APPLITEC

optima tools
wyłączny dystrybutor w Polsce
APPLITEC SWISS TOOLING

ECO-Line

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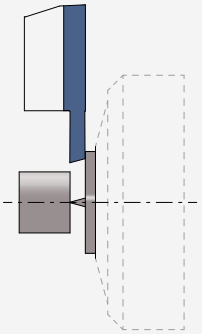
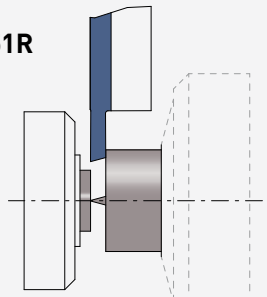
261



251R



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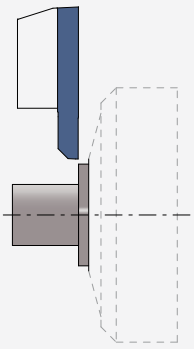

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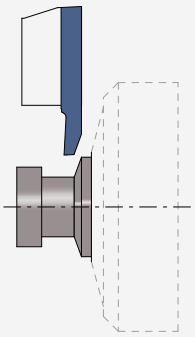

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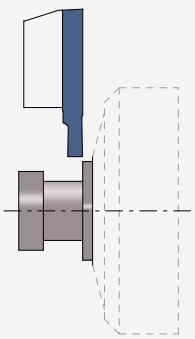

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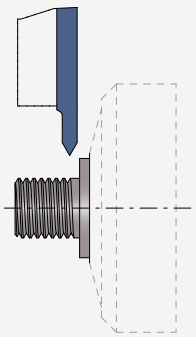

wyłączny dystrybutor w Polsce
APPLITEC SWISS TOOLING

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ECO-Line

Nuances
Sorten
Grades

optima tools
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NEW

AP302
µK20 + revêtement PVD
µK20 + PVD Beschichtung
µK20 + PVD coating

- 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

AP202
µK20 + revêtement PVD
µK20 + PVD Beschichtung
µK20 + PVD coating

- nuance particulièrement adaptée aux faibles vitesses de coupe

- besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten

- grade particularly suitable for low cutting speeds

N (µK20)
non revêtu
unbeschichtet
uncoated

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

- zähe Feinkornsorte
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen geeignet

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

NEW

AH302
µK10 + revêtement PVD
µK10 + PVD Beschichtung
µK10 + 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

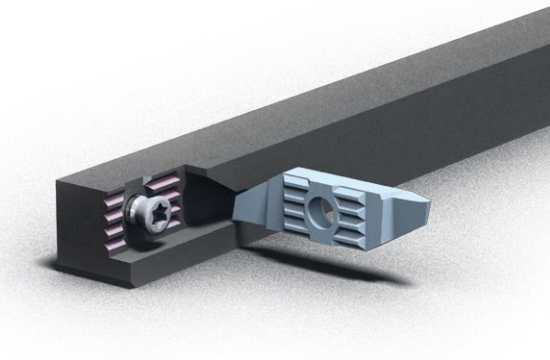
NEW

HN (µK10)
non revêtu
unbeschichtet
uncoated

- 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
- empfehlenswert für die Bearbeitung von niedrig legiertem Titan
- 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



Patented rigid clamping system

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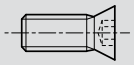
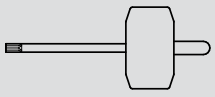
Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

	Tournage Drehen Turning		Tronçonnage Abstechen Cut off	
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 Steel < 600 N/mm²	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12
Acier Stahl Steel < 800 N/mm²	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10
Acier Stahl Steel < 800 N/mm²	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

