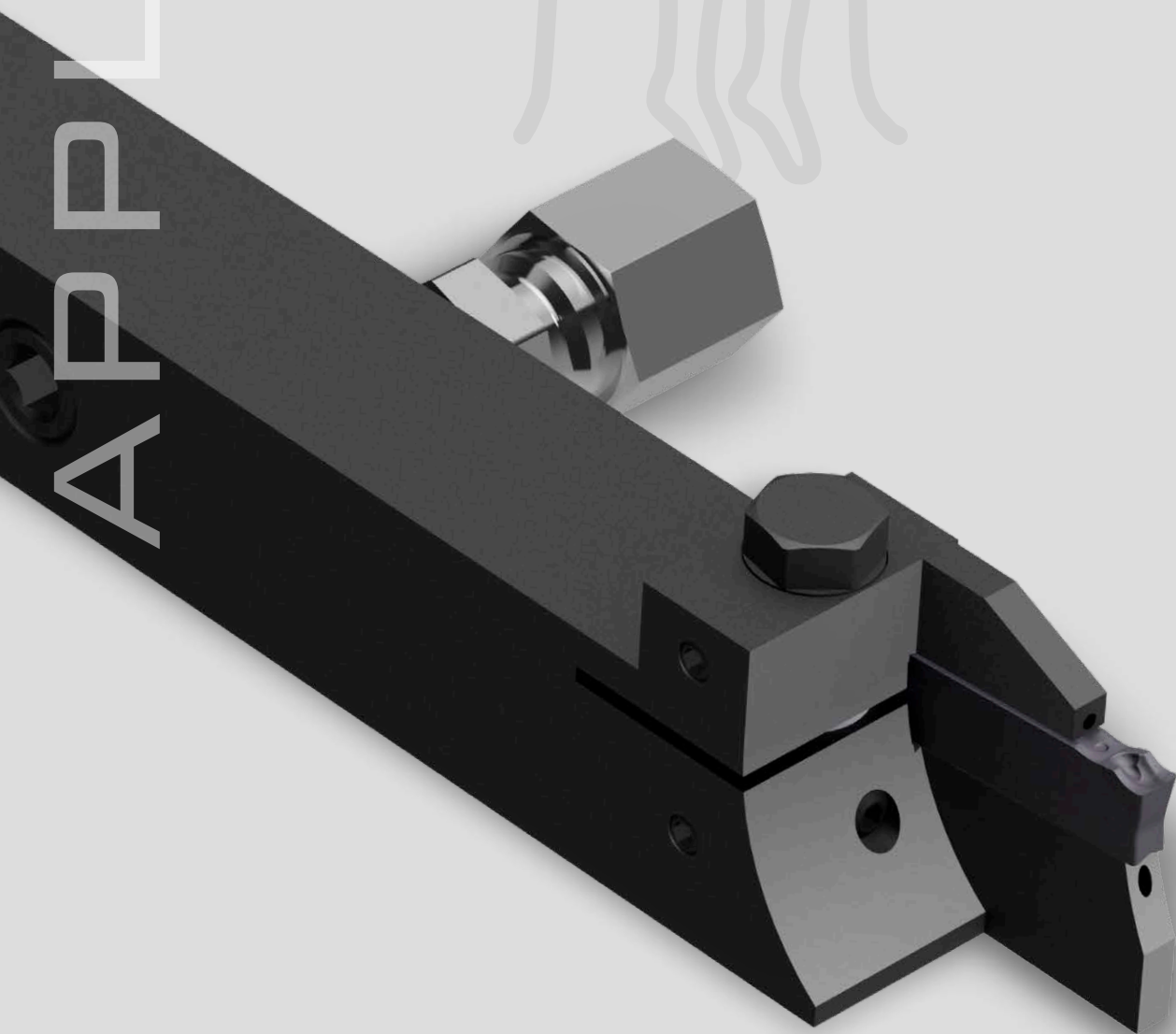


APPLITEC

EVOCUT-Line



APPLITEC
SWISS TOOLING

EVOCUT-Line

APPLITEC

Porte-outils / Halter / Holders

H

Système de serrage monobloc
Einteiliges Klemmsystem
Monobloc top clamp system

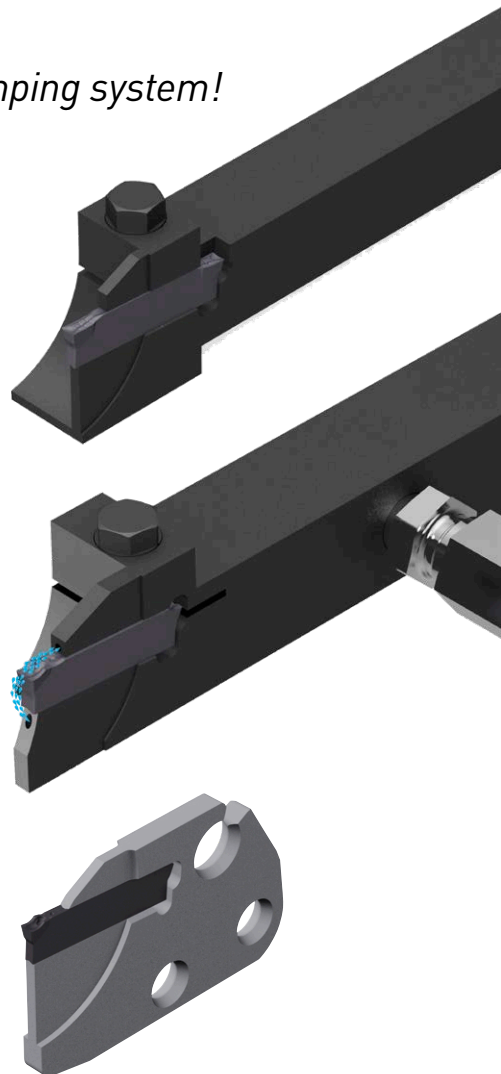
H JET

Porte-outils avec arrosage intégré
Halter mit integriertem Kühlmittelzufuhr
Holder with integrated coolant supply

**HK
HUK
HM**

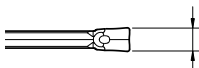
Lames
Stechklinge
Part-off blades

Very rigid clamping system!



