

Index

Informations techniques
Technisches Informationen
Technical information > **8.02**

Géométries de coupe
Spanformgeometrie
Cutting geometries > **8.04**

Nuances
Sorten
Grades > **8.05**

H Series sans arrosage
ohne Kühlung
without coolant > **8.06**

H JET Series avec arrosage
mit Kühlung
with coolant > **8.07**

H-HM-JET Series avec arrosage
mit Kühlung
with coolant > **8.08** **new**

GWS Series Göltenbodt > **8.09** **new**

MS Series Index > **8.13** **new**

Lames
Stecklingen
Blades **HM-HK-HUK Series** > **8.14**

U Series > **8.20**

J Series > **8.22**

T Series > **8.24**

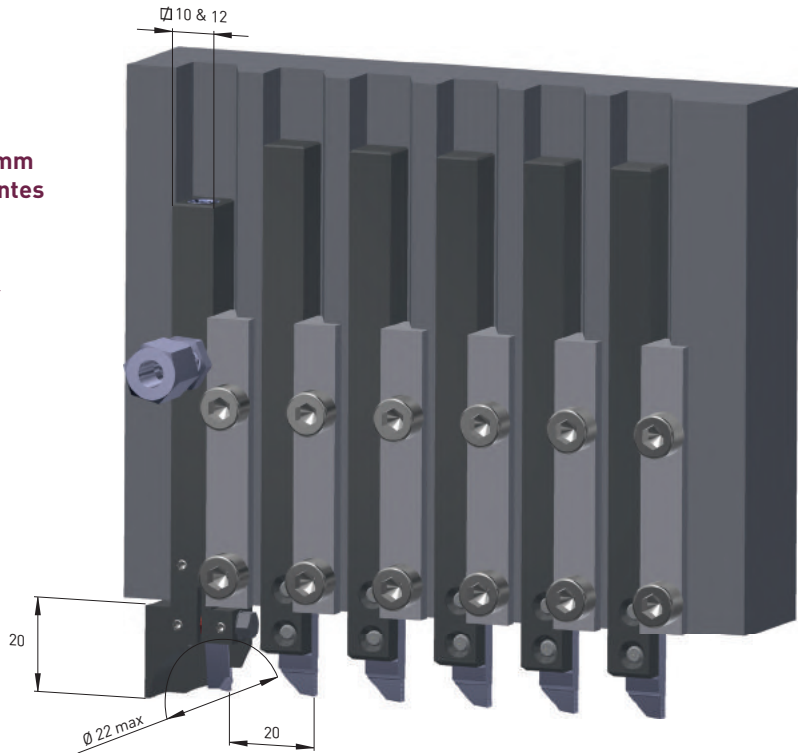
A Series > **8.26**

Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data > **8.28**

Compact: seulement 20 mm
pour les machines courantes

Kompakt: nur 20 mm für
übliche Maschinen

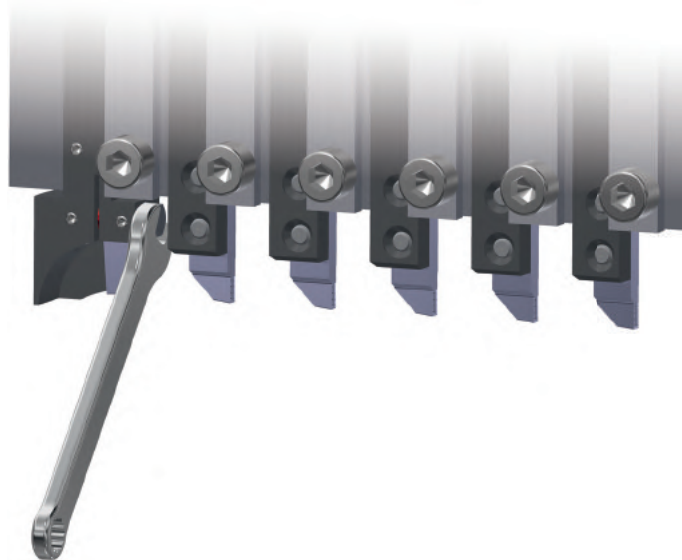
Compact: only 20 mm for
current machines



Facilité d'accès

Zugangseichtigkeit

Excellent accessibility



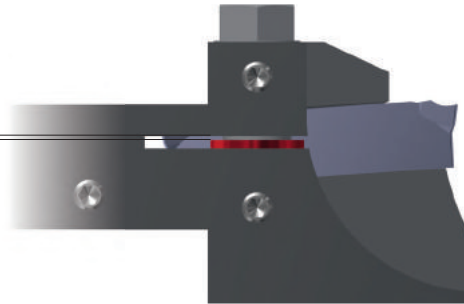
Changement de la plaquelette
sans démontage

Veränderung der Platte
ohne Zerlegung

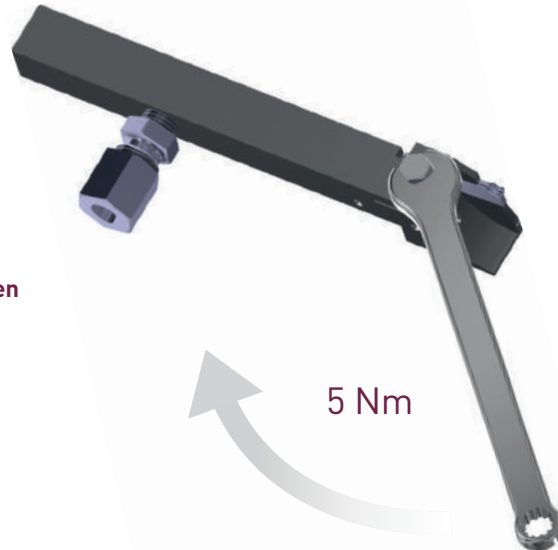
Change of insert
without disassembly

Butée de serrage
Spannungs-Anschlag
Clamping stop

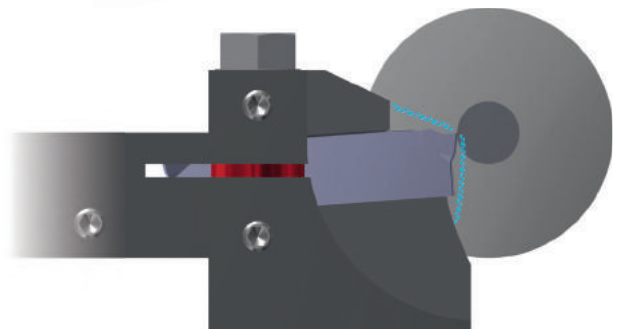
Distance de serrage
 Anschlagabstand
 Distance clamping



Recommendations de serrage:
 n'utiliser que la clé fournie
Spannungsempfehlungen:
 nur den gelieferten Schlüssel benutzen
Tightening recommendation:
 only use the delivered key



Support JET à double lubrification
JET Halter mit doppeltem Schmierung
Jet holder with double lubrication



EVOCUT-LINE

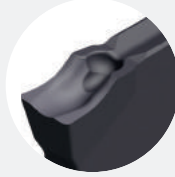
Géométries de coupe

Spanformgeometrie

Cutting geometries

UN

UL
UR



- géométrie positive universelle, faibles efforts de coupe
- bonne maîtrise du copeau
- 1^{er} choix pour l'inox

- allgemeine Geometrie, geringe Schnittkräfte
- gute Spankontrolle
- 1. Wahl für rostfreiem Stahl

- all-round geometry, low cutting forces
- efficient chip control
- 1st choice for stainless steel

JN

JR



- géométrie universelle
- excellent rétrécissement du copeau pour un meilleur contrôle
- conseillé pour le tronçonnage de pièces à parois minces
- pour acier et inox

- allgemeine Geometrie
- ausgezeichnete Spanversmalerung für eine bessere Spankontrolle
- für abstechen von dünnwandigen Teilen empfohlen
- für Stahl und rostfreiem Stahl

- all-round geometry
- very efficient arrow for a better chip control
- recommended for parting off of thin-walled parts
- for steel and stainless steel

