PRECITOOL

FRAISES CIRCULAIRES EN METAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

OUTILS DE DECOLLETAGE
WERKZEUGE FÜR DREHAUTOMATE
TOOLS FOR AUTOMATIC LATHES

PRECITOOL SA

56, rue de Soleure
CH-2740 MOUTIER
SWITZERLAND

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Fax ++ 41 32 494 64 77

E-mail: info@precitool.c
Adresse: www.precitool.c

PRECITOOL SA

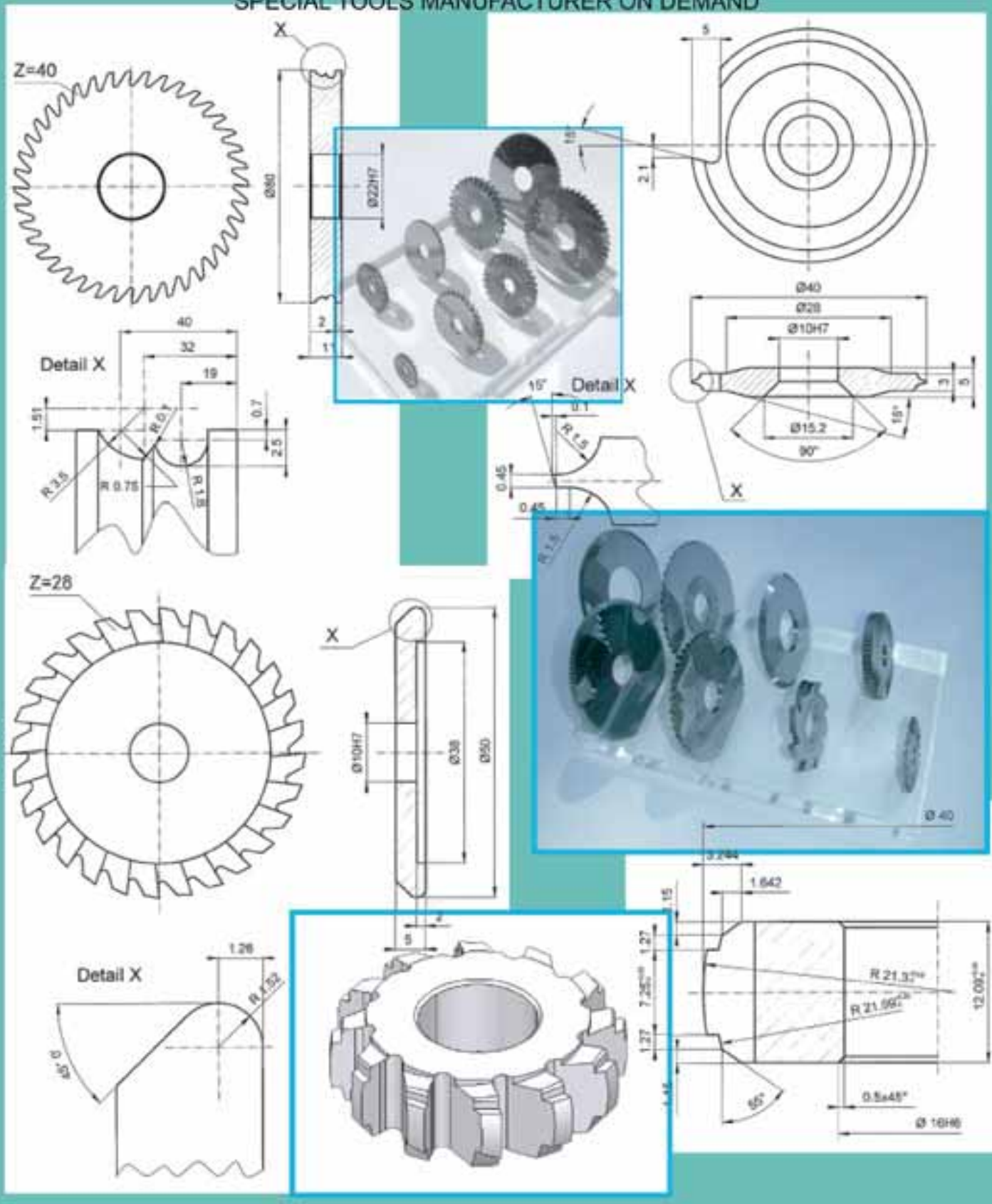
56, rue de Soleure CH 2740 MOUTIER

Fabricant d'outillage carbure depuis 1969
Vollhartmetallwerkzeug - Hersteller seit 1969
Manufacturer carbide cutting tools since 1969

FABRICANT D'OUTILS SPECIAUX SUR DEMANDE

HERSTELLER VON SPEZIAL WERKZEUG AUF ANFRAGE

SPECIAL TOOLS MANUFACTURER ON DEMAND



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FRAISES CIRCULAIRES EN MÉTAL DUR
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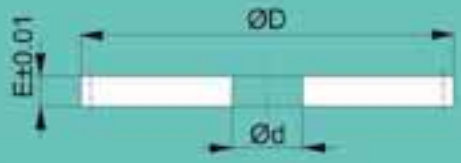
SOLID CARBIDE SLITTING SAWS

DIN 1837 Denture fine
DIN 1837 Feine Verzahnung
DIN 1837 Fine teeth

Type 101



D js15 [mm]	15	20	25	30	40	50	63	80	100	125	150	160	200
d H7 [mm]	5		8		10	13	16	22			32		
E [mm]	Nombre de dents / Anzahl Zähne / Number of teeth												
0.1	64	80	80	100	128	128							
0.15	64	80	80	100	128	128							
0.2	64	80	80	100	128	128	160						
0.25	64	64	80	100	100	128	160						
0.3	64	64	80	80	100	128	128						
0.35	64	64	64	80	100	100	128						
0.4	64	64	64	80	100	100	128	160					
0.5	48	48	64	80	80	100	128	128	160				
0.6	48	48	64	64	80	100	100	128	160	160			
0.7	48	48	48	64	80	80	100	128	128	160			
0.8	40	48	48	64	80	80	100	128	128	160			
0.9	40	40	48	64	64	80	100	100	128	160			
1	40	40	48	64	64	80	100	100	128	160	150	160	
1.1	40	40	48	64	64	80	80	100	128	128			
1.2	40	40	48	48	64	80	80	100	128	128	150	160	
1.3	40	40	40	48	64	64	80	100	100	128			
1.4	40	40	40	48	64	64	80	100	100	128			
1.5	40	40	40	48	64	64	80	100	100	128	150	160	160
1.6	40	40	40	48	64	64	80	100	100	128	150	160	160
1.7	40	40	40	48	48	64	80	80	100	128			
1.8	40	32	40	48	48	64	80	80	100	128			
1.9	40	32	40	48	48	64	80	80	100	128			
2	40	32	40	48	48	64	80	80	100	128	128	128	160
2.5	40	32	40	40	48	64	64	80	100	100	128	128	160
3	40	32	32	40	48	48	64	80	80	100	128	128	128
3.5	24	24	32	40	48	48	64	64	80	100			
4	24	24	32	40	40	48	64	64	80	100	128	100	128
4.5	24	24	32	32	40	48	64	64	80	100			
5	24	24	32	32	40	48	48	64	80	80			
5.5	24	24	24	32	40	40	48	64	64	80			
6	24	24	24	32	40	40	48	64	64	80			

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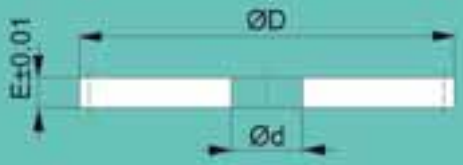
FRAISES CIRCULAIRES EN MÉTAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

DIN 1838 Denture grossière
DIN 1838 Grobe Verzahnung
DIN 1838 Large teeth

Type 102



D js15 [mm]	15	20	25	30	40	50	63	80	100	125
d H7 [mm]	5		8		10	13	16	22		
E [mm]	Nombre de dents / Anzahl Zähne / Number of teeth									
0.2	20	20	20	30	40	48				
0.25	20	20	20	30	40	48				
0.3	20	20	20	30	40	48	64	64		
0.35	20	20	20	30	40	48	64	64		
0.4	20	20	20	30	40	48	64	64		
0.5	20	20	20	30	40	48	64	64	80	
0.6	20	20	20	30	40	48	48	64	80	
0.7	20	20	20	30	40	40	48	64	80	
0.8	20	20	20	24	32	40	48	64	64	80
0.9	20	20	20	24	32	40	48	48	64	80
1	20	20	20	24	32	40	48	48	64	80
1.1	20	20	20	24	32	40	40	48	64	64
1.2	20	20	20	24	32	40	40	48	64	64
1.3	20	20	20	24	32	32	40	48	48	64
1.4	20	20	20	24	32	32	40	48	48	64
1.5	20	20	20	24	32	32	40	48	48	64
1.6	20	20	20	24	32	32	40	48	48	64
1.7	20	20	20	24	32	32	40	40	48	64
1.8	20	20	20	24	32	32	40	40	48	64
1.9	20	20	20	24	32	32	40	40	48	64
2	20	20	20	24	32	32	40	40	48	64
2.5	20	20	20	24	32	32	32	40	48	48
3	20	20	20	24	32	24	32	40	40	48
3.5	20	20	20	24	32	24	32	32	40	48
4	20	20	20	24	32	24	32	32	40	48
4.5	20	20	20	24	32	24	32	32	40	40
5	20	20	20	24	32	24	24	32	40	40
5.5	20	20	20	24	32	20	24	32	32	40
6	20	20	20	24	32	20	24	32	32	40

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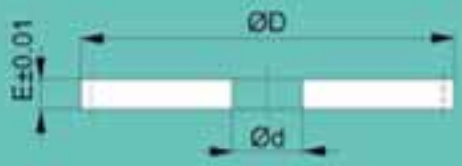
FRAISES CIRCULAIRES EN MÉTAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

Type 103

Denture hélicoïdale
Schrägverzahnung
Helical teeth

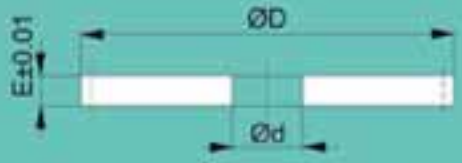


D js15 [mm]	30	40	50	63	80
d H7 [mm]	8	10	13	16	22
E [mm]	Nombre de dents		Anzahl Zähne		Number of teeth
1 - 6	20	24	30	40	50

FRAISES CIRCULAIRES EN MÉTAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

Type 104

3 tailles
3-Seitig schneidend
3 cuts



D js15 [mm]	20	25	30	40	50	63	80
d H7 [mm]	5	8		10	13	16	22
E [mm]	Nombre de dents			Anzahl Zähne		Number of teeth	
2	12	20	24	30	40	50	60
3	12	12	24	20	40	50	50
4	12	12	30	20	30	30	50

Autres dimensions sur demande Andere Abmessungen auf Anfrage Other dimensions on demand

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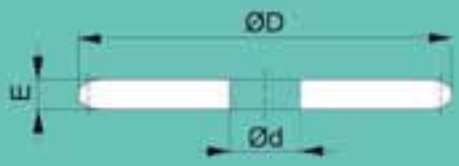
FRAISES CIRCULAIRES EN MÉTAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

Type **105**

A rayon convexe
Mit Konvex Radius
With convex radius

Denture **B** pour matières à copeaux longs
Verzahnung **B** für langspanende Werkstoffe
Teeth **B** for matérial with long chips



D js15 [mm]	20	25	30	40	50	63
d H7 [mm]	5	8		10	13	16
E [mm]	Nombre de dents / Anzahl Zähne / Number of teeth					
0.8	30	30	30			
1.0	30	30	30	24	30	
1.5	30	30	30			
2.0	30	24	30	24	30	40
2.5	20	24	30			
3.0	20	24	30	24	30	40
4.0				24	30	40
5.0				20	24	30
6.0				20	24	30

Autres dimensions sur demande — Andere Abmessungen auf Anfrage — Other dimensions on demand

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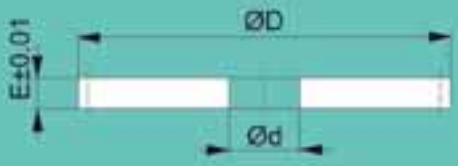
FRAISES CIRCULAIRES EN MÉTAL DUR
VOLLHARTMETALL-KREISSÄGEBLÄTTER
SOLID CARBIDE SLITTING SAWS

DIN 1837 Denture extra-fine
DIN 1837 Extrafeine Verzahnung
DIN 1837 Extrafine teeth

Type 110



D js15 [mm]	15	20	25		30	35	40		45	50		63	80
d H7 [mm]	5		8				10	8	10	13		16	
E [mm]	Nombre de dents / Anzahl Zähne / Number of teeth												
0.1	80	100	100	120	120								
0.15	80	100	100	120	120								
0.2	80	100	100	120	120	120	160	160	160	160	160		
0.25	80	100	100	120	120	120	160	160	160	160	160		
0.3	80	100	100	120	120	120	160	160	160	160	160		
0.35	80	100	100	120	120	120	160	160	160	160	160		
0.4	80	100	100	120	120	120	160	160	160	160	160		
0.5	80	80	80	100	100	100	160	120	120	120	120		
0.6	80	80	80	100	100	100	160	120	120	120	120		
0.7	80	80	80	100	100	100	160	120	120	120	120		
0.8	80	80	80	100	100	100	160	120	120	120	120		
0.9	80	80	80	100	100	100	160	120	120	120	120		
1	80	80	80	100	100	100	160	120	120	120	120		
1.1	80	80	80	100	100	100	160	120	120	120	120		
1.2	80	80	80	100	100	100	160	120	120	120	120		
1.4	80	80	80	100	100	100	160	120	120	120	120		
1.5	80	80	80	100	100	100	160	120	120	120	120		
2	80	80	80	100	100	100	160	120	120	120	120		
2.5	SUR DEMANDE / AUF ANFRAGE / ON DEMAND												
3													
3.5													
4													
4.5													
5													
5.5													
6													

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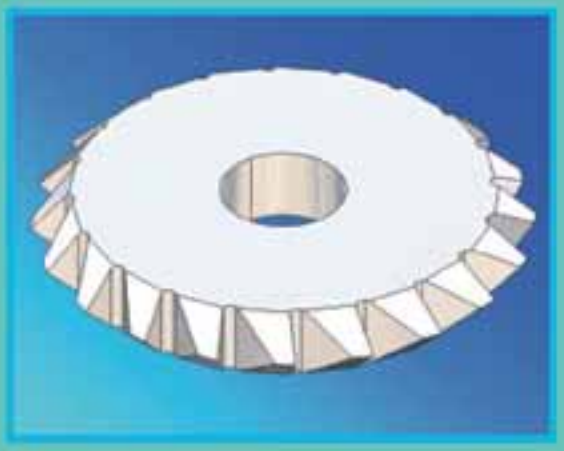
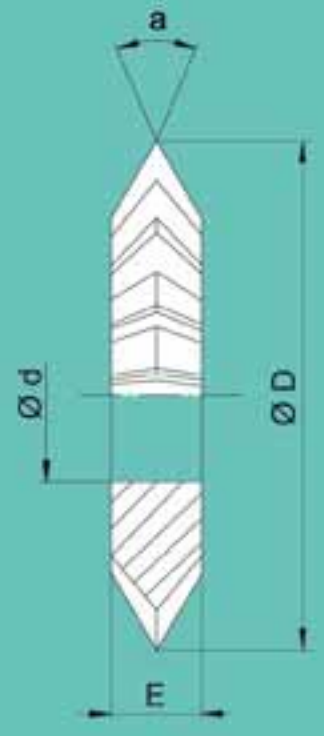
FRAISES ISOCELES EN MÉTAL DUR
VOLLHARTMETALL-PRISMENFRÄSER
SOLID CARBIDE BICONAL CUTTERS



Type **130**	Type **131**	Type **132**
60°	90°	120°

ØD [mm]	E [mm]	Ød2 [mm]	Z
20	1.0	5.0	20
20	1.5	5.0	20
20	2.0	5.0	20
25	1.0	8.0	20
25	1.5	8.0	20
25	2.0	8.0	20
30	2.0	8.0	24
30	2.5	8.0	24
30	3.0	8.0	24
40	2.0	10.0	32
40	3.0	10.0	32
40	4.0	10.0	32
50	3.0	13.0	32
50	4.0	13.0	32
63	4.0	16.0	40
63	5.0	16.0	40



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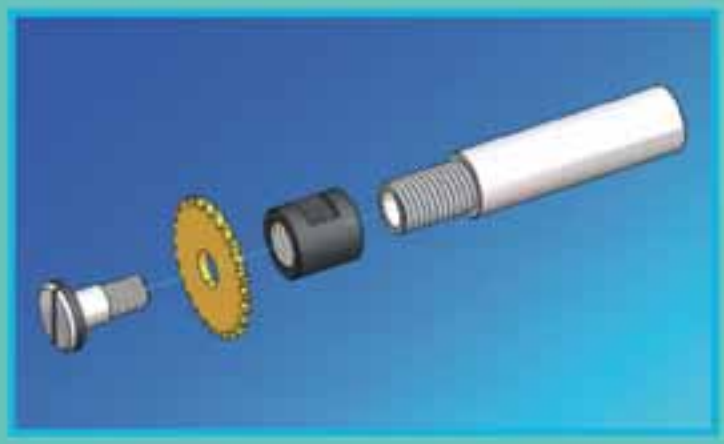
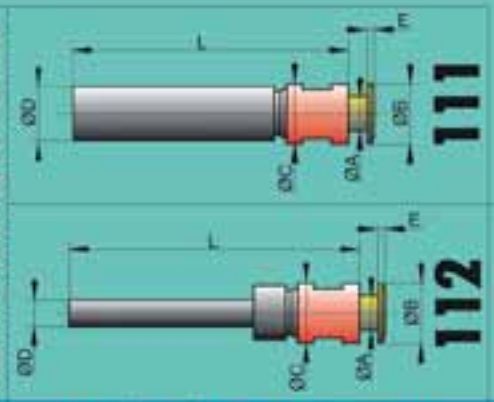
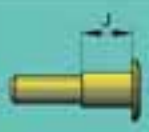
MANDRINS PORTE FRAISE-SCIE
KREISSÄGENFUTTER
COLLETS FOR SLITTING SAWS

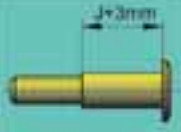
Type 111 & 112





Dimensions en [mm]
Masse in [mm]
Dimension in [mm]