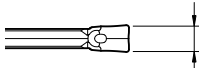
Plaquettes / WSP / Inserts

ET 15

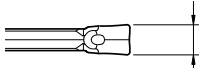
=  1.5 mm

Ø max 32 mm

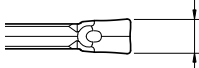
ET 20

=  2.0 mm

ET 25

=  2.5 mm

ET 30

=  3.0 mm

Ø max 44 mm



U



J



T



A

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EVOCUT-Line

Informations techniques

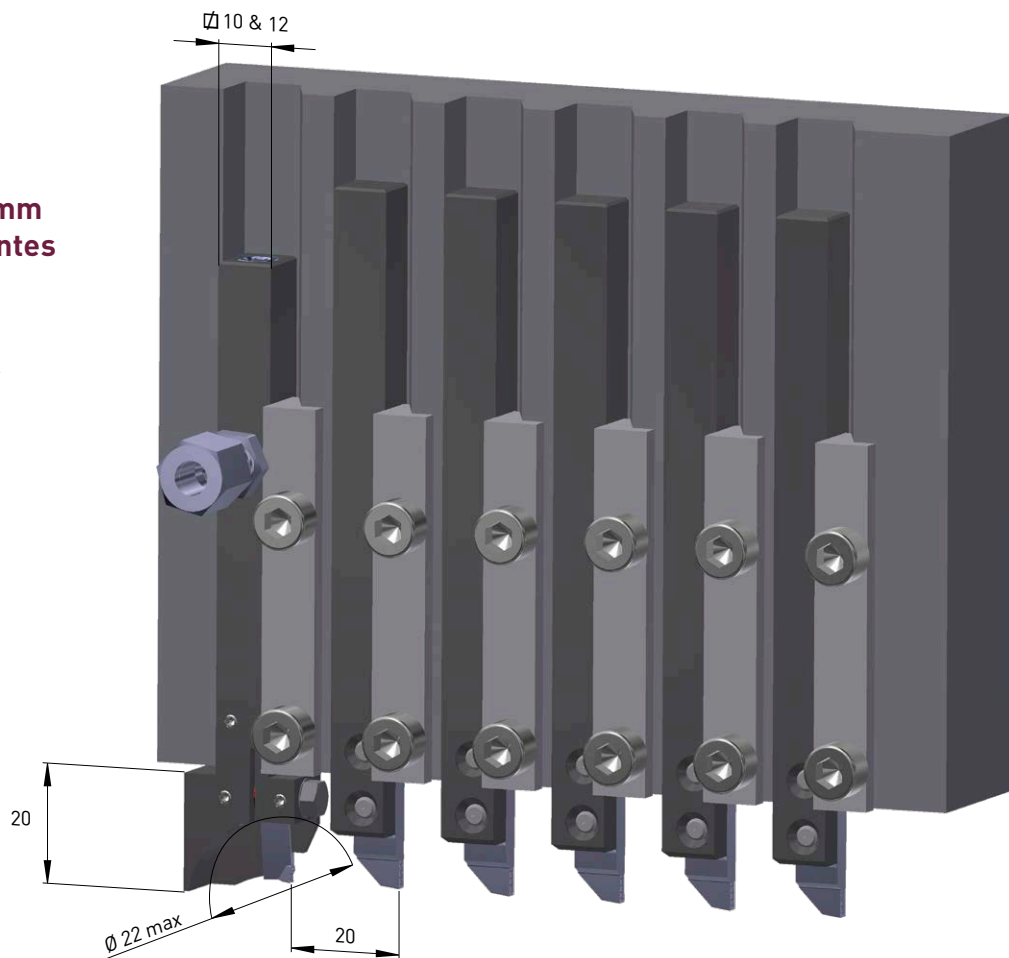
Technische Informationen

Technical information

**Compact: seulement 20 mm
pour les machines courantes**

**Kompakt: nur 20 mm für
übliche Maschinen**

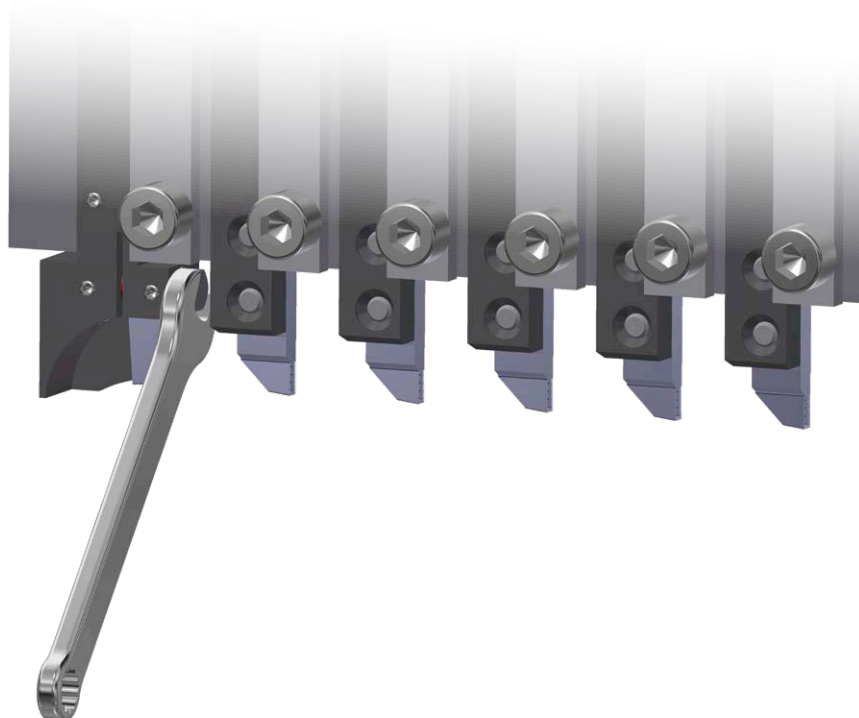
**Compact: only 20 mm for
current machines**



Facilité d'accès

Zugangsleichtigkeit

Excellent accessibility



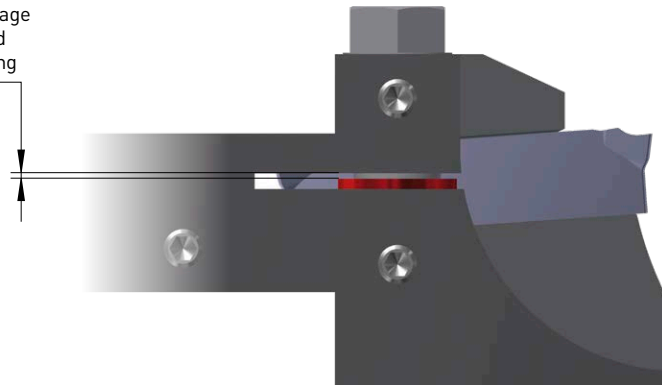
**Changement de la plaquette
sans démontage**

**Veränderung der Platte
ohne Zerlegung**

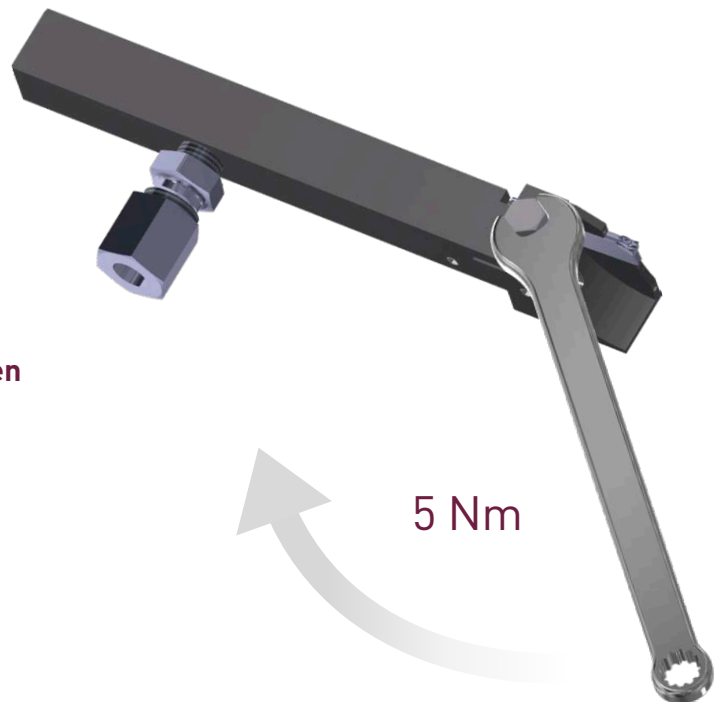
**Change of insert
without disassembly**

