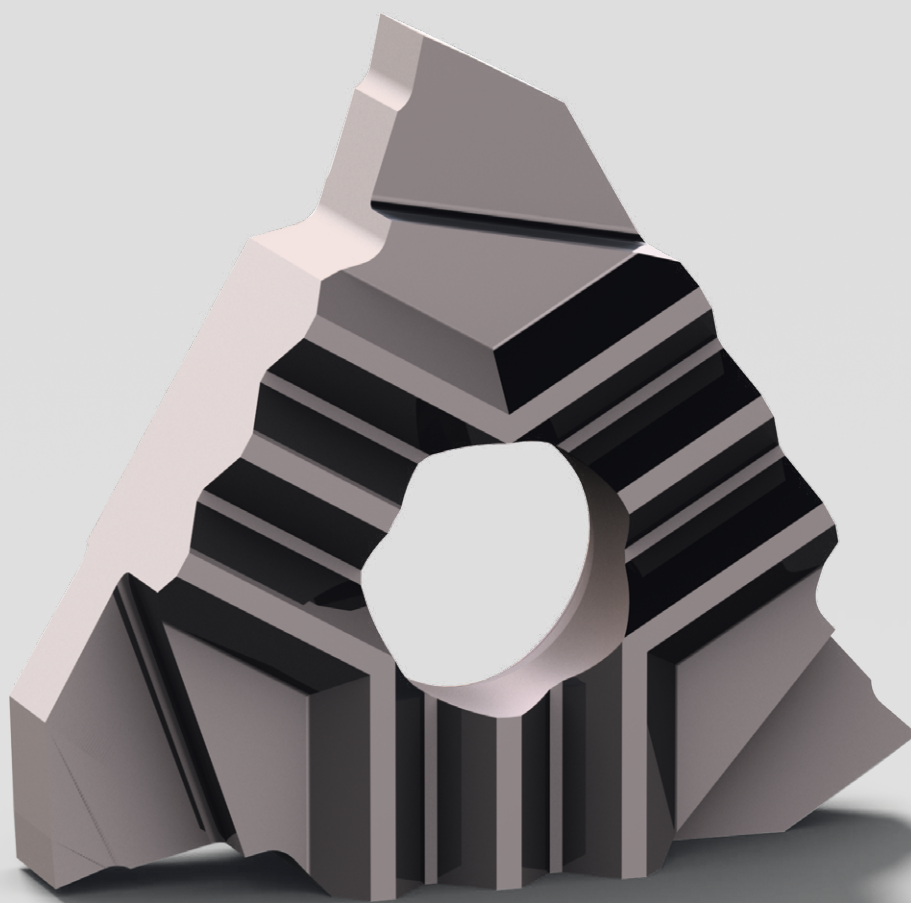


TRIO-Line

2014



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Applitec Moutier S.A.
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CH-2740 Moutier

