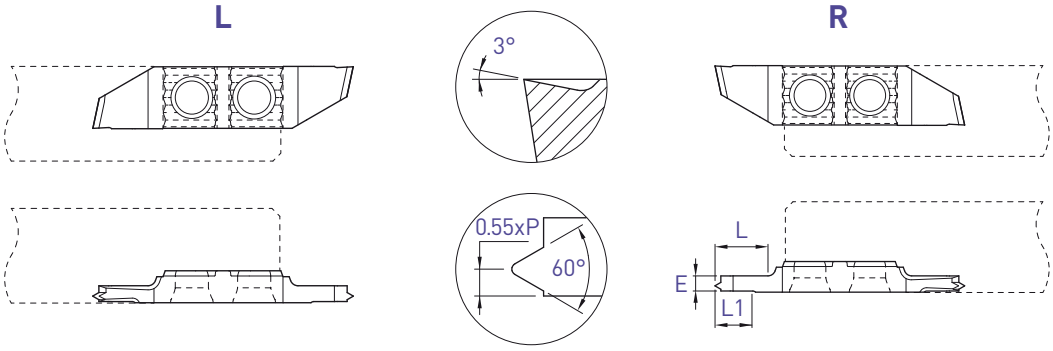


		L			R		
E	L	Art. N°	TiAlN	N (µk20)	Art. N°	TiAlN	N (µk20)
1.5	4	635X5-90-1.5	●	●	645X5-90-1.5	●	●



Profil partiel
Teilprofil
Partial profile

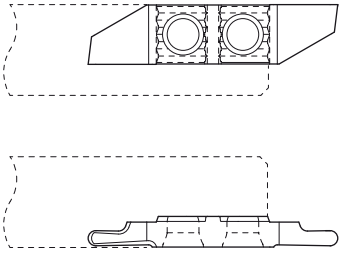
				L			R		
A	E	L	R	Art. N°	TiAlN	N (μk20)	Art. N°	TiAlN	N (μk20)
55°	1.5	4	0	636X3-55-1.5	●	●	646X3-55-1.5	●	●
55°	2.0	6	0.03	636X3-55-2.0-R03	●	●	646X3-55-2.0-R03	●	●
60°	1.5	4	0	636X3-60-1.5	●	●	646X3-60-1.5	●	●
60°	2.0	6	0.03	636X3-60-2.0-R03	●	●	646X3-60-2.0-R03	●	●
60°	2.0	6	0.06	636X3-60-2.0-R06	●	●	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	●	●



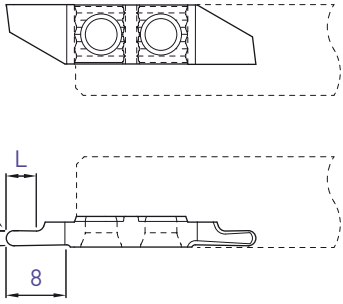
Profil complet métrique
Metrisches Vollprofil
Metric full profile

				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**	●	●

L



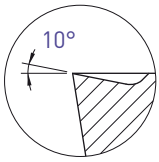
R

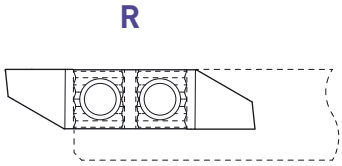


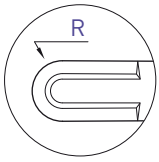
		L						R					
R	L	Art. N°	P M N S	N	P M N S	N		Art. N°	P M N S	N	P M N S	N	
			TiAlN	N (µk20)	HTA	HN (µk10)			TiAlN	N (µk20)	HTA	HN (µk10)	
0.25	1.5	-						647-R0.25	●	●			
0.4	2	-						647-R0.4	●	●			
0.5	2.5	637-R0.5	●	●				647-R0.5	●	●	●	●	
0.6	2.5	-						647-R0.6	●	●			
0.75	3	-						647-R0.75	●	●			
0.8	3	-						647-R0.8	●	●			
1.0	4	637-R1.0	●	●				647-R1.0	●	●			
1.5	6	-						647-R1.5	●	●			

