

_ADDED VALUE FOR YOUR PRODUCTION.

Product Innovations catalogue



How to find and order your standard tools:



Personal – worldwide

You can contact us by phone, fax or e-mail. The contact details for your local contact can be found on our website at: walter-tools.com



The Walter General Catalogue 2017

contains the entire standard range of our competence brands Walter, Walter Titex and Walter Prototyp. It is supplemented regularly with the latest Product Innovations catalogue.



General Catalogue 2017

+



Product Innovations catalogue 2020

= the entire range of tools

At walter-tools.com, you can access and order your Walter products quickly and conveniently online – via smartphone, tablet or PC. The benefit for you: Direct access from any device, displayed in an optimised form, at any time.

Walter online catalogue

Tool-specific search

You can find products in the Walter online catalogue using the familiar structure of our product catalogue as well as filter and search functions. Other features: A shopping function and links to drawings and models.

Walter GPS

Application-based search

With Walter GPS, it takes just a few steps for you to find the best machining solution for your component, online and offline – and the solution can be transferred directly to the Walter TOOLSHOP if required!

Walter eLibrary

Document-based search

The Walter eLibrary app provides you with all the information you need on your mobile devices within a matter of seconds: E.g. brochures and catalogues – online and offline, in 17 languages.

Digital ordering methods



TOOLSHOP



EDI B2B

Walter TOOLSHOP & EDI

The Walter TOOLSHOP offers customers opportunities to find information and place orders quickly. EDI (electronic data interchange) also makes it possible to exchange documents (e.g. orders) – even special tools can be ordered.

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Technologies at Walter.

(((Accure-tec

The patented Walter Accure-tec technology ensures maximum vibration damping on boring bars for turning and adaptors for milling. Ideal for turning, milling and holmaking operations involving extended tool applications.

Tiger-tec®Gold

Tiger-tec® Gold is a new Walter technology platform for unique indexable insert coatings. These are produced using the innovative ultra low pressure method (ULP-CVD). The special titanium aluminium nitride layer makes them highly resistant to abrasion, hairline cracks, oxidation and plastic deformation, as well as ensuring maximum tool life and process reliability.

Tiger-tec®Silver

With Tiger-tec® Silver, Walter is offering a world first in coating technology for indexable inserts. The special aluminium oxide layer with optimised microstructure reduces wear during turning, milling and holmaking operations, and increases toughness and temperature resistance for significantly higher cutting data.

Walter BLAXX

Walter BLAXX is the benchmark for a new generation of milling cutters: The milling bodies are extremely robust thanks to their special surface treatment. The milling systems, which are mainly positioned tangentially, are equipped with Tiger-tec® indexable inserts. Tools with the "Walter BLAXX" designation combine high wear resistance with unbeatable performance data.

Xtra-tec®

Xtra-tec® indexable insert milling cutters and drills guarantee extremely soft cutting action and optimal surface quality on almost all materials. Indexable inserts with highly positive geometries and the Tiger-tec® coating have a particularly beneficial hardness/toughness ratio. For maximum productivity and process reliability.

Walter Nexxt

Engineering Kompetenz and digital expertise go hand in hand at Walter. Together with our wholly owned software subsidiary Comara, we develop digital solutions that efficiently connect machines and tools, optimising their performance on the basis of real-time data. Digital solutions on a level playing field with Industry 4.0 – Walter Nexxt.

Xtra-tec®XT

Xtra-tec® XT is the latest generation of Walter milling tools. As the "Xtended" Xtra-tec® technology, it offers a completely new perspective on productivity and process reliability. It can cover nearly all milling operations in every common material group: More reliable, productive, cost-efficient than ever before – all while compensating for the CO₂ emissions through Walter Green.

XD Technology

Walter Titex solid carbide drilling and reaming tools stand for precision, high performance and cost-efficiency when holmaking in practically any material. Walter Titex XD Technology offers the greatest precision and cost-efficiency in deep-hole drilling operations up to 70 × D_c without pecking.

Walter Xpress

Walter Xpress is the rapid ordering and delivery service offered by Walter Multiply for high-quality special tools. It is available for around 10,000 tool varieties, with a maximum delivery time of two to four weeks from the order date. The ordering process is clearly structured and guarantees absolute planning security. Quotations for all enquiries are calculated and provided within 24 hours.

Walter Green

Walter Green: Sustainability and responsible use of resources are central components of our company principles. We use our "Walter Green" seal to show how we implement these principles, such as by offsetting our CO₂ emissions with environmental conservation projects.



Walter Capto™ is a modular tool adaptor system. It is suitable for all turning, milling, holmaking and threading processes. Its ISO-standardised polygon taper absorbs torsional moments and bending moments extremely well and ensures optimal repeat accuracy.



Walter ConeFit is an extremely flexible solid carbide milling system with a wide range of high-performance exchangeable heads and shaft variants. Its conical thread can self-centre, thereby guaranteeing maximum stability and concentricity.



Walter ScrewFit users benefit from maximum flexibility. Its modular interface is suitable for a wide variety of adaptors and a wide range of tool diameters and lengths for milling and holmaking.



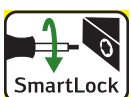
The precision-ground QuadFit interface with taper and support face characterises the precision of the vibration-damped boring bars for turning with Walter Accure-tec technology. The exchangeable head system, which can be rotated by 180°, makes it possible to rapidly replace tools with high accuracy during changeovers.



The Walter precision coolant system provides cooling at the centre of chip formation. Its dual coolant jets are directed precisely onto the flank and rake faces of the insert. This system provides significantly increased tool life, improved chip breaking and greater efficiency for turning and grooving applications.



"Flash" refers to specialized solid carbide milling cutters for high-feed milling. Their end-face geometry reduces the chip thickness "h" and therefore enables an extremely high feed per tooth. Forces that occur are diverted axially towards the centre of the tool, which helps to stabilise the machining process.



On Walter turning toolholders with "SmartLock", the clamping screw can be operated from the side of the tool. This makes it possible to change the inserts in the machine quickly and easily where access is limited. Tool change times are reduced as a result. Ideal for use on CNC lathe and multi-spindle machines.



ISO turning – A1

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Grooving – A2

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Technical information – A1/A2

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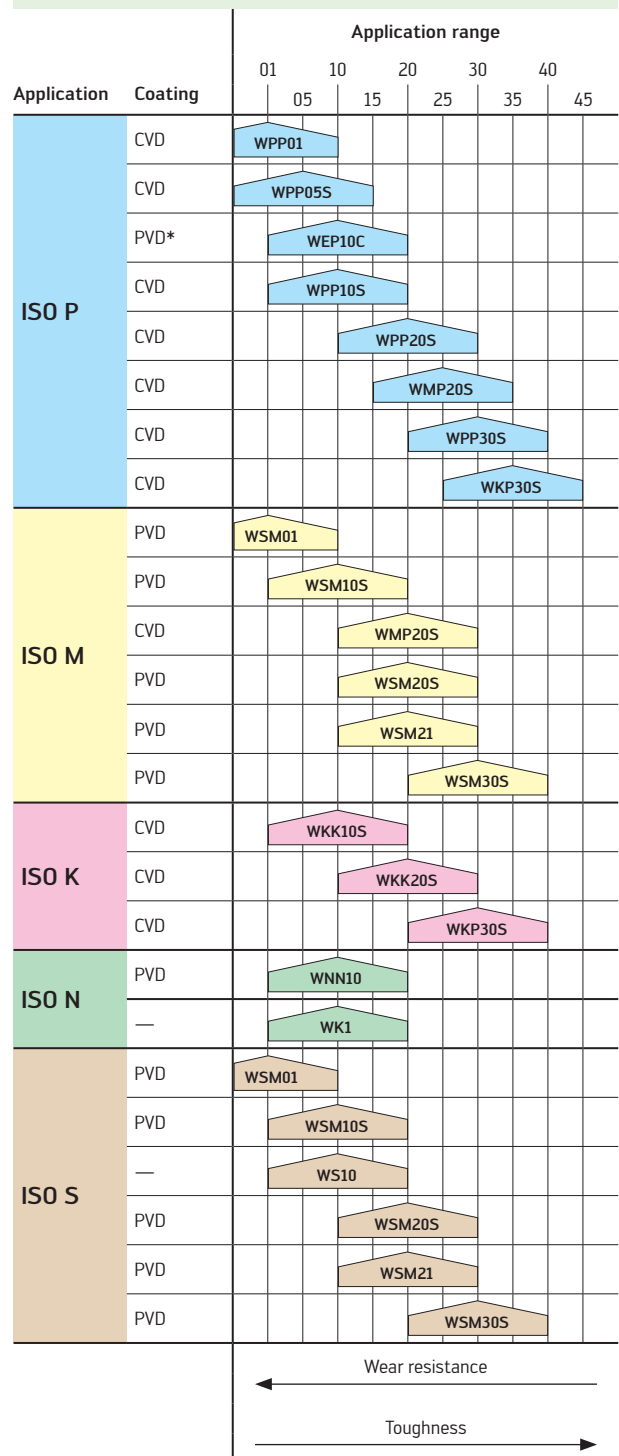
Product range overview of indexable inserts and cutting tool materials: ISO turning – Carbide



Indexable inserts

Insert shape	Description	Page
 C Wiper	Negative basic shape	12
	Positive basic shape 7°	27
	Positive basic shape 11°	29
 D Wiper	Negative basic shape	16
	Positive basic shape 7°	31
	Positive basic shape 11°	32
 R	Negative basic shape	18
	Positive basic shape 7°	33
 S	Negative basic shape	19
	Positive basic shape 7°	34
	Positive basic shape 11°	35
 T	Negative basic shape	21
	Positive basic shape 7°	36
	Positive basic shape 11°	38
 V	Negative basic shape	23
	Positive basic shape 5°/7°	40
 W Wiper	Negative basic shape	24
	Positive basic shape 7°	41





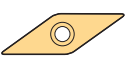

Cutting tool materials: Carbide



* Cermet

Product range overview of indexable inserts and cutting tool materials: ISO turning – Carbide, Perform line

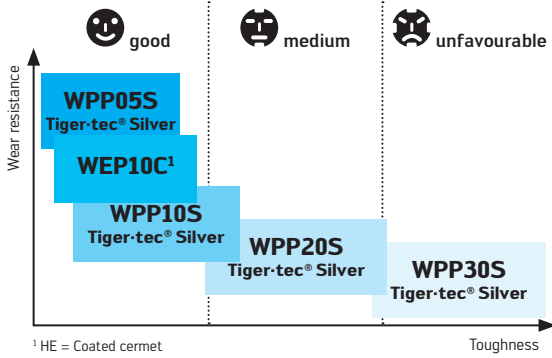


Indexable inserts		
Insert shape	Description	Page
	C Negative basic shape Positive basic shape 7°	15
		30
	D Negative basic shape Positive basic shape 7°	18
		33
	S Negative basic shape	20
	T Negative basic shape Positive basic shape 7°	22
		39
	V Negative basic shape Positive basic shape 5°/7°	23
		41
	W Negative basic shape	26

Cutting tool materials: Carbide, Perform line		Application range						
Application	Coating	01	10	20	30	40		
		05	15	25	35	45		
ISO P	CVD	WPV10						
	CVD	WPV20						
ISO K	CVD	WKV10						
	CVD	WKV20						
		← Wear resistance						
		Toughness →						

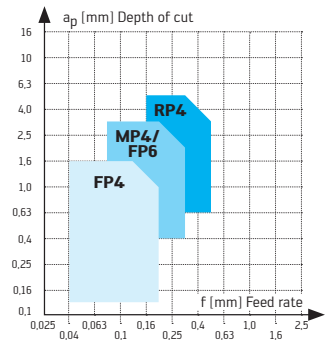
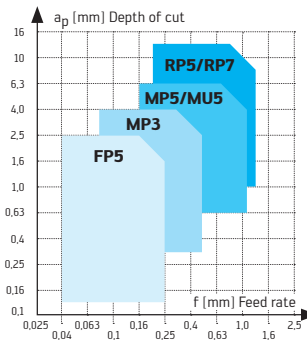
Product range overview of indexable inserts for ISO turning: Tiger-tec® Silver grades and geometries

Machining steel ISO P



Negative basic shape

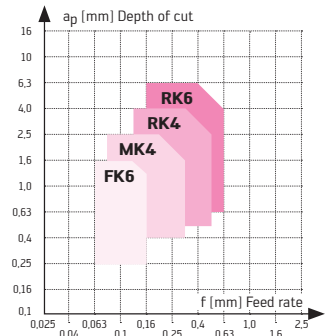
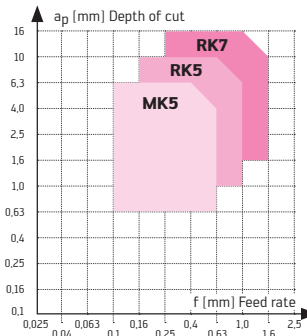
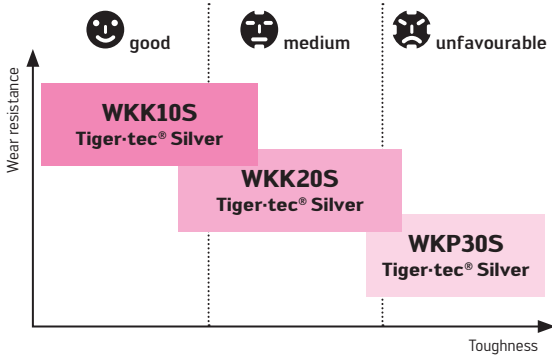
Positive basic shape



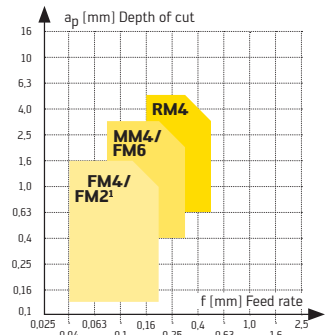
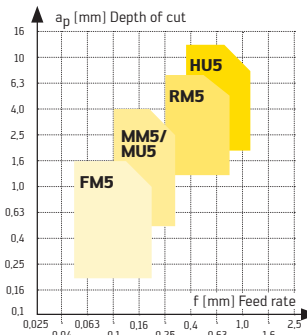
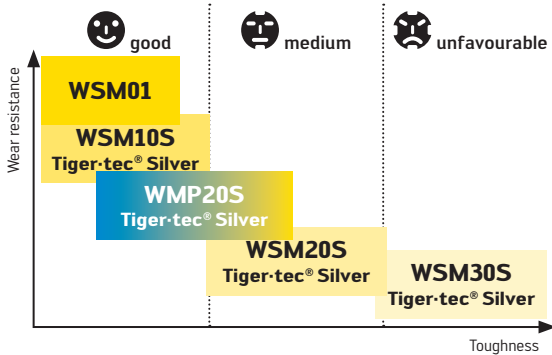
MP5: For universal machining
 MU5: Easy-cutting – for ISO P and ISO M
 RP5: For universal machining
 RP7: For interrupted cuts, cast skin/forged skin

MP4: for universal machining, copy turning
 FP6: For semi-finishing operations

Cast iron machining ISO K



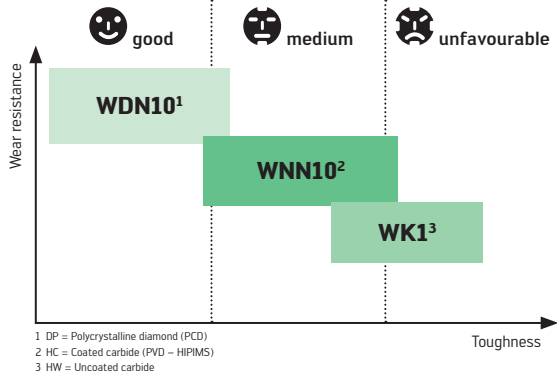
Stainless steel ISO M



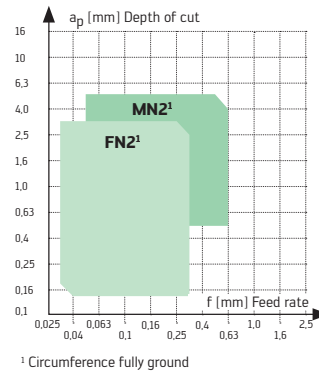
MM5: For universal machining
 MU5: Easy-cutting – for ISO P and ISO M

MM4: For universal machining, copy turning
 FM6: For semi-finishing operations
¹ Circumference fully ground

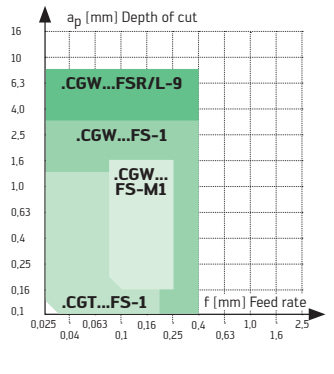
NF metals ISO N



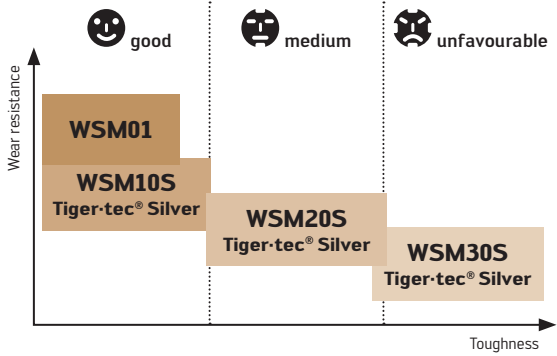
Positive basic shape Carbide



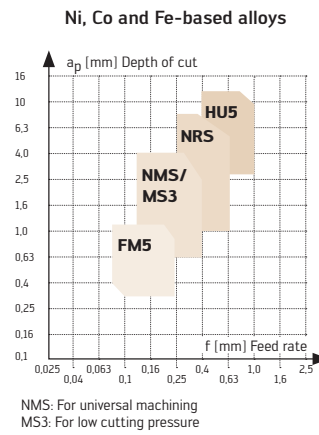
Positive basic shape PCD



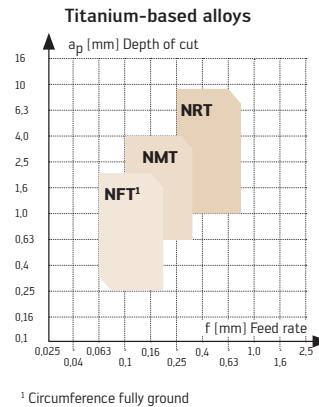
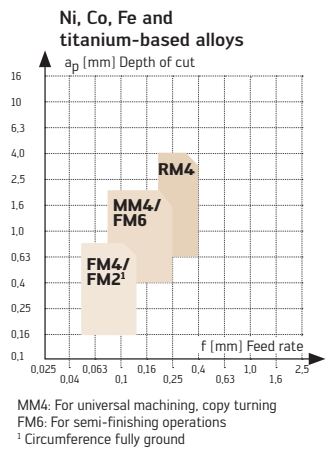
ISO S high-temperature alloys and titanium alloys



Negative basic shape



Positive basic shape



Product range overview of indexable inserts for ISO turning: Perform line

Designation key

Simple geometry designation:

M	V	5
1	2	3

- 1: Chip breaking range – e.g. M = Medium machining
- 2: Versatile materials
- 3: Feed/chip breaking range

Simple grade designation:

W	P	V	20
1	2	3	4

- 1: Walter
- 2: First primary application – e.g. P = ISO P
- 3: Second primary application, "Versatile"
- 4: ISO application range

Grades and geometries

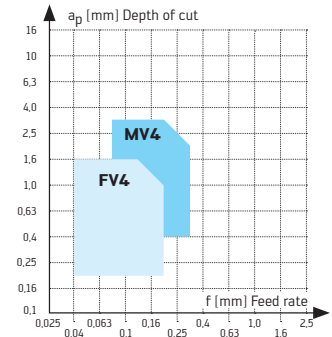
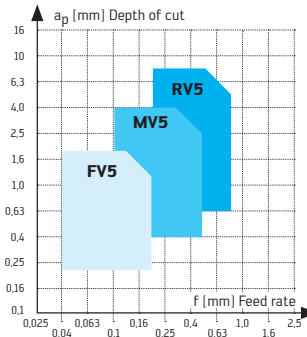
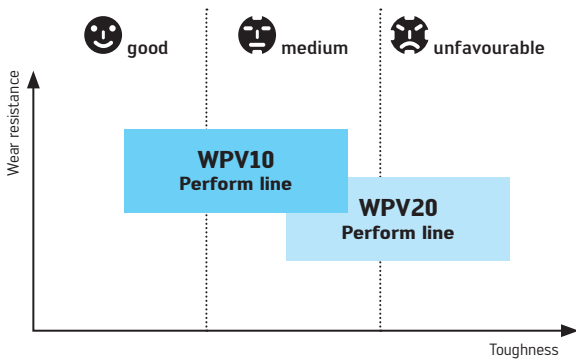
Machining steel ISO P



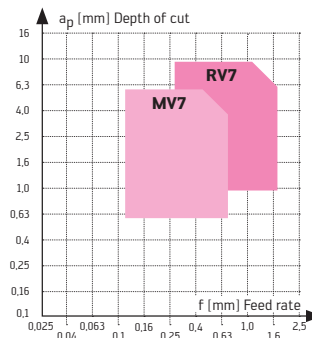
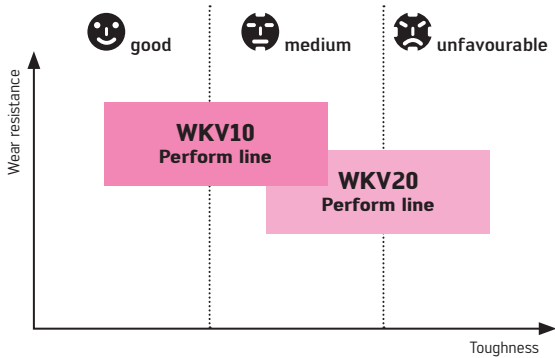
Negative basic shape



Positive basic shape

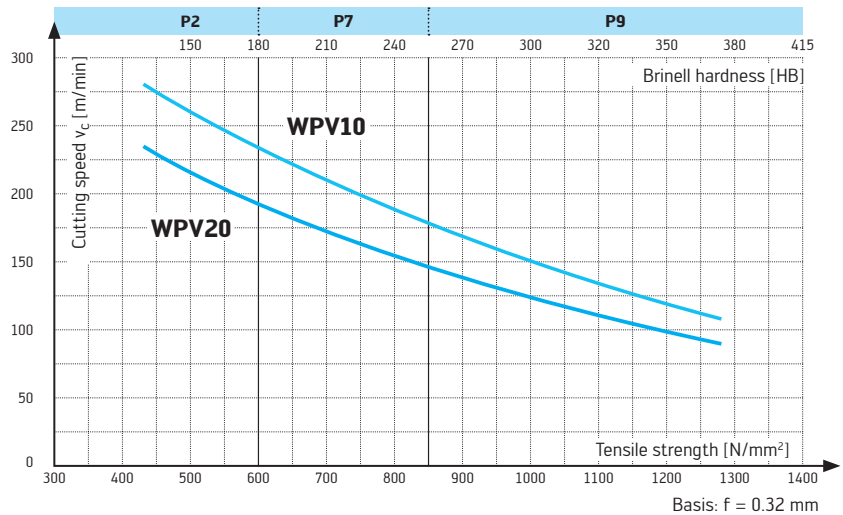


Cast iron machining ISO K



Cutting speeds

Cutting speed selection based on tensile strength/hardness:

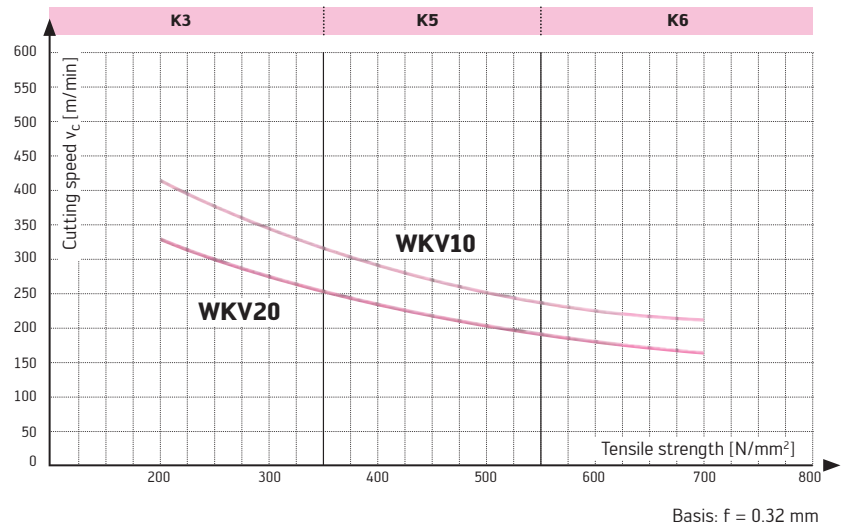


Machining steel ISO P

Cutting speed range for selected materials:

ISO material group	Material	Tensile strength	Brinell hardness	Cutting speed	
				WPV10	WPV20
P2	S235JR (St37), C45	500 N/mm ²	150 HB	200 – 240 – 340 m/min	160 – 200 – 280 m/min
P7	100Cr6, 42CrMo4	800 N/mm ²	240 HB	130 – 180 – 200 m/min	100 – 150 – 180 m/min
P9	56NiCrMoV7	1250 N/mm ²	370 HB	80 – 130 – 140 m/min	70 – 100 – 130 m/min

Cutting speed selection for ISO K materials based on tensile strength:



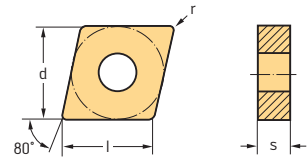
Cutting speed range for selected materials:

ISO material group	Material	Tensile strength	Brinell hardness	Cutting speed	
				WKV10	WKV20
K3	GG-25 (FC250)	250 N/mm ²	180 HB	270 – 360 – 560 m/min	210 – 300 – 500 m/min
K5	GGG-40 (FCD400)	400 N/mm ²	155 HB	210 – 270 – 370 m/min	160 – 220 – 290 m/min
K6	GGG-70 (FCD700)	700 N/mm ²	265 HB	170 – 210 – 270 m/min	130 – 170 – 210 m/min

For indexable inserts with positive basic shape, the cutting speed should be reduced by approximately 10%

Negative rhombic 80° CNMG / CNGG / CNMA / CNMM

Tiger-tec® Silver



Indexable inserts

Designation	r mm	f mm	a _p mm	P						M				K			S			
				HC						HC				HC			HC			
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S
 CNMG120404-NF CNMG120408-NF Wiper	0,4	0,10–0,40	0,4–2,0	☉	☉	☉				☉								☉		
	0,8	0,15–0,55	0,5–3,0	☉	☉	☉				☉								☉		
 CNMG120404-NFT CNMG120408-NFT	0,4	0,08–0,17	0,4–1,5							☉								☉		☉
	0,8	0,10–0,20	0,5–2,0							☉								☉		☉
 CNMG120402-FM5 CNMG120404-FM5 CNMG120408-FM5 CNMG120412-FM5	0,2	0,03–0,10	0,1–1,0							☉	☉							☉	☉	
	0,4	0,05–0,15	0,2–1,5							☉	☉							☉	☉	
	0,8	0,07–0,20	0,4–1,5							☉	☉							☉	☉	
	1,2	0,10–0,25	0,5–2,0							☉	☉							☉	☉	
 CNMG120408-NM CNMG120412-NM Wiper	0,8	0,20–0,55	0,8–3,0		☉	☉				☉		☉	☉					☉		
	1,2	0,25–0,70	1,5–4,0		☉	☉				☉		☉	☉					☉		
 CNMG120404-MS3 CNMG120408-MS3	0,4	0,12–0,25	0,6–3,0							☉	☉	☉	☉				☉	☉	☉	☉
	0,8	0,15–0,30	0,8–3,0		☉	☉				☉	☉	☉	☉					☉	☉	☉
 CNGG120401-MS3 CNGG120402-MS3 CNGG120404-MS3 CNGG120408-MS3	0,1	0,02–0,06	0,2–2,5							☉								☉		
	0,2	0,05–0,12	0,4–2,5							☉								☉		
	0,4	0,10–0,25	0,6–3,0							☉								☉		
	0,8	0,12–0,30	0,8–3,0							☉								☉		
 CNMG120408-NMT CNMG120412-NMT	0,8	0,12–0,30	0,8–4,0							☉								☉		☉
	1,2	0,15–0,32	1,0–4,0							☉								☉		☉
 CNMG120404-NMS CNMG120408-NMS CNMG120412-NMS	0,4	0,10–0,24	0,6–2,5							☉	☉	☉	☉				☉	☉	☉	☉
	0,8	0,13–0,32	0,8–3,5							☉	☉	☉	☉				☉	☉	☉	☉
	1,2	0,16–0,36	1,0–3,5							☉	☉						☉	☉		☉
 CNMG090304-MP3 CNMG090308-MP3 CNMG120404-MP3 CNMG120408-MP3 CNMG120412-MP3	0,4	0,06–0,20	0,3–2,2		☉	☉														
	0,8	0,10–0,28	0,6–3,0		☉	☉	☉													
	0,4	0,08–0,22	0,3–2,5		☉	☉	☉	☉												
	0,8	0,12–0,32	0,6–3,2		☉	☉	☉	☉												
	1,2	0,16–0,40	0,8–3,5		☉	☉	☉	☉												

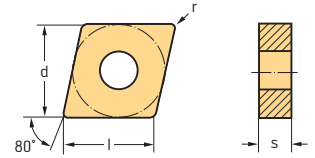
See the ISO 1832 designation key for dimensions

 HC = Coated carbide
 HW = Uncoated carbide

/ ★ New addition to the product range

Negative rhombic 80° CNMG / CNGG / CNMA / CNMM

Tiger-tec® Silver

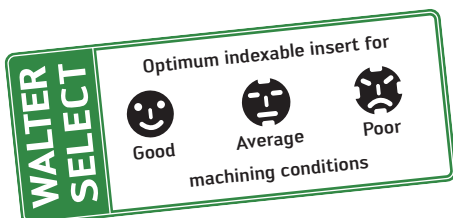


Indexable inserts

Designation	r mm	f mm	a _p mm	P						M				K			S			
				HC						HC				HC			HC			
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S
	CNMG120404-MM5	0,4	0,10-0,20	0,5-3,0																
	CNMG120408-MM5	0,8	0,15-0,32	0,8-3,0																
	CNMG120412-MM5	1,2	0,15-0,35	0,8-3,5																
	CNMG120416-MM5	1,6	0,15-0,40	1,0-4,0																
	CNMG160608-MM5	0,8	0,15-0,35	0,8-4,5																
	CNMG160612-MM5	1,2	0,18-0,40	0,8-4,5																
	CNMG160616-MM5	1,6	0,20-0,45	1,0-4,5																
	CNMG120408-MU5	0,8	0,15-0,40	0,6-5,0	☹	☹	☹	☹	☹		☹							☹		
	CNMG120412-MU5	1,2	0,25-0,60	1,0-5,0	☹	☹	☹	☹	☹		☹							☹		
	CNMG090308-MK5	0,8	0,10-0,20	0,2-3,0										☹	☹					
	CNMG120404-MK5	0,4	0,16-0,25	0,6-5,0										☹	☹					
	CNMG120408-MK5	0,8	0,25-0,50	0,8-5,0										☹	☹					
	CNMG120412-MK5	1,2	0,30-0,50	1,2-5,0										☹	☹					
	CNMG120416-MK5	1,6	0,35-0,50	1,5-5,0										☹	☹					
	CNMG160608-MK5	0,8	0,25-0,50	0,8-7,0										☹	☹					
	CNMG160612-MK5	1,2	0,30-0,60	1,2-7,0										☹	☹					
	CNMG160616-MK5	1,6	0,35-0,60	1,5-7,0										☹	☹					
	CNMG190612-MK5	1,2	0,30-0,65	1,2-8,0										☹	☹					
	CNMG190616-MK5	1,6	0,35-0,80	1,5-8,0										☹	☹					
		CNMG120408-NRT	0,8	0,18-0,35	1,0-6,0															☹
CNMG120412-NRT		1,2	0,20-0,40	1,2-6,0															☹	
CNMG160612-NRT		1,2	0,28-0,55	1,5-7,5															☹	
CNMG190616-NRT		1,6	0,35-0,70	2,0-9,0															☹	
	CNMG120408-NRS	0,8	0,16-0,35	1,0-4,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG120412-NRS	1,2	0,18-0,40	1,2-4,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG160612-NRS	1,2	0,21-0,45	1,2-6,5						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG160616-NRS	1,6	0,23-0,50	1,5-6,5						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG190608-NRS	0,8	0,20-0,45	1,0-8,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG190612-NRS	1,2	0,23-0,50	1,2-8,5						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG120408-RM5	0,8	0,20-0,40	1,2-5,0		☹	☹			☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG120412-RM5	1,2	0,25-0,50	1,5-5,0		☹	☹			☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG120416-RM5	1,6	0,30-0,55	2,0-5,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG160608-RM5	0,8	0,22-0,45	1,2-7,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG160612-RM5	1,2	0,25-0,60	1,5-7,0		☹	☹			☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG160616-RM5	1,6	0,30-0,65	2,0-7,0		☹	☹			☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG190612-RM5	1,2	0,25-0,60	1,5-8,0						☹	☹	☹	☹			☹	☹	☹	☹	
	CNMG190616-RM5	1,6	0,30-0,80	2,0-8,0						☹	☹	☹	☹			☹	☹	☹	☹	

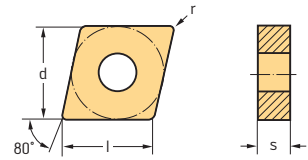
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide



Negative rhombic 80° CNMG / CNGG / CNMA / CNMM

Tiger-tec® Silver



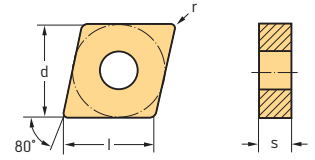
Indexable inserts

Designation	r mm	f mm	a _p mm	P						M			K			S					
				HC						HC			HC			HC					
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	WSM30S
	CNMA120404-RK5	0,4	0,16–0,25	0,6–5,0																	
	CNMA120408-RK5	0,8	0,25–0,50	0,8–5,0																	
	CNMA120412-RK5	1,2	0,30–0,50	1,2–5,0																	
	CNMA120416-RK5	1,6	0,35–0,70	1,5–5,0																	
	CNMA160612-RK5	1,2	0,35–0,70	1,2–7,0																	
	CNMA160616-RK5	1,6	0,35–0,80	1,5–7,0																	
	CNMA190612-RK5	1,2	0,30–0,65	1,2–8,0																	
	CNMA190616-RK5	1,6	0,35–0,80	1,5–8,0																	
	CNMA190624-RK5	2,4	0,40–0,90	2,5–8,0																	
	CNMA120408-RK7	0,8	0,25–0,50	0,8–5,0																	
	CNMA120412-RK7	1,2	0,30–0,50	1,2–5,0																	
	CNMA120416-RK7	1,6	0,35–0,70	1,5–5,0																	
	CNMA160612-RK7	1,2	0,35–0,70	1,2–7,0																	
	CNMA160616-RK7	1,6	0,35–0,80	1,5–7,0																	
	CNMA190612-RK7	1,2	0,30–0,65	1,2–8,0																	
	CNMA190616-RK7	1,6	0,35–0,80	1,5–8,0																	
	CNMM120408-HU5	0,8	0,25–0,55	1,0–7,0																	
	CNMM120412-HU5	1,2	0,30–0,70	1,5–7,0																	
	CNMM160612-HU5	1,2	0,35–0,70	1,5–9,0																	
	CNMM160616-HU5	1,6	0,40–0,80	2,0–9,0																	
	CNMM190612-HU5	1,2	0,35–0,70	1,5–10,0																	
	CNMM190616-HU5	1,6	0,40–0,90	2,0–10,0																	
	CNMM190624-HU5	2,4	0,45–1,00	2,0–10,0																	

See the ISO 1832 designation key for dimensions

 HC = Coated carbide
 HW = Uncoated carbide

Negative rhombic 80° CNMG Perform / CNMA Perform

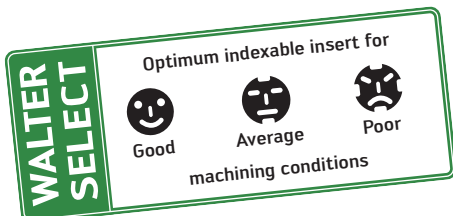


Indexable inserts

Designation	r mm	f mm	a _p mm	P						M			K				S				
				HC						HC			HC				HC				
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WKV10	WKV20	WSM10S	WSM20S
CNMG120404-FV5	0,4	0,05-0,20	0,2-1,5																		
	CNMG120408-FV5	0,8	0,08-0,25	0,4-2,0																	
CNMG120404-MV5	0,4	0,10-0,20	0,5-3,5																		
	CNMG120408-MV5	0,8	0,15-0,32	0,8-4,0																	
	CNMG120412-MV5	1,2	0,18-0,40	0,8-4,0																	
	CNMG160612-MV5	1,2	0,20-0,45	0,8-5,0																	
CNMG120408-MV7	0,8	0,20-0,45	0,8-5,0																		
	CNMG120412-MV7	1,2	0,25-0,50	1,2-5,0																	
	CNMG120416-MV7	1,6	0,30-0,55	1,5-5,0																	
	CNMG160612-MV7	1,2	0,25-0,50	1,2-7,0																	
	CNMG160616-MV7	1,6	0,30-0,55	1,5-7,0																	
	CNMG190612-MV7	1,2	0,30-0,60	1,2-8,0																	
	CNMG120408-RV5	0,8	0,20-0,40	1,0-5,0																	
	CNMG120412-RV5	1,2	0,25-0,55	1,0-5,0																	
CNMG160612-RV5	1,2	0,25-0,55	2,0-6,0																		
	CNMG160616-RV5	1,6	0,35-0,60	2,0-6,0																	
	CNMA120408-RV7	0,8	0,25-0,50	0,8-5,0																	
	CNMA120412-RV7	1,2	0,30-0,55	1,2-5,0																	
CNMA120416-RV7	1,6	0,35-0,70	1,5-5,0																		

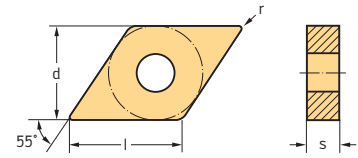
See the ISO 1832 designation key for dimensions

HC = Coated carbide



Negative rhombic 55° DNMG / DNGG / DNMM

Tiger-tec® Silver



Indexable inserts

Designation	r mm	f mm	a _p mm	P						M				K			S				HW		
				HC						HC				HC			HC						
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	WSM30S	WS10	
Wiper	DNMG110408-NF	0,8	0,15-0,50	0,5-2,0	☉	☉							☉								☉		
	DNMG150408-NF	0,8	0,15-0,50	0,5-3,0	☉	☉							☉								☉		
	DNMG150608-NF	0,8	0,15-0,50	0,5-3,0	☉	☉							☉								☉		
	DNMG150404-NFT	0,4	0,06-0,16	0,4-1,5									☉								☉		
	DNMG150604-NFT	0,4	0,06-0,16	0,4-1,5									☉								☉		
	DNMG150608-NFT	0,8	0,08-0,19	0,5-2,0									☉								☉		☉
	DNMG110404-FM5	0,4	0,05-0,15	0,2-1,0					☉	☉		☉	☉							☉	☉		
	DNMG110408-FM5	0,8	0,07-0,20	0,4-1,5					☉	☉		☉	☉							☉	☉		
	DNMG150404-FM5	0,4	0,05-0,15	0,2-1,5					☉	☉		☉	☉							☉	☉		
	DNMG150408-FM5	0,8	0,07-0,20	0,4-1,5					☉	☉		☉	☉							☉	☉		
	DNMG150602-FM5	0,2	0,03-0,10	0,1-1,0								☉	☉							☉	☉		
	DNMG150604-FM5	0,4	0,05-0,15	0,2-1,5					☉	☉		☉	☉							☉	☉		
	DNMG150608-FM5	0,8	0,07-0,20	0,4-1,5					☉	☉		☉	☉							☉	☉		
	DNMG150608-FM5	0,8	0,07-0,20	0,4-1,5					☉	☉		☉	☉							☉	☉		
	DNMG110408-MS3	0,8	0,12-0,30	0,8-2,5							☉	☉	☉						☉	☉		☉	
	DNMG150404-MS3	0,4	0,12-0,25	0,6-2,5							☉	☉	☉						☉	☉		☉	
	DNMG150408-MS3	0,8	0,15-0,30	0,8-2,5		☉					☉	☉	☉						☉	☉		☉	
	DNMG150604-MS3	0,4	0,12-0,25	0,6-2,5							☉	☉	☉						☉	☉		☉	
	DNMG150608-MS3	0,8	0,15-0,30	0,8-2,5				☉			☉	☉	☉						☉	☉		☉	
	DNGG150402-MS3	0,2	0,05-0,12	0,4-2,0							☉								☉				
	DNGG150404-MS3	0,4	0,10-0,25	0,6-2,5							☉								☉				
	DNGG150408-MS3	0,8	0,12-0,30	0,8-2,5							☉								☉				
	DNMG110404-NMT	0,4	0,08-0,22	0,4-2,5								☉	☉							☉	☉		
	DNMG110408-NMT	0,8	0,12-0,28	0,6-3,2								☉	☉							☉	☉		
	DNMG150408-NMT	0,8	0,12-0,28	0,6-4,0								☉	☉							☉	☉		☉
	DNMG150608-NMT	0,8	0,12-0,28	0,6-4,0								☉	☉							☉	☉		☉
	DNMG150612-NMT	1,2	0,15-0,30	0,8-4,0									☉	☉							☉	☉	
	DNMG150404-NMS	0,4	0,09-0,22	0,6-2,5							☉	☉	☉						☉	☉		☉	
	DNMG150408-NMS	0,8	0,11-0,30	0,8-3,5							☉	☉	☉						☉	☉		☉	
	DNMG150604-NMS	0,4	0,09-0,22	0,6-2,5							☉	☉	☉						☉	☉		☉	
	DNMG150608-NMS	0,8	0,11-0,30	0,8-3,5							☉	☉	☉	☉					☉	☉		☉	☉
	DNMG110404-MM5	0,4	0,10-0,18	0,5-2,0					☉	☉		☉	☉						☉	☉		☉	
	DNMG110408-MM5	0,8	0,15-0,25	0,8-3,0					☉	☉		☉	☉						☉	☉		☉	
	DNMG150404-MM5	0,4	0,10-0,18	0,5-2,5					☉	☉		☉	☉						☉	☉		☉	
	DNMG150408-MM5	0,8	0,15-0,25	0,8-3,0					☉	☉		☉	☉						☉	☉		☉	
	DNMG150412-MM5	1,2	0,18-0,30	0,8-3,0								☉	☉							☉	☉		
	DNMG150604-MM5	0,4	0,10-0,18	0,5-2,5					☉	☉		☉	☉						☉	☉		☉	
	DNMG150608-MM5	0,8	0,15-0,25	0,8-3,0					☉	☉		☉	☉						☉	☉		☉	
	DNMG150612-MM5	1,2	0,18-0,30	0,8-3,0					☉	☉		☉	☉						☉	☉		☉	

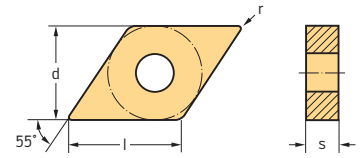
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

☉ ☉ ☉ / ★ New addition to the product range

Negative rhombic 55° DNMG / DNGG / DNMM

Tiger-tec® Silver

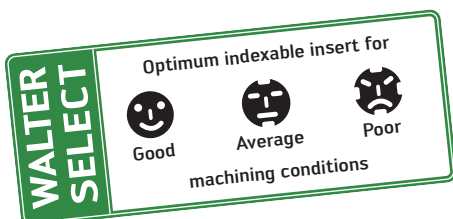


Indexable inserts

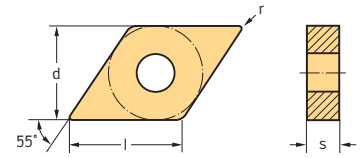
Designation	r mm	f mm	a _p mm	P						M				K			S			
				HC						HC				HC			HC			
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	WSM30S
DNMG110408-MU5	0,8	0,18-0,35	0,6-4,0																	
DNMG150408-MU5	0,8	0,18-0,35	0,6-5,0																	
DNMG150608-MU5	0,8	0,18-0,35	0,6-5,0																	
DNMG150612-MU5	1,2	0,20-0,45	1,0-5,0																	
DNMG150616-MU5	1,6	0,25-0,50	1,2-5,0																	
DNMG150408-NRS	0,8	0,13-0,32	1,0-4,0																	
DNMG150608-NRS	0,8	0,13-0,32	1,0-4,0																	
DNMG150612-NRS	1,2	0,15-0,35	1,2-4,0																	
DNMG110408-RM5	0,8	0,20-0,40	1,2-3,5																	
DNMG110412-RM5	1,2	0,25-0,50	1,5-3,5																	
DNMG150408-RM5	0,8	0,20-0,40	1,2-4,0																	
DNMG150608-RM5	0,8	0,20-0,40	1,2-4,0																	
DNMG150612-RM5	1,2	0,25-0,50	1,5-4,0																	
DNMM150608-HU5	0,8	0,25-0,45	1,0-5,0																	
DNMM150612-HU5	1,2	0,30-0,50	1,5-5,0																	

See the ISO 1832 designation key for dimensions





HC = Coated carbide
HW = Uncoated carbide



Negative rhombic 55° DNMG Perform



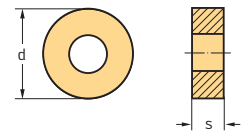
Indexable inserts

Designation	r mm	f mm	a _p mm	P								M			K				S			
				HC								HC			HC				HC			
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WKV10	WKV20	WSM10S	WSM20S	WSM30S
 DNMG110404-FV5 DNMG110408-FV5 DNMG150408-FV5 DNMG150604-FV5 DNMG150608-FV5	0,4	0,05–0,20	0,2–1,5																			
	0,8	0,08–0,25	0,4–2,0																			
	0,8	0,08–0,25	0,4–2,0																			
	0,4	0,05–0,20	0,2–1,5																			
	0,8	0,08–0,25	0,4–2,0																			
 DNMG110408-MV5 DNMG150408-MV5 DNMG150608-MV5	0,8	0,15–0,32	0,8–3,0																			
	0,8	0,15–0,32	0,8–3,5																			
	0,8	0,15–0,32	0,8–3,5																			
 DNMG150412-MV7 DNMG150608-MV7 DNMG150612-MV7	1,2	0,25–0,45	1,2–5,0																			
	0,8	0,20–0,45	0,8–5,0																			
	1,2	0,25–0,45	1,2–5,0																			
 DNMG150608-RV5 DNMG150612-RV5	0,8	0,15–0,40	1,0–4,5																			
	1,2	0,20–0,50	1,0–4,5																			



See the ISO 1832 designation key for dimensions

HC = Coated carbide

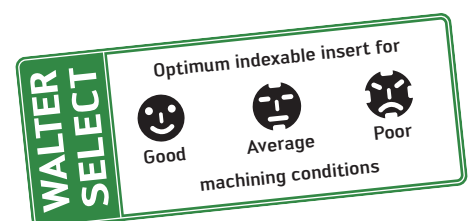
Negative round RNMG / RNMA Tiger-tec® Silver



Indexable inserts

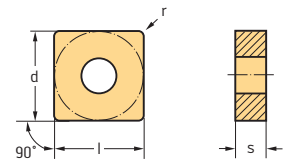
Designation	d mm	f mm	a _p mm	P					M			K			S			HW		
				HC					HC			HC			HC			HW		
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM10S	WSM20S	WSM30S	WS10	
 RNMG120400-RP5	12,7	0,20–0,60	1,2–5,0																	
 RNMA120400-RK5	12,7	0,15–0,60	1,2–4,0																	

See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Negative square SNMG / SNMA / SNMM

Tiger-tec® Silver



Indexable inserts

Designation	r mm	f mm	a _p mm	P					M				K			S				HW	
				HC					HC				HC			HC					
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S		WSM30S
SNMG120408-FM5	0,8	0,07-0,20	0,4-1,5																		
SNMG120412-FM5	1,2	0,10-0,25	0,5-2,0																		
SNMG120404-MM5	0,4	0,10-0,18	0,5-2,0																		
SNMG120408-MM5	0,8	0,15-0,25	0,8-3,0																		
SNMG120412-MM5	1,2	0,18-0,30	0,8-3,5																		
SNMG090308-MK5	0,8	0,10-0,20	0,2-3,0																		
SNMG120408-MK5	0,8	0,25-0,50	0,8-5,0																		
SNMG120412-MK5	1,2	0,30-0,50	1,2-5,0																		
SNMG120416-MK5	1,6	0,35-0,50	1,5-5,0																		
SNMG150612-MK5	1,2	0,30-0,60	1,2-7,0																		
SNMG150616-MK5	1,6	0,35-0,60	1,5-7,0																		
SNMG190612-MK5	1,2	0,30-0,65	1,2-8,0																		
SNMG190616-MK5	1,6	0,35-0,80	1,5-8,0																		
SNMG120408-NMS	0,8	0,12-0,35	0,8-3,5																		
SNMG120412-NMS	1,2	0,15-0,40	0,8-3,5																		
SNMG120416-NMS	1,6	0,18-0,45	1,0-3,5																		
SNMG120412-NRT	1,2	0,25-0,50	0,8-6,0																		
SNMG150612-NRT	1,2	0,30-0,60	1,0-7,5																		
SNMG190616-NRT	1,6	0,40-0,80	1,5-9,0																		
SNMG120408-NRS	0,8	0,20-0,40	0,8-5,0																		
SNMG120412-NRS	1,2	0,22-0,45	1,0-5,0																		
SNMG150616-NRS	1,6	0,24-0,55	1,2-7,0																		
SNMG190612-NRS	1,2	0,24-0,55	1,0-9,0																		
SNMG190616-NRS	1,6	0,27-0,60	1,2-9,0																		
SNMG120408-RM5	0,8	0,20-0,40	1,2-5,0																		
SNMG120412-RM5	1,2	0,25-0,50	1,5-5,0																		
SNMG120416-RM5	1,6	0,30-0,55	2,0-5,0																		
SNMG150612-RM5	1,2	0,25-0,60	1,5-7,0																		
SNMG150616-RM5	1,6	0,30-0,55	2,0-7,0																		
SNMG190612-RM5	1,2	0,25-0,60	1,5-8,0																		
SNMG190616-RM5	1,6	0,30-0,80	2,0-8,0																		
SNMA120408-RK7	0,8	0,25-0,50	0,8-5,0																		
SNMA120412-RK7	1,2	0,30-0,60	1,2-5,0																		
SNMA120416-RK7	1,6	0,35-0,70	1,5-5,0																		
SNMA150616-RK7	1,6	0,35-0,80	1,5-7,0																		
SNMA190616-RK7	1,6	0,35-0,80	1,5-8,0																		

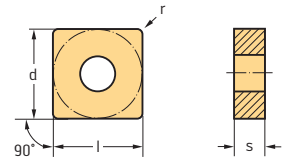
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide


/ ★ New addition to the product range

Negative square SNMG / SNMA / SNMM

Tiger-tec® Silver



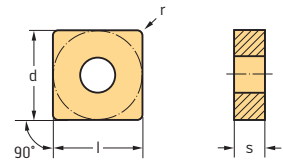
Indexable inserts

Designation	r mm	f mm	a _p mm	P						M			K			S			
				HC						HC			HC			HC			
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S
 SNMM120412-HU5	1,2	0,30-0,70	1,5-7,0			☉	☉	☉	☉		☉	☉					☉	☉	
SNMM150612-HU5	1,2	0,35-0,70	1,5-9,0			☉	☉	☉	☉		☉	☉					☉	☉	
SNMM190612-HU5	1,2	0,35-0,80	1,5-10,0		☉	☉	☉	☉	☉		☉	☉					☉	☉	
SNMM190616-HU5	1,6	0,40-1,00	2,0-10,0		☉	☉	☉	☉	☉		☉	☉					☉	☉	
SNMM190624-HU5	2,4	0,45-1,10	2,0-10,0		☉	☉	☉	☉	☉		☉	☉					☉	☉	
SNMM250924-HU5	2,4	0,50-1,20	2,5-12,0		☉	☉	☉	☉	☉		☉	☉					☉	☉	



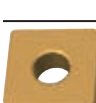


See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Negative square SNMG Perform / SNMA Perform



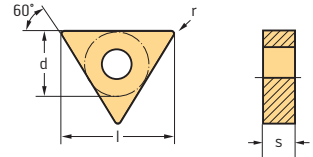
Indexable inserts

Designation	r mm	f mm	a _p mm	P						M			K				S			
				HC						HC			HC				HC			
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WKV10	WKV20	WSM10S
 SNMG120408-MV5	0,8	0,15-0,32	0,8-4,0																	
 SNMG120408-MV7	0,8	0,25-0,50	0,8-5,0													☉	☉			
 SNMG120412-MV7	1,2	0,30-0,50	1,2-5,0													☉	☉			
 SNMG150612-MV7	1,2	0,30-0,60	1,2-7,0													☉	☉			
 SNMA120412-RV7	1,2	0,30-0,60	1,2-5,0													☉	☉			

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Negative triangular 60° TNMG Tiger-tec® Silver

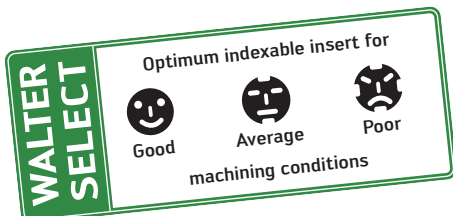


Indexable inserts

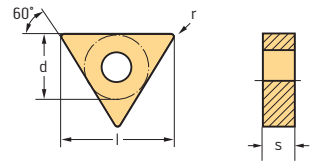
Designation	r mm	f mm	a _p mm	P					M				K			S				HW
				HC					HC				HC			HC				
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	
TNMG160404-FM5	0,4	0,05–0,15	0,2–1,0																	
TNMG160408-FM5	0,8	0,07–0,20	0,4–1,5																	
TNMG160412-FM5	1,2	0,10–0,25	0,5–2,0																	
TNMG160304-MS3	0,4	0,12–0,25	0,6–3,0																	
TNMG160308-MS3	0,8	0,15–0,30	0,8–3,0																	
TNMG160404-MS3	0,4	0,12–0,25	0,6–3,0																	
TNMG160408-MS3	0,8	0,15–0,30	0,8–3,0																	
TNMG220404-MS3	0,4	0,12–0,25	0,6–3,0																	
TNMG220408-MS3	0,8	0,15–0,30	0,8–3,0																	
TNMG160404-NMT	0,4	0,08–0,20	0,6–3,0																	
TNMG160408-NMT	0,8	0,12–0,30	1,0–4,0																	
TNMG160404-NMS	0,4	0,09–0,22	0,6–2,5																	
TNMG160408-NMS	0,8	0,11–0,30	0,8–3,5																	
TNMG160404-MM5	0,4	0,10–0,18	0,5–2,0																	
TNMG160408-MM5	0,8	0,15–0,25	0,8–3,0																	
TNMG160412-MM5	1,2	0,18–0,30	0,8–3,5																	
TNMG160416-MM5	1,6	0,20–0,35	1,0–4,0																	
TNMG160408-MU5	0,8	0,18–0,35	0,6–4,0																	
TNMG160412-MU5	1,2	0,20–0,45	1,0–4,0																	
TNMG160412-NRS	1,2	0,25–0,50	1,5–4,5																	
TNMG160408-RM5	0,8	0,20–0,40	1,2–4,0																	
TNMG160412-RM5	1,2	0,25–0,50	1,5–4,0																	
TNMG220408-RM5	0,8	0,20–0,40	1,2–4,0																	
TNMG220412-RM5	1,2	0,25–0,55	1,5–5,0																	

See the ISO 1832 designation key for dimensions





HC = Coated carbide
HW = Uncoated carbide



Negative triangular 60° TNMG Perform



Indexable inserts


Designation	r mm	f mm	a _p mm	P						M			K				S						
				HC						HC			HC				HC						
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WKV10	WKV20	WSM10S	WSM20S	WSM30S	
 TNMG160404-FV5 TNMG160408-FV5	0,4	0,05-0,20	0,2-1,5						☺	☹													
	0,8	0,08-0,25	0,4-2,0							☺	☹												
 TNMG160404-MV5 TNMG160408-MV5	0,4	0,10-0,20	0,5-3,5						☺	☹													
	0,8	0,15-0,32	0,8-3,5							☺	☹												
 TNMG160408-MV7 TNMG160412-MV7	0,8	0,20-0,45	0,8-5,0															☺	☹				
	1,2	0,25-0,45	1,2-5,0																☺	☹			
 TNMG160408-RV5	0,8	0,15-0,40	1,0-4,5						☺	☹													


See the ISO 1832 designation key for dimensions


HC = Coated carbide

WALTER SELECT

Optimum indexable insert for

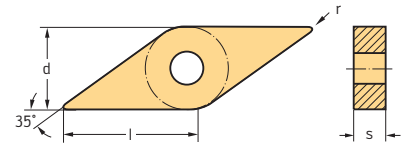

Good


Average


Poor

machining conditions

Negative rhombic 35° VNMG / VNGG Tiger-tec® Silver



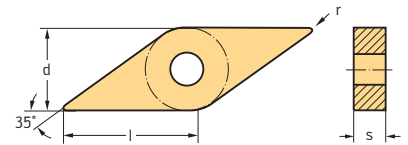
Indexable inserts

Designation	r mm	f mm	a _p mm	P					M				K			S			
				HC					HC				HC			HC			
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S
VNMG160404-NFT	0,4	0,05–0,15	0,2–1,5																
VNMG160408-NFT	0,8	0,07–0,18	0,3–2,0																
VNMG160402-FM5	0,2	0,03–0,10	0,1–1,0																
VNMG160404-FM5	0,4	0,05–0,15	0,2–1,0																
VNMG160408-FM5	0,8	0,07–0,20	0,4–1,5																
VNMG160404-FP5	0,4	0,04–0,22	0,1–1,5																
VNMG160408-FP5	0,8	0,08–0,25	0,2–2,0																
VNMG160412-FP5	1,2	0,12–0,28	0,3–2,5																
VNMG160404-MS3	0,4	0,10–0,20	0,6–2,5																
VNMG160408-MS3	0,8	0,12–0,25	0,8–2,5																
VNGG160401-MS3	0,1	0,02–0,06	0,2–2,0																
VNGG160402-MS3	0,2	0,05–0,12	0,4–2,0																
VNGG160404-MS3	0,4	0,10–0,20	0,6–2,0																
VNMG160404-NMS	0,4	0,08–0,16	0,5–1,5																
VNMG160408-NMS	0,8	0,10–0,22	0,8–2,2																
VNMG160404-MM5	0,4	0,10–0,18	0,5–2,0																
VNMG160408-MM5	0,8	0,15–0,25	0,8–3,0																

See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Negative rhombic 35° VNMG Perform



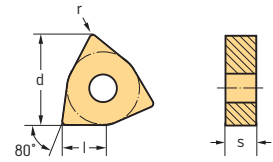
Indexable inserts

Designation	r mm	f mm	a _p mm	P					M				K			S			
				HC					HC				HC			HC			
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM10S	WSM20S
VNMG160404-FV5	0,4	0,05–0,20	0,2–1,5																
VNMG160408-FV5	0,8	0,08–0,25	0,4–2,0																

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Negative Trigon 80° WNMG / WNMA Tiger-tec® Silver

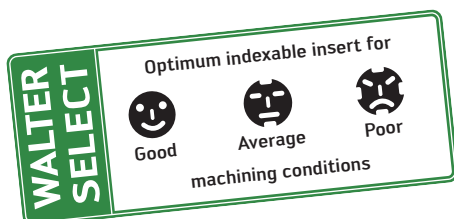


Indexable inserts

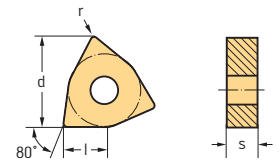
Designation	r mm	f mm	a _p mm	P						M				K			S				HW
				HC						HC				HC			HC				
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	
WNMG060404-NF	0,4	0,10–0,40	0,4–2,0	☺		☺						☺							☺		
WNMG060408-NF	0,8	0,15–0,50	0,5–3,0	☺		☺						☺							☺		
WNMG080404-NF	0,4	0,20–0,40	0,4–2,0	☺		☺						☺							☺		
WNMG080408-NF	0,8	0,25–0,55	0,5–3,0	☺		☺						☺							☺		
WNMG080412-NF	1,2	0,25–0,70	0,8–3,0			☺															
WNMG060404-FM5	0,4	0,05–0,15	0,2–1,0							☺	☺								☺	☺	
WNMG060408-FM5	0,8	0,07–0,20	0,4–1,5							☺	☺								☺	☺	
WNMG080404-FM5	0,4	0,05–0,15	0,2–1,5							☺	☺								☺	☺	
WNMG080408-FM5	0,8	0,07–0,20	0,4–1,5							☺	☺								☺	☺	
WNMG080412-FM5	1,2	0,10–0,25	0,5–2,0							☺	☺								☺	☺	
WNMG060408-NM	0,8	0,20–0,55	0,8–3,0			☺						☺									
WNMG060412-NM	1,2	0,25–0,55	1,5–4,0			☺															
WNMG080408-NM	0,8	0,20–0,55	0,8–3,0			☺	☺					☺	☺						☺		
WNMG080412-NM	1,2	0,25–0,70	1,5–4,0			☺	☺					☺	☺						☺		
WNMG080404-MS3	0,4	0,12–0,25	0,6–3,0							☺	☺								☺	☺	☺
WNMG080408-MS3	0,8	0,15–0,30	0,8–3,0							☺	☺								☺	☺	☺
WNMG080408-NMT	0,8	0,12–0,30	0,8–4,0									☺								☺	☺
WNMG060408-NMS	0,8	0,10–0,30	0,8–3,0							☺	☺								☺	☺	☺
WNMG080404-NMS	0,4	0,10–0,24	0,6–2,5							☺	☺	☺	☺						☺	☺	☺
WNMG080408-NMS	0,8	0,13–0,32	0,8–3,5							☺	☺	☺	☺						☺	☺	☺
WNMG060404-MM5	0,4	0,10–0,18	0,5–2,0									☺	☺						☺	☺	☺
WNMG060408-MM5	0,8	0,15–0,25	0,8–2,5									☺	☺						☺	☺	☺
WNMG060412-MM5	1,2	0,18–0,30	0,8–3,0									☺	☺						☺	☺	☺
WNMG080404-MM5	0,4	0,10–0,20	0,5–3,0									☺	☺						☺	☺	☺
WNMG080408-MM5	0,8	0,15–0,32	0,8–3,0									☺	☺						☺	☺	☺
WNMG080412-MM5	1,2	0,15–0,35	0,8–3,5									☺	☺						☺	☺	☺
WNMG080416-MM5	1,6	0,15–0,40	1,0–4,0									☺	☺						☺	☺	☺
WNMG100608-MM5	0,8	0,18–0,40	0,8–4,5									☺	☺						☺	☺	☺
WNMG100612-MM5	1,2	0,20–0,45	0,8–4,5									☺	☺						☺	☺	☺

See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide



Negative Trigon 80° WNMG / WNMA Tiger-tec® Silver



Indexable inserts

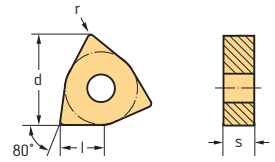
Designation	r mm	f mm	a _p mm	P						M				K			S				HW
				HC						HC				HC			HC				
				WPP01	WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WSM01	WSM10S	WSM20S	
WNMG080408-MU5	0,8	0,15-0,40	0,6-5,0																		
	WNMG080412-MU5	1,2	0,20-0,50	1,0-5,0																	
	WNMG060404-MK5	0,4	0,16-0,25	0,6-4,0																	
	WNMG060408-MK5	0,8	0,20-0,40	0,8-4,0																	
	WNMG060412-MK5	1,2	0,16-0,45	0,6-4,0																	
	WNMG080404-MK5	0,4	0,16-0,25	0,6-5,0																	
	WNMG080408-MK5	0,8	0,20-0,45	1,2-5,0																	
	WNMG080412-MK5	1,2	0,22-0,50	1,5-5,0																	
	WNMG080416-MK5	1,6	0,25-0,55	2,0-5,0																	
	WNMG100608-MK5	0,8	0,25-0,50	0,8-7,0																	
	WNMG100612-MK5	1,2	0,30-0,60	1,2-7,0																	
WNMG100616-MK5	1,6	0,35-0,60	1,5-7,0																		
	WNMG080408-NRS	0,8	0,16-0,35	1,0-4,0																	
	WNMG080412-NRS	1,2	0,18-0,40	1,2-4,0																	
	WNMG060408-RM5	0,8	0,20-0,40	1,2-3,5																	
	WNMG080408-RM5	0,8	0,20-0,40	1,2-4,5																	
	WNMG080412-RM5	1,2	0,25-0,50	1,5-4,5																	
	WNMG080408-RP7	0,8	0,16-0,45	1,0-5,0																	
	WNMG080412-RP7	1,2	0,20-0,45	1,5-5,0																	
	WNMG100608-RP7	0,8	0,30-0,50	0,8-6,0																	
	WNMG100612-RP7	1,2	0,35-0,60	1,2-6,0																	
	WNMG100616-RP7	1,6	0,40-0,60	1,5-6,0																	
	WNMA080408-RK7	0,8	0,20-0,45	1,2-5,0																	
	WNMA080412-RK7	1,2	0,22-0,50	1,5-5,0																	

See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

/ ★ New addition to the product range

Negative Trigon 80° WNMG Perform / WNMA Perform



Indexable inserts

Designation	r mm	f mm	a _p mm	P						M			K				S									
				HC						HC			HC				HC									
				WPP05S	WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WKP30S	WKV10	WKV20	WSM10S	WSM20S	WSM30S				
WNMG080408-FV5	0,8	0,08-0,25	0,4-2,0																							
WNMG060408-MV5	0,8	0,15-0,32	0,8-3,0																							
WNMG080404-MV5	0,4	0,10-0,20	0,5-3,5																							
WNMG080408-MV5	0,8	0,15-0,32	0,8-4,0																							
WNMG080412-MV5	1,2	0,18-0,40	0,8-4,0																							
WNMG080408-MV7	0,8	0,20-0,45	1,2-5,0																							
WNMG080412-MV7	1,2	0,25-0,50	1,5-5,0																							
WNMG080408-RV5	0,8	0,20-0,40	1,0-5,0																							
WNMG080412-RV5	1,2	0,25-0,55	1,0-5,0																							
WNMA080408-RV7	0,8	0,20-0,45	1,2-5,0																							
WNMA080412-RV7	1,2	0,25-0,50	1,5-5,0																							

See the ISO 1832 designation key for dimensions

HC = Coated carbide

WALTER SELECT

Optimum indexable insert for

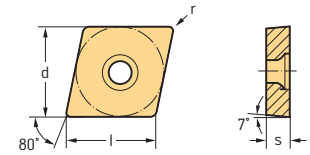
Good

Average

Poor

machining conditions

Positive rhombic 80°
CCMT / CCGT
Tiger-tec® Silver



Indexable inserts

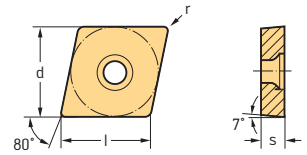
Designation	l mm	r mm	f mm	a _p mm	P					M				K		N	S			
					HE					HC				HC		HC	HC			
					WEP10C	WPP01	WPP10S	WPP20S	WPP30S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S
CCMT060204-PF	6,45	0,4	0,05-0,30	0,3-2,0		☺	☺	☺					☺	☺					☺	☺
CCMT060208-PF	6,45	0,8	0,09-0,35	0,3-2,0			☺	☺					☺						☺	☺
CCMT09T304-PF	9,67	0,4	0,07-0,30	0,3-3,0		☺	☺	☺					☺	☺					☺	☺
CCMT09T308-PF	9,67	0,8	0,12-0,45	0,3-3,0			☺	☺					☺	☺					☺	☺
CCGT060201-FN2	6,45	0,1	0,02-0,06	0,1-1,5													☺			
CCGT060202-FN2	6,45	0,2	0,05-0,12	0,2-2,0												☺				
CCGT060204-FN2	6,45	0,4	0,08-0,25	0,2-2,5												☺				
CCGT09T301-FN2	9,67	0,1	0,02-0,06	0,1-1,5												☺				
CCGT09T302-FN2	9,67	0,2	0,05-0,12	0,2-2,0												☺				
CCGT09T304-FN2	9,67	0,4	0,08-0,25	0,2-2,5												☺				
CCGT09T308-FN2	9,67	0,8	0,10-0,30	0,3-3,0												☺				
CCGT120404-FN2	12,90	0,4	0,08-0,25	0,2-3,0												☺				
CCGT120408-FN2	12,90	0,8	0,10-0,30	0,3-3,5												☺				
CCGT060201-FM2	6,45	0,1	0,02-0,06	0,1-1,5																☺
CCGT060202-FM2	6,45	0,2	0,05-0,12	0,2-2,0							☺		☺					☺		☺
CCGT060204-FM2	6,45	0,4	0,08-0,25	0,2-2,5							☺		☺					☺		☺
CCGT09T301-FM2	9,67	0,1	0,02-0,06	0,1-1,5									☺							☺
CCGT09T302-FM2	9,67	0,2	0,05-0,12	0,2-2,0							☺		☺					☺		☺
CCGT09T304-FM2	9,67	0,4	0,08-0,25	0,2-2,5							☺	☺	☺					☺	☺	☺
CCGT09T308-FM2	9,67	0,8	0,10-0,30	0,3-3,0							☺	☺	☺					☺	☺	☺
CCGT120404-FM2	12,90	0,4	0,08-0,25	0,2-3,0									☺							☺
CCGT120408-FM2	12,90	0,8	0,10-0,30	0,3-3,5									☺							☺
CCMT060202-FP4	6,45	0,2	0,04-0,12	0,1-1,0	☺		☺	☺												
CCMT060204-FP4	6,45	0,4	0,05-0,16	0,1-1,5	☺		☺	☺												
CCMT060208-FP4	6,45	0,8	0,08-0,20	0,1-1,5			☺	☺												
CCMT09T302-FP4	9,67	0,2	0,04-0,12	0,1-1,0	☺		☺	☺												
CCMT09T304-FP4	9,67	0,4	0,05-0,16	0,1-1,5	☺		☺	☺												
CCMT09T308-FP4	9,67	0,8	0,08-0,20	0,1-1,5	☺		☺	☺												
CCMT120404-FP4	12,90	0,4	0,05-0,16	0,1-1,5			☺	☺												
CCMT120408-FP4	12,90	0,8	0,08-0,20	0,1-1,5			☺	☺												
CCMT060204-FM6	6,45	0,4	0,08-0,25	0,3-1,6									☺	☺					☺	☺
CCMT060208-FM6	6,45	0,8	0,12-0,30	0,5-1,6									☺	☺					☺	☺
CCMT09T304-FM6	9,67	0,4	0,08-0,25	0,3-2,0									☺	☺					☺	☺
CCMT09T308-FM6	9,67	0,8	0,12-0,32	0,5-2,0									☺	☺					☺	☺
CCMT120408-FM6	12,90	0,8	0,12-0,32	0,5-2,5									☺	☺					☺	☺

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 80° CCMT / CCGT

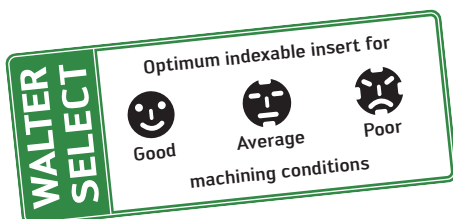
Tiger-tec® Silver



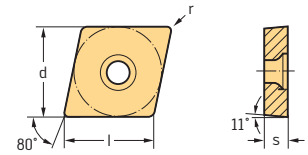
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P						M				K		N		S				
					HE	HC					HC				HC		HC		HC				
					WEP10C	WPP01	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S	
CCGT060201-MN2	6,45	0,1	0,02-0,06	0,5-1,5														☺					
CCGT060202-MN2	6,45	0,2	0,05-0,12	0,5-2,0								☺						☺	☺				
CCGT060204-MN2	6,45	0,4	0,08-0,25	0,6-3,0								☺						☺	☺				
CCGT09T301-MN2	9,67	0,1	0,02-0,06	0,5-1,5														☺					
CCGT09T302-MN2	9,67	0,2	0,05-0,12	0,5-2,0								☺						☺	☺				
CCGT09T304-MN2	9,67	0,4	0,08-0,25	0,6-4,0								☺						☺	☺				
CCGT09T308-MN2	9,67	0,8	0,10-0,35	0,8-4,0								☺						☺	☺				
CCGT120402-MN2	12,90	0,2	0,05-0,12	0,5-2,0														☺					
CCGT120404-MN2	12,90	0,4	0,08-0,25	0,6-5,0														☺					
CCGT120408-MN2	12,90	0,8	0,10-0,35	0,8-5,0														☺					
CCMT060204-MM4	6,45	0,4	0,08-0,20	0,4-2,0						☺	☺	☺	☺	☺	☺					☺	☺	☺	☺
CCMT060208-MM4	6,45	0,8	0,12-0,25	0,5-2,0						☺	☺	☺	☺	☺	☺						☺	☺	☺
CCMT09T304-MM4	9,67	0,4	0,08-0,25	0,4-3,0						☺	☺	☺	☺	☺	☺					☺	☺	☺	☺
CCMT09T308-MM4	9,67	0,8	0,12-0,32	0,5-3,0						☺	☺	☺	☺	☺	☺					☺	☺	☺	☺
CCMT120404-MM4	12,90	0,4	0,12-0,25	0,4-3,5						☺	☺	☺	☺	☺	☺						☺	☺	☺
CCMT120408-MM4	12,90	0,8	0,12-0,32	0,5-3,5						☺	☺	☺	☺	☺	☺						☺	☺	☺
CCGT060204-MM4	6,45	0,4	0,08-0,20	0,4-2,0								☺	☺	☺	☺					☺	☺	☺	☺
CCGT060208-MM4	6,45	0,8	0,12-0,25	0,5-2,0								☺	☺	☺	☺						☺	☺	☺
CCGT09T304-MM4	9,67	0,4	0,08-0,25	0,4-3,0								☺	☺	☺	☺					☺	☺	☺	☺
CCGT09T308-MM4	9,67	0,8	0,12-0,32	0,5-3,0								☺	☺	☺	☺					☺	☺	☺	☺
CCGT120408-MM4	12,90	0,8	0,12-0,32	0,5-3,5									☺	☺	☺						☺	☺	☺

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

**Positive rhombic 80°
CPMT / CPGT / CPMW**
Tiger-tec® Silver



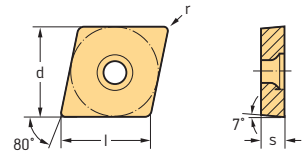
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P				M				K		S			
					HC				HC				HC		HC			
					WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM01	WSM10S	WSM20S
	CPMT050204-FM4	5,64	0,4	0,05-0,16	0,1-1,5													
	CPMT060204-FM4	6,45	0,4	0,05-0,16	0,1-1,5													
	CPMT09T304-FM4	9,67	0,4	0,05-0,16	0,1-1,5													
	CPMT09T308-FM4	9,67	0,8	0,08-0,20	0,1-1,5													
	CPMT050204-FP4	5,64	0,4	0,05-0,16	0,1-1,5	☺												
	CPMT060204-FP4	6,45	0,4	0,05-0,16	0,1-1,5	☺												
	CPMT09T304-FP4	9,67	0,4	0,05-0,16	0,1-1,5	☺												
	CPMT09T308-FP4	9,67	0,8	0,08-0,20	0,1-1,5	☺												
	CPMT04T104-MM4	4,84	0,4	0,06-0,16	0,3-1,5													
	CPMT060204-MM4	6,45	0,4	0,08-0,20	0,4-2,0													
	CPMT060208-MM4	6,45	0,8	0,12-0,25	0,5-2,0													
	CPMT09T304-MM4	9,67	0,4	0,08-0,25	0,4-3,0													
	CPMT09T308-MM4	9,67	0,8	0,12-0,32	0,5-3,0													
	CPGT050204-MM4	5,64	0,4	0,08-0,20	0,4-1,5													
	CPGT060201-MM4	6,45	0,1	0,04-0,12	0,1-2,0													
	CPGT060202-MM4	6,45	0,2	0,06-0,16	0,2-2,0													
	CPGT060204-MM4	6,45	0,4	0,08-0,20	0,4-2,0													
	CPGT060208-MM4	6,45	0,8	0,12-0,25	0,5-2,0													
	CPGT09T301-MM4	9,67	0,1	0,06-0,20	0,1-3,0													
	CPGT09T304-MM4	9,67	0,4	0,08-0,25	0,4-3,0													
	CPGT09T308-MM4	9,67	0,8	0,12-0,32	0,5-3,0													
	CPMT04T104-MP4	4,84	0,4	0,06-0,16	0,3-1,5													
	CPMT060204-MP4	6,45	0,4	0,08-0,20	0,4-2,0													
	CPMT060208-MP4	6,45	0,8	0,12-0,25	0,5-2,0													
	CPMT09T304-MP4	9,67	0,4	0,08-0,25	0,4-3,0													
	CPMT09T308-MP4	9,67	0,8	0,12-0,32	0,5-3,0													
	CPMW050204-RK6	5,64	0,4	0,12-0,25	0,4-2,5													
	CPMW060204-RK6	6,45	0,4	0,12-0,25	0,4-2,5													
	CPMW09T304-RK6	9,67	0,4	0,12-0,25	0,4-3,0													
	CPMW09T308-RK6	9,67	0,8	0,16-0,35	0,5-4,0													



See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive rhombic 80°
CCMT Perform