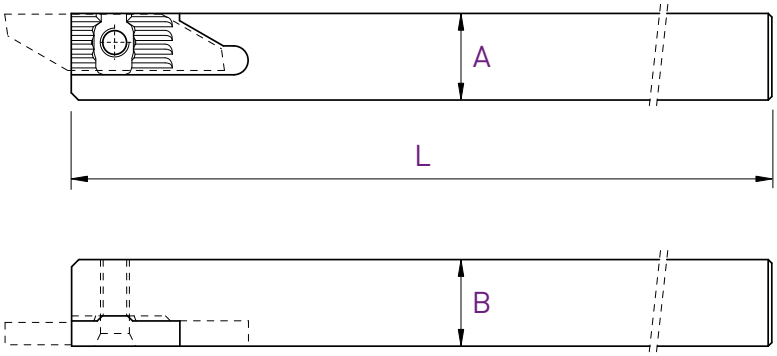
Accessoires
Zubehör
Accessories

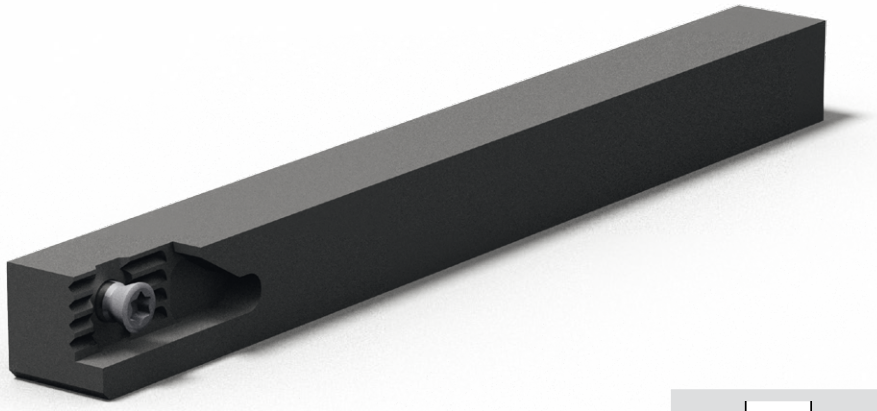
Porte-outils Halter Holders			Option
250-... / 260-...	**V-M4X9-T15**	**C-T15**	**SET-NM-TX15**
250-8 / 260-8	**V-M3.5X7-T15**		
250RC / 260-C	**V-M4X7.3-T15**		

Recommandation de serrage
Drehmoment Empfehlung
Clamping recommendation

3.0 Nm

SET-NM-TX15

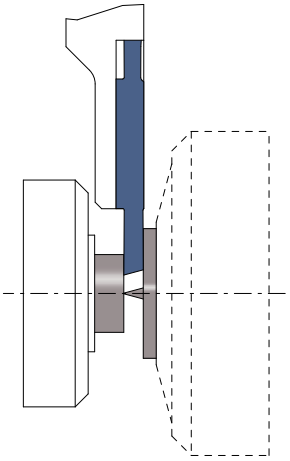


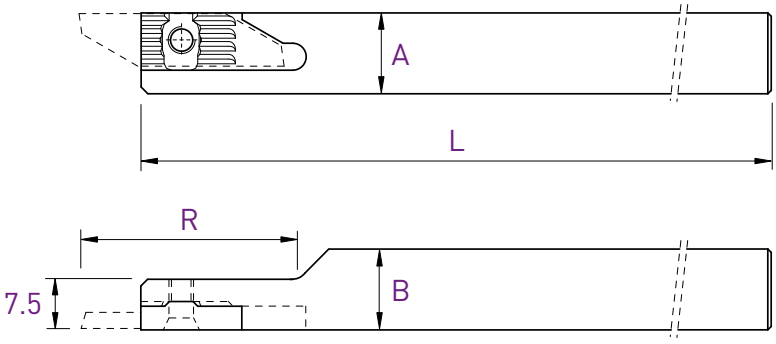


		L	R
A x B	L	Art. N°	Art. N°
8 x 8	115	**250-8**	**260-8**
10 x 10	115	**250-10**	**260-10**
12 x 12	130	**250-12**	**260-12**
12 x 12	90	**250-12-90**	**260-12-90**
12.7 x 12.7	130	**250-12.7**	**260-12.7**
16 x 16	130	**250-16**	**260-16**
16 x 16	75	**250-16-75**	**260-16-75**
20 x 20	120	**250-20**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

Porte-outils
Halter
Holders

260-C



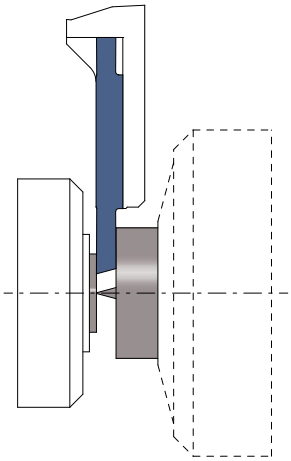


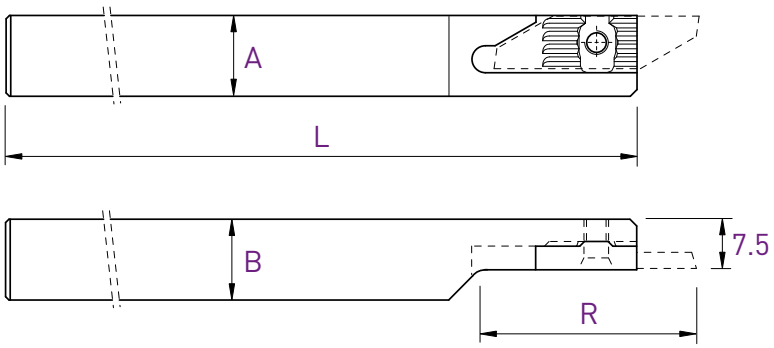
R

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

Porte-outils
Halter
Holders

250RC

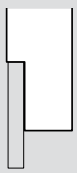




utiliser des plaquettes type 251R
WSP Typ 251R verwenden
use inserts type 251R

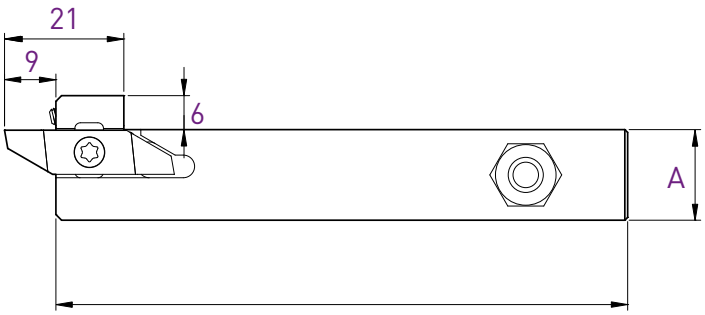
L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