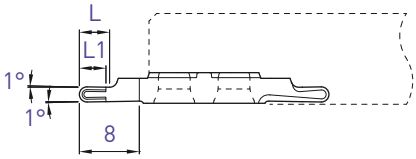
Plaquettes à rayon
Radius Wendeplatten
Radius inserts

647ZX10

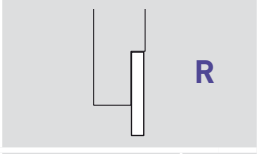




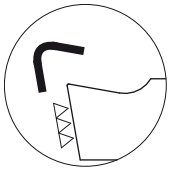




Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



R	L	L1	Art. N°	TiAlN	N (µk20)
1.0	4	3.5	**647ZX10-R1.0**	●	
1.5	6	4	**647ZX10-R1.5**	●	



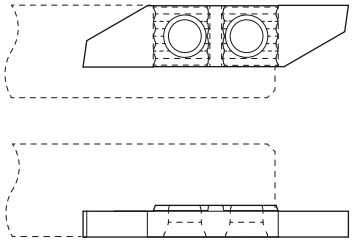
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

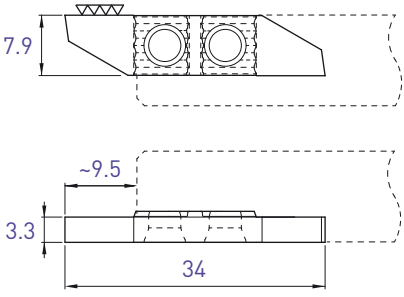
631-EP / 641-EP

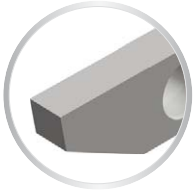
Plaquettes ébauches
WSP-Rohlinge
Blank inserts

L

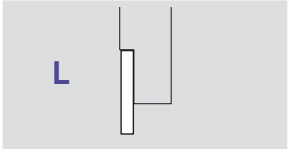


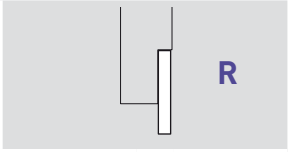
R





Face de coupe polie
Polierte Schneidfläche
Polished cutting face

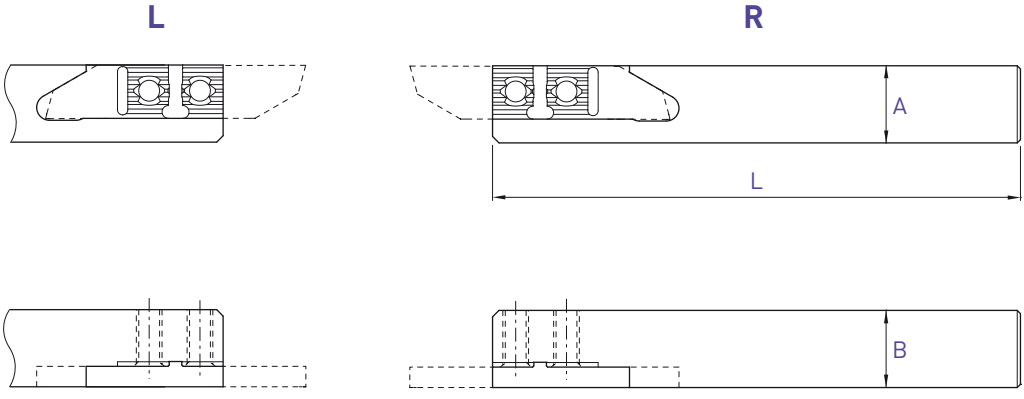




Art. N°	P M N S TiAlN	N (μk20)	P M N S HTA	HN (μk10)	Art. N°	P M N S TiAlN	N (μk20)	P M N S HTA	HN (μk10)
631-EP	●	●	●	●	641-EP	●	●	●	●