Butée de serrage
Spannungs-Anschlag
Clamping stop

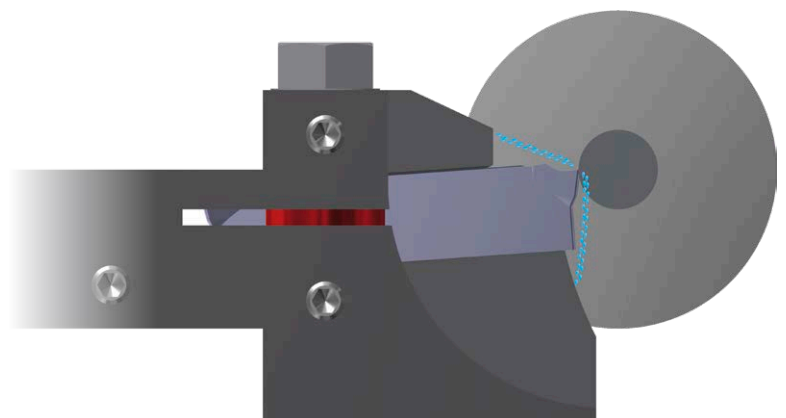
Distance de serrage
Anschlagabstand
Distance clamping



Recommendations de serrage:
n'utiliser que la clé fournie
Spannungsempfehlungen:
nur den gelieferten Schlüssel benutzen
Tightening recommendation:
only use the delivered key



Support JET à double lubrification
JET Halter mit doppeltem Schmierung
Jet holder with double lubrication



EVOCUT-Line

Géométries de coupe

Spanformgeometrie

Cutting geometries

UN

UL
UR



- Géométrie positive universelle, faibles efforts de coupe
- Bonne maîtrise du copeau
- 1^{er} choix pour l'inox

- Allgemeine Geometrie, geringe Schnittkräfte
- Gute Spankontrolle
- 1. Wahl für rostfreiem Stahl

- All-round geometry, low cutting forces
- Efficient chip control
- 1st choice for stainless steel

JN

JR



- Géométrie universelle
- Excellent rétrécissement du copeau pour un meilleur contrôle
- Conseillé pour le tronçonnage de pièces à parois minces
- Pour acier et inox

- Allgemeine Geometrie
- Ausgezeichnete Spanverschmälerung für eine bessere Spankontrolle
- Für abstechen von dünnwandigen Teilen empfohlen
- Für Stahl und rostfreiem Stahl

- All-round geometry
- Very efficient arrow for a better chip control
- Recommended for parting off of thin-walled parts
- For steel and stainless steel

TN

TR



- Géométrie négative
- Utilisation dans des conditions de rigidité optimale
- Pour les matières à haute ténacité
- Universel pour les aciers et inox

- Negative Geometrie
- Einsetzbar bei stabilen Verhältnissen
- Für hohe widerstandsfähige Rohstoffe
- Allgemein für Stahl und rostfreiem Stahl

- Negative geometry
- Use in solid cutting conditions
- For high toughness material
- Universal for steel and stainless steel

AN

AR



- Géométrie fortement positive
- Roule copeaux poli avec arêtes de coupe vives
- 1^{er} choix pour aluminium et matériaux non ferreux

- Stark positive Geometrie
- Geschliffene Spanrolle mit scharfe Schneidkanten
- 1. Wahl für Aluminium und Nichteisenmetalle

- Very positive geometry
- Polished chip roller with sharp cutting edge
- 1st choice for aluminium and non-ferrous materials

Nuances

Sorten

Grades

P

M

N

S

TiALN

revêtement PVD
PVD Beschichtung
PVD coating

- pour l'usinage des aciers, aciers inoxydables et alliages de titane
- 1^{er} choix pour les avances faibles à modérées

- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen
- beste Wahl für niedrige bis mittlere Vorschübe

- for machining of steel, stainless steel and titanium alloys
- first choice for low to average cutting speed

P

M

☐

☐

Tmax

revêtement PVD
PVD Beschichtung
PVD coating

- nuance pour usinage moyen à lourd des aciers, aciers alliés et inoxydables
- bonne résistance aux températures d'usinage élevées
- 1^{er} choix pour le tronçonnage des aciers au carbone et des aciers fortement alliés

- Sorte für mittlere bis hohe Belastung in Stahl und legierter Stahlbearbeitung
- gute Bearbeitungswarmfestigkeit
- bestens geeignet für die Bearbeitung von legiertem Kohlenstahl und hoch legiertem Stahl

- grade for medium to heavy machining of steel, stainless steel and alloyed steel
- high machining heat resistance
- first choice for the machining of carbon steel and high alloyed steel

P

M

☐

☐

Zmax

revêtement PVD
PVD Beschichtung
PVD coating

- pour l'usinage des aciers, aciers inoxydables et alliages de titane en conditions défavorables
- bonne résistance aux chocs à des vitesses de coupe moyenne à faible
- 1^{er} choix pour le tronçonnage en coupe interrompue

- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen in schwierige Bearbeitungsfälle
- gute Bruchfestigkeit mit durchschnittliche bis niedrige Schnittgeschwindigkeit
- für die Bearbeitung in unterbrochenen Schnitte bestens geeignet

- for machining of steel, stainless steel and titanium alloys in unfavourable machining conditions
- good impact resistance with average to low cutting speed
- first choice for machining in interrupted cut

P

M

☐

☐

ZTi6

revêtement CVD
CVD Beschichtung
CVD coating

- nuance très tenace
- grande résistance à la température
- 1^{er} choix pour les aciers «haute température»
- secondairement pour les aciers inox

- sehr zähe Sorte
- hohe Bearbeitungswarmfestigkeit
- 1. Wahl für „hohe Temperatur“ Stähle
- sekundär für rostfreie Stähle

- very strong grade
- good wear resistance
- 1st choice for "high temperature" steels
- secondarily for stainless steels

☐

☐

N

S

N

non-revêtu
unbeschichtet
uncoated

- nuance non revêtu
- recommandé pour l'usinage des matières non-ferreuses
- titane, laiton, cuivre, aluminium sans silicium, plastique

- Unbeschichtete Sorte
- Empfohlen für die Bearbeitung von Nichteisenmetalle
- Titan, Messing, Kupfer, Silicium freies Aluminium, Kunststoff

- uncoated grade
- recommended for machining of non-ferrous materials
- titanium, brass, bronze, aluminium without silicium, plastic

☐

☐

N

S

AS

revêtement PVD
PVD Beschichtung
PVD coating

- nuance pour métaux non ferreux
- très faible coefficient de frottement
- 1^{er} choix pour l'usinage des aluminiums jusqu'à 5% Si, des cuivres et titanes faiblement alliés

- Sorte für Nichteisenmetalle
- sehr geringer Reibwert
- für die Bearbeitung von Aluminium bis 5% Si, Kupfer und niedriglegiertem Titan bestens geeignet

- grade for non-ferrous materials
- very low friction ratio
- first choice for Aluminium up to 5% Si, copper and low alloyed titanium

EVOCUT-Line

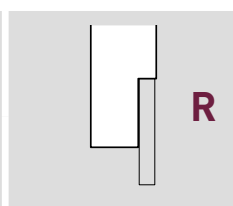
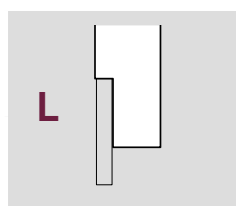
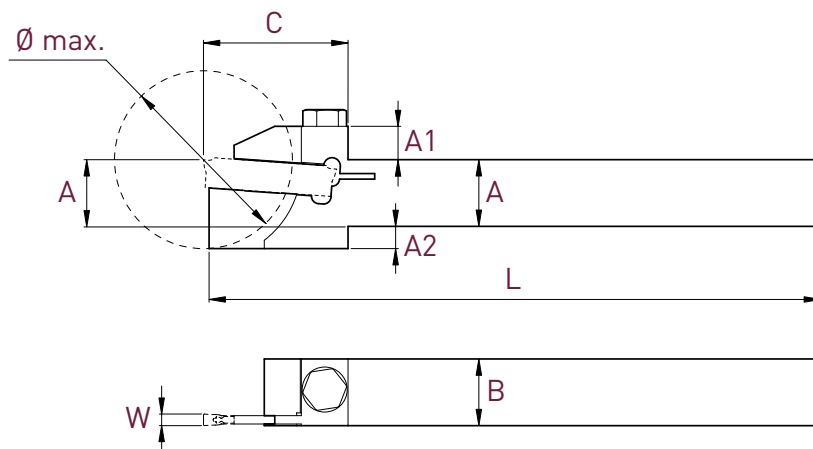
Porte-outils