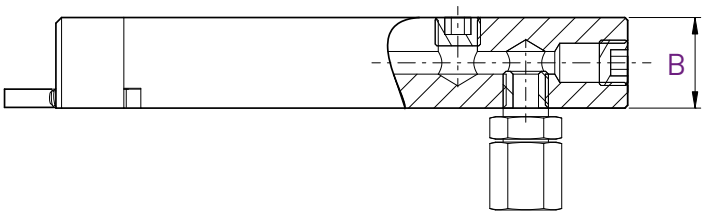


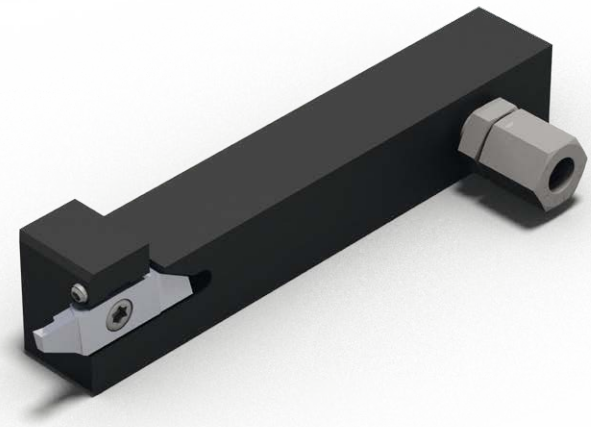
A x B	L	R	Art. N°
12 x 12	130	30	**250RC-12**
16 x 16	130	40	**250RC-16**

250JET / 260JET



NEW



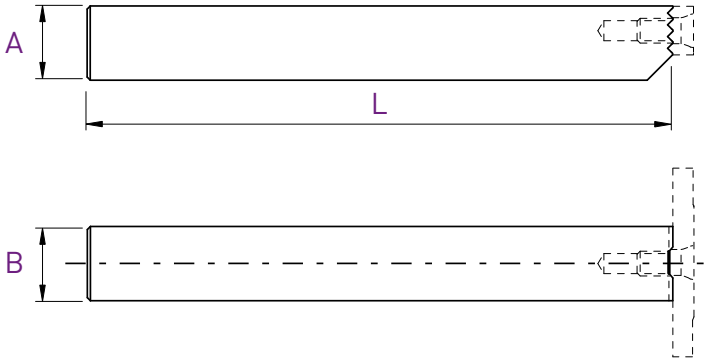


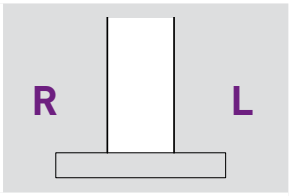
		L	R
A x B	L	Art. N°	Art. N°
10 x 12	100	**250-1012-JET**	**260-1012-JET**
12 x 12	100	**250-12-JET**	**260-12-JET**
16 x 16	100	**250-16-JET**	**260-16-JET**
20 x 20	100	**250-20-JET**	**260-20-JET**

Pièces de rechange Ersatzteile Spare parts		
	Art. N°	Art. N°
250-JET/260-JET	**J-M8X1-D6**	**JB-M8X1**

Porte-outils
Halter
Holders

260/250F

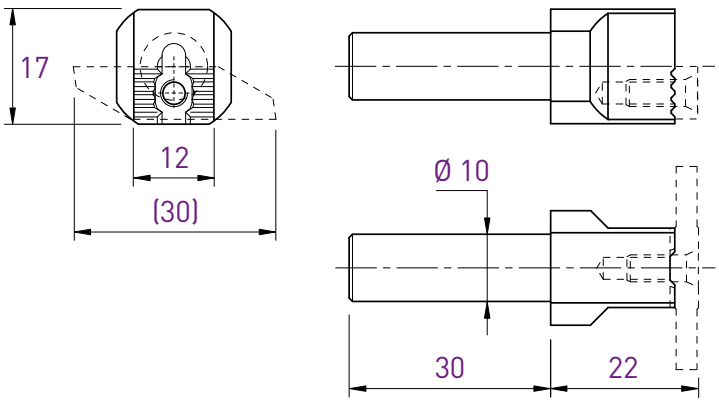


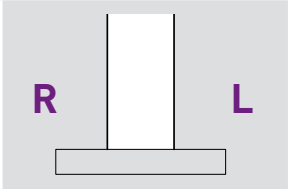


A x B	L	Art. N°
10 x 12	120	**260/250F-1012**
12 x 12	120	**260/250F-1212**

Porte-outils
Halter
Holders

260/250-D





Art. N°
260/250-D10

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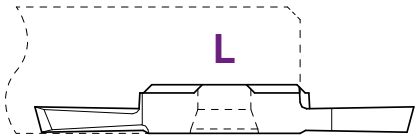
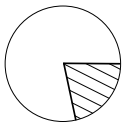
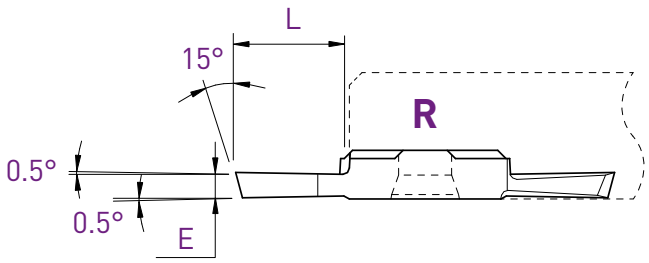
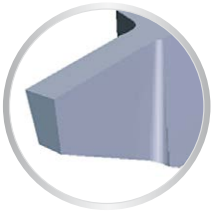
Tronçonnage
Abstechen
Cut off

