

APPLITEC

# ECO-Line



**Applitec Moutier S.A.**  
Ch. Nicolas-Junker 2  
CH-2740 Moutier

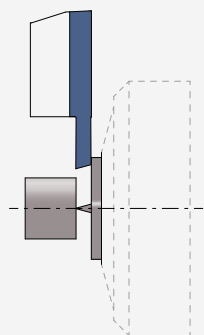


**APPLITEC**  
SWISS TOOLING

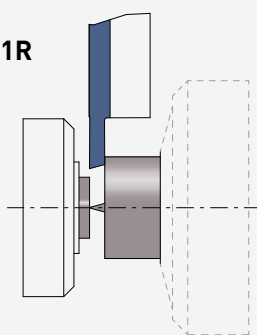
Tél. +41 32 494 60 20  
Fax +41 32 493 42 60  
[www.applitec-tools.com](http://www.applitec-tools.com)



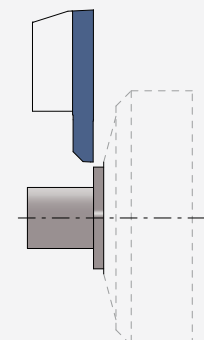
261



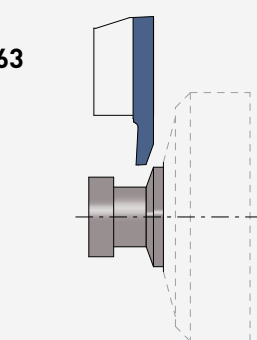
251R



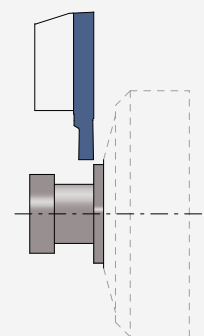
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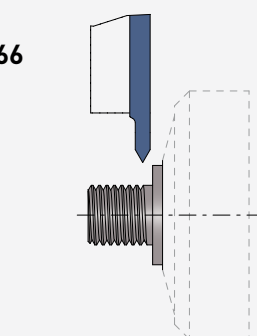
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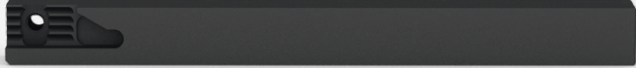
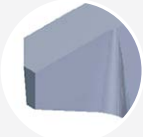
264



266



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**NEW**

## AP302

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

- excellente nuance universelle
- 1<sup>er</sup> choix pour l'usinage des aciers, aciers inoxydables et alliages de titane
- très bonne résistance à la température

- beste Universalsorte
- für die Bearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bestens geeignet
- sehr gute Warmfestigkeit

- best universal grade
- first choice for steel, stainless steel and titanium alloys machining
- very good heat resistance

## AP202

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

- nuance particulièrement adaptée aux faibles vitesses de coupe

- besonders geeignete Sorte für niedrige Schnittgeschwindigkeiten

- grade particularly suitable for low cutting speeds

## N (μK20)

non revêtu  
unbeschichtet  
uncoated

- nuance micro-grain tenace
- supporte les coupes interrompues et autres conditions d'usinage défavorables

- zähe Feinkornsorte
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen geeignet

- tough micro-grain grade
- suitable for interrupted cut and other unfavourable machining conditions

**NEW**

## AH302

μK10 + revêtement PVD  
μK10 + PVD Beschichtung  
μK10 + PVD coating

- nuance très résistante à l'usure
- pour l'usinage en finition dans des conditions favorables des aciers, aciers inoxydables et alliages de titane

- sehr verschleißfeste Sorte
- für die Feinbearbeitung von Stahl, rostfreiem Stahl und Titanlegierungen bei guten Bearbeitungsbedingungen

- very wear resistant grade
- for light machining of steel, stainless steel and titanium alloys under favourable machining conditions

**NEW**

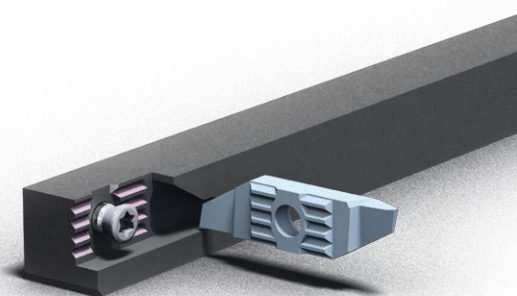
## HN (μK10)

non revêtu  
unbeschichtet  
uncoated

- nuance micro-grain très résistante à l'usure
- recommandé pour l'usinage du titane faiblement allié
- déconseillé en cas de coupe interrompue et autres conditions d'usinage défavorables

- verschleißfeste Feinkornsorte
- empfehlenswert für die Bearbeitung von niedrig legiertem Titan
- für unterbrochene Schnitte und andere ungünstige Bearbeitungsbedingungen nicht geeignet

- wear resistant micro-grain grade
- suitable for the machining of low alloyed titanium
- not suitable for interrupted cut and other unfavourable machining conditions



*Patented rigid clamping system*

## Paramètres de coupe indicatifs

## Empfohlene Schnittwerte

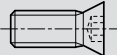
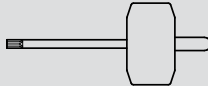
## Standard machining data

| Matière<br>Werkstoff<br>Material                                           | Tournage<br>Drehen<br>Turning |             | Tronçonnage<br>Abstechen<br>Cut off |             |
|----------------------------------------------------------------------------|-------------------------------|-------------|-------------------------------------|-------------|
|                                                                            | VC<br>(m/min)                 | F<br>(mm/U) | VC<br>(m/min)                       | F<br>(mm/U) |
| Acier de décolletage<br>Automatenstahl<br>Free-cutting steel               | 120 - 200                     | 0.01 - 0.20 | 80 - 150                            | 0.01 - 0.15 |
| Acier<br>Stahl<br>Steel < 600 N/mm <sup>2</sup>                            | 80 - 160                      | 0.01 - 0.18 | 70 - 120                            | 0.01 - 0.12 |
| Acier<br>Stahl<br>Steel < 800 N/mm <sup>2</sup>                            | 60 - 120                      | 0.01 - 0.15 | 60 - 100                            | 0.01 - 0.10 |
| Acier<br>Stahl<br>Steel < 800 N/mm <sup>2</sup>                            | 50 - 100                      | 0.01 - 0.12 | 40 - 80                             | 0.01 - 0.08 |
| Acier inoxydable<br>Rostfreistahl<br>Stainless steel                       | 60 - 120                      | 0.01 - 0.15 | 60 - 100                            | 0.01 - 0.08 |
| Aluminium                                                                  | 180 - 800                     | 0.01 - 0.30 | 150 - 300                           | 0.01 - 0.20 |
| Titane<br>Titan<br>Titanium                                                | 30 - 70                       | 0.01 - 0.12 | 30 - 50                             | 0.01 - 0.06 |
| Cuivre, laiton, bronze<br>Kupfer, Messing, Bronze<br>Copper, brass, bronze | 100 - 500                     | 0.01 - 0.30 | 100 - 300                           | 0.01 - 0.20 |