POUR FRAISE ALÉSAGE FÜR KREISSÄGEN BOHRUNG FOR SLITTING SAWS BORE ØA	J	Ø DE QUEUE DU MANDRIN FUTTER SCHAFT DURCHMESSER SHANK DIAMETER FOR COLLET ØD	L	E	ØB; ØC	réf.	Ecrou	Vis	Vis+3
5	7	6	50	3	9	*112 5 6	111 01 5	111 02 5	111 03 5
			60		10	112 5			
		7				*112 5 7			
		10				111 5			
8	8	6			15	112 8	111 01 8	111 02 8	111 03 8
		7				*112 8 7			
		10				*112 8 10			
		13	65			*112 8 13			
		14				111 8			
10	8	6	60		17	112 10	111 01 10	111 02 10	111 03 10
		7				*112 10 7			
		10				*112 1010			
		13	70			*112 1013			
		16				111 10			
13	14	10	60	4	20	112 13	111 01 13	111 02 13	111 03 13
		16	70			*112 1316			
		18	80			111 13			
16	19	10	60		24	*112 1610	111 01 16	111 02 16	111 03 16
		16	70			112 16			
		20	90			111 16			
22	20			5	32	*111 22	111 01 22	111 02 22	111 03 22

*Disponible uniquement sur demande Lieferbar nur auf Anfrage Delivered only on Request

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PARAMÈTRES DE COUPE INDICATIFS POUR FRAISES CIRCULAIRES
EMPFOHLENE SCHNITTWERTE FÜR KREISSÄGEBLÄTTER
STANDARD MACHINING DATA FOR SLITTING SAWS

Matériaux / Werkstoffe / Materials	N / mm2	Diamètre des fraises / Kreissägen Durchmesser / Slitting Saws diam. Vc:m/min	Ø 15-30 fz:mm	Ø 30-50 fz:mm	Ø 50-80 fz:mm	Ø 80-125 fz:mm	Ø125-160 fz:mm
Acier décolletage	~500	120-200	.002-.006	.003-.007	.005-.010	.005-.010	.003-.012
Automatenstahl	~500	100-180	.002-.004	.003-.007	.003-.008	.003-.012	.003-.012
Free-cutting steel							
* Acier non allié							
* Acier faiblement allié	~750	50-80	.001-.004	.002-.006	.002-.008	.003-.010	.003-.012
Acier fortement allié	~1000	20-80	.001-.003	.002-.004	.002-.006	.003-.008	.003-.010
* Acier Acier fritté	~750	50-120	.001-.003	.002-.004	.002-.006	.003-.008	.003-.010
Acier Inox	~1000	50-100	.001-.003	.002-.005	.002-.008	.003-.010	.003-.012
Rostfreier Stahl							
Stainless steel							
Acier Inox réfract.	~1000	30-60	.001-.003	.002-.005	.002-.008	.003-.010	.003-.012
Titane / *Titan* / Titanium	~750	20-70	.001-.004	.002-.005	.002-.008	.003-.010	.003-.012
Laiton - Bronze	~500	100-300	.003-.007	.004-.008	.005-.010	.005-.010	.004-.012
Cuivre / *Kupfer* / Copper	~500	100-300	.003-.006	.003-.008	.004-.010	.004-.010	.004-.012
Bronze à l'alum. - Cuivre (CuAlFe)	~500	150-300	.001-.003	.002-.005	.002-.007	.003-.008	.003-.010
Aluminium alliage		150-400	.003-.006	.004-.007	.004-.008	.005-.010	.003-.012
Aluminium Si <12%		200-500	.003-.007	.004-.008	.004-.010	.005-.010	.005-.012
Aluminium Si >12%		150-400	.003-.007	.004-.008	.004-.010	.005-.010	.005-.012
Fonte / *Gusseisen* / cast iron	~750	50-120	.001-.004	.002-.005	.002-.008	.003-.010	.003-.012
Fonte graphite sphér.perlitique	<250HB	80-140	.002-.004	.002-.007	.003-.010	.004-.010	.004-.010
Fonte graphite sphér.perlitique	>250HB	50-80	.001-.004	.002-.005	.002-.006	.003-.010	.003-.012
Fonte mallé., graph.,sphér.ferrit.	>250HB	50-80	.002-.004	.003-.007	.004-.008	.004-.010	.004-.012
Or, argent / *Gold, Silber* / Gold, silver		130-180	.002-.006	.004-.008	.004-.010	.005-.010	.005-.012
Alliages spéciaux Inconel Nimonic Hasteloy		20-30	.001-.003	.002-.005	.002-.008	.002-.010	.003-.012
Magnésium alliage		150-400	.003-.006	.004-.007	.004-.010	.005-.010	.005-.012
Plastique / *Kunststoff* / Plastic		120-200	.003-.010	.004-.010	.005-.012	.003-.012	.005-.015

Valeurs indicatives: à interpréter selon caractéristiques de la machine, serrages de la matière et porte-outils, fluide d'arrosage, etc...
Richtwerte: Nach Eigenschaften der Maschine zu interpretieren; Festklemmen von Material und Werkzeughalter; Kühlflüssigkeit; usw...
Approximate values: Depending on the machine charateristics; Material and tool clamping device; Cooling liquid; etc...

* **Acier** / ***Stahl*** / Steel **Laiton** / ***Messing*** / brass

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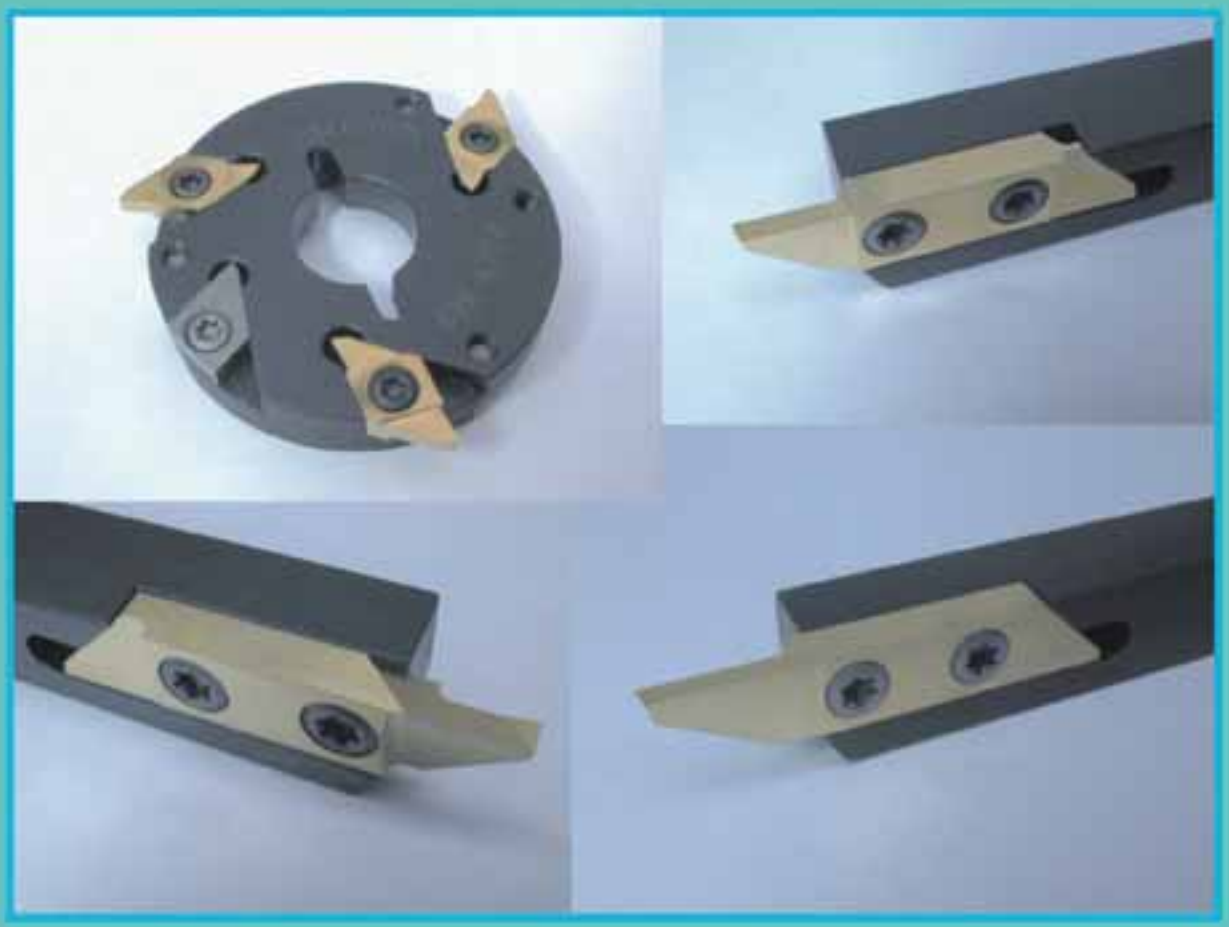
PRECITOOL

PLAQUETTES CARBURE
- Utilisables: 2 côtés
- Réaffûtables
- Fixations: gauche et droite
- Standards ou selon dessin
- Revêtements : Non revêtues. TiN, TiCN, FUTURA
- Sur demande: formes et revêtements particuliers.

VHM PLATTEN
- Benutzung: beidseitig
- Nachschleifbar
- Fixierung: links und rechts
- Standard oder nach Zeichnung
- Beschichtung : Unbeschichtet TiN, TiCN, FUTURA
- Auf Anfrage: Formen und besondere Beschichtung.

CARBIDE INSERT
- Usable: both sides
- Regrindable
- Fixations: left and right
- Standard or after drawing
- Coated : Without coating TiN, TiCN, FUTURA
- On demand: Forms and special coating

DECO



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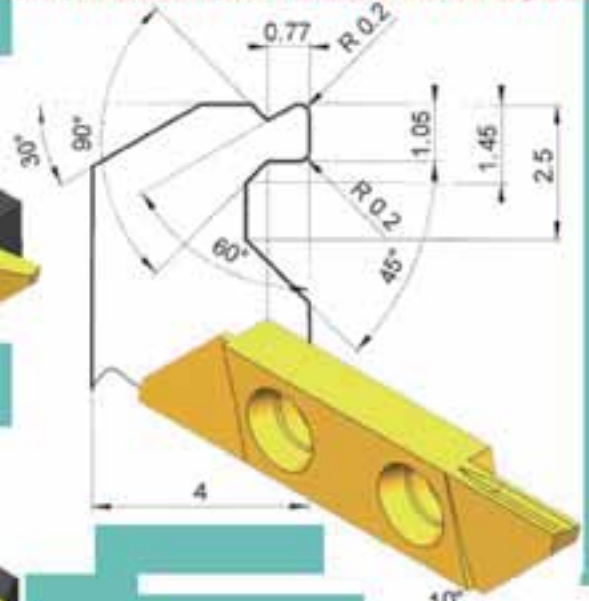
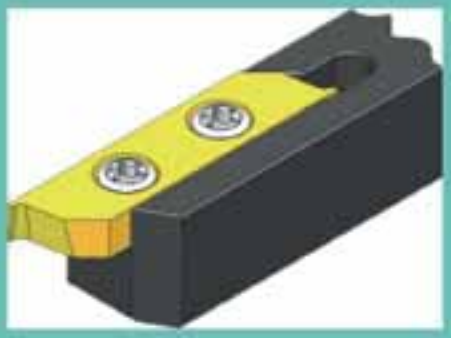
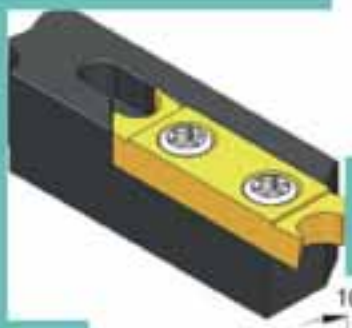
Vollhartmetallwerkzeug - Hersteller seit 1969
Manufacturer carbide cutting tools since 1969

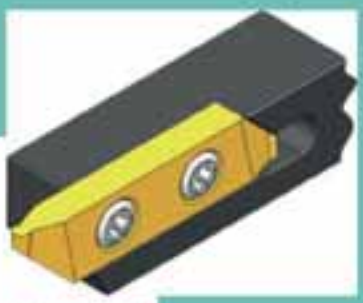
REALISATION DE PLAQUETTES SPECIALES SELON DESSIN
FORMPLATTEN NACH ZEICHNUNG
SPECIAL FORM INSERTS TO DRAWING

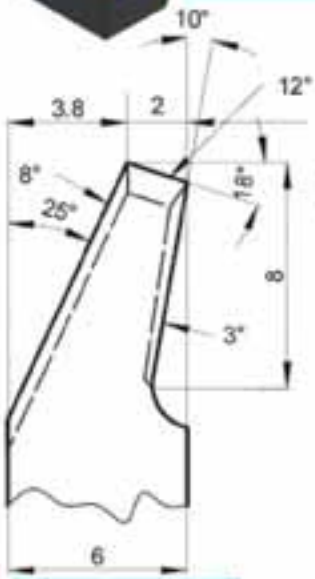
Sur base / Fundiert auf / Based on : 615; 630; 671; 715; 815

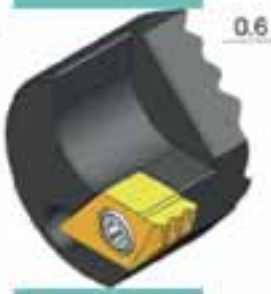


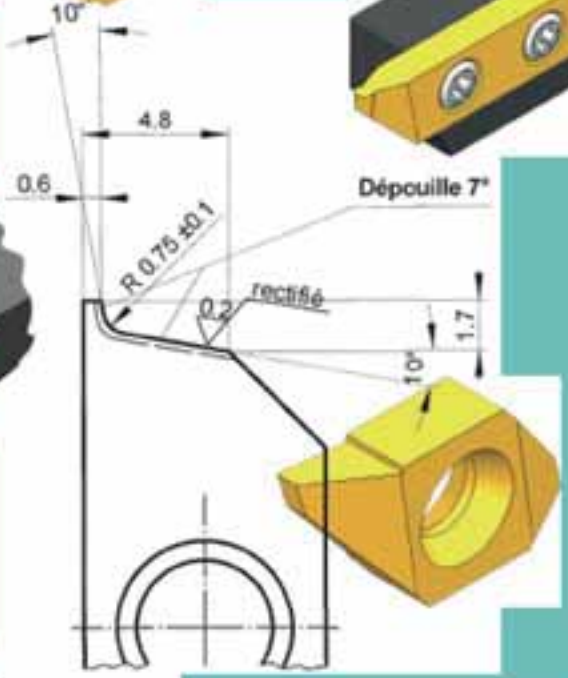












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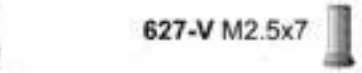
PORTE-PLAQUETTES
KLEMMHALTER
INSERTHOLDERS

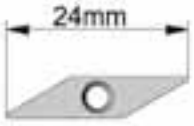
PLAQUETTES
PLÄTTCHEN
INSERTS

L / R

515

507L/R 7x7x150mm
508L/R 8x8x150mm
510 100L/R 10x10x100mm
510 150L/R 10X10x150mm
512 100L/R 12x12x100mm
512 150L/R 12x12x150mm
514 100L/R 14x14x100mm
516 100L/R 16x16x100mm
520 100L/R 20x20x100mm

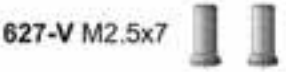


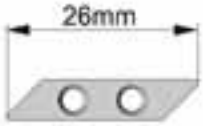


E= 3mm

630

608L/R 7x7x150mm
609L/R 8x8x150mm
609 10L/R 10x10x150mm
609 12L/R 12x12x150mm
609 20L/R 20x20x150mm





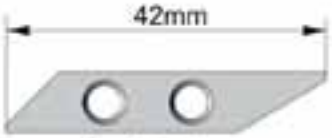
E= 3mm

615

610 L/R 10x10x100mm
611 L/R 10X10x150mm
612 L/R 12x12x100mm
613 L/R 12x12x150mm
614 L/R 14x14x150mm
622 L/R 16x16x100/140mm
623 L/R 20x20x100/140mm

E= 4mm / 6mm

715



E= 4mm

815

800 L/R 16x16x140mm
801 L/R 20X20x140mm
802 L/R 25x25x140mm

E= 4.1mm

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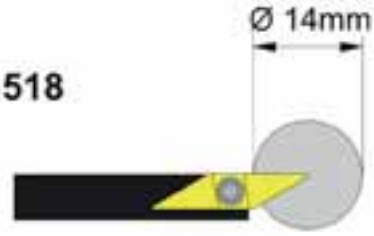
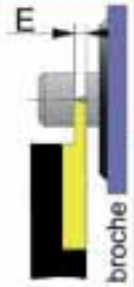
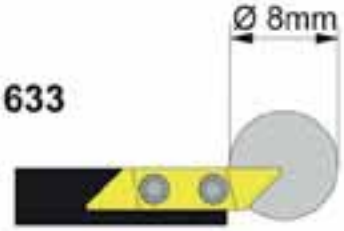
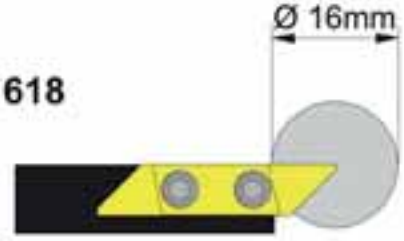
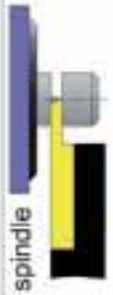
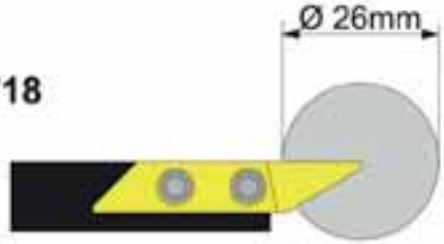
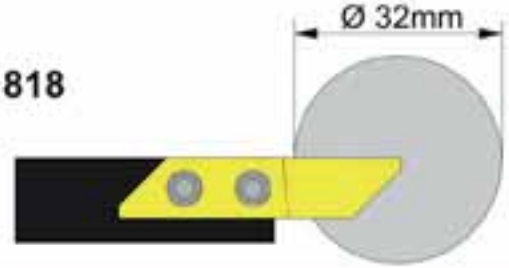
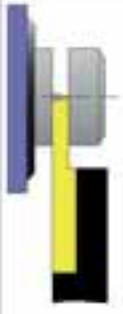
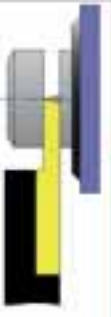
TRONCONNAGE ABSTECHEN CUT OFF

Type Typ Type	R	E [mm] Revêtement Beschichtung Coated	L	
518 		E= 1.0 1.5 2.0 2.5 ~Ø= 10 12 12 14 Non revêtue FUTURA		515
633 		E= 0.8 1.0 1.2 1.5 1.8 2.0 ~Ø= 6 6 6 8 8 8 Non revêtue TiN TiCN FUTURA		630
618 		E= 0.8 1.0 1.2 1.5 1.8 ~Ø= 10 10 10 14 14 E= 2.0 2.2 2.5 3.0 ~Ø= 16 16 16 16 Non revêtue TiN TiCN FUTURA		615
718 		E= 2.0 2.5 3.0 ~Ø= 22 26 26 Non revêtue TiN TiCN FUTURA		715
818 		E= 3.0 3.5 4.0 ~Ø= 32 32 32 Non revêtue TiN TiCN FUTURA		815