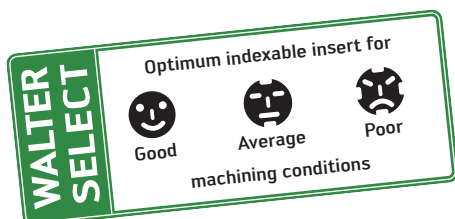


Indexable inserts

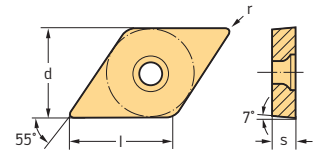
Designation	l mm	r mm	f mm	a _p mm	P						M			K		S		
					HC						HC			HC		HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM10S	WSM20S
 CCMT060204-FV4 CCMT09T304-FV4 CCMT09T308-FV4	6,45	0,4	0,05–0,16	0,1–1,5														
	9,67	0,4	0,05–0,16	0,1–1,5														
	9,67	0,8	0,08–0,20	0,1–1,5														
 CCMT060204-MV4 CCMT09T304-MV4 CCMT09T308-MV4 CCMT120408-MV4	6,45	0,4	0,10–0,25	0,4–2,5														
	9,67	0,4	0,10–0,25	0,4–3,0														
	9,67	0,8	0,15–0,32	0,6–3,0														
	12,90	0,8	0,15–0,35	0,6–3,5														

See the ISO 1832 designation key for dimensions

HC = Coated carbide



Positive rhombic 55°
DCMT / DCGT
Tiger-tec® Silver



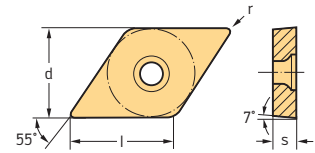
Indexable inserts

Designation	l mm	r mm	f mm	ap mm	P					M				K		N		S						
					HE	HC				HC				HC		HC		HC						
					WEP10C	WPP01	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S		
DCMT070204-PF	7,75	0,4	0,05-0,25	0,3-2,0			☺	☺						☺	☺							☺	☺	
	DCMT070208-PF	7,75	0,8	0,05-0,25	0,3-2,0			☺	☺					☺	☺								☺	☺
	DCMT11T304-PF	11,63	0,4	0,07-0,30	0,3-3,0		☺	☺	☺					☺	☺								☺	☺
	DCMT11T308-PF	11,63	0,8	0,12-0,40	0,3-3,0		☺	☺	☺					☺	☺								☺	☺
DCGT070201-FN2	7,75	0,1	0,02-0,06	0,1-1,5															☺					
	DCGT070202-FN2	7,75	0,2	0,05-0,12	0,2-2,0														☺					
	DCGT070204-FN2	7,75	0,4	0,08-0,25	0,2-2,5														☺					
	DCGT11T301-FN2	11,63	0,1	0,02-0,06	0,1-1,5														☺					
	DCGT11T302-FN2	11,63	0,2	0,05-0,12	0,2-2,0														☺					
	DCGT11T304-FN2	11,63	0,4	0,08-0,25	0,2-2,5														☺					
	DCGT11T308-FN2	11,63	0,8	0,10-0,30	0,3-3,0														☺					
DCGT070201-FM2	7,75	0,1	0,02-0,06	0,1-1,5										☺									☺	
	DCGT070202-FM2	7,75	0,2	0,05-0,12	0,2-2,0							☺	☺	☺					☺	☺	☺		☺	
	DCGT070204-FM2	7,75	0,4	0,08-0,25	0,2-2,5							☺	☺	☺					☺	☺	☺		☺	
	DCGT11T301-FM2	11,63	0,1	0,02-0,06	0,1-1,5										☺								☺	
	DCGT11T302-FM2	11,63	0,2	0,05-0,12	0,2-2,0							☺	☺	☺					☺	☺	☺		☺	
	DCGT11T304-FM2	11,63	0,4	0,08-0,25	0,2-2,5							☺	☺	☺					☺	☺	☺		☺	
	DCGT11T308-FM2	11,63	0,8	0,10-0,30	0,3-3,0							☺	☺	☺					☺	☺	☺		☺	
DCMT070202-FP4	7,75	0,2	0,04-0,12	0,1-1,0	☺		☺	☺																
	DCMT070204-FP4	7,75	0,4	0,05-0,16	0,1-1,5	☺		☺	☺															
	DCMT070208-FP4	7,75	0,8	0,08-0,20	0,1-1,5			☺	☺															
	DCMT11T302-FP4	11,63	0,2	0,04-0,12	0,1-1,0	☺		☺	☺															
	DCMT11T304-FP4	11,63	0,4	0,05-0,16	0,1-1,5	☺		☺	☺															
	DCMT11T308-FP4	11,63	0,8	0,08-0,20	0,1-1,5	☺		☺	☺															
DCMT070204-FM6	7,75	0,4	0,08-0,25	0,3-1,6										☺	☺							☺	☺	
	DCMT11T304-FM6	11,63	0,4	0,08-0,25	0,3-2,0									☺	☺							☺	☺	
	DCMT11T308-FM6	11,63	0,8	0,12-0,32	0,6-2,0									☺	☺							☺	☺	
DCMT11T304-PM	11,63	0,4	0,12-0,40	0,5-4,0			☺	☺						☺	☺							☺		
	DCMT11T308-PM	11,63	0,8	0,15-0,50	0,5-4,0			☺	☺					☺	☺							☺		
DCGT070201-MN2	7,75	0,1	0,02-0,06	0,5-1,5															☺					
	DCGT070202-MN2	7,75	0,2	0,05-0,12	0,5-2,0									☺					☺	☺				
	DCGT070204-MN2	7,75	0,4	0,08-0,25	0,6-2,5									☺					☺	☺				
	DCGT11T301-MN2	11,63	0,1	0,02-0,06	0,5-1,5														☺					
	DCGT11T302-MN2	11,63	0,2	0,05-0,12	0,5-2,0									☺					☺	☺				
	DCGT11T304-MN2	11,63	0,4	0,08-0,25	0,6-3,0									☺					☺	☺				
	DCGT11T308-MN2	11,63	0,8	0,10-0,30	0,8-3,5									☺					☺	☺				

See the ISO 1832 designation key for dimensions

HE = Coated cermet
 HC = Coated carbide

Positive rhombic 55° DCMT / DCGT Tiger-tec® Silver



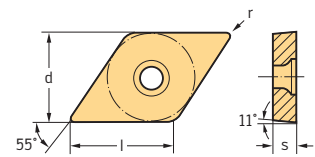
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P		M				K		N		S								
					HE	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC								
					WEP10C	WPP01	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S	
DCMT070204-MM4	7,75	0,4	0,08–0,20	0,4–2,0						☒	☒	☒	☒	☒						☒	☒	☒	
DCMT070208-MM4	7,75	0,8	0,12–0,25	0,5–2,0						☒	☒	☒	☒							☒	☒	☒	
DCMT11T302-MM4	11,63	0,2	0,04–0,12	0,2–2,0								☒	☒	☒							☒	☒	☒
DCMT11T304-MM4	11,63	0,4	0,08–0,25	0,4–3,0						☒	☒	☒	☒	☒						☒	☒	☒	☒
DCMT11T308-MM4	11,63	0,8	0,12–0,32	0,5–3,0						☒	☒	☒	☒	☒						☒	☒	☒	☒
DCMT11T312-MM4	11,63	1,2	0,15–0,35	0,5–3,0								☒	☒								☒	☒	
DCGT070204-MM4	7,75	0,4	0,08–0,20	0,4–2,0								☒	☒							☒	☒		
DCGT11T302-MM4	11,63	0,2	0,04–0,12	0,2–2,0								☒	☒								☒	☒	
DCGT11T304-MM4	11,63	0,4	0,08–0,25	0,4–3,0								☒	☒	☒						☒	☒	☒	☒
DCGT11T308-MM4	11,63	0,8	0,12–0,32	0,5–3,0								☒	☒	☒						☒	☒	☒	☒

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 55° DPMT / DPGT / DPMW Tiger-tec® Silver



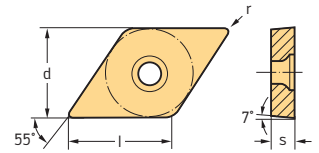
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P				M				K		S							
					HC	HC	HC	HC	HC	HC	HC	HC	HC	HC								
					WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM01	WSM10S	WSM20S	WSM30S			
DPMT070204-FM4	7,75	0,4	0,05–0,16	0,1–1,5				☒	☒											☒		
DPMT11T304-FM4	11,63	0,4	0,05–0,16	0,1–1,5				☒	☒												☒	
DPMT11T308-FM4	11,63	0,8	0,08–0,20	0,1–1,5				☒	☒												☒	
DPMT070204-FP4	7,75	0,4	0,05–0,16	0,1–1,5	☒																	
DPMT11T304-FP4	11,63	0,4	0,05–0,16	0,1–1,5	☒																	
DPMT11T308-FP4	11,63	0,8	0,08–0,20	0,1–1,5	☒																	
DPGT070204-MM4	7,75	0,4	0,08–0,20	0,4–2,0						☒	☒									☒	☒	
DPGT11T304-MM4	11,63	0,4	0,08–0,25	0,4–3,0						☒	☒									☒	☒	
DPGT11T308-MM4	11,63	0,8	0,12–0,32	0,5–3,0						☒	☒									☒	☒	
DPMW11T308-RK6	11,63	0,8	0,16–0,35	0,5–4,0											☒							



See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive rhombic 55° DCMT Perform



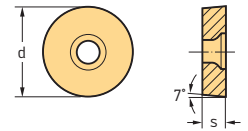
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P						M			K		S		
					HC						HC			HC		HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM10S	WSM20S
 DCMT070204-FV4	7,75	0,4	0,05–0,16	0,1–1,5														
DCMT11T302-FV4	11,63	0,2	0,04–0,12	0,1–1,0														
DCMT11T304-FV4	11,63	0,4	0,05–0,16	0,1–1,5														
DCMT11T308-FV4	11,63	0,8	0,08–0,20	0,1–1,5														
 DCMT11T304-MV4	11,63	0,4	0,10–0,25	0,4–3,0														
DCMT11T308-MV4	11,63	0,8	0,15–0,32	0,6–3,0														


See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive round RCGT

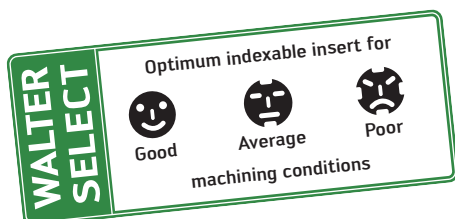


Indexable inserts

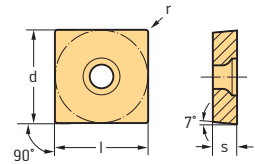
Designation	d mm	f mm	a _p mm	P				M			K		N	S			
				HC				HC			HC		HC	HC			
				WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM10S	WSM20S	WSM30S
 RCGT0602M0-MN2	6	0,10–0,55	0,6–2,5														
RCGT0803M0-MN2	8	0,12–0,60	0,7–3,0														
RCGT10T3M0-MN2	10	0,15–0,70	0,8–4,0														
RCGT1204M0-MN2	12	0,18–0,80	1,0–5,0														
RCGT120400-MN2	12,7	0,18–0,80	1,0–5,0														

See the ISO 1832 designation key for dimensions

HC = Coated carbide



Positive square
SCGT / SCMT
Tiger-tec® Silver

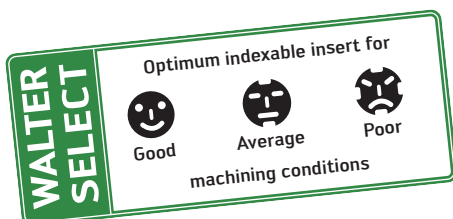


Indexable inserts

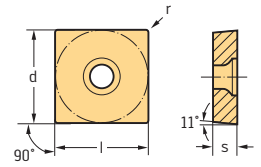
Designation	l mm	r mm	f mm	a _p mm	HE		P				M				K		N		S				
							HC						HC		HC								
					WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S		
	SCGT09T304-FN2	9,53	0,4	0,08-0,25	0,2-2,5																		
	SCGT09T308-FN2	9,53	0,8	0,10-0,30	0,3-3,0																		
	SCGT120408-FN2	12,7	0,8	0,10-0,30	0,3-3,0																		
	SCGT09T304-FM2	9,53	0,4	0,08-0,25	0,2-2,5																		
	SCGT09T308-FM2	9,53	0,8	0,10-0,30	0,3-3,0																		
	SCGT120408-FM2	12,7	0,8	0,10-0,30	0,3-3,0																		
	SCMT060204-FM4	6,35	0,4	0,05-0,16	0,1-1,5																		
	SCMT09T304-FM4	9,53	0,4	0,05-0,15	0,1-1,5																		
	SCMT09T308-FM4	9,53	0,8	0,05-0,18	0,1-1,8																		
	SCMT120404-FM4	12,7	0,4	0,05-0,15	0,1-1,5																		
	SCMT120408-FM4	12,7	0,8	0,05-0,18	0,1-1,8																		
	SCMT060204-FP4	6,35	0,4	0,05-0,16	0,1-1,5																		
	SCMT09T304-FP4	9,53	0,4	0,05-0,15	0,1-1,5																		
	SCMT09T308-FP4	9,53	0,8	0,05-0,18	0,1-1,8																		
	SCMT120404-FP4	12,7	0,4	0,05-0,15	0,1-1,5																		
	SCMT120408-FP4	12,7	0,8	0,05-0,18	0,1-1,8																		
	SCMT120412-FP4	12,7	1,2	0,12-0,32	0,3-1,8																		
	SCMT09T304-FM6	9,53	0,4	0,08-0,25	0,3-2,0																		
	SCMT09T308-FM6	9,53	0,8	0,12-0,30	0,5-2,0																		
	SCMT120408-FM6	12,7	0,8	0,12-0,32	0,5-2,5																		
	SCGT09T304-MN2	9,53	0,4	0,08-0,25	0,6-4,0																		
	SCGT09T308-MN2	9,53	0,8	0,10-0,35	0,7-4,0																		
	SCGT120408-MN2	12,7	0,8	0,10-0,40	0,8-6,0																		
	SCMT09T304-MM4	9,53	0,4	0,08-0,25	0,4-3,0																		
	SCMT09T308-MM4	9,53	0,8	0,12-0,32	0,5-3,0																		
	SCMT120408-MM4	12,7	0,8	0,12-0,32	0,5-3,5																		
	SCGT09T304-MM4	9,53	0,4	0,08-0,25	0,4-3,0																		
	SCGT09T308-MM4	9,53	0,8	0,12-0,32	0,5-3,0																		
	SCGT120408-MM4	12,7	0,8	0,12-0,32	0,5-3,5																		

See the ISO 1832 designation key for dimensions









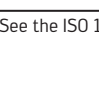




HE = Coated cermet
HC = Coated carbide



**Positive square
SPMT / SPGT / SPMW
Tiger-tec® Silver**



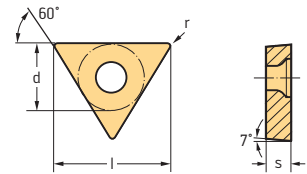
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P				M				K		S		
					HC				HC				HC		HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM01	WSM10S
 SPMT120408-FP4	12,7	0,8	0,05-0,18	0,1-1,8	☺												
 SPMT09T304-MM4	9,53	0,4	0,08-0,25	0,4-3,0													☺
 SPMT09T308-MM4	9,53	0,8	0,12-0,32	0,5-3,0													☺
 SPGT09T304-MM4	9,53	0,4	0,08-0,25	0,4-3,0													☺
 SPGT09T308-MM4	9,53	0,8	0,12-0,32	0,5-3,0													☺
 SPMT09T304-MP4	9,53	0,4	0,08-0,25	0,4-3,0		☺											
 SPMT09T308-MP4	9,53	0,8	0,12-0,32	0,5-3,0		☺											
 SPGT09T304-MP4	9,53	0,4	0,08-0,25	0,4-3,0		☺											
 SPGT09T308-MP4	9,53	0,8	0,12-0,32	0,5-3,0		☺											
 SPMT09T304-MK4	9,53	0,4	0,08-0,25	0,4-3,0													☺
 SPMT09T308-MK4	9,53	0,8	0,12-0,32	0,5-3,0													☺
 SPGT09T304-MK4	9,53	0,4	0,08-0,25	0,4-3,0													☺
 SPGT09T308-MK4	9,53	0,8	0,12-0,32	0,5-3,0													☺
SPMW09T304-RK6	9,53	0,4	0,12-0,25	0,4-3,0													☺
SPMW09T308-RK6	9,53	0,8	0,16-0,35	0,6-4,0													☺
SPMW120408-RK6	12,7	0,8	0,16-0,40	0,6-5,0													☺

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive triangular 60°
TCGT / TCMT
Tiger-tec® Silver

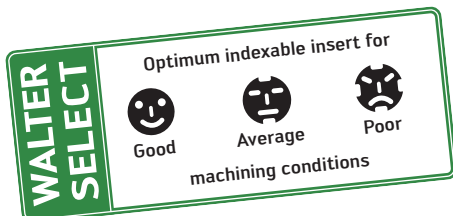


Indexable inserts

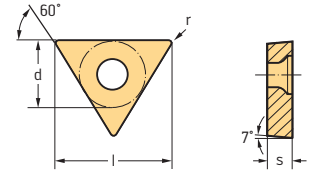
Designation	l mm	r mm	f mm	ap mm	P					M					K		N	S						
					HE	HC				HC					HC	HC	HC							
					WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S		
	TCGT06T101-FN2	6,87	0,1	0,02-0,06	0,1-1,5													☺						
	TCGT06T102-FN2	6,87	0,2	0,05-0,12	0,2-2,0													☺						
	TCGT06T104-FN2	6,87	0,4	0,08-0,25	0,2-2,5													☺						
	TCGT090202-FN2	9,62	0,2	0,05-0,12	0,2-2,0													☺						
	TCGT090204-FN2	9,62	0,4	0,08-0,25	0,2-2,5													☺						
	TCGT110202-FN2	11,00	0,2	0,05-0,12	0,2-2,0													☺						
	TCGT110204-FN2	11,00	0,4	0,08-0,25	0,2-2,5													☺						
	TCGT16T304-FN2	16,50	0,4	0,08-0,25	0,2-2,5													☺						
	TCGT16T308-FN2	16,50	0,8	0,10-0,30	0,3-3,0													☺						
	TCGT06T101-FM2	6,87	0,1	0,02-0,06	0,1-1,5									☹										
	TCGT06T102-FM2	6,87	0,2	0,05-0,12	0,2-2,0									☹										
	TCGT06T104-FM2	6,87	0,4	0,08-0,25	0,2-2,5						☺			☹					☺					
	TCGT090202-FM2	9,62	0,2	0,05-0,12	0,2-2,0									☹									☹	
	TCGT090204-FM2	9,62	0,4	0,08-0,25	0,2-2,5									☹									☹	
	TCGT110201-FM2	11,00	0,1	0,02-0,06	0,1-1,5									☹									☹	
	TCGT110202-FM2	11,00	0,2	0,05-0,12	0,2-2,0						☺			☹					☺				☹	
	TCGT110204-FM2	11,00	0,4	0,08-0,25	0,2-2,5						☺			☹					☺				☹	
	TCGT16T302-FM2	16,50	0,2	0,05-0,12	0,2-2,0									☹									☹	
	TCGT16T304-FM2	16,50	0,4	0,08-0,25	0,2-2,5						☺			☹					☺				☹	
TCGT16T308-FM2	16,50	0,8	0,10-0,30	0,3-3,0						☺			☹					☺				☹		
	TCMT06T102-FM4	6,87	0,2	0,02-0,10	0,1-1,0									☹										
	TCMT06T104-FM4	6,87	0,4	0,04-0,17	0,1-1,0									☹										
	TCMT090202-FM4	9,62	0,2	0,04-0,12	0,1-1,0									☺	☹						☺	☹	☹	
	TCMT090204-FM4	9,62	0,4	0,05-0,16	0,1-1,5									☺	☹						☺	☹	☹	
	TCMT090208-FM4	9,62	0,8	0,08-0,20	0,1-1,5									☺	☹						☺	☹	☹	
	TCMT110202-FM4	11,00	0,2	0,04-0,12	0,1-1,0									☺	☹						☺	☹	☹	
	TCMT110204-FM4	11,00	0,4	0,05-0,16	0,1-1,5									☺	☹						☺	☹	☹	
	TCMT110208-FM4	11,00	0,8	0,08-0,20	0,1-1,5									☺	☹						☺	☹	☹	
	TCMT16T302-FM4	16,50	0,2	0,04-0,12	0,1-1,0									☺	☹						☺	☹	☹	
	TCMT16T304-FM4	16,50	0,4	0,05-0,16	0,1-1,5									☺	☹						☺	☹	☹	
TCMT16T308-FM4	16,50	0,8	0,08-0,20	0,1-1,5									☺	☹						☺	☹	☹		

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide



Positive triangular 60°
TCGT / TCMT
Tiger-tec® Silver



Indexable inserts

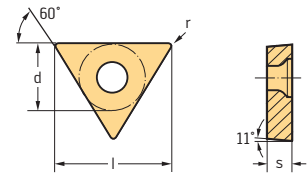
Designation	l mm	r mm	f mm	a _p mm	P					M					K		N		S					
					HE		HC			HC					HC		HC		HC					
					WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S		
TCMT06T102-FP4	6,87	0,2	0,02-0,10	0,1-1,0																				
TCMT06T104-FP4	6,87	0,4	0,04-0,17	0,1-1,0	☺		☺																	
TCMT090202-FP4	9,62	0,2	0,04-0,12	0,1-1,0				☺																
TCMT090204-FP4	9,62	0,4	0,05-0,16	0,1-1,5	☺	☺	☺																	
TCMT090208-FP4	9,62	0,8	0,08-0,20	0,1-1,5				☺																
TCMT110202-FP4	11,00	0,2	0,04-0,12	0,1-1,0				☺																
TCMT110204-FP4	11,00	0,4	0,05-0,16	0,1-1,5	☺	☺	☺																	
TCMT110208-FP4	11,00	0,8	0,08-0,20	0,1-1,5				☺																
TCMT16T302-FP4	16,50	0,2	0,04-0,12	0,1-1,0				☺																
TCMT16T304-FP4	16,50	0,4	0,05-0,16	0,1-1,5	☺	☺	☺																	
TCMT16T308-FP4	16,50	0,8	0,08-0,20	0,1-1,5	☺	☺	☺																	
TCMT110204-FM6	11,00	0,4	0,08-0,25	0,3-1,6								☺	☺									☺	☺	
TCMT110208-FM6	11,00	0,8	0,12-0,30	0,5-1,6								☺	☺									☺	☺	
TCMT16T304-FM6	16,50	0,4	0,08-0,25	0,3-2,0								☺	☺									☺	☺	
TCMT16T308-FM6	16,50	0,8	0,12-0,32	0,5-2,5								☺										☺		
TCGT110201-MN2	11,00	0,1	0,02-0,06	0,5-1,5													☺							
TCGT110202-MN2	11,00	0,2	0,05-0,12	0,6-2,0													☺							
TCGT110204-MN2	11,00	0,4	0,08-0,25	0,6-3,0							☺						☺	☺						
TCGT16T302-MN2	16,50	0,2	0,05-0,12	0,5-2,0													☺							
TCGT16T304-MN2	16,50	0,4	0,08-0,25	0,6-4,0							☺						☺	☺						
TCGT16T308-MN2	16,50	0,8	0,10-0,35	0,8-4,0							☺						☺	☺						
TCGT090204-MM4	9,62	0,4	0,08-0,20	0,4-2,0								☺											☺	
TCGT110204-MM4	11,00	0,4	0,08-0,20	0,4-2,0							☺												☺	
TCGT110208-MM4	11,00	0,8	0,12-0,30	0,5-2,0							☺												☺	
TCGT16T304-MM4	16,50	0,4	0,08-0,25	0,4-3,0								☺											☺	
TCGT16T308-MM4	16,50	0,8	0,12-0,32	0,5-3,0								☺											☺	
TCMT090204-MP4	9,62	0,4	0,08-0,20	0,4-2,0	☺	☺																		
TCMT090208-MP4	9,62	0,8	0,12-0,25	0,5-2,0	☺	☺	☺																	
TCMT110204-MP4	11,00	0,4	0,08-0,20	0,4-2,0	☺	☺	☺																	
TCMT110208-MP4	11,00	0,8	0,12-0,30	0,5-2,0	☺	☺	☺																	
TCMT16T304-MP4	16,50	0,4	0,08-0,25	0,4-3,0	☺	☺	☺																	
TCMT16T308-MP4	16,50	0,8	0,12-0,32	0,5-3,0	☺	☺	☺																	
TCMT220408-MP4	22,00	0,8	0,12-0,32	0,5-3,5			☺																	

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive triangular 60° TPMT / TPGT / TPMW / TPMR / TPGN

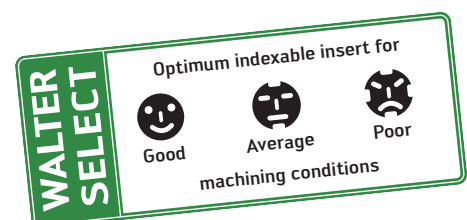
Tiger-tec® Silver



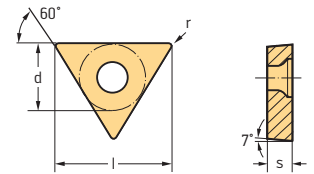
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P				M				K		S				HW	
					HC				HC				HC		HC					
					WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM01	WSM10S	WSM20S		WSM30S
TPMT110204-FM4	11,00	0,4	0,05–0,16	0,1–1,5																
TPMT16T304-FM4	16,50	0,4	0,05–0,16	0,1–1,5																
TPMT110204-FP4	11,00	0,4	0,05–0,16	0,1–1,5	☺															
TPMT16T304-FP4	16,50	0,4	0,05–0,16	0,1–1,5	☺															
TPGT110204-MM4	11,00	0,4	0,08–0,20	0,4–2,0						☺	☺			☺	☺					
TPGT110208-MM4	11,00	0,8	0,12–0,30	0,5–2,0						☺	☺			☺	☺					
TPGT16T304-MM4	16,50	0,4	0,08–0,25	0,4–3,0						☺	☺			☺	☺					
TPGT16T308-MM4	16,50	0,8	0,12–0,32	0,5–3,0						☺	☺			☺	☺					
TPMT090204-MP4	9,62	0,4	0,08–0,20	0,4–2,0		☺														
TPMT110204-MP4	11,00	0,4	0,08–0,20	0,4–2,0		☺														
TPMT110208-MP4	11,00	0,8	0,12–0,30	0,5–2,0		☺														
TPMT16T304-MP4	16,50	0,4	0,08–0,25	0,4–3,0		☺														
TPMT16T308-MP4	16,50	0,8	0,12–0,32	0,5–3,0		☺														
TPMT220408-MP4	22,00	0,8	0,15–0,32	0,5–3,5		☺														
TPMT090204-MK4	9,62	0,4	0,08–0,20	0,4–2,0										☺						
TPMT090208-MK4	9,62	0,8	0,12–0,20	0,5–2,0										☺						
TPMT110204-MK4	11,00	0,4	0,08–0,20	0,4–2,0										☺						
TPMT110208-MK4	11,00	0,8	0,12–0,30	0,5–2,0										☺						
TPMT16T304-MK4	16,50	0,4	0,08–0,25	0,4–3,0										☺						
TPMT16T308-MK4	16,50	0,8	0,12–0,32	0,5–3,0										☺						
TPMW110204-RK6	11,00	0,4	0,12–0,25	0,4–2,5										☺						
TPMW16T304-RK6	16,50	0,4	0,12–0,25	0,4–3,0										☺						
TPMW16T308-RK6	16,50	0,8	0,16–0,35	0,6–4,0										☺						
TPMR110308	11,00	0,8	0,16–0,30	0,6–3,0										☺						
TPMR130308	13,75	0,8	0,16–0,30	0,6–3,0		☺														
TPMR160304	16,50	0,4	0,12–0,25	0,4–3,0		☺														
TPMR160308	16,50	0,8	0,16–0,30	0,6–4,0		☺														
TPGN090204	9,62	0,4	0,10–0,18	0,4–2,0										☺						
TPGN090208	9,62	0,8	0,12–0,20	0,8–2,0										☺						
TPGN110308	11,00	0,8	0,12–0,20	0,8–2,0										☺					☺	
TPGN160304	16,50	0,4	0,10–0,25	0,4–3,0		☺	☺							☺					☺	☺
TPGN160308	16,50	0,8	0,12–0,30	0,8–3,0		☺	☺							☺					☺	☺
TPGN220404	22,00	0,4	0,10–0,25	0,4–4,0		☺								☺						
TPGN220408	22,00	0,8	0,12–0,30	0,8–4,0		☺								☺						


See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Positive triangular 60° TCMT Perform



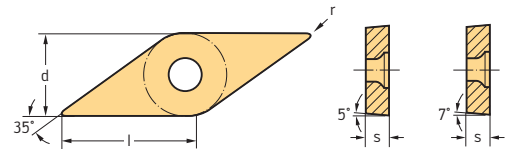
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P						M			K		S		
					HC						HC			HC		HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM10S	WSM20S
 TCMT110204-MV4	11,00	0,4	0,10-0,25	0,4-2,0														
TCMT16T304-MV4	16,50	0,4	0,10-0,25	0,4-3,0														
TCMT16T308-MV4	16,50	0,8	0,12-0,32	0,5-3,0														




See the ISO 1832 designation key for dimensions

HC = Coated carbide

Tiger-tec® Silver



Indexable inserts

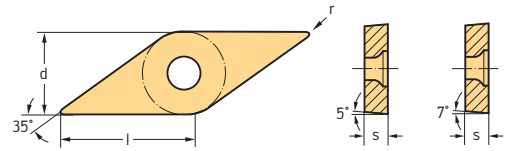
Designation	l mm	r mm	f mm	a _p mm	P		M				K		N	S				
					HE	HC	HC				HC		HC	HC				
					WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01
 VCGT110301-FN2	11,07	0,1	0,02-0,06	0,1-1,5														
VCGT110302-FN2	11,07	0,2	0,05-0,12	0,2-2,0														
VCGT110304-FN2	11,07	0,4	0,08-0,25	0,2-2,5														
VCGT160402-FN2	16,61	0,2	0,05-0,12	0,2-2,0														
VCGT160404-FN2	16,61	0,4	0,08-0,25	0,2-2,5														
VCGT160408-FN2	16,61	0,8	0,10-0,30	0,3-3,0														
 VCGT110301-FM2	11,07	0,1	0,02-0,06	0,1-1,5														
VCGT110302-FM2	11,07	0,2	0,05-0,12	0,2-2,0														
VCGT110304-FM2	11,07	0,4	0,08-0,25	0,2-2,5														
VCGT160402-FM2	16,61	0,2	0,05-0,12	0,2-2,0														
VCGT160404-FM2	16,61	0,4	0,08-0,25	0,2-2,5														
VCGT160408-FM2	16,61	0,8	0,10-0,30	0,3-3,0														
 VCMT110302-FP4	11,07	0,2	0,04-0,12	0,1-1,0														
VCMT110304-FP4	11,07	0,4	0,05-0,16	0,1-1,5														
VCMT160402-FP4	16,61	0,2	0,04-0,12	0,1-1,0														
VCMT160404-FP4	16,61	0,4	0,05-0,16	0,1-1,5														
VCMT160408-FP4	16,61	0,8	0,08-0,20	0,1-1,5														

See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 35° VCGT / VCMT / VBMT

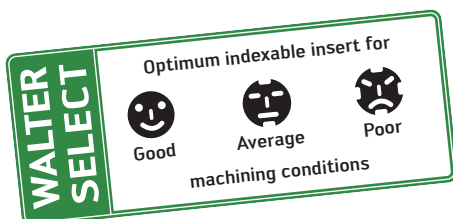
Tiger-tec® Silver



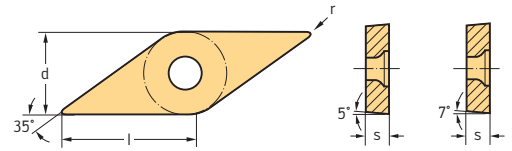
Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P					M				K		N		S			
					HE		HC			HC				HC		HC		HC			
					WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S
VBMT110304-FM6	11,07	0,4	0,08–0,20	0,3–1,6								☺	☺	☺					☺	☺	☺
VBMT110308-FM6	11,07	0,8	0,12–0,30	0,5–1,6								☺	☺	☺					☺	☺	☺
VBMT160404-FM6	16,61	0,4	0,08–0,25	0,3–2,0								☺	☺	☺					☺	☺	☺
VBMT160408-FM6	16,61	0,8	0,12–0,30	0,6–2,5								☺	☺						☺	☺	
VBMT160412-FM6	16,61	1,2	0,15–0,30	1,0–2,5								☺	☺						☺	☺	
VCGT110301-MN2	11,07	0,1	0,02–0,06	0,5–1,5												☺					
VCGT110302-MN2	11,07	0,2	0,05–0,12	0,5–2,0												☺					
VCGT110304-MN2	11,07	0,4	0,08–0,25	0,6–2,5												☺					
VCGT110308-MN2	11,07	0,8	0,10–0,35	0,8–3,0												☺					
VCGT130301-MN2	13,1	0,1	0,02–0,06	0,5–1,5												☺					
VCGT130302-MN2	13,1	0,2	0,05–0,12	0,5–2,0												☺					
VCGT130304-MN2	13,1	0,4	0,08–0,25	0,6–3,0												☺					
VCGT160404-MN2	16,61	0,4	0,08–0,25	0,6–3,5							☺					☺	☺				
VCGT160408-MN2	16,61	0,8	0,10–0,35	0,8–3,5							☺					☺	☺				
VCGT160412-MN2	16,61	1,2	0,10–0,45	1,0–3,5												☺					
VBMT110304-MM4	11,07	0,4	0,08–0,20	0,4–1,5					☺	☺									☺	☺	
VBMT110308-MM4	11,07	0,8	0,12–0,25	0,5–1,5							☺	☺							☺	☺	
VBMT160404-MM4	16,61	0,4	0,08–0,20	0,4–2,0					☺	☺		☺							☺	☺	☺
VBMT160408-MM4	16,61	0,8	0,12–0,30	0,5–2,0					☺	☺		☺							☺	☺	☺
VBMT160412-MM4	16,61	1,2	0,12–0,32	0,5–2,0								☺							☺	☺	
VCGT110302-MM4	11,07	0,2	0,05–0,12	0,2–1,5							☺							☺		☺	
VCGT110304-MM4	11,07	0,4	0,08–0,20	0,4–1,5							☺							☺		☺	
VCGT160402-MM4	16,61	0,2	0,05–0,12	0,2–2,0							☺							☺		☺	
VCGT160404-MM4	16,61	0,4	0,08–0,20	0,4–2,0							☺							☺		☺	
VCGT160408-MM4	16,61	0,8	0,12–0,30	0,5–2,0							☺							☺		☺	
VBMT160404-MK4	16,61	0,4	0,08–0,20	0,4–2,0										☺	☺						
VBMT160408-MK4	16,61	0,8	0,12–0,30	0,5–2,0										☺	☺						
VBMT160412-MK4	16,61	1,2	0,12–0,32	0,5–2,0										☺	☺						



See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 35° VCMT Perform / VBMT Perform



Indexable inserts

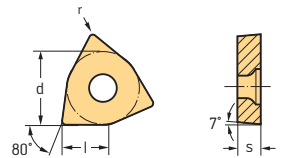
Designation	l mm	r mm	f mm	a _p mm	P						M			K		S		
					HC						HC			HC		HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WSM10S	WSM20S
 VCMT110304-FV4	11,07	0,4	0,05–0,16	0,1–1,5														
VCMT160404-FV4	16,61	0,4	0,05–0,16	0,1–1,5														
VCMT160408-FV4	16,61	0,8	0,08–0,20	0,1–1,5														
 VBMT160404-MV4	16,61	0,4	0,10–0,25	0,4–2,0														
VBMT160408-MV4	16,61	0,8	0,15–0,30	0,5–2,0														

See the ISO 1832 designation key for dimensions

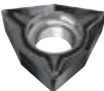


HC = Coated carbide

Positive Trigon 80° WCGT

Tiger-tec®



Indexable inserts

Designation	l mm	r mm	f mm	a _p mm	P						M			K		N	S		
					HC						HC			HC		HC	HC		
					WPP10S	WPP20S	WPP30S	WMP20S	WSM10S	WSM20S	WSM21	WSM30S	WKK10S	WKK20S	WNN10	WSM10S	WSM20S	WSM30S	
 WCGT020102-FN2	2,7	0,2	0,05–0,12	0,2–1,5															
WCGT020104-FN2	2,7	0,4	0,08–0,20	0,2–1,5															
WCGT030202-FN2	3,91	0,2	0,05–0,12	0,2–2,0															
WCGT030204-FN2	3,91	0,4	0,08–0,25	0,2–2,5															
WCGT040202-FN2	4,34	0,2	0,05–0,12	0,2–2,0															
WCGT040204-FN2	4,34	0,4	0,08–0,25	0,2–2,5															
WCGT06T304-FN2	6,52	0,4	0,08–0,25	0,2–2,5															
WCGT06T308-FN2	6,52	0,8	0,10–0,30	0,3–3,0															
 WCGT030202-FM2	3,91	0,2	0,05–0,12	0,2–2,0															
WCGT030204-FM2	3,91	0,4	0,08–0,25	0,2–2,5															
WCGT040202-FM2	4,34	0,2	0,05–0,12	0,2–2,0															
WCGT040204-FM2	4,34	0,4	0,08–0,25	0,2–2,5															
 WCGT030202-MN2	3,91	0,2	0,05–0,12	0,5–1,5															
WCGT030204-MN2	3,91	0,4	0,08–0,20	0,6–1,5															
WCGT040204-MN2	4,34	0,4	0,08–0,25	0,6–2,5															
WCGT06T302-MN2	6,52	0,2	0,05–0,12	0,6–2,0															
WCGT06T304-MN2	6,52	0,4	0,08–0,25	0,6–3,0															
WCGT080404-MN2	8,69	0,4	0,08–0,25	0,6–4,0															
WCGT080408-MN2	8,69	0,8	0,10–0,35	0,8–4,0															

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Product range overview of indexable inserts and cutting tool materials: ISO turning – CBN/PCD/ceramic



CBN indexable inserts

Insert shape	Description	Page
C <i>Wiper</i>	Negative basic shape Positive basic shape 7°	46 51
D <i>Wiper</i>	Negative basic shape Positive basic shape 7°	47 52
R	Negative basic shape	48
S	Negative basic shape Positive basic shape 7°	48 53
T	Negative basic shape Positive basic shape 7°	49 53
V	Negative basic shape Positive basic shape 5° Positive basic shape 7°	50 54 54
W	Negative basic shape	55

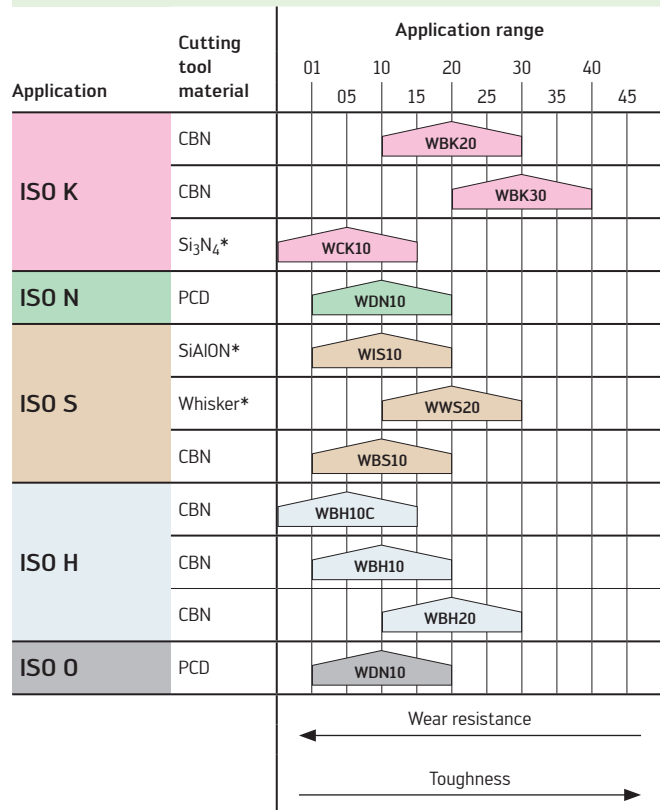
Ceramic indexable inserts

Insert shape	Description	Page
C	Negative basic shape	57
D	Negative basic shape	57
S	Negative basic shape	58
T	Negative basic shape	59
W	Negative basic shape	59

PCD indexable inserts

Insert shape	Description	Page
C	Positive basic shape 11°	55
D	Positive basic shape 11°	55
S	Positive basic shape 11°	56
T	Positive basic shape 11°	56

Cutting tool materials: CBN, PCD, ceramic



* Ceramic

Designation key for CBN/cermet/ceramic/PCD cutting tool materials – Turning

Example:

W	B	H	10	C
Walter	1	2	3	4

1	2	3	4
Cutting tool material	Primary application	ISO application range	Coating
<p>B CBN</p> <p>C Si₃N₄ ceramic</p> <p>D Diamond</p> <p>E Cermet</p> <p>I SiAlON ceramic</p> <p>W Whisker-reinforced ceramic</p>	<p>P Steel</p> <p>M Stainless steel</p> <p>K Cast iron</p> <p>N NF metals</p> <p>S Materials with difficult cutting properties</p> <p>H Hard materials</p>	<p style="text-align: center;">Wear resistance</p> <div style="display: flex; align-items: center;"> <div style="writing-mode: vertical-rl; transform: rotate(180deg); margin-right: 10px;"> 01 05 10 20 21 23 30 32 33 43 </div> </div> <p style="text-align: center;">Toughness</p>	<p>C Coated</p>

Designation key in accordance with ISO 1832 for indexable inserts for turning

Example: Ceramic indexable inserts

R	N	G	N	12	07	00	T	010	20
1	2	3	4	5	6	7	8	11	12

1	
Insert shape	
A	
B	
C	
D	
E	
H	
K	
L	
M	
O	
P	
R	
S	
T	
V	
W	

2	
Clearance angle	
A	
B	
C	
D	
E	
F	
G	
N	
P	

3			
Tolerances			
Permissible deviation in mm for			
	d	m	s
A	± 0,025	± 0,005	± 0,025
C	± 0,025	± 0,013	± 0,025
E	± 0,025	± 0,025	± 0,025
F	± 0,013	± 0,005	± 0,025
G	± 0,025	± 0,025	± 0,130
H	± 0,013	± 0,013	± 0,025
J ¹	± 0,05–0,15 ²	± 0,005	± 0,025
K ¹	± 0,05–0,15 ²	± 0,013	± 0,025
L ¹	± 0,05–0,15 ²	± 0,025	± 0,025
M	± 0,05–0,15 ²	± 0,08–0,20 ²	± 0,130
N	± 0,05–0,15 ²	± 0,08–0,20 ²	± 0,025
U	± 0,08–0,25 ²	± 0,13–0,38 ²	± 0,130

¹ Inserts with ground planar cutting edges
² Depending on the insert size (see ISO standard 1832)

6	
Insert thickness s [mm]	
	01 s = 1,59
	T1 s = 1,98
	02 s = 2,38
	T2 s = 2,78
	03 s = 3,18
	T3 s = 3,97
	04 s = 4,76
	05 s = 5,56
	06 s = 6,35
	07 s = 7,94
	09 s = 9,52

7	
Corner radius r [mm]	
	01 r = 0,1
	02 r = 0,2
	04 r = 0,4
	08 r = 0,8
	12 r = 1,2
	16 r = 1,6
	24 r = 2,4
	R
M0	Metric version "diameter in [mm]"
00	Inch version "diameter with inch units in [mm]"

8	
Edge formation	
F	
E	
T	
S	

9	
Cutting edge preparation	
S	small
M	medium

10	
Cutting direction	
	R
	L
	N

Example: CBN indexable insert

C	N	G	A	12	04	08	T	M	.	-	MW	.	2
1	2	3	4	5	6	7	8	9	10		13	14	15

4	
Machining and fastening features	
A	N
B	Q
C	R
F	T
G	U
H	W
J	X
M	

5														
Cutting edge length l [mm]														
Inner circle diameter d	C		D		R	S		T		V		W		
	Size	l	Size	l	Size	Size	l	Size	l	Size	l	Size	l	
3,97	5/32							06	6,9					
5	0,197				05							03	3,8	
5,56	7/32							09	9					
6	0,236				06									
6,35	2/8	06	6,4	07	7,7	06 ¹								
8	0,315					08								
9,525	3/8	09	9,6	11	11,6	09 ¹	09	9,5	16	16,5	16	16,5	06	6,5
10	0,394					10								
12	0,472					12								
12,7	4/8	12	12,9	15	15,5	12 ¹	12	12,7	22	22			08	8,7
15,875	5/8	16	16,1				15	15,8	27	27			10	10,8
16	0,63					16								
17,46	11/16												12	11,6
19,05	6/8	19	19,3			19 ¹	19	19,0						
20	0,787					20								
25	0,984					25								
25,4	8/8	25	25,8			25 ¹	25	25,4						
32	1,26					32								

¹ Inch version (00)

11
Chamfer width
010 = 0,10 mm
020 = 0,20 mm
025 = 0,25 mm
070 = 0,70 mm
150 = 1,50 mm
200 = 2,00 mm

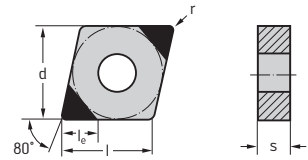
12
Chamfer angle
15 = 15°
20 = 20°

13
Wiper cutting edge
MW Wiper – medium feed






14
Chip breaking area
M Medium machining

15	
Number of cutting edges/version	
1 single	
2 double	
3 triple	
4 quadruple	
...	
9 strip	
0 full-face	
S solid	

CBN – Negative rhombic 80° CNGA



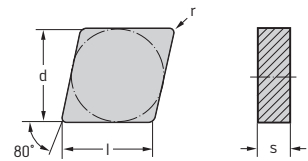
Indexable inserts

Designation	Number of cutting edges	l_e mm	r mm	f mm	a_p mm	K		N		S		H		O	
						CN	BH	DP	BH	WBS10	WBH10C	WBH10	WBH20	WDN10	DP
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	DP
 Wiper CNGA120404TM-MW2 CNGA120408TM-MW2 CNGA120412TM-MW2	2	2,8	0,4	0,05–0,20	0,1–0,5							☺	☺		
	2	2,7	0,8	0,05–0,25	0,1–1,0							☺	☺		
	2	2,8	1,2	0,05–0,30	0,1–1,0							☺	☺		
 CNGA120404EM-2 CNGA120408EM-2	2	2,8	0,4	0,05–0,20	0,1–0,5					☺					
	2	2,7	0,8	0,05–0,25	0,1–1,0					☺					
 CNGA120404TS-2 CNGA120408TS-2 CNGA120412TS-2	2	2,8	0,4	0,05–0,20	0,1–2,0		☹								
	2	2,7	0,8	0,05–0,25	0,1–2,0		☹								
	2	2,8	1,2	0,05–0,30	0,1–2,0		☹								
 Chip breaker CNGA120404TM-M2 CNGA120408TM-M2 CNGA120412TM-M2	2	2,8	0,4	0,05–0,20	0,1–0,5							☺			
	2	2,7	0,8	0,05–0,25	0,1–1,0							☺			
	2	2,8	1,2	0,05–0,30	0,1–1,0							☺			
 CNGA120404TM-2 CNGA120408TM-2 CNGA120412TM-2	2	2,8	0,4	0,05–0,20	0,1–0,5							☺	☺	☹	
	2	2,7	0,8	0,05–0,25	0,1–1,0							☺	☺	☹	
	2	2,8	1,2	0,05–0,30	0,1–1,0							☺	☺	☹	


See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si_3N_4
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative rhombic 80° CNGN



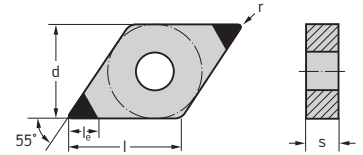
Indexable inserts

Designation	Number of cutting edges	r mm	f mm	a_p mm	K		N		S		H		O	
					CN	BH	DP	BH	WBS10	WBH10C	WBH10	WBH20	WDN10	DP
					WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	DP
 CNGN120412TM-S CNGN120416TM-S	4	1,2	0,05–0,50	0,1–5,0										
	4	1,6	0,05–0,50	0,1–5,0										

CN = Silicon nitride Si_3N_4
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

☹ ☹ ☹ / ★ New addition to the product range

CBN – Negative rhombic 55° DNGA



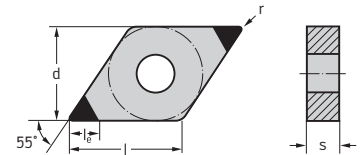
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN	BH	DP	BH	BL	BL	DP	DP		
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
DNGA150404TM-MW2	2	2,9	0,4	0,05–0,20	0,1–0,5										
	DNGA150604TM-MW2	2	2,9	0,4	0,05–0,20	0,1–0,5									
	DNGA150408TM-MW2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150608TM-MW2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150612TM-MW2	2	2,8	1,2	0,05–0,30	0,1–1,0									
DNGA150404EM-2	2	2,9	0,4	0,05–0,20	0,1–0,5										
	DNGA150408EM-2	2	2,8	0,8	0,05–0,25	0,1–1,0									
DNGA150404TS-2	2	2,9	0,4	0,05–0,20	0,1–2,0										
	DNGA150604TS-2	2	2,9	0,4	0,05–0,20	0,1–2,0									
	DNGA150408TS-2	2	2,8	0,8	0,05–0,25	0,1–2,0									
	DNGA150608TS-2	2	2,8	0,8	0,05–0,25	0,1–2,0									
	DNGA150412TS-2	2	2,8	1,2	0,05–0,30	0,1–2,0									
DNGA150612TS-2	2	2,8	1,2	0,05–0,30	0,1–2,0										

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative rhombic 55° DNGA



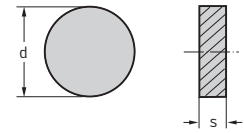
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN	BH	DP	BH	BL	BL	DP	DP		
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
DNGA150404TM-M2	2	2,9	0,4	0,05–0,20	0,1–0,5										
	DNGA150604TM-M2	2	2,9	0,4	0,05–0,20	0,1–0,5									
	DNGA150408TM-M2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150608TM-M2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150612TM-M2	2	2,8	1,2	0,05–0,30	0,1–1,0									
DNGA150404TM-2	2	2,9	0,4	0,05–0,20	0,1–0,5										
	DNGA150604TM-2	2	2,9	0,4	0,05–0,20	0,1–0,5									
	DNGA150408TM-2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150608TM-2	2	2,8	0,8	0,05–0,25	0,1–1,0									
	DNGA150612TM-2	2	2,8	1,2	0,05–0,30	0,1–1,0									



See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative round RNGN

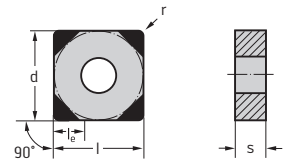


Indexable inserts





Designation	d mm	f mm	a _p mm	K		N		S		H		O	
				CN		DP		BH		BL		DP	
				WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 RNGN120400TS-0	12,7	0,05–0,40	0,1–5,0		☞								
 RNGN120400TM-S	12,7	0,05–0,40	0,1–5,0		☞								

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative square SNGA



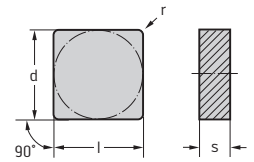
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN		DP		BH		BL		DP	
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 SNGA120408TS-4	4	2,8	0,8	0,05–0,30	0,1–2,0		☞								
 SNGA120412TS-4	4	2,8	1,2	0,05–0,30	0,1–2,0		☞								
 SNGA120408TM-4	4	2,8	0,8	0,05–0,30	0,1–1,0								☞		
 SNGA120412TM-4	4	2,8	1,2	0,05–0,30	0,1–1,0								☞		

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative square SNGN

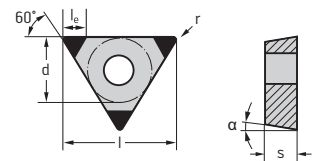


Indexable inserts

Designation	Number of cutting edges	r mm	f mm	a _p mm	K		N		S		H		O	
					CN	BH	DP	BH	BL	BL	DP			
					WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
	SNGN120408TM-S	8	0,8	0,05–0,50	0,1–5,0									
	SNGN120412TM-S	8	1,2	0,05–0,50	0,1–5,0									
	SNGN120416TM-S	8	1,6	0,05–0,50	0,1–5,0									

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Negative triangular 60° TNGA



Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN	BH	DP	BH	BL	BL	DP			
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
	TNGA160404TS-3	3	3	0,4	0,05–0,20	0,1–2,0									
	TNGA160408TS-3	3	2,8	0,8	0,05–0,25	0,1–2,0									
	TNGA160404TM-3	3	3	0,4	0,05–0,20	0,1–0,5									
	TNGA160408TM-3	3	2,8	0,8	0,05–0,20	0,1–0,5									

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

WALTER SELECT

Optimum indexable insert for

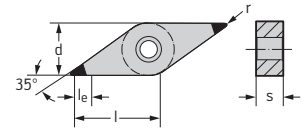
Good

Average



Poor

machining conditions

**CBN – Negative rhombic 35°
VNGA**



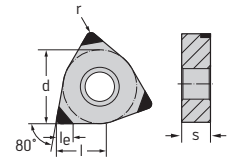
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN		DP		BH		BL		DP	
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 VNGA160404TS-2 VNGA160408TS-2	2	3	0,4	0,05–0,20	0,1–2,0	★	★								
	2	3	0,8	0,05–0,20	0,1–2,0	★	★								
 VNGA160404TM-2 VNGA160408TM-2	2	3	0,4	0,05–0,20	0,1–0,5					☺	☺	☺			
	2	3	0,8	0,05–0,20	0,1–0,5					☺	☺	☺			



See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

**CBN – Negative Trigon 80°
WNGA**



Indexable inserts

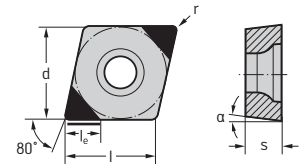
Designation	Number of cutting edges	l _e mm	r mm	f mm	a _p mm	K		N		S		H		O	
						CN		DP		BH		BL		DP	
						WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 WNGA080408TS-3	3	2,8	0,8	0,05–0,25	0,1–2,0	★	★								
 WNGA080408TM-3	3	2,8	0,8	0,05–0,25	0,1–1,0						☺	☺			

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

★ / ★ New addition to the product range

CBN – Positive rhombic 80° CCGW

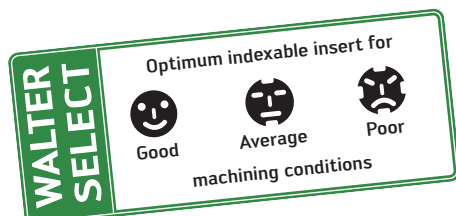


Indexable inserts

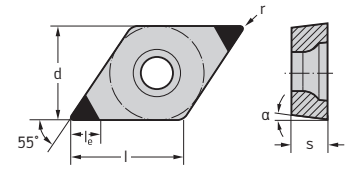
Designation	Number of cutting edges	l _e mm	r mm	α	f mm	a _p mm	K		N		S		H		O			
							CN		BH		DP		BH		BL		DP	
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10			
 Wiper	CCGW09T304TS-MW2	2	2,8	0,4	7°	0,05–0,20	0,1–0,5					☺	☺					
	CCGW09T308TM-MW2	2	2,7	0,8	7°	0,05–0,25	0,1–0,5					☺	☺					
	CCGW060202EM-2	2	2,8	0,2	7°	0,05–0,15	0,1–0,3					☺						
	CCGW060204EM-2	2	2,8	0,4	7°	0,05–0,20	0,1–0,3					☺						
	CCGW09T304EM-2	2	2,8	0,4	7°	0,05–0,20	0,1–0,5					☺						
	CCGW09T308EM-2	2	2,7	0,8	7°	0,05–0,25	0,1–0,5					☺						
	CCGW060202TS-2	2	2,8	0,2	7°	0,05–0,15	0,1–0,3	☹				☺	☺					
	CCGW060204TS-2	2	2,8	0,4	7°	0,05–0,20	0,1–0,3	☹				☺						
	CCGW060208TS-2	2	2,7	0,8	7°	0,05–0,25	0,1–0,5	☹				☺						
	CCGW09T304TS-2	2	2,8	0,4	7°	0,05–0,15	0,1–0,5	☹				☺						
	CCGW09T308TS-2	2	2,7	0,8	7°	0,05–0,20	0,1–0,5	☹				☺						
	CCGW060204TM-2	2	2,8	0,4	7°	0,05–0,20	0,1–0,3					☺	☺	☺				
	CCGW060208TM-2	2	2,7	0,8	7°	0,05–0,25	0,1–0,5					☺	☺	☺				
	CCGW09T304TM-2	2	2,8	0,4	7°	0,05–0,20	0,1–0,5					☺	☺	☺				
	CCGW09T308TM-2	2	2,7	0,8	7°	0,05–0,25	0,1–0,5					☺	☺	☺				

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content



CBN – Positive rhombic 55° DCGW



Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	α	f mm	a _p mm	K		N		S		H		O	
							CN		BH		DP		BL		DP	
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
DCGW070202EM-2	2	3	0,2	7°	0,05–0,15	0,1–0,3					☺					
DCGW070204EM-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,3					☺					
DCGW11T304EM-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,5					☺					
DCGW11T308EM-2	2	2,8	0,8	7°	0,05–0,25	0,1–0,5					☺					
DCGW070202TS-2	2	3	0,2	7°	0,05–0,15	0,1–0,3	☹					☺	☺			
DCGW070204TS-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,3	☹					☺	☺			
DCGW070208TS-2	2	2,8	0,8	7°	0,05–0,25	0,1–0,5	☹									
DCGW11T302TS-2	2	3	0,2	7°	0,05–0,15	0,1–0,5	☹					☺	☺			
DCGW11T304TS-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,5	☹									
DCGW11T308TS-2	2	2,8	0,8	7°	0,05–0,25	0,1–0,5	☹									
DCGW070202TM-2	2	3	0,2	7°	0,05–0,15	0,1–0,3										☺
DCGW070204TM-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,3						☺	☺	☺		
DCGW070208TM-2	2	2,8	0,8	7°	0,05–0,25	0,1–0,5						☺	☺	☺		
DCGW11T302TM-2	2	3	0,2	7°	0,05–0,15	0,1–0,5										☺
DCGW11T304TM-2	2	2,9	0,4	7°	0,05–0,20	0,1–0,5						☺	☺	☺		
DCGW11T308TM-2	2	2,8	0,8	7°	0,05–0,25	0,1–0,5						☺	☺	☺		

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

WALTER SELECT

Optimum indexable insert for

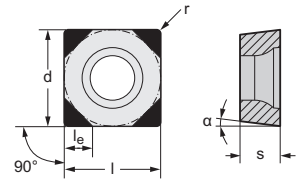
Good

Average

Poor

machining conditions

CBN – Positive square SCGW

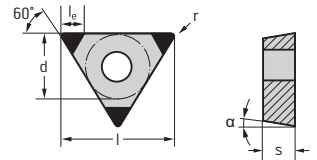


Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	α	f mm	a _p mm	K		N		S		H		O	
							CN		BH		DP		BL		DP	
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
SCGW09T304TS-4	4	2,8	0,4	7°	0,05–0,20	0,1–0,5	☹	☹								
SCGW09T308TS-4	4	2,8	0,8	7°	0,05–0,25	0,1–0,5	☹	☹								

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Positive triangular 60° TCGW

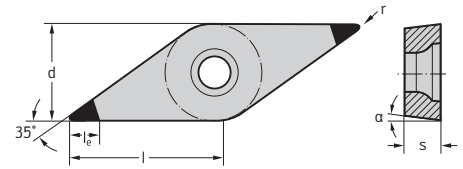


Indexable inserts




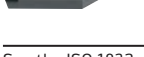
Designation	Number of cutting edges	l _e mm	r mm	α	f mm	a _p mm	K		N		S		H		O	
							CN		BH		DP		BL		DP	
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
TCGW110202TS-3	3	2,8	0,2	7°	0,05–0,15	0,1–0,3	☹	☹								
TCGW110204TS-3	3	2,8	0,4	7°	0,05–0,20	0,1–0,3	☹	☹								

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Positive rhombic 35° VBGW



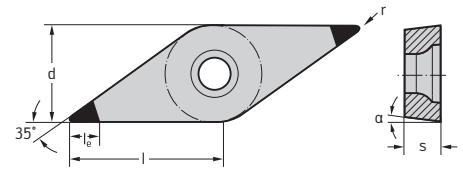
Indexable inserts

Designation	Number of cutting edges	l_e mm	r mm	α	f mm	a_p mm	K		N		S		H		O	
							CN	BH	DP	BH	BL	BL	DP			
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 VBGW160404TS-2	2	3	0,4	5°	0,05–0,20	0,1–0,5							☺			
 VBGW160408TS-2	2	3	0,8	5°	0,05–0,25	0,1–0,5							☺			
 VBGW160404TM-2	2	3	0,4	5°	0,05–0,20	0,1–0,5							☺	☺		
 VBGW160408TM-2	2	3	0,8	5°	0,05–0,25	0,1–0,5							☺	☺		









See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si_3N_4
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

CBN – Positive rhombic 35° VCGW

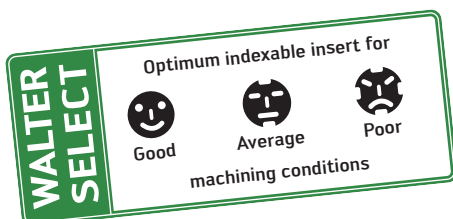


Indexable inserts

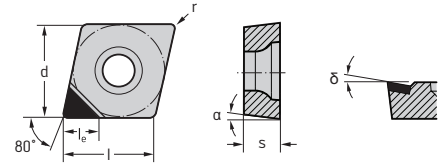
Designation	Number of cutting edges	l_e mm	r mm	α	f mm	a_p mm	K		N		S		H		O	
							CN	BH	DP	BH	BL	BL	DP			
							WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 VCGW110302EM-2	2	3,4	0,2	7°	0,05–0,15	0,1–0,3							☺			
 VCGW110304EM-2	2	3	0,4	7°	0,05–0,20	0,1–0,3							☺			
 VCGW160404EM-2	2	3	0,4	7°	0,05–0,20	0,1–0,5							☺			
 VCGW160408EM-2	2	3	0,8	7°	0,05–0,25	0,1–0,5							☺			
 VCGW160404TS-2	2	3	0,4	7°	0,05–0,20	0,1–0,5							☺			
 VCGW160408TS-2	2	3	0,8	7°	0,05–0,25	0,1–0,5							☺			
 VCGW160404TM-2	2	3	0,4	7°	0,05–0,20	0,1–0,5							☺			
 VCGW160408TM-2	2	3	0,8	7°	0,05–0,25	0,1–0,5							☺			

See the ISO 1832 designation key for dimensions

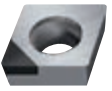
CN = Silicon nitride Si_3N_4
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content



PCD – Positive rhombic 80° CPGW



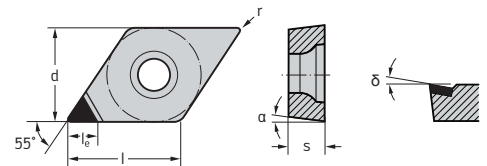
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	α	δ	f mm	a _p mm	K			N		S		H		O
								CN		BH	DP	BH	BL	BL	DP		
								WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 CPGW050204FS-1	1	3	0,4	11°	0°	0,03–0,25	0,1–2,5				☉						☉
CPGW060204FS-1	1	3,5	0,4	11°	0°	0,03–0,25	0,1–3,0				☉						☉
CPGW09T304FS-1	1	4	0,4	11°	0°	0,03–0,25	0,1–3,5				☉						☉
CPGW09T308FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5				☉						☉
CPGW120408FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5				☉						☉

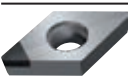
See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

PCD – Positive rhombic 55° DPGW



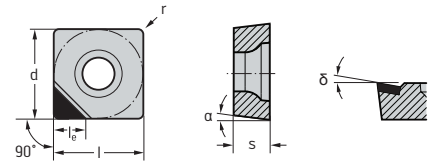
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	α	δ	f mm	a _p mm	K			N		S		H		O
								CN		BH	DP	BH	BL	BL	DP		
								WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 DPGW070204FS-1	1	3,5	0,4	11°	0°	0,03–0,25	0,1–3,0				☉						☉
DPGW11T304FS-1	1	4	0,4	11°	0°	0,03–0,25	0,1–3,5				☉						☉
DPGW11T308FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5				☉						☉

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

**PCD – Positive square
SPGW**



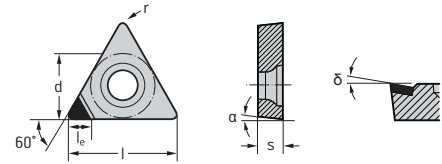
Indexable inserts

Designation	Number of cutting edges	l _e mm	r mm	α	δ	f mm	a _p mm	K		N	S	H		O
								CN	BH	DP	BH	BL	DP	
								WCK10 WBK20 WBK30	WDN10	WBS10	WBH10C WBH10 WBH20	WDN10		
SPGW09T308FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5			☺				☺

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

**PCD – Positive triangular 60°
TPGW**

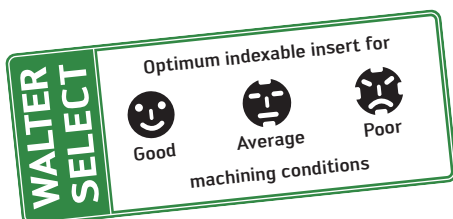


Indexable inserts

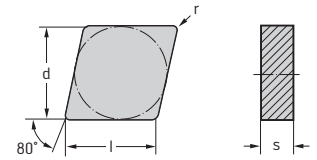
Designation	Number of cutting edges	l _e mm	r mm	α	δ	f mm	a _p mm	K		N	S	H		O
								CN	BH	DP	BH	BL	DP	
								WCK10 WBK20 WBK30	WDN10	WBS10	WBH10C WBH10 WBH20	WDN10		
TPGW110204FS-1	1	4,2	0,4	11°	0°	0,03–0,25	0,1–3,5			☺				☺
TPGW110208FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5			☺				☺
TPGW16T304FS-1	1	4,2	0,4	11°	0°	0,03–0,25	0,1–3,5			☺				☺
TPGW16T308FS-1	1	4	0,8	11°	0°	0,03–0,38	0,1–3,5			☺				☺

See the ISO 1832 designation key for dimensions




CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content



Ceramic – Negative rhombic 80° CNGN / CNGA



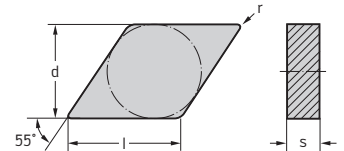
Indexable inserts

Designation	r mm	f mm	a _p mm	K		N		S		H		O
				CN	BH	DP	BH	CN	CR	BL	DP	
				WCK10 WBK20 WBK30	WDN10 WBS10 WIS10 WWS20	WBH10 WBH20	WDN10					
 CNGN120408T01020 CNGN120412T01020 CNGN120708T01020 CNGN120712T01020 CNGN120716T01020	0,8	0,10–0,22	0,1–3,6									
	1,2	0,10–0,32	0,1–3,6									
	0,8	0,10–0,22	0,1–3,6									
	1,2	0,10–0,32	0,1–3,6									
	1,6	0,10–0,42	0,1–3,6									
 CNGN120408T02020 CNGN120412T02020 CNGN120416T02020 CNGN120712T02020 CNGN120716T02020	0,8	0,10–0,40	0,1–6,0	☺								
	1,2	0,10–0,60	0,1–6,0	☺								
	1,6	0,10–0,60	0,1–6,0	☺								
	1,2	0,10–0,60	0,1–6,0	☺								
	1,6	0,10–0,60	0,1–6,0	☺								
 CNGA120408T02020 CNGA120412T02020 CNGA120416T02020	0,8	0,10–0,40	0,1–6,0	☺								
	1,2	0,10–0,60	0,1–6,0	☺								
	1,6	0,10–0,60	0,1–6,0	☺								

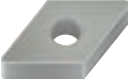
See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 CR = Reinforced ceramic
 BL = CBN with low CBN content

Ceramic – Negative rhombic 80° DNGA



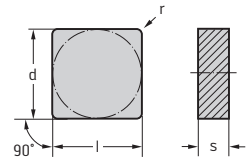
Indexable inserts

Designation	r mm	f mm	a _p mm	K		N		S		H		O
				CN	BH	DP	BH	BL	DP			
				WCK10 WBK20 WBK30	WDN10 WBS10 WBH10 WBH20	WDN10						
 DNGA150608T02020 DNGA150612T02020	0,8	0,10–0,40	0,1–5,0	☺								
	1,2	0,10–0,60	0,1–5,0	☺								




See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

Ceramic – Negative square SNGN / SNGA

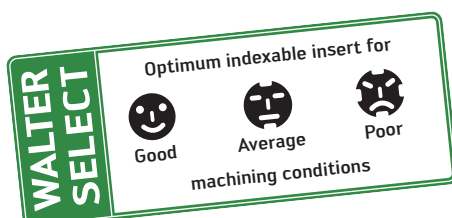


Indexable inserts

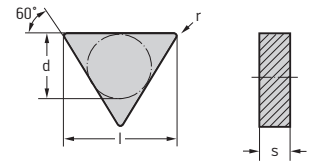
Designation	r mm	f mm	a _p mm	K		N	S		H		O			
				CN		BH	DP	BH		CN	CR	BL		DP
				WCK10	WBK20	WBK30	WDN10	WBS10	WIS10	WWS20	WBH10C	WBH10	WBH20	WDN10
 SNGN120708T01020 SNGN120712T01020	0,8	0,10–0,22	0,1–3,6											
	1,2	0,10–0,32	0,1–3,6											
 SNGN120412T02020 SNGN120416T02020 SNGN120712T02020 SNGN120716T02020	1,2	0,10–0,60	0,1–5,0	☹										
	1,6	0,10–0,60	0,1–5,0	☹										
	1,2	0,10–0,60	0,1–5,0	☹										
	1,6	0,10–0,60	0,1–5,0	☹										
 SNGA120408T02020 SNGA120412T02020 SNGA120416T02020	0,8	0,10–0,40	0,1–5,0	☹										
	1,2	0,10–0,60	0,1–5,0	☹										
	1,6	0,10–0,80	0,1–5,0	☹										

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 CR = Reinforced ceramic
 BL = CBN with low CBN content



Ceramic – Negative triangular 60° TNGN / TNGA



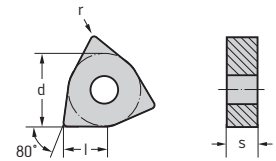
Indexable inserts

Designation	r mm	f mm	a _p mm	K		N		S		H		O	
				CN	BH	DP	BH	WBH10C	WBH10	WBH20	WDN10	DP	
 TNGN160412T02020 TNGN160416T02020	1,2	0,10–0,60	0,1–5,0	⊕									
	1,6	0,10–0,60	0,1–5,0	⊕									
 TNGA160408T02020 TNGA160412T02020	0,8	0,10–0,40	0,1–5,0	⊕									
	1,2	0,10–0,60	0,1–5,0	⊕									

See the ISO 1832 designation key for dimensions

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

Ceramic – Negative Trigon 80° WNGA



Indexable inserts

Designation	r mm	f mm	a _p mm	K		N		S		H		O	
				CN	BH	DP	BH	WBH10C	WBH10	WBH20	WDN10	DP	
 WNGA080408T02020 WNGA080412T02020	0,8	0,10–0,40	0,1–5,0	⊕									
	1,2	0,10–0,60	0,1–5,0	⊕									

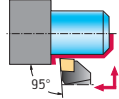
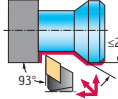
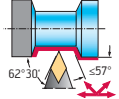
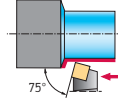
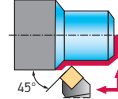
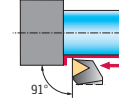
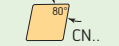
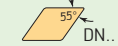

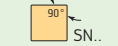
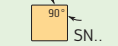







See the ISO 1832 designation key for dimensions

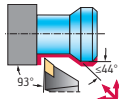
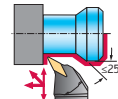
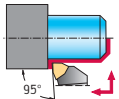
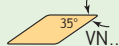
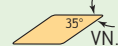




CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

Walter Turn turning tools product range overview – External machining

Square shank turning toolholders

Negative basic shape

Machining						
Type						
Designation	DCLN...-P	DDJN...-P	DDPN	DSBN...-P	DSSN...-P	DTGN...-P
Approach angle κ	95°	93°	62° 30'	75°	45°	91°
Clamping system	Clamp	Clamp	Clamp	Clamp	Clamp	Clamp
Coolant supply	Precision cooling	Precision cooling	external	Precision cooling	Precision cooling	Precision cooling
Shank size h [mm]	20–32	20–25		25	25	
Shank size h [inch]	0.750–1.000	0.750–1.000	0.750–1.250			0.750–1.000
Page	63	65	67	68	69	70
						

Machining			
Type			
Designation	DVJN...-P	DVTN	DWLN...-P
Approach angle κ	93°	117,5°	95°
Clamping system	Clamp	Clamp	Clamp
Coolant supply	Precision cooling	external	Precision cooling
Shank size h [mm]	20–25		20–25
Shank size h [inch]	0.750–1.000	0.750–1.250	0.750–1.000
Page	71	73	74
			

Positive basic shape

Machining		
Type		
Designation	DDJC...-P	DVJB...-P
Approach angle κ	93°	93°
Clamping system	Clamp	Clamp
Coolant supply	Precision cooling	Precision cooling
Shank size h [mm]	20–25	20–25
Shank size h [inch]		
Page	76	77

Ceramic indexable inserts

Machining		
Type		
Designation	CRSN...-P	
Approach angle κ	0°	
Clamping system	Clamp	
Coolant supply	Precision cooling	
Shank size h [mm]	25	
Shank size h [inch]		
Page	78	

Walter Turn turning tools product range overview – External machining

Walter Capto™ turning toolholders

Negative basic shape

Machining					
Type					
Designation	C...-DCLN...-P	C...-DDHN...-P	C...-DDJN...-P	C...-DDUN...-P	C...-DVJN...-P
Lead angle κ	95°	107,5°	93°	93°	93°
Clamping system	Clamp	Clamp	Clamp	Clamp	Clamp
Coolant supply	Precision cooling	Precision cooling	Precision cooling	Precision cooling	Precision cooling
Walter Capto™ size	C4–C8	C6	C4–C8	C6	C4–C6
Insert size l [mm]	12–16	15	11–15	15	16
Page	79	80	81	82	83

Positive basic shape

Machining		
Type		
Designation	C...-DDJC...-P	C...-DVJB...-P
Lead angle κ	93°	93°
Clamping system	Clamp	Clamp
Coolant supply	Precision cooling	Precision cooling
Walter Capto™ size	C4–C5	C4–C8
Insert size l [mm]	11	16
Page	84	85

Ceramic indexable inserts

Machining	
Type	
Designation	C...-CRSN...-P
Approach angle κ	0°
Clamping system	Clamp
Coolant supply	Precision cooling
Walter Capto™ size	C6
Insert size l [mm]	12
Page	86

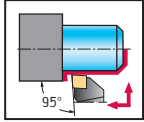
Shank tool – Rigid clamping

DCLN...-P

Walter Turn



– Precision cooling



Tool	Designation		h = h ₁ mm	b mm	b ₁ mm	f mm	l ₁ mm	l ₄ mm	γ	λ _s	Type	
	DCLNR/L2020X12-P		12	20	20	10	25	115	38,5	-6°	-6°	CN .. 1204 ..
	DCLNR/L2525X12-P		12	25	25	4	32	130	38,5	-6°	-6°	
	DCLNR/L2525X16-P		16	25	25	12	32	135	43,5	-6°	-6°	CN .. 1606 ..
	DCLNR/L3232X16-P		16	32	32	6	40	147	43,5	-6°	-6°	

Measured with master insert: CN .. 120408 / CN .. 160612

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DCLNR2020X12-P/ordering example, left-hand tool: DCLNL2020X12-P

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

Assembly parts	Type	CN .. 1204 ..		CN .. 1606 ..	
	Shim	AP301-CN12		AP302-CN16	
	Screw for shim	FS1461 (Torx 15IP)		FS1463 (Torx 20IP)	
	Tightening torque	2,5 Nm		5,0 Nm	
	Left clamp	PK265L		PK267	
	Right clamp	PK265R		PK267	
	Clamp screw	FS1473 (Torx 15IP)		FS1474 (Torx 20IP)	
	Tightening torque	3,9 Nm		6,4 Nm	
	Pressure spring	FS2188		FS2298	
	G 1/8" threaded plug	FS2258 (SW 5)		FS2258 (SW 5)	
	M6 threaded plug	FS2288 (SW 3)		FS2288 (SW 3)	
	Torx key	FS1465 (Torx 15IP / SW 3,5)		FS1464 (Torx 20IP)	

Accessories	Type	CN .. 1204 ..		CN .. 1606 ..	
	Left clamp set (standard assembly parts)	PK265L-SET		PK267-SET	
	Right clamp set (standard assembly parts)	PK265R-SET		PK267-SET	

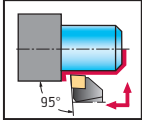
Shank tool – Rigid clamping

DCLN...-P inch

Walter Turn



– Precision cooling



Tool	Designation	(in)	$h = h_1$ inch	b inch	b_1 inch	f inch	l_1 inch	l_4 inch	γ	λ_s	Type
	DCLNR/L124B-P	0,500	0,750	0,750	0,394	1,000	4,500	1,575	-6°	-6°	CN .. 1204 ..
	DCLNR/L164D-P	0,500	1,000	1,000	0,157	1,250	6,000	1,516	-6°	-6°	
	DCLNR/L165D-P	0,625	1,000	1,000	0,472	1,250	6,000	1,713	-6°	-6°	

Measured with master insert: CN .. 120408 / CN .. 160612
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: DCLNR124B-P/ordering example, left-hand tool: DCLNL124B-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		CN .. 1204 ..	CN .. 1606 ..
	Shim	AP301-CN12	AP302-CN16
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm	FS1463 (Torx 20IP) 5,0 Nm
	Left clamp	PK265L	PK267
	Right clamp	PK265R	PK267
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm	FS1474 (Torx 20IP) 6,4 Nm
	Pressure spring	FS2188	FS2298
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)	FS1464 (Torx 20IP)

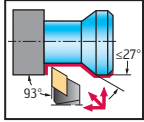
Accessories		CN .. 1204 ..	CN .. 1606 ..
	Left clamp set (standard assembly parts)	PK265L-SET	PK267-SET
	Right clamp set (standard assembly parts)	PK265R-SET	PK267-SET

Shank tool – Rigid clamping

DDJN...-P

Walter Turn

– Precision cooling



Tool	Designation		h = h ₁ mm	b mm	b ₁ mm	f mm	l ₁ mm	l ₄ mm	γ	λ _s	Type	
	DDJNR/L2020X11-P		11	20	20	6	25	125	48,5	-6°	-7°	DN .. 1104 ..
	DDJNR/L2525X11-P		11	25	25	3	32	140	48,5	-6°	-7°	DN .. 1104 ..
	DDJNR/L2020X15-P		15	20	20	7	25	125	48,5	-6°	-7°	DN .. 1506 ..
	DDJNR/L2525X15-P		15	25	25	3	32	140	48,5	-6°	-7°	DN .. 1506 ..