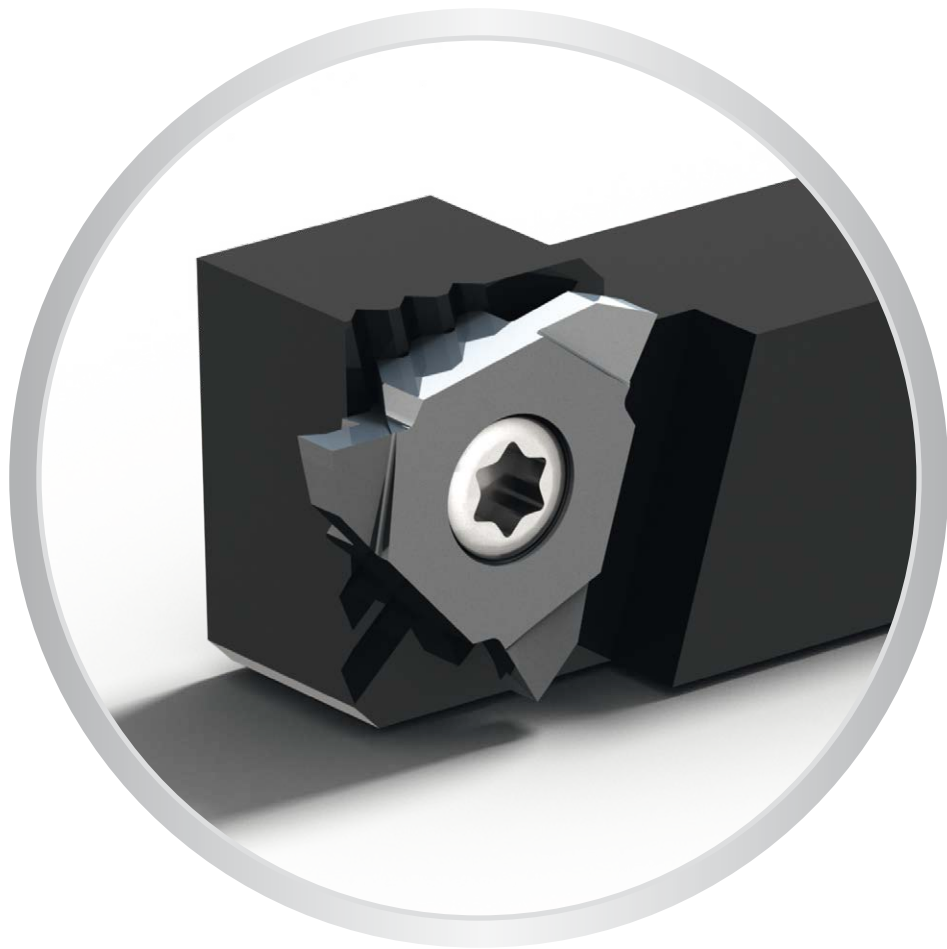


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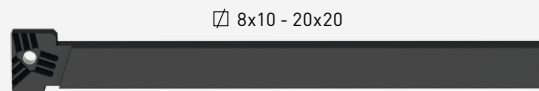
Index

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



> **3**

Porte-outils
Halter
Holders



> **4**

GX

Gorge de précision
Präzisionseinstechen
High precision grooving

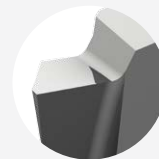
DIN6799
& DIN471



> **5**

FT

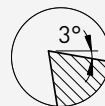
Tournage finition
Schlicht drehen
Fine turning



> **6**

GT

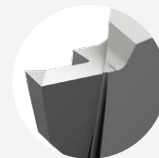
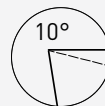
Foncer tourner
Einstechen und drehen
Grooving and turning



