

ONE-Watch



APPLITEC
CUTTING TOOLS

Index

Codification Kodifizierung Coding guide			> 4.03
Infos et avantages Infos und Vorteile Infos and advantages			> 4.04
Nuances Sorten Grades			> 4.05
Porte-outils Halter Holder	130 / 140		> 4.07
Tronçonnage Abstechen Parting off	131SF / 141SF		> 4.10
Tournage avant Vorwärts drehen Front turning	142SF		> 4.13
Tournage arrière Rückwärts drehen Back turning	143SF		> 4.16
Filetage Gewinde drehen Threading	146SFX3		> 4.19
Plaquettes piqure avant Fronteinstich WSP Front grooving inserts	148SF		> 4.20
Plaquettes piqure arrière Rüceinstich WSP Back grooving inserts	149SF		> 4.21
Plaquettes ébauches WSP-Rohlinge Blank inserts	131-ESF / 141-ESF		> 4.22
Pièces de rechange et accessoires Ersatzteile und Zubehör Spare parts and accessories			> 4.23

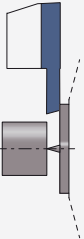
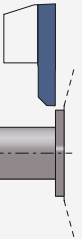
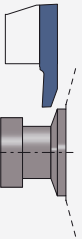
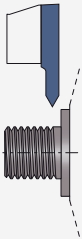
1	4	3	SF	-	3/3	-	45	-	KSTF
---	---	---	----	---	-----	---	----	---	------

Super finish

Dimension
Abmessung
Dimension

Nuance
Sorte
Grade

Géométrie d'usinage
Bearbeitungsgeometrie
Machining geometry

1	2	3	6	8	9
					

Gamme de produit
Produktserie
Product series

définit la compatibilité des plaquettes avec le porte-outils
 bestimmt die WSP und Halter Kompatibilität
 define the compatibility of the inserts with the toolholder

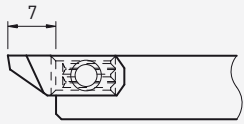
L = 3 (chiffre impair / ungerade Zahl / uneven number)
 R = 4 (chiffre pair / gerade Zahl / even number)

L

130

R

140



Applitec série 100
Applitec 100 Serie
Applitec 100 series

Système de serrage à denture décalée avec 1 vis de fixation
 Spannsystem mit 1 Schraube und verschobener Verzahnung
 Shifted teeth clamping system with 1 screw

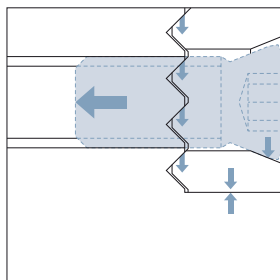
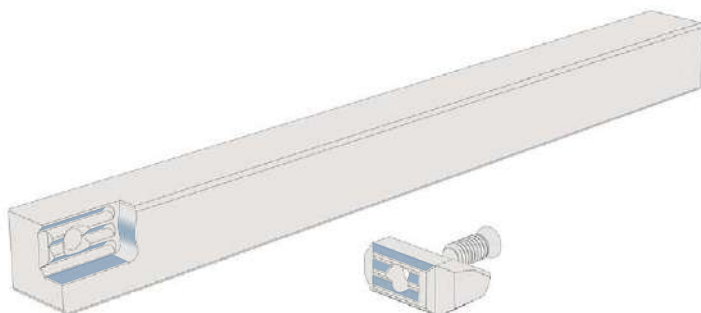
Infos et avantages

Infos und Vorteile

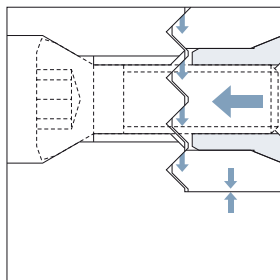
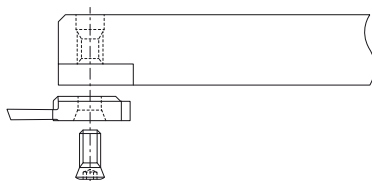
Infos and advantages

Rigid !

