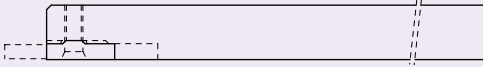


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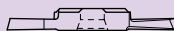
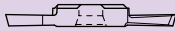
L

R



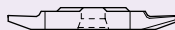
4.02

4.03



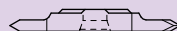
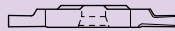
4.04

4.05



4.06

4.07



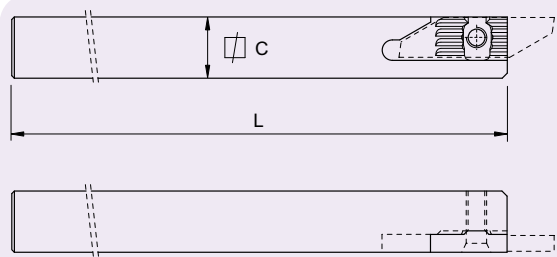
4.08

4.09

Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data

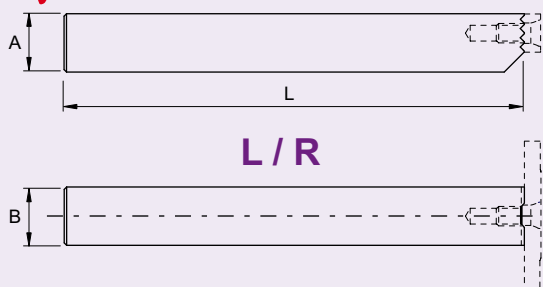
Matière Werkstoff Material	Tournage Drehen Turning		Tronçonnage Abstechen Cut off		Indications pour premiers réglages Hinweise für die erste Einrichtung Indications for first setting	
	Vc (m/min)	F (mm/U)	Vc (m/min)	F (mm/U)	ébauche schruppen roughing	finition schlichten finishing
Acier de décolletage Automatenstahl Free-cutting steel	120 - 200	0.01 - 0.20	80 - 150	0.01 - 0.15	vitesse de coupe moyenne avance élevée	vitesse de coupe élevée avance faible
Acier Stahl < 600 N/mm ² Steel	80 - 160	0.01 - 0.18	70 - 120	0.01 - 0.12		
Acier Stahl < 800 N/mm ² Steel	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.10	durchschnittliche Schnittgeschwindigkeit	hohe Schnittgeschwindigkeit
Acier Stahl > 800 N/mm ² Steel	50 - 100	0.01 - 0.12	40 - 80	0.01 - 0.08	hoher Vorschub	niedriger Vorschub
Acier inoxydable Rostfreistahl Stainless steel	60 - 120	0.01 - 0.15	60 - 100	0.01 - 0.08	average cutting speed	high cutting speed
Aluminium	180 - 800	0.01 - 0.30	150 - 300	0.01 - 0.20	high cutting feed	low cutting feed
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		

porte-outils
Halter
holders

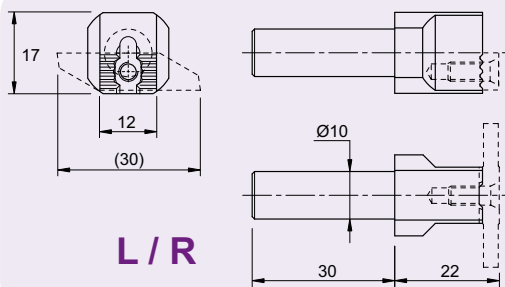


C	L	Art. N°
8 x 8	115	250-8
10 x 10	115	250-10
12 x 12	130	250-12
12 x 12	90	250-12-90
13 x 13	130	250-13
16 x 16	130	250-16
16 x 16	75	250-16-75
20 x 20	120	250-20

new



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



Art. N°
260 / 250-D10

Vis et clés de rechange
Ersatzschrauben und Schlüssel
Spare screws and keys

porte-outils
Halter
holders

250-... / 260-...
250-8 / 260-8
250RC / 260-C

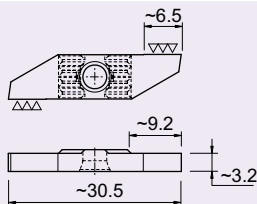
vis
Schrauben
screw

V-M4x9-T15
V-M3.5x7-T15
V-M4x7.3-T15

clé
Schlüssel
key

C-T15

plaquette ébauche
VHM-Rohling
blank insert



	Art. N°
sans revêtement unbeschichtet uncoated	251-E-N
revêtu beschichtet coated	251-E-AP202