> **7**

GTX

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



> **8**

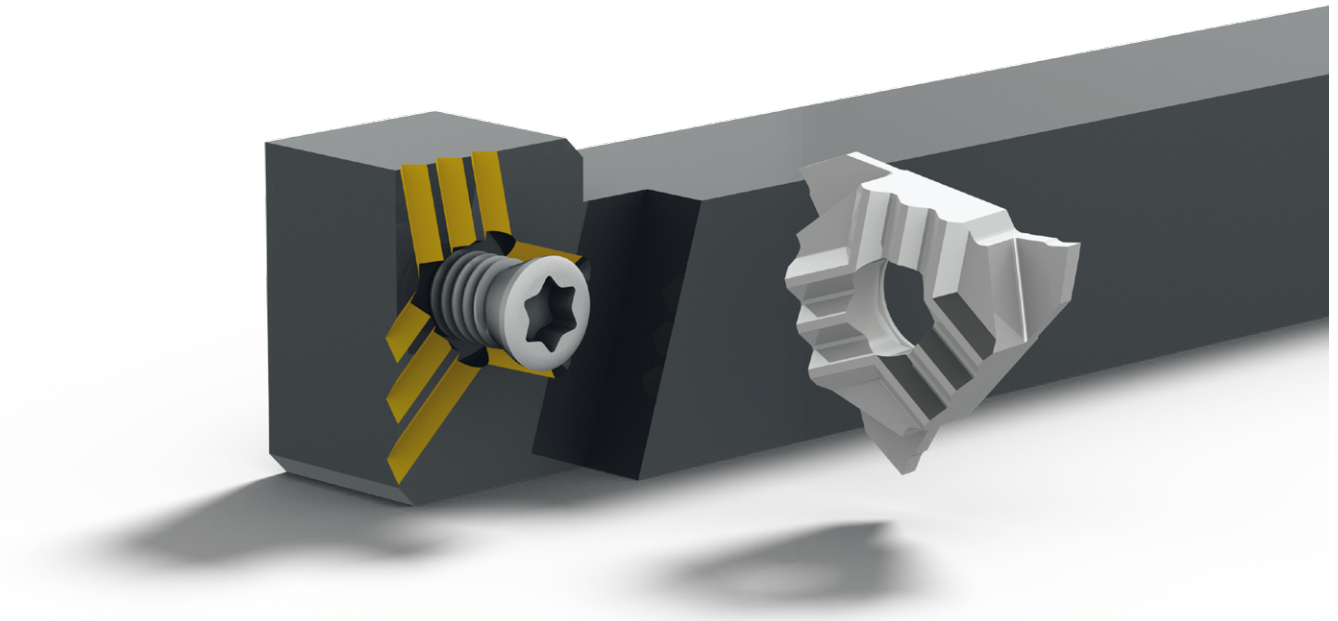
EP

Ebauche
Rohling
Blank



> **9**

Rigid clamping system with the famous Applitec teeth clamping



Nuance micro-grain à dureté élevée

Verschleissfeste Feinkornsorten

Wear resistant micro-grain grades

HN (μ 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

HTA

μ K10 + revêtement PVD
 μ K10 + PVD Beschichtung
 μ 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

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

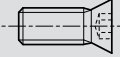
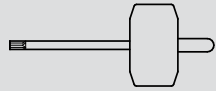
Standard machining data

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

Accessoires

Zubehör

Accessories

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

Recommandation de serrage
Drehmoment Empfehlung
Clamping recommendation

3.0 Nm



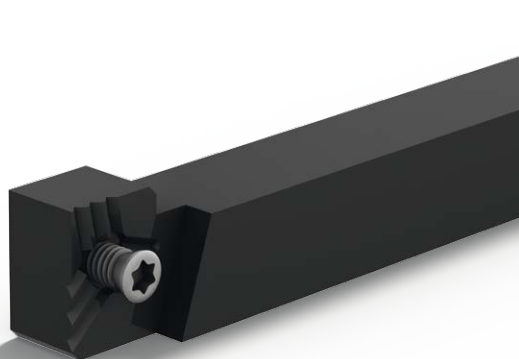
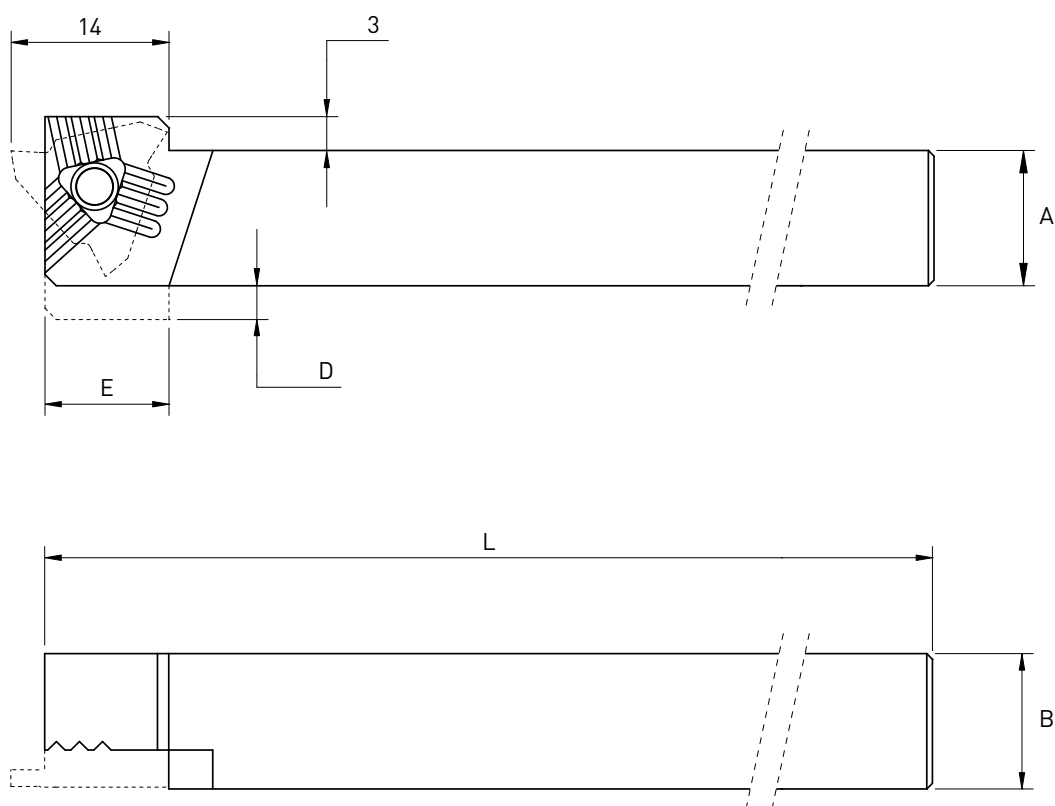
SET-NM-TX15

