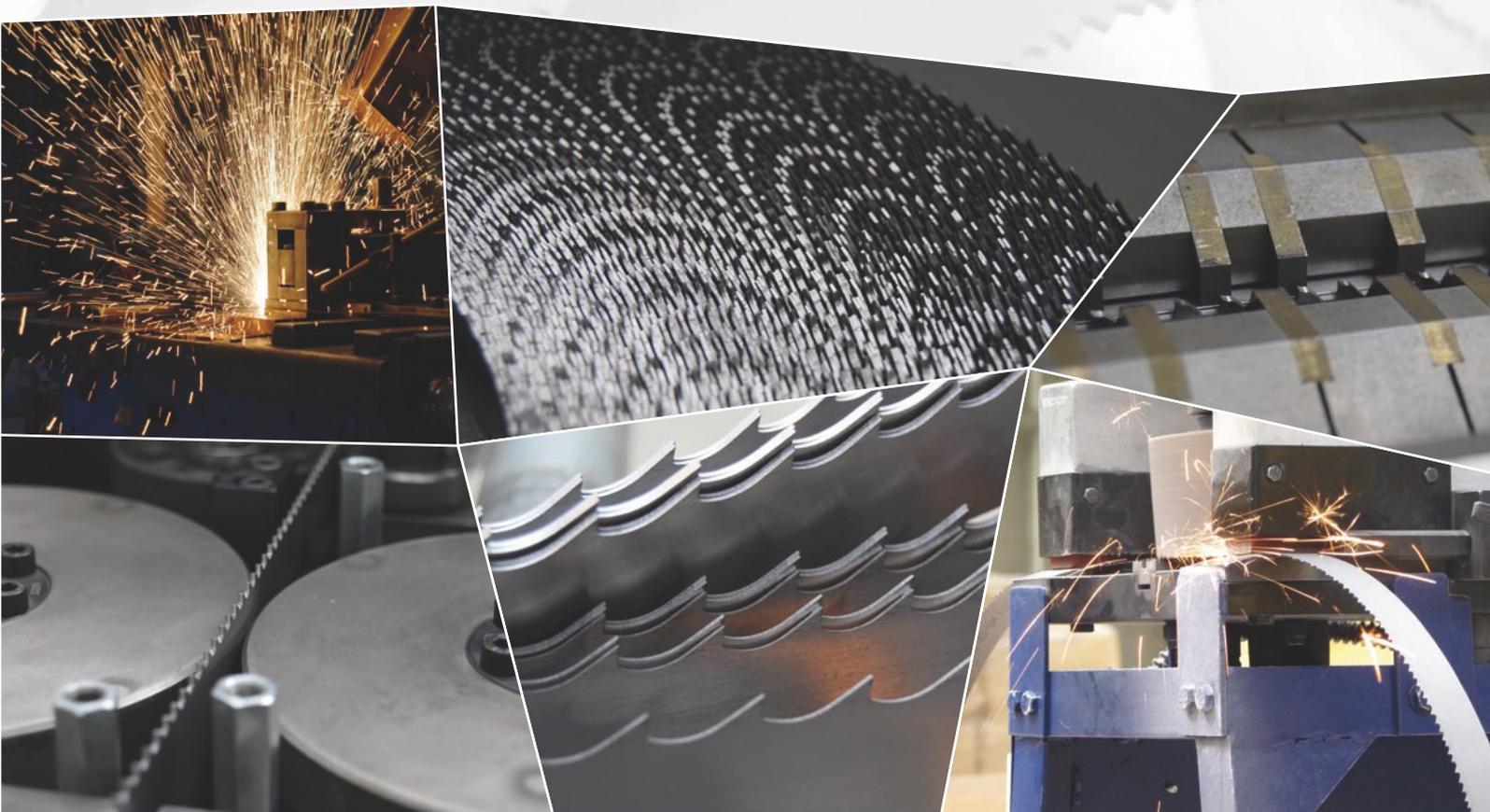


Pilana

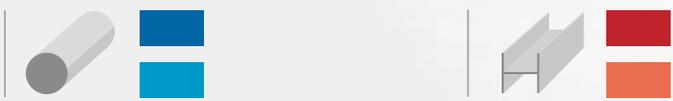
METAL

Made in Czech Republic
since 1934





		UNIVERSAL	MASSIVE	ALUCUT	PROFILE	REGULAR	GRINDCUT	PLUSCUT	PROFI MASSIVE	GRINDCUT PROFI	PLUSCUT PROFI
[Dark Blue]	< 70	Light Blue, Red			Red	Light Blue, Orange					
	80 - 350		Dark Blue		Red	Light Blue					
	> 350		Dark Blue					Light Blue			Light Blue
[Medium Blue]	< 70	Light Blue, Red			Red	Light Blue, Orange					
	80 - 350		Dark Blue		Orange	Light Blue	Light Blue			Light Blue	
	> 350		Dark Blue					Light Blue		Light Blue	Light Blue
[Dark Blue]	< 70	Light Blue, Red			Orange	Light Blue, Orange					
	80 - 350		Dark Blue			Light Blue	Light Blue		Dark Blue	Dark Blue	
	> 350		Dark Blue					Light Blue	Dark Blue	Dark Blue	Dark Blue
[Medium Blue]	< 70	Light Blue, Red			Orange	Light Blue, Orange					
	80 - 350		Dark Blue			Light Blue	Light Blue	Dark Blue	Dark Blue		
	> 350		Dark Blue					Light Blue	Dark Blue	Dark Blue	Dark Blue
[Dark Blue]	< 70	Light Blue, Red			Orange						
	80 - 350		Dark Blue				Light Blue	Dark Blue	Dark Blue	Light Blue	
	> 350		Dark Blue					Light Blue	Dark Blue	Dark Blue	Dark Blue
[Medium Blue]	< 70	Light Blue, Red									
	80 - 350		Dark Blue				Light Blue	Dark Blue	Dark Blue	Light Blue	
	> 350		Dark Blue						Dark Blue		Light Blue
[Dark Blue]	< 70	Light Blue, Red			Red						
	80 - 350		Dark Blue	Dark Blue, Red				Light Blue	Dark Blue		