Système de serrage Applitec à denture décalée
Applitec-Spannsystem mit verschobener Verzahnung
Applitec clamping system with shifted teeth

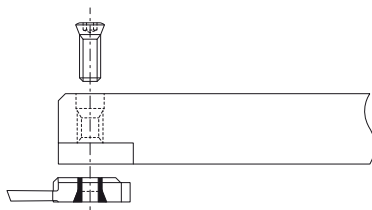


Serrage standard (A)
Standard Spannsystem (A)
Standard clamping system (A)



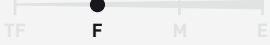
Serrage type B*
Spannsystem Typ B*
Clamping system type B*

ajouter -B après le numéro d'article
-B nach der Artikelreferenz hinzufügen
add -B after the article number



Changement de la plaquette possible dans la machine, sans démontage du porte-outil
WSP-Austauschmöglichkeit in der Maschine ohne Halterausbau
The insert can be changed in the machine without removing the tool holder

* = sur demande / auf Anfrage / on request

μK10 - μK20	KTC  ● K10 - K20 μK10 - μK20 + revêtement PVD μK10 - μK20 + PVD Beschichtung μK10 - μK20 + PVD coating  <table border="1"> <tr><td>P</td><td>★★★★★</td></tr> <tr><td>M</td><td>★★★★★</td></tr> <tr><td>N</td><td>★★★★★</td></tr> <tr><td>S</td><td>★★★★★</td></tr> </table>	P	★★★★★	M	★★★★★	N	★★★★★	S	★★★★★
P	★★★★★								
M	★★★★★								
N	★★★★★								
S	★★★★★								

- nuance résistante à l'usure, faible coefficient de frottement, recommandée pour des opérations d'ébauche et de finition
- **conseillé pour l'usinage de la matière 20AP + aciers de décolletage**

- verschleissfeste Sorte, geringer Reibwert, für Schruppen und Schlichtbearbeitung empfohlen
- **empfohlen für die Bearbeitung von Material 20AP + Automa-tenstahl**

- wear resistant grade, low friction ratio, recommended for roughing and finishing
- **recommended for suitable for machining of 20AP material + Free-cutting steel**

Nuances

Sorten

Grades

KTAF-RE

● K10 - K20

μK10 - μK20 + revêtement PVD
μK10 - μK20 + PVD Beschichtung
μK10 - μK20 + PVD coating

TF F M E

P	★★★★★
M	★★★★★
N	★★★★★
S	★★★★★

- nuance identique à KTAF avec dépouilles rectifiées après revêtement pour des opérations de finition
- **recommandé pour les matières Finemac et inox 4c27a**

- gleiche Sorte wie KTAF nach der Beschichtung geschliffener Freiwinkel, für Schlichtbearbeitung empfohlen
- **empfohlen für die Bearbeitung von Finemac und Inox 4c27a rostfreiem Stahl**

- same grade as KTAF, with clearance angles rectify after coating, recommended for finishing
- **recommended for suitable for machining of Finemac and 4c27a stainless steel**

KSTF

● K10 - K20

μK10 - μK20 + revêtement PVD
μK10 - μK20 + PVD Beschichtung
μK10 - μK20 + PVD coating

TF F M E

P	★★★★★
M	★★★★★
N	★★★★★
S	★★★★★

- nuance très résistante à l'usure et à la température
- 1^{er} choix pour les aciers > 50 HRC, les aciers à base de nickel, chrome-cobalt, inox et titane allié

- verschleißfeste Sorte, beständig gegen hohe Temperaturen
- erste Wahl für Stähle > 50 HRC, Nickelbasislegierungen, Chrom-Kobalt, rostfreien Stahl und legiertes Titan

- wear-resistant grade, highly resistant to temperature
- first choice for steels > 50 HRC, nickel-based alloys, chrome-cobalt, stainless steel, and alloyed titanium

KN

● K10 - K20

Non revêtu
Unbeschichtet
Uncoated

P	★☆☆☆☆
M	★☆☆☆☆
N	★★★★★
S	★★★★★

- nuance de base non revêtue micro-grain, alliant une très bonne résistance à l'usure et une bonne ténacité
- **recommandé pour l'usinage des matières ne nécessitant aucun revêtement, par exemple le titane pur**

- verschleißfeste Feinkornsorte, unbeschichtet, mit hoher Zähigkeit und guter Widerstandsfähigkeit
- **empfohlen für die Bearbeitung von Werkstoffen, die keine Beschichtung erfordern, zum Beispiel reines Titan**

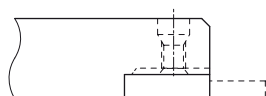
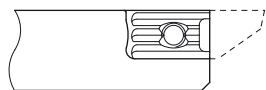
- wear-resistant micro-grain grade, uncoated, with high toughness and good resistance
- **recommended for machining materials that do not require coating, such as pure titanium**

