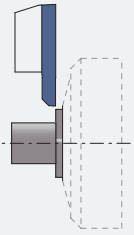
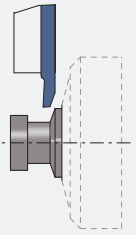
APPLITEC

Codification des usinages
Bearbeitung Bezeichnungssystem
Machining designation key

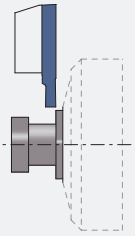
642



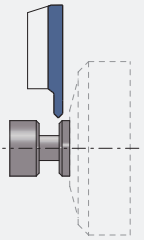
643



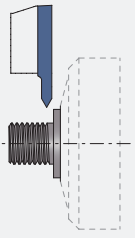
644



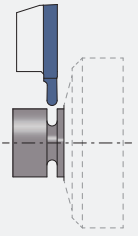
645



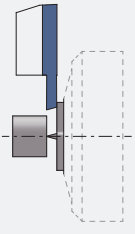
646



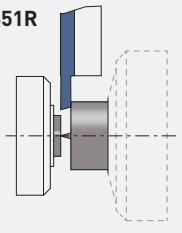
647



661



651R



Codification des plaquettes PRO-Line série 600
WSP-Bezeichnungssystem für PRO-Line 600 Serie
Inserts designation key for PRO-Line 600 series

INFO

6	4	4	X	–	2.0	–	R15	–	TiAlN

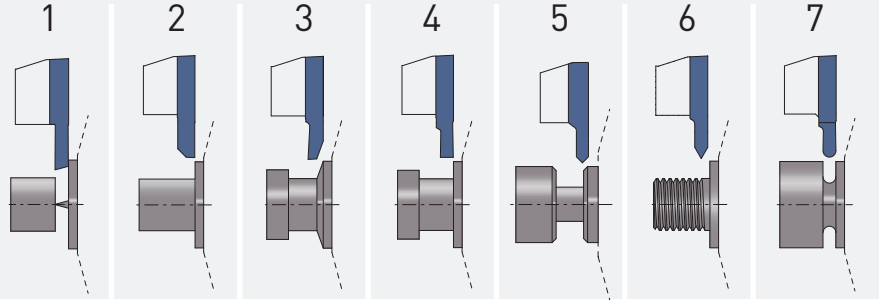
Dimension
Abmessung
Dimension

Rayon
Radius
Radius

Nuance
Sorte
Grade

Géométrie de coupe brise-copeau particularités
Schneidgeometrie Spanbrecher Sondereigenschaften
Cutting geometry chip breaker special features

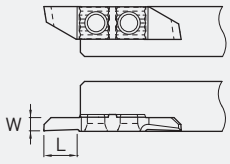
Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry



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

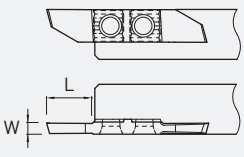
L = 3, 5 (chiffre impair / ungerade Zahl / uneven number)
R = 4, 6 (chiffre pair / gerade Zahl / even number)

SERIES	L	R
Tournage et gorge Drehen und Einstechen Turning and grooving	630	640



W max = 3 mm
L max = 8 mm

SERIES	L	R
Tronçonnage Abstechen Parting off	650	660



W max = 2.5 mm
L max = 11 mm

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

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

Matière Werkstoff Material		Tournage Drehen Turning 630/640			Tronçonnage Abstechen Parting off 650/660		
		VC	Prof. de passe Schnitttiefe Depth of cut	Avance Vorschub Feed	VC	Largeur de coupe Abstechbreite Cutting width	Avance Vorschub Feed
		(m/min)	(mm)	(mm/U)	(m/min)	(mm)	(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

Nuances
Sorten
Grades

TiAlN

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

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 unfavorable machining conditions

HTA

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 favorable machining conditions

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

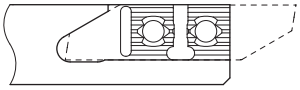
- verschleissfeste Feinkornsorte
- für die Bearbeitung von niedrig legiertem Titan empfehlenswert
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen nicht geeignet

- wear resistant micro-grain grade
- suitable for the machining of low alloyed titanium
- not suitable for interrupted cut and other unfavorable machining conditions

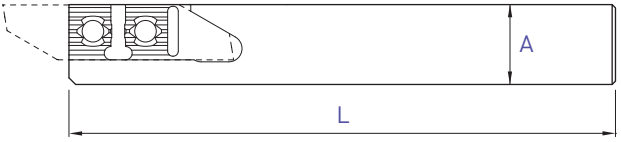
Porte-outils
Halter
Holders

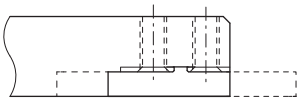
630 / 640

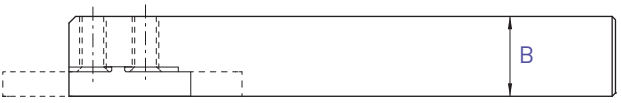
L

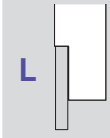


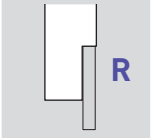
R









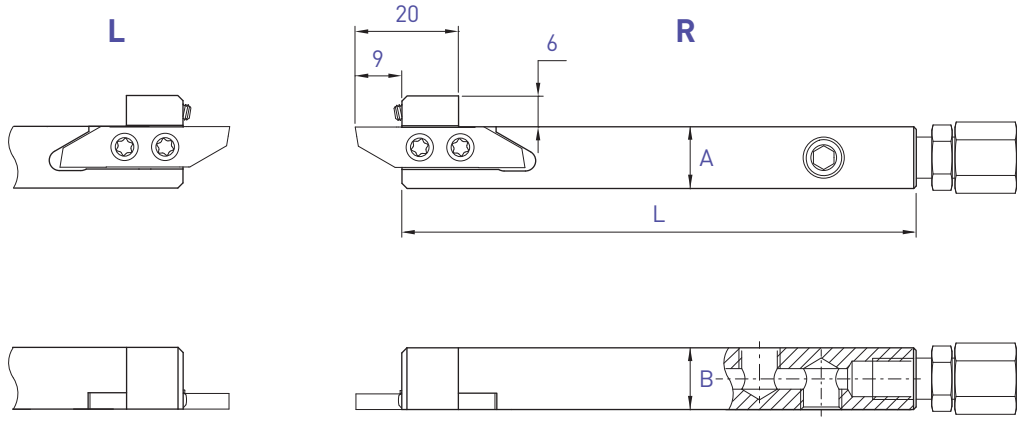


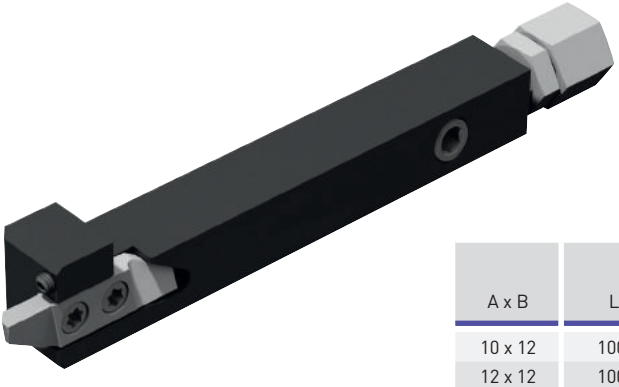
A x B	L	Art. N°	Art. N°
8 x 8	115	**630-8**	**640-8**
10 x 10	115	**630-10**	**640-10**
10 x 10	50	**630-10-50**	**640-10-50**
12 x 12	130	**630-12**	**640-12**
12 x 12	90	**630-12-90**	**640-12-90**
12.7 x 12.7	130	**630-12.7**	**640-12.7**
16 x 16	130	**630-16**	**640-16**
16 x 16	75	**630-16-75**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

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

Porte-outils avec arrosage intégré
Halter mit integrierter Kühlmittelzufuhr
Holders with integrated coolant supply

630-JET / 640-JET





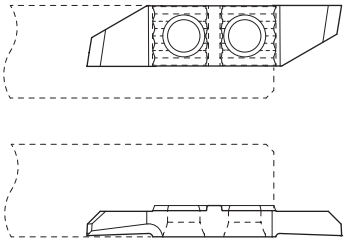
		L	R
A x B	L	Art. N°	Art. N°
10 x 12	100	**630-1012-JET**	**640-1012-JET**
12 x 12	100	**630-12-JET**	**640-12-JET**
12.7 x 12.7	100	**630-12.7-JET**	**640-12.7-JET**
16 x 16	100	**630-16-JET**	**640-16-JET**
20 x 20	100	**630-20-JET**	**640-20-JET**

Chaque support est livré avec vis, clé, raccord droit et buse d'arrosage Ø 1.5 mm.
Jeder Halter wird mit Spannschraube(n), Schlüssel, gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert.
Screw(s), key, straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder.