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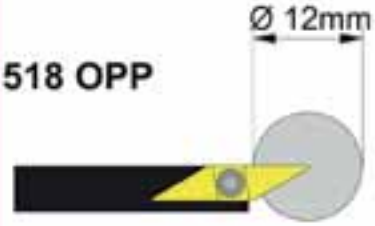
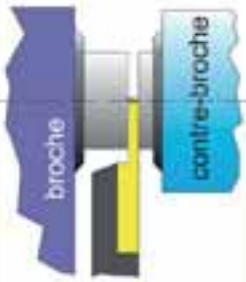
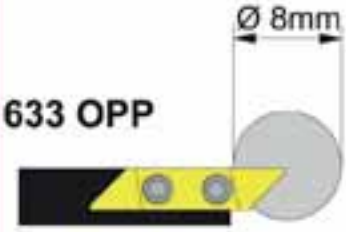
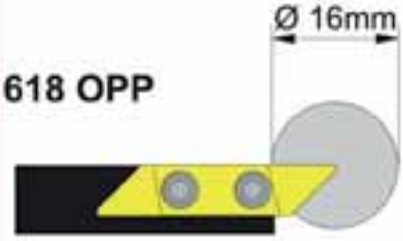
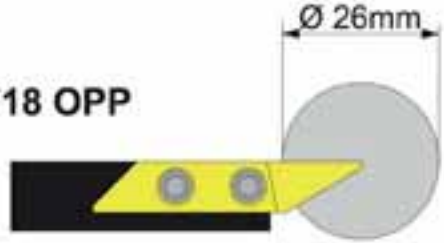
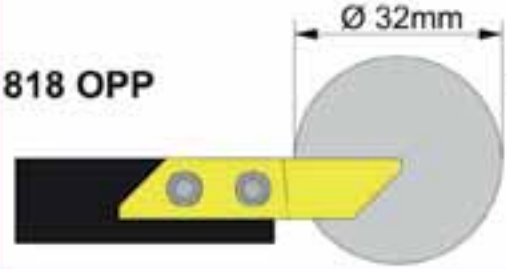
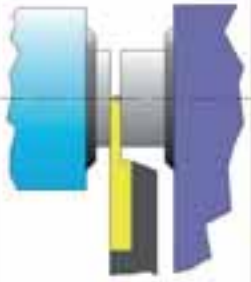
TRONCONNAGE ABSTECHEN CUT OFF "OPPOSEES"

Type Typ Type	R opp.	E [mm] Revêtement Beschichtung Coated	L opp.	
518 OPP 		E= 1.0 1.5 2.0 ~Ø= 10 12 12 Non revêtue FUTURA		515
633 OPP 		E= 1.0 1.5 2.0 ~Ø= 6 8 8 Non revêtue TiN TiCN FUTURA		630
618 OPP 		E= 1.5 2.0 ~Ø= 14 16 Non revêtue TiN TiCN FUTURA		615
718 OPP 		E= 2.0 2.5 3.0 ~Ø= 22 26 26 Non revêtue TiN TiCN FUTURA		715
818 OPP 		E= 3.0 3.5 ~Ø= 32 32 Non revêtue TiN TiCN FUTURA		815

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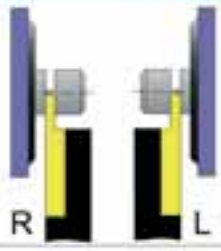
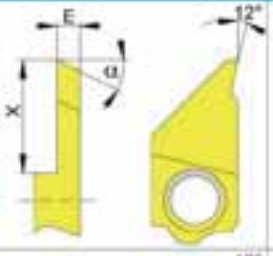
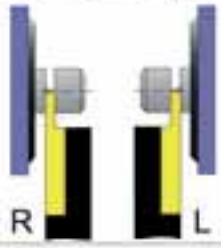
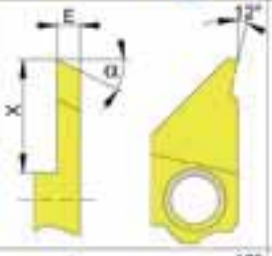
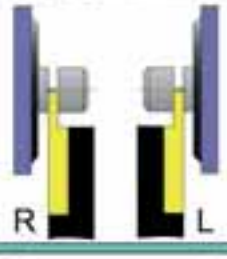
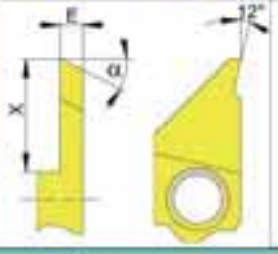
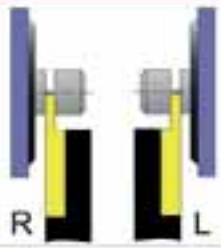
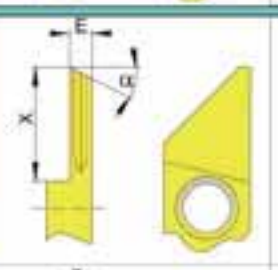
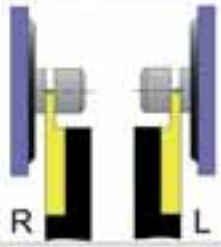
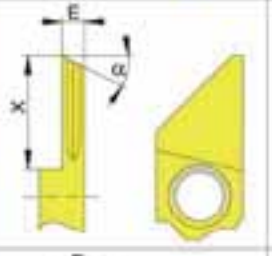
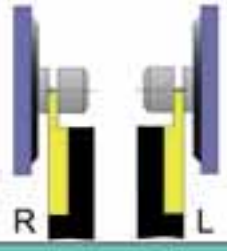
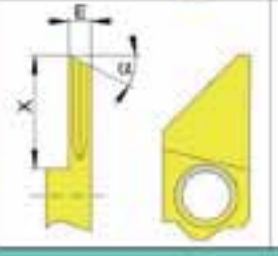
TRONCONNAGE BC et RC ABSTECHEN BC und RC CUT OFF BC and RC

Forme Form Form		Usage Anwendung Application	Type Typ Type	E X [mm]	Revêtement Beschichtung Coated	
		Tronçonnage Abstechen Part off	618L BC 618R BC	E= 1.5 2.0 2.5 X= 7 8 8 α= 18° 12° 12°	Non revêtue TiN TiCN FUTURA	615
		Tronçonnage Abstechen Part off	718L BC 718R BC	E= 2.5 3.0 X= 13 13 α= 12° 12°	Non revêtue TiN TiCN FUTURA	715
		Tronçonnage Abstechen Part off	818L BC 818R BC	E= 3.0 3.5 X= 16 16 α= 12° 12°	Non revêtue TiN TiCN FUTURA	815
		Tronçonnage Abstechen Part off	618L RC 618R RC	E= 1.5 2.0 2.5 X= 7 8 8 α= 18° 12° 12°	Non revêtue TiN TiCN FUTURA	615
		Tronçonnage Abstechen Part off	718L RC 718R RC	E= 2.5 3.0 X= 13 13 α= 12° 12°	Non revêtue TiN TiCN FUTURA	715
		Tronçonnage Abstechen Part off	818L RC 818R RC	E= 3.0 3.5 X= 16 16 α= 12° 12°	Non revêtue TiN TiCN FUTURA	815

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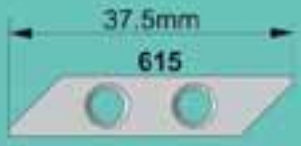
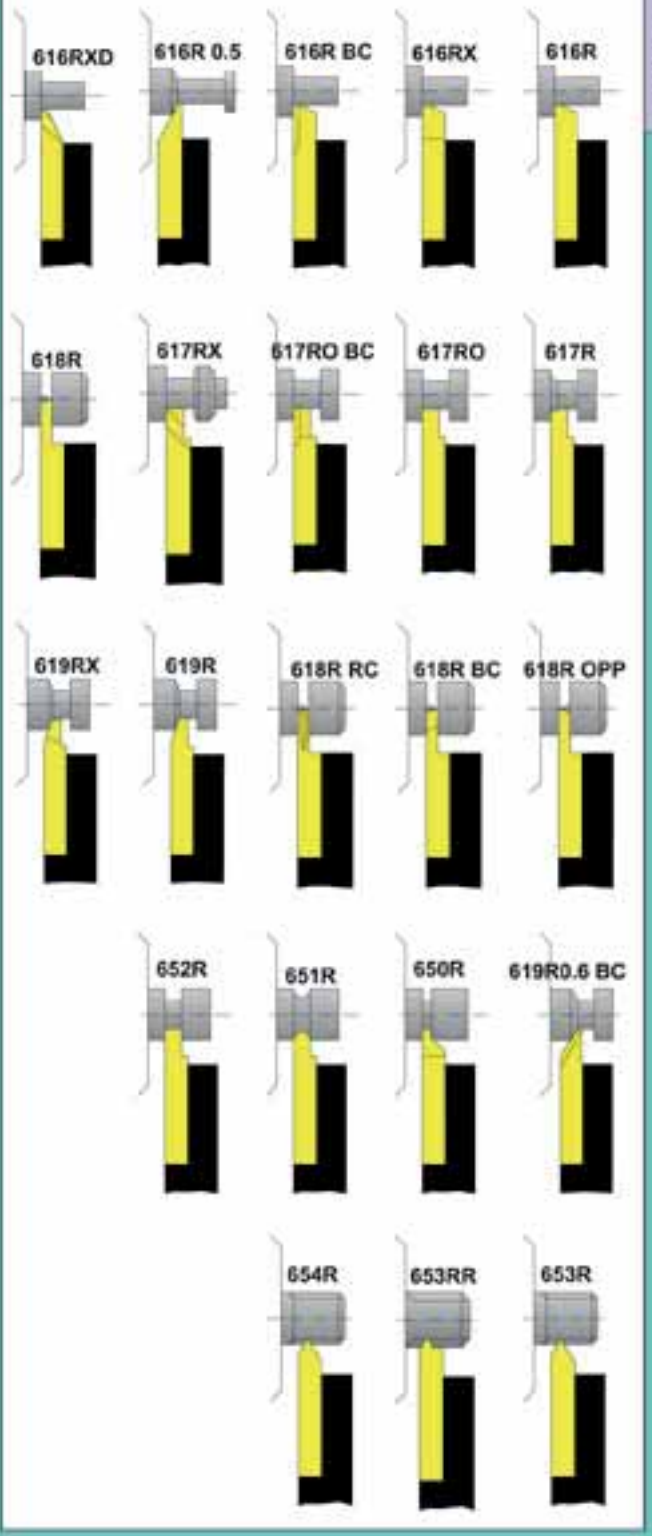
PROGRAMME TYPE 615
PROGRAMM TYP 615
PROGRAM TYPE 615



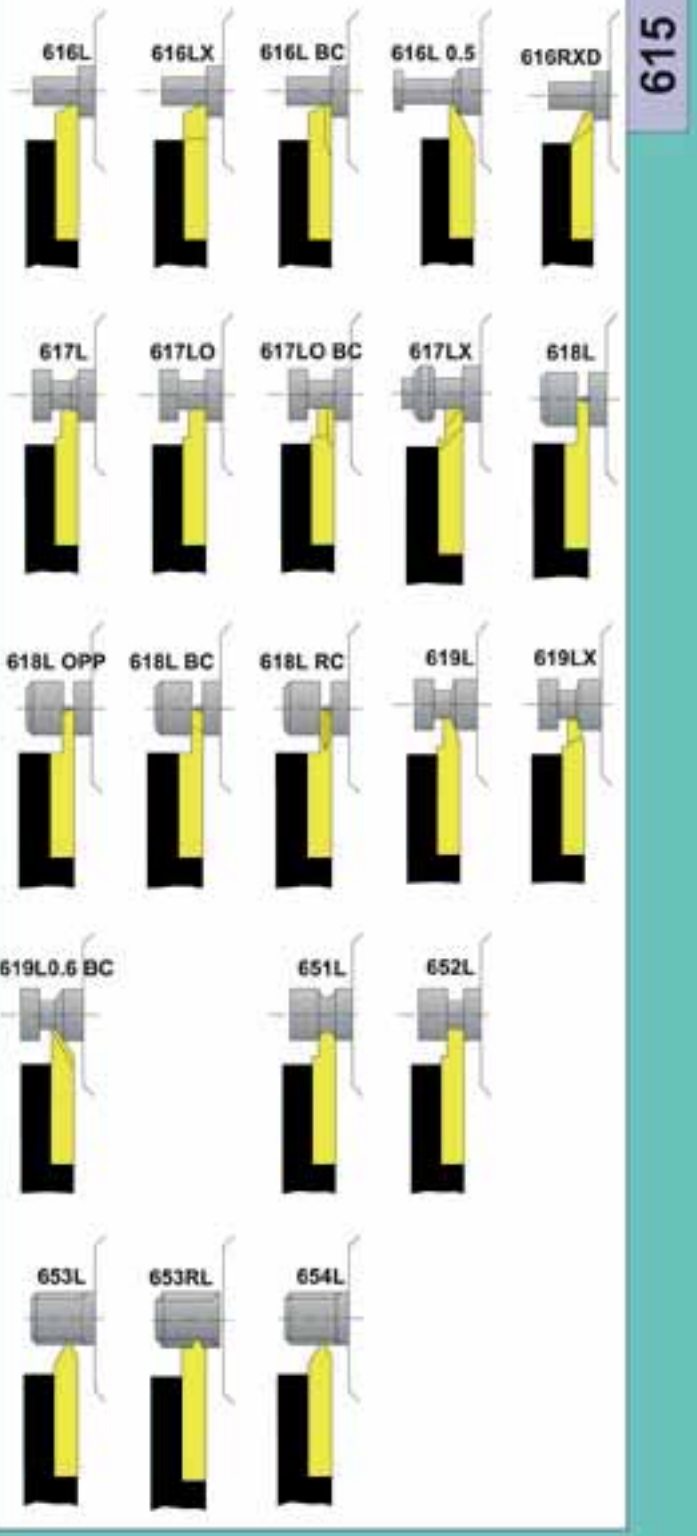
R
à droite rechts right hand

615



L
à gauche links left hand

615



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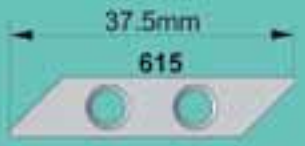
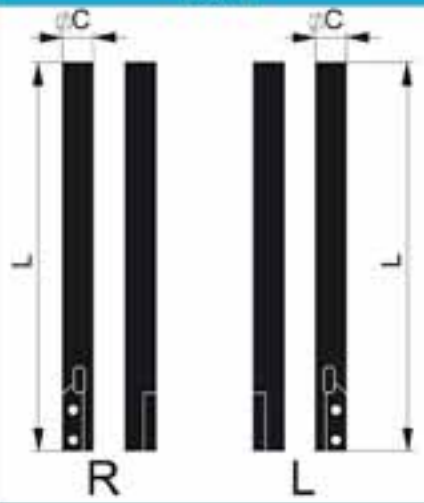
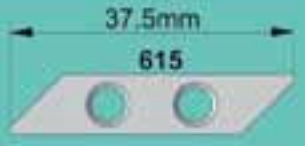
PORTE-PLAQUETTES POUR TYPE **615**
KLEMMHALTER FÜR TYP **615**
INSERT HOLDERS FOR TYPE **615**
ø 10 - 12 - 14 - 16 - 20mm

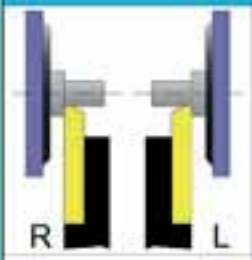
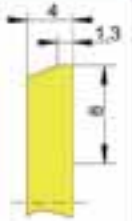
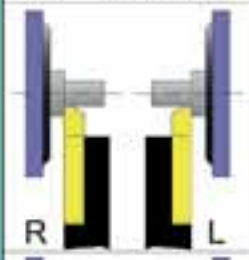
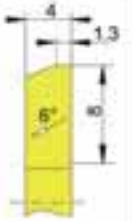
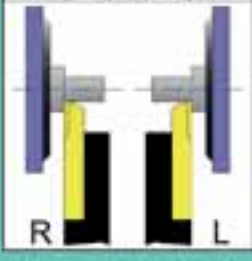
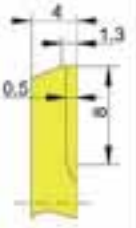


Forme Form Form	Type Typ Type	ø C [mm]	L [mm]
	610L/R	10 x 10	100
	611L/R	10 x 10	150
	612L/R	12 x 12	100
	613L/R	12 x 12	150
	614L/R	14 x 14	150
	622L/R	16 x 16	100 / 140
	623L/R	20 x 20	100 / 140

615

PLAQUETTE CARBURE TYPE **615** / Deux coupes et affûtables
HARTMETALLPLATTEN TYP **615** / Beidseitig und nachschleifbar
CARBIDE INSERTS TYPE **615** / Double ended and regrindable
ø 10 - 12 - 14 - 16 - 20mm



Forme Form Form		Usage Anwendung Application	Type Typ Type	E [mm]	Revêtement Beschichtung Coated
		Tournage avant Drehen vorne Front turn	616L 616R	E=4	Non revêtue TiN TiCN FUTURA
		Tournage avant Drehen vorne Front turn	616LX 616RX	E=4	Non revêtue TiN TiCN FUTURA
		Tournage avant Drehen vorne Front turn	616L BC 616R BC	E=4	Non revêtue TiN TiCN FUTURA

615

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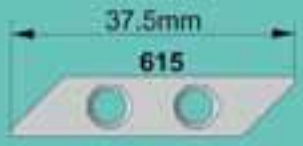
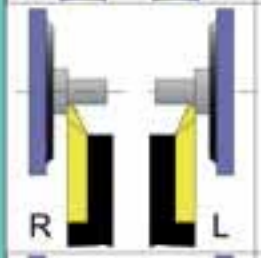
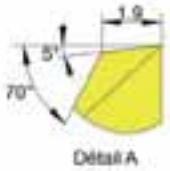
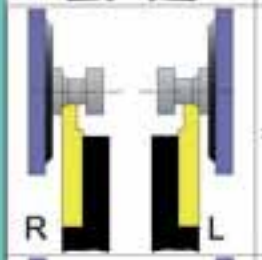
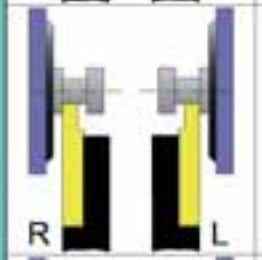
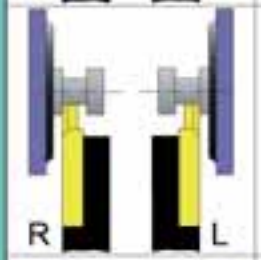
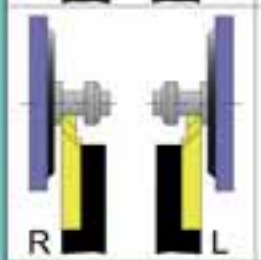
ø 10 - 12 - 14 - 16 - 20mm



