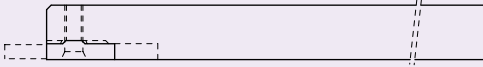


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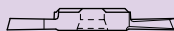
L

R



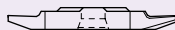
4.02

4.03



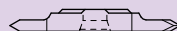
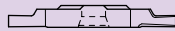
4.04

4.05



4.06

4.07



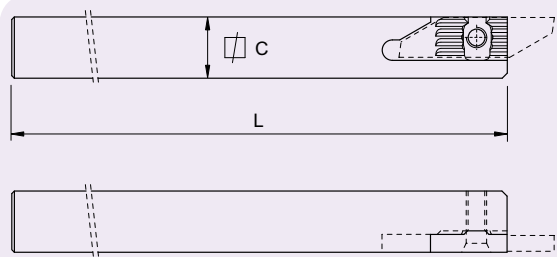
4.08

4.09

Paramètres de coupe indicatifs Empfohlene Schnittwerte Standard machining data

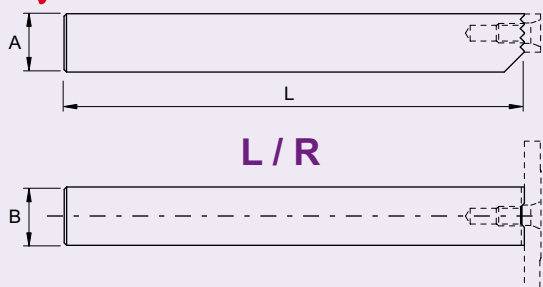
| Matière Werkstoff Material | Tournage Drehen Turning | | Tronçonnage Abstechen Cut off | | Indications pour premiers réglages Hinweise für die erste Einrichtung Indications for first setting | |
|--|-------------------------------|-------------|-------------------------------------|-------------|---|--|
| | 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

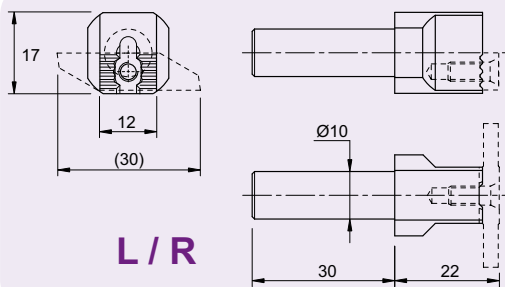


| C | L | Art. N° |
|---------|-----|-----------|
| 8 x 8 | 115 | 250-8 |
| 10 x 10 | 115 | 250-10 |
| 12 x 12 | 130 | 250-12 |
| 12 x 12 | 90 | 250-12-90 |
| 13 x 13 | 130 | 250-13 |
| 16 x 16 | 130 | 250-16 |
| 16 x 16 | 75 | 250-16-75 |
| 20 x 20 | 120 | 250-20 |

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

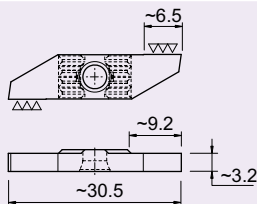
vis
Schrauben
screw

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 |

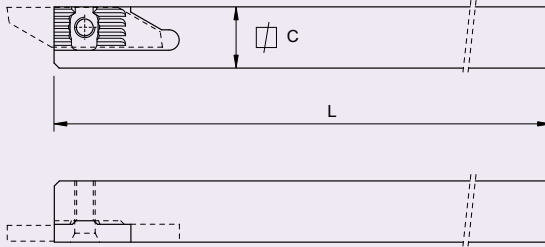
AP202

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

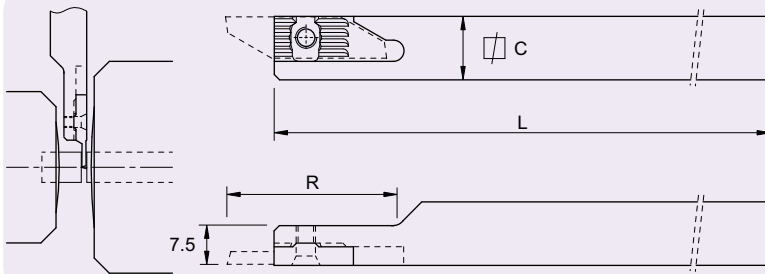
porte-outils

Halter

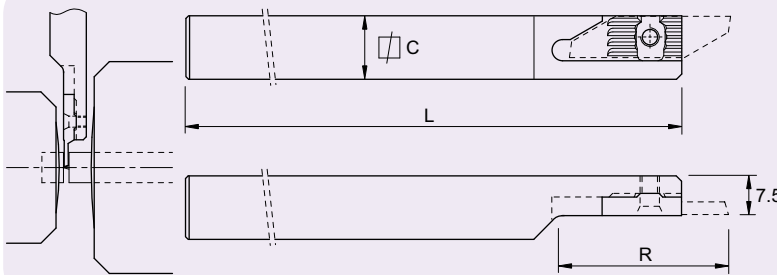
holders



| 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 |



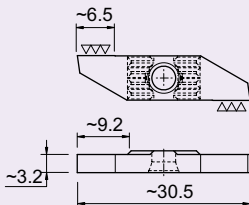
| C | L | R | Art. N° |
|---------|-----|----|-----------------|
| 12 x 12 | 130 | 30 | 250RC-12 |
| 16 x 16 | 130 | 40 | 250RC-16 |

