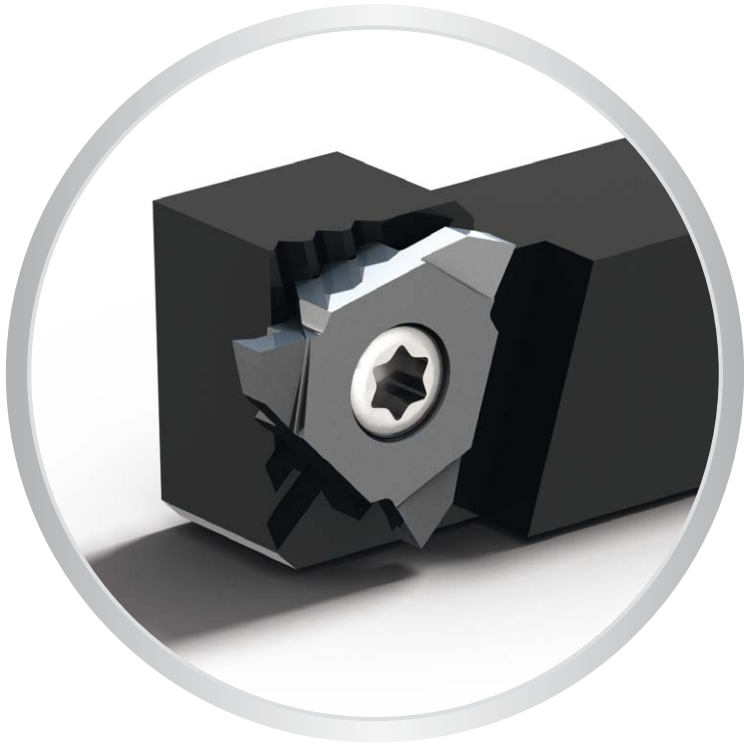


TRIO-Line

APPLITEC



PERFORMANCE | PRECISION | RIGIDITY

Conseils d'utilisation - Accessoires  
 Anwendungsempfehlungen - Zubehör  
 Application recommendations - Accessories



> **2.03**

Porte-outils  
 Halter  
 Holders



> **2.04**

**GX**

Gorge de précision  
 Präzisionseinstechen  
 High precision grooving

DIN6799  
 & DIN471



> **2.05**

**FT**

Tournage finition  
 Schlicht drehen  
 Fine turning



> **2.06**

**GT**

Foncer tourner  
 Einstechen und drehen  
 Grooving and turning



> **2.07**

**GTX**

Foncer tourner avec coupe positive  
 Einstechen und drehen mit positivem Spanwinkel  
 Grooving and turning with positive cut



> **2.08**

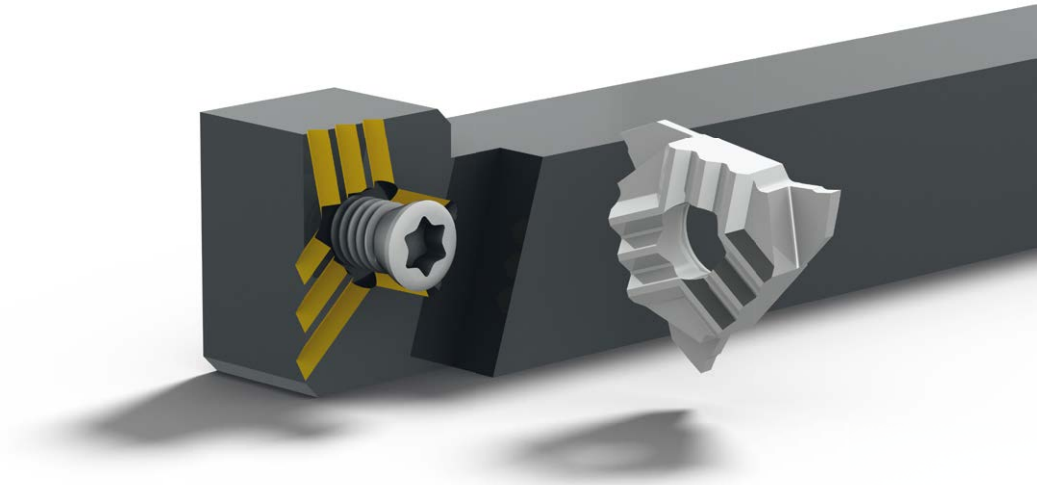
**EP**

Plaquette ébauche  
 WSP-Rohling  
 Blank insert



> **2.09**

*Rigid clamping system with the famous  
Applitec teeth clamping*



**Nuance micro-grain à dureté élevée**

**Verschleissfeste Feinkornsorten**

**Wear resistant micro-grain grades**

## HTA

$\mu$ K10 + revêtement PVD  
 $\mu$ K10 + PVD Beschichtung  
 $\mu$ K10 + PVD coating