Porte-outils
Halter
Holders

650 / 660

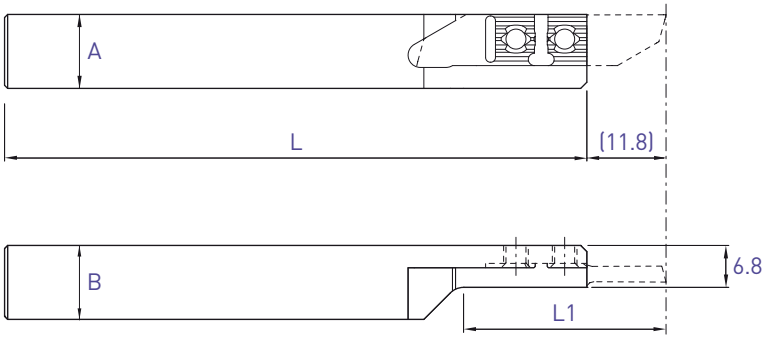


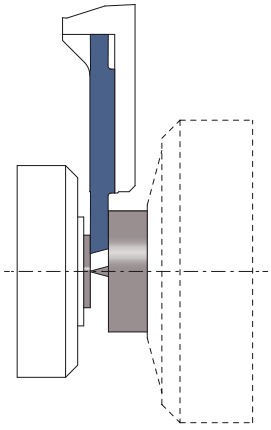
A x B	L	L Art. N°	R Art. N°
8 x 8	115	**650-8**	**660-8**
10 x 10	115	**650-10**	**660-10**
10 x 10	50	**650-10-50**	**660-10-50**
12 x 12	130	**650-12**	**660-12**
12 x 12	90	**650-12-90**	**660-12-90**
12.7 x 12.7	130	**650-12.7**	**660-12.7**
16 x 16	130	**650-16**	**660-16**
16 x 16	75	**650-16-75**	**660-16-75**
20 x 20	120	**650-20**	**660-20**

Chaque support est livré avec 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.

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

Voir dès page 5.39
Siehe ab Seite 5.39
See from page 5.39





L (R)

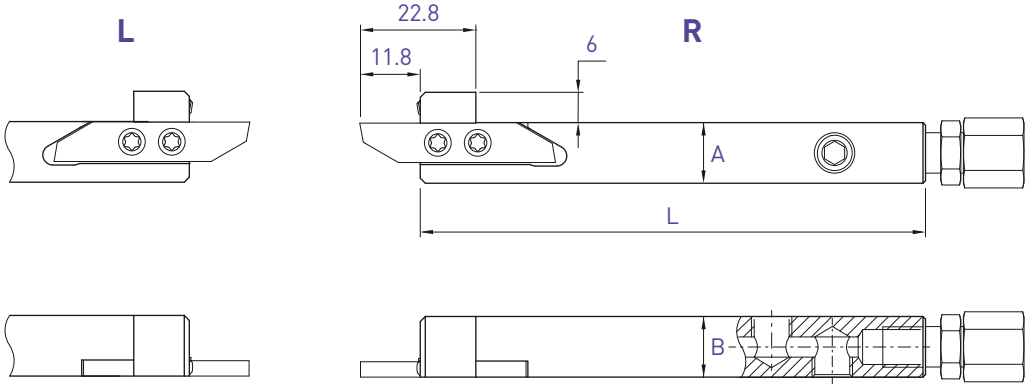
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