Forme Form Form	Usage Anwendung Application	Type Typ Type	E X [mm]	Revêtement Beschichtung Coated
	Tournage avant Drehen vorne Front turn	616L 0.5 616R 0.5	E=0.5	Non revêtue TiN TiCN FUTURA
	Tournage avant Drehen vorne Front turn	616LXD 616RXD		Non revêtue TiN TiCN FUTURA
	Tournage arrière finition Feindrehen hinten Finisch back turn	617L 617R	E= 1.5 1.8 2.0 2.2 X= 4 4 5 5 E= 2.5 2.8 3.0 X= 7 7 7	Non revêtue TiN TiCN FUTURA
	Tournage arrière finition Feindrehen hinten Finisch back turn	617LO 617RO	E= 1.0 1.5 2.0 2.5 3.0 X= 2 3 4 5 6	Non revêtue TiN TiCN FUTURA
	Tournage arrière Drehen hinten Back turn	617LO BC 617RO BC	E= 2.5 X= 6	Non revêtue TiN TiCN FUTURA
	Chariotage fonçage d'une gorge et tournage arrière avec coupe. Drehung hinten mit Schnitt und Stechen einer Nut. Groove and turn with top rake and chip roller.	617LX 617RX	E= 0.8 1.0 1.5 X= 2 2 3 E= 2.0 2.5 3.0 X= 4 5 5	Non revêtue TiN TiCN FUTURA

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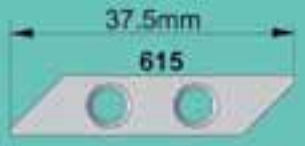
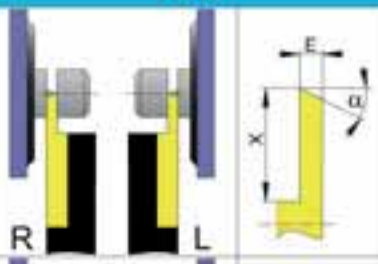
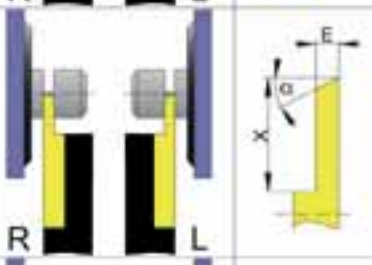
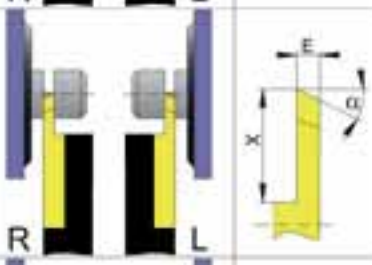
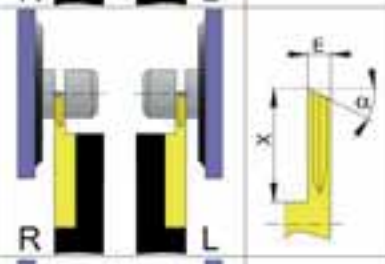
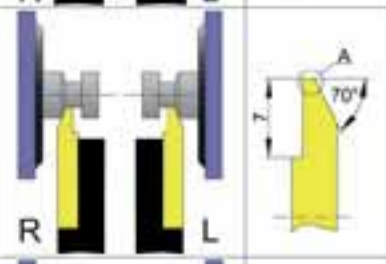
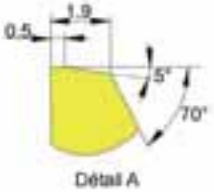
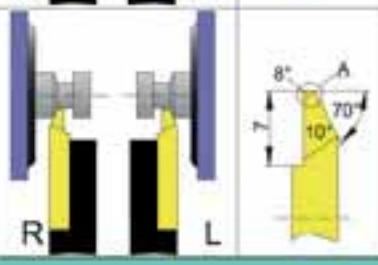
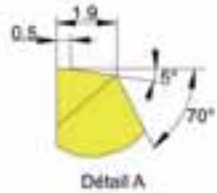


Forme Form Form	Usage Anwendung Application	Type Typ Type	E X [mm]	Revêtement Beschichtung Coated
	Tronçonnage Abstechen Part off	618L 618R	E= 0.8 1.0 1.2 1.5 1.8 x= 5 5 5 7 7 α= 18° 18° 18° 18° 18° E= 2.0 2.2 2.5 3.0 x= 8 8 8 8 α= 12° 12° 12° 12°	Non revêtue TiN TiCN FUTURA
	Tronçonnage Abstechen Part off	618L OPP 618R OPP	E= 1.5 2.0 x= 7 8 α= 18° 18°	Non revêtue TiN TiCN FUTURA
	Tronçonnage Abstechen Part off	618L BC 618R BC	E= 1.5 2.0 2.5 x= 7 8 8 α= 18° 12° 12°	Non revêtue TiN TiCN FUTURA
	Tronçonnage Abstechen Part off	618L RC 618R RC	E= 1.5 2.0 2.5 x= 7 8 8 α= 18° 12° 12°	Non revêtue TiN TiCN FUTURA
	Tournage arrière ébauche Vordrehen hinten Rough back turn	619L 619R	 Détail A	Non revêtue TiN TiCN FUTURA
	Tournage arrière ébauche avec coupe Vordrehen hinten mit Spanleitstufe Rough back turn with top rake	619LX 619RX	 Détail A	Non revêtue TiN TiCN FUTURA

615

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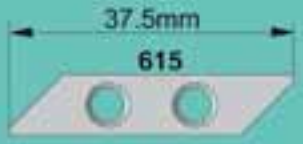
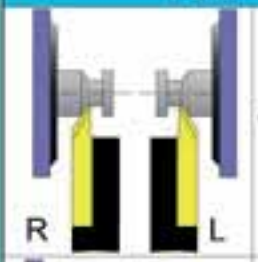
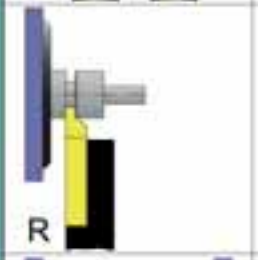
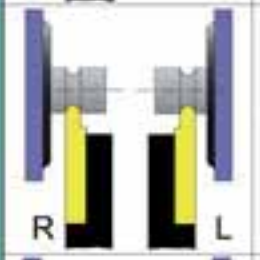
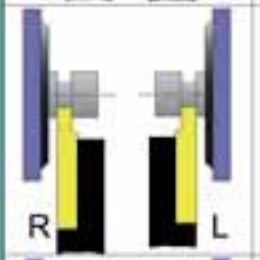
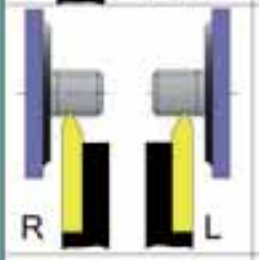
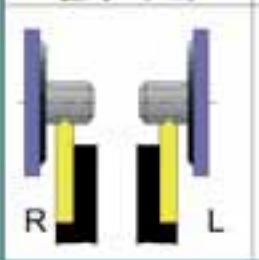


Forme Form Form	Usage Anwendung Application	Type Typ Type	E R [mm]	Revêtement Beschichtung Coated
	Tournage arrière Drehen hinten Back turn	619L0.6 BC 619R0.6 BC	E=0.6	Non revêtue TiN TiCN FUTURA
	Pré-coupeur pour multibroches Vorschneider für Mehrspindelautomat Pre part off for multispindles	650R	E=1.4 - 1.6 - 1.8	Non revêtue TiN TiCN FUTURA
	Rayon Radius Radius	651L 651R	R= 0.5 0.75 1.0 / X= 2 3 4 R= 1.25 1.5 2.0 / X= 5 6 6	Non revêtue TiN TiCN FUTURA
	Gorge Präzisions-Einstich Groove	652L 652R	E= 0.8 1.0 1.5 2.0 / X= 2 2 3 4	Non revêtue TiN TiCN FUTURA
	Filetage (autres profils sur demande) Gewinde (andere Profile auf Anfrage) Threading (other profiles on demand)	653L 653R	60° Métrique ISO Metrisch ISO Metric ISO	Non revêtue TiN TiCN FUTURA
	Filetage complet (autres profils sur demande) Gesamt Gewinde (andere Profile auf Anfrage) Full Threading (other profiles on demand)	653RL 653RR	60° Métrique Metrisch Metric Pas Steigung Pitch 0.25-0.30-0-35-0.40-0.45-0.50-0.60-0.70-0.75-0.80-1.00-1.25-1.50-1.75	Non revêtue TiN TiCN FUTURA

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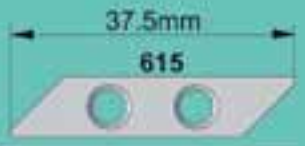
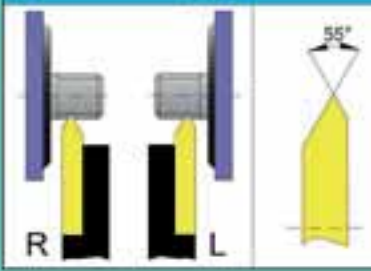
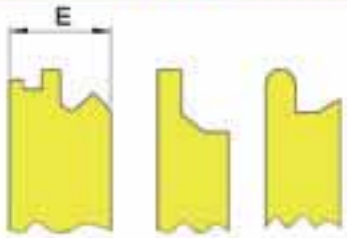


Forme Form Form	Usage Anwendung Application	Type Typ Type	E [mm]	Revêtement Beschichtung Coated
	Filetage (autres profils sur demande) Gewinde (andere Profile auf Anfrage) Threading (other profiles on demand)	654L 654R	55° Whitworth W	Non revêtue TiN TiCN FUTURA

615

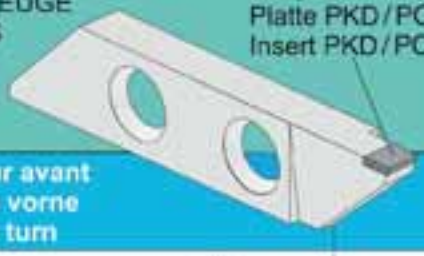
PLAQUETTES DE FORME
FORMPLATTEN
FORM INSERTS

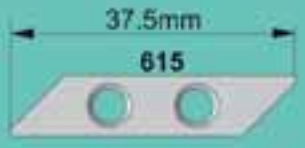
Forme Form Form	Caractéristiques Kennzeichnungen Characteristics	Revêtement Beschichtung Coated
	**615**: E = 4 - 6 mm **630**: E = 3mm Réalisation de plaquettes spéciales selon dessin. Formplatten nach Zeichnung. Special form inserts to drawing.	Non revêtue TiN TiCN FUTURA

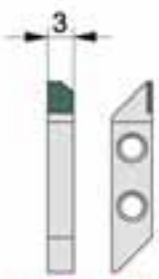
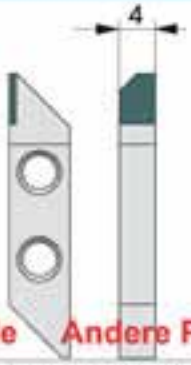
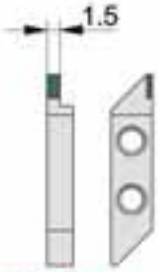
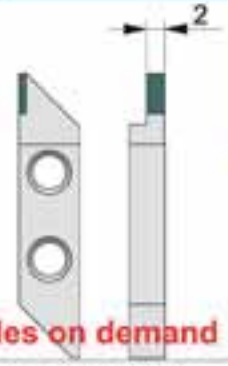
630
615

OUTILS DE COUPE DIAMANT
DIAMANT-SCHNEIDWERKZEUGE
DIAMOND CUTTING TOOLS

Dimensions en [mm]
Masse in [mm]
Dimension in [mm]





Tourneur avant Drehen vorne Front turn		Tourneur arrière Drehen hinten Finish back turn	
			
631L PKD/PCD 631R PKD/PCD	616L PKD/PCD 616R PKD/PCD	632L PKD/PCD 632R PKD/PCD	617L PKD/PCD 617R PKD/PCD

630
615

Autres profils sur demande **Andere Profile auf Anfrage** **Other profiles on demand**

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PRECITOOL SA

56, rue de Soleure CH 2740 MOUTIER

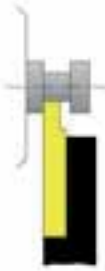
Fabricant d'outillage carbure depuis 1969
Vollhartmetallwerkzeug - Hersteller seit 1969
Manufacturer carbide cutting tools since 1969

PROGRAMME TYPE 630
PROGRAMM TYP 630
INSERT PROGRAM TYPE 630

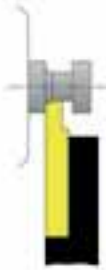
R
à droite rechts right hand

630

tourneur arrière drehen hinten back turning **632RO**



tourneur arrière drehen hinten back turning **632R**

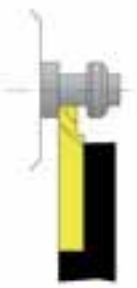


tourneur avant drehen vorne front turning **631R**

coupeur abstechen part off **633R OPP**

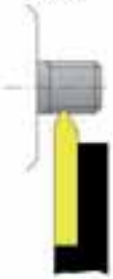
coupeur abstechen part off **633R**

tourneur avant et arrière drehen vorne und hinten front or back turning **632RX**

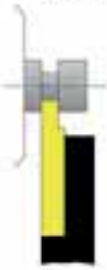


filetage 55° gewinde 55° threading 55° **663R**

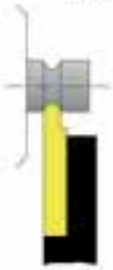
Filetage 60° gewinde 60° threading 60° **662R**



gorge präzisions-einstich groove **661R**



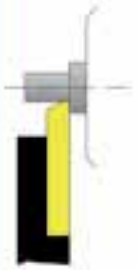
rayon radius radius **660R**



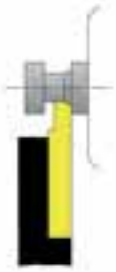
L
à gauche links left hand

630

tourneur avant drehen vorne front turning **631L**



tourneur arrière drehen hinten back turning **632L**



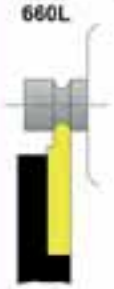
tourneur arrière drehen hinten back turning **632LO**

tourneur avant et arrière drehen vorne und hinten front or back turning **632LX**

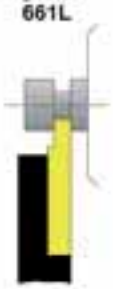
coupeur abstechen part off **633L**

coupeur abstechen part off **633L OPP**

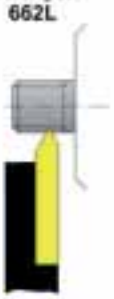
rayon radius radius **660L**



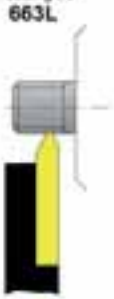
gorge präzisions-einstich groove **661L**



filetage 60° gewinde 60° threading 60° **662L**



filetage 55° gewinde 55° threading 55° **663L**



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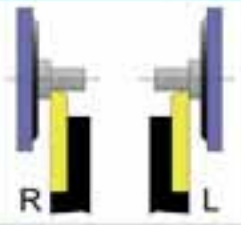
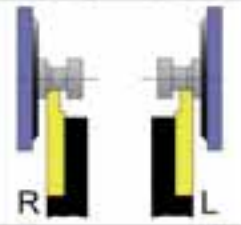
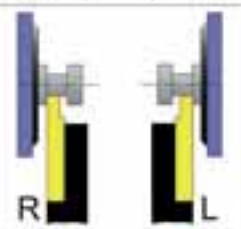
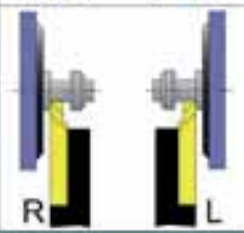
Manufacturer carbide cutting tools since 1969

PORTE-PLAQUETTES POUR TYPE **630**
KLEMMHALTER FÜR TYP **630**
INSERT HOLDERS FOR TYP **630**
⌀ 7 - 8 - 10 - 12 - 20mm

Forme Form Form	Type Typ Type	⌀ C [mm]	L [mm]
	608L/R	7 x 7	150
	609L/R	8 x 8	150
	609 10L/R	10 x 10	150
	609 12L/R	12 x 12	150
	609 20L/R	20 x 20	100

630

PLAQUETTE CARBURE TYPE **630** / Deux coupes et affûtables
HARTMETALLPLATTEN TYP **630** / Beidseitig und nachschleifbar
CARBIDE INSERTS TYPE **630** / Double ended and regrindable
⌀ 7 - 8 - 10 - 12 - 20mm

Forme Form Form	Usage Anwendung Application	Type Typ Type	E X [mm]	Revêtement Beschichtung Coated
	Tournage avant Drehen vorne Front turn	631L 631R	E=3	Non revêtue TiN TiCN FUTURA
	Tournage arrière Drehen hinten Back turn	632L 632R	E= 1.0 1.2 1.5 1.8 X= 3 3 4 4 E= 2.0 2.2 2.5 X= 4 4 4	Non revêtue TiN TiCN FUTURA
	Tournage arrière Drehen hinten Back turn	632LO 632RO	E= 1.0 1.5 2.0 2.5 X= 3 4 4 4	Non revêtue TiN TiCN FUTURA
	Tournage arrière Drehen hinten Back turn	632LX 632RX	E= 1.0 1.2 1.5 X= 2 3 3 E= 2.0 2.2 2.5 X= 4 5 5	Non revêtue TiN TiCN FUTURA

630

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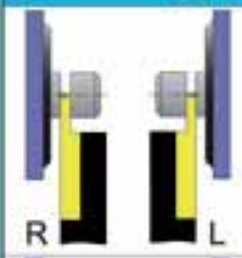
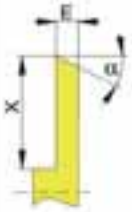
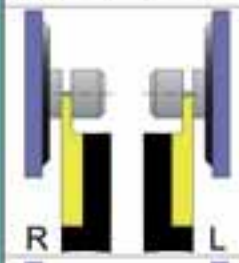
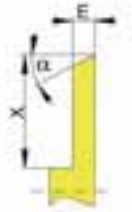
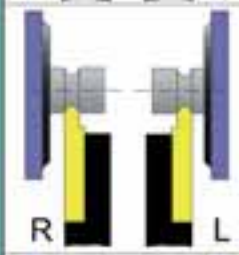
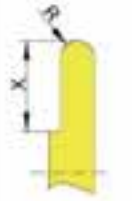
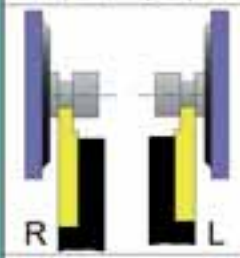
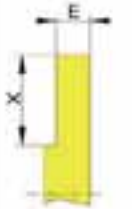
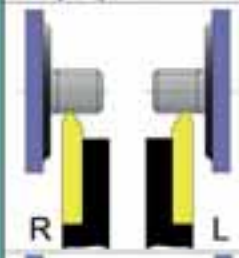
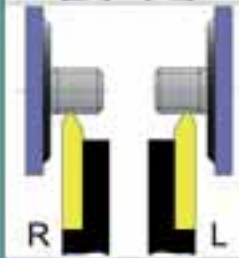
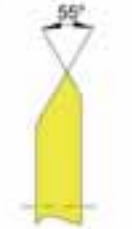
PLAQUETTE CARBURE TYPE **630** / Deux coupes et affûtables
HARTMETALLPLATTEN TYP **630** / Beidseitig und nachschleifbar
CARBIDE INSERTS TYPE **630** / Double ended and regrindable
Ø 7 - 8 - 10 - 12 - 20mm