Porte-outils

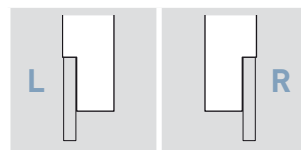
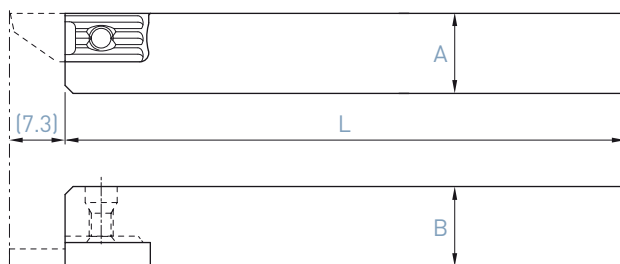
Halter
Holders

130 / 140

L

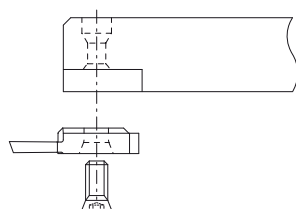


R

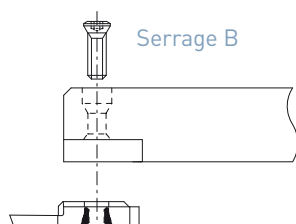


A x B	L	Serrage Spannsystem Clamping	Art. N°	Art. N°
8 x 8	115	A+B	130-8	140-8
10 x 10	115	A+B	130-10	140-10
12 x 12	115	A+B	130-12	140-12

Serrage A



Serrage B



Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schrauben geliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

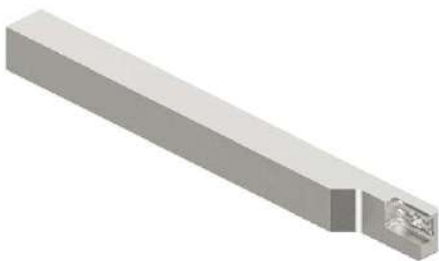
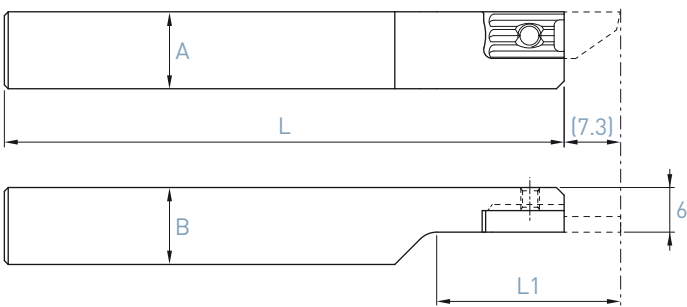
130RC

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

Porte-outils
Halter
Holders

Utiliser des plaquettes type 131R
WSP Typ 131R verwenden
Use inserts type 131R

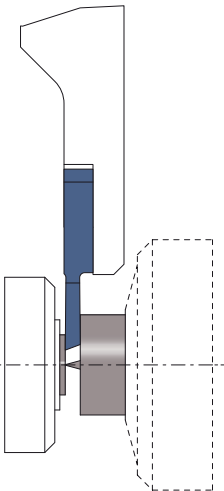
Voir pages 4.10 - 4.11
Siehe Seiten 4.10 - 4.11
See pages 4.10 - 4.11



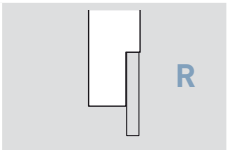
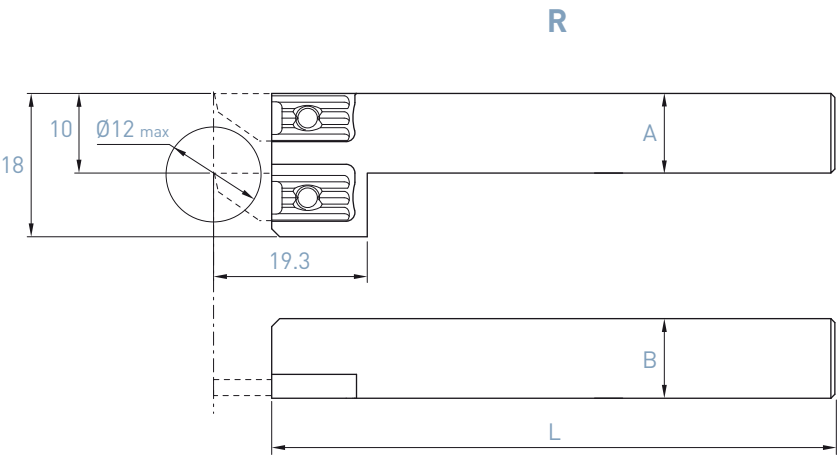
L (R)

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

AxB	L	L1	Serrage Spannsystem Clamping	Art. N°
8 x 8	115	24	A	130RC-8
10 x 10	115	24	A	130RC-10
12 x 12	115	30	A	130RC-12



Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schrauben geliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.