## Accessoires

## Zubehör

## Accessories

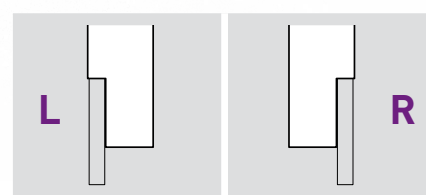
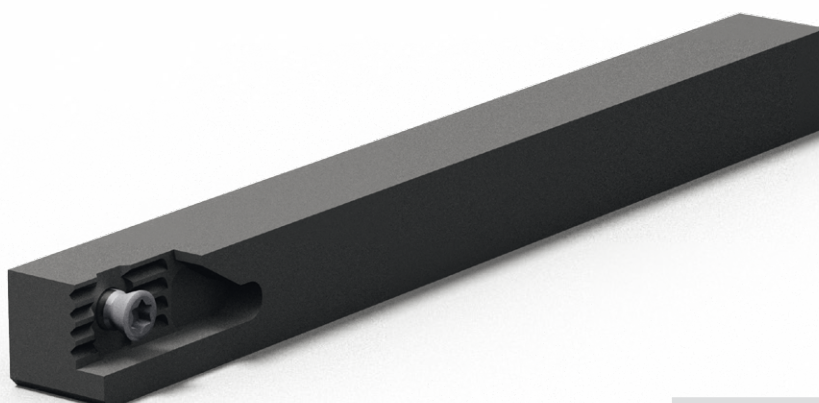
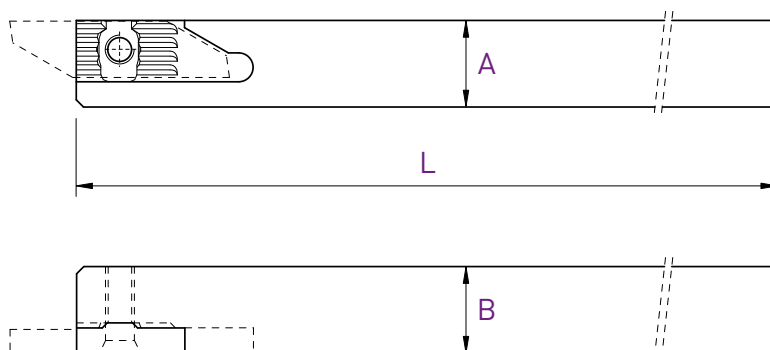
| Porte-outils<br>Halter<br>Holders |  |  | Option      |
|-----------------------------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|-------------|
| 250-... / 260-...                 | V-M4X9-T15                                                                          | C-T15                                                                                | SET-NM-TX15 |
| 250-8 / 260-8                     | V-M3.5X7-T15                                                                        |                                                                                      |             |
| 250RC / 260-C                     | V-M4X7.3-T15                                                                        |                                                                                      |             |

Recommandation de serrage  
Drehmoment Empfehlung  
Clamping recommendation

3.0 Nm



SET-NM-TX15



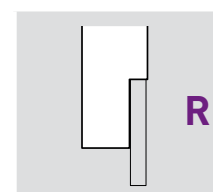
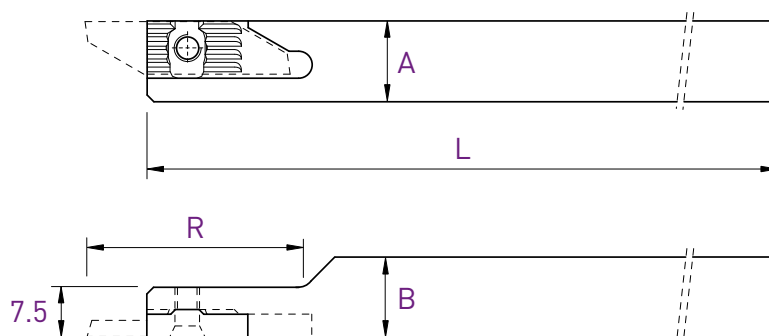
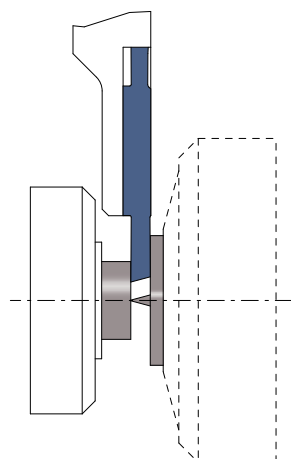
| A x B       | L   | Art. N°          | Art. N°          |
|-------------|-----|------------------|------------------|
| 8 x 8       | 115 | <b>250-8</b>     | <b>260-8</b>     |
| 10 x 10     | 115 | <b>250-10</b>    | <b>260-10</b>    |
| 12 x 12     | 130 | <b>250-12</b>    | <b>260-12</b>    |
| 12 x 12     | 90  | <b>250-12-90</b> | <b>260-12-90</b> |
| 12.7 x 12.7 | 130 | <b>250-12.7</b>  | <b>260-12.7</b>  |
| 16 x 16     | 130 | <b>250-16</b>    | <b>260-16</b>    |
| 16 x 16     | 75  | <b>250-16-75</b> | <b>260-16-75</b> |
| 20 x 20     | 120 | <b>250-20</b>    | <b>260-20</b>    |

Porte-outils

Halter

Holders

260-C



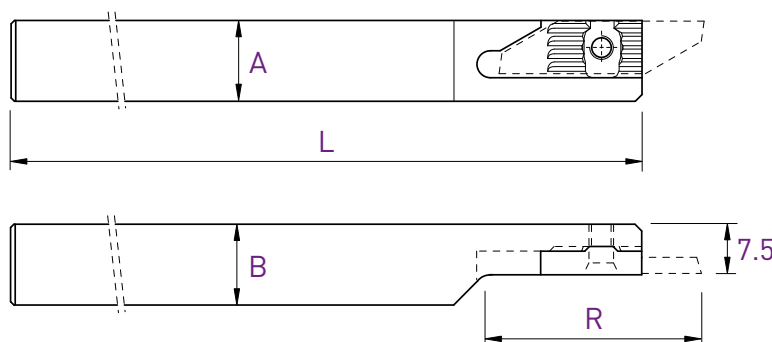
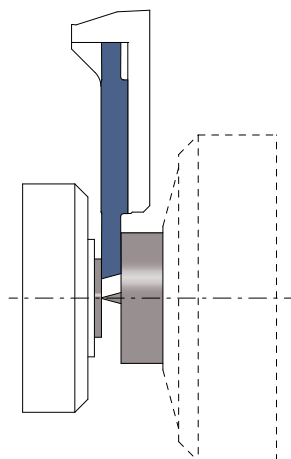
| A x B   | L   | R  | Art. N°  |
|---------|-----|----|----------|
| 12 x 12 | 130 | 30 | 260-C-12 |