Halter

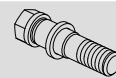
Holders

Ø max 44 mm

H Series



Pièces de rechange
Ersatzteile
Spare parts



Plaquette WSP Insert	A x B x L	Ø max.	C	A1	A2	Art. N°	Art. N°	Art. N°	Art. N°
W 1.5 Type ET15	10x12x110	22	20	5	6	ET15-H1012L-D22	ET15-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12x110	22	20	5	4	ET15-H1212L-D22	ET15-H1212R-D22		
	12x12x110	32	26	6	4	ET15-H1212L-D32	ET15-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	16x16x110	32	26	6	-	ET15-H1616L-D32	ET15-H1616R-D32		
W 2.0 Type ET20	10x12x110	22	20	5	6	ET20-H1012L-D22	ET20-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12x110	22	20	5	4	ET20-H1212L-D22	ET20-H1212R-D22		
	12x12x110	32	26	6	4	ET20-H1212L-D32	ET20-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	16x16x110	32	26	6	-	ET20-H1616L-D32	ET20-H1616R-D32		
	16x16x130	44	35	8	4	ET20-H1616L-D44	ET20-H1616R-D44	V-M5X27-6P7	C-6PEX-7.0
	20x20x130	44	35	8	-	ET20-H2020L-D44	ET20-H2020R-D44		
W 2.5 Type ET25	10x12x110	22	20	5	6	ET25-H1012L-D22	ET25-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12x110	22	20	5	4	ET25-H1212L-D22	ET25-H1212R-D22		
	12x12x110	32	26	6	4	ET25-H1212L-D32	ET25-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	16x16x110	32	26	6	-	ET25-H1616L-D32	ET25-H1616R-D32		
	16x16x130	44	35	8	4	ET25-H1616L-D44	ET25-H1616R-D44	V-M5X27-6P7	C-6PEX-7.0
	20x20x130	44	35	8	-	ET25-H2020L-D44	ET25-H2020R-D44		
W 3.0 Type ET30	16x16x110	32	26	6	-	ET30-H1616L-D32	ET30-H1616R-D32	V-M5X21-6P7	C-6PEX-7.0
	16x16x130	44	35	8	4	ET30-H1616L-D44	ET30-H1616R-D44	V-M5X27-6P7	C-6PEX-7.0
	20x20x130	44	35	8	-	ET30-H2020L-D44	ET30-H2020R-D44		

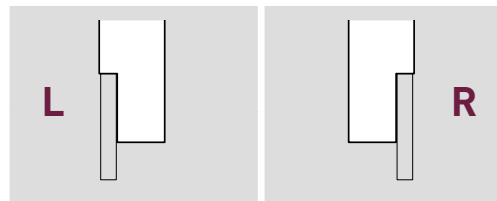
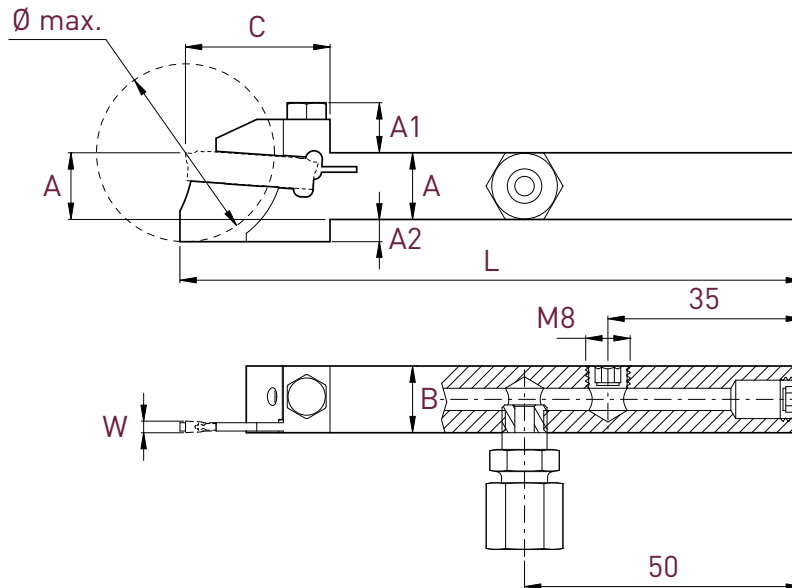
* livré avec chaque porte-outil
mit jedem Halter geliefert
delivered with each holder

Porte-outils avec arrosage intégré

Halter mit integriertem Kühlmittelzufuhr $\varnothing$ max 44 mm

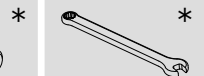
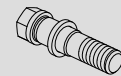
H JET Series

Holder with integrated coolant supply



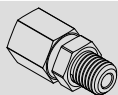
Plaquette WSP Insert	A x B x L	$\varnothing$ max.	A1	C	A2	Art. N°	Art. N°
W 2.0 Type ET20	10x12x110	22	5	20	6	ET20-H1012R-JET22	ET20-H1012L-JET22
	12x12x110	22	5	20	4	ET20-H1212R-JET22	ET20-H1212L-JET22
	12x12x110	32	6	26	4	ET20-H1212R-JET32	ET20-H1212L-JET32
	16x16x110	32	6	26	-	ET20-H1616R-JET32	ET20-H1616L-JET32
	16x16x130	44	8	35	4	ET20-H1616R-JET44	ET20-H1616L-JET44
	20x20x130	44	8	35	-	ET20-H2020R-JET44	ET20-H2020L-JET44
W 2.5 Type ET25	10x12x110	22	5	20	6	ET25-H1012R-JET22	ET25-H1012L-JET22
	12x12x110	22	5	20	4	ET25-H1212R-JET22	ET25-H1212L-JET22
	12x12x110	32	6	26	4	ET25-H1212R-JET32	ET25-H1212L-JET32
	16x16x110	32	6	26	-	ET25-H1616R-JET32	ET25-H1616L-JET32
	16x16x130	44	8	35	4	ET25-H1616R-JET44	ET25-H1616L-JET44
	20x20x130	44	8	35	-	ET25-H2020R-JET44	ET25-H2020L-JET44
W 3.0 Type ET30	16x16x110	32	6	26	-	ET30-H1616R-JET32	ET30-H1616L-JET32
	16x16x130	44	8	35	4	ET30-H1616R-JET44	ET30-H1616L-JET44
	20x20x130	44	8	35	-	ET30-H2020R-JET44	ET30-H2020L-JET44

Pièces de rechange
Ersatzteile
Spare parts



Art. N°	Art. N°
V-M5X20-6P6-J	C-6PEX-6.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0
V-M5X20-6P6-J	C-6PEX-6.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0

Pièces de rechange
Ersatzteile
Spare parts



Art. N°

Art. N°

J-M8X1-D6

JB-M8X1

* livré avec chaque porte-outil
mit jedem Halter geliefert
delivered with each holder