Forme Form Form		Usage Anwendung Application	Type Typ Type	E R X [mm]	Revêtement Beschichtung Coated
		Tronçonnage Abstechen Part off	633L 633R	E= 0.8 1.0 1.2 1.5 1.8 2.0 x= 3 3 3 4 4 4 α= 18° 18° 18° 18° 18° 18°	Non revêtue TiN TiCN FUTURA
		Tronçonnage Abstechen Part off	633L OPP 633R OPP	E= 1.0 1.5 2.0 x= 3 4 4 α= 18° 18° 18°	Non revêtue TiN TiCN FUTURA
		Rayon Radius Radius	660L 660R	R= 0.25 0.5 0.75 X= 1 2 3 R= 1.0 1.25 1.5 X= 4 4 5	Non revêtue TiN TiCN FUTURA
		Gorge Präzisions-Einstich Groove	661L 661R	E=0.5-0.6-0.8-1- 1.2-1.4-1.5-1.8-2 X=(2 x E) Sur demande Auf Anfrage On demand	Non revêtue TiN TiCN FUTURA
		Filetage (autres profils sur demande) Gewinde (andere Profile auf Anfrage) Threading (other profiles on demand)	662L 662R	60° Métrique ISO Metrisch ISO Metric ISO	Non revêtue TiN TiCN FUTURA
		Filetage (autres profils sur demande) Gewinde (andere Profile auf Anfrage) Threading (other profiles on demand)	663L 663R	55° Whitworth W	Non revêtue TiN TiCN FUTURA

630

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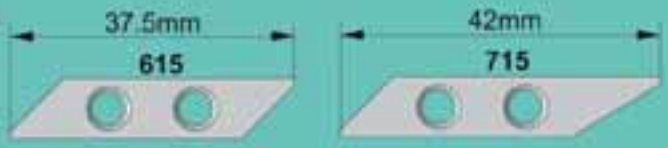
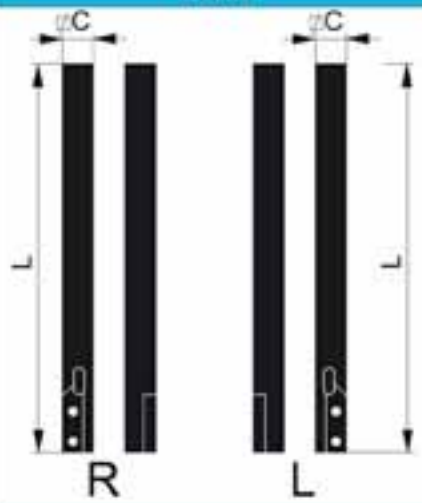
PORTE-PLAQUETTES "TYPE F" POUR TYPE **615** ET **715**
KLEMMHALTER " TYP F" FÜR TYP **615** UND **715**
INSERT HOLDERS "TYPE F" FOR TYPE **615** AND **715**
ø 10 - 12 - 14 - 16 - 20mm



Forme Form Form	Type Typ Type	ø C [mm]	L [mm]
	610L-F / 610R-F	10 x 10	100
	611L-F / 611R-F	10 x 10	150
	612L-F / 612R-F	12 x 12	100
	613L-F / 613R-F	12 x 12	150
	614L-F / 614R-F	14 x 14	150
	622L-F / 622R-F	16 x 16	100 / 140
	623L-F / 623R-F	20 x 20	100 / 140

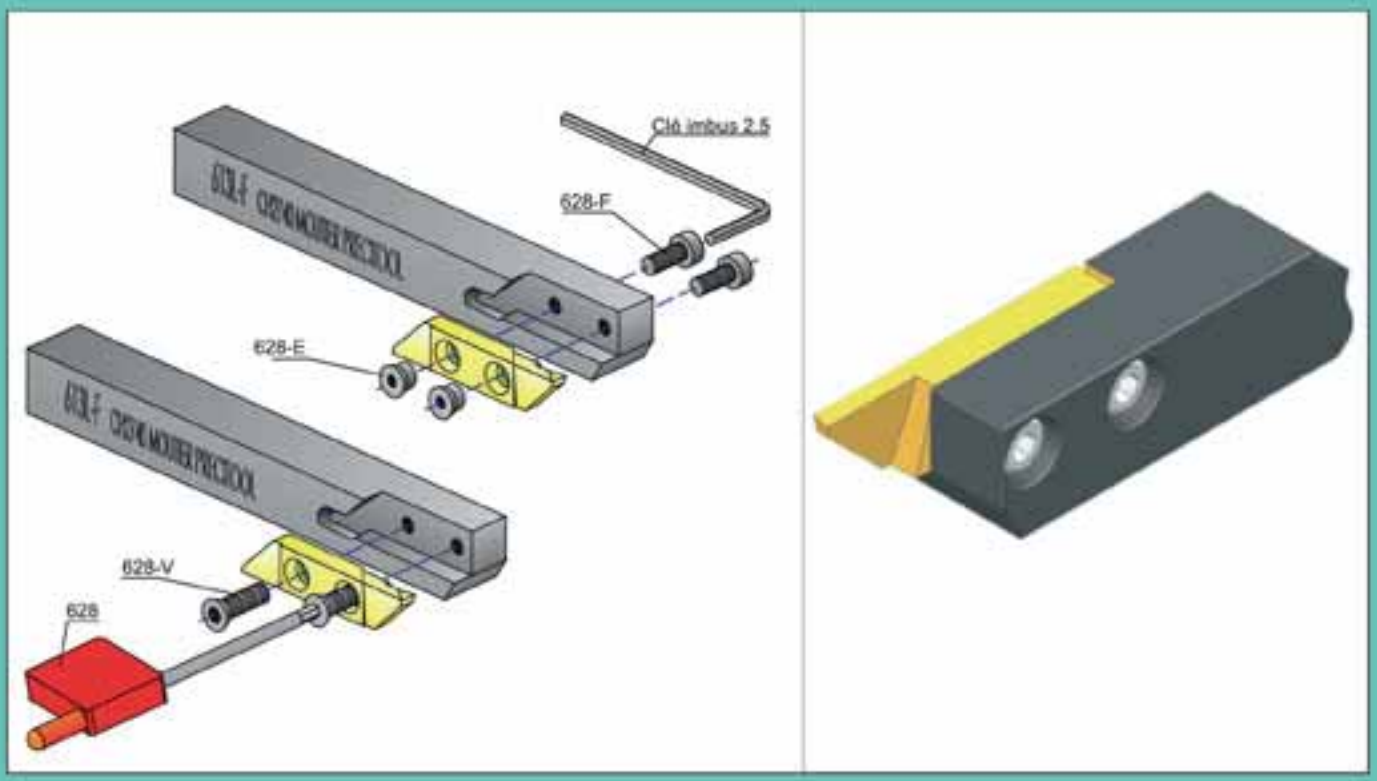
615

715

Plaquette interchangeable sans enlever le porte-plaquette de la machine. Les insets **628-E** se monte par pression.

Auswechseln der Wendeplatten an der Maschine ohne Entfernung des Halters. Die Stiffte **628-E** montieren sich mit leichtem Druck.

Interchangeable inserts without removing the tool holder from the machine. When changing inserts do not over the screw **628-E**.



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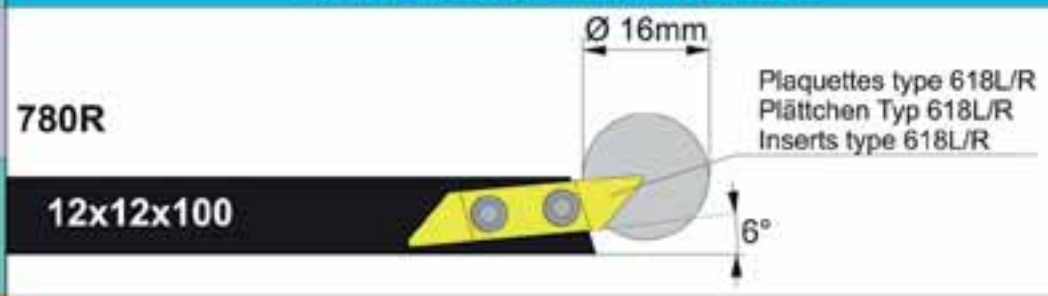
MULTIBROCHES MEHRSPINDEL MULTISPINDLE

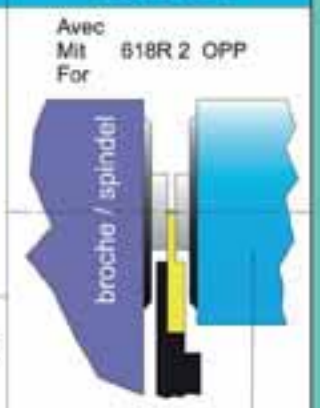
Porte-plaquettes pour multibroches Klemmhalter für Mehrspindel Drehautomat Insert holders for multispindle automatic	Usage Anwendung Application

615

780R

12x12x100

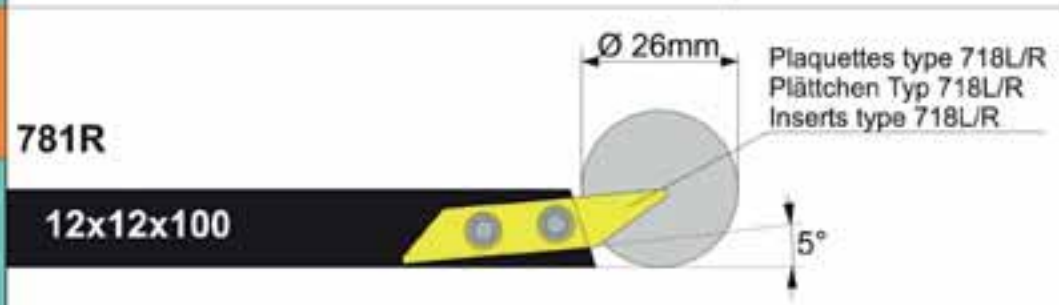


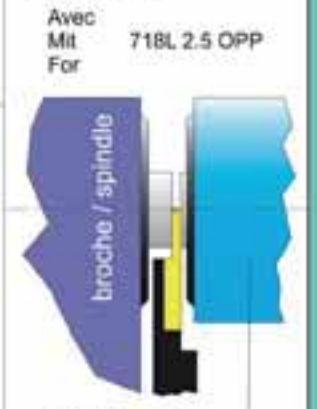


715

781R

12x12x100

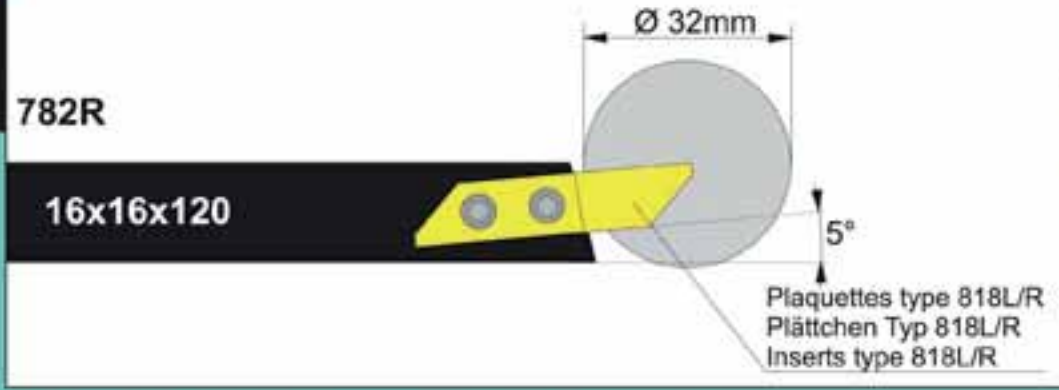




815

782R

16x16x120

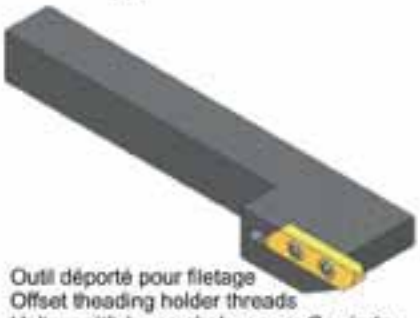


PORTE- PLAQUETTES SPECIAUX
SPEZIALKLEMMHALTER
SPECIAL INSERTHOLDERS

Type 600

Pour TORNOS DECO10

Type 624 .....



Outil déporté pour filetage
Offset theading holder threads
Halter seitlich verschoben zum Gewinde

Type 621R

12x12x80mm Tornos TOP100

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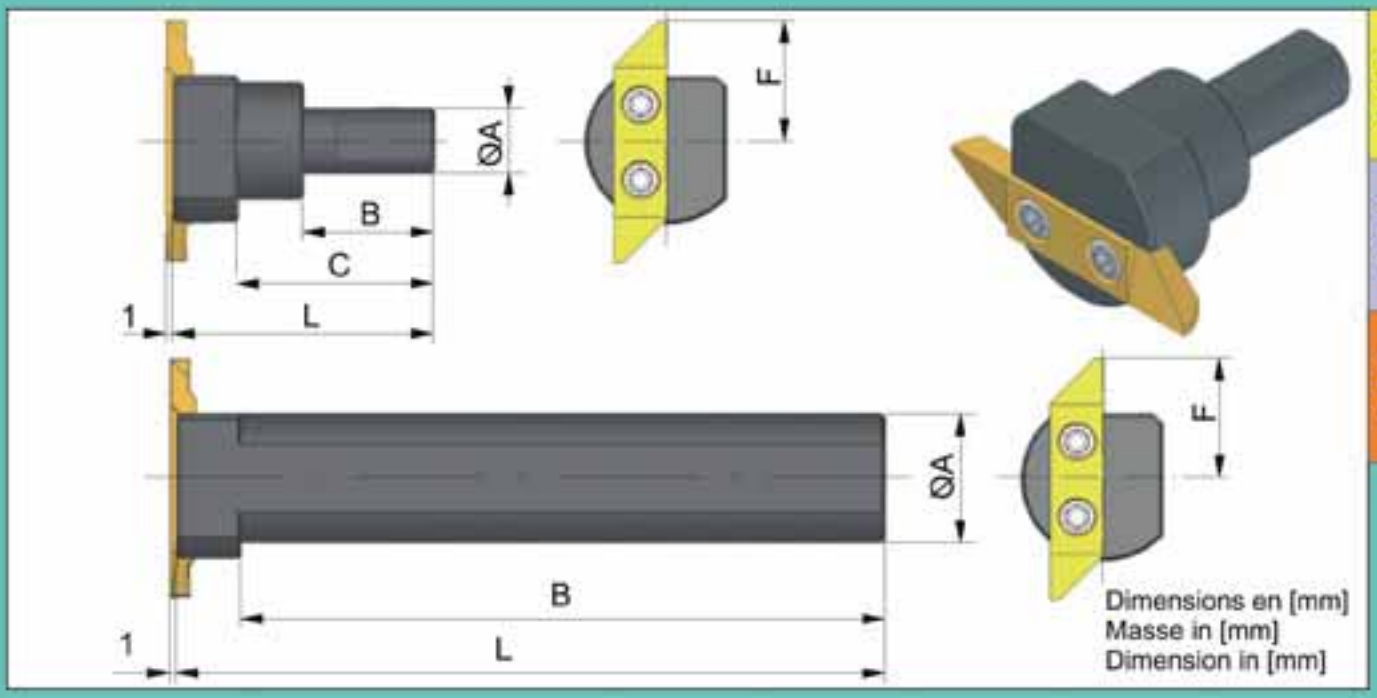
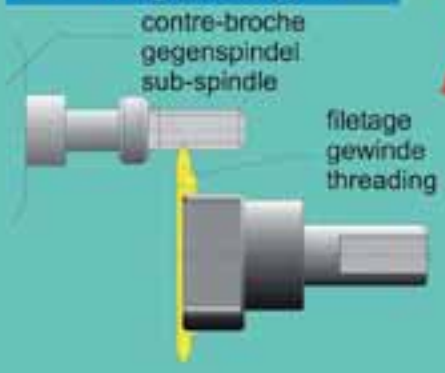
PORTE-PLAQUETTES: ***POUR CONTRE OPÉRATION AVEC CONTRE-BROCHE***
KLEMMHALTER: ***FÜR DREHEN MIT GEGENSPINDEL***
INSERT HOLDER: ***FOR TURNING ON SUB-SPINDLE***



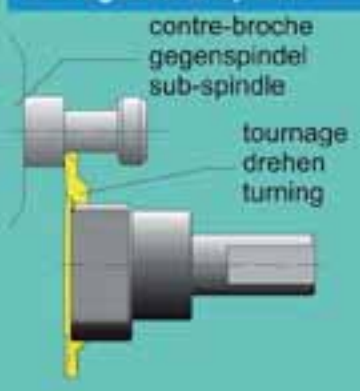
630
615
715

Type	Type de plaquette	ØA	B	C	L	F
775	630	10	20	30	40	14.5
775-20	630	20	100	-	110	14.5
776	615	10	20	30	40	18.5
776	715	10	20	30	40	23.5
776-16	615	16	80	-	90	18.5
776-16	715	16	80	-	90	23.5
776-19	615	19.05	100	-	110	18.5
776-19	715	19.05	100	-	110	23.5
776-20	615	20	100	-	110	18.5
776-20	715	20	100	-	110	23.5
776-25.4	615	25.4	100	-	110	18.5
776-25.4	715	25.4	100	-	110	23.5