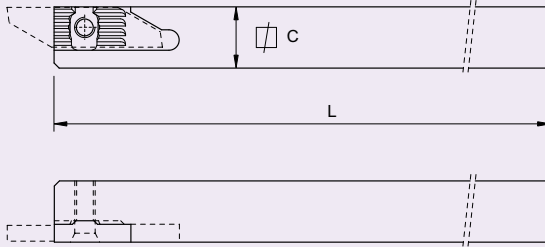
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

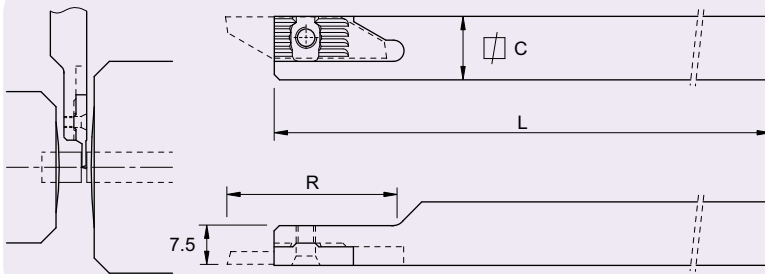
porte-outils

Halter

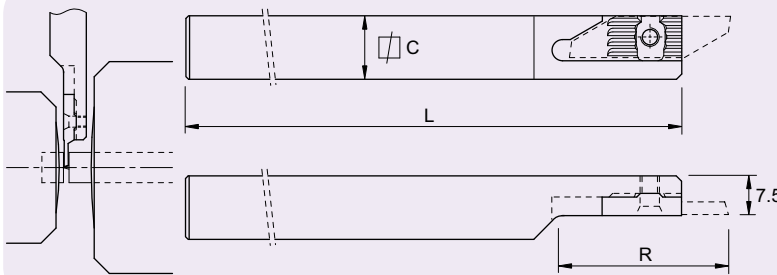
holders



C	L	Art. N°
8 x 8	115	260-8
10 x 10	115	260-10
12 x 12	130	260-12
12 x 12	90	260-12-90
13 x 13	130	260-13
16 x 16	130	260-16
16 x 16	75	260-16-75
20 x 20	120	260-20



C	L	R	Art. N°
12 x 12	130	30	260-C-12



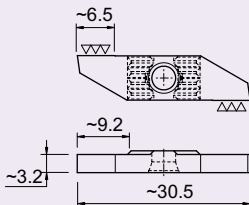
C	L	R	Art. N°
12 x 12	130	30	250RC-12
16 x 16	130	40	250RC-16

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

plaquette ébauche

VHM-Rohling

blank insert

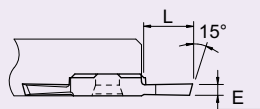


	Art. N°
sans revêtement unbeschichtet uncoated	261-E-N
revêtu beschichtet coated	261-E-AP202

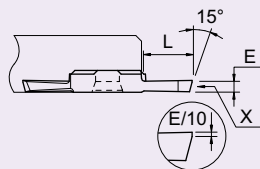
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

Tronçonnage
Abstechen
Cut off

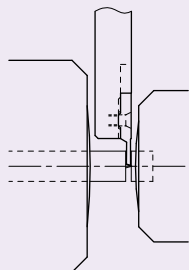


E	L	Art. N°
0.8	4	251-0.8-AP202
1.0	5	251-1.0-AP202
1.2	5	251-1.2-AP202
1.5	7	251-1.5-AP202
2.0	8.5	251-2.0-AP202
2.5	8.5	251-2.5-AP202