TN

TR



- géométrie négative
- utilisation dans des conditions de rigidité optimale
- pour les matières à haute ténacité
- universel pour les aciers et inox

- negative Geometrie
- bei stabilen Verhältnissen einsetzbar
- für hohe widerstandsfähige Rohstoffe
- allgemein für Stahl und rostfreiem Stahl

- negative geometry
- use in solid cutting conditions
- for high toughness material
- universal for steel and stainless steel

AN

AR



- géométrie fortement positive
- roule-copeau poli avec arêtes de coupe vives
- 1^{er} choix pour aluminium et matériaux non ferreux

- stark positive Geometrie
- geschliffene Spanrolle mit scharfe Schneidkanten
- 1. Wahl für Aluminium und Nichteisenmetalle

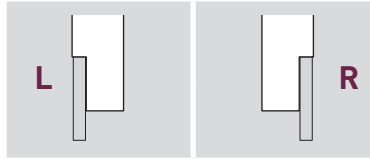
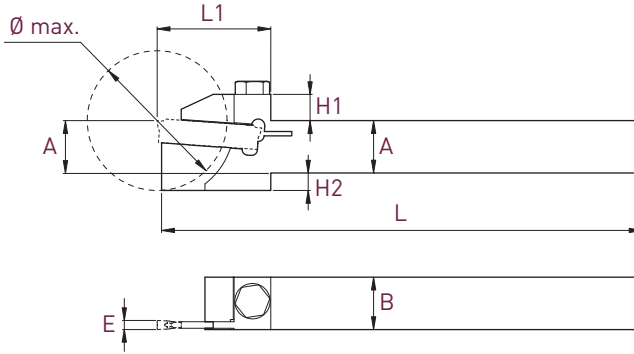
- very positive geometry
- polished chip roller with sharp cutting edge
- 1st choice for aluminium and non-ferrous materials

Nuances

Sorten

Grades

<p>P M N S</p> <p>TiAlN revêtement PVD PVD Beschichtung PVD coating</p>	<p>P M <input type="checkbox"/> <input type="checkbox"/></p> <p>Tmax revêtement PVD PVD Beschichtung PVD coating</p>	<p>P M <input type="checkbox"/> <input type="checkbox"/></p> <p>Zmax revêtement PVD PVD Beschichtung PVD coating</p>
<ul style="list-style-type: none"> pour l'usinage des aciers, aciers inoxydables et alliages de titane 1^{er} choix pour les avances faibles à modérées 	<ul style="list-style-type: none"> nuance pour usinage moyen à lourd des aciers, aciers alliés et inoxydables bonne résistance aux températures d'usinage élevées 1^{er} choix pour le tronçonnage des aciers au carbone et des aciers fortement alliés 	<ul style="list-style-type: none"> pour l'usinage des aciers, aciers inoxydables et alliages de titane en conditions défavorables bonne résistance aux chocs à des vitesses de coupe moyenne à faible 1^{er} choix pour le tronçonnage en coupe interrompue
<ul style="list-style-type: none"> für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen beste Wahl für niedrige bis mittlere Vorschübe 	<ul style="list-style-type: none"> Sorte für mittlere bis hohe Belastung in Stahl und legierter Stahlbearbeitung gute Bearbeitungswarmfestigkeit für die Bearbeitung von legiertem Kohlenstahl und hoch legiertem Stahl bestens geeignet 	<ul style="list-style-type: none"> für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen in schwierige Bearbeitungsfälle gute Bruchfestigkeit mit durchschnittliche bis niedrige Schnittgeschwindigkeit für die Bearbeitung in unterbrochenen Schnitte bestens geeignet
<ul style="list-style-type: none"> for machining of steel, stainless steel and titanium alloys first choice for low to average cutting speed 	<ul style="list-style-type: none"> grade for medium to heavy machining of steel, stainless steel and alloyed steel high machining heat resistance first choice for the machining of carbon steel and high alloyed steel 	<ul style="list-style-type: none"> for machining of steel, stainless steel and titanium alloys in unfavourable machining conditions good impact resistance with average to low cutting speed first choice for machining in interrupted cut
<p>P M <input type="checkbox"/> <input type="checkbox"/></p> <p>ZTi6 revêtement CVD CVD Beschichtung CVD coating</p>	<p><input type="checkbox"/> <input type="checkbox"/> N S</p> <p>AS revêtement PVD PVD Beschichtung PVD coating</p>	<p><input type="checkbox"/> <input type="checkbox"/> N S</p> <p>N non-revêtu unbeschichtet uncoated</p>
<ul style="list-style-type: none"> nuance très tenace grande résistance à la température 1^{er} choix pour les aciers «haute température» secondairement pour les aciers inox 	<ul style="list-style-type: none"> nuance pour métaux non ferreux très faible coefficient de frottement 1^{er} choix pour l'usinage des aluminiums jusqu'à 5% Si, des cuivres et titanes faiblement alliés 	<ul style="list-style-type: none"> nuance non revêtu recommandé pour l'usinage des matières non-ferreuses titane, laiton, cuivre, aluminium sans silicium, plastique
<ul style="list-style-type: none"> sehr zähe Sorte hohe Bearbeitungswarmfestigkeit 1. Wahl für „hohe Temperatur“ Stähle sekundär für rostfreie Stähle 	<ul style="list-style-type: none"> Sorte für Nichteisenmetalle sehr geringer Reibwert für die Bearbeitung von Aluminium bis 5% Si, Kupfer und niedriglegiertem Titan bestens geeignet 	<ul style="list-style-type: none"> unbeschichtete Sorte für die Bearbeitung von Nichteisenmetalle empfohlen Titan, Messing, Kupfer, Silicium freies Aluminium, Kunststoff
<ul style="list-style-type: none"> very strong grade good wear resistance 1st choice for "high temperature" steels secondarily for stainless steels 	<ul style="list-style-type: none"> grade for non-ferrous materials very low friction ratio first choice for aluminium up to 5% Si, copper and low alloyed titanium 	<ul style="list-style-type: none"> uncoated grade recommended for machining of non-ferrous materials titanium, brass, bronze, aluminium without silicium, plastic