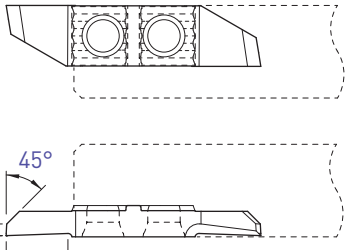
Tournage avant
Vorwärts drehen
Front turning

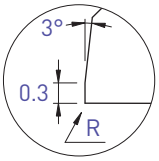
632 / 642

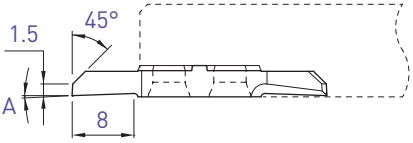
L



R





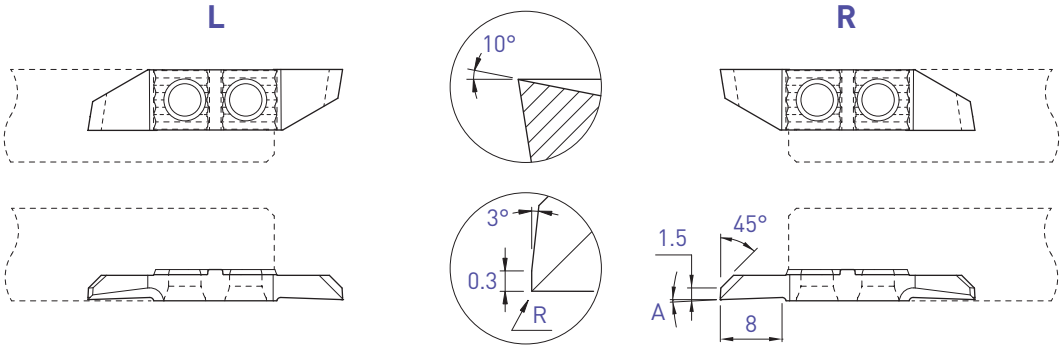


L						R				
A	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0°	0	**632**	■	■			**642**	■	■	□	□
0°	0.08	–					**642-R08**	■	■	□	□
0°	0.15	–					**642-R15**	■	■	□	□
2°	0	**632-2°**	■	■			**642-2°**	■	■	□	□
2°	0.08	–					**642-2°-R08**	■	■	□	□
2°	0.15	–					**642-2°-R15**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

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

Tournage avant
Vorwärts drehen
Front turning

632X / 642X



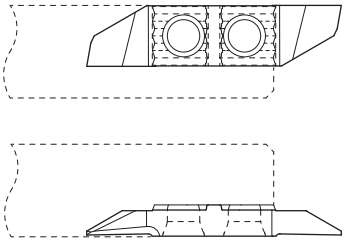
L						R				
A	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0°	0	632X10	■	■			642X10	■	■	□	□
0°	0.08	–					642X10-R08	■	■	□	□
0°	0.15	–					642X10-R15	■	■	□	□
2°	0	632X10-2°	■	■			642X10-2°	■	■	□	□
2°	0.08	–					642X10-2°-R08	■	■	□	□
2°	0.15	–					642X10-2°-R15	■	■	□	□

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

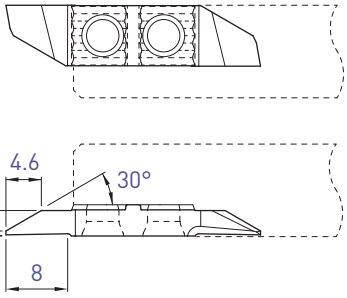
Tournage multifonction
Mehrweck drehen
Multifunction turning

632S / 642S

L



R



Tournage avant
Vorwärts drehen
Front turning

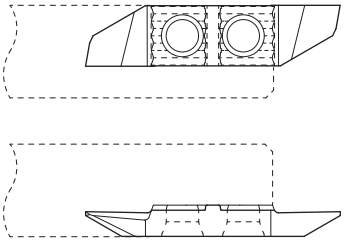
L				R			
Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
632S05	■	■			642S05	■	■	□	□

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

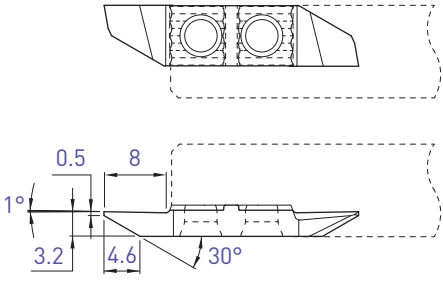
Tournage multifonction
Mehrweck drehen
Multifunction turning

633S / 643S

L



R

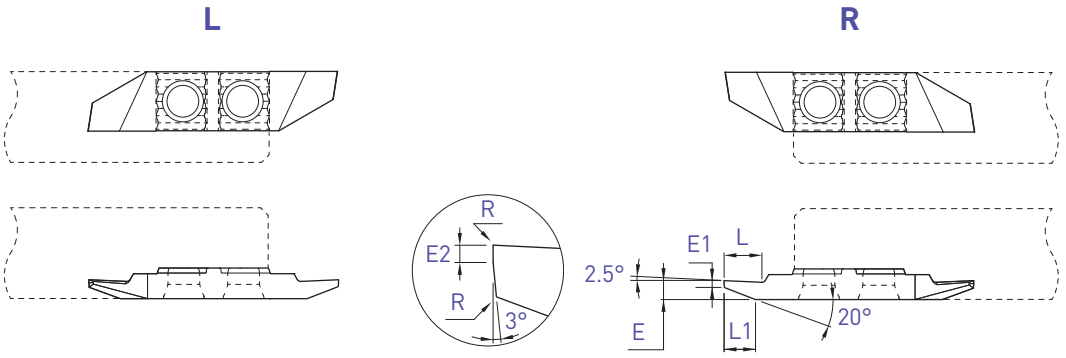


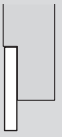
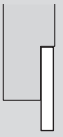
Tournage arrière
Rückwärts drehen
Back turning

L					R				
Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
633S05	■	■			643S05	■	■	□	□

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

Tournage arrière
Rückwärts drehen
Back turning

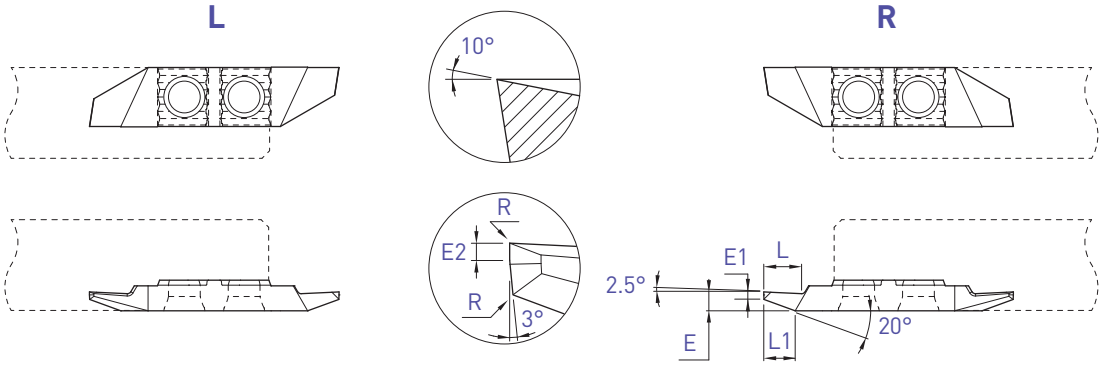


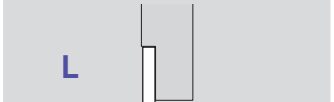
L	R
	

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	**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