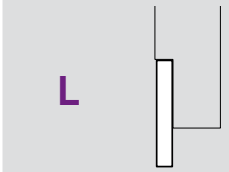
251 / 261

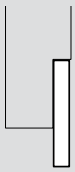








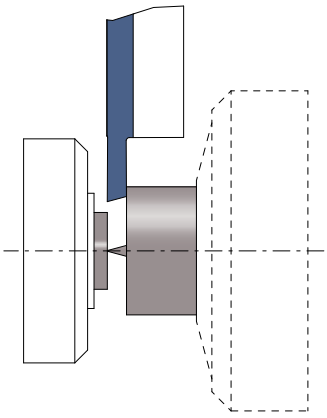


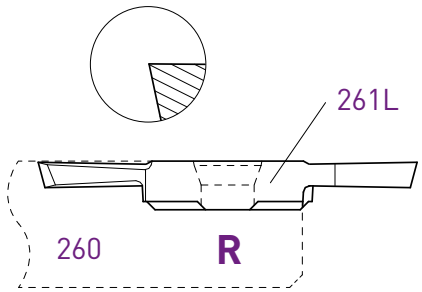


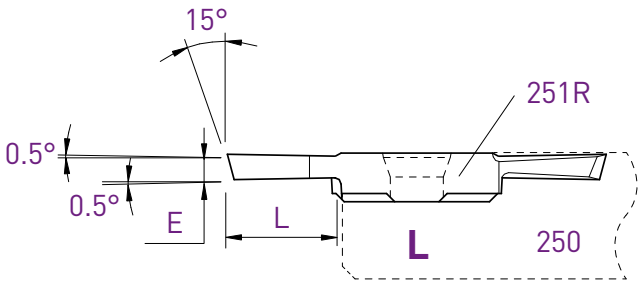
E	L	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
0.8	4	**251-0.8**	■	□	■	**261-0.8**	■	□	■
1.0	5	**251-1.0**	■	□	■	**261-1.0**	■	□	■
1.2	5	**251-1.2**	■	□	■	**261-1.2**	■	□	■
1.5	7	**251-1.5**	■	□	■	**261-1.5**	■	□	■
2.0	8.5	**251-2.0**	■	□	■	**261-2.0**	■	□	■
2.5	8.5	**251-2.5**	■	□	■	**261-2.5**	■	□	■

Coupe déportée
Versetztes Schneiden
Cut off line

261L / 251R





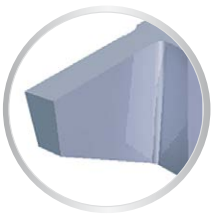


R (L)

Coupe à gauche déportée
Versetztes Linksschneiden
Left cut off line

L (R)

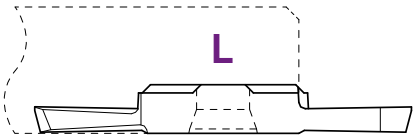
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

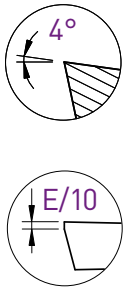


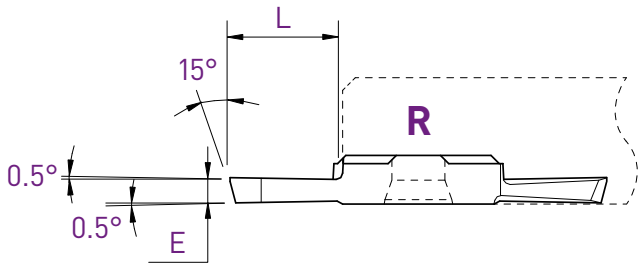
E	L	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
1.0	5	-	■	□	■	**251R-1.0**	■	□	■
1.5	7	-	■	□	■	**251R-1.5**	■	□	■
2.0	8.5	**261L-2.0**	■	□	■	**251R-2.0**	■	□	■