Filetage en contre opération
Gewinde mit Gegenspindel
Srewcutting on sub-spindle



Tournage en contre opération
Drehen mit Gegenspindel
Turning on sub-spindle



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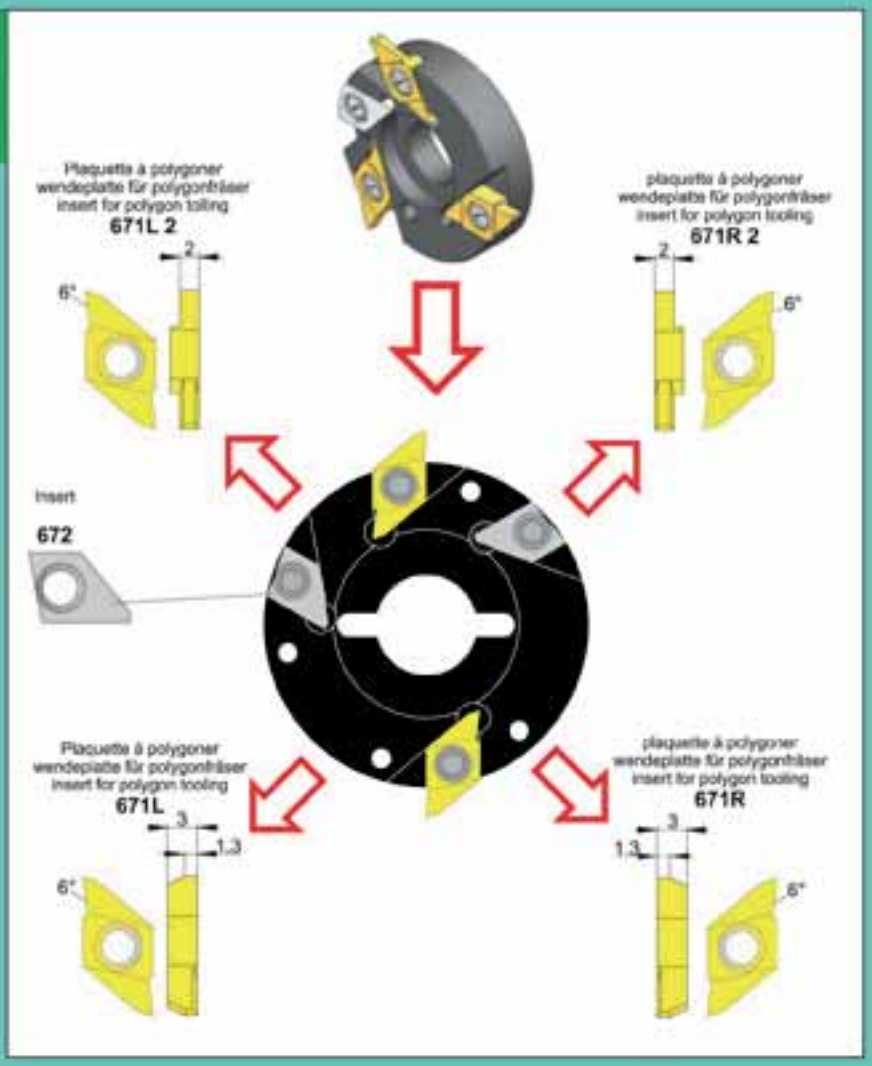
FRAISES A POLYGONER POLYGONFRÄSER POLYGON TOOLING

671



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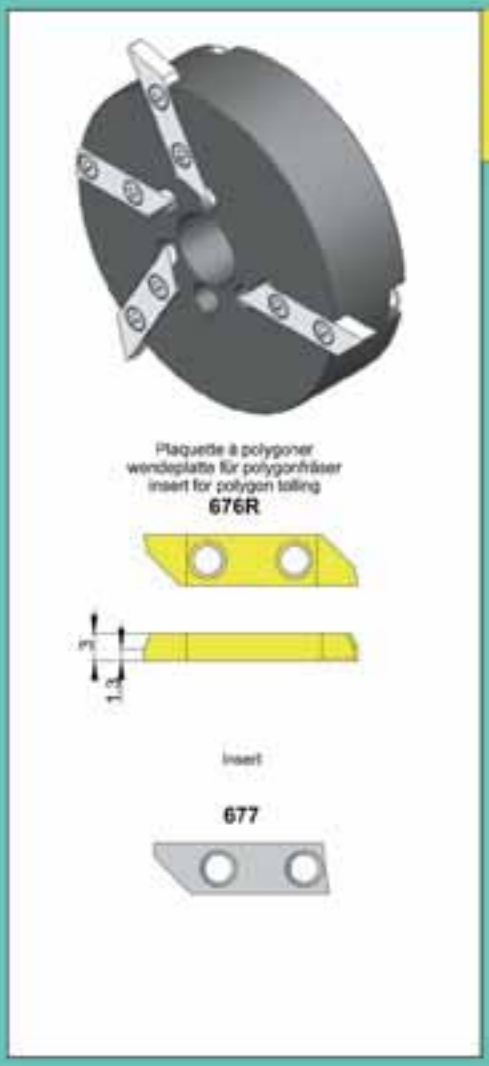

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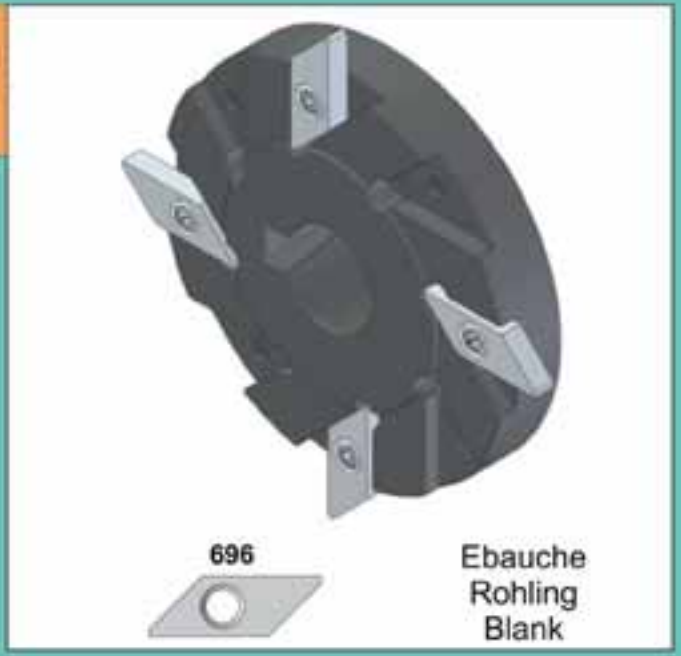

615

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FRAISES A POLYGONER
POLYGONFRÄSER
POLYGON TOOLING

671 => 671L/R 671L2 / 671R2

630 => 676R

696

Type Typ Type	Usage Anwendung Application	Ø total [mm]	Ø fraise Ø Fräser Ø milling [mm]	Ø alésage Ø Bohrung Ø bore [mm]	Caractéristiques plaquettes Kennzeichnungen Plättchen Characteristics Inserts
669	Tornos TOP100 / ENC 75	50	42	13	671L / 671L2 / 671R / 671R2
673	Tornos ENC 167	50	42	13	671L / 671L2 / 671R / 671R2
674	Tornos AS 14 / SAS 16 DC	57	49	16	671R / 671R2
675	Tornos TOP 200	81	71	16	676R
675-1	Tornos TOP 200	79.5	71	16	671R / 671R2
685-3	Tornos AS 14 / INDEX	60	51	16	671R / 671R2
685-4	Tornos AS 14 / INDEX	60	51	16	671L / 671L2
690	Tornos ENC 164 / POLY 164-60	60	51.8	13	671L / 671L2
691	Tornos ENC 164 / POLY 164-90	69	60.5	13	671L / 671L2
692-3	Tornos MS-7	50	42	28	671L / 671L2
692-4	Tornos MS-7	50	42	28	671L / 671L2
693	Tornos SAS 16DC	72	63.5	16	671R / 671R2
694	Tornos ENC 164 / POLY 164-69P7	69	55	13	696 Ebauche / Rohling / Blank
698	Tornos DECO2000 7-10mm	40	33	10	671R / 671R2
699	Tornos DECO2000 7-10mm	40	33	10	671L / 671L2
700R	Tornos DECO2000 20-25mm	80	72	16	671R / 671R2
700L	Tornos DECO2000 20-25mm	80	72	16	671L / 671L2
702	Tornos MULTIDECO 26-6	86	78	*24.69	671L / 671L2 / 671R / 671R2
703	Tornos MULTIDECO 20-6 / 20-8	80	72	*24.69	671L / 671L2 / 671R / 671R2
717	Tornos ENC 167	40	33	13	671R / 671R2
719	Tornos DECO 13	80	71	16	676R
720	Tornos MULTIDECO 20-6 / 20-8	86	72	*24.69	696 Ebauche / Rohling / Blank
727	Tornos MULTIDECO 20-6 / 20-8	89 / 84	87 / 75	*24.69	671L / 671L2 / 671R / 671R2

671 630 696 615

*Alésage conique: 8° 16' 33"
*Konus Bohrung: 8° 16' 33"
*Conical bore: 8° 16' 33"

685-P7	INDEX P7	90	75.8	27	696 Ebauche / Rohling / Blank
706	INDEX MS25	70	62.1	16	671L / 671L2
707	INDEX ABC	90	75	27	615 Ebauche / Rohling / Blank
724	INDEX ABC	90	81	27	671R / 671R2
732-3	INDEX ABC	90	75	27	615 Ebauche / Rohling / Blank
732-4	INDEX ABC	90	75	27	615 Ebauche / Rohling / Blank
733	INDEX ER	76	67	18	671R / 671R2

705 60	CITIZEN M12	60	52.1	16	671R / 671R2
711	CITIZEN M32	80	71	16	671R / 671R2
713	CITIZEN M32	80	71	16	671L / 671L2
730	CITIZEN M32	80	71	5/8"	671L / 671L2

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FRAISES A POLYGONER
POLYGONFRÄSER
POLYGON TOOLING

671 => 671L/R 671L2 / 671R2

630 => 676R

696

Type Typ Type	Usage Anwendung Application	Ø total [mm]	Ø fraise Ø Fräser Ø milling [mm]	Ø alésage Ø Bohrung Ø bore [mm]	Caractéristiques plaquettes Kennzeichnungen Plättchen Characteristics Inserts
684	Manurhin FLD KMX / POLY KMX	64	53.8	12	676R
684-1	Manurhin FLD KMX / POLY KMX1	64	71	12	671L / 671L2 / 671R / 671R2
684-2	Manurhin FLD KMX / POLY KMX80	80	71	16	671R / 671R2
684-3	Manurhin FLD KMX / POLY KMX80-2	80	71	16	671R / 671R2
684-4	Manurhin FLD KMX / POLY KMX80-42	80	71	12	671L / 671L2 / 671R / 671R2
701	Manurhin FLD KMX / KMX SWING 13 20	50	42	13	671L / 671L2 / 671R / 671R2
704 80	Manurhin FLD KMX / KMX XL-32 / XS-32	80	72	16	671L / 671L2
704 90	Manurhin FLD KMX / KMX XL-32 / XS-32	90	81.9	16	671L / 671L2
704 100	Manurhin FLD KMX / KMX XL-32 / XS-32	100	91.7	16	671L / 671L2
684-3	Manurhin FLD KMX / POLY KMX80-2	80	71	16	671R / 671R2
684-4	Manurhin FLD KMX / POLY KMX80-42	80	71	16	671L / 671L2 / 671R / 671R2
710	Manurhin FLD KMX / KMX 442	78	69	12	671L / 671L2 / 671R / 671R2
712	Manurhin FLD KMX / KMX 442	64	55	12	671R / 671R2
728	Manurhin FLD KMX / KMX 442	98	81	12	615 Ebauche / Rohling / Blank
708	STAR SV20	70	62.1	16	671R / 671R2
721	STAR SV32	70	61.5	16	671R / 671R2
683	Traub / POLY TD 16/26	64	56	12	671L / 671L2
683-1	Traub / POLY TRAUB Ø90	90	81	27	671R / 671R2
714	BAECHLER AR7/10	64	56	12	671L / 671L2
722	EMCO 365 MC	90	71	27	671L / 671L2
725	BIGLIA	64	56	12	615 Ebauche / Rohling / Blank
709		36	29	8	671L / 671L2
726		35	28.4	12	671R / 671R2
729		73	65	18	671L / 671L2 / 671R / 671R2

671 630 696 615

AUTRES FRAISES A POLYGONER SUR DEMANDE
ANDERE POLYGONFRÄSER AUF ANFRAGE
OTHERS POLYGON TOOLING ORDER

CITIZEN; GILDEMEISTER; STAR; TZUGAMI;.....

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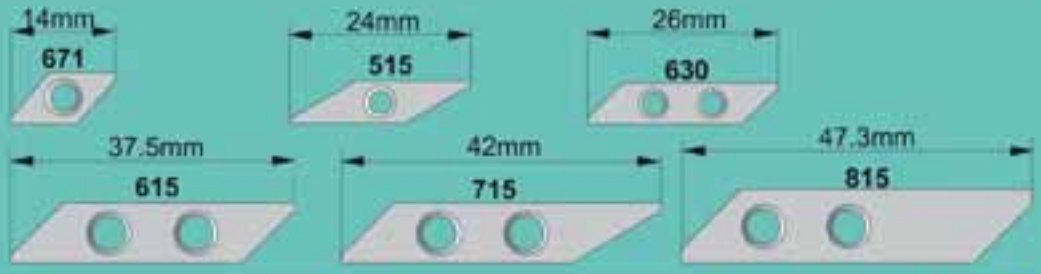
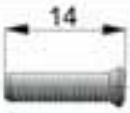
FOURNITURES
ERSATZTEILE
ITEMS



Forme Form Form	Usage Anwendung Application	Type Typ Type	Caractéristiques Kennzeichnungen Characteristics
	Porte-plaquette Klemmhalter Insert holders 507; 508; 510; 512; 514; 520; 608; 609 L/R; 775 Fraise à polygoner Polygonfräser Polygon tooling 669; 673; 674; 675-1; 683; 684-1; 684-2; 684-3; 684-4; 685-3; 685-4; 690; 691; 692-3; 692-4; 693; 700R; 700L; 701; 702; 703	627	T8
	Porte-plaquette Klemmhalter Insert holders 507; 508; 510; 512; 514; 520; 608; 609 L/R Fraise à polygoner Polygonfräser Polygon tooling 684; 775	627-V	M2.5x7 / T8
	Fraise à polygoner Polygonfräser Polygon tooling 669; 673; 674; 675-1; 683; 684; 684-1; 684-2; 684-3; 684-4; 685-3; 685-4; 690; 691; 692-3; 692-4; 693; 700R; 700L; 701; 702; 703	627-P	M3x7 / T8
	Pour plaquette 671-5 Für Platte 671-5 E=5mm For Insert 671-5	627-PP	M3x9 / T8
	Porte-plaquette Klemmhalter Insert holders 610; 611; 612; 613; 614; 622; 623; 781R; 782R; 800; 801; 802 L/R; 776 Fraise à polygoner Polygonfräser Polygon tooling 694; 685-P7	628	T15
	Pour plaquette type 615 Für PlatteTyp 615 For Insert Type 615	628-E	M3
	Porte-plaquette Klemmhalter Insert holders 610-F; 611-F; 612-F; 613-F; 614-F; 622-F; 623-F L/R	628-F	M3x8
	Porte-plaquette Klemmhalter Insert holders 610; 611; 612; 613; 614; 622; 623; 776; 781R; 782R; 800; 801; 802 L/R Fraise à polygoner Polygonfräser Polygon tooling 694; 685-P7	628-V	M3.5x9 / T15
	Pour plaquette 615-6 Für Platte 615-6 E=6mm For Insert 615-6	628-VV	M3.5x14 / T15

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PARAMÈTRES DE COUPE INDICATIFS POUR PROGRAMME DECO
EMPFOHLENE SCHNITTWERTE FÜR DECO PROGRAMM
STANDARD MACHINING DATA FOR PROGRAM DECO

Matériaux / Werkstoffe / Materials	HB	Revêt.	Tournage Drehen Turning – ébauche / schruppen / roughing – Prof. de passe <5.0 / Schnitttiefe / Depth of cut – VC:m/min	F:mm/t	semi finition / vorbearbeiten / semi finished – Prof. de passe <2.0 / Schnitttiefe / Depth of cut – VC:m/min	F:mm/t	finition / schlichten / finishing – Prof. de passe <1.0 / Schnitttiefe / Depth of cut – VC:m/min	F:mm/t	Tronçonnage Abstechen Cut off – E=0.50-2.0 >4.0 – VC:m/min	F: mm/t
Acier décolleté	~500	TIN	70-150	0,08-0,20	70-150	0.10-0.20	80-180	0.05-0.15	70-120	0.01-0.05 >0.10
Automatenstahl	~500	TICN	100-170	0.10-0.25	100-170	0.08-0.15	100-200	0.07-0.15	70-130	0.01-0.05 >0.10
Free-cutting steel	~500	Futura	100-180	0.10-0.30	120-200	0.08-0.15	120-220	0.10-0.15	70-140	0.01-0.05 >0.10
● Acier non-allié										
Acier N/mm2	~750	TIN	50-100	0.05-025	50-100	0.03-020	50-100	.005-0.10	60-100	0.01-0.05 >0.10
● Acier faibt.allié	~750	TICN	50-100	0.05-025	60-110	0.03-020	60-110	.005-0.10	60-100	0.01-0.05 >0.10
	~750	Futura	50-100	0.05-025	70-120	0.03-020	70-120	.005-0.10	60-100	0.01-0.05 >0.10
Acier N/mm2	~1000	TIN	40-80	0.05-0.15	50-100	0.03-0.10	50-100	.005-0.07	40-80	0.01-0.03 >0.06
● Acier fort.allié	~1000	TICN	40-80	0.05-0.15	50-100	0.03-0.10	50-100	.005-0.07	40-80	0.01-0.03 >0.06
		Futura	40-80	0.05-0.15	50-100	0.03-0.10	50-100	.005-0.07	40-80	0.01-0.03 >0.06
Acier INOX	~750	TIN	50-100	0.05-0.15	50-120	0.03-0.10	50-120	.005-0.06	40-80	0.01-0.04 >0.08
Rostfreier Stahl	~750	TICN	60-110	0.05-0.15	60-120	0.03-0.10	60-120	.005-0.07	40-80	0.01-0.04 >0.08
Stainless steel	~750	Futura	60-120	0.05-0.15	60-130	0.03-0.10	60-130	.005-0.07	40-80	0.01-0.04 >0.08
Titane	~750	Futura	30-70	0.05-0.15	30-70	0.03-0.08	30-80	.005-0.07	40-80	0.01-0.03 >0.06
Titan										
Titanium										
Laiton	~500	TIN	80-400	0.05-0.40	80-450	0.05-0.45	80-500	0.02-0.25	40-80	0.01-0.10 >0.20
● Cuivre	~500	TICN	100-400	0.05-0.40	100-450	0.05-0.45	100-500	0.02-0.25	40-80	0.01-0.10 >0.20
Bronze	~500	Futura	100-400	0.05-0.40	100-450	0.05-0.45	100-500	0.02-0.25	40-80	0.01-0.10 >0.20
Aluminium		TIN	150-1000	0.01-0.25	150-1200	0.01-0.25	150-1200	0.01-0.25	150-350	0.01-0.10 >0.20
Alu Si <12%		TICN	150-1000	0.01-0.25	150-1200	0.01-0.25	150-1200	0.01-0.25	150-350	0.01-0.10 >0.20
		Futura	150-1000	0.01-0.25	150-1200	0.01-0.25	150-1200	0.01-0.25	150-350	0.01-0.10 >0.20
Aluminium		TIN	100-800	.005-020	120-1000	.005-020	120-1000	.005-0.20	120-300	0.01-0.10 >0.20
Alu Si >12%		TICN	100-800	.005-020	120-1000	.005-020	120-1000	.005-0.20	120-300	0.01-0.10 >0.20
		Futura	100-800	.005-020	120-1000	.005-020	120-1000	.005-0.20	120-300	0.01-0.10 >0.20
OR - Argent		TIN	50-100	0.02-0.12	50-120	0.02-0.10	50-120	0.02-0.08	40-100	0.01-0.03 >0.07
Gold - Silber		TICN	50-110	0.02-0.12	50-130	0.02-0.10	50-130	0.02-0.08	50-110	0.01-0.03 >0.07
Gold - silver		Futura	50-120	0.02-0.12	50-140	0.02-0.10	50-140	0.02-0.08	50-120	0.01-0.03 >0.07

Valeurs indicatives: à interpréter selon caractéristiques de la machine, serrages de la matière et porte-outils, fluide d'arrosage, etc...
Richtwerte: *Nach Eigenschaften der Maschine zu interpretieren; Festklemmen von Material und Werkzeughalter; Kühlflüssigkeit; usw...*
Approximate values: Depending on the machine charateristics: Material and tool clamping device; Cooling liquid; etc...