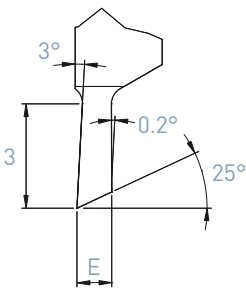
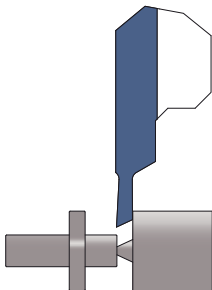
A x B	L	Serrage Spannsystem Clamping	Art. N°
8 x 8	115	A+B	140-8-H10-DUO
10 x 10	115	A+B	140-10-H10-DUO
12 x 12	115	A+B	140-12-H10-DUO

Chaque support est livré avec une ou plusieurs vis. Les clés sont à commander séparément.
Jeder Halter wird mit einer oder mehreren Schrauben geliefert. Die Schlüssel sind separat zu bestellen.
Each holder is supplied with one or more screws. The keys must be ordered separately.

131RSF

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

Tronçonnage
Abstechen
Parting off



L (R)		Coupe à droite déportée Versetztes Rechtsschneiden Right cut off line		
E	Art. N°	KTAF	KSTF	KN (uk10-20)
1.0	131RSF-1.0-25	●	●	●

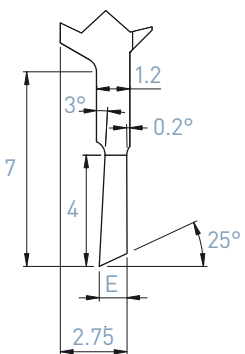
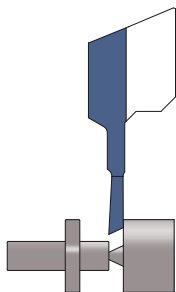
Tronçonnage

Abstechen
Parting off

Coupe à droite déportée

Versetztes Rechtsschneiden
Right cut off line

131RDSF



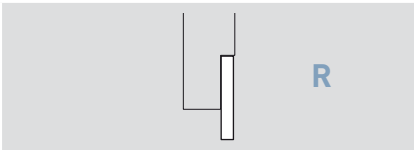
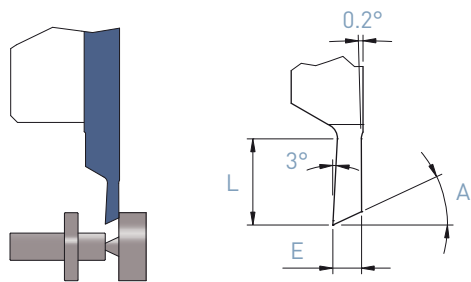
**L (R)**

Coupe à droite déportée
Versetztes Rechtsschneiden
Right cut off line

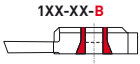
E	Art. N°	P	P
		M	M
		N	N
		S	S
		KTAF	KN [µk10-20]
1.0	131RDSF-1.0-25	●	●

141SF

Tronçonnage
Abstechen
Parting off



A	E	L	Art. N°	P	P	P	P	P	P
						M	M	M	M
						N	N	N	N
						S	S	S	S
				KTC	KTC-RE	KTAF	KTAF-RE	KSTF	KN (uk10-20)
25°	0.5	2	141SF-0.5-25	●	●	●	●	●	●
	0.8	3	141SF-0.8-25	●	●	●	●	●	●
	1.0	3	141SF-1.0-25	●	●	●	●	●	●
22°	1.2	5	141SF-1.2-22	●	●	●	●	●	●

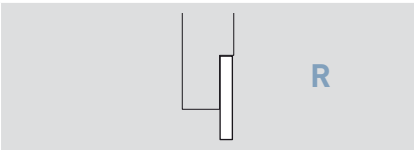
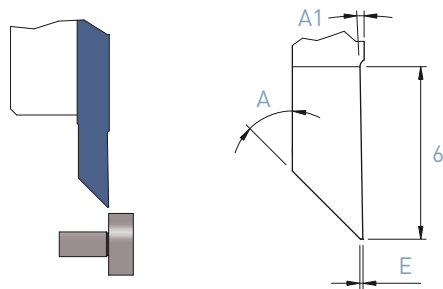