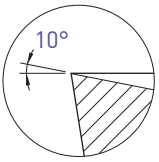


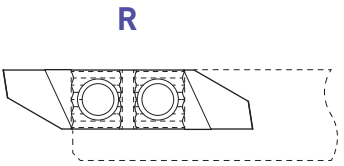
E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.5	0.25	3	2.8	1.5	0	**633X10-0.5**	■	■			**643X10-0.5**	■	■	□	□
0.5	0.25	3	2.8	1.5	0.08	-					**643X10-0.5-R08**	■	■	□	□
0.8	0.40	4.5	3.3	2.0	0	-					**643X10-0.8**	■	■	□	□
0.8	0.40	4.5	3.3	2.0	0.08	-					**643X10-0.8-R08**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

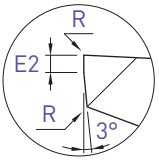
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

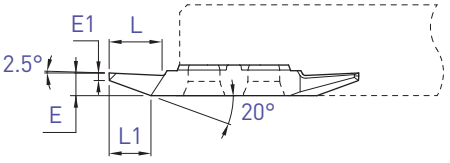
Tournage arrière
Rückwärts drehen
Back turning

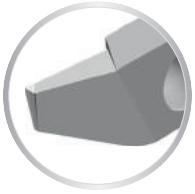
643XS

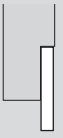








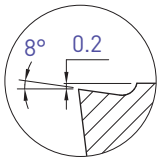


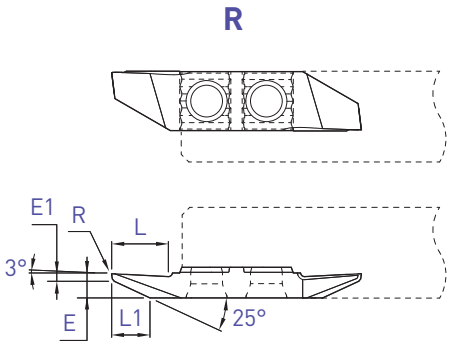


E1	E2	L	L1	E	R	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
1.0	0.4	7	5.5	3.0	0	**643X10S-1.0**	■	■	□	□
1.0	0.4	7	5.5	3.0	0.08	**643X10S-1.0-R08**	■	■	□	□

Tournage arrière
Rückwärts drehen
Back turning

643VX8



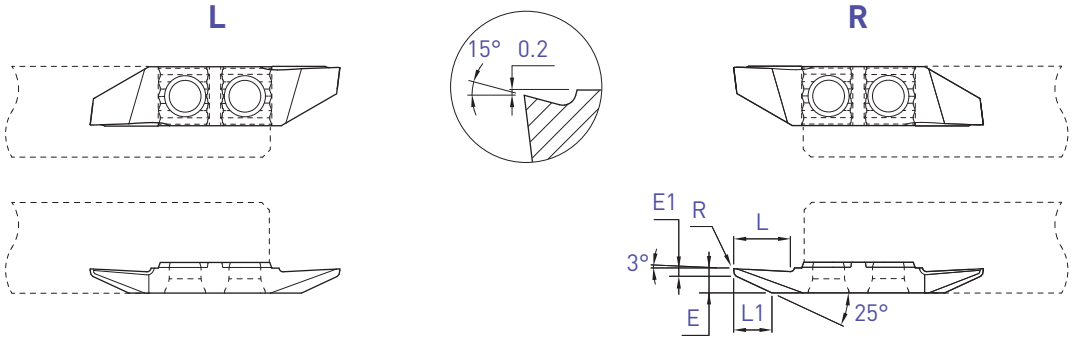


E1	L	L1	E	R	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
1.0	7.5	5.0	3.2	0	**643VX8**	■	■	□	□
1.0	7.5	5.0	3.2	0.08	**643VX8-R08**	■	■	□	□

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

Tournage arrière
Rückwärts drehen
Back turning

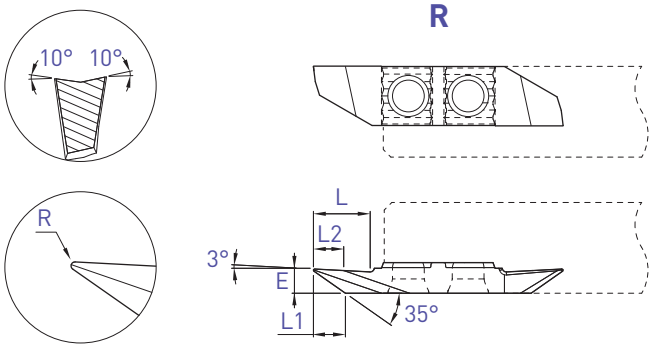
633VX15 / 643VX15



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



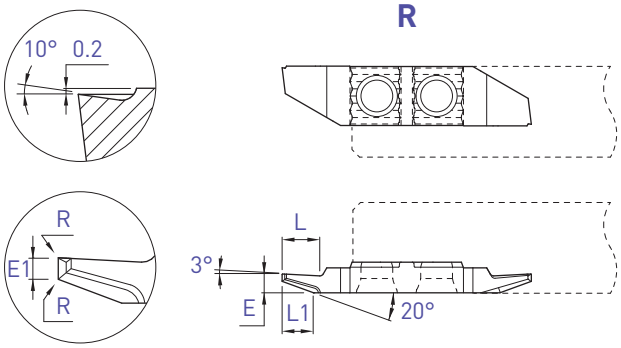
R

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**	■	■	□	□

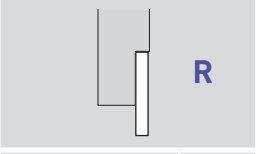
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

Tournage arrière
Rückwärts drehen
Back turning

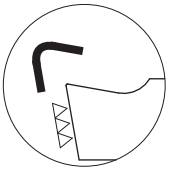
643ZX



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



E1	L	L1	E	R	Art. N°	TiAlN 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**	■



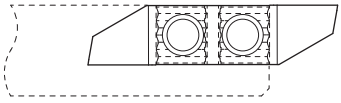
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

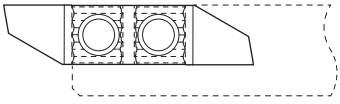
Fonçage-tournage
Einstechen und drehen
Grooving and turning

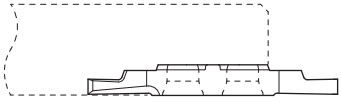
634 / 644

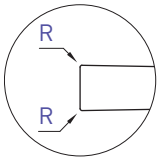
L

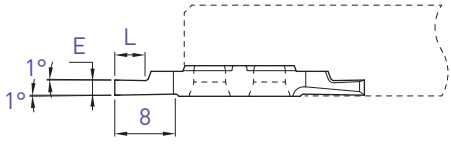


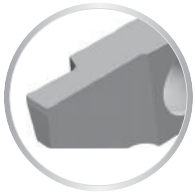
R









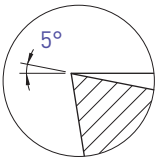


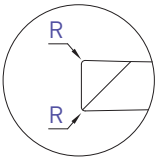
L						R				
E	L	R	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
0.5	1.5	0	**634-0.5**	■	■			**644-0.5**	■	■	□	□
0.6	1.8	0	-					**644-0.6**	■	■	□	□
0.75	2	0	-					**644-0.75**	■	■	□	□
0.8	2	0	**634-0.8**	■	■			**644-0.8**	■	■	□	□
0.9	2.5	0	-					**644-0.9**	■	■	□	□
0.95	3	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**	■	■	□	□