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

plaquette ébauche

VHM-Rohling

blank insert

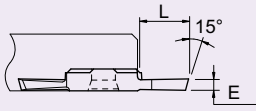


| | Art. N° |
|--|--------------------|
| sans revêtement unbeschichtet uncoated | 261-E-N |
| revêtu beschichtet coated | 261-E-AP202 |

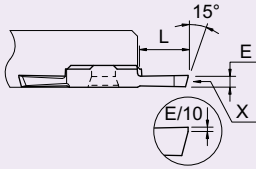
AP202

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

Tronçonnage
Abstechen
Cut off

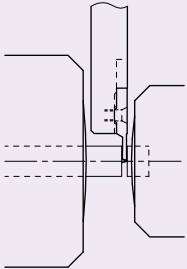


| E | L | Art. N° |
|-----|-----|---------------|
| 0.8 | 4 | 251-0.8-AP202 |
| 1.0 | 5 | 251-1.0-AP202 |
| 1.2 | 5 | 251-1.2-AP202 |
| 1.5 | 7 | 251-1.5-AP202 |
| 2.0 | 8.5 | 251-2.0-AP202 |
| 2.5 | 8.5 | 251-2.5-AP202 |

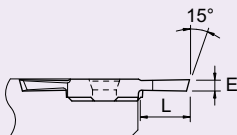


| E | L | Art. N° |
|-----|-----|-----------------|
| 1.5 | 7 | 251xf-1.5-AP202 |
| 2.0 | 8.5 | 251xf-2.0-AP202 |

coupe à gauche déportée
versetztes Linksschneiden
left cut off line



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

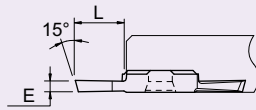


| E | L | Art. N° |
|-----|-----|----------------|
| 2.0 | 8.5 | 261L-2.0-AP202 |

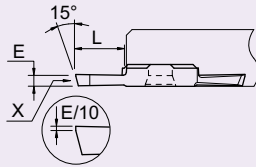
AP202

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

Tronçonnage
Abstechen
Cut off

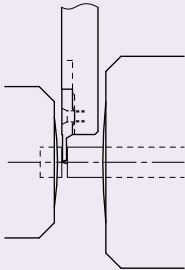


| E | L | Art. N° |
|-----|-----|---------------|
| 0.8 | 4 | 261-0.8-AP202 |
| 1.0 | 5 | 261-1.0-AP202 |
| 1.2 | 5 | 261-1.2-AP202 |
| 1.5 | 7 | 261-1.5-AP202 |
| 2.0 | 8.5 | 261-2.0-AP202 |
| 2.5 | 8.5 | 261-2.5-AP202 |

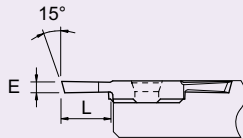


| E | L | Art. N° |
|-----|-----|-----------------|
| 1.5 | 7 | 261xf-1.5-AP202 |
| 2.0 | 8.5 | 261xf-2.0-AP202 |

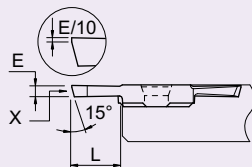
coupe à droite déportée
versetztes Rechtsschneiden
right cut off line



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 |

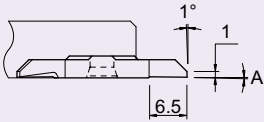


| E | L | Art. N° |
|-----|-----|------------------|
| 1.5 | 7 | 251Rxf-1.5-AP202 |
| 2.0 | 8.5 | 251Rxf-2.0-AP202 |

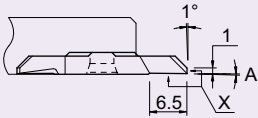
AP202

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

tourneur avant
vorwärts drehen
front turning

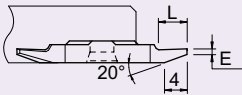


| A | Art. N° |
|----|--------------|
| 0° | 252-AP202 |
| 2° | 252-2°-AP202 |

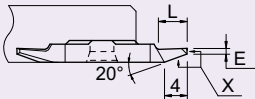


| A | Art. N° |
|----|---------------|
| 0° | 252x-AP202 |
| 2° | 252x-2°-AP202 |

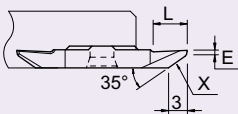
tourneur arrière
rückwärts drehen
back turning



