
TURNING

| | |
|---------------|----------|
| Walter | 3 |
| ISO turning | 4 |
| Grooving | 16 |

DRILLING AND THREADING

| | |
|------------------------------|-----------|
| Walter Titex | 85 |
| DC170 – The Ikon of drilling | 86 |
| Solid carbide drills | 88 |

| | |
|------------------|------------|
| Walter | 119 |
| Chamfering tools | 120 |
| Precision boring | 122 |
| Counterboring | 126 |

| | |
|------------------------------|------------|
| Walter Prototyp | 149 |
| Solid carbide thread formers | 150 |
| HSS-E taps | 151 |
| Solid carbide thread mills | 152 |

MILLING

| | |
|------------------------|------------|
| Walter Prototyp | 173 |
| Solid carbide cutters | 174 |

| | |
|-------------------------------|------------|
| Walter | 193 |
| Machining expertise | 194 |
| Face, shoulder and slot mills | 204 |
| Cutting tool materials | 216 |

ADAPTORS

| | |
|-----------------|------------|
| Adaptors | 301 |
| Walter Capto™ | 302 |



Watch the innovations video:
Scan this QR code or go directly to
<http://goo.gl/5vHNmd>



Product innovations
Edition 2014-2

Turning

_ TOOL INNOVATIONS IN TURNING

**Start turning
cost-effectively today.**

The WALTER logo is printed on the side of a black metal tool holder. It consists of the stylized vertical bar followed by the word "WALTER" in a white, sans-serif font.

Walter Tiger-tec® Silver WPP05S – extremely wear-resistant for excellent cutting data when machining steel.

**NEW
2014**

THE APPLICATION

WPP05S (ISO P05)

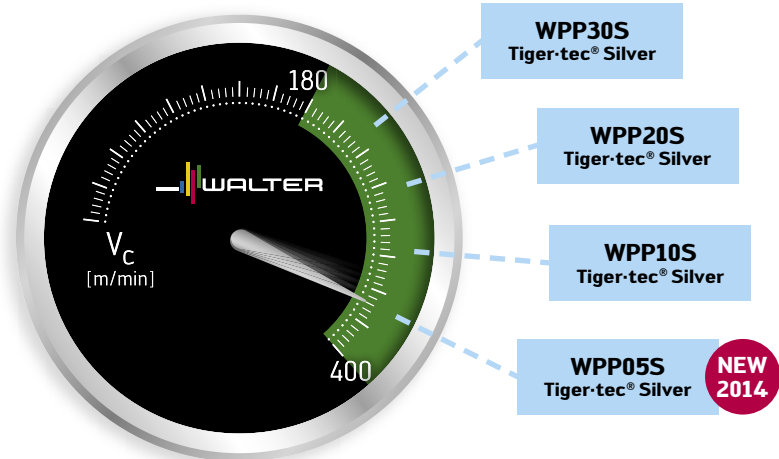
- First choice for roughing forged parts with high cutting data
- Second generation post-treatment ensures increased toughness and, as a result, prevents fractures
- Maximum wear resistance under conditions of plastic deformation and crater wear



BENEFITS FOR YOU

- Wear-resistant under extremely high temperatures thanks to 150 per cent more aluminium oxide
- Very high cutting speeds possible thanks to latest Tiger-tec® Silver technology
- Maximum productivity in mass production of forged parts, transmission shafts, wheel hubs, etc.

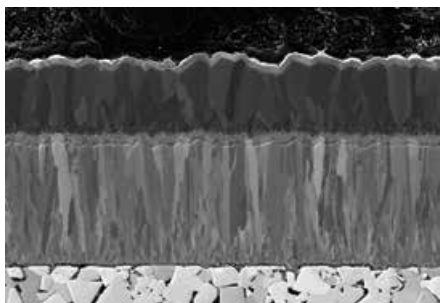
CUTTING SPEED (Material: 42CrMo4)



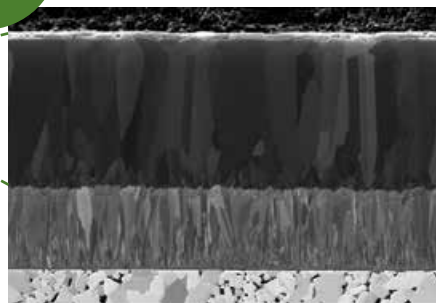
Tiger-tec® Silver

**TIGER-TEC® SILVER
WPP05S COATING COMPOSITION:**

**+ 150%
Al₂O₃
Heat shield**



Conventional layer



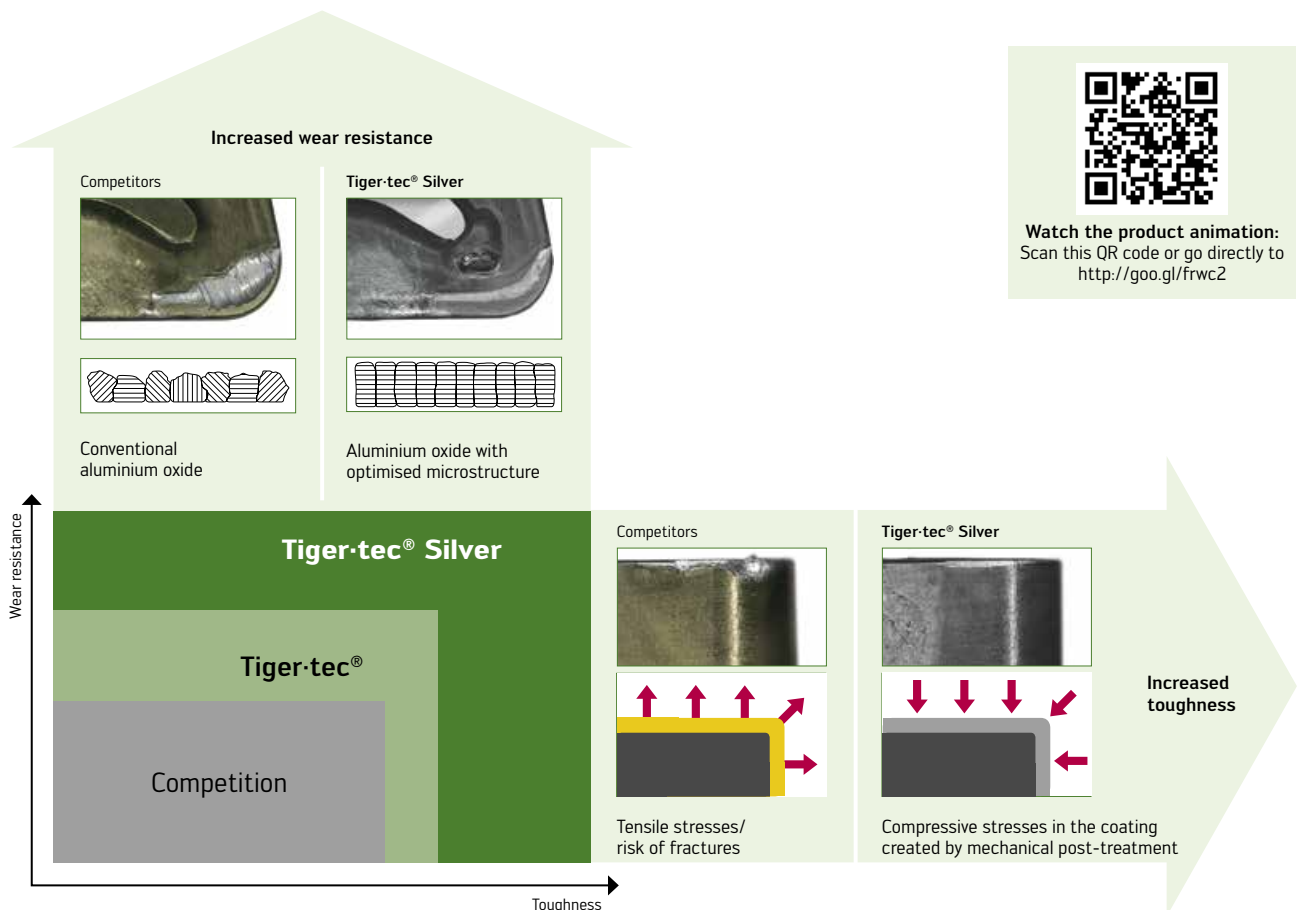
Tiger-tec® Silver WPP05S

Smooth surface
for low friction

+150% aluminium oxide layer
for maximum temperature wear
resistance and tool life

Mid-temperature
titanium carbon nitride layer

TIGER-TEC® SILVER TECHNOLOGY



Walter Tiger-tec® Silver ISO K generation – fast and reliable for maximum performance.

THE APPLICATION

- Grey cast iron DIN-GG, EN-GJL, JIS-FC
- Ductile cast iron DIN-GGG, EN-GJS, JIS-FCD
- Vermicular cast iron DIN-GGV, EN-GJV

WKK10S (ISO K10)

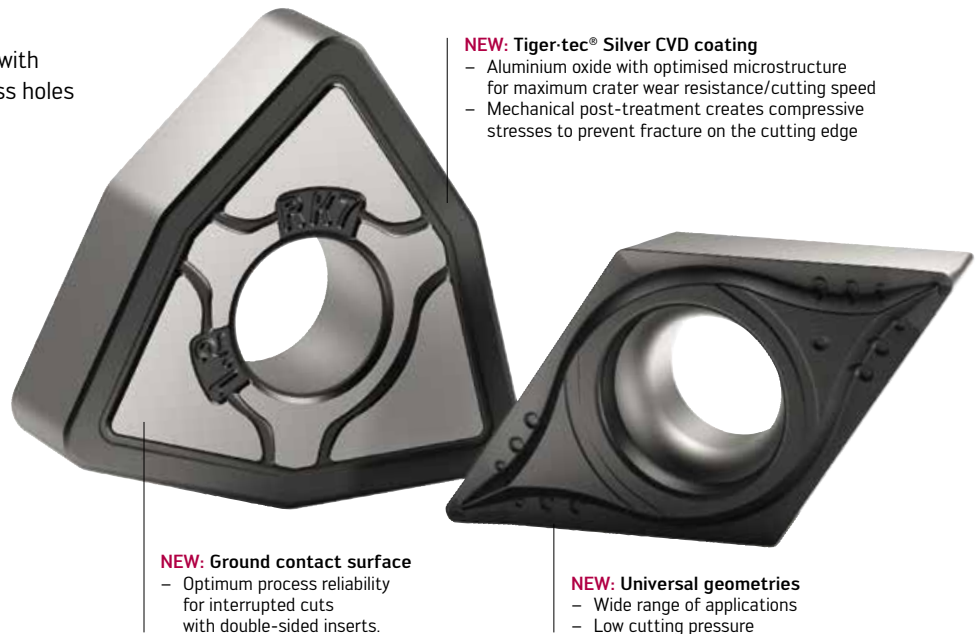
- Maximum cutting speed and wear resistance
- From continuous cuts up to slightly interrupted cuts

WKK20S (ISO K20)

- Process reliability for workpieces with interrupted cuts, cast skin or cross holes
- Ideal for wet or dry machining



Tiger-tec® Silver



- NEW: Tiger-tec® Silver CVD coating**
- Aluminium oxide with optimised microstructure for maximum crater wear resistance/cutting speed
 - Mechanical post-treatment creates compressive stresses to prevent fracture on the cutting edge

- NEW: Ground contact surface**
- Optimum process reliability for interrupted cuts with double-sided inserts.

- NEW: Universal geometries**
- Wide range of applications
 - Low cutting pressure

CUTTING SPEED (Material: GG25)



WKK20S
Tiger-tec® Silver

WKK10S
Tiger-tec® Silver

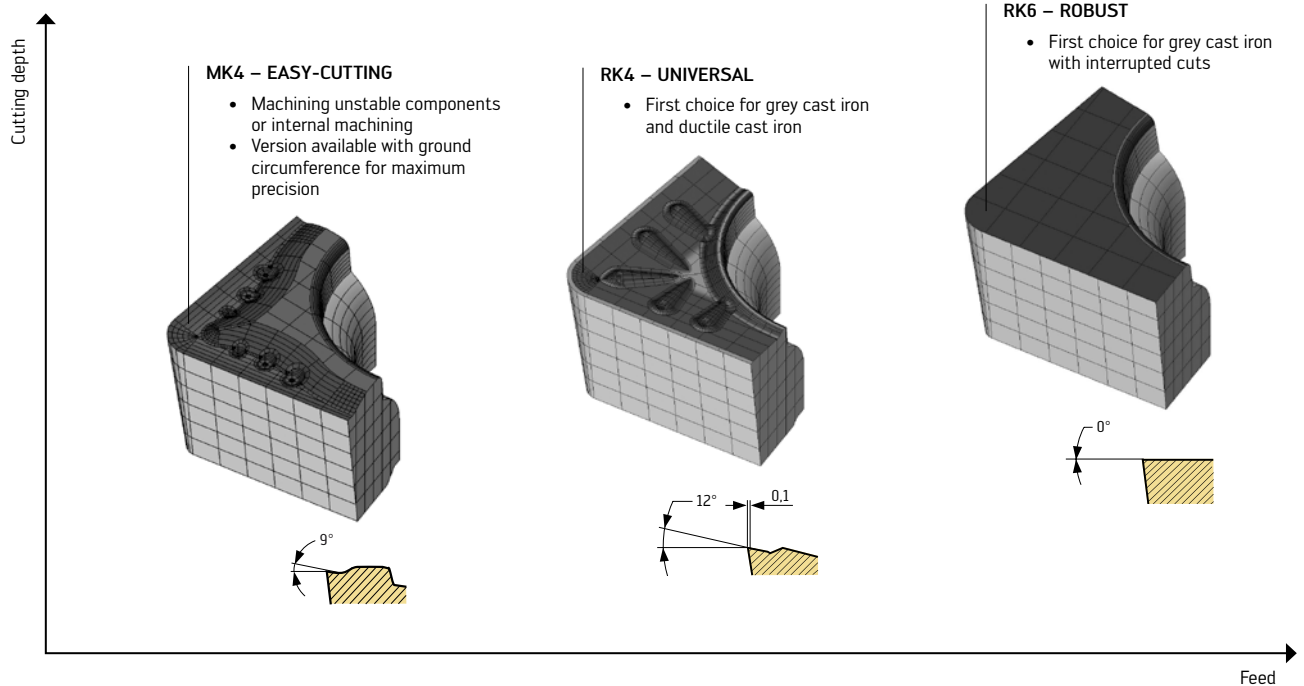
BENEFITS FOR YOU

- Short machining times due to maximum cutting speed thanks to Tiger-tec® Silver technology and new geometries
- Increased process reliability due to additionally ground contact surface and mechanical post-treatment
- Reduction in tooling costs due to increase in tool life of up to 75 per cent

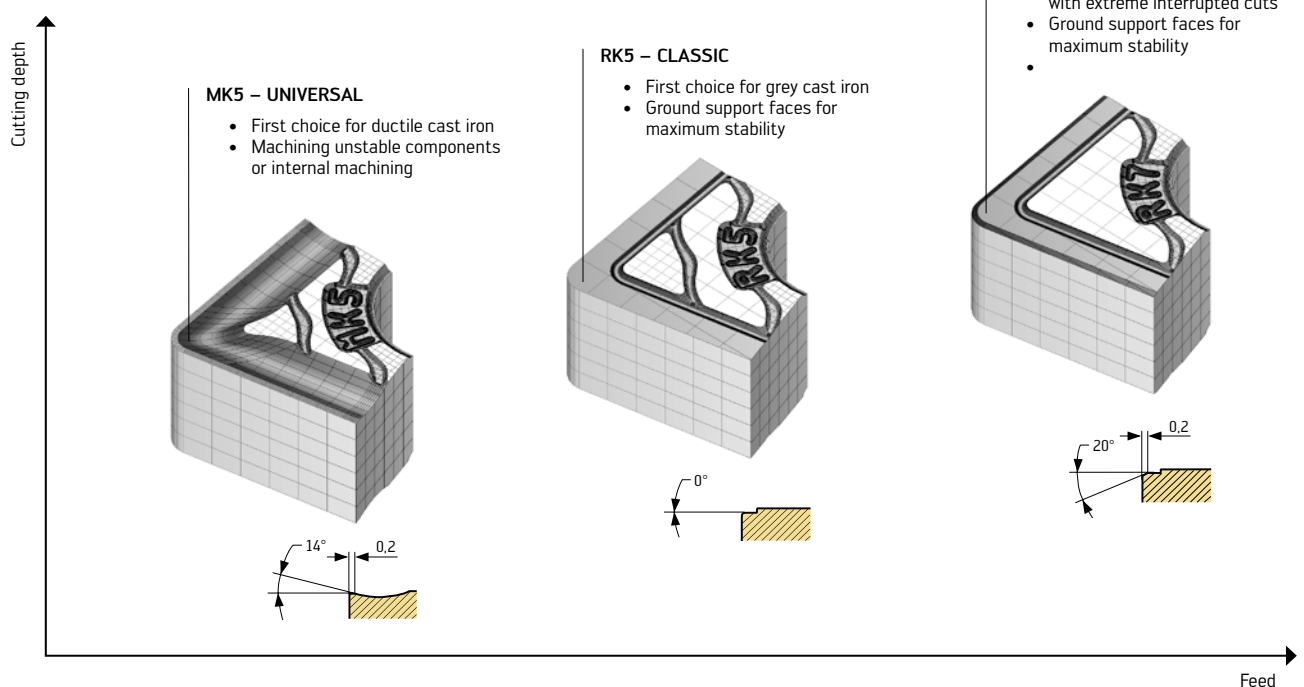
New geometries for even greater efficiency when machining cast irons.

**NEW
2014**

NEW: POSITIVE BASIC SHAPE



NEGATIVE BASIC SHAPE



Walter Tiger-tec® Silver – WMP20S: The universal cutting material for machining ISO M and ISO P materials.



THE APPLICATION

Primary application of ISO M:

- Machining stainless materials such as X5CrNi18-10 (1.4301)(304) or X6CrNiMoTi17-12-2 (1.4571)(316)

Primary application of ISO P:

- Machining steels such as 42CrMo4, 100Cr6 and C45

Secondary application of ISO S:

- Materials such as Inconel 718

THE NEW GRADE

WMP20S (ISO M20; ISO P20)

- Excellent wear resistance thanks to Tiger-tec® Silver CVD coating
- For continuous cuts and occasional interrupted cuts
- Universal use in ISO M and ISO P workpiece materials
- Low diversity of tools needs to be held despite a very wide spectrum of materials and parts in production

BENEFITS FOR YOU

- Reduction in diversity of grades held due to universal application in stainless and steel materials
- Maximum productivity thanks to **Tiger-tec® Silver** technology
- Alternative universal cutting material to our **Tiger-tec®** WSM grades, especially for higher cutting speeds
- Particularly suited to small and medium batch sizes



Tiger-tec® Silver

Axle

Workpiece material: X2CrNiMo17 / 1.4404
AISI / SAE 316L

Machine: Okuma LB15
Emulsion 6-8%

Operation: Facing/longitudinal
turning

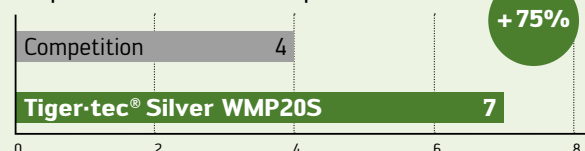
Indexable insert: WNMG080412-NM4

Cutting material: WMP20S



| | Competition ISO M20 | Tiger-tec® Silver WMP20S |
|------------------|------------------------|-----------------------------|
| v_c | 200 m/min | 200 m/min |
| f | 0.25 mm | 0.25 mm |
| a_p | 3 mm | 3 mm |
| Tool life | 4 components | 7 components |

Comparison of the number of components

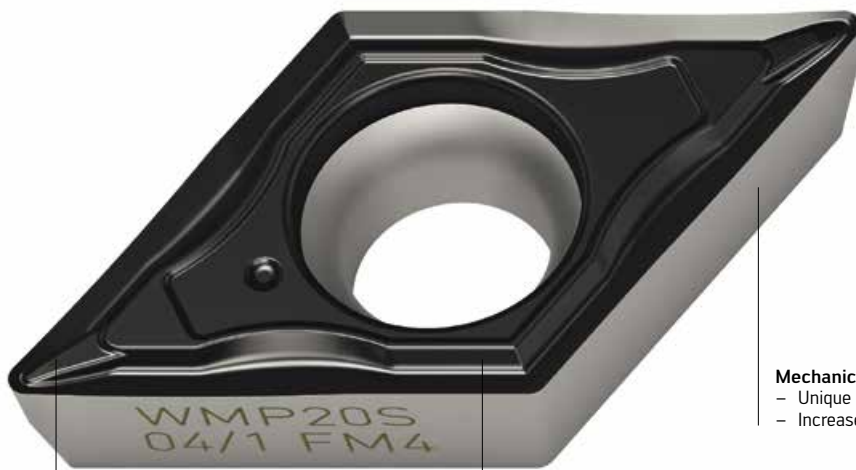


THE GEOMETRIES:

After the success of the negative geometries NF4, NM4 and NR4 in the new WMP20S grade, Walter is now providing new chip formers for positive indexable inserts. The universal grade is available in combination with the three geometries **FM4, MM4 and RM4**.



Watch the product video:
Scan QR code or go directly to
<http://goo.gl/9r3Nr>



WMP20S cutting material
– For universal use

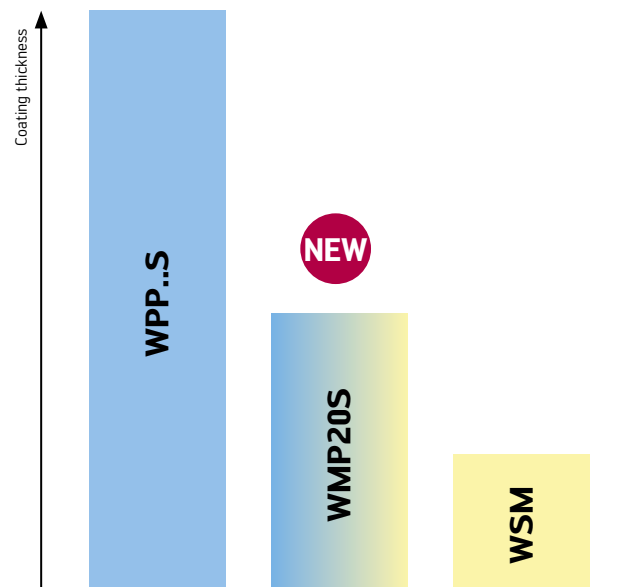
Mechanical post-treatment
– Unique residual stress state
– Increased toughness

- NEW: Positive geometries**
- FM4
 - MM4
 - RM4

- Negative geometries**
- NF4
 - NM4
 - NR4

The combination of sharp ISO M geometries and a Tiger-tec® Silver cutting material with high wear resistance provides a high-performance alternative to the present WSM and WPP..S cutting materials.

The schematic diagram shows the ratio of the coating thickness.



Walter FP4, MP4, RP4 – the positive ISO P indexable inserts with bite.

NEW
2014

THE NEW ISO P GEOMETRIES:



FP4: Steel finishing – universal

- Circumference precision-sintered
- 7° clearance angle

Application:

- Finish machining of small-diameter shafts
- Maximum surface finish quality and optimum chip breaking
- a_p : 0.1-2.5 mm; f : 0.04-0.25 mm



Tiger-tec® Silver



MP4: Medium steel machining – optimum chip breaking

- Circumference precision ground
- Circumference precision-sintered
- 7° clearance angle (.CGT...)
- 11° clearance angle (.PGT...)
- Straight cutting edge in C, S and T basic shapes, for use as a chamfer insert in counterboring tools

Application:

- Machining of long-chipping materials, such as St37
- Universal use in a wide range of applications
- Fully ground circumference gives highest diameter tolerance accuracy for use in counterboring tools
- a_p 0.4-3.5 mm; f : 0.08-0.35 mm



RP4: Steel roughing – stable cutting edge

- Circumference precision-sintered
- 7° clearance angle

Application:

- Roughing of forged parts, bar material, etc.
- Maximum machining volumes and tool life
- a_p 0.6-5.0 mm; f : 0.12-0.50 mm

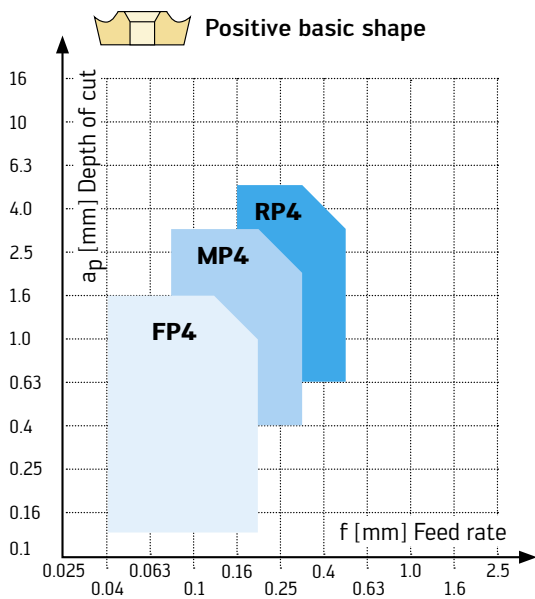


Watch the product video:
Scan QR code or go directly to
<http://goo.gl/K1xV4Y>

BENEFITS FOR YOU

- Increase in performance of 75% and in some cases, even higher thanks to the new Tiger-tec® Silver cutting materials WPP10S, WPP20S and WPP30S
- Very good chip-breaking even on long-chipping materials, such as 16MnCr5 or structural steels, particularly with the MP4 geometry
- Easy identification thanks to information lasered directly onto the indexable insert

RANGE OF APPLICATIONS:



ADDITIONAL INFORMATION:

Laser engraving of the corner radius size, grade and geometry ensures that there will not be any mix-up of indexable inserts on the machine.





Cutting material grade WPP10S

Cutting edge corner radius
Metric: 0.4 mm
Inches: 1 (1/64")

Geometry Designation MP4

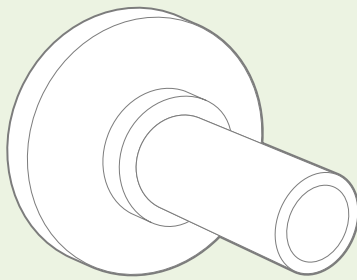
TWO VERSIONS OF THE MP4 GEOMETRY:

| |  Circumference precision-ground e.g. CCGT...- MP4 |  Circumference precision-sintered e.g. CCMT...- MP4 |
|--|---|--|
| Repeatability/ repeat accuracy | ++ | - |
| Diameter tolerance/ turning internal fits | ++ | + |
| Machining long, unstable components | ++ | + |
| Machining interrupted cuts and skins | - | ++ |

++ Very well suited
+ Well suited
- Acceptable

Walter Tiger-tec® Silver – exceptional in everyday applications.