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

- sehr verschleissfeste Sorte
- für die Feinbearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bei guten Bearbeitungsbedingungen

- very wear resistant grade
- for light machining of steel, stainless steel and titanium alloys under favourable machining conditions

## HN ( $\mu$ K10)

non revêtu  
unbeschichtet  
uncoated

- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du laiton, de l'aluminium et du titane faiblement allié

- sehr verschleissfeste Feinkornsorte
- empfehlenswert für die Bearbeitung von Messing und niedrig legiertem Aluminium und Titan

- very wear resistant micro-grain grade
- suitable for the machining of brass and low alloyed aluminium and titanium

## Paramètres de coupe indicatifs

## Empfohlene Schnittwerte

## Standard machining data

Matière Werkstoff Material	Tournage Drehen Turning		Foncer Einstechen Grooving	
	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15
Acier Stahl Steel < 600 N/mm <sup>2</sup>	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel < 800 N/mm <sup>2</sup>	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel > 800 N/mm <sup>2</sup>	50 - 100	0.01 - 0.12	40 - 80	0.01 - 0.08
Acier inoxydable Rostfreistahl Stainless steel	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.08
Aluminium	180 - 800	0.01 - 0.30	150 - 300	0.01 - 0.20
Titane Titan Titanium	30 - 70	0.01 - 0.12	30 - 50	0.01 - 0.06
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze	100 - 500	0.01 - 0.30	100 - 300	0.01 - 0.20

## Accessoires

## Zubehöre

## Accessories

Porte-outils Halter Holders			Option Art. N°
T216-H...	V-M4X9-T15	T15	SET-NM-TX15

Recommandation de serrage  
Drehmoment Empfehlung  
Clamping recommendation

3.0 Nm



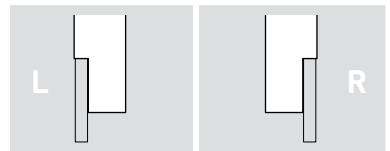
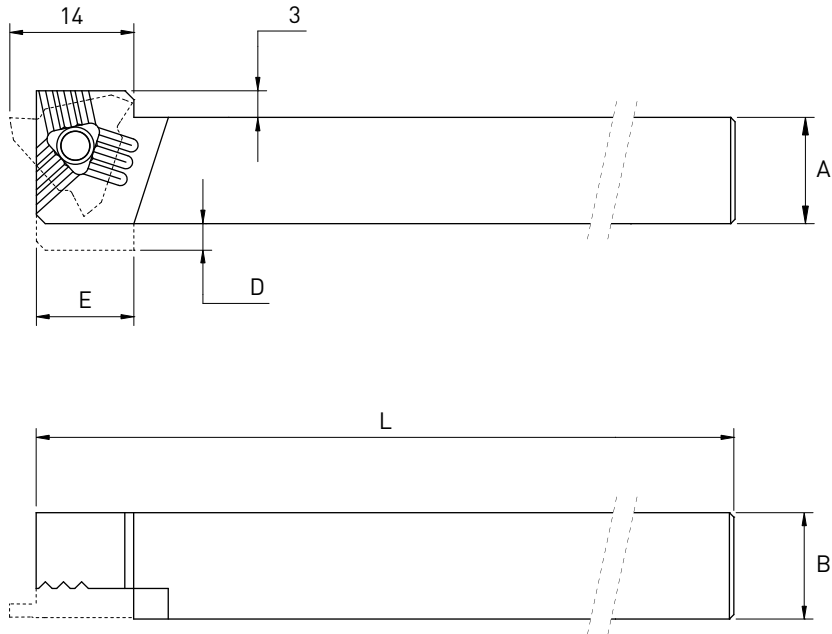
SET-NM-TX15