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Porte-outils

Halter

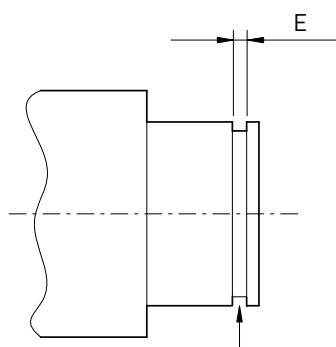
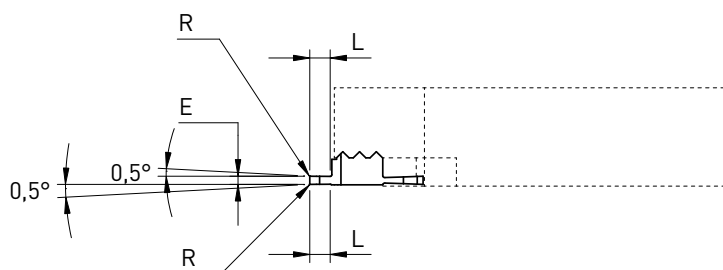
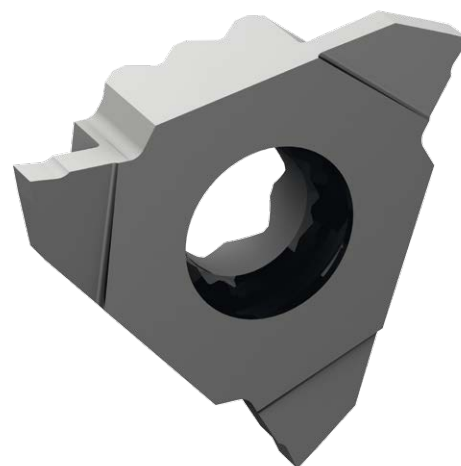
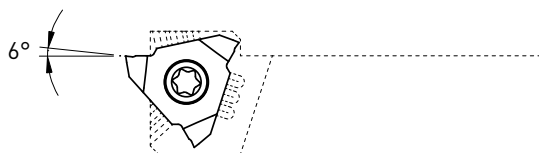
Holders



					 	
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

GX



selon DIN6799 et DIN471
gemäss DIN6799 und DIN471
according to DIN6799 and DIN471

			L		R	
			Art. N°		Art. N°	
			H		H	
			HTA		HTA	
E ±0,01	L	R	Art. N°		Art. N°	
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	■ ■