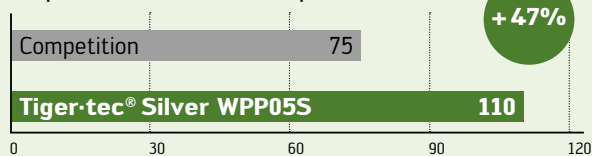
Wheel hub – C53
Face and
longitudinal
turning



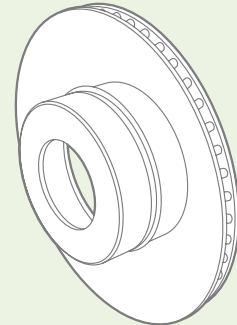
Workpiece material: C53 (1.1213)
Machine: EMAG VSC 130 Twin
Operation: Facing/longitudinal turning
Tool: DCLNR2525M16
Indexable insert: CNMG160612-RP5
Cutting material: WPP05S – Tiger-tec® Silver

| Cutting data | Competition P05 | Tiger-tec® Silver WPP05S |
|------------------|--------------------|-----------------------------|
| v_c | 240 m/min | 240 m/min |
| f | 0.4-0.5 mm | 0.3-0.6 mm |
| a_p | 1-4 mm | 1-4 mm |
| Tool life | 75 components | 110 components |

Comparison of the number of components



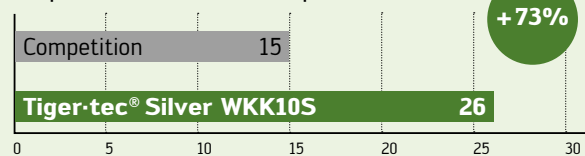
Brake disc – GG25
Internal machining



Workpiece material: GG25 (0.6025) / 300 N/mm²
Machine: Vertical lathe TVL-40
Operation: Internal machining
Tool: A40T-DCLNL12
Indexable insert: WNMA080412-RK5
Cutting material: WKK10S – Tiger-tec® Silver

| Cutting data | Competition ISO K10 | Tiger-tec® Silver WKK10S |
|---------------------------|------------------------|-----------------------------|
| v_c | 450 m/min | 450 m/min |
| f | 0.35 mm | 0.35 mm |
| a_p | 2-3 mm | 2-3 mm |
| Tool life | 15 components | 26 components |
| Flank face wear VB | 0.3 mm | 0.3 mm |

Comparison of the number of components

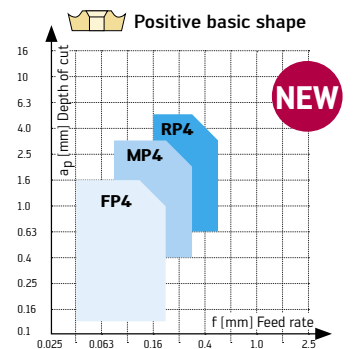
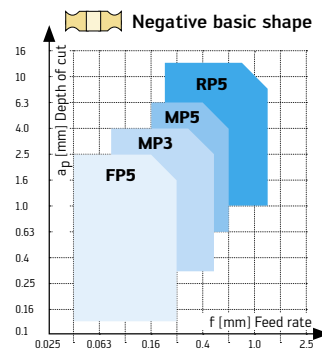
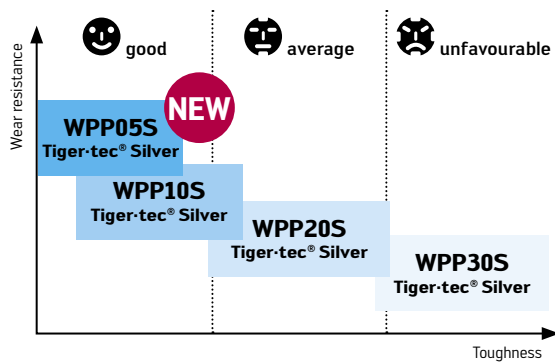


Tiger-tec® Silver

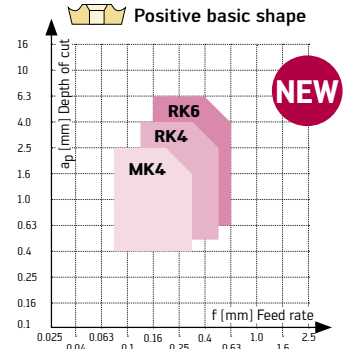
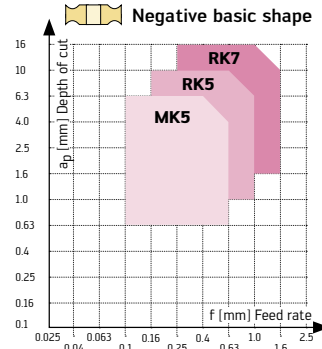
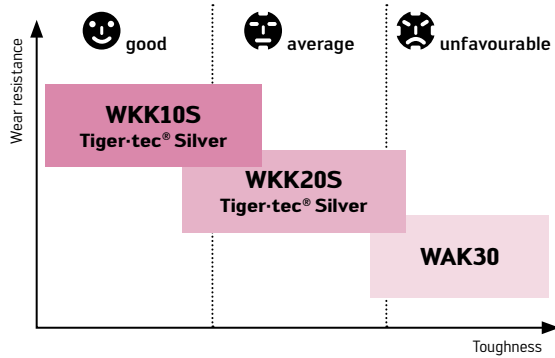
Walter Tiger-tec® Silver: The grades and geometries.

**NEW
2014**

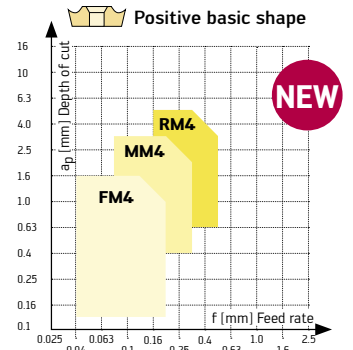
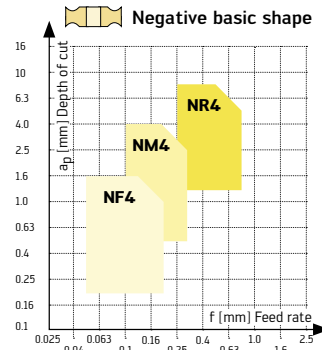
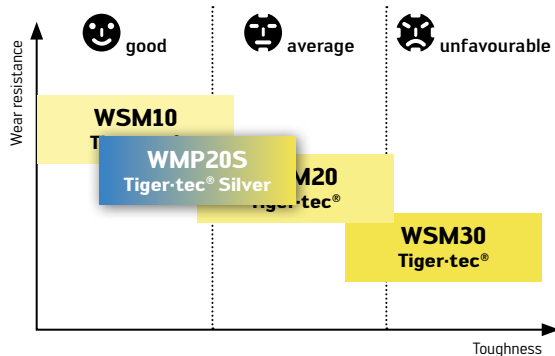
OVERVIEW OF GRADES AND GEOMETRIES: ISO P



OVERVIEW OF GRADES AND GEOMETRIES: ISO K



OVERVIEW OF GRADES AND GEOMETRIES: ISO M



Walter PCD range: WDN10 – High-performance cutting material for ISO N and ISO O materials.



THE APPLICATION

Primary application:

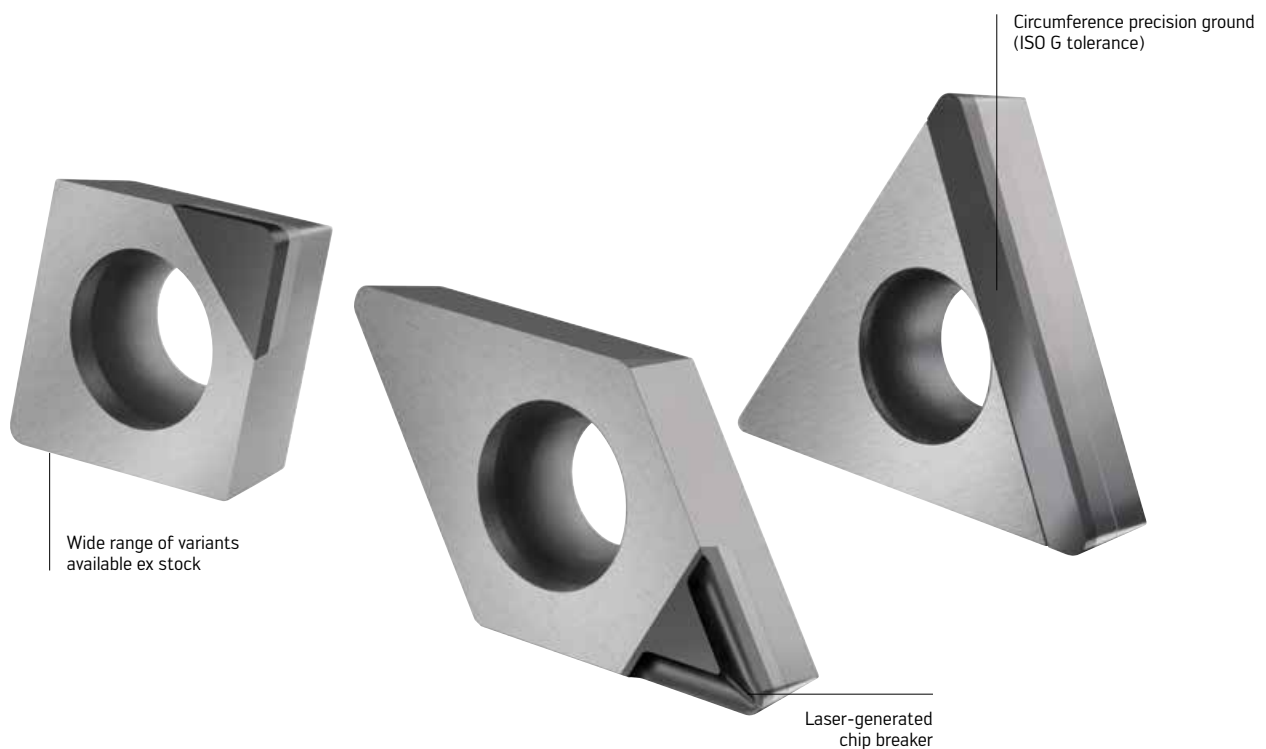
- ISO N non-ferrous metals such as aluminium and copper alloys
- ISO O materials such as composite materials

First choice for:

- Maximum surface finish quality requirements
- Extremely tight tolerance positions

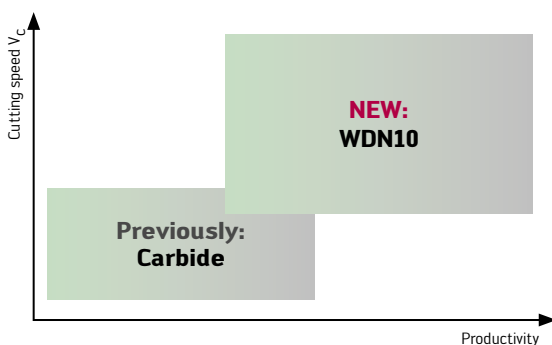
THE NEW GRADE

- The extremely hard PCD universal grade WDN 10 is a polycrystalline medium grain diamond with maximum cutting edge sharpness and wear resistance
- The standard selection comprises the basic shapes: CCGW/T, DCGW/T, SCGW, TCGW, VCGW/T
- Other basic shapes, cutting materials and geometries are available as special versions



WALTER PCD STANDARD RANGE

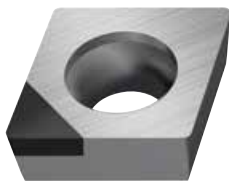
Maximum performance in ISO N and ISO O materials



BENEFITS FOR YOU

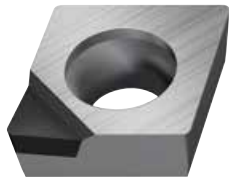
- Maximum productivity and cost efficiency thanks to extremely high level of PCD cutting material wear resistance
- Maximum repeat accuracy when replacing inserts thanks to indexable inserts with precision-ground circumference
- Excellent surface finishes thanks to maximum sharpness of cutting edges
- Worldwide support from our Walter PCD specialists

THE GEOMETRIES:



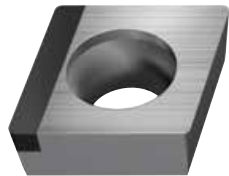
W...FS-1 – The stable one

- 0° rake angle for stable application conditions and maximum tool life



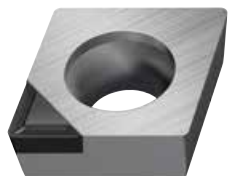
T...FS-1 – The soft-cutting one

- 7-10° rake angle for minimum cutting pressures and machining forces



FSL/R-9 - FS-9 – The efficient one

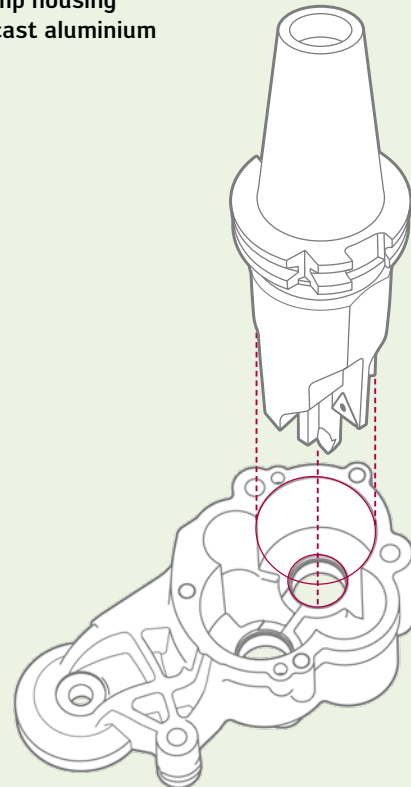
- Fitted with full insert length PCD cutting edge for maximum cutting depth and shoulder machining



FS-M1 – Ultimate flexibility and process reliability

- The laser-generated chip-breaker geometry for parameters from finishing to medium machining and optimum chip guidance

Pump housing in cast aluminium

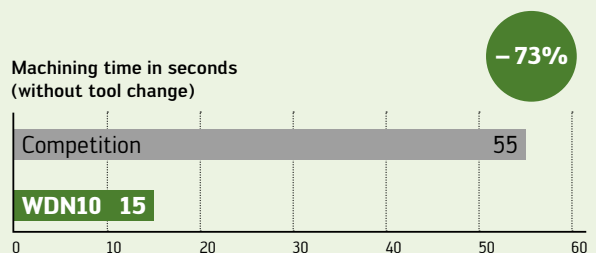


Workpiece material: AlSi10MgCuT6 (3.2383)
Tensile strength: 240 N/mm²
Indexable insert: TCGW110204FS-9
Cutting material: WDN10 – PKD
Tool: Special step drill with IC
Projection length: 175 mm (3 x D)
Machining: D: 55 +/-0.1 mm + D: 22 mm heavily interrupted cut

| | |
|-----------------------|---|
| Competition solution: | Walter solution: |
| 1. PCD mill, brazed | 1. Step drill with ISO PCD indexable inserts |
| 2. PCD drill, brazed | |

| | | |
|---|------------|-------------------|
| Machining time (without tool change) | 55 seconds | 15 seconds |
|---|------------|-------------------|

Machining time in seconds (without tool change)



Watch the product animation:
 Scan this QR code or go directly to <http://goo.gl/AkkUIO>



Watch the product video:
 Scan this QR code or go directly to <http://goo.gl/CG6LFL>

Walter Cut – SX: Parting off and slitting with the new single-edged grooving system.

THE SYSTEM

The Walter Cut range of grooving tools is being extended with the new SX grooving system. This enables the user to part off and groove, or slit and slot mill, using the same insert.



Tiger-tec® Silver



G2012-P
Monoblock toolholder with precise internal coolant supply, parting off up to a diameter of 90 mm



G2042 / G2042-P
Deep parting blades, with and without internal coolant supply, parting off up to a diameter of 160 mm



F5055
Slotting cutters with a diameter range of 63-250 mm

BENEFITS FOR YOU

- Maximum tool life due to new self-clamping with positive locking
- User-friendly self-clamping system for fast replacement of the cutting edge
- Lower inventory costs through the use of one type of cutting insert in multiple tool variants

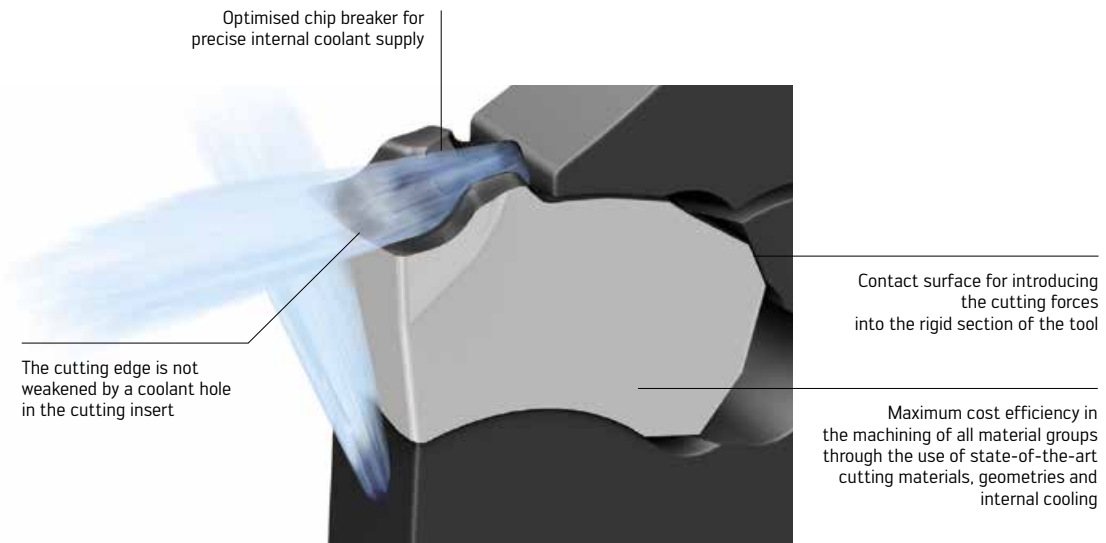


Watch the product video:
Scan this QR code or go directly to
<http://goo.gl/mjxsMT>



Watch the product animation:
Scan this QR code or go directly to
<http://goo.gl/jJ2nMS>

THE STABILITY



INSERT WIDTHS

1.5 / 2.0 / 3.0 / 4.0 / 5.0 / 6.0

CHIP BREAKER TYPES



CE4 – The universal one

- Sturdy cutting edge for maximum feed rates
- Excellent chip constriction
- 6° angled parting off inserts available in right- and left-hand version



CF5 – The positive one

- Reduced burr and pip formation
- For long-chipping workpiece materials
- 15°, 7° and 6° angled parting off inserts for parting off with low burr and pip formation



CF6 – The sharp one

- Minimum burr and pip formation
- For small diameters and thin-walled tubes

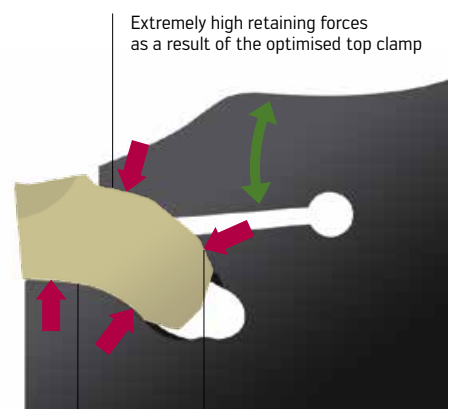
CUTTING MATERIAL GRADES

Three **Tiger-tec® Silver** PVD grades: WSM23S, WSM33S and WSM43S for steel, stainless steels and materials that are difficult to machine

One **Tiger-tec® Silver** CVD grade: WKP23S for steel and cast iron machining

One uncoated grade: WK1 for machining NF metals

ACTION / POSITIVE-LOCKING CLAMPING



Walter Cut – G2042 R/L-C-P: More productive with reinforced contra blades and internal cooling.

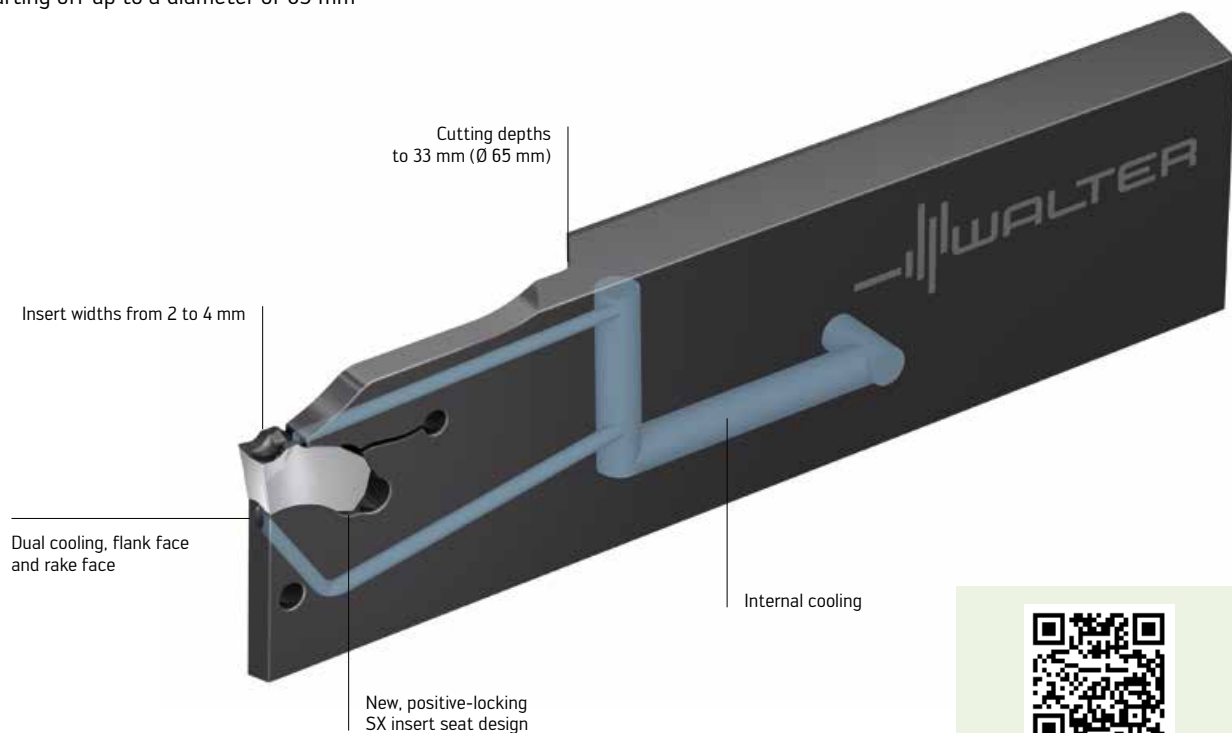
**NEW
2014**

THE TOOLS

- G2042..R/L-C-P Parting blades with reinforced shank and internal coolant supply
- Blade heights of 26 and 32 mm
- Insert widths from 2 to 4 mm
- Available in right- and left-hand contra version
- Grooving to a cutting depth of 33 mm and parting off up to a diameter of 65 mm

THE APPLICATION

- For grooving and parting off on all types of lathes
- For parting off operations where space is limited
- For parting off operations with low stability loss when using long tool projections
- First choice of blade when parting off



Reinforced blade with internal cooling

Type: G2042R/L-C-P



Watch the product video:
Scan this QR code or go directly to
<http://goo.gl/KBIHp1>

Left-hand tool



Contra

Right-hand tool



Contra

BENEFITS FOR YOU

- No loss of the cutting edge during machining due to the optimal, positive-locking design of the insert seat
- Longer tool life and productivity thanks to optimum cooling directly in the cutting zone from a coolant pressure as low as 10 bar
- Optimum chip control through internal coolant supply
- Can be used on all conventional clamping blocks
- Low vibration tendency thanks to reinforced shank

Walter Cut – G2661-P: Clamping blocks with direct coolant transfer for through coolant parting blades.

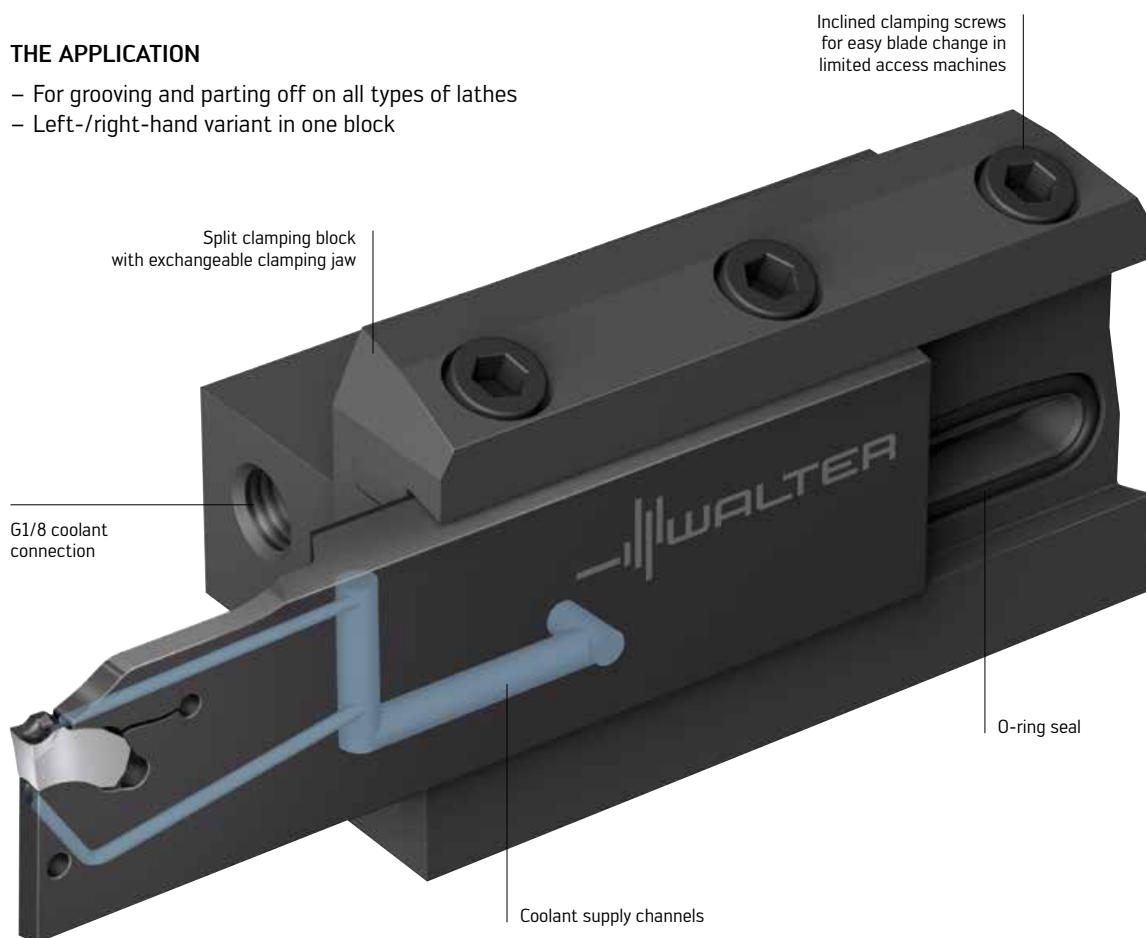
**NEW
2014**

THE TOOLS

- Clamping blocks with direct coolant transfer
- Blade heights of 26 and 32 mm
- Shank sizes 20 x 20 mm, 25 x 25 mm and 32 x 32 mm

THE APPLICATION

- For grooving and parting off on all types of lathes
- Left-/right-hand variant in one block



Clamping block for internal cooling

Type: G2661-P

BENEFITS FOR YOU

- No loss of pressure due to the O-ring seal for reliable transfer of the coolant
- No vibration thanks to sturdy holder design with rigid clamping
- Easy handling of the blade without removing the clamping block thanks to the inclined clamping screws

Walter A2110-P / A2111-P: VDI parting blade adaptors with direct coolant transfer for through coolant parting blades.