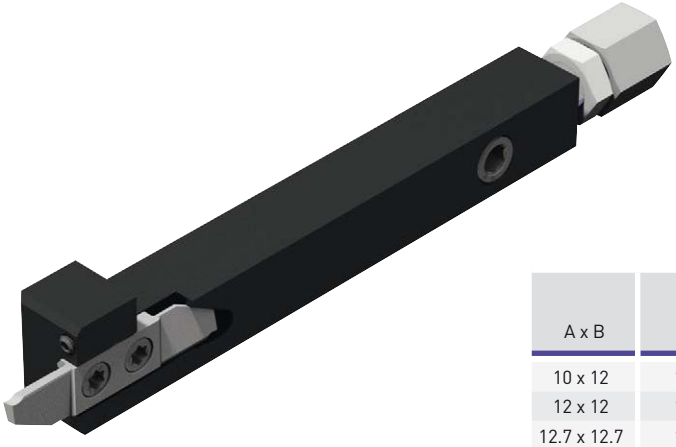
A x B	L	L1	Art. N°
10 x 10	115	32	**650RC-10**
12 x 12	130	32	**650RC-12**
16 x 16	130	42	**650RC-16**

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 avec arrosage intégré
Halter mit integrierter Kuhlmittelzufuhr
Holders with integrated coolant supply

650-JET / 660-JET

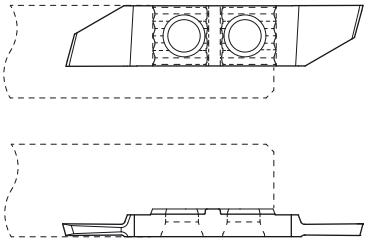




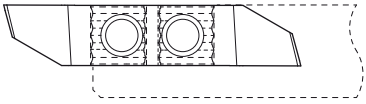
A x B	L	L Art. N°	R Art. N°
10 x 12	100	**650-1012-JET**	**660-1012-JET**
12 x 12	100	**650-12-JET**	**660-12-JET**
12.7 x 12.7	100	**650-12.7-JET**	**660-12.7-JET**
16 x 16	100	**650-16-JET**	**660-16-JET**
20 x 20	100	**650-20-JET**	**660-20-JET**

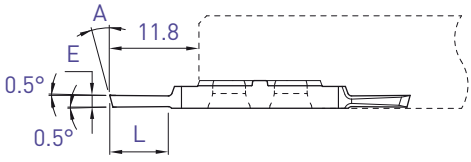
Chaque support est livré avec vis, raccord droit et buse d'arrosage Ø 1.5 mm. Les clés sont à commander séparément.
Jeder Halter wird mit Spannschraube(n), gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert. Die Schlüssel sind separat zu bestellen.
Screw(s), straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder. The keys must be ordered separately.