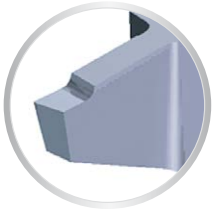
Tronçonnage
Abstechen
Cut off

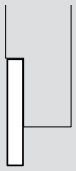
251XF / 261XF

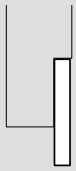








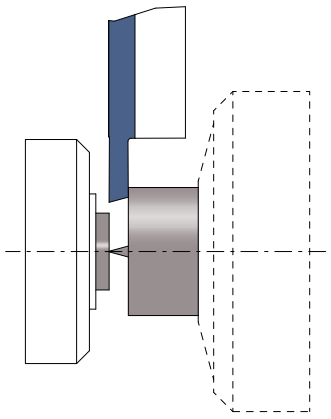


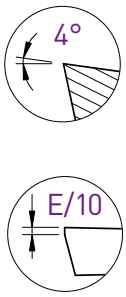


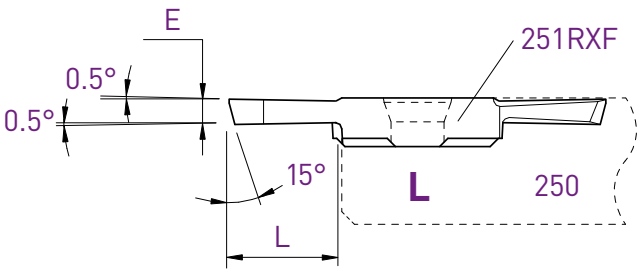
E	L	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
1.5	7	**251XF-1.5**	■	□	■	**261XF-1.5**	■	□	■
2.0	8.5	**251XF-2.0**	■	□	■	**261XF-2.0**	■	□	■

Coupe déportée
Versetztes Schneiden
Cut off line

251RXF







L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

E	L	Art. N°	AP302	AP202	N
1.5	7	**251RXF-1.5**	■	□	■
2.0	8.5	**251RXF-2.0**	■	□	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending the stock availability

optima tools
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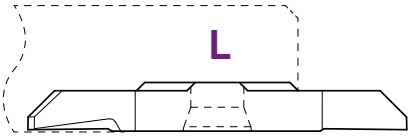
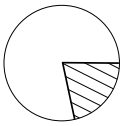
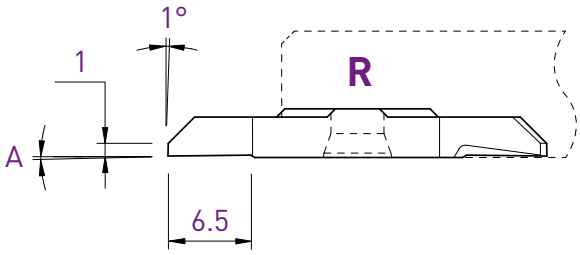
Tourneur avant
Vorwärts drehen
Front turning

252 / 262



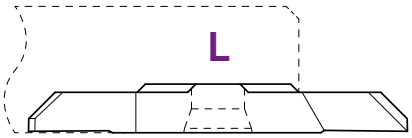


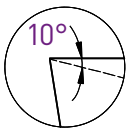


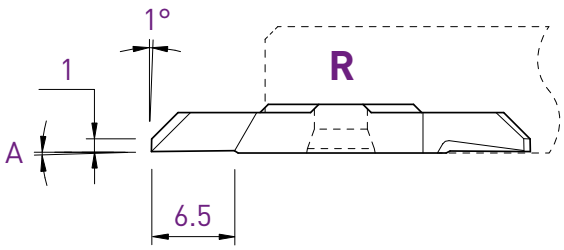
	L			R		
A	Art. N°	AP302	AP202	Art. N°	AP302	AP202
0°	252	■	□	262	■	□
2°	252-2°	■	□	262-2°	■	□

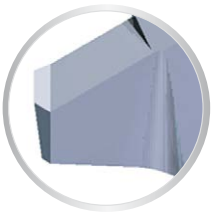
Tourneur avant
Vorwärts drehen
Front turning

252X / 262X







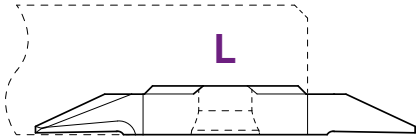


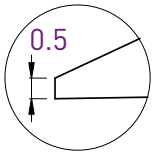
	L			R		
A	Art. N°	AP302	AP202	Art. N°	AP302	AP202
0°	252X	■	□	262X	■	□
2°	252X-2°	■	□	262X-2°	■	□

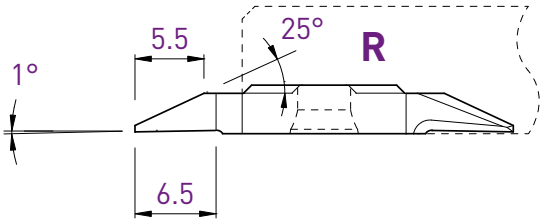
Tourneur avant
Vorwärts drehen
Front turning

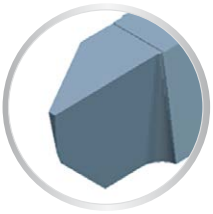
NEW

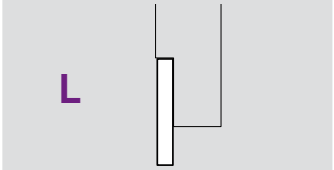
252S / 262S

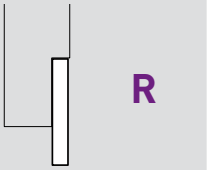










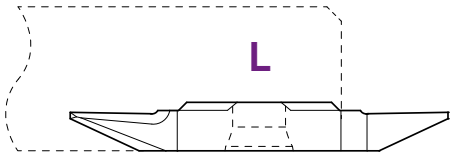


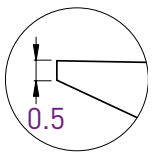
Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
252S05	■	□	■	262S05	■	□	■