1XX-XX-B

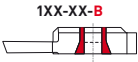
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Tournage avant
Vorwärts drehen
Front turning

142SF

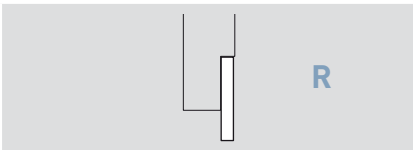
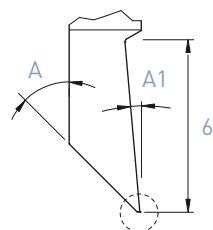
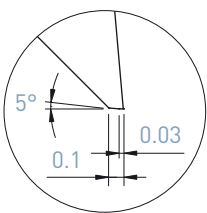
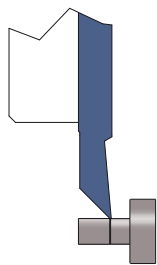


E	A	A1	Art. N°	P	P	P	P	P	P
						M	M	M	M
						N	N	N	N
						S	S	S	S
				KTC	KTC-RE	KTAF	KTAF-RE	KSTF	KN µk10-20
0.03	45°	3°	142SF-3/3-45	●	●	●	●	●	●
0.05	45°	3°	142SF-5/5-45	●	●	●	●	●	●
0.08	45°	1°	142SF-8/8-45	●	●	●	●	●	●

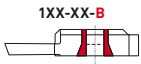


1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04



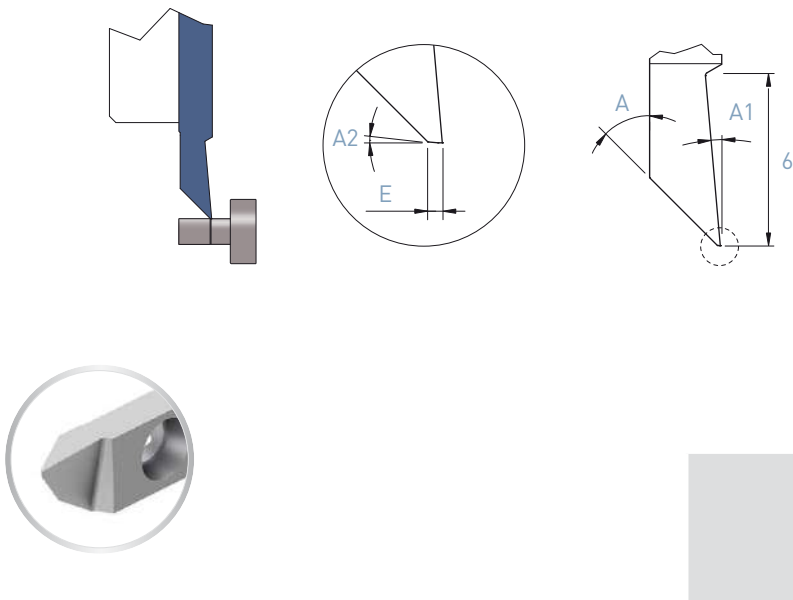
		Art. N°						
A	A1		KTC	KTC-RE	KTAF	KTAF-RE	KSTF	KN (uk10-20)
45°	5°	142SF-10/3	●	●	●	●	●	●



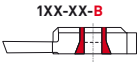
1XX-XX-B
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Tournage avant
Vorwärts drehen
Front turning

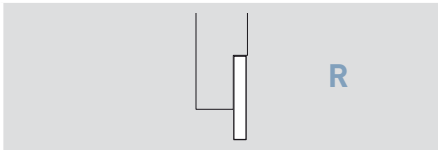
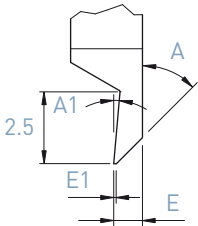
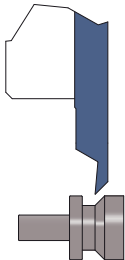
142SF-_0



						
E	A	A1	A2	Art. N°	KTAF-RE P M N S	KSTF P M N S
0.1	45°	5°	5°	142SF-10/0-5-45	●	●
0.15	30°	3°	2°	142SF-15/0-2-30	●	●



1XX-XX-B
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04



E1	E	A	A1	Art. N°	P	P	P	P	P	P
					☐	☐	☒	☒	☒	☒
					KTC	KTC-RE	KTAF	KTAF-RE	KSTF	KN (uk10-20)
0.03	1.0	45°	5°	143SF-3/3-45-1.0	●	●	●	●	●	●
0.03	1.2	45°	5°	143SF-3/3-45-1.2	●	●	●	●	●	●
0.10	1.0	45°	5°	143SF-10/10-45-1.0	●	●	●	●	●	●
0.05	0.8	30°	3°	143SF-5/5-30-0.8				●		