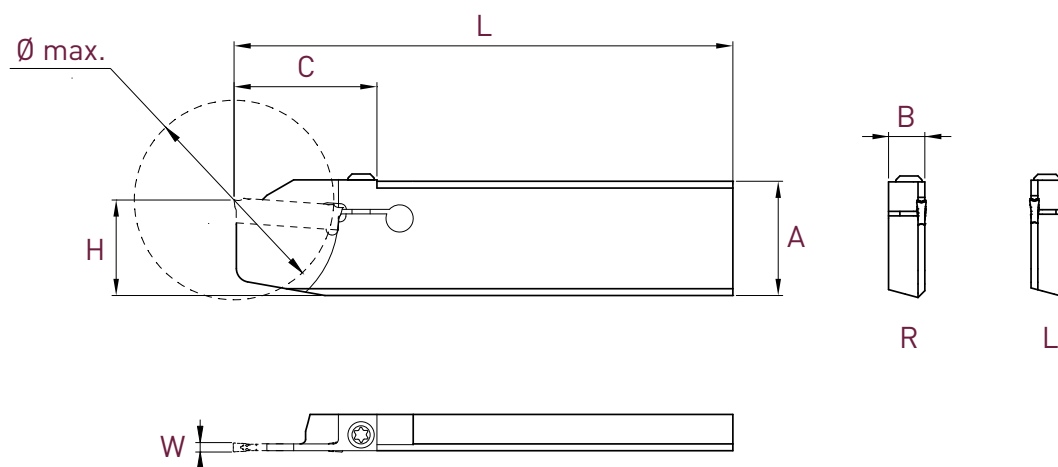
EVOCUT-Line

Lames de tronçonnage

Stechklinge

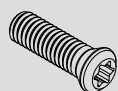
Part-off blades

HK Series



Plaquette WSP Insert	A x B x L	Ø max.	C	H	Art. N°	Art. N°
W 1.5	26x8x110	20	19,5	21	ET15-HK-2608L-110-D20	ET15-HK-2608R-110-D20
Type ET15	26x8x110	32	25,5	21	ET15-HK-2608L-110-D32	ET15-HK-2608R-110-D32
W 2.0	26x8x110	32	25,5	21	ET20-HK-2608L-110-D32	ET20-HK-2608R-110-D32
Type ET20	26x8x110	44	31,5	21	ET20-HK-2608L-110-D44	ET20-HK-2608R-110-D44

Pièces de rechange
Ersatzteile
Spare parts



*

Art. N°

V-M4X14.5-T15-EVOCUT



*

Art. N°

C-T15

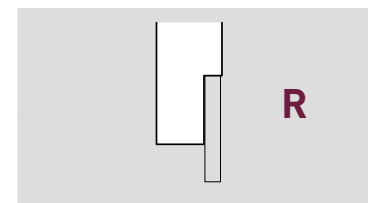
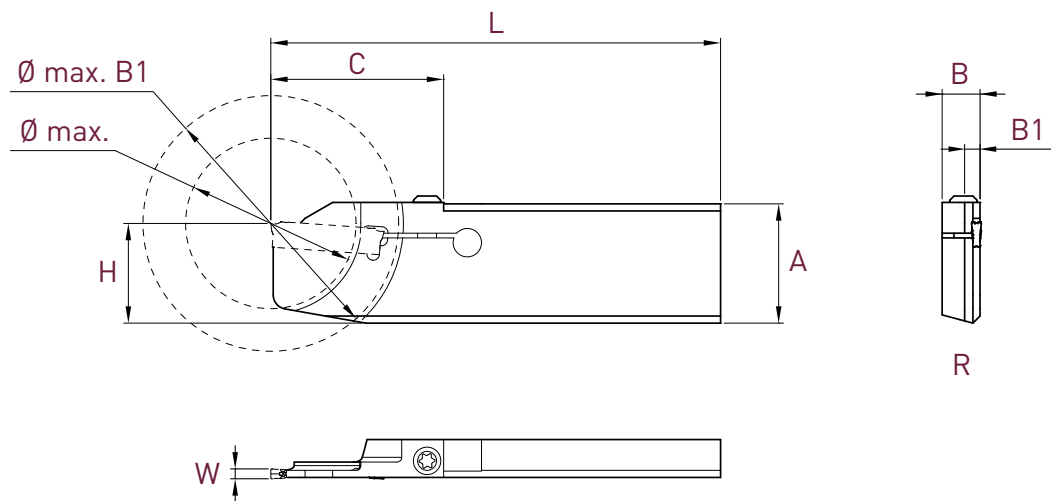
* livré avec chaque lame
mit jedem Stechkling geliefert
delivered with each blade

Lames de tronçonnage avec dégagement pour accès contre-broche

Steckklinge mit Aussparung für Gegenspindel Zugriff

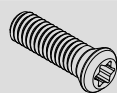
Part-off blades with recess for subspindle access

HK-RS Series



Plaquette WSP Insert	A x B x L	Ø max.	Ø max B1	B1	C	H	Art. N°
W 1.5 Type ET15	26x8x95	36	54	3,25	36,5	21	ET15-HK-2608RS-95-D36
W 2.0 Type ET20	26x8x95	36	54	3,25	36,5	21	ET20-HK-2608RS-95-D36

Pièces de rechange
Ersatzteile
Spare parts



*

Art. N°

V-M4X14.5-T15-EVOCUT



*

Art. N°

C-T15

* livré avec chaque lame
mit jedem Steckling geliefert
delivered with each blade

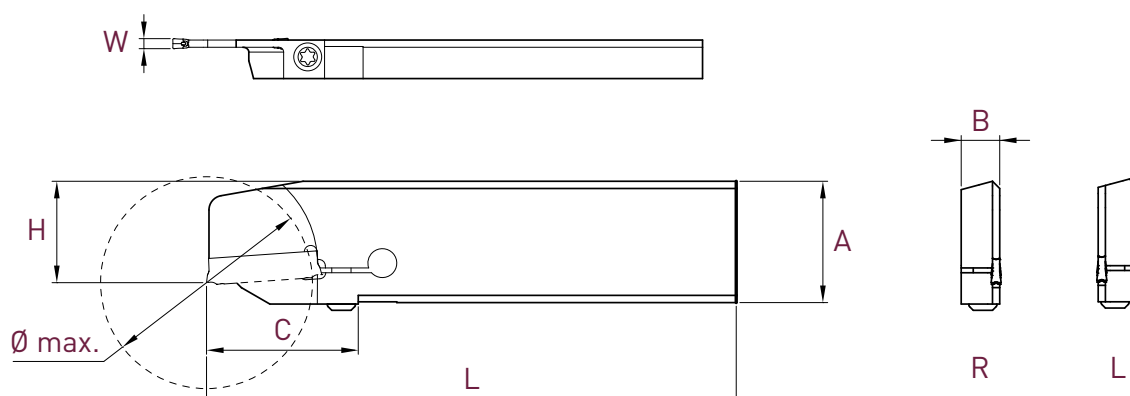
EVO CUT-Line

Lames de tronçonnage inversées

Überkopf Stechklinge

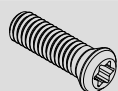
Upside down Part-off blades

HUK Series



Plaquette WSP Insert	A x B x L	Ø max.	C	H	Art. N°	Art. N°
W 1.5	26x8x110	20	19,5	21	ET15-HUK-2608L-110-D20	ET15-HUK-2608R-110-D20
Type ET15	26x8x110	32	25,5	21	ET15-HUK-2608L-110-D32	ET15-HUK-2608R-110-D32
W 2.0	26x8x110	32	25,5	21	ET20-HUK-2608L-110-D32	ET20-HUK-2608R-110-D32
Type ET20	26x8x110	44	31,5	21	ET20-HUK-2608L-110-D44	ET20-HUK-2608R-110-D44