Measured with master insert: DN .. 110408 / DN .. 150608

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DDJNR2020X11-P/ordering example, left-hand tool: DDJNL2020X11-P

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

Assembly parts	Type	DN .. 1104 ..		DN .. 1506 ..	
	Shim	AP305-DN11		AP304-DN15	
	Screw for shim	FS1462 (Torx 9IP)		FS1461 (Torx 15IP)	
	Tightening torque	1,5 Nm		2,5 Nm	
	Left clamp	PK261L		PK265L	
	Right clamp	PK261R		PK265R	
	Clamp screw	FS1473 (Torx 15IP)		FS1473 (Torx 15IP)	
	Tightening torque	3,9 Nm		3,9 Nm	
	Pressure spring	FS2188		FS2188	
	G 1/8" threaded plug	FS2258 (SW 5)		FS2258 (SW 5)	
	M6 threaded plug	FS2288 (SW 3)		FS2288 (SW 3)	
	Torx key	FS1465 (Torx 15IP / SW 3,5)		FS1465 (Torx 15IP / SW 3,5)	

Accessories	Type	DN .. 1104 ..		DN .. 1506 ..	
	Left clamp set (standard assembly parts)	PK261L-SET		PK265L-SET	
	Right clamp set (standard assembly parts)	PK261R-SET		PK265R-SET	
	Shim for DN .. 1504 ..			AP304-DN1504	

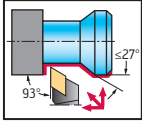
Shank tool – Rigid clamping

DDJN...-P inch

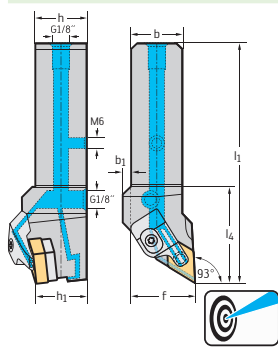
Walter Turn




– Precision cooling



Tool



Designation	 h = h ₁ inch	b inch	b ₁ inch	f inch	l ₁ inch	l ₄ inch	γ	λ _s	Type
DDJNR/L163D-P	0,375	1,000	1,000	0,118	1,250	6,000	-6°	-7°	DN .. 1104 ..
DDJNR/L124B-P	0,500	0,750	0,750	0,276	1,000	4,500	-6°	-7°	DN .. 1504 ..
DDJNR/L164D-P	0,500	1,000	1,000	0,118	1,250	6,000	-6°	-7°	

Measured with master insert: DN .. 110408 / DN .. 150408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"


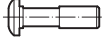



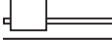
For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)




Ordering example, right-hand tool: DDJNR163D-P/ordering example, left-hand tool: DDJNL163D-P

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

Assembly parts

Type	DN .. 1104 ..	DN .. 1504 ..
 Shim	AP305-DN11	AP304-DN1504
 Screw for shim Tightening torque	FS1462 (Torx 9IP) 1,5 Nm	FS1461 (Torx 15IP) 2,5 Nm
 Left clamp	PK261L	PK265L
 Right clamp	PK261R	PK265R
 Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm	FS1473 (Torx 15IP) 3,9 Nm
 Pressure spring	FS2188	FS2188
 G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
 M6 threaded plug	FS2288 (SW 3)	FS2288 (SW 3)
 Torx key	FS1465 (Torx 15IP /SW 3,5)	FS1465 (Torx 15IP /SW 3,5)

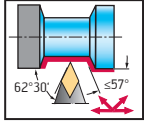
Accessories

Type	DN .. 1104 ..	DN .. 1504 ..
 Left clamp set (standard assembly parts)	PK261L-SET	PK265L-SET
 Right clamp set (standard assembly parts)	PK261R-SET	PK265R-SET
 Shim for DN .. 1506 ..		AP304-DN15

Shank tool – Rigid clamping

DDPN inch

Walter Turn



Tool	Designation		$h = h_1$	b	f	l_1	l_4	γ	λ_s	Type
		inch	inch	inch	inch	inch	inch	°	°	
	DDPNN124B	0,500	0,750	0,750	0,375	4,500	1,610	-5°	-9°	DN .. 1504 ..
	DDPNN164D	0,500	1,000	1,000	0,500	6,000	1,610	-5°	-9°	
	DDPNN204D	0,500	1,250	1,250	0,625	6,000	1,610	-5°	-9°	

Measured with master insert: DN .. 150408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Type	DN .. 1504 ..
	Shim		AP304-DN1504
	Screw for shim Tightening torque		FS1461 (Torx 15IP) 2,5 Nm
	Clamp		PK241
	Clamp screw Tightening torque		FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring		FS1470
	Pin		RS117
	Torx key		FS1465 (Torx 15IP /SW 3,5)

Accessories		Type	DN .. 1504 ..
	Clamp set (standard assembly parts)		PK241-SET
	Carbide clamp set Insert with drilled hole		PK245-SET
	Carbide clamp set Insert without drilled hole		PK254-SET
	Shim for DN .. 1504 ..		AP304-DN1504
	Shim for DN .. 1507 ..		AP412-DN1507

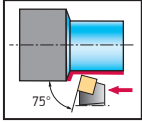
Shank tool – Rigid clamping

DSBN...-P

Walter Turn



– Precision cooling



Tool	Designation		h = h ₁ mm	b mm	b ₁ mm	f mm	l ₁ mm	l ₄ mm	γ	λ _s	Type
	DSBNR/L2525X12-P	12	25	25	7	22	135	43,5	-6°	-6°	SN .. 1204 ..

Measured with master insert: SN .. 120408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DSBNR2525X12-P/ordering example, left-hand tool: DSBNL2525X12-P

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

Assembly parts	Type	SN .. 1204 ..
	Shim	AP308-SN12
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Left clamp	PK265L
	Right clamp	PK265R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories	Type	SN .. 1204 ..
	Left clamp set (standard assembly parts)	PK265L-SET
	Right clamp set (standard assembly parts)	PK265R-SET

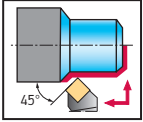
Shank tool – Rigid clamping

DSSN...-P

Walter Turn



– Precision cooling



Tool	Designation		$h = h_1$	b	f	f_1	l_1	l_4	l_{20}	γ	λ_s	Type
			mm	mm	mm	mm	mm	mm	mm	mm		
	DSSNR/L2525X12-P	12	25	25	32	23,7	130	48	138,7	-8°	0°	SN .. 1204 ..

Measured with master insert: SN .. 120408
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: DSSNR2525X12-P/ordering example, left-hand tool: DSSNL2525X12-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		
Type	SN .. 1204 ..	
	Shim	AP308-SN12
	Screw for shim	FS1461 (Torx 15IP)
	Tightening torque	2,5 Nm
	Left clamp	PK265L
	Right clamp	PK265R
	Clamp screw	FS1473 (Torx 15IP)
	Tightening torque	3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories		
Type	SN .. 1204 ..	
	Left clamp set (standard assembly parts)	PK265L-SET
	Right clamp set (standard assembly parts)	PK265R-SET

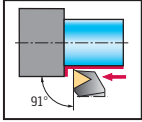
Shank tool – Rigid clamping

DTGN...-P inch

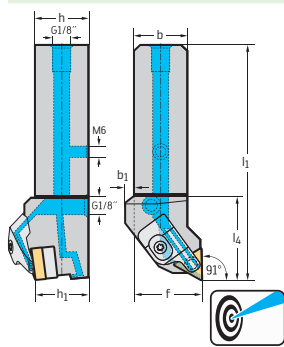
Walter Turn



– Precision cooling



Tool



Designation		h = h ₁ inch	b inch	b ₁ inch	f inch	l ₁ inch	l ₄ inch	γ	λ _s	Type	
DTGNR/L123B-P		0,375	0,750	0,750	0,000	1,000	4,500	1,516	-6°	-6°	TN .. 1604 ..
DTGNR/L163D-P		0,375	1,000	1,000	0,000	1,250	6,000	1,520	-6°	-6°	

Measured with master insert: TN .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

Ordering example, right-hand tool: DTGNR123B-P/ordering example, left-hand tool: DTGNL123B-P

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

Assembly parts

Type	TN .. 1604 ..
Shim	AP321-TN16
Screw for shim Tightening torque	FS1462 (Torx 9IP) 1,5 Nm
Left clamp	PK261L
Right clamp	PK261R
Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
Pressure spring	FS2188
G 1/8" threaded plug	FS2258 (SW 5)
M6 threaded plug	FS2288 (SW 3)
Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories

Type	TN .. 1604 ..
Left clamp set (standard assembly parts)	PK261L-SET
Right clamp set (standard assembly parts)	PK261R-SET

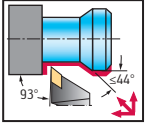
Shank tool – Rigid clamping

DVJN...-P

Walter Turn



– Precision cooling



Tool	Designation	h = h ₁ mm	b mm	b ₁ mm	f mm	l ₁ mm	l ₄ mm	γ	λ _s	Type	
	DVJNR/L2020X16-P	16	20	20	4	25	125	48,5	-4°	-13°	VN .. 1604 ..
	DVJNR/L2525X16-P	16	25	25	0	32	140	48	-4°	-13°	

Measured with master insert: VN .. 160408
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 Ordering example, right-hand tool: DVJNR2020X16-P/ordering example, left-hand tool: DVJNL2020X16-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	VN .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories	Type	VN .. 1604 ..
	Left clamp set (standard assembly parts)	PK261L-SET
	Right clamp set (standard assembly parts)	PK261R-SET

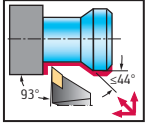
Shank tool – Rigid clamping

DVJN...-P inch

Walter Turn



– Precision cooling



Tool

Designation	h = h ₁ inch	b inch	b ₁ inch	f inch	l ₁ inch	l ₄ inch	γ	λ _s	Type
DVJNR/L123B-P	0,375	0,750	0,750	0,157	1,000	4,496	-4°	-13°	VN .. 1604 ..
DVJNR/L163D-P	0,375	1,000	1,000	0,000	1,250	5,996	-4°	-13°	

Measured with master insert: VN .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DVJNR123B-P/ordering example, left-hand tool: DVJNL123B-P

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

Assembly parts

Type	VN .. 1604 ..
Shim	AP312-VN16
Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
Left clamp	PK261L
Right clamp	PK261R
Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
Pressure spring	FS2188
G 1/8" threaded plug	FS2258 (SW 5)
M6 threaded plug	FS2288 (SW 3)
Torx key	FS1465 (Torx 15IP /SW 3,5)

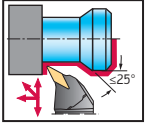
Accessories

Type	VN .. 1604 ..
Left clamp set (standard assembly parts)	PK261L-SET
Right clamp set (standard assembly parts)	PK261R-SET

Shank tool – Rigid clamping

DVTN inch

Walter Turn



Tool	Designation	$h = h_1$ inch	b inch	f inch	l_1 inch	l_4 inch	γ	λ_s	Type
	DVTNR/L123B	0,375	0,750	0,750	1,000	4,500	-4°	-13°	VN .. 1604 ..
	DVTNR/L163D	0,375	1,000	1,000	1,250	6,000	-4°	-13°	
	DVTNR/L203D	0,375	1,250	1,250	1,500	6,000	-4°	-13°	

Measured with master insert: VN .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

Ordering example, right-hand tool: DVTNR123B/ordering example, left-hand tool: DVTNL123B

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

Assembly parts	Type	VN .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Clamp	PK244
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS1470
	Pin	RS117
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories	Type	VN .. 1604 ..
	Clamp set (standard assembly parts)	PK244-SET

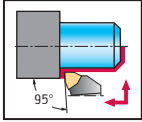
Shank tool – Rigid clamping

DWLN...-P

Walter Turn



– Precision cooling



Tool

Designation		h = h ₁ mm	b mm	b ₁ mm	f mm	l ₁ mm	l ₄ mm	γ	λ _s	Type
DWLNLR/L2020X08-P		8	20	20	0	25	120,0	-7°	-6°	WN .. 0804 ..
DWLNLR/L2525X08-P		8	25	25	0	32	135,0	-7°	-6°	

Measured with master insert: WN .. 080408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DWLNLR2020X08-P/ordering example, left-hand tool: DWLNL2020X08-P

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

Assembly parts

Type	WN .. 0804 ..
Shim	AP307-WN08
Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
Left clamp	PK266L
Right clamp	PK266R
Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
Pressure spring	FS2188
G 1/8" threaded plug	FS2258 (SW 5)
M6 threaded plug	FS2288 (SW 3)
Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories

Type	WN .. 0804 ..
Left clamp set (standard assembly parts)	PK266L-SET
Right clamp set (standard assembly parts)	PK266R-SET

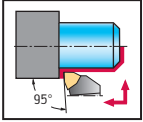
Shank tool – Rigid clamping

DWLN...-P **inch**

Walter Turn



– Precision cooling



Tool	Designation		h = h ₁ inch	b inch	b ₁ inch	f inch	l ₁ inch	l ₄ inch	γ	λ _s	Type
	DWLN/L124B-P		0,500	0,750	0,750	1,000	4,500	1,713	-6°	-6°	WN .. 0804 ..
	DWLN/L164D-P		0,500	1,000	1,000	1,250	6,000	1,713	-7°	-6°	

Measured with master insert: WN .. 080408
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 Ordering example, right-hand tool: DWLN/L124B-P/ordering example, left-hand tool: DWLN/L124B-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	WN .. 0804 ..
	Shim	AP307-WN08
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Left clamp	PK266L
	Right clamp	PK266R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP / SW 3,5)

Accessories	Type	WN .. 0804 ..
	Left clamp set (standard assembly parts)	PK266L-SET
	Right clamp set (standard assembly parts)	PK266R-SET

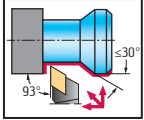
Shank tool – Rigid clamping


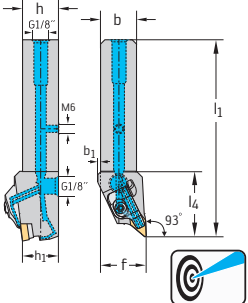
DDJC...-P

Walter Turn



– Precision cooling



Tool	Designation		$h = h_1$ mm	b mm	b_1 mm	f mm	l_1 mm	l_4 mm	γ	λ_s	Type
	DDJCR/L2020X11-P		11	20	20	6	25	125	-3°	-7°	DC .. 11T3 ..
	DDJCR/L2525X11-P		11	25	25	0	32	140	-3°	-7°	

Measured with master insert: DC .. 11T308

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"




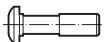



For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: DDJCR2020X11-P/ordering example, left-hand tool: DDJCL2020X11-P

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

Assembly parts

	Type	DC .. 11T3 ..
	Shim for radius	AP315-DC1108 $r \leq 0,8$ mm
	Screw for shim	FS2068 (SW 3,5)
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw	FS1473 (Torx 15IP)
	Tightening torque	3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories

	Type	DC .. 11T3 ..
	Left clamp set (standard assembly parts)	PK261L-SET
	Right clamp set (standard assembly parts)	PK261R-SET

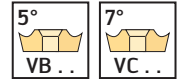
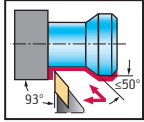
Shank tool – Rigid clamping

DVJB...-P

Walter Turn



– Precision cooling



Tool	Designation	h = h ₁		b	b ₁	f	l ₁	l ₄	γ	λ _s	Type
		mm	mm								
	DVJBR/L2020X16-P	16	20	20	4	25	125	48,5	-2°	-7°	VB .. 1604 ..
	DVJBR/L2525X16-P	16	25	25	0	32	140	48,5	-2°	-7°	VC .. 1604 ..

Measured with master insert: VB .. 160408
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: DVJBR2020X16-P/ordering example, left-hand tool: DVJBL2020X16-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	VB .. 1604 .. VC .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

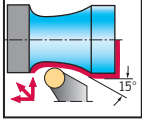
Accessories	Type	VB .. 1604 .. VC .. 1604 ..
	Left clamp set (standard assembly parts)	PK261L-SET
	Right clamp set (standard assembly parts)	PK261R-SET


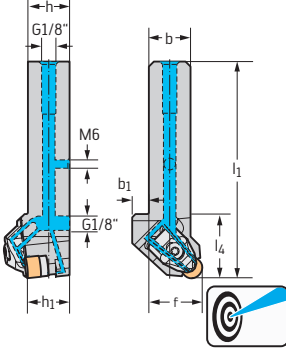
Shank tool – Rigid clamping

CRSN...-P

Walter Turn

- Precision cooling
- For ceramic indexable inserts



Tool	Designation		$h = h_1$ mm	b mm	b_1 mm	f mm	l_1 mm	l_4 mm	γ	λ_s	Type
	CRSNR/L2525X12-P	12	25	25	10	32	130	38,5	-6°	-6°	RN .. 1207 ..

Measured with master insert: RN .. 120700

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"








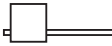
For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)


Ordering example, right-hand tool: CRSNR2525X12-P/ordering example, left-hand tool: CRSNL2525X12-P

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

Assembly parts

	Type	RN .. 1207 ..
	Shim	AP418-RN1207
	Screw for shim Tightening torque	FS2241 (Torx 20) 5,0 Nm
	Clamp	PK268
	Clamp screw Tightening torque	FS1474 (Torx 20IP) 6,4 Nm
	Pressure spring	FS2298
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1464 (Torx 20IP)

Accessories

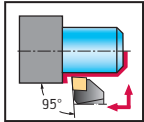
	Type	RN .. 1207 ..
	Clamp set (standard assembly parts)	PK268-SET

Turning toolholders – Rigid clamping

C...-DCLN...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation		d ₁	f mm	l ₄ mm	D _{min} mm	D _{min2} mm	γ	λ _s	Type
	Walter Capto™ in acc. with ISO 26623 C4-DCLNR/L-27050-12-P	12	C4	27	50	500	500	-6°	-6°	CN .. 1204 ..
	C5-DCLNR/L-35060-12-P	12	C5	35	60	600	600	-6°	-6°	
	C6-DCLNR/L-45065-12-P	12	C6	45	65	600	600	-6°	-6°	
	C8-DCLNR/L-55080-12-P	12	C8	55	80	700	700	-6°	-6°	
	C5-DCLNR/L-35060-16-P	16	C5	35	60	600	600	-6°	-6°	CN .. 1606 ..
	C6-DCLNR/L-45065-16-P	16	C6	45	65	600	600	-6°	-6°	
	C8-DCLNR/L-55080-16-P	16	C8	55	80	700	700	-6°	-6°	

Measured with master insert: CN .. 120408 / CN .. 160612

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C4-DCLNR-27050-12-P/ordering example, left-hand tool: C4-DCLNL-27050-12-P

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

Assembly parts		CN .. 1204 ..	CN .. 1606 ..
	Shim	AP301-CN12	AP302-CN16
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm	FS1463 (Torx 20IP) 5,0 Nm
	Clamp	PK255	PK267
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm	FS1474 (Torx 20IP) 6,4 Nm
	Pressure spring	FS2188	FS2298
	Torx key	FS1465 (Torx 15IP /SW 3,5)	FS1464 (Torx 20IP)

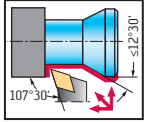
Accessories		CN .. 1204 ..	CN .. 1606 ..
	Clamp set (standard assembly parts)	PK255-SET	PK267-SET

Turning toolholders – Rigid clamping

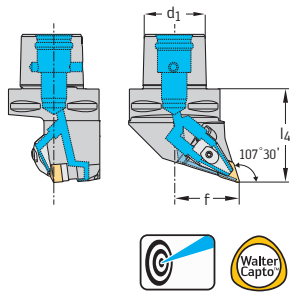
C...-DDHN...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation		d_1	f mm	l_4 mm	D_{min} mm	D_{min2} mm	γ	λ_s	Type
Walter Capto™ in acc. with ISO 26623	C6-DDHNR/L-45065-15-P	15	C6	45	65	500	700	-6°	7°	DN .. 1506 ..



Measured with master insert: DN .. 150608

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C6-DDHNR-45065-15-P/ordering example, left-hand tool: C6-DDHNL-45065-15-P

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

Assembly parts	Type	DN .. 1506 ..
	Shim	AP304-DN15
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Clamp	PK256
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	Torx key	FS1465 (Torx 15IP /SW 3,5)

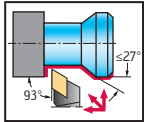
Accessories	Type	DN .. 1506 ..
	Clamp set (standard assembly parts)	PK256-SET
	Shim for DN .. 1504 ..	AP304-DN1504

Turning toolholders – Rigid clamping

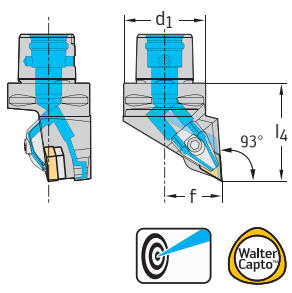
C...-DDJN...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool		Designation		d ₁	f mm	l ₄ mm	D _{min} mm	D _{min2} mm	γ	λ _s	Type
Walter Capto™ in acc. with ISO 26623		C4-DDJNR/L-27055-11-P	11	C4	27	55	500	500	-6°	-7°	DN .. 1104 ..
		C4-DDJNR/L-27055-15-P	15	C4	27	55	500	500	-6°	-7°	DN .. 1506 ..



Measured with master insert: DN .. 110408 / DN .. 150608
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: C4-DDJNR-27055-11-P/ordering example, left-hand tool: C4-DDJNL-27055-11-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts			
Type	DN .. 1104 ..	DN .. 1506 ..	
	Shim	AP305-DN11	AP304-DN15
	Screw for shim Tightening torque	FS1462 (Torx 9IP) 1,5 Nm	FS1461 (Torx 15IP) 2,5 Nm
	Clamp	PK255	PK256
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188	FS2188
	Torx key	FS1465 (Torx 15IP / SW 3,5)	FS1465 (Torx 15IP / SW 3,5)

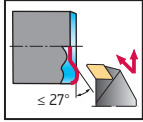
Accessories			
Type	DN .. 1104 ..	DN .. 1506 ..	
	Clamp set (standard assembly parts)	PK255-SET	PK256-SET
	Shim for DN .. 1504 ..		AP304-DN1504


Turning toolholders – Rigid clamping

C...-DDUN...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation		d_1	f mm	l_4 mm	D_{min} mm	D_{min2} mm	γ	λ_s	Type
Walter Capto™ in acc. with ISO 26623	C6-DDUNR/L-45065-15-P	15	C6	45	65	500	600	-7°	-6°	DN .. 1506 ..




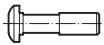


Measured with master insert: DN .. 150608



For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C6-DDUNR-45065-15-P/ordering example, left-hand tool: C6-DDUNL-45065-15-P

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

Assembly parts	Type	DN .. 1506 ..
	Shim	AP304-DN15
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Clamp	PK256
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	Torx key	FS1465 (Torx 15IP /SW 3,5)

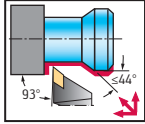
Accessories	Type	DN .. 1506 ..
	Clamp set (standard assembly parts)	PK256-SET
	Shim for DN .. 1504 ..	AP304-DN1504


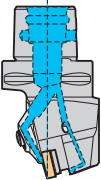
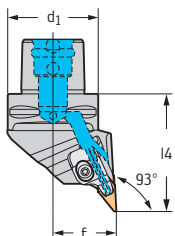

Turning toolholders – Rigid clamping

C...-DVJN...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation		d_1	f mm	l_4 mm	D_{min} mm	D_{min2} mm	γ	λ_s	Type	
Walter Capto™ in acc. with ISO 26623	C4-DVJNR/L-27062-16-P		16	C4	27	62	500	125	-4°	-13°	VN .. 1604 ..
	C5-DVJNR/L-35065-16-P		16	C5	35	65	600	150	-4°	-13°	
	C6-DVJNR/L-45065-16-P		16	C6	45	65	700	150	-4°	-13°	
											






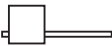
Measured with master insert: VN .. 160408


For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C4-DVJNR-27062-16-P/ordering example, left-hand tool: C4-DVJNL-27062-16-P

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

Assembly parts	Type	VN .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	Torx key	FS1465 (Torx 15IP /SW 3,5)

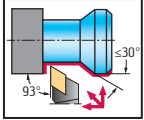
Accessories	Type	VN .. 1604 ..
	Left clamp set	PK261L-SET
	Right clamp set	PK261R-SET

Turning toolholders – Rigid clamping

C...-DDJC...-P 

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation		d_1	f mm	l_4 mm	D_{min} mm	D_{min2} mm	γ	λ_s	Type
Walter Capto™ in acc. with ISO 26623	C4-DDJCR/L-27050-11-P	11	C4	27	50	1200	250	-3°	-7°	DC .. 11T3 ..
	C5-DDJCR/L-35060-11-P	11	C5	35	60	1400	300	-3°	-7°	

Measured with master insert: DC .. 11T308

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C4-DDJCR-27050-11-P/ordering example, left-hand tool: C4-DDJCL-27050-11-P

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

Assembly parts

	Type	DC .. 11T3 ..
	Shim for radius	AP315-DC1108 $r \leq 0,8$ mm
	Screw for shim	FS2068 (SW 3,5)
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories

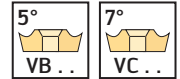
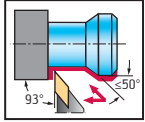
	Type	DC .. 11T3 ..
	Left clamp set (standard assembly parts)	PK261L-SET
	Right clamp set (standard assembly parts)	PK261R-SET

Turning toolholders – Rigid clamping

C...-DVJB...-P

Walter Turn

- Precision cooling
- Walter Capto™



Tool	Designation	d ₁	f mm	l ₄ mm	D _{min} mm	D _{min2} mm	γ	λ _s	Type
 	Walter Capto™ in acc. with ISO 26623 C4-DVJBR/L-27062-16-P	16	C4	27	62	2200	250	-2°	-7°
	C5-DVJBR/L-35065-16-P	16	C5	35	65	2400	300	-2°	-7°
	C6-DVJBR/L-45065-16-P	16	C6	45	65	2500	350	-2°	-7°
	C8-DVJBR/L-55080-16-P	16	C8	55	65	2800	400	-2°	-7°
									VB .. 1604 ..
									VC .. 1604 ..

Measured with master insert: VB .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C4-DVJBR-27062-16-P/ordering example, left-hand tool: C4-DVJBL-27062-16-P

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

Assembly parts	Type	VB .. 1604 .. VC .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Left clamp	PK261L
	Right clamp	PK261R
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS2188
	Torx key	FS1465 (Torx 15IP /SW 3,5)

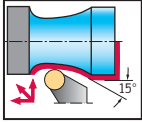
Accessories	Type	VB .. 1604 .. VC .. 1604 ..
	Left clamp set (standard assembly parts)	PK261L-SET
	Right clamp set (standard assembly parts)	PK261R-SET



Turning toolholders – Rigid clamping

C...-CRSN...-P 

Walter Turn

- Precision cooling
- For ceramic indexable inserts



Tool	Designation		d ₁	f mm	l ₄ mm	D _{min} mm	D _{min2} mm	γ	λ _s	Type	
Walter Capto™ in acc. with ISO 26623	C6-CRSNR/L-45065-12-P		12	C6	45	65	600	700	-6°	-6°	RN .. 1207 ..







Measured with master insert: RN .. 120700


For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

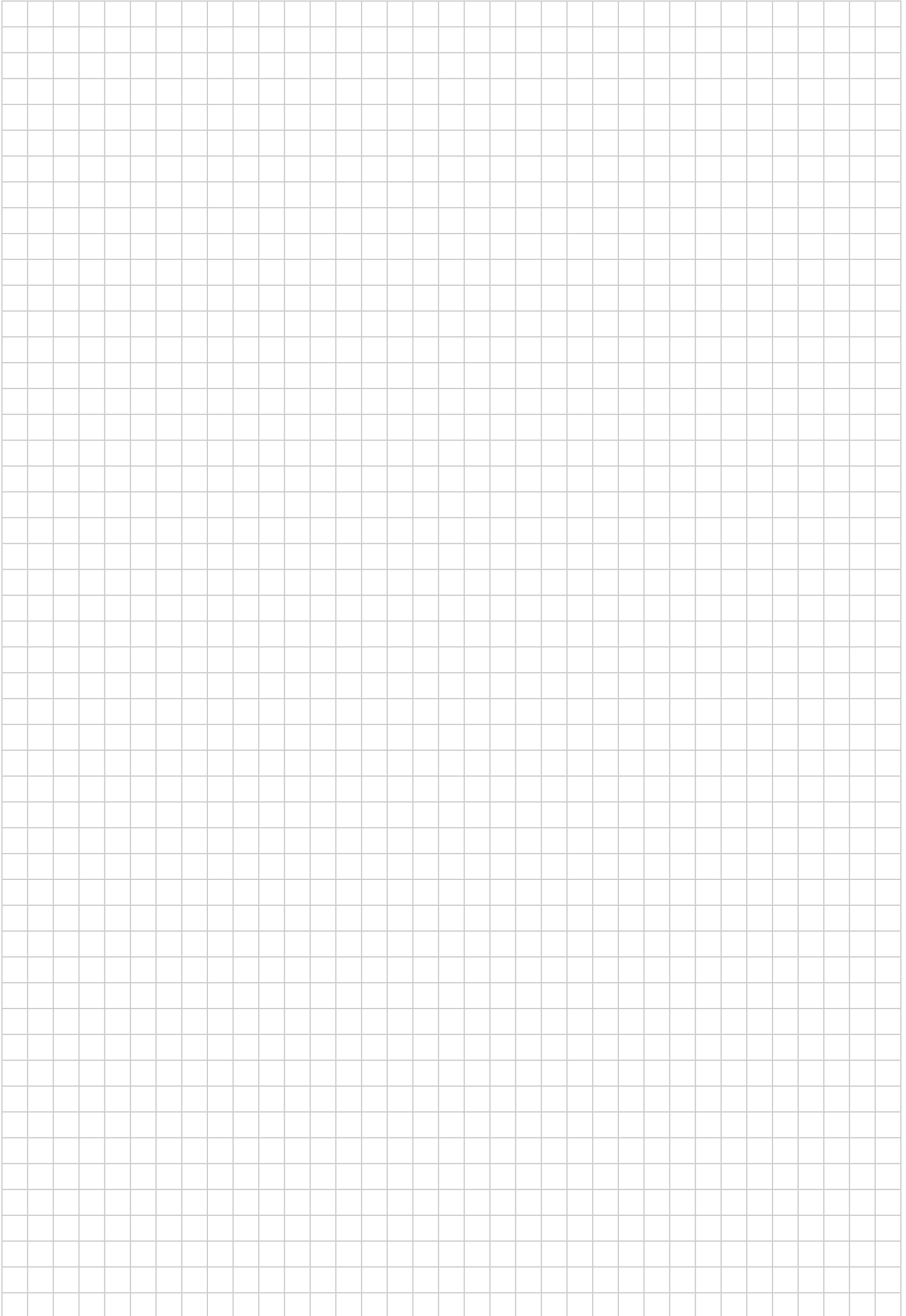
The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: C6-CRSNR-45065-12-P/ordering example, left-hand tool: C6-CRSNL-45065-12-P

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

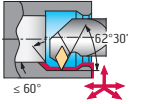
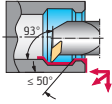
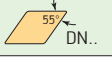
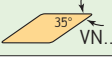


Assembly parts	Type	RN .. 1207 ..
	Shim	AP418-RN1207
	Screw for shim Tightening torque	FS2241 (Torx 20) 5,0 Nm
	Clamp	PK268
	Clamp screw Tightening torque	FS1474 (Torx 20IP) 6,4 Nm
	Pressure spring	FS2298
	Torx key	FS1464 (Torx 20IP)

Accessories	Type	RN .. 1207 ..
	Clamp set (standard assembly parts)	PK268-SET

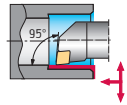
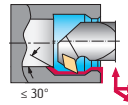
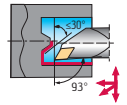
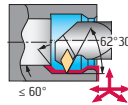
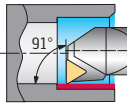
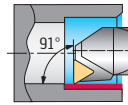
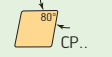
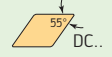
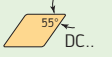
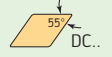










Walter Turn turning tools product range overview – Internal machining Boring bars

Negative basic shape

Machining		
Type		
Designation	A...-DDXN	A...-DVUN
Approach angle κ	93°	93°
Clamping system	Clamp	Clamp
Coolant supply	internal	internal
Boring bar diameter d ₁ [mm]	32–40	32–38
Insert size l [mm]	11–15	16
Page	91	92
		

Positive basic shape

Machining						
Type						
Designation	A...-SCLP / E...-SCLP	A...-SDUC...-X	A...-SDJC	A...-SDXC...	A...-STFC	E...-STFC
Approach angle κ	95°	93°	93°	62,5°	91°	91°
Clamping system	Screw	Screw	Screw	Screw	Screw	Screw
Coolant supply	internal	internal	internal	internal	internal	internal
Boring bar diameter d ₁ [mm]	8–25	25–32	16–25	12–25	10–32	10–25
Insert size l [mm]	6–9	7–11	7–11	7–11	11–16	9–16
Page	93	94	95	96	97	97
						

Positive basic shape

Machining		
Type		
Designation	A...-SVJB	A2140-W
Approach angle κ	93°	
Clamping system	Screw	
Coolant supply	internal	axial
Boring bar diameter d_1 [mm]	16–20	25–40
Insert size l [mm]	11	0
Page	98	99

Walter Turn turning tools product range overview – Internal machining Accure-tec vibration-damped boring bar / adaptor

Designation	A3000	A3000-C	A3000-HSK-T
Tool type	QuadFit adaptors		
Machine-interface	Parallel shank	Walter Capto™ in acc. with ISO 26623	HSK-T DIN 69893-7
Cutting Head interface	Q32 / Q40 / Q50	Q32 / Q40 / Q50	Q32 / Q40 / Q50
Boring bar diameter d_2 [mm]	32–50	32–50	32–50
Boring bar length l_4 [mm]	160–470	160–468	224–468
Page	100	102	103

Walter Turn turning tools product range overview – Internal machining QuadFit exchangeable head

Negative basic shape

Machining			
Type			
Designation	Q...-DCLN	Q...-DDUN	Q...-DWLN
Lead angle κ	95°	93°	95°
Clamping system	Clamp	Clamp	Clamp
Coolant supply	internal	internal	internal
QuadFit size	Q32-Q50	Q32-Q50	Q32-Q50
Insert size l [mm]	12-16	15	8
Page	104	105	106

Positive basic shape

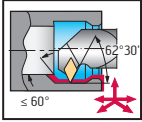
Machining						
Type						
Designation	Q...-SCLC	Q...-SDUC	Q...-SDUC...-X	Q...-SDXC	Q...-STFC	Q...-SVUB
Lead angle κ	95°	93°	93°	62,5°	90°	93°
Clamping system	Screw	Screw	Screw	Screw	Screw	Screw
Coolant supply	internal	internal	internal	internal	internal	internal
QuadFit size	Q32-Q50	Q32-Q50	Q32-Q50	Q32-Q50	Q32-Q50	Q32-Q50
Insert size l [mm]	9-12	11	11	11	16	16
Page	107	108	109	110	111	112

Boring bar – Rigid clamping

A...-DDXN

Walter Turn

- A = Steel version with internal coolant
- Additional coolant hole for blind hole machining



Tool	Designation		D_{min} mm	d_1 mm	f mm	h mm	l_1 mm	l_{20} mm	γ	λ_s	Type	
Parallel shank	★ A32T-DDXNR/L11		11	40	32	22	30	300	306,1	-6°	-10°	DN .. 1104 ..
	★ A40T-DDXNR/L15		15	50	40	27	37	300	308,5	-6°	-11°	DN .. 1506 ..

Measured with master insert: DN .. 110408 / DN .. 150608

Ordering example, right-hand tool: A32T-DDXNR11/ordering example, left-hand tool: A32T-DDXNL11

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

Assembly parts		DN .. 1104 ..	DN .. 1506 ..
	Shim	AP305-DN11	AP304-DN15
	Screw for shim	FS1462 (Torx 9IP)	FS1461 (Torx 15IP)
	Tightening torque	1,5 Nm	2,5 Nm
	Clamp	PK240	PK241
	Clamp screw	FS1472 (Torx 9IP)	FS1473 (Torx 15IP)
	Tightening torque	1,7 Nm	3,9 Nm
	Pressure spring	FS1469	FS1470
	Pin	RS116	RS117
	Torx key	FS1466 (Torx 9IP)	FS1465 (Torx 15IP /SW 3,5)

Accessories		DN .. 1104 ..	DN .. 1506 ..
	Clamp set (standard assembly parts)	PK240-SET	PK241-SET
	Carbide clamp set Insert with drilled hole		PK245-SET
	Carbide clamp set Insert without drilled hole		PK254-SET
	Shim for DN .. 1504 ..	AP304-DN1504	AP304-DN1504

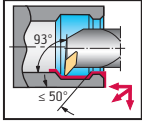
Boring bar – Rigid clamping

A...-DVUN inch

Walter Turn

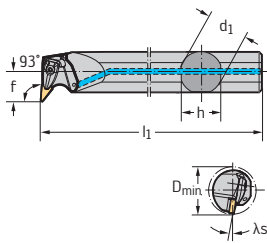


– A = Steel version with internal coolant



Tool

	Designation	inch	D _{min} inch	d ₁ inch	f inch	h inch	l ₁ inch	γ	λ _s	Type
Parallel shank	A20T-DVUNR/L3	0,375	1,705	1,250	1,000	1,181	12,000	-6°	-9°	VN .. 1604 ..
	A24T-DVUNR/L3	0,375	2,000	1,500	1,125	1,374	12,000	-6°	-8°	



Measured with master insert: VN .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

Ordering example, right-hand tool: A20T-DVUNR3/ordering example, left-hand tool: A20T-DVUNL3

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

Assembly parts

	Type	VN .. 1604 ..
	Shim	AP312-VN16
	Screw for shim Tightening torque	FS1467 (Torx 15IP) 3,0 Nm
	Clamp	PK244
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS1470
	Pin	RS117
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories

	Type	VN .. 1604 ..
	Clamp set (standard assembly parts)	PK244-SET

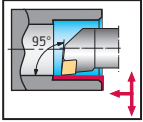
Boring bar – Screw clamping

A...-SCLP / E...-SCLP inch

Walter Turn



- A = Steel version with internal coolant
- E = Solid carbide version with internal coolant



Tool	Designation	(in)	D _{min} inch	d ₁ inch	f inch	h inch	l ₁ inch	γ	λ _s	Type
Parallel shank 	A05K-SCLPR/L2	0,250	0,413	0,313	0,219	0,272	5,000	0°	-9°	CP .. 0602 ..
	A06M-SCLPR/L2	0,250	0,480	0,375	0,250	0,336	6,000	4°	-6,5°	
	A08M-SCLPR/L2	0,250	0,598	0,500	0,312	0,460	6,000	6°	-2,6°	
	A10R-SCLPR/L2	0,250	0,772	0,625	0,406	0,562	8,000	0°	5°	CP .. 09T3 ..
	A12S-SCLPR/L3	0,375	0,929	0,750	0,500	0,709	10,000	0°	-6,3°	
	A16T-SCLPR/L3	0,375	1,201	1,000	0,639	0,906	14,173	6°	1°	
Parallel shank 	E06M-SCLPR/L2	0,250	0,480	0,375	0,250	0,359	6,000	4°	-7°	CP .. 0602 ..
	E08R-SCLPR/L2	0,250	0,598	0,500	0,312	0,484	8,000	6°	-3°	

Measured with master insert: CP.. 060204 / CP .. 09T304

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

Ordering example, right-hand tool: A05K-SCLPR2/ordering example, left-hand tool: A05K-SCLPL2

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

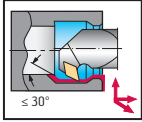
Assembly parts	Type	CP .. 0602 .. 0,413	CP .. 0602 .. 0,480–0,598	CP .. 0602 .. 0,772	CP .. 09T3 .. 0,929	CP .. 09T3 .. 1,201
	Clamping screw for indexable insert	FS2187 (Torx 7IP)	FS2066 (Torx 7IP)	FS2061 (Torx 7IP)	FS2062 (Torx 15IP)	FS2063 (Torx 15IP)
	Tightening torque	0,9 Nm	0,9 Nm	0,9 Nm	3,0 Nm	3,0 Nm
	Torx key	FS1490 (Torx 7IP)	FS1490 (Torx 7IP)	FS1490 (Torx 7IP)	FS1465 (Torx 15IP / SW 3,5)	FS1465 (Torx 15IP / SW 3,5)

Boring bar – Screw clamping

A...-SDUC...-X inch

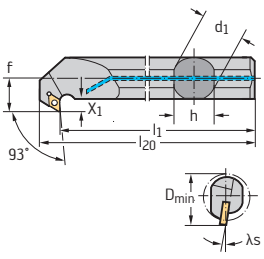
Walter Turn

- A = Steel version with internal coolant
- Reverse copy boring bar



Tool

Designation	D _{min} inch	d ₁ inch	f inch	h inch	l ₁ inch	l ₂₀ inch	γ	λ _s	Type	
Parallel shank A16T-SDUCR/L2-X	0,250	1,299	1,000	0,750	0,906	12,000	12,480	0°	-0,9°	DC .. 0702 ..
A20T-SDUCR/L3-X	0,375	1,579	1,250	0,875	1,181	12,000	12,610	0°	-7,5°	DC .. 11T3 ..



Measured with master insert: DC .. 070204 / DC .. 11T308
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 $X_1 = f - d_1/2$
 Ordering example, right-hand tool: A16T-SDUCR2-X/ordering example, left-hand tool: A16T-SDUCL2-X
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

Type	DC .. 0702 ..	DC .. 11T3 ..
Clamping screw for indexable insert Tightening torque	FS2061 (Torx 7IP) 0,9 Nm	FS2062 (Torx 15IP) 3,0 Nm
Torx key	FS1490 (Torx 7IP)	FS1465 (Torx 15IP /SW 3,5)

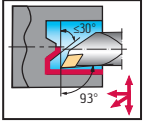
Boring bar – Screw clamping

A...-SDJC

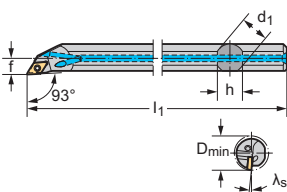
Walter Turn



- A = Steel version with internal coolant
- Additional coolant hole for blind hole machining



Tool	Designation		D_{min} mm	d_1 mm	f mm	h mm	l_1 mm	γ	λ_s	Type
Parallel shank	★ A16R-SDJCR/L07	7	20	16	9	15	200	0°	-6°	DC .. 0702 ..
	★ A20S-SDJCR/L11	11	25	20	11,5	18	250	0°	-6°	DC .. 11T3 ..
	★ A25T-SDJCR/L11	11	32	25	14	23	300	0°	-4°	



Measured with master insert: DC .. 070204 / DC .. 11T308
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 Ordering example, right-hand tool: A16R-SDJCR07/ordering example, left-hand tool: A16R-SDJCL07
 Bodies and assembly parts are included in the scope of delivery.

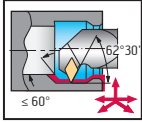
Assembly parts	Type	DC .. 0702 ..	DC .. 11T3 ..
	Clamping screw for indexable insert Tightening torque	FS2061 (Torx 7IP) 0,9 Nm	FS2062 (Torx 15IP) 3,0 Nm
	Torx key	FS1490 (Torx 7IP)	FS1465 (Torx 15IP /SW 3,5)

Boring bar – Screw clamping

A...-SDXC...

Walter Turn

- A = Steel version with internal coolant
- Forwards/reverse copy boring bar



Tool	Designation		D _{min} mm	d ₁ mm	f mm	h mm	l ₁ mm	l ₂₀ mm	γ	λ _s	Type	
Parallel shank	★ A12M-SDXCR/L07		7	16	12	9	11	150	154,3	0°	-4°	DC .. 0702 ..
	★ A16R-SDXCR/L07		7	20	16	11	15	200	205	-2°	-4°	
	★ A20S-SDXCR/L11		11	25	20	13	18	250	257	-3°	-6°	DC .. 11T3 ..
	A25T-SDXCR/L11		11	32	25	17	23	300	306	-2°	-3°	

Measured with master insert: DC .. 070204 / DC .. 11T308

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

$X_1 = f - d_1/2$

Ordering example, right-hand tool: A12M-SDXCR07/ordering example, left-hand tool: A12M-SDXCL07

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

Assembly parts	Type D _{min} [mm]	DC .. 0702 ..	DC .. 11T3 ..	DC .. 11T3 ..
		16–20	25	32
	Clamping screw for indexable insert Tightening torque	FS2061 (Torx 7IP) 0,9 Nm	FS2062 (Torx 15IP) 3,0 Nm	FS2063 (Torx 15IP) 3,0 Nm
	Torx key	FS1490 (Torx 7IP)	FS1465 (Torx 15IP /SW 3,5)	FS1465 (Torx 15IP /SW 3,5)

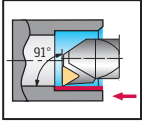
Boring bar – Screw clamping

A...-STFC / E...-STFC inch

Walter Turn



- A = Steel version with internal coolant
- E = Solid carbide version with internal coolant



Tool	Designation		D _{min} inch	d ₁ inch	f inch	h inch	l ₁ inch	γ	λ _s	Type
Parallel shank 	A06M-STFCR/L2		0,250	0,500	0,250	0,336	6,000	0°	-10,1°	TC .. 1102 ..
	A08M-STFCR/L2		0,250	0,598	0,312	0,460	6,000	0°	-7,2°	
	A10R-STFCR/L2		0,250	0,772	0,406	0,562	8,000	0°	-4,7°	
	A12S-STFCR/L2		0,250	0,929	0,500	0,709	10,000	0°	-3,2°	TC .. 16T3 ..
	A16T-STFCR/L3		0,375	1,201	0,640	0,906	12,000	0°	-3,8°	
	A20T-STFCR/L3		0,375	1,469	0,765	1,181	12,000	0°	-8,7°	
Parallel shank	E06M-STFCR/L1.8		0,219	0,500	0,264	0,359	6,000	0°	-9,5°	TC .. 0902 ..
	E08R-STFCR/L1.8		0,219	0,630	0,349	0,460	8,000	0°	-7°	TC .. 1102 ..
	E10R-STFCR/L2		0,250	0,772	0,406	0,609	8,000	0°	-6°	
	E12S-STFCR/L2		0,250	0,929	0,500	0,734	10,000	0°	-4°	
	E16T-STFCR/L3		0,375	1,201	0,640	0,984	12,000	0°	-4°	TC .. 16T3 ..

Measured with master insert: TC .. 110204 / TC .. 16T308 / TC .. 090204 / TC .. 110200

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

Ordering example, right-hand tool: A06M-STFCR2/ordering example, left-hand tool: A06M-STFCL2

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

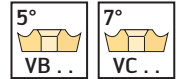
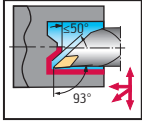
Assembly parts	Type	TC .. 0902 .. D _{min} [inch] 0,500–0,630	TC .. 1102 .. 0,500–0,598	TC .. 1102 .. 0,772–0,929	TC .. 16T3 .. 1,201	TC .. 16T3 .. 1,469
	Clamping screw for indexable insert Tightening torque	FS2149 (Torx 7IP) 0,9 Nm	FS2067 (Torx 7IP) 0,9 Nm	FS2061 (Torx 7IP) 0,9 Nm	FS2063 (Torx 15IP) 3,0 Nm	FS2060 (Torx 15IP) 3,0 Nm
	Torx key	FS1490 (Torx 7IP)	FS1490 (Torx 7IP)	FS1490 (Torx 7IP)	FS1465 (Torx 15IP / SW 3,5)	FS1465 (Torx 15IP / SW 3,5)
	Shim for radius					AP317-TC1612 r ≤ 1,2 mm
	Clamping screw for shim					FS2068 (SW 3,5)

Boring bar – Screw clamping

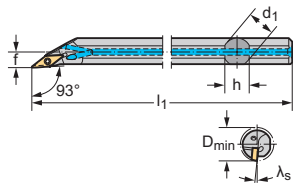
A...-SVJB

Walter Turn

- A = Steel version with internal coolant
- Additional coolant hole for blind hole machining



Tool	Designation		D_{\min} mm	d_1 mm	f mm	h mm	l_1 mm	γ	λ_s	Type
Parallel shank	★ A16R-SVJBR/L11		11	20	9	15	200	0°	-6°	VB .. 1103 ..
	★ A20S-SVJBR/L11		11	25	11	18	250	0°	-6°	VC .. 1103 ..



Measured with master insert: VB .. 110304

Ordering example, right-hand tool: A16R-SVJBR11/ordering example, left-hand tool: A16R-SVJBL11

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

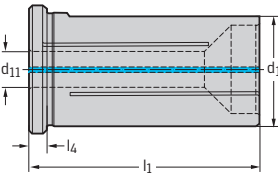
Assembly parts	Type D_{\min} [mm]	VB .. 1103 ..	VB .. 1103 ..
		VC .. 1103 .. 20	VC .. 1103 .. 25
	Clamping screw for indexable insert Tightening torque	FS2067 (Torx 7IP) 0,9 Nm	FS2172 (Torx 7IP) 0,9 Nm
	Torx key	FS1490 (Torx 7IP)	FS1490 (Torx 7IP)

Boring bar adaptor

A2140-W



- With Weldon shank in accordance with DIN 9766
- Self-centring for cylindrical round shank

Tool	Designation	d ₁ mm	d ₁₁ mm	l ₁ mm	l ₄ mm	kg
Parallel shank with surface in accordance with ISO 9766 	A2140-W25-R06-061	25	6	61	5	0,2
	A2140-W25-R08-061	25	8	61	5	0,2
	A2140-W25-R10-061	25	10	61	5	0,2
	A2140-W25-R12-061	25	12	61	5	0,2
	A2140-W25-R16-061	25	16	61	5	0,1
	A2140-W32-R06-065	32	6	65	5	0,3
	A2140-W32-R08-065	32	8	65	5	0,3
	A2140-W32-R10-065	32	10	65	5	0,3
	A2140-W32-R12-065	32	12	65	5	0,3
	A2140-W32-R16-065	32	16	65	5	0,3
	A2140-W32-R20-065	32	20	65	5	0,2
	A2140-W40-R06-075	40	6	75	5	0,6
	A2140-W40-R08-075	40	8	75	5	0,6
	A2140-W40-R10-075	40	10	75	5	0,6
	A2140-W40-R12-075	40	12	75	5	0,6
	A2140-W40-R16-075	40	16	75	5	0,6
	A2140-W40-R20-075	40	20	75	5	0,6
	A2140-W40-R25-075	40	25	75	5	0,5

Note: Groove for self-centring is present on all Walter Turn boring bars with fully rounded shank (-R) dia. 6–25 mm.

Plain Cylindrical Adaptor – vibration-damped

A3000

Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁ mm	d ₁₁	l ₄ mm	l ₅ mm	l ₁ mm	d ₁₃	kg
	Parallel shank							
	★ A3000-32-Q32-160	32	Q32	160	128	293	G 1/4	1,8
	★ A3000-32-Q32-224	32	Q32	224	128	357	G 1/4	2,3
	★ A3000-40-Q40-208	40	Q40	208	160	374	G 1/4	3,8
	★ A3000-40-Q40-288	40	Q40	288	160	454	G 1/4	4,6
	★ A3000-50-Q50-268	50	Q50	268	200	475	G 1/4	7,5
	★ A3000-50-Q50-368	50	Q50	368	200	575	G 1/4	9,1
	★ A3000-40-Q40-368	40	Q40	368	160	534	G 1/4	5,5
	★ A3000-50-Q50-468	50	Q50	468	200	675	G 1/4	11

QuadFit exchangeable heads – see the "Turning" section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque	SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories	d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque	SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench	SD6000-Q32	SD6000-Q40	SD6000-Q50

Plain Cylindrical Adaptor – vibration-damped

A3000 inch

Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁ inch	d ₁₁	l ₄ inch	l ₅ inch	l ₁ inch	d ₁₃	lbs	
Parallel shank 	★ A3000.20-Q32-165	1,250	Q32	6,500	5,000	11,713	G 1/4	3,97	
	★ A3000.20-Q32-229	1,250	Q32	9,000	5,000	14,213	G 1/4	5,07	
	★ A3000.24-Q40-203	1,500	Q40	8,000	6,000	14,252	G 1/4	7,72	
	★ A3000.24-Q40-279	1,500	Q40	11,000	6,000	17,252	G 1/4	9,48	
	★ A3000.32-Q50-267	2,000	Q50	10,500	8,000	18,791	G 1/4	16,76	
	★ A3000.32-Q50-368	2,000	Q50	14,496	8,000	22,791	G 1/4	20,28	
	★ A3000.24-Q40-356	1,500	Q40	14,000	6,000	20,252	G 1/4	11,46	
	★ A3000.32-Q50-470	2,000	Q50	18,500	8,000	26,791	G 1/4	24,69	

QuadFit exchangeable heads – see the "Turning" section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque	SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories	d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque	SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench	SD6000-Q32	SD6000-Q40	SD6000-Q50

Walter Capto™ adaptor – vibration-damped

A3000-C mm

Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁	d ₁₁	d ₁₂ mm	l ₄ mm	l ₁₆ mm	l ₁₇ mm	n _{max}	kg
	★ A3000-C6-Q32-160	C6	Q32	32	160	129	135	10000	1,8
	★ A3000-C6-Q32-224	C6	Q32	32	224	193	199	8000	2,1
	★ A3000-C6-Q32-288	C6	Q32	32	288	257	263	6000	2,6
	★ A3000-C6-Q40-208	C6	Q40	40	208	177	183	8000	2,9
	★ A3000-C6-Q40-288	C6	Q40	40	288	257	263	6000	3,7
	★ A3000-C6-Q40-368	C6	Q40	40	368	337	343	5000	4,5
	★ A3000-C6-Q50-268	C6	Q50	50	268	238	243	6000	5
	★ A3000-C6-Q50-368	C6	Q50	50	368	338	343	4000	6,6
	★ A3000-C6-Q50-468	C6	Q50	50	468	438	443	2500	8,5
	★ A3000-C8-Q32-224	C8	Q32	32	224	181	191	8000	3,2
	★ A3000-C8-Q32-288	C8	Q32	32	288	245	255	6000	3,6
	★ A3000-C8-Q40-288	C8	Q40	40	288	245	255	6000	4,7
	★ A3000-C8-Q40-368	C8	Q40	40	368	325	335	5000	5,6
	★ A3000-C8-Q50-268	C8	Q50	50	268	225	235	6000	5,9
	★ A3000-C8-Q50-368	C8	Q50	50	368	325	335	4000	7,5
	★ A3000-C8-Q50-468	C8	Q50	50	468	425	435	2500	9,4

QuadFit exchangeable heads – see the “Turning” section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque		SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories		d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque		SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench		SD6000-Q32	SD6000-Q40	SD6000-Q50


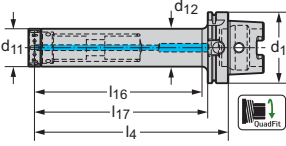
HSK-T adaptor – vibration-damped

A3000-HSK-T




Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁ mm	d ₁₁	d ₁₂ mm	l ₄ mm	l ₁₆ mm	l ₁₇ mm	n _{max}	
	★ A3000-H100T-Q32-224	100	Q32	32	224	189	195	8000	3,4
	★ A3000-H100T-Q32-288	100	Q32	32	288	253	259	6000	3,8
	★ A3000-H100T-Q40-288	100	Q40	40	288	253	259	6000	4,9
	★ A3000-H100T-Q40-368	100	Q40	40	368	333	339	5000	5,8
	★ A3000-H100T-Q50-268	100	Q50	50	268	234	239	6000	6,2
	★ A3000-H100T-Q50-368	100	Q50	50	368	334	339	4000	7,8
	★ A3000-H100T-Q50-468	100	Q50	50	468	434	439	25000	9,7

QuadFit exchangeable heads – see the “Turning” section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque		SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm
Accessories		d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque		SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench		SD6000-Q32	SD6000-Q40	SD6000-Q50

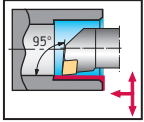
Exchangeable head – Rigid clamping

Q...-DCLN

Walter Turn



– QuadFit



Tool	Designation		d_1	D_{min} mm	f mm	l_4 mm	γ	λ_s	Type
 	★ Q32-DCLNR/L-22032-12	12	Q32	40	22	32	-6°	-10°	CN .. 1204 ..
	★ Q40-DCLNR/L-27032-12	12	Q40	50	27	32	-6°	-10°	
	★ Q50-DCLNR/L-32032-12	12	Q50	63	32	32	-6°	-8°	CN .. 1606 ..
	★ Q50-DCLNR/L-32037-16	16	Q50	63	32	37	-5°	-14°	

Measured with master insert: CN .. 120408 / CN .. 160612

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

Ordering example, right-hand tool: Q32-DCLNR-22032-12/ordering example, left-hand tool: Q32-DCLNL-22032-12

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

Assembly parts	Type	CN .. 1204 ..	CN .. 1606 ..
	Shim	AP354-CN12	AP302-CN16
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm	FS1463 (Torx 20IP) 5,0 Nm
	Clamp	PK241	PK242
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm	FS1474 (Torx 20IP) 6,4 Nm
	Pressure spring	FS1470	FS1471
	Pin	RS117	RS117
	Torx key	FS1465 (Torx 15IP /SW 3,5)	FS1464 (Torx 20IP)

Accessories	Type	CN .. 1204 ..	CN .. 1606 ..
	Clamp set (standard assembly parts)	PK241-SET	PK242-SET
	Carbide clamp set Insert with drilled hole	PK245-SET	PK246-SET
	Carbide clamp set Insert without drilled hole	PK254-SET	

/ ★ New addition to the product range

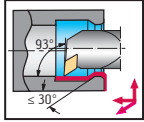
Exchangeable head – Rigid clamping

Q...-DDUN

Walter Turn



– QuadFit



Tool	Designation		d ₁	D _{min} mm	f mm	l ₄ mm	γ	λ _s	Type
	★ Q32-DDUNR/L-22032-15	15	Q32	40	21,9	32	-6°	-14°	DN .. 1506 ..
	★ Q40-DDUNR/L-27032-15	15	Q40	50	27	32	-6°	-12°	
	★ Q50-DDUNR/L-32032-15	15	Q50	63	32	32	-6°	-12°	

Measured with master insert: DN .. 150608

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

Ordering example, right-hand tool: Q32-DDUNR-22032-15/ordering example, left-hand tool: Q32-DDUNL-22032-15

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

Assembly parts		DN .. 1506 ..
	Shim	AP304-DN15
	Screw for shim	FS1461 (Torx 15IP)
	Tightening torque	2,5 Nm
	Clamp	PK241
	Clamp screw	FS1473 (Torx 15IP)
	Tightening torque	3,9 Nm
	Pressure spring	FS1470
	Pin	RS117
	Torx key	FS1465 (Torx 15IP / SW 3,5)

Accessories		DN .. 1506 ..
	Carbide clamp set Insert with drilled hole	PK245-SET
	Clamp set (standard assembly parts)	PK241-SET
	Carbide clamp set Insert without drilled hole	PK254-SET
	Shim for DN .. 1504 ..	AP304-DN1504

/ ★ New addition to the product range

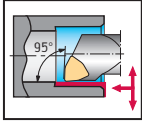
Exchangeable head – Rigid clamping

Q...-DWLN

Walter Turn



– QuadFit



Tool	Designation		d_1	D_{min} mm	f mm	l_4 mm	γ	λ_s	Type
	★ Q32-DWLN/L-22035-08	8	Q32	40	22	35	-5°	-14°	WN .. 0804 ..
	★ Q40-DWLN/L-27037-08	8	Q40	50	27	37	-5°	-12°	
	★ Q50-DWLN/L-32038-08	8	Q50	63	32	38	-5°	-12°	

Measured with master insert: WN .. 080408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"

Ordering example, right-hand tool: Q32-DWLN/L-22035-08/ordering example, left-hand tool: Q32-DWLN/L-22035-08

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

Assembly parts	Type	WN .. 0804 ..
	Shim	AP331-WN08
	Screw for shim Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Clamp	PK241
	Clamp screw Tightening torque	FS1473 (Torx 15IP) 3,9 Nm
	Pressure spring	FS1470
	Pin	RS117
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Accessories	Type	WN .. 0804 ..
	Clamp set (standard assembly parts)	PK241-SET
	Carbide clamp set Insert with drilled hole	PK245-SET
	Carbide clamp set Insert without drilled hole	PK254-SET

/ ★ New addition to the product range

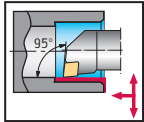
Exchangeable head – Screw clamping

Q...-SCLC

Walter Turn



– QuadFit



Tool	Designation		d ₁	D _{min} mm	f mm	l ₄ mm	γ	λ _s	Type	
	★ Q32-SCLCR/L-22032-09		9	Q32	40	22	32	0°	-2°	CC .. 09T3 ..
	★ Q40-SCLCR/L-27032-09		9	Q40	50	27	32	0°	-2°	
	★ Q50-SCLCR/L-32032-09		9	Q50	63	32	32	0°	-2°	
	★ Q32-SCLCR/L-22032-12		12	Q32	40	22	32	0°	-8°	CC .. 1204 ..
	★ Q40-SCLCR/L-27032-12		12	Q40	50	27	32	0°	-8°	
	★ Q50-SCLCR/L-32032-12		12	Q50	63	32	32	0°	-9°	

Measured with master insert: CC.. 09T308 / CC .. 120408
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"
 Ordering example, right-hand tool: Q32-SCLCR-22032-09/ordering example, left-hand tool: Q32-SCLCL-22032-09
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		CC .. 09T3 ..	CC .. 1204 ..
	Clamping screw for indexable insert Tightening torque	FS2062 (Torx 15IP) 3,0 Nm	FS2281 (Torx 20IP) 5,0 Nm
	Shim		AP364-CC1208
	Screw for shim		FS2592 (SW 5)
	Torx key	FS1465 (Torx 15IP / SW 3,5)	
	Allen key		FS1464 (Torx 20IP)
	Allen key for shim		ISO2936-5 (SW 5)

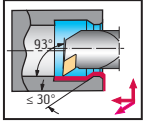
Exchangeable head – Screw clamping

Q...-SDUC

Walter Turn



– QuadFit



Tool	Designation		d_1	D_{min} mm	f mm	l_4 mm	γ	λ_s	Type
	★ Q32-SDUCR/L-22032-11	11	Q32	40	22	32	0°	-5°	DC .. 11T3 ..
	★ Q40-SDUCR/L-27032-11	11	Q40	50	27	32	0°	-5°	
	★ Q50-SDUCR/L-32032-11	11	Q50	63	32	32	0°	-5°	

Measured with master insert: DC .. 11T308
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 Ordering example, right-hand tool: Q32-SDUCR-22032-11/ordering example, left-hand tool: Q32-SDUCL-22032-11
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	DC .. 11T3 ..
	Clamping screw for indexable insert Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Torx key	FS1465 (Torx 15IP /SW 3,5)

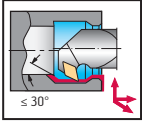
Exchangeable head – Screw clamping

Q...-SDUC...-X

Walter Turn



– QuadFit



Tool	Designation		d ₁	D _{min} mm	f mm	l ₄ mm	l ₂₀ mm	X ₁ mm	γ	λ _s	Type	
	★ Q32-SDUCR/L-22018-11X		11	Q32	40	21,9	18	37,5	5,9	0°	-5°	
	★ Q40-SDUCR/L-27017-11X		11	Q40	50	26,9	17	40,5	6,9	0°	-5°	DC .. 11T3 ..
	★ Q50-SDUCR/L-32017-11X		11	Q50	63	32	17	42,5	6,9	0°	-5°	

Measured with master insert: DC .. 11T308
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see “Technical information – ISO turning”
 Ordering example, right-hand tool: Q32-SDUCR-22018-11X/ordering example, left-hand tool: Q32-SDUCL-22018-11X
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	DC .. 11T3 ..
	Clamping screw for indexable insert Tightening torque	FS1461 (Torx 15IP) 2,5 Nm
	Torx key	FS1465 (Torx 15IP /SW 3,5)

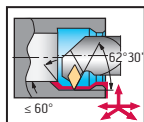
Exchangeable head – Screw clamping

Q...-SDXC

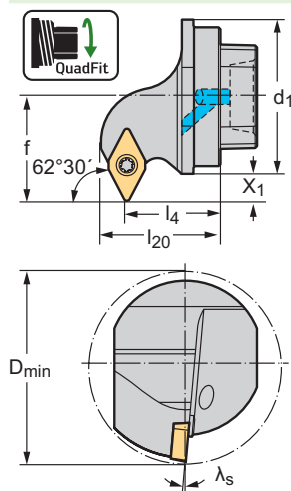
Walter Turn



– For QuadFit exchangeable heads



Tool



Designation

Designation		d ₁	D _{min} mm	f mm	l ₄ mm	l ₂₀ mm	X ₁ mm	γ	λ _s	Type
★ Q32-SDXCR/L-22025-11	11	Q32	40	21,9	25	37,5	5,9	0°	-5°	DC .. 11T3 ..
★ Q40-SDXCR/L-27025-11	11	Q40	50	26,9	25	40,5	6,9	0°	-5°	
★ Q50-SDXCR/L-32025-11	11	Q50	63	31,9	25	42,5	6,9	0°	-5°	

Measured with master insert: DC .. 11T308

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

Ordering example, right-hand tool: Q32-SDXCR-22025-11/ordering example, left-hand tool: Q32-SDXCL-22025-11

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

Assembly parts



Type

Clamping screw for indexable insert
Tightening torque

DC .. 11T3 ..

FS1461 (Torx 15IP)
2,5 Nm



Torx key

FS1465 (Torx 15IP /SW 3,5)

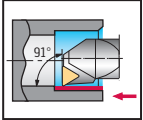
Exchangeable head – Screw clamping

Q...-STFC

Walter Turn



– QuadFit



Tool	Designation		d_1	D_{min} mm	f mm	l_4 mm	γ	λ_s	Type
	★ Q32-STFCR/L-22032-16		Q32	40	22	32	0°	-10°	TC .. 16T3 ..
	★ Q40-STFCR/L-27032-16		Q40	50	27	32	0°	-8°	
	★ Q50-STFCR/L-32032-16		Q50	63	32	32	0°	-8°	

Measured with master insert: TC .. 16T308
 For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s , see "Technical information – ISO turning"
 Ordering example, right-hand tool: Q32-STFCR-22032-16/ordering example, left-hand tool: Q32-STFCL-22032-16
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Type	TC .. 16T3 ..
	Clamping screw for indexable insert		FS2063 (Torx 15IP)
	Tightening torque		3,0 Nm
	Shim for radius		AP317-TC1612 $r \leq 1,2$ mm
	Screw for shim		FS2068 (SW 3,5)
	Torx key		FS1465 (Torx 15IP /SW 3,5)

★ New addition to the product range

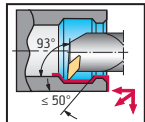
Exchangeable head – Screw clamping



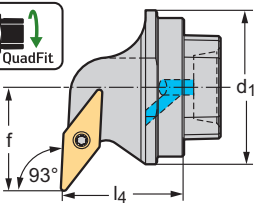
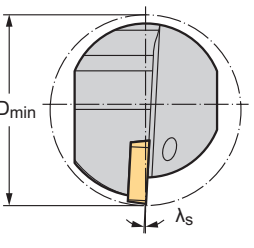
Q...-SVUB

Walter Turn



– QuadFit







Tool	Designation		d ₁	D _{min} mm	f mm	l ₄ mm	γ	λ _s	Type
  	★ Q32-SVUBR/L-22032-16		16	Q32	40	22	0°	-3°	VB .. 1604 .. VC .. 1604 ..
	★ Q40-SVUBR/L-27032-16		16	Q40	50	26,9	0°	-3°	
	★ Q50-SVUBR/L-32032-16		16	Q50	63	31,9	0°	-3°	

Measured with master insert: VB .. 160408

For information on the rake angle γ (for indexable inserts without chip groove) and on the inclination angle λ_s, see "Technical information – ISO turning"

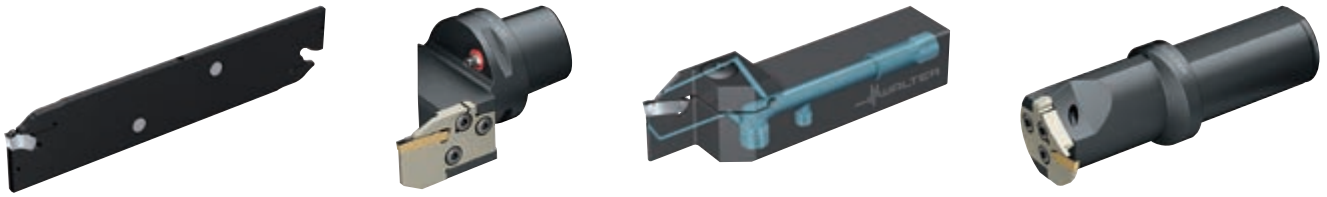
Ordering example, right-hand tool: Q32-SVUBR-22032-16/ordering example, left-hand tool: Q32-SVUBL-22032-16

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

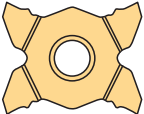

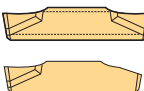

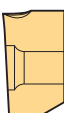


Assembly parts	Type	VB .. 1604 .. VC .. 1604 ..
	Clamping screw for indexable insert Tightening torque	FS2063 (Torx 15IP) 3,0 Nm
	Shim for radius	AP316-VB1608 r ≤ 0,8 mm
	Screw for shim	FS2068 (SW 3,5)
	Torx key	FS1465 (Torx 15IP /SW 3,5)

Product range overview of cutting inserts and cutting tool materials: Grooving

A2



Cutting inserts

Insert shape	Description	Page
Parting off/grooving		
 MX	Walter Cut MX grooving inserts Four-edged	117
 DX	Walter Cut DX grooving inserts Double-edged	122
 GX	Walter Cut GX grooving inserts Double-edged/ single-edged	124
 SX	Walter Cut SX grooving inserts Single-edged	131
 UX	Walter Cut UX grooving inserts Single-edged	133
Recessing		
 GX	Walter Cut GX grooving inserts Double-edged	128
Semi-finished parts/ blanks		
 MX	Walter Cut MX grooving inserts Four-edged	121

Cutting tool materials: Carbide

Application	Coating	Application range										
		01	05	10	15	20	25	30	35	40	45	
ISO P	CVD	WKP13S										
	CVD		WKP23S									
	CVD			WKP33S								
	PVD			WSM23S								
	PVD				WSM33S							
	PVD						WSM43S					
ISO M	PVD	WSM13S										
	PVD		WSM23S									
	PVD			WSM33S								
	PVD					WSM43S						
ISO K	CVD	WKP13S										
	CVD		WKP23S									
	CVD			WKP33S								
ISO N	—	WK1										
ISO N	PCD	WDN10										
ISO S	PVD	WSM13S										
	PVD		WSM23S									
	PVD			WSM33S								
	PVD					WSM43S						
	CBN	WBS10										
ISO H	CBN	WBH20										

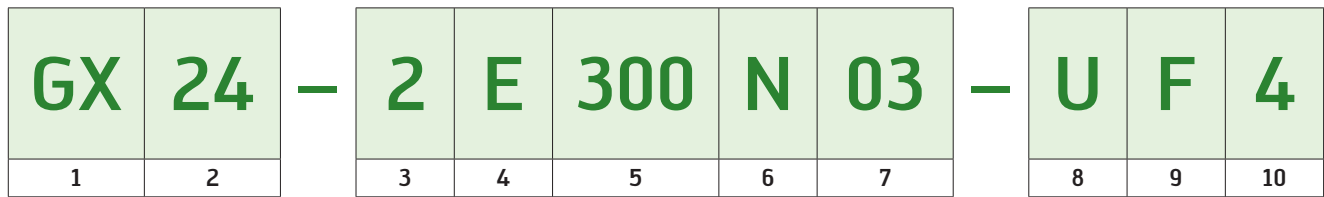
← Wear resistance

Toughness →

Designation key for Walter Cut inserts

A2

Example:

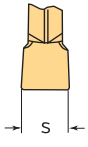


1	2	3	4
Insert type	Insert length l [mm]	Width category	Basic shape
<p>MX </p> <p>DX </p> <p>GX </p> <p>SX </p> <p>UX </p>	<p style="text-align: center;"></p> <p>09 l = 9</p> <p>16 l = 16</p> <p>18 l = 18</p> <p>24 l = 24</p> <p>30 l = 30</p> <p>34 l = 34</p>	<p style="text-align: center;"></p> <p style="text-align: center;">0</p> <p style="text-align: center;">1</p> <p style="text-align: center;">2</p> <p style="text-align: center;">3</p> <p style="text-align: center;">4</p> <p style="text-align: center;">5</p>	<p>E </p> <p>F </p> <p>R Right</p> <p>L Left</p>

8		
Application		
<p>C "Cut off"</p> <ul style="list-style-type: none"> – Parting off – Radial grooving <p>G "Grooving"</p> <ul style="list-style-type: none"> – Radial grooving – Axial grooving – Parting off <p>R "Radius"</p> <ul style="list-style-type: none"> – Radial grooving – Axial grooving – Longitudinal turning – Facing 	<p>S "Slitting"</p> <ul style="list-style-type: none"> – Slitting – Slot milling <p>U "Universal"</p> <ul style="list-style-type: none"> – Longitudinal turning – Radial grooving – Axial grooving – Facing – Parting off 	

5

Insert width *s* [mm]








For example:

200	<i>s</i> = 2,0
220	<i>s</i> = 2,2
250	<i>s</i> = 2,5
300	<i>s</i> = 3,0
310	<i>s</i> = 3,1
etc.	

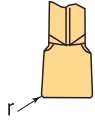
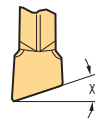
6

Version

Grooving:	R		Right
	L		Left
	N		Neutral
Parting off:	R		Right
	L		Left

7





Corner radius *r* [mm]/
approach angle χ [°]

	02	<i>r</i> = 0,2
	03	<i>r</i> = 0,3
	04	<i>r</i> = 0,4
	05	<i>r</i> = 0,5
etc.		
	00	χ = 0°
	6	χ = 6°
	7	χ = 7°
	15	χ = 15°
etc.		