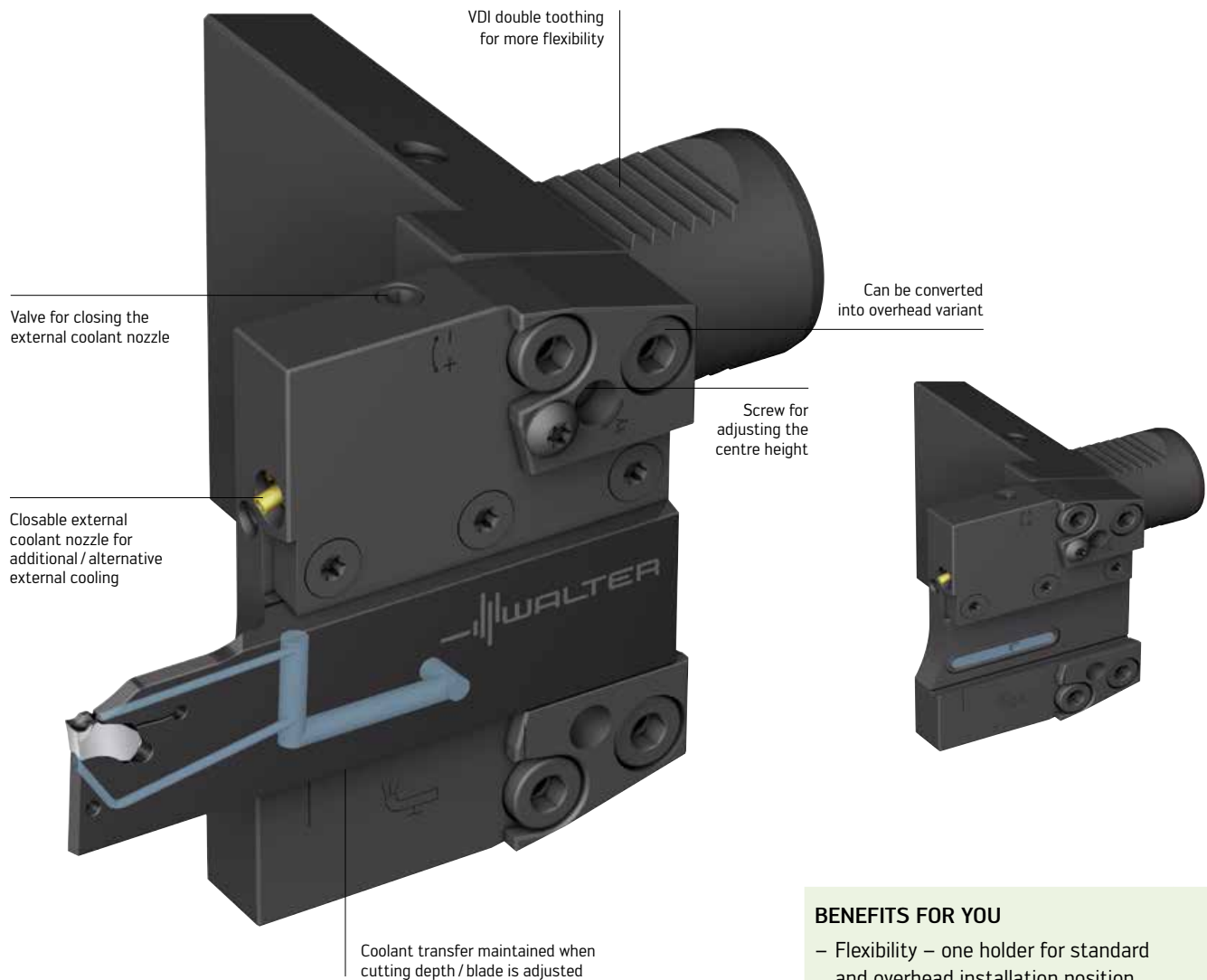
**NEW
2014**

THE TOOLS: A2110-P

- VDI25/30/40 for star / peripheral turret
- Transfer of the coolant directly through the VDI interface into the internally cooled parting blade

THE APPLICATION

- For use on all VDI star / peripheral turret machines
- For grooving and parting off with internal cooling



VDI adaptor for star / peripheral turret

Type: A2110-P

BENEFITS FOR YOU

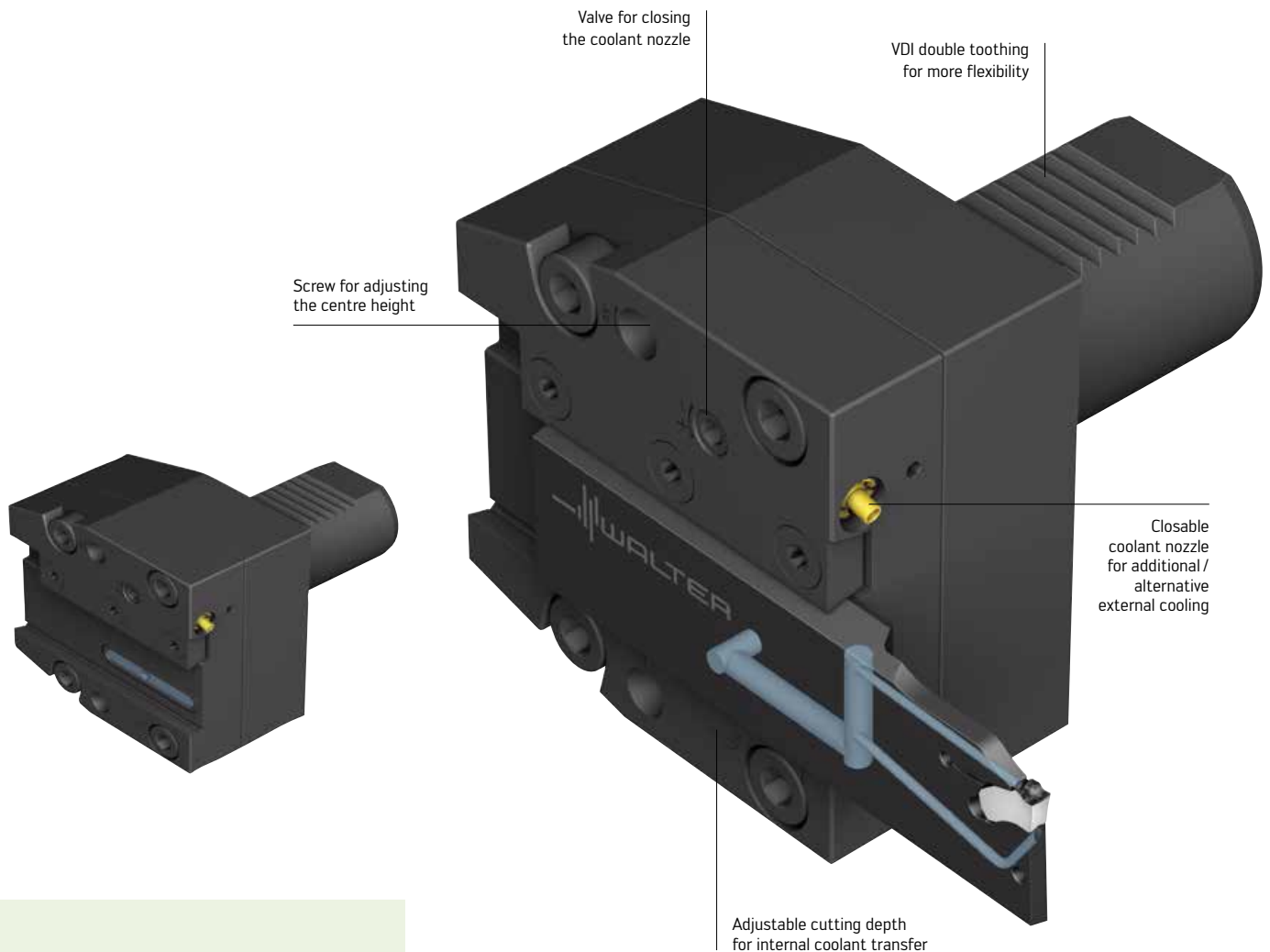
- Flexibility – one holder for standard and overhead installation position
- Longer tool life and productivity thanks to optimum cooling directly in the cutting zone from a coolant pressure as low as 10 bar
- Short chips, therefore no downtimes for removing chip accumulation

THE TOOLS: A2111-P

- VDI30/40 for disc turret
- Transfer of the coolant directly through the VDI interface into the internally cooled parting blade

THE APPLICATION

- For use on all VDI disc turret machines
- For grooving and parting off with internal cooling



- No loss of pressure due to the O-ring seal for reliable transfer of the coolant
- No vibration thanks to sturdy holder design, adjustable to every machining position
- Precise insert position thanks to easily adjustable centre height in a range from ± 0.5 mm

VDI adaptor for disc turret

Type: A2111-P

_ GROOVING

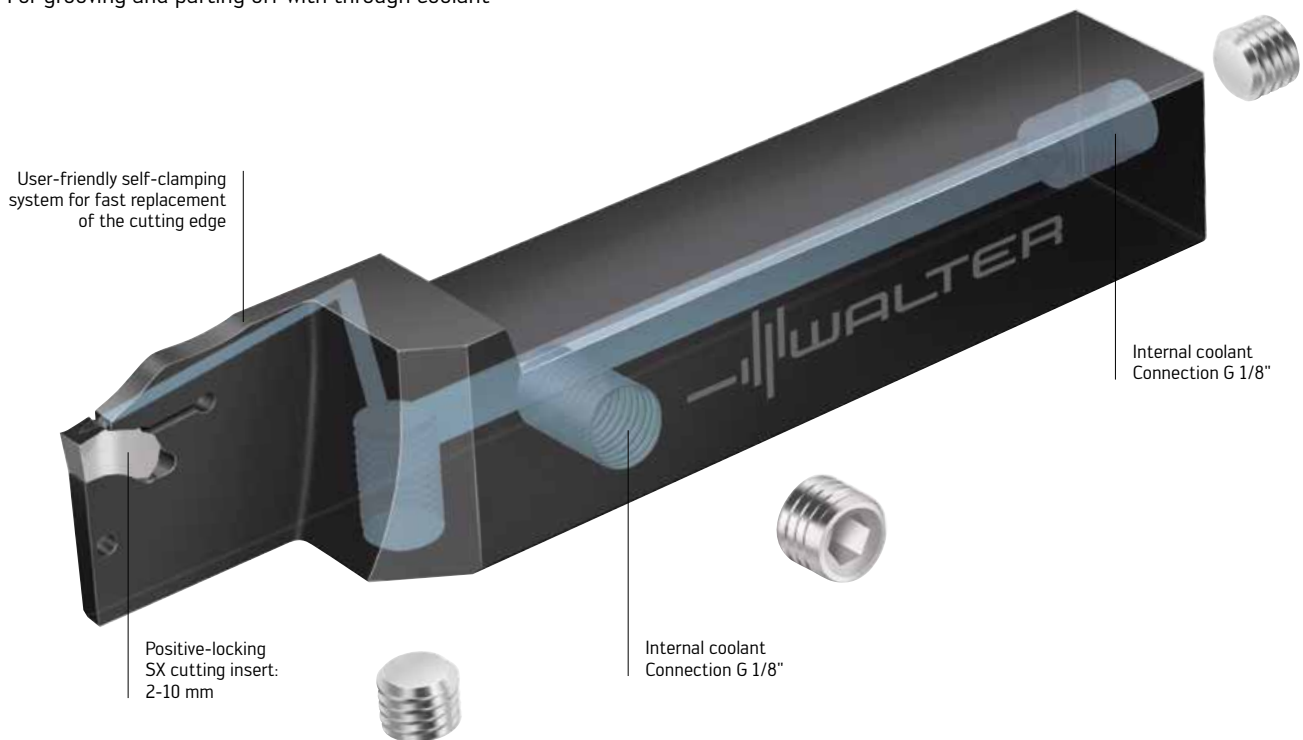
Walter Cut – G2012-P tool holder with through coolant for single-sided SX cutting inserts.

THE TOOLS

- G2012-P in sizes 12 x 12 mm, 16 x 16 mm, 20 x 20 mm, 25 x 25 mm and 32 x 25 mm with internal coolant supply
- Insert widths from 2-10 mm
- Grooving to a cutting depth of 45 mm and parting off to a bar diameter of 90 mm

THE APPLICATION

- For use on all types of lathes
- For grooving and parting off with through coolant



SX monoblock tools with internal coolant supply
2020 and 2525 mm shanks

Type: G2012-P

BENEFITS FOR YOU

- Longer tool life and productivity thanks to optimum cooling directly in the cutting zone from a coolant pressure as low as 10 bar
- Short chips, therefore no downtimes for removing chip accumulation

Walter Cut – G1011-P tool holder with through coolant for double-edged GX cutting inserts.

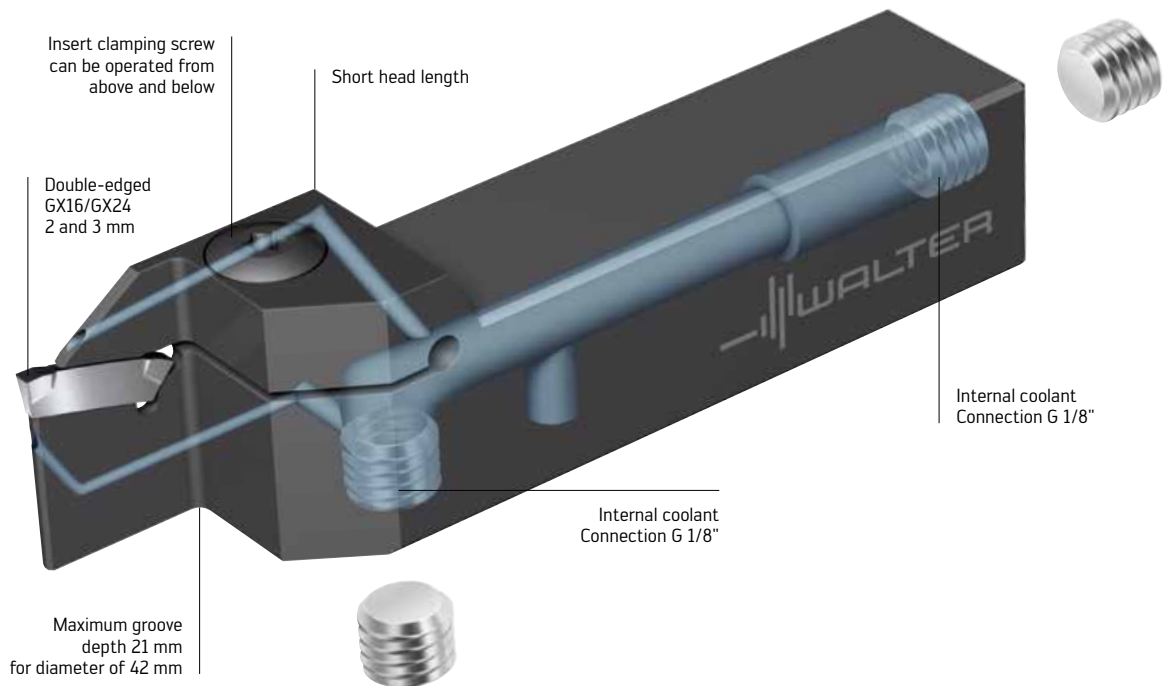


THE TOOLS

- G1011-P in sizes 16 x 16 mm, 20 x 20 mm and 25 x 25 mm with internal coolant supply
- Insert widths 2 and 3 mm
- Grooving to a maximum cutting depth of 21 mm and parting off to a bar diameter of 42 mm

THE APPLICATION

- For use on lathes of all types, in particular:
 - Short automatic lathes
 - Multi-spindle machines
 - Bar feed lathes



- Low head height for optimum chip removal
- Very good surface finish quality and flatness thanks to excellent cooling and lubrication

GX monoblock tools with internal coolant supply

Type: G1011-P

Walter Cut – Tiger-tec® Silver WKP13S, WKP23S, WKP33S – the high-performance cutting material for grooving.



THE APPLICATION

Primary application of ISO P:

- Typical steels, such as 42CrMo4, 100Cr6 and C45

Primary application of ISO K:

- All cast iron materials, such as grey cast iron (EN-GJL), ductile cast iron (EN-GJS) and vermicular cast iron (EN-GJV)

THE NEW GRADES

WKP13S (ISO P10 ; ISO K20)

- Excellent wear resistance and cutting speed
- Continuous cut

WKP23S (ISO P20 ; ISO K25)

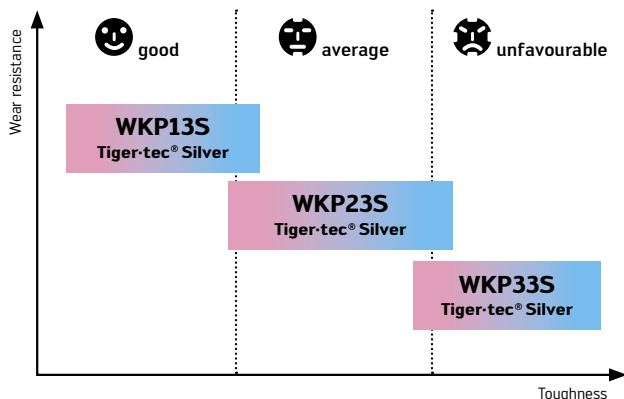
- Excellent wear resistance and cutting speed
- For continuous and occasional interrupted cuts
- Universal grade for approx. 80% of all applications

WKP33S (ISO P30 ; ISO K30)

- Excellent wear resistance and toughness
- Unfavourable conditions or interrupted cuts

NEW: Tiger-tec® Silver CVD coating

- Aluminium oxide with optimised microstructure for maximum crater wear resistance/cutting speed
- Mechanical post-treatment creates compressive stresses to prevent fracture on the cutting edge
- Silver flank face as an indicator layer for easy wear detection



Tiger-tec® Silver



THE GEOMETRIES:

The new WKP13S, WKP23S and WKP33S grades are introduced in combination with the proven recessing geometries UD4, UA4, UF4 and RD4, and the plunge grooving and parting off geometries GD3 and CE4. This means the new Tiger-tec® Silver technology is combined in machining with the long-standing experience of our existing geometries.

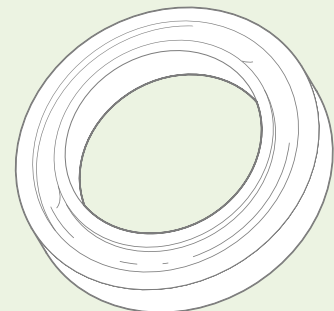


Watch the product video:
Scan this QR code or go directly to
<http://goo.gl/dcyLLa>

BENEFITS FOR YOU

- Maximum productivity by increasing the cutting data while maintaining the same or improved tool life thanks to latest **Tiger-tec® Silver** technology
- Wear-resistant cutting material as an alternative to our WSM grades

Axial grooving 2 x 4 mm Forged blank

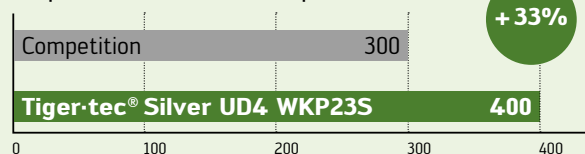


Workpiece material: C45 (1.0503)
Indexable insert: GX24-3E400N04-UD4
Cutting material: WKP23S Tiger-tec® Silver
Tool: G1111.2525R-5T12-0406X24

| Cutting data | Competition CVD | Tiger-tec® Silver WKP23S |
|-----------------------|--------------------|-----------------------------|
| v_c | 250 m/min | 250 m/min |
| f | 0.15 mm | 0.20 mm |
| Cutting depth | 4 mm | 4 mm |
| Tool life | 300 components | 400 components |
| Machining time | 36 sec | 30 sec |

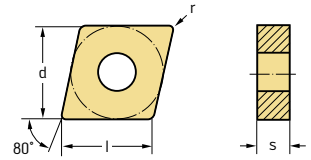
Note:
Very good chip breaking due to UD4 geometry,
high level of process reliability

Comparison of the number of components







Negative rhombic 80° CNMG/CNMM

Tiger-tec® Silver



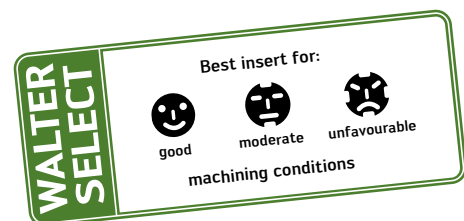
Indexable inserts

| Designation | r mm | f mm | a _p mm | P HC | | | | | M HC | | | | K HC | | | |
|--|----------------|-------------|----------------------|------------|--------|--------|--------|--------|---------|-------|-------|-------|---------|--------|-------|--|
| | | | | WPP05S | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 | |
|  CNMG120408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,2 | ☺ | ☺ | ☺ | ☺ | | | | | | | | | |
| | CNMG120412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,5 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
|  CNMG120408-MP5 | 0,8 | 0,18 - 0,40 | 0,6 - 5,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | | |
| | CNMG120412-MP5 | 1,2 | 0,20 - 0,45 | 1,0 - 5,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
| | CNMG160608-MP5 | 0,8 | 0,25 - 0,50 | 0,8 - 7,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
| | CNMG160612-MP5 | 1,2 | 0,30 - 0,50 | 1,0 - 7,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
|  CNMG120408-RP5 | 0,8 | 0,20 - 0,40 | 0,8 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | ☺ | |
| | CNMG120412-RP5 | 1,2 | 0,25 - 0,60 | 1,0 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | ☺ | |
| | CNMG120416-RP5 | 1,6 | 0,35 - 0,70 | 1,6 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
| | CNMG160612-RP5 | 1,2 | 0,25 - 0,60 | 1,2 - 8,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | ☺ | |
| | CNMG160616-RP5 | 1,6 | 0,35 - 0,70 | 1,6 - 8,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | ☺ | |
| | CNMG190612-RP5 | 1,2 | 0,25 - 0,65 | 1,2 - 10,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
| | CNMG190616-RP5 | 1,6 | 0,35 - 0,80 | 1,6 - 10,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
|  CNMM120412-NRF | 1,2 | 0,35 - 0,70 | 1,2 - 7,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | | |
| | CNMM160612-NRF | 1,2 | 0,35 - 0,70 | 1,2 - 9,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |
| | CNMM160616-NRF | 1,6 | 0,40 - 0,90 | 1,6 - 9,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

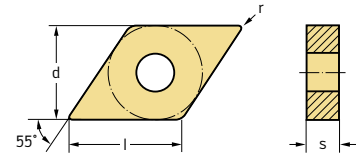
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide







Negative rhombic 55° DNMG/DNMM

Tiger-tec® Silver



Indexable inserts

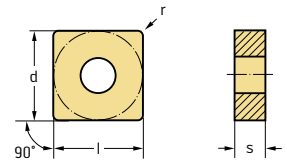
| Designation | r mm | f mm | a _p mm | P | | | | | M | | | | K | | |
|---|----------------|---------|----------------------|-----------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | | HC | | | | HC | | |
| | | | | WPP05S | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  | DNMG110408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG110412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,2 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,2 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,5 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150608-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,2 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150612-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,5 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
|  | DNMG150408-MP5 | 0,8 | 0,18 - 0,35 | 0,6 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150412-MP5 | 1,2 | 0,20 - 0,40 | 1,0 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150608-MP5 | 0,8 | 0,18 - 0,35 | 0,6 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150612-MP5 | 1,2 | 0,20 - 0,40 | 1,0 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
|  | DNMG110408-RP5 | 0,8 | 0,18 - 0,35 | 0,8 - 4,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG110412-RP5 | 1,2 | 0,20 - 0,40 | 1,0 - 4,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150408-RP5 | 0,8 | 0,15 - 0,35 | 0,8 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMG150608-RP5 | 0,8 | 0,15 - 0,35 | 0,8 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | ☹ | |
| | DNMG150612-RP5 | 1,2 | 0,20 - 0,55 | 1,0 - 6,0 | ☺ | ☺ | ☹ | ☹ | | | | | | ☹ | |
| | DNMG150616-RP5 | 1,6 | 0,25 - 0,65 | 1,6 - 6,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
|  | DNMM150612-NRF | 1,2 | 0,30 - 0,50 | 1,2 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | DNMM150616-NRF | 1,6 | 0,35 - 0,60 | 1,6 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.