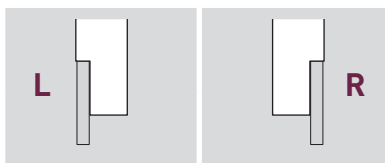
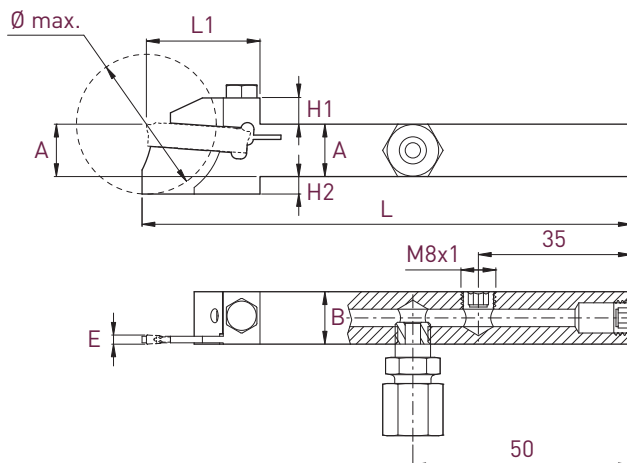
Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H1	H2	Art. N°		Pièces de rechange Ersatzteile Spare parts	
							Art. N°	Art. N°	Art. N°	Art. N°
E 1.5	10x12	110	22	20	5	6	ET15-H1012L-D22	ET15-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12	110	22	20	5	4	ET15-H1212L-D22	ET15-H1212R-D22		
	12.7x12.7	110	22	20	5	3	ET15-H12.7L-D22	ET15-H12.7R-D22		
Type ET15	12x12	110	32	26	6	4	ET15-H1212L-D32	ET15-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	12.7x12.7	110	32	26	6	3	ET15-H12.7L-D32	ET15-H12.7R-D32		
	16x16	110	32	26	6	-	ET15-H1616L-D32	ET15-H1616R-D32		
E 2.0	10x12	110	22	20	5	6	ET20-H1012L-D22	ET20-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12	110	22	20	5	4	ET20-H1212L-D22	ET20-H1212R-D22		
	12.7x12.7	110	22	20	5	3	ET20-H12.7L-D22	ET20-H12.7R-D22		
Type ET20	12x12	110	32	26	6	4	ET20-H1212L-D32	ET20-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	12.7x12.7	110	32	26	6	3	ET20-H12.7L-D32	ET20-H12.7R-D32		
	16x16	110	32	26	6	-	ET20-H1616L-D32	ET20-H1616R-D32		
E 2.5	10x12	110	22	20	5	6	ET25-H1012L-D22	ET25-H1012R-D22	V-M5X20-6P6	C-6PEX-6.0
	12x12	110	22	20	5	4	ET25-H1212L-D22	ET25-H1212R-D22		
	12.7x12.7	110	22	20	5	3	ET25-H12.7L-D22	ET25-H12.7R-D22		
Type ET25	12x12	110	32	26	6	4	ET25-H1212L-D32	ET25-H1212R-D32	V-M5X21-6P7	C-6PEX-7.0
	12.7x12.7	110	32	26	6	3	ET25-H12.7L-D32	ET25-H12.7R-D32		
	16x16	110	32	26	6	-	ET25-H1616L-D32	ET25-H1616R-D32		
E 3.0	16x16	130	44	35	8	4	ET30-H1616L-D44	ET30-H1616R-D44	V-M5X27-6P7	C-6PEX-7.0
	20x20	130	44	35	8	-	ET30-H2020L-D44	ET30-H2020R-D44		
	25x25	140	44	35	8	-	ET30-H2525L-D44	ET30-H2525R-D44		
Type ET30	16x16	130	44	35	8	4	ET30-H1616L-D44	ET30-H1616R-D44	V-M5X27-6P7	C-6PEX-7.0
	20x20	130	44	35	8	-	ET30-H2020L-D44	ET30-H2020R-D44		
	25x25	140	44	35	8	-	ET30-H2525L-D44	ET30-H2525R-D44		

* livré avec chaque porte-outil
mit jedem Halter geliefert
delivered with each holder


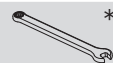
Porte-outils avec arrosage intégré
 Halter mit integrierter Kühlmittelzufuhr
 Holders with integrated coolant supply

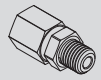

Ø max 44 mm

H JET Series



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H1	H2	Art. N°	
							Art. N°	Art. N°
E 2.0 Type ET20	10x12	110	22	20	5	6	ET20-H1012L-JET22	ET20-H1012R-JET22
	12x12	110	22	20	5	4	ET20-H1212L-JET22	ET20-H1212R-JET22
	12.7x12.7	110	22	20	5	3	ET20-H12.7L-JET22	ET20-H12.7R-JET22
	12x12	110	32	26	6	4	ET20-H1212L-JET32	ET20-H1212R-JET32
	12.7x12.7	110	32	26	6	3	ET20-H12.7L-JET32	ET20-H12.7R-JET32
	16x16	110	32	26	6	-	ET20-H1616L-JET32	ET20-H1616R-JET32
	16x16	130	44	35	8	4	ET20-H1616L-JET44	ET20-H1616R-JET44
20x20	130	44	35	8	-	ET20-H2020L-JET44	ET20-H2020R-JET44	
E 2.5 Type ET25	10x12	110	22	20	5	6	ET25-H1012L-JET22	ET25-H1012R-JET22
	12x12	110	22	20	5	4	ET25-H1212L-JET22	ET25-H1212R-JET22
	12.7x12.7	110	22	20	5	3	ET25-H12.7L-JET22	ET25-H12.7R-JET22
	12x12	110	32	26	6	4	ET25-H1212L-JET32	ET25-H1212R-JET32
	12.7x12.7	110	32	26	6	3	ET25-H12.7L-JET32	ET25-H12.7R-JET32
	16x16	110	32	26	6	-	ET25-H1616L-JET32	ET25-H1616R-JET32
	16x16	130	44	35	8	4	ET25-H1616L-JET44	ET25-H1616R-JET44
20x20	130	44	35	8	-	ET25-H2020L-JET44	ET25-H2020R-JET44	
E 3.0 Type ET30	16x16	110	32	26	6	-	ET30-H1616L-JET32	ET30-H1616R-JET32
	16x16	130	44	35	8	4	ET30-H1616L-JET44	ET30-H1616R-JET44
	20x20	130	44	35	8	-	ET30-H2020L-JET44	ET30-H2020R-JET44
	25x25	140	44	35	8	-	ET30-H2525L-JET44	ET30-H2525R-JET44

Pièces de rechange Ersatzteile Spare parts	
 *	 *
Art. N°	Art. N°
V-M5X20-6P6-J	C-6PEX-6.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0
V-M5X20-6P6-J	C-6PEX-6.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0
V-M5X21-6P7-J	C-6PEX-7.0
V-M5X27-6P7-J	C-6PEX-7.0

Pièces de rechange Ersatzteile Spare parts		
	Art. N°	Art. N°
	J-M8X1-D6	JB-M8X1

* Livré avec chaque porte-outil
 mit jedem Halter geliefert
 delivered with each holder

EVOCUT-LINE

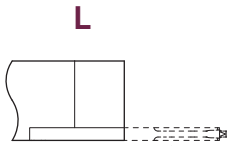
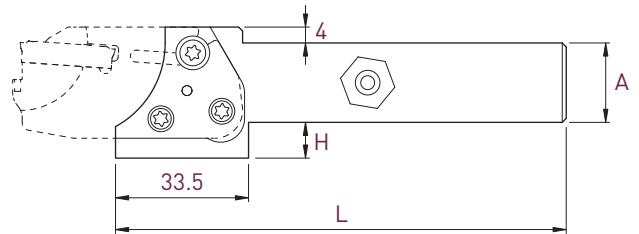
Porte-lames avec arrosage

Halter für Stechklinge mit Kühlung

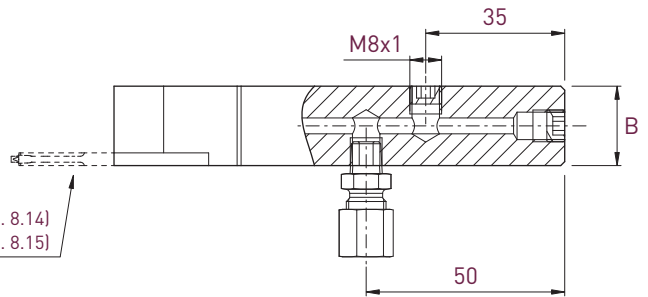
Holder for parting-off blades with coolant

H-HM-JET Series

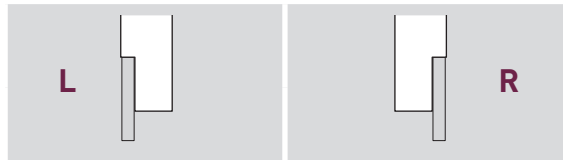
new



HM-IN (p. 8.14)
HM-IL-JET (p. 8.15)



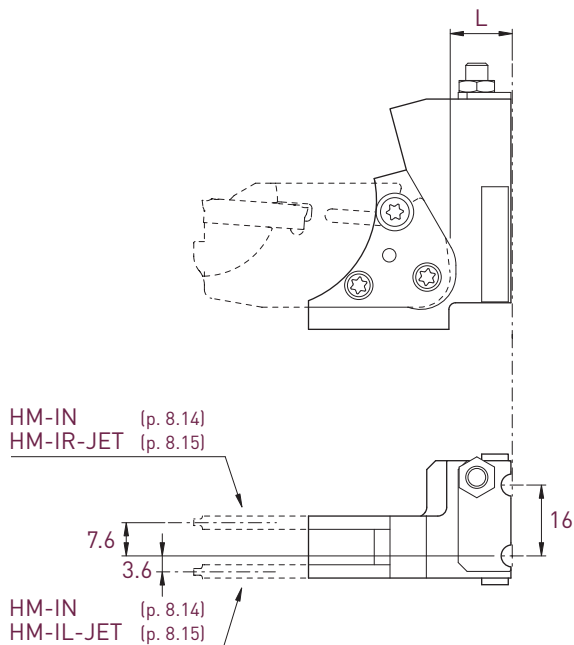
HM-IN (p. 8.14)
HM-IR-JET (p. 8.15)