9

Rake angle

smaller






	A
	D
	F
	K

larger

10

Cutting edge

tough

	1
	3
	4
	6
	8

sharp

Designation key for carbide cutting tool materials – Grooving

A2

Example:

W	S	M	33	S
Walter	1	2	3	4

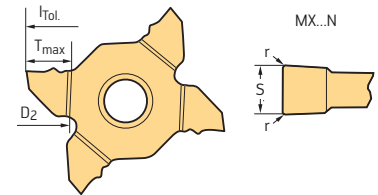
1
1. Primary application or coating type
P Steel
M Stainless steel
K Cast iron
N NF metals
S Materials with difficult cutting properties
H Hard materials
A CVD aluminium oxide coating
X PVD coating

2
2. Primary application
P Steel
M Stainless steel
K Cast iron
N NF metals
S Materials with difficult cutting properties
H Hard materials

3
ISO application range
Cutting tool materials for: 0 ISO turning 1 ISO turning 5 ISO turning 2 Thread turning 3 Grooving


4
Generation
S Tiger-tec® Silver

Grooving and parting off MX cutting inserts Tiger-tec® Silver



A2

Cutting inserts


Designation	s mm	r mm	T _{max} mm	D ₂ mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M		K	S			
								HC			HC		HC	HC			
								WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WKP23S	WSM13S	WSM23S	WSM33S	
 MX22-2E050N01-GD8	0,5	0,1	2,5		0,02-0,04	±0,02	±0,03	☹			☹			☹			
MX22-2E100N01-GD8	1	0,1	3,5	130	0,03-0,06	±0,02	±0,03	☹			☹			☹			
MX22-2E120N01-GD8	1,2	0,1	2		0,03-0,07	±0,02	±0,03	☹			☹			☹			
MX22-2E140N01-GD8	1,4	0,1	4		0,03-0,08	±0,02	±0,03	☹			☹			☹			
MX22-2E140N01-GD8	1,4	0,1	2		0,03-0,08	±0,02	±0,03	☹			☹			☹			
MX22-2E150N01-GD8	1,5	0,1	5	130	0,03-0,09	±0,02	±0,03	☹			☹			☹			
MX22-2E157N02-GD8	1,57	0,2	3	130	0,03-0,10	±0,02	±0,03	☹			☹			☹			
MX22-2E170N02-GD8	1,7	0,2	3		0,03-0,10	±0,02	±0,03	☹			☹			☹			
MX22-2E185N02-GD8	1,85	0,2	3		0,04-0,10	±0,02	±0,03	☹			☹			☹			
MX22-2E196N02-GD8	1,96	0,2	3	100	0,04-0,10	±0,02	±0,03	☹			☹			☹			
MX22-2E200N02-GD8	2	0,2	6	100	0,04-0,10	±0,02	±0,03	☹			☹			☹			
MX22-2E224N02-GD8	2,24	0,2	6	100	0,04-0,12	±0,02	±0,03	☹			☹			☹			
MX22-2E239N02-GD8	2,39	0,2	6	100	0,04-0,14	±0,02	±0,03	☹			☹			☹			
MX22-2E275N02-GD8	2,75	0,2	6	100	0,04-0,14	±0,02	±0,03	☹			☹			☹			
MX22-2E300N02-GD8	3	0,2	6	100	0,04-0,14	±0,02	±0,03	☹			☹			☹			
MX22-2E318N02-GD8	3,18	0,2	6	100	0,04-0,14	±0,02	±0,03	☹			☹			☹			
MX22-2E325N02-GD8	3,25	0,2	6	100	0,04-0,15	±0,02	±0,03	☹			☹			☹			


l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"


HC = Coated carbide

WALTER SELECT

Optimum indexable insert for


 Good

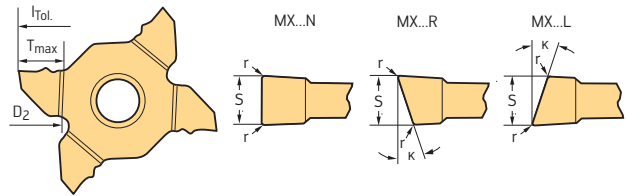

 Average


 Poor




machining conditions

Grooving and parting off MX cutting inserts Tiger-tec® Silver

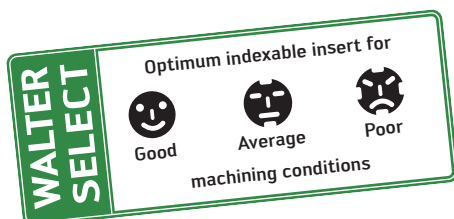
A2



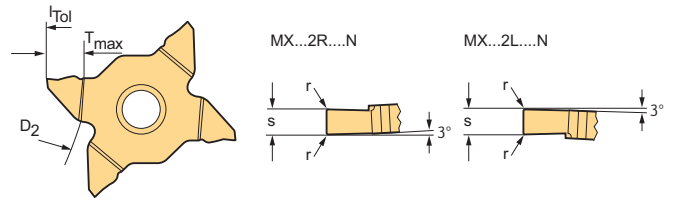
Cutting inserts

Designation	s mm	r mm	k	T _{max} mm	D ₂ mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M			K		S			
									HC			HC			HC		HC			
									WSM23S	WSM33S	WSM43S	WSM13S	WSM23S	WSM33S	WSM43S	WKP23S	WSM13S	WSM23S	WSM33S	
 MX22-2E080N01-CF5	0,8	0,1		1,6	130	0,02-0,05	±0,02	±0,03	☺				☺				☺			
MX22-2E100N01-CF5	1	0,1		3,5	130	0,03-0,07	±0,02	±0,03	☺			☺					☺			
MX22-2E104N01-CF5	1,04	0,1		2		0,03-0,07	±0,02	±0,03	☺								☺			
MX22-2E120N01-CF5	1,2	0,1		2		0,03-0,08	±0,02	±0,03	☺								☺			
MX22-2E140N01-CF5	1,4	0,1		2		0,03-0,09	±0,02	±0,03	☺								☺			
MX22-2E147N01-CF5	1,47	0,1		2,5		0,03-0,09	±0,02	±0,03	☺								☺			
MX22-2E150N01-CF5	1,5	0,1		5	130	0,03-0,10	±0,02	±0,03	☺			☺					☺			
MX22-2E157N02-CF5	1,57	0,2		3		0,04-0,12	±0,02	±0,03	☺								☺			
MX22-2E170N02-CF5	1,7	0,2		3		0,04-0,12	±0,02	±0,03	☺								☺			
MX22-2E185N02-CF5	1,85	0,2		3		0,04-0,12	±0,02	±0,03	☺								☺			
MX22-2E196N02-CF5	1,96	0,2		3		0,04-0,12	±0,02	±0,03	☺								☺			
MX22-2E200N02-CF5	2	0,2		6	100	0,04-0,14	±0,02	±0,03	☺			☺					☺			
MX22-2E224N02-CF5	2,24	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-2E239N02-CF5	2,39	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-2E250N02-CF5	2,5	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-2E275N02-CF5	2,75	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-2E300N02-CF5	3	0,2		6	100	0,04-0,16	±0,02	±0,03	☺			☺					☺			
MX22-2E318N02-CF5	3,18	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-2E325N02-CF5	3,25	0,2		6	100	0,04-0,16	±0,02	±0,03	☺								☺			
MX22-4E400N02-CF5	4	0,2		6	100	0,10-0,20	±0,02	±0,03	☺								☺			
MX22-4E400N04-CF5	4	0,4		6	100	0,10-0,20	±0,02	±0,03	☺								☺			
MX22-4E425N02-CF5	4,25	0,2		6	100	0,10-0,20	±0,02	±0,03	☺								☺			
MX22-4E480N06-CF5	4,8	0,6		6	100	0,10-0,25	±0,02	±0,03	☺								☺			
MX22-4E500N02-CF5	5	0,2		6	100	0,10-0,25	±0,02	±0,03	☺								☺			
MX22-4E500N04-CF5	5	0,4		6	100	0,10-0,25	±0,02	±0,03	☺								☺			
MX22-4E525N02-CF5	5,25	0,2		6	100	0,10-0,25	±0,02	±0,03	☺								☺			
MX22-4E556N02-CF5	5,56	0,2		6	100	0,10-0,28	±0,02	±0,03	☺								☺			
 MX22-2E080L5-CF5	0,8	0,05	5°	1,6	130	0,02-0,04	±0,02	±0,03	☺								☺			
MX22-2E100L10-CF5	1	0,05	10°	3,5	130	0,02-0,04	±0,02	±0,03	☺								☺			
MX22-2E150L10-CF5	1,5	0,05	10°	5	130	0,03-0,06	±0,02	±0,03	☺								☺			
MX22-2E200L6-CF5	2	0,1	6°	6	100	0,04-0,12	±0,02	±0,03	☺								☺			
 MX22-2E080R5-CF5	0,8	0,05	5°	1,6	130	0,02-0,04	±0,02	±0,03	☺								☺			
MX22-2E100R10-CF5	1	0,05	10°	3,5	130	0,02-0,04	±0,02	±0,03	☺								☺			
MX22-2E150R10-CF5	1,5	0,05	10°	5	130	0,03-0,06	±0,02	±0,03	☺								☺			
MX22-2E200R6-CF5	2	0,1	6°	6	100	0,04-0,12	±0,02	±0,03	☺								☺			

HC = Coated carbide




Grooving and parting off 3° MX cutting inserts



A2

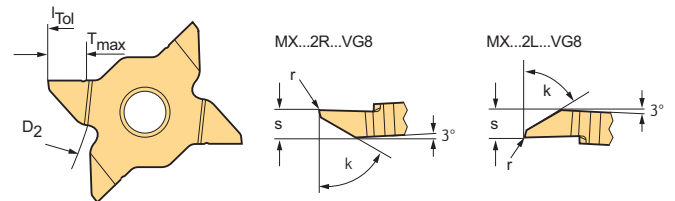
Cutting inserts

Designation	s mm	r mm	T _{max} mm	D ₂ mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M		K	S		
								WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	HC	WSM13S	WSM23S	WSM33S
 MX22-2L150N01-GD8	1,5	0,1	5	130	0,03–0,06	±0,02	±0,03	⊕			⊕			⊕		
MX22-2L200N02-GD8	2	0,2	5	100	0,04–0,10	±0,02	±0,03	⊕			⊕			⊕		
MX22-2L300N02-GD8	3	0,2	5	100	0,04–0,14	±0,02	±0,03	⊕			⊕			⊕		
MX22-2R150N01-GD8	1,5	0,1	5	130	0,03–0,06	±0,02	±0,03	⊕			⊕			⊕		
MX22-2R200N02-GD8	2	0,2	5	100	0,04–0,10	±0,02	±0,03	⊕			⊕			⊕		
MX22-2R300N02-GD8	2	0,2	5	100	0,05–0,14	±0,02	±0,03	⊕			⊕			⊕		


l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"

HC = Coated carbide

Grooving and recessing 3° MX cutting inserts



Cutting inserts

Designation	s mm	r mm	κ	T _{max} mm	D ₂ mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M		K	S		
									WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	HC	WKP23S	WSM13S	WSM23S
 MX22-2L280L01-VG8	2,8	0,05	60°	5,5	100	0,05–0,12	±0,02	±0,03	⊕			⊕			⊕		
MX22-2R280R01-VG8	2,8	0,05	60°	5,5	100	0,05–0,12	±0,02	±0,03	⊕			⊕			⊕		

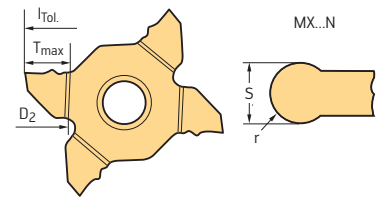
l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"

HC = Coated carbide


⊕ / ★ New addition to the product range

Grooving and copy turning MX cutting inserts Tiger-tec® Silver

A2



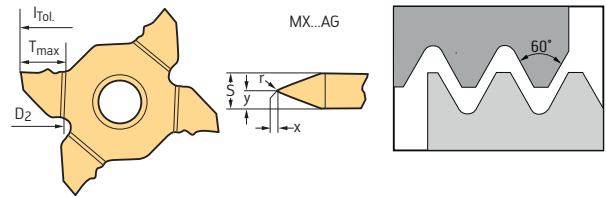
Cutting inserts

Designation	s mm	r mm	T _{max} mm	D ₂ mm	f mm	S _{Tol} mm	l _{Tol} mm	P		M		K	S		
								HC		HC		HC	HC		
								WSM23S	WSM33S	WSM43S	WSM13S	WSM23S	WSM33S	WKP23S	WSM13S
 MX22-2E157N08-RF5	1,57	0,8	3	130	0,04–0,12	±0,02	±0,03	⊕							
MX22-2E200N10-RF5	2	1	6	100	0,04–0,14	±0,02	±0,03	⊕		⊕		⊕	⊕		
MX22-2E239N12-RF5	2,39	1,2	6	100	0,04–0,18	±0,02	±0,03	⊕					⊕	⊕	
MX22-2E300N15-RF5	3	1,5	6	100	0,04–0,20	±0,02	±0,03	⊕		⊕			⊕	⊕	
MX22-2E318N16-RF5	3,18	1,6	6	100	0,04–0,20	±0,02	±0,03	⊕						⊕	
MX22-4E400N20-RF5	4	2	6	100	0,01–0,22	±0,02	±0,03	⊕						⊕	
MX22-4E480N24-RF5	4,8	2,4	6	100	0,01–0,25	±0,02	±0,03	⊕						⊕	
MX22-4E500N25-RF5	5	2,5	6	100	0,06–0,25	±0,02	±0,03	⊕						⊕	


l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"

HC = Coated carbide

External thread – Partial profile 60° MX cutting inserts Tiger-tec® Silver



Cutting inserts – Thread

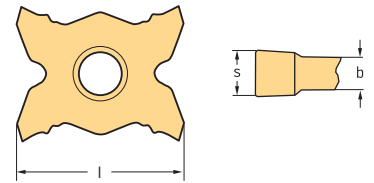
Designation	Pitch P mm	Pitch (TPI) inch	r mm	X mm	Y mm	P		M		K	S	
						HC		HC		HC	HC	
						WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WKP23S	WSM13S
 MX22-2E-EN-A60	0,50–1,50	48–16	0,05	0,05	1,68	⊕						
MX22-4E-EN-AG60	0,50–3,00	48–8	0,08	0,08	2,83	⊕	⊕	⊕			⊕	⊕

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide

⊕ / ★ New addition to the product range

Semi-finished blanks for special profiles MX cutting inserts



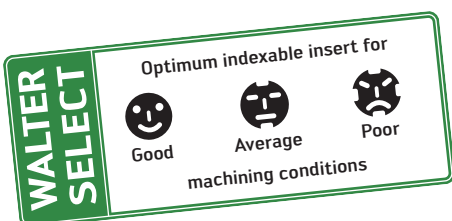
A2

Blanks for special profiles

Designation	s mm	b mm	l mm	P				M		K	S			
				HC		HF		HC	HF	HC	HF			
				WSM23S	WSM33S	WSM43S	WMG30	WSM23S	WSM33S	WSM43S	WKP23S	WSM13S	WSM33S	WMG30
MX22-2E335N	3,35	3,35	23,2				☉							
MX22-4E565N	5,65	5,65	23,2				☉							

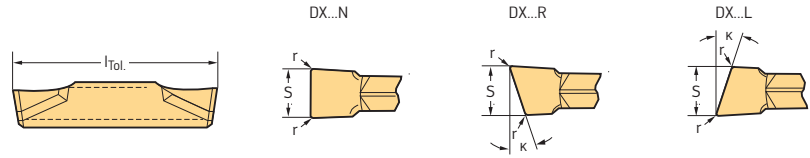
Grade WMG30 has the ISO application ranges P20, M20 and S20

HC = Coated carbide
HF = Uncoated fine-grained carbide



Grooving and parting off DX cutting inserts Tiger-tec® Silver

A2



Cutting inserts

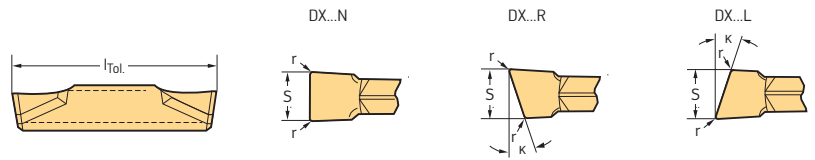
Designation	s mm	r mm	κ	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P		M			S						
								HC		HC			HC						
								WKP23S	WKP33S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S					
DX18-1E150N01-CF6	1,5	0,15		18	0,03-0,12	±0,05	±0,15												
DX18-2E200N02-CF6	2	0,2		18	0,03-0,14	±0,05	±0,15												
DX18-2E250N02-CF6	2,5	0,2		18	0,03-0,18	±0,05	±0,15												
DX18-3E300N02-CF6	3	0,2		18	0,04-0,23	±0,05	±0,15												
DX18-2E200L6-CF6	2	0,2	6°	18	0,03-0,12	±0,05	±0,15												
DX18-2E250L6-CF6	2,5	0,2	6°	18	0,03-0,15	±0,05	±0,15												
DX18-3E300L6-CF6	3	0,2	6°	18	0,04-0,19	±0,05	±0,15												
DX18-2E200R6-CF6	2	0,2	6°	18	0,03-0,12	±0,05	±0,15												
DX18-2E250R6-CF6	2,5	0,2	6°	18	0,03-0,15	±0,05	±0,15												
DX18-3E300R6-CF6	3	0,2	6°	18	0,04-0,19	±0,05	±0,15												
DX18-1E150N01-CF5	1,5	0,15		18	0,03-0,12	±0,05	±0,15												
DX18-2E200N00-CF5	2	0		18	0,03-0,12	±0,05	±0,15												
DX18-2E200N02-CF5	2	0,2		18	0,04-0,14	±0,05	±0,15												
DX18-2E250N02-CF5	2,5	0,2		18	0,05-0,18	±0,05	±0,15												
DX18-3E300N02-CF5	3	0,2		18	0,08-0,23	±0,05	±0,15												
DX18-2E200L6-CF5	2	0,2	6°	18	0,03-0,12	±0,05	±0,15												
DX18-2E200L7-CF5	2	0	7°	18	0,03-0,12	±0,05	±0,15												
DX18-2E200L15-CF5	2	0	15°	18	0,03-0,12	±0,05	±0,15												
DX18-2E250L6-CF5	2,5	0,2	6°	18	0,03-0,15	±0,05	±0,15												
DX18-3E300L6-CF5	3	0,2	6°	18	0,04-0,19	±0,05	±0,15												
DX18-2E200R6-CF5	2	0,2	6°	18	0,03-0,12	±0,05	±0,15												
DX18-2E200R7-CF5	2	0	7°	18	0,03-0,12	±0,05	±0,15												
DX18-2E200R15-CF5	2	0	15°	18	0,03-0,12	±0,05	±0,15												
DX18-2E250R6-CF5	2,5	0,2	6°	18	0,03-0,15	±0,05	±0,15												
DX18-3E300R6-CF5	3	0,2	6°	18	0,04-0,19	±0,05	±0,15												
DX18-1E150N01-CE4	1,5	0,15		18	0,03-0,12	±0,05	±0,15												
DX18-2E200N02-CE4	2	0,2		18	0,06-0,17	±0,05	±0,15												
DX18-2E250N02-CE4	2,5	0,2		18	0,07-0,21	±0,05	±0,15												
DX18-3E300N02-CE4	3	0,2		18	0,09-0,33	±0,05	±0,15												
DX18-2E200L6-CE4	2	0,2	6°	18	0,04-0,12	±0,05	±0,15												
DX18-2E250L6-CE4	2,5	0,2	6°	18	0,05-0,15	±0,05	±0,15												
DX18-3E300L6-CE4	3	0,2	6°	18	0,09-0,27	±0,05	±0,15												
DX18-2E200R6-CE4	2	0,2	6°	18	0,04-0,12	±0,05	±0,15												
DX18-2E250R6-CE4	2,5	0,2	6°	18	0,05-0,15	±0,05	±0,15												
DX18-3E300R6-CE4	3	0,2	6°	18	0,09-0,27	±0,05	±0,15												

 l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm


HC = Coated carbide

/ ★ New addition to the product range

Grooving and parting off DX cutting inserts Tiger-tec® Silver

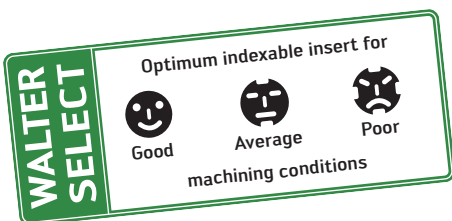


Cutting inserts

Designation	s mm	r mm	k	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P		M		S						
								HC		HC		HC						
								WKP23S	WKP33S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S			
 DX18-2E200N02-GD6	2	0,2		18	0,04-0,14	±0,05	±0,15			☺	☺	☺	☺					
DX18-2E250N02-GD6	2,5	0,2		18	0,06-0,20	±0,05	±0,15			☺	☺	☺	☺					
DX18-3E300N03-GD6	3	0,2		18	0,08-0,21	±0,05	±0,15			☺	☺	☺	☺					

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

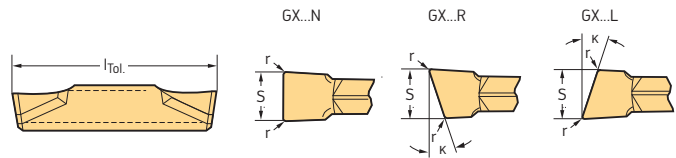
HC = Coated carbide





A2

Grooving and parting off GX cutting inserts Tiger-tec® Silver

A2



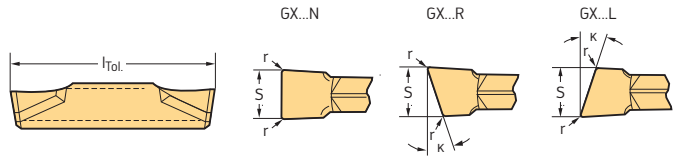
Cutting inserts

Designation	s mm	r mm	κ	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P				M			K	N	S		
								HC				HC			HC	HW	HC		
								WKP23S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S	WKP23S	WK1	WSM23S	WSM33S	WSM43S
 GX16-1E200N02-CK8	2	0,2		16,6	0,04–0,12	±0,02	±0,03								☉				
GX16-2E300N02-CK8	3	0,2		16,6	0,08–0,20	±0,02	±0,03								☉				
GX24-2E300N02-CK8	3	0,2		24,6	0,08–0,20	±0,02	±0,03								☉				
GX24-3E400N02-CK8	4	0,2		24,6	0,10–0,22	±0,02	±0,03								☉				
 GX16-1E200N00-CF5	2	0		16,6	0,03–0,10	±0,02	±0,05			☉								☉	
GX16-1E200N02-CF5	2	0,2		16,6	0,04–0,12	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX16-1E200R/L6-CF5	2	0,2	6°	16,6	0,03–0,10	±0,05	±0,15			☉	☉	☉					☉	☉	
GX16-1E200R/L7-CF5	2	0	7°	16,4	0,03–0,10	±0,05	±0,15			☉							☉		
GX16-1E200R/L15-CF5	2	0	15°	16,4	0,03–0,10	±0,05	±0,15			☉							☉		
GX16-1E250N02-CF5	2,5	0,2		16,6	0,05–0,15	±0,05	±0,15			☉	☉	☉					☉	☉	
GX16-1E250R/L6-CF5	2,5	0,2	6°	16,6	0,03–0,12	±0,05	±0,15			☉							☉		
GX16-2E300N02-CF5	3	0,2		16,6	0,08–0,20	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX16-2E300R/L6-CF5	3	0,2	6°	16,6	0,04–0,16	±0,05	±0,15			☉							☉		
GX16-2E300R7-CF5	3	0	7°	16,6	0,04–0,13	±0,05	±0,15			☉							☉		
GX16-2E300R/L15-CF5	3	0	15°	16,6	0,04–0,13	±0,05	±0,15			☉							☉		
GX24-1E200N02-CF5	2	0,2		24	0,04–0,12	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX24-1E250N02-CF5	2,5	0,2		24	0,05–0,15	±0,05	±0,15			☉							☉		
GX24-2E300N00-CF5	3	0		24,6	0,04–0,16	±0,02	±0,05			☉							☉		
GX24-2E300N02-CF5	3	0,2		24	0,08–0,20	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX24-2E300R/L6-CF5	3	0,2	6°	24,6	0,04–0,16	±0,05	±0,15			☉							☉	☉	
GX24-3E400N02-CF5	4	0,2		24	0,10–0,22	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX24-3E400R/L6-CF5	4	0,2	6°	24,6	0,10–0,18	±0,05	±0,15			☉							☉		
GX24-3E500N03-CF5	5	0,3		24	0,10–0,25	±0,05	±0,15			☉							☉	☉	
GX34-2E300N03-CF5	3	0,3		34	0,08–0,20	±0,05	±0,15		☉	☉	☉	☉					☉	☉	
GX34-2E300R/L6-CF5	3	0,3	6°	34	0,04–0,16	±0,05	±0,15			☉							☉		
GX34-3E400N04-CF5	4	0,4		34	0,10–0,22	±0,05	±0,15		☉	☉	☉	☉					☉	☉	

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 Parting off with diameters up to 32 mm is possible with GX16 inserts (l = 16.6 mm)



HC = Coated carbide
 HW = Uncoated carbide

Grooving and parting off GX cutting inserts Tiger-tec® Silver



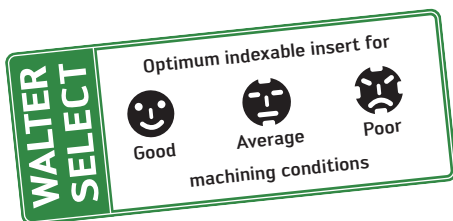
A2

Cutting inserts

Designation	s mm	r mm	κ	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M			K	N	S		
								HC			HC			HC	HW	HC		
								WKP23S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S	WKP23S	WK1	WSM23S	WSM33S
 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	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX16-1E250R6-CE4	2,5	0,2	6°	16,6	0,05-0,12	±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	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX34-2E300N03-CE4	3	0,3		34	0,09-0,30	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX34-2E300R/L6-CE4	3	0,3	6°	34	0,09-0,24	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX34-3E400N04-CE4	4	0,4		34	0,10-0,32	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
 GX16-1E200N02-GD6	2	0,2		16	0,04-0,12	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX16-1E250N02-GD6	2,5	0,2		16	0,06-0,17	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX16-2E300N03-GD6	3	0,3		16	0,08-0,18	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX16-3E400N04-GD6	4	0,4		16	0,10-0,22	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX16-3E500N04-GD6	5	0,4		16	0,12-0,24	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX24-2E300N03-GD6	3	0,3		24	0,08-0,18	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX24-3E400N04-GD6	4	0,4		24	0,10-0,22	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX24-3E500N04-GD6	5	0,4		24	0,12-0,24	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX24-4E600N05-GD6	6	0,5		24	0,14-0,30	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX34-2E300N03-GD6	3	0,3		34	0,08-0,20	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕
GX34-3E400N04-GD6	4	0,4		34	0,10-0,22	±0,05	±0,15	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 Parting off with diameters up to 32 mm is possible with GX16 inserts (l = 16.6 mm)

HC = Coated carbide
 HW = Uncoated carbide

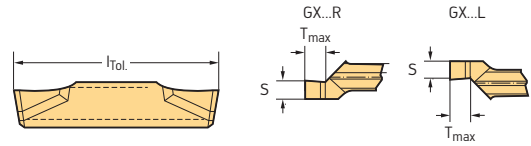


Grooving and parting off


GX cutting inserts

Tiger-tec® Silver

A2



Cutting inserts

Designation	s mm	r mm	T _{max} mm	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	WSM43S	WKP23S	WSM23S
 GX09-1E100R/L00-GD8	1	0	1,14	9	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-1E120R/L00-GD8	1,2	0	1,34	9	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-1E140R/L00-GD8	1,4	0	1,53	9	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E100R/L00-GD8	1	0	1,14	16	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E120R/L00-GD8	1,2	0	1,34	16	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E140R/L00-GD8	1,4	0	1,53	16	0,05-0,10	±0,02	±0,02	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

 l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch

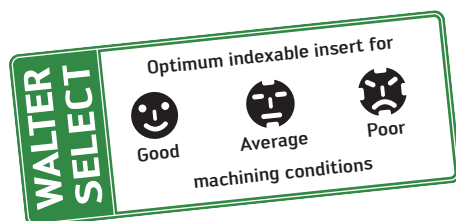
HC = Coated carbide

 Radius tolerance r_{Tol} = ± 0.05 mm

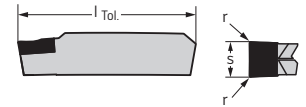
Cutting insert can be used in G15... / NCCE / NCNE / NCCI tools

With other tools, adapt support to the cutting insert profile

Further cutting inserts for circlip grooves: GX...UF8 / MX22...GD8 / MX22...CF5



CBN – Grooving and parting off GX cutting inserts



A2

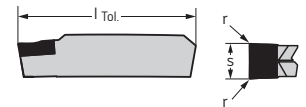
Cutting inserts

Designation	s mm	r mm	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M			K			S			H	
							HC	HC	HC	HC	HC	HC	BH	BL	HC	HC	HC	BH	BL	
							WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WKP23S	WSM33S	WSM43S	WBS10	WBH20				
	GX24-2F300N02EM-1	3	0,2	24	0,10–0,15	±0,02	±0,025													
	GX24-3F400N02EM-1	4	0,2	24	0,10–0,20	±0,02	±0,025													
	GX24-3F500N04EM-1	5	0,4	24	0,10–0,25	±0,02	±0,025													
	GX24-4F600N04EM-1	6	0,4	24	0,10–0,30	±0,02	±0,025													
	GX24-2F300N02TM-1	3	0,2	24	0,02–0,10	±0,02	±0,025													
	GX24-3F400N02TM-1	4	0,2	24	0,02–0,12	±0,02	±0,025													
	GX24-3F500N04TM-1	5	0,4	24	0,02–0,14	±0,02	±0,025													
	GX24-4F600N04TM-1	6	0,4	24	0,02–0,15	±0,02	±0,025													

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide
 BH = CBN with high CBN content
 BL = CBN with low CBN content

PCD – Grooving and parting off GX cutting inserts



Cutting inserts

Designation	s mm	r mm	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P			M		N		K		S			
							HC	HC	HC	HC	DP	HC	HC	DP					
							WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WDN10	WKP23S	WSM33S	WSM43S	WDN10			
	GX16-1F200N02FS-F1	2	0,2	16	0,04–0,12	±0,02	±0,02												
	GX24-2F300N02FS-F1	3	0,2	24	0,05–0,16	±0,02	±0,02												
	GX24-2F318N02FS-F1	3,18	0,2	24	0,05–0,16	±0,02	±0,02												
	GX24-3F400N02FS-F1	4	0,2	24	0,06–0,22	±0,02	±0,02												
	GX24-3F475N02FS-F1	4,75	0,2	24	0,06–0,25	±0,02	±0,02												
	GX24-3F500N02FS-F1	5	0,2	24	0,06–0,25	±0,02	±0,02												
	GX24-4F600N02FS-F1	6	0,2	24	0,06–0,28	±0,02	±0,02												

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

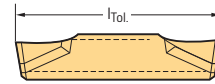
HC = Coated carbide
 DP = Polycrystalline diamond

Grooving and recessing

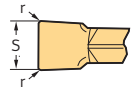
GX cutting inserts

Tiger-tec® Silver

A2



GX...N

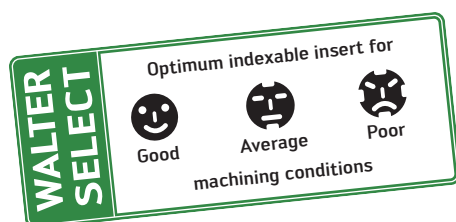


Cutting inserts

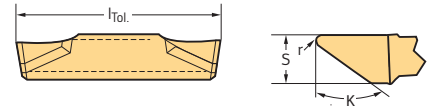
Designation	s mm	r mm	l mm	f mm	a _p mm	S _{Tol} mm	l _{Tol} mm	P				M			K		S		
								HC				HC			HC		HC		
								WKP23S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S	WKP23S	WSM23S	WSM33S	WSM43S	WKP23S
GX09-0E170N01-UF8	1,7	0,1	9	0,05-0,15	0,3-0,8	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-0E196N01-UF8	1,96	0,1	9	0,05-0,15	0,3-0,8	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-1E225N01-UF8	2,25	0,1	9	0,05-0,20	0,3-1,0	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-1E275N01-UF8	2,75	0,1	9	0,05-0,22	0,3-1,3	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX09-2E325N01-UF8	3,25	0,1	9	0,07-0,24	0,4-1,5	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-0E160N01-UF8	1,6	0,1	16	0,05-0,17	0,3-1,0	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-0E170N01-UF8	1,7	0,1	16	0,05-0,17	0,3-1,0	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-0E185N01-UF8	1,85	0,1	16	0,05-0,22	0,3-1,0	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-0E196N01-UF8	1,96	0,1	16	0,05-0,22	0,3-1,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-1E200N02-UF8	2	0,2	16	0,05-0,22	0,3-1,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-1E225N01-UF8	2,25	0,1	16	0,05-0,22	0,3-1,3	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-1E275N01-UF8	2,75	0,1	16	0,06-0,22	0,3-1,3	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E300N02-UF8	3	0,2	16	0,07-0,24	0,4-1,5	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E318N02-UF8	3,18	0,2	16	0,07-0,24	0,4-1,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-2E325N01-UF8	3,25	0,1	16	0,07-0,24	0,4-1,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-3E400N04-UF8	4	0,4	16	0,09-0,30	0,9-2,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-3E425N02-UF8	4,25	0,2	16	0,09-0,30	0,5-2,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX16-3E525N02-UF8	5,25	0,2	16	0,11-0,35	0,9-2,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-1E239N02-UF8	2,39	0,2	24	0,05-0,22	0,3-1,3	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-2E300N02-UF8	3	0,2	24	0,07-0,24	0,4-1,5	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-2E300N04-UF8	3	0,4	24	0,07-0,24	0,4-1,5	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-2E318N02-UF8	3,18	0,2	24	0,07-0,24	0,4-1,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-2E325N01-UF8	3,25	0,1	24	0,07-0,24	0,4-1,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E400N02-UF8	4	0,2	24	0,09-0,30	0,3-2,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E400N04-UF8	4	0,4	24	0,09-0,30	0,5-2,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E475N05-UF8	4,75	0,5	24	0,09-0,30	0,6-2,4	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E500N02-UF8	5	0,2	24	0,11-0,35	0,3-2,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E500N04-UF8	5	0,4	24	0,11-0,35	0,6-2,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-3E500N08-UF8	5	0,8	24	0,11-0,35	0,9-2,6	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-4E600N02-UF8	6	0,2	24	0,11-0,35	0,3-3,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-4E600N04-UF8	6	0,4	24	0,11-0,35	0,6-3,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-4E600N08-UF8	6	0,8	24	0,11-0,35	0,9-3,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-4E635N04-UF8	6,35	0,4	24	0,11-0,35	0,6-3,4	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX24-4E635N08-UF8	6,35	0,8	24	0,11-0,35	0,9-3,4	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
GX30-5E800N08-UF8	8	0,8	30	0,13-0,40	1,0-4,2	±0,02	±0,03	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide



Grooving and recessing GX cutting inserts Tiger-tec® Silver



A2

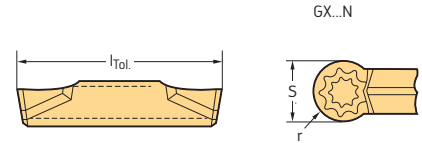
Cutting inserts

Designation	s mm	r mm	κ	l mm	f mm	a _p 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	WSM43S
GX24-2E280R02-VG7	2,8	0,2	50°	24	0,05-0,12	0,2-2,0	±0,05	±0,15	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX24-2E280R04-VG7	2,8	0,4	50°	24	0,08-0,25	0,2-2,5	±0,05	±0,15	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm
 Cutting insert can be used in G15... tools
 With other tools, adapt support to the cutting insert profile

HC = Coated carbide

Grooving and copy turning GX cutting inserts Tiger-tec® Silver



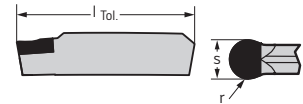
Cutting inserts

Designation	s mm	r mm	l mm	f mm	a _p mm	S _{Tol} mm	l _{Tol} mm	P				M			K	S		
								HC				HC			HC	HC		
								WKP23S	WSM13S	WSM23S	WSM33S	WSM43S	WSM13S	WSM23S	WSM33S	WSM43S	WKP23S	WSM13S
GX09-1E200N10-RF8	2	1	9	0,05-0,17	0,1-1,0	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX09-1E239N12-RF8	2,39	1,20	9	0,05-0,20	0,2-1,2	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-1E200N10-RF8	2	1	16	0,08-0,25	0,1-1,0	±0,05	±0,05	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-1E239N12-RF8	2,39	1,20	16	0,08-0,28	0,2-1,2	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-2E300N15-RF8	3	1,5	16	0,10-0,30	0,1-1,5	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-3E400N20-RF8	4	2	16	0,12-0,45	0,1-2,0	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-3E500N25-RF8	5	2,5	16	0,15-0,10	0,2-2,5	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX16-4E600N30-RF8	6	3	16	0,15-0,55	0,1-3,0	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX24-2E300N15-RF8	3	1,5	24	0,10-0,30	0,1-1,5	±0,02	±0,02	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
GX24-2E318N16-RF8	3,18	1,59	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 inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm



HC = Coated carbide

CBN – Grooving and copy turning GX cutting inserts



A2

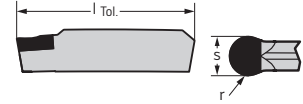
Cutting inserts

Designation	s mm	r mm	l mm	f mm	a _p mm	S _{Tol} mm	l _{Tol} mm	P		M		K	S		H	
								HC		HC		HC	HC		BH	BL
								WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WKP23S	WSM33S	WSM43S	WBS10
 GX24-2F300N15EM-1	3	1,5	24	0,10–0,15	0,1–1,5	±0,02	±0,03									
GX24-3F400N20EM-1	4	2	24	0,10–0,20	0,1–2,0	±0,02	±0,03									
GX24-3F500N25EM-1	5	2,5	24	0,10–0,25	0,1–2,5	±0,02	±0,03									
GX24-4F600N30EM-1	6	3	24	0,10–0,30	0,1–3,0	±0,02	±0,03									
 GX24-2F300N15TM-1	3	1,5	24	0,02–0,10	0,1–1,5	±0,02	±0,03									
GX24-3F400N20TM-1	4	2	24	0,02–0,12	0,1–2,0	±0,02	±0,03									
GX24-3F500N25TM-1	5	2,5	24	0,02–0,14	0,1–2,5	±0,02	±0,03									
GX24-4F600N30TM-1	6	3	24	0,02–0,15	0,1–3,0	±0,02	±0,03									


l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide
 BH = CBN with high CBN content
 BL = CBN with low CBN content

PCD – Grooving and copy turning GX cutting inserts



Cutting inserts

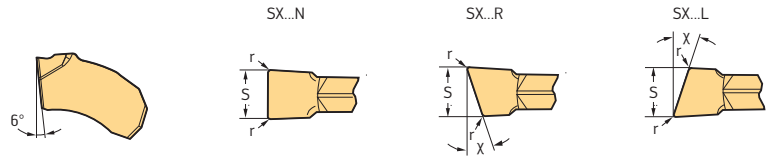
Designation	s mm	r mm	l mm	f mm	a _p mm	S _{Tol} mm	l _{Tol} mm	P		M	N	K	S		
								HC		HC	DP	HC	HC		DP
								WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WDN10	WKP23S	WSM33S
 GX16-1F200N10FS-M1	2	1	16	0,05–0,25	0,1–1,0	±0,02	±0,02								
GX24-2F300N15FS-M1	3	1,5	24	0,05–0,30	0,1–1,5	±0,02	±0,02								
GX24-2F318N16FS-M1	3,18	1,59	24	0,05–0,30	0,1–1,5	±0,02	±0,02								
GX24-3F400N20FS-M1	4	2	24	0,05–0,35	0,1–2,0	±0,02	±0,02								
GX24-3F475N24FS-M1	4,75	2,38	24	0,05–0,40	0,1–2,3	±0,02	±0,02								
GX24-3F500N25FS-M1	5	2,5	24	0,05–0,40	0,1–2,5	±0,02	±0,02								
GX24-4F600N30FS-M1	6	3	24	0,05–0,50	0,1–3,0	±0,02	±0,02								
GX30-5F800N40FS-M1	8	4	30	0,05–0,60	0,1–4,0	±0,02	±0,02								

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide
 DP = Polycrystalline diamond

 / ★ New addition to the product range

Grooving and parting off SX cutting inserts Tiger-tec® Silver



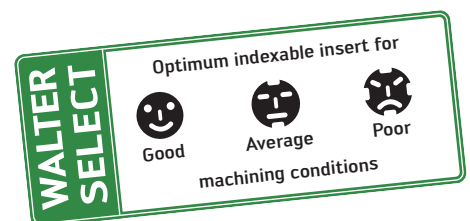
A2

Cutting inserts

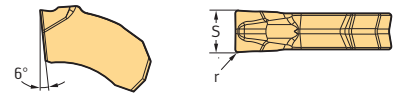
Designation	s mm	r mm	k	f mm	S _{Tol} mm	l _{Tol} mm	P			M		K	N	S			
							HC			HC		HC	HW	HC			
							WKP23S	WSM23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S	WKP23S	WK1	WSM23S	WSM33S
SX-2E200N02-CK8	2	0,2		0,04–0,12	±0,02	±0,05							☺				
SX-3E300N02-CK8	3	0,2		0,08–0,20	±0,02	±0,05							☺				
SX-4E400N02-CK8	4	0,2		0,10–0,22	±0,02	±0,05							☺				
SX-5E500N04-CK8	5	0,4		0,10–0,25	±0,02	±0,05							☺				
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		☺	☺	☺	☺					☺	☺
SX-1E150N01-CE4	1,5	0,15		0,03–0,12	±0,05	±0,1			☺								☺
SX-2E200N02-CE4	2	0,2		0,06–0,15	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺
SX-2E200R6-CE4	2	0,2	6°	0,06–0,10	±0,05	±0,1			☺								☺
SX-2E260N03-CE4	2,6	0,3		0,06–0,18	±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°	0,09–0,20	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺
SX-3E310N03-CE4	3,1	0,3		0,09–0,30	±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°	0,10–0,22	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺
SX-4E410N03-CE4	4,1	0,3		0,10–0,32	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺
SX-4E480N03-CE4	4,8	0,3		0,12–0,35	±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°	0,12–0,25	±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		0,20–0,55	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺
SX-10E1000N08-CE4	10	0,8		0,25–0,60	±0,05	±0,1	☺	☺	☺	☺	☺					☺	☺

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide
HW = Uncoated carbide



Grooving and recessing SX cutting inserts Tiger-tec® Silver



A2

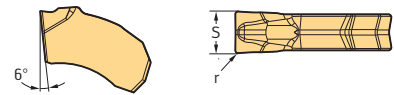
Cutting inserts

Designation	s mm	r mm	l mm	f mm	a _p mm	S _{Tol} mm	l _{Tol} mm	P		M		K	S	
								HC		HC		HC	HC	
								WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WKP23S	WSM33S
SX-8E800N08-UF4	8	0,8	17,4	0,18–0,55	0,9–4,0	±0,05	±0,1	☺	☺	☺	☺	☺	☺	☺

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide

Slitting SX cutting inserts Tiger-tec® Silver



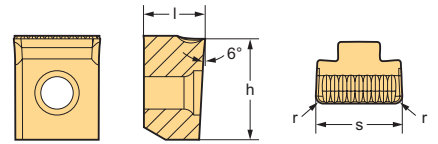
Cutting inserts

Designation	s mm	r mm	f mm	S _{Tol} mm	l _{Tol} mm	P		M		K	N	S	
						HC		HC		HC	HW	HC	
						WKP23S	WSM33S	WSM43S	WSM33S	WSM43S	WKP23S	WK1	WSM33S
SX-1E150N01-SK8	1,5	0,1	0,03–0,08	±0,02	±0,05						☺		
SX-2E200N02-SK8	2	0,2	0,05–0,10	±0,02	±0,05						☺		
SX-3E300N02-SK8	3	0,2	0,05–0,15	±0,02	±0,05						☺		
SX-4E400N02-SK8	4	0,2	0,05–0,20	±0,02	±0,05						☺		
SX-5E500N04-SK8	5	0,4	0,05–0,25	±0,02	±0,05						☺		
SX-1E150N01-SF5	1,5	0,15	0,03–0,10	±0,05	±0,1	☺	☺					☺	
SX-2E200N02-SF5	2	0,2	0,06–0,15	±0,05	±0,1	☺	☺	☺	☺			☺	☺
SX-3E300N02-SF5	3	0,2	0,08–0,20	±0,05	±0,1	☺	☺	☺	☺			☺	☺
SX-4E400N02-SF5	4	0,2	0,10–0,22	±0,05	±0,1	☺	☺	☺	☺			☺	☺
SX-5E500N04-SF5	5	0,4	0,10–0,25	±0,05	±0,1	☺	☺	☺	☺			☺	☺

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide
HW = Uncoated carbide

Grooving and parting off UX cutting inserts Tiger-tec® Silver



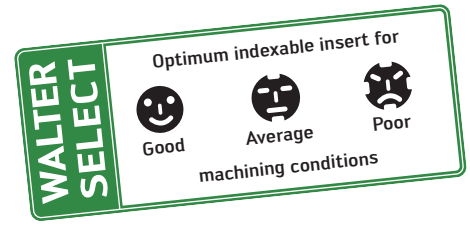
A2

Cutting inserts

Designation	s mm	r mm	l mm	h mm	f mm	S _{Tol} mm	l _{Tol} mm	P			K									
								HC	WKP13S	WKP23S	WKP33S	HC	WKP13S							WKP23S
UX-12E1200N10-GD2	12	1	8,6	14	0,20-0,40	±0,2	±0,1	☺	☺	☺	☺	☺	☺	☺						
UX-19E1900N15-GD2	19	1,5	13,6	18	0,25-0,60	±0,2	±0,1	☺	☺	☺	☺	☺	☺	☺						

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
 Radius tolerance r_{Tol} = ± 0.05 mm

HC = Coated carbide



☺ ☺ ☺ / ★ New addition to the product range

Walter Cut grooving tools product range overview

Shank tools/parting blades/boring bars/Walter Capto™ groove turning holders

A2

Machining						
Type						
Designation	G3011	G3011...-P	G3051...-P	G3021...-P	G4014	G4014-P
Insert width s [mm]	0,8–3,25	0,8–5,65	0,8–3,25	0,8–5,65	1,5–3	2–3
Cutting depth T_{max} [mm]	6	6	6	6	10–18	12–18
Coolant supply	external	Precision cooling	Precision cooling	Precision cooling	external	Precision cooling
Shank size h [mm]	10–12	12–25	12–25	20–25	10–20	12–20
Shank size h [inch]	0,394–0,472	0,472–1,000	0,472–1,000	0,787–1,000	0,394–0,787	0,472–0,787
Page	135	136	140	145	149	150

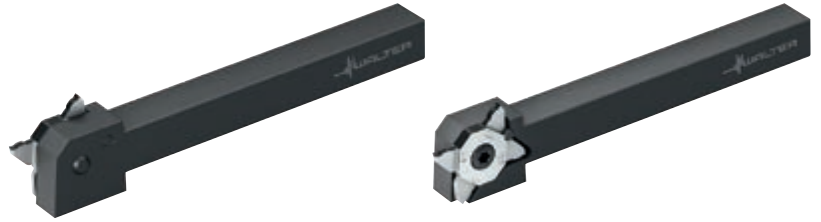
Machining						
Type						
Designation	G1011	G1011...-P	G2012	G2016...-P	G3041	G3041...C
Insert width s [mm]	4	2–8	1,5–3	12–19	0,8–3,25	0,8–3,25
Cutting depth T_{max} [mm]	32	12–33	15–33	41	6	6
Coolant supply	external	Precision cooling	external	Precision cooling	external	external
Shank size h [mm]	25	12–32	12–25	25–32	26	26
Shank size h [inch]	1,000	0,472–1,260	0,472–1,000	0,984–1,260	1,024	1,024
Page	156	157	164	167	147	148

				Boring bar for internal grooving	Walter Capto™ groove turning holders
Machining					
Type					
Designation	G1041...-P	G1041...C-P	G2042...R/L...-P	G1221...-P	C...-G3011...-P
Insert width s [mm]	2–4	2–4	2–4	2–6	0,5–5,56
Cutting depth T_{max} [mm]	16–33	16–33	26–33	4–12	6
Coolant supply	Precision cooling	Precision cooling	Precision cooling	Precision cooling	Precision cooling
Shank size h [mm]	26–32	26–32	26–32	16–40	Walter Capto™ size:
Shank size h [inch]	1,024–1,260	1,024–1,260	1,024–1,260	0,625–1,500	C3/C4/C5/C6
Page	160	161	166	162	169

Shank tool – Radial grooving

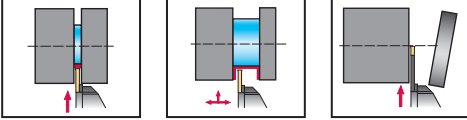
G3011 mm

Walter Cut



A2

– Screw clamping



Tool		s	T _{max}	h = h ₁	b	f ₁	l ₁	h ₄	l ₄	Type
Designation		mm	mm	mm	mm	mm	mm	mm	mm	
	G3011-1010R/L-MX22-2	0,8– 3,25	6	10	10	8,3	120	7	28	MX22-2E ..
	G3011-1212R/L-MX22-2									

$f = f_1 + s/2$
 For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 Ordering example, right-hand tool: G3011-1010R-MX22-2/ordering example, left-hand tool: G3011-1010L-MX22-2
 Bodies and assembly parts are included in the scope of delivery.

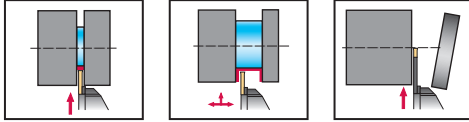
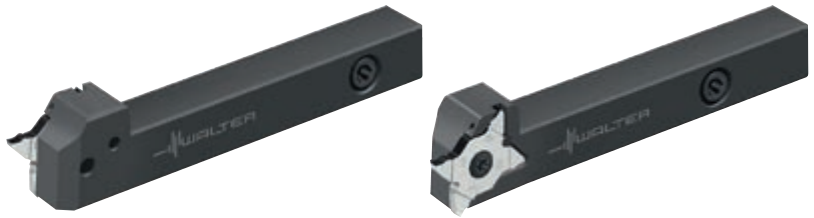
Assembly parts		h = h ₁ [mm]	10-12
	Clamping screw for grooving insert Tightening torque		FS2570 (Torx 20IP) 5,0 Nm
	Torx key		FS2572 (Torx 10IP)

Shank tool – Radial grooving

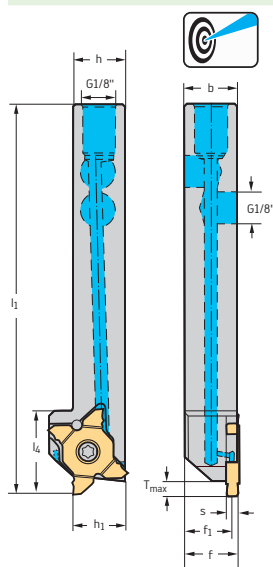
 G3011...-P

Walter Cut

- Screw clamping
- Precision cooling



Tool



Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	Type
G3011-1212R/L-MX22-2-P	0,8–3,25	6	12	12	10,3	120	26	MX22-2E ..
G3011-1616R/L-MX22-2-P		6	16	16	14,3	120	26	
G3011-1616R/L-MX22-4-P	4–5,65	6	16	16	13,2	120	26	MX22-4E ..

$$f = f_1 + s/2$$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3011-1212R-MX22-2-P/ordering example, left-hand tool: G3011-1212L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h = h ₁ [mm] s [mm]	12-16 0,8–3,25	16 4–5,65
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
	Torx key	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool – Radial grooving

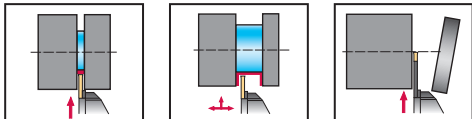
G3011...-P

Walter Cut

- Screw clamping
- Precision cooling



A2



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	Type
	G3011-2020R/L-MX22-2-P	0,8-3,25	6	20	20	18,3	125	26	MX22-2E ..
	G3011-2525R/L-MX22-2-P		6	25	25	23,3	125	26	
	G3011-2020R/L-MX22-4-P	4-5,65	6	20	20	17,2	125	26	MX22-4E ..
	G3011-2525R/L-MX22-4-P		6	25	25	22,2	125	26	

f = f₁ + s/2
 For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3011-2020R-MX22-2-P/ordering example, left-hand tool: G3011-2020L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

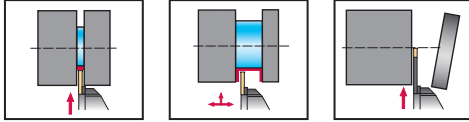
Assembly parts	h = h ₁ [mm] s [mm]	20 0,8-3,25	20 4-5,65	25 0,8-3,25/4-5,65
Clamping screw for grooving insert Tightening torque		FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
G 1/8" threaded plug		FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)
M6 threaded plug		FS2288 (SW 3)	FS2288 (SW 3)	FS2288 (SW 3)
Torx key		FS2572 (Torx 10IP)	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool – Radial grooving

G3011...-P inch

Walter Cut

- Screw clamping
- Precision cooling



Tool	Designation	s inch	T _{max} inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	Type
	★ G3011.08R/L-MX22-2-P	0,031– 0,128	0,236	0,500	0,500	0,434	4,724	1,024	MX22-2E ..
	★ G3011.10R/L-MX22-2-P		0,236	0,625	0,625	0,559	4,724	1,024	

$f = f_1 + s/2$
 For information on the maximum cutting depth T_{max} , see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3011.08R-MX22-2-P/ordering example, left-hand tool: G3011.08L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	h = h ₁ [inch]	0,500	0,625
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm	FS2570 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug		FS2258 (SW 5)
	UNF 5/16-24 threaded plug	FS2593	
	Torx key	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Accessories	h = h ₁ [inch]	0,500	
	5/16" UNF angle connection		FS2594
	5/16" UNF connection element		FS2595
	Copper gasket		FS2598

Shank tool – Radial grooving

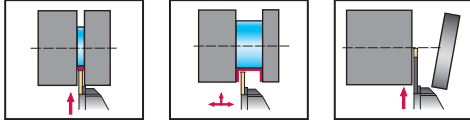
G3011...-P inch

Walter Cut

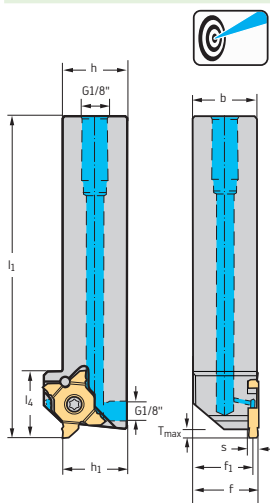
- Screw clamping
- Precision cooling



A2



Tool



Designation	s inch	T _{max} inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	Type
G3011.12R/L-MX22-2-P	0,031– 0,128	0,236	0,750	0,750	0,684	5,906	1,024	MX22-2E ..
G3011.16R/L-MX22-2-P		0,236	1,000	1,000	0,934	5,906	1,024	
G3011.12R/L-MX22-4-P	0,157– 0,222	0,236	0,750	0,750	0,639	5,906	1,024	MX22-4E ..
G3011.16R/L-MX22-4-P		0,236	1,000	1,000	0,889	5,906	1,024	

$$f = f_1 + s/2$$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: G3011.12R-MX22-2-P/ordering example, left-hand tool: G3011.12L-MX22-2-P

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

Assembly parts

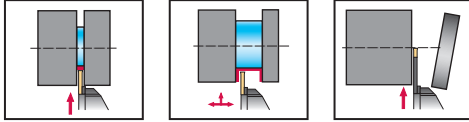
	h = h ₁ [inch] s [inch]	0,750 0,031–0,128	0,750 0,157–0,222	1,000 0,031–0,128/0,157–0,222
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)
	Torx key	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool 3° – Radial grooving

 G3051...-P

Walter Cut

- Grooving and parting off for shoulder with clearance
- Precision cooling



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
	★ G3051-1212R/L-MX22-2-P	0,8–3,25	6	12	12	10,3	120	5	26	MX22-2R.. MX22-2L..

$$f = f_1 + s/2$$

 For information on the maximum cutting depth T_{max}, see "Cutting inserts"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

When using G3051...R, the MX22-2R... cutting insert should be used/when using G3051...L, the MX22-2L... cutting insert should be used

Ordering example, right-hand tool: G3051-1212R-MX22-2-P/ordering example, left-hand tool: G3051-1212L-MX22-2-P

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

Assembly parts	h = h ₁ [mm]	12
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm
	M8x1 threaded plug	FS2587
	Torx key	FS2572 (Torx 10IP)

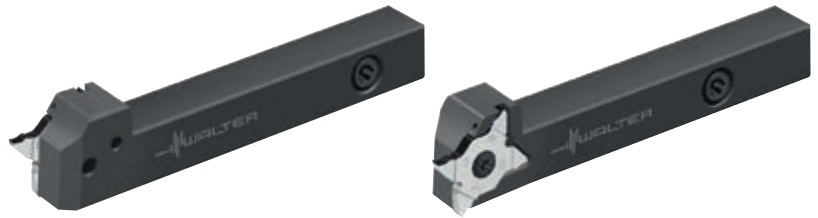
Accessories	h = h ₁ [mm]	12
	M8x1 angle connection	FS2596
	M8x1 connection element	FS2597
	Copper gasket	FS2598

Shank tool 3° – Radial grooving

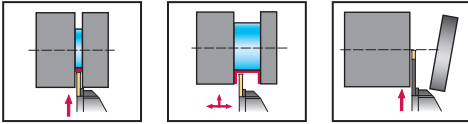
G3051...-P

Walter Cut

- Grooving and parting off for shoulder with clearance
- Precision cooling



A2



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	Type
	★ G3051-1616R/L-MX22-2-P	0,8-3,25	6	16	16	14,3	120	26	MX22-2R .. MX22-2L ..

$f = f_1 + s/2$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

When using G3051...R, the MX22-2R... cutting insert should be used/when using G3051...L, the MX22-2L... cutting insert should be used

Ordering example, right-hand tool: G3051-1616R-MX22-2-P/ordering example, left-hand tool: G3051-1616L-MX22-2-P

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

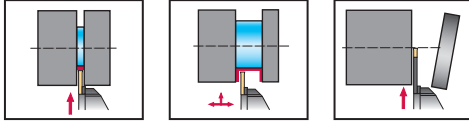
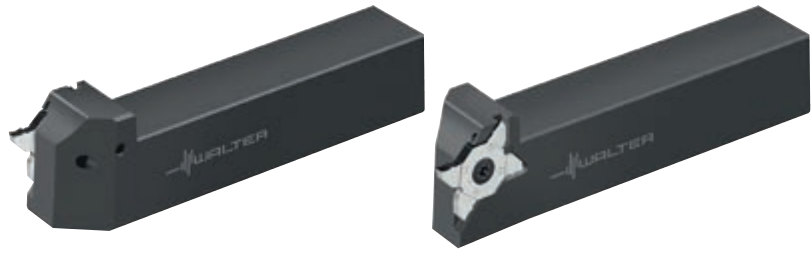
Assembly parts		h = h ₁ [mm]	16
	Clamping screw for grooving insert Tightening torque		FS2570 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug		FS2258 (SW 5)
	Torx key		FS2572 (Torx 10IP)

Shank tool 3° – Radial grooving

G3051...-P

Walter Cut

- Grooving and parting off for shoulder with clearance
- Precision cooling



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	Type
	★ G3051-2020R/L-MX22-2-P	0,8–3,25	6	20	20	18,3	125	26	MX22-2R ..
	★ G3051-2525R/L-MX22-2-P		6	25	25	23,3	125	26	MX22-2L ..

$$f = f_1 + s/2$$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"

The maximum recommended coolant pressure is 150 bar (2175 psi)

When using G3051...R, the MX22-2R... cutting insert should be used/when using G3051...L, the MX22-2L... cutting insert should be used

Ordering example, right-hand tool: G3051-2020R-MX22-2-P/ordering example, left-hand tool: G3051-2020L-MX22-2-P

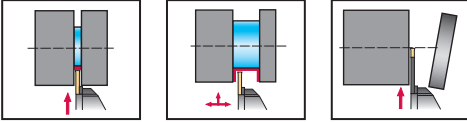
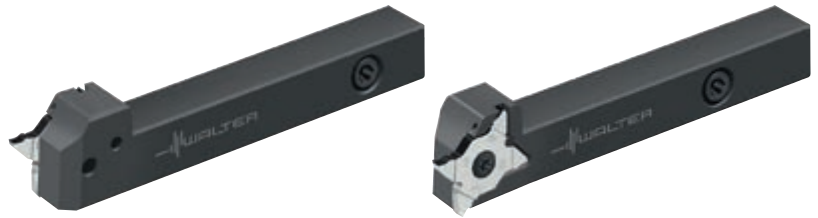
Bodies and assembly parts are included in the scope of delivery.

Assembly parts	h = h ₁ [mm]	20	25
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)	FS2288 (SW 3)
	Torx key	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool 3° – Radial grooving G3051...-P inch

Walter Cut

- Grooving and parting off for shoulder with clearance
- Precision cooling



Tool	Designation	s inch	T _{max} inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	Type
	★ G3051.10R/L-MX22-2-P	0,031–0,128	0,236	0,625	0,625	0,691	4,724	1,024	MX22-2R .. MX22-2L ..

$f = f_1 + s/2$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"

The maximum recommended coolant pressure is 150 bar (2175 psi)

When using G3051...R, the MX22-2R... cutting insert should be used/when using G3051...L, the MX22-2L... cutting insert should be used

Ordering example, right-hand tool: G3051.10R-MX22-2-P/ordering example, left-hand tool: G3051.10L-MX22-2-P

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

Assembly parts		h = h ₁ [inch]	0,625
	Clamping screw for grooving insert Tightening torque		FS2570 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug		FS2258 (SW 5)
	Torx key		FS2572 (Torx 10IP)

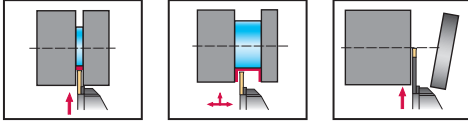
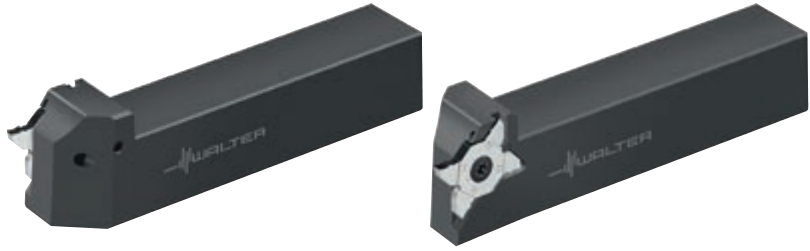
A2

Shank tool 3° – Radial grooving

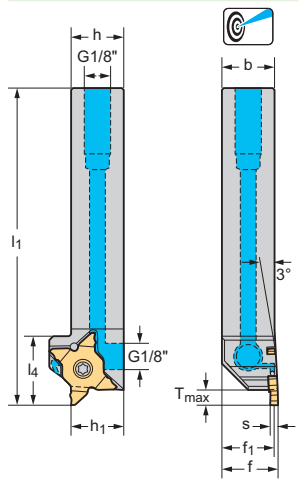
G3051...-P inch

Walter Cut

- Grooving and parting off for shoulder with clearance
- Precision cooling



Tool



Designation	s inch	T _{max} inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	Type
★ G3051.12R/L-MX22-2-P	0,031–0,128	0,236	0,750	0,750	0,816	5,906	1,024	MX22-2R ..
★ G3051.16R/L-MX22-2-P		0,236	1,000	1,000	1,066	5,906	1,024	MX22-2L ..

$$f = f_1 + s/2$$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 When using G3051...R, the MX22-2R... cutting insert should be used/when using G3051...L, the MX22-2L... cutting insert should be used
 Ordering example, right-hand tool: G3051.12R-MX22-2-P/ordering example, left-hand tool: G3051.12L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

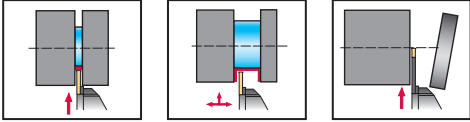
Assembly parts	h = h ₁ [inch]	0,750	1,000
Clamping screw for grooving insert Tightening torque		FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
G 1/8" threaded plug		FS2258 (SW 5)	FS2258 (SW 5)
Torx key		FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool – Radial grooving

G3021...-P

Walter Cut

- Screw clamping
- Precision cooling



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f mm	l ₄ mm	l ₂₁ mm	Type
	G3021-2020R/L-MX22-2-P	0,8–3,25	6	20	20	30	19	123,3	MX22-2E ..
	G3021-2525R/L-MX22-2-P		6	25	25	35	19	123,3	
	G3021-2525R/L-MX22-4-P	4–5,65	6	25	25	35	19	124,5	MX22-4E ..

l₁ = l₂₁ + s/2
 For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3021-2020R-MX22-2-P/ordering example, left-hand tool: G3021-2020L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

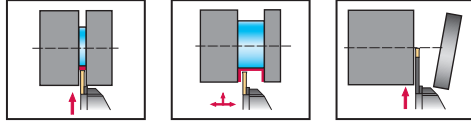
Assembly parts	h = h ₁ [mm] s [mm]	20 0,8–3,25	25 0,8–3,25	25 4–5,65
	Clamping screw for grooving insert Tightening torque	FS2570 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm	FS2571 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)	FS2288 (SW 3)	
	Torx key	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)	FS2572 (Torx 10IP)

Shank tool – Radial grooving

G3021...-P **inch**

Walter Cut

- Screw clamping
- Precision cooling



Tool

Designation	s inch	T _{max} inch	h = h ₁ inch	b inch	f inch	l ₄ inch	l ₂₁ inch	Type
G3021.16R/L-MX22-2-P	0,031– 0,128	0,236	1,000	1,000	1,394	0,748	5,842	MX22-2E ..
G3021.16R/L-MX22-4-P	0,157– 0,222	0,236	1,000	1,000	1,394	0,748	5,794	MX22-4E ..

$$l_1 = l_{21} + s/2$$

For information on the maximum cutting depth T_{max} , see "Cutting inserts"
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3021.16R-MX22-2-P/ordering example, left-hand tool: G3021.16L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

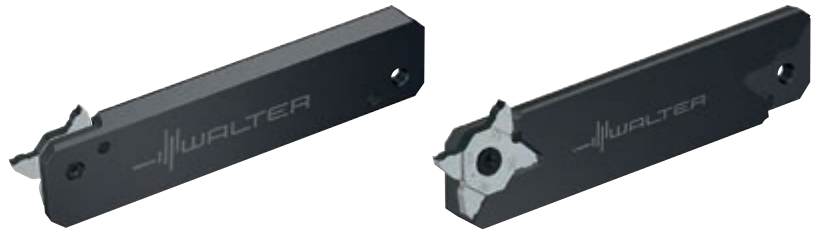
Assembly parts

h = h ₁ [inch]	1,000	
	Clamping screw for grooving insert Tightening torque	FS2571 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)
	Torx key	FS2572 (Torx 10IP)

Reinforced parting blade

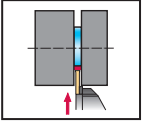
G3041

Walter Cut



A2

– Screw clamping



Tool		s mm	T _{max} mm	h ₄ mm	l ₁ mm	h ₁ mm	Type	
	Designation	G3041.26R/L-MX22-2	0,8–3,25	6	26	110	21	MX22-2E ..

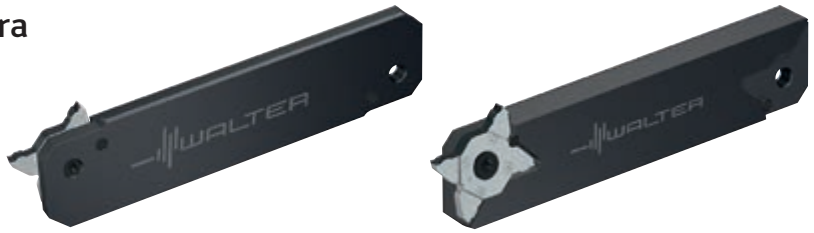
For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 Ordering example, right-hand tool: G3041.26R-MX22-2/ordering example, left-hand tool: G3041.26L-MX22-2
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		h ₄ [mm]	26
	Clamping screw for grooving insert		FS2574 (Torx 20IP)
	Tightening torque		5,0 Nm
	Torx key		FS2572 (Torx 10IP)

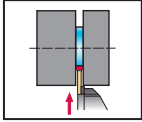
Reinforced parting blade – Contra

G3041...C

Walter Cut



– Screw clamping



Tool

	Designation	s mm	T _{max} mm	h ₄ mm	l ₁ mm	h ₁ mm	Type
	G3041.26R/L-MX22-2C	0,8–3,25	6	26	110	21	MX22-2E ..

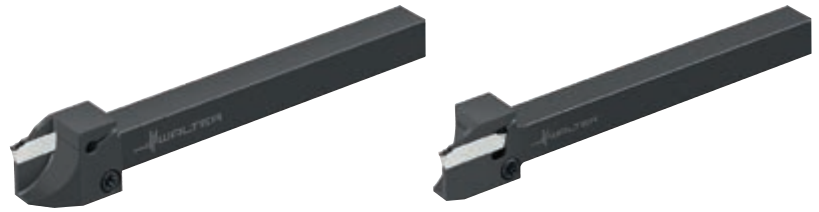
For information on the maximum cutting depth T_{max}, see “Cutting inserts”
 Ordering example, right-hand tool: G3041.26R-MX22-2C/ordering example, left-hand tool: G3041.26L-MX22-2C
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h ₄ [mm]	26
	Clamping screw for grooving insert Tightening torque	FS2574 (Torx 20IP) 5,0 Nm
	Torx key	FS2572 (Torx 10IP)

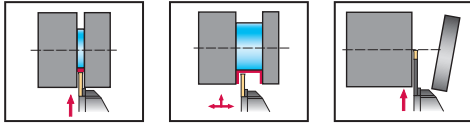
Shank tool – Radial grooving

G4014



A2

– Side screw clamping



Tool		Designation	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
	★	G4014-1010R/L-1.5T10DX18	1.5	20	10	10	9,4	110	4	21	DX18-1E1 ..
	★	G4014-1212R/L-1.5T12DX18		25	12	12	11,4	110	3	22	
	★	G4014-1616R/L-1.5T12DX18		25	16	16	15,4	120	4	24	
	★	G4014-1010R/L-2T10DX18	2	20	10	10	9,2	110	4	21	DX18-2E2 ..
	★	G4014-1212R/L-2T12DX18		25	12	12	11,2	110	3	22	
	★	G4014-1616R/L-2T12DX18		25	16	16	15,2	120	4	24	
	★	G4014-1616R/L-3T17DX18	3	35	16	16	14,8	120	4	30	DX18-3E3 ..
	★	G4014-2020R/L-3T17DX18		35	20	20	18,8	120	3	30	

f = f₁ + s/2
 Ordering example, right-hand tool: G4014-1010R-1.5T10DX18/ordering example, left-hand tool: G4014-1010L-1.5T10DX18
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		h = h ₁ [mm]	10-12	16-20
	Clamping screw for grooving insert Tightening torque		FS2586 (Torx 15IP) 2,0 Nm	FS2585 (Torx 15IP) 3,0 Nm
	Screw plug		FS2589	FS2589
	Torx key		FS1465 (Torx 15IP / SW 3,5)	FS1465 (Torx 15IP / SW 3,5)

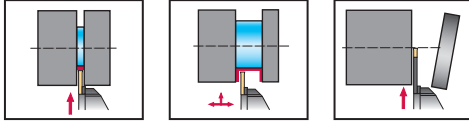
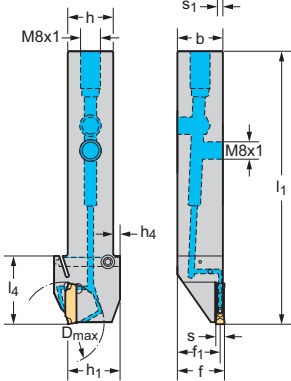
Accessories		h = h ₁ [mm]	10-20
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)

Shank tool – Radial grooving

 G4014-P mm

Walter Cut

- Side screw clamping
- Precision cooling


Tool

Designation

	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
★ G4014-1212R/L-2T12DX18-P	2	25	12	12	11,2	110	3	22	DX18-2E2 ..
★ G4014-1212R/L-2.5T12DX18-P	2,5	25	12	12	11	110	3	22	DX18-2E25 ..
★ G4014-1212R/L-3T12DX18-P	3	25	12	12	10,8	110	3	22	DX18-3E3 ..

$f = f_1 + s/2$
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G4014-1212R-2T12DX18-P/ordering example, left-hand tool: G4014-1212L-2T12DX18-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		h = h ₁ [mm]	12
	Clamping screw for grooving insert Tightening torque		FS2586 (Torx 15IP) 2,0 Nm
	Screw plug		FS2589
	M8x1 threaded plug		FS2587
	Torx key		FS1465 (Torx 15IP /SW 3,5)

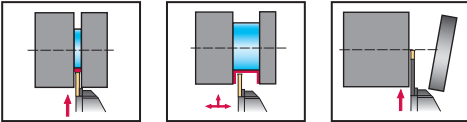
Accessories		h = h ₁ [mm]	12
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)
	M8x1 angle connection		FS2596
	M8x1 connection element		FS2597
	Copper gasket		FS2598

Shank tool – Radial grooving

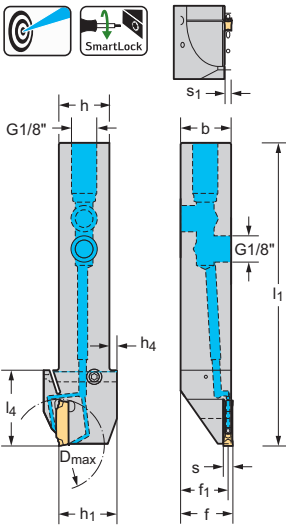
G4014-P

Walter Cut

- Side screw clamping
- Precision cooling



Tool



Designation	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
★ G4014-1616R/L-2T12DX18-P	2	25	16	16	15,2	120	4	24	DX18-2E2 ..
★ G4014-1616R/L-2T17DX18-P		35	16	16	15,2	120	4	30	
★ G4014-1616R/L-2.5T17DX18-P	2,5	35	16	16	15	120	4	30	DX18-2E25 ..
★ G4014-1616R/L-3T17DX18-P	3	35	16	16	14,8	120	4	30	DX18-3E3 ..

f = f₁ + s/2
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G4014-1616R-2T12DX18-P/ordering example, left-hand tool: G4014-1616L-2T12DX18-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

h = h ₁ [mm]	16
Clamping screw for grooving insert Tightening torque	FS2585 (Torx 15IP) 3,0 Nm
Screw plug	FS2589
G 1/8" threaded plug	FS2258 (SW 5)
Torx key	FS1465 (Torx 15IP / SW 3,5)

Accessories

h = h ₁ [mm]	16
Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
Interchangeable blade	FS2014 (Torx 15IP)

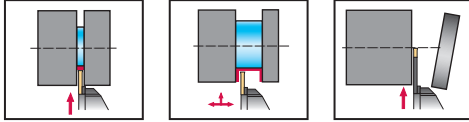
Shank tool – Radial grooving

 G4014-P

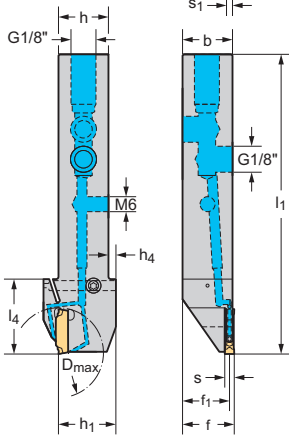
A2

Walter Cut

- Side screw clamping
- Precision cooling



Tool



Designation	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
★ G4014-2020R/L-2T17DX18-P	2	35	20	20	19,2	120	3	30	DX18-2E2 ..
★ G4014-2020R/L-3T17DX18-P	3	35	20	20	18,8	120	3	30	DX18-3E3 ..

$f = f_1 + s/2$
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G4014-2020R-2T17DX18-P/ordering example, left-hand tool: G4014-2020L-2T17DX18-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h = h ₁ [mm]	20
	Clamping screw for grooving insert Tightening torque	FS2585 (Torx 15IP) 3,0 Nm
	Screw plug	FS2589
	G 1/8" threaded plug	FS2258 (SW 5)
	M6 threaded plug	FS2288 (SW 3)
	Torx key	FS1465 (Torx 15IP /SW 3.5)

Accessories

	h = h ₁ [mm]	20
	Torque screwdriver, analogue Tightening torque	FS2003 1,5-5,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)

Shank tool – Radial grooving

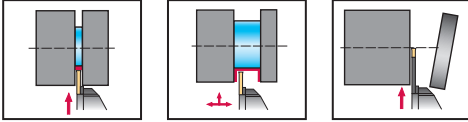
G4014 **inch**

Walter Cut



A2

– Side screw clamping



Tool		Designation	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
	★	G4014.08R/L-1.5T12DX18	1,5	25	12,7	12,7	12,1	110	2	22	DX18-1E1 ..

f = f₁ + s/2
 Ordering example, right-hand tool: G4014.08R-1.5T12DX18/ordering example, left-hand tool: G4014.08L-1.5T12DX18
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		h = h ₁ [mm]	12,7
	Clamping screw for grooving insert Tightening torque		FS2586 (Torx 15IP) 2,0 Nm
	Screw plug		FS2589
	Torx key		FS1465 (Torx 15IP /SW 3,5)

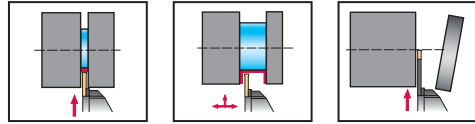
Accessories		h = h ₁ [mm]	12,7
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)

Shank tool – Radial grooving

G4014-P inch

Walter Cut

- Side screw clamping
- Precision cooling



Tool		s	D _{max}	h = h ₁	b	f ₁	l ₁	h ₄	l ₄	Type
Designation		mm	mm	mm	mm	mm	mm	mm	mm	
	★ G4014.08R/L-2T12DX18-P	2	25	12,7	12,7	11,9	110	2	22	DX18-2E2 ..
	★ G4014.08R/L-3T12DX18-P	3	25	12,7	12,7	11,5	110	2	22	DX18-3E3 ..

$f = f_1 + s/2$
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G4014.08R-2T12DX18-P/ordering example, left-hand tool: G4014.08L-2T12DX18-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		
	h = h ₁ [mm]	12,7
	Clamping screw for grooving insert Tightening torque	FS2586 (Torx 15IP) 2,0 Nm
	Screw plug	FS2589
	UNF 5/16-24 threaded plug	FS2593
	Torx key	FS1465 (Torx 15IP /SW 3,5)

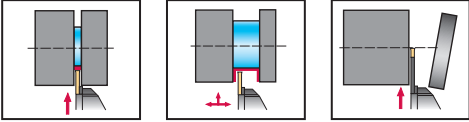
Accessories		
	h = h ₁ [mm]	12,7
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	5/16" UNF angle connection	FS2594
	5/16" UNF connection element	FS2597
	Copper gasket	FS2598

Shank tool – Radial grooving

G4014-P 1/2 inch

Walter Cut

- Side screw clamping
- Precision cooling



Tool	Designation	s mm	D _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	h ₄ mm	l ₄ mm	Type
	★ G4014.10R/L-2T17DX18-P	2	35	15,9	15,9	15,1	120	4	30	DX18-2E2 ..
	★ G4014.10R/L-3T17DX18-P	3	35	15,9	15,9	14,7	120	4	30	DX18-3E3 ..

f = f₁ + s/2
 For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G4014.10R-2T17DX18-P/ordering example, left-hand tool: G4014.10L-2T17DX18-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		h = h ₁ [mm]	15,9
	Clamping screw for grooving insert Tightening torque		FS2585 (Torx 15IP) 3,0 Nm
	Screw plug		FS2589
	G 1/8" threaded plug		FS2258 (SW 5)
	Torx key		FS1465 (Torx 15IP /SW 3,5)

Accessories		h = h ₁ [mm]	15,9
	Torque screwdriver, analogue Tightening torque		FS2003 1,5-5,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)

☠☠☠ / ★ New addition to the product range

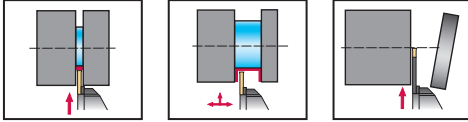
Shank tool – Radial grooving

G1011 inch

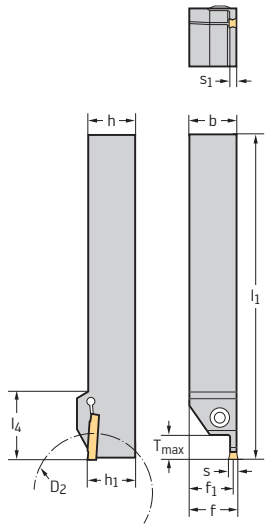
Walter Cut



– Screw clamping



Tool



Designation	s inch	T _{max} inch	D ₂ inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	s ₁ inch	Type
G1011.16R/L-4T32GX24	0,157	1,260		1,000	1,000	0,933	6,496	2,165	0,134	GX24-3E4 .. GX24-3F4 ..