HC = Coated carbide

Negative square SNMG

Tiger-tec® Silver



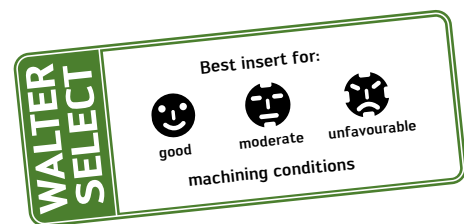
Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | | M | | | | K | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | | HC | | | | HC | | |
| | | | | WPP05S | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  SNMG120408-MP5 | 0,8 | 0,18 - 0,40 | 0,6 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
| SNMG120412-MP5 | 1,2 | 0,20 - 0,45 | 1,0 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
| SNMG120416-MP5 | 1,6 | 0,25 - 0,50 | 1,2 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
|  SNMG120412-RP5 | 1,2 | 0,25 - 0,65 | 1,0 - 6,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
| SNMG120416-RP5 | 1,6 | 0,35 - 0,75 | 1,6 - 6,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
| SNMG150612-RP5 | 1,2 | 0,25 - 0,70 | 1,2 - 8,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |
| SNMG150616-RP5 | 1,6 | 0,35 - 0,80 | 1,6 - 8,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

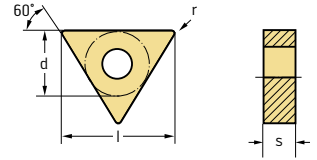
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide



Negative triangular TNMG

Tiger-tec® Silver



Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | | M | | | K | | | |
|----------------|----------------|----------------|----------------------|-------------|-----------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | | HC | | | HC | | | |
| | | | | WPP05S | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| | TNMG160408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG160412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,2 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG220408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,2 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG220412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,5 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG160404-MP5 | 0,4 | 0,16 - 0,25 | 0,5 - 4,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG160408-MP5 | 0,8 | 0,18 - 0,35 | 0,6 - 4,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG160412-MP5 | 1,2 | 0,20 - 0,40 | 1,0 - 4,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG220404-MP5 | 0,4 | 0,16 - 0,25 | 0,7 - 4,0 | | ☺ | ☹ | | | | | | | | |
| | TNMG220408-MP5 | 0,8 | 0,18 - 0,35 | 0,8 - 5,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG220412-MP5 | 1,2 | 0,20 - 0,40 | 1,0 - 5,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG270608-MP5 | 0,8 | 0,25 - 0,45 | 0,8 - 7,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG270612-MP5 | 1,2 | 0,30 - 0,50 | 1,0 - 7,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | TNMG270616-MP5 | 1,6 | 0,35 - 0,55 | 1,2 - 7,0 | | ☺ | ☹ | ☹ | | | | | | | |
| | | TNMG160408-RP5 | 0,8 | 0,20 - 0,40 | 0,8 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | ☹ |
| TNMG160412-RP5 | | 1,2 | 0,25 - 0,55 | 1,0 - 5,0 | ☺ | ☺ | ☹ | ☹ | | | | | | ☹ | |
| TNMG220408-RP5 | | 0,8 | 0,20 - 0,45 | 0,8 - 7,0 | | ☺ | ☹ | ☹ | | | | | | | |
| TNMG220412-RP5 | | 1,2 | 0,25 - 0,60 | 1,0 - 7,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| TNMG220416-RP5 | | 1,6 | 0,35 - 0,70 | 1,6 - 7,0 | ☺ | ☺ | ☹ | ☹ | | | | | | | |
| TNMG270612-RP5 | | 1,2 | 0,35 - 0,70 | 1,6 - 10,0 | | ☺ | ☹ | ☹ | | | | | | | |
| TNMG270616-RP5 | | 1,6 | 0,35 - 0,80 | 2,0 - 10,0 | | ☺ | ☹ | ☹ | | | | | | | |

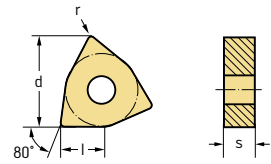
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Negative Trigon 80° WNMG

Tiger-tec® Silver

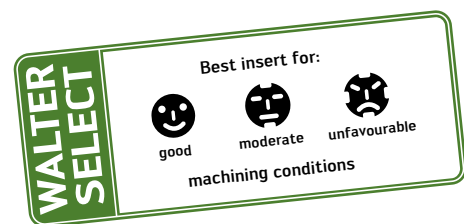


Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | | M | | | | K | | |
|-------------|----------------|---------|----------------------|-----------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | | HC | | | | HC | | |
| | | | | WPP05S | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| | WNMG080408-MP3 | 0,8 | 0,12 - 0,32 | 0,6 - 3,2 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG080412-MP3 | 1,2 | 0,16 - 0,40 | 0,8 - 3,5 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG060408-MP5 | 0,8 | 0,18 - 0,35 | 0,6 - 4,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG060412-MP5 | 1,2 | 0,20 - 0,40 | 1,0 - 4,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG080408-MP5 | 0,8 | 0,18 - 0,40 | 0,6 - 5,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG080412-MP5 | 1,2 | 0,20 - 0,45 | 1,0 - 5,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG080408-RP5 | 0,8 | 0,20 - 0,40 | 0,8 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | ☺ | ☺ | |
| | WNMG080412-RP5 | 1,2 | 0,25 - 0,60 | 1,0 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | ☺ | ☺ | |
| | WNMG080416-RP5 | 1,6 | 0,35 - 0,70 | 1,6 - 6,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG100612-RP5 | 1,2 | 0,25 - 0,60 | 1,2 - 8,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |
| | WNMG100616-RP5 | 1,6 | 0,35 - 0,70 | 1,6 - 8,0 | ☺ | ☺ | ☺ | ☺ | | | | | | | |

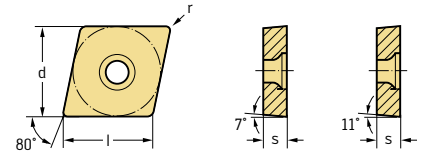
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide







Positive rhombic 80° CCMT/CCGT/CPGT/CCMW

Tiger-tec® Silver



Indexable inserts

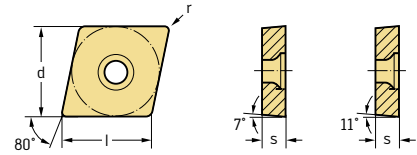
| Designation | r mm | f mm | a _p mm | P | | | | M | | | K | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|
| | | | | HC | | | | HC | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S |
|  CCMT060202-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | |
| CCMT060204-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
| CCMT060208-FP4 | 0,8 | 0,08 - 0,2 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
| CCMT09T302-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | |
| CCMT09T304-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
| CCMT09T308-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
| CCMT120404-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
| CCMT120408-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | |
|  CCMT060202-FM4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | | | ☺ | ☺ | | | | | |
| CCMT060204-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | |
| CCMT060208-FM4 | 0,8 | 0,08 - 0,2 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | |
| CCMT09T302-FM4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | | | ☺ | ☺ | | | | | |
| CCMT09T304-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | |
| CCMT09T308-FM4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | |
|  CCMT060204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | |
| CCMT060208-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | ☺ | ☺ | | | | | | | | |
| CCMT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | |
| CCMT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | |
| CCMT120404-MP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,5 | ☺ | ☺ | | | | | | | | |
| CCMT120408-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | ☺ | ☺ | | | | | | | | |
|  CCGT060204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | |
| CCGT060208-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | ☺ | ☺ | | | | | | | | |
| CCGT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | |
| CCGT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | |
| CCGT120408-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | ☺ | ☺ | | | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive rhombic 80° CCMT/CCGT/CPGT/CCMW

Tiger-tec® Silver



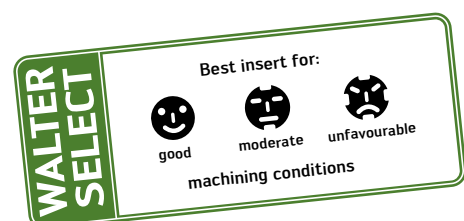
Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | K | | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | HC | | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| CPGT050204-MP4 | 0,4 | 0,08-0,20 | 0,4-2,0 | | ☺ | | | | | | | | | |
| CPGT060204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| CPGT060208-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | ☺ | ☺ | | | | | | | | | |
| CPGT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| CPGT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| CCMT060204-MM4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | ☹ | ☹ | | | | | | |
| CCMT060208-MM4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | | | | ☹ | ☹ | | | | | | |
| CCMT09T304-MM4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | ☹ | ☹ | | | | | | |
| CCMT09T308-MM4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | ☹ | ☹ | | | | | | |
| CCMT060204-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | | | | | ☹ | ☹ | | |
| CCMT060208-MK4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | | | | | | | | ☹ | ☹ | | |
| CCMT09T304-MK4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | | | | | ☹ | ☹ | | |
| CCMT09T308-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | | | | | ☹ | ☹ | | |
| CCMT120404-MK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,5 | | | | | | | | ☹ | ☹ | | |
| CCMT120408-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | | | | | | | | ☹ | ☹ | | |
| CCMT060204-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT060208-RP4 | 0,8 | 0,16 - 0,30 | 0,6 - 2,5 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT09T304-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT09T308-RP4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT120404-RP4 | 0,4 | 0,12 - 0,30 | 0,4 - 4,0 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT120408-RP4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | ☺ | ☺ | ☹ | | | | | | | | |
| CCMT120412-RP4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | ☺ | ☺ | ☹ | | | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

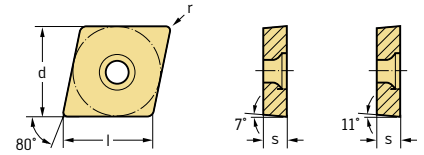
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide






Positive rhombic 80° CCMT/CCGT/CPGT/CCMW

Tiger-tec® Silver



Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | K | | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | HC | | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  CCMT060204-RM4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | | | |
| CCMT060208-RM4 | 0,8 | 0,16 - 0,30 | 0,6 - 2,5 | | | | | | | | | | | |
| CCMT09T304-RM4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | |
| CCMT09T308-RM4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | | | |
| CCMT120404-RM4 | 0,4 | 0,12 - 0,30 | 0,4 - 4,0 | | | | | | | | | | | |
| CCMT120408-RM4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | | | | | | | | |
| CCMT120412-RM4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | | | | | | | | |
|  CCMT060204-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | | | |
| CCMT060208-RK4 | 0,8 | 0,16 - 0,30 | 0,6 - 2,5 | | | | | | | | | | | |
| CCMT09T304-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | |
| CCMT09T308-RK4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | | | |
| CCMT120404-RK4 | 0,4 | 0,12 - 0,30 | 0,4 - 4,0 | | | | | | | | | | | |
| CCMT120408-RK4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | | | | | | | | |
| CCMT120412-RK4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | | | | | | | | |
|  CCMW060202-RK6 | 0,2 | 0,08 - 0,12 | 0,2 - 2,5 | | | | | | | | | | | |
| CCMW060204-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | | | |
| CCMW060208-RK6 | 0,8 | 0,16 - 0,30 | 0,5 - 2,5 | | | | | | | | | | | |
| CCMW09T304-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | |
| CCMW09T308-RK6 | 0,8 | 0,16 - 0,35 | 0,5 - 4,0 | | | | | | | | | | | |
| CCMW120404-RK6 | 0,4 | 0,12 - 0,30 | 0,4 - 4,0 | | | | | | | | | | | |
| CCMW120408-RK6 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | | | | | | | | |
| CCMW120412-RK6 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | | | | | | | | |

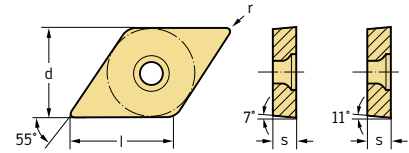
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive rhombic 55° DCMT/DCGT/DPGT/DCMW

Tiger-tec® Silver



Indexable inserts

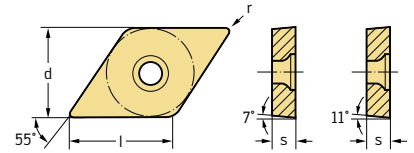
| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| DCMT070202-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| DCMT070204-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| DCMT070208-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| DCMT11T302-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| DCMT11T304-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| DCMT11T308-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| DCMT070204-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| DCMT11T302-FM4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | | | ☺ | ☺ | | | | | | |
| DCMT11T304-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| DCMT11T308-FM4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| DCMT070204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☹ | ☹ | | | | | | | | | |
| DCMT070208-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | ☹ | ☹ | | | | | | | | | |
| DCMT11T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☹ | ☹ | | | | | | | | | |
| DCMT11T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☹ | ☹ | | | | | | | | | |
| DCMT11T312-MP4 | 1,2 | 0,15 - 0,35 | 0,5 - 3,0 | ☹ | ☹ | | | | | | | | | |
| DCGT070204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| DCGT11T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| DCGT11T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| DPGT070204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| DPGT11T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| DPGT11T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| DCMT070204-MM4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | ☹ | ☹ | | | | | | |
| DCMT070208-MM4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | | | | ☹ | ☹ | | | | | | |
| DCMT11T304-MM4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | ☹ | ☹ | | | | | | |
| DCMT11T308-MM4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | ☹ | ☹ | | | | | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive rhombic 55° DCMT/DCGT/DPGT/DCMW

Tiger-tec® Silver



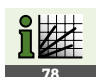
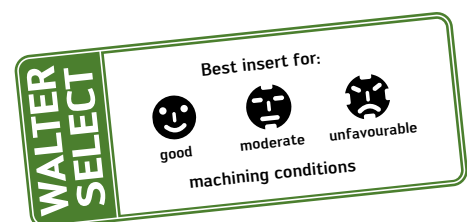
Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|---|--|
| | | | | HC | | | | HC | | | | HC | | | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 | | |
| DCMT070204-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | | | | | | | ☺ | ☹ | | |
| DCMT070208-MK4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | | | | | | | | | | | ☹ | ☹ | |
| DCMT11T304-MK4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT11T308-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT11T312-MK4 | 1,2 | 0,15 - 0,35 | 0,5 - 3,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT070204-RP4 | 0,4 | 0,12 - 0,20 | 0,4 - 2,0 | ☺ | ☹ | ☹ | | | | | | | | | | |
| DCMT070208-RP4 | 0,8 | 0,16 - 0,30 | 0,6 - 2,0 | ☺ | ☹ | ☹ | | | | | | | | | | |
| DCMT11T304-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | | | |
| DCMT11T308-RP4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | | | |
| DCMT11T312-RP4 | 1,2 | 0,20 - 0,40 | 0,8 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | | | |
| DCMT070204-RM4 | 0,4 | 0,12 - 0,20 | 0,4 - 2,0 | | | | ☹ | ☹ | | | | | | | | |
| DCMT11T304-RM4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | ☹ | ☹ | | | | | | | | |
| DCMT11T308-RM4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | ☹ | ☹ | | | | | | | | |
| DCMT070204-RK4 | 0,4 | 0,12 - 0,20 | 0,4 - 2,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT070208-RK4 | 0,8 | 0,16 - 0,30 | 0,6 - 2,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT11T304-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT11T308-RK4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMT11T312-RK4 | 1,2 | 0,20 - 0,40 | 0,8 - 4,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMW11T304-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | ☺ | ☹ | |
| DCMW11T308-RK6 | 0,8 | 0,16 - 0,35 | 0,5 - 4,0 | | | | | | | | | | | ☺ | ☹ | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

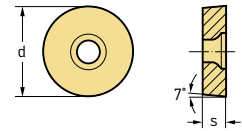
HC = Coated carbide



☺ ☹ ☹ New addition to the product range

Positive round RCMT

Tiger-tec® Silver



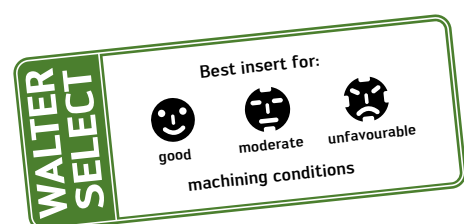
Indexable inserts

| Designation | d mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| RCMT0602M0-FP4 | 6 | 0,07 - 0,30 | 0,6 - 2,5 | ☺ | ☺ | | | | | | | | | |
| RCMT0803M0-FP4 | 8 | 0,08 - 0,30 | 0,8 - 3,0 | | ☺ | | | | | | | | | |
| RCMT10T3M0-FP4 | 10 | 0,10 - 0,35 | 1,0 - 4,0 | | ☺ | | | | | | | | | |
| RCMT1204M0-FP4 | 12 | 0,12 - 0,40 | 1,2 - 5,0 | ☺ | ☺ | | | | | | | | | |
| RCMT0602M0-RP4 | 6 | 0,08 - 0,50 | 0,6 - 2,5 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT060300-RP4 | 6,35 | 0,08 - 0,50 | 0,6-2,5 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT0803M0-RP4 | 8 | 0,10 - 0,60 | 0,8 - 3,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT09T300-RP4 | 9,525 | 0,10 - 0,60 | 0,8-3,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT10T3M0-RP4 | 10 | 0,12 - 0,80 | 1,0 - 4,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT120400-RP4 | 12,7 | 0,12 - 1,00 | 1,2 - 5,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT1204M0-RP4 | 12 | 0,12 - 1,00 | 1,2 - 5,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT1605M0-RP4 | 16 | 0,15 - 1,20 | 1,6 - 7,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT1606M0-RP4 | 16 | 0,15 - 1,20 | 1,6 - 7,0 | ☺ | ☺ | ☒ | | | | | | | | |
| RCMT0803M0-RM4 | 8 | 0,10 - 0,60 | 0,8 - 3,0 | | | | ☒ | ☒ | | | | | | |
| RCMT1013M0-RM4 | 10 | 0,12 - 0,80 | 1,0 - 4,0 | | | | ☒ | ☒ | | | | | | |
| RCMT1204M0-RM4 | 12 | 0,12 - 1,00 | 1,2 - 5,0 | | | | ☒ | ☒ | | | | | | |
| RCMT0602M0-RK4 | 6 | 0,08 - 0,50 | 0,6 - 2,5 | | | | | | | | | | ☒ | |
| RCMT0803M0-RK4 | 8 | 0,10 - 0,60 | 0,8 - 3,0 | | | | | | | | | | ☒ | |
| RCMT10T3M0-RK4 | 10 | 0,12 - 0,80 | 1,0 - 4,0 | | | | | | | | | ☺ | ☒ | |
| RCMT1204M0-RK4 | 12 | 0,12 - 1,00 | 1,2 - 5,0 | | | | | | | | | ☺ | ☒ | |
| RCMT1605M0-RK4 | 16 | 0,15 - 1,20 | 1,6 - 7,0 | | | | | | | | | | ☒ | |
| RCMT1606M0-RK4 | 16 | 0,15 - 1,20 | 1,6 - 7,0 | | | | | | | | | | ☒ | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

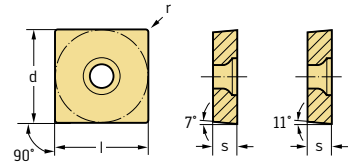
HC = Coated carbide










☺ ☒ ☒ New addition to the product range

Positive square SCMT/SCGT/SPGT/SCMW

Tiger-tec® Silver



Indexable inserts

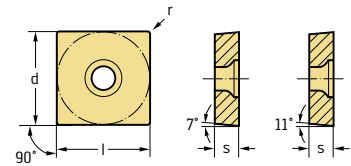
| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  SCMT09T304-FP4 | 0,4 | 0,05 - 0,15 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| SCMT09T308-FP4 | 0,8 | 0,05 - 0,18 | 0,1 - 1,8 | ☺ | ☺ | | | | | | | | | |
| SCMT120404-FP4 | 0,4 | 0,05 - 0,15 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| SCMT120408-FP4 | 0,8 | 0,05 - 0,18 | 0,1 - 1,8 | ☺ | ☺ | | | | | | | | | |
| SCMT120412-FP4 | 1,2 | 0,12 - 0,32 | 0,3 - 1,8 | ☺ | ☺ | | | | | | | | | |
|  SCMT09T304-FM4 | 0,4 | 0,05 - 0,15 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| SCMT09T308-FM4 | 0,8 | 0,05 - 0,18 | 0,1 - 1,8 | | | | ☺ | ☺ | | | | | | |
|  SCMT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| SCMT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| SCMT120408-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | ☺ | ☺ | | | | | | | | | |
|  SCGT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| SCGT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| SCGT120408-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | ☺ | ☺ | | | | | | | | | |
|  SPGT09T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| SPGT09T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
|  SCMT09T304-MM4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | ☺ | ☺ | | | | | | |
| SCMT09T308-MM4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | ☺ | ☺ | | | | | | |
|  SCMT09T304-MK4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | | | | | ☺ | ☺ | | |
| SCMT09T308-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | | | | | ☺ | ☺ | | |
| SCMT120408-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,5 | | | | | | | | ☺ | ☺ | | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.





HC = Coated carbide

Positive square SCMT/SCGT/SPGT/SCMW

Tiger-tec® Silver

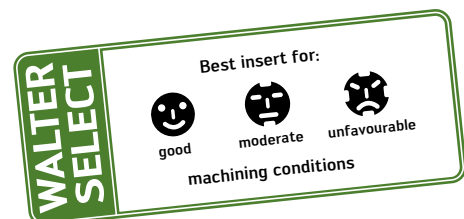


Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  SCMT09T304-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | ☹ | | | | | | | | |
| SCMT09T308-RP4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | ☺ | ☺ | ☹ | | | | | | | | |
| SCMT09T312-RP4 | 1,2 | 0,20 - 0,45 | 0,8 - 5,0 | ☺ | | | | | | | | | | |
| SCMT120404-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | ☹ | | | | | | | | |
| SCMT120408-RP4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | ☺ | ☺ | ☹ | | | | | | | | |
| SCMT120412-RP4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | ☺ | ☺ | ☹ | | | | | | | | |
|  SCMT09T308-RM4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | ☺ | ☺ | | | | | | |
| SCMT120408-RM4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | ☺ | ☺ | | | | | | |
| SCMT120412-RM4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | ☺ | ☺ | | | | | | |
|  SCMT09T304-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☹ | ☹ | |
| SCMT09T308-RK4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | ☹ | ☹ | |
| SCMT120404-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☹ | ☹ | |
| SCMT120408-RK4 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | | | | | | ☹ | ☹ | |
| SCMT120412-RK4 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | | | | | | ☹ | ☹ | |
|  SCMW09T304-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☹ | ☹ | |
| SCMW09T308-RK6 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | ☹ | ☹ | |
| SCMW120404-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 4,0 | | | | | | | | | ☹ | ☹ | |
| SCMW120408-RK6 | 0,8 | 0,16 - 0,40 | 0,6 - 5,0 | | | | | | | | | ☹ | ☹ | |
| SCMW120412-RK6 | 1,2 | 0,20 - 0,50 | 0,8 - 5,0 | | | | | | | | | ☹ | ☹ | |

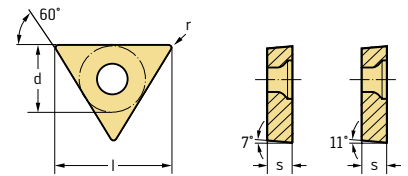
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide






Positive triangular TCMT/TCGT/TPGT/TCMW

Tiger-tec® Silver



Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|--|
| | | | | HC | | | | HC | | | | HC | | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 | |
|  TCMT06T102-FP4 | 0,2 | 0,02 - 0,10 | 0,1 - 1,0 | | ☞ | | | | | | | | | | |
| TCMT06T104-FP4 | 0,4 | 0,04 - 0,17 | 0,1 - 1,0 | | ☞ | | | | | | | | | | |
| TCMT090202-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | ☞ | | | | | | | | | | |
| TCMT090204-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☞ | ☞ | | | | | | | | | | |
| TCMT090208-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | | ☞ | | | | | | | | | | |
| TCMT110202-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT110204-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☞ | ☞ | | | | | | | | | | |
| TCMT110208-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☞ | ☞ | | | | | | | | | | |
| TCMT16T302-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | ☞ | | | | | | | | | | |
| TCMT16T304-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☞ | ☞ | | | | | | | | | | |
| TCMT16T308-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☞ | ☞ | | | | | | | | | | |
|  TCMT110204-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☞ | ☞ | | | | | | | |
| TCMT16T304-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☞ | ☞ | | | | | | | |
| TCMT16T308-FM4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | | | | ☞ | ☞ | | | | | | | |
|  TCMT090204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT090208-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT110204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT110208-MP4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT16T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☞ | ☞ | | | | | | | | | | |
| TCMT16T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☞ | ☞ | | | | | | | | | | |

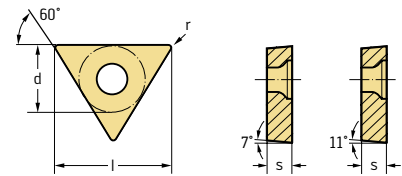
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive triangular TCMT/TCGT/TPGT/TCMW

Tiger-tec® Silver

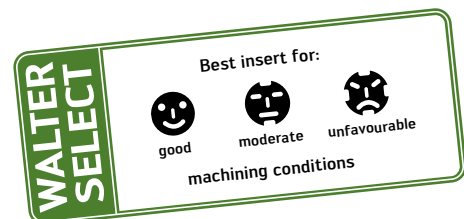


Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| TCMT090204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TCMT110204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TCMT110208-MP4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TCMT16T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| TCMT16T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| TPGT090204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TPGT110204-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TPGT110208-MP4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | ☺ | ☺ | | | | | | | | | |
| TPGT16T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | ☺ | ☺ | | | | | | | | | |
| TPGT16T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | ☺ | ☺ | | | | | | | | | |
| TCMT16T304-MM4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | ☹ | ☹ | | | | | | |
| TCMT16T308-MM4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | ☹ | ☹ | | | | | | |
| TCMT090204-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | | | | | | ☹ | ☹ | |
| TCMT090208-MK4 | 0,8 | 0,12 - 0,25 | 0,5 - 2,0 | | | | | | | | | ☹ | ☹ | |
| TCMT110204-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | | | | | | ☹ | ☹ | |
| TCMT110208-MK4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | | | | | | | | | ☹ | ☹ | |
| TCMT16T304-MK4 | 0,4 | 0,08 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☹ | ☹ | |
| TCMT16T308-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 3,0 | | | | | | | | | ☹ | ☹ | |

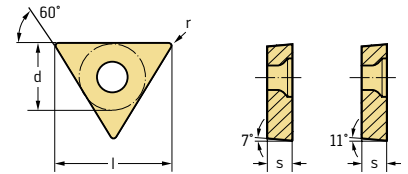
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide



Positive triangular TCMT/TCGT/TPGT/TCMW

Tiger-tec® Silver



Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| TCMT090204-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT090208-RP4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT110204-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT110208-RP4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT16T304-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT16T308-RP4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT16T312-RP4 | 1,2 | 0,20 - 0,40 | 0,8 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | |
| TCMT110208-RM4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | ☹ | ☹ | | | | | | |
| TCMT16T304-RM4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | ☹ | ☹ | | | | | | |
| TCMT16T308-RM4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | ☹ | ☹ | | | | | | |
| TCMT090204-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMT090208-RK4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMT110204-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMT110208-RK4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMT16T304-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMT16T308-RK4 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | ☺ | ☹ | |
| TCMT16T312-RK4 | 1,2 | 0,20 - 0,40 | 0,8 - 4,0 | | | | | | | | | ☺ | ☹ | |
| TCMW110202-RK6 | 0,2 | 0,08 - 0,12 | 0,2 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMW110204-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMW110208-RK6 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMW16T304-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | |
| TCMW16T308-RK6 | 0,8 | 0,16 - 0,35 | 0,6 - 4,0 | | | | | | | | | ☺ | ☹ | |

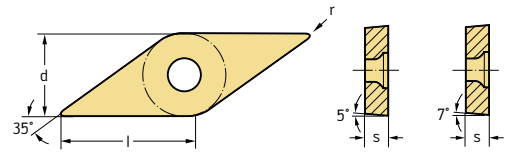
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive rhombic 35° VCMT/VBMT/VCMW