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

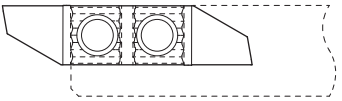
Fonçage-tournage
Einstechen und drehen
Grooving and turning

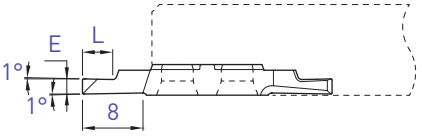
644X5

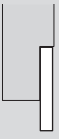




R

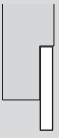






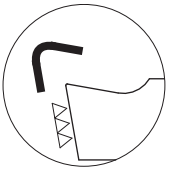
R

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**	■	■	□	□



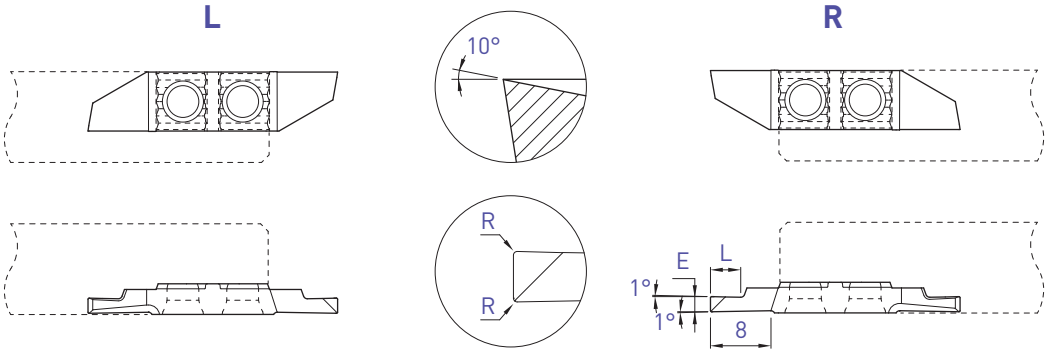
R

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



Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

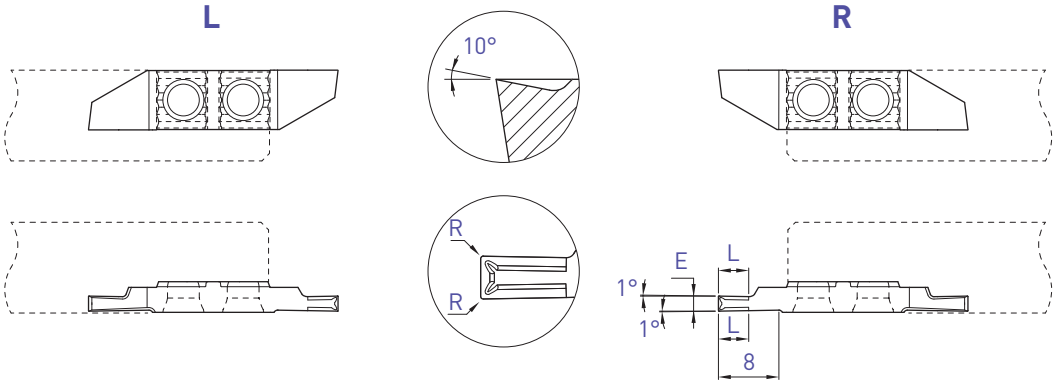


			L				R			
E	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.8	2	0	634X10-0.8	■	■			644X10-0.8	■	■	□	□
1.0	2.5	0	634X10-1.0	■	■			644X10-1.0	■	■	□	□
1.0	2.5	0.08	634X10-1.0-R08	■	■			644X10-1.0-R08	■	■	□	□
1.2	3	0	-					644X10-1.2	■	■	□	□
1.2	3	0.08	-					644X10-1.2-R08	■	■	□	□
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	■	■	□	□

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

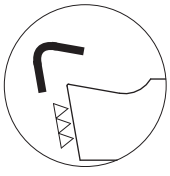
Fonçage-tournage
Einstechen und drehen
Grooving and turning

634ZXB / 644ZXB



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**	■

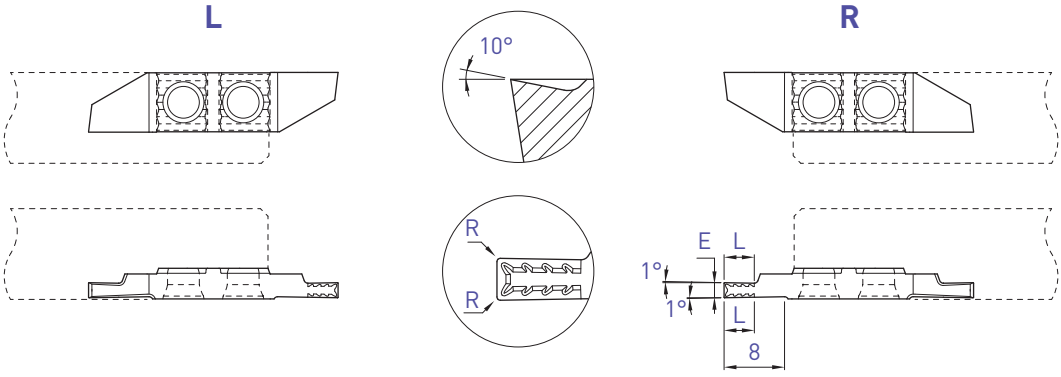


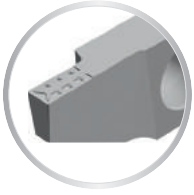
Arête de coupe honée
Gehonte Schneidkante
Honed edge

f min: 0.02 mm/U

Fonçage-tournage
Einstechen und drehen
Grooving and turning

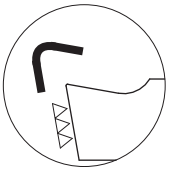
634ZXT / 644ZXT





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

			L		R	
E	L	R	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN 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

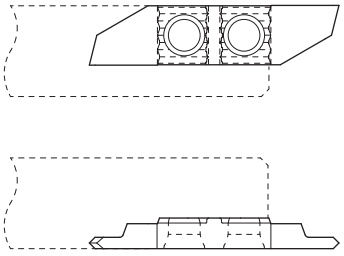
f min: 0.02 mm/U

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

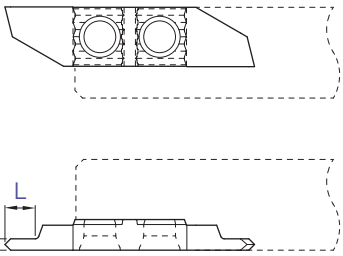
Chanfreinage
Anfasen
Chamfering

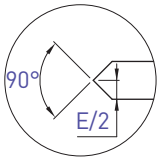
635-90 / 645-90

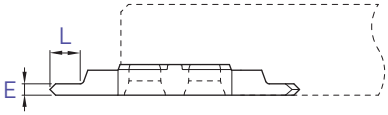
L



R



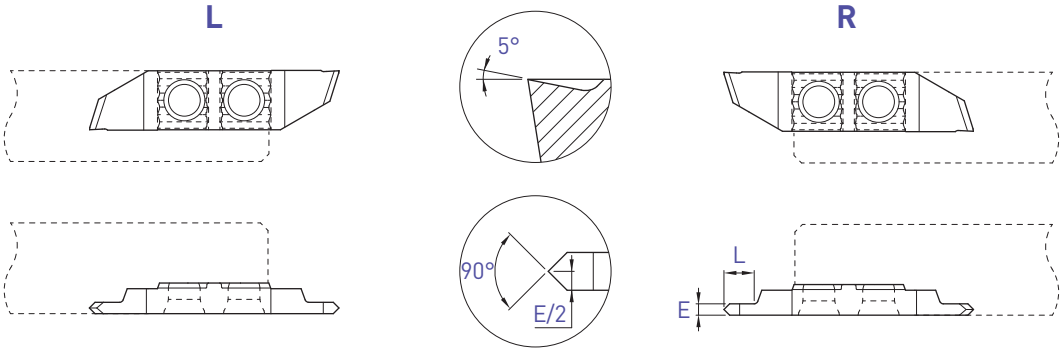




		L			R		
E	L	Art. N°	TiAlN	N (µk20)	Art. N°	TiAlN	N (µk20)
1.5	4	635-90-1.5	■	■	645-90-1.5	■	■