Porte-outils

Halter

Holders

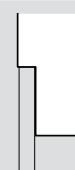
250RC



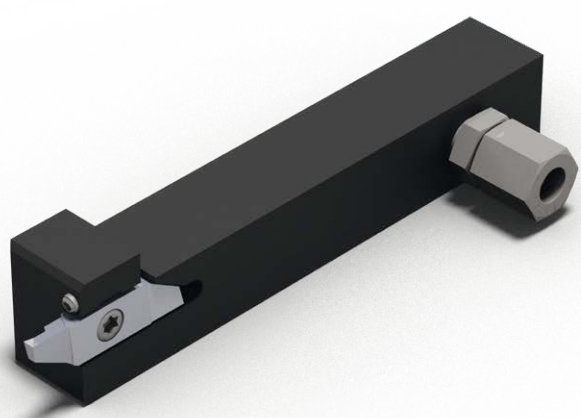
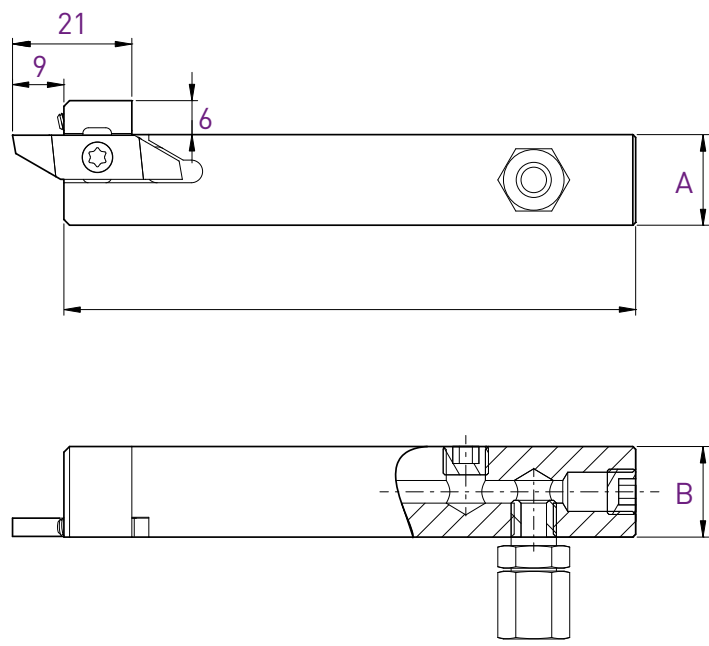
utiliser des plaquettes type 251R  
WSP Typ 251R verwenden  
use inserts type 251R

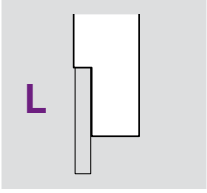
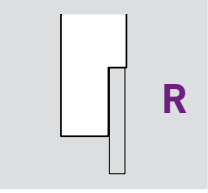
**L (R)**

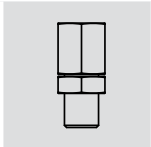
Coupe à droite déportée  
Versetztes Rechtsschneiden  
Right cut off line



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



|         |     |                                                                                       |                                                                                       |
|---------|-----|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
|         |     |  |  |
| A x B   | L   | Art. N°                                                                               | Art. N°                                                                               |
| 10 x 12 | 100 | 250-1012-JET                                                                          | 260-1012-JET                                                                          |
| 12 x 12 | 100 | 250-12-JET                                                                            | 260-12-JET                                                                            |
| 16 x 16 | 100 | 250-16-JET                                                                            | 260-16-JET                                                                            |
| 20 x 20 | 100 | 250-20-JET                                                                            | 260-20-JET                                                                            |

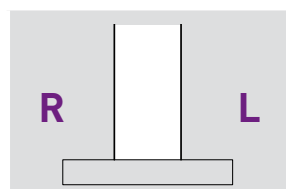
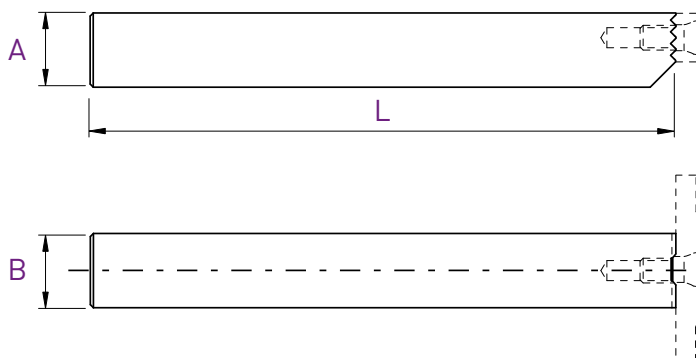
|                                                  |                                                                                       |                                                                                       |
|--------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| Pièces de rechange<br>Ersatzteile<br>Spare parts |  |  |
|                                                  | Art. N°                                                                               | Art. N°                                                                               |
| 250-JET/260-JET                                  | J-M8X1-D6                                                                             | JB-M8X1                                                                               |

Porte-outils

Halter

Holders

## 260/250F



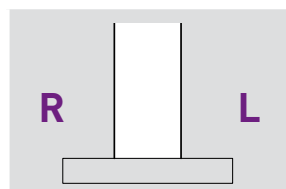
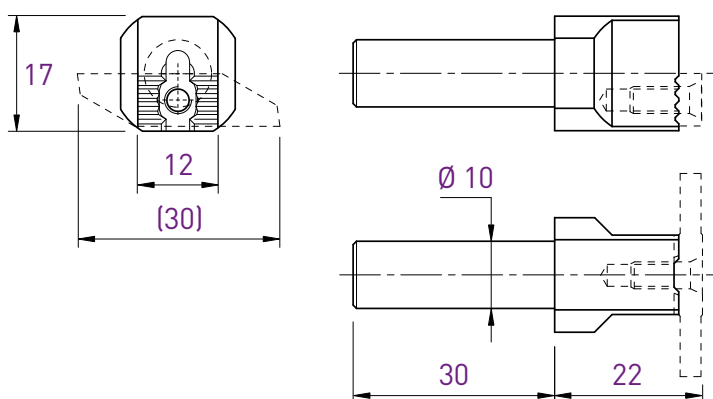
| A x B   | L   | Art. N°       |
|---------|-----|---------------|
| 10 x 12 | 120 | 260/250F-1012 |
| 12 x 12 | 120 | 260/250F-1212 |