# TRIO-Line

Porte-outils

Halter

Holder



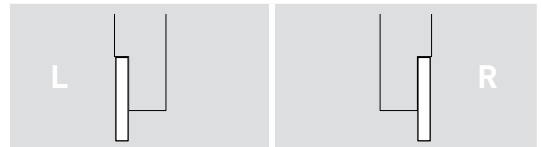
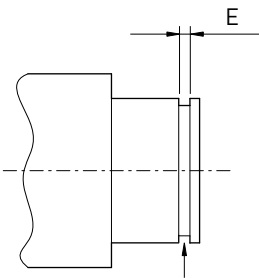
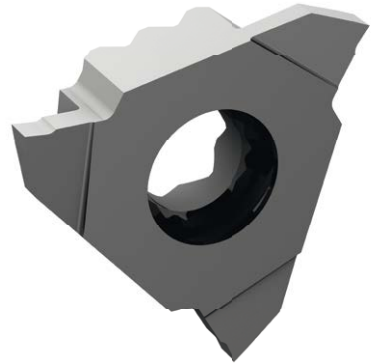
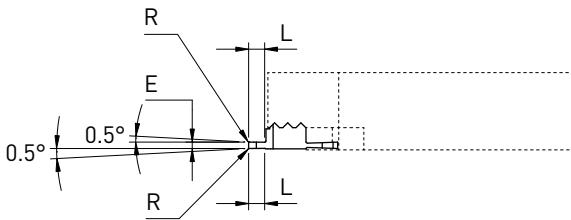
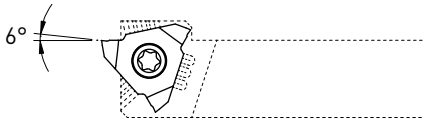
Chaque support est livré avec vis et clé.  
 Jeder Halter wird mit Spannschraube(n)  
 und Schlüssel geliefert.  
 Screw(s) and key are included with each  
 tool holder.

A	B	D	E	L	Art. N°	Art. N°
8	10	4	11	115	T216-H0810L	T216-H0810R
10	10	2	8	130	T216-H1010L	T216-H1010R
12	12	-	-	130	T216-H1212L	T216-H1212R
12	12	-	-	90	T216-H1212L-90	T216-H1212R-90
16	16	-	-	120	T216-H1616L	T216-H1616R
20	20	-	-	130	T216-H2020L	T216-H2020R

Plaquettes de gorge pour circlips

Einstechwendeplatte für Seegerring

Grooving inserts for retaining ring



Selon DIN6799 et DIN471  
Gemäss DIN6799 und DIN471  
According to DIN6799 and DIN471

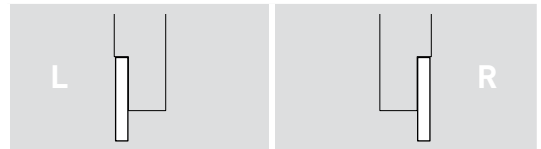
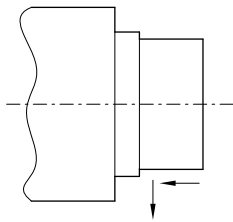
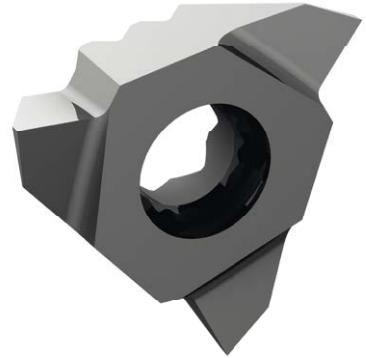
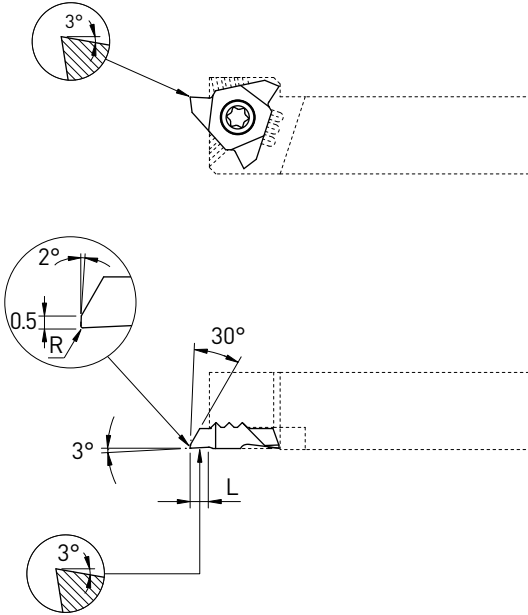
E ±0,01	L	R	L		R	
			Art. N°	HTA HN	Art. N°	HTA HN
0.26	0.8	0.03	T216L-GX026	■ ■	T216R-GX026	■ ■
0.36	0.8	0.03	T216L-GX036	■ ■	T216R-GX036	■ ■
0.46	0.8	0.03	T216L-GX046	■ ■	T216R-GX046	■ ■
0.50	1.5	0.03	T216L-GX050	■ ■	T216R-GX050	■ ■
0.57	1.5	0.03	T216L-GX057	■ ■	T216R-GX057	■ ■
0.67	1.5	0.03	T216L-GX067	■ ■	T216R-GX067	■ ■
0.77	2.0	0.03	T216L-GX077	■ ■	T216R-GX077	■ ■
0.87	2.0	0.03	T216L-GX087	■ ■	T216R-GX087	■ ■
0.97	2.5	0.03	T216L-GX097	■ ■	T216R-GX097	■ ■
1.00	2.5	0.03	T216L-GX100	■ ■	T216R-GX100	■ ■
1.10	2.5	0.03	T216L-GX110	■ ■	T216R-GX110	■ ■
1.20	2.5	0.03	T216L-GX120	■ ■	T216R-GX120	■ ■
1.30	2.5	0.03	T216L-GX130	■ ■	T216R-GX130	■ ■
1.50	2.5	0.03	T216L-GX150	■ ■	T216R-GX150	■ ■
1.60	2.5	0.03	T216L-GX160	■ ■	T216R-GX160	■ ■
1.85	2.5	0.03	T216L-GX185	■ ■	T216R-GX185	■ ■
2.00	2.5	0.03	T216L-GX200	■ ■	T216R-GX200	■ ■
2.50	2.5	0.03	T216L-GX250	■ ■	T216R-GX250	■ ■