Chanfreinage
Anfasen
Chamfering

635X-90 / 645X-90

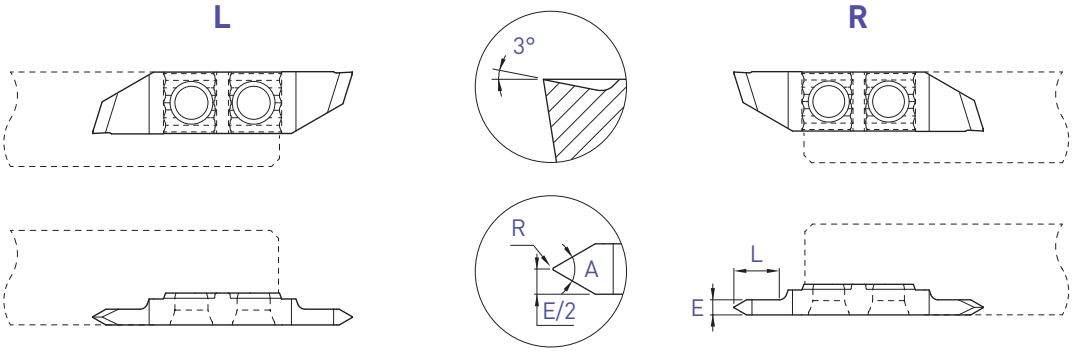


		L			R		
E	L	Art. N°	TiAlN	N (µk20)	Art. N°	TiAlN	N (µk20)
1.5	4	635X5-90-1.5	■	■	645X5-90-1.5	■	■

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

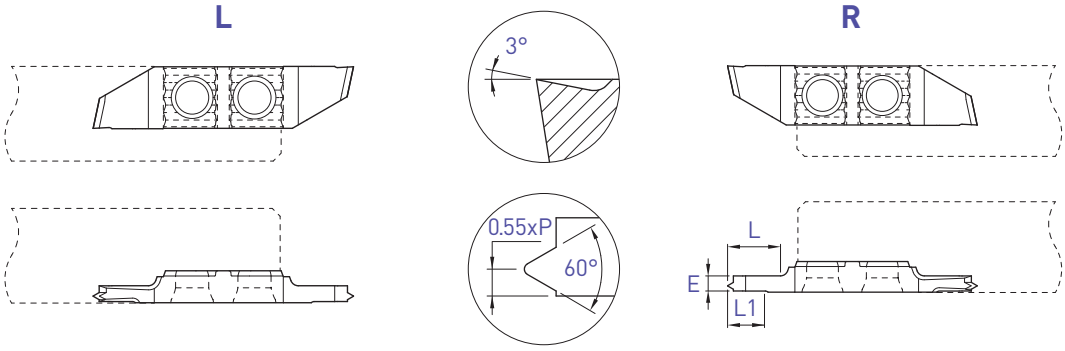
Filetage
Gewinde drehen
Threading

636X / 646X



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

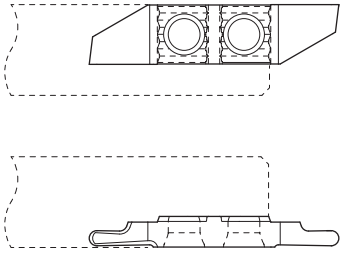
L							R		
E	L	L1	Pas Steigung Pitch P	Art. N°	TiAlN	N (µk20)	Art. N°	TiAlN	N (µk20)
1.0	3	3	0.25	**636X3-M-0.25**	■	■	**646X3-M-0.25**	■	■
1.0	3	3	0.30	**636X3-M-0.30**	■	■	**646X3-M-0.30**	■	■
1.0	3	3	0.35	**636X3-M-0.35**	■	■	**646X3-M-0.35**	■	■
1.0	3	3	0.40	**636X3-M-0.40**	■	■	**646X3-M-0.40**	■	■
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**	■	■

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

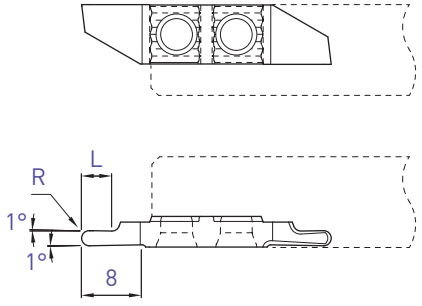
Plaquettes à rayon
Radius Wendeplatten
Radius inserts

637 / 647

L



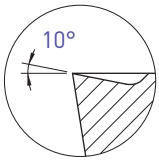
R

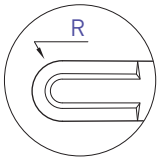


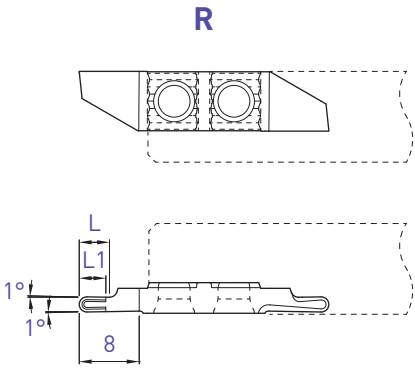
		L				R			
R	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.25	1.5	-					647-R0.25	■	■		
0.4	2	-					647-R0.4	■	■		
0.5	2.5	637-R0.5	■	■			647-R0.5	■	■	□	□
0.6	2.5	-					647-R0.6	■	■		
0.75	3	-					647-R0.75	■	■		
0.8	3	-					647-R0.8	■	■		
1.0	4	637-R1.0	■	■			647-R1.0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

Plaquettes à rayon
Radius Wendeplatten
Radius inserts

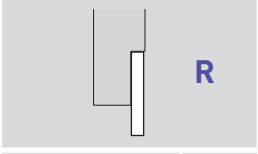
647ZX10



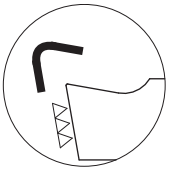




Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip-control



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



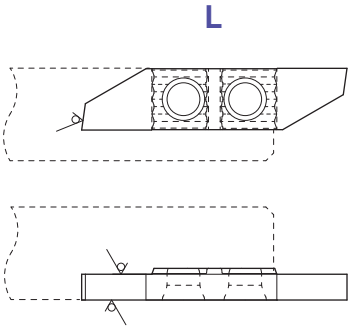
Arête de coupe honée
Gehonte Schneidkante
Honed edge

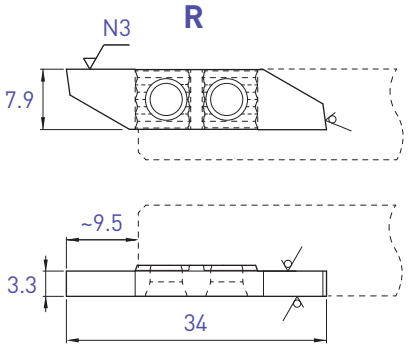
f min: 0.02 mm/U

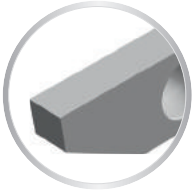
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