For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"
 f = f₁ + s/2
 Ordering example, right-hand tool: G1011.16R-4T32GX24/ordering example, left-hand tool: G1011.16L-4T32GX24
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h = h ₁ [inch]	1,000
	Clamping screw for grooving insert Tightening torque	FS2118 (Torx 20IP) 5,0 Nm
	Torx key	FS1464 (Torx 20IP)

Shank tool – Radial grooving

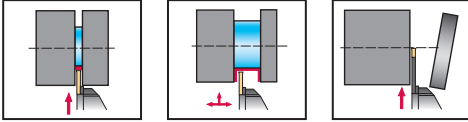
G1011...-P

Walter Cut

- Screw clamping
- Precision cooling



A2



Tool	Designation	s mm	T _{max} mm	D ₂ mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	s ₁ mm	Type	
	G1011.1212R/L-2T12GX16-P	2	12		12	12	11,2	120	31,5	1,6	GX16-1E2 .. GX16-1F2 ..	
	G1011.1616R/L-2T15GX16-P		15		16	16	15,2	120	35,5	1,6		
	G1011.1616R/L-2T21GX24-P	3	21	80	16	16	15,3	120	40	1,6	GX24-1E2 ..	
	G1011.1616R/L-3T15GX16-P		15		16	16	14,9	120	35,5	2,2	GX16-2E3 ..	
	G1011.1616R/L-3T12GX24-P	4	12		16	16	14,8	120	31,5	2,4	GX24-2E .. GX24-2F3 ..	
	G1011.1616R/L-3T21GX24-P		21	80	16	16	14,8	120	40	2,4		
	G1011.1616R/L-4T12GX24-P		4	12		16	16	14,3	120	35	3,4	GX24-3E4 .. GX24-3F4 ..
	G1011.2020R/L-2T15GX16-P	2	15		20	20	19,2	120	35,5	1,6	GX16-1E2 .. GX16-1F2 ..	
	G1011.2020R/L-2T21GX24-P		21	80	20	20	19,2	125	40	1,6	GX24-1E2 ..	
	G1011.2525R/L-2T21GX24-P	3	21		25	25	24,2	130	40	1,5	GX24-1E2 ..	
	G1011.2020R/L-3T15GX16-P		15		20	20	18,9	120	35,5	2,2	GX16-2E3 ..	
	G1011.2020R/L-3T12GX24-P	4	12		20	20	18,8	120	31,5	2,4	GX24-2E .. GX24-2F3 ..	
	G1011.2020R/L-3T21GX24-P		21	80	20	20	18,8	125	40	2,4		
	G1011.2525R/L-3T12GX24-P	5	12		25	25	23,8	125	35	2,4	GX24-2E .. GX24-2F3 ..	
	G1011.2525R/L-3T21GX24-P		21	80	25	25	23,8	130	40	2,4		
	G1011.2020R/L-3T33GX34-P	4	33	140	20	20	18,8	140	53	2,4	GX34-2E3 ..	
	G1011.2525R/L-3T33GX34-P		33	140	25	25	23,8	145	53	2,4		
	G1011.2020R/L-4T12GX24-P	5	12		20	20	18,3	120	35	3,4	GX24-3E4 .. GX24-3F4 ..	
	G1011.2020R/L-4T21GX24-P		21		20	20	18,3	125	40	3,4		
	G1011.2525R/L-4T12GX24-P	4	12		25	25	23,3	125	35	3,4	GX24-3E4 .. GX24-3F4 ..	
	G1011.2525R/L-4T21GX24-P		21		25	25	23,3	130	40	3,4		
	G1011.2525R/L-4T32GX24-P	5	32		25	25	23,3	145	55	3,4	GX24-3E4 .. GX24-3F4 ..	
	G1011.2020R/L-4T33GX34-P		33	140	20	20	18,4	140	53	3,3	GX34-3E4 ..	
	G1011.2525R/L-4T33GX34-P	4	33	140	25	25	23,4	145	53	3,3	GX34-3E4 ..	
	G1011.2020R/L-5T12GX24-P		5	12		20	20	17,9	120	35	4,2	GX24-3E5 .. GX24-3F5 ..
	G1011.2020R/L-5T21GX24-P	21			20	20	17,9	125	40	4,2		

$f = f_1 + s/2$

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: G1011.1212R-2T12GX16-P/ordering example, left-hand tool: G1011.1212L-2T12GX16-P

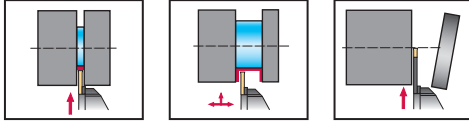
Bodies and assembly parts are included in the scope of delivery.

Shank tool – Radial grooving

 G1011...-P

Walter Cut

- Screw clamping
- Precision cooling



Tool	Designation	s mm	T _{max} mm	D ₂ mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	s ₁ mm	Type	
	G1011.2525R/L-5T12GX24-P	5	12		25	25	22,9	125	35	4,2	GX24-3E5 .. GX24-3F5 ..	
	G1011.2525R/L-5T21GX24-P		21		25	25	22,9	130	40	4,2		
	G1011.2525R/L-5T32GX24-P		32	120	25	25	22,9	145	55	4,2		
	G1011.2525R/L-6T12GX24-P	6	12		25	25	22,4	125	35	5,2	GX24-4 .. GX24-4F6 ..	
	G1011.2525R/L-6T21GX24-P		21		25	25	22,4	130	40	5,2		
	G1011.2525R/L-6T32GX24-P		32		25	25	22,4	145	55	5,2		
	G1011.2525R/L-8T28GX30-P	8	28		25	25	22	145	55	6,1	GX30-5E8 .. GX30-5F8 ..	
	G1011.3225R/L-8T28GX30-P		28	32	25	22	145	55	6,1			

$$f = f_1 + s/2$$

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: G1011.1212R-2T12GX16-P/ordering example, left-hand tool: G1011.1212L-2T12GX16-P

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

Assembly parts	h = h ₁ [mm]	12	16	20	20-25	25	32
	T _{max} [mm]	12	12-21	12-21	33	12-32	28
	Clamping screw for grooving insert Tightening torque	FS2118 (Torx 20IP) 5,0 Nm	FS2118 (Torx 20IP) 5,0 Nm	FS2118 (Torx 20IP) 5,0 Nm	M06X025 ISO4762 12.9 (SW 5) 5,0 Nm	FS2118 (Torx 20IP) 5,0 Nm	FS2118 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug			FS2288 (SW 3)	FS2288 (SW 3)	FS2288 (SW 3)	FS2288 (SW 3)
	Torx key	FS1464 (Torx 20IP)	FS1464 (Torx 20IP)	FS1464 (Torx 20IP)		FS1464 (Torx 20IP)	FS1464 (Torx 20IP)
	ISO 2936 key				ISO2936-5 (SW 5)		

Shank tool – Radial grooving

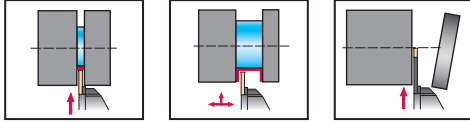
G1011...-P inch

Walter Cut

- Screw clamping
- Precision cooling



A2



Tool	Designation	s inch	T _{max} inch	D ₂ inch	h = h ₁ inch	b inch	f ₁ inch	l ₁ inch	l ₄ inch	s ₁ inch	Type
	G1011.12R/L-2T15GX16-P	0,079	0,591		0,750	0,750	0,719	5,906	1,398	0,063	GX16-1E2 .. GX16-1F2 ..
	G1011.16R/L-2T15GX16-P		0,591		1,000	1,000	0,969	5,906	1,398	0,063	
	G1011.12R/L-3T15GX16-P	0,118	0,591		0,750	0,750	0,707	5,906	1,398	0,087	GX16-2E3 ..
	G1011.12R/L-3T21GX24-P		0,827	3,150	0,750	0,750	0,701	5,906	1,575	0,094	GX24-2E .. GX24-2F3 ..
	G1011.16R/L-3T12GX24-P	0,118	0,472		1,000	1,000	0,953	5,906	1,575	0,094	
	G1011.16R/L-3T21GX24-P		0,827	3,150	1,000	1,000	0,953	5,906	1,575	0,094	
	G1011.12R/L-3T33GX34-P	0,157	1,299	5,512	0,750	0,750	0,703	5,906	2,087	0,094	GX34-2E3 ..
	G1011.16R/L-3T33GX34-P		1,299	5,512	1,000	1,000	0,953	5,906	2,087	0,094	
	G1011.12R/L-4T12GX24-P	0,157	0,472		0,750	0,750	0,685	5,906	1,378	0,134	
	G1011.12R/L-4T21GX24-P		0,827		0,750	0,750	0,685	5,906	1,575	0,134	GX24-3E4 .. GX24-3F4 ..
	G1011.16R/L-4T12GX24-P	0,157	0,472		1,000	1,000	0,933	5,709	1,378	0,134	
	G1011.16R/L-4T21GX24-P		0,827		1,000	1,000	0,933	5,906	1,575	0,134	
	G1011.16R/L-4T32GX24-P	0,157	1,260		1,000	1,000	0,933	5,906	2,165	0,134	
	G1011.12R/L-4T33GX34-P		1,299	5,512	0,750	0,750	0,685	5,906	2,087	0,130	GX34-3E4 ..
	G1011.16R/L-4T33GX34-P	0,197	1,299	5,512	1,000	1,000	0,937	5,906	2,087	0,130	
	G1011.12R/L-5T21GX24-P		0,827		0,750	0,750	0,669	5,906	1,575	0,165	GX24-3E5 .. GX24-3F5 ..
	G1011.16R/L-5T12GX24-P	0,197	0,472		1,000	1,000	0,917	5,709	1,378	0,165	
	G1011.16R/L-5T21GX24-P		0,827		1,000	1,000	0,917	5,906	1,575	0,165	
	G1011.16R/L-5T32GX24-P	0,236	1,260		1,000	1,000	0,917	5,906	2,165	0,165	
	G1011.16R/L-6T12GX24-P		0,472		1,000	1,000	0,898	5,709	1,378	0,205	GX24-4 .. GX24-4F6 ..
G1011.16R/L-6T21GX24-P	0,236	0,827		1,000	1,000	0,898	5,906	1,575	0,205		
G1011.16R/L-6T32GX24-P		1,260		1,000	1,000	0,898	5,906	2,165	0,205		

$$f = f_1 + s/2$$

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

Ordering example, right-hand tool: G1011.12R-2T15GX16-P/ordering example, left-hand tool: G1011.12L-2T15GX16-P

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

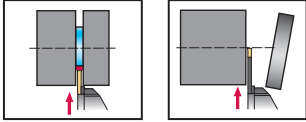
Assembly parts	h = h ₁ [inch] T _{max} [inch]	0,750 0,472–0,827	0,750–1,000 1,299	1,000 0,472–1,260
	Clamping screw for grooving insert Tightening torque	FS2118 (Torx 20IP) 5,0 Nm	M06X025 ISO4762 12.9 (SW 5) 5,0 Nm	FS2118 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug		FS2288 (SW 3)	
	Torx key	FS1464 (Torx 20IP)		FS1464 (Torx 20IP)
	ISO 2936 key		ISO2936-5 (SW 5)	

Reinforced parting blade

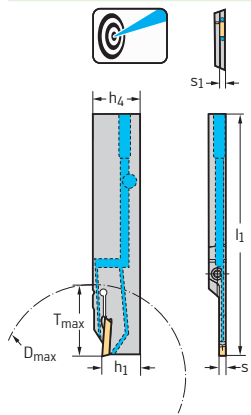
 G1041...-P

Walter Cut

- Screw clamping
- Precision cooling



Tool



Designation	s mm	T _{max} mm	D _{max} mm	h ₄ mm	l ₁ mm	h ₁ mm	s ₁ mm	Type
G1041.26R/L-2T16GX16-P	2	16	32	26	110	21	1,5	GX16-1E2 .. GX16-1F2 ..
G1041.26R/L-3T23GX24-P	3	23	46	26	110	21	2,2	GX24-2E .. GX24-2F3 ..
G1041.32R/L-3T23GX24-P		23	46	32	110	24,6	2,2	
G1041.32R/L-3T32GX24-P		32	65	32	110	24,6	2,2	
G1041.32R/L-3T33GX34-P	4	33	65	32	110	24,6	2,4	GX34-2E3 ..
G1041.32R/L-4T32GX24-P		32	65	32	110	24,6	3,1	GX24-3E4 .. GX24-3F4 ..
G1041.32R/L-4T33GX34-P		33	65	32	110	24,6	3,3	GX34-3E4 ..

Ordering example, right-hand tool: G1041.26R-2T16GX16-P/ordering example, left-hand tool: G1041.26L-2T16GX16-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h ₄ [mm]	26-32
	Clamping screw for grooving insert Tightening torque	FS2164 (Torx 15IP) 3,5 Nm

Accessories

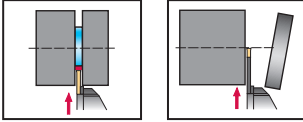
	h ₄ [mm]	26-32
	Screwdriver for grooving insert	FS1485 (Torx 15IP)

Reinforced parting blade – Contra

G1041...C-P

Walter Cut

- Screw clamping
- Precision cooling



A2

Tool	Designation	s mm	T _{max} mm	D _{max} mm	h ₄ mm	l ₁ mm	h ₁ mm	s ₁ mm	Type
	G1041.26R/L-2T16GX16C-P	2	16	32	26	110	21	1,5	GX16-1E2 .. GX16-1F2 ..
	G1041.32R/L-2T23GX24C-P		23	46	32	110	24,6	1,5	GX24-1E2 ..
	G1041.26R/L-3T23GX24C-P	3	23	46	26	110	21	2,2	GX24-2E .. GX24-2F3 ..
	G1041.32R/L-3T23GX24C-P		23	46	32	110	24,6	2,2	
	G1041.32R/L-3T33GX34C-P		33	65	32	110	24,6	2,4	GX34-2E3 ..
	G1041.32R/L-4T32GX24C-P	4	32	65	32	110	24,6	3,1	GX24-3E4 .. GX24-3F4 ..
	G1041.32R/L-4T33GX34C-P		33	65	32	110	24,6	3,3	GX34-3E4 ..

Ordering example, right-hand tool: G1041.26R-2T16GX16C-P/ordering example, left-hand tool: G1041.26L-2T16GX16C-P
Bodies and assembly parts are included in the scope of delivery.

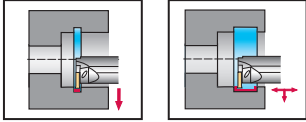
Assembly parts		h ₄ [mm]	26-32
	Clamping screw for grooving insert Tightening torque		FS2164 (Torx 15IP) 3,5 Nm
Accessories		h ₄ [mm]	26-32
	Screwdriver for grooving insert		FS1485 (Torx 15IP)

Boring bar – Internal grooving

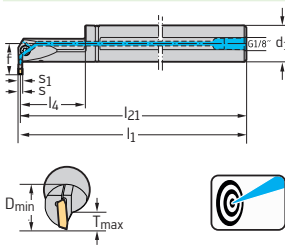
 G1221...-P mm

Walter Cut

- Screw clamping
- Precision cooling



Tool



Designation	s mm	T _{max} mm	D _{min} mm	d ₁ mm	f mm	l ₄ mm	l ₂₁ mm	s ₁ mm	Type
G1221-16QR/L-2T04-GX09-P	2-2,5	4	16	16	12,6	29,3	179,3	1,4	GX09- . E ..
G1221-20QR/L-2T06-GX09-P		6	20	20	16,6	36,3	179,3	1,4	GX16-1E2 .. GX16-1F2 ..
G1221-25RR/L-2T08-GX16-P		8	25	25	21,1	45,2	199,3	1,5	GX16-2E3 ..
G1221-20QR/L-3T06-GX09-P	2,5-3	6	20	20	16,6	35,9	179,0	2,1	GX09-2E3 ..
G1221-25RR/L-3T08-GX16-P	3	8	25	25	21,1	44,9	199,0	2,1	GX16-2E3 ..
G1221-32SR/L-3T10-GX16-P		10	32	32	26,6	57,9	249,0	2,1	GX24-2E .. GX24-2F3 ..
G1221-40TR/L-3T12-GX24-P		12	40	40	32,6	72,0	299,0	2,1	GX16-3E ..
G1221-32SR/L-4T10-GX16-P	4	10	32	32	26,6	57,4	248,5	3,1	GX24-3E ..
G1221-40TR/L-4T12-GX24-P		12	40	40	32,6	71,5	298,5	3,1	GX24-3E .. GX24-3F ..
G1221-40TR/L-5T12-GX24-P		5-6	12	40	40	32,6	71,1	298,1	3,8

$$l_1 = l_{21} + s/2$$

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

Ordering example, right-hand tool: G1221-16QR-2T04-GX09-P/ordering example, left-hand tool: G1221-16QL-2T04-GX09-P

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

Assembly parts

D _{min} [mm]	16	20	25	32	40
	FS1453 (Torx 15IP) 3,5 Nm	FS2081 (Torx 15IP) 4,0 Nm	FS1495 (Torx 20IP) 5,0 Nm	FS2089 (Torx 25IP) 5,0 Nm	FS2089 (Torx 25IP) 5,0 Nm
	M02X002 ISO 4026 (SW 0,9)	M03X003 ISO 4026 (SW 1,5)	M03X003 ISO 4026 (SW 1,5)	M03X003 ISO 4026 (SW 1,5)	M02X002 ISO 4026 (SW 0,9)
	O-RING 11X2	O-RING 15X2	O-RING 20X2	O-RING 27X2	O-RING 34X2
	FS1485 (Torx 15IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)	FS1487 (Torx 25IP)

Accessories

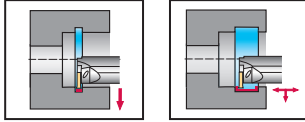
D _{min} [mm]	16-20	25	32-40
	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm
	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2016 (Torx 25IP)

Boring bar – Internal grooving

G1221...-P inch

Walter Cut

- Screw clamping
- Precision cooling



A2

Tool	Designation	s inch	T _{max} inch	D _{min} inch	d ₁ inch	f inch	l ₄ inch	l ₂₁ inch	s ₁ inch	Type
	G1221.10QR/L-2T04-GX09-P	0,079– 0,098	0,157	0,625	0,625	0,492	1,154	7,059	0,055	GX09- . E ..
	G1221.12QR/L-2T06-GX09-P		0,236	0,750	0,750	0,634	1,429	7,059	0,055	GX16-1E2 .. GX16-1F2 ..
	G1221.16RR/L-2T08-GX16-P	0,118	0,315	1,000	1,000	0,839	1,780	7,844	0,059	GX16-2E3 ..
	G1221.12QR/L-3T06-GX09-P		0,236	0,750	0,750	0,634	1,413	7,045	0,083	GX09-2E3 ..
	G1221.16RR/L-3T08-GX16-P	0,157	0,315	1,000	1,000	0,839	1,768	7,833	0,083	GX16-2E3 ..
	G1221.20SR/L-3T10-GX16-P		0,394	1,250	1,250	1,043	2,280	9,801	0,083	GX16-3E ..
	G1221.20SR/L-4T10-GX16-P	0,197– 0,236	0,394	1,250	1,250	1,043	2,260	9,781	0,122	GX24-3E ..
	G1221.24TR/L-4T12-GX24-P		0,472	1,500	1,500	1,244	2,813	11,750	0,122	GX24-3F ..
	G1221.24TR/L-5T12-GX24-P	0,472	1,500	1,500	1,244	2,799	11,736	0,150	GX24-3F ..	

$$l_1 = l_{21} + s/2$$

For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

Ordering example, right-hand tool: G1221.10QR-2T04-GX09-P/ordering example, left-hand tool: G1221.10QL-2T04-GX09-P

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

Assembly parts	D _{min} [inch]	0,625	0,750	1,000	1,250	1,500
	Clamping screw for grooving insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS2081 (Torx 15IP) 4,0 Nm	FS1495 (Torx 20IP) 5,0 Nm	FS2089 (Torx 25IP) 5,0 Nm	FS2089 (Torx 25IP) 5,0 Nm
	Threaded plug	M02X002 ISO 4026 (SW 0,9)	M03X003 ISO 4026 (SW 1,5)	M03X003 ISO 4026 (SW 1,5)	M03X003 ISO 4026 (SW 1,5)	M02X002 ISO 4026 (SW 0,9)
	O-ring	O-RING 11X2	O-RING 15X2	O-RING 20X2	O-RING 27X2	O-RING 34X2
	Screwdriver	FS1485 (Torx 15IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)	FS1487 (Torx 25IP)

Accessories	D _{min} [inch]	0,625-0,750	1,000	1,250-1,500
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2016 (Torx 25IP)

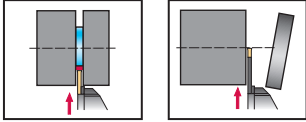
Shank tool – Radial grooving

G2012

Walter Cut



– Self-clamping system



Tool

	Designation	s mm	T _{max} mm	D ₂ mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	s ₁ mm	Type
	G2012.1212R/L-1.5T15SX	1,5	15	38	12	12	11,4	120	25	1,2	SX-1E1 ..
	G2012.1616R/L-1.5T15SX		15	38	16	16	15,4	120	25	1,2	
	G2012.2020R/L-1.5T15SX		15	38	20	20	19,4	120	25	1,2	
	G2012.2525R/L-2T26SX	2	26	52	25	25	24,2	146	36	1,6	SX-2E2 ..
	G2012.2525R/L-3T33SX	3	33	65	25	25	23,8	150	43	2,5	SX-3E3 ..

$f = f_1 + s/2$
 Ordering example, right-hand tool: G2012.1212R-1.5T15SX/ordering example, left-hand tool: G2012.1212L-1.5T15SX

Accessories

	h = h ₁ [mm]	12-20	25
	Mounting wrench for grooving insert	FS2249	FS1494

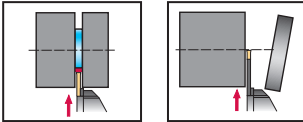
Shank tool – Radial grooving

G2012 inch

Walter Cut



– Self-clamping system



Tool		s	T _{max}	D ₂	h = h ₁	b	f ₁	l ₁	l ₄	s ₁	Type
Designation		inch	inch	inch	inch	inch	inch	inch	inch	inch	
	G2012.12R/L-1.5T15SX	0,059	0,591	1,496	0,750	0,750	0,726	4,724	0,984	0,047	SX-1E1 ..
	G2012.16R/L-2T26SX	0,079	1,024	2,047	1,000	1,000	0,969	5,748	1,417	0,061	SX-2E2 ..
	G2012.16R/L-3T33SX	0,118	1,299	2,559	1,000	1,000	0,952	5,906	1,693	0,096	SX-3E3 ..

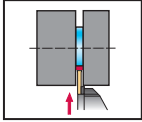
f = f₁ + s/2
 Ordering example, right-hand tool: G2012.12R-1.5T15SX/ordering example, left-hand tool: G2012.12L-1.5T15SX

Accessories			
	h = h ₁ [inch]	0,750	1,000
	Mounting wrench for grooving insert	FS2249	FS1494

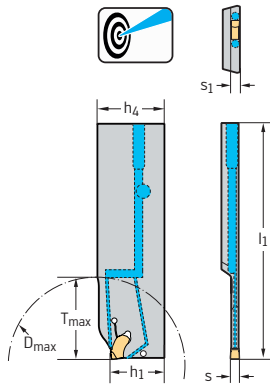
Reinforced parting blade G2042...R/L...-P

Walter Cut

- Self-clamping system
- Precision cooling



Tool



Designation	s mm	T _{max} mm	D _{max} mm	h ₄ mm	l ₁ mm	h ₁ mm	s ₁ mm	Type
G2042.32R/L-2T26SX-P	2	26	52	32	110	24,7	1,6	SX-2E2 ..
G2042.26R/L-3T33SX-P	3	33	65	26	110	21	2,4	SX-3E3 ..
G2042.32R/L-3T33SX-P		33	65	32	110	24,7	2,4	
G2042.32R/L-4T33SX-P	4	33	65	32	110	24,7	3,4	SX-4E4 ..

Ordering example, right-hand tool: G2042.32R-2T26SX-P/ordering example, left-hand tool: G2042.32L-2T26SX-P

Accessories

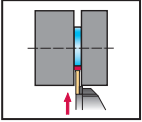
	h ₄ [mm]	
	Mounting wrench for grooving insert	FS1494

Shank tool – Radial grooving

G2016...-P

Walter Cut

- Screw clamping
- Precision cooling



A2



Tool		s	T _{max}	h = h ₁	b	f	l ₁	l ₄	Type
Designation		mm	mm	mm	mm	mm	mm	mm	
	★ G2016-2525N-12T40UX-P	12	41	25	25	19	150	53	UX-12E12 ..
	★ G2016-3232N-19T40UX-P	19	41	32	32	22,5	150	53	UX-19E19 ..

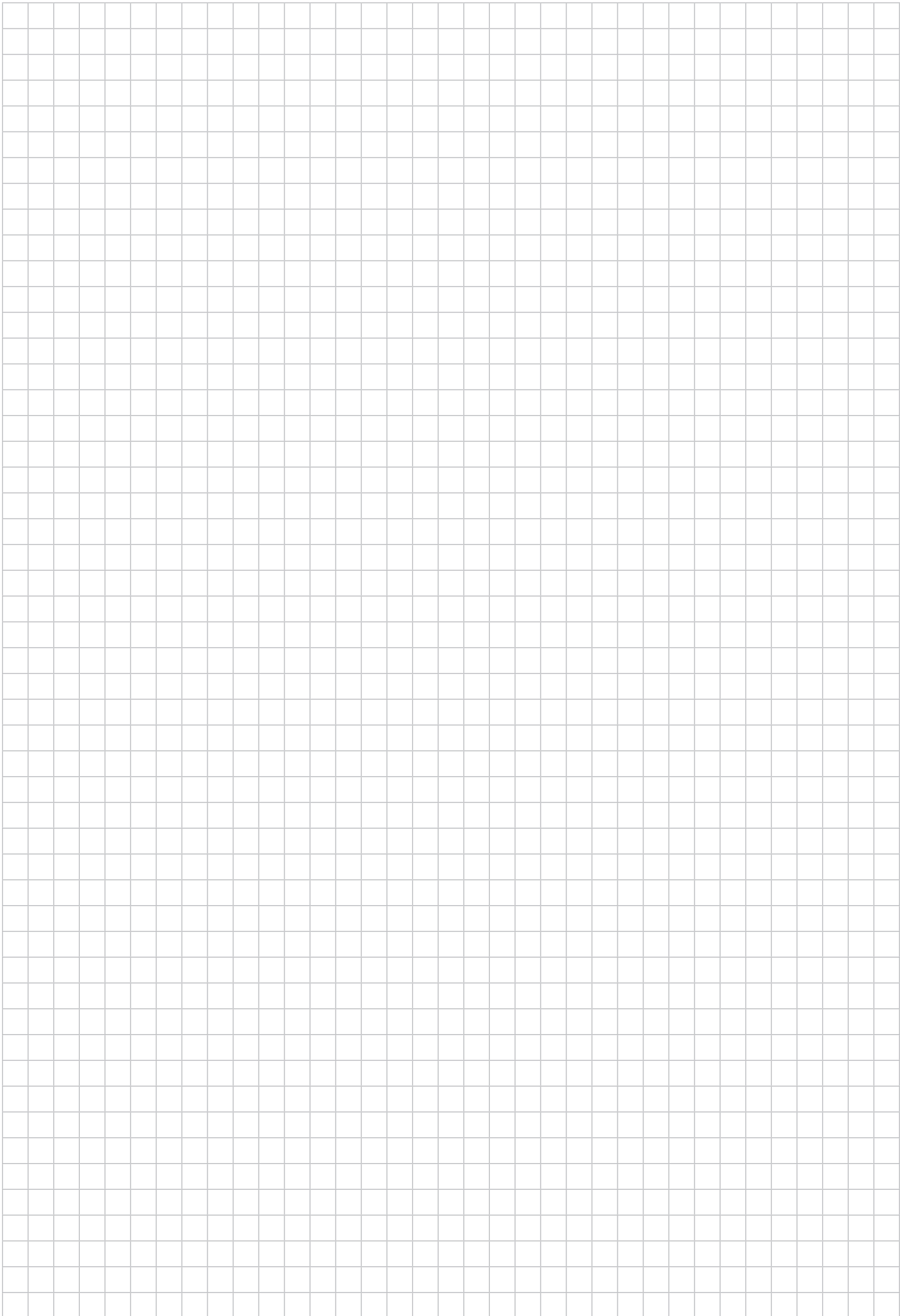
For the connection set for coolant supply with G1/8" thread, see "Assembly parts and accessories"

The maximum recommended coolant pressure is 150 bar (2175 psi)

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

Assembly parts	h = h ₁ [mm]	25	32
		Clamping screw for grooving insert Tightening torque	FS2081 (Torx 15IP) 4,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
	Torx key	FS1465 (Torx 15IP /SW 3,5)	FS1464 (Torx 20IP)

A2

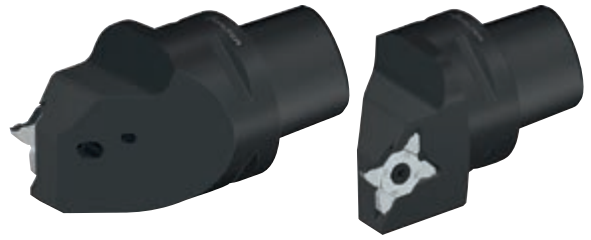


Groove turning holders – Radial grooving

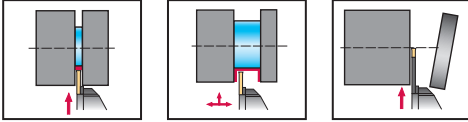
C...-G3011...-P

Walter Cut

- Walter Capto™
- Screw clamping



A2



Tool		s mm	T _{max} mm	d ₁	f ₁ mm	l ₄ mm	Type
	Walter Capto™ in acc. with ISO 26623						
	Designation						
	G3011-C3R/L-MX22-2-P	0,8–3,25	6	C3	20	45	MX22-2E ..
	G3011-C4R/L-MX22-2-P		6	C4	20	60	
	G3011-C5R/L-MX22-2-P		6	C5	25	60	
	G3011-C6R/L-MX22-2-P	6	6	C6	32	65	
	G3011-C4R/L-MX22-4-P	4–5,65	6	C4	20	60	MX22-4E ..
	G3011-C5R/L-MX22-4-P		6	C5	25	60	
G3011-C6R/L-MX22-4-P	6		C6	32	65		

$$f = f_1 + s/2$$

For information on the maximum cutting depth T_{max}, see "Cutting inserts"

The maximum recommended coolant pressure is 150 bar (2175 psi)

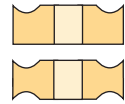
Ordering example, right-hand tool: G3011-C3R-MX22-2-P/ordering example, left-hand tool: G3011-C3L-MX22-2-P

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

Assembly parts		s [mm]	0,8–3,25/4–5,65
	Clamping screw for grooving insert Tightening torque		FS2571 (Torx 20IP) 5,0 Nm
	Torx key		FS2572 (Torx 10IP)

Cutting data for turning inserts – Negative basic shape

Carbide grades



Material group	Overview of the 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			
								WSM01			
								f [mm/rev]			
								0,10	0,20	0,50	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	●	240	230	
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	●●	●	190	160	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	●●	●	160	130	
		C > 0.55%	Annealed	190	640	P4	●●	●	150	130	
		C > 0.55%	Heat-treated	300	1010	P5	●●	●	140	100	
	Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	210	190		
	Low-alloy steel	Annealed	175	590	P7	●●	●	150	130		
		Heat-treated	285	960	P8	●●	●	130	80		
		Heat-treated	380	1280	P9	●●	●	100	70		
		Heat-treated	430	1480	P10	●●	●	80	60		
High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	●●	●	140	120			
	Hardened and tempered	300	1010	P12	●●	●	120	90			
	Hardened and tempered	380	1280	P13	●●	●	70	50			
Stainless steel	Ferritic/martensitic, annealed	200	680	P14	●●	●	200	180			
	Martensitic, heat-treated	330	1110	P15	●●	●	150	120			
M	Stainless steel	Austenitic, quench hardened	200	680	M1	●●	●	250	190	120	
		Austenitic, precipitation hardened (PH)	300	1010	M2	●●	●	150	130		
		Austenitic/ferritic, duplex	230	780	M3	●●	●	160	140	100	
K	Malleable cast iron	Ferritic	200	400	K1	●●	●				
		Pearlitic	260	700	K2	●●	●				
	Grey cast iron	Low tensile strength	180	200	K3	●●	●				
		High tensile strength/austenitic	245	350	K4	●●	●				
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	●●	●				
		Pearlitic	265	700	K6	●●	●				
GGV (CGI)		230	400	K7	●●	●					
N	Wrought aluminium alloys	Not hardenable	30	–	N1			3000	2400	1800	
		Hardenable, hardened	100	340	N2			900	720	360	
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3			960	540	360	
		≤ 12% Si, hardenable, hardened	90	310	N4			600	360	240	
		> 12% Si, not hardenable	130	450	N5						
	Magnesium-based alloys ³		70	250	N6						
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7			720	480	320	
		Brass, bronze, red brass	90	310	N8			480	360	300	
Cu alloys, short-chipping		110	380	N9			340	240	160		
High tensile, Ampco		300	1010	N10							
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	●●	●	100	70	
			Hardened	280	940	S2	●●	●	80	60	
		Ni- or Co-based	Annealed	250	840	S3	●●	●	80	60	
			Hardened	350	1180	S4	●●	●	70	50	
	Cast		320	1080	S5	●●	●	60	40		
			320	1080	S5	●●	●	60	40		
	Titanium alloys	Pure titanium	200	680	S6	●●	●				
α and β alloys, hardened		375	1260	S7	●●	●	70	50			
β alloys		410	1400	S8	●●	●	50	40			
Tungsten alloys		300	1010	S9							
Molybdenum alloys		300	1010	S10							
H	Hardened steel	Hardened and tempered	50 HRC		H1	●	●●	50			
		Hardened and tempered	55 HRC		H2	●	●●	40			
		Hardened and tempered	60 HRC		H3	●	●●				
	Hardened cast iron	Hardened and tempered	55 HRC		H4	●	●●				
O	Thermoplastics	Without abrasive fillers			O1						
	Thermosets	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 is regarded as starting values for the recommended application)
- Possible application

Note: If dry machining is possible, the tool life is reduced by 20–30% on average.

¹ The classification of the machining groups can be found from page A 468 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

Cutting data for turning inserts – Positive basic shape

Carbide grades



Material group	Overview of the 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]				
								HE				
								WEP10C				
								f [mm/rev]				
								0,10	0,20	0,30		
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	●	300	250	200	
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	●●	●	230	200	180	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	●●	●	210	180	150	
		C > 0.55%	Annealed	190	640	P4	●●	●	220	200	180	
		C > 0.55%	Heat-treated	300	1010	P5	●●	●	180	150		
	Low-alloy steel	Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	230	200	180	
		Annealed		175	590	P7	●●	●	210	180	150	
		Heat-treated		285	960	P8	●●	●	150	130	110	
		Heat-treated		380	1280	P9	●●	●				
	High-alloyed steel and high-alloyed tool steel	Heat-treated		430	1480	P10	●●	●				
Annealed			200	680	P11	●●	●	160	140	130		
Hardened and tempered			300	1010	P12	●●	●					
Stainless steel	Hardened and tempered		380	1280	P13	●●	●					
	Ferritic/martensitic, annealed		200	680	P14	●●	●					
M	Stainless steel	Martensitic, heat-treated		330	1110	P15	●●	●				
		Austenitic, quench hardened		200	680	M1	●●	●	210	190	160	
		Austenitic, precipitation hardened (PH)		300	1010	M2	●●	●	150	130	110	
		Austenitic/ferritic, duplex		230	780	M3	●●	●	160	140	110	
K	Malleable cast iron	Ferritic		200	400	K1	●●	●	220	200	180	
		Pearlitic		260	700	K2	●●	●	190	170	150	
	Grey cast iron	Low tensile strength		180	200	K3	●●	●	420	390	360	
		High tensile strength/austenitic		245	350	K4	●●	●	220	200	180	
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●	●	240	220	200	
		Pearlitic		265	700	K6	●●	●	170	140	130	
GGV (CGI)		230	400	K7	●●	●	220	180	170			
N	Wrought aluminium alloys	Not hardenable		30	–	N1	●●	●				
		Hardenable, hardened		100	340	N2	●●	●				
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3	●●	●				
		≤ 12% Si, hardenable, hardened		90	310	N4	●●	●				
		> 12% Si, not hardenable		130	450	N5						
	Copper and copper alloys (bronze/brass)	Magnesium-based alloys ³		70	250	N6						
		Unalloyed, electrolytic copper		100	340	N7	●●	●				
Brass, bronze, red brass			90	310	N8	●●	●					
Cu alloys, short-chipping			110	380	N9	●●	●					
S	Heat-resistant alloys	High tensile, Ampco		300	1010	N10						
		Fe-based	Annealed		200	680	S1	●●	●			
			Hardened		280	940	S2	●●	●			
		Ni- or Co-based	Annealed		250	840	S3	●●	●			
			Hardened		350	1180	S4	●●	●			
	Cast			320	1080	S5	●●	●				
	Titanium alloys	Pure titanium		200	680	S6	●●	●				
		α and β alloys, hardened		375	1260	S7	●●	●				
		β alloys		410	1400	S8	●●	●				
	Tungsten alloys		300	1010	S9							
Molybdenum alloys		300	1010	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						
	Thermosets	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 is regarded as starting values for the recommended application)
- Possible application

Note: If dry machining is possible, the tool life is reduced by 20–30% on average.

¹ The classification of the machining groups can be found from page A 468 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

Cutting material grades												
Starting values for cutting speed v_c [m/min]												
HC												
WSM01			WNN10			WPV10			WPV20			
f [mm/rev]			f [mm/rev]			f [mm/rev]			f [mm/rev]			
0,10	0,20	0,40	0,10	0,20	0,40	0,10	0,20	0,40	0,10	0,20	0,40	
240	230		230	210		400	350	300	330	300	250	
190	160		170	150		320	280	230	270	240	190	
160	130		130	120		240	210	200	190	170	160	
150	130		140	120		280	260	250	240	220	200	
140	100					190	160	160	160	130	120	
210	190		180	160		360	340	330	310	280	270	
150	130		120	100		290	270	260	250	230	210	
130	80					160	140	130	130	120	100	
100	70					100	80	80	80	70	50	
80	60					70	50		50	40		
140	120		130	100		280	250	240	230	200	190	
120	90					170	160	140	140	120	100	
70	50					60	50		50	40		
200	180					240	220	210	170	160	140	
150	120					100	80	80	80	80	60	
250	190	120	200	180		220	200	130	180	160	100	
150	130		140	120		160	140		130	110		
160	140	100	150	130		170	150	110	140	120	90	
			250	220		230	200	190	200	180	160	
			210	180		200	170	160	170	150	130	
			480	450		430	400	360	390	360	350	
			210	180		230	200	190	170	150	130	
			230	200		240	220	200	190	160	150	
			60	130		170	150	130	130	110	90	
						230	190	170				
3000	2400	1800	3000	2400	1800							
900	720	360	900	720	360							
960	540	360	960	540	360							
600	360	240	600	360	240							
720	480	320	720	480	320							
480	360	300	480	360	300							
340	240	160	340	240	160							
100	70		80	60								
80	60		60	50								
80	60		60	50								
70	50		50	40								
60	40		40	30								
			220	200	160							
70	50		70	50								
50	40		40	30								
50												
40												
			400	400								
			300	300								
			600	600								

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

HC = Coated carbide
HE = Coated cermet

Cutting data for turning inserts – Negative and positive basic shape CBN/PCD/ceramic

Material group	Overview of the 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]					
						CBN					
						BL WBH10C					
						f [mm/rev]					
						0.05	0.15	0.20			
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1					
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2					
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3					
		C > 0.55%	Annealed	190	640	P4					
		C > 0.55%	Heat-treated	300	1010	P5					
		Free-machining steel (short-chipping)	Annealed	220	750	P6					
	Low-alloy steel	Annealed		175	590	P7					
		Heat-treated		285	960	P8					
		Heat-treated		380	1280	P9					
		Heat-treated		430	1480	P10					
	High-alloyed steel and high-alloyed tool steel	Annealed		200	680	P11					
		Hardened and tempered		300	1010	P12					
		Hardened and tempered		380	1280	P13					
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14					
		Martensitic, heat-treated		330	1110	P15					
M	Stainless steel	Austenitic, quench hardened		200	680	M1					
		Austenitic, precipitation hardened (PH)		300	1010	M2					
		Austenitic/ferritic, duplex		230	780	M3					
K	Malleable cast iron	Ferritic		200	400	K1	●●●	●			
		Pearlitic		260	700	K2	●●●	●			
	Grey cast iron	Low tensile strength		180	200	K3	●●●	●			
		High tensile strength/austenitic		245	350	K4	●●●	●			
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●●	●			
		Pearlitic		265	700	K6	●●●	●			
	GGV (CGI)			230	400	K7					
N	Wrought aluminium alloys	Not hardenable		30	–	N1					
		Hardenable, hardened		100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3					
		≤ 12% Si, hardenable, hardened		90	310	N4					
		> 12% Si, not hardenable		130	450	N5					
	Magnesium-based alloys		70	250	N6						
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	340	N7					
		Brass, bronze, red brass		90	310	N8					
		Cu alloys, short-chipping		110	380	N9					
		High tensile, Ampco		300	1010	N10					
S	Heat-resistant alloys	Fe-based	Annealed		200	680	S1				
			Hardened		280	940	S2				
		Ni- or Co-based	Annealed		250	840	S3	●●●	●		
			Hardened		350	1180	S4	●●●	●		
		Cast		320	1080	S5	●●●	●			
	Titanium alloys	Pure titanium		200	680	S6					
		α and β alloys, hardened		375	1260	S7					
		β alloys		410	1400	S8					
Tungsten alloys		300	1010	S9							
Molybdenum alloys		300	1010	S10							
H	Hardened steel	Hardened and tempered		50 HRC	–	H1	●	●●	300	250	220
		Hardened and tempered		55 HRC	–	H2	●	●●	280	230	200
		Hardened and tempered		60 HRC	–	H3	●	●●	250	200	180
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4	●	●●	250	200	180
O	Thermoplastics	Without abrasive fillers				O1					
	Thermosets	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 is regarded as starting values for the recommended application)
- Possible application

¹ The classification of the machining groups can be found from page A 468 onwards in the Walter General Catalogue 2017.

Cutting tool material application chart

Carbide

Walter grade designation	Standard designation	Material groups							Application range							Coating process	Coating composition	Indexable insert example
		P	M	K	N	S	H	O	01	05	10	15	20	25	30			
WPV10	HC - P 10	●●							[Application range diagram]							CVD	TiCN + Al ₂ O ₃ + TiN	
	HC - M 20		●					[Application range diagram]										
	HC - K 20				●			[Application range diagram]										
WPV20	HC - P 20	●●						[Application range diagram]							CVD	TiCN + Al ₂ O ₃ + TiN		
	HC - M 30		●				[Application range diagram]											
	HC - K 30				●			[Application range diagram]										
WKV10	HC - K 10			●●				[Application range diagram]							CVD	TiCN + Al ₂ O ₃ + TiN		
	HC - P 10	●					[Application range diagram]											
	HC - H 30						●	[Application range diagram]										
WKV20	HC - K 20			●●				[Application range diagram]							CVD	TiCN + Al ₂ O ₃ + TiN		
	HC - P 20	●					[Application range diagram]											
WSM01	HC - M 01		●●					[Application range diagram]							PVD	TiAlN (HIPIMS)		
	HC - S 01					●●	[Application range diagram]											
	HC - P 10	●					[Application range diagram]											
	HC - N 10				●		[Application range diagram]											
	HC - H 20						●	[Application range diagram]										
WSM21	HC - M 20		●●					[Application range diagram]							PVD	TiAlN		
	HC - S 20					●●	[Application range diagram]											
	HC - P 20	●●					[Application range diagram]											
WNN10	HC - N 10				●●			[Application range diagram]							PVD	TiAlN (HIPIMS)		
	HC - P 01	●					[Application range diagram]											
	HC - M 01		●				[Application range diagram]											
	HC - K 01			●			[Application range diagram]											
	HC - S 01					●	[Application range diagram]											
	HC - O 01						●	[Application range diagram]										

HC = Coated carbide ●● Primary application
 HW = Uncoated carbide ● Additional application

CBN/cermet/PCD/ceramic


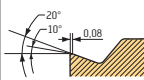
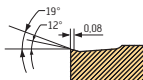

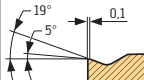
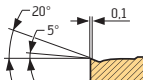
Walter grade designation	Standard designation	Material groups							Application range							Coating process	Cutting tool material	Indexable insert example
		P	M	K	N	S	H	O	01	05	10	15	20	25	30			
WBH10C	BL – H 05						••		[Application range diagram: 01-10]							PVD	CBN + TiAlSiN	
WBH10	BL – H 10						••		[Application range diagram: 01-15]							-	CBN	
WBH20	BL – H 20						••		[Application range diagram: 10-20]							-	CBN	
WBS10	BH – S 10					••			[Application range diagram: 05-15]							-	CBN	
WBK20	BH – K 20			••			•		[Application range diagram: 15-25]							-	CBN	
WBK30	BH – K 30			••			•		[Application range diagram: 20-30]							-	CBN	
WEP10C	HE – P 10	••							[Application range diagram: 01-10]							PVD	TiCN + TiAlN	
	HE – M 10		•						[Application range diagram: 05-10]									
	HE – K 10			•					[Application range diagram: 10-15]									
WDN10	DP – N 20				••				[Application range diagram: 10-20]							-	PCD	
	DP – O 20						••		[Application range diagram: 10-15]									
WCK10	CN – K 10			••					[Application range diagram: 10-20]							-	Si ₃ N ₄ ceramic	
WIS10	CN – S 10					••			[Application range diagram: 05-15]							-	SiAlON ceramic	
WWS20	CR – S 20					••			[Application range diagram: 10-20]							-	Whisker ceramic	
	CR – H 20						•		[Application range diagram: 10-15]									

BH = CBN with high CBN content
 BL = CBN with low CBN content
 CN = Silicon nitride Si₃N₄
 CR = Reinforced ceramic
 DP = Polycrystalline diamond


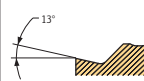
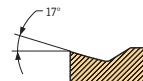

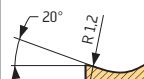
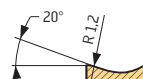

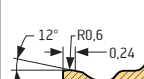
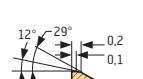

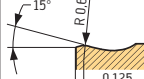
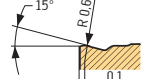

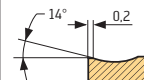
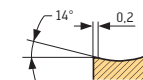
•• Primary application
 • Additional application

Geometry overview of turning inserts – Negative basic shape

Finishing operation

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
 FM5 – Finishing stainless materials and high-temperature alloys – Finishing long-chipping steel materials – Curved cutting edge for cutting pressure reduction	● Steel ●● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,1–4,5	0,03–0,50							
 FV5 – Finishing steel materials – Can also be used in semi-finishing	●● Steel ● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,2–2,0	0,05–0,25							


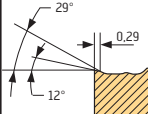
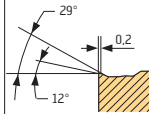

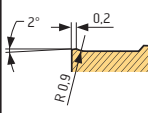
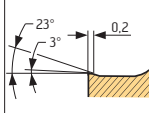

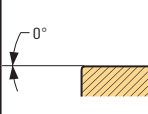
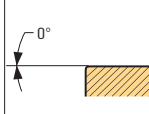

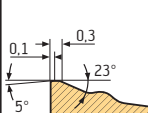
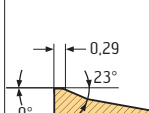
Medium machining

 MS3 – For unstable or thin-walled components – Low cutting forces thanks to sharp cutting edge design – Circumference precision-ground – Circumference precision-sintered	● Steel ● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,2–3,0	0,02–0,30
 MM5 – Universal geometry for stainless materials and high-temperature alloys – Machining long-chipping steels	● Steel ●● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,5–4,5	0,10–0,45
 MU5 – Universal geometry for steel and stainless materials – Low cutting forces and heat development when machining	●● Steel ●● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,5–6,0	0,15–0,60
 MV5 – Universal geometry for steel materials – Wide range of applications	●● Steel ● Stainless steel ● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,5–5,0	0,10–0,45
 MV7 – Universal geometry for cast iron workpieces – Machining steel materials with higher strength	● Steel ● Stainless steel ●● Cast iron ● NF metals ● Materials with difficult cutting properties ● Hard materials ● Other			0,8–8,0	0,20–0,60

- Primary application
 ● Additional application

Note: Sectional views show CNMG120408 . .
 or CNMA 120408 . .

Roughing operation


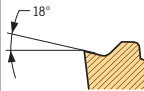
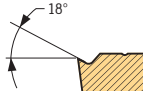

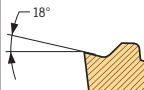
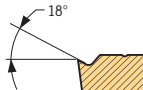

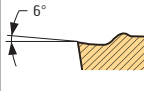
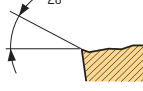

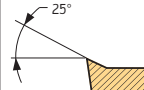
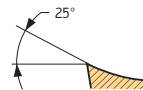

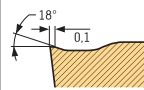
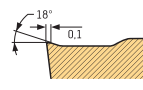
		Material groups							Main cutting edge section	Corner radius section	a _p [mm]	f [mm]
		P	M	K	N	S	H	O				
Geometry	Remarks/field of applications	Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
	RM5 – Roughing operations in stainless materials and high-temperature alloys		••			••					1,2–8,0	0,20–0,80
	RV5 – Roughing steel materials – Roughing ductile cast iron	••		•							1,0–6,0	0,15–0,60
	RV7 – Universal geometry for cast iron workpieces			••				•			0,8–5,0	0,20–0,70
Roughing operations – Single-sided indexable inserts												
	HU5 – Universal, single sided roughing insert – Open chip breaker groove design for reduced heat development – Low cutting forces due to curved cutting edge	•	••	•		••					2,5–10,0	0,30–1,00

- Primary application
- Additional application

Note: Sectional views show SNMM190616 . .

Geometry overview of turning inserts – Positive basic shape

Finishing operation


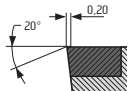
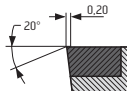


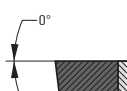

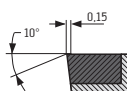
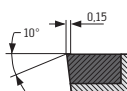

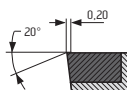
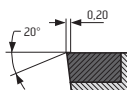

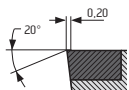
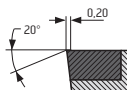

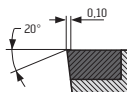
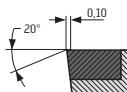



Geometry	Remarks/field of applications	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
	FN2 – Finishing insert with circumference fully ground – Low cutting forces – Machining long, small diameter shafts with a tendency to vibrate	••	••	•	••	••					0,12–4,5	0,02–0,45
	FM2 – Finishing insert with circumference fully ground – Low cutting forces – Machining long, small diameter shafts with a tendency to vibrate	••	••	•	••	••					0,12–4,5	0,02–0,45
	FV4 – Universal finishing indexable insert – Excellent chip control – Can also be used for precision boring	••		•		•					0,1–2,5	0,04–0,20
Medium machining												
	MN2 – Universal indexable insert for non-ferrous metallic materials – Sharp cutting edge with circumference fully ground – Polished rake face – Precision finishing on steel and stainless materials	•	•		••	•					0,5–6,0	0,02–0,80
	MV4 – Machining long-chipping materials – Can be used universally in a wide range of applications	••	•	•		•					0,4–3,5	0,10–0,35

- Primary application
- Additional application

Note: Sectional views show CCMT09T308 ...
or CCGT09T308 ...

Geometry overview of turning inserts – Negative basic shape CBN/PCD/ceramic

Ceramic

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	Corner radius section	a _p [mm]	f [mm]
		P	M	K	N	S	H	O				
 <p>Wiper</p>	<p>CNG..TM-MW2</p> <ul style="list-style-type: none"> - CBN indexable insert with circumference fully ground to G tolerance - CBN indexable insert with chamfered cutting edge - Effective wiper geometry for the best surfaces 										0,1–0,5	0,05–0,30
	<p>CNG..EM2</p> <ul style="list-style-type: none"> - CBN indexable insert with circumference fully ground to G tolerance - Rounded cutting edge for minimum cutting forces - Machining high-temperature alloys 									0,1–2,0	0,05–0,20	
	<p>CNG..TS2</p> <ul style="list-style-type: none"> - CBN indexable insert with circumference fully ground to G tolerance - Universal CBN indexable insert with chamfered cutting edge - Finishing operations in hardened steel, cast iron and sintered steel 									0,1–0,5	0,05–0,25	
	<p>CNG..TM-S</p> <ul style="list-style-type: none"> - Solid CBN indexable insert with circumference fully ground to G tolerance - Universal CBN indexable insert with chamfered cutting edge - Roughing operations in hardened steel, cast iron and sintered steel 									Up to 8 mm in cast material	0,05–0,4	
	<p>CNG..TM2</p> <ul style="list-style-type: none"> - CBN indexable insert with circumference fully ground to G tolerance - Universal CBN indexable insert with chamfered cutting edge - Machining operations in hardened steel, cast iron and sintered steel 									0,1–0,5	0,05–0,25	
 <p>Chip breaker</p>	<p>CNG..TM-M2</p> <ul style="list-style-type: none"> - CBN indexable insert with circumference fully ground to G tolerance - CBN indexable insert with chamfered cutting edge - Effective chip formation for hard machining 									0,1–0,5	0,05–0,25	
	<p>... E</p> <ul style="list-style-type: none"> - Ceramic indexable insert with circumference fully ground - Rounded cutting edge for minimum cutting forces - Machining high-temperature alloys 									0,1–7,5	0,1–0,5	

●● Primary application
● Additional application

Note: Sectional views show RNGN120700 . .
CNGA120408 . .

Geometry overview of turning inserts – Negative basic shape

CBN/PCD/ceramic (continued)

Ceramic		Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
Geometry	Remarks/field of applications	P	M	K	N	S	H	O				
	<p>... T01020</p> <ul style="list-style-type: none"> – Ceramic indexable insert with circumference fully ground – Chamfered cutting edge for maximum stability for medium machining to roughing operations – Machining high-temperature alloys 					••	•				0,1–5,0	0,1–0,45
	<p>... T02020</p> <ul style="list-style-type: none"> – Ceramic indexable insert with circumference fully ground – Chamfered cutting edge for maximum stability for medium machining to roughing operations – Machining cast iron 			••							0,1–6,0	0,1–0,4

•• Primary application
 • Additional application

Note: Sectional views show RNGN120700 ... CNGA120408 ...

Geometry overview of turning inserts – Positive basic shape

CBN/PCD/ceramic

Ceramic		Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
Geometry	Remarks/field of applications	P	M	K	N	S	H	O				
	<p>. CGT ... FS-1</p> <ul style="list-style-type: none"> – PCD finishing insert with circumference fullyground in G tolerance – Extremely low cutting forces due to 7°–10° rake angle – Extremely high surface quality 				••	•		••	–		0,05–1,5	0,03–0,38
 Chip breaker	<p>. CGT ... FS-M1</p> <ul style="list-style-type: none"> – PCD indexable insert with circumference fully ground in G tolerance – Excellent chip control thanks to laser-generated chip-breaker geometry – Finishing to medium machining 				••	•		••			0,1–3,0	0,08–0,2
	<p>. CGW ... FS-1</p> <ul style="list-style-type: none"> – PCD indexable insert with circumference fully ground in G tolerance – Universal PCD indexable insert with 0° rake angle – Maximum repeat accuracy 				••	•		••			0,05–3,5	0,03–0,38

•• Primary application
 • Additional application

Note: Sectional views show CCGT09T304 ... CCGW09T304 ... or RCGX090700 ...

Geometry overview of turning inserts – Positive basic shape

CBN/PCD/ceramic (continued)

Ceramic

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	Corner radius section	a _p [mm]	f [mm]
		P	M	K	N	S	H	O				
	. CGW . . FSL/R-9 – PCD indexable insert with circumference fully ground in G tolerance – Cutting edge with guide pad – Maximum depth of cut and shoulder machining				••	•		••			0,05–9,0	0,03–0,38
	. CGW . . TM-MW2 – CBN indexable insert with circumference fully ground to G tolerance – Universal CBN indexable insert with chamfered cutting edge – Effective wiper geometry for the best surfaces						••			0,1–0,5	0,05–0,30	
	. CGW . . EM2 – CBN indexable insert with circumference fully ground – Rounded cutting edge for minimum cutting forces – Machining high-temperature alloys					••				0,1–2,0	0,05–0,20	
	. CGW . . TS2 – CBN indexable insert with circumference fully ground to G tolerance – Universal CBN indexable insert with chamfered cutting edge – Finishing operations in hardened steel						••			0,1–0,5	0,05–0,25	
	. CGW . . TM2 – CBN indexable insert with circumference fully ground to G tolerance – Universal CBN indexable insert with chamfered cutting edge – Machining of hardened steel						••			0,1–0,5	0,05–0,25	
	. . . E – Ceramic indexable insert with circumference fully ground – Rounded cutting edge for minimum cutting forces – Machining high-temperature alloys					••				0,1–3,6	0,1–0,32	
	. . . T01020 – Ceramic indexable insert with circumference fully ground – Chamfered cutting edge for maximum stability for medium machining to roughing operations – Machining high-temperature alloys					••				0,1–3,6	0,1–0,32	

- Primary application
- Additional application

Note: Sectional views show CCGT09T304 . . . CCGW09T304 . . . or RCGX090700 . . .

Application information: Accure-tec A3000 – vibration-damped boring bars for turning

1. Assembly recommendations

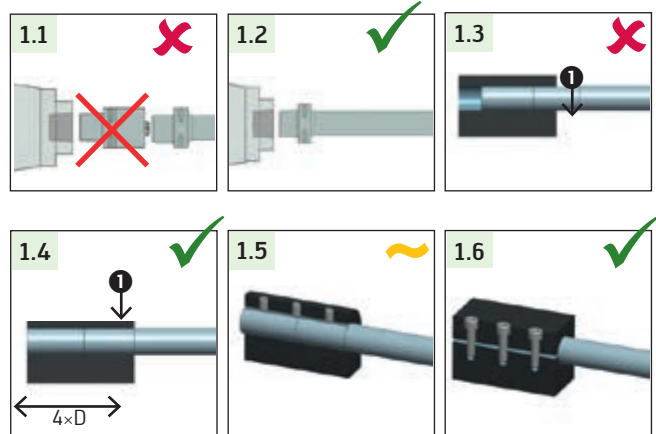
The Accure-tec vibration-damped boring bars are instantly ready for use. The built-in damping system is preset to provide the best results. The boring bars must be clamped directly onto the machine without any extensions or adaptor sleeves (see 1.1 and 1.2).

Additional recommendations are applicable when using parallel shank boring bars:

– Optimal clamping is achieved when clamping the boring bar directly onto the machine tool interface or using a split adaptor (see 1.6) with 4×D clamping length. Example: Clamp the boring bar diameter of 40 mm with a clamping length of 160 mm.

– Marking ❶ (see 1.3 and 1.4) indicates the divide between the clamping area and useable length. This marking has to be aligned such that the face is flush with the machine tool interface.

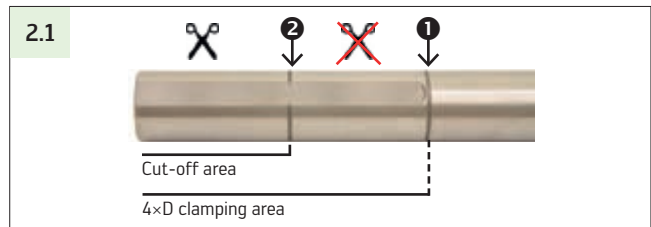
– As an alternative (though this is not ideal), the 6×D and 8×D parallel shank bars feature a clamping surface in the clamping length range for clamping with screws (see 1.5). 10×D boring bars do not feature this clamping surface and can reach maximum stability only if clamped using a split adaptor (see 1.6).



2. Shortening parallel shank boring bars

An optimal clamping system is achieved using the Accure-tec boring bars as delivered. If necessary, the adaptor can be shortened within the cut-off area between the end of the boring bar and the first marking ❷.

Take care: Shortening the boring bars will also remove the coolant connection thread.



3. Assembling and disassembling QuadFit exchangeable heads

Turning and boring heads are fitted on the Accure-tec adaptors using the QuadFit interface. The QuadFit interface allows quick and easy replacement of exchangeable heads, with perfect positioning and repeat accuracy.

Assembly

Clamp the Accure-tec boring bar to an assembly block or directly onto the machine tool interface.

- Clean the QuadFit interface on both bar and head.
- Use the exchangeable head in a standard or overhead position (turned 180°).
- Tighten the union nut on the boring bar by hand. (Tighten the union nut in the direction of the "locked padlock" symbol (see 3.1)).
- Tighten the nut with the appropriate key.

Note:

Using a torque wrench is advisable, to comply with the recommended tightening torque. Torque wrenches are available as an accessory (see Table 3.2).

Disassembly

- Loosen the union nut using the appropriate key (do not use a torque wrench).
- Hold the exchangeable head and turn the nut manually until the head can be released. Turn the union nut in the direction of the 'open padlock' symbol (see 3.1).



3.2. Tightening key/tightening torque

Connection size	Q25	Q32	Q40	Q50
Mounting wrench	SD9000-Q25	SD9000-Q32	SD9000-Q40	SD9000-Q50
Torque wrench	–	SD4000-Q32-25	SD4000-Q40-35	SD4000-Q50-55
Tightening torque	25 Nm	25 Nm	35 Nm	55 Nm

4. Speed limits for boring

Please make sure not to exceed the max. speed of the vibration-damped adaptor (see table 4.1).

Note:

Parallel shank bars are intended for static application (turning) only. The specified maximum speed is not applicable.

4.1. Maximum speed in boring [rpm]*

Connection size	Length		
	6 × D	8 × D	10 × D
Q25	10000	8000	6000
Q32	10000	8000	6000
Q40	8000	6000	5000
Q50	6000	4000	2500

* The maximum speed can be lower, depending on the rigidity of the spindle.

5. Maximum temperature of use

Make sure that the Accure-tec boring bars/ adaptors never exceed the maximum temperature of use, as this would damage the damping system.

Maximum temperature of use = 80 °C/176 °F

6. Recommended cutting data

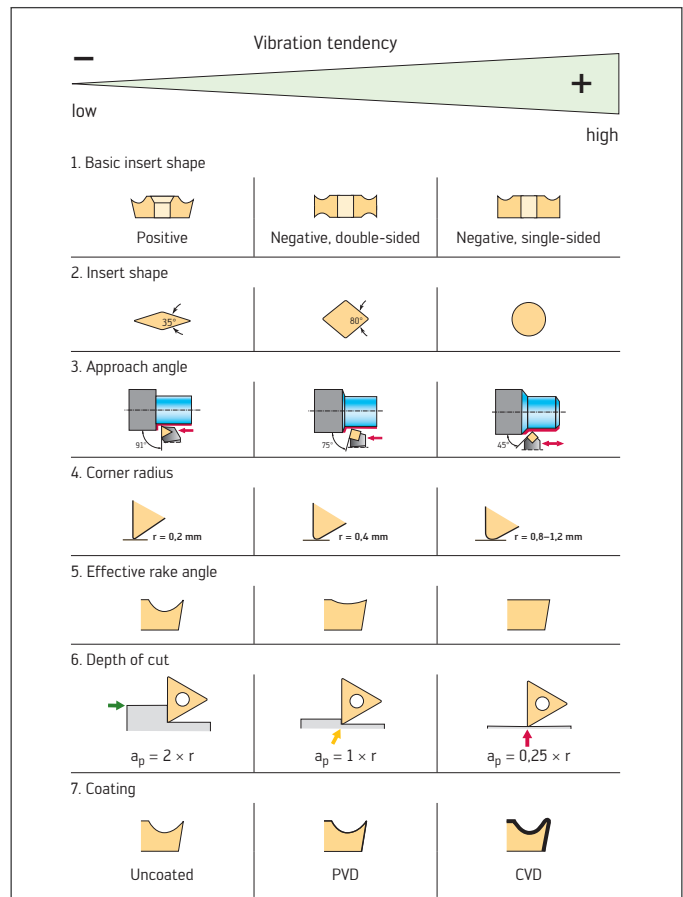
Incorrect cutting data could cause vibration in the tooling system. This would influence the damper's efficiency and could damage the Accure-tec boring bar's components. Therefore, make sure to set the cutting data so that no vibration is created.

Cutting data selection order:

1. Cutting speed v_c and feed f : Select the average value for the indexable insert you are using (see Walter General Catalogue or Walter GPS tool navigation system).
2. Depth of cut a_p is the preferred parameter for optimisation. It can be increased within the recommended application range of the indexable insert provided that no vibration occurs.


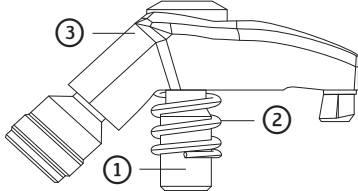

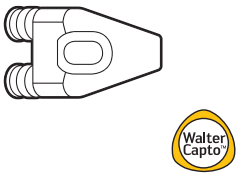
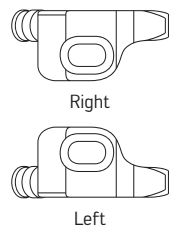





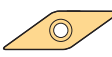

Take care:

- In contrast to the use of conventional boring bars, machining cannot be stabilised using additional radial forces (e.g. by increasing the feed).
- Particularly for small boring bars (< 32 mm dia.), be mindful of good chip control to avoid chips getting stuck in the bore.

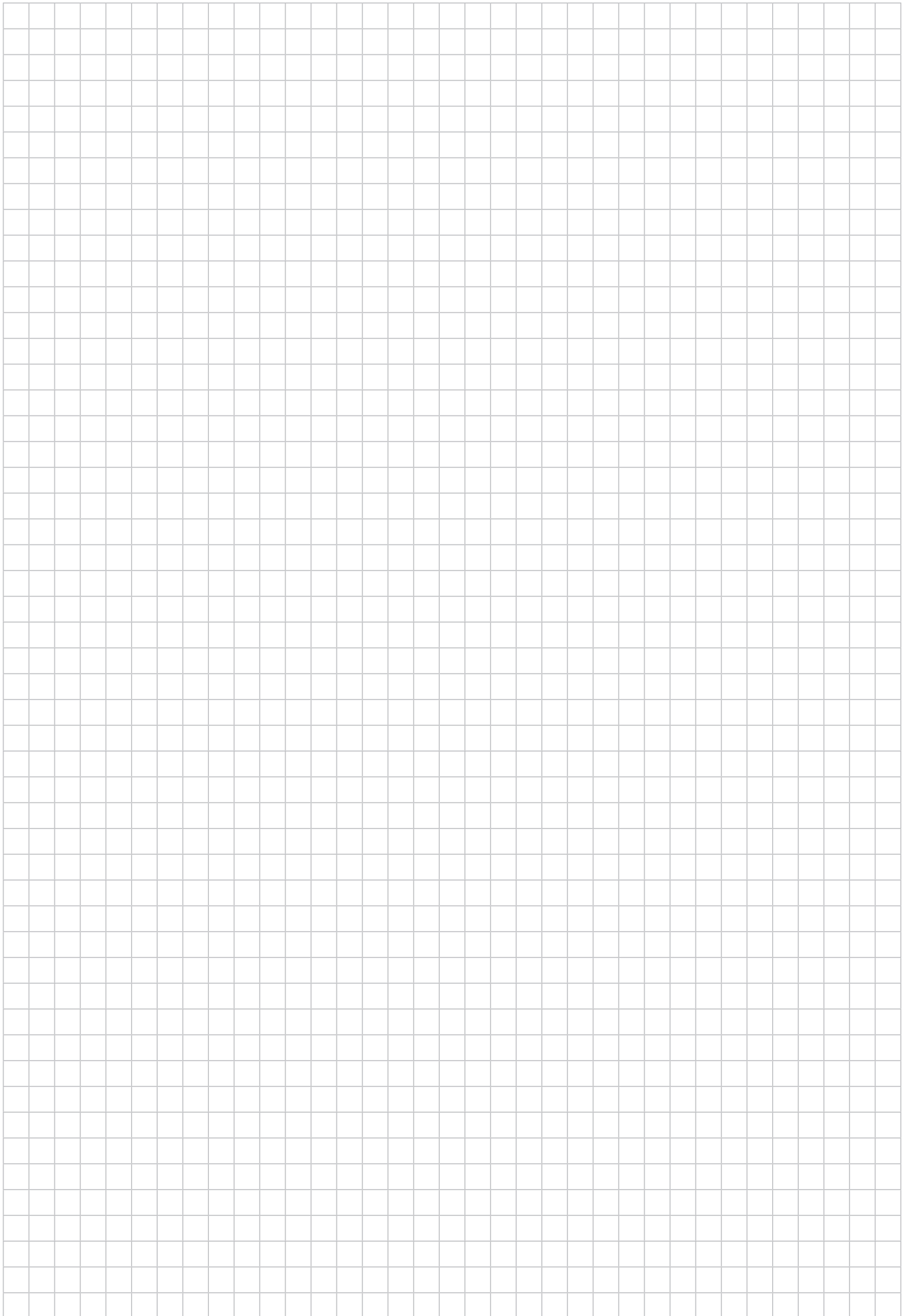


Assembly parts and accessories for Walter Turn rigid clamping with precision cooling

Standard clamps for tools with precision cooling

Application	 <p>for indexable inserts with drilled hole</p>							
								
Version						 <p>Right Left</p>		
Set	PK255 set	PK256 set	PK264 set	PK267 set	PK268 set ²	PK261R/L set	PK265R/L set	PK266R/L set
① Clamp screw	FS1473 (Torx 15IP)	FS1473 (Torx 15IP)	FS1474 (Torx 20IP)	FS1474 (Torx 20IP)	FS1474 (Torx20IP)	FS1473 (Torx 15IP)	FS1473 (Torx 15IP)	FS1473 (Torx 15IP)
② Pressure spring	FS2188	FS2188	FS2298	FS2298	FS2298	FS2188	FS2188	FS2188
③ Clamp	PK255	PK256	PK264	PK267	PK268	PK261R/L	PK265R/L	PK266R/L
Type	Size							
	CN .. 12 ..		CN .. 19 ..	CN .. 16 ..		CN .. 12 ..	CN .. 12 .. ¹⁾	
	DN .. 11 ..	DN .. 15 ..				DN .. 11 .. DC .. 11 ..	DN .. 15 ..	
					RN . N12 ..			
	SN .. 12 ..					SN .. 12 ..	SN .. 12 .. ¹⁾	
	TN .. 16 .. TC .. 16T3 ..					TN .. 16 .. TC .. 16T3 ..		
	VB .. 1604 ..					VB .. 1604 ..		
	WN .. 08 ..							WN .. 08 ..

¹⁾ First choice²⁾ for ceramic inserts without a hole



Cutting data for grooving inserts – CBN/PCD


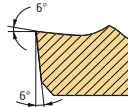
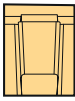

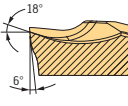


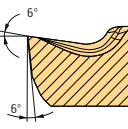
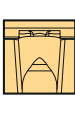

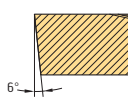
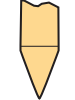
Material group	Overview of the main material groups and code letters		Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	Cutting material grades					
						Starting values for cutting speed v _c [m/min]					
						CBN					
						BH WBH20					
						f [mm/rev]					
						0,05	0,15	0,20			
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1					
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2					
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3					
		C > 0.55%	Annealed	190	640	P4					
		C > 0.55%	Heat-treated	300	1010	P5					
		Free-machining steel (short-chipping)	Annealed	220	750	P6					
	Low-alloy steel	Annealed		175	590	P7					
		Heat-treated		285	960	P8					
		Heat-treated		380	1280	P9					
		Heat-treated		430	1480	P10					
	High-alloyed steel and high-alloyed tool steel	Annealed		200	680	P11					
		Hardened and tempered		300	1010	P12					
		Hardened and tempered		380	1280	P13					
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14					
		Martensitic, heat-treated		330	1110	P15					
M	Stainless steel	Austenitic, quench hardened		200	680	M1					
		Austenitic, precipitation hardened (PH)		300	1010	M2					
		Austenitic/ferritic, duplex		230	780	M3					
K	Malleable cast iron	Ferritic		200	400	K1					
		Pearlitic		260	700	K2					
	Grey cast iron	Low tensile strength		180	200	K3					
		High tensile strength/austenitic		245	350	K4					
	Cast iron with spheroidal graphite	Ferritic		155	400	K5					
		Pearlitic		265	700	K6					
	GGV (CGI)			230	400	K7					
N	Wrought aluminium alloys	Not hardenable		30	–	N1					
		Hardenable, hardened		100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3					
		≤ 12% Si, hardenable, hardened		90	310	N4					
	Magnesium-based alloys	> 12% Si, not hardenable		130	450	N5					
				70	250	N6					
Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	340	N7						
	Brass, bronze, red brass		90	310	N8						
	Cu alloys, short-chipping		110	380	N9						
	High tensile, Ampco		300	1010	N10						
S	Heat-resistant alloys	Fe-based	Annealed		200	680	S1				
			Hardened		280	940	S2				
		Ni- or Co-based	Annealed		250	840	S3	●●	●		
			Hardened		350	1180	S4	●●	●		
			Cast		320	1080	S5	●●	●		
	Titanium alloys	Pure titanium		200	680	S6					
		α and β alloys, hardened		375	1260	S7					
		β alloys		410	1400	S8					
	Tungsten alloys			300	1010	S9					
	Molybdenum alloys			300	1010	S10					
H	Hardened steel	Hardened and tempered		50 HRC	–	H1	●	●●	250	200	180
		Hardened and tempered		55 HRC	–	H2	●	●●	220	180	150
		Hardened and tempered		60 HRC	–	H3	●	●●	200	150	120
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4	●	●●	200	150	120
O	Thermoplastics	Without abrasive fillers				O1					
	Thermosets	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							

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


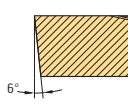

¹ The classification of the machining groups can be found from page A 468 onwards in the Walter General Catalogue 2017.