# TRIO-Line

Tournage avant  
Vorwärts drehen  
Front turning

FT



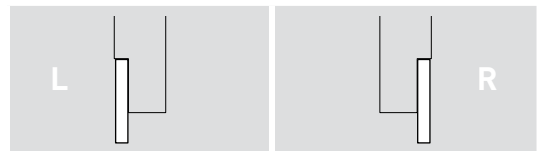
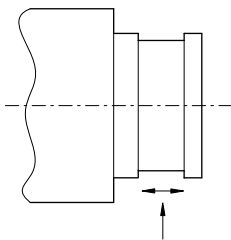
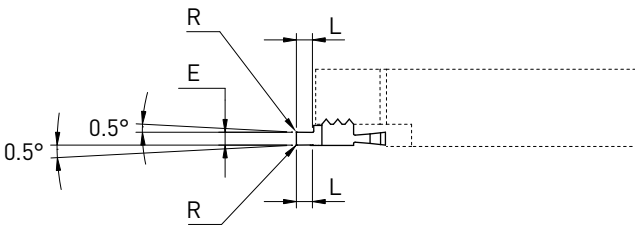
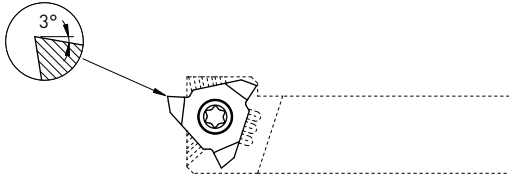
L	R	Art. N°	HTA		HN		
			HTA	HN	HTA	HN	
3.0	0.03	T216L-FT	■	■	T216R-FT	■	■
3.0	0.08	T216L-FT-R08	■	■	T216R-FT-R08	■	■

Foncer-tourner

Einstecken und drehen

Grooving and turning

GT



E	L	R	Art. N°	HTA		Art. N°	HTA	
				HN	HN		HN	HN
0.5	1.5	0.03	T216L-GT050	■	■	T216R-GT050	■	■
1.0	2.5	0.03	T216L-GT100	■	■	T216R-GT100	■	■
1.0	2.5	0.08	T216L-GT100-R08	■	■	T216R-GT100-R08	■	■
1.5	2.5	0.03	T216L-GT150	■	■	T216R-GT150	■	■
1.5	2.5	0.08	T216L-GT150-R08	■	■	T216R-GT150-R08	■	■
1.5	2.5	0.15	T216L-GT150-R15	■	■	T216R-GT150-R15	■	■
2.0	2.5	0.03	T216L-GT200	■	■	T216R-GT200	■	■
2.0	2.5	0.08	T216L-GT200-R08	■	■	T216R-GT200-R08	■	■
2.0	2.5	0.15	T216L-GT200-R15	■	■	T216R-GT200-R15	■	■
2.5	2.5	0.15	T216L-GT250-R15	■	■	T216R-GT250-R15	■	■