A x B	L	H	Art. N°	Art. N°
16x16	113.5	13	H1616L-HM-JET	H1616R-HM-JET
20x20	113.5	9	H2020L-HM-JET	H2020R-HM-JET
25x25	138.5	4	H2525L-HM-JET	H2525R-HM-JET

Pièces de rechange Ersatzteile Spare parts					
	Art. N°	Art. N°	Art. N°	Art. N°	Art. N°
	V-M5X10-T20IP	V-M6X10-T20IP	J-M8X1-D6	JB-M8X1	C-T20IP

new

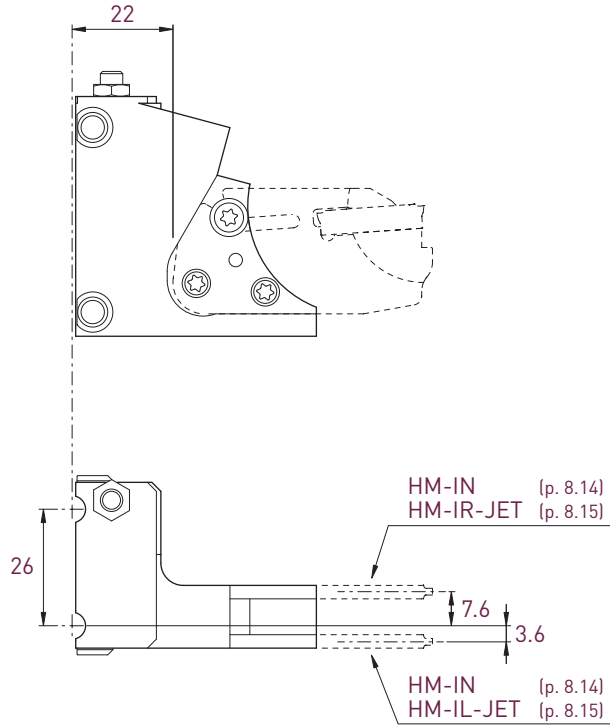


Pièces de rechange
Ersatzteile
Spare parts

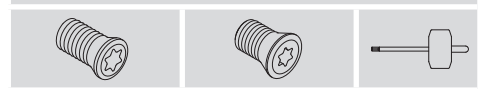


Interface	Machine compatibility	L	Art. N°	Art. N°	Art. N°	Art. N°
GWS02	AS14	14	GWS02R-02001-HM-JET	V-M5X10-T20IP	V-M6X10-T20IP	C-T20IP
	SAS16					
	SBS20					
	Others	22	GWS02R-02002-HM-JET			

new

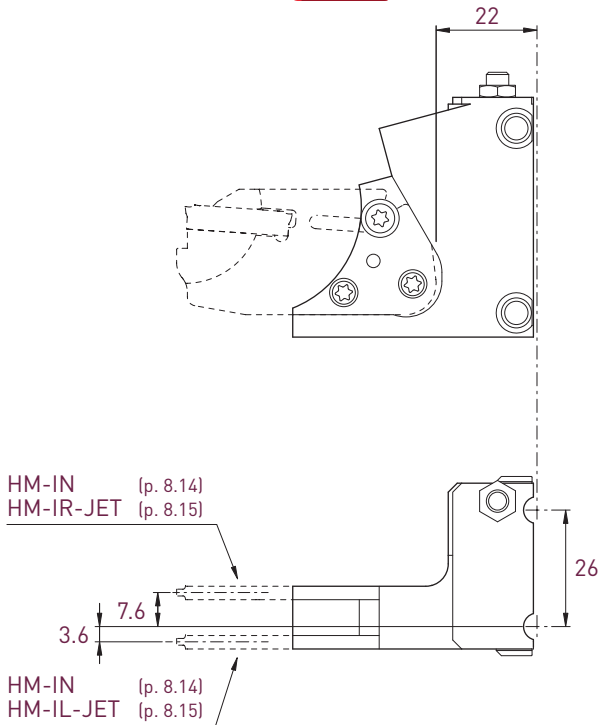


Pièces de rechange
Ersatzteile
Spare parts



Interface	Machine compatibility	Art. N°	Art. N°	Art. N°	Art. N°
GWS41	MultiSwiss 6X16	GWS41L-41001-HM-JET	V-M5X10-T20IP	V-M6X10-T20IP	C-T20IP
	MultiDeco 20X6				
	MultiDeco 20X8				
	MultiDeco 26X6				
	MultiDeco 32X6				
	MultiAlpha 20X8				
	MultiSigma 24X8				

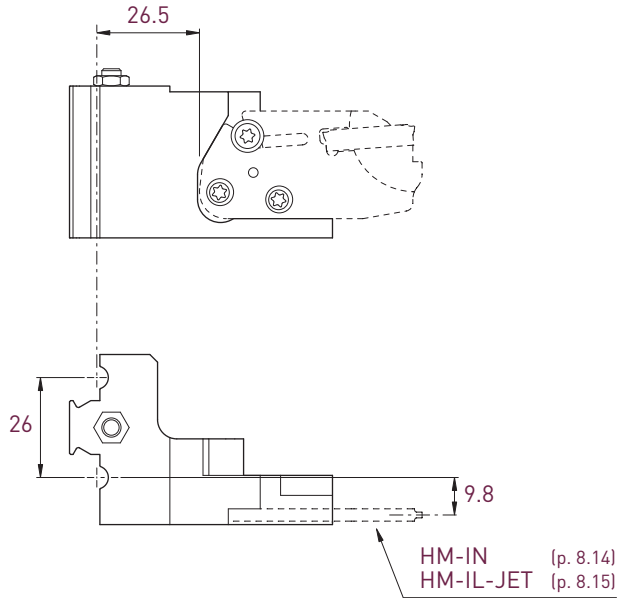
new



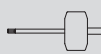


Pièces de rechange
Ersatzteile
Spare parts

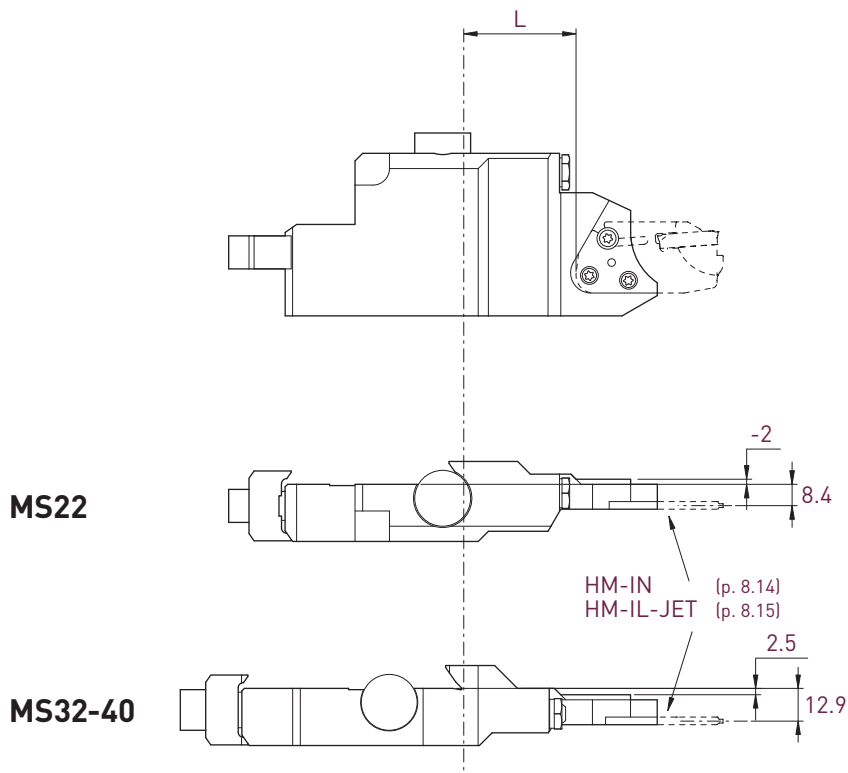
Interface	Machine compatibility	Art. N°	Pièces de rechange Ersatzteile Spare parts		
			Art. N°	Art. N°	Art. N°
GWS41	MultiSwiss 6X16	GWS41R-41001-HM-JET	V-M5X10-T20IP	V-M6X10-T20IP	C-T20IP
	MultiDeco 20X6				
	MultiDeco 20X8				
	MultiDeco 26X6				
	MultiDeco 32X6				
	MultiAlpha 20X8				
	MultiSigma 24X8				