Pièces de rechange
Ersatzteile
Spare parts



*

Art. N°

V-M4X14.5-T15-EVO CUT



*

Art. N°

C-T15

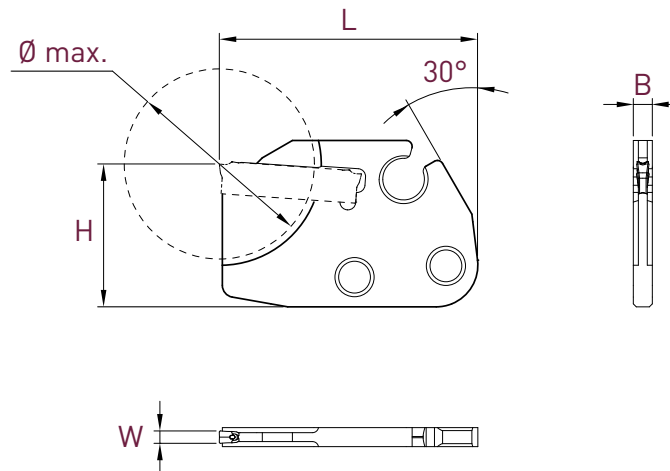
* livré avec chaque lame
mit jedem Steckling geliefert
delivered with each blade

Lames pour système modulaire

Stechklinge für modulares System

Part-off blades for modular system

HM Series



				N
Plaquette WSP Insert	Ø max.	L	H	Art. N°
W 1.5 Type ET15	20	43,5	24	ET15-HM-IN-43-D20
	32	43,5	24	ET15-HM-IN-43-D32
W 2.0 Type ET20	20	43,5	24	ET20-HM-IN-43-D20
	26	43,5	24	ET20-HM-IN-43-D26
	26	54	24	ET20-HM-IN-54-D26
	32	43,5	24	ET20-HM-IN-43-D32
W 3.0 Type ET20	32	43,5	24	ET30-HM-IN-43-D32

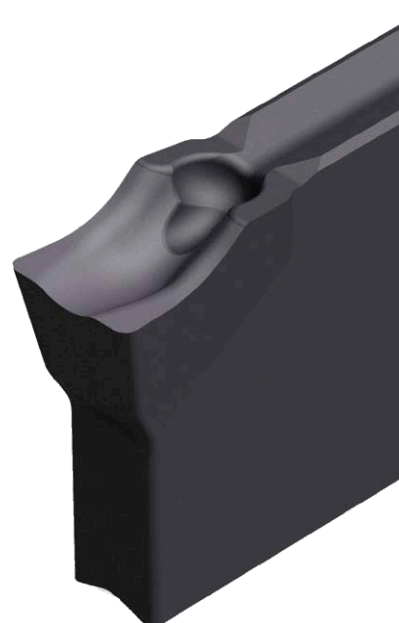
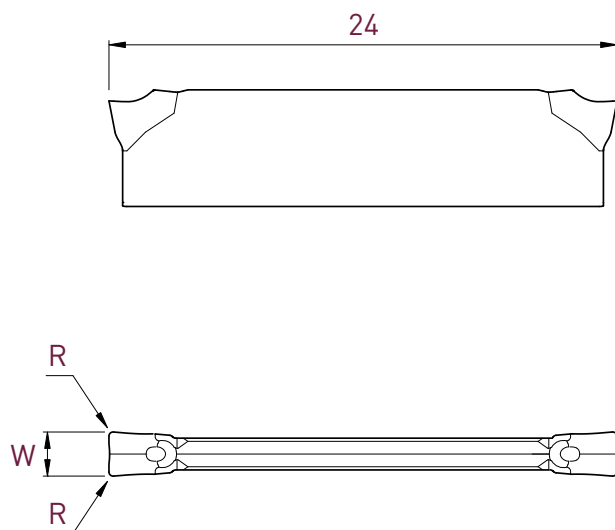
EVO CUT-Line

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

UN Series



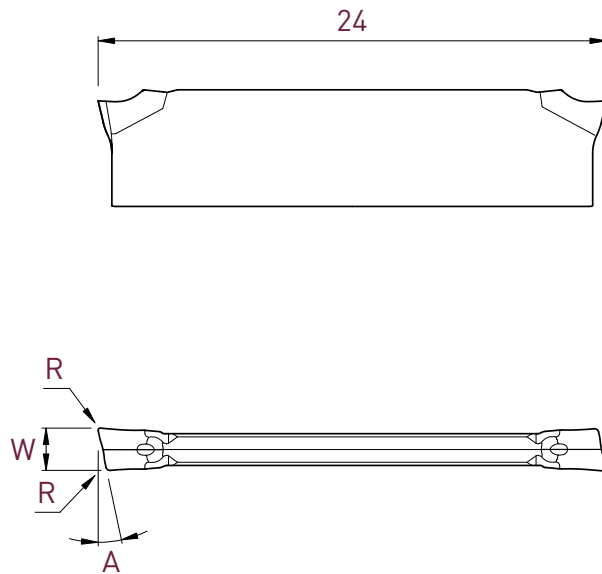
			UN				
				P M N S P M P M P M			
Type	W $\pm 0,05$	R	Art. N°	TIALN	Tmax	Zmax	ZTi6
ET15	1.5	0	ET15-UN-000F	■			
	1.5	0.2	ET15-UN-002	■	■	■	
ET20	2.0	0	ET20-UN-000F	■			
	2.0	0.2	ET20-UN-002	■	■	■	■
ET25	2.5	0	ET25-UN-000F	■			
	2.5	0.2	ET25-UN-003	■	■	■	■
ET30	3.0	0	ET30-UN-000F	■			
	3.0	0.3	ET30-UN-003	■	■	■	■

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

UL-UR Series



Type	W $\pm 0,05$	A	R	Art. N°	UL			Art. N°	UR		
					P M N S	P M	P M		P M N S	P M	P M
ET15	1.5	6°	0.2	-				ET15-UR-602	■	■	■
	1.5	8°	0	-				ET15-UR-800F	■		
	1.5	12°	0.1	-				ET15-UR-1201	■	■	■
	1.5	15°	0	ET15-UL-1500F	■			ET15-UR-1500F	■		
ET20	2.0	6°	0.2	-				ET20-UR-602	■	■	■
	2.0	8°	0	-				ET20-UR-800F	■		
	2.0	12°	0.1	-				ET20-UR-1201	■	■	■
	2.0	15°	0	ET20-UL-1500F	■			ET20-UR-1500F	■		
ET25	2.5	6°	0.2	-				ET25-UR-602	■	■	■
	2.5	8°	0	-				ET25-UR-800F	■		
	2.5	12°	0.1	-				ET25-UR-1201	■	■	■
	2.5	15°	0	ET25-UL-1500F	■			ET25-UR-1500F	■		
ET30	3.0	6°	0.3	-				ET30-UR-603	■	■	■
	3.0	8°	0	-				ET30-UR-800F	■		
	3.0	12°	0.2	-				ET30-UR-1202	■	■	■
	3.0	15°	0	ET30-UL-1500F	■			ET30-UR-1500F	■		