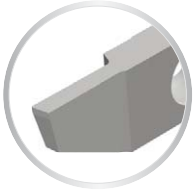
L



R



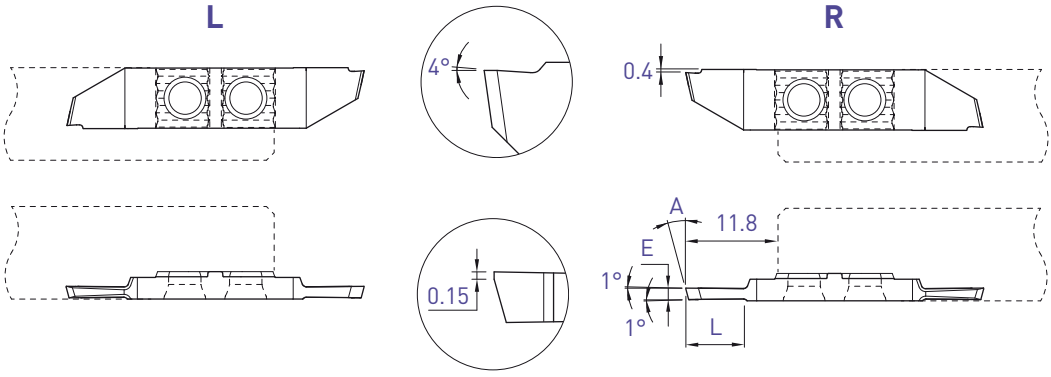




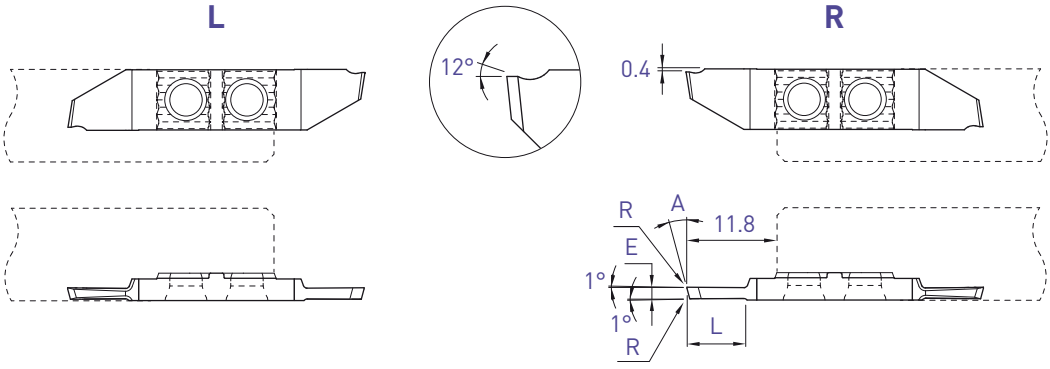
L								R				
E	A	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.8	20°	5	**651-0.8-20°**	●	●			**661-0.8-20°**	●	●	●	●
1.0	15°	5	–					**661-1.0-15°**	●	●		
1.0	20°	5	**651-1.0-20°**	●	●			**661-1.0-20°**	●	●		
1.2	15°	5	–					**661-1.2-15°**	●	●		
1.2	20°	5	**651-1.2-20°**	●	●			**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°**	●	●		

Tronçonnage
Abstechen
Parting off

651XF / 661XF



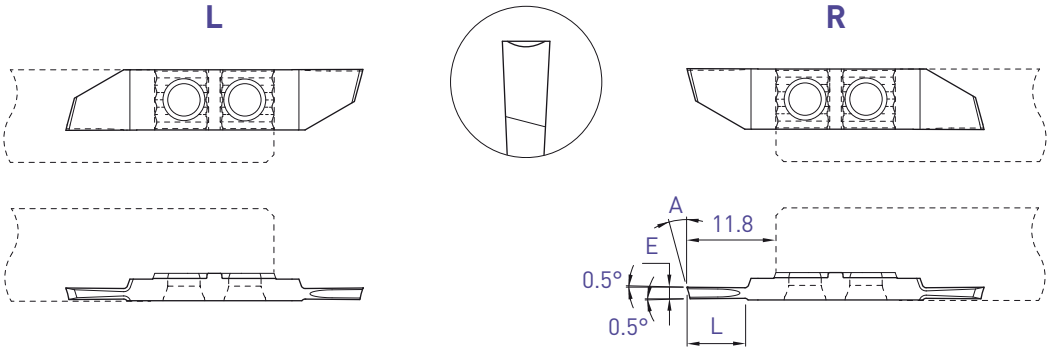
L								R				
E	A	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.5	15°	7.5	**651XF-1.5**	●	●			**661XF-1.5**	●	●		
2.0	15°	11	**651XF-2.0**	●	●			**661XF-2.0**	●	●		

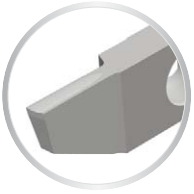


				L					R				
E	A	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.0	15°	5	0.03	**651X12-1.0**	●	●			**661X12-1.0**	●	●		
1.5	15°	7.5	0.03	**651X12-1.5**	●	●			**661X12-1.5**	●	●		
2.0	15°	11	0.03	**651X12-2.0**	●	●			**661X12-2.0**	●	●		