new



		Pièces de rechange Ersatzteile Spare parts			
Interface	Machine compatibility	Art. N°	 Art. N°	 Art. N°	 Art. N°
GWS202	MultiSwiss 6X32	GWS202L-202001-HM-JET	V-M5X10-T20IP	V-M6X10-T20IP	C-T20IP
	MultiSwiss 8X26				

new



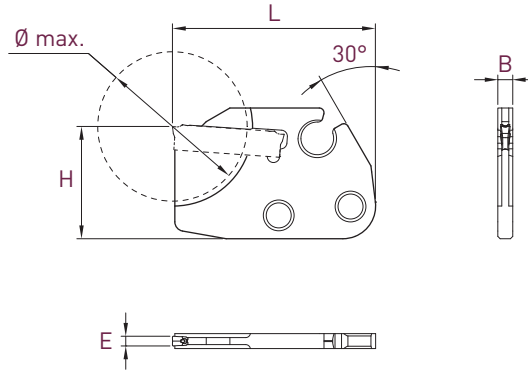
Pièces de rechange
Ersatzteile
Spare parts

Machine compatibility	L	Art. N°	Pièces de rechange Ersatzteile Spare parts		
			Art. N°	Art. N°	Art. N°
MS22	44.2	MS22-W5190231-HM-JET	V-M5X10-T20IP	V-M6X10-T20IP	C-T20IP
MS32-40	45.5	MS32-40-W5190233-HM-JET			

EVO CUT-LINE

Lames pour système modulaire
 Stechklinge für modulares System
 Parting-off blades for modular system

HM Series



N

Plaquettes WSP Inserts	Ø max.	B	L	H	Art. N°
E 1.5 Type ET15	20	3.2	43.5	24	ET15-HM-IN-43-D20
	32	3.2	43.5	24	ET15-HM-IN-43-D32
E 2.0 Type ET20	20	3.2	43.5	24	ET20-HM-IN-43-D20
	26	3.2	43.5	24	ET20-HM-IN-43-D26
	26	3.2	54	24	ET20-HM-IN-54-D26
	32	3.2	43.5	24	ET20-HM-IN-43-D32
E 3.0 Type ET30	32	3.2	43.5	24	ET30-HM-IN-43-D32

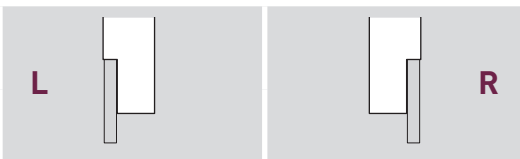
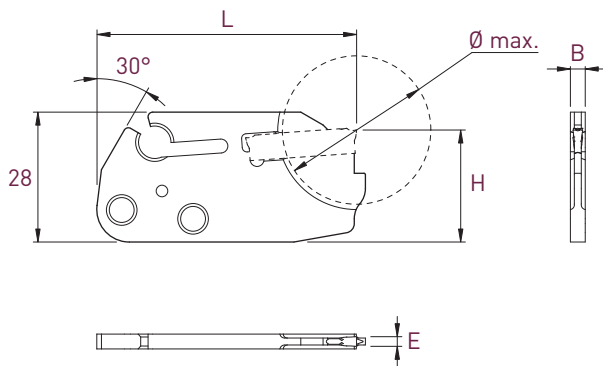
Lames avec arrosage intégré

Stechklinge mit integrierter Kühlmittelzufuhr

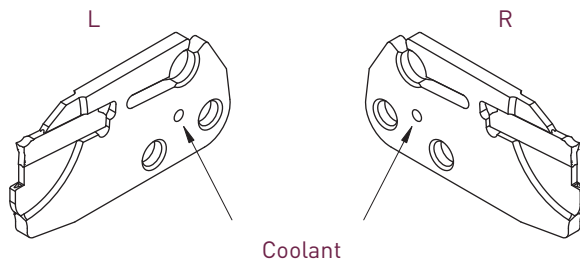
Parting-off blades with integrated coolant supply

HM-JET Series

new



Plaquettes WSP Inserts	Ø max.	B	L	H	Art. N°	Art. N°
E 2.0 Type ET20	20	3.2	48.5	24	ET20-HM-IL-48.5-JET20	ET20-HM-IR-48.5-JET20
	24		48.5		ET20-HM-IL-48.5-JET24	ET20-HM-IR-48.5-JET24
	32		45.5		ET20-HM-IL-45.5-JET32	ET20-HM-IR-45.5-JET32
	32		56		ET20-HM-IL-56-JET32	ET20-HM-IR-56-JET32
	42		48.5		ET20-HM-IL-48.5-JET42	ET20-HM-IR-48.5-JET42
E 3.0 Type ET30	32	3.2	45.5	24	ET30-HM-IL-45.5-JET32	ET30-HM-IR-45.5-JET32
	44		48.5		ET30-HM-IL-48.5-JET42	ET30-HM-IR-48.5-JET42



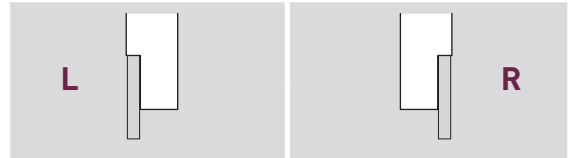
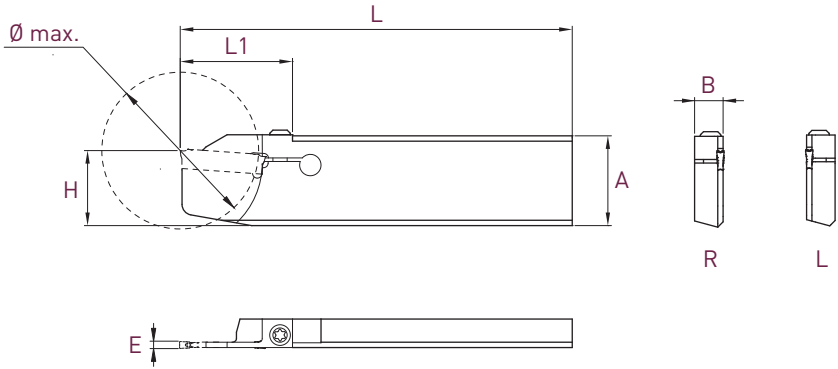
EVOCUT-LINE

Lames de tronçonnage


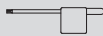
Stechklinge

Parting-off blades

HK Series



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	Art. N°	Art. N°
E 1.5 Type ET15	26x8	110	20	19.5	21	ET15-HK-2608L-110-D20	ET15-HK-2608R-110-D20
	26x8	110	32	25.5	21	ET15-HK-2608L-110-D32	ET15-HK-2608R-110-D32
E 2.0 Type ET20	26x8	110	32	25.5	21	ET20-HK-2608L-110-D32	ET20-HK-2608R-110-D32
	26x8	110	44	31.5	21	ET20-HK-2608L-110-D44	ET20-HK-2608R-110-D44

Pièces de rechange Ersatzteile Spare parts	 *	 *
	Art. N°	Art. N°
	V-M4X14.5-T15-EVOCUT	C-T15