Porte-outils

Halter

Holders

## 260/250-D



| Art. N°     |
|-------------|
| 260/250-D10 |

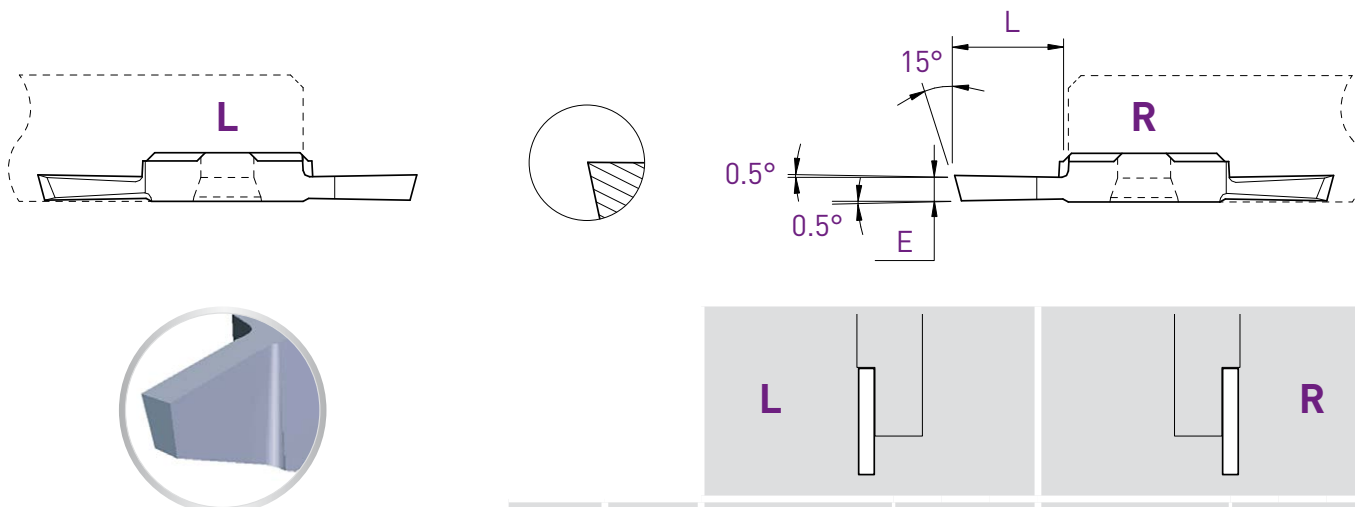
# ECO-Line

Tronçonnage

Abstechen

Cut off

251 / 261



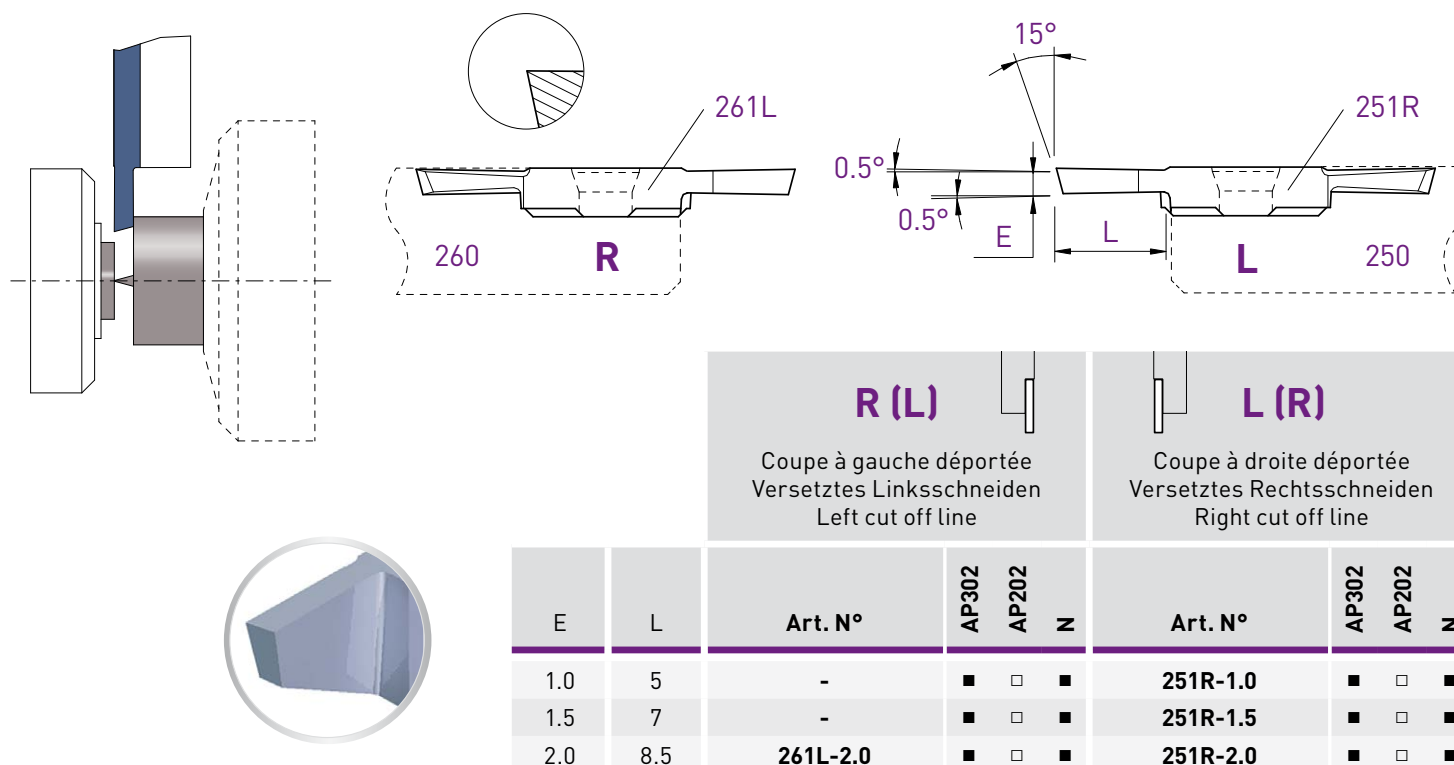
|     |     | L       |       |       | R       |       |       |
|-----|-----|---------|-------|-------|---------|-------|-------|
| E   | L   | Art. N° | AP302 | AP202 | Art. N° | AP302 | AP202 |
| 0.8 | 4   | 251-0.8 | ■     | □     | 261-0.8 | ■     | □     |
| 1.0 | 5   | 251-1.0 | ■     | □     | 261-1.0 | ■     | □     |
| 1.2 | 5   | 251-1.2 | ■     | □     | 261-1.2 | ■     | □     |
| 1.5 | 7   | 251-1.5 | ■     | □     | 261-1.5 | ■     | □     |
| 2.0 | 8.5 | 251-2.0 | ■     | □     | 261-2.0 | ■     | □     |
| 2.5 | 8.5 | 251-2.5 | ■     | □     | 261-2.5 | ■     | □     |

Coupe déportée

Versetztes Schneiden

Cut off line

261L / 251R



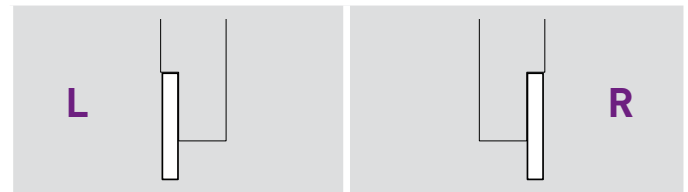
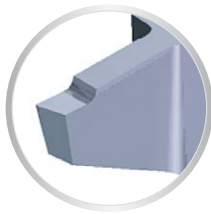
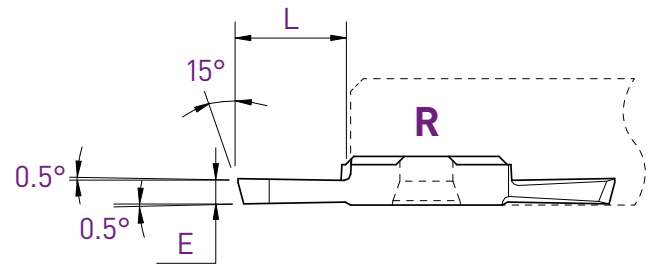
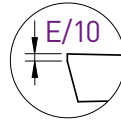
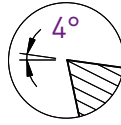
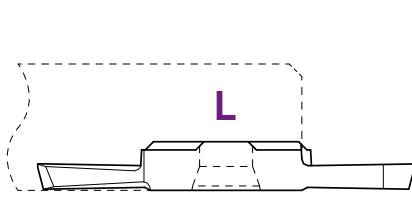
|     |     | R (L)    |       |       | L (R)    |       |       |
|-----|-----|----------|-------|-------|----------|-------|-------|
| E   | L   | Art. N°  | AP302 | AP202 | Art. N°  | AP302 | AP202 |
| 1.0 | 5   | -        | ■     | □     | 251R-1.0 | ■     | □     |
| 1.5 | 7   | -        | ■     | □     | 251R-1.5 | ■     | □     |
| 2.0 | 8.5 | 261L-2.0 | ■     | □     | 251R-2.0 | ■     | □     |