Plaquettes ébauches
WSP-Rohlinge
Blank inserts

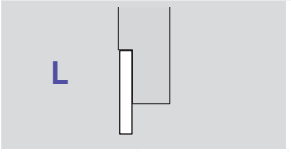
631-EP / 641-EP

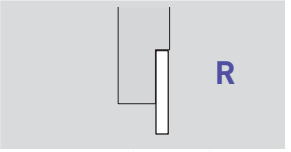






Face de coupe polie
Polierte Schneidfläche
Polished cutting face



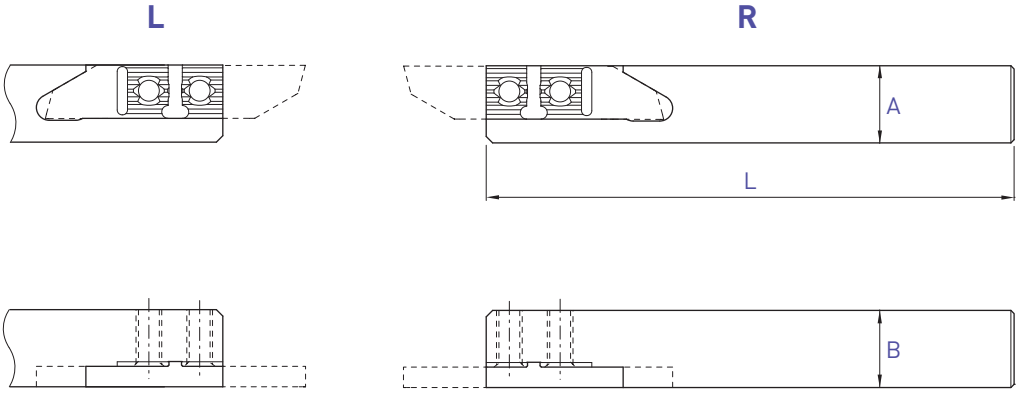


Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
631-EP	■	■	■	■

Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
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 vis et clé.
Jeder Halter wird mit Spannschraube(n) und Schlüssel geliefert.
Screw(s) and key are included with each tool holder.

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

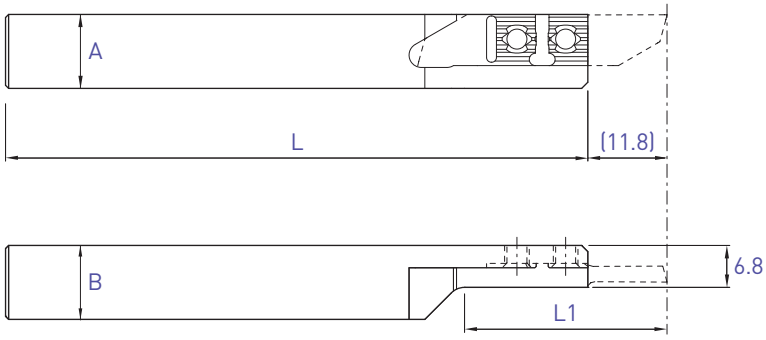
Porte-outils
Halter
Holders

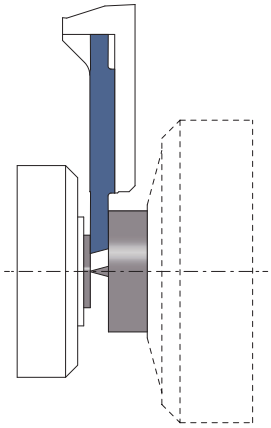
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

650 RC

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

Voir dès page 3.39
Siehe ab Seite 3.39
See from page 3.39





L (R)

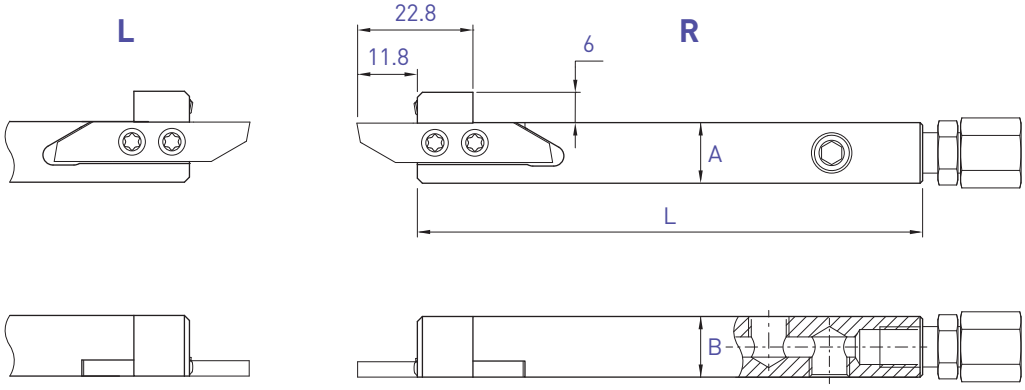
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

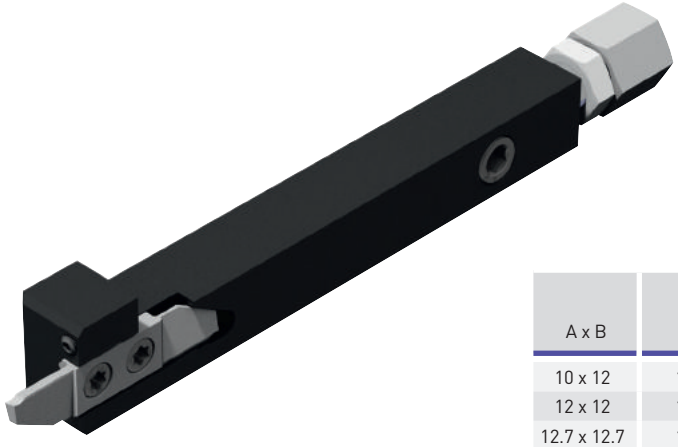
A x B	L	L1	Art. N°
10 x 10	115	32	**650RC-10**
12 x 12	130	32	**650RC-12**
16 x 16	130	42	**650RC-16**

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

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

650-JET / 660-JET





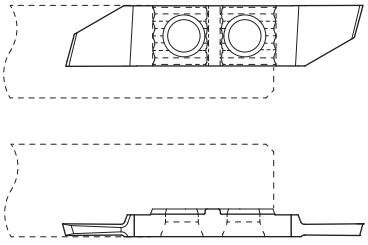
A x B	L	L Art. N°	R Art. N°
10 x 12	100	**650-1012-JET**	**660-1012-JET**
12 x 12	100	**650-12-JET**	**660-12-JET**
12.7 x 12.7	100	**650-12.7-JET**	**660-12.7-JET**
16 x 16	100	**650-16-JET**	**660-16-JET**
20 x 20	100	**650-20-JET**	**660-20-JET**

Chaque support est livré avec vis, clé, raccord droit et buse d'arrosage Ø 1.5 mm.
Jeder Halter wird mit Spannschraube(n), Schlüssel, gerader Kühlmittelanschluss und Kühlmitteldüse Ø 1.5 mm geliefert.
Screw(s), key, straight connector and coolant nozzle Ø 1.5 mm are included with each tool holder.

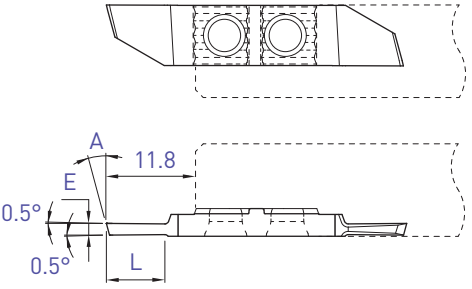
Tronçonnage
Abstechen
Parting off

651 / 661

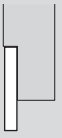
L



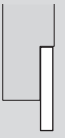
R



L



R

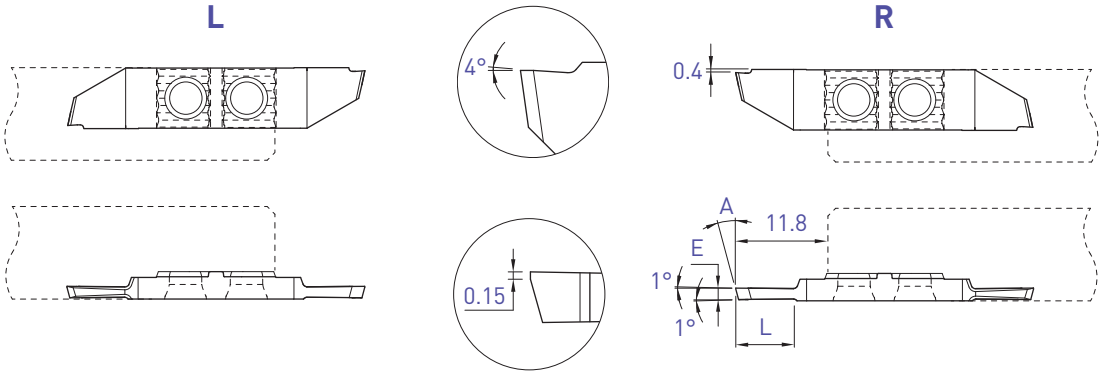


E	A	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
0.8	20°	5	**651-0.8-20°**	■	■			**661-0.8-20°**	■	■	□	□
1.0	15°	5	–					**661-1.0-15°**	■	■	□	□
1.0	20°	5	**651-1.0-20°**	■	■			**661-1.0-20°**	■	■	□	□
1.2	15°	5	–					**661-1.2-15°**	■	■	□	□
1.2	20°	5	**651-1.2-20°**	■	■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