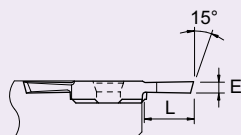


E	L	Art. N°
1.5	7	251xf-1.5-AP202
2.0	8.5	251xf-2.0-AP202

coupe à gauche déportée
versetztes Linksschneiden
left cut off line



Utiliser des porte-outils série 260
Halter Serie 260 verwenden
Use 260 series holders

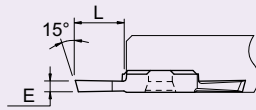


E	L	Art. N°
2.0	8.5	261L-2.0-AP202

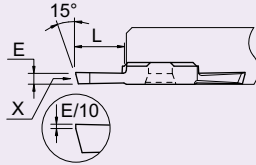
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

Tronçonnage
Abstechen
Cut off

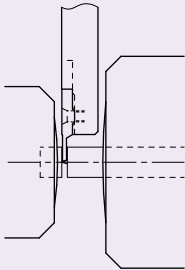


E	L	Art. N°
0.8	4	261-0.8-AP202
1.0	5	261-1.0-AP202
1.2	5	261-1.2-AP202
1.5	7	261-1.5-AP202
2.0	8.5	261-2.0-AP202
2.5	8.5	261-2.5-AP202

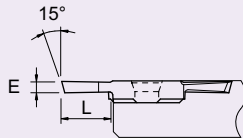


E	L	Art. N°
1.5	7	261xf-1.5-AP202
2.0	8.5	261xf-2.0-AP202

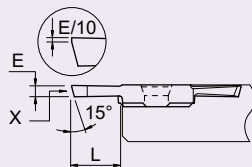
coupe à droite déportée
versetztes Rechtsschneiden
right cut off line



Utiliser des porte-outils série 250
Halter Serie 250 verwenden
Use 250 series holders



E	L	Art. N°
1.0	5	251R-1.0-AP202
1.5	7	251R-1.5-AP202
2.0	8.5	251R-2.0-AP202

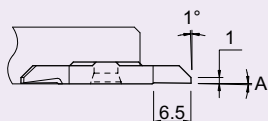


E	L	Art. N°
1.5	7	251Rxf-1.5-AP202
2.0	8.5	251Rxf-2.0-AP202

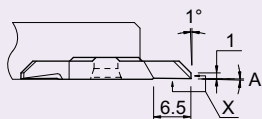
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

tourneur avant
vorwärts drehen
front turning

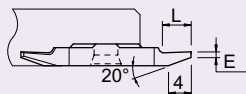


A	Art. N°
0°	252-AP202
2°	252-2°-AP202

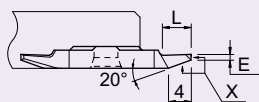


A	Art. N°
0°	252x-AP202
2°	252x-2°-AP202

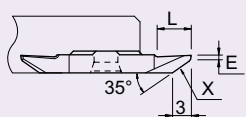
tourneur arrière
rückwärts drehen
back turning



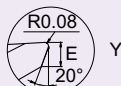
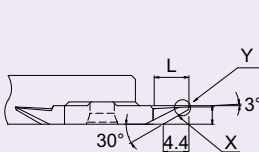
E	L	Art. N°
0.5	4	253-0.5-AP202
1.0	5	253-1.0-AP202



E	L	Art. N°
1.0	5	253x-1.0-AP202



E	L	Art. N°
1.0	6	253vx-8°-AP202



new

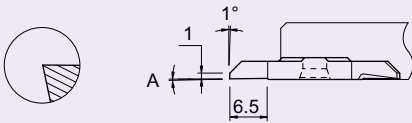


E	L	Art. N°
0.5	6	253vx-805-R08-AP202

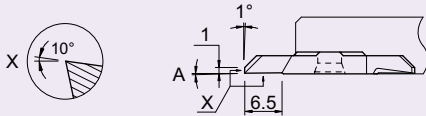
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

tourneur avant
vorwärts drehen
front turning

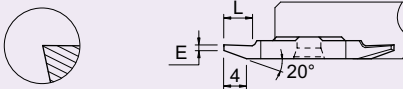


A	Art. N°
0°	262-AP202
2°	262-2°-AP202

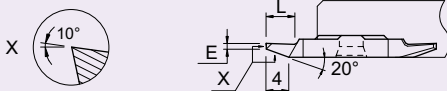


A	Art. N°
0°	262x-AP202
2°	262x-2°-AP202

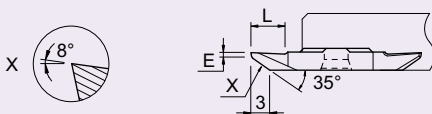
tourneur arrière
rückwärts drehen
back turning