Tronçonnage

Abstechen

Cut off

## 251XF / 261XF



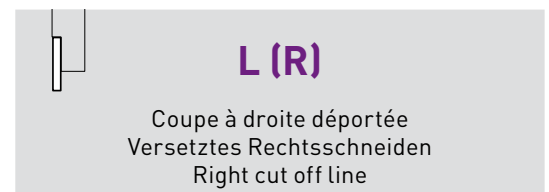
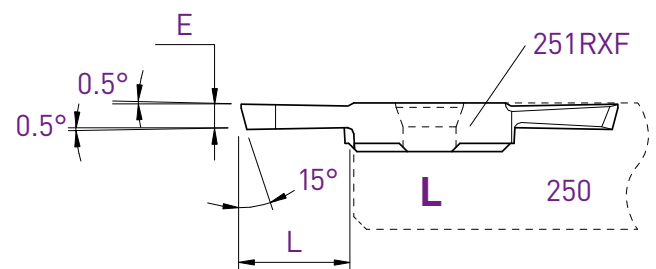
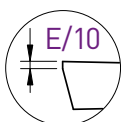
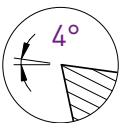
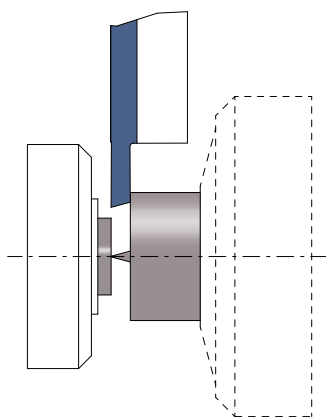
| E   | L   | Art. N°   | AP302 | AP202 | z | Art. N°   | AP302 | AP202 | z |
|-----|-----|-----------|-------|-------|---|-----------|-------|-------|---|
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| 2.0 | 8.5 | 251XF-2.0 | ■     | □     | ■ | 261XF-2.0 | ■     | □     | ■ |

Coupe déportée

Versetztes Schneiden

Cut off line

## 251RXF

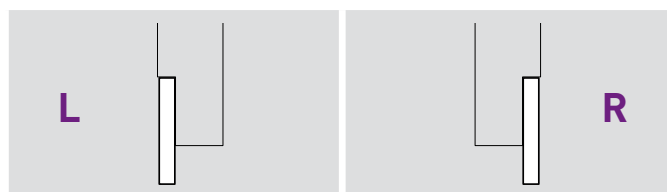
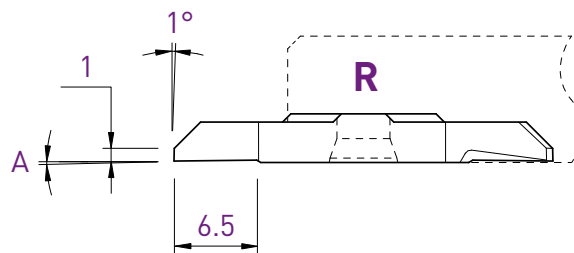
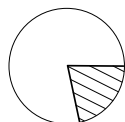
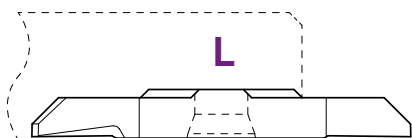


| E   | L   | Art. N°    | AP302 | AP202 | z |
|-----|-----|------------|-------|-------|---|
| 1.5 | 7   | 251RXF-1.5 | ■     | □     | ■ |
| 2.0 | 8.5 | 251RXF-2.0 | ■     | □     | ■ |

# ECO-Line

Tourneur avant  
Vorwärts drehen  
Front turning

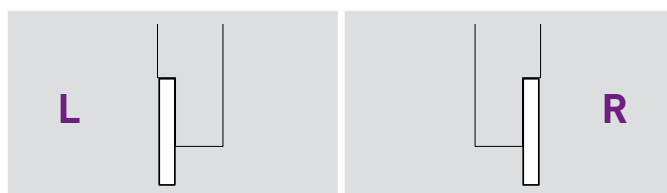
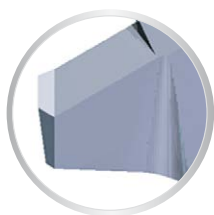
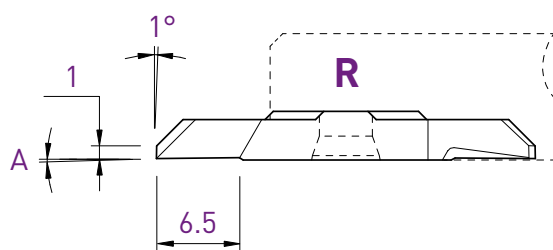
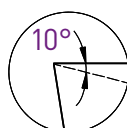
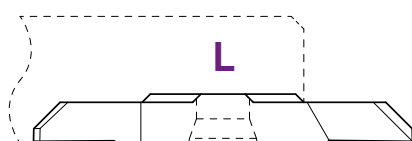
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| A  | Art. N° | AP302 AP202 Z |   |   | Art. N° | AP302 AP202 Z |   |   |
|----|---------|---------------|---|---|---------|---------------|---|---|
|    |         | ■             | □ | ■ |         | ■             | □ | ■ |
| 0° | 252     | ■             | □ | ■ | 262     | ■             | □ | ■ |
| 2° | 252-2°  | ■             | □ | ■ | 262-2°  | ■             | □ | ■ |

Tourneur avant  
Vorwärts drehen  
Front turning

252X / 262X

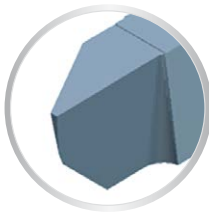
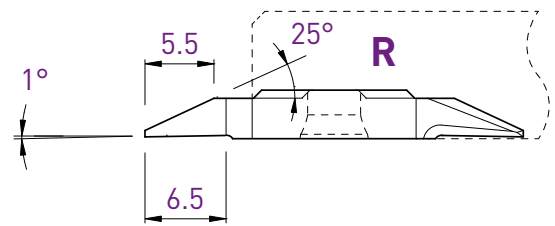
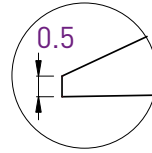
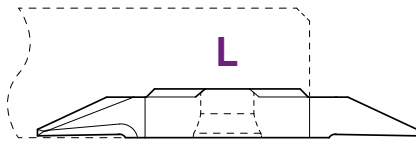


| A  | Art. N° | AP302 AP202 Z |   |   | Art. N° | AP302 AP202 Z |   |   |
|----|---------|---------------|---|---|---------|---------------|---|---|
|    |         | ■             | □ | ■ |         | ■             | □ | ■ |
| 0° | 252X    | ■             | □ | ■ | 262X    | ■             | □ | ■ |
| 2° | 252X-2° | ■             | □ | ■ | 262X-2° | ■             | □ | ■ |

**Tourneur avant**  
**Vorwärts drehen**  
**Front turning**



**252S / 262S**

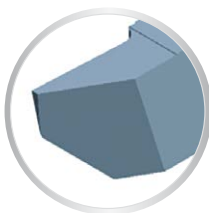
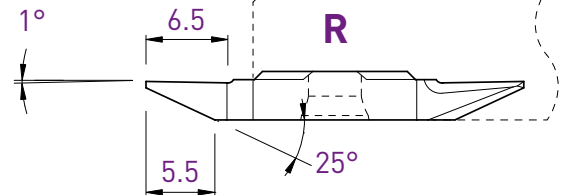
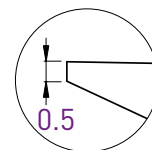
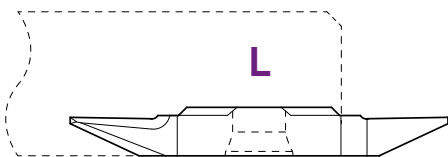


| L       |       |       |   | R       |       |       |   |
|---------|-------|-------|---|---------|-------|-------|---|
| Art. N° | AP302 | AP202 | Z | Art. N° | AP302 | AP202 | Z |
| 252S05  | ■     | □     | ■ | 262S05  | ■     | □     | ■ |