Tronçonnage
Abstechen
Parting off

651U / 661U

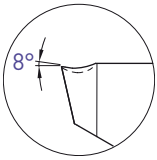


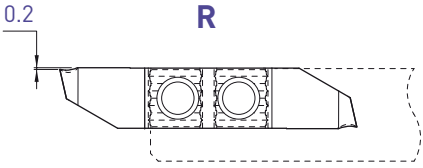


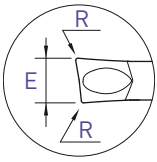
L						R		
E	A	L	Art. N°	P M N S TiAlN	N N (µk20)	Art. N°	P M N S TiAlN	N N (µk20)
1.5	15°	7.5	**651U-1.5**	●	●	**661U-1.5**	●	●
2.0	15°	11	**651U-2.0**	●	●	**661U-2.0**	●	●

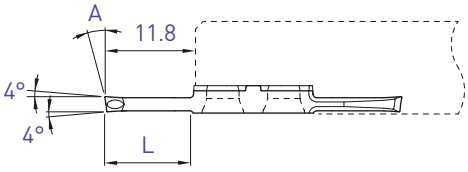
661ZU

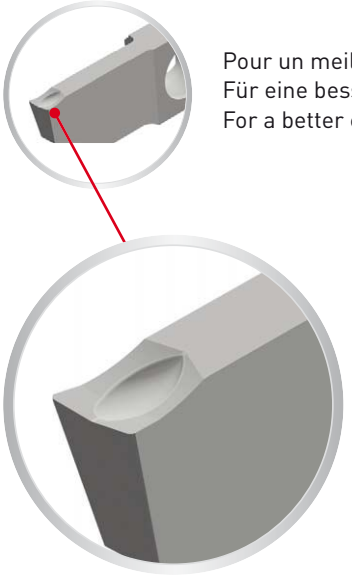
Tronçonnage
Abstechen
Parting off



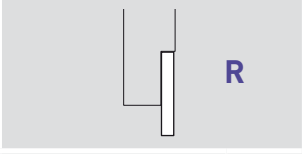




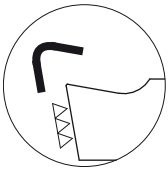




Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control



E	A	L	R	Art. N°	TiAlN	N (μK20)
2.0	8°	11	0.10	**661ZU8-2.0-8°-R10**	●	



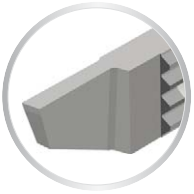
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

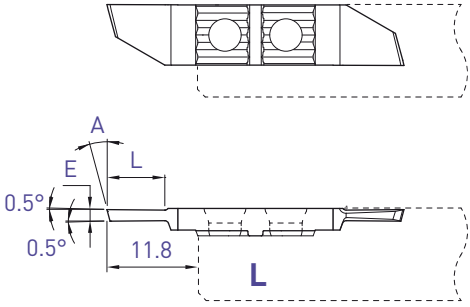
Tronçonnage
Abstechen
Parting off

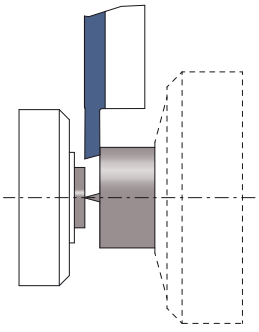
Coupe déportée
Versetztes Schneiden
Cut off line

651R



Cut R





L (R)

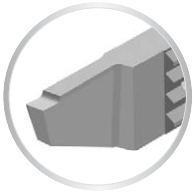
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

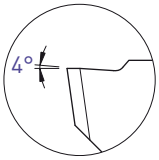
E	A	L	Art. N°	TiAlN	N (μk20)	HTA	HN (μk10)
1.0	15°	5	**651R-1.0-15°**	●	●		
1.2	15°	5	**651R-1.2-15°**	●	●		
1.5	15°	7.5	**651R-1.5-15°**	●	●		
2.0	15°	11	**651R-2.0-15°**	●	●		
2.5	15°	11	**651R-2.5-15°**	●	●		