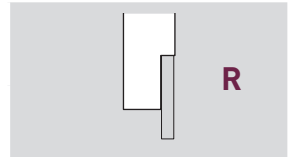
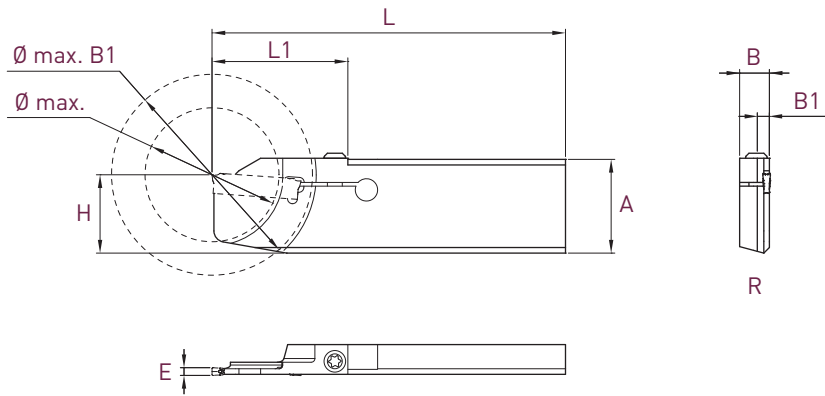
* livré avec chaque lame
mit jedem Stechkling geliefert
delivered with each blade

Lames de tronçonnage avec dégagement pour accès contre-broche

Stecklinge mit Aussparung für Gegenspindel Zugriff

Parting-off blades with recess for subspindle access

HK-RS Series



Plaquettes WSP Inserts	A x B	L	Ø max.	Ø max. B1	B1	L1	H	Art. N°
E 1.5 Type ET15	26x8	95	36	54	3.25	36.5	21	ET15-HK-2608RS-95-D36
E 2.0 Type ET20	26x8	95	36	54	3.25	36.5	21	ET20-HK-2608RS-95-D36

Pièces de rechange
Ersatzteile
Spare parts



*

Art. N°

V-M4X14.5-T15-EVOCUT



*

Art. N°

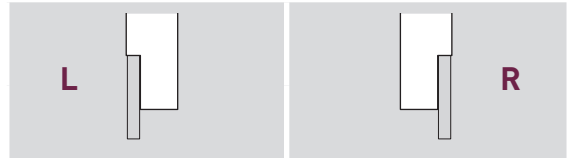
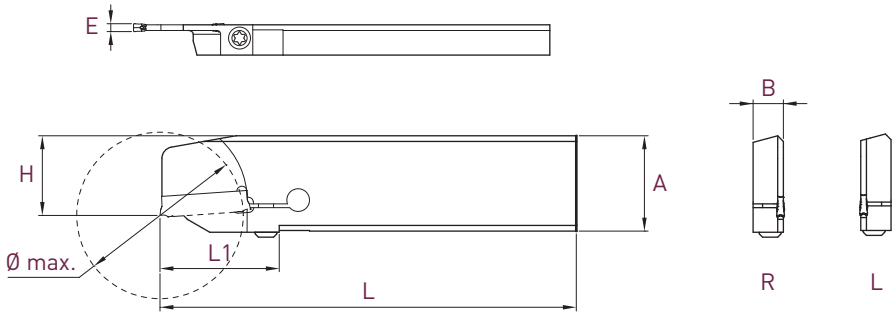
C-T15

* livré avec chaque lame
mit jedem Steckling geliefert
delivered with each blade


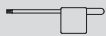
EVOCUT-LINE

Lames de tronçonnage inversées
 Überkopf Stechklinge
 Upside down parting-off blades

HUK Series



Plaquettes WSP Inserts	A x B	L	Ø max.	L1	H	Art. N°	Art. N°
E 1.5 Type ET15	26x8	110	20	19.5	21	ET15-HUK-2608L-110-D20	ET15-HUK-2608R-110-D20
	26x8	110	32	25.5	21	ET15-HUK-2608L-110-D32	ET15-HUK-2608R-110-D32
E 2.0 Type ET20	26x8	110	32	25.5	21	ET20-HUK-2608L-110-D32	ET20-HUK-2608R-110-D32
	26x8	110	44	31.5	21	ET20-HUK-2608L-110-D44	ET20-HUK-2608R-110-D44

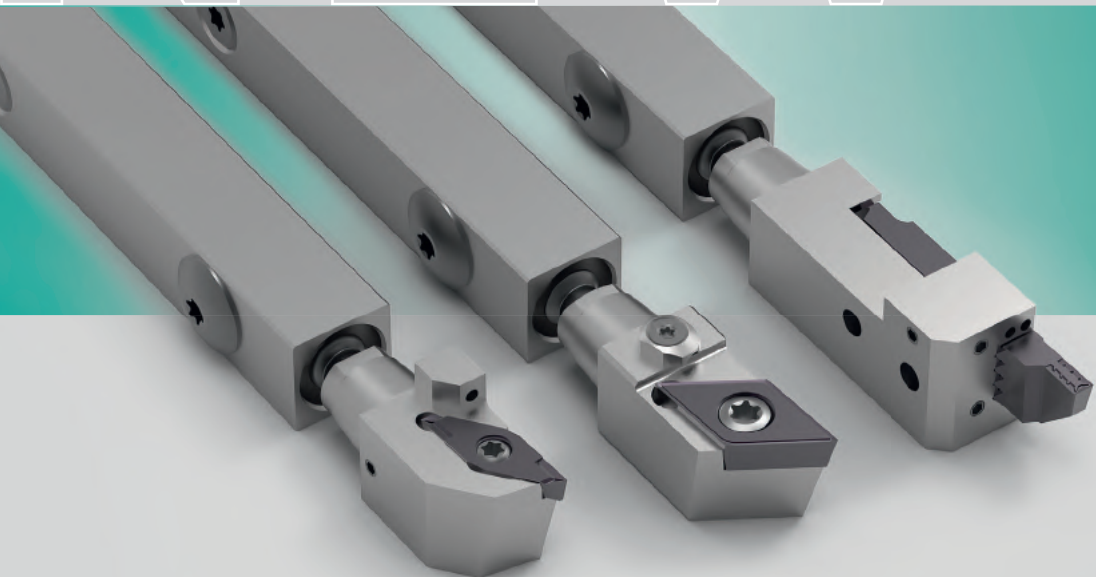
Pièces de rechange Ersatzteile Spare parts	 *	 *
	Art. N°	Art. N°
	V-M4X14.5-T15-EVOCUT	C-T15

* livré avec chaque lame
 mit jedem Steckling geliefert
 delivered with each blade

SWITCH-LINE



NEW

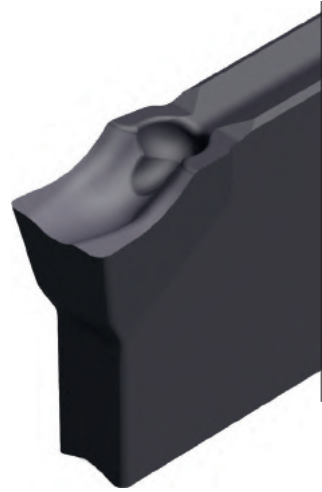
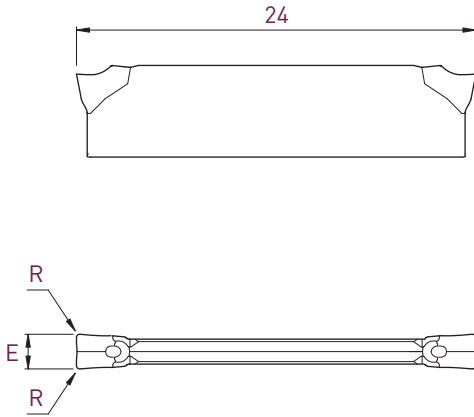


DISCOVER THE RANGE SWITCH-LINE IN CHAPTER 11!