Geometry overview of cutting inserts:

MX system: Cutting inserts for grooving and parting off

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s		f
		P	M	K	N	S	H	O			[mm]	[mm]	
 <p>GD8 – For DIN 471 circlip grooves with the tolerance class H13 – For precision grooving – Extremely soft cutting action – Light to moderate feeds</p>	●● ● ● ● ●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●			1	0,03–0,06	1,5 0,03–0,09 2 0,04–0,10 2,5 0,04–0,14 3 0,04–0,14	
										1,5	0,03–0,09		
										2	0,04–0,10		
										2,5	0,04–0,14		
										3	0,04–0,14		
 <p>CF5 – Grooving and parting off operations – Light to moderate feeds – Excellent chip control – Low burr/centre pip formation</p>	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●			1	0,03–0,07	1,5 0,03–0,10 2 0,04–0,14 2,5 0,04–0,16 3 0,04–0,16 4 0,10–0,20 5 0,10–0,25	
										1,5	0,03–0,10		
										2	0,04–0,14		
										2,5	0,04–0,16		
										3	0,04–0,16		
 <p>RF5 – For full radius grooves – Circumference fully ground – For low to moderate feeds</p>	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●			2	0,04–0,14	2,5 0,04–0,18 3 0,04–0,20 4 0,10–0,20 5 0,10–0,20	
										2,5	0,04–0,18		
										3	0,04–0,20		
										4	0,10–0,20		
 <p>AG60 – For thread turning operations where space is limited – Thread turning with the same basic holder – 60° partial profile external thread – Pitch range 0.5–3.0 mm</p>	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●			3,35	–	5,65 –	
										5,65	–		


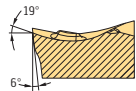


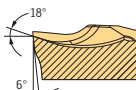


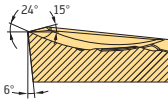


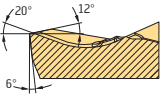

MX system: Recessing

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s	a _p	f
		P	M	K	N	S	H	O			[mm]	[mm]	[mm]
 <p>VG8 – For finishing operations on the rear side of a component, particularly on multi-spindle machines – Enormous savings on workpiece material compared to standard ISO indexable inserts</p>	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●	●● ●● ● ● ●●			2,8	0,2–2,5	0,05–0,25	

Additional shapes via Walter Xpress

- Primary application
- Additional application


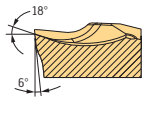


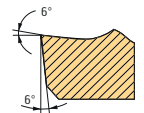


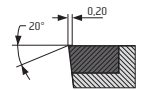
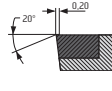

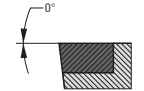
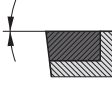
DX system: Grooving and parting off

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s [mm]	f [mm]
		P	M	K	N	S	H	O				
 <p>CF6 – Low feed rates – Low burr/centre pip formation – Low cutting force</p>		●●	●●		●●	●●					1,5	0,03–0,12
		2	0,03–0,14									
		2,5	0,03–0,18									
		3	0,04–0,23									
 <p>CF5 – Grooving and parting off operations – Light to moderate feeds – Good chip control – Low burr/centre pip formation</p>		●●	●●	●	●●	●●					1,5	0,03–0,13
		2	0,04–0,17									
		2,5	0,05–0,18									
		3	0,08–0,23									
 <p>GD6 – Medium feeds – Long-chipping materials – Medium machining conditions</p>		●●	●●	●	●	●●					2	0,04–0,14
		2,5	0,06–0,20									
		3	0,08–0,21									
 <p>CE4 – Grooving and parting off operations – Moderate to high feed rates – Good chip constriction – Stable cutting edge</p>		●●	●	●●	●	●	●				1,5	0,03–0,14
		2	0,06–0,17									
		2,5	0,07–0,21									
		3	0,09–0,33									

- Primary application
- Additional application

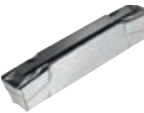
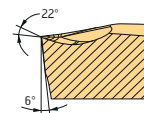


Geometry overview of cutting inserts:

GX system: Grooving and parting off

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s [mm]	f [mm]
		P	M	K	N	S	H	O				
 <p>CK8 – Grooving and parting off operations – Light to moderate feeds – Good chip control – Low burr/centre pip formation – Polished rake face</p>		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			2	0,04–0,15
											2,5	0,05–0,15
											3	0,08–0,20
											4	0,10–0,22
											5	0,10–0,25
 <p>GD8 – For DIN 471 circlip grooves with the tolerance class H13 – For precision grooving – Extremely soft cutting action – Light to moderate feeds</p>		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			1	0,03–0,06
											1,5	0,03–0,09
											2	0,04–0,10
											2,5	0,04–0,14
 <p>GX...TM – Grooving operations – Low feed rates – CBN indexable insert with circumference fully ground – CBN insert with chamfered cutting edge</p>		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			3	0,02–0,10
											4	0,02–0,12
											5	0,02–0,14
											6	0,02–0,15
 <p>GX...EM – Grooving operations – Light to moderate feed rates – CBN indexable insert with circumference fully ground – CBN insert with rounded cutting edge</p>		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			3	0,1–0,15
											4	0,1–0,20
											5	0,1–0,25
											6	0,1–0,30

- Primary application
- Additional application


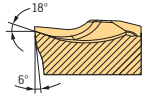

GX system: Grooving, parting off and recessing

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s [mm]	a _p [mm]	f [mm]
		P	M	K	N	S	H	O					
 <p>UF8 – All grooving operations – Excellent chip control – Low to average feed range – For DIN 471 circlip grooves with the tolerance class H13</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>			1,6	0,3–1,0	0,05–0,17	
										2	0,3–1,2	0,05–0,22	
										3	0,4–1,5	0,07–0,24	
										4	0,3–2,2	0,07–0,30	
										5	0,3–2,6	0,11–0,35	
										6	0,3–3,2	0,11–0,35	
										8	1,0–4,2	0,13–0,40	
										 <p>VG7 – For finishing operations on the rear side of a component, particularly on multi-spindle machines – Enormous savings on work-piece material compared to standard ISO indexable inserts – Optimum chip breaking for finishing operations</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>	<p>•• •• • •• ••</p>

- Primary application
- Additional application


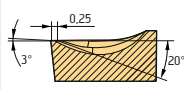

Geometry overview of cutting inserts

SX system: Grooving and parting off

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s [mm]	f [mm]
		P	M	K	N	S	H	O				
	CK8 – Grooving and parting off operations – Light to moderate feeds – Good chip control – Low burr/centre pip formation – Polished rake face	Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			2	0,04–0,15
		2,5	0,05–0,15									
		3	0,08–0,20									
		4	0,10–0,22									
		5	0,10–0,25									

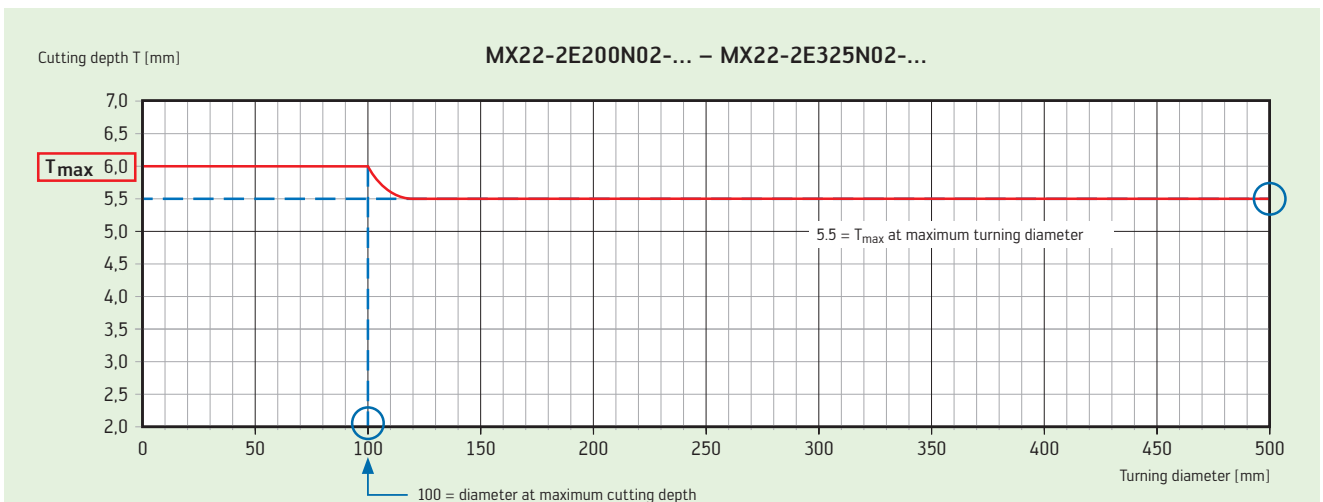
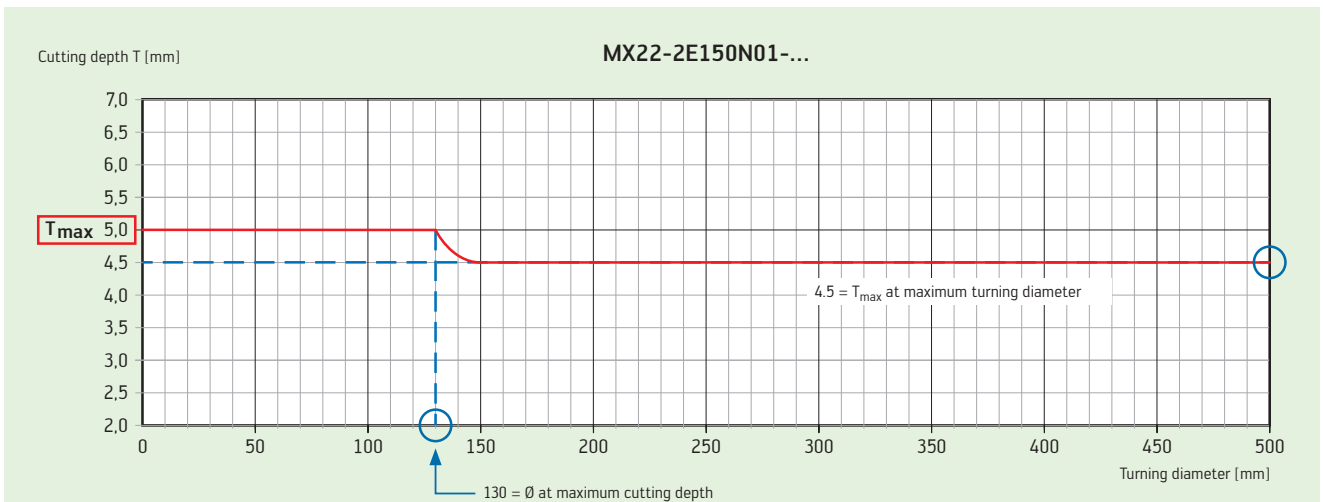
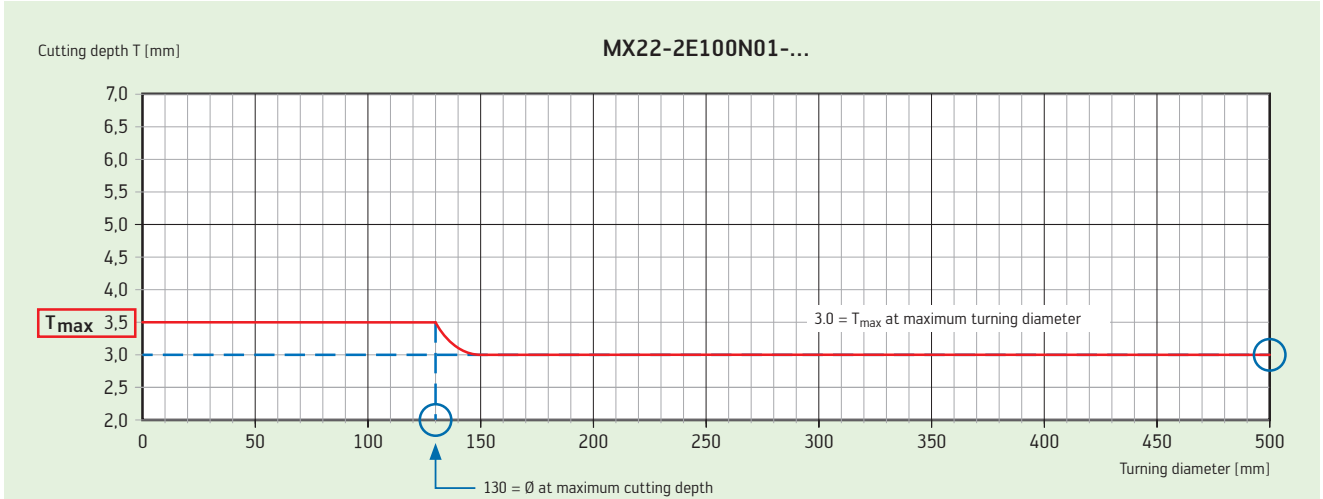
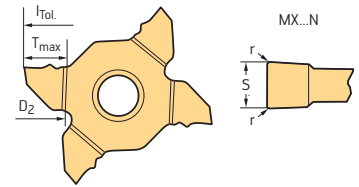
- Primary application
- Additional application

UX system: Grooving and widening

Geometry	Remarks/field of applications	Material groups							Main cutting edge section	View of main cutting edge	s [mm]	f [mm]
		P	M	K	N	S	H	O				
	GD2 – Universal chip former – For grooving and widening wide grooves – Very short chips – Low to high feed rates	Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other			12	0,2–0,4
		19	0,25–0,60									

- Primary application
- Additional application

Application information: Cutting depths depending on turning diameter



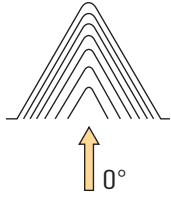
Application information: Standard values for thread turning with Walter Cut MX

Feed types and their influence on machining

Radial feed

Recommended for:

- Short-chipping materials
- Hard materials

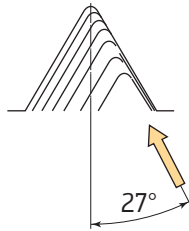


- Formation of V-shaped chips
- Both cutting edges engaged
- High cutting temperature
- Even indexable insert wear on both flanks
- Suitable for small pitches

Feed via flank 27°–29°

Recommended for:

- Pitches greater than 1.5 mm or 16 TPI
- The manufacture of trapezoidal threads

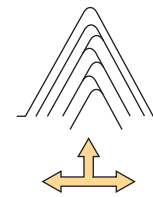


- Good chip formation
- Formation of helical chips
- One cutting edge engaged
- Chips are guided away from the thread
- Thread flanks with excellent surface quality

Alternating feed

Recommended for:

- Steep pitches
- Long-chipping materials



- Good chip formation
- Formation of flat helical chips
- Both cutting edges are evenly engaged, ensuring even wear

Standard values for the number of radial infeeds for each thread turning pass on manual lathes

The recommended cutting passes are only to be regarded as standard values. They were determined under good operating conditions with medium-strength steel materials. In the case of high-strength steel materials, the number of feeds must be increased. It is important to reduce the initial threading cuts in this case.

External machining, metric 60°

No. of feeds	Pitch [mm]											
	0,5	0,6	0,7	0,75	0,8	1,0	1,25	1,5	1,75	2,0	2,5	3,0
Total depth [mm]	0,34	0,40	0,47	0,50	0,54	0,67	0,80	0,94	1,14	1,28	1,58	1,89
16												
15												
14												
13												
12												0,08
11												0,10
10											0,08	0,11
9											0,11	0,12
8									0,08	0,08	0,11	0,12
7									0,10	0,11	0,12	0,13
6							0,08	0,08	0,10	0,12	0,13	0,14
5						0,08	0,10	0,12	0,12	0,14	0,15	0,16
4	0,07	0,07	0,07	0,07	0,08	0,11	0,11	0,14	0,14	0,16	0,17	0,18
3	0,07	0,08	0,10	0,11	0,12	0,13	0,14	0,17	0,17	0,18	0,20	0,21
2	0,09	0,11	0,14	0,15	0,16	0,16	0,17	0,21	0,21	0,24	0,24	0,26
1	0,11	0,14	0,16	0,17	0,18	0,19	0,20	0,22	0,22	0,25	0,27	0,28

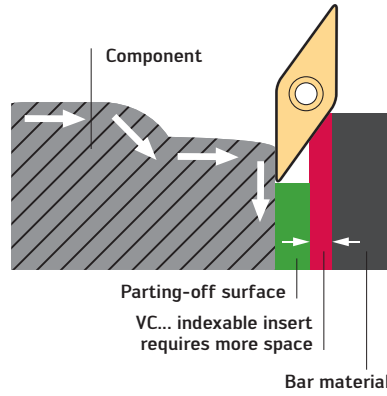
Radial infeed [mm]

Reduce the cutting speed

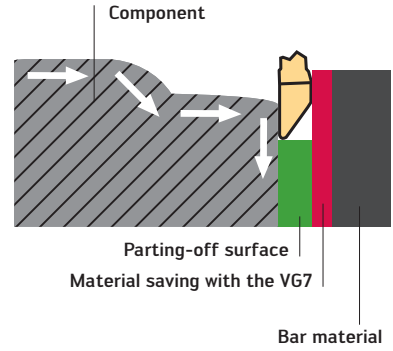
Application information: Reverse turning with Walter Cut GX-VG7

Comparison of material savings with the VG7 geometry when reverse turning instead of using a VC.. Finishing insert

Example of a VC... indexable insert (35°)

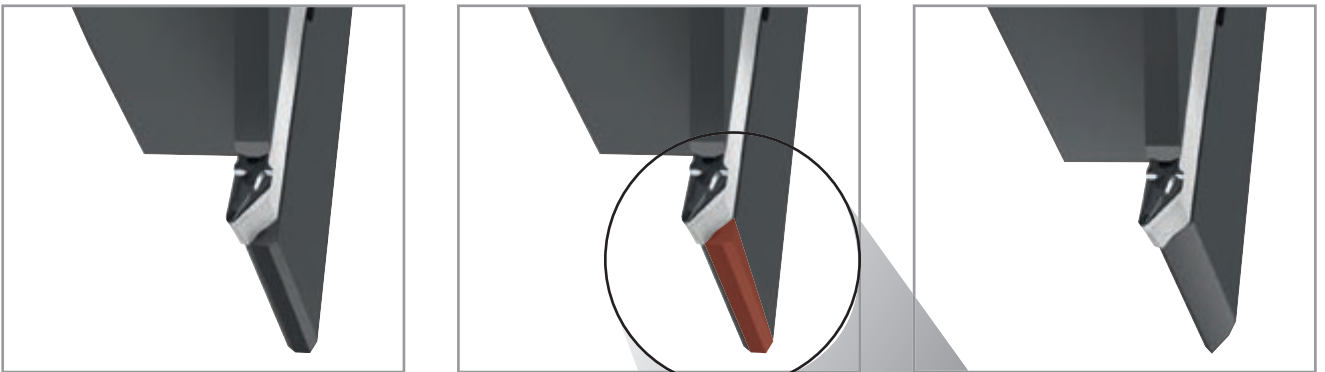


GX24-2E280R02-VG7 WSM33S

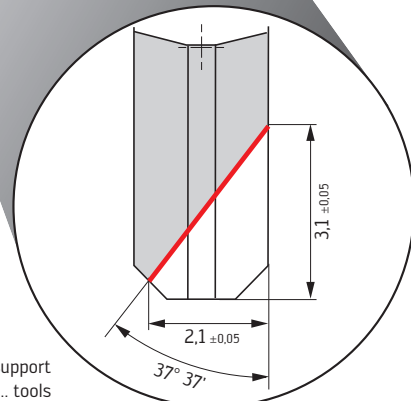


Modification of grooving tools for VG7 cutting inserts

Cutting inserts can be used in G15.../NCCE/NCNE/NCCI tools.
With other tools, e.g. G1011, adapt support to the cutting insert profile.



Dimensional drawing for adapting the support of G1011...3T... tools





Drilling from solid – B1

Solid carbide drilling and reaming tools	Product range overview	200
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	Solid carbide drills – with internal coolant	203
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HSS drilling and reaming tools	Product range overview	336
	HSS drills	337

Technical information – B1

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Boring and precision boring – B2

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










Technical information – B2







Boring and precision boring tools	Cutting data	434
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Product range overview of solid carbide drilling and reaming tools

Solid carbide drills with internal coolant












B 1

Machining									
Drilling depth	3 x D _c	3 x D _c		5 x D _c			8 x D _c		12 x D _c
Designation	DC260 Advance X-treme Evo	DC160 Advance X-treme Evo	DC150 Perform	DB133 Supreme	DC160 Advance X-treme Evo	DC150 Perform	DB133 Supreme	DC160 Advance X-treme Evo	DB133 Supreme
Standard	Walter	DIN 6537 K	DIN 6537 K	Walter	DIN 6537 L	DIN 6537 L	Walter	Walter	Walter
Dia. range [mm]	3,3–14	3–20	3–20	0,7–1,984	3–25	3–20	0,7–1,984	3–20	0,7–1,984
Page	203	204	211	212	213	221	224	225	228
									

Machining					
Drilling depth	12 x D _c	16 x D _c	20 x D _c	25 x D _c	30 x D _c
Designation	DC160 Advance X-treme Evo	DC160 Advance X-treme Evo	DC160 Advance X-treme Evo	DC160 Advance X-treme Evo	DC160 Advance X-treme Evo
Standard	Walter	Walter	Walter	Walter	Walter
Dia. range [mm]	3–20	3–16	3–16	3–12	3–12
Page	229	232	233	234	235
					

Product range overview of solid carbide drilling and reaming tools

Solid carbide drills without internal coolant

Machining			 					
Drilling depth	3 x D _c	2 x D _c	3 x D _c			5 x D _c		
Designation	DC260 Advance X-treme Evo	DB131 Supreme	DC160 Advance X-treme Evo	DC150 Perform	DC150 Perform	DB130 Advance	DC160 Advance X-treme Evo	DC150 Perform
Standard	Walter	Walter	DIN 6537 K	DIN 6539	DIN 6537 K	DIN 1899	DIN 6537 L	DIN 6537 L
Dia. range [mm]	3,3–14,5	0,5–1,984	3–20	1,5–2,9	3–20	0,1–1,45	3–25	3–20
Page	236	259	237	244	245	247	249	256
								

B 1

Designation key for Walter Titex solid drills

D	C	1	70	-	16	-	03.000	A	1	-	W	J	30	EJ
1	2	3	4	5	6	7	8	9	Grade					

1	2	3	4	5
Tool group	Generation	Tool type	Tool type	1. Delimiters
D Drilling		1 Cylindrical drill 2 Chamfer drills	10 Perform type N 50 Perform Universal 30 Advance micro drill 60 Advance Universal 31 Supreme micro pilot drill 33 Supreme micro drill 70 Supreme ISO P; ISO K	- Metric · Inch

6	7	8	9
Drilling depth	Cutting diameter	Shank type	Cooling
03 $\approx 3 \times D_c$ in accordance with DIN 6537 short 05 $\approx 5 \times D_c$ in accordance with DIN 6537 long or in accordance with Walter standard 08 $\approx 8 \times D_c$ in accordance with Walter standard in accordance with DIN 338 12 $\approx 12 \times D_c$ in accordance with Walter standard 16 $\approx 16 \times D_c$ in accordance with Walter standard 20 $\approx 20 \times D_c$ in accordance with Walter standard 25 $\approx 25 \times D_c$ in accordance with Walter standard 30 $\approx 30 \times D_c$ in accordance with Walter standard		A DIN 6535 HA parallel shank F DIN 6535 HE parallel shank U Parallel shank Parallel shank D DIN 6535 HB/ DIN 6535 HE	0 External coolant 1 Axial internal coolant

Grade designation key for solid carbide and HSS cutting tool materials

W	J	30	EJ
Walter	1	2	3

1	2	3
Substrate	Application range	Coating
Solid carbide J HSS Z		EJ TiAlN (AlCrN) RE TiAlN TA TiAlN EL AlCrN ER AlCrN point coating UU Uncoated ET TiSiAlCrN/AlTiN EU TiSiAlCrN/AlTiN point coating AJ TiN point coating

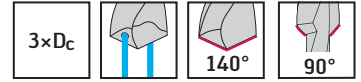
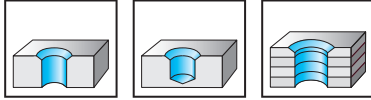
Solid carbide chamfer drills with coolant-through

DC260 Advance

X-treme Evo



- Step length in accordance with DIN 8378
- For thread core hole drilling



	P	M	K	N	S	H	O
WJ30ET	●	●	●	●	●	●	●

	Designation	For thread	D _c m7 mm	d ₁₀ h7 mm	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC260-03-03.300A1-	M 4	3,3	5	11	66	28	36	6	
	DC260-03-04.200A1-	M 5	4,2	6	14	66	28	36	6	
	DC260-03-05.000A1-	M 6	5	8	17	79	41	36	8	
	DC260-03-06.800A1-	M 8	6,8	10	21	89	47	40	10	
	DC260-03-08.500A1-	M 10	8,5	12	26	102	55	45	12	
	DC260-03-10.200A1-	M 12	10,2	14	30	107	60	45	14	
	DC260-03-12.000A1-	M 14	12	16	35	115	65	48	16	
	DC260-03-14.000A1-	M 16	14	18	39	123	73	48	18	
Shank DIN 6535 HE 	DC260-03-03.300F1-	M 4	3,3	5	11	66	28	36	6	
	DC260-03-04.200F1-	M 5	4,2	6	14	66	28	36	6	
	DC260-03-05.000F1-	M 6	5	8	17	79	41	36	8	
	DC260-03-06.800F1-	M 8	6,8	10	21	89	47	40	10	
	DC260-03-08.500F1-	M 10	8,5	12	26	102	55	45	12	
	DC260-03-10.200F1-	M 12	10,2	14	30	107	60	45	14	
	DC260-03-12.000F1-	M 14	12	16	35	115	65	48	16	
	DC260-03-14.000F1-	M 16	14	18	39	123	73	48	18	

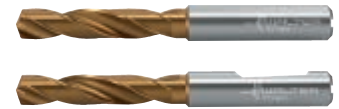
Ordering example for the WJ30ET grade: DC260-03-03.300A1-WJ30ET

B 1

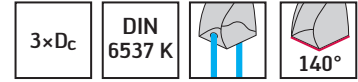
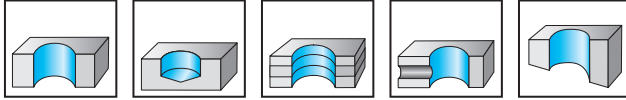
Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



B 1

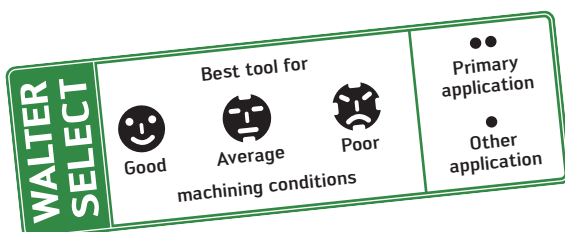


P	M	K	N	S	H	O
●	●	●	●	●	●	●

Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
DC160-03-03.000A1-	3		14	62	20	36	6	●
DC160-03-03.100A1-	3,1		14	62	20	36	6	●
DC160-03-03.175A1-	3,175	1/8"	14	62	20	36	6	●
DC160-03-03.200A1-	3,2		14	62	20	36	6	●
DC160-03-03.250A1-	3,25		14	62	20	36	6	●
DC160-03-03.300A1-	3,3		14	62	20	36	6	●
DC160-03-03.400A1-	3,4		14	62	20	36	6	●
DC160-03-03.500A1-	3,5		14	62	20	36	6	●
DC160-03-03.572A1-	3,572	9/64"	14	62	20	36	6	●
DC160-03-03.600A1-	3,6		14	62	20	36	6	●
DC160-03-03.650A1-	3,65		14	62	20	36	6	●
DC160-03-03.700A1-	3,7		14	62	20	36	6	●
DC160-03-03.800A1-	3,8		17	66	24	36	6	●
DC160-03-03.900A1-	3,9		17	66	24	36	6	●
DC160-03-03.969A1-	3,969	5/32"	17	66	24	36	6	●
DC160-03-04.000A1-	4		17	66	24	36	6	●
DC160-03-04.100A1-	4,1		17	66	24	36	6	●
DC160-03-04.200A1-	4,2		17	66	24	36	6	●
DC160-03-04.300A1-	4,3		17	66	24	36	6	●
DC160-03-04.366A1-	4,366	11/64"	17	66	24	36	6	●
DC160-03-04.400A1-	4,4		17	66	24	36	6	●
DC160-03-04.500A1-	4,5		17	66	24	36	6	●
DC160-03-04.600A1-	4,6		17	66	24	36	6	●
DC160-03-04.650A1-	4,65		17	66	24	36	6	●
DC160-03-04.700A1-	4,7		17	66	24	36	6	●
DC160-03-04.763A1-	4,763	3/16"	20	66	28	36	6	●
DC160-03-04.800A1-	4,8		20	66	28	36	6	●
DC160-03-04.900A1-	4,9		20	66	28	36	6	●
DC160-03-05.000A1-	5		20	66	28	36	6	●
DC160-03-05.100A1-	5,1		20	66	28	36	6	●
DC160-03-05.159A1-	5,159	13/64"	20	66	28	36	6	●
DC160-03-05.200A1-	5,2		20	66	28	36	6	●
DC160-03-05.300A1-	5,3		20	66	28	36	6	●
DC160-03-05.400A1-	5,4		20	66	28	36	6	●
DC160-03-05.500A1-	5,5		20	66	28	36	6	●
DC160-03-05.550A1-	5,55		20	66	28	36	6	●
DC160-03-05.556A1-	5,556	7/32"	20	66	28	36	6	●
DC160-03-05.600A1-	5,6		20	66	28	36	6	●
DC160-03-05.700A1-	5,7		20	66	28	36	6	●
DC160-03-05.800A1-	5,8		20	66	28	36	6	●
DC160-03-05.900A1-	5,9		20	66	28	36	6	●
DC160-03-05.953A1-	5,953	15/64"	20	66	28	36	6	●
DC160-03-06.000A1-	6		20	66	28	36	6	●

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

Continued



Continued

	Designation	D _c mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-06.100A1-	6,1		24	79	34	36	8	☺
	DC160-03-06.200A1-	6,2		24	79	34	36	8	☺
	DC160-03-06.300A1-	6,3		24	79	34	36	8	☺
	DC160-03-06.350A1-	6,35	1/4"	24	79	34	36	8	☺
	DC160-03-06.400A1-	6,4		24	79	34	36	8	☺
	DC160-03-06.500A1-	6,5		24	79	34	36	8	☺
	DC160-03-06.600A1-	6,6		24	79	34	36	8	☺
	DC160-03-06.700A1-	6,7		24	79	34	36	8	☺
	DC160-03-06.747A1-	6,747	17/64"	24	79	34	36	8	☺
	DC160-03-06.800A1-	6,8		24	79	34	36	8	☺
	DC160-03-06.900A1-	6,9		24	79	34	36	8	☺
	DC160-03-07.000A1-	7		24	79	34	36	8	☺
	DC160-03-07.100A1-	7,1		29	79	41	36	8	☺
	DC160-03-07.144A1-	7,144	9/32"	29	79	41	36	8	☺
	DC160-03-07.200A1-	7,2		29	79	41	36	8	☺
	DC160-03-07.300A1-	7,3		29	79	41	36	8	☺
	DC160-03-07.400A1-	7,4		29	79	41	36	8	☺
	DC160-03-07.500A1-	7,5		29	79	41	36	8	☺
	DC160-03-07.541A1-	7,541	19/64"	29	79	41	36	8	☺
	DC160-03-07.550A1-	7,55		29	79	41	36	8	☺
	DC160-03-07.600A1-	7,6		29	79	41	36	8	☺
	DC160-03-07.700A1-	7,7		29	79	41	36	8	☺
	DC160-03-07.800A1-	7,8		29	79	41	36	8	☺
	DC160-03-07.900A1-	7,9		29	79	41	36	8	☺
	DC160-03-07.938A1-	7,938	5/16"	29	79	41	36	8	☺
	DC160-03-08.000A1-	8		29	79	41	36	8	☺
	DC160-03-08.100A1-	8,1		35	89	47	40	10	☺
	DC160-03-08.200A1-	8,2		35	89	47	40	10	☺
	DC160-03-08.300A1-	8,3		35	89	47	40	10	☺
	DC160-03-08.334A1-	8,334	21/64"	35	89	47	40	10	☺
	DC160-03-08.400A1-	8,4		35	89	47	40	10	☺
	DC160-03-08.500A1-	8,5		35	89	47	40	10	☺
	DC160-03-08.600A1-	8,6		35	89	47	40	10	☺
	DC160-03-08.700A1-	8,7		35	89	47	40	10	☺
	DC160-03-08.731A1-	8,731	11/32"	35	89	47	40	10	☺
	DC160-03-08.800A1-	8,8		35	89	47	40	10	☺
	DC160-03-08.900A1-	8,9		35	89	47	40	10	☺
	DC160-03-09.000A1-	9		35	89	47	40	10	☺
	DC160-03-09.100A1-	9,1		35	89	47	40	10	☺
	DC160-03-09.128A1-	9,128	23/64"	35	89	47	40	10	☺
DC160-03-09.200A1-	9,2		35	89	47	40	10	☺	
DC160-03-09.300A1-	9,3		35	89	47	40	10	☺	
DC160-03-09.400A1-	9,4		35	89	47	40	10	☺	
DC160-03-09.500A1-	9,5		35	89	47	40	10	☺	
DC160-03-09.525A1-	9,525	3/8"	35	89	47	40	10	☺	
DC160-03-09.550A1-	9,55		35	89	47	40	10	☺	
DC160-03-09.600A1-	9,6		35	89	47	40	10	☺	
DC160-03-09.700A1-	9,7		35	89	47	40	10	☺	
DC160-03-09.800A1-	9,8		35	89	47	40	10	☺	
DC160-03-09.900A1-	9,9		35	89	47	40	10	☺	
DC160-03-09.922A1-	9,922	25/64"	35	89	47	40	10	☺	
DC160-03-10.000A1-	10		35	89	47	40	10	☺	
DC160-03-10.100A1-	10,1		40	102	55	45	12	☺	
DC160-03-10.200A1-	10,2		40	102	55	45	12	☺	
DC160-03-10.300A1-	10,3		40	102	55	45	12	☺	
DC160-03-10.319A1-	10,319	13/32"	40	102	55	45	12	☺	
DC160-03-10.400A1-	10,4		40	102	55	45	12	☺	
DC160-03-10.500A1-	10,5		40	102	55	45	12	☺	
DC160-03-10.600A1-	10,6		40	102	55	45	12	☺	
DC160-03-10.700A1-	10,7		40	102	55	45	12	☺	
DC160-03-10.716A1-	10,716	27/64"	40	102	55	45	12	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

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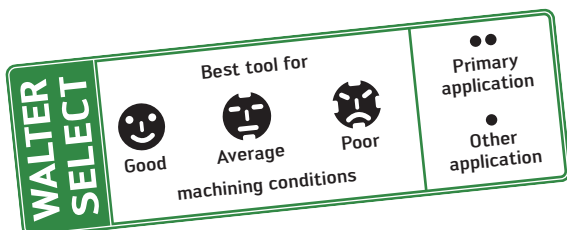
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-10.800A1-	10,8		40	102	55	45	12	☺
	DC160-03-10.900A1-	10,9		40	102	55	45	12	☺
	DC160-03-11.000A1-	11		40	102	55	45	12	☺
	DC160-03-11.100A1-	11,1		40	102	55	45	12	☺
	DC160-03-11.113A1-	11,113	7/16"	40	102	55	45	12	☺
	DC160-03-11.200A1-	11,2		40	102	55	45	12	☺
	DC160-03-11.300A1-	11,3		40	102	55	45	12	☺
	DC160-03-11.400A1-	11,4		40	102	55	45	12	☺
	DC160-03-11.500A1-	11,5		40	102	55	45	12	☺
	DC160-03-11.509A1-	11,509	29/64"	40	102	55	45	12	☺
	DC160-03-11.550A1-	11,55		40	102	55	45	12	☺
	DC160-03-11.600A1-	11,6		40	102	55	45	12	☺
	DC160-03-11.700A1-	11,7		40	102	55	45	12	☺
	DC160-03-11.800A1-	11,8		40	102	55	45	12	☺
	DC160-03-11.900A1-	11,9		40	102	55	45	12	☺
	DC160-03-11.906A1-	11,906	15/32"	40	102	55	45	12	☺
	DC160-03-12.000A1-	12		40	102	55	45	12	☺
	DC160-03-12.100A1-	12,1		43	107	60	45	14	☺
	DC160-03-12.200A1-	12,2		43	107	60	45	14	☺
	DC160-03-12.250A1-	12,25		43	107	60	45	14	☺
	DC160-03-12.300A1-	12,3		43	107	60	45	14	☺
	DC160-03-12.303A1-	12,303	31/64"	43	107	60	45	14	☺
	DC160-03-12.400A1-	12,4		43	107	60	45	14	☺
	DC160-03-12.500A1-	12,5		43	107	60	45	14	☺
	DC160-03-12.600A1-	12,6		43	107	60	45	14	☺
	DC160-03-12.700A1-	12,7	1/2"	43	107	60	45	14	☺
	DC160-03-12.750A1-	12,75		43	107	60	45	14	☺
	DC160-03-12.800A1-	12,8		43	107	60	45	14	☺
	DC160-03-12.900A1-	12,9		43	107	60	45	14	☺
	DC160-03-13.000A1-	13		43	107	60	45	14	☺
	DC160-03-13.100A1-	13,1		43	107	60	45	14	☺
	DC160-03-13.200A1-	13,2		43	107	60	45	14	☺
DC160-03-13.300A1-	13,3		43	107	60	45	14	☺	
DC160-03-13.400A1-	13,4		43	107	60	45	14	☺	
DC160-03-13.494A1-	13,494	17/32"	43	107	60	45	14	☺	
DC160-03-13.500A1-	13,5		43	107	60	45	14	☺	
DC160-03-13.600A1-	13,6		43	107	60	45	14	☺	
DC160-03-13.700A1-	13,7		43	107	60	45	14	☺	
DC160-03-13.800A1-	13,8		43	107	60	45	14	☺	
DC160-03-13.900A1-	13,9		43	107	60	45	14	☺	
DC160-03-14.000A1-	14		43	107	60	45	14	☺	
DC160-03-14.100A1-	14,1		45	115	65	48	16	☺	
DC160-03-14.200A1-	14,2		45	115	65	48	16	☺	
DC160-03-14.288A1-	14,288	9/16"	45	115	65	48	16	☺	
DC160-03-14.300A1-	14,3		45	115	65	48	16	☺	
DC160-03-14.400A1-	14,4		45	115	65	48	16	☺	
DC160-03-14.500A1-	14,5		45	115	65	48	16	☺	
DC160-03-14.600A1-	14,6		45	115	65	48	16	☺	
DC160-03-14.700A1-	14,7		45	115	65	48	16	☺	
DC160-03-14.750A1-	14,75		45	115	65	48	16	☺	
DC160-03-14.800A1-	14,8		45	115	65	48	16	☺	
DC160-03-15.000A1-	15		45	115	65	48	16	☺	
DC160-03-15.100A1-	15,1		45	115	65	48	16	☺	
DC160-03-15.200A1-	15,2		45	115	65	48	16	☺	
DC160-03-15.300A1-	15,3		45	115	65	48	16	☺	
DC160-03-15.500A1-	15,5		45	115	65	48	16	☺	
DC160-03-15.600A1-	15,6		45	115	65	48	16	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-15.700A1-	15,7		45	115	65	48	16	☺
	DC160-03-15.800A1-	15,8		45	115	65	48	16	☺
	DC160-03-15.875A1-	15,875	5/8"	45	115	65	48	16	☺
	DC160-03-15.900A1-	15,9		45	115	65	48	16	☺
	DC160-03-16.000A1-	16		45	115	65	48	16	☺
	DC160-03-16.100A1-	16,1		51	123	73	48	18	☺
	DC160-03-16.200A1-	16,2		51	123	73	48	18	☺
	DC160-03-16.300A1-	16,3		51	123	73	48	18	☺
	DC160-03-16.400A1-	16,4		51	123	73	48	18	☺
	DC160-03-16.500A1-	16,5		51	123	73	48	18	☺
	DC160-03-16.600A1-	16,6		51	123	73	48	18	☺
	DC160-03-16.700A1-	16,7		51	123	73	48	18	☺
	DC160-03-16.750A1-	16,75		51	123	73	48	18	☺
	DC160-03-16.800A1-	16,8		51	123	73	48	18	☺
	DC160-03-17.000A1-	17		51	123	73	48	18	☺
	DC160-03-17.200A1-	17,2		51	123	73	48	18	☺
	DC160-03-17.300A1-	17,3		51	123	73	48	18	☺
	DC160-03-17.500A1-	17,5		51	123	73	48	18	☺
	DC160-03-17.600A1-	17,6		51	123	73	48	18	☺
	DC160-03-17.700A1-	17,7		51	123	73	48	18	☺
DC160-03-17.800A1-	17,8		51	123	73	48	18	☺	
DC160-03-18.000A1-	18		51	123	73	48	18	☺	
DC160-03-18.200A1-	18,2		55	131	79	50	20	☺	
DC160-03-18.500A1-	18,5		55	131	79	50	20	☺	
DC160-03-18.700A1-	18,7		55	131	79	50	20	☺	
DC160-03-18.800A1-	18,8		55	131	79	50	20	☺	
DC160-03-19.000A1-	19		55	131	79	50	20	☺	
DC160-03-19.050A1-	19,05	3/4"	55	131	79	50	20	☺	
DC160-03-19.500A1-	19,5		55	131	79	50	20	☺	
DC160-03-19.700A1-	19,7		55	131	79	50	20	☺	
DC160-03-19.800A1-	19,8		55	131	79	50	20	☺	
DC160-03-20.000A1-	20		55	131	79	50	20	☺	
Shank DIN 6535 HE 	DC160-03-03.000F1-	3		14	62	20	36	6	☺
	DC160-03-03.100F1-	3,1		14	62	20	36	6	☺
	DC160-03-03.200F1-	3,2		14	62	20	36	6	☺
	DC160-03-03.250F1-	3,25		14	62	20	36	6	☺
	DC160-03-03.300F1-	3,3		14	62	20	36	6	☺
	DC160-03-03.400F1-	3,4		14	62	20	36	6	☺
	DC160-03-03.500F1-	3,5		14	62	20	36	6	☺
	DC160-03-03.600F1-	3,6		14	62	20	36	6	☺
	DC160-03-03.650F1-	3,65		14	62	20	36	6	☺
	DC160-03-03.700F1-	3,7		14	62	20	36	6	☺
	DC160-03-03.800F1-	3,8		17	66	24	36	6	☺
	DC160-03-03.900F1-	3,9		17	66	24	36	6	☺
	DC160-03-04.000F1-	4		17	66	24	36	6	☺
	DC160-03-04.100F1-	4,1		17	66	24	36	6	☺
	DC160-03-04.200F1-	4,2		17	66	24	36	6	☺
	DC160-03-04.300F1-	4,3		17	66	24	36	6	☺
	DC160-03-04.400F1-	4,4		17	66	24	36	6	☺
	DC160-03-04.500F1-	4,5		17	66	24	36	6	☺
	DC160-03-04.600F1-	4,6		17	66	24	36	6	☺
	DC160-03-04.650F1-	4,65		17	66	24	36	6	☺
	DC160-03-04.700F1-	4,7		17	66	24	36	6	☺
	DC160-03-04.800F1-	4,8		20	66	28	36	6	☺
	DC160-03-04.900F1-	4,9		20	66	28	36	6	☺
	DC160-03-05.000F1-	5		20	66	28	36	6	☺
	DC160-03-05.100F1-	5,1		20	66	28	36	6	☺
	DC160-03-05.200F1-	5,2		20	66	28	36	6	☺
	DC160-03-05.300F1-	5,3		20	66	28	36	6	☺
DC160-03-05.400F1-	5,4		20	66	28	36	6	☺	
DC160-03-05.500F1-	5,5		20	66	28	36	6	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

Continued

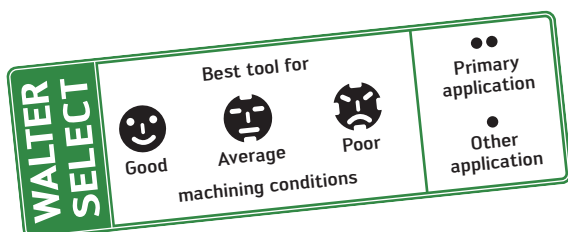
B 1

Continued

	Designation	D _c mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-03-05.550F1-	5,55		20	66	28	36	6	☺
	DC160-03-05.600F1-	5,6		20	66	28	36	6	☺
	DC160-03-05.700F1-	5,7		20	66	28	36	6	☺
	DC160-03-05.800F1-	5,8		20	66	28	36	6	☺
	DC160-03-05.900F1-	5,9		20	66	28	36	6	☺
	DC160-03-06.000F1-	6		20	66	28	36	6	☺
	DC160-03-06.100F1-	6,1		24	79	34	36	8	☺
	DC160-03-06.200F1-	6,2		24	79	34	36	8	☺
	DC160-03-06.300F1-	6,3		24	79	34	36	8	☺
	DC160-03-06.400F1-	6,4		24	79	34	36	8	☺
	DC160-03-06.500F1-	6,5		24	79	34	36	8	☺
	DC160-03-06.600F1-	6,6		24	79	34	36	8	☺
	DC160-03-06.700F1-	6,7		24	79	34	36	8	☺
	DC160-03-06.800F1-	6,8		24	79	34	36	8	☺
	DC160-03-06.900F1-	6,9		24	79	34	36	8	☺
	DC160-03-07.000F1-	7		24	79	34	36	8	☺
	DC160-03-07.100F1-	7,1		29	79	41	36	8	☺
	DC160-03-07.200F1-	7,2		29	79	41	36	8	☺
	DC160-03-07.300F1-	7,3		29	79	41	36	8	☺
	DC160-03-07.400F1-	7,4		29	79	41	36	8	☺
	DC160-03-07.500F1-	7,5		29	79	41	36	8	☺
	DC160-03-07.550F1-	7,55		29	79	41	36	8	☺
	DC160-03-07.600F1-	7,6		29	79	41	36	8	☺
	DC160-03-07.700F1-	7,7		29	79	41	36	8	☺
	DC160-03-07.800F1-	7,8		29	79	41	36	8	☺
	DC160-03-07.900F1-	7,9		29	79	41	36	8	☺
	DC160-03-08.000F1-	8		29	79	41	36	8	☺
	DC160-03-08.100F1-	8,1		35	89	47	40	10	☺
	DC160-03-08.200F1-	8,2		35	89	47	40	10	☺
	DC160-03-08.300F1-	8,3		35	89	47	40	10	☺
	DC160-03-08.400F1-	8,4		35	89	47	40	10	☺
	DC160-03-08.500F1-	8,5		35	89	47	40	10	☺
	DC160-03-08.600F1-	8,6		35	89	47	40	10	☺
	DC160-03-08.700F1-	8,7		35	89	47	40	10	☺
	DC160-03-08.800F1-	8,8		35	89	47	40	10	☺
DC160-03-08.900F1-	8,9		35	89	47	40	10	☺	
DC160-03-09.000F1-	9		35	89	47	40	10	☺	
DC160-03-09.100F1-	9,1		35	89	47	40	10	☺	
DC160-03-09.200F1-	9,2		35	89	47	40	10	☺	
DC160-03-09.300F1-	9,3		35	89	47	40	10	☺	
DC160-03-09.400F1-	9,4		35	89	47	40	10	☺	
DC160-03-09.500F1-	9,5		35	89	47	40	10	☺	
DC160-03-09.550F1-	9,55		35	89	47	40	10	☺	
DC160-03-09.600F1-	9,6		35	89	47	40	10	☺	
DC160-03-09.700F1-	9,7		35	89	47	40	10	☺	
DC160-03-09.800F1-	9,8		35	89	47	40	10	☺	
DC160-03-09.900F1-	9,9		35	89	47	40	10	☺	
DC160-03-10.000F1-	10		35	89	47	40	10	☺	
DC160-03-10.100F1-	10,1		40	102	55	45	12	☺	
DC160-03-10.200F1-	10,2		40	102	55	45	12	☺	
DC160-03-10.300F1-	10,3		40	102	55	45	12	☺	
DC160-03-10.400F1-	10,4		40	102	55	45	12	☺	
DC160-03-10.500F1-	10,5		40	102	55	45	12	☺	
DC160-03-10.600F1-	10,6		40	102	55	45	12	☺	
DC160-03-10.700F1-	10,7		40	102	55	45	12	☺	
DC160-03-10.800F1-	10,8		40	102	55	45	12	☺	
DC160-03-10.900F1-	10,9		40	102	55	45	12	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-03-11.000F1-	11		40	102	55	45	12	☺
	DC160-03-11.100F1-	11.1		40	102	55	45	12	☺
	DC160-03-11.200F1-	11.2		40	102	55	45	12	☺
	DC160-03-11.300F1-	11.3		40	102	55	45	12	☺
	DC160-03-11.400F1-	11.4		40	102	55	45	12	☺
	DC160-03-11.500F1-	11.5		40	102	55	45	12	☺
	DC160-03-11.550F1-	11.55		40	102	55	45	12	☺
	DC160-03-11.600F1-	11.6		40	102	55	45	12	☺
	DC160-03-11.700F1-	11.7		40	102	55	45	12	☺
	DC160-03-11.800F1-	11.8		40	102	55	45	12	☺
	DC160-03-11.900F1-	11.9		40	102	55	45	12	☺
	DC160-03-12.000F1-	12		40	102	55	45	12	☺
	DC160-03-12.100F1-	12.1		43	107	60	45	14	☺
	DC160-03-12.200F1-	12.2		43	107	60	45	14	☺
	DC160-03-12.250F1-	12.25		43	107	60	45	14	☺
	DC160-03-12.300F1-	12.3		43	107	60	45	14	☺
	DC160-03-12.400F1-	12.4		43	107	60	45	14	☺
	DC160-03-12.500F1-	12.5		43	107	60	45	14	☺
	DC160-03-12.600F1-	12.6		43	107	60	45	14	☺
	DC160-03-12.700F1-	12.7	1/2"	43	107	60	45	14	☺
	DC160-03-12.750F1-	12.75		43	107	60	45	14	☺
	DC160-03-12.800F1-	12.8		43	107	60	45	14	☺
	DC160-03-12.900F1-	12.9		43	107	60	45	14	☺
	DC160-03-13.000F1-	13		43	107	60	45	14	☺
	DC160-03-13.100F1-	13.1		43	107	60	45	14	☺
	DC160-03-13.200F1-	13.2		43	107	60	45	14	☺
	DC160-03-13.300F1-	13.3		43	107	60	45	14	☺
	DC160-03-13.400F1-	13.4		43	107	60	45	14	☺
	DC160-03-13.500F1-	13.5		43	107	60	45	14	☺
	DC160-03-13.600F1-	13.6		43	107	60	45	14	☺
	DC160-03-13.700F1-	13.7		43	107	60	45	14	☺
	DC160-03-13.800F1-	13.8		43	107	60	45	14	☺
	DC160-03-13.900F1-	13.9		43	107	60	45	14	☺
	DC160-03-14.000F1-	14		43	107	60	45	14	☺
	DC160-03-14.100F1-	14.1		45	115	65	48	16	☺
DC160-03-14.200F1-	14.2		45	115	65	48	16	☺	
DC160-03-14.300F1-	14.3		45	115	65	48	16	☺	
DC160-03-14.400F1-	14.4		45	115	65	48	16	☺	
DC160-03-14.500F1-	14.5		45	115	65	48	16	☺	
DC160-03-14.600F1-	14.6		45	115	65	48	16	☺	
DC160-03-14.700F1-	14.7		45	115	65	48	16	☺	
DC160-03-14.750F1-	14.75		45	115	65	48	16	☺	
DC160-03-14.800F1-	14.8		45	115	65	48	16	☺	
DC160-03-15.000F1-	15		45	115	65	48	16	☺	
DC160-03-15.100F1-	15.1		45	115	65	48	16	☺	
DC160-03-15.200F1-	15.2		45	115	65	48	16	☺	
DC160-03-15.300F1-	15.3		45	115	65	48	16	☺	
DC160-03-15.500F1-	15.5		45	115	65	48	16	☺	
DC160-03-15.600F1-	15.6		45	115	65	48	16	☺	
DC160-03-15.700F1-	15.7		45	115	65	48	16	☺	
DC160-03-15.800F1-	15.8		45	115	65	48	16	☺	
DC160-03-15.900F1-	15.9		45	115	65	48	16	☺	
DC160-03-16.000F1-	16		45	115	65	48	16	☺	
DC160-03-16.100F1-	16.1		51	123	73	48	18	☺	
DC160-03-16.200F1-	16.2		51	123	73	48	18	☺	
DC160-03-16.300F1-	16.3		51	123	73	48	18	☺	
DC160-03-16.400F1-	16.4		51	123	73	48	18	☺	
DC160-03-16.500F1-	16.5		51	123	73	48	18	☺	
DC160-03-16.600F1-	16.6		51	123	73	48	18	☺	
DC160-03-16.700F1-	16.7		51	123	73	48	18	☺	
DC160-03-16.750F1-	16.75		51	123	73	48	18	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET

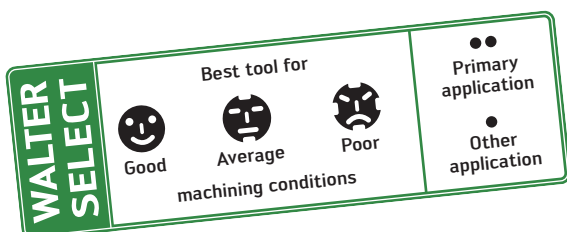
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B 1

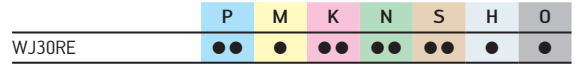
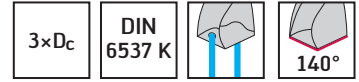
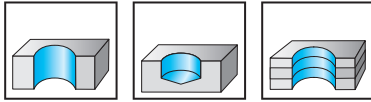
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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	DC160-03-16.800F1-	16,8		51	123	73	48	18	
	DC160-03-17.000F1-	17		51	123	73	48	18	
	DC160-03-17.200F1-	17,2		51	123	73	48	18	
	DC160-03-17.300F1-	17,3		51	123	73	48	18	
	DC160-03-17.500F1-	17,5		51	123	73	48	18	
	DC160-03-17.600F1-	17,6		51	123	73	48	18	
	DC160-03-17.700F1-	17,7		51	123	73	48	18	
	DC160-03-17.800F1-	17,8		51	123	73	48	18	
	DC160-03-18.000F1-	18		51	123	73	48	18	
	DC160-03-18.200F1-	18,2		55	131	79	50	20	
	DC160-03-18.500F1-	18,5		55	131	79	50	20	
	DC160-03-18.700F1-	18,7		55	131	79	50	20	
	DC160-03-18.800F1-	18,8		55	131	79	50	20	
	DC160-03-19.000F1-	19		55	131	79	50	20	
	DC160-03-19.500F1-	19,5		55	131	79	50	20	
	DC160-03-19.700F1-	19,7		55	131	79	50	20	
	DC160-03-19.800F1-	19,8		55	131	79	50	20	
	DC160-03-20.000F1-	20		55	131	79	50	20	

Ordering example for the WJ30ET grade: DC160-03-03.000A1-WJ30ET



Solid carbide drill with coolant-through DC150 Perform



Designation	D _c m7 mm	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30RE
DIN 6535 HE, turned 180° DIN 6535 HB							
DC150-03-03.000D1-	3	14	62	20	36	6	☺
DC150-03-03.300D1-	3,3	14	62	20	36	6	☺
DC150-03-03.400D1-	3,4	14	62	20	36	6	☺
DC150-03-03.500D1-	3,5	14	62	20	36	6	☺
DC150-03-03.700D1-	3,7	14	62	20	36	6	☺
DC150-03-03.800D1-	3,8	17	66	24	36	6	☺
DC150-03-04.000D1-	4	17	66	24	36	6	☺
DC150-03-04.200D1-	4,2	17	66	24	36	6	☺
DC150-03-04.300D1-	4,3	17	66	24	36	6	☺
DC150-03-04.500D1-	4,5	17	66	24	36	6	☺
DC150-03-04.800D1-	4,8	20	66	28	36	6	☺
DC150-03-05.000D1-	5	20	66	28	36	6	☺
DC150-03-05.100D1-	5,1	20	66	28	36	6	☺
DC150-03-05.300D1-	5,3	20	66	28	36	6	☺
DC150-03-05.500D1-	5,5	20	66	28	36	6	☺
DC150-03-06.000D1-	6	20	66	28	36	6	☺
DC150-03-06.500D1-	6,5	24	79	34	36	8	☺
DC150-03-06.700D1-	6,7	24	79	34	36	8	☺
DC150-03-06.800D1-	6,8	24	79	34	36	8	☺
DC150-03-07.000D1-	7	24	79	34	36	8	☺
DC150-03-07.500D1-	7,5	29	79	41	36	8	☺
DC150-03-07.800D1-	7,8	29	79	41	36	8	☺
DC150-03-08.000D1-	8	29	79	41	36	8	☺
DC150-03-08.500D1-	8,5	35	89	47	40	10	☺
DC150-03-08.600D1-	8,6	35	89	47	40	10	☺
DC150-03-08.800D1-	8,8	35	89	47	40	10	☺
DC150-03-09.000D1-	9	35	89	47	40	10	☺
DC150-03-10.000D1-	10	35	89	47	40	10	☺
DC150-03-10.200D1-	10,2	40	102	55	45	12	☺
DC150-03-10.300D1-	10,3	40	102	55	45	12	☺
DC150-03-10.500D1-	10,5	40	102	55	45	12	☺
DC150-03-10.800D1-	10,8	40	102	55	45	12	☺
DC150-03-11.000D1-	11	40	102	55	45	12	☺
DC150-03-11.800D1-	11,8	40	102	55	45	12	☺
DC150-03-12.000D1-	12	40	102	55	45	12	☺
DC150-03-12.200D1-	12,2	43	107	60	45	14	☺
DC150-03-12.500D1-	12,5	43	107	60	45	14	☺
DC150-03-13.000D1-	13	43	107	60	45	14	☺
DC150-03-14.000D1-	14	43	107	60	45	14	☺
DC150-03-15.000D1-	15	45	115	65	48	16	☺
DC150-03-15.500D1-	15,5	45	115	65	48	16	☺
DC150-03-16.000D1-	16	45	115	65	48	16	☺
DC150-03-16.500D1-	16,5	51	123	73	48	18	☺
DC150-03-17.000D1-	17	51	123	73	48	18	☺
DC150-03-17.500D1-	17,5	51	123	73	48	18	☺
DC150-03-18.000D1-	18	51	123	73	48	18	☺
DC150-03-19.000D1-	19	55	131	79	50	20	☺
DC150-03-20.000D1-	20	55	131	79	50	20	☺

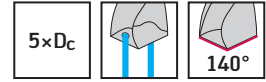
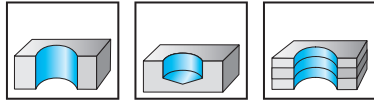
Ordering example for the WJ30RE grade: DC150-03-03.000D1-WJ30RE

B 1

Solid carbide micro drill with coolant-through DB133 Supreme



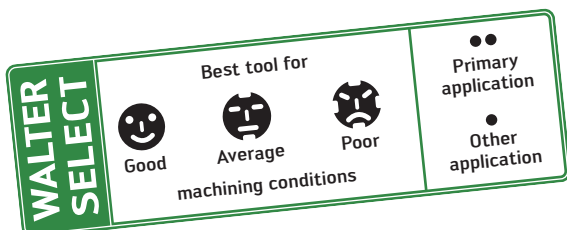
B 1



	P	M	K	N	S	H	O
WJ30EL	●	●	●	●	●	●	●

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EL
Shank DIN 6535 HA 	DB133-05-00.700A1-	0,7		4,9	48	6	35	3	●
	DB133-05-00.750A1-	0,75		5,8	48	7	34	3	●
	DB133-05-00.794A1-	0,794	1/32"	5,8	48	7	34	3	●
	DB133-05-00.800A1-	0,8		5,8	48	7	34	3	●
	DB133-05-00.850A1-	0,85		6,6	50	8	35	3	●
	DB133-05-00.900A1-	0,9		6,6	50	8	35	3	●
	DB133-05-00.950A1-	0,95		7,5	50	9	34	3	●
	DB133-05-01.000A1-	1		7,5	50	9	34	3	●
	DB133-05-01.050A1-	1,05		7	51	9	36	3	●
	DB133-05-01.100A1-	1,1		7	51	9	36	3	●
	DB133-05-01.150A1-	1,15		8	51	10	35	3	●
	DB133-05-01.191A1-	1,191	3/64"	8	51	10	35	3	●
	DB133-05-01.200A1-	1,2		8	51	10	35	3	●
	DB133-05-01.250A1-	1,25		9	51	11	34	3	●
	DB133-05-01.300A1-	1,3		9	53	11	36	3	●
	DB133-05-01.350A1-	1,35		9	53	12	35	3	●
	DB133-05-01.400A1-	1,4		9	53	12	35	3	●
	DB133-05-01.450A1-	1,45		10	53	13	34	3	●
	DB133-05-01.500A1-	1,5		10	53	13	34	3	●
	DB133-05-01.550A1-	1,55		11	54	14	35	3	●
	DB133-05-01.588A1-	1,588	1/16"	11	54	14	35	3	●
	DB133-05-01.600A1-	1,6		11	54	14	35	3	●
	DB133-05-01.650A1-	1,65		11	54	14	35	3	●
	DB133-05-01.700A1-	1,7		11	54	14	35	3	●
	DB133-05-01.750A1-	1,75		12	54	15	34	3	●
	DB133-05-01.800A1-	1,8		12	54	15	34	3	●
	DB133-05-01.850A1-	1,85		13	57	16	36	3	●
	DB133-05-01.900A1-	1,9		13	57	16	36	3	●
	DB133-05-01.950A1-	1,95		14	57	17	35	3	●
	DB133-05-01.984A1-	1,984	5/64"	14	57	17	35	3	●

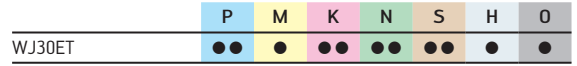
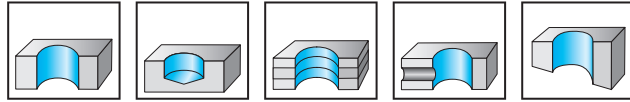
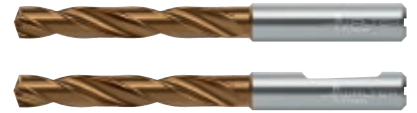
Ordering example for the WJ30EL grade: DB133-05-00.700A1-WJ30EL



Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
DC160-05-03.000A1-	3		23	66	28	36	6	●
DC160-05-03.100A1-	3,1		23	66	28	36	6	●
DC160-05-03.175A1-	3,175	1/8"	23	66	28	36	6	●
DC160-05-03.200A1-	3,2		23	66	28	36	6	●
DC160-05-03.250A1-	3,25		23	66	28	36	6	●
DC160-05-03.300A1-	3,3		23	66	28	36	6	●
DC160-05-03.400A1-	3,4		23	66	28	36	6	●
DC160-05-03.500A1-	3,5		23	66	28	36	6	●
DC160-05-03.572A1-	3,572	9/64"	23	66	28	36	6	●
DC160-05-03.600A1-	3,6		23	66	28	36	6	●
DC160-05-03.650A1-	3,65		23	66	28	36	6	●
DC160-05-03.700A1-	3,7		23	66	28	36	6	●
DC160-05-03.800A1-	3,8		29	74	36	36	6	●
DC160-05-03.900A1-	3,9		29	74	36	36	6	●
DC160-05-03.969A1-	3,969	5/32"	29	74	36	36	6	●
DC160-05-04.000A1-	4		29	74	36	36	6	●
DC160-05-04.100A1-	4,1		29	74	36	36	6	●
DC160-05-04.200A1-	4,2		29	74	36	36	6	●
DC160-05-04.300A1-	4,3		29	74	36	36	6	●
DC160-05-04.366A1-	4,366	11/64"	29	74	36	36	6	●
DC160-05-04.400A1-	4,4		29	74	36	36	6	●
DC160-05-04.500A1-	4,5		29	74	36	36	6	●
DC160-05-04.600A1-	4,6		29	74	36	36	6	●
DC160-05-04.650A1-	4,65		29	74	36	36	6	●
DC160-05-04.700A1-	4,7		29	74	36	36	6	●
DC160-05-04.763A1-	4,763	3/16"	35	82	44	36	6	●
DC160-05-04.800A1-	4,8		35	82	44	36	6	●
DC160-05-04.900A1-	4,9		35	82	44	36	6	●
DC160-05-05.000A1-	5		35	82	44	36	6	●
DC160-05-05.100A1-	5,1		35	82	44	36	6	●
DC160-05-05.159A1-	5,159	13/64"	35	82	44	36	6	●
DC160-05-05.200A1-	5,2		35	82	44	36	6	●
DC160-05-05.300A1-	5,3		35	82	44	36	6	●
DC160-05-05.400A1-	5,4		35	82	44	36	6	●
DC160-05-05.500A1-	5,5		35	82	44	36	6	●
DC160-05-05.550A1-	5,55		35	82	44	36	6	●
DC160-05-05.556A1-	5,556	7/32"	35	82	44	36	6	●
DC160-05-05.600A1-	5,6		35	82	44	36	6	●
DC160-05-05.700A1-	5,7		35	82	44	36	6	●
DC160-05-05.800A1-	5,8		35	82	44	36	6	●
DC160-05-05.900A1-	5,9		35	82	44	36	6	●
DC160-05-05.953A1-	5,953	15/64"	35	82	44	36	6	●
DC160-05-06.000A1-	6		35	82	44	36	6	●
DC160-05-06.100A1-	6,1		43	91	53	36	8	●
DC160-05-06.200A1-	6,2		43	91	53	36	8	●
DC160-05-06.300A1-	6,3		43	91	53	36	8	●
DC160-05-06.350A1-	6,35	1/4"	43	91	53	36	8	●

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

Continued

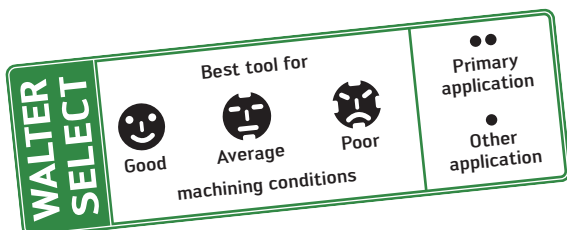
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-06.400A1-	6,4		43	91	53	36	8	☺
	DC160-05-06.500A1-	6,5		43	91	53	36	8	☺
	DC160-05-06.600A1-	6,6		43	91	53	36	8	☺
	DC160-05-06.700A1-	6,7		43	91	53	36	8	☺
	DC160-05-06.747A1-	6,747	17/64"	43	91	53	36	8	☺
	DC160-05-06.800A1-	6,8		43	91	53	36	8	☺
	DC160-05-06.900A1-	6,9		43	91	53	36	8	☺
	DC160-05-07.000A1-	7		43	91	53	36	8	☺
	DC160-05-07.100A1-	7,1		43	91	53	36	8	☺
	DC160-05-07.144A1-	7,144	9/32"	43	91	53	36	8	☺
	DC160-05-07.200A1-	7,2		43	91	53	36	8	☺
	DC160-05-07.300A1-	7,3		43	91	53	36	8	☺
	DC160-05-07.400A1-	7,4		43	91	53	36	8	☺
	DC160-05-07.500A1-	7,5		43	91	53	36	8	☺
	DC160-05-07.541A1-	7,541	19/64"	43	91	53	36	8	☺
	DC160-05-07.550A1-	7,55		43	91	53	36	8	☺
	DC160-05-07.600A1-	7,6		43	91	53	36	8	☺
	DC160-05-07.700A1-	7,7		43	91	53	36	8	☺
	DC160-05-07.800A1-	7,8		43	91	53	36	8	☺
	DC160-05-07.900A1-	7,9		43	91	53	36	8	☺
	DC160-05-07.938A1-	7,938	5/16"	43	91	53	36	8	☺
	DC160-05-08.000A1-	8		43	91	53	36	8	☺
	DC160-05-08.100A1-	8,1		49	103	61	40	10	☺
	DC160-05-08.200A1-	8,2		49	103	61	40	10	☺
	DC160-05-08.300A1-	8,3		49	103	61	40	10	☺
	DC160-05-08.334A1-	8,334	21/64"	49	103	61	40	10	☺
	DC160-05-08.400A1-	8,4		49	103	61	40	10	☺
	DC160-05-08.500A1-	8,5		49	103	61	40	10	☺
	DC160-05-08.600A1-	8,6		49	103	61	40	10	☺
	DC160-05-08.700A1-	8,7		49	103	61	40	10	☺
	DC160-05-08.731A1-	8,731	11/32"	49	103	61	40	10	☺
	DC160-05-08.800A1-	8,8		49	103	61	40	10	☺
	DC160-05-08.900A1-	8,9		49	103	61	40	10	☺
DC160-05-09.000A1-	9		49	103	61	40	10	☺	
DC160-05-09.100A1-	9,1		49	103	61	40	10	☺	
DC160-05-09.128A1-	9,128	23/64"	49	103	61	40	10	☺	
DC160-05-09.200A1-	9,2		49	103	61	40	10	☺	
DC160-05-09.300A1-	9,3		49	103	61	40	10	☺	
DC160-05-09.400A1-	9,4		49	103	61	40	10	☺	
DC160-05-09.500A1-	9,5		49	103	61	40	10	☺	
DC160-05-09.525A1-	9,525	3/8"	49	103	61	40	10	☺	
DC160-05-09.550A1-	9,55		49	103	61	40	10	☺	
DC160-05-09.600A1-	9,6		49	103	61	40	10	☺	
DC160-05-09.700A1-	9,7		49	103	61	40	10	☺	
DC160-05-09.800A1-	9,8		49	103	61	40	10	☺	
DC160-05-09.900A1-	9,9		49	103	61	40	10	☺	
DC160-05-09.922A1-	9,922	25/64"	49	103	61	40	10	☺	
DC160-05-10.000A1-	10		49	103	61	40	10	☺	
DC160-05-10.100A1-	10,1		56	118	71	45	12	☺	
DC160-05-10.200A1-	10,2		56	118	71	45	12	☺	
DC160-05-10.300A1-	10,3		56	118	71	45	12	☺	
DC160-05-10.319A1-	10,319	13/32"	56	118	71	45	12	☺	
DC160-05-10.400A1-	10,4		56	118	71	45	12	☺	
DC160-05-10.500A1-	10,5		56	118	71	45	12	☺	
DC160-05-10.600A1-	10,6		56	118	71	45	12	☺	
DC160-05-10.700A1-	10,7		56	118	71	45	12	☺	
DC160-05-10.716A1-	10,716	27/64"	56	118	71	45	12	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-10.800A1-	10,8		56	118	71	45	12	☺
	DC160-05-10.900A1-	10,9		56	118	71	45	12	☺
	DC160-05-11.000A1-	11		56	118	71	45	12	☺
	DC160-05-11.100A1-	11,1		56	118	71	45	12	☺
	DC160-05-11.113A1-	11,113	7/16"	56	118	71	45	12	☺
	DC160-05-11.200A1-	11,2		56	118	71	45	12	☺
	DC160-05-11.300A1-	11,3		56	118	71	45	12	☺
	DC160-05-11.400A1-	11,4		56	118	71	45	12	☺
	DC160-05-11.500A1-	11,5		56	118	71	45	12	☺
	DC160-05-11.509A1-	11,509	29/64"	56	118	71	45	12	☺
	DC160-05-11.550A1-	11,55		56	118	71	45	12	☺
	DC160-05-11.600A1-	11,6		56	118	71	45	12	☺
	DC160-05-11.700A1-	11,7		56	118	71	45	12	☺
	DC160-05-11.800A1-	11,8		56	118	71	45	12	☺
	DC160-05-11.900A1-	11,9		56	118	71	45	12	☺
	DC160-05-11.906A1-	11,906	15/32"	56	118	71	45	12	☺
	DC160-05-12.000A1-	12		56	118	71	45	12	☺
	DC160-05-12.100A1-	12,1		60	124	77	45	14	☺
	DC160-05-12.200A1-	12,2		60	124	77	45	14	☺
	DC160-05-12.250A1-	12,25		60	124	77	45	14	☺
	DC160-05-12.300A1-	12,3		60	124	77	45	14	☺
	DC160-05-12.303A1-	12,303	31/64"	60	124	77	45	14	☺
	DC160-05-12.400A1-	12,4		60	124	77	45	14	☺
	DC160-05-12.500A1-	12,5		60	124	77	45	14	☺
	DC160-05-12.600A1-	12,6		60	124	77	45	14	☺
	DC160-05-12.700A1-	12,7	1/2"	60	124	77	45	14	☺
	DC160-05-12.750A1-	12,75		60	124	77	45	14	☺
	DC160-05-12.800A1-	12,8		60	124	77	45	14	☺
	DC160-05-12.900A1-	12,9		60	124	77	45	14	☺
	DC160-05-13.000A1-	13		60	124	77	45	14	☺
	DC160-05-13.100A1-	13,1		60	124	77	45	14	☺
	DC160-05-13.200A1-	13,2		60	124	77	45	14	☺
	DC160-05-13.300A1-	13,3		60	124	77	45	14	☺
	DC160-05-13.400A1-	13,4		60	124	77	45	14	☺
	DC160-05-13.494A1-	13,494	17/32"	60	124	77	45	14	☺
DC160-05-13.500A1-	13,5		60	124	77	45	14	☺	
DC160-05-13.600A1-	13,6		60	124	77	45	14	☺	
DC160-05-13.700A1-	13,7		60	124	77	45	14	☺	
DC160-05-13.800A1-	13,8		60	124	77	45	14	☺	
DC160-05-13.900A1-	13,9		60	124	77	45	14	☺	
DC160-05-14.000A1-	14		60	124	77	45	14	☺	
DC160-05-14.100A1-	14,1		63	133	83	48	16	☺	
DC160-05-14.200A1-	14,2		63	133	83	48	16	☺	
DC160-05-14.288A1-	14,288	9/16"	63	133	83	48	16	☺	
DC160-05-14.300A1-	14,3		63	133	83	48	16	☺	
DC160-05-14.400A1-	14,4		63	133	83	48	16	☺	
DC160-05-14.500A1-	14,5		63	133	83	48	16	☺	
DC160-05-14.600A1-	14,6		63	133	83	48	16	☺	
DC160-05-14.700A1-	14,7		63	133	83	48	16	☺	
DC160-05-14.750A1-	14,75		63	133	83	48	16	☺	
DC160-05-14.800A1-	14,8		63	133	83	48	16	☺	
DC160-05-14.900A1-	14,9		63	133	83	48	16	☺	
DC160-05-15.000A1-	15		63	133	83	48	16	☺	
DC160-05-15.100A1-	15,1		63	133	83	48	16	☺	
DC160-05-15.200A1-	15,2		63	133	83	48	16	☺	
DC160-05-15.300A1-	15,3		63	133	83	48	16	☺	
DC160-05-15.400A1-	15,4		63	133	83	48	16	☺	
DC160-05-15.500A1-	15,5		63	133	83	48	16	☺	
DC160-05-15.600A1-	15,6		63	133	83	48	16	☺	
DC160-05-15.700A1-	15,7		63	133	83	48	16	☺	
DC160-05-15.800A1-	15,8		63	133	83	48	16	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

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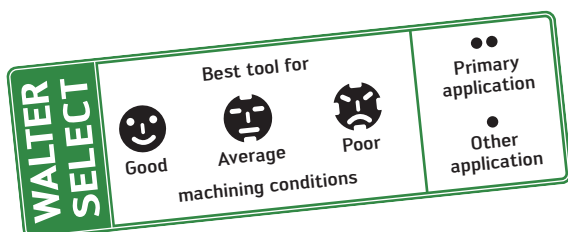
B 1

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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-15.875A1-	15,875	5/8"	63	133	83	48	16	☺
	DC160-05-15.900A1-	15,9		63	133	83	48	16	☺
	DC160-05-16.000A1-	16		63	133	83	48	16	☺
	DC160-05-16.100A1-	16,1		71	143	93	48	18	☺
	DC160-05-16.200A1-	16,2		71	143	93	48	18	☺
	DC160-05-16.300A1-	16,3		71	143	93	48	18	☺
	DC160-05-16.400A1-	16,4		71	143	93	48	18	☺
	DC160-05-16.500A1-	16,5		71	143	93	48	18	☺
	DC160-05-16.600A1-	16,6		71	143	93	48	18	☺
	DC160-05-16.700A1-	16,7		71	143	93	48	18	☺
	DC160-05-16.750A1-	16,75		71	143	93	48	18	☺
	DC160-05-16.800A1-	16,8		71	143	93	48	18	☺
	DC160-05-16.900A1-	16,9		71	143	93	48	18	☺
	DC160-05-17.000A1-	17		71	143	93	48	18	☺
	DC160-05-17.100A1-	17,1		71	143	93	48	18	☺
	DC160-05-17.200A1-	17,2		71	143	93	48	18	☺
	DC160-05-17.300A1-	17,3		71	143	93	48	18	☺
	DC160-05-17.400A1-	17,4		71	143	93	48	18	☺
	DC160-05-17.500A1-	17,5		71	143	93	48	18	☺
	DC160-05-17.600A1-	17,6		71	143	93	48	18	☺
	DC160-05-17.700A1-	17,7		71	143	93	48	18	☺
	DC160-05-17.800A1-	17,8		71	143	93	48	18	☺
	DC160-05-17.900A1-	17,9		71	143	93	48	18	☺
	DC160-05-18.000A1-	18		71	143	93	48	18	☺
	DC160-05-18.100A1-	18,1		77	153	101	50	20	☺
DC160-05-18.200A1-	18,2		77	153	101	50	20	☺	
DC160-05-18.300A1-	18,3		77	153	101	50	20	☺	
DC160-05-18.400A1-	18,4		77	153	101	50	20	☺	
DC160-05-18.500A1-	18,5		77	153	101	50	20	☺	
DC160-05-18.600A1-	18,6		77	153	101	50	20	☺	
DC160-05-18.700A1-	18,7		77	153	101	50	20	☺	
DC160-05-18.800A1-	18,8		77	153	101	50	20	☺	
DC160-05-18.900A1-	18,9		77	153	101	50	20	☺	
DC160-05-19.000A1-	19		77	153	101	50	20	☺	
DC160-05-19.050A1-	19,05	3/4"	77	153	101	50	20	☺	
DC160-05-19.100A1-	19,1		77	153	101	50	20	☺	
DC160-05-19.200A1-	19,2		77	153	101	50	20	☺	
DC160-05-19.300A1-	19,3		77	153	101	50	20	☺	
DC160-05-19.400A1-	19,4		77	153	101	50	20	☺	
DC160-05-19.500A1-	19,5		77	153	101	50	20	☺	
DC160-05-19.600A1-	19,6		77	153	101	50	20	☺	
DC160-05-19.700A1-	19,7		77	153	101	50	20	☺	
DC160-05-19.800A1-	19,8		77	153	101	50	20	☺	
DC160-05-19.900A1-	19,9		77	153	101	50	20	☺	
DC160-05-20.000A1-	20		77	153	101	50	20	☺	
DC160-05-20.500A1-	20,5		86	166	108	56	25	☺	
DC160-05-21.000A1-	21		86	166	108	56	25	☺	
DC160-05-21.500A1-	21,5		86	166	108	56	25	☺	
DC160-05-22.000A1-	22		86	166	108	56	25	☺	
DC160-05-22.500A1-	22,5		91	173	115	56	25	☺	
DC160-05-23.000A1-	23		91	173	115	56	25	☺	
DC160-05-23.500A1-	23,5		91	173	115	56	25	☺	
DC160-05-24.000A1-	24		91	173	115	56	25	☺	
DC160-05-24.500A1-	24,5		97	180	122	56	25	☺	
DC160-05-25.000A1-	25		97	180	122	56	25	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