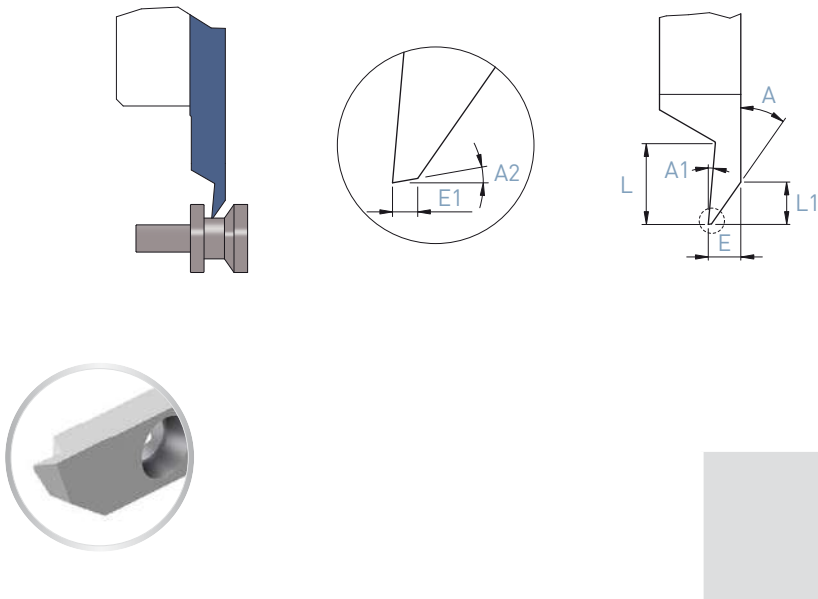
1XX-XX-B



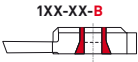
Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Tournage arrière
Rückwärts drehen
Back turning

143SF-_0

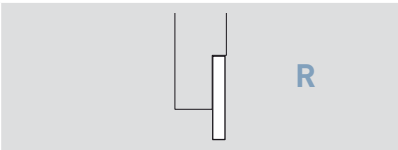
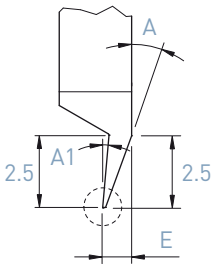
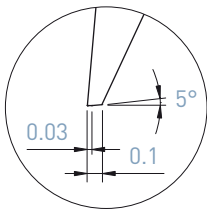
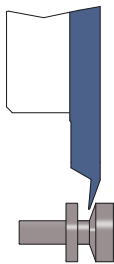


E1	E	L1	L	A	A1	A2	Art. N°	KTAF-RE	KN (µk10-20)
0.08	1.0	1.6	2.5	30°	5°	2°	143SF-8/0-2-30-1.0	●	●
0.15	1.2	1.8	4.0	30°	3°	2°	143SF-15/0-2-30-1.2	●	●
0.10	1.0	1.3	2.5	35°	5°	10°	143SF-10/0-10-35-1.0	●	●