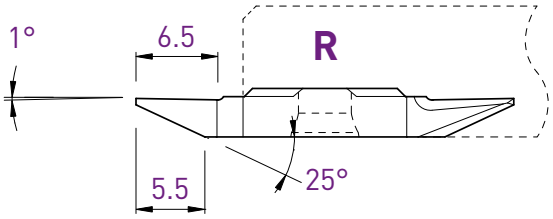
Tourneur arrière
Rückwärts drehen
Back turning

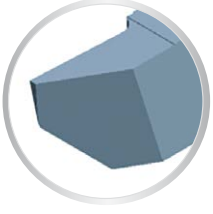
NEW

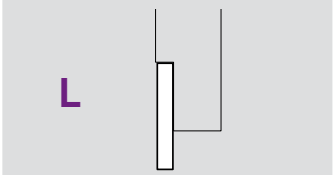
253S / 263S

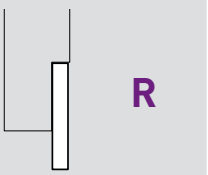












Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
253S05	■	□	■	263S05	■	□	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending the stock availability

optima tools
wyłączny dystrybutor w Polsce
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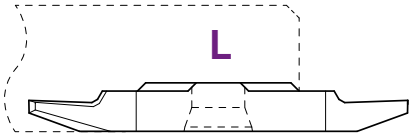
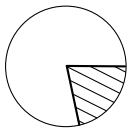
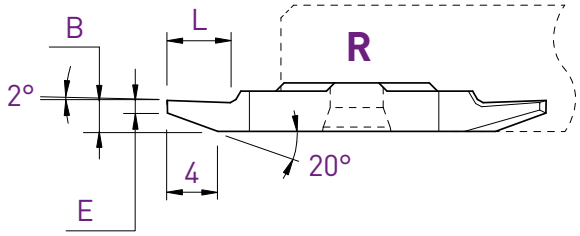
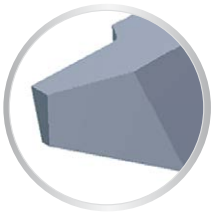
Tourneur arrière
Rückwärts drehen
Back turning

253 / 263





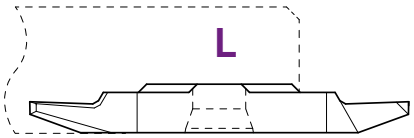


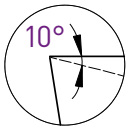


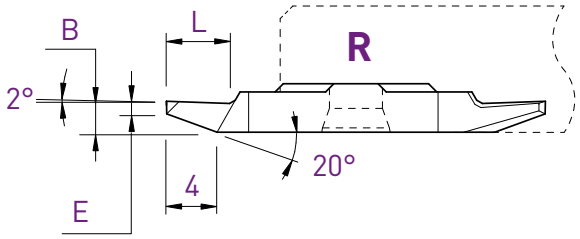
			L				R			
B	E	L	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
2.0	0.5	4	**253-0.5**	■	□	■	**263-0.5**	■	□	■
2.5	1.0	5	**253-1.0**	■	□	■	**263-1.0**	■	□	■

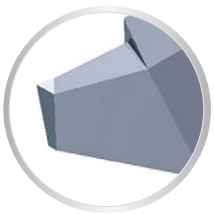
Tourneur arrière
Rückwärts drehen
Back turning

253X / 263X





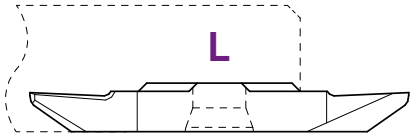


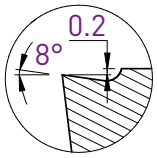


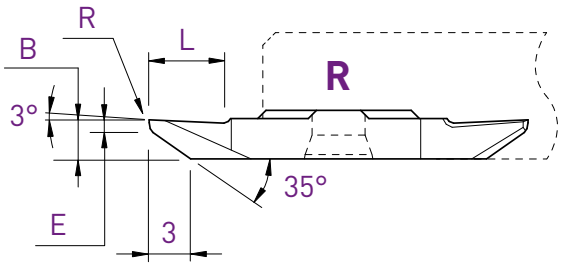
			L				R			
B	E	L	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
2.0	0.5	5	**253X-0.5**	■	□	■	**263X-0.5**	■	□	■
2.5	1.0	5	**253X-1.0**	■	□	■	**263X-1.0**	■	□	■

Tourneur arrière
Rückwärts drehen
Back turning

253VX-8° / 263VX-8°



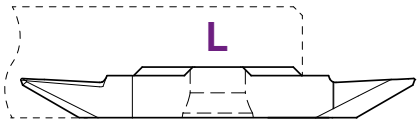


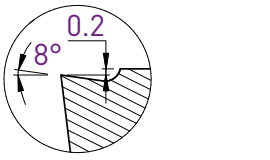


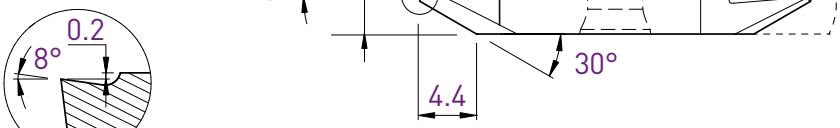
				L				R				
B	E	L	R	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N	AH302	HN
3.1	1.0	6	0	**253VX-8°**	■	□	■	**263VX-8°**	■	□	■		
3.1	1.0	6	0.08	-				**263VX-8°-R08**	■	□	■	■	■
3.1	1.0	6	0.2	-				**263VX-8°-R20**	■	□	■	■	■