●**Acier / *Stahl* / Steel** **Cuivre / *Kupfer* / Copper** **Laiton / *Messing* / brass**

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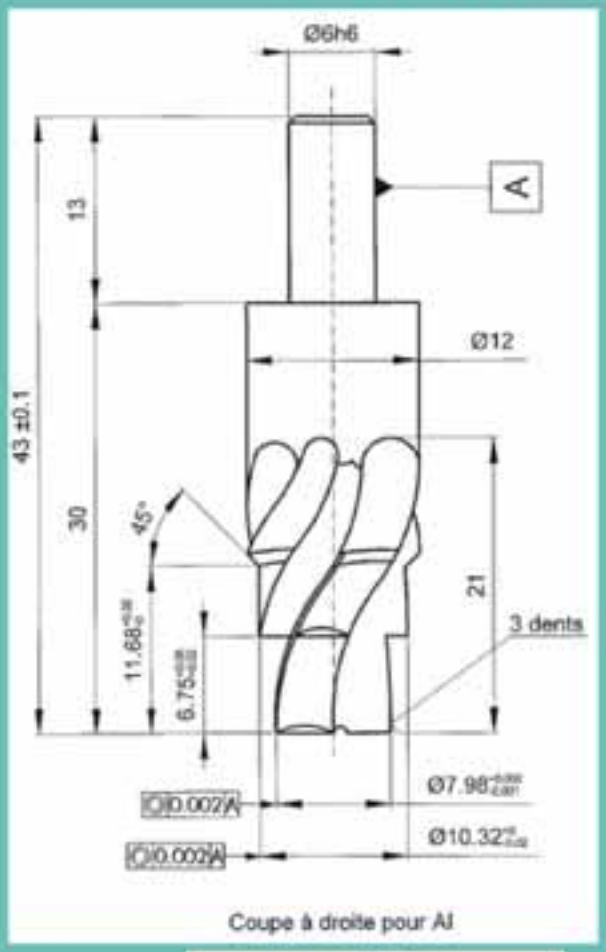
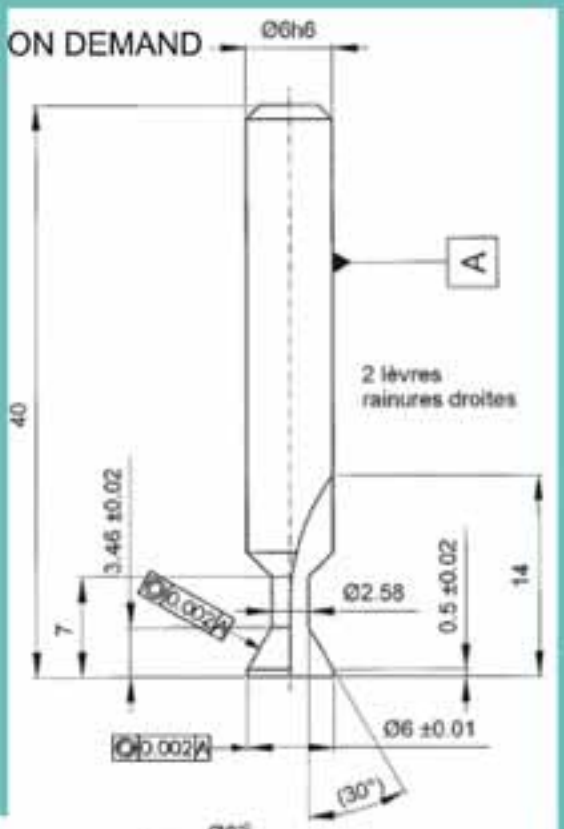
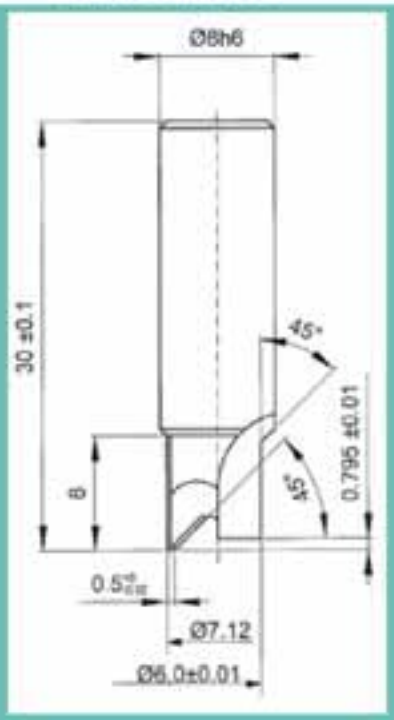
FABRICANT D'OUTILS SPECIAUX SUR DEMANDE

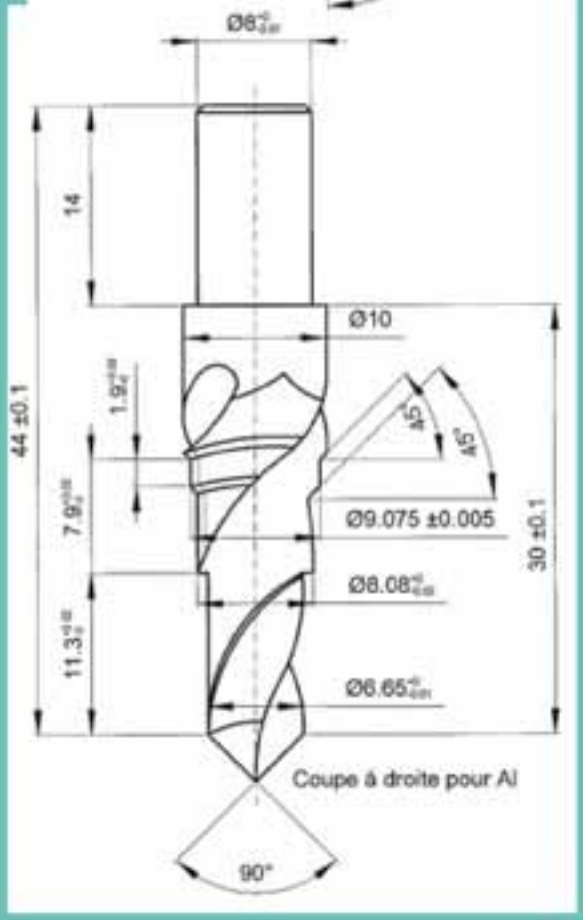
HERSTELLER VON SPEZIAL WERKZEUG AUF ANFRAGE

SPECIAL TOOLS MANUFACTURER ON DEMAND









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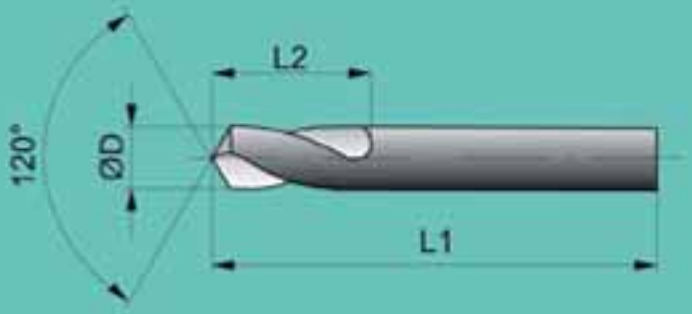
MECHES A CENTRER EN METAL DUR POUR NC
VOLLHARTMETALL-NC-ANBOHRER
SOLID CARBIDE NC-CENTER DRILL

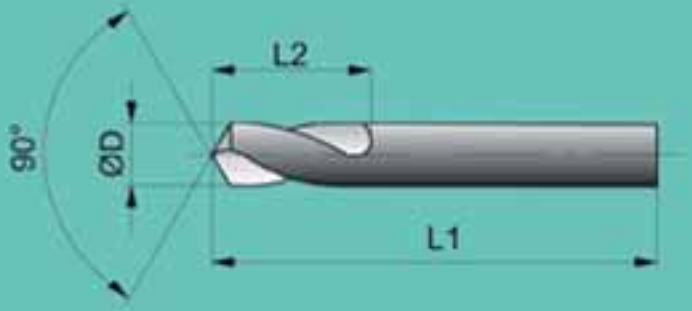
Type 220

Coupe à droite
Rechts schneidend
Right cutting



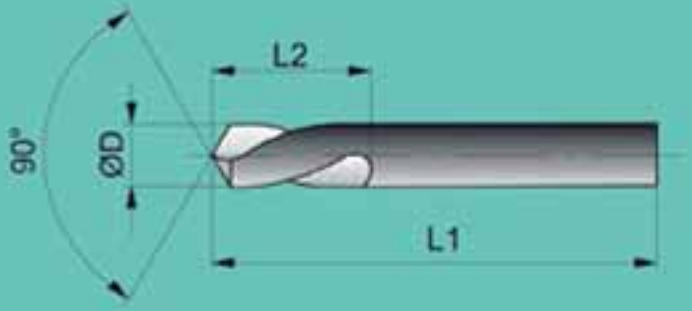
Type 221

Coupe à droite
Rechts schneidend
Right cutting



Type 223

Coupe à gauche
Links schneidend
Left cutting



D [mm]	L1 [mm]	L2 [mm]
2	38	8
3	45	10
4	50	12
5	55	12
6	60	15
8	70	20
10	75	20
12	80	25

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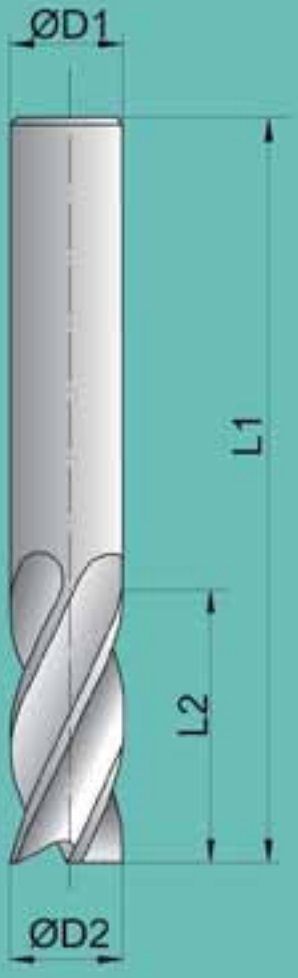
Vollhartmetallwerkzeug - Hersteller seit 1969
Manufacturer carbide cutting tools since 1969

FRAISES À RAINURER EN MÉTAL DUR K10
SCHAFTFRÄSER AUS VOLLHARTMETALL K10
SLOTTING END MILLS OF CARBIDE K10

Type 300 — Coupe au centre, 2 lèvres / Schnitt im Zentrum, 2-Lippig / Center-cutting, 2 flutes

Type 301 — Coupe au centre, 3 lèvres / Schnitt im Zentrum, 3-Lippig / Center-cutting, 3 flutes

Type 302 — 4 lèvres / 4-Lippig / 4 flutes



ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
2.0	38	7	2.0
2.5	38	8	2.5
3.0	38	8	3.0
4.0	43	11	4.0
5.0	47	13	5.0
6.0	57	13	6.0
8.0	63	19	8.0
10.0	72	22	10.0
12.0	83	26	12.0
14.0	83	26	14.0
16.0	89	32	16.0
18.0	92	32	18.0
20.0	101	38	20.0

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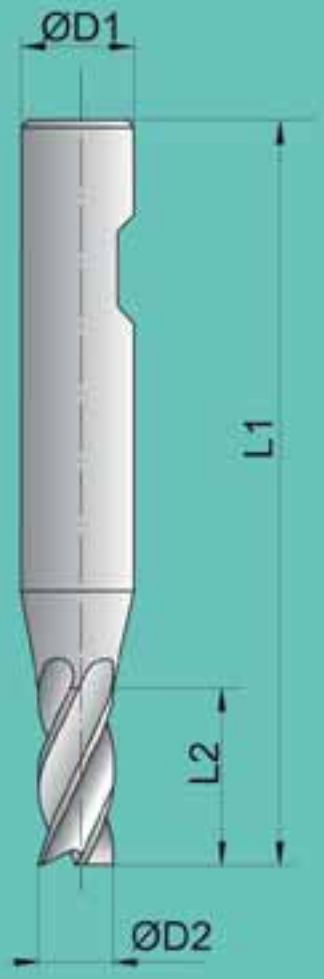
FRAISES À RAINURER EN MÉTAL DUR K10
SCHAFTFRÄSER AUS VOLLHARTMETALL K10
SLOTTING END MILLS OF CARBIDE K10

AVEC PLAT WELDON
MIT SPANNFLÄCHE
WITH CLAMPING

Type 310

Coupe au centre, 2 lèvres
Schnitt im Zentrum, 2-Lippig
Center-cutting, 2 flutes

ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
1.5	47	3.0	6.0
2.0	48	4.0	6.0
2.5	49	5.0	6.0
3.0	49	5.0	6.0
4.0	51	7.0	6.0
5.0	52	8.0	6.0
6.0	52	8.0	6.0
8.0	55	11.0	8.0
10.0	63	13.0	10.0
12.0	73	16.0	12.0



Type 311

Coupe au centre, 3 lèvres
Schnitt im Zentrum, 3-Lippig
Center-cutting, 3 flutes

ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
2.0	51	7.0	6.0
2.5	52	8.0	6.0
3.0	52	8.0	6.0
4.0	55	11.0	6.0
5.0	57	13.0	6.0
6.0	57	13.0	6.0
8.0	63	19.0	8.0
10.0	72	22.0	10.0
12.0	83	26.0	12.0

Type 312

4 lèvres
4-Lippig
4 flutes

ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
3.0	52	8.0	6.0
4.0	55	11.0	6.0
5.0	57	13.0	6.0
6.0	57	13.0	6.0
8.0	63	19.0	8.0
10.0	72	22.0	10.0
12.0	83	26.0	12.0

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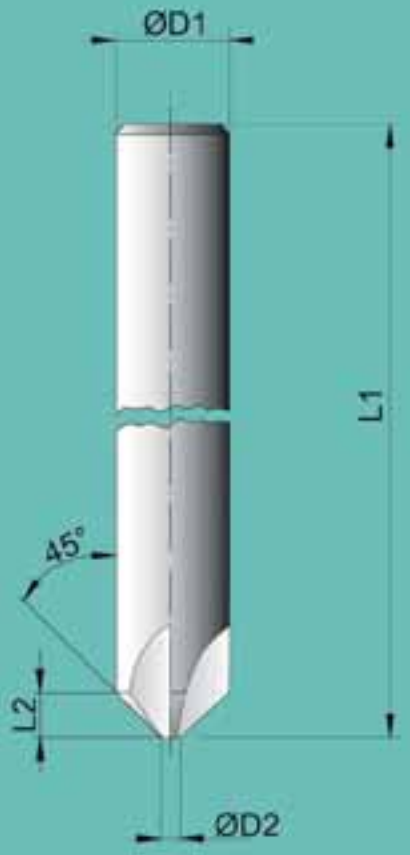
FRAISES A ANGLER EN MÉTAL DUR
VOLLHARTMETALL FASEN-SCHAFTFRÄSER
SOLID CARBIDE COUNTERSINK

Type 327

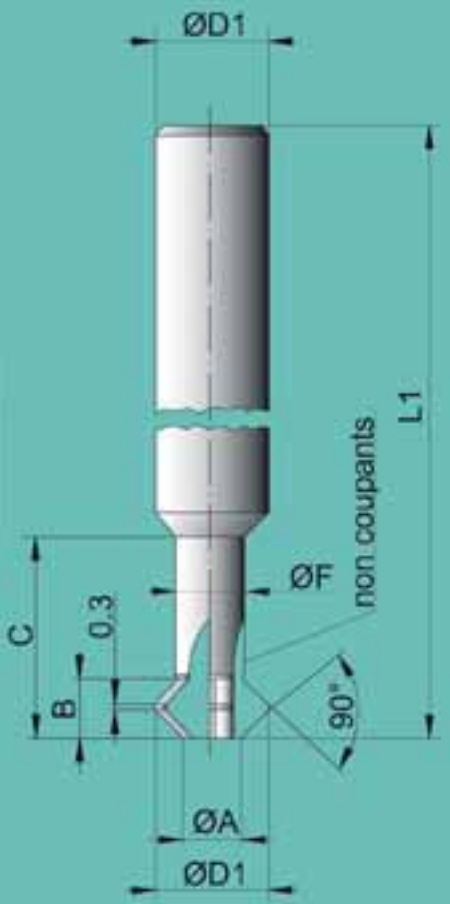
ØD1 [mm]	L1 [mm]	L2 [mm]	ØD2 [mm]	Z
4	50	1.5	1	4
6	60	2.3	1.5	4
8	70	3	2	4
10	75	3.8	2.5	4
12	80	4.5	3	4
16	90	7	3.5	6
20	100	8	4	6



FRAISES A ANGLER ISOCELES EN MÉTAL DUR
VOLLHARTMETALL PRISMEN-SCHAFTFRÄSER
SOLID CARBIDE DOUBLE ANGLE MILLING

Type 328

ØD1 [mm]	L1 [mm]	B [mm]	C [mm]	ØA [mm]	ØF [mm]
6	60	2.5	12	3.5	4
8	70	4	15	4	5
10	75	5	18	5	6
12	80	6	21	6	7



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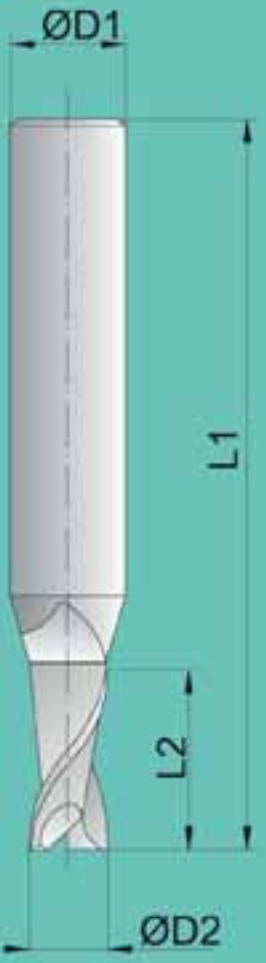
MICRO-FRAISES 2 DENTS
MIKRO PRÄZISIONSFRÄSER 2 ZÄHNE
MINIATURE END-MILLS 2 TEETH