	> 350		Dark Blue						Dark Blue	Light Blue	Light Blue
[Medium Blue]	< 70	Light Blue, Red									
	80 - 350		Dark Blue	Light Blue, Orange				Dark Blue	Dark Blue	Light Blue	
	> 350		Dark Blue							Dark Blue	Dark Blue
[Dark Blue]	< 70	Light Blue, Red							Dark Blue		
	80 - 350		Dark Blue	Light Blue, Orange				Dark Blue	Dark Blue	Dark Blue	
	> 350		Dark Blue							Dark Blue	Dark Blue



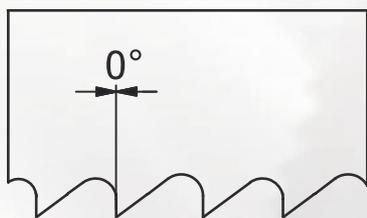


()		()	
380 - 700	1,25	> 550	0,75/1,25
200 - 400	2	300 - 600	1,4/2
120 - 200	3	120 - 350	2/3
80 - 120	4	80 - 160	3/4
50 - 80	6	60 - 110	4/6
30 - 50	8	40 - 70	5/8
20 - 30	10	30 - 60	6/10
10 - 20	14	20 - 40	8/12
< 10	18	< 20	10/14

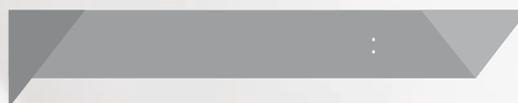


()	()									
	20	40	60	80	100	120	150	200	300	500
2	14	14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10
3	14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8
4	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8
5	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6
6	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
8	10/14	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6
10		6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6
15		6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6
20			4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6
30				4/6	4/6	4/6	4/6	3/4	3/4	3/4
50						3/4	3/4	3/4	2/3	2/3
80							3/4	2/3	2/3	2/3
100								2/3	2/3	1,4/2