Tourneur arrière
Rückwärts drehen
Back turning

253VX-805 / 263VX-805

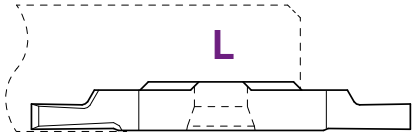


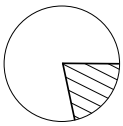


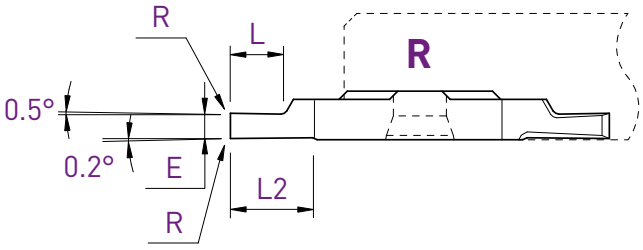


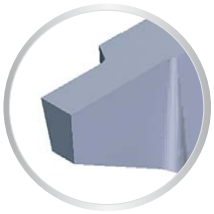
				L				R				
B	E	L	R	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N	AH302	HN
3.0	0.5	6	0.08	**253VX-805-R08**	■	□	■	**263VX-805-R08**	■	□	■	■	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending the stock availability

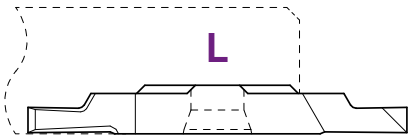


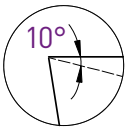


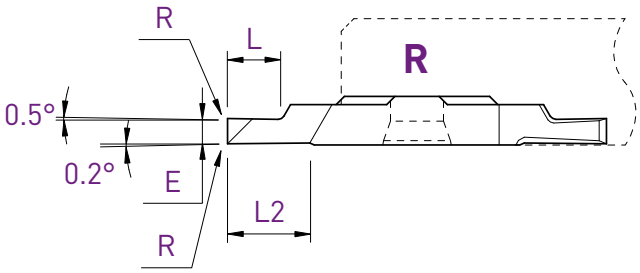


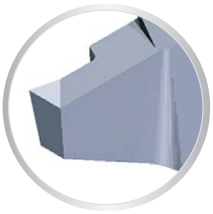


	L			L			R		
E	L	L2	R	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N
0.8	2	4	0	**254-0.8**	■	□	■	**264-0.8**	■	□	■
1.0	2.5	4	0	**254-1.0**	■	□	■	**264-1.0**	■	□	■
1.2	3	4	0	**254-1.2**	■	□	■	**264-1.2**	■	□	■
1.5	3	4	0	**254-1.5**	■	□	■	**264-1.5**	■	□	■
1.8	4	6.5	0	-				**264-1.8**	■	□	■
2.0	4	6.5	0	**254-2.0**	■	□	■	**264-2.0**	■	□	■
2.5	6	6.5	0	**254-2.5**	■	□	■	**264-2.5**	■	□	■
3.0	6.5	6.5	0	**254-3.0**	■	□	■	**264-3.0**	■	□	■







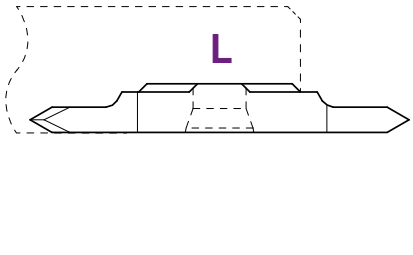


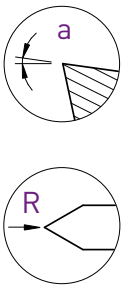
				L				R				
E	L	L2	R	Art. N°	AP302	AP202	N	Art. N°	AP302	AP202	N	AH302	HN
0.8	2	4	0	**254X-0.8**	■	□	■	**264X-0.8**	■	□	■		
1.0	2.5	4	0	**254X-1.0**	■	□	■	**264X-1.0**	■	□	■		
1.0	2.5	4	0.08	-				**264X-1.0-R08**	■	□	■	■	■
1.2	3	4	0	**254X-1.2**	■	□	■	**264X-1.2**	■	□	■		
1.5	3	4	0	**254X-1.5**	■	□	■	**264X-1.5**	■	□	■		
1.5	3	4	0.08	-				**264X-1.5-R08**	■	□	■	■	■
1.5	3	4	0.2	-				**264X-1.5-R20**	■	□	■	■	■
2.0	4	6.5	0	**254X-2.0**	■	□	■	**264X-2.0**	■	□	■		
2.0	4	6.5	0.08	-				**264X-2.0-R08**	■	□	■	■	■
2.0	4	6.5	0.2	-				**264X-2.0-R20**	■	□	■	■	■
2.5	6	6.5	0	**254X-2.5**	■	□	■	**264X-2.5**	■	□	■		
2.5	6.5	6.5	0.08	-				**264X-2.5-R08**	■	□	■	■	■
2.5	6.5	6.5	0.2	-				**264X-2.5-R20**	■	□	■	■	■
3.0	6.5	6.5	0	**254X-3.0**	■	□	■	**264X-3.0**	■	□	■		
3.0	6.5	6.5	0.08	-				**264X-3.0-R08**	■	□	■	■	■
3.0	6.5	6.5	0.2	-				**264X-3.0-R20**	■	□	■	■	■