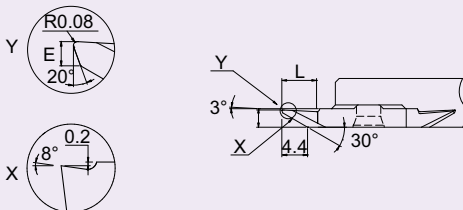
E	L	Art. N°
0.5	4	263-0.5-AP202
1.0	5	263-1.0-AP202



E	L	Art. N°
1.0	5	263x-1.0-AP202



E	L	Art. N°
1.0	6	263vx-8°-AP202

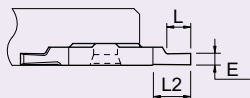


E	L	Art. N°
0.5	6	263vx-805-R08-AP202

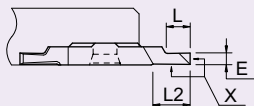
AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)

foncer-tourner
einstechen und drehen
grooving and turning

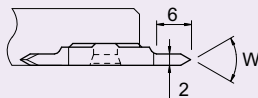


E	L	L2	Art. N°
0.8	2	4	254-0.8-AP202
1.0	2.5	4	254-1.0-AP202
1.2	3	4	254-1.2-AP202
1.5	3	4	254-1.5-AP202
2.0	4	6.5	254-2.0-AP202
2.5	6	6.5	254-2.5-AP202
3.0	6.5	6.5	254-3.0-AP202



E	L	L2	Art. N°
1.0	2.5	4	254x-1.0-AP202
1.2	3	4	254x-1.2-AP202
1.5	3	4	254x-1.5-AP202
2.0	4	6.5	254x-2.0-AP202
2.5	6	6.5	254x-2.5-AP202
3.0	6.5	6.5	254x-3.0-AP202

fileter
Gewinde drehen
threading

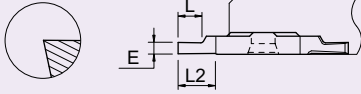


W	Art. N°
60°	256-60-2-AP202

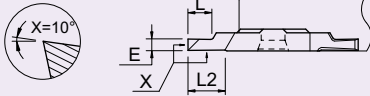
AP202

revêtement PVD universel haute performance (TIALN)
 universelle Hochleistung PVD Beschichtung (TIALN)
 universal high performance PVD coating (TIALN)

fonceur-tourner
einstechen und drehen
grooving and turning

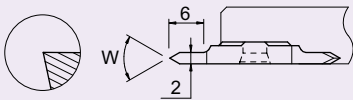


E	L	L2	Art. N°
0.8	2	4	264-0.8-AP202
1.0	2.5	4	264-1.0-AP202
1.2	3	4	264-1.2-AP202
1.5	3	4	264-1.5-AP202
2.0	4	6.5	264-2.0-AP202
2.5	6	6.5	264-2.5-AP202
3.0	6.5	6.5	264-3.0-AP202



E	L	L2	Art. N°
1.0	2.5	4	264x-1.0-AP202
1.2	3	4	264x-1.2-AP202
1.5	3	4	264x-1.5-AP202
2.0	4	6.5	264x-2.0-AP202
2.5	6	6.5	264x-2.5-AP202
3.0	6.5	6.5	264x-3.0-AP202

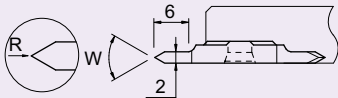
fileter
Gewinde drehen
threading



W	Art. N°
60°	266-60-2-AP202



new



Pas Steigung Pitch	R	W	Art. N°
P	0.06	60°	266-AG60-AP202

AP202

revêtement PVD universel haute performance (TIALN)
universelle Hochleistung PVD Beschichtung (TIALN)
universal high performance PVD coating (TIALN)