Tiger-tec® Silver

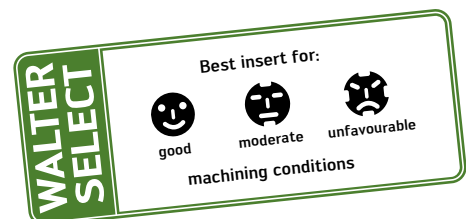


Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| VCMT110302-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| VCMT110304-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| VCMT160402-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| VCMT160404-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| VCMT160408-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| VCMT110302-FM4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | | | ☺ | ☺ | | | | | | |
| VCMT110304-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| VCMT160402-FM4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | | | | ☺ | ☺ | | | | | | |
| VCMT160404-FM4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| VCMT160408-FM4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | | | | ☺ | ☺ | | | | | | |
| VBMT110304-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 1,5 | ☹ | ☹ | | | | | | | | | |
| VBMT110308-MP4 | 0,8 | 0,12 - 0,25 | 0,5 - 1,5 | ☹ | ☹ | | | | | | | | | |
| VBMT160404-MP4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | ☹ | ☹ | | | | | | | | | |
| VBMT160406-MP4 | 0,6 | 0,12 - 0,25 | 0,5 - 2,0 | ☹ | ☹ | | | | | | | | | |
| VBMT160408-MP4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | ☹ | ☹ | | | | | | | | | |
| VBMT160412-MP4 | 1,2 | 0,12 - 0,32 | 0,5 - 2,0 | ☹ | ☹ | | | | | | | | | |
| VBMT160404-MM4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | ☹ | ☹ | | | | | | |
| VBMT160408-MM4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | | | | ☹ | ☹ | | | | | | |

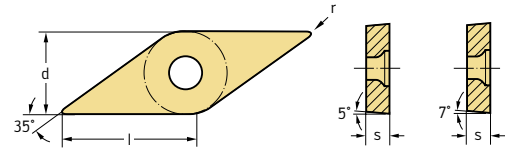
For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide



Positive rhombic 35° VCMT/VBMT/VCMW

Tiger-tec® Silver



Indexable inserts

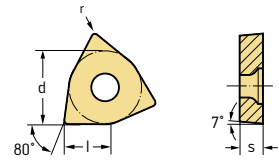
| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|----------------|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
| VBMT110304-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 1,5 | | | | | | | | | ☺ | ☺ | |
| VBMT110308-MK4 | 0,8 | 0,12 - 0,25 | 0,5 - 1,5 | | | | | | | | | ☺ | ☺ | |
| VBMT160404-MK4 | 0,4 | 0,08 - 0,20 | 0,4 - 2,0 | | | | | | | | | ☺ | ☺ | |
| VBMT160408-MK4 | 0,8 | 0,12 - 0,30 | 0,5 - 2,0 | | | | | | | | | ☺ | ☺ | |
| VBMT160412-MK4 | 1,2 | 0,12 - 0,32 | 0,5 - 2,0 | | | | | | | | | | ☺ | |
| VCMT110304-RP4 | 0,4 | 0,12 - 0,20 | 0,4 - 2,5 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT110308-RP4 | 0,8 | 0,16 - 0,25 | 0,6 - 3,0 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT160404-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT160406-RP4 | 0,6 | 0,15 - 0,25 | 0,6 - 3,0 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT160408-RP4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT160412-RP4 | 1,2 | 0,20 - 0,35 | 0,8 - 3,0 | ☺ | ☺ | ☺ | | | | | | | | |
| VCMT160404-RM4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | ☺ | ☺ | | | | | | |
| VCMT160408-RM4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | ☺ | ☺ | | | | | | |
| VCMT110304-RK4 | 0,4 | 0,12 - 0,20 | 0,4 - 2,5 | | | | | | | | | ☺ | ☺ | |
| VCMT110308-RK4 | 0,8 | 0,16 - 0,25 | 0,6 - 3,0 | | | | | | | | | ☺ | ☺ | |
| VCMT160404-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | ☺ | ☺ | |
| VCMT160408-RK4 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | | | | | | ☺ | ☺ | |
| VCMT160412-RK4 | 1,2 | 0,20 - 0,35 | 0,8 - 3,0 | | | | | | | | | ☺ | ☺ | |
| VCMW160404-RK6 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | ☺ | ☺ | |
| VCMW160408-RK6 | 0,8 | 0,16 - 0,30 | 0,6 - 3,0 | | | | | | | | | ☺ | ☺ | |
| VCMW160412-RK6 | 1,2 | 0,20 - 0,35 | 0,8 - 3,0 | | | | | | | | | ☺ | ☺ | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.


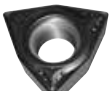

For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

Positive Trigon 80° WCMT Tiger-tec® Silver



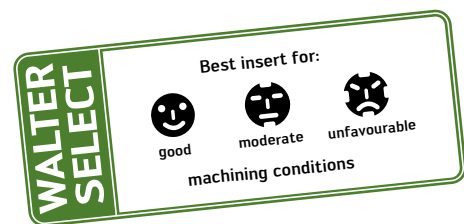
Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | |
|--|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|
| | | | | HC | | | | HC | | | | HC | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 |
|  WCMT040202-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| WCMT040204-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| WCMT040208-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| WCMT06T302-FP4 | 0,2 | 0,04 - 0,12 | 0,1 - 1,0 | ☺ | ☺ | | | | | | | | | |
| WCMT06T304-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | ☺ | | | | | | | | | |
| WCMT06T308-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | | | | | | | | | | |
| WCMT080404-FP4 | 0,4 | 0,05 - 0,16 | 0,1 - 1,5 | ☺ | | | | | | | | | | |
| WCMT080408-FP4 | 0,8 | 0,08 - 0,20 | 0,1 - 1,5 | ☺ | | | | | | | | | | |
|  WCMT06T304-MP4 | 0,4 | 0,08 - 0,25 | 0,4 - 2,5 | | ☹ | | | | | | | | | |
| WCMT06T308-MP4 | 0,8 | 0,12 - 0,32 | 0,5 - 2,5 | | ☹ | | | | | | | | | |
|  WCMT06T304-MK4 | 0,4 | 0,08 - 0,25 | 0,4 - 2,5 | | | | | | | | | | ☹ | |
| WCMT06T308-MK4 | 0,8 | 0,12 - 0,32 | 0,5 - 2,5 | | | | | | | | | | ☹ | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.

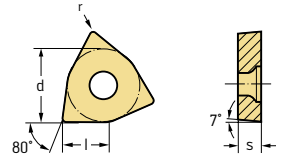
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide





Positive Trigon 80° WCMT

Tiger-tec® Silver



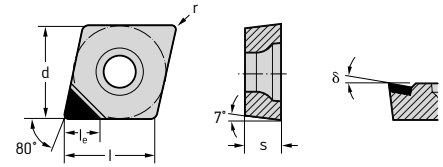
Indexable inserts

| Designation | r mm | f mm | a _p mm | P | | | | M | | | | K | | | |
|---|---------|-------------|----------------------|--------|--------|--------|--------|--------|-------|-------|-------|--------|--------|-------|--|
| | | | | HC | | | | HC | | | | HC | | | |
| | | | | WPP10S | WPP20S | WPP30S | WMP20S | WMP20S | WSM10 | WSM20 | WSM30 | WKK10S | WKK20S | WAK30 | |
|  WCMT030202-RP4 | 0,2 | 0,08 - 0,12 | 0,2 - 1,5 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT040204-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT06T304-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT06T308-RP4 | 0,8 | 0,16 - 0,35 | 0,6 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT080404-RP4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT080408-RP4 | 0,8 | 0,16 - 0,40 | 0,6 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | | |
| WCMT080412-RP4 | 1,2 | 0,20 - 0,45 | 0,8 - 4,0 | ☺ | ☹ | ☹ | | | | | | | | | |
|  WCMT030202-RK4 | 0,2 | 0,08 - 0,12 | 0,2 - 1,5 | | | | | | | | | | | ☹ | |
| WCMT040204-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 2,5 | | | | | | | | | | | ☹ | |
| WCMT06T304-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | ☺ | ☹ | | |
| WCMT06T308-RK4 | 0,8 | 0,16 - 0,35 | 0,6 - 3,0 | | | | | | | | | ☺ | ☹ | | |
| WCMT080404-RK4 | 0,4 | 0,12 - 0,25 | 0,4 - 3,0 | | | | | | | | | | | ☹ | |
| WCMT080408-RK4 | 0,8 | 0,16 - 0,40 | 0,6 - 4,0 | | | | | | | | | | | ☹ | |
| WCMT080412-RK4 | 1,2 | 0,20 - 0,45 | 0,8 - 4,0 | | | | | | | | | | | ☹ | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

HC = Coated carbide

PCD – Positive rhombic 80° CCGT/CCGW

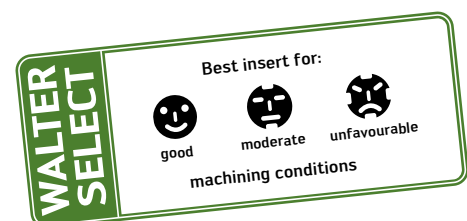


Indexable inserts

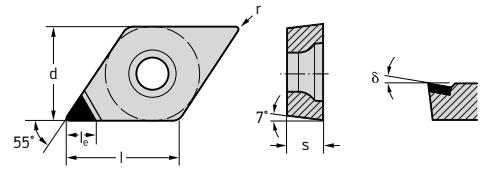
| Designation | Number of cutting edges | le mm | δ | r mm | f mm | ap mm | N | O |
|-------------|-------------------------|-------|------|------|------------|-------------|-------|-------|
| | | | | | | | DP | DP |
| | | | | | | | WDN10 | WDN10 |
| | CCGT060204FS-M1 | 1 | 3,50 | 0,4 | 0,08 - 0,2 | 0,1 - 2,5 | ☺ | ☹ |
| | CCGT09T304FS-M1 | 1 | 4,00 | 0,4 | 0,08 - 0,2 | 0,1 - 3,0 | ☺ | ☹ |
| | CCGT060202FS-1 | 1 | 3,50 | 7° | 0,2 | 0,03 - 0,12 | ☺ | ☹ |
| | CCGT060204FS-1 | 1 | 3,50 | 7° | 0,4 | 0,03 - 0,25 | ☺ | ☹ |
| | CCGT060208FS-1 | 1 | 3,50 | 7° | 0,8 | 0,03 - 0,38 | ☺ | ☹ |
| | CCGT09T304FS-1 | 1 | 4,00 | 10° | 0,4 | 0,03 - 0,25 | ☺ | ☹ |
| | CCGT09T308FS-1 | 1 | 4,00 | 10° | 0,8 | 0,03 - 0,38 | ☺ | ☹ |
| | CCGW060202FS-1 | 1 | 3,58 | 0° | 0,2 | 0,03 - 0,12 | ☹ | ☹ |
| | CCGW060204FS-1 | 1 | 3,54 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW060208FS-1 | 1 | 3,46 | 0° | 0,8 | 0,03 - 0,38 | ☹ | ☹ |
| | CCGW09T302FS-1 | 1 | 4,12 | 0° | 0,2 | 0,03 - 0,12 | ☹ | ☹ |
| | CCGW09T304FS-1 | 1 | 4,08 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW09T308FS-1 | 1 | 4,00 | 0° | 0,8 | 0,03 - 0,38 | ☹ | ☹ |
| | CCGW120404FS-1 | 1 | 4,08 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW120408FS-1 | 1 | 4,00 | 0° | 0,8 | 0,03 - 0,38 | ☹ | ☹ |
| | CCGW060204FSL-9 | 1 | 6,40 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW09T304FSL-9 | 1 | 9,70 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW09T308FSL-9 | 1 | 9,70 | 0° | 0,8 | 0,03 - 0,38 | ☹ | ☹ |
| | CCGW060204FSR-9 | 1 | 6,40 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW09T304FSR-9 | 1 | 9,70 | 0° | 0,4 | 0,03 - 0,25 | ☹ | ☹ |
| | CCGW09T308FSR-9 | 1 | 9,70 | 0° | 0,8 | 0,03 - 0,38 | ☹ | ☹ |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

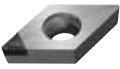


DP = Polycrystalline diamond



PCD – Positive rhombic 55° DCGT/DCGW



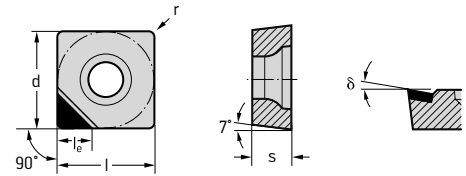
Indexable inserts

| | Designation | Number of cutting edges | le mm | δ | r mm | f mm | ap mm | N | O |
|---|-----------------|-------------------------|-------|----------|------|-------------|------------|-------|-------|
| | | | | | | | | DP | DP |
| | | | | | | | | WDN10 | WDN10 |
|  | DCGT070204FS-M1 | 1 | 3,50 | | 0,4 | 0,08 - 0,2 | 0,1 - 2,5 | ☺ | ☺ |
| | DCGT11T304FS-M1 | 1 | 4,00 | | 0,4 | 0,08 - 0,2 | 0,1 - 3,0 | ☺ | ☺ |
|  | DCGT070202FS-1 | 1 | 3,68 | 7° | 0,2 | 0,03 - 0,12 | 0,05 - 1,0 | ☺ | ☺ |
| | DCGT070204FS-1 | 1 | 3,50 | 7° | 0,4 | 0,03 - 0,25 | 0,05 - 1,0 | ☺ | ☺ |
| | DCGT070208FS-1 | 1 | 3,50 | 7° | 0,8 | 0,03 - 0,38 | 0,05 - 1,5 | ☺ | ☺ |
| | DCGT11T302FS-1 | 1 | 4,18 | 10° | 0,2 | 0,03 - 0,12 | 0,05 - 1,0 | ☺ | ☺ |
| | DCGT11T304FS-1 | 1 | 4,00 | 10° | 0,4 | 0,03 - 0,25 | 0,05 - 1,0 | ☺ | ☺ |
| | DCGT11T308FS-1 | 1 | 4,00 | 10° | 0,8 | 0,03 - 0,38 | 0,05 - 1,5 | ☺ | ☺ |
|  | DCGW070202FS-1 | 1 | 3,68 | 0° | 0,2 | 0,03 - 0,12 | 0,05 - 3,0 | ☺ | ☺ |
| | DCGW070204FS-1 | 1 | 3,50 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,0 | ☺ | ☺ |
| | DCGW070208FS-1 | 1 | 3,50 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 3,0 | ☺ | ☺ |
| | DCGW11T302FS-1 | 1 | 4,18 | 0° | 0,2 | 0,03 - 0,12 | 0,05 - 3,5 | ☺ | ☺ |
| | DCGW11T304FS-1 | 1 | 4,00 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,5 | ☺ | ☺ |
| | DCGW11T308FS-1 | 1 | 4,00 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 3,5 | ☺ | ☺ |


For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

DP = Polycrystalline diamond

PCD – Positive square SCGW



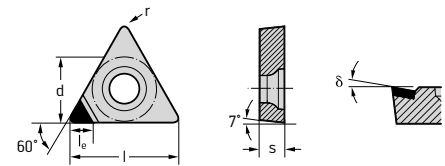
Indexable inserts

| Designation | Number of cutting edges | le mm | δ | r mm | f mm | ap mm | N | O |
|--|-------------------------|-------|----------|------|-------------|------------|-------|-------|
| | | | | | | | DP | DP |
| | | | | | | | WDN10 | WDN10 |
|  SCGW09T304FS-9 | 1 | 9,52 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 9,0 | ☺ | ☹ |
| | | | | | | | | |
| | | | | | | | | |



For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

DP = Polycrystalline diamond

PCD – Positive triangular TCGW



Indexable inserts

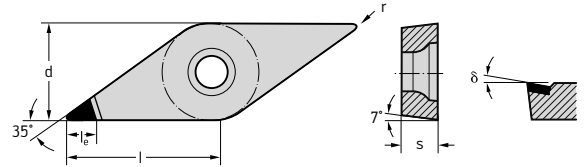
| Designation | Number of cutting edges | le mm | δ | r mm | f mm | ap mm | N | O | |
|--|-------------------------|-------|----------|------|-------------|-------------|-------------|-------|---|
| | | | | | | | DP | DP | |
| | | | | | | | WDN10 | WDN10 | |
|  TCGW090202FS-1 | 1 | 3,94 | 0° | 0,2 | 0,03 - 0,12 | 0,05 - 3,0 | ☺ | ☹ | |
| | TCGW090204FS-1 | 1 | 3,79 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,0 | ☺ | ☹ |
| | TCGW110202FS-1 | 1 | 4,44 | 0° | 0,2 | 0,03 - 0,12 | 0,05 - 3,0 | ☺ | ☹ |
| | TCGW110204FS-1 | 1 | 4,29 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,0 | ☺ | ☹ |
| | TCGW110208FS-1 | 1 | 4,00 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 3,0 | ☹ | ☹ |
| | TCGW16T304FS-1 | 1 | 4,29 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,5 | ☹ | ☹ |
| | TCGW16T308FS-1 | 1 | 4,00 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 3,5 | ☹ | ☹ |
|  TCGW090204FS-9 | 1 | 9,04 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 8,5 | ☹ | ☹ | |
| | TCGW110204FS-9 | 1 | 10,41 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 9,9 | ☹ | ☹ |
| | TCGW16T308FS-9 | 1 | 15,32 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 14,4 | ☹ | ☹ |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

DP = Polycrystalline diamond



PCD – Positive rhombic 35° VCGT/VCGW

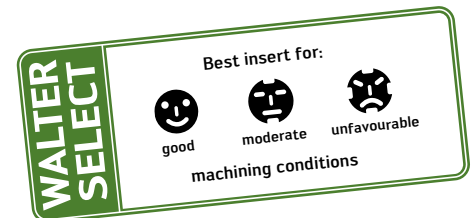


Indexable inserts

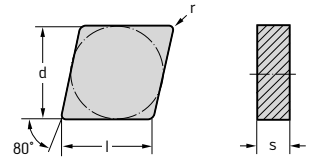
| | Designation | Number of cutting edges | le mm | δ | r mm | f mm | ap mm | N | O |
|--|----------------|-------------------------|-------|-----|------|-------------|------------|-------|-------|
| | | | | | | | | DP | DP |
| | | | | | | | | WDN10 | WDN10 |
| | VCGT110302FS-1 | 1 | 4,13 | 10° | 0,2 | 0,03 - 0,12 | 0,05 - 1,0 | ☺ | ☺ |
| | VCGT110304FS-1 | 1 | 3,70 | 10° | 0,4 | 0,03 - 0,25 | 0,05 - 1,0 | ☺ | ☺ |
| | VCGT160404FS-1 | 1 | 4,50 | 10° | 0,4 | 0,03 - 0,25 | 0,05 - 1,0 | ☺ | ☺ |
| | VCGT160408FS-1 | 1 | 4,50 | 10° | 0,8 | 0,03 - 0,38 | 0,05 - 1,5 | ☺ | ☺ |
| | VCGW110302FS-1 | 1 | 4,13 | 0° | 0,2 | 0,03 - 0,12 | 0,05 - 3,0 | ☺ | ☺ |
| | VCGW110304FS-1 | 1 | 3,70 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 3,0 | ☺ | ☺ |
| | VCGW110308FS-1 | 1 | 3,70 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 3,0 | ☺ | ☺ |
| | VCGW160404FS-1 | 1 | 4,50 | 0° | 0,4 | 0,03 - 0,25 | 0,05 - 4,0 | ☺ | ☺ |
| | VCGW160408FS-1 | 1 | 4,50 | 0° | 0,8 | 0,03 - 0,38 | 0,05 - 4,0 | ☺ | ☺ |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.






DP = Polycrystalline diamond



Ceramic – Negative rhombic 80° CNGN

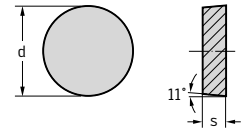


Indexable inserts






| Designation | r mm | f mm | a _p mm | S | |
|--|---------|------------|----------------------|-------|--|
| | | | | CN | CR |
| | | | | WIS10 | WWS20 |
|  CNGN120408T01020 CNGN120412T01020 | 0,8 | 0,1 - 0,22 | 0,1 - 3,6 | |   |
| | 1,2 | 0,1 - 0,32 | 0,1 - 3,6 | |   |

CN = Silicon nitride Si₃N₄
CR = Reinforced ceramic

Ceramic – Positive round RPGN

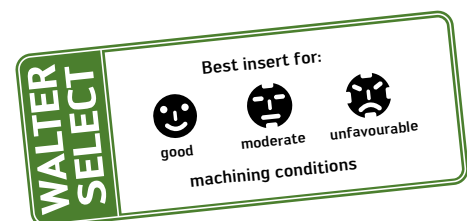


Indexable inserts

| Designation | d mm | f mm | a _p mm | S | |
|--|---------|------------|----------------------|--|-------|
| | | | | CN | CR |
| | | | | WIS10 | WWS20 |
|  RPGN090300T01020 RPGN120400T01020 | 9,525 | 0,1 - 0,25 | 0,2 - 2,4 |   | |
| | 12,7 | 0,1 - 0,32 | 0,2 - 3,6 |   | |

For dimensions, see the ISO 1832 designation key from page A-4 onwards in the Walter Supplementary Catalogue 2013/2014.
For achievable surface finish qualities and technical information, see page A 298 in the Walter General Catalogue 2012.

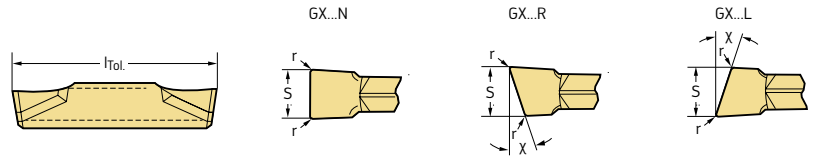
CN = Silicon nitride Si₃N₄
CR = Reinforced ceramic





Walter Cut GX grooving inserts

Grooving and parting off

Tiger-tec® Silver



Indexable inserts

| Designation | s mm | r mm | κ | l mm | f mm | s _{Tol} mm | l _{Tol} mm | P | | | M | | | K | S | | | | |
|---|---------|---------|----|---------|-------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--|
| | | | | | | | | HC | | | HC | | | WKP23S | HC | | WKP23S | HC | |
| | | | | | | | | WKM23S | WSM33S | WSM43S | WKM23S | WSM33S | WSM43S | | WKM23S | WSM33S | | WSM43S | |
|  GX16-1E200N02-CE4 | 2 | 0,2 | | 16,6 | 0,06 - 0,15 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1E200R/L6-CE4 | 2 | 0,2 | 6° | 16,6 | 0,04 - 0,10 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1E250N02-CE4 | 2,5 | 0,2 | | 16,6 | 0,07 - 0,18 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1E250R/L6-CE4 | 2,5 | 0,2 | 6° | 16,6 | 0,04 - 0,12 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-2E300N02-CE4 | 3 | 0,2 | | 16,6 | 0,09 - 0,30 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-2E300R/L6-CE4 | 3 | 0,2 | 6° | 16,6 | 0,09 - 0,24 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-1E200N02-CE4 | 2 | 0,2 | | 24 | 0,06 - 0,15 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-1E250N02-CE4 | 2,5 | 0,2 | | 24 | 0,07 - 0,18 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-2E300N02-CE4 | 3 | 0,2 | | 24 | 0,09 - 0,30 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-2E300R/L6-CE4 | 3 | 0,2 | 6° | 24,6 | 0,09 - 0,24 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3E400N03-CE4 | 4 | 0,3 | | 24 | 0,10 - 0,32 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3E400R/L6-CE4 | 4 | 0,2 | 6° | 24,6 | 0,10 - 0,26 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3E500N03-CE4 | 5 | 0,3 | | 24 | 0,12 - 0,35 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-4E600N03-CE4 | 6 | 0,3 | | 24 | 0,12 - 0,40 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
|  GX16-1F200N02-CE4 | 2 | 0,2 | | 16 | 0,04 - 0,12 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1F250N02-CE4 | 2,5 | 0,2 | | 16 | 0,05 - 0,15 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-2F300N02-CE4 | 3 | 0,2 | | 24 | 0,09 - 0,30 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3F400N03-CE4 | 4 | 0,3 | | 24 | 0,10 - 0,32 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |

l_{Tol} = Repeat accuracy when changing indexable insert

Radius tolerance r_{Tol} = ± 0.05 mm

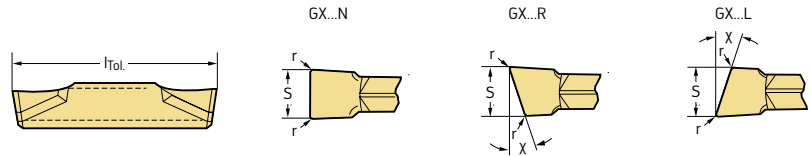
Parting off with diameters up to 32 mm is possible with these inserts (l = 16.6 mm)

HC = Coated carbide

Walter Cut GX grooving inserts

Grooving and parting off

Tiger-tec® Silver



Indexable inserts

| Designation | s mm | r mm | κ | l mm | f mm | s _{Tol} mm | l _{Tol} mm | P | | | M | | | K | S | | |
|---------------------|---------|---------|-----|---------|-------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| | | | | | | | | HC | | | HC | | | HC | HC | | |
| | | | | | | | | WKP23S | WSM23S | WSM33S | WSM43S | WSM23S | WSM33S | WSM43S | WKP23S | WSM23S | WSM33S |
| GX16-0E150N01-CF6 | 1,5 | 0,15 | | 16,6 | 0,03 - 0,10 | ±0,02 | ±0,05 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-0E150R/L10-CF6 | 1,5 | 0,15 | 10° | 16,6 | 0,03 - 0,10 | ±0,02 | ±0,05 | | ☑ | | | ☑ | | | | ☑ | |
| GX16-1E200N02-CF6 | 2 | 0,2 | | 16,6 | 0,03 - 0,12 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-1E200R/L6-CF6 | 2 | 0,2 | 6° | 16,6 | 0,03 - 0,10 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-1E200R/L7-CF6 | 2 | | 7° | 16,2 | 0,03 - 0,10 | ±0,02 | ±0,15 | | ☑ | | | ☑ | | | | ☑ | |
| GX16-1E200R/L15-CF6 | 2 | | 15° | 16,2 | 0,03 - 0,10 | ±0,02 | ±0,15 | | ☑ | | | ☑ | | | | ☑ | |
| GX16-1E250N02-CF6 | 2,5 | 0,2 | | 16,6 | 0,03 - 0,15 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-1E250R/L6-CF6 | 2,5 | 0,2 | 6° | 16,6 | 0,03 - 0,12 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-2E300N02-CF6 | 3 | 0,2 | | 16,6 | 0,04 - 0,20 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-2E300R/L6-CF6 | 3 | 0,2 | 6° | 16,6 | 0,04 - 0,16 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX16-2E300R/L7-CF6 | 3 | | 7° | 16,2 | 0,04 - 0,13 | ±0,02 | ±0,15 | | ☑ | | | ☑ | | | | ☑ | |
| GX16-2E300R/L15-CF6 | 3 | | 15° | 16,2 | 0,04 - 0,13 | ±0,02 | ±0,15 | | ☑ | | | ☑ | | | | ☑ | |
| GX24-1E200N02-CF6 | 2 | 0,2 | | 24 | 0,03 - 0,12 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | ☑ | ☑ | | | ☑ | ☑ |
| GX24-1E250N02-CF6 | 2,5 | 0,2 | | 24 | 0,03 - 0,15 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | ☑ | ☑ | | | ☑ | ☑ |
| GX24-2E300N02-CF6 | 3 | 0,2 | | 24,6 | 0,04 - 0,20 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |
| GX24-2E300R/L6-CF6 | 3 | 0,2 | 6° | 24,6 | 0,04 - 0,16 | ±0,05 | ±0,15 | | ☑ | ☑ | ☑ | | | | | ☑ | ☑ |

l_{Tol} = Repeat accuracy when changing indexable insert

Radius tolerance r_{Tol} = ± 0.05 mm

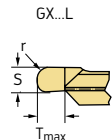
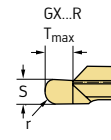
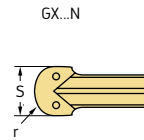
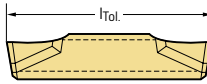
Parting off with diameters up to 32 mm is possible with these inserts (l = 16.6 mm)