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Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-05-03.000F1-	3		23	66	28	36	6	☺
	DC160-05-03.100F1-	3,1		23	66	28	36	6	☺
	DC160-05-03.200F1-	3,2		23	66	28	36	6	☺
	DC160-05-03.250F1-	3,25		23	66	28	36	6	☺
	DC160-05-03.300F1-	3,3		23	66	28	36	6	☺
	DC160-05-03.400F1-	3,4		23	66	28	36	6	☺
	DC160-05-03.500F1-	3,5		23	66	28	36	6	☺
	DC160-05-03.600F1-	3,6		23	66	28	36	6	☺
	DC160-05-03.650F1-	3,65		23	66	28	36	6	☺
	DC160-05-03.700F1-	3,7		23	66	28	36	6	☺
	DC160-05-03.800F1-	3,8		29	74	36	36	6	☺
	DC160-05-03.900F1-	3,9		29	74	36	36	6	☺
	DC160-05-04.000F1-	4		29	74	36	36	6	☺
	DC160-05-04.100F1-	4,1		29	74	36	36	6	☺
	DC160-05-04.200F1-	4,2		29	74	36	36	6	☺
	DC160-05-04.300F1-	4,3		29	74	36	36	6	☺
	DC160-05-04.400F1-	4,4		29	74	36	36	6	☺
	DC160-05-04.500F1-	4,5		29	74	36	36	6	☺
	DC160-05-04.600F1-	4,6		29	74	36	36	6	☺
	DC160-05-04.650F1-	4,65		29	74	36	36	6	☺
	DC160-05-04.700F1-	4,7		29	74	36	36	6	☺
	DC160-05-04.800F1-	4,8		35	82	44	36	6	☺
	DC160-05-04.900F1-	4,9		35	82	44	36	6	☺
	DC160-05-05.000F1-	5		35	82	44	36	6	☺
	DC160-05-05.100F1-	5,1		35	82	44	36	6	☺
	DC160-05-05.200F1-	5,2		35	82	44	36	6	☺
	DC160-05-05.300F1-	5,3		35	82	44	36	6	☺
	DC160-05-05.400F1-	5,4		35	82	44	36	6	☺
	DC160-05-05.500F1-	5,5		35	82	44	36	6	☺
	DC160-05-05.550F1-	5,55		35	82	44	36	6	☺
	DC160-05-05.600F1-	5,6		35	82	44	36	6	☺
	DC160-05-05.700F1-	5,7		35	82	44	36	6	☺
	DC160-05-05.800F1-	5,8		35	82	44	36	6	☺
	DC160-05-05.900F1-	5,9		35	82	44	36	6	☺
	DC160-05-06.000F1-	6		35	82	44	36	6	☺
DC160-05-06.100F1-	6,1		43	91	53	36	8	☺	
DC160-05-06.200F1-	6,2		43	91	53	36	8	☺	
DC160-05-06.300F1-	6,3		43	91	53	36	8	☺	
DC160-05-06.400F1-	6,4		43	91	53	36	8	☺	
DC160-05-06.500F1-	6,5		43	91	53	36	8	☺	
DC160-05-06.600F1-	6,6		43	91	53	36	8	☺	
DC160-05-06.700F1-	6,7		43	91	53	36	8	☺	
DC160-05-06.800F1-	6,8		43	91	53	36	8	☺	
DC160-05-06.900F1-	6,9		43	91	53	36	8	☺	
DC160-05-07.000F1-	7		43	91	53	36	8	☺	
DC160-05-07.100F1-	7,1		43	91	53	36	8	☺	
DC160-05-07.200F1-	7,2		43	91	53	36	8	☺	
DC160-05-07.300F1-	7,3		43	91	53	36	8	☺	
DC160-05-07.400F1-	7,4		43	91	53	36	8	☺	
DC160-05-07.500F1-	7,5		43	91	53	36	8	☺	
DC160-05-07.550F1-	7,55		43	91	53	36	8	☺	
DC160-05-07.600F1-	7,6		43	91	53	36	8	☺	
DC160-05-07.700F1-	7,7		43	91	53	36	8	☺	
DC160-05-07.800F1-	7,8		43	91	53	36	8	☺	
DC160-05-07.900F1-	7,9		43	91	53	36	8	☺	
DC160-05-08.000F1-	8		43	91	53	36	8	☺	
DC160-05-08.100F1-	8,1		49	103	61	40	10	☺	
DC160-05-08.200F1-	8,2		49	103	61	40	10	☺	
DC160-05-08.300F1-	8,3		49	103	61	40	10	☺	
DC160-05-08.400F1-	8,4		49	103	61	40	10	☺	
DC160-05-08.500F1-	8,5		49	103	61	40	10	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

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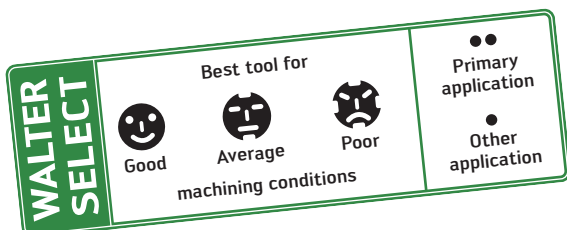
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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	Shank DIN 6535 HE								
	DC160-05-08.600F1-	8,6		49	103	61	40	10	☺
	DC160-05-08.700F1-	8,7		49	103	61	40	10	☺
	DC160-05-08.800F1-	8,8		49	103	61	40	10	☺
	DC160-05-08.900F1-	8,9		49	103	61	40	10	☺
	DC160-05-09.000F1-	9		49	103	61	40	10	☺
	DC160-05-09.100F1-	9,1		49	103	61	40	10	☺
	DC160-05-09.200F1-	9,2		49	103	61	40	10	☺
	DC160-05-09.300F1-	9,3		49	103	61	40	10	☺
	DC160-05-09.400F1-	9,4		49	103	61	40	10	☺
	DC160-05-09.500F1-	9,5		49	103	61	40	10	☺
	DC160-05-09.550F1-	9,55		49	103	61	40	10	☺
	DC160-05-09.600F1-	9,6		49	103	61	40	10	☺
	DC160-05-09.700F1-	9,7		49	103	61	40	10	☺
	DC160-05-09.800F1-	9,8		49	103	61	40	10	☺
	DC160-05-09.900F1-	9,9		49	103	61	40	10	☺
	DC160-05-10.000F1-	10		49	103	61	40	10	☺
	DC160-05-10.100F1-	10,1		56	118	71	45	12	☺
	DC160-05-10.200F1-	10,2		56	118	71	45	12	☺
	DC160-05-10.300F1-	10,3		56	118	71	45	12	☺
	DC160-05-10.400F1-	10,4		56	118	71	45	12	☺
	DC160-05-10.500F1-	10,5		56	118	71	45	12	☺
	DC160-05-10.600F1-	10,6		56	118	71	45	12	☺
	DC160-05-10.700F1-	10,7		56	118	71	45	12	☺
	DC160-05-10.800F1-	10,8		56	118	71	45	12	☺
	DC160-05-10.900F1-	10,9		56	118	71	45	12	☺
	DC160-05-11.000F1-	11		56	118	71	45	12	☺
	DC160-05-11.100F1-	11,1		56	118	71	45	12	☺
	DC160-05-11.200F1-	11,2		56	118	71	45	12	☺
	DC160-05-11.300F1-	11,3		56	118	71	45	12	☺
	DC160-05-11.400F1-	11,4		56	118	71	45	12	☺
	DC160-05-11.500F1-	11,5		56	118	71	45	12	☺
	DC160-05-11.550F1-	11,55		56	118	71	45	12	☺
DC160-05-11.600F1-	11,6		56	118	71	45	12	☺	
DC160-05-11.700F1-	11,7		56	118	71	45	12	☺	
DC160-05-11.800F1-	11,8		56	118	71	45	12	☺	
DC160-05-11.900F1-	11,9		56	118	71	45	12	☺	
DC160-05-12.000F1-	12		56	118	71	45	12	☺	
DC160-05-12.100F1-	12,1		60	124	77	45	14	☺	
DC160-05-12.200F1-	12,2		60	124	77	45	14	☺	
DC160-05-12.250F1-	12,25		60	124	77	45	14	☺	
DC160-05-12.300F1-	12,3		60	124	77	45	14	☺	
DC160-05-12.400F1-	12,4		60	124	77	45	14	☺	
DC160-05-12.500F1-	12,5		60	124	77	45	14	☺	
DC160-05-12.600F1-	12,6		60	124	77	45	14	☺	
DC160-05-12.700F1-	12,7	1/2"	60	124	77	45	14	☺	
DC160-05-12.750F1-	12,75		60	124	77	45	14	☺	
DC160-05-12.800F1-	12,8		60	124	77	45	14	☺	
DC160-05-12.900F1-	12,9		60	124	77	45	14	☺	
DC160-05-13.000F1-	13		60	124	77	45	14	☺	
DC160-05-13.100F1-	13,1		60	124	77	45	14	☺	
DC160-05-13.200F1-	13,2		60	124	77	45	14	☺	
DC160-05-13.300F1-	13,3		60	124	77	45	14	☺	
DC160-05-13.400F1-	13,4		60	124	77	45	14	☺	
DC160-05-13.500F1-	13,5		60	124	77	45	14	☺	
DC160-05-13.600F1-	13,6		60	124	77	45	14	☺	
DC160-05-13.700F1-	13,7		60	124	77	45	14	☺	
DC160-05-13.800F1-	13,8		60	124	77	45	14	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-05-13.900F1-	13,9		60	124	77	45	14	☺
	DC160-05-14.000F1-	14		60	124	77	45	14	☺
	DC160-05-14.100F1-	14,1		63	133	83	48	16	☺
	DC160-05-14.200F1-	14,2		63	133	83	48	16	☺
	DC160-05-14.300F1-	14,3		63	133	83	48	16	☺
	DC160-05-14.400F1-	14,4		63	133	83	48	16	☺
	DC160-05-14.500F1-	14,5		63	133	83	48	16	☺
	DC160-05-14.600F1-	14,6		63	133	83	48	16	☺
	DC160-05-14.700F1-	14,7		63	133	83	48	16	☺
	DC160-05-14.750F1-	14,75		63	133	83	48	16	☺
	DC160-05-14.800F1-	14,8		63	133	83	48	16	☺
	DC160-05-14.900F1-	14,9		63	133	83	48	16	☺
	DC160-05-15.000F1-	15		63	133	83	48	16	☺
	DC160-05-15.100F1-	15,1		63	133	83	48	16	☺
	DC160-05-15.200F1-	15,2		63	133	83	48	16	☺
	DC160-05-15.300F1-	15,3		63	133	83	48	16	☺
	DC160-05-15.400F1-	15,4		63	133	83	48	16	☺
	DC160-05-15.500F1-	15,5		63	133	83	48	16	☺
	DC160-05-15.600F1-	15,6		63	133	83	48	16	☺
	DC160-05-15.700F1-	15,7		63	133	83	48	16	☺
	DC160-05-15.800F1-	15,8		63	133	83	48	16	☺
	DC160-05-15.900F1-	15,9		63	133	83	48	16	☺
	DC160-05-16.000F1-	16		63	133	83	48	16	☺
	DC160-05-16.100F1-	16,1		71	143	93	48	18	☺
	DC160-05-16.200F1-	16,2		71	143	93	48	18	☺
	DC160-05-16.300F1-	16,3		71	143	93	48	18	☺
	DC160-05-16.400F1-	16,4		71	143	93	48	18	☺
	DC160-05-16.500F1-	16,5		71	143	93	48	18	☺
	DC160-05-16.600F1-	16,6		71	143	93	48	18	☺
	DC160-05-16.700F1-	16,7		71	143	93	48	18	☺
	DC160-05-16.750F1-	16,75		71	143	93	48	18	☺
	DC160-05-16.800F1-	16,8		71	143	93	48	18	☺
	DC160-05-16.900F1-	16,9		71	143	93	48	18	☺
	DC160-05-17.000F1-	17		71	143	93	48	18	☺
	DC160-05-17.100F1-	17,1		71	143	93	48	18	☺
DC160-05-17.200F1-	17,2		71	143	93	48	18	☺	
DC160-05-17.300F1-	17,3		71	143	93	48	18	☺	
DC160-05-17.400F1-	17,4		71	143	93	48	18	☺	
DC160-05-17.500F1-	17,5		71	143	93	48	18	☺	
DC160-05-17.600F1-	17,6		71	143	93	48	18	☺	
DC160-05-17.700F1-	17,7		71	143	93	48	18	☺	
DC160-05-17.800F1-	17,8		71	143	93	48	18	☺	
DC160-05-17.900F1-	17,9		71	143	93	48	18	☺	
DC160-05-18.000F1-	18		71	143	93	48	18	☺	
DC160-05-18.100F1-	18,1		77	153	101	50	20	☺	
DC160-05-18.200F1-	18,2		77	153	101	50	20	☺	
DC160-05-18.300F1-	18,3		77	153	101	50	20	☺	
DC160-05-18.400F1-	18,4		77	153	101	50	20	☺	
DC160-05-18.500F1-	18,5		77	153	101	50	20	☺	
DC160-05-18.600F1-	18,6		77	153	101	50	20	☺	
DC160-05-18.700F1-	18,7		77	153	101	50	20	☺	
DC160-05-18.800F1-	18,8		77	153	101	50	20	☺	
DC160-05-18.900F1-	18,9		77	153	101	50	20	☺	
DC160-05-19.000F1-	19		77	153	101	50	20	☺	
DC160-05-19.100F1-	19,1		77	153	101	50	20	☺	
DC160-05-19.200F1-	19,2		77	153	101	50	20	☺	
DC160-05-19.300F1-	19,3		77	153	101	50	20	☺	
DC160-05-19.400F1-	19,4		77	153	101	50	20	☺	
DC160-05-19.500F1-	19,5		77	153	101	50	20	☺	
DC160-05-19.600F1-	19,6		77	153	101	50	20	☺	
DC160-05-19.700F1-	19,7		77	153	101	50	20	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET

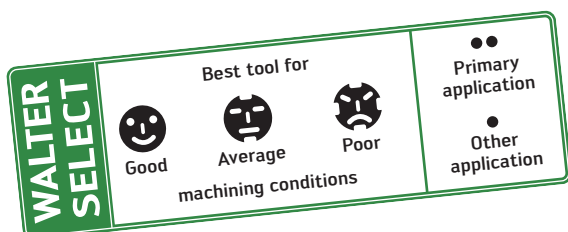
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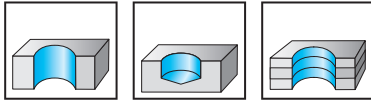
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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	DC160-05-19.800F1-	19,8		77	153	101	50	20	☺
	DC160-05-19.900F1-	19,9		77	153	101	50	20	☺
	DC160-05-20.000F1-	20		77	153	101	50	20	☺
	DC160-05-20.500F1-	20,5		86	166	108	56	25	☺
	DC160-05-21.000F1-	21		86	166	108	56	25	☺
	DC160-05-21.500F1-	21,5		86	166	108	56	25	☺
	DC160-05-22.000F1-	22		86	166	108	56	25	☺
	DC160-05-22.500F1-	22,5		91	173	115	56	25	☺
	DC160-05-23.000F1-	23		91	173	115	56	25	☺
	DC160-05-23.500F1-	23,5		91	173	115	56	25	☺
	DC160-05-24.000F1-	24		91	173	115	56	25	☺
	DC160-05-24.500F1-	24,5		97	180	122	56	25	☺
	DC160-05-25.000F1-	25		97	180	122	56	25	☺

Ordering example for the WJ30ET grade: DC160-05-03.000A1-WJ30ET



Solid carbide drill with coolant-through DC150 Perform



	Designation	D _c m7 mm	D _c Inch./no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30RE
DIN 6535 HE, turned 180° DIN 6535 HB 	DC150-05-03.000D1-	3		23	66	28	36	6	
	DC150-05-03.100D1-	3,1		23	66	28	36	6	
	DC150-05-03.200D1-	3,2		23	66	28	36	6	
	DC150-05-03.300D1-	3,3		23	66	28	36	6	
	DC150-05-03.400D1-	3,4		23	66	28	36	6	
	DC150-05-03.500D1-	3,5		23	66	28	36	6	
	DC150-05-03.600D1-	3,6		23	66	28	36	6	
	DC150-05-03.700D1-	3,7		23	66	28	36	6	
	DC150-05-03.800D1-	3,8		29	74	36	36	6	
	DC150-05-03.900D1-	3,9		29	74	36	36	6	
	DC150-05-04.000D1-	4		29	74	36	36	6	
	DC150-05-04.100D1-	4,1		29	74	36	36	6	
	DC150-05-04.200D1-	4,2		29	74	36	36	6	
	DC150-05-04.300D1-	4,3		29	74	36	36	6	
	DC150-05-04.400D1-	4,4		29	74	36	36	6	
	DC150-05-04.500D1-	4,5		29	74	36	36	6	
	DC150-05-04.600D1-	4,6		29	74	36	36	6	
	DC150-05-04.650D1-	4,65		29	74	36	36	6	
	DC150-05-04.700D1-	4,7		29	74	36	36	6	
	DC150-05-04.800D1-	4,8		35	82	44	36	6	
	DC150-05-04.900D1-	4,9		35	82	44	36	6	
	DC150-05-05.000D1-	5		35	82	44	36	6	
	DC150-05-05.100D1-	5,1		35	82	44	36	6	
	DC150-05-05.200D1-	5,2		35	82	44	36	6	
	DC150-05-05.300D1-	5,3		35	82	44	36	6	
	DC150-05-05.400D1-	5,4		35	82	44	36	6	
	DC150-05-05.500D1-	5,5		35	82	44	36	6	
	DC150-05-05.550D1-	5,55		35	82	44	36	6	
	DC150-05-05.600D1-	5,6		35	82	44	36	6	
	DC150-05-05.700D1-	5,7		35	82	44	36	6	
	DC150-05-05.800D1-	5,8		35	82	44	36	6	
	DC150-05-05.900D1-	5,9		35	82	44	36	6	
	DC150-05-06.000D1-	6		35	82	44	36	6	
	DC150-05-06.100D1-	6,1		43	91	53	36	8	
DC150-05-06.200D1-	6,2		43	91	53	36	8		
DC150-05-06.300D1-	6,2		43	91	53	36	8		
DC150-05-06.400D1-	6,4		43	91	53	36	8		
DC150-05-06.500D1-	6,5		43	91	53	36	8		
DC150-05-06.600D1-	6,6		43	91	53	36	8		
DC150-05-06.700D1-	6,7		43	91	53	36	8		
DC150-05-06.800D1-	6,8		43	91	53	36	8		
DC150-05-06.900D1-	6,9		43	91	53	36	8		
DC150-05-07.000D1-	7		43	91	53	36	8		
DC150-05-07.100D1-	7,1		43	91	53	36	8		
DC150-05-07.200D1-	7,2		43	91	53	36	8		
DC150-05-07.300D1-	7,3		43	91	53	36	8		
DC150-05-07.400D1-	7,4		43	91	53	36	8		

Ordering example for the WJ30RE grade: DC150-05-03.000D1-WJ30RE

Continued

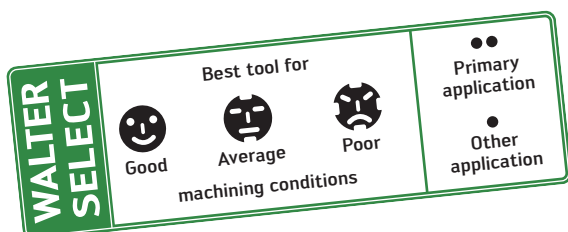
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30RE
DIN 6535 HE, turned 180°	DC150-05-07.500D1-	7,5		43	91	53	36	8	☺☺
	DC150-05-07.600D1-	7,6		43	91	53	36	8	☺☺
DIN 6535 HB	DC150-05-07.700D1-	7,7		43	91	53	36	8	☺☺
	DC150-05-07.800D1-	7,8		43	91	53	36	8	☺☺
	DC150-05-07.900D1-	7,9		43	91	53	36	8	☺☺
	DC150-05-08.000D1-	8		43	91	53	36	8	☺☺
	DC150-05-08.100D1-	8,1		49	103	61	40	10	☺☺
	DC150-05-08.200D1-	8,2		49	103	61	40	10	☺☺
	DC150-05-08.300D1-	8,3		49	103	61	40	10	☺☺
	DC150-05-08.400D1-	8,4		49	103	61	40	10	☺☺
	DC150-05-08.500D1-	8,5		49	103	61	40	10	☺☺
	DC150-05-08.600D1-	8,6		49	103	61	40	10	☺☺
	DC150-05-08.700D1-	8,7		49	103	61	40	10	☺☺
	DC150-05-08.800D1-	8,8		49	103	61	40	10	☺☺
	DC150-05-09.000D1-	9		49	103	61	40	10	☺☺
	DC150-05-09.100D1-	9,1		49	103	61	40	10	☺☺
	DC150-05-09.200D1-	9,2		49	103	61	40	10	☺☺
	DC150-05-09.300D1-	9,3		49	103	61	40	10	☺☺
	DC150-05-09.400D1-	9,4		49	103	61	40	10	☺☺
	DC150-05-09.500D1-	9,5		49	103	61	40	10	☺☺
	DC150-05-09.600D1-	9,6		49	103	61	40	10	☺☺
	DC150-05-09.700D1-	9,7		49	103	61	40	10	☺☺
	DC150-05-09.800D1-	9,8		49	103	61	40	10	☺☺
	DC150-05-09.900D1-	9,9		49	103	61	40	10	☺☺
	DC150-05-10.000D1-	10		49	103	61	40	10	☺☺
	DC150-05-10.100D1-	10,1		56	118	71	45	12	☺☺
	DC150-05-10.200D1-	10,2		56	118	71	45	12	☺☺
	DC150-05-10.300D1-	10,3		56	118	71	45	12	☺☺
	DC150-05-10.400D1-	10,4		56	118	71	45	12	☺☺
	DC150-05-10.500D1-	10,5		56	118	71	45	12	☺☺
	DC150-05-10.600D1-	10,6		56	118	71	45	12	☺☺
	DC150-05-10.800D1-	10,8		56	118	71	45	12	☺☺
	DC150-05-11.000D1-	11		56	118	71	45	12	☺☺
	DC150-05-11.100D1-	11,1		56	118	71	45	12	☺☺
	DC150-05-11.200D1-	11,2		56	118	71	45	12	☺☺
	DC150-05-11.300D1-	11,3		56	118	71	45	12	☺☺
	DC150-05-11.500D1-	11,5		56	118	71	45	12	☺☺
	DC150-05-11.600D1-	11,6		56	118	71	45	12	☺☺
	DC150-05-11.700D1-	11,7		56	118	71	45	12	☺☺
	DC150-05-11.800D1-	11,8		56	118	71	45	12	☺☺
	DC150-05-11.900D1-	11,9		56	118	71	45	12	☺☺
	DC150-05-12.000D1-	12		56	118	71	45	12	☺☺
	DC150-05-12.100D1-	12,1		60	124	77	45	14	☺☺
	DC150-05-12.200D1-	12,2		60	124	77	45	14	☺☺
	DC150-05-12.300D1-	12,3		60	124	77	45	14	☺☺
	DC150-05-12.400D1-	12,4		60	124	77	45	14	☺☺
	DC150-05-12.500D1-	12,5		60	124	77	45	14	☺☺
	DC150-05-12.700D1-	12,7	1/2"	60	124	77	45	14	☺☺
	DC150-05-12.800D1-	12,8		60	124	77	45	14	☺☺
	DC150-05-13.000D1-	13		60	124	77	45	14	☺☺
	DC150-05-13.100D1-	13,1		60	124	77	45	14	☺☺
	DC150-05-13.200D1-	13,2		60	124	77	45	14	☺☺
	DC150-05-13.500D1-	13,5		60	124	77	45	14	☺☺
	DC150-05-13.800D1-	13,8		60	124	77	45	14	☺☺
	DC150-05-14.000D1-	14		60	124	77	45	14	☺☺
	DC150-05-14.100D1-	14,1		63	133	83	48	16	☺☺
	DC150-05-14.200D1-	14,2		63	133	83	48	16	☺☺

Ordering example for the WJ30RE grade: DC150-05-03.000D1-WJ30RE

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30RE
DIN 6535 HE, turned 180° DIN 6535 HB 	DC150-05-14.300D1-	14,3		63	133	83	48	16	☺
	DC150-05-14.500D1-	14,5		63	133	83	48	16	☺
	DC150-05-14.600D1-	14,6		63	133	83	48	16	☺
	DC150-05-14.800D1-	14,8		63	133	83	48	16	☺
	DC150-05-15.000D1-	15		63	133	83	48	16	☺
	DC150-05-15.100D1-	15,1		63	133	83	48	16	☺
	DC150-05-15.200D1-	15,2		63	133	83	48	16	☺
	DC150-05-15.300D1-	15,3		63	133	83	48	16	☺
	DC150-05-15.500D1-	15,5		63	133	83	48	16	☺
	DC150-05-15.600D1-	15,6		63	133	83	48	16	☺
	DC150-05-15.700D1-	15,7		63	133	83	48	16	☺
	DC150-05-15.800D1-	15,8		63	133	83	48	16	☺
	DC150-05-16.000D1-	16		63	133	83	48	16	☺
	DC150-05-16.500D1-	16,5		71	143	93	48	18	☺
	DC150-05-16.600D1-	16,6		71	143	93	48	18	☺
	DC150-05-17.000D1-	17		71	143	93	48	18	☺
	DC150-05-17.200D1-	17,2		71	143	93	48	18	☺
	DC150-05-17.300D1-	17,3		71	143	93	48	18	☺
	DC150-05-17.500D1-	17,5		71	143	93	48	18	☺
	DC150-05-17.700D1-	17,7		71	143	93	48	18	☺
DC150-05-17.800D1-	17,8		71	143	93	48	18	☺	
DC150-05-18.000D1-	18		71	143	93	48	18	☺	
DC150-05-18.100D1-	18,1		77	153	101	50	20	☺	
DC150-05-18.500D1-	18,5		77	153	101	50	20	☺	
DC150-05-18.800D1-	18,8		77	153	101	50	20	☺	
DC150-05-19.000D1-	19		77	153	101	50	20	☺	
DC150-05-19.500D1-	19,5		77	153	101	50	20	☺	
DC150-05-19.700D1-	19,7		77	153	101	50	20	☺	
DC150-05-20.000D1-	20		77	153	101	50	20	☺	

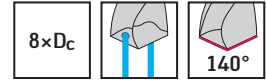
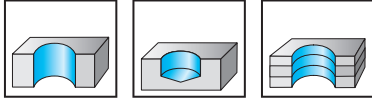
Ordering example for the WJ30RE grade: DC150-05-03.000D1-WJ30RE

B 1

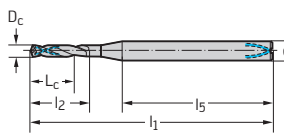
Solid carbide micro drill with coolant-through DB133 Supreme



B 1




	P	M	K	N	S	H	O
WJ30ER	●	●	●	●	●	●	●


	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ER
Shank DIN 6535 HA 	DB133-08-00.700A1-	0,7		6,9	50	8	35	3	●
	DB133-08-00.750A1-	0,75		7,8	50	9	34	3	●
	DB133-08-00.794A1-	0,794	1/32"	7,8	50	9	34	3	●
	DB133-08-00.800A1-	0,8		7,8	50	9	34	3	●
	DB133-08-00.850A1-	0,85		8,6	53	10	36	3	●
	DB133-08-00.900A1-	0,9		8,6	53	10	36	3	●
	DB133-08-00.950A1-	0,95		10,5	53	12	34	3	●
	DB133-08-01.000A1-	1		10,5	53	12	34	3	●
	DB133-08-01.050A1-	1,05		11	54	13	35	3	●
	DB133-08-01.100A1-	1,1		11	54	13	35	3	●
	DB133-08-01.150A1-	1,15		12	54	14	34	3	●
	DB133-08-01.191A1-	1,191	3/64"	12	54	14	34	3	●
	DB133-08-01.200A1-	1,2		12	54	14	34	3	●
	DB133-08-01.250A1-	1,25		12	54	14	34	3	●
	DB133-08-01.300A1-	1,3		13	57	15	36	3	●
	DB133-08-01.350A1-	1,35		13	57	16	35	3	●
	DB133-08-01.400A1-	1,4		13	57	16	35	3	●
	DB133-08-01.450A1-	1,45		14	57	17	34	3	●
	DB133-08-01.500A1-	1,5		14	57	17	34	3	●
	DB133-08-01.550A1-	1,55		15	60	18	37	3	●
	DB133-08-01.588A1-	1,588	1/16"	15	60	18	37	3	●
	DB133-08-01.600A1-	1,6		15	60	18	37	3	●
	DB133-08-01.650A1-	1,65		17	60	20	35	3	●
	DB133-08-01.700A1-	1,7		17	60	20	35	3	●
	DB133-08-01.750A1-	1,75		18	60	21	34	3	●
	DB133-08-01.800A1-	1,8		18	60	21	34	3	●
	DB133-08-01.820A1-	1,82		19	63	22	36	3	●
	DB133-08-01.850A1-	1,85		19	63	22	36	3	●
	DB133-08-01.900A1-	1,9		19	63	22	36	3	●
	DB133-08-01.950A1-	1,95		20	63	23	35	3	●
	DB133-08-01.984A1-	1,984	5/64"	20	63	23	35	3	●


Ordering example for the WJ30ER grade: DB133-08-00.700A1-WJ30ER

WALTER SELECT

Best tool for


Good


Average


Poor

machining conditions

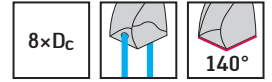
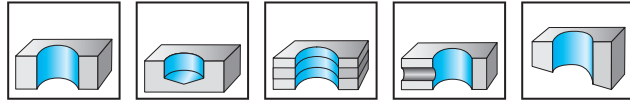
●● Primary application

● Other application

Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



WJ30ET	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
DC160-08-03.000A1-	3		28	74	34	36	6	●
DC160-08-03.100A1-	3,1		28	74	34	36	6	●
DC160-08-03.175A1-	3,175	1/8"	28	74	34	36	6	●
DC160-08-03.200A1-	3,2		28	74	34	36	6	●
DC160-08-03.300A1-	3,3		28	74	34	36	6	●
DC160-08-03.400A1-	3,4		28	74	34	36	6	●
DC160-08-03.500A1-	3,5		28	74	34	36	6	●
DC160-08-03.572A1-	3,572	9/64"	28	74	34	36	6	●
DC160-08-03.600A1-	3,6		28	74	34	36	6	●
DC160-08-03.700A1-	3,7		28	74	34	36	6	●
DC160-08-03.800A1-	3,8		37	85	45	36	6	●
DC160-08-03.900A1-	3,9		37	85	45	36	6	●
DC160-08-03.969A1-	3,969	5/32"	37	85	45	36	6	●
DC160-08-04.000A1-	4		37	85	45	36	6	●
DC160-08-04.100A1-	4,1		37	85	45	36	6	●
DC160-08-04.200A1-	4,2		37	85	45	36	6	●
DC160-08-04.300A1-	4,3		37	85	45	36	6	●
DC160-08-04.366A1-	4,366	11/64"	37	85	45	36	6	●
DC160-08-04.400A1-	4,4		37	85	45	36	6	●
DC160-08-04.500A1-	4,5		37	85	45	36	6	●
DC160-08-04.600A1-	4,6		37	85	45	36	6	●
DC160-08-04.700A1-	4,7		37	85	45	36	6	●
DC160-08-04.763A1-	4,763	3/16"	48	97	57	36	6	●
DC160-08-04.800A1-	4,8		48	97	57	36	6	●
DC160-08-04.900A1-	4,9		48	97	57	36	6	●
DC160-08-05.000A1-	5		48	97	57	36	6	●
DC160-08-05.100A1-	5,1		48	97	57	36	6	●
DC160-08-05.159A1-	5,159	13/64"	48	97	57	36	6	●
DC160-08-05.200A1-	5,2		48	97	57	36	6	●
DC160-08-05.300A1-	5,3		48	97	57	36	6	●
DC160-08-05.400A1-	5,4		48	97	57	36	6	●
DC160-08-05.500A1-	5,5		48	97	57	36	6	●
DC160-08-05.556A1-	5,556	7/32"	48	97	57	36	6	●
DC160-08-05.600A1-	5,6		48	97	57	36	6	●
DC160-08-05.700A1-	5,7		48	97	57	36	6	●
DC160-08-05.800A1-	5,8		48	97	57	36	6	●
DC160-08-05.900A1-	5,9		48	97	57	36	6	●
DC160-08-05.953A1-	5,953	15/64"	48	97	57	36	6	●
DC160-08-06.000A1-	6		48	97	57	36	6	●
DC160-08-06.100A1-	6,1		55	106	66	36	8	●
DC160-08-06.200A1-	6,2		55	106	66	36	8	●
DC160-08-06.300A1-	6,3		55	106	66	36	8	●
DC160-08-06.350A1-	6,35	1/4"	55	106	66	36	8	●
DC160-08-06.400A1-	6,4		55	106	66	36	8	●
DC160-08-06.500A1-	6,5		55	106	66	36	8	●
DC160-08-06.600A1-	6,6		55	106	66	36	8	●
DC160-08-06.700A1-	6,7		55	106	66	36	8	●

Ordering example for the WJ30ET grade: DC160-08-03.000A1-WJ30ET

Continued

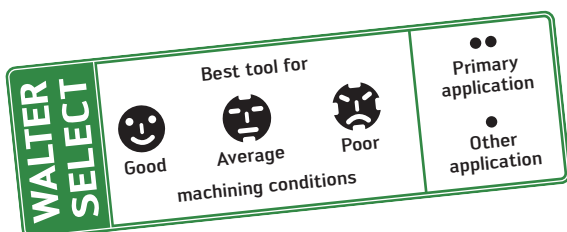
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET	
	Shank DIN 6535 HA	DC160-08-06.747A1-	6,747	17/64"	55	106	66	36	8	☺
		DC160-08-06.800A1-	6,8		55	106	66	36	8	☺
		DC160-08-06.900A1-	6,9		55	106	66	36	8	☺
		DC160-08-07.000A1-	7		55	106	66	36	8	☺
		DC160-08-07.100A1-	7,1		64	116	76	36	8	☺
		DC160-08-07.144A1-	7,144	9/32"	64	116	76	36	8	☺
		DC160-08-07.200A1-	7,2		64	116	76	36	8	☺
		DC160-08-07.300A1-	7,3		64	116	76	36	8	☺
		DC160-08-07.400A1-	7,4		64	116	76	36	8	☺
		DC160-08-07.500A1-	7,5		64	116	76	36	8	☺
		DC160-08-07.541A1-	7,541	19/64"	64	116	76	36	8	☺
		DC160-08-07.600A1-	7,6		64	116	76	36	8	☺
		DC160-08-07.700A1-	7,7		64	116	76	36	8	☺
		DC160-08-07.800A1-	7,8		64	116	76	36	8	☺
		DC160-08-07.900A1-	7,9		64	116	76	36	8	☺
		DC160-08-07.938A1-	7,938	5/16"	64	116	76	36	8	☺
		DC160-08-08.000A1-	8		64	116	76	36	8	☺
		DC160-08-08.100A1-	8,1		80	139	95	40	10	☺
		DC160-08-08.200A1-	8,2		80	139	95	40	10	☺
		DC160-08-08.300A1-	8,3		80	139	95	40	10	☺
		DC160-08-08.334A1-	8,334	21/64"	80	139	95	40	10	☺
		DC160-08-08.400A1-	8,4		80	139	95	40	10	☺
		DC160-08-08.500A1-	8,5		80	139	95	40	10	☺
		DC160-08-08.600A1-	8,6		80	139	95	40	10	☺
		DC160-08-08.700A1-	8,7		80	139	95	40	10	☺
		DC160-08-08.731A1-	8,731	11/32"	80	139	95	40	10	☺
		DC160-08-08.800A1-	8,8		80	139	95	40	10	☺
		DC160-08-08.900A1-	8,9		80	139	95	40	10	☺
		DC160-08-09.000A1-	9		80	139	95	40	10	☺
		DC160-08-09.100A1-	9,1		80	139	95	40	10	☺
		DC160-08-09.128A1-	9,128	23/64"	80	139	95	40	10	☺
		DC160-08-09.200A1-	9,2		80	139	95	40	10	☺
		DC160-08-09.300A1-	9,3		80	139	95	40	10	☺
	DC160-08-09.400A1-	9,4		80	139	95	40	10	☺	
	DC160-08-09.500A1-	9,5		80	139	95	40	10	☺	
	DC160-08-09.525A1-	9,525	3/8"	80	139	95	40	10	☺	
	DC160-08-09.600A1-	9,6		80	139	95	40	10	☺	
	DC160-08-09.700A1-	9,7		80	139	95	40	10	☺	
	DC160-08-09.800A1-	9,8		80	139	95	40	10	☺	
	DC160-08-09.900A1-	9,9		80	139	95	40	10	☺	
	DC160-08-09.922A1-	9,922	25/64"	80	139	95	40	10	☺	
	DC160-08-10.000A1-	10		80	139	95	40	10	☺	
	DC160-08-10.100A1-	10,1		96	163	114	45	12	☺	
	DC160-08-10.200A1-	10,2		96	163	114	45	12	☺	
	DC160-08-10.300A1-	10,3		96	163	114	45	12	☺	
	DC160-08-10.319A1-	10,319	13/32"	96	163	114	45	12	☺	
	DC160-08-10.400A1-	10,4		96	163	114	45	12	☺	
	DC160-08-10.500A1-	10,5		96	163	114	45	12	☺	
	DC160-08-10.600A1-	10,6		96	163	114	45	12	☺	
	DC160-08-10.700A1-	10,7		96	163	114	45	12	☺	
	DC160-08-10.716A1-	10,716	27/64"	96	163	114	45	12	☺	
	DC160-08-10.800A1-	10,8		96	163	114	45	12	☺	
	DC160-08-10.900A1-	10,9		96	163	114	45	12	☺	
	DC160-08-11.000A1-	11		96	163	114	45	12	☺	
	DC160-08-11.100A1-	11,1		96	163	114	45	12	☺	
	DC160-08-11.113A1-	11,113	7/16"	96	163	114	45	12	☺	
	DC160-08-11.200A1-	11,2		96	163	114	45	12	☺	

Ordering example for the WJ30ET grade: DC160-08-03.000A1-WJ30ET

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET	
	Shank DIN 6535 HA	DC160-08-11.300A1-		96	163	114	45	12	⊗	
		DC160-08-11.400A1-		96	163	114	45	12	⊗	
		DC160-08-11.500A1-		96	163	114	45	12	⊗	
		DC160-08-11.509A1-	11,509	29/64"	96	163	114	45	12	⊗
		DC160-08-11.600A1-	11,6		96	163	114	45	12	⊗
		DC160-08-11.700A1-	11,7		96	163	114	45	12	⊗
		DC160-08-11.800A1-	11,8		96	163	114	45	12	⊗
		DC160-08-11.900A1-	11,9		96	163	114	45	12	⊗
		DC160-08-11.906A1-	11,906	15/32"	96	163	114	45	12	⊗
		DC160-08-12.000A1-	12		96	163	114	45	12	⊗
		DC160-08-12.303A1-	12,303	31/64"	119	182	133	45	14	⊗
		DC160-08-12.500A1-	12,5		119	182	133	45	14	⊗
		DC160-08-12.700A1-	12,7	1/2"	119	182	133	45	14	⊗
		DC160-08-13.000A1-	13		119	182	133	45	14	⊗
		DC160-08-13.494A1-	13,494	17/32"	119	182	133	45	14	⊗
		DC160-08-13.500A1-	13,5		119	182	133	45	14	⊗
		DC160-08-14.000A1-	14		119	182	133	45	14	⊗
		DC160-08-14.288A1-	14,288	9/16"	136	204	152	48	16	⊗
		DC160-08-14.500A1-	14,5		136	204	152	48	16	⊗
		DC160-08-15.000A1-	15		136	204	152	48	16	⊗
	DC160-08-15.500A1-	15,5		136	204	152	48	16	⊗	
	DC160-08-15.875A1-	15,875	5/8"	136	204	152	48	16	⊗	
	DC160-08-16.000A1-	16		136	204	152	48	16	⊗	
	DC160-08-16.500A1-	16,5		153	223	171	48	18	⊗	
	DC160-08-17.000A1-	17		153	223	171	48	18	⊗	
	DC160-08-17.500A1-	17,5		153	223	171	48	18	⊗	
	DC160-08-18.000A1-	18		153	223	171	48	18	⊗	
	DC160-08-18.500A1-	18,5		170	244	190	50	20	⊗	
	DC160-08-19.000A1-	19		170	244	190	50	20	⊗	
	DC160-08-19.050A1-	19,05	3/4"	170	244	190	50	20	⊗	
	DC160-08-19.500A1-	19,5		170	244	190	50	20	⊗	
	DC160-08-20.000A1-	20		170	244	190	50	20	⊗	

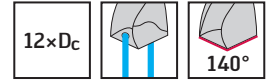
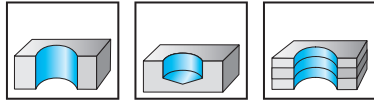
Ordering example for the WJ30ET grade: DC160-08-03.000A1-WJ30ET

B 1

Solid carbide micro drill with coolant-through DB133 Supreme



B 1



	P	M	K	N	S	H	O
WJ30ER	●	●	●	●	●	●	●

	Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ER
Shank DIN 6535 HA 	DB133-12-00.700A1-	0,7		9,9	53	11	35	3	●
	DB133-12-00.750A1-	0,75		10,8	53	12	34	3	●
	DB133-12-00.794A1-	0,794	1/32"	10,8	53	12	34	3	●
	DB133-12-00.800A1-	0,8		10,8	53	12	34	3	●
	DB133-12-00.850A1-	0,85		12,6	57	14	36	3	●
	DB133-12-00.900A1-	0,9		12,6	57	14	36	3	●
	DB133-12-00.950A1-	0,95		14,5	57	16	34	3	●
	DB133-12-01.000A1-	1		14,5	57	16	34	3	●
	DB133-12-01.050A1-	1,05		15	59	17	36	3	●
	DB133-12-01.100A1-	1,1		15	59	17	36	3	●
	DB133-12-01.150A1-	1,15		17	59	19	34	3	●
	DB133-12-01.191A1-	1,191	3/64"	17	59	19	34	3	●
	DB133-12-01.200A1-	1,2		17	59	19	34	3	●
	DB133-12-01.250A1-	1,25		17	59	19	34	3	●
	DB133-12-01.300A1-	1,3		18	63	20	37	3	●
	DB133-12-01.350A1-	1,35		19	63	22	35	3	●
	DB133-12-01.400A1-	1,4		19	63	22	35	3	●
	DB133-12-01.450A1-	1,45		20	63	23	34	3	●
	DB133-12-01.500A1-	1,5		20	63	23	34	3	●
	DB133-12-01.550A1-	1,55		22	67	25	37	3	●
	DB133-12-01.588A1-	1,588	1/16"	22	67	25	37	3	●
	DB133-12-01.600A1-	1,6		22	67	25	37	3	●
	DB133-12-01.650A1-	1,65		23	67	26	36	3	●
	DB133-12-01.700A1-	1,7		23	67	26	36	3	●
	DB133-12-01.750A1-	1,75		25	67	28	34	3	●
	DB133-12-01.800A1-	1,8		25	67	28	34	3	●
	DB133-12-01.850A1-	1,85		26	72	29	38	3	●
	DB133-12-01.900A1-	1,9		26	72	29	38	3	●
	DB133-12-01.950A1-	1,95		28	72	31	36	3	●
	DB133-12-01.984A1-	1,984	5/64"	28	72	31	36	3	●

Ordering example for the WJ30ER grade: DB133-12-00.700A1-WJ30ER

WALTER SELECT

Best tool for

Good

Average

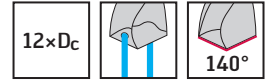
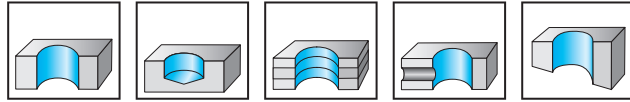
Poor

machining conditions

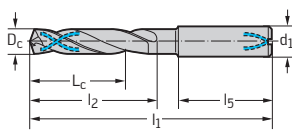
●● Primary application

● Other application

Solid carbide drill with coolant-through DC160 Advance X-treme Evo



Shank DIN 6535 HA



Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU
DC160-12-03.000A1-	3		48	92	54	36	6	●
DC160-12-03.100A1-	3,1		48	92	54	36	6	●
DC160-12-03.175A1-	3,175	1/8"	48	92	54	36	6	●
DC160-12-03.200A1-	3,2		48	92	54	36	6	●
DC160-12-03.300A1-	3,3		48	92	54	36	6	●
DC160-12-03.400A1-	3,4		48	92	54	36	6	●
DC160-12-03.500A1-	3,5		48	92	54	36	6	●
DC160-12-03.572A1-	3,572	9/64"	48	92	54	36	6	●
DC160-12-03.600A1-	3,6		48	92	54	36	6	●
DC160-12-03.700A1-	3,7		48	92	54	36	6	●
DC160-12-03.800A1-	3,8		56	102	64	36	6	●
DC160-12-03.900A1-	3,9		56	102	64	36	6	●
DC160-12-03.969A1-	3,969	5/32"	56	102	64	36	6	●
DC160-12-04.000A1-	4		56	102	64	36	6	●
DC160-12-04.100A1-	4,1		56	102	64	36	6	●
DC160-12-04.200A1-	4,2		56	102	64	36	6	●
DC160-12-04.300A1-	4,3		56	102	64	36	6	●
DC160-12-04.366A1-	4,366	11/64"	56	102	64	36	6	●
DC160-12-04.400A1-	4,4		56	102	64	36	6	●
DC160-12-04.500A1-	4,5		56	102	64	36	6	●
DC160-12-04.600A1-	4,6		56	102	64	36	6	●
DC160-12-04.700A1-	4,7		56	102	64	36	6	●
DC160-12-04.763A1-	4,763	3/16"	74	121	83	36	6	●
DC160-12-04.800A1-	4,8		74	121	83	36	6	●
DC160-12-04.900A1-	4,9		74	121	83	36	6	●
DC160-12-05.000A1-	5		74	121	83	36	6	●
DC160-12-05.100A1-	5,1		74	121	83	36	6	●
DC160-12-05.159A1-	5,159	13/64"	74	121	83	36	6	●
DC160-12-05.200A1-	5,2		74	121	83	36	6	●
DC160-12-05.300A1-	5,3		74	121	83	36	6	●
DC160-12-05.400A1-	5,4		74	121	83	36	6	●
DC160-12-05.500A1-	5,5		74	121	83	36	6	●
DC160-12-05.550A1-	5,55		74	121	83	36	6	●
DC160-12-05.556A1-	5,556	7/32"	74	121	83	36	6	●
DC160-12-05.600A1-	5,6		74	121	83	36	6	●
DC160-12-05.700A1-	5,7		74	121	83	36	6	●
DC160-12-05.800A1-	5,8		74	121	83	36	6	●
DC160-12-05.900A1-	5,9		74	121	83	36	6	●
DC160-12-06.000A1-	6		74	121	83	36	6	●
DC160-12-06.100A1-	6,1		98	148	110	36	8	●
DC160-12-06.200A1-	6,2		98	148	110	36	8	●
DC160-12-06.300A1-	6,3		98	148	110	36	8	●
DC160-12-06.350A1-	6,35	1/4"	98	148	110	36	8	●
DC160-12-06.400A1-	6,4		98	148	110	36	8	●
DC160-12-06.500A1-	6,5		98	148	110	36	8	●
DC160-12-06.600A1-	6,6		98	148	110	36	8	●
DC160-12-06.700A1-	6,7		98	148	110	36	8	●

Ordering example for the WJ30EU grade: DC160-12-03.000A1-WJ30EU

Continued

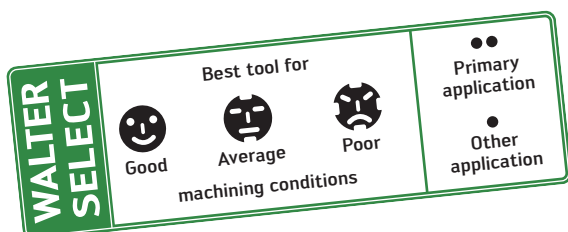
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU	
	Shank DIN 6535 HA	DC160-12-06.747A1-	6,747	17/64"	98	148	110	36	8	☺
		DC160-12-06.800A1-	6,8		98	148	110	36	8	☺
		DC160-12-06.900A1-	6,9		98	148	110	36	8	☺
		DC160-12-07.000A1-	7		98	148	110	36	8	☺
		DC160-12-07.100A1-	7,1		98	148	110	36	8	☺
		DC160-12-07.144A1-	7,144	9/32"	98	148	110	36	8	☺
		DC160-12-07.200A1-	7,2		98	148	110	36	8	☺
		DC160-12-07.300A1-	7,3		98	148	110	36	8	☺
		DC160-12-07.400A1-	7,4		98	148	110	36	8	☺
		DC160-12-07.500A1-	7,5		98	148	110	36	8	☺
		DC160-12-07.541A1-	7,541	19/64"	98	148	110	36	8	☺
		DC160-12-07.800A1-	7,8		98	148	110	36	8	☺
		DC160-12-07.900A1-	7,9		98	148	110	36	8	☺
		DC160-12-07.938A1-	7,938	5/16"	98	148	110	36	8	☺
		DC160-12-08.000A1-	8		98	148	110	36	8	☺
		DC160-12-08.100A1-	8,1		123	180	138	40	10	☺
		DC160-12-08.200A1-	8,2		123	180	138	40	10	☺
		DC160-12-08.300A1-	8,3		123	180	138	40	10	☺
		DC160-12-08.400A1-	8,4		123	180	138	40	10	☺
		DC160-12-08.500A1-	8,5		123	180	138	40	10	☺
		DC160-12-08.600A1-	8,6		123	180	138	40	10	☺
		DC160-12-08.700A1-	8,7		123	180	138	40	10	☺
		DC160-12-08.731A1-	8,731	11/32"	123	180	138	40	10	☺
		DC160-12-08.800A1-	8,8		123	180	138	40	10	☺
		DC160-12-09.000A1-	9		123	180	138	40	10	☺
		DC160-12-09.128A1-	9,128	23/64"	123	180	138	40	10	☺
		DC160-12-09.200A1-	9,2		123	180	138	40	10	☺
		DC160-12-09.300A1-	9,3		123	180	138	40	10	☺
		DC160-12-09.500A1-	9,5		123	180	138	40	10	☺
		DC160-12-09.525A1-	9,525	3/8"	123	180	138	40	10	☺
		DC160-12-09.600A1-	9,6		123	180	138	40	10	☺
		DC160-12-09.700A1-	9,7		123	180	138	40	10	☺
		DC160-12-09.800A1-	9,8		123	180	138	40	10	☺
		DC160-12-09.922A1-	9,922	25/64"	123	180	138	40	10	☺
		DC160-12-10.000A1-	10		123	180	138	40	10	☺
		DC160-12-10.100A1-	10,1		140	206	158	45	12	☺
		DC160-12-10.200A1-	10,2		140	206	158	45	12	☺
		DC160-12-10.300A1-	10,3		140	206	158	45	12	☺
		DC160-12-10.319A1-	10,319	13/32"	140	206	158	45	12	☺
		DC160-12-10.400A1-	10,4		140	206	158	45	12	☺
	DC160-12-10.500A1-	10,5		140	206	158	45	12	☺	
	DC160-12-10.716A1-	10,716	27/64"	140	206	158	45	12	☺	
	DC160-12-10.800A1-	10,8		140	206	158	45	12	☺	
	DC160-12-11.000A1-	11		140	206	158	45	12	☺	
	DC160-12-11.100A1-	11,1		140	206	158	45	12	☺	
	DC160-12-11.113A1-	11,113	7/16"	140	206	158	45	12	☺	
	DC160-12-11.200A1-	11,2		140	206	158	45	12	☺	
	DC160-12-11.500A1-	11,5		140	206	158	45	12	☺	
	DC160-12-11.509A1-	11,509	29/64"	140	206	158	45	12	☺	
	DC160-12-11.700A1-	11,7		140	206	158	45	12	☺	
	DC160-12-11.800A1-	11,8		140	206	158	45	12	☺	
	DC160-12-11.906A1-	11,906	15/32"	140	206	158	45	12	☺	
	DC160-12-12.000A1-	12		140	206	158	45	12	☺	
	DC160-12-12.100A1-	12,1		168	230	182	45	14	☺	
	DC160-12-12.200A1-	12,2		168	230	182	45	14	☺	
	DC160-12-12.300A1-	12,3		168	230	182	45	14	☺	
	DC160-12-12.303A1-	12,303	31/64"	168	230	182	45	14	☺	

Ordering example for the WJ30EU grade: DC160-12-03.000A1-WJ30EU

Continued



Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU	
	Shank DIN 6535 HA	DC160-12-12.500A1-		168	230	182	45	14	⊗	
		DC160-12-12.600A1-		168	230	182	45	14	⊗	
		DC160-12-12.700A1-	1/2"	168	230	182	45	14	⊗	
		DC160-12-13.000A1-	13		168	230	182	45	14	⊗
		DC160-12-13.494A1-	13,494	17/32"	168	230	182	45	14	⊗
		DC160-12-13.500A1-	13,5		168	230	182	45	14	⊗
		DC160-12-14.000A1-	14		168	230	182	45	14	⊗
		DC160-12-14.288A1-	14,288	9/16"	192	260	208	48	16	⊗
		DC160-12-14.500A1-	14,5		192	260	208	48	16	⊗
		DC160-12-15.000A1-	15		192	260	208	48	16	⊗
		DC160-12-15.500A1-	15,5		192	260	208	48	16	⊗
		DC160-12-15.875A1-	15,875	5/8"	192	260	208	48	16	⊗
		DC160-12-16.000A1-	16		192	260	208	48	16	⊗
		DC160-12-16.500A1-	16,5		216	285	234	48	18	⊗
		DC160-12-17.000A1-	17		216	285	234	48	18	⊗
		DC160-12-17.500A1-	17,5		216	285	234	48	18	⊗
		DC160-12-18.000A1-	18		216	285	234	48	18	⊗
		DC160-12-18.500A1-	18,5		238	310	258	50	20	⊗
		DC160-12-19.000A1-	19		238	310	258	50	20	⊗
		DC160-12-19.500A1-	19,5		238	310	258	50	20	⊗
	DC160-12-20.000A1-	20		238	310	258	50	20	⊗	

Ordering example for the WJ30EU grade: DC160-12-03.000A1-WJ30EU

B 1

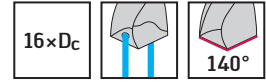
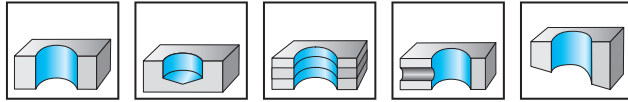
Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



B 1



P	M	K	N	S	H	O
●	●	●	●	●	●	●

WJ30EU

Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU
Shank DIN 6535 HA								
DC160-16-03.000A1-	3		52	89	57	28	4	●
DC160-16-03.175A1-	3,175	1/8"	60	98	66	28	4	●
DC160-16-03.500A1-	3,5		72	110	78	28	4	●
DC160-16-03.572A1-	3,572	9/64"	72	110	78	28	4	●
DC160-16-03.969A1-	3,969	5/32"	72	110	78	28	4	●
DC160-16-04.000A1-	4		72	110	78	28	4	●
DC160-16-04.500A1-	4,5		93	132	100	28	5	●
DC160-16-04.763A1-	4,763	3/16"	92	132	100	28	5	●
DC160-16-04.800A1-	4,8		92	132	100	28	5	●
DC160-16-05.000A1-	5		92	132	100	28	5	●
DC160-16-05.500A1-	5,5		101	150	110	36	6	●
DC160-16-05.556A1-	5,556	7/32"	111	160	120	36	6	●
DC160-16-05.800A1-	5,8		111	160	120	36	6	●
DC160-16-06.000A1-	6		111	160	120	36	6	●
DC160-16-06.100A1-	6,1		124	175	135	36	8	●
DC160-16-06.350A1-	6,35	1/4"	124	175	135	36	8	●
DC160-16-06.500A1-	6,5		124	175	135	36	8	●
DC160-16-06.800A1-	6,8		124	175	135	36	8	●
DC160-16-07.000A1-	7		124	175	135	36	8	●
DC160-16-07.144A1-	7,144	9/32"	140	192	152	36	8	●
DC160-16-07.400A1-	7,4		140	192	152	36	8	●
DC160-16-07.500A1-	7,5		140	192	152	36	8	●
DC160-16-07.938A1-	7,938	5/16"	140	192	152	36	8	●
DC160-16-08.000A1-	8		140	192	152	36	8	●
DC160-16-08.300A1-	8,3		148	206	162	40	10	●
DC160-16-08.500A1-	8,5		148	206	162	40	10	●
DC160-16-08.731A1-	8,731	11/32"	148	206	162	40	10	●
DC160-16-09.000A1-	9		148	206	162	40	10	●
DC160-16-09.525A1-	9,525	3/8"	165	224	180	40	10	●
DC160-16-09.800A1-	9,8		165	224	180	40	10	●
DC160-16-10.000A1-	10		165	224	180	40	10	●
DC160-16-10.200A1-	10,2		181	247	198	45	12	●
DC160-16-10.319A1-	10,319	13/32"	181	247	198	45	12	●
DC160-16-11.000A1-	11		181	247	198	45	12	●
DC160-16-11.113A1-	11,113	7/16"	198	265	216	45	12	●
DC160-16-11.500A1-	11,5		198	265	216	45	12	●
DC160-16-11.800A1-	11,8		198	265	216	45	12	●
DC160-16-11.906A1-	11,906	15/32"	198	265	216	45	12	●
DC160-16-12.000A1-	12		198	265	216	45	12	●
DC160-16-12.700A1-	12,7	1/2"	238	301	252	45	14	●
DC160-16-13.000A1-	13		238	301	252	45	14	●
DC160-16-14.000A1-	14		238	301	252	45	14	●
DC160-16-14.288A1-	14,288	9/16"	272	340	288	48	16	●
DC160-16-15.000A1-	15		272	340	288	48	16	●
DC160-16-16.000A1-	16		272	340	288	48	16	●

Ordering example for the WJ30EU grade: DC160-16-03.000A1-WJ30EU

● ● ● / ★ New addition to the product range

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

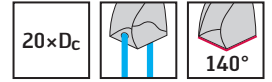
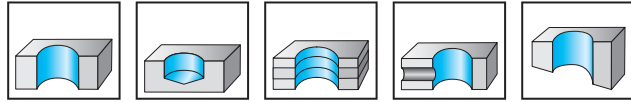
● ● Primary application

● Other application

Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU
DC160-20-03.000A1-	3		60	97	65	28	4	●
DC160-20-03.175A1-	3,175	1/8"	74	112	80	28	4	●
DC160-20-03.500A1-	3,5		86	124	92	28	4	●
DC160-20-03.572A1-	3,572	9/64"	86	124	92	28	4	●
DC160-20-03.969A1-	3,969	5/32"	86	124	92	28	4	●
DC160-20-04.000A1-	4		86	124	92	28	4	●
DC160-20-04.500A1-	4,5		111	150	118	28	5	●
DC160-20-04.763A1-	4,763	3/16"	110	150	118	28	5	●
DC160-20-04.800A1-	4,8		110	150	118	28	5	●
DC160-20-05.000A1-	5		110	150	118	28	5	●
DC160-20-05.500A1-	5,5		123	170	132	36	6	●
DC160-20-05.556A1-	5,556	7/32"	135	182	144	36	6	●
DC160-20-05.800A1-	5,8		135	182	144	36	6	●
DC160-20-06.000A1-	6		135	182	144	36	6	●
DC160-20-06.100A1-	6,1		151	200	162	36	8	●
DC160-20-06.350A1-	6,35	1/4"	151	200	162	36	8	●
DC160-20-06.500A1-	6,5		151	200	162	36	8	●
DC160-20-06.800A1-	6,8		151	200	162	36	8	●
DC160-20-07.000A1-	7		151	200	162	36	8	●
DC160-20-07.144A1-	7,144	9/32"	172	222	184	36	8	●
DC160-20-07.400A1-	7,4		172	222	184	36	8	●
DC160-20-07.500A1-	7,5		172	222	184	36	8	●
DC160-20-07.938A1-	7,938	5/16"	172	222	184	36	8	●
DC160-20-08.000A1-	8		172	222	184	36	8	●
DC160-20-08.300A1-	8,3		184	240	198	40	10	●
DC160-20-08.500A1-	8,5		184	240	198	40	10	●
DC160-20-08.731A1-	8,731	11/32"	184	240	198	40	10	●
DC160-20-09.000A1-	9		184	240	198	40	10	●
DC160-20-09.525A1-	9,525	3/8"	205	262	220	40	10	●
DC160-20-09.800A1-	9,8		205	262	220	40	10	●
DC160-20-10.000A1-	10		205	262	220	40	10	●
DC160-20-10.200A1-	10,2		225	289	242	45	12	●
DC160-20-10.319A1-	10,319	13/32"	225	289	242	45	12	●
DC160-20-11.000A1-	11		225	289	242	45	12	●
DC160-20-11.113A1-	11,113	7/16"	246	311	264	45	12	●
DC160-20-11.500A1-	11,5		246	311	264	45	12	●
DC160-20-11.800A1-	11,8		246	311	264	45	12	●
DC160-20-11.906A1-	11,906	15/32"	246	311	264	45	12	●
DC160-20-12.000A1-	12		246	311	264	45	12	●
DC160-20-12.700A1-	12,7	1/2"	294	357	308	45	14	●
DC160-20-13.000A1-	13		294	357	308	45	14	●
DC160-20-14.000A1-	14		294	357	308	45	14	●
DC160-20-14.288A1-	14,288	9/16"	336	404	352	48	16	●
DC160-20-15.000A1-	15		336	404	352	48	16	●
DC160-20-16.000A1-	16		336	404	352	48	16	●

Ordering example for the WJ30EU grade: DC160-20-03.000A1-WJ30EU

B 1

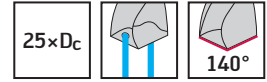
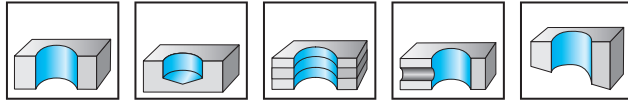
Solid carbide drill with coolant-through

DC160 Advance

X-treme Evo



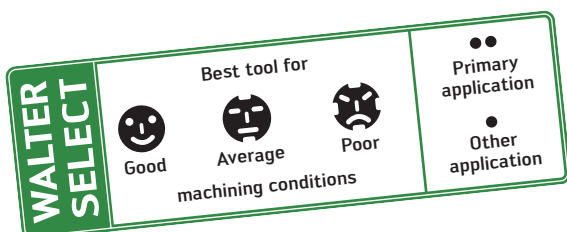
B 1



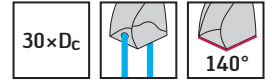
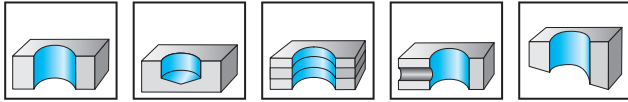
	P	M	K	N	S	H	O
WJ30EU	●	●	●	●	●	●	●

Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU
Shank DIN 6535 HA								
DC160-25-03.000A1-	3		79	119	84	28	4	●
DC160-25-03.175A1-	3,175	1/8"	96	148	102	28	4	●
DC160-25-03.500A1-	3,5		108	148	114	28	4	●
DC160-25-03.572A1-	3,572	9/64"	108	148	114	28	4	●
DC160-25-03.969A1-	3,969	5/32"	108	148	114	28	4	●
DC160-25-04.000A1-	4		108	148	114	28	4	●
DC160-25-04.500A1-	4,5		138	177	145	28	5	●
DC160-25-04.763A1-	4,763	3/16"	137	177	145	28	5	●
DC160-25-04.800A1-	4,8		137	177	145	28	5	●
DC160-25-05.000A1-	5		137	177	145	28	5	●
DC160-25-05.500A1-	5,5		151	200	160	36	6	●
DC160-25-05.556A1-	5,556	7/32"	165	214	174	36	6	●
DC160-25-05.800A1-	5,8		165	214	174	36	6	●
DC160-25-06.000A1-	6		165	214	174	36	6	●
DC160-25-06.100A1-	6,1		183	234	194	36	8	●
DC160-25-06.350A1-	6,35	1/4"	183	234	194	36	8	●
DC160-25-06.500A1-	6,5		183	234	194	36	8	●
DC160-25-06.800A1-	6,8		183	234	194	36	8	●
DC160-25-07.000A1-	7		183	234	194	36	8	●
DC160-25-07.144A1-	7,144	9/32"	208	260	220	36	8	●
DC160-25-07.400A1-	7,4		208	260	220	36	8	●
DC160-25-07.500A1-	7,5		208	260	220	36	8	●
DC160-25-07.938A1-	7,938	5/16"	208	260	220	36	8	●
DC160-25-08.000A1-	8		208	260	220	36	8	●
DC160-25-08.300A1-	8,3		229	289	243	40	10	●
DC160-25-08.500A1-	8,5		229	289	243	40	10	●
DC160-25-08.731A1-	8,731	11/32"	229	289	243	40	10	●
DC160-25-09.000A1-	9		229	289	243	40	10	●
DC160-25-09.525A1-	9,525	3/8"	255	314	270	40	10	●
DC160-25-09.800A1-	9,8		255	314	270	40	10	●
DC160-25-10.000A1-	10		255	314	270	40	10	●
DC160-25-10.200A1-	10,2		280	346	297	45	12	●
DC160-25-10.319A1-	10,319	13/32"	280	346	297	45	12	●
DC160-25-11.000A1-	11		280	346	297	45	12	●
DC160-25-11.113A1-	11,113	7/16"	306	373	324	45	12	●
DC160-25-11.500A1-	11,5		306	373	324	45	12	●
DC160-25-11.800A1-	11,8		306	373	324	45	12	●
DC160-25-11.906A1-	11,906	15/32"	306	373	324	45	12	●
DC160-25-12.000A1-	12		306	373	324	45	12	●

Ordering example for the WJ30EU grade: DC160-25-03.000A1-WJ30EU



Solid carbide drill with coolant-through DC160 Advance X-treme Evo



WJ30EU	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EU
Shank DIN 6535 HA								
DC160-30-03.000A1-	3		92	132	97	28	4	☞
DC160-30-03.175A1-	3,175	1/8"	114	166	120	28	4	☞
DC160-30-03.500A1-	3,5		127	166	133	28	4	☞
DC160-30-03.572A1-	3,572	9/64"	127	166	133	28	4	☞
DC160-30-03.969A1-	3,969	5/32"	127	166	133	28	4	☞
DC160-30-04.000A1-	4		127	166	133	28	4	☞
DC160-30-04.500A1-	4,5		162	200	169	28	5	☞
DC160-30-04.763A1-	4,763	3/16"	161	200	169	28	5	☞
DC160-30-04.800A1-	4,8		161	200	169	28	5	☞
DC160-30-05.000A1-	5		161	200	169	28	5	☞
DC160-30-05.500A1-	5,5		178	225	187	36	6	☞
DC160-30-05.556A1-	5,556	7/32"	195	242	204	36	6	☞
DC160-30-05.800A1-	5,8		195	242	204	36	6	☞
DC160-30-06.000A1-	6		195	242	204	36	6	☞
DC160-30-06.100A1-	6,1		217	268	228	36	8	☞
DC160-30-06.350A1-	6,35	1/4"	217	268	228	36	8	☞
DC160-30-06.500A1-	6,5		217	268	228	36	8	☞
DC160-30-06.800A1-	6,8		217	268	228	36	8	☞
DC160-30-07.000A1-	7		217	268	228	36	8	☞
DC160-30-07.144A1-	7,144	9/32"	244	294	256	36	8	☞
DC160-30-07.400A1-	7,4		244	294	256	36	8	☞
DC160-30-07.500A1-	7,5		244	294	256	36	8	☞
DC160-30-07.938A1-	7,938	5/16"	244	294	256	36	8	☞
DC160-30-08.000A1-	8		244	294	256	36	8	☞
DC160-30-08.300A1-	8,3		273	330	287	40	10	☞
DC160-30-08.500A1-	8,5		273	330	287	40	10	☞
DC160-30-08.731A1-	8,731	11/32"	273	330	287	40	10	☞
DC160-30-09.000A1-	9		273	330	287	40	10	☞
DC160-30-09.525A1-	9,525	3/8"	305	364	320	40	10	☞
DC160-30-09.800A1-	9,8		305	364	320	40	10	☞
DC160-30-10.000A1-	10		305	364	320	40	10	☞
DC160-30-10.200A1-	10,2		335	401	352	45	12	☞
DC160-30-10.319A1-	10,319	13/32"	335	401	352	45	12	☞
DC160-30-11.000A1-	11		335	401	352	45	12	☞
DC160-30-11.113A1-	11,113	7/16"	364	430	382	45	12	☞
DC160-30-11.500A1-	11,5		364	430	382	45	12	☞
DC160-30-11.800A1-	11,8		364	430	382	45	12	☞
DC160-30-11.906A1-	11,906	15/32"	364	430	382	45	12	☞
DC160-30-12.000A1-	12		364	430	382	45	12	☞

Ordering example for the WJ30EU grade: DC160-30-03.000A1-WJ30EU

B 1

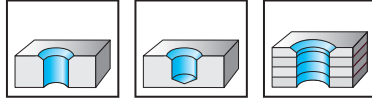
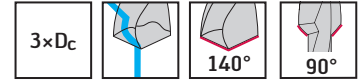
Solid carbide chamfer drills

DC260 Advance

X-treme Evo



- Step length in accordance with DIN 8378
- For thread core hole drilling



	P	M	K	N	S	H	O
WJ30ET	●	●	●	●	●	●	●

B 1

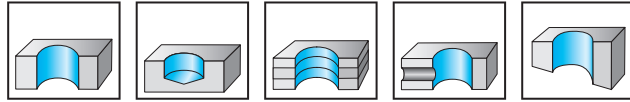
	Designation	For thread	D _c m7 mm	d ₁₀ h7 mm	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC260-03-03.300A0-	M 4	3,3	5	11	66	28	36	6	●
	DC260-03-04.200A0-	M 5	4,2	6	14	66	28	36	6	●
	DC260-03-05.000A0-	M 6	5	8	17	79	41	36	8	●
	DC260-03-06.800A0-	M 8	6,8	10	21	89	47	40	10	●
	DC260-03-08.500A0-	M 10	8,5	12	26	102	55	45	12	●
	DC260-03-10.200A0-	M 12	10,2	14	30	107	60	45	14	●
	DC260-03-12.000A0-	M 14	12	16	35	115	65	48	16	●
	DC260-03-14.000A0-	M 16	14	18	39	123	73	48	18	●
Shank DIN 6535 HE 	DC260-03-03.300F0-	M 4	3,3	5	11	66	28	36	6	●
	DC260-03-04.200F0-	M 5	4,2	6	14	66	28	36	6	●
	DC260-03-05.000F0-	M 6	5	8	17	79	41	36	8	●
	DC260-03-06.800F0-	M 8	6,8	10	21	89	47	40	10	●
	DC260-03-07.000F0-	M 8 X 1	7	10	21	89	47	40	10	●
	DC260-03-08.500F0-	M 10	8,5	12	26	102	55	45	12	●
	DC260-03-09.000F0-	M 10 X 1	9	12	26	102	55	45	12	●
	DC260-03-10.200F0-	M 12	10,2	14	30	107	60	45	14	●
	DC260-03-10.500F0-	M 12 X 1,5	10,5	14	30	107	60	45	14	●
	DC260-03-12.000F0-	M 14	12	16	35	115	65	48	16	●
	DC260-03-12.500F0-	M 14 X 1,5	12,5	16	35	115	65	48	16	●
	DC260-03-14.000F0-	M 16	14	18	39	123	73	48	18	●
DC260-03-14.500F0-	M 16 X 1,5	14,5	18	39	123	73	48	18	●	

Ordering example for the WJ30ET grade: DC260-03-03.300A0-WJ30ET

Solid carbide twist drill

DC160 Advance

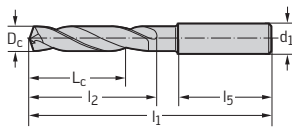
X-treme Evo



P	M	K	N	S	H	O
●	●	●	●	●	●	●

Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
DC160-03-03.000A0-	3		14	62	20	36	6	●
DC160-03-03.100A0-	3,1		14	62	20	36	6	●
DC160-03-03.175A0-	3,175	1/8"	14	62	20	36	6	●
DC160-03-03.200A0-	3,2		14	62	20	36	6	●
DC160-03-03.250A0-	3,25		14	62	20	36	6	●
DC160-03-03.300A0-	3,3		14	62	20	36	6	●
DC160-03-03.400A0-	3,4		14	62	20	36	6	●
DC160-03-03.500A0-	3,5		14	62	20	36	6	●
DC160-03-03.572A0-	3,572	9/64"	14	62	20	36	6	●
DC160-03-03.600A0-	3,6		14	62	20	36	6	●
DC160-03-03.650A0-	3,65		14	62	20	36	6	●
DC160-03-03.700A0-	3,7		14	62	20	36	6	●
DC160-03-03.800A0-	3,8		17	66	24	36	6	●
DC160-03-03.900A0-	3,9		17	66	24	36	6	●
DC160-03-03.969A0-	3,969	5/32"	17	66	24	36	6	●
DC160-03-04.000A0-	4		17	66	24	36	6	●
DC160-03-04.100A0-	4,1		17	66	24	36	6	●
DC160-03-04.200A0-	4,2		17	66	24	36	6	●
DC160-03-04.300A0-	4,3		17	66	24	36	6	●
DC160-03-04.366A0-	4,366	11/64"	17	66	24	36	6	●
DC160-03-04.400A0-	4,4		17	66	24	36	6	●
DC160-03-04.500A0-	4,5		17	66	24	36	6	●
DC160-03-04.600A0-	4,6		17	66	24	36	6	●
DC160-03-04.650A0-	4,65		17	66	24	36	6	●
DC160-03-04.700A0-	4,7		17	66	24	36	6	●
DC160-03-04.763A0-	4,763	3/16"	20	66	28	36	6	●
DC160-03-04.800A0-	4,8		20	66	28	36	6	●
DC160-03-04.900A0-	4,9		20	66	28	36	6	●
DC160-03-05.000A0-	5		20	66	28	36	6	●
DC160-03-05.100A0-	5,1		20	66	28	36	6	●
DC160-03-05.159A0-	5,159	13/64"	20	66	28	36	6	●
DC160-03-05.200A0-	5,2		20	66	28	36	6	●
DC160-03-05.300A0-	5,3		20	66	28	36	6	●
DC160-03-05.400A0-	5,4		20	66	28	36	6	●
DC160-03-05.500A0-	5,5		20	66	28	36	6	●
DC160-03-05.550A0-	5,55		20	66	28	36	6	●
DC160-03-05.556A0-	5,556	7/32"	20	66	28	36	6	●
DC160-03-05.600A0-	5,6		20	66	28	36	6	●
DC160-03-05.700A0-	5,7		20	66	28	36	6	●
DC160-03-05.800A0-	5,8		20	66	28	36	6	●
DC160-03-05.900A0-	5,9		20	66	28	36	6	●
DC160-03-05.953A0-	5,953	15/64"	20	66	28	36	6	●
DC160-03-06.000A0-	6		20	66	28	36	6	●

Shank DIN 6535 HA



Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

Continued

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-06.100A0-	6,1		24	79	34	36	8	WJ30ET
	DC160-03-06.200A0-	6,2		24	79	34	36	8	WJ30ET
	DC160-03-06.300A0-	6,3		24	79	34	36	8	WJ30ET
	DC160-03-06.350A0-	6,35	1/4"	24	79	34	36	8	WJ30ET
	DC160-03-06.400A0-	6,4		24	79	34	36	8	WJ30ET
	DC160-03-06.500A0-	6,5		24	79	34	36	8	WJ30ET
	DC160-03-06.600A0-	6,6		24	79	34	36	8	WJ30ET
	DC160-03-06.700A0-	6,7		24	79	34	36	8	WJ30ET
	DC160-03-06.747A0-	6,747	17/64"	24	79	34	36	8	WJ30ET
	DC160-03-06.800A0-	6,8		24	79	34	36	8	WJ30ET
	DC160-03-06.900A0-	6,9		24	79	34	36	8	WJ30ET
	DC160-03-07.000A0-	7		24	79	34	36	8	WJ30ET
	DC160-03-07.100A0-	7,1		29	79	41	36	8	WJ30ET
	DC160-03-07.144A0-	7,144	9/32"	29	79	41	36	8	WJ30ET
	DC160-03-07.200A0-	7,2		29	79	41	36	8	WJ30ET
	DC160-03-07.300A0-	7,3		29	79	41	36	8	WJ30ET
	DC160-03-07.400A0-	7,4		29	79	41	36	8	WJ30ET
	DC160-03-07.500A0-	7,5		29	79	41	36	8	WJ30ET
	DC160-03-07.541A0-	7,541	19/64"	29	79	41	36	8	WJ30ET
	DC160-03-07.550A0-	7,55		29	79	41	36	8	WJ30ET
	DC160-03-07.600A0-	7,6		29	79	41	36	8	WJ30ET
	DC160-03-07.700A0-	7,7		29	79	41	36	8	WJ30ET
	DC160-03-07.800A0-	7,8		29	79	41	36	8	WJ30ET
	DC160-03-07.900A0-	7,9		29	79	41	36	8	WJ30ET
	DC160-03-07.938A0-	7,938	5/16"	29	79	41	36	8	WJ30ET
	DC160-03-08.000A0-	8		29	79	41	36	8	WJ30ET
	DC160-03-08.100A0-	8,1		35	89	47	40	10	WJ30ET
	DC160-03-08.200A0-	8,2		35	89	47	40	10	WJ30ET
	DC160-03-08.300A0-	8,3		35	89	47	40	10	WJ30ET
	DC160-03-08.334A0-	8,334	21/64"	35	89	47	40	10	WJ30ET
	DC160-03-08.400A0-	8,4		35	89	47	40	10	WJ30ET
	DC160-03-08.500A0-	8,5		35	89	47	40	10	WJ30ET
	DC160-03-08.600A0-	8,6		35	89	47	40	10	WJ30ET
	DC160-03-08.700A0-	8,7		35	89	47	40	10	WJ30ET
	DC160-03-08.731A0-	8,731	11/32"	35	89	47	40	10	WJ30ET
	DC160-03-08.800A0-	8,8		35	89	47	40	10	WJ30ET
DC160-03-08.900A0-	8,9		35	89	47	40	10	WJ30ET	
DC160-03-09.000A0-	9		35	89	47	40	10	WJ30ET	
DC160-03-09.100A0-	9,1		35	89	47	40	10	WJ30ET	
DC160-03-09.128A0-	9,128	23/64"	35	89	47	40	10	WJ30ET	
DC160-03-09.200A0-	9,2		35	89	47	40	10	WJ30ET	
DC160-03-09.300A0-	9,3		35	89	47	40	10	WJ30ET	
DC160-03-09.400A0-	9,4		35	89	47	40	10	WJ30ET	
DC160-03-09.500A0-	9,5		35	89	47	40	10	WJ30ET	
DC160-03-09.525A0-	9,525	3/8"	35	89	47	40	10	WJ30ET	
DC160-03-09.550A0-	9,55		35	89	47	40	10	WJ30ET	
DC160-03-09.600A0-	9,6		35	89	47	40	10	WJ30ET	
DC160-03-09.700A0-	9,7		35	89	47	40	10	WJ30ET	
DC160-03-09.800A0-	9,8		35	89	47	40	10	WJ30ET	
DC160-03-09.900A0-	9,9		35	89	47	40	10	WJ30ET	
DC160-03-09.922A0-	9,922	25/64"	35	89	47	40	10	WJ30ET	
DC160-03-10.000A0-	10		35	89	47	40	10	WJ30ET	
DC160-03-10.100A0-	10,1		40	102	55	45	12	WJ30ET	
DC160-03-10.200A0-	10,2		40	102	55	45	12	WJ30ET	
DC160-03-10.300A0-	10,3		40	102	55	45	12	WJ30ET	
DC160-03-10.319A0-	10,319	13/32"	40	102	55	45	12	WJ30ET	
DC160-03-10.400A0-	10,4		40	102	55	45	12	WJ30ET	
DC160-03-10.500A0-	10,5		40	102	55	45	12	WJ30ET	
DC160-03-10.600A0-	10,6		40	102	55	45	12	WJ30ET	
DC160-03-10.700A0-	10,7		40	102	55	45	12	WJ30ET	
DC160-03-10.716A0-	10,716	27/64"	40	102	55	45	12	WJ30ET	