M42 UNIVERSAL



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68 HRC

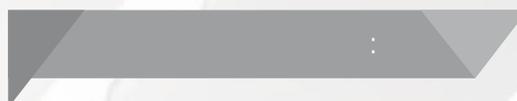
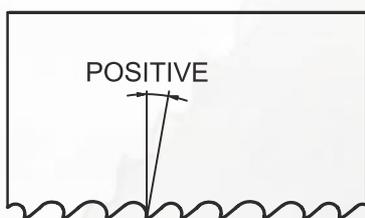
M42

mm	5/8	6/10	8/12	10/14
13 x 0,65	V-0	V-0	V-0	V-0
13 x 0,90	V-0	V-0	V-0	V-0
20 x 0,90	V-0	V-0	V-0	V-0
27 x 0,90	V-0	V-0	V-0	V-0
34 x 1,10	V-0	V-0	V-0	V-0
41 x 1,30	V-0			

V-0 =

: -20 , -80%, -50%

M42 MASSIVE



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68 HRC

M42

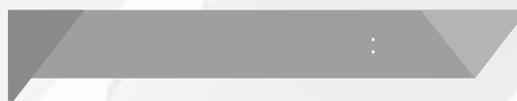
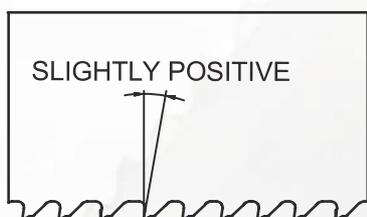
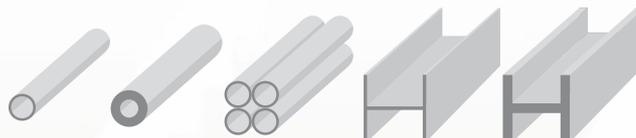
mm	0,75/1,25	1,4/2	2/3	3/4	4/6
20 x 0,90					V-POS
27 x 0,90			V-POS	V-POS	V-POS
34 x 1,10			V-POS	V-POS	V-POS
41 x 1,30		V-POS*	V-POS	V-POS	V-POS
54 x 1,60	V-POS*	V-POS	V-POS	V-POS	V-POS
67 x 1,60	V-POS*	V-POS	V-POS	V-POS	

V-POS =

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M42 PROFILE



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M42 HSS

68 HRC

mm	2/3	3/4	4/6	5/7	8/11
27 x 0,90		V-POS*	V-POS	V-POS	V-POS
34 x 1,10		V-POS	V-POS	V-POS	V-POS*
41 x 1,30	V-POS*	V-POS	V-POS		
54 x 1,60	V-POS	V-POS			
67 x 1,60	V-POS*	V-POS*			

V-POS =

*

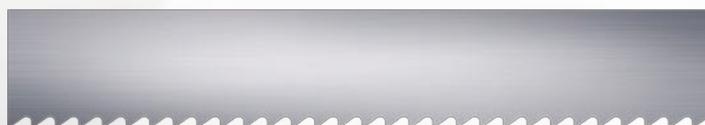
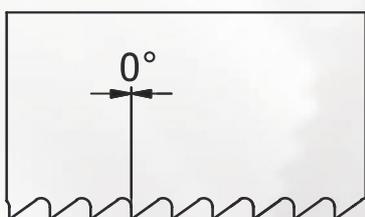
- 20

- 80%,

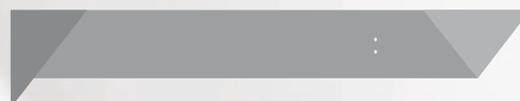
- 50%.

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M42 REGULAR



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M42 HSS
68 HRC

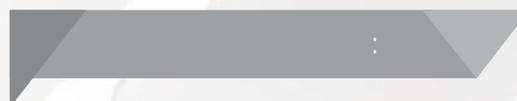
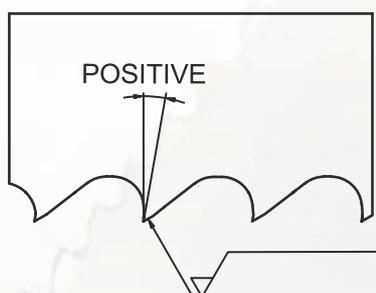
mm	14	18
13 x 0,65	N	N
13 x 0,90	N*	N*
20 x 0,90	N	N
27 x 0,90	N	N

N =

*

: -20 , -80%, -50% !