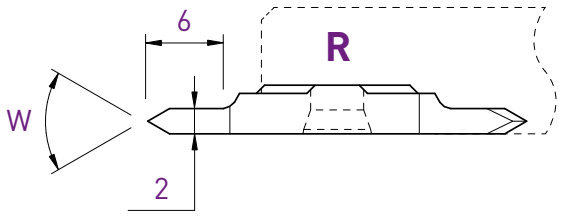
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending the stock availability

Fileter
Gewinde drehen
Threading

Partial profil 60° – 256-60 / 266-60



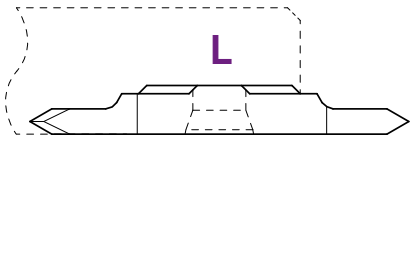


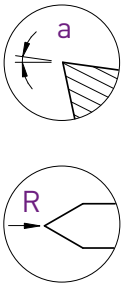


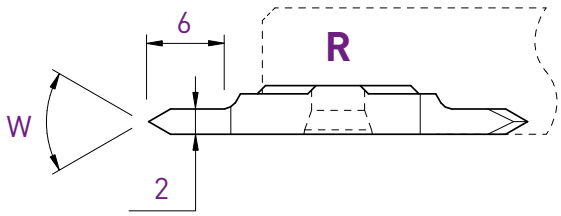
W	R	a	L Art. N°	AP302	AP202	N	R Art. N°	AP302	AP202	N
60°	0	0°	256-60-2	■	□	■	266-60-2	■	□	■
60°	0.06	3°	256-AG60	■	□	■	266-AG60	■	□	■

Fileter
Gewinde drehen
Threading

Partial profil 55° – 256-55 / 266-55







W	R	a	L Art. N°	AP302	AP202	N	R Art. N°	AP302	AP202	N
55°	0	0°	256-55-2	■	□	■	266-55-2	■	□	■
55°	0.06	3°	256-AG55	■	□	■	266-AG55	■	□	■

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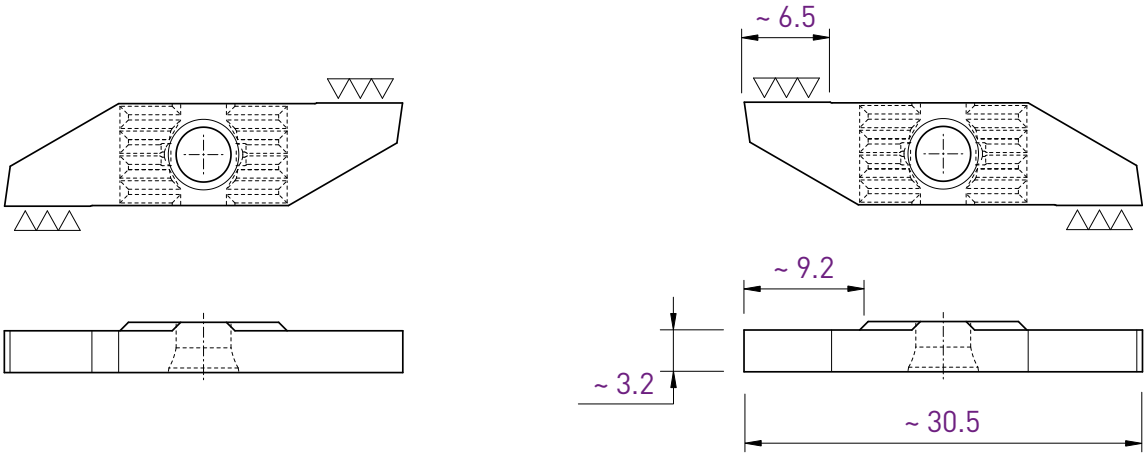
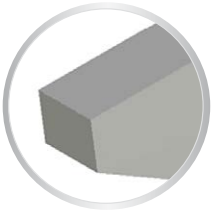
Ebauche
Rohling
Blank

251-E / 261-E





L					R				
Art. N°	AP302	AP202	N	AH302	HN	Art. N°	AP302	AP202	N	AH302	HN
251-E	■	□	■	■	■	261-E	■	□	■	■	■

■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending the stock availability

PERFORMANCE | PRECISION | RIGIDITY

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