HC = Coated carbide



Walter Cut GX grooving inserts

Grooving and longitudinal turning

Tiger-tec® Silver

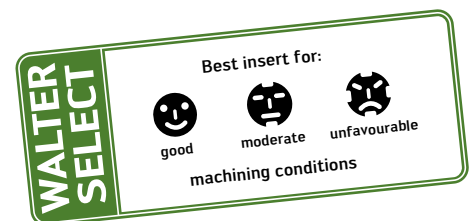


Indexable inserts

| Designation | s mm | r mm | l mm | f mm | a _p mm | s _{Tol} mm | l _{Tol} mm | P | | | M | | | K | | N | S | | |
|---|---------|---------|---------|-------------|----------------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|-------|--------|--------|-----|--------|
| | | | | | | | | HC | | | HC | | | HC | | HW | HC | | |
| | | | | | | | | WKP23S | WSM13S | WSM23S | WSM33S | WSM13S | WSM23S | WSM33S | WSM33 | WKP23S | WKP33S | WK1 | WSM13S |
|  GX16-1E200N10-RD4 | 2 | 1 | 16 | 0,08 - 0,25 | 0,2 - 1,0 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX16-1E239N12-RD4 | 2,39 | 1,2 | 16 | 0,08 - 0,25 | 0,2 - 1,0 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-2E300N15-RD4 | 3 | 1,5 | 24 | 0,10 - 0,35 | 0,5 - 1,5 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-2E318N16-RD4 | 3,18 | 1,59 | 24 | 0,08 - 0,35 | 1,6 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-3E400N20-RD4 | 4 | 2 | 24 | 0,15 - 0,50 | 0,5 - 2,0 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-3E475N24-RD4 | 4,75 | 2,38 | 24 | 0,10 - 0,40 | 2,4 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-3E500N25-RD4 | 5 | 2,5 | 24 | 0,17 - 0,70 | 0,5 - 2,5 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-4E600N30-RD4 | 6 | 3 | 24 | 0,17 - 0,70 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-4E635N32-RD4 | 6,35 | 3,18 | 24 | 0,15 - 0,60 | 3 | ±0,05 | ±0,15 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
|  GX16-2E300N15-RF8 | 3 | 1,5 | 16 | 0,10 - 0,30 | 0,1 - 1,5 | ±0,02 | ±0,02 | ☺ | ☹ | ☹ | ☺ | ☹ | ☺ | ☺ | ☺ | ☺ | ☺ | ☹ | ☹ |
| GX24-2E300N15-RF8 | 3 | 1,5 | 24 | 0,10 - 0,30 | 0,1 - 1,5 | ±0,02 | ±0,02 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-3E400N20-RF8 | 4 | 2 | 24 | 0,12 - 0,45 | 0,1 - 2,0 | ±0,02 | ±0,02 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-3E500N25-RF8 | 5 | 2,5 | 24 | 0,15 - 0,50 | 0,1 - 2,5 | ±0,02 | ±0,02 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX24-4E600N30-RF8 | 6 | 3 | 24 | 0,15 - 0,55 | 0,1 - 3,0 | ±0,02 | ±0,02 | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ | ☺ |
| GX30-5E800N40-RF8 | 8 | 4 | 30 | 0,18 - 0,60 | 0,2 - 4,0 | ±0,02 | ±0,02 | ☺ | ☹ | ☹ | ☺ | ☹ | ☺ | ☺ | ☺ | ☺ | ☺ | ☹ | ☹ |

l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ±0.05

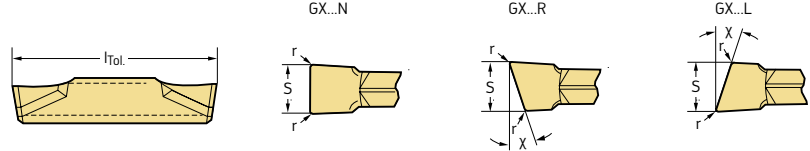
HC = Coated carbide
 HW = Uncoated carbide



Walter Cut GX grooving inserts

Grooving and parting off

Tiger-tec® Silver



Indexable inserts

| Designation | s mm | r mm | k | l mm | f mm | s _{Tol} mm | l _{Tol} mm | P | | | M | | | K | S | | | | |
|-------------------|---------|---------|---|---------|-------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--|
| | | | | | | | | HC | | | HC | | | | | | HC | | |
| | | | | | | | | WKP23S | WSM23S | WSM33S | WSM43S | WSM23S | WSM33S | WSM43S | WKP23S | WSM23S | WSM33S | WSM43S | |
| GX09-1E200N02-GD3 | 2 | 0,2 | | 9 | 0,04 - 0,12 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX09-1E250N02-GD3 | 2,5 | 0,2 | | 9 | 0,04 - 0,14 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX09-2E300N03-GD3 | 3 | 0,3 | | 9 | 0,06 - 0,18 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX09-2E350N03-GD3 | 3,5 | 0,3 | | 9 | 0,06 - 0,18 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1E200N02-GD3 | 2 | 0,2 | | 16 | 0,04 - 0,12 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-1E250N02-GD3 | 2,5 | 0,2 | | 16 | 0,04 - 0,14 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-2E300N03-GD3 | 3 | 0,3 | | 16 | 0,06 - 0,18 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-3E400N04-GD3 | 4 | 0,4 | | 16 | 0,10 - 0,20 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-3E500N04-GD3 | 5 | 0,4 | | 16 | 0,12 - 0,25 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX16-4E600N05-GD3 | 6 | 0,5 | | 16 | 0,14 - 0,28 | ±0,02 | ±0,05 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-2E300N03-GD3 | 3 | 0,3 | | 24 | 0,06 - 0,18 | ±0,05 | ±0,15 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3E400N04-GD3 | 4 | 0,4 | | 24 | 0,10 - 0,20 | ±0,05 | ±0,15 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-3E500N04-GD3 | 5 | 0,4 | | 24 | 0,12 - 0,25 | ±0,05 | ±0,15 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |
| GX24-4E600N05-GD3 | 6 | 0,5 | | 24 | 0,14 - 0,28 | ±0,05 | ±0,15 | ☺ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | | |

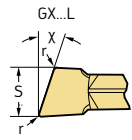
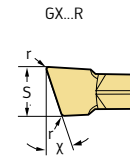
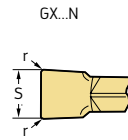
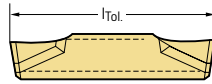
l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide

Walter Cut GX grooving inserts

Grooving and longitudinal turning

Tiger-tec® Silver

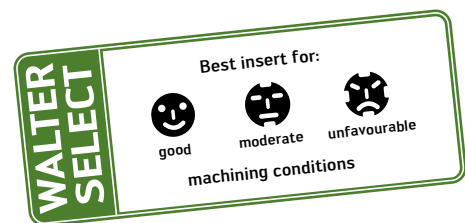


Indexable inserts

| Designation | s mm | r mm | l mm | f mm | a _p mm | s _{Tol} mm | l _{Tol} mm | P | | | | | | M | | | K | | | S | | | |
|-------------------|---------|---------|---------|-------------|----------------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---|
| | | | | | | | | HC | | | | | | HC | | | K | | | S | | | |
| | | | | | | | | WKP13S | WKP23S | WKP33S | WSM23S | WSM33S | WSM43S | WSP23S | WSP33S | WSP43S | WSP23S | WSP33S | WSP43S | WSP23S | WSP33S | WSP43S | |
| GX16-1E200N02-UD4 | 2 | 0,2 | 16 | 0,10 - 0,15 | 0,3 - 1,2 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX16-2E300N03-UD4 | 3 | 0,3 | 16 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX16-3E400N04-UD4 | 4 | 0,4 | 16 | 0,10 - 0,30 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX16-3E500N04-UD4 | 5 | 0,4 | 16 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-2E300N03-UD4 | 3 | 0,3 | 24 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-2E318N03-UD4 | 3,18 | 0,3 | 24 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-3E400N04-UD4 | 4 | 0,4 | 24 | 0,10 - 0,30 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-3E400N08-UD4 | 4 | 0,8 | 24 | 0,10 - 0,30 | 0,9 - 2,8 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-3E500N04-UD4 | 5 | 0,4 | 24 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-3E500N08-UD4 | 5 | 0,8 | 24 | 0,12 - 0,35 | 0,9 - 3,0 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-4E600N05-UD4 | 6 | 0,5 | 24 | 0,14 - 0,40 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX24-4E600N08-UD4 | 6 | 0,8 | 24 | 0,14 - 0,40 | 0,9 - 3,5 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX30-5E800N08-UD4 | 8 | 0,8 | 30 | 0,14 - 0,40 | 0,9 - 3,5 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |
| GX30-5E800N12-UD4 | 8 | 1,2 | 30 | 0,14 - 0,40 | 1,0 - 3,5 | ±0,05 | ±0,15 | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ | ☹ |

l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ± 0.05 mm

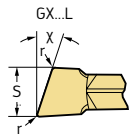
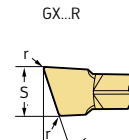
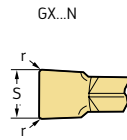
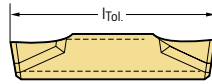
HC = Coated carbide





Walter Cut GX grooving inserts

Grooving and longitudinal turning

Tiger-tec® Silver

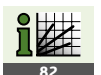


Indexable inserts

| Designation | s mm | r mm | l mm | f mm | a _p mm | s _{Tol} mm | l _{Tol} mm | P | | | | | | M | | | K | | | S | | | |
|---|---------|---------|---------|-------------|----------------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---|
| | | | | | | | | HC | | | | | | HC | | | K | | | S | | | |
| | | | | | | | | WKP13S | WKP23S | WKP33S | WSM23S | WSM33S | WSM43S | WSM23S | WSM33S | WSM43S | WKP13S | WKP23S | WKP33S | WSM23S | WSM33S | WSM43S | |
|  GX09-1E200N02-UF4 | 2 | 0,2 | 9 | 0,10 - 0,15 | 0,3 - 1,0 | ±0,05 | ±0,15 | | | | | ☺ | ☺ | | | | | | | | | ☺ | ☺ |
| GX09-2E300N03-UF4 | 3 | 0,3 | 9 | 0,10 - 0,20 | 0,4 - 1,5 | ±0,05 | ±0,15 | | | | | ☺ | ☺ | | | | | | | | | ☺ | ☺ |
| GX16-1E200N02-UF4 | 2 | 0,2 | 16 | 0,10 - 0,15 | 0,3 - 1,2 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX16-1E239N02-UF4 | 2,39 | 0,2 | 16 | 0,10 - 0,18 | 0,3 - 1,3 | ±0,05 | ±0,15 | | | | | ☺ | ☺ | | | | | | | | | ☺ | ☺ |
| GX16-1E250N02-UF4 | 2,5 | 0,2 | 16 | 0,10 - 0,18 | 0,3 - 1,3 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX16-2E300N03-UF4 | 3 | 0,3 | 16 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX16-3E400N04-UF4 | 4 | 0,4 | 16 | 0,10 - 0,30 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX16-3E500N04-UF4 | 5 | 0,4 | 16 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX16-4E600N05-UF4 | 6 | 0,5 | 16 | 0,14 - 0,40 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX24-2E300N03-UF4 | 3 | 0,3 | 24 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX24-2E318N03-UF4 | 3,18 | 0,3 | 24 | 0,10 - 0,20 | 0,4 - 2,0 | ±0,05 | ±0,15 | | | | | ☺ | ☺ | | | | | | | | | ☺ | ☺ |
| GX24-3E400N04-UF4 | 4 | 0,4 | 24 | 0,10 - 0,30 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX24-3E400N08-UF4 | 4 | 0,8 | 24 | 0,10 - 0,30 | 0,9 - 2,8 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX24-3E475N04-UF4 | 4,75 | 0,4 | 24 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX24-3E500N04-UF4 | 5 | 0,4 | 24 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX24-3E500N08-UF4 | 5 | 0,8 | 24 | 0,12 - 0,35 | 0,9 - 3,0 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX24-4E600N05-UF4 | 6 | 0,5 | 24 | 0,14 - 0,40 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX24-4E600N08-UF4 | 6 | 0,8 | 24 | 0,14 - 0,40 | 0,8 - 3,5 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX24-4E635N05-UF4 | 6,35 | 0,5 | 24 | 0,15 - 0,60 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | | | | ☺ | ☺ | | | | | | ☹ | | | ☺ | ☺ |
| GX30-5E800N08-UF4 | 8 | 0,8 | 30 | 0,18 - 0,60 | 0,9 - 4,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
| GX30-5E800N12-UF4 | 8 | 1,2 | 30 | 0,18 - 0,60 | 1,3 - 4,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | ☺ | ☺ | ☺ | ☺ | | | | ☹ | | ☹ | ☺ | ☺ |
|  GX16-1E200N02-UA4 | 2 | 0,2 | 16 | 0,08 - 0,15 | 0,3 - 1,2 | ±0,05 | ±0,15 | ☹ | | | | | | | | | | | ☹ | | | | |
| GX16-2E300N03-UA4 | 3 | 0,3 | 16 | 0,10 - 0,22 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX16-3E400N04-UA4 | 4 | 0,4 | 16 | 0,10 - 0,35 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX16-3E500N04-UA4 | 5 | 0,4 | 16 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX16-4E600N05-UA4 | 6 | 0,5 | 16 | 0,14 - 0,40 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX24-2E300N03-UA4 | 3 | 0,3 | 24 | 0,10 - 0,22 | 0,4 - 2,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX24-3E400N04-UA4 | 4 | 0,4 | 24 | 0,10 - 0,35 | 0,5 - 2,8 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX24-3E500N04-UA4 | 5 | 0,4 | 24 | 0,12 - 0,35 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |
| GX24-4E600N05-UA4 | 6 | 0,5 | 24 | 0,14 - 0,40 | 0,6 - 3,5 | ±0,05 | ±0,15 | ☹ | | | ☹ | | | | | | | | ☹ | | ☹ | | |

l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide

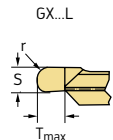
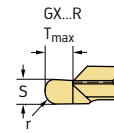
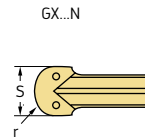
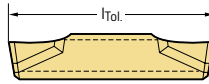


☹ ☹ ☹ New addition to the product range

Walter Cut GX grooving inserts

Grooving and longitudinal turning

Tiger-tec® Silver

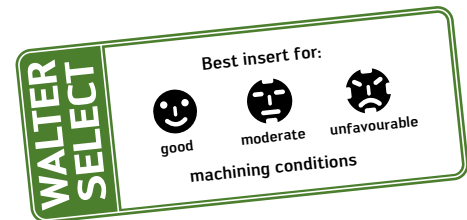


Indexable inserts

| Designation | s mm | r mm | l mm | f mm | a _p mm | s _{Tol} mm | l _{Tol} mm | P | | | | M | | | K | S | | | | |
|-------------------|---------|---------|---------|-------------|----------------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| | | | | | | | | HC | | | | HC | | | WKM23S | WKM33S | WKM43S | WKM23S | WKM33S | WKM43S |
| | | | | | | | | WKP23S | WSM23S | WSM33S | WSM43S | WKM23S | WKM33S | WKM43S | | | | | | |
| GX16-1E200N10-RD4 | 2 | 1 | 16 | 0,08 - 0,25 | 0,2 - 1,0 | ±0,05 | ±0,15 | ☺ | ☺ | ☹ | | ☺ | ☹ | | ☹ | ☺ | ☹ | | | |
| GX16-1E239N12-RD4 | 2,39 | 1,2 | 16 | 0,08 - 0,25 | 0,2 - 1,0 | ±0,05 | ±0,15 | | ☺ | ☹ | | ☹ | | | | | ☹ | | | |
| GX16-1E300N15-RD4 | 3 | 1,5 | 16 | 0,10 - 0,35 | 0,5 - 1,5 | ±0,05 | ±0,15 | | ☺ | ☹ | | ☹ | | | | ☺ | ☹ | | | |
| GX24-2E300N15-RD4 | 3 | 1,5 | 24 | 0,10 - 0,35 | 0,5 - 1,5 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-2E318N16-RD4 | 3,18 | 1,59 | 24 | 0,10 - 0,35 | 0,5 - 1,5 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-3E400N20-RD4 | 4 | 2 | 24 | 0,15 - 0,50 | 0,5 - 2,0 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-3E475N24-RD4 | 4,75 | 2,38 | 24 | 0,17 - 0,70 | 0,5 - 2,5 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-3E500N25-RD4 | 5 | 2,5 | 24 | 0,17 - 0,70 | 0,5 - 2,5 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-4E600N30-RD4 | 6 | 3 | 24 | 0,17 - 0,70 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX24-4E635N32-RD4 | 6,35 | 3,18 | 24 | 0,17 - 0,70 | 0,5 - 3,0 | ±0,05 | ±0,15 | ☺ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |
| GX30-5E800N40-RD4 | 8 | 4 | 30 | 0,17 - 0,70 | 0,6 - 4,5 | ±0,05 | ±0,15 | ☹ | | ☹ | | ☹ | | | ☹ | | ☹ | | | |

l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide



Standard blanks for making special inserts



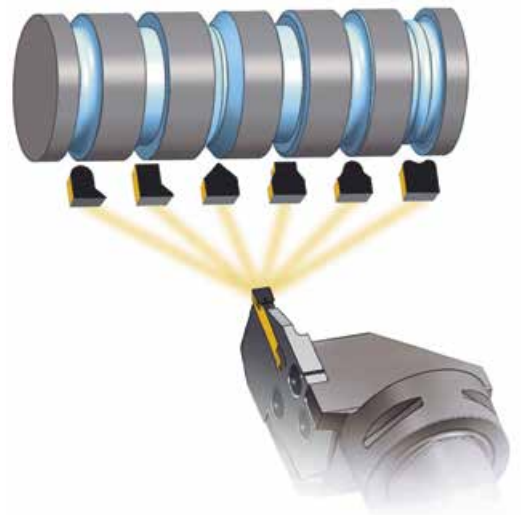
Blanks for special forms



| Designation | s mm | b mm | l mm | HW WMG40 |
|----------------|---------|---------|---------|-------------|
| GX 16-1E3.30N | 3,3 | 1,4 | 16,6 | △ |
| GX 16-2E4.30N | 4,3 | 2,1 | 16,6 | △ |
| GX 24-2E4.80N | 4,8 | 2,1 | 24,6 | △ |
| GX 16-3E6.30N | 6,3 | 3,05 | 16,6 | △ |
| GX 24-3E6.30N | 3,6 | 3,05 | 24,6 | △ |
| GX 16-4E8.30N | 8,3 | 4,3 | 24,6 | △ |
| GX 24-4E8.30N | 8,3 | 4,3 | 24,6 | △ |
| GX 24-5E10.30N | 10,3 | 6,2 | 24,6 | △ |

The cutting material WMG40 has the ISO application range P30, M30.

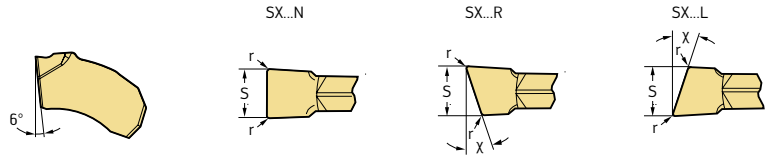
HW = Uncoated carbide






Walter Cut SX grooving inserts

Grooving and parting off

Tiger-tec® Silver



Indexable inserts

| Designation | s mm | r mm | κ | f mm | s _{Tol} mm | l _{Tol} mm | P | | | | M | | M | S | | N | | |
|---|---------|---------|-----|-------------|------------------------|------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-----|
| | | | | | | | HC | HC | HC | HC | HC | HC | HC | HC | HC | HW | | |
| | | | | | | | WKP23S | WSM23S | WSM33S | WSM43S | WSM23S | WSM33S | WSM43S | WKP23S | WSM23S | WSM33S | WSM43S | WK1 |
|  SX-1E150N01-CE4 | 1,5 | 0,1 | | 0,03 - 0,12 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-1E15R/L6-CE4 | 1,5 | 0,1 | 6° | 0,03 - 0,08 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-2E200N02-CE4 | 2 | 0,2 | | 0,06 - 0,15 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-2E200R/L6-CE4 | 2 | 0,2 | 6° | 0,06 - 0,10 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-3E300N02-CE4 | 3 | 0,2 | | 0,09 - 0,30 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-3E300R/L6-CE4 | 3 | 0,2 | 6° | 0,06 - 0,20 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-4E400N02-CE4 | 4 | 0,2 | | 0,10 - 0,32 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-4E400R/L6-CE4 | 4 | 0,2 | 6° | 0,08 - 0,22 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-5E500N04-CE4 | 5 | 0,4 | | 0,12 - 0,35 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-5E500R/L6-CE4 | 5 | 0,4 | 6° | 0,10 - 0,25 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-6E600N04-CE4 | 6 | 0,4 | | 0,12 - 0,40 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-6E600R/L6-CE4 | 6 | 0,4 | 6° | 0,12 - 0,30 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-8E800N08-CE4 | 8 | 0,8 | - | 0,20 - 0,50 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
| SX-10E1000N08-CE4 | 10 | 0,8 | - | 0,25 - 0,55 | ±0,05 | ±0,1 | ☹ | ☹ | ☹ | ☹ | | | | | | | | |
|  SX-1E150N01-CF5 | 1,5 | 0,1 | | 0,03 - 0,10 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-1E150R/L6-CF5 | 1,5 | 0,1 | 6° | 0,03 - 0,08 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-1E150R/L7-CF5 | 1,5 | | 7° | 0,03 - 0,08 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-1E150R/L15-CF5 | 1,5 | | 15° | 0,03 - 0,08 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-2E200N02-CF5 | 2 | 0,2 | | 0,04 - 0,12 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | ☹ |
| SX-2E200R/L6-CF5 | 2 | 0,2 | 6° | 0,03 - 0,10 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-2E200R/L7-CF5 | 2 | | 7° | 0,03 - 0,10 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-2E200R/L15-CF5 | 2 | | 15° | 0,03 - 0,10 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-3E300N02-CF5 | 3 | 0,2 | | 0,08 - 0,20 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | ☹ |
| SX-3E300R/L6-CF5 | 3 | 0,2 | 6° | 0,04 - 0,16 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-3E300R/L7-CF5 | 3 | | 7° | 0,04 - 0,13 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-3E300R/L15-CF5 | 3 | | 15° | 0,04 - 0,13 | ±0,02 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-4E400N02-CF5 | 4 | 0,2 | | 0,10 - 0,22 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-4E400R/L6-CF5 | 4 | 0,2 | 6° | 0,08 - 0,18 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-5E500N04-CF5 | 5 | 0,4 | | 0,10 - 0,25 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-5E500R/L6-CF5 | 5 | 0,4 | 6° | 0,10 - 0,20 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-6E600N04-CF5 | 6 | 0,4 | | 0,10 - 0,30 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
|  SX-1E150N01-CF6 | 1,5 | 0,1 | | 0,03 - 0,10 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-2E200N02-CF6 | 2 | 0,2 | | 0,03 - 0,12 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |
| SX-3E300N02-CF6 | 3 | 0,2 | | 0,04 - 0,20 | ±0,05 | ±0,1 | | | ☹ | ☹ | | | | | | | | |

l_{Tol} = Repeat accuracy when changing indexable insert
 Radius tolerance r_{Tol} = ± 0.05

HC = Coated carbide



MORE POWER, MORE ENDURANCE, MORE BITE.

Tiger-tec® Silver turning inserts for ISO P, ISO K and ISO M materials

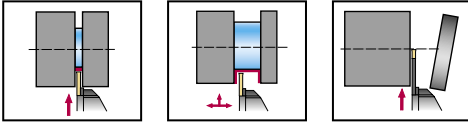
New cutting materials plus new geometries together produce an increase in performance of up to 75 per cent. Based on the unique wear resistance and toughness, it is possible to determine what these cutting materials can endure. This is made possible by a new, patented aluminium oxide coating, which, in conjunction with the Tiger-tec® Silver procedure that is recognised worldwide, adds a whole new dimension to machining.

Tiger-tec® Silver – Because process reliability deserves more bite.