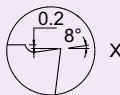
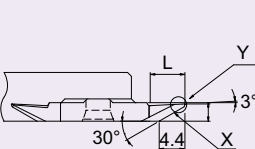
| E | L | Art. N° |
|-----|---|---------------|
| 0.5 | 4 | 253-0.5-AP202 |
| 1.0 | 5 | 253-1.0-AP202 |



| E | L | Art. N° |
|-----|---|----------------|
| 1.0 | 5 | 253x-1.0-AP202 |



| E | L | Art. N° |
|-----|---|----------------|
| 1.0 | 6 | 253vx-8°-AP202 |



new

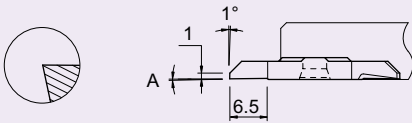


| E | L | Art. N° |
|-----|---|---------------------|
| 0.5 | 6 | 253vx-805-R08-AP202 |

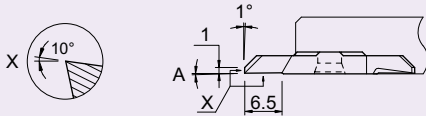
AP202

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

tourneur avant
vorwärts drehen
front turning

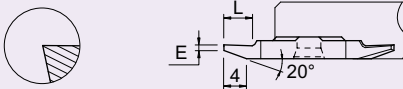


| A | Art. N° |
|----|--------------|
| 0° | 262-AP202 |
| 2° | 262-2°-AP202 |

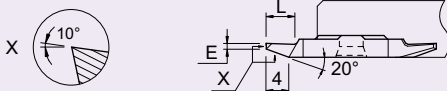


| A | Art. N° |
|----|---------------|
| 0° | 262x-AP202 |
| 2° | 262x-2°-AP202 |

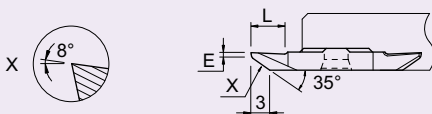
tourneur arrière
rückwärts drehen
back turning



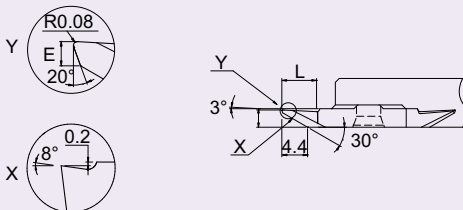
| E | L | Art. N° |
|-----|---|---------------|
| 0.5 | 4 | 263-0.5-AP202 |
| 1.0 | 5 | 263-1.0-AP202 |



| E | L | Art. N° |
|-----|---|----------------|
| 1.0 | 5 | 263x-1.0-AP202 |



| E | L | Art. N° |
|-----|---|----------------|
| 1.0 | 6 | 263vx-8°-AP202 |

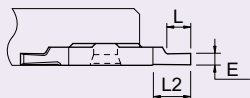


| E | L | Art. N° |
|-----|---|---------------------|
| 0.5 | 6 | 263vx-805-R08-AP202 |

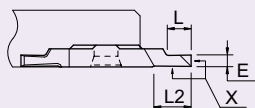
AP202

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

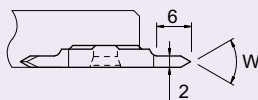


| E | L | L2 | Art. N° |
|-----|-----|-----|---------------|
| 0.8 | 2 | 4 | 254-0.8-AP202 |
| 1.0 | 2.5 | 4 | 254-1.0-AP202 |
| 1.2 | 3 | 4 | 254-1.2-AP202 |
| 1.5 | 3 | 4 | 254-1.5-AP202 |
| 2.0 | 4 | 6.5 | 254-2.0-AP202 |
| 2.5 | 6 | 6.5 | 254-2.5-AP202 |
| 3.0 | 6.5 | 6.5 | 254-3.0-AP202 |



| 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

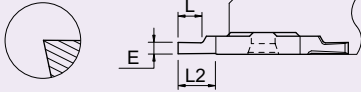


| W | Art. N° |
|-----|----------------|
| 60° | 256-60-2-AP202 |

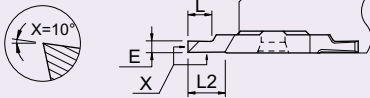
AP202

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

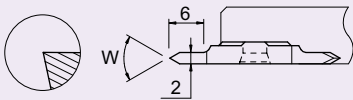


| E | L | L2 | Art. N° |
|-----|-----|-----|---------------|
| 0.8 | 2 | 4 | 264-0.8-AP202 |
| 1.0 | 2.5 | 4 | 264-1.0-AP202 |
| 1.2 | 3 | 4 | 264-1.2-AP202 |
| 1.5 | 3 | 4 | 264-1.5-AP202 |
| 2.0 | 4 | 6.5 | 264-2.0-AP202 |
| 2.5 | 6 | 6.5 | 264-2.5-AP202 |
| 3.0 | 6.5 | 6.5 | 264-3.0-AP202 |



| 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 |

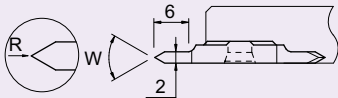
fileter
Gewinde drehen
threading



| W | Art. N° |
|-----|----------------|
| 60° | 266-60-2-AP202 |



new



| Pas Steigung Pitch | R | W | Art. N° |
|--------------------------|------|-----|----------------|
| 0.50-1.50 | 0.06 | 60° | 266-AG60-AP202 |

AP202

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