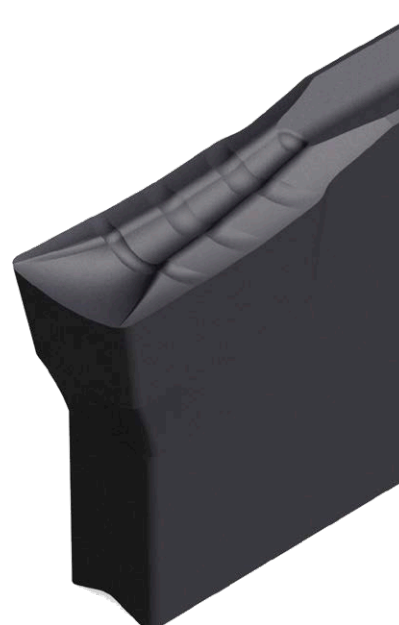
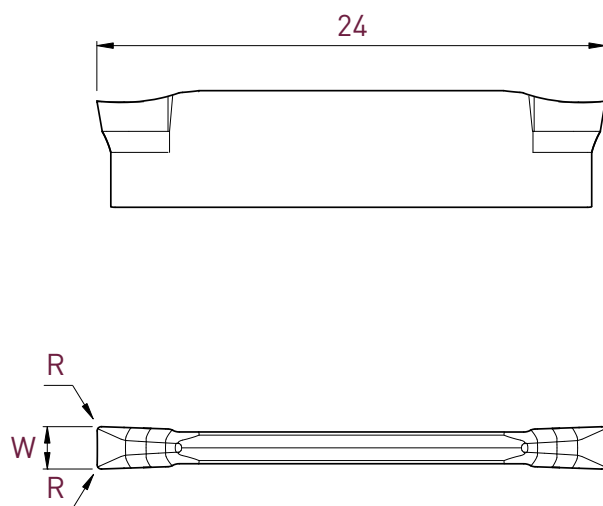
EVOCUT-Line

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

JN Series



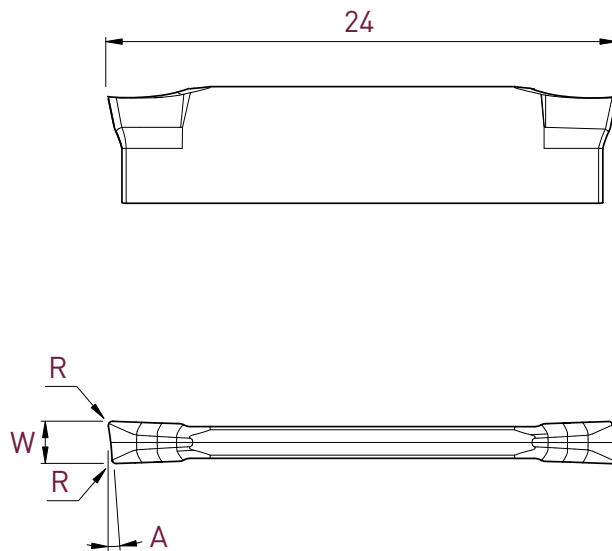
				JN				
Type	W $\pm 0,05$	R	T	Art. N°	P M N S TiAlN	P M Tmax	P M Zmax	P M ZTi6
ET15	1.5	0.2	3.0	ET15-JN-002	■	■	■	
ET20	2.0	0.2	3.0	ET20-JN-002	■	■	■	■
ET25	2.5	0.3	3.0	ET25-JN-003	■	■	■	■
ET30	3.0	0.3	3.0	ET30-JN-003	■	■	■	■

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

JR Series



				JR			
					P M N S	P M	P M
Type	W $\pm 0,05$	A	R	Art. N°	TiALN	Tmax	Zmax
ET15	1.5	6°	0.2	ET15-JR-602	■	■	■
ET20	2.0	6°	0.2	ET20-JR-602	■	■	■
ET25	2.5	6°	0.2	ET25-JR-602	■	■	■
ET30	3.0	6°	0.3	ET30-JR-603	■	■	■

EVOCUT-Line

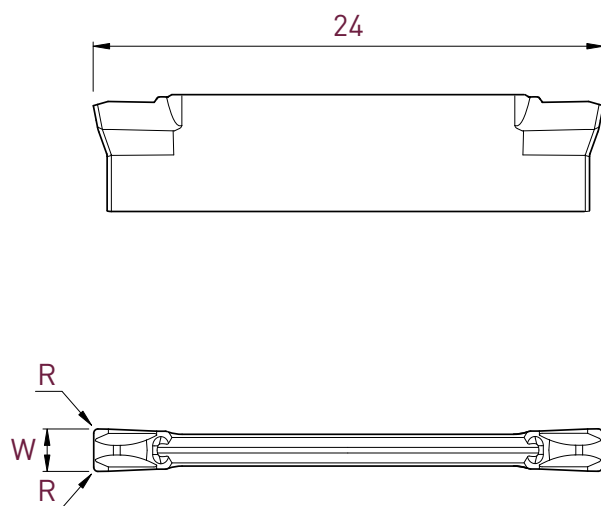
Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

negative geometry

TN Series



			TN				
Type	W $\pm 0,05$	R	Art. N°	P M N	P M	P M	P M
				TiALN	Tmax	Zmax	ZTi6
ET20	2.0	0.2	ET20-TN-002	■	■	■	■
ET25	2.5	0.3	ET25-TN-003	■	■	■	■
ET30	3.0	0.3	ET30-TN-003	■	■	■	■

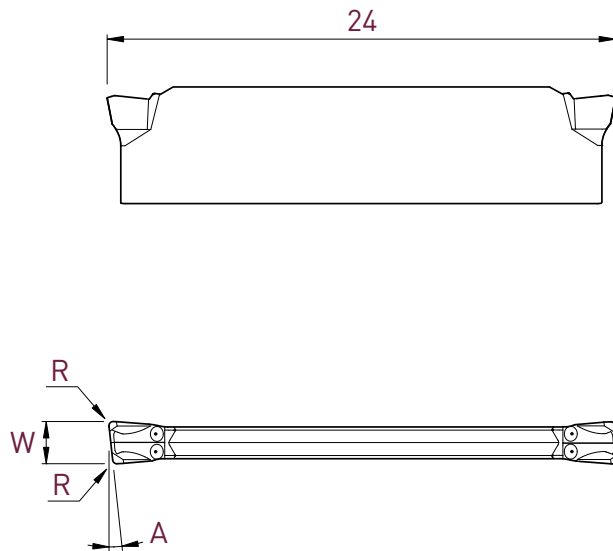
Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

negative geometry

TR Series



				TR				
Type	W $\pm 0,05$	A	R	Art. N°	TIALN	Tmax	Zmax	ZTi6
ET20	2.0	6°	0.2	ET20-TR-602	■	■	■	
ET25	2.5	6°	0.2	ET25-TR-602	■	■	■	
ET30	3.0	6°	0.3	ET30-TR-603	■	■	■	■