Tiger-tec® Silver

Walter Cut G1011-P inch



- External machining
- Radial grooving 0°
- One-piece shank tool with internal coolant supply
- For grooving, recessing and parting off
- For GX cutting inserts

| Tool | Designation | s in | s mm | T _{max} in | D _{max} in | h=h ₁ in | b in | f ₁ in | l ₁ in | l ₄ in | s ₁ in | Type |
|------|--------------------------|---------|---------|------------------------|------------------------|------------------------|---------|----------------------|----------------------|----------------------|----------------------|-------------|
| | ★ G1011.12L/R-2T15GX16-P | 0,079 | 2 | 0,59 | | 0,75 | 0,75 | 0,719 | 6 | 1,398 | 0,063 | GX16-1E2 .. |
| | ★ G1011.12L/R-3T21GX16-P | 0,118 | 3 | 0,827 | 3,15 | 0,75 | 0,75 | 0,701 | 6 | 1,575 | 0,094 | GX24-2E3 .. |
| | ★ G1011.16L/R-2T15GX16-P | 0,079 | 2 | 0,59 | | 1 | 1 | 0,969 | 6 | 1,398 | 0,063 | GX16-1E2 .. |
| | ★ G1011.16L/R-3T21GX16-P | 0,118 | 3 | 0,827 | 3,15 | 1 | 1 | 0,701 | 6 | 1,575 | 0,094 | GX24-2E3 .. |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |

For T_{max} with greater dimensions than D_{max}, see "Technical information" from page A 316 in the Walter General Catalogue 2012.

f = f₁+s/2

Ordering example: Right-handed shank tool: G1011.2020R-3T12GX24-P / left-handed shank tool: G1011.2020L-3T12GX24-P

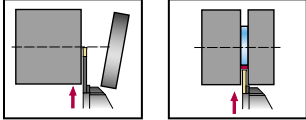
Bodies and assembly parts are included in the scope of delivery.

| Assembly parts | | Type | GX 16-1E2/F2 ..GX 24-2E3 .. |
|----------------|---|------|------------------------------|
| | Clamping screw for grooving insert Tightening torque | | FS2118 (Torx 20IP) 5.0 Nm |
| | Torx key | | FS1464 (Torx 20IP) |

★ New addition to the product range

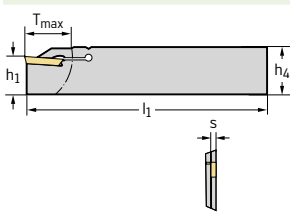


Walter Cut G1041 R/L metric



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

Tool



| Designation | s mm | T _{max} mm | h ₄ mm | l ₁ mm | h ₁ mm | Type |
|------------------------|---------|------------------------|----------------------|----------------------|----------------------|---------------|
| G1041.26R/L-1.5T16GX16 | 1,5 | 16 | 26 | 110 | 21 | GX16-0E.. |
| G1041.26R/L-2T16GX16 | 2 | 16 | 26 | 110 | 21 | GX16-1E2/F2.. |
| G1041.32R/L-2T23GX16 | | 23 | 32 | 110 | 24,6 | |
| ★ G1041.26R/L-2T23GX24 | 2 | 23 | 26 | 110 | 21 | GX24-1E2.. |
| ★ G1041.32R/L-2T23GX24 | | 23 | 32 | 110 | 24,6 | |
| ★ G1041.32R/L-2T32GX24 | | 32 | 32 | 110 | 24,6 | |
| G1041.26R/L-3T16GX16 | 3 | 16 | 26 | 110 | 21 | GX16-2E3/F3.. |
| G1041.26R/L-3T23GX24 | | 23 | 26 | 110 | 21 | |
| G1041.32R/L-3T23GX24 | | 23 | 32 | 110 | 24,6 | GX24-2E3/F3.. |
| G1041.32R/L-3T32GX24 | | 32 | 32 | 110 | 24,6 | |
| G1041.32R/L-4T32GX24 | 4 | 32 | 32 | 110 | 24,6 | GX24-3E4/F4.. |

For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For a description of the contra version/standard version, see page 18.

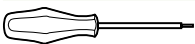
Bodies and assembly parts are included in the scope of delivery.

Assembly parts



| Type | GX16-0E . . . -GX24-3E . . . |
|------------------------------------|------------------------------|
| Clamping screw for grooving insert | FS2164 (Torx 15IP) |
| Tightening torque | 3.5 Nm |

Accessories

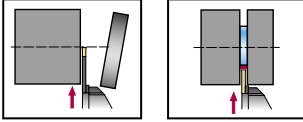


| Type | GX16-0E . . . -GX24-3E . . . |
|-------------|------------------------------|
| Screwdriver | FS1485 (Torx 15IP) |

★ New addition to range



Walter Cut G1041 R/L inch



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

| Tool | Designation | s in | s mm | T _{max} in | h ₄ in | l ₁ in | h ₁ in | Type | |
|------|------------------------|---------|---------|------------------------|----------------------|----------------------|----------------------|---------------|---------------|
| | G1041.26R/L-1.5T16GX16 | 0,059 | 1,5 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-0E.. | |
| | G1041.26R/L-2T16GX16 | 0,079 | 2 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-1E2/F2.. | |
| | G1041.32R/L-2T23GX16 | | | 0,906 | 1,260 | 4,331 | 0,969 | | |
| | ★ G1041.26R/L-2T23GX24 | 0,079 | 2 | 0,906 | 1,024 | 4,331 | 0,827 | GX24-1E2.. | |
| | ★ G1041.32R/L-2T23GX24 | | | 0,906 | 1,26 | 4,331 | 0,969 | | |
| | ★ G1041.32R/L-2T32GX24 | | | 1,26 | 1,26 | 4,331 | 0,969 | | |
| | G1041.26R/L-3T16GX16 | 0,118 | 3 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-2E3/F3.. | |
| | G1041.26R/L-3T23GX24 | | | 0,906 | 1,024 | 4,331 | 0,827 | | |
| | G1041.32R/L-3T23GX24 | | | 0,906 | 1,260 | 4,331 | 0,969 | | GX24-2E3/F3.. |
| | G1041.32R/L-3T32GX24 | | | 1,260 | 1,260 | 4,331 | 0,969 | | |
| | G1041.32R/L-4T32GX24 | 0,157 | 4 | 1,260 | 1,260 | 4,331 | 0,969 | GX24-3E4/F4.. | |

For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For a description of the contra version/standard version, see page 18.

Bodies and assembly parts are included in the scope of delivery.

Assembly parts

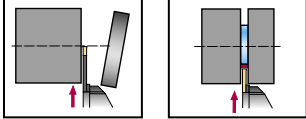
| | Type | GX16-0E . . . -GX24-3E . . . |
|--|---|------------------------------|
| | Clamping screw for grooving insert Tightening torque | FS2164 (Torx 15IP) 3,5 Nm |

Accessories

| | Type | GX16-0E . . . -GX24-3E . . . |
|--|-------------|------------------------------|
| | Screwdriver | FS1485 (Torx 15IP) |

★ New addition to the product range

Walter Cut G1041 R/L-C metric Contra version



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

| Tool | Designation | s mm | T _{max} mm | h ₄ mm | l ₁ mm | h ₁ mm | Type |
|------|-------------------------|---------|------------------------|----------------------|----------------------|----------------------|----------------|
| | G1041.26R/L-1.5T16GX16C | 1,5 | 16 | 26 | 110 | 21 | GX16-0E .. |
| | G1041.26R/L-2T16GX16C | 2 | 16 | 26 | 110 | 21 | GX16-1E2/F2 .. |
| | G1041.32R/L-2T23GX16C | | 23 | 32 | 110 | 24,6 | |
| | ★ G1041.26R/L-2T23GX24C | 2 | 23 | 26 | 110 | 21 | GX24-1E2.. |
| | ★ G1041.32R/L-2T23GX24C | | 23 | 32 | 110 | 24,6 | |
| | ★ G1041.32R/L-2T32GX24C | | 32 | 32 | 110 | 24,6 | |
| | G1041.26R/L-3T16GX16C | 3 | 16 | 26 | 110 | 21 | GX16-2E3/F3 .. |
| | G1041.26R/L-3T23GX24C | | 23 | 26 | 110 | 21 | |
| | G1041.32R/L-3T23GX24C | | 23 | 32 | 110 | 24,6 | GX24-2E3/F3 .. |
| | G1041.32R/L-3T32GX24C | | 32 | 32 | 110 | 24,6 | |
| | G1041.32R/L-4T32GX24C | 4 | 32 | 32 | 110 | 24,6 | GX24-3E4/F4 .. |

For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For a description of the contra version/standard version, see page 18.

Bodies and assembly parts are included in the scope of delivery.

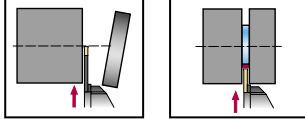
Assembly parts

| | Type | GX16-0E .. –GX24-3E .. |
|--|---|------------------------------|
| | Clamping screw for grooving insert Tightening torque | FS2164 (Torx 15IP) 3,5 Nm |

Accessories

| | Type | GX16-0E .. –GX24-3E .. |
|--|-------------|------------------------|
| | Screwdriver | FS1485 (Torx 15IP) |

Walter Cut G1041 R/L-C inch Contra version



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

| Tool | Designation | s in | s mm | T _{max} in | h ₄ in | l ₁ in | h ₁ in | Type |
|------|-------------------------|---------|---------|------------------------|----------------------|----------------------|----------------------|---------------|
| | G1041.26R/L-1.5T16GX16C | 0,059 | 1,5 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-0E.. |
| | G1041.26R/L-2T16GX16C | 0,079 | 2 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-1E2/F2.. |
| | G1041.32R/L-2T23GX16C | | | 0,906 | 1,260 | 4,331 | 0,969 | |
| | ★ G1041.26R/L-2T23GX24C | 0,079 | 2 | 0,906 | 1,024 | 4,331 | 0,827 | GX24-1E2.. |
| | ★ G1041.26R/L-2T32GX24C | | | 1,26 | 1,024 | 4,331 | 0,827 | |
| | ★ G1041.32R/L-2T23GX24C | | | 0,906 | 1,26 | 4,331 | 0,969 | |
| | ★ G1041.32R/L-2T32GX24C | | | 1,26 | 1,26 | 4,331 | 0,969 | |
| | G1041.26R/L-3T16GX16C | 0,118 | 3 | 0,630 | 1,024 | 4,331 | 0,827 | GX16-2E3/F3.. |
| | G1041.26R/L-3T23GX24C | | | 0,906 | 1,024 | 4,331 | 0,827 | |
| | G1041.32R/L-3T23GX24C | | | 0,906 | 1,260 | 4,331 | 0,969 | GX24-2E3/F3.. |
| | G1041.32R/L-3T32GX24C | | | 1,260 | 1,260 | 4,331 | 0,969 | |
| | G1041.32R/L-4T32GX24C | 0,157 | 4 | 1,260 | 1,260 | 4,331 | 0,969 | GX24-3E4/F4.. |

For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For a description of the contra version/standard version, see page 18.

Bodies and assembly parts are included in the scope of delivery.

Assembly parts

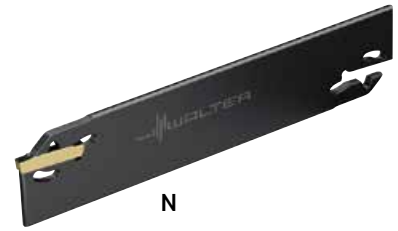
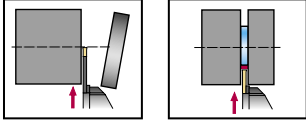
| | Type | GX16-0E . . . -GX24-3E . . . |
|--|---|------------------------------|
| | Clamping screw for grooving insert Tightening torque | FS2164 (Torx 15IP) 3.5 Nm |

Accessories

| | Type | GX16-0E . . . -GX24-3E . . . |
|--|-------------|------------------------------|
| | Screwdriver | FS1485 (Torx 15IP) |

★ New addition to the product range

Walter Cut G1042 metric


N


- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

| Tool | Designation | s mm | T _{max} mm | h ₄ mm | l ₁ mm | h ₁ mm | Type |
|------|----------------------|---------|------------------------|----------------------|----------------------|----------------------|----------------|
| | G1042.26N-2T25GX16 | 2 | 25 | 26 | 108,3 | 21,1 | GX16-1E2/F2... |
| | G1042.32N-2T25GX16 | | 25 | 32 | 149,3 | 24,8 | |
| | ★ G1042.26N-2T40GX24 | | 40 | 26 | 108,3 | 21,0 | GX24-1E2... |
| | ★ G1042.32N-2T50GX24 | | 50 | 32 | 149,3 | 24,5 | |
| | G1042.26N-3T40GX24 | 3 | 40 | 26 | 108,3 | 21 | GX24-2E3/F3... |
| | G1042.32N-3T50GX24 | | 50 | 32 | 149,3 | 24,7 | |
| | G1042.26N-4T40GX24 | 4 | 40 | 26 | 108,3 | 20,9 | GX24-3E4/F4... |
| | G1042.32N-4T50GX24 | | 50 | 32 | 149,3 | 24,6 | |
| | G1042.32N-5T60GX24 | 5 | 60 | 32 | 149,3 | 24,5 | GX24-3E5/F5... |
| | G1042.32N-6T60GX24 | 6 | 60 | 32 | 149,3 | 24,4 | GX24-4E6/F6... |

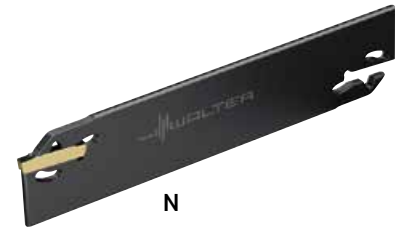
For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For instructions on replacing the cutting edge, see page A 314 of the Walter General Catalogue 2012.

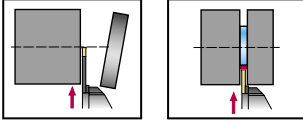
Accessories

| | Type | GX16-1E2/F2...-GX24-4E6/F6... |
|--|-------------------------------------|-------------------------------|
| | Mounting wrench for grooving insert | FS1494 |

Walter Cut G1042 inch



N



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For GX cutting inserts

| Tool | Designation | s in | s mm | T _{max} in | h ₄ in | l ₁ in | h ₁ in | Type |
|------|----------------------|---------|---------|------------------------|----------------------|----------------------|----------------------|----------------|
| | G1042.26N-2T25GX16 | 0,079 | 2 | 0,980 | 1,020 | 4,264 | 0,831 | GX16-1E2/F2... |
| | G1042.32N-2T25GX16 | | | 0,980 | 1,260 | 5,878 | 0,976 | |
| | ★ G1042.26N-2T40GX24 | 0,079 | 2 | 1,570 | 1,024 | 4,264 | 0,827 | GX24-1E2... |
| | ★ G1042.32N-2T50GX24 | | | 1,970 | 1,024 | 5,878 | 0,969 | |
| | G1042.26N-3T40GX24 | 0,118 | 3 | 1,570 | 1,020 | 4,264 | 0,827 | GX24-2E3/F3... |
| | G1042.32N-3T50GX24 | | | 1,970 | 1,260 | 5,878 | 0,972 | |
| | G1042.26N-4T40GX24 | 0,157 | 4 | 1,570 | 1,020 | 4,264 | 0,823 | GX24-3E4/F4... |
| | G1042.32N-4T50GX24 | | | 1,970 | 1,260 | 5,878 | 0,969 | |
| | G1042.32N-5T60GX24 | 0,198 | 5 | 2,360 | 1,260 | 5,878 | 0,965 | GX24-3E5/F5... |
| | G1042.32N-6T60GX24 | 0,236 | 6 | 2,360 | 1,260 | 5,878 | 0,961 | GX24-4E6/F6... |

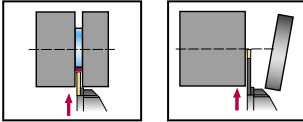
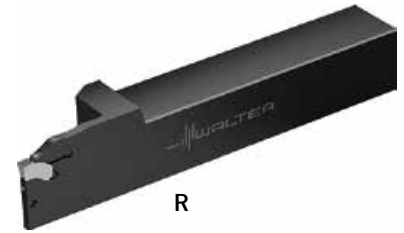
For clamping blocks, see page A 217 of the Walter General Catalogue 2012.

For instructions on replacing the cutting edge, see page A 314 of the Walter General Catalogue 2012.

Accessories

| | Type | GX16-1E2/F2 . . .-GX24-4E6/F6... |
|--|-------------------------------------|----------------------------------|
| | Mounting wrench for grooving insert | FS1494 |

Walter Cut G2012-P inch



- External machining
- Radial grooving 0°
- One-piece shank tool with internal coolant supply
- For grooving and parting off
- For SX cutting inserts

| Tool | Designation | s in | s mm | T _{max} in | h=h ₁ in | b in | f ₁ in | l ₁ in | l ₄ in | s ₁ in | Type |
|------|-------------------------|---------|---------|------------------------|------------------------|---------|----------------------|----------------------|----------------------|----------------------|-------------|
| | ★ G2012.08R/L-2T16SX-P | 0,079 | 2 | 0,59 | 0,5 | 0,5 | 0,469 | 4,724 | 0,984 | 0,063 | SX-2E2 .. |
| | ★ G2012.08R/L-3T16SX-P | 0,118 | 3 | 0,59 | 0,5 | 0,5 | 0,469 | 4,724 | 0,984 | 0,095 | SX-3E3 .. |
| | ★ G2012.10R/L-2T16SX-P | 0,079 | 2 | 0,59 | 0,625 | 0,625 | 0,594 | 4,724 | 0,984 | 0,063 | SX-2E2 .. |
| | ★ G2012.10R/L-3T16SX-P | 0,118 | 3 | 0,59 | 0,625 | 0,625 | 0,594 | 4,724 | 0,984 | 0,095 | SX-3E3 .. |
| | ★ G2012.12R/L-2T20SX-P | 0,079 | 2 | 0,78 | 0,75 | 0,75 | 0,719 | 6 | 1,41 | 0,063 | SX-2E2 .. |
| | G2012.12R/L-3T22SX-P | 0,118 | 3 | 0,866 | 0,75 | 0,75 | 0,702 | 6 | 1,460 | 0,095 | SX-3 .. |
| | G2012.16R/L-3T33SX-P | | | 1,300 | 1 | 1 | 0,951 | 6 | 1,740 | 0,095 | |
| | G2012.12R/L-4T29SX-P | 0,156 | 4 | 1,142 | 0,75 | 0,75 | 0,683 | 6 | 1,740 | 0,134 | SX-4 .. |
| | G2012.16R/L-4T33SX-P | | | 1,300 | 1 | 1 | 0,933 | 6 | 1,740 | 0,134 | |
| | ★ G2012.12R/L-5T29SX-P | 0,197 | 5 | 1,142 | 0,75 | 0,75 | 0,665 | 6 | 1,772 | 0,169 | SX-5E5 .. |
| | ★ G2012.16R/L-5T40SX-P | 0,197 | 5 | 1,575 | 1 | 1 | 0,915 | 6 | 2,047 | 0,169 | SX-5E5 .. |
| | ★ G2012.16R/L-6T40SX-P | 0,236 | 6 | 1,575 | 1 | 1 | 0,896 | 6 | 2,047 | 0,208 | SX-6E6 .. |
| | ★ G2012.16R/L-8T40SX-P | 0,315 | 8 | 1,575 | 1 | 1 | 0,866 | 6 | 2,165 | 0,268 | SX-8E8 .. |
| | ★ G2012.16R/L-10T40SX-P | 0,393 | 10 | 1,575 | 1 | 1 | 0,827 | 6 | 2,165 | 0,346 | SX-10E10 .. |
| | ★ G2012.20R/L-8T45SX-P | 0,315 | 8 | 1,77 | 1,25 | 1,25 | 1,116 | 6 | 2,362 | 0,268 | SX-8E8 .. |
| | ★ G2012.20R/L-10T45SX-P | 0,393 | 10 | 1,77 | 1,25 | 1,25 | 1,077 | 6 | 2,362 | 0,346 | SX-10E10 .. |

For instructions on replacing the cutting edge, see page A-150 of the Walter Supplementary Catalogue 2013/2014.

For the connection set for internal coolant supply with G1/8" thread, see page A-151 of the Walter Supplementary Catalogue 2013/2014.

$f = f_1 + s/2$

Ordering example: Right-handed shank tool: G2012.2020R-3T22SX-P / left-handed shank tool: G2012.2020L-3T22SX-P

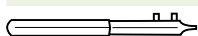
Assembly parts



1/8" blind plug

FS2258

Accessories



Type

Mounting wrench
for grooving insert

SX-2 ..-SX-3 ..
08-10

FS2249

SX-2 ..-SX-6 ..
12-16

FS1494

SX-8 ..-SX-10 ..
16-20

FS2274



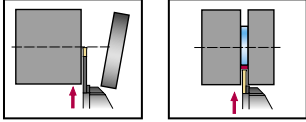
60



82

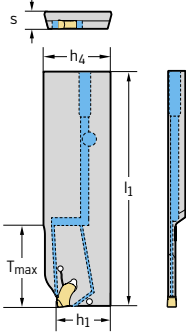
★ New addition to the product range

Walter Cut G2042 R/L-C-P metric Contra version with internal cooling



- External machining
- Radial grooving 0°
- Deep parting blade
- For parting off and grooving
- For SX cutting inserts

Tool



| Designation | s mm | T _{max} mm | h ₄ mm | l ₁ mm | h ₁ mm | Type |
|------------------------|---------|------------------------|----------------------|----------------------|----------------------|-----------|
| G2042.26L/R-2T26SX-C-P | 2 | 26 | 26 | 110 | 21 | SX-2E2 .. |
| G2042.32L/R-2T26SX-C-P | | | 32 | | 24,6 | |
| G2042.26L/R-3T33SX-C-P | 3 | 33 | 26 | 110 | 21 | SX-3E3 .. |
| G2042.32L/R-3T33SX-C-P | | | 32 | | 24,6 | |
| G2042.32L/R-4T33SX-C-P | | | 32 | | 24,6 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

For clamping blocks, see page 74.

For instructions on replacing the cutting edge, see page A-150 of the Walter Supplementary Catalogue 2013/2014.

For VDI adaptors for parting blades, see page 310.

Accessories

| Type | SX-2 .. - SX-4 .. |
|--|-------------------|
| Mounting wrench for grooving insert | FS1494 |



★ New addition to range

Walter Cut

Clamping block with internal cooling

G2661-P metric



- Clamping blocks for parting blades
- Internal coolant

| Tool | Designation | h_4 mm | h_1 mm | b mm | l_1 mm |
|------|------------------|-------------|-------------|---------|-------------|
| | G2661.2020N-26-P | 26 | 20 | 20 | 95 |
| | G2661.2020N-32-P | 32 | 20 | 20 | 95 |
| | G2661.2525N-32-P | 32 | 25 | 25 | 95 |
| | G2661.3232N-32-P | 32 | 32 | 32 | 95 |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

Bodies and assembly parts are included in the scope of delivery.
For blades with internal cooling, see page 72.

For the connection set for internal coolant supply with G1/8" thread, see page A-151 of the Walter Supplementary Catalogue 2013/2014.

| Assembly parts | h_4 mm | 26 - 32 |
|----------------|----------|----------------------|
| | Screw | M06X020 ISO4762 12.9 |
| | Wedge | PK260 |
| | O-ring | O-ring 20 x 2 |
| | Wrenches | ISO 2936-5 |

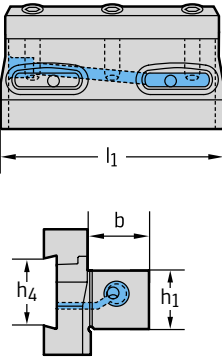
Walter Cut

Clamping block with internal cooling

G2661-P inch




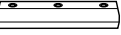


- Clamping blocks for parting blades
- Internal coolant

| Tool | Designation | h_4 in | h_4 mm | h_1 in | b in | l_1 in |
|--|----------------|-------------|-------------|-------------|---------|-------------|
|  | G2661.12N-26-P | 1,024 | 26 | 0,750 | 0,750 | 3,74 |
| | G2661.12N-32-P | 1,260 | 32 | 0,750 | 0,750 | 3,74 |
| | G2661.16N-32-P | 1,260 | 32 | 1,000 | 1,000 | 3,74 |
| | G2661.20N-32-P | 1,260 | 32 | 1,250 | 1,250 | 3,74 |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Bodies and assembly parts are included in the scope of delivery.

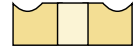
For blades with internal cooling, see page 72.

For the connection set for internal coolant supply with G1/8" thread, see page A-151 of the Walter Supplementary Catalogue 2013/2014.

| Assembly parts | h_4 mm | 26 - 32 |
|---|----------|----------------------|
|  | Screw | M06X020 ISO4762 12.9 |
|  | Wedge | PK260 |
|  | O-ring | O-ring 20 x 2 |
|  | Wrenches | ISO 2936-5 |

Cutting data for turning inserts – Negative basic shape

Carbide grades



The specified cutting data are average recommended values.
For special applications, adjustment is recommended.

| Material group | Structure of main material groups and code letters | | Brinell hardness HB | Tensile strength R _m N/mm ² | Machining group ¹ | | | Cutting material grades | | | | |
|--|--|---|---------------------|---|------------------------------|------|-----|--|-----|-----|-----|--|
| | | | | | | | | Starting values for cutting speed v _c [m/min] | | | | |
| | | | | | | | | HC WPP05S f [mm/rev] | | | | |
| | | | 0,10 | 0,40 | 0,60 | | | | | | | |
| P | Non-alloyed steel | C ≤ 0,25% | Annealed | 125 | 428 | P1 | ●● | ● | 630 | 490 | 360 | |
| | | C > 0,25... ≤ 0,55% | Annealed | 190 | 639 | P2 | ●● | ● | 540 | 390 | 310 | |
| | | C > 0,25... ≤ 0,55% | Heat-treated | 210 | 708 | P3 | ●● | ● | 420 | 320 | 270 | |
| | | C > 0,55% | Annealed | 190 | 639 | P4 | ●● | ● | 520 | 370 | 290 | |
| | | C > 0,55% | Heat-treated | 300 | 1013 | P5 | ●● | ● | 320 | 250 | 230 | |
| | Low-alloyed steel | Free cutting steel (short-chipping) | Annealed | 220 | 745 | P6 | ●● | ● | 520 | 370 | 290 | |
| | | Annealed | | 175 | 591 | P7 | ●● | ● | 480 | 340 | 300 | |
| | | Heat-treated | | 300 | 1013 | P8 | ●● | ● | 300 | 240 | 210 | |
| | | Heat-treated | | 380 | 1282 | P9 | ●● | ● | 270 | 180 | 140 | |
| | | Heat-treated | | 430 | 1477 | P10 | ●● | ● | 70 | 60 | | |
| High-alloyed steel and high-alloyed tool steel | Annealed | | 200 | 675 | P11 | ●● | ● | 500 | 310 | 230 | | |
| | Hardened and tempered | | 300 | 1013 | P12 | ●● | ● | 260 | 140 | 110 | | |
| | Hardened and tempered | | 400 | 1361 | P13 | ●● | ● | 80 | 70 | | | |
| Stainless steel | Ferritic/martensitic, annealed | | 200 | 675 | P14 | ●● | ● | | | | | |
| | Martensitic, heat-treated | | 330 | 1114 | P15 | ●● | ● | | | | | |
| M | Stainless steel | Austenitic, quench hardened | | 200 | 675 | M1 | ●● | ● | | | | |
| | | Austenitic, precipitation hardened (PH) | | 300 | 1013 | M2 | ●● | ● | | | | |
| | | Austenitic/ferritic, duplex | | 230 | 778 | M3 | ●● | ● | | | | |
| K | Malleable cast iron | Ferritic | | 200 | 675 | K1 | ●● | ● | | | | |
| | | Pearlitic | | 260 | 867 | K2 | ●● | ● | | | | |
| | Grey cast iron | Low tensile strength | | 180 | 602 | K3 | ●● | ● | | | | |
| | | High tensile strength/austenitic | | 245 | 825 | K4 | ●● | ● | | | | |
| | Cast iron with spheroidal graphite | Ferritic | | 155 | 518 | K5 | ●● | ● | | | | |
| Pearlitic | | | 265 | 885 | K6 | ●● | ● | | | | | |
| GGV (CGI) | | 200 | 675 | K7 | ●● | ● | 400 | 260 | | | | |
| N | Aluminium wrought alloys | Cannot be hardened | | 30 | – | N1 | | | | | | |
| | | Hardenable, hardened | | 100 | 343 | N2 | | | | | | |
| | Cast aluminium alloys | ≤ 12% Si, cannot be hardened | | 75 | 260 | N3 | | | | | | |
| | | ≤ 12% Si, hardenable, hardened | | 90 | 314 | N4 | | | | | | |
| | | > 12% Si, cannot be hardened | | 130 | 447 | N5 | | | | | | |
| | Magnesium alloys | | 70 | 250 | N6 | | | | | | | |
| | Copper and copper alloys (bronze/brass) | Non-alloyed, electrolytic copper | | 100 | 343 | N7 | | | | | | |
| Brass, bronze, red brass | | | 90 | 314 | N8 | | | | | | | |
| Cu-alloys, short-chipping | | | 110 | 382 | N9 | | | | | | | |
| High-strength, Ampco | | | 300 | 1013 | N10 | | | | | | | |
| S | Heat-resistant alloys | Fe-based | Annealed | | 200 | 675 | S1 | ●● | ● | | | |
| | | | Hardened | | 280 | 943 | S2 | ●● | ● | | | |
| | | Ni or Co base | Annealed | | 250 | 839 | S3 | ●● | ● | | | |
| | | | Hardened | | 350 | 1177 | S4 | ●● | ● | | | |
| | Titanium alloys | Cast | | 320 | 1076 | S5 | ●● | ● | | | | |
| | | Pure titanium | | 200 | 675 | S6 | ●● | ● | | | | |
| | | α and β alloys, hardened | | 375 | 1262 | S7 | ●● | ● | | | | |
| Tungsten alloys | β alloys | | 410 | 1396 | S8 | ●● | ● | | | | | |
| Molybdenum alloys | | 300 | 1013 | S9 | | | | | | | | |
| | | 300 | 1013 | S10 | | | | | | | | |
| H | Hardened steel | Hardened and tempered | | 50 HRC | – | H1 | ● | ●● | | | | |
| | | Hardened and tempered | | 55 HRC | – | H2 | ● | ●● | | | | |
| | | Hardened and tempered | | 60 HRC | – | H3 | ● | ●● | | | | |
| | Hardened cast iron | Hardened and tempered | | 55 HRC | – | H4 | ● | ●● | | | | |
| O | Thermoplastics | Without abrasive fillers | | | | O1 | | | | | | |
| | Thermosetting plastics | Without abrasive fillers | | | | O2 | | | | | | |
| | Plastic, glass-fibre reinforced | GFRP | | | | O3 | | | | | | |
| | Plastic, carbon-fibre reinforced | CFRP | | | | O4 | | | | | | |
| | Plastic, aramid-fibre reinforced | AFRP | | | | O5 | | | | | | |
| | Graphite (technical) | | 80 Shore | | | | O6 | | | | | |

- Recommended application (the specified cutting data are regarded as starting values for the recommended application)
- Possible application

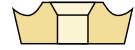
Note:

If dry machining is possible, the tool life reduces by an average of 20-30%.