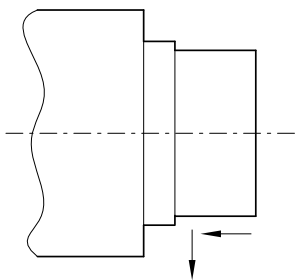
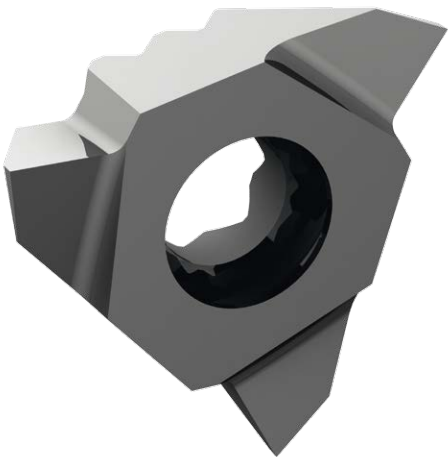
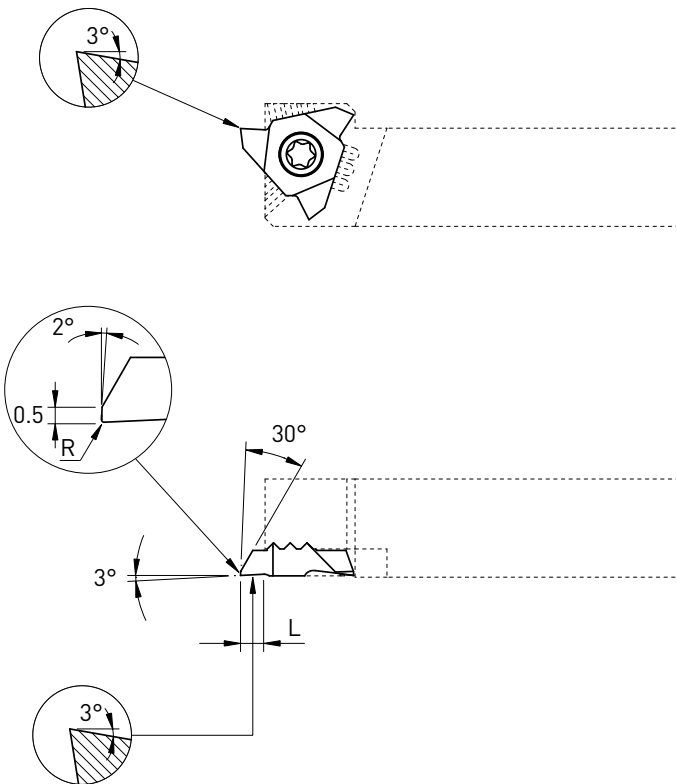


Tournage avant

Vorwärts drehen

Front turning

FT



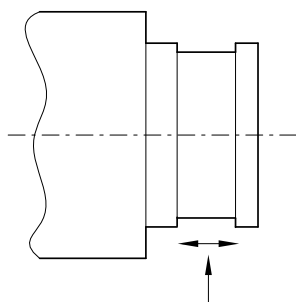
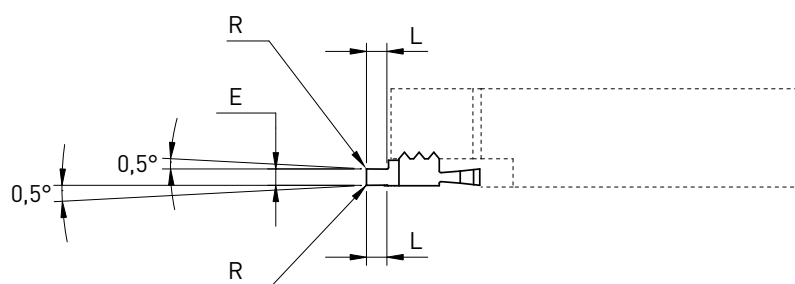
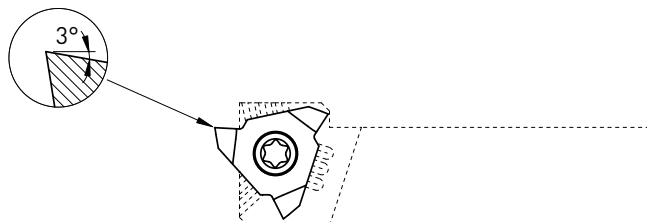
		L			R		
		Art. N°			Art. N°		
L	R	HN	HTA		HN	HTA	
3.0	0.03	■	■	T216L-FT	■	■	T216R-FT
3.0	0.08	■	■	T216L-FT-R08	■	■	T216R-FT-R08