1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04



E	A	A1	Art. N°	P KTC	P KTC-RE	P M N S KTAF	P M N S KTAF-RE	P M N S KN (uk10-20)
1.0	20°	5°	143SF-10/3	●	●	●	●	

1XX-XX-B

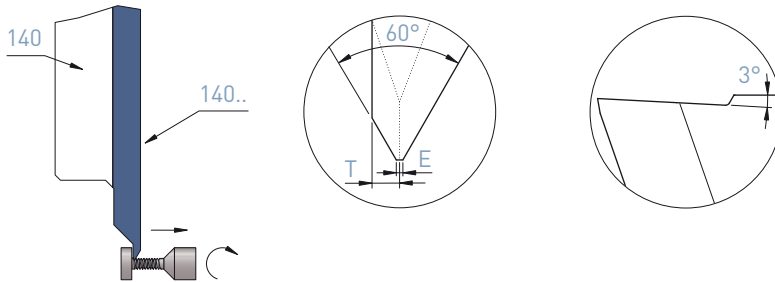


Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Filetage

Gewinde drehen

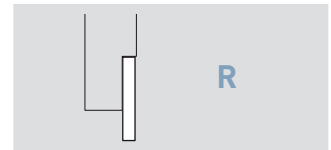
Threading

146SFX3

Filetage à droite
sens rotation machine M3

Rechtgewinde Drehrichtung
der Maschine M3

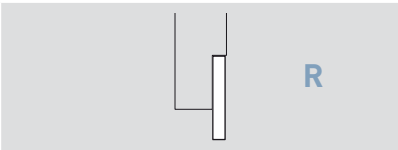
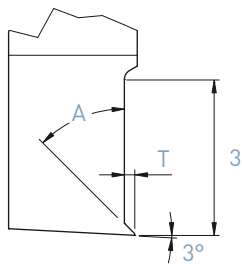
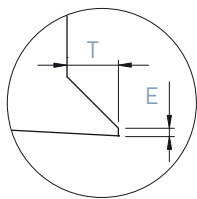
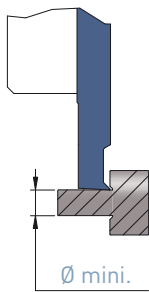
Right-hand thread rotating
machinery M3



Filetage Gewinde drehen Threading	Pas Steigung Pitch P	T	E 0/-0.01	Art. N°	P M N S P M N S KTAF KN [µk'10-20]
S0.50	0.125	0.07	0.025	146SFX3-A60-S0.50-AR	● ●
S0.60	0.150	0.09	0.030	146SFX3-A60-S0.60-AR	● ●
S0.70	0.175	0.10	0.035	146SFX3-A60-S0.70-AR	● ●
S0.80	0.200	0.12	0.040	146SFX3-A60-S0.80-AR	● ●
S0.90	0.225	0.13	0.045	146SFX3-A60-S0.90-AR	● ●
S1.00	0.250	0.15	0.050	146SFX3-A60-S1.00-AR	● ●

1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04



E	A	T	Ø mini.	Art. N°	P P P M N S P M N S P M N S				
					KTC	KTC-RE	KTAF	KTAF-RE	KN (uk10-20)
0.03	46°	0.2	0.3	148SF-E03-A46-L20	●	●	●	●	●
0.05	46°	0.3	0.4	148SF-E05-A46-L30	●	●	●	●	●
0.08	46°	0.5	0.5	148SF-E08-A46-L50	●	●	●	●	●

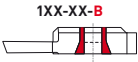
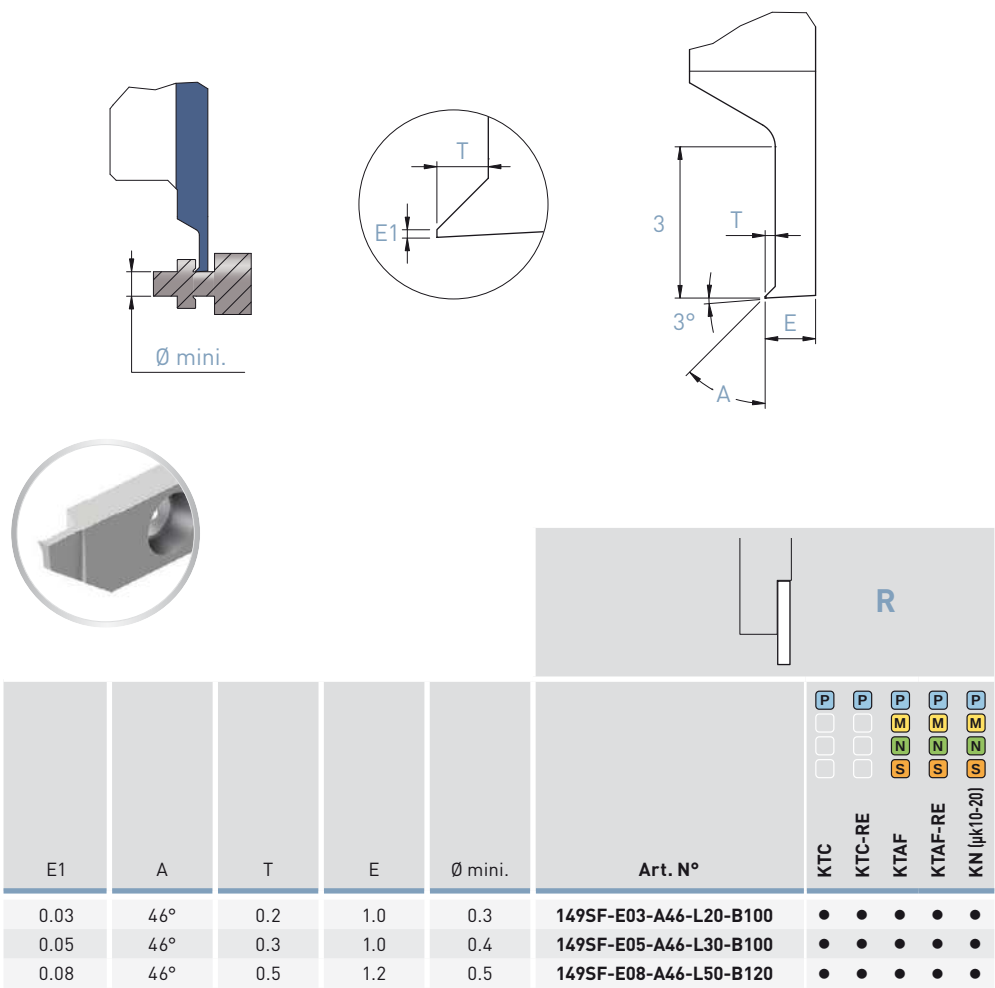
1XX-XX-B



Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

Plaquettes piqûre arrière
Rückeinstich WSP
Back grooving inserts

149SF



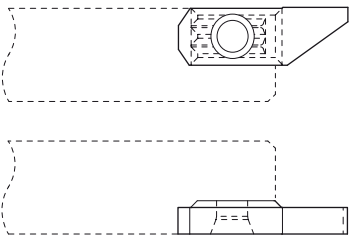
1XX-XX-B

Sur demande pour serrage type B, voir page 4.04
Auf Anfrage für B-Spannsystem, siehe Seite 4.04
On request for B clamping system, see page 4.04

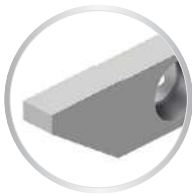
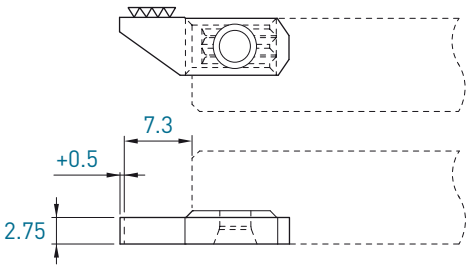
131-ESF / 141-ESF

Plaquettes ébauchées
WSP-Rohlinge
Blank inserts

L



R



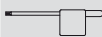
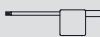
Face de coupe polie
Polierte Schnittfläche
Polished cutting face

L						R					
Art. N°	KTC	KTAF	KSTF	KCR-TF	KN [µk10-20]	Art. N°	KTC	KTAF	KSTF	KCR-TF	KN [µk10-20]
131-ESF	●	●	●	●	●	141-ESF	●	●	●	●	●

Pièces de rechange et accessoires

Ersatzteile und Zubehör

Spare parts and accessories

		Porte-outils Halter Holders	Serrage standard (A) Standard Spannsystem (A) Standard clamping system (A) 	Options 	Serrage type B Spannsystem Typ B Clamping system type B 	Options 
130	130-8	V-M3x7-T8	C-T8	V-M2.5X7.8-T8	C-T8	
	130-10					
	130-12					
	130RC-8	V-M3x5.5-T8				
	130RC-10					
	130RC-12					
140	140-8	V-M3x7-T8	C-T8	V-M2.5X7.8-T8	C-T8	
	140-10					
	140-12					
	140-8-H10-DUO					
	140-10-H10-DUO					
	140-12-H10-DUO					

SYMBOL

Légende des symboles

Symbollegende

Symbol Legend

E	L	Art. N°	TiAlN	TiN	N (µK20)	HTA	HTiN	HN (µK10)
1.0	5	731RU-1.0	•	•				
1.2	5	731RU-1.2	•	•				
1.5	7	731RU-1.5	•	•	•	•	•	•
2.0	7	731RU-2.0	•	•				



Acier
Stahl
Steel



Inox
Rostfreistahl
Stainless steel



Alliages d'aluminium et non ferreux
Aluminium- und Nichtisenlegierungen
Aluminium and non-ferrous alloys



Titane et superalliages
Titan und Superlegierungen
Titanium and superalloys



Acier trempé
Gehärteter Stahl
Hardened steel



Fonte
Gusseisen
Cast iron



Matière exotique
Exotisches material
Exotic material



Carbure
Hartmetall
Carbide

TiAlN



 K20

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

TF F M E