EVOCUT-LINE

Plaquettes de tronçonnage
 Abstechwendeplatten
 Cut off inserts

UN Series



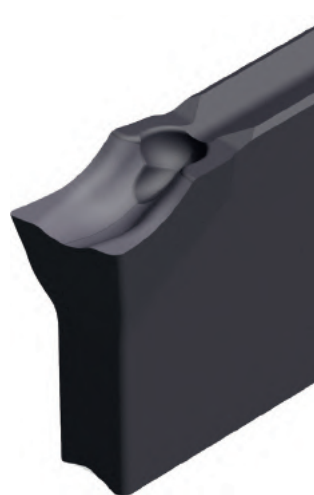
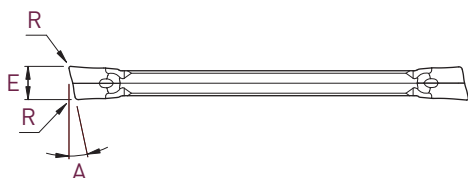
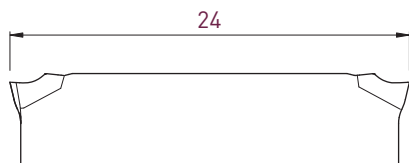
			UN				
Type	$E_{\pm 0.05}$	R	Art. N°	T:AIN	Tmax	Zmax	ZTi6
ET15	1.35	0	ET15-UN-000F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	1.5	0.2	ET15-UN-002	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET20	1.85	0	ET20-UN-000F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	2.0	0.2	ET20-UN-002	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET25	2.35	0	ET25-UN-000F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	2.5	0.3	ET25-UN-003	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET30	2.85	0	ET30-UN-000F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	3.0	0.3	ET30-UN-003	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

UL-UR Series



Type	E ±0.05	A	R	UL			UR				
				Art. N°	TiAlN	Tmax	Zmax	Art. N°	TiAlN	Tmax	Zmax
ET15	1.5	6°	0.2	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET15-UR-602	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	1.35	8°	0	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET15-UR-800F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	1.5	12°	0.1	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET15-UR-1201	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	1.35	15°	0	ET15-UL-1500F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET15-UR-1500F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET20	2.0	6°	0.2	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET20-UR-602	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	1.85	8°	0	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET20-UR-800F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.0	12°	0.1	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET20-UR-1201	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	1.85	15°	0	ET20-UL-1500F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET20-UR-1500F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET25	2.5	6°	0.2	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET25-UR-602	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.35	8°	0	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET25-UR-800F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	12°	0.1	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET25-UR-1201	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.35	15°	0	ET25-UL-1500F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET25-UR-1500F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET30	3.0	6°	0.3	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET30-UR-603	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.85	8°	0	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET30-UR-800F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	3.0	12°	0.2	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET30-UR-1202	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	2.85	15°	0	ET30-UL-1500F	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	ET30-UR-1500F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

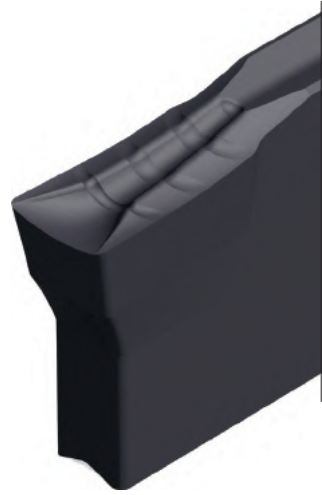
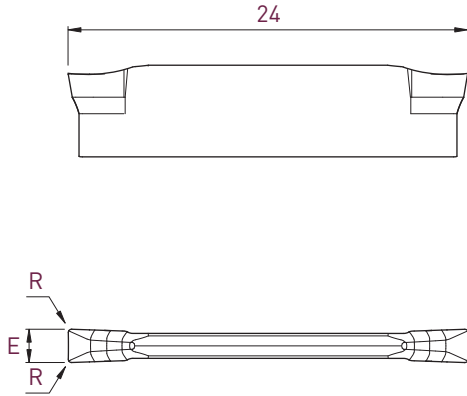
EVOCUT-LINE


Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

JN Series



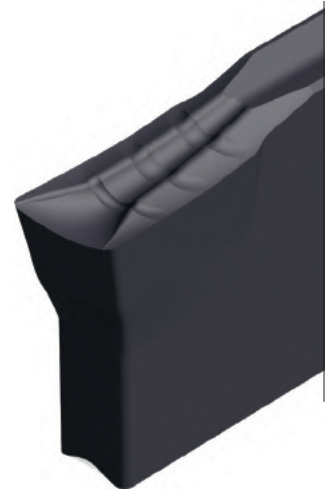
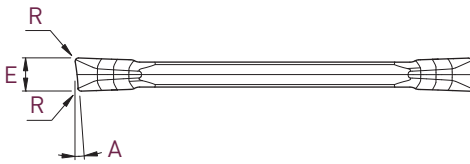
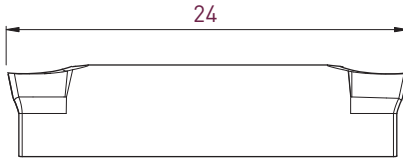
			JN																				
																							
Type	E ±0.05	R	Art. N°	<table border="1"> <tr> <td>P</td><td>P</td><td>P</td><td>P</td> </tr> <tr> <td>M</td><td>M</td><td>M</td><td>M</td> </tr> <tr> <td>N</td><td></td><td></td><td></td> </tr> <tr> <td>G</td><td></td><td></td><td></td> </tr> </table>	P	P	P	P	M	M	M	M	N				G				Tmax	Zmax	ZTi6
P	P	P	P																				
M	M	M	M																				
N																							
G																							
				TiAlN																			
ET15	1.5	0.2	ET15-JN-002	■	■	■																	
ET20	2.0	0.2	ET20-JN-002	■	■	■	■																
ET25	2.5	0.3	ET25-JN-003	■	■	■	■																
ET30	3.0	0.3	ET30-JN-003	■	■	■	■																

Plaquettes de tronçonnage

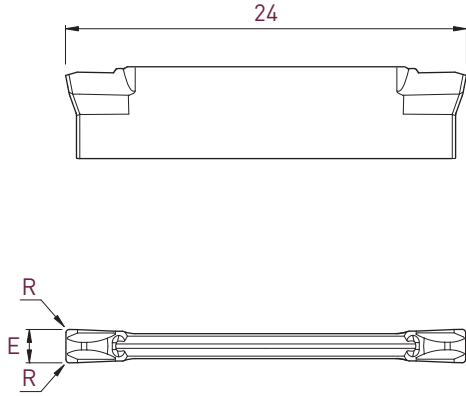
Abstechwendeplatten


Cut off inserts

JR Series



				JR			
Type	E ± 0.05	A	R	Art. N°	TiAlN	Tmax	Zmax
ET15	1.5	6°	0.2	ET15-JR-602	■	■	■
ET20	2.0	6°	0.2	ET20-JR-602	■	■	■
ET25	2.5	6°	0.2	ET25-JR-602	■	■	■
ET30	3.0	6°	0.3	ET30-JR-603	■	■	■



			TN 				
Type	E ±0.05	R	Art. N°	TiAlN <input type="checkbox"/>	Tmax <input type="checkbox"/>	Zmax <input type="checkbox"/>	ZTi6 <input type="checkbox"/>
ET20	2.0	0.2	ET20-TN-002	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET25	2.5	0.3	ET25-TN-003	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET30	3.0	0.3	ET30-TN-003	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

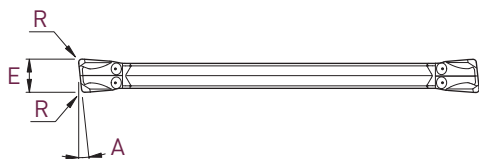
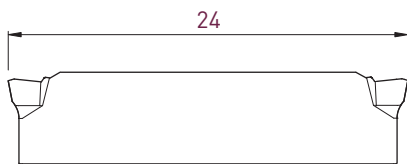
Plaquettes de tronçonnage