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

Tronçonnage
Abstechen
Parting off

651XF / 661XF

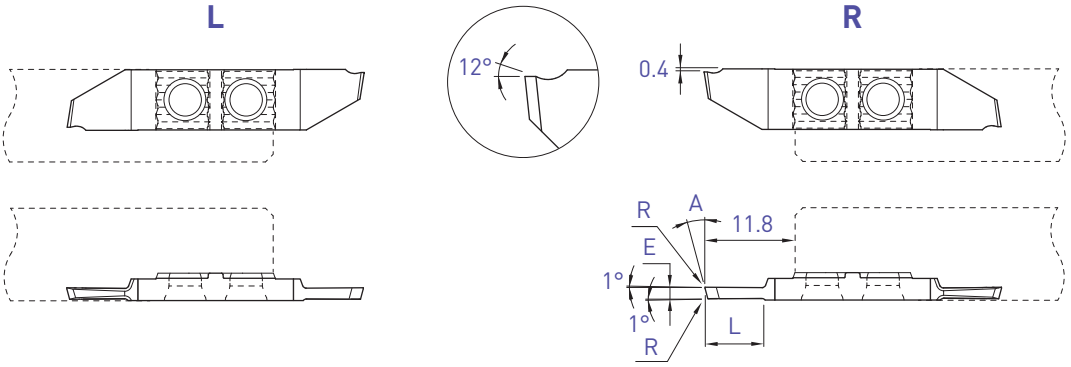


L							R				
E	A	L	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.5	15°	7.5	**651XF-1.5**	■	■			**661XF-1.5**	■	■	□	□
2.0	15°	11	**651XF-2.0**	■	■			**661XF-2.0**	■	■	□	□

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

Tronçonnage
Abstechen
Parting off

651X12 / 661X12

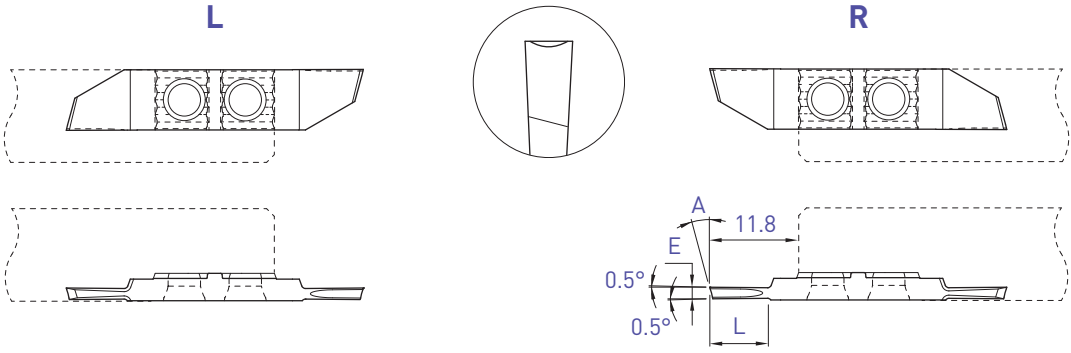


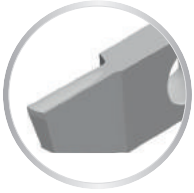
L								R				
E	A	L	R	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
1.0	15°	5	0.03	**651X12-1.0**	■	■			**661X12-1.0**	■	■	□	□
1.5	15°	7.5	0.03	**651X12-1.5**	■	■			**661X12-1.5**	■	■	□	□
2.0	15°	11	0.03	**651X12-2.0**	■	■			**661X12-2.0**	■	■	□	□

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

Tronçonnage
Abstechen
Parting off

651U / 661U



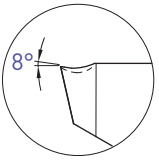


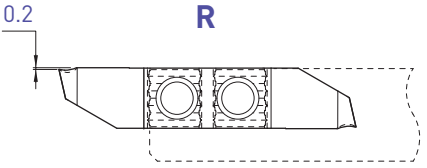
			L		R	
E	A	L	Art. N°	TiAlN N (µk20)	Art. N°	TiAlN N (µk20)
1.5	15°	7.5	**651U-1.5**	■ ■	**661U-1.5**	■ ■
2.0	15°	11	**651U-2.0**	■ ■	**661U-2.0**	■ ■

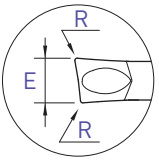
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

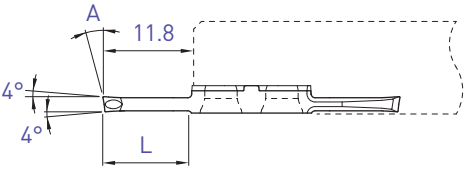
Tronçonnage
Abstechen
Parting off

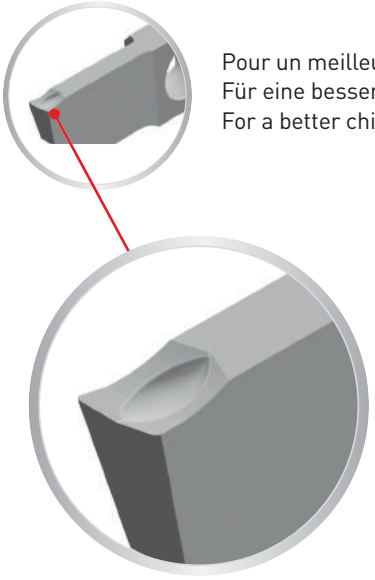
661ZU



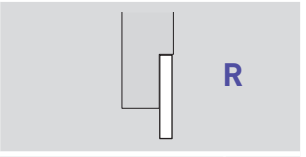




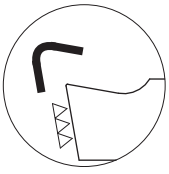




Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip-control



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

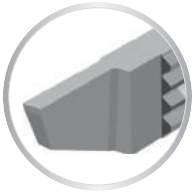
f min: 0.02 mm/U

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

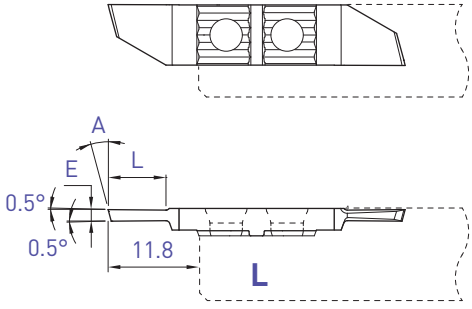
Tronçonnage
Abstechen
Parting off

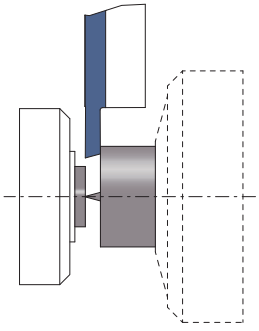
Coupe déportée
Versetztes Schneiden
Cut off line

651R



Cut R





L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

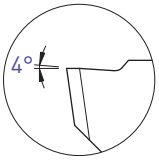
E	A	L	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
1.0	15°	5	**651R-1.0-15°**	■	■	□	□
1.2	15°	5	**651R-1.2-15°**	■	■	□	□
1.5	15°	7.5	**651R-1.5-15°**	■	■	□	□
2.0	15°	11	**651R-2.0-15°**	■	■	□	□
2.5	15°	11	**651R-2.5-15°**	■	■	□	□