PRECISION±0.01

Type 362

ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
0.3	39	1.0	3
0.4	39	1.5	3
0.5	39	1.5	3
0.6	39	1.5	3
0.7	39	2.0	3
0.8	39	2.0	3
0.9	39	2.5	3
1.0	39	3.0	3
1.1	39	3.0	3
1.2	39	4.0	3
1.3	39	4.0	3
1.4	39	4.0	3
1.5	39	4.0	3
1.6	39	5.0	3
1.7	39	5.0	3
1.8	39	5.0	3
1.9	39	5.0	3
2.0	39	5.0	3
2.1	39	6.0	3
2.2	39	6.0	3
2.3	39	6.0	3
2.4	39	6.0	3
2.5	39	7.0	3
2.6	39	7.0	3
2.7	39	7.0	3
2.8	39	7.0	3
2.9	39	7.0	3
3.0	44	10.0	4



RAINURAGE - GRAVURE

SLOTTING - ENGRAVING

PERCAGE A FOND PLAT

FLAT BOTTOM BORING

Exemple de commande : *362-08 pour Ø 0.8mm 2 dents*
Bestellung Beispiel : *362-08 für Ø 0.8mm 2 Zähne*
Order sample : *362-08 for Ø 0.8mm 2 teeths*

Revêtement sur demande
Beschichtung auf Anfrage
Coating on demande

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Manufacturer carbide cutting tools since 1969

MICRO-FRAISES 3 DENTS
MIKRONPRÄZISIONSFRÄSER 3 ZÄHNE
MINIATURE END-MILLS 3 TEETH

PRECISION±0.01

Type 363

ØD2 [mm]	L1 [mm]	L2 [mm]	ØD1 [mm]
0.5	39	1.5	3
0.6	39	1.5	3
0.7	39	2.0	3
0.8	39	2.0	3
0.9	39	2.5	3
1.0	39	3.0	3
1.1	39	3.0	3
1.2	39	4.0	3
1.3	39	4.0	3
1.4	39	4.0	3
1.5	39	4.0	3
1.6	39	5.0	3
1.7	39	5.0	3
1.8	39	5.0	3
1.9	39	5.0	3
2.0	39	5.0	3
2.1	39	6.0	3
2.2	39	6.0	3
2.3	39	6.0	3
2.4	39	6.0	3
2.5	39	7.0	3
2.6	39	7.0	3
2.7	39	7.0	3
2.8	39	7.0	3
2.9	39	7.0	3
3.0	44	10.0	4

RAINURAGE - GRAVURE

SLOTTING - ENGRAVING

PERCAGE A FOND PLAT

FLAT BOTTOM BORING

Exemple de commande : *363-08 pour Ø 0.8mm 3 dents*
Bestellung Beispiel : *363-08 für Ø 0.8mm 3 Zähne*
Order sample : *363-08 for Ø 0.8mm 3 teeths*

Revêtement sur demande
Beschichtung auf Anfrage
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PORTE-CENTREUR
STAHLHALTER
CENTERING TOOL-HOLDER

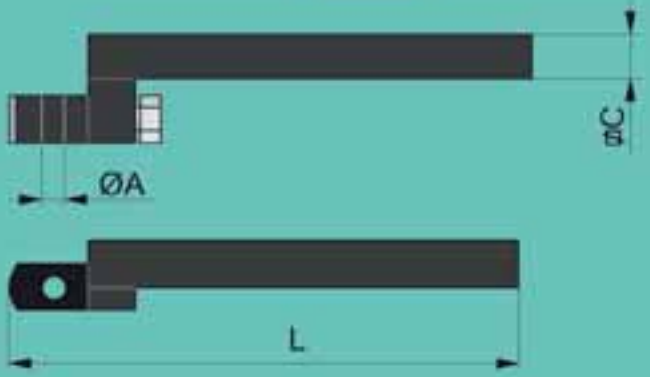
Type 400

Gauche
Links
Left

C [mm]	A [mm]	L [mm]
6 x 6	2	132
6 x 6	3	132
7 x 7	2	140
7 x 7	3	140
8 x 8	2	140
8 x 8	3	140
10 x 15	2	150
10 x 15	3	150
10 x 15	4	150

Type 401

Gauche
Links
Left



C [mm]	A [mm]	L [mm]
7 x 7	3	135
7 x 7	4	135
8 x 8	3	146
8 x 8	4	146
8 x 8	5	146
10 x 10	4	150
10 x 10	5	150
10 x 10	6	150
10 x 10	7	150
12 x 12	4	150
12 x 12	6	150
12 x 12	8	150
14 x 14	4	160
14 x 14	6	160
14 x 14	8	160

Type 413

Droite
Rechts
Right

C [mm]	A [mm]
10 x 10	4
10 x 10	5
10 x 10	6
12 x 12	4
12 x 12	5
12 x 12	6
16 x 16	5
16 x 16	6
16 x 16	8

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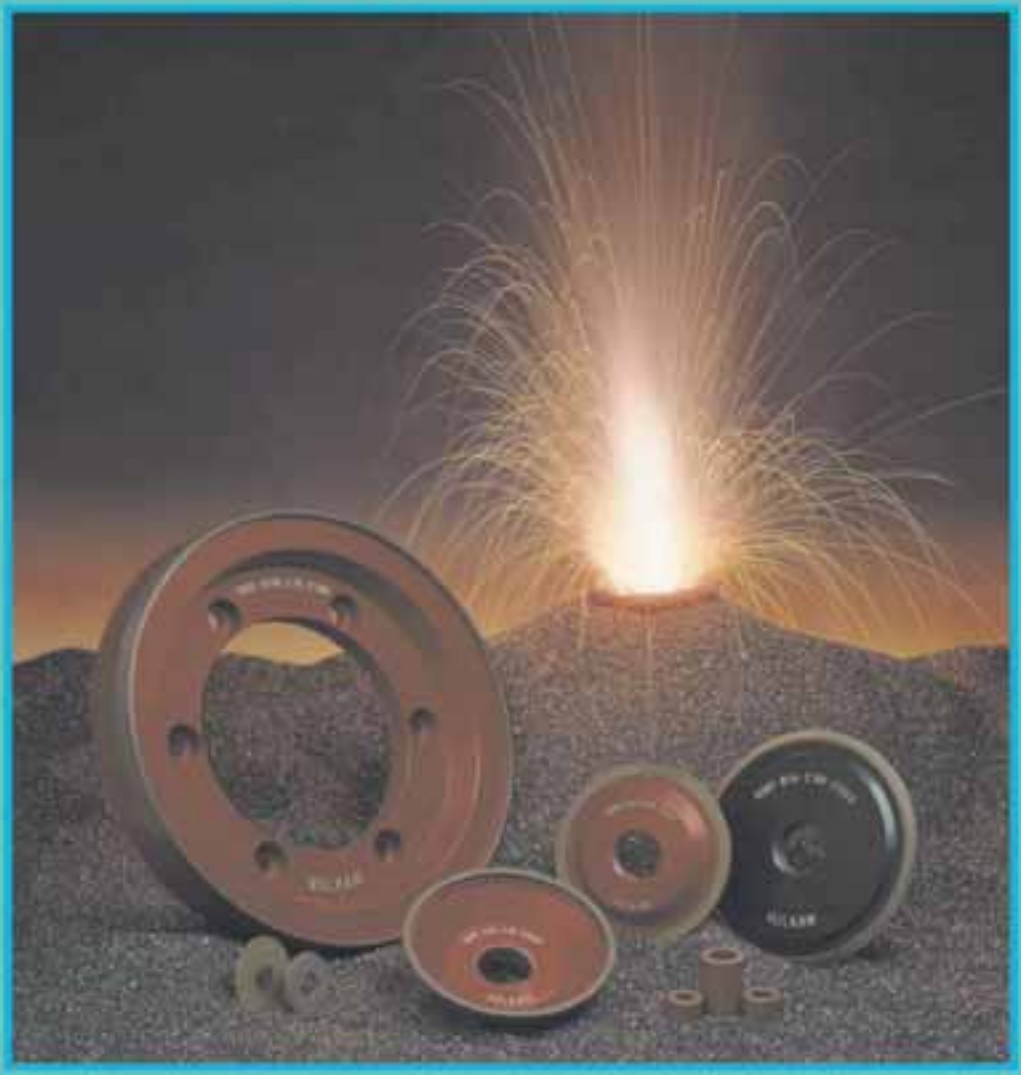

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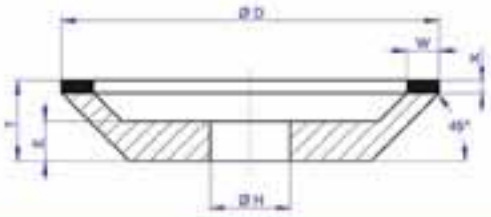
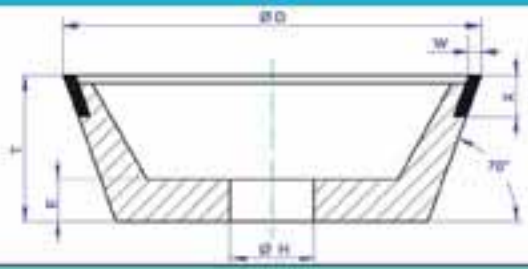
MEULES DIAMANTEES / MEULES AU NITRURE DE BORE (CBN)
DIAMANTSCHLEIFSCHEIBEN / BORNITRIDSCHLEIFSCHEIBEN (CBN)
DIAMOND GRINDING WHEELS / BORON NITRIDE GRINDING WHEELS (CBN)

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
12A2 45°		Pour l'affûtage d'outils de coupe multiple avec plaquettes en métal dur. Zum Schleifen von hartmetallbestückten Schneid-Werkzeugen. For the grinding of cutting tools with brazed tips.

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	E
75 × 3 × 4	D10 D15	C75	E505KH	20	25	10
75 × 3 × 4	D20 D25	C75	E505E	20	25	10
75 × 3 × 4	D46 D54 D64 D76 D91 D126	C75	E545P	20	25	10
100 × 3 × 4	D20	C75	E505E	20	25	10
100 × 3 × 4	D46 D107	C75	E545P	20	25	10

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
11V9		Pour l'affûtage d'outils avec plaquettes en métal dur permettant aussi le détallonage du corps acier. Zum Schleifen von hartmetallbestückten Schneid-Werkzeugen, auch mit bis 50% Anteil an Schaft-Material. For the grinding of cutting tools with brazed tips allowing for grinding of the steels shanks.

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	E
75 × 2 × 10	D15 D64 D126	C75	E503S	20	30	10
100 × 2 × 10	D64 D126	C75	E503S	20	35	10
100 × 3 × 10	D107 D126	C75	E503S	20	35	10
125 × 2 × 10	D20	C75	E503S	20	40	10
125 × 3 × 10	D64 D91 D126 D151	C75	E503S	20	40	10
150 × 2 × 10	D64 D91 D126	C75	E503S	20	50	10
150 × 3 × 10	D64 D91 D126	C75	E503S	20	50	10

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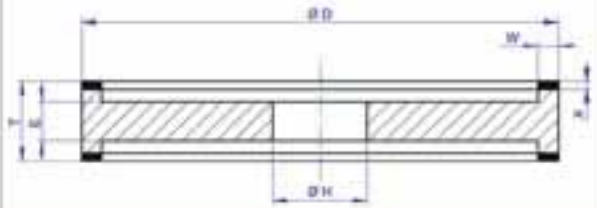
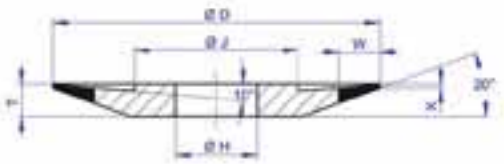
MEULES DIAMANTEES / MEULES AU NITRURE DE BORE (CBN)
DIAMANTSCHLEIFSCHEIBEN / BORNITRIDSCHLEIFSCHEIBEN (CBN)
DIAMOND GRINDING WHEELS / BORON NITRIDE GRINDING WHEELS (CBN)

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
9A3		Pour l'affûtage de burins de tournage et de décolletage avec plaquettes en métal dur. Zum Schleifen von präzisen hartmetallbestückten Drehmeisseln und Automatenstählen. For the grinding of turning and part-off tools for automatics (carbide tipped).

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	E
125 × 6 × 2	D20 D30	C75	E505E	12	22	10
125 × 6 × 2	D91 D126	C75	E505P	12	22	10
150 × 6 × 2	D20 D30	C75	E545E	16	25/35	14
150 × 6 × 2	D91 D126	C75	E505P	16	25/35	14
175 × 4 × 2	D20 D30	C75	E545E	20	25/35	14
175 × 4 × 2	D91 D126	C75	E503P	20	25/35	14
175 × 6 × 2	D15 D20 D30	C75	E503E	20	25/35	14
175 × 6 × 2	D91 D126	C75	E503P	20	25/35	14

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
4BT9		Taillage du métal dur. Trennen / Formschleifen. For the grinding of solid carbide tools.

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	J
75 × 6 × 0.3	D15 D91	C75	E510Q	20	8	40
75 × 6 × 0.3	D20	C75	E505E	20	8	40
75 × 6 × 0.3	D30 D46 D54	C75	E503P	20	8	40
75 × 6 × 0.5	D15	C75	E505E	20	8	40
75 × 6 × 0.5	D20	C75	E510Q	20	8	40
75 × 6 × 0.5	D46	C75	E503P	20	8	40
75 × 6 × 0.5	D91 D126	C75	E503S	20	8	40

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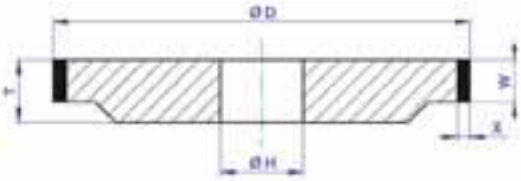
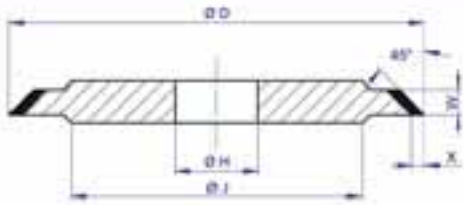
MEULES DIAMANTEES / MEULES AU NITRURE DE BORE (CBN)
DIAMANTSCHLEIFSCHEIBEN / BORNITRIDSCHLEIFSCHEIBEN (CBN)
DIAMOND GRINDING WHEELS / BORON NITRIDE GRINDING WHEELS (CBN)

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
1A1		Pour rectification plane et cylindrique d'outils en métal dur. Zum Flach- und Rundschleifen von hartmetallbestückten Werzeugen. For grinding flat and cylindrical carbide tools.

D × W × X [mm]	Grain Kornung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T
75 × 4 × 3	D20 D46 D107	C75	E505E E545P E545P	20	8
100 × 4 × 3	D25 D46 D107	C75	E505E E545P E503P	20	8
125 × 3 × 6	D46	C75	E503P	20	10
125 × 5 × 6	D46	C75	E545P	20	10
125 × 6 × 6	D46	C75	E545P	20	10
150 × 5 × 6	D46	C75	E545P	20	10
150 × 6 × 6	D46	C75	E545P	20	10
150 × 8 × 6	D46	C75	E545P	20	10
200 × 8 × 3	D126	C75	E545P	50	10
250 × 10 × 3	D126	C75	E545P	70	12
300 × 10 × 3	D20 D46 D126	C75	E545P E545P E545P	127	20
300 × 20 × 3	D91 D126	C75	E545P E545P E545P	127	20

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
1V1 45°		Rectification du métal dur en passe profonde sur machine CNC. Zum Schleifen von Hartmetallen für tiefe Operationen auf CNC-Maschinen. For grinding of solide carbide with deep cuts on CNC machines.

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	J
75 × 4 × 3	D46 D64 D91 D126	C75	E503S	20	10	50
75 × 6 × 5	D46 D64 D91 D126	C75	E503S	20	10	50
100 × 6 × 8	D46 D64 D91 D126	C75	E503S	20	10	70

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PRECITOOL SA

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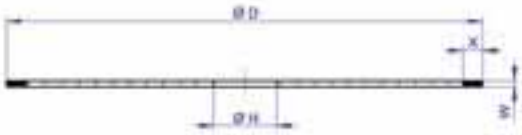
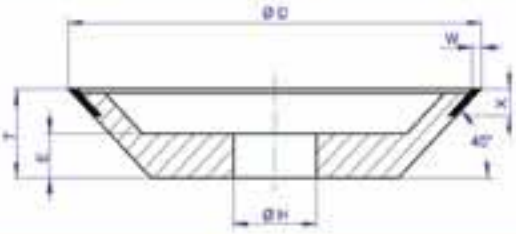
Fabricant d'outillage carbure depuis 1969
Vollhartmetallwerkzeug - Hersteller seit 1969
Manufacturer carbide cutting tools since 1969

MEULES DIAMANTEES / MEULES AU NITRURE DE BORE (CBN)
DIAMANTSCHLEIFSCHEIBEN / BORNITRIDSCHLEIFSCHEIBEN (CBN)
DIAMOND GRINDING WHEELS / BORON NITRIDE GRINDING WHEELS (CBN)

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
1A1R		Tronçonnage de barreaux en métal dur, HSS ou acier trempé. Trennen von Hartmetallstäben, HSS oder gehärtetem Stahl. Slitting dics for solid carbide, speed steel or steel..

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H
40 × 1 × 20	D76	C150	E510P	6 / 10
50 × 1 × 20	D76	C150	E510P	10
75 × 0.6 × 5	D126	C150	E510P	10 / 20
75 × 0.7 × 5	D126	C150	E510P	10 / 20
75 × 0.8 × 5	D126	C150	E510P	10 / 20
75 × 1 × 5	D126	C150	E510P	10 / 20
80 × 0.8 × 5	D126	C150	E510P	10 / 20
80 × 1 × 5	D126	C150	E510P	10 / 20
100 × 1 × 5	D126	C150	E510P	10 / 20

Forme Form Form	Croquis Skizze Style	Usage Anwendung Application
12V9		Pour l'affûtage d'outils avec plaquettes en métal dur permettant aussi le détallonage du corps acier. Zum Schleifen von hartmetallbestückten Schneid-Werkzeugen, auch mit bis 50% Anteil an Schaft-Material. For the grinding of cutting tools with brazed tips allowing for grinding of the steels shanks.

D × W × X [mm]	Grain Körnung Gritt	Conc. Konz. Conc.	Liant Bindung Bond	H	T	J
75 × 2 × 6	D20	C50	E505E	20	20	10
75 × 2 × 6	D107	C75	E503S	20	20	10
100 × 2 × 6	D20	C50	E505E	20	20	10
100 × 2 × 6	D107	C75	E503S	20	20	10

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Vollhartmetallwerkzeug - Hersteller seit 1969

Manufacturer carbide cutting tools since 1969

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