**Tourneur arrière**  
**Rückwärts drehen**  
**Back turning**



**253S / 263S**

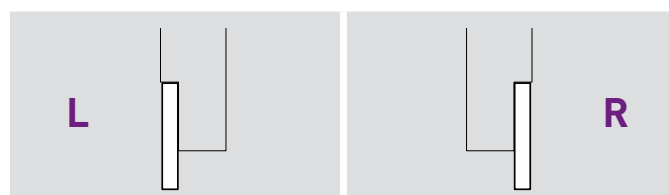
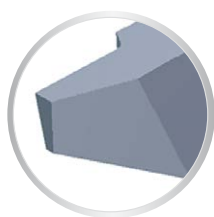
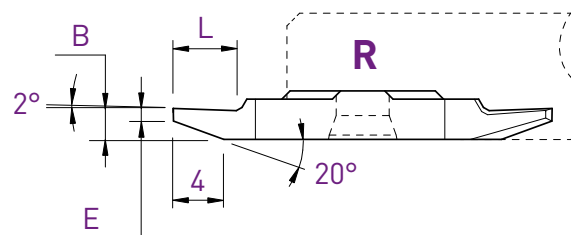
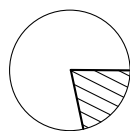
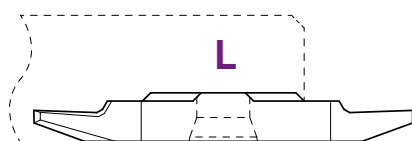


| L       |       |       |   | R       |       |       |   |
|---------|-------|-------|---|---------|-------|-------|---|
| Art. N° | AP302 | AP202 | Z | Art. N° | AP302 | AP202 | Z |
| 253S05  | ■     | □     | ■ | 263S05  | ■     | □     | ■ |

# ECO-Line

Tourneur arrière  
Rückwärts drehen  
Back turning

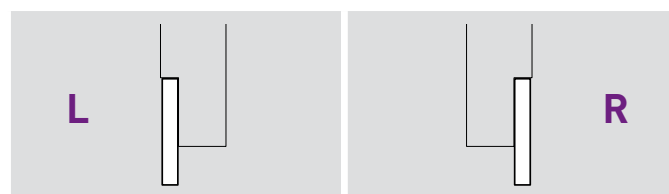
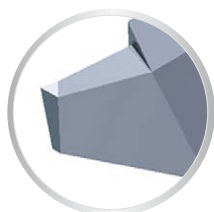
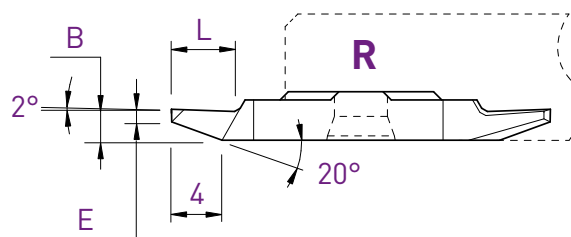
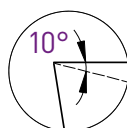
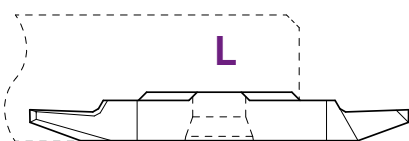
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| B   | E   | L | Art. N° | AP302 | AP202 | z | Art. N° | AP302 | AP202 | z |
|-----|-----|---|---------|-------|-------|---|---------|-------|-------|---|
| 2.0 | 0.5 | 4 | 253-0.5 | ■     | □     | ■ | 263-0.5 | ■     | □     | ■ |
| 2.5 | 1.0 | 5 | 253-1.0 | ■     | □     | ■ | 263-1.0 | ■     | □     | ■ |

Tourneur arrière  
Rückwärts drehen  
Back turning

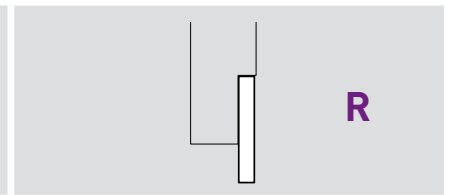
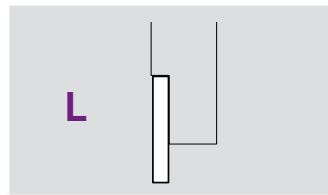
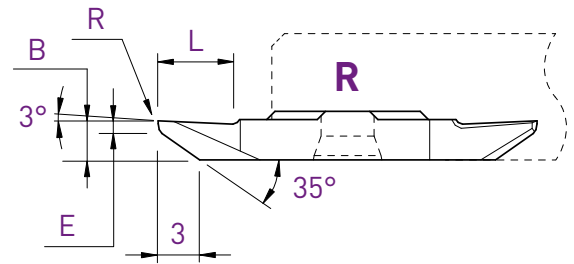
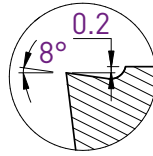
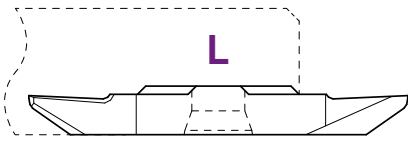
253X / 263X



| B   | E   | L | Art. N°  | AP302 | AP202 | z | Art. N°  | AP302 | AP202 | z |
|-----|-----|---|----------|-------|-------|---|----------|-------|-------|---|
| 2.0 | 0.5 | 5 | 253X-0.5 | ■     | □     | ■ | 263X-0.5 | ■     | □     | ■ |
| 2.5 | 1.0 | 5 | 253X-1.0 | ■     | □     | ■ | 263X-1.0 | ■     | □     | ■ |

Tourneur arrière  
Rückwärts drehen  
Back turning

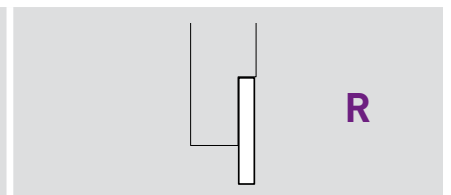
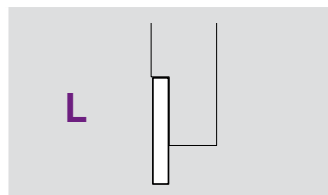
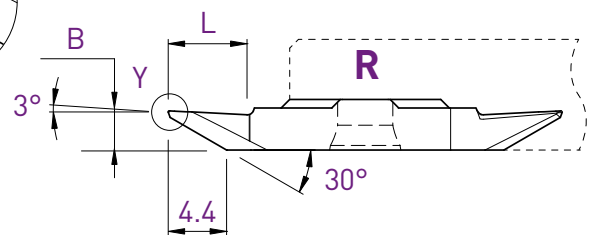
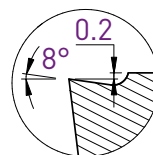
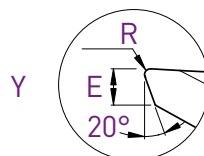
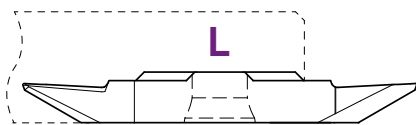
## 253VX-8° / 263VX-8°



| B   | E   | L | R    | Art. N°  | AP302 | AP202 | Z | Art. N°      | AP302 | AP202 | Z | AH302 | HN |
|-----|-----|---|------|----------|-------|-------|---|--------------|-------|-------|---|-------|----|
| 3.1 | 1.0 | 6 | 0    | 253VX-8° | ■     | □     | ■ | 263VX-8°     | ■     | □     | ■ |       |    |
| 3.1 | 1.0 | 6 | 0.08 | -        |       |       |   | 263VX-8°-R08 | ■     | □     | ■ | ■     | ■  |
| 3.1 | 1.0 | 6 | 0.2  | -        |       |       |   | 263VX-8°-R20 | ■     | □     | ■ | ■     | ■  |