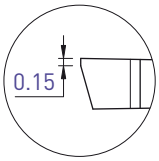
651RXF

Coupe déportée
Versetztes Schneiden
Cut off line

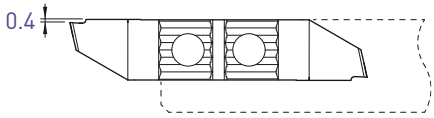
Tronçonnage
Abstechen
Parting off

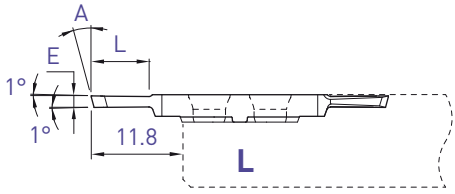


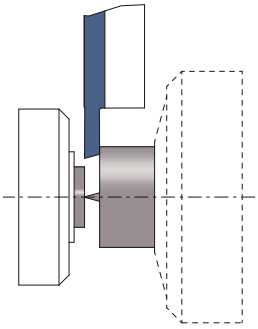




Cut R







L (R)

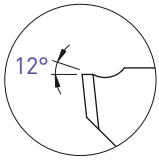
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.5	15°	7.5	**651RXF-1.5**	●	●		
2.0	15°	11	**651RXF-2.0**	●	●		

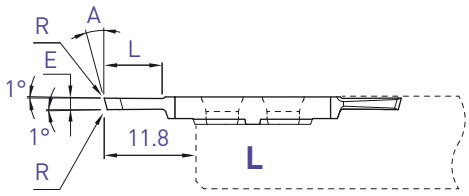
Tronçonnage
Abstechen
Parting off

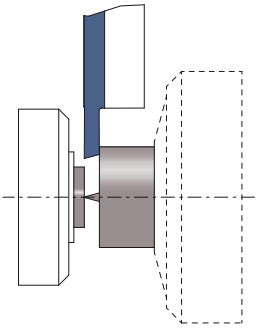
Coupe déportée
Versetztes Schneiden
Cut off line

651RX12



Cut R





L (R)

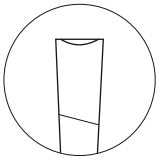
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

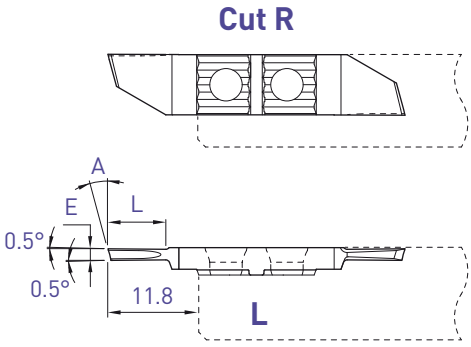
E	A	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.5	15°	7.5	0.03	**651RX12-1.5**	●	●		
2.0	15°	11	0.03	**651RX12-2.0**	●	●		

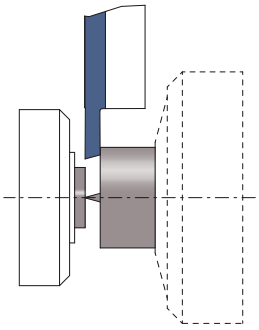
651RU

Coupe déportée
Versetztes Schneiden
Cut off line

Tronçonnage
Abstechen
Parting off







L (R)

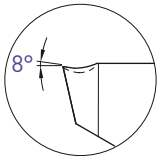
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

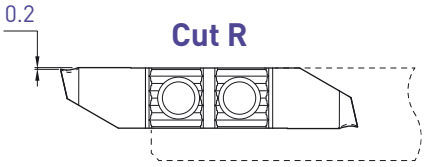
E	A	L	Art. N°	P M N S TiAlN	N N (µK20)
1.5	15°	7.5	**651RU-1.5**	●	●
2.0	15°	11	**651RU-2.0**	●	●

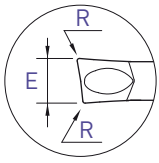
Tronçonnage
Abstechen
Parting off

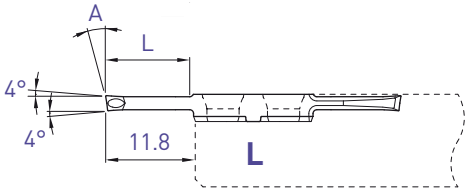
Coupe déportée
Versetztes Schneiden
Cut off line