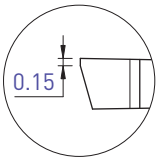
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

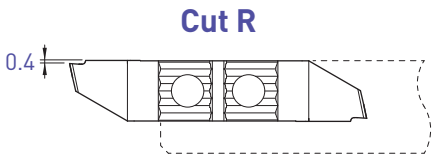
Tronçonnage
Abstechen
Parting off

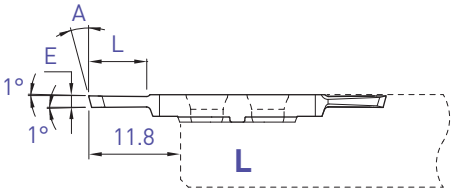
Coupe déportée
Versetztes Schneiden
Cut off line

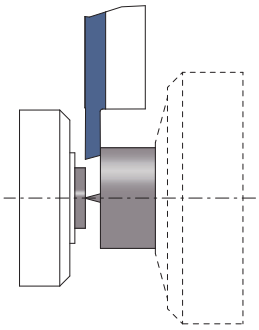
651RXF











L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

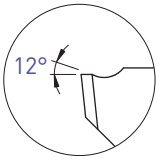
E	A	L	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
1.5	15°	7.5	**651RXF-1.5**	■	■	□	□
2.0	15°	11	**651RXF-2.0**	■	■	□	□

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

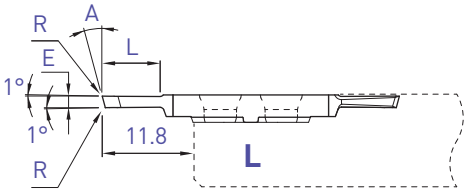
Tronçonnage
Abstechen
Parting off

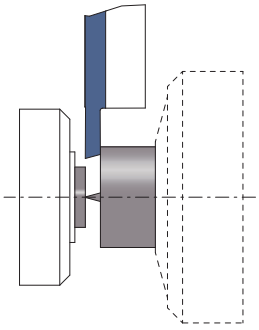
Coupe déportée
Versetztes Schneiden
Cut off line

651RX12



Cut R





L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

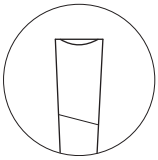
E	A	L	R	Art. N°	TiAlN	N (µK20)	HTA	HN (µK10)
1.5	15°	7.5	0.03	**651RX12-1.5**	■	■	□	□
2.0	15°	11	0.03	**651RX12-2.0**	■	■	□	□

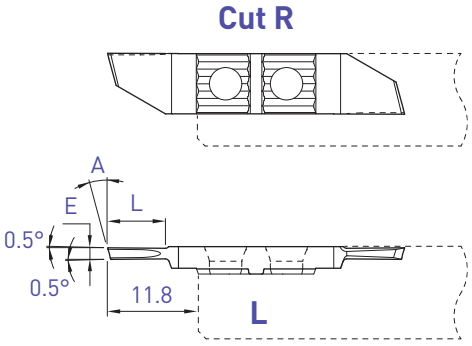
■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

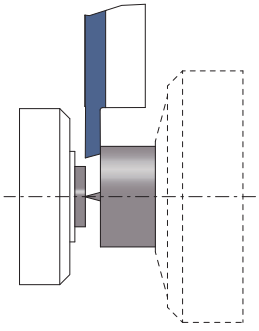
Tronçonnage
Abstechen
Parting off

Coupe déportée
Versetztes Schneiden
Cut off line

651RU







L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

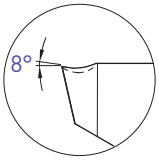
E	A	L	Art. N°	TiAlN	N (µK20)
1.5	15°	7.5	**651RU-1.5**	■	■
2.0	15°	11	**651RU-2.0**	■	■

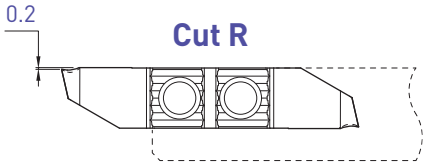
Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

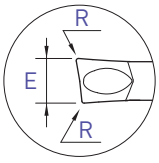
Tronçonnage
Abstechen
Parting off

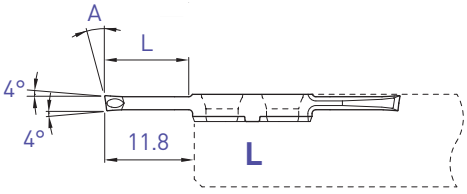
Coupe déportée
Versetztes Schneiden
Cut off line

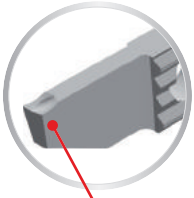
651RZU

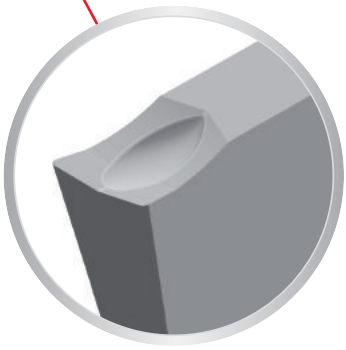










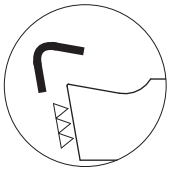


Pour un meilleur contrôle des copeaux
Für eine bessere Spankontrolle
For a better chip control

L (R)

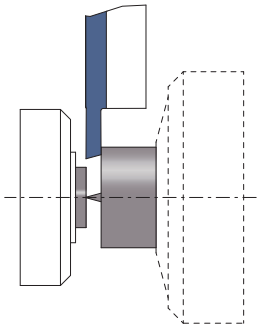
Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

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

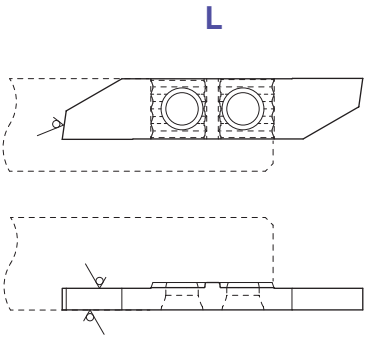
f min: 0.02 mm/U

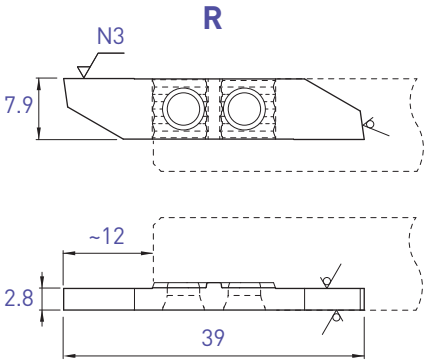


■ = disponible / verfügbar / available
□ = selon disponibilité du stock / jenach Lagerverfügbarkeit / depending on stock availability

Plaquettes ébauches
WSP-Rohlinge
Blank inserts

651-EP / 661-EP



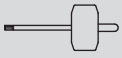
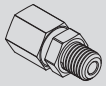


Face de coupe polie
Polierte Schneidfläche
Polished cutting face

Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)	Art. N°	TiAlN	N (µk20)	HTA	HN (µk10)
651-EP	■	■	■	■	661-EP	■	■	■	■

Autre revêtement sur demande / Andere Beschichtung auf Anfrage / Other coating on request

Pièces de rechange et accessoires
Ersatzteile und Zubehöre
Spare parts and accessories

Pièces de rechange Ersatzteile Spare parts							
Porte-outils Halter Holders						**Option** **Art. N°**	Recommandation de serrage Drehmoment Empfehlung Clamping recommendation
630 640	**V-M4X9-T15**	**C-T15**	-	-	-	**SET-NM-TX15**	3 Nm
630-JET 640-JET			**J-M8X1-D6**	**JB-M8X1**	**JJ-M3X6-D1.5**		
650 660			-	-	-		
650-RC	**V-M4X6.5-T15**		-	-	-		
650-JET 660-JET	**V-M4X9-T15**		**J-M8X1-D6**	**JB-M8X1**	**JJ-M3X6-D1.5**		

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