Tourneur arrière  
Rückwärts drehen  
Back turning

## 253VX-805 / 263VX-805



| B   | E   | L | R    | Art. N°       | AP302 | AP202 | Z | Art. N°       | AP302 | AP202 | Z | AH302 | HN |
|-----|-----|---|------|---------------|-------|-------|---|---------------|-------|-------|---|-------|----|
| 3.0 | 0.5 | 6 | 0.08 | 253VX-805-R08 | ■     | □     | ■ | 263VX-805-R08 | ■     | □     | ■ | ■     | ■  |

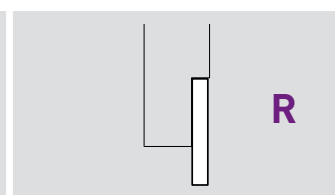
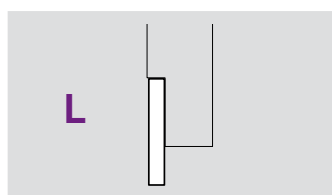
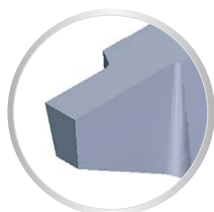
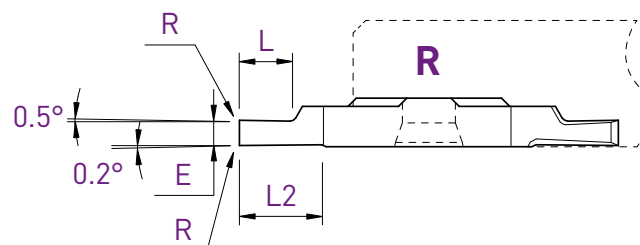
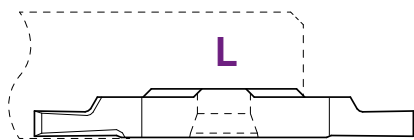
# ECO-Line

Foncer-tourner

Einstecken und drehen

Grooving and turning

254 / 264



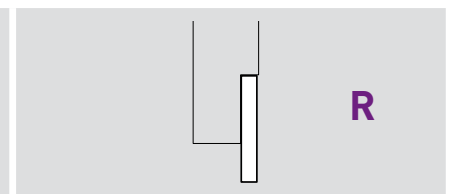
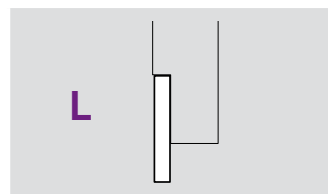
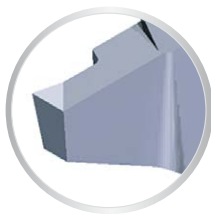
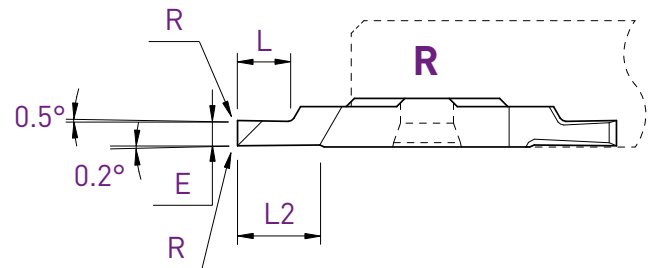
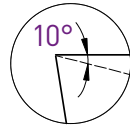
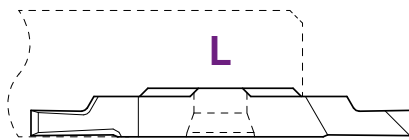
| E   | L   | L2  | R | Art. N° | AP302 | AP202 | z | Art. N° | AP302 | AP202 | z |
|-----|-----|-----|---|---------|-------|-------|---|---------|-------|-------|---|
| 0.8 | 2   | 4   | 0 | 254-0.8 | ■     | □     | ■ | 264-0.8 | ■     | □     | ■ |
| 1.0 | 2.5 | 4   | 0 | 254-1.0 | ■     | □     | ■ | 264-1.0 | ■     | □     | ■ |
| 1.2 | 3   | 4   | 0 | 254-1.2 | ■     | □     | ■ | 264-1.2 | ■     | □     | ■ |
| 1.5 | 3   | 4   | 0 | 254-1.5 | ■     | □     | ■ | 264-1.5 | ■     | □     | ■ |
| 1.8 | 4   | 6.5 | 0 | -       |       |       |   | 264-1.8 | ■     | □     | ■ |
| 2.0 | 4   | 6.5 | 0 | 254-2.0 | ■     | □     | ■ | 264-2.0 | ■     | □     | ■ |
| 2.5 | 6   | 6.5 | 0 | 254-2.5 | ■     | □     | ■ | 264-2.5 | ■     | □     | ■ |
| 3.0 | 6.5 | 6.5 | 0 | 254-3.0 | ■     | □     | ■ | 264-3.0 | ■     | □     | ■ |