Abstechwendeplatten

Cut off inserts

Negative geometry

TR Series

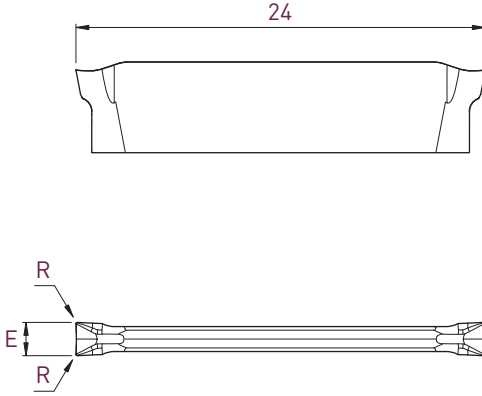



				TR																	
Type	E ±0.05	A	R	Art. N°	<table border="1"> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> </table>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
ET20	2.0	6°	0.2	ET20-TR-602	<table border="1"> <tr> <td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> </table>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
ET25	2.5	6°	0.2	ET25-TR-602	<table border="1"> <tr> <td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> </table>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
ET30	3.0	6°	0.3	ET30-TR-603	<table border="1"> <tr> <td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td><td><input checked="" type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> <tr> <td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td><td><input type="checkbox"/></td> </tr> </table>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>																		

EVOCUT-LINE

- Plaquettes de tronçonnage
- Abstechwendeplatten
- Cut off inserts

AN Series



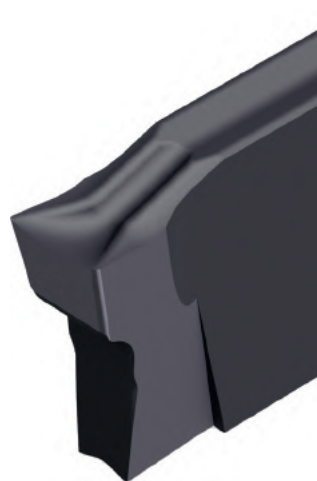
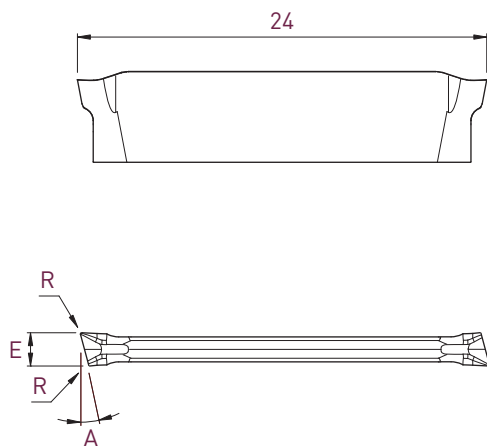
				AN 		
Type	E ± 0.05	R	Art. N°	TIALN	A5	N
ET20	2.0	0.2	ET20-AN-002F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ET30	3.0	0.3	ET30-AN-003F	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Plaquettes de tronçonnage

Abstechwendeplatten

Cut off inserts

AR Series












				AR			
Type	E ± 0.05	A	R	Art. N°	TiAIN	AS	N
ET20	2.0	15°	0.1	ET20-AR-1501F	■	■	■
ET30	3.0	15°	0.2	ET30-AR-1502F	■	■	■

EVOCUT-LINE

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

						P Acier Stahl Steel						M Inox Rostfreistahl Stainless steel					
		ET15		ET20		ET25		ET30		Acier de décolletage Automatenstahl Free-cutting steel		Acier faiblement allié Leicht legierter Stahl Low alloyed steel		Acier fortement allié Legierter Stahl High alloyed steel		Austenitique et martensitique Austenitisch und martensitische Austenitic and martensitic	
		VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)				
Avance standard Standard Vorschub Standard feed rate	UN 	TiAlN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08			
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08			
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10			
		ZTi6	■	■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08			
	UR 	TiAlN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08			
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08			
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10			
		ZTi6	■	■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08			
	JN 	TiAlN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08			
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08			
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10			
		ZTi6	■	■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08			
	JR 	TiAlN	■	■	■	■	90-140	0.04-0.08	60-120	0.04-0.08	50-100	0.04-0.08	50-120	0.04-0.08			
		Tmax	■	■	■	■	100-170	0.04-0.08	70-150	0.04-0.08	60-120	0.04-0.08	60-150	0.04-0.08			
		Zmax	■	■	■	■	80-130*	0.04-0.10	50-110*	0.04-0.10	50-90*	0.04-0.10	50-120*	0.04-0.10			
		ZTi6	■	■	■	■	110-200	0.04-0.08	80-160	0.04-0.08	70-140	0.04-0.08	70-160	0.04-0.08			
	TN 	TiAlN	■	■	■	■	90-150	0.08-0.18	70-130	0.08-0.18	50-100	0.08-0.15	50-120	0.08-0.20			
		Tmax	■	■	■	■	100-170	0.08-0.18	70-150	0.08-0.18	60-120	0.08-0.15	60-150	0.08-0.20			
		Zmax	■	■	■	■	80-130*	0.08-0.18	50-110*	0.08-0.18	50-90*	0.08-0.15	50-120*	0.08-0.20			
		ZTi6	■	■	■	■	110-200	0.08-0.18	80-160	0.08-0.18	70-140	0.08-0.15	70-160	0.08-0.20			
	TR 	TiAlN	■	■	■	■	90-150	0.08-0.18	70-130	0.08-0.18	50-100	0.08-0.15	50-120	0.08-0.20			
		Tmax	■	■	■	■	100-170	0.08-0.18	70-150	0.08-0.18	60-120	0.08-0.15	60-150	0.08-0.20			
		Zmax	■	■	■	■	80-130*	0.08-0.18	50-110*	0.08-0.18	50-90*	0.08-0.15	50-120*	0.08-0.20			
		ZTi6	■	■	■	■	110-200	0.08-0.18	80-160	0.08-0.18	70-140	0.08-0.15	70-160	0.08-0.20			
Avance modérée Niedriger Vorschub Low feed rate	UN-000F 	TiAlN	■	■	■	■	80-120	0.02-0.05	50-100	0.02-0.05	40-80	0.02-0.05	40-100	0.02-0.05			
		UR/ULF	TiAlN	■	■	■	■	80-120	0.02-0.05	50-100	0.02-0.05	40-80	0.02-0.05	40-100	0.02-0.05		
	ANF 	N	■	■	■	■											
		TiAlN	■	■	■	■							40-80	0.02-0.05			
	ARF 	N	■	■	■	■											
		TiAlN	■	■	■	■							40-80	0.02-0.05			
		AS	■	■	■	■											

* premier choix en cas de coupe interrompue

** arête de coupe vive

* beste Basis für unterbrochene Schnitte

** scharfe Schneidkante

* first choice for interrupted cut

** sharp cutting edge

N Alliage d'aluminium et non ferreux Aluminium- und Nichteisenlegierungen Aluminium and non-ferrous alloys								S Titane Titan Titanium			
Aluminium		Alu silicium max. 5% Aluminiumsilicium max. 5% Aluminium silicon max. 5%		Cuivre Kupfer Copper		Laiton & bronze Messing & Bronze Brass & bronze		Gr. 1 - 3		Gr. 4 - 5	
VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)	VC (m/min)	F (mm/U)
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
100-250	0.03-0.10	100-250	0.03-0.10	100-300	0.03-0.10	100-300	0.03-0.10			50-100	0.04-0.08
						150-300	0.05-0.20				
						150-300	0.05-0.20				
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06			50-100	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06			50-100	0.01-0.06
80-200	0.02-0.06			80-200	0.01-0.05	80-200	0.02-0.06	50-100	0.01-0.06	50-100	0.01-0.06
100-250	0.02-0.06	80-150	0.01-0.05	100-200	0.01-0.05	80-200	0.02-0.06			30-80	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06	50-120	0.01-0.06	50-120	0.01-0.06
80-200	0.02-0.06			80-200	0.01-0.05	80-200	0.02-0.06	50-100	0.01-0.06	50-100	0.01-0.06
100-250	0.02-0.06	80-150	0.01-0.05	100-200	0.01-0.05	80-200	0.02-0.06			30-80	0.01-0.06
100-300	0.02-0.06	100-200	0.01-0.05	100-250	0.01-0.05	100-300	0.02-0.06	50-120	0.01-0.06	50-120	0.01-0.06