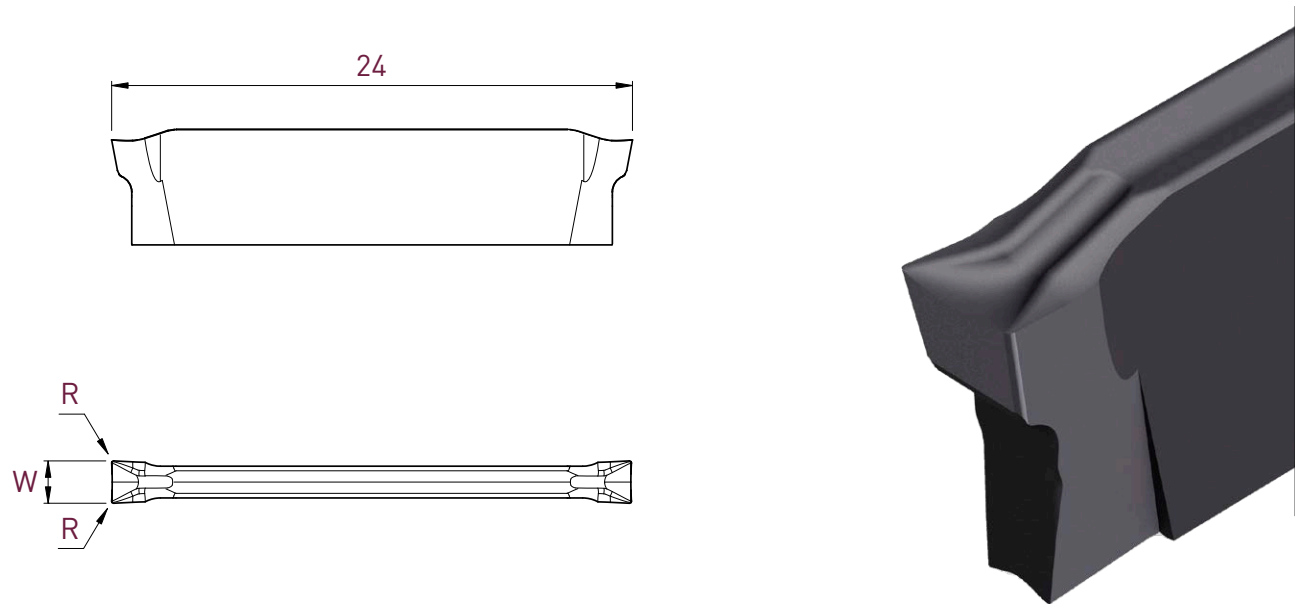
EVOCUT-Line

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

AN Series



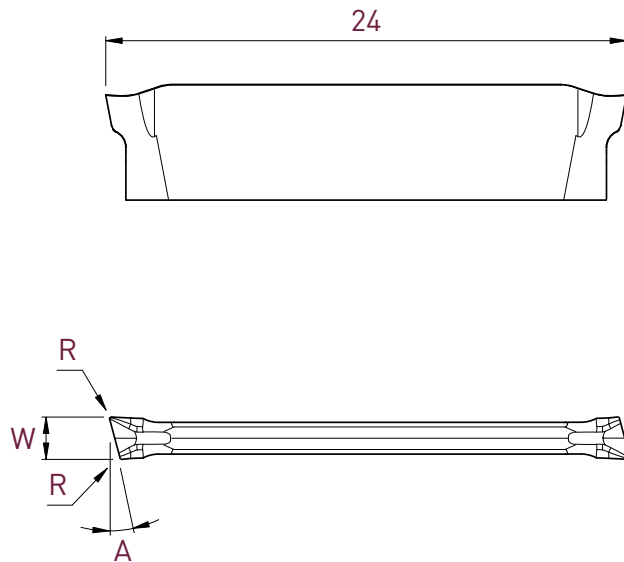
			AN			
Type	W $\pm 0,05$	R	Art. N°	TIALN	AS	Z
ET20	2.0	0.2	ET20-AN-002F	■	■	■
ET30	3.0	0.3	ET30-AN-003F	■	■	■

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

AR Series



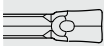
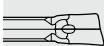
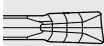
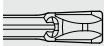
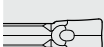
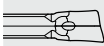
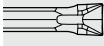
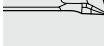
				AR			
Type	W $\pm 0,05$	A	R	Art. N°	TIALN	AS	Z
ET20	2.0	15°	0.1	ET20-AR-1501F	■	■	■
ET30	3.0	15°	0.2	ET30-AR-1502F	■	■	■

EVOCUT-Line

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

			ET15	ET20	ET25	ET30	P Acier Stahl Steel						M Inox Rostfreistahl Stainless steel	
							Acier de décolletage Automatenstahl Free-cutting steel		Acier faiblement allié Leicht legierter Stahl Low alloyed steel		Acier fortement allié Legierter Stahl High alloyed steel		Austénitique et martensitique Austenitisch und martensitisch Austenitic and martensitic	
							VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Avance standard Standard Vorschub Standard feed rate	UN 	TiALN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10
		ZTi6		■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08
	UR 	TiALN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10
		ZTi6		■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08
	JN 	TiALN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10
		ZTi6		■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08
	JR 	TiALN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10
		ZTi6		■	■	■	110-200	0.08-0.18	80-160	0.08-0.18	70-140	0.08-0.15	70-160	0.08-0.20
	TN 	TiALN		■	■	■	90-150	0.08-0.18	70-130	0.08-0.18	50-100	0.08-0.15	50-120	0.08-0.20
		Tmax		■	■	■	100-170	0.08-0.18	70-150	0.08-0.18	60-120	0.08-0.15	60-150	0.08-0.20
		Zmax		■	■	■	80-130*	0.08-0.18	50-110*	0.08-0.18	50-90*	0.08-0.15	50-120*	0.08-0.20
		ZTi6		■	■	■	110-200	0.08-0.18	80-160	0.08-0.18	70-140	0.08-0.15	70-160	0.08-0.20
	TR 	TiALN		■	■	■	90-150	0.08-0.18	70-130	0.08-0.18	50-100	0.08-0.15	50-120	0.08-0.20
		Tmax		■	■	■	100-170	0.08-0.18	70-150	0.08-0.18	60-120	0.08-0.15	60-150	0.08-0.20
		Zmax		■	■	■	80-130*	0.08-0.18	50-110*	0.08-0.18	50-90*	0.08-0.15	50-120*	0.08-0.20
		ZTi6				■	110-200	0.08-0.18	80-160	0.08-0.18	70-140	0.08-0.15	70-160	0.08-0.20
Avance modérée Niedriger Vorschub Low feed rate	UN-000F 	TiALN	■	■	■	■	80-120	0.02-0.05	50-100	0.02-0.05	40-80	0.02-0.05	40-100	0.02-0.05
	UR/UL 	TiALN	■	■	■	■	80-120	0.02-0.05	50-100	0.02-0.05	40-80	0.02-0.05	40-100	0.02-0.05
	AN 	N		■		■								
		TiALN		■		■							40-80	0.02-0.05
		AS		■		■								
	AR 	N		■		■								
		TiALN		■		■							40-80	0.02-0.05
		AS		■		■								

* premier choix en cas
de coupe interrompue

** arête de coupe vive

* beste Basis für
unterbrochene Schnitte

** scharfe Schneidkante

* first choice
for interrupted cut

** sharp cutting edge

N Alliages d'aluminium et non ferreux Aluminium- und Nichteisenlegierungen Aluminium and non-ferrous alloys								S Titane Titan Titanium			
Aluminium		Alu silicium max. 5% Aluminiumsilicium max. 5% Aluminium silicon max. 5%		Cuivre Kupfer Copper		Laiton & bronze Messing & Bronze Brass & bronze		Gr. 1 - 3		Gr. 4 - 5	
VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
						150-300	0.05-0.20				
						150-300	0.05-0.20				
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06			50-100	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06			50-100	0.01-0.06
80-200	0.02-0.06			80-200	0.01-0.05	80-200	0.02-0.06	50-100	0.01-0.06	50-100	0.01-0.06
100-250	0.02-0.06	80-150	0.01-0.05	100-200	0.01-0.05	80-200	0.02-0.06			30-80	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06	50-120	0.01-0.06	50-120	0.01-0.06
80-200	0.02-0.06			80-200	0.01-0.05	80-200	0.02-0.06	50-100	0.01-0.06	50-100	0.01-0.06
100-250	0.02-0.06	80-150	0.01-0.05	100-200	0.01-0.05	80-200	0.02-0.06			30-80	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06	50-120	0.01-0.06	50-120	0.01-0.06

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