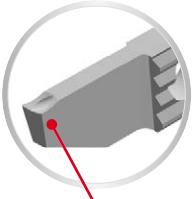
651RZU

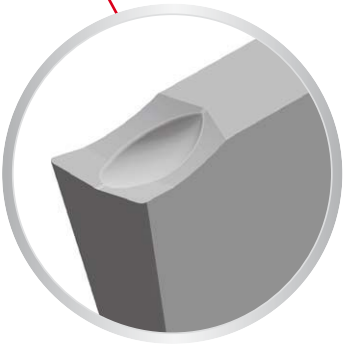










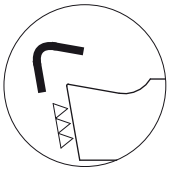


Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control

L (R)

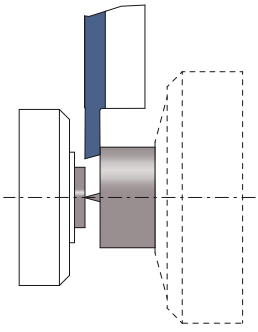
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	A	L	R	Art. N°	TiAlN	N (µK20)
2.0	8°	11	0.10	**651RZU8-2.0-8°-R10**	●	



Arête de coupe honée
Gehonte Schneidkante
Honed edge

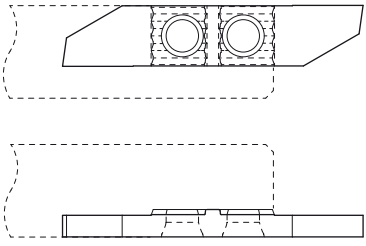
f min: 0.02 mm/U



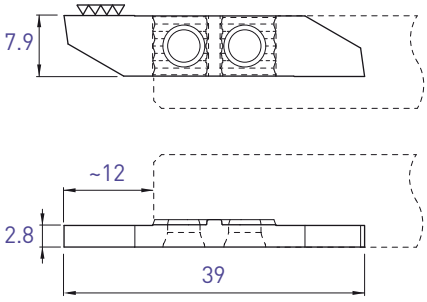
651-EP / 661-EP

Plaquettes ébauches
WSP-Rohlinge
Blank inserts

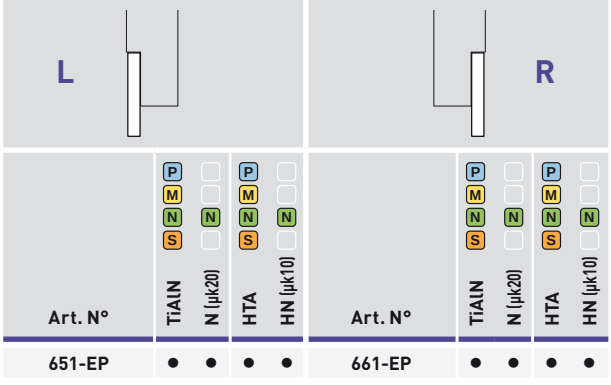
L

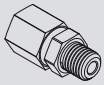


R



Face de coupe polie
Polierte Schneidfläche
Polished cutting face



Porte-outils Halter Holders					Options 	 **Art. N°**	Recommandation de serrage Empfehlung zum Spannen Clamping recommendation
630 640		-	-	-			
630-JET 640-JET	**V-M4X9-T15**	**J-M8X1-D6**	**JB-M8X1**	**JJ-M3X6-D1.5**			
650 660		-	-	-	**C-T15**	**SET-NM3.0-TX15**	3 Nm
650-RC	**V-M4X6.5-T15**	-	-	-			
650-JET 660-JET	**V-M4X9-T15**	**J-M8X1-D6**	**JB-M8X1**	**JJ-M3X6-D1.5**			

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