Foncer tourner

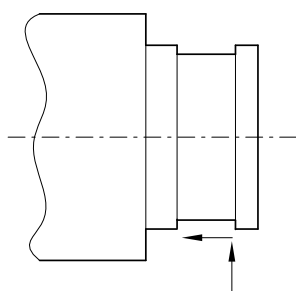
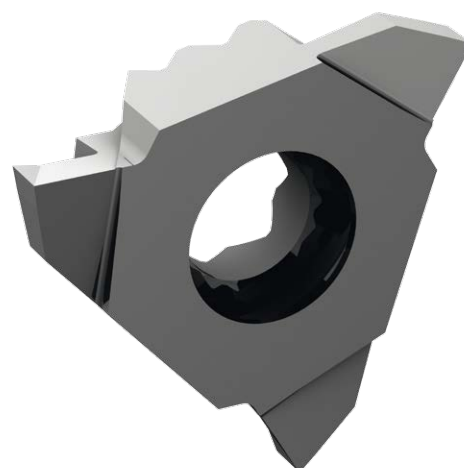
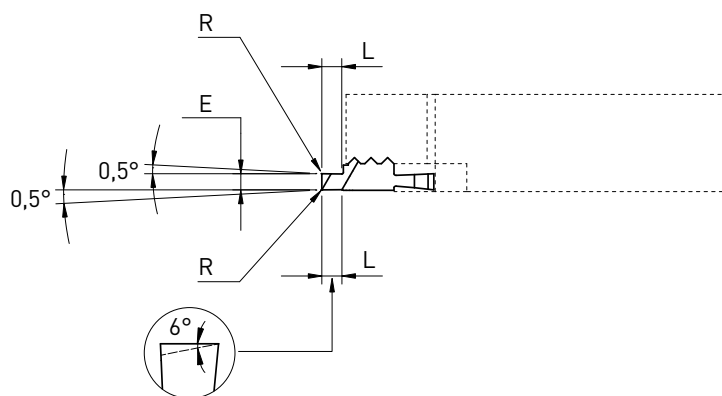
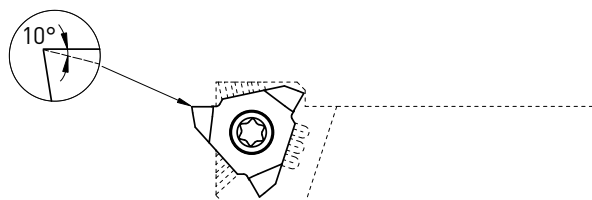
Einstecken und drehen

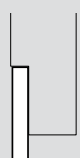
Grooving and turning

GT



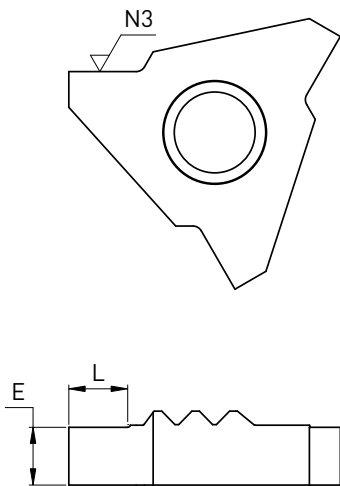
			L		R	
E	L	R	Art. N°	HN HTA	Art. N°	HN HTA
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1.0	2.5	0.03	T216L-GT100	■ ■	T216R-GT100	■ ■
1.0	2.5	0.08	T216L-GT100-R08	■ ■	T216R-GT100-R08	■ ■
1.5	2.5	0.03	T216L-GT150	■ ■	T216R-GT150	■ ■
1.5	2.5	0.08	T216L-GT150-R08	■ ■	T216R-GT150-R08	■ ■
1.5	2.5	0.15	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	■ ■
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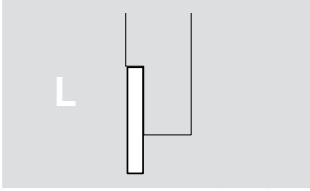
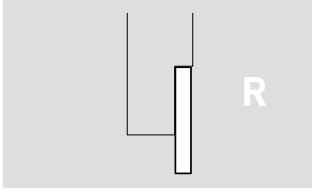


			L			R		
								
E	L	R	Art. N°	HN	HTA	Art. N°	HN	HTA
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1.5	2.5	0.08	T216L-GTX150-R08	■	■	T216R-GTX150-R08	■	■
1.5	2.5	0.15	T216L-GTX150-R15	■	■	T216R-GTX150-R15	■	■
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2.0	2.5	0.15	T216L-GTX200-R15	■	■	T216R-GTX200-R15	■	■
2.5	2.5	0.15	T216L-GTX250-R15	■	■	T216R-GTX250-R15	■	■

Ebauche
Rohling
Blank

EP



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

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