M42 GRIDNCUT



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68 HRC

M42

mm	0,75/1,25	1,4/2	2/3	3/4
27 x 0,90			V-POS	V-POS
34 x 1,10		V-POS	V-POS	V-POS
41 x 1,30		V-POS	V-POS	V-POS
54 x 1,60	V-POS	V-POS	V-POS	V-POS
67 x 1,60	V-POS	V-POS	V-POS	V-POS

POS =

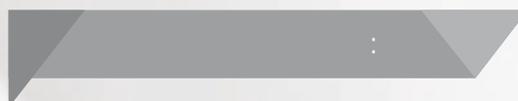
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: -20 , -80%, -50% !

M42 PLUSCUT



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68 HRC

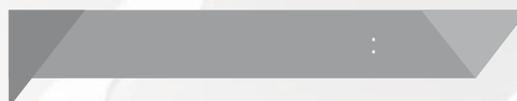
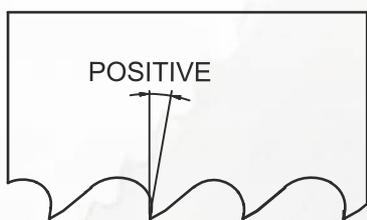
M42

mm	1,4/2	2/3	3/4
27 x 0,90		V-POS+	V-POS+
34 x 1,10		V-POS+	V-POS+
41 x 1,30	V-POS+	V-POS+	V-POS+
54 x 1,60	V-POS+	V-POS+	V-POS+

V-POS+ =

: -20 , -80%, -50% !

M51 MASSIVE PROFI



69 HRC

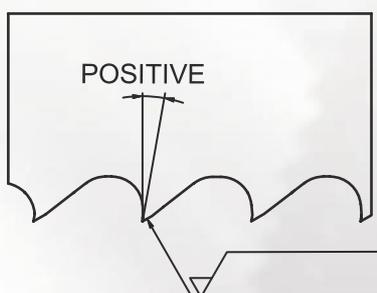
M51

mm	1,4/2	2/3	3/4	4/6
27 x 0,90		V-POS	V-POS	V-POS
34 x 1,10		V-POS	V-POS	V-POS
41 x 1,30	V-POS	V-POS	V-POS	V-POS
54 x 1,60	V-POS	V-POS	V-POS	
67 x 1,60	V-POS*	V-POS*		

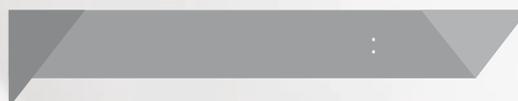
V-POS =

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M51 GRINDCUT PROFIL



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69 HRC

M51

mm	1,4/2	2/3	3/4
27 x 0,90		V-POS	V-POS
34 x 1,10		V-POS	V-POS
41 x 1,30	V-POS	V-POS	V-POS
54 x 1,60	V-POS	V-POS	V-POS
67 x 1,60	V-POS*	V-POS*	

V-POS =

*

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TiN

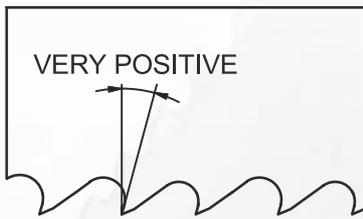
-20

-80%

-50%

!

M51 PLUSCUT PROFI



69 HRC

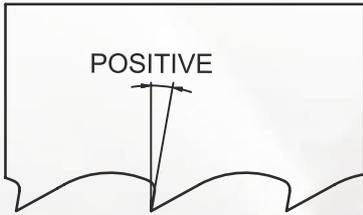
mm	1,4/2	2/3	3/4
27 x 0,90		V-POS+	V-POS+
34 x 1,10		V-POS+	V-POS+
41 x 1,30	V-POS+	V-POS+	V-POS+
54 x 1,60	V-POS+	V-POS+	V-POS+

V-POS+ =

-20, -80%, -50%

!

WOODCUT



mm	1,14	2
34 x 0,90	W	W
34 x 1,10	W	
38 x 1,10	W	
41 x 1,10	W	
50 x 1,10	W	
54 x 1,10	W	

W = 10°

, 30°



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and Innovations for Competitiveness