¹ The classification of the machining groups can be found in the Walter General Catalogue 2012 from page H 8 onwards.

Cutting data for turning inserts – Positive basic shape

Carbide grades



The specified cutting data are average recommended values.
For special applications, adjustment is recommended.

| Material group | Structure of main material groups and code letters | | Brinell hardness HB | Tensile strength R _m N/mm ² | Machining group ¹ | | | Cutting material grades | | | |
|--|--|---|---------------------|---|------------------------------|------|-----|--|--------|------|-----|
| | | | | | | | | Starting values for cutting speed v _c [m/min] | | | |
| | | | | | | | | f [mm/rev] | | | |
| | | | | | | | | HC | WPP10S | | |
| | | | | | | | | 0,10 | 0,20 | 0,40 | |
| P | Non-alloyed steel | C ≤ 0,25% | Annealed | 125 | 428 | P1 | ●● | ● | 560 | 500 | 430 |
| | | C > 0,25... ≤ 0,55% | Annealed | 190 | 639 | P2 | ●● | ● | 470 | 430 | 340 |
| | | C > 0,25... ≤ 0,55% | Heat-treated | 210 | 708 | P3 | ●● | ● | 360 | 330 | 300 |
| | | C > 0,55% | Annealed | 190 | 639 | P4 | ●● | ● | 460 | 430 | 410 |
| | | C > 0,55% | Heat-treated | 300 | 1013 | P5 | ●● | ● | 270 | 240 | 220 |
| | Low-alloyed steel | Free cutting steel (short-chipping) | Annealed | 220 | 745 | P6 | ●● | ● | 460 | 430 | 410 |
| | | Annealed | | 175 | 591 | P7 | ●● | ● | 420 | 390 | 370 |
| | | Heat-treated | | 300 | 1013 | P8 | ●● | ● | 250 | 220 | 200 |
| | | Heat-treated | | 380 | 1282 | P9 | ●● | ● | 190 | 160 | 140 |
| | | Heat-treated | | 430 | 1477 | P10 | ●● | ● | 60 | 50 | |
| High-alloyed steel and high-alloyed tool steel | Annealed | | 200 | 675 | P11 | ●● | ● | 440 | 410 | 390 | |
| | Hardened and tempered | | 300 | 1013 | P12 | ●● | ● | 210 | 190 | 170 | |
| | Hardened and tempered | | 400 | 1361 | P13 | ●● | ● | 70 | 60 | | |
| Stainless steel | Ferritic/martensitic, annealed | | 200 | 675 | P14 | ●● | ● | 380 | 350 | 330 | |
| | Martensitic, heat-treated | | 330 | 1114 | P15 | ●● | ● | 190 | 160 | 140 | |
| M | Stainless steel | Austenitic, quench hardened | | 200 | 675 | M1 | ●● | ● | | | |
| | | Austenitic, precipitation hardened (PH) | | 300 | 1013 | M2 | ●● | ● | | | |
| | | Austenitic/ferritic, duplex | | 230 | 778 | M3 | ●● | ● | | | |
| K | Malleable cast iron | Ferritic | | 200 | 675 | K1 | ●● | ● | 280 | 250 | 230 |
| | | Pearlitic | | 260 | 867 | K2 | ●● | ● | 240 | 210 | 190 |
| | Grey cast iron | Low tensile strength | | 180 | 602 | K3 | ●● | ● | 530 | 490 | 450 |
| | | High tensile strength/austenitic | | 245 | 825 | K4 | ●● | ● | 280 | 250 | 230 |
| | Cast iron with spheroidal graphite | Ferritic | | 155 | 518 | K5 | ●● | ● | 300 | 270 | 250 |
| | | Pearlitic | | 265 | 885 | K6 | ●● | ● | 210 | 180 | 160 |
| GGV (CGI) | | 200 | 675 | K7 | ●● | ● | 280 | 230 | 210 | | |
| N | Aluminium wrought alloys | Cannot be hardened | | 30 | – | N1 | | | | | |
| | | Hardenable, hardened | | 100 | 343 | N2 | | | | | |
| | Cast aluminium alloys | ≤ 12% Si, cannot be hardened | | 75 | 260 | N3 | | | | | |
| | | ≤ 12% Si, hardenable, hardened | | 90 | 314 | N4 | | | | | |
| | | > 12% Si, cannot be hardened | | 130 | 447 | N5 | | | | | |
| | Magnesium alloys | | 70 | 250 | N6 | | | | | | |
| | Copper and copper alloys (bronze/brass) | Non-alloyed, electrolytic copper | | 100 | 343 | N7 | | | | | |
| Brass, bronze, red brass | | | 90 | 314 | N8 | | | | | | |
| Cu-alloys, short-chipping | | | 110 | 382 | N9 | | | | | | |
| High-strength, Ampco | | | 300 | 1013 | N10 | | | | | | |
| S | Heat-resistant alloys | Fe-based | Annealed | | 200 | 675 | S1 | ●● | ● | | |
| | | | Hardened | | 280 | 943 | S2 | ●● | ● | | |
| | | Ni or Co base | Annealed | | 250 | 839 | S3 | ●● | ● | | |
| | | | Hardened | | 350 | 1177 | S4 | ●● | ● | | |
| | Titanium alloys | Cast | | 320 | 1076 | S5 | ●● | ● | | | |
| | | Pure titanium | | 200 | 675 | S6 | | | | | |
| | | α and β alloys, hardened | | 375 | 1262 | S7 | ●● | ● | | | |
| | | β alloys | | 410 | 1396 | S8 | ●● | ● | | | |
| Tungsten alloys | | 300 | 1013 | S9 | ●● | | | | | | |
| Molybdenum alloys | | 300 | 1013 | S10 | ●● | | | | | | |
| H | Hardened steel | Hardened and tempered | | 50 HRC | – | H1 | | | | | |
| | | Hardened and tempered | | 55 HRC | – | H2 | | | | | |
| | | Hardened and tempered | | 60 HRC | – | H3 | | | | | |
| | Hardened cast iron | Hardened and tempered | | 55 HRC | – | H4 | | | | | |
| O | Thermoplastics | Without abrasive fillers | | | | 01 | | | | | |
| | Thermosetting plastics | Without abrasive fillers | | | | 02 | | | | | |
| | Plastic, glass-fibre reinforced | GFRP | | | | 03 | | | | | |
| | Plastic, carbon-fibre reinforced | CFRP | | | | 04 | | | | | |
| | Plastic, aramid-fibre reinforced | AFRP | | | | 05 | | | | | |
| | Graphite (technical) | | 80 Shore | | | | 06 | | | | |

- Recommended application (the specified cutting data are regarded as starting values for the recommended application)
- Possible application

Note:

If dry machining is possible, the tool life reduces by an average of 20-30%.

¹ The classification of the machining groups can be found in the Walter General Catalogue 2012 from page H 8 onwards.

Cutting data for turning inserts – PCD/ceramic

The specified cutting data are average recommended values.
For special applications, adjustment is recommended.

| Material group | = Cutting data for wet machining = Dry machining is possible | | Birnell hardness HB | Tensile strength R _m N/mm ² | Machining group ¹ | | Cutting material grades | | | | |
|---------------------------|---|---|---------------------|--|------------------------------|------|---|------|------|------|-----|
| | | | | | | | Starting values for cutting speed v _c [m/min] | | | | |
| | | | | | | | WDN10 | | | | |
| | | | | | | | f [mm/rev] | | | | |
| | | | | | | | 0,10 | 0,20 | 0,40 | | |
| P | Non-alloyed steel | C ≤ 0,25% | Annealed | 125 | 428 | P1 | | | | | |
| | | C > 0,25... ≤ 0,55% | Annealed | 190 | 639 | P2 | | | | | |
| | | C > 0,25... ≤ 0,55% | Heat-treated | 210 | 708 | P3 | | | | | |
| | | C > 0,55% | Annealed | 190 | 639 | P4 | | | | | |
| | | C > 0,55% | Heat-treated | 300 | 1013 | P5 | | | | | |
| | Low-alloyed steel | Free cutting steel (short-chipping) | Annealed | 220 | 745 | P6 | | | | | |
| | | Annealed | | 175 | 591 | P7 | | | | | |
| | | Heat-treated | | 300 | 1013 | P8 | | | | | |
| | | Heat-treated | | 380 | 1282 | P9 | | | | | |
| | High-alloyed steel and high-alloyed tool steel | Heat-treated | | 430 | 1477 | P10 | | | | | |
| | | Annealed | | 200 | 675 | P11 | | | | | |
| | | Hardened and tempered | | 300 | 1013 | P12 | | | | | |
| | Stainless steel | Hardened and tempered | | 400 | 1361 | P13 | | | | | |
| | | Ferritic/martensitic, annealed | | 200 | 675 | P14 | | | | | |
| | | Martensitic, heat-treated | | 330 | 1114 | P15 | | | | | |
| M | Stainless steel | Austenitic, quench hardened | | 200 | 675 | M1 | | | | | |
| | | Austenitic, precipitation hardened (PH) | | 300 | 1013 | M2 | | | | | |
| | | Austenitic/ferritic, duplex | | 230 | 778 | M3 | | | | | |
| K | Malleable cast iron | Ferritic | | 200 | 675 | K1 | | | | | |
| | | Pearlitic | | 260 | 867 | K2 | | | | | |
| | Grey cast iron | Low tensile strength | | 180 | 602 | K3 | | | | | |
| | | High tensile strength/austenitic | | 245 | 825 | K4 | | | | | |
| | Cast iron with spheroidal graphite | Ferritic | | 155 | 518 | K5 | | | | | |
| | | Pearlitic | | 265 | 885 | K6 | | | | | |
| GGV (CGI) | | | 200 | 675 | K7 | | | | | | |
| N | Aluminium wrought alloys | Cannot be hardened | | 30 | – | N1 | ●● | 3000 | 2800 | 2200 | |
| | | Hardenable, hardened | | 100 | 343 | N2 | ●● | 2000 | 1800 | 1400 | |
| | Cast aluminium alloys | ≤ 12% Si, cannot be hardened | | 75 | 260 | N3 | ●● | 2200 | 2000 | 1600 | |
| | | ≤ 12% Si, hardenable, hardened | | 90 | 314 | N4 | ●● | 1800 | 1600 | 1200 | |
| | | > 12% Si, cannot be hardened | | 130 | 447 | N5 | ●● | 500 | 450 | 300 | |
| | Magnesium alloys | | | 70 | 250 | N6 | ●● | 1800 | 1600 | 1200 | |
| | Copper and copper alloys (bronze/brass) | Non-alloyed, electrolytic copper | | 100 | 343 | N7 | ●● | 1000 | 900 | 700 | |
| Brass, bronze, red brass | | | 90 | 314 | N8 | ●● | 700 | 650 | 500 | | |
| Cu-alloys, short-chipping | | | 110 | 382 | N9 | ●● | 650 | 550 | 400 | | |
| High-strength, Ampco | | | 300 | 1013 | N10 | ●● | 400 | 300 | 150 | | |
| S | Heat-resistant alloys | Fe-based | Annealed | | 200 | 675 | S1 | | | | |
| | | | Hardened | | 280 | 943 | S2 | | | | |
| | | Ni or Co base | Annealed | | 250 | 839 | S3 | ●● | | | |
| | | | Hardened | | 350 | 1177 | S4 | ●● | | | |
| | | | Cast | | 320 | 1076 | S5 | ●● | | | |
| | Titanium alloys | Pure titanium | | 200 | 675 | S6 | ●● | 300 | 220 | 200 | |
| | | α and β alloys, hardened | | 375 | 1262 | S7 | | | | | |
| | | β alloys | | 410 | 1396 | S8 | | | | | |
| | Tungsten alloys | | | 300 | 1013 | S9 | ●● | 30 | 25 | 15 | |
| | Molybdenum alloys | | | 300 | 1013 | S10 | | | | | |
| H | Hardened steel | Hardened and tempered | | 50 HRC | – | H1 | ●● | | | | |
| | | Hardened and tempered | | 55 HRC | – | H2 | ●● | | | | |
| | | Hardened and tempered | | 60 HRC | – | H3 | ●● | | | | |
| | Hardened cast iron | Hardened and tempered | | 55 HRC | – | H4 | ●● | | | | |
| O | Thermoplastics | Without abrasive fillers | | | | O1 | ●● | 1500 | 1200 | 800 | |
| | Thermosetting plastics | Without abrasive fillers | | | | O2 | ●● | 1500 | 1200 | 800 | |
| | Plastic, glass-fibre reinforced | GFRP | | | | O3 | ●● | 1000 | 900 | 700 | |
| | Plastic, carbon-fibre reinforced | CFRP | | | | O4 | ●● | 800 | 700 | 500 | |
| | Plastic, aramid-fibre reinforced | AFRP | | | | O5 | ●● | 800 | 700 | 500 | |
| | Graphite (technical) | | 80 Shore | | | | O6 | ●● | 400 | 300 | 150 |

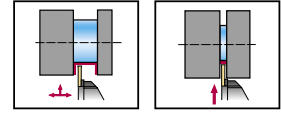
- Recommended application (the specified cutting data are regarded as starting values for the recommended application)
- Possible application

Note:

If dry machining is possible, the tool life reduces by an average of 20-30%.

¹ The classification of the machining groups can be found in the Walter General Catalogue 2012 from page H 8 onwards.

Cutting data for Walter Cut

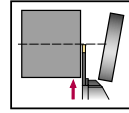


| Material group | Structure of main material groups and code letters | | Brinell hardness HB | Tensile strength R _m N/mm ² | Machining group ¹ | | Cutting material grades | | | |
|--|--|---|--------------------------|---|------------------------------|-----|--|--------|-----|-----|
| | | | | | | | Starting values for cutting speed v _c [m/min] | | | |
| | | | | | | | HC | | | |
| | | | | | | | WSM13S | WSM23S | | |
| P | Non-alloyed steel | C ≤ 0,25% | Annealed | 125 | 428 | P1 | ●● | ● | 200 | 190 |
| | | C > 0,25... ≤ 0,55% | Annealed | 190 | 639 | P2 | ●● | ● | 180 | 170 |
| | | C > 0,25... ≤ 0,55% | Heat-treated | 210 | 708 | P3 | ●● | ● | 170 | 160 |
| | | C > 0,55% | Annealed | 190 | 639 | P4 | ●● | ● | 190 | 180 |
| | | C > 0,55% | Heat-treated | 300 | 1013 | P5 | ●● | ● | 160 | 150 |
| | | Free cutting steel (short-chipping) | Annealed | 220 | 745 | P6 | ●● | ● | 190 | 180 |
| | Low-alloyed steel | | Annealed | 175 | 591 | P7 | ●● | ● | 190 | 180 |
| | | | Heat-treated | 300 | 1013 | P8 | ●● | ● | 160 | 150 |
| | | | Heat-treated | 380 | 1282 | P9 | ●● | ● | 160 | 150 |
| | | | Heat-treated | 430 | 1477 | P10 | ●● | ● | | |
| High-alloyed steel and high-alloyed tool steel | | Annealed | 200 | 675 | P11 | ●● | ● | 140 | 130 | |
| | | Hardened and tempered | 300 | 1013 | P12 | ●● | ● | 120 | 110 | |
| | | Hardened and tempered | 400 | 1361 | P13 | ●● | ● | | | |
| Stainless steel | | Ferritic/martensitic, annealed | 200 | 675 | P14 | ●● | ● | 190 | 180 | |
| | | Martensitic, heat-treated | 330 | 1114 | P15 | ●● | ● | 120 | 100 | |
| M | Stainless steel | Austenitic, quench hardened | 200 | 675 | M1 | ●● | ● | 190 | 170 | |
| | | Austenitic, precipitation hardened (PH) | 300 | 1013 | M2 | ●● | ● | 120 | 100 | |
| | | Austenitic/ferritic, duplex | 230 | 778 | M3 | ●● | ● | 170 | 150 | |
| K | Malleable cast iron | Ferritic | 200 | 675 | K1 | ●● | ● | 190 | 180 | |
| | | Pearlitic | 260 | 867 | K2 | ●● | ● | 170 | 160 | |
| K | Grey cast iron | Low tensile strength | 180 | 602 | K3 | ●● | ● | 220 | 210 | |
| | | High tensile strength/austenitic | 245 | 825 | K4 | ●● | ● | 180 | 170 | |
| | Cast iron with spheroidal graphite | Ferritic | 155 | 518 | K5 | ●● | ● | 220 | 210 | |
| Pearlitic | | 265 | 885 | K6 | ●● | ● | 180 | 170 | | |
| | GGV (CGI) | | 200 | 675 | K7 | ●● | ● | | | |
| N | Aluminium wrought alloys | Cannot be hardened | 30 | – | N1 | ●● | ● | | | |
| | | Hardenable, hardened | 100 | 343 | N2 | ●● | ● | | | |
| | Cast aluminium alloys | ≤ 12% Si, cannot be hardened | 75 | 260 | N3 | ●● | ● | | | |
| | | ≤ 12% Si, hardenable, hardened | 90 | 314 | N4 | ●● | ● | | | |
| | | > 12% Si, cannot be hardened | 130 | 447 | N5 | | | | | |
| | | Magnesium alloys | | 70 | 250 | N6 | | | | |
| Copper and copper alloys (bronze/brass) | | Non-alloyed, electrolytic copper | 100 | 343 | N7 | ●● | ● | | | |
| | | Brass, bronze, red brass | 90 | 314 | N8 | ●● | ● | | | |
| | | Cu-alloys, short-chipping | 110 | 382 | N9 | ●● | ● | | | |
| | | High-strength, Ampco | 300 | 1013 | N10 | | | | | |
| S | Heat-resistant alloys | Fe-based | Annealed | 200 | 675 | S1 | ●● | ● | 110 | 100 |
| | | | Hardened | 280 | 943 | S2 | ●● | ● | 60 | 50 |
| | | Ni or Co base | Annealed | 250 | 839 | S3 | ●● | ● | 90 | 80 |
| | | | Hardened | 350 | 1177 | S4 | ●● | ● | 80 | 70 |
| | | | Cast | 320 | 1076 | S5 | ●● | ● | 80 | 70 |
| | Titanium alloys | Pure titanium | 200 | 675 | S6 | ●● | ● | 160 | 150 | |
| | | α and β alloys, hardened | 375 | 1262 | S7 | ●● | ● | 45 | 40 | |
| | β alloys | 410 | 1396 | S8 | ●● | ● | 35 | 30 | | |
| | Tungsten alloys | | 300 | 1013 | S9 | | | | | |
| | Molybdenum alloys | | 300 | 1013 | S10 | | | | | |
| H | Hardened steel | | Hardened and tempered | 50 HRC | – | H1 | | | | |
| | | | Hardened and tempered | 55 HRC | – | H2 | | | | |
| | | | Hardened and tempered | 60 HRC | – | H3 | | | | |
| | Hardened cast iron | | Hardened and tempered | 55 HRC | – | H4 | | | | |
| O | Thermoplastics | | Without abrasive fillers | | | O1 | | | | |
| | Thermosetting plastics | | Without abrasive fillers | | | O2 | | | | |
| | Plastic, glass-fibre reinforced | | GFRP | | | O3 | | | | |
| | Plastic, carbon-fibre reinforced | | CFRP | | | O4 | | | | |
| | Plastic, aramid-fibre reinforced | | AFRP | | | O5 | | | | |
| | Graphite (technical) | | | 80 Shore | | | O6 | | | |

- Recommended application (the specified cutting data are regarded as starting values for the recommended application)
- Possible application

¹ The classification of the machining groups can be found in the Walter General Catalogue 2012 from page H 8 onwards.

1. Grooving and recessing



2. Parting off

| Cutting material grades | | | | | | | | | | | |
|---|--------|-------|--------|--------|--------|--------|--------|--------|--------|--------|-----|
| Starting values for cutting speed v_c [m/min] | | | | | | | | | | | |
| Grooving and recessing | | | | | | HC | | | | | HW |
| WSM33S | WSM43S | WTA33 | WKP13S | WKP23S | WKP33S | WSM13S | WSM23S | WSM33S | WSM43S | WKP23S | WK1 |
| ↕ | ↕ | ↕ | ↕ | ↕ | ↕ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| 180 | 170 | 190 | 220 | 200 | 180 | 190 | 180 | 170 | 160 | 190 | |
| 170 | 160 | 180 | 200 | 180 | 170 | 180 | 170 | 160 | 150 | 170 | |
| 150 | 140 | 160 | 190 | 170 | 160 | 160 | 150 | 140 | 130 | 160 | |
| 170 | 160 | 180 | 200 | 180 | 170 | 180 | 170 | 160 | 150 | 170 | |
| 140 | 130 | 120 | 170 | 150 | 150 | 150 | 140 | 130 | 120 | 140 | |
| 170 | 160 | 180 | 200 | 180 | 170 | 180 | 170 | 160 | 150 | 170 | |
| 160 | 150 | 180 | 200 | 180 | 160 | 180 | 170 | 150 | 140 | 170 | |
| 110 | 100 | 150 | 170 | 150 | 150 | 150 | 140 | 100 | 90 | 140 | |
| 100 | 100 | 130 | 170 | 150 | 130 | 150 | 140 | 90 | 90 | 140 | |
| | | | 100 | 80 | 60 | | | | | | |
| 120 | 110 | 180 | 180 | 170 | 160 | 130 | 120 | 110 | 100 | 120 | |
| 90 | 80 | 140 | 160 | 150 | 140 | 110 | 100 | 80 | 70 | 100 | |
| | | | 100 | 80 | 60 | | | | | | |
| 160 | 140 | 180 | 200 | 180 | 160 | 180 | 170 | 150 | 130 | | |
| 80 | 60 | 100 | 130 | 120 | 110 | 100 | 90 | 70 | 50 | | |
| 150 | 130 | 150 | | | | 170 | 160 | 140 | 120 | | |
| 80 | 60 | 100 | 130 | 120 | 110 | 100 | 90 | 70 | 50 | | |
| 130 | 110 | 130 | | | | 150 | 140 | 120 | 100 | | |
| 170 | | 100 | 190 | 160 | 140 | 180 | 170 | 160 | | 180 | |
| 150 | | 60 | 170 | 130 | 100 | 160 | 150 | 140 | | 160 | |
| 200 | | 260 | 350 | 330 | 250 | 230 | 220 | 210 | | 230 | |
| 160 | | 210 | 310 | 300 | 290 | 190 | 180 | 170 | | 190 | |
| 200 | | 240 | 300 | 290 | 280 | 210 | 200 | 190 | | 210 | |
| 160 | | 190 | 260 | 250 | 240 | 170 | 160 | 150 | | 170 | |
| | | | 220 | 200 | 180 | | | | | 190 | |
| | | | | | | | | | | | 900 |
| | | | | | | | | | | | 600 |
| | | | | | | | | | | | 350 |
| | | | | | | | | | | | 250 |
| | | | | | | | | | | | |
| | | | | | | | | | | | 400 |
| | | | | | | | | | | | 300 |
| | | | | | | | | | | | 200 |
| | | | | | | | | | | | |
| 90 | 80 | | | | | 100 | 90 | 80 | 70 | | |
| 40 | 30 | | | | | 50 | 40 | 30 | 25 | | |
| 70 | 60 | | | | | 80 | 70 | 60 | 50 | | |
| 60 | 50 | | | | | 70 | 60 | 50 | 40 | | |
| 60 | 50 | | | | | 70 | 60 | 50 | 40 | | |
| 130 | 120 | | | | | 150 | 140 | 130 | 110 | | |
| 35 | 30 | | | | | 50 | 40 | 30 | 25 | | |
| 25 | | | | | | 40 | 30 | 25 | | | |

HC = Coated carbide
 HW = Uncoated carbide

The specified cutting data are average recommended values.
 For special applications, adjustment is recommended.