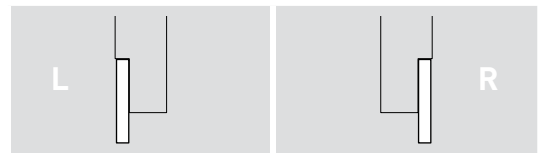
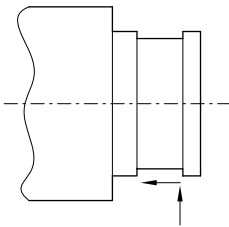
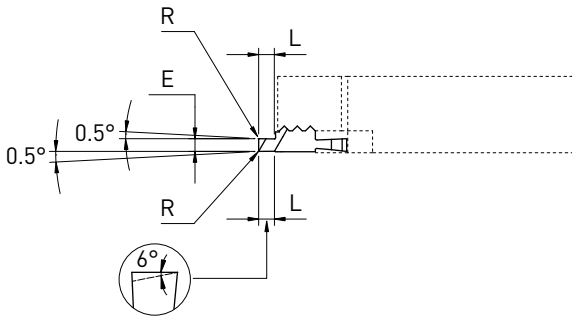
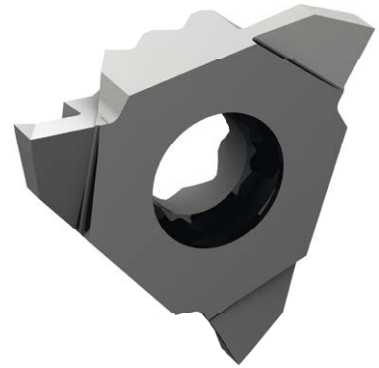
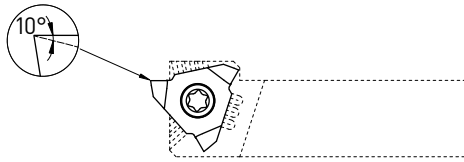
# TRIO-Line

Foncer-tourner

Einstecken und drehen

Grooving and turning

GTX



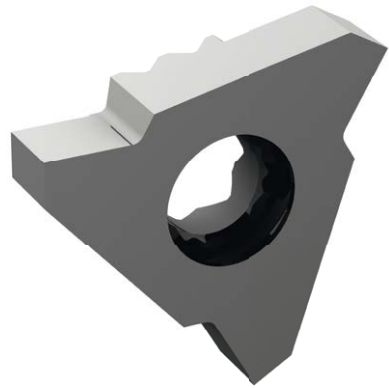
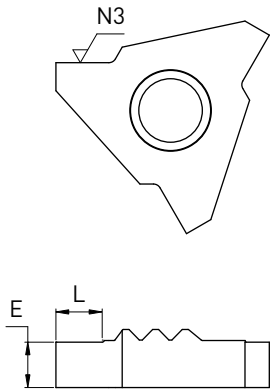
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				HTA	HN		HTA	HN
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1.0	2.5	0.08	T216L-GTX100-R08	■	■	T216R-GTX100-R08	■	■
1.5	2.5	0.03	T216L-GTX150	■	■	T216R-GTX150	■	■
1.5	2.5	0.08	T216L-GTX150-R08	■	■	T216R-GTX150-R08	■	■
1.5	2.5	0.15	T216L-GTX150-R15	■	■	T216R-GTX150-R15	■	■
2.0	2.5	0.03	T216L-GTX200	■	■	T216R-GTX200	■	■
2.0	2.5	0.08	T216L-GTX200-R08	■	■	T216R-GTX200-R08	■	■
2.0	2.5	0.15	T216L-GTX200-R15	■	■	T216R-GTX200-R15	■	■
2.5	2.5	0.15	T216L-GTX250-R15	■	■	T216R-GTX250-R15	■	■

Plaquette ébauche

WSP-Rohling

Blank insert

EP



		L		R	
E	L	Art. N°	HTA HN	Art. N°	HTA HN
-3	3	T216L-EP	■	T216R-EP	■