Foncer-tourner

Einstecken und drehen

Grooving and turning

254X / 264X



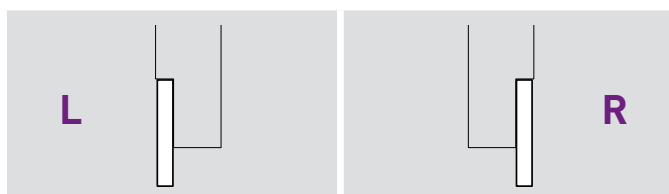
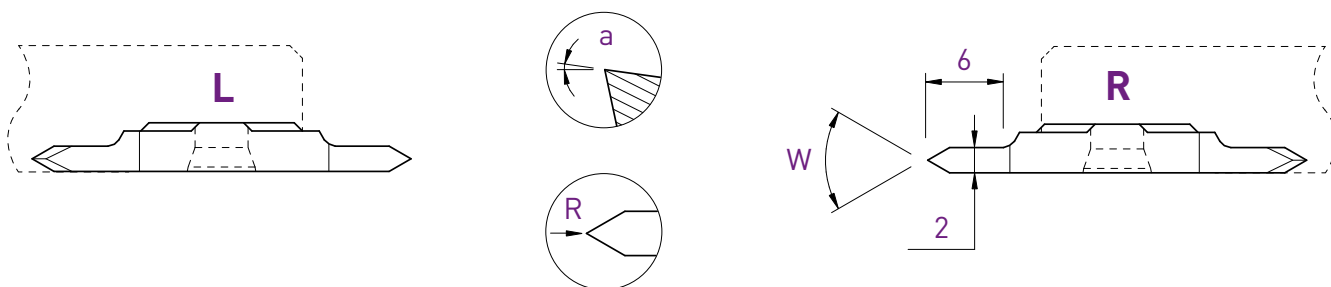
| E   | L   | L2  | R    | Art. N°  | AP302 | AP202 | Z | Art. N°      | AP302 | AP202 | Z | AH302 | HN |
|-----|-----|-----|------|----------|-------|-------|---|--------------|-------|-------|---|-------|----|
| 0.8 | 2   | 4   | 0    | 254X-0.8 | ■     | □     | ■ | 264X-0.8     | ■     | □     | ■ |       |    |
| 1.0 | 2.5 | 4   | 0    | 254X-1.0 | ■     | □     | ■ | 264X-1.0     | ■     | □     | ■ |       |    |
| 1.0 | 2.5 | 4   | 0.08 | -        |       |       |   | 264X-1.0-R08 | ■     | □     | ■ | ■     | ■  |
| 1.2 | 3   | 4   | 0    | 254X-1.2 | ■     | □     | ■ | 264X-1.2     | ■     | □     | ■ |       |    |
| 1.5 | 3   | 4   | 0    | 254X-1.5 | ■     | □     | ■ | 264X-1.5     | ■     | □     | ■ |       |    |
| 1.5 | 3   | 4   | 0.08 | -        |       |       |   | 264X-1.5-R08 | ■     | □     | ■ | ■     | ■  |
| 1.5 | 3   | 4   | 0.2  | -        |       |       |   | 264X-1.5-R20 | ■     | □     | ■ | ■     | ■  |
| 2.0 | 4   | 6.5 | 0    | 254X-2.0 | ■     | □     | ■ | 264X-2.0     | ■     | □     | ■ |       |    |
| 2.0 | 4   | 6.5 | 0.08 | -        |       |       |   | 264X-2.0-R08 | ■     | □     | ■ | ■     | ■  |
| 2.0 | 4   | 6.5 | 0.2  | -        |       |       |   | 264X-2.0-R20 | ■     | □     | ■ | ■     | ■  |
| 2.5 | 6   | 6.5 | 0    | 254X-2.5 | ■     | □     | ■ | 264X-2.5     | ■     | □     | ■ |       |    |
| 2.5 | 6.5 | 6.5 | 0.08 | -        |       |       |   | 264X-2.5-R08 | ■     | □     | ■ | ■     | ■  |
| 2.5 | 6.5 | 6.5 | 0.2  | -        |       |       |   | 264X-2.5-R20 | ■     | □     | ■ | ■     | ■  |
| 3.0 | 6.5 | 6.5 | 0    | 254X-3.0 | ■     | □     | ■ | 264X-3.0     | ■     | □     | ■ |       |    |
| 3.0 | 6.5 | 6.5 | 0.08 | -        |       |       |   | 264X-3.0-R08 | ■     | □     | ■ | ■     | ■  |
| 3.0 | 6.5 | 6.5 | 0.2  | -        |       |       |   | 264X-3.0-R20 | ■     | □     | ■ | ■     | ■  |

Fileter

Gewinde drehen

Threading

## Partial profil 60° – 256-60 / 266-60



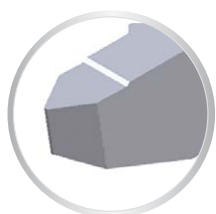
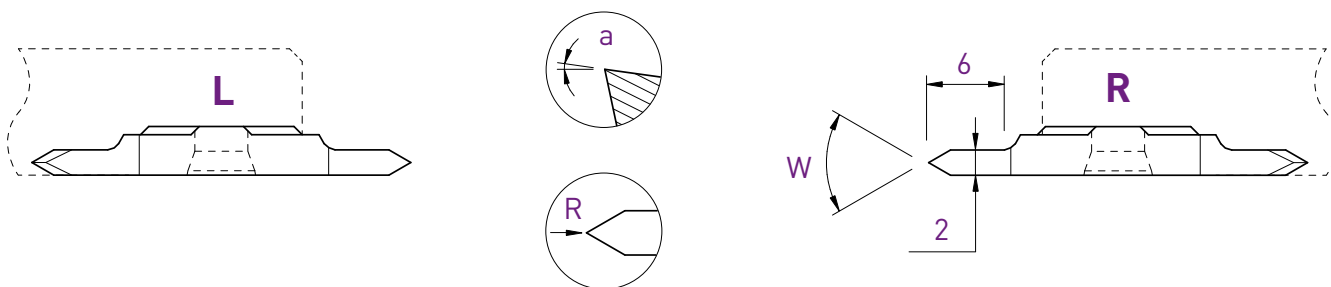
| W   | R    | a  | Art. N°  | AP302 | AP202 | z | Art. N°  | AP302 | AP202 | z |
|-----|------|----|----------|-------|-------|---|----------|-------|-------|---|
| 60° | 0    | 0° | 256-60-2 | ■     | □     | ■ | 266-60-2 | ■     | □     | ■ |
| 60° | 0.06 | 3° | 256-AG60 | ■     | □     | ■ | 266-AG60 | ■     | □     | ■ |

Fileter

Gewinde drehen

Threading

## Partial profil 55° – 256-55 / 266-55



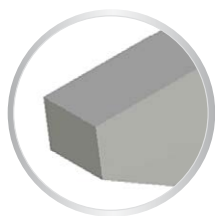
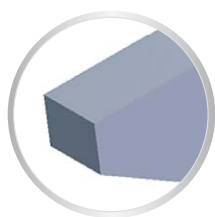
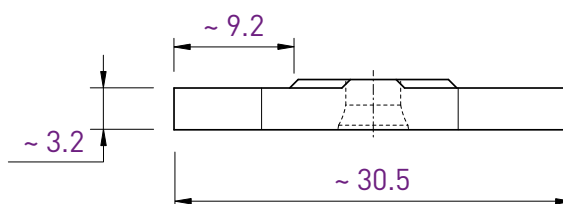
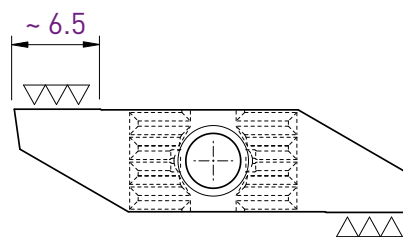
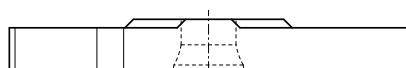
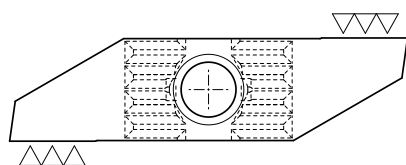
| W   | R    | a  | Art. N°  | AP302 | AP202 | z | Art. N°  | AP302 | AP202 | z |
|-----|------|----|----------|-------|-------|---|----------|-------|-------|---|
| 55° | 0    | 0° | 256-55-2 | ■     | □     | ■ | 266-55-2 | ■     | □     | ■ |
| 55° | 0.06 | 3° | 256-AG55 | ■     | □     | ■ | 266-AG55 | ■     | □     | ■ |

Ebauche

Rohling

Blank

251-E / 261-E



| L       |       |       |   |       |    | R       |       |       |   |       |    |
|---------|-------|-------|---|-------|----|---------|-------|-------|---|-------|----|
| Art. N° | AP302 | AP202 | N | AH302 | HN | Art. N° | AP302 | AP202 | N | AH302 | HN |
| 251-E   | ■     | □     | ■ | ■     | ■  | 261-E   | ■     | □     | ■ | ■     | ■  |

PERFORMANCE | PRECISION | RIGIDITY



SWISS MADE



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