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

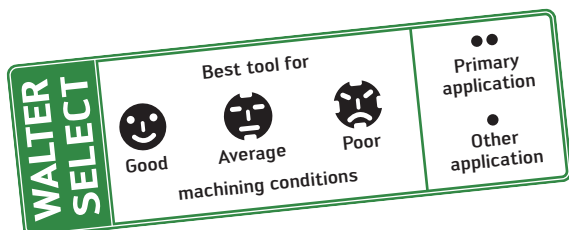
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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-10.800A0-	10,8		40	102	55	45	12	☺
	DC160-03-10.900A0-	10,9		40	102	55	45	12	☺
	DC160-03-11.000A0-	11		40	102	55	45	12	☺
	DC160-03-11.100A0-	11,1		40	102	55	45	12	☺
	DC160-03-11.113A0-	11,113	7/16"	40	102	55	45	12	☺
	DC160-03-11.200A0-	11,2		40	102	55	45	12	☺
	DC160-03-11.300A0-	11,3		40	102	55	45	12	☺
	DC160-03-11.400A0-	11,4		40	102	55	45	12	☺
	DC160-03-11.500A0-	11,5		40	102	55	45	12	☺
	DC160-03-11.509A0-	11,509	29/64"	40	102	55	45	12	☺
	DC160-03-11.550A0-	11,55		40	102	55	45	12	☺
	DC160-03-11.600A0-	11,6		40	102	55	45	12	☺
	DC160-03-11.700A0-	11,7		40	102	55	45	12	☺
	DC160-03-11.800A0-	11,8		40	102	55	45	12	☺
	DC160-03-11.900A0-	11,9		40	102	55	45	12	☺
	DC160-03-11.906A0-	11,906	15/32"	40	102	55	45	12	☺
	DC160-03-12.000A0-	12		40	102	55	45	12	☺
	DC160-03-12.100A0-	12,1		43	107	60	45	14	☺
	DC160-03-12.200A0-	12,2		43	107	60	45	14	☺
	DC160-03-12.250A0-	12,25		43	107	60	45	14	☺
	DC160-03-12.300A0-	12,3		43	107	60	45	14	☺
	DC160-03-12.303A0-	12,303	31/64"	43	107	60	45	14	☺
	DC160-03-12.400A0-	12,4		43	107	60	45	14	☺
	DC160-03-12.500A0-	12,5		43	107	60	45	14	☺
	DC160-03-12.600A0-	12,6		43	107	60	45	14	☺
	DC160-03-12.700A0-	12,7	1/2"	43	107	60	45	14	☺
	DC160-03-12.750A0-	12,75		43	107	60	45	14	☺
	DC160-03-12.800A0-	12,8		43	107	60	45	14	☺
	DC160-03-12.900A0-	12,9		43	107	60	45	14	☺
	DC160-03-13.000A0-	13		43	107	60	45	14	☺
	DC160-03-13.100A0-	13,1		43	107	60	45	14	☺
	DC160-03-13.200A0-	13,2		43	107	60	45	14	☺
	DC160-03-13.300A0-	13,3		43	107	60	45	14	☺
	DC160-03-13.400A0-	13,4		43	107	60	45	14	☺
	DC160-03-13.494A0-	13,494	17/32"	43	107	60	45	14	☺
DC160-03-13.500A0-	13,5		43	107	60	45	14	☺	
DC160-03-13.600A0-	13,6		43	107	60	45	14	☺	
DC160-03-13.700A0-	13,7		43	107	60	45	14	☺	
DC160-03-13.800A0-	13,8		43	107	60	45	14	☺	
DC160-03-13.900A0-	13,9		43	107	60	45	14	☺	
DC160-03-14.000A0-	14		43	107	60	45	14	☺	
DC160-03-14.100A0-	14,1		45	115	65	48	16	☺	
DC160-03-14.200A0-	14,2		45	115	65	48	16	☺	
DC160-03-14.288A0-	14,288	9/16"	45	115	65	48	16	☺	
DC160-03-14.300A0-	14,3		45	115	65	48	16	☺	
DC160-03-14.400A0-	14,4		45	115	65	48	16	☺	
DC160-03-14.500A0-	14,5		45	115	65	48	16	☺	
DC160-03-14.600A0-	14,6		45	115	65	48	16	☺	
DC160-03-14.700A0-	14,7		45	115	65	48	16	☺	
DC160-03-14.750A0-	14,75		45	115	65	48	16	☺	
DC160-03-14.800A0-	14,8		45	115	65	48	16	☺	
DC160-03-15.000A0-	15		45	115	65	48	16	☺	
DC160-03-15.100A0-	15,1		45	115	65	48	16	☺	
DC160-03-15.200A0-	15,2		45	115	65	48	16	☺	
DC160-03-15.300A0-	15,3		45	115	65	48	16	☺	
DC160-03-15.500A0-	15,5		45	115	65	48	16	☺	
DC160-03-15.600A0-	15,6		45	115	65	48	16	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

Continued



B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-03-15.700A0-	15,7		45	115	65	48	16	WJ30ET
	DC160-03-15.800A0-	15,8		45	115	65	48	16	WJ30ET
	DC160-03-15.875A0-	15,875	5/8"	45	115	65	48	16	WJ30ET
	DC160-03-15.900A0-	15,9		45	115	65	48	16	WJ30ET
	DC160-03-16.000A0-	16		45	115	65	48	16	WJ30ET
	DC160-03-16.100A0-	16,1		51	123	73	48	18	WJ30ET
	DC160-03-16.200A0-	16,2		51	123	73	48	18	WJ30ET
	DC160-03-16.300A0-	16,3		51	123	73	48	18	WJ30ET
	DC160-03-16.400A0-	16,4		51	123	73	48	18	WJ30ET
	DC160-03-16.500A0-	16,5		51	123	73	48	18	WJ30ET
	DC160-03-16.600A0-	16,6		51	123	73	48	18	WJ30ET
	DC160-03-16.700A0-	16,7		51	123	73	48	18	WJ30ET
	DC160-03-16.750A0-	16,75		51	123	73	48	18	WJ30ET
	DC160-03-16.800A0-	16,8		51	123	73	48	18	WJ30ET
	DC160-03-17.000A0-	17		51	123	73	48	18	WJ30ET
	DC160-03-17.200A0-	17,2		51	123	73	48	18	WJ30ET
	DC160-03-17.300A0-	17,3		51	123	73	48	18	WJ30ET
	DC160-03-17.500A0-	17,5		51	123	73	48	18	WJ30ET
	DC160-03-17.600A0-	17,6		51	123	73	48	18	WJ30ET
	DC160-03-17.700A0-	17,7		51	123	73	48	18	WJ30ET
DC160-03-17.800A0-	17,8		51	123	73	48	18	WJ30ET	
DC160-03-18.000A0-	18		51	123	73	48	18	WJ30ET	
DC160-03-18.200A0-	18,2		55	131	79	50	20	WJ30ET	
DC160-03-18.500A0-	18,5		55	131	79	50	20	WJ30ET	
DC160-03-18.700A0-	18,7		55	131	79	50	20	WJ30ET	
DC160-03-18.800A0-	18,8		55	131	79	50	20	WJ30ET	
DC160-03-19.000A0-	19		55	131	79	50	20	WJ30ET	
DC160-03-19.050A0-	19,05	3/4"	55	131	79	50	20	WJ30ET	
DC160-03-19.500A0-	19,5		55	131	79	50	20	WJ30ET	
DC160-03-19.700A0-	19,7		55	131	79	50	20	WJ30ET	
DC160-03-19.800A0-	19,8		55	131	79	50	20	WJ30ET	
DC160-03-20.000A0-	20		55	131	79	50	20	WJ30ET	
Shank DIN 6535 HE 	DC160-03-03.000F0-	3		14	62	20	36	6	WJ30ET
	DC160-03-03.100F0-	3,1		14	62	20	36	6	WJ30ET
	DC160-03-03.200F0-	3,2		14	62	20	36	6	WJ30ET
	DC160-03-03.250F0-	3,25		14	62	20	36	6	WJ30ET
	DC160-03-03.300F0-	3,3		14	62	20	36	6	WJ30ET
	DC160-03-03.400F0-	3,4		14	62	20	36	6	WJ30ET
	DC160-03-03.500F0-	3,5		14	62	20	36	6	WJ30ET
	DC160-03-03.600F0-	3,6		14	62	20	36	6	WJ30ET
	DC160-03-03.650F0-	3,65		14	62	20	36	6	WJ30ET
	DC160-03-03.700F0-	3,7		14	62	20	36	6	WJ30ET
	DC160-03-03.800F0-	3,8		17	66	24	36	6	WJ30ET
	DC160-03-03.900F0-	3,9		17	66	24	36	6	WJ30ET
	DC160-03-04.000F0-	4		17	66	24	36	6	WJ30ET
	DC160-03-04.100F0-	4,1		17	66	24	36	6	WJ30ET
	DC160-03-04.200F0-	4,2		17	66	24	36	6	WJ30ET
	DC160-03-04.300F0-	4,3		17	66	24	36	6	WJ30ET
	DC160-03-04.400F0-	4,4		17	66	24	36	6	WJ30ET
	DC160-03-04.500F0-	4,5		17	66	24	36	6	WJ30ET
	DC160-03-04.600F0-	4,6		17	66	24	36	6	WJ30ET
	DC160-03-04.650F0-	4,65		17	66	24	36	6	WJ30ET
	DC160-03-04.700F0-	4,7		17	66	24	36	6	WJ30ET
	DC160-03-04.800F0-	4,8		20	66	28	36	6	WJ30ET
	DC160-03-04.900F0-	4,9		20	66	28	36	6	WJ30ET
	DC160-03-05.000F0-	5		20	66	28	36	6	WJ30ET
	DC160-03-05.100F0-	5,1		20	66	28	36	6	WJ30ET
	DC160-03-05.200F0-	5,2		20	66	28	36	6	WJ30ET
	DC160-03-05.300F0-	5,3		20	66	28	36	6	WJ30ET
DC160-03-05.400F0-	5,4		20	66	28	36	6	WJ30ET	
DC160-03-05.500F0-	5,5		20	66	28	36	6	WJ30ET	

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	DC160-03-05.550FO-	5,55		20	66	28	36	6	☺
	DC160-03-05.600FO-	5,6		20	66	28	36	6	☺
	DC160-03-05.700FO-	5,7		20	66	28	36	6	☺
	DC160-03-05.800FO-	5,8		20	66	28	36	6	☺
	DC160-03-05.900FO-	5,9		20	66	28	36	6	☺
	DC160-03-06.000FO-	6		20	66	28	36	6	☺
	DC160-03-06.100FO-	6,1		24	79	34	36	8	☺
	DC160-03-06.200FO-	6,2		24	79	34	36	8	☺
	DC160-03-06.300FO-	6,3		24	79	34	36	8	☺
	DC160-03-06.400FO-	6,4		24	79	34	36	8	☺
	DC160-03-06.500FO-	6,5		24	79	34	36	8	☺
	DC160-03-06.600FO-	6,6		24	79	34	36	8	☺
	DC160-03-06.700FO-	6,7		24	79	34	36	8	☺
	DC160-03-06.800FO-	6,8		24	79	34	36	8	☺
	DC160-03-06.900FO-	6,9		24	79	34	36	8	☺
	DC160-03-07.000FO-	7		24	79	34	36	8	☺
	DC160-03-07.100FO-	7,1		29	79	41	36	8	☺
	DC160-03-07.200FO-	7,2		29	79	41	36	8	☺
	DC160-03-07.300FO-	7,3		29	79	41	36	8	☺
	DC160-03-07.400FO-	7,4		29	79	41	36	8	☺
	DC160-03-07.500FO-	7,5		29	79	41	36	8	☺
	DC160-03-07.550FO-	7,55		29	79	41	36	8	☺
	DC160-03-07.600FO-	7,6		29	79	41	36	8	☺
	DC160-03-07.700FO-	7,7		29	79	41	36	8	☺
	DC160-03-07.800FO-	7,8		29	79	41	36	8	☺
	DC160-03-07.900FO-	7,9		29	79	41	36	8	☺
	DC160-03-08.000FO-	8		29	79	41	36	8	☺
	DC160-03-08.100FO-	8,1		35	89	47	40	10	☺
	DC160-03-08.200FO-	8,2		35	89	47	40	10	☺
	DC160-03-08.300FO-	8,3		35	89	47	40	10	☺
	DC160-03-08.400FO-	8,4		35	89	47	40	10	☺
	DC160-03-08.500FO-	8,5		35	89	47	40	10	☺
	DC160-03-08.600FO-	8,6		35	89	47	40	10	☺
	DC160-03-08.700FO-	8,7		35	89	47	40	10	☺
	DC160-03-08.800FO-	8,8		35	89	47	40	10	☺
DC160-03-08.900FO-	8,9		35	89	47	40	10	☺	
DC160-03-09.000FO-	9		35	89	47	40	10	☺	
DC160-03-09.100FO-	9,1		35	89	47	40	10	☺	
DC160-03-09.200FO-	9,2		35	89	47	40	10	☺	
DC160-03-09.300FO-	9,3		35	89	47	40	10	☺	
DC160-03-09.400FO-	9,4		35	89	47	40	10	☺	
DC160-03-09.500FO-	9,5		35	89	47	40	10	☺	
DC160-03-09.550FO-	9,55		35	89	47	40	10	☺	
DC160-03-09.600FO-	9,6		35	89	47	40	10	☺	
DC160-03-09.700FO-	9,7		35	89	47	40	10	☺	
DC160-03-09.800FO-	9,8		35	89	47	40	10	☺	
DC160-03-09.900FO-	9,9		35	89	47	40	10	☺	
DC160-03-10.000FO-	10		35	89	47	40	10	☺	
DC160-03-10.100FO-	10,1		40	102	55	45	12	☺	
DC160-03-10.200FO-	10,2		40	102	55	45	12	☺	
DC160-03-10.300FO-	10,3		40	102	55	45	12	☺	
DC160-03-10.400FO-	10,4		40	102	55	45	12	☺	
DC160-03-10.500FO-	10,5		40	102	55	45	12	☺	
DC160-03-10.600FO-	10,6		40	102	55	45	12	☺	
DC160-03-10.700FO-	10,7		40	102	55	45	12	☺	
DC160-03-10.800FO-	10,8		40	102	55	45	12	☺	
DC160-03-10.900FO-	10,9		40	102	55	45	12	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

Continued

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	DC160-03-11.000FO-	11		40	102	55	45	12	☺
	DC160-03-11.100FO-	11,1		40	102	55	45	12	☺
	DC160-03-11.200FO-	11,2		40	102	55	45	12	☺
	DC160-03-11.300FO-	11,3		40	102	55	45	12	☺
	DC160-03-11.400FO-	11,4		40	102	55	45	12	☺
	DC160-03-11.500FO-	11,5		40	102	55	45	12	☺
	DC160-03-11.550FO-	11,55		40	102	55	45	12	☺
	DC160-03-11.600FO-	11,6		40	102	55	45	12	☺
	DC160-03-11.700FO-	11,7		40	102	55	45	12	☺
	DC160-03-11.800FO-	11,8		40	102	55	45	12	☺
	DC160-03-11.900FO-	11,9		40	102	55	45	12	☺
	DC160-03-12.000FO-	12		40	102	55	45	12	☺
	DC160-03-12.100FO-	12,1		43	107	60	45	14	☺
	DC160-03-12.200FO-	12,2		43	107	60	45	14	☺
	DC160-03-12.250FO-	12,25		43	107	60	45	14	☺
	DC160-03-12.300FO-	12,3		43	107	60	45	14	☺
	DC160-03-12.400FO-	12,4		43	107	60	45	14	☺
	DC160-03-12.500FO-	12,5		43	107	60	45	14	☺
	DC160-03-12.600FO-	12,6		43	107	60	45	14	☺
	DC160-03-12.700FO-	12,7	1/2"	43	107	60	45	14	☺
	DC160-03-12.750FO-	12,75		43	107	60	45	14	☺
	DC160-03-12.800FO-	12,8		43	107	60	45	14	☺
	DC160-03-12.900FO-	12,9		43	107	60	45	14	☺
	DC160-03-13.000FO-	13		43	107	60	45	14	☺
	DC160-03-13.100FO-	13,1		43	107	60	45	14	☺
	DC160-03-13.200FO-	13,2		43	107	60	45	14	☺
	DC160-03-13.300FO-	13,3		43	107	60	45	14	☺
	DC160-03-13.400FO-	13,4		43	107	60	45	14	☺
	DC160-03-13.500FO-	13,5		43	107	60	45	14	☺
	DC160-03-13.600FO-	13,6		43	107	60	45	14	☺
	DC160-03-13.700FO-	13,7		43	107	60	45	14	☺
	DC160-03-13.800FO-	13,8		43	107	60	45	14	☺
	DC160-03-13.900FO-	13,9		43	107	60	45	14	☺
	DC160-03-14.000FO-	14		43	107	60	45	14	☺
DC160-03-14.100FO-	14,1		45	115	65	48	16	☺	
DC160-03-14.200FO-	14,2		45	115	65	48	16	☺	
DC160-03-14.300FO-	14,3		45	115	65	48	16	☺	
DC160-03-14.400FO-	14,4		45	115	65	48	16	☺	
DC160-03-14.500FO-	14,5		45	115	65	48	16	☺	
DC160-03-14.600FO-	14,6		45	115	65	48	16	☺	
DC160-03-14.700FO-	14,7		45	115	65	48	16	☺	
DC160-03-14.750FO-	14,75		45	115	65	48	16	☺	
DC160-03-14.800FO-	14,8		45	115	65	48	16	☺	
DC160-03-15.000FO-	15		45	115	65	48	16	☺	
DC160-03-15.100FO-	15,1		45	115	65	48	16	☺	
DC160-03-15.200FO-	15,2		45	115	65	48	16	☺	
DC160-03-15.300FO-	15,3		45	115	65	48	16	☺	
DC160-03-15.500FO-	15,5		45	115	65	48	16	☺	
DC160-03-15.600FO-	15,6		45	115	65	48	16	☺	
DC160-03-15.700FO-	15,7		45	115	65	48	16	☺	
DC160-03-15.800FO-	15,8		45	115	65	48	16	☺	
DC160-03-15.900FO-	15,9		45	115	65	48	16	☺	
DC160-03-16.000FO-	16		45	115	65	48	16	☺	
DC160-03-16.100FO-	16,1		51	123	73	48	18	☺	
DC160-03-16.200FO-	16,2		51	123	73	48	18	☺	
DC160-03-16.300FO-	16,3		51	123	73	48	18	☺	
DC160-03-16.400FO-	16,4		51	123	73	48	18	☺	
DC160-03-16.500FO-	16,5		51	123	73	48	18	☺	
DC160-03-16.600FO-	16,6		51	123	73	48	18	☺	
DC160-03-16.700FO-	16,7		51	123	73	48	18	☺	
DC160-03-16.750FO-	16,75		51	123	73	48	18	☺	

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

Continued

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	Shank DIN 6535 HE	DC160-03-16.800F0-	16,8	51	123	73	48	18	☺
		DC160-03-17.000F0-	17	51	123	73	48	18	☺
		DC160-03-17.200F0-	17,2	51	123	73	48	18	☺
		DC160-03-17.300F0-	17,3	51	123	73	48	18	☺
		DC160-03-17.500F0-	17,5	51	123	73	48	18	☺
		DC160-03-17.600F0-	17,6	51	123	73	48	18	☺
		DC160-03-17.700F0-	17,7	51	123	73	48	18	☺
		DC160-03-17.800F0-	17,8	51	123	73	48	18	☺
		DC160-03-18.000F0-	18	51	123	73	48	18	☺
		DC160-03-18.200F0-	18,2	55	131	79	50	20	☺
		DC160-03-18.500F0-	18,5	55	131	79	50	20	☺
		DC160-03-18.700F0-	18,7	55	131	79	50	20	☺
		DC160-03-18.800F0-	18,8	55	131	79	50	20	☺
		DC160-03-19.000F0-	19	55	131	79	50	20	☺
		DC160-03-19.500F0-	19,5	55	131	79	50	20	☺
		DC160-03-19.700F0-	19,7	55	131	79	50	20	☺
		DC160-03-19.800F0-	19,8	55	131	79	50	20	☺
		DC160-03-20.000F0-	20	55	131	79	50	20	☺

Ordering example for the WJ30ET grade: DC160-03-03.000A0-WJ30ET

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

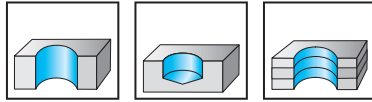
B 1

Solid carbide twist drill

DC150 Perform



– Up to 1.9 mm dimensions in accordance with DIN 1897

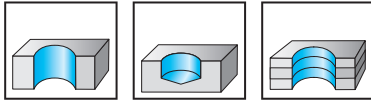


	P	M	K	N	S	H	O
WJ30RE	●	●	●	●	●	●	●

	Designation	D _c h7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	d ₁ h6 mm	WJ30RE
Parallel shank 	DC150-03-01.500U0-	1,5		6	32	9	1,5	⊕
	DC150-03-01.588U0-	1,588	1/16"	7	34	10	1,588	⊕
	DC150-03-01.600U0-	1,6		7	34	10	1,6	⊕
	DC150-03-01.700U0-	1,7		7	34	10	1,7	⊕
	DC150-03-01.800U0-	1,8		8	36	11	1,8	⊕
	DC150-03-01.820U0-	1,82		8	36	11	1,82	⊕
	DC150-03-01.900U0-	1,9		8	36	11	1,9	⊕
	DC150-03-01.984U0-	1,984	5/64"	8	38	12	1,984	⊕
	DC150-03-02.000U0-	2		8	38	12	2	⊕
	DC150-03-02.050U0-	2,05		8	38	12	2,05	⊕
	DC150-03-02.100U0-	2,1		8	38	12	2,1	⊕
	DC150-03-02.200U0-	2,2		9	40	13	2,2	⊕
	DC150-03-02.300U0-	2,3		9	40	13	2,3	⊕
	DC150-03-02.381U0-	2,381	3/32"	10	43	14	2,381	⊕
	DC150-03-02.400U0-	2,4		10	43	14	2,4	⊕
	DC150-03-02.500U0-	2,5		10	43	14	2,5	⊕
	DC150-03-02.600U0-	2,6		10	43	14	2,6	⊕
	DC150-03-02.700U0-	2,7		11	46	16	2,7	⊕
	DC150-03-02.778U0-	2,778	7/64"	11	46	16	2,778	⊕
	DC150-03-02.800U0-	2,8		11	46	16	2,8	⊕
DC150-03-02.900U0-	2,9		11	46	16	2,9	⊕	

Ordering example for the WJ30RE grade: DC150-03-01.500U0-WJ30RE

Solid carbide twist drill DC150 Perform



	Designation	D _c m7 mm	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30RE
DIN 6535 HE, turned 180° DIN 6535 HB	DC150-03-03.000D0-	3	14	62	20	36	6	●
	DC150-03-03.100D0-	3,1	14	62	20	36	6	●
	DC150-03-03.200D0-	3,2	14	62	20	36	6	●
	DC150-03-03.300D0-	3,3	14	62	20	36	6	●
	DC150-03-03.400D0-	3,4	14	62	20	36	6	●
	DC150-03-03.500D0-	3,5	14	62	20	36	6	●
	DC150-03-03.600D0-	3,6	14	62	20	36	6	●
	DC150-03-03.700D0-	3,7	14	62	20	36	6	●
	DC150-03-03.800D0-	3,8	17	66	24	36	6	●
	DC150-03-03.900D0-	3,9	17	66	24	36	6	●
	DC150-03-04.000D0-	4	17	66	24	36	6	●
	DC150-03-04.200D0-	4,2	17	66	24	36	6	●
	DC150-03-04.300D0-	4,3	17	66	24	36	6	●
	DC150-03-04.500D0-	4,5	17	66	24	36	6	●
	DC150-03-04.650D0-	4,65	17	66	24	36	6	●
	DC150-03-04.700D0-	4,7	17	66	24	36	6	●
	DC150-03-04.800D0-	4,8	20	66	28	36	6	●
	DC150-03-05.000D0-	5	20	66	28	36	6	●
	DC150-03-05.100D0-	5,1	20	66	28	36	6	●
	DC150-03-05.300D0-	5,3	20	66	28	36	6	●
	DC150-03-05.500D0-	5,5	20	66	28	36	6	●
	DC150-03-05.550D0-	5,55	20	66	28	36	6	●
	DC150-03-05.600D0-	5,6	20	66	28	36	6	●
	DC150-03-05.800D0-	5,8	20	66	28	36	6	●
	DC150-03-06.000D0-	6	20	66	28	36	6	●
	DC150-03-06.100D0-	6,1	24	79	34	36	8	●
	DC150-03-06.200D0-	6,2	24	79	34	36	8	●
	DC150-03-06.300D0-	6,3	24	79	34	36	8	●
	DC150-03-06.500D0-	6,5	24	79	34	36	8	●
	DC150-03-06.600D0-	6,6	24	79	34	36	8	●
DC150-03-06.700D0-	6,7	24	79	34	36	8	●	
DC150-03-06.800D0-	6,8	24	79	34	36	8	●	
DC150-03-07.000D0-	7	24	79	34	36	8	●	
DC150-03-07.100D0-	7,1	29	79	41	36	8	●	
DC150-03-07.400D0-	7,4	29	79	41	36	8	●	
DC150-03-07.500D0-	7,5	29	79	41	36	8	●	
DC150-03-07.600D0-	7,6	29	79	41	36	8	●	
DC150-03-07.800D0-	7,8	29	79	41	36	8	●	
DC150-03-08.000D0-	8	29	79	41	36	8	●	
DC150-03-08.100D0-	8,1	35	89	47	40	10	●	
DC150-03-08.200D0-	8,2	35	89	47	40	10	●	
DC150-03-08.300D0-	8,3	35	89	47	40	10	●	
DC150-03-08.400D0-	8,4	35	89	47	40	10	●	

Ordering example for the WJ30RE grade: DC150-03-03.000D0-WJ30RE

Continued

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

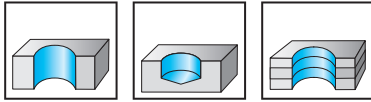
● Other application

Continued

		D_c m7 mm	L_c mm	l_1 mm	l_2 mm	l_5 mm	d_1 h6 mm	WJ30RE
DIN 6535 HE, turned 180°	DC150-03-08.500D0-	8,5	35	89	47	40	10	
	DC150-03-08.600D0-	8,6	35	89	47	40	10	
DIN 6535 HB	DC150-03-08.700D0-	8,7	35	89	47	40	10	
	DC150-03-08.800D0-	8,8	35	89	47	40	10	
	DC150-03-09.000D0-	9	35	89	47	40	10	
	DC150-03-09.100D0-	9,1	35	89	47	40	10	
	DC150-03-09.500D0-	9,5	35	89	47	40	10	
	DC150-03-09.700D0-	9,5	35	89	47	40	10	
	DC150-03-09.800D0-	9,8	35	89	47	40	10	
	DC150-03-10.000D0-	10	35	89	47	40	10	
	DC150-03-10.100D0-	10,1	40	102	55	45	12	
	DC150-03-10.200D0-	10,2	40	102	55	45	12	
	DC150-03-10.300D0-	10,3	40	102	55	45	12	
	DC150-03-10.400D0-	10,4	40	102	55	45	12	
	DC150-03-10.500D0-	10,5	40	102	55	45	12	
	DC150-03-10.600D0-	10,6	40	102	55	45	12	
	DC150-03-10.800D0-	10,8	40	102	55	45	12	
	DC150-03-10.900D0-	10,9	40	102	55	45	12	
	DC150-03-11.000D0-	11	40	102	55	45	12	
	DC150-03-11.100D0-	11,1	40	102	55	45	12	
	DC150-03-11.200D0-	11,2	40	102	55	45	12	
	DC150-03-11.300D0-	11,3	40	102	55	45	12	
	DC150-03-11.500D0-	11,5	40	102	55	45	12	
	DC150-03-11.600D0-	11,6	40	102	55	45	12	
DC150-03-11.800D0-	11,8	40	102	55	45	12		
DC150-03-12.000D0-	12	40	102	55	45	12		
DC150-03-12.200D0-	12,2	43	107	60	45	14		
DC150-03-12.300D0-	12,3	43	107	60	45	14		
DC150-03-12.500D0-	12,5	43	107	60	45	14		
DC150-03-13.000D0-	13	43	107	60	45	14		
DC150-03-13.200D0-	13,2	43	107	60	45	14		
DC150-03-13.300D0-	13,3	43	107	60	45	14		
DC150-03-13.400D0-	13,4	43	107	60	45	14		
DC150-03-13.500D0-	13,5	43	107	60	45	14		
DC150-03-13.600D0-	13,6	43	107	60	45	14		
DC150-03-13.800D0-	13,8	43	107	60	45	14		
DC150-03-14.000D0-	14	43	107	60	45	14		
DC150-03-14.500D0-	14,5	45	115	65	48	16		
DC150-03-15.000D0-	15	45	115	65	48	16		
DC150-03-15.100D0-	15,1	45	115	65	48	16		
DC150-03-16.000D0-	16	45	115	65	48	16		
DC150-03-16.500D0-	16,5	51	123	73	48	18		
DC150-03-17.000D0-	17	51	123	73	48	18		
DC150-03-17.500D0-	17,5	51	123	73	48	18		
DC150-03-18.000D0-	18	51	123	73	48	18		
DC150-03-18.500D0-	18,5	55	131	79	50	20		
DC150-03-19.000D0-	19	55	131	79	50	20		
DC150-03-20.000D0-	20	55	131	79	50	20		

Ordering example for the WJ30RE grade: DC150-03-03.000D0-WJ30RE

Solid carbide micro twist drills DB130 Advance



	Designation	D _c 0-0,004 mm	L _c mm	l ₁ mm	l ₂ mm	d ₁ h8 mm	WJ30UU
Parallel shank 	DB130-05-00.100U0-	0,1	0,3	25	0,5	1	●●
	DB130-05-00.110U0-	0,11	0,3	25	0,5	1	●●
	DB130-05-00.120U0-	0,12	0,3	25	0,5	1	●●
	DB130-05-00.130U0-	0,13	0,5	25	0,8	1	●●
	DB130-05-00.140U0-	0,14	0,5	25	0,8	1	●●
	DB130-05-00.150U0-	0,15	0,5	25	0,8	1	●●
	DB130-05-00.160U0-	0,16	0,8	25	1,1	1	●●
	DB130-05-00.170U0-	0,17	0,8	25	1,1	1	●●
	DB130-05-00.180U0-	0,18	0,8	25	1,1	1	●●
	DB130-05-00.190U0-	0,19	0,8	25	1,1	1	●●
	DB130-05-00.200U0-	0,2	1,1	25	1,5	1	●●
	DB130-05-00.210U0-	0,21	1,1	25	1,5	1	●●
	DB130-05-00.220U0-	0,22	1,1	25	1,5	1	●●
	DB130-05-00.230U0-	0,23	1,1	25	1,5	1	●●
	DB130-05-00.240U0-	0,24	1,1	25	1,5	1	●●
	DB130-05-00.250U0-	0,25	1,4	25	1,9	1	●●
	DB130-05-00.260U0-	0,26	1,4	25	1,9	1	●●
	DB130-05-00.270U0-	0,27	1,4	25	1,9	1	●●
	DB130-05-00.280U0-	0,28	1,4	25	1,9	1	●●
	DB130-05-00.290U0-	0,29	1,4	25	1,9	1	●●
	DB130-05-00.300U0-	0,3	1,4	25	1,9	1	●●
	DB130-05-00.310U0-	0,31	1,8	25	2,4	1	●●
	DB130-05-00.320U0-	0,32	1,8	25	2,4	1	●●
	DB130-05-00.330U0-	0,33	1,8	25	2,4	1	●●
	DB130-05-00.340U0-	0,34	1,8	25	2,4	1	●●
	DB130-05-00.350U0-	0,35	1,8	25	2,4	1	●●
	DB130-05-00.360U0-	0,36	1,8	25	2,4	1	●●
	DB130-05-00.370U0-	0,37	1,8	25	2,4	1	●●
	DB130-05-00.380U0-	0,38	1,8	25	2,4	1	●●
	DB130-05-00.390U0-	0,39	2,2	25	3	1	●●
	DB130-05-00.400U0-	0,4	2,2	25	3	1	●●
	DB130-05-00.410U0-	0,41	2,2	25	3	1	●●
	DB130-05-00.420U0-	0,42	2,2	25	3	1	●●
DB130-05-00.430U0-	0,43	2,2	25	3	1	●●	
DB130-05-00.440U0-	0,44	2,2	25	3	1	●●	
DB130-05-00.450U0-	0,45	2,2	25	3	1	●●	
DB130-05-00.460U0-	0,46	2,2	25	3	1	●●	
DB130-05-00.470U0-	0,47	2,2	25	3	1	●●	
DB130-05-00.480U0-	0,48	2,2	25	3	1	●●	
DB130-05-00.490U0-	0,49	2,6	25	3,4	1	●●	
DB130-05-00.500U0-	0,5	2,6	25	3,4	1	●●	
DB130-05-00.510U0-	0,51	2,6	25	3,4	1	●●	
DB130-05-00.520U0-	0,52	2,6	25	3,4	1	●●	

Ordering example for the WJ30UU grade: DB130-05-00.100U0-WJ30UU

Continued

WALTER SELECT

Best tool for

 Good
 Average
 Poor

Primary application

Other application

machining conditions

Continued

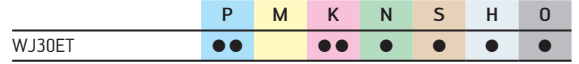
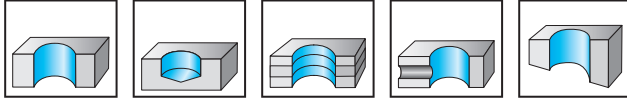
	Designation	D_c 0-0,004 mm	L_c mm	l_1 mm	l_2 mm	d_1 h8 mm	WJ30UU
Parallel shank 	DB130-05-00.530U0-	0,53	2,6	25	3,4	1	☺
	DB130-05-00.540U0-	0,54	3	25	3,9	1	☺
	DB130-05-00.550U0-	0,55	3	25	3,9	1	☺
	DB130-05-00.560U0-	0,56	3	25	3,9	1	☺
	DB130-05-00.570U0-	0,57	3	25	3,9	1	☺
	DB130-05-00.580U0-	0,58	3	25	3,9	1	☺
	DB130-05-00.590U0-	0,59	3	25	3,9	1	☺
	DB130-05-00.600U0-	0,6	3	25	3,9	1	☺
	DB130-05-00.610U0-	0,61	3,1	25	4,2	1	☺
	DB130-05-00.620U0-	0,62	3,1	25	4,2	1	☺
	DB130-05-00.630U0-	0,63	3,1	25	4,2	1	☺
	DB130-05-00.640U0-	0,64	3,1	25	4,2	1	☺
	DB130-05-00.650U0-	0,65	3,1	25	4,2	1	☺
	DB130-05-00.660U0-	0,66	3,1	25	4,2	1	☺
	DB130-05-00.670U0-	0,67	3,1	25	4,2	1	☺
	DB130-05-00.680U0-	0,68	3,6	25	4,8	1	☺
	DB130-05-00.690U0-	0,69	3,6	25	4,8	1	☺
	DB130-05-00.700U0-	0,7	3,6	25	4,8	1	☺
	DB130-05-00.710U0-	0,71	3,6	25	4,8	1	☺
	DB130-05-00.720U0-	0,72	3,6	25	4,8	1	☺
	DB130-05-00.730U0-	0,73	3,6	25	4,8	1	☺
	DB130-05-00.740U0-	0,74	3,6	25	4,8	1	☺
	DB130-05-00.750U0-	0,75	3,6	25	4,8	1	☺
	DB130-05-00.760U0-	0,76	4,1	25	5,3	1	☺
	DB130-05-00.770U0-	0,77	4,1	25	5,3	1	☺
	DB130-05-00.780U0-	0,78	4,1	25	5,3	1	☺
	DB130-05-00.790U0-	0,79	4,1	25	5,3	1	☺
	DB130-05-00.800U0-	0,8	4	25	5,3	1,5	☺
	DB130-05-00.810U0-	0,81	4	25	5,3	1,5	☺
	DB130-05-00.820U0-	0,82	4	25	5,3	1,5	☺
	DB130-05-00.830U0-	0,83	4	25	5,3	1,5	☺
	DB130-05-00.840U0-	0,84	4	25	5,3	1,5	☺
	DB130-05-00.850U0-	0,85	4	25	5,3	1,5	☺
	DB130-05-00.860U0-	0,86	4,5	25	6	1,5	☺
	DB130-05-00.870U0-	0,87	4,5	25	6	1,5	☺
	DB130-05-00.880U0-	0,88	4,5	25	6	1,5	☺
	DB130-05-00.890U0-	0,89	4,5	25	6	1,5	☺
	DB130-05-00.900U0-	0,9	4,5	25	6	1,5	☺
	DB130-05-00.910U0-	0,91	4,5	25	6	1,5	☺
	DB130-05-00.920U0-	0,92	4,5	25	6	1,5	☺
	DB130-05-00.930U0-	0,93	4,5	25	6	1,5	☺
	DB130-05-00.940U0-	0,94	4,5	25	6	1,5	☺
	DB130-05-00.950U0-	0,95	4,5	25	6	1,5	☺
	DB130-05-00.960U0-	0,96	5	25	6,8	1,5	☺
	DB130-05-00.970U0-	0,97	5	25	6,8	1,5	☺
DB130-05-00.980U0-	0,98	5	25	6,8	1,5	☺	
DB130-05-00.990U0-	0,99	5	25	6,8	1,5	☺	
DB130-05-01.000U0-	1	5	25	6,8	1,5	☺	
DB130-05-01.050U0-	1,05	5	25	6,8	1,5	☺	
DB130-05-01.100U0-	1,1	5	25	7,6	1,5	☺	
DB130-05-01.150U0-	1,15	5	25	7,6	1,5	☺	
DB130-05-01.200U0-	1,2	6	25	8,5	1,5	☺	
DB130-05-01.250U0-	1,25	6	25	8,5	1,5	☺	
DB130-05-01.300U0-	1,3	6	25	8,5	1,5	☺	
DB130-05-01.350U0-	1,35	7	25	9,5	1,5	☺	
DB130-05-01.400U0-	1,4	7	25	9,5	1,5	☺	
DB130-05-01.450U0-	1,45	7	25	9,5	1,5	☺	

Ordering example for the WJ30UU grade: DB130-05-00.100U0-WJ30UU

Solid carbide twist drill

DC160 Advance

X-treme Evo



Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
DC160-05-03.000A0-	3		23	66	28	36	6	●
DC160-05-03.100A0-	3,1		23	66	28	36	6	●
DC160-05-03.175A0-	3,175	1/8"	23	66	28	36	6	●
DC160-05-03.200A0-	3,2		23	66	28	36	6	●
DC160-05-03.250A0-	3,25		23	66	28	36	6	●
DC160-05-03.300A0-	3,3		23	66	28	36	6	●
DC160-05-03.400A0-	3,4		23	66	28	36	6	●
DC160-05-03.500A0-	3,5		23	66	28	36	6	●
DC160-05-03.572A0-	3,572	9/64"	23	66	28	36	6	●
DC160-05-03.600A0-	3,6		23	66	28	36	6	●
DC160-05-03.650A0-	3,65		23	66	28	36	6	●
DC160-05-03.700A0-	3,7		23	66	28	36	6	●
DC160-05-03.800A0-	3,8		29	74	36	36	6	●
DC160-05-03.900A0-	3,9		29	74	36	36	6	●
DC160-05-03.969A0-	3,969	5/32"	29	74	36	36	6	●
DC160-05-04.000A0-	4		29	74	36	36	6	●
DC160-05-04.100A0-	4,1		29	74	36	36	6	●
DC160-05-04.200A0-	4,2		29	74	36	36	6	●
DC160-05-04.300A0-	4,3		29	74	36	36	6	●
DC160-05-04.366A0-	4,366	11/64"	29	74	36	36	6	●
DC160-05-04.400A0-	4,4		29	74	36	36	6	●
DC160-05-04.500A0-	4,5		29	74	36	36	6	●
DC160-05-04.600A0-	4,6		29	74	36	36	6	●
DC160-05-04.650A0-	4,65		29	74	36	36	6	●
DC160-05-04.700A0-	4,7		29	74	36	36	6	●
DC160-05-04.763A0-	4,763	3/16"	35	82	44	36	6	●
DC160-05-04.800A0-	4,8		35	82	44	36	6	●
DC160-05-04.900A0-	4,9		35	82	44	36	6	●
DC160-05-05.000A0-	5		35	82	44	36	6	●
DC160-05-05.100A0-	5,1		35	82	44	36	6	●
DC160-05-05.159A0-	5,159	13/64"	35	82	44	36	6	●
DC160-05-05.200A0-	5,2		35	82	44	36	6	●
DC160-05-05.300A0-	5,3		35	82	44	36	6	●
DC160-05-05.400A0-	5,4		35	82	44	36	6	●
DC160-05-05.500A0-	5,5		35	82	44	36	6	●
DC160-05-05.550A0-	5,55		35	82	44	36	6	●
DC160-05-05.556A0-	5,556	7/32"	35	82	44	36	6	●
DC160-05-05.600A0-	5,6		35	82	44	36	6	●
DC160-05-05.700A0-	5,7		35	82	44	36	6	●
DC160-05-05.800A0-	5,8		35	82	44	36	6	●
DC160-05-05.900A0-	5,9		35	82	44	36	6	●
DC160-05-05.953A0-	5,953	15/64"	35	82	44	36	6	●
DC160-05-06.000A0-	6		35	82	44	36	6	●

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

Continued

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-06.100A0-	6,1		43	91	53	36	8	WJ30ET
	DC160-05-06.200A0-	6,2		43	91	53	36	8	WJ30ET
	DC160-05-06.300A0-	6,3		43	91	53	36	8	WJ30ET
	DC160-05-06.350A0-	6,35	1/4"	43	91	53	36	8	WJ30ET
	DC160-05-06.400A0-	6,4		43	91	53	36	8	WJ30ET
	DC160-05-06.500A0-	6,5		43	91	53	36	8	WJ30ET
	DC160-05-06.600A0-	6,6		43	91	53	36	8	WJ30ET
	DC160-05-06.700A0-	6,7		43	91	53	36	8	WJ30ET
	DC160-05-06.747A0-	6,747	17/64"	43	91	53	36	8	WJ30ET
	DC160-05-06.800A0-	6,8		43	91	53	36	8	WJ30ET
	DC160-05-06.900A0-	6,9		43	91	53	36	8	WJ30ET
	DC160-05-07.000A0-	7		43	91	53	36	8	WJ30ET
	DC160-05-07.100A0-	7,1		43	91	53	36	8	WJ30ET
	DC160-05-07.144A0-	7,144	9/32"	43	91	53	36	8	WJ30ET
	DC160-05-07.200A0-	7,2		43	91	53	36	8	WJ30ET
	DC160-05-07.300A0-	7,3		43	91	53	36	8	WJ30ET
	DC160-05-07.400A0-	7,4		43	91	53	36	8	WJ30ET
	DC160-05-07.500A0-	7,5		43	91	53	36	8	WJ30ET
	DC160-05-07.541A0-	7,541	19/64"	43	91	53	36	8	WJ30ET
	DC160-05-07.550A0-	7,55		43	91	53	36	8	WJ30ET
	DC160-05-07.600A0-	7,6		43	91	53	36	8	WJ30ET
	DC160-05-07.700A0-	7,7		43	91	53	36	8	WJ30ET
	DC160-05-07.800A0-	7,8		43	91	53	36	8	WJ30ET
	DC160-05-07.900A0-	7,9		43	91	53	36	8	WJ30ET
	DC160-05-07.938A0-	7,938	5/16"	43	91	53	36	8	WJ30ET
	DC160-05-08.000A0-	8		43	91	53	36	8	WJ30ET
	DC160-05-08.100A0-	8,1		49	103	61	40	10	WJ30ET
	DC160-05-08.200A0-	8,2		49	103	61	40	10	WJ30ET
	DC160-05-08.300A0-	8,3		49	103	61	40	10	WJ30ET
	DC160-05-08.334A0-	8,334	21/64"	49	103	61	40	10	WJ30ET
	DC160-05-08.400A0-	8,4		49	103	61	40	10	WJ30ET
	DC160-05-08.500A0-	8,5		49	103	61	40	10	WJ30ET
	DC160-05-08.600A0-	8,6		49	103	61	40	10	WJ30ET
	DC160-05-08.700A0-	8,7		49	103	61	40	10	WJ30ET
	DC160-05-08.731A0-	8,731	11/32"	49	103	61	40	10	WJ30ET
	DC160-05-08.800A0-	8,8		49	103	61	40	10	WJ30ET
DC160-05-08.900A0-	8,9		49	103	61	40	10	WJ30ET	
DC160-05-09.000A0-	9		49	103	61	40	10	WJ30ET	
DC160-05-09.100A0-	9,1		49	103	61	40	10	WJ30ET	
DC160-05-09.128A0-	9,128	23/64"	49	103	61	40	10	WJ30ET	
DC160-05-09.200A0-	9,2		49	103	61	40	10	WJ30ET	
DC160-05-09.300A0-	9,3		49	103	61	40	10	WJ30ET	
DC160-05-09.400A0-	9,4		49	103	61	40	10	WJ30ET	
DC160-05-09.500A0-	9,5		49	103	61	40	10	WJ30ET	
DC160-05-09.525A0-	9,525	3/8"	49	103	61	40	10	WJ30ET	
DC160-05-09.550A0-	9,55		49	103	61	40	10	WJ30ET	
DC160-05-09.600A0-	9,6		49	103	61	40	10	WJ30ET	
DC160-05-09.700A0-	9,7		49	103	61	40	10	WJ30ET	
DC160-05-09.800A0-	9,8		49	103	61	40	10	WJ30ET	
DC160-05-09.900A0-	9,9		49	103	61	40	10	WJ30ET	
DC160-05-09.922A0-	9,922	25/64"	49	103	61	40	10	WJ30ET	
DC160-05-10.000A0-	10		49	103	61	40	10	WJ30ET	
DC160-05-10.100A0-	10,1		56	118	71	45	12	WJ30ET	
DC160-05-10.200A0-	10,2		56	118	71	45	12	WJ30ET	
DC160-05-10.300A0-	10,3		56	118	71	45	12	WJ30ET	
DC160-05-10.319A0-	10,319	13/32"	56	118	71	45	12	WJ30ET	
DC160-05-10.400A0-	10,4		56	118	71	45	12	WJ30ET	
DC160-05-10.500A0-	10,5		56	118	71	45	12	WJ30ET	
DC160-05-10.600A0-	10,6		56	118	71	45	12	WJ30ET	
DC160-05-10.700A0-	10,7		56	118	71	45	12	WJ30ET	
DC160-05-10.716A0-	10,716	27/64"	56	118	71	45	12	WJ30ET	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

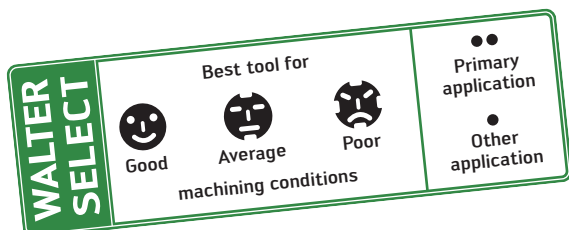
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Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-10.800A0-	10,8		56	118	71	45	12	☺
	DC160-05-10.900A0-	10,9		56	118	71	45	12	☺
	DC160-05-11.000A0-	11		56	118	71	45	12	☺
	DC160-05-11.100A0-	11,1		56	118	71	45	12	☺
	DC160-05-11.113A0-	11,113	7/16"	56	118	71	45	12	☺
	DC160-05-11.200A0-	11,2		56	118	71	45	12	☺
	DC160-05-11.300A0-	11,3		56	118	71	45	12	☺
	DC160-05-11.400A0-	11,4		56	118	71	45	12	☺
	DC160-05-11.500A0-	11,5		56	118	71	45	12	☺
	DC160-05-11.509A0-	11,509	29/64"	56	118	71	45	12	☺
	DC160-05-11.550A0-	11,55		56	118	71	45	12	☺
	DC160-05-11.600A0-	11,6		56	118	71	45	12	☺
	DC160-05-11.700A0-	11,7		56	118	71	45	12	☺
	DC160-05-11.800A0-	11,8		56	118	71	45	12	☺
	DC160-05-11.900A0-	11,9		56	118	71	45	12	☺
	DC160-05-11.906A0-	11,906	15/32"	56	118	71	45	12	☺
	DC160-05-12.000A0-	12		56	118	71	45	12	☺
	DC160-05-12.100A0-	12,1		60	124	77	45	14	☺
	DC160-05-12.200A0-	12,2		60	124	77	45	14	☺
	DC160-05-12.250A0-	12,25		60	124	77	45	14	☺
	DC160-05-12.300A0-	12,3		60	124	77	45	14	☺
	DC160-05-12.303A0-	12,303	31/64"	60	124	77	45	14	☺
	DC160-05-12.400A0-	12,4		60	124	77	45	14	☺
	DC160-05-12.500A0-	12,5		60	124	77	45	14	☺
	DC160-05-12.600A0-	12,6		60	124	77	45	14	☺
	DC160-05-12.700A0-	12,7	1/2"	60	124	77	45	14	☺
	DC160-05-12.750A0-	12,75		60	124	77	45	14	☺
	DC160-05-12.800A0-	12,8		60	124	77	45	14	☺
	DC160-05-12.900A0-	12,9		60	124	77	45	14	☺
	DC160-05-13.000A0-	13		60	124	77	45	14	☺
	DC160-05-13.100A0-	13,1		60	124	77	45	14	☺
	DC160-05-13.200A0-	13,2		60	124	77	45	14	☺
	DC160-05-13.300A0-	13,3		60	124	77	45	14	☺
	DC160-05-13.400A0-	13,4		60	124	77	45	14	☺
	DC160-05-13.494A0-	13,494	17/32"	60	124	77	45	14	☺
DC160-05-13.500A0-	13,5		60	124	77	45	14	☺	
DC160-05-13.600A0-	13,6		60	124	77	45	14	☺	
DC160-05-13.700A0-	13,7		60	124	77	45	14	☺	
DC160-05-13.800A0-	13,8		60	124	77	45	14	☺	
DC160-05-13.900A0-	13,9		60	124	77	45	14	☺	
DC160-05-14.000A0-	14		60	124	77	45	14	☺	
DC160-05-14.100A0-	14,1		63	133	83	48	16	☺	
DC160-05-14.200A0-	14,2		63	133	83	48	16	☺	
DC160-05-14.288A0-	14,288	9/16"	63	133	83	48	16	☺	
DC160-05-14.300A0-	14,3		63	133	83	48	16	☺	
DC160-05-14.400A0-	14,4		63	133	83	48	16	☺	
DC160-05-14.500A0-	14,5		63	133	83	48	16	☺	
DC160-05-14.600A0-	14,6		63	133	83	48	16	☺	
DC160-05-14.700A0-	14,7		63	133	83	48	16	☺	
DC160-05-14.750A0-	14,75		63	133	83	48	16	☺	
DC160-05-14.800A0-	14,8		63	133	83	48	16	☺	
DC160-05-15.000A0-	15		63	133	83	48	16	☺	
DC160-05-15.100A0-	15,1		63	133	83	48	16	☺	
DC160-05-15.200A0-	15,2		63	133	83	48	16	☺	
DC160-05-15.300A0-	15,3		63	133	83	48	16	☺	
DC160-05-15.500A0-	15,5		63	133	83	48	16	☺	
DC160-05-15.600A0-	15,6		63	133	83	48	16	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

Continued



B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HA 	DC160-05-15.700A0-	15,7		63	133	83	48	16	WJ30ET
	DC160-05-15.800A0-	15,8		63	133	83	48	16	WJ30ET
	DC160-05-15.875A0-	15,875	5/8"	63	133	83	48	16	WJ30ET
	DC160-05-15.900A0-	15,9		63	133	83	48	16	WJ30ET
	DC160-05-16.000A0-	16		63	133	83	48	16	WJ30ET
	DC160-05-16.100A0-	16,1		71	143	93	48	18	WJ30ET
	DC160-05-16.200A0-	16,2		71	143	93	48	18	WJ30ET
	DC160-05-16.300A0-	16,3		71	143	93	48	18	WJ30ET
	DC160-05-16.400A0-	16,4		71	143	93	48	18	WJ30ET
	DC160-05-16.500A0-	16,5		71	143	93	48	18	WJ30ET
	DC160-05-16.600A0-	16,6		71	143	93	48	18	WJ30ET
	DC160-05-16.700A0-	16,7		71	143	93	48	18	WJ30ET
	DC160-05-16.750A0-	16,75		71	143	93	48	18	WJ30ET
	DC160-05-16.800A0-	16,8		71	143	93	48	18	WJ30ET
	DC160-05-17.000A0-	17		71	143	93	48	18	WJ30ET
	DC160-05-17.200A0-	17,2		71	143	93	48	18	WJ30ET
	DC160-05-17.300A0-	17,3		71	143	93	48	18	WJ30ET
	DC160-05-17.500A0-	17,5		71	143	93	48	18	WJ30ET
	DC160-05-17.600A0-	17,6		71	143	93	48	18	WJ30ET
	DC160-05-17.700A0-	17,7		71	143	93	48	18	WJ30ET
	DC160-05-17.800A0-	17,8		71	143	93	48	18	WJ30ET
	DC160-05-18.000A0-	18		71	143	93	48	18	WJ30ET
	DC160-05-18.200A0-	18,2		77	153	101	50	20	WJ30ET
	DC160-05-18.500A0-	18,5		77	153	101	50	20	WJ30ET
	DC160-05-18.700A0-	18,7		77	153	101	50	20	WJ30ET
	DC160-05-18.800A0-	18,8		77	153	101	50	20	WJ30ET
	DC160-05-19.000A0-	19		77	153	101	50	20	WJ30ET
	DC160-05-19.050A0-	19,05	3/4"	77	153	101	50	20	WJ30ET
	DC160-05-19.500A0-	19,5		77	153	101	50	20	WJ30ET
	DC160-05-19.700A0-	19,7		77	153	101	50	20	WJ30ET
	DC160-05-19.800A0-	19,8		77	153	101	50	20	WJ30ET
	DC160-05-20.000A0-	20		77	153	101	50	20	WJ30ET
	DC160-05-20.500A0-	20,5		86	166	108	56	25	WJ30ET
	DC160-05-21.000A0-	21		86	166	108	56	25	WJ30ET
DC160-05-21.500A0-	21,5		86	166	108	56	25	WJ30ET	
DC160-05-22.000A0-	22		86	166	108	56	25	WJ30ET	
DC160-05-22.500A0-	22,5		91	173	115	56	25	WJ30ET	
DC160-05-23.000A0-	23		91	173	115	56	25	WJ30ET	
DC160-05-23.500A0-	23,5		91	173	115	56	25	WJ30ET	
DC160-05-24.000A0-	24		91	173	115	56	25	WJ30ET	
DC160-05-24.500A0-	24,5		97	180	122	56	25	WJ30ET	
DC160-05-25.000A0-	25		97	180	122	56	25	WJ30ET	
Shank DIN 6535 HE 	DC160-05-03.000F0-	3		23	66	28	36	6	WJ30ET
	DC160-05-03.100F0-	3,1		23	66	28	36	6	WJ30ET
	DC160-05-03.200F0-	3,2		23	66	28	36	6	WJ30ET
	DC160-05-03.250F0-	3,25		23	66	28	36	6	WJ30ET
	DC160-05-03.300F0-	3,3		23	66	28	36	6	WJ30ET
	DC160-05-03.400F0-	3,4		23	66	28	36	6	WJ30ET
	DC160-05-03.500F0-	3,5		23	66	28	36	6	WJ30ET
	DC160-05-03.600F0-	3,6		23	66	28	36	6	WJ30ET
	DC160-05-03.650F0-	3,65		23	66	28	36	6	WJ30ET
	DC160-05-03.700F0-	3,7		23	66	28	36	6	WJ30ET
	DC160-05-03.800F0-	3,8		29	74	36	36	6	WJ30ET
	DC160-05-03.900F0-	3,9		29	74	36	36	6	WJ30ET
	DC160-05-04.000F0-	4		29	74	36	36	6	WJ30ET
	DC160-05-04.100F0-	4,1		29	74	36	36	6	WJ30ET
	DC160-05-04.200F0-	4,2		29	74	36	36	6	WJ30ET
	DC160-05-04.300F0-	4,3		29	74	36	36	6	WJ30ET
	DC160-05-04.400F0-	4,4		29	74	36	36	6	WJ30ET
	DC160-05-04.500F0-	4,5		29	74	36	36	6	WJ30ET
DC160-05-04.600F0-	4,6		29	74	36	36	6	WJ30ET	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

Continued

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-05-04.650FO-	4,65		29	74	36	36	6	☺
	DC160-05-04.700FO-	4,7		29	74	36	36	6	☺
	DC160-05-04.800FO-	4,8		35	82	44	36	6	☺
	DC160-05-04.900FO-	4,9		35	82	44	36	6	☺
	DC160-05-05.000FO-	5		35	82	44	36	6	☺
	DC160-05-05.100FO-	5,1		35	82	44	36	6	☺
	DC160-05-05.200FO-	5,2		35	82	44	36	6	☺
	DC160-05-05.300FO-	5,3		35	82	44	36	6	☺
	DC160-05-05.400FO-	5,4		35	82	44	36	6	☺
	DC160-05-05.500FO-	5,5		35	82	44	36	6	☺
	DC160-05-05.550FO-	5,55		35	82	44	36	6	☺
	DC160-05-05.600FO-	5,6		35	82	44	36	6	☺
	DC160-05-05.700FO-	5,7		35	82	44	36	6	☺
	DC160-05-05.800FO-	5,8		35	82	44	36	6	☺
	DC160-05-05.900FO-	5,9		35	82	44	36	6	☺
	DC160-05-06.000FO-	6		35	82	44	36	6	☺
	DC160-05-06.100FO-	6,1		43	91	53	36	8	☺
	DC160-05-06.200FO-	6,2		43	91	53	36	8	☺
	DC160-05-06.300FO-	6,3		43	91	53	36	8	☺
	DC160-05-06.400FO-	6,4		43	91	53	36	8	☺
	DC160-05-06.500FO-	6,5		43	91	53	36	8	☺
	DC160-05-06.600FO-	6,6		43	91	53	36	8	☺
	DC160-05-06.700FO-	6,7		43	91	53	36	8	☺
	DC160-05-06.800FO-	6,8		43	91	53	36	8	☺
	DC160-05-06.900FO-	6,9		43	91	53	36	8	☺
	DC160-05-07.000FO-	7		43	91	53	36	8	☺
	DC160-05-07.100FO-	7,1		43	91	53	36	8	☺
	DC160-05-07.200FO-	7,2		43	91	53	36	8	☺
	DC160-05-07.300FO-	7,3		43	91	53	36	8	☺
	DC160-05-07.400FO-	7,4		43	91	53	36	8	☺
	DC160-05-07.500FO-	7,5		43	91	53	36	8	☺
	DC160-05-07.550FO-	7,55		43	91	53	36	8	☺
	DC160-05-07.600FO-	7,6		43	91	53	36	8	☺
	DC160-05-07.700FO-	7,7		43	91	53	36	8	☺
	DC160-05-07.800FO-	7,8		43	91	53	36	8	☺
DC160-05-07.900FO-	7,9		43	91	53	36	8	☺	
DC160-05-08.000FO-	8		43	91	53	36	8	☺	
DC160-05-08.100FO-	8,1		49	103	61	40	10	☺	
DC160-05-08.200FO-	8,2		49	103	61	40	10	☺	
DC160-05-08.300FO-	8,3		49	103	61	40	10	☺	
DC160-05-08.400FO-	8,4		49	103	61	40	10	☺	
DC160-05-08.500FO-	8,5		49	103	61	40	10	☺	
DC160-05-08.600FO-	8,6		49	103	61	40	10	☺	
DC160-05-08.700FO-	8,7		49	103	61	40	10	☺	
DC160-05-08.800FO-	8,8		49	103	61	40	10	☺	
DC160-05-08.900FO-	8,9		49	103	61	40	10	☺	
DC160-05-09.000FO-	9		49	103	61	40	10	☺	
DC160-05-09.100FO-	9,1		49	103	61	40	10	☺	
DC160-05-09.200FO-	9,2		49	103	61	40	10	☺	
DC160-05-09.300FO-	9,3		49	103	61	40	10	☺	
DC160-05-09.400FO-	9,4		49	103	61	40	10	☺	
DC160-05-09.500FO-	9,5		49	103	61	40	10	☺	
DC160-05-09.550FO-	9,55		49	103	61	40	10	☺	
DC160-05-09.600FO-	9,6		49	103	61	40	10	☺	
DC160-05-09.700FO-	9,7		49	103	61	40	10	☺	
DC160-05-09.800FO-	9,8		49	103	61	40	10	☺	
DC160-05-09.900FO-	9,9		49	103	61	40	10	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

Continued

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
	DC160-05-10.000FO-	10		49	103	61	40	10	WJ30ET
	DC160-05-10.100FO-	10,1		56	118	71	45	12	WJ30ET
	DC160-05-10.200FO-	10,2		56	118	71	45	12	WJ30ET
	DC160-05-10.300FO-	10,3		56	118	71	45	12	WJ30ET
	DC160-05-10.400FO-	10,4		56	118	71	45	12	WJ30ET
	DC160-05-10.500FO-	10,5		56	118	71	45	12	WJ30ET
	DC160-05-10.600FO-	10,6		56	118	71	45	12	WJ30ET
	DC160-05-10.700FO-	10,7		56	118	71	45	12	WJ30ET
	DC160-05-10.800FO-	10,8		56	118	71	45	12	WJ30ET
	DC160-05-10.900FO-	10,9		56	118	71	45	12	WJ30ET
	DC160-05-11.000FO-	11		56	118	71	45	12	WJ30ET
	DC160-05-11.100FO-	11,1		56	118	71	45	12	WJ30ET
	DC160-05-11.200FO-	11,2		56	118	71	45	12	WJ30ET
	DC160-05-11.300FO-	11,3		56	118	71	45	12	WJ30ET
	DC160-05-11.400FO-	11,4		56	118	71	45	12	WJ30ET
	DC160-05-11.500FO-	11,5		56	118	71	45	12	WJ30ET
	DC160-05-11.550FO-	11,55		56	118	71	45	12	WJ30ET
	DC160-05-11.600FO-	11,6		56	118	71	45	12	WJ30ET
	DC160-05-11.700FO-	11,7		56	118	71	45	12	WJ30ET
	DC160-05-11.800FO-	11,8		56	118	71	45	12	WJ30ET
	DC160-05-11.900FO-	11,9		56	118	71	45	12	WJ30ET
	DC160-05-12.000FO-	12		56	118	71	45	12	WJ30ET
	DC160-05-12.100FO-	12,1		60	124	77	45	14	WJ30ET
	DC160-05-12.200FO-	12,2		60	124	77	45	14	WJ30ET
	DC160-05-12.250FO-	12,25		60	124	77	45	14	WJ30ET
	DC160-05-12.300FO-	12,3		60	124	77	45	14	WJ30ET
	DC160-05-12.400FO-	12,4		60	124	77	45	14	WJ30ET
	DC160-05-12.500FO-	12,5		60	124	77	45	14	WJ30ET
	DC160-05-12.600FO-	12,6		60	124	77	45	14	WJ30ET
	DC160-05-12.700FO-	12,7	1/2"	60	124	77	45	14	WJ30ET
	DC160-05-12.750FO-	12,75		60	124	77	45	14	WJ30ET
	DC160-05-12.800FO-	12,8		60	124	77	45	14	WJ30ET
	DC160-05-12.900FO-	12,9		60	124	77	45	14	WJ30ET
	DC160-05-13.000FO-	13		60	124	77	45	14	WJ30ET
DC160-05-13.100FO-	13,1		60	124	77	45	14	WJ30ET	
DC160-05-13.200FO-	13,2		60	124	77	45	14	WJ30ET	
DC160-05-13.300FO-	13,3		60	124	77	45	14	WJ30ET	
DC160-05-13.400FO-	13,4		60	124	77	45	14	WJ30ET	
DC160-05-13.500FO-	13,5		60	124	77	45	14	WJ30ET	
DC160-05-13.600FO-	13,6		60	124	77	45	14	WJ30ET	
DC160-05-13.700FO-	13,7		60	124	77	45	14	WJ30ET	
DC160-05-13.800FO-	13,8		60	124	77	45	14	WJ30ET	
DC160-05-13.900FO-	13,9		60	124	77	45	14	WJ30ET	
DC160-05-14.000FO-	14		60	124	77	45	14	WJ30ET	
DC160-05-14.100FO-	14,1		63	133	83	48	16	WJ30ET	
DC160-05-14.200FO-	14,2		63	133	83	48	16	WJ30ET	
DC160-05-14.300FO-	14,3		63	133	83	48	16	WJ30ET	
DC160-05-14.400FO-	14,4		63	133	83	48	16	WJ30ET	
DC160-05-14.500FO-	14,5		63	133	83	48	16	WJ30ET	
DC160-05-14.600FO-	14,6		63	133	83	48	16	WJ30ET	
DC160-05-14.700FO-	14,7		63	133	83	48	16	WJ30ET	
DC160-05-14.750FO-	14,75		63	133	83	48	16	WJ30ET	
DC160-05-14.800FO-	14,8		63	133	83	48	16	WJ30ET	
DC160-05-15.000FO-	15		63	133	83	48	16	WJ30ET	
DC160-05-15.100FO-	15,1		63	133	83	48	16	WJ30ET	
DC160-05-15.200FO-	15,2		63	133	83	48	16	WJ30ET	
DC160-05-15.300FO-	15,3		63	133	83	48	16	WJ30ET	
DC160-05-15.500FO-	15,5		63	133	83	48	16	WJ30ET	
DC160-05-15.600FO-	15,6		63	133	83	48	16	WJ30ET	
DC160-05-15.700FO-	15,7		63	133	83	48	16	WJ30ET	
DC160-05-15.800FO-	15,8		63	133	83	48	16	WJ30ET	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

Continued

Continued

		D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30ET
Shank DIN 6535 HE 	DC160-05-15.900F0-	15,9		63	133	83	48	16	☺
	DC160-05-16.000F0-	16		63	133	83	48	16	☺
	DC160-05-16.100F0-	16,1		71	143	93	48	18	☺
	DC160-05-16.200F0-	16,2		71	143	93	48	18	☺
	DC160-05-16.300F0-	16,3		71	143	93	48	18	☺
	DC160-05-16.400F0-	16,4		71	143	93	48	18	☺
	DC160-05-16.500F0-	16,5		71	143	93	48	18	☺
	DC160-05-16.600F0-	16,6		71	143	93	48	18	☺
	DC160-05-16.700F0-	16,7		71	143	93	48	18	☺
	DC160-05-16.750F0-	16,75		71	143	93	48	18	☺
	DC160-05-16.800F0-	16,8		71	143	93	48	18	☺
	DC160-05-17.000F0-	17		71	143	93	48	18	☺
	DC160-05-17.200F0-	17,2		71	143	93	48	18	☺
	DC160-05-17.300F0-	17,3		71	143	93	48	18	☺
	DC160-05-17.500F0-	17,5		71	143	93	48	18	☺
	DC160-05-17.600F0-	17,6		71	143	93	48	18	☺
	DC160-05-17.700F0-	17,7		71	143	93	48	18	☺
	DC160-05-17.800F0-	17,8		71	143	93	48	18	☺
	DC160-05-18.000F0-	18		71	143	93	48	18	☺
	DC160-05-18.200F0-	18,2		77	153	101	50	20	☺
	DC160-05-18.500F0-	18,5		77	153	101	50	20	☺
	DC160-05-18.700F0-	18,7		77	153	101	50	20	☺
	DC160-05-18.800F0-	18,8		77	153	101	50	20	☺
	DC160-05-19.000F0-	19		77	153	101	50	20	☺
	DC160-05-19.500F0-	19,5		77	153	101	50	20	☺
DC160-05-19.700F0-	19,7		77	153	101	50	20	☺	
DC160-05-19.800F0-	19,8		77	153	101	50	20	☺	
DC160-05-20.000F0-	20		77	153	101	50	20	☺	
DC160-05-20.500F0-	20,5		86	166	108	56	25	☺	
DC160-05-21.000F0-	21		86	166	108	56	25	☺	
DC160-05-21.500F0-	21,5		86	166	108	56	25	☺	
DC160-05-22.000F0-	22		86	166	108	56	25	☺	
DC160-05-22.500F0-	22,5		91	173	115	56	25	☺	
DC160-05-23.000F0-	23		91	173	115	56	25	☺	
DC160-05-23.500F0-	23,5		91	173	115	56	25	☺	
DC160-05-24.000F0-	24		91	173	115	56	25	☺	
DC160-05-24.500F0-	24,5		97	180	122	56	25	☺	
DC160-05-25.000F0-	25		97	180	122	56	25	☺	

Ordering example for the WJ30ET grade: DC160-05-03.000A0-WJ30ET

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

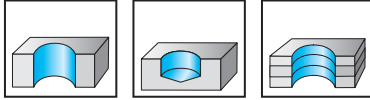
B 1

Solid carbide twist drill

DC150 Perform



B 1



	P	M	K	N	S	H	O
WJ30TA	●	●	●	●	●	●	●

Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30TA
Shank DIN 6535 HA								
DC150-05-03.000A0-	3		23	66	28	36	6	●
DC150-05-03.100A0-	3,1		23	66	28	36	6	●
DC150-05-03.175A0-	3,175	1/8"	23	66	28	36	6	●
DC150-05-03.200A0-	3,2		23	66	28	36	6	●
DC150-05-03.250A0-	3,25		23	66	28	36	6	●
DC150-05-03.300A0-	3,3		23	66	28	36	6	●
DC150-05-03.400A0-	3,4		23	66	28	36	6	●
DC150-05-03.500A0-	3,5		23	66	28	36	6	●
DC150-05-03.600A0-	3,6		23	66	28	36	6	●
DC150-05-03.650A0-	3,65		23	66	28	36	6	●
DC150-05-03.700A0-	3,7		23	66	28	36	6	●
DC150-05-03.800A0-	3,8		29	74	36	36	6	●
DC150-05-03.900A0-	3,9		29	74	36	36	6	●
DC150-05-03.969A0-	3,969	5/32"	29	74	36	36	6	●
DC150-05-04.000A0-	4		29	74	36	36	6	●
DC150-05-04.100A0-	4,1		29	74	36	36	6	●
DC150-05-04.200A0-	4,2		29	74	36	36	6	●
DC150-05-04.300A0-	4,3		29	74	36	36	6	●
DC150-05-04.366A0-	4,366	11/64"	29	74	36	36	6	●
DC150-05-04.400A0-	4,4		29	74	36	36	6	●
DC150-05-04.500A0-	4,5		29	74	36	36	6	●
DC150-05-04.600A0-	4,6		29	74	36	36	6	●
DC150-05-04.650A0-	4,65		29	74	36	36	6	●
DC150-05-04.700A0-	4,7		29	74	36	36	6	●
DC150-05-04.763A0-	4,763	3/16"	35	82	44	36	6	●
DC150-05-04.800A0-	4,8		35	82	44	36	6	●
DC150-05-04.900A0-	4,9		35	82	44	36	6	●
DC150-05-05.000A0-	5		35	82	44	36	6	●
DC150-05-05.100A0-	5,1		35	82	44	36	6	●
DC150-05-05.159A0-	5,159	13/64"	35	82	44	36	6	●
DC150-05-05.200A0-	5,2		35	82	44	36	6	●
DC150-05-05.300A0-	5,3		35	82	44	36	6	●
DC150-05-05.400A0-	5,4		35	82	44	36	6	●
DC150-05-05.500A0-	5,5		35	82	44	36	6	●
DC150-05-05.550A0-	5,55		35	82	44	36	6	●
DC150-05-05.556A0-	5,556	7/32"	35	82	44	36	6	●
DC150-05-05.600A0-	5,6		35	82	44	36	6	●
DC150-05-05.700A0-	5,7		35	82	44	36	6	●
DC150-05-05.800A0-	5,8		35	82	44	36	6	●
DC150-05-05.900A0-	5,9		35	82	44	36	6	●
DC150-05-05.953A0-	5,953	15/64"	35	82	44	36	6	●
DC150-05-06.000A0-	6		35	82	44	36	6	●
DC150-05-06.100A0-	6,1		43	91	53	36	8	●
DC150-05-06.200A0-	6,2		43	91	53	36	8	●
DC150-05-06.300A0-	6,3		43	91	53	36	8	●
DC150-05-06.350A0-	6,35	1/4"	43	91	53	36	8	●
DC150-05-06.400A0-	6,4		43	91	53	36	8	●

Ordering example for the WJ30TA grade: DC150-05-03.000A0-WJ30TA

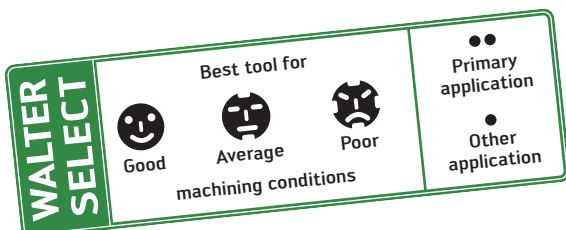
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	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30TA
Shank DIN 6535 HA 	DC150-05-06.500A0-	6,5		43	91	53	36	8	☺
	DC150-05-06.600A0-	6,6		43	91	53	36	8	☺
	DC150-05-06.700A0-	6,7		43	91	53	36	8	☺
	DC150-05-06.747A0-	6,747	17/64"	43	91	53	36	8	☺
	DC150-05-06.800A0-	6,8		43	91	53	36	8	☺
	DC150-05-06.900A0-	6,9		43	91	53	36	8	☺
	DC150-05-07.000A0-	7		43	91	53	36	8	☺
	DC150-05-07.100A0-	7,1		43	91	53	36	8	☺
	DC150-05-07.144A0-	7,144	9/32"	43	91	53	36	8	☺
	DC150-05-07.200A0-	7,2		43	91	53	36	8	☺
	DC150-05-07.300A0-	7,3		43	91	53	36	8	☺
	DC150-05-07.400A0-	7,4		43	91	53	36	8	☺
	DC150-05-07.500A0-	7,5		43	91	53	36	8	☺
	DC150-05-07.600A0-	7,6		43	91	53	36	8	☺
	DC150-05-07.700A0-	7,7		43	91	53	36	8	☺
	DC150-05-07.800A0-	7,8		43	91	53	36	8	☺
	DC150-05-07.900A0-	7,9		43	91	53	36	8	☺
	DC150-05-07.938A0-	7,938	5/16"	43	91	53	36	8	☺
	DC150-05-08.000A0-	8		43	91	53	36	8	☺
	DC150-05-08.100A0-	8,1		49	103	61	40	10	☺
	DC150-05-08.200A0-	8,2		49	103	61	40	10	☺
	DC150-05-08.300A0-	8,3		49	103	61	40	10	☺
	DC150-05-08.334A0-	8,334	21/64"	49	103	61	40	10	☺
	DC150-05-08.400A0-	8,4		49	103	61	40	10	☺
	DC150-05-08.500A0-	8,5		49	103	61	40	10	☺
	DC150-05-08.600A0-	8,6		49	103	61	40	10	☺
	DC150-05-08.700A0-	8,7		49	103	61	40	10	☺
	DC150-05-08.731A0-	8,731	11/32"	49	103	61	40	10	☺
	DC150-05-08.800A0-	8,8		49	103	61	40	10	☺
	DC150-05-08.900A0-	8,9		49	103	61	40	10	☺
	DC150-05-09.000A0-	9		49	103	61	40	10	☺
	DC150-05-09.100A0-	9,1		49	103	61	40	10	☺
	DC150-05-09.128A0-	9,128	23/64"	49	103	61	40	10	☺
	DC150-05-09.200A0-	9,2		49	103	61	40	10	☺
	DC150-05-09.300A0-	9,3		49	103	61	40	10	☺
	DC150-05-09.400A0-	9,4		49	103	61	40	10	☺
	DC150-05-09.500A0-	9,5		49	103	61	40	10	☺
DC150-05-09.525A0-	9,525	3/8"	49	103	61	40	10	☺	
DC150-05-09.600A0-	9,6		49	103	61	40	10	☺	
DC150-05-09.700A0-	9,7		49	103	61	40	10	☺	
DC150-05-09.800A0-	9,8		49	103	61	40	10	☺	
DC150-05-09.900A0-	9,9		49	103	61	40	10	☺	
DC150-05-09.922A0-	9,922	25/64"	49	103	61	40	10	☺	
DC150-05-10.000A0-	10		49	103	61	40	10	☺	
DC150-05-10.100A0-	10,1		56	118	71	45	12	☺	
DC150-05-10.200A0-	10,2		56	118	71	45	12	☺	
DC150-05-10.300A0-	10,3		56	118	71	45	12	☺	
DC150-05-10.319A0-	10,319	13/32"	56	118	71	45	12	☺	
DC150-05-10.400A0-	10,4		56	118	71	45	12	☺	
DC150-05-10.500A0-	10,5		56	118	71	45	12	☺	
DC150-05-10.600A0-	10,6		56	118	71	45	12	☺	
DC150-05-10.700A0-	10,7		56	118	71	45	12	☺	
DC150-05-10.716A0-	10,716	27/64"	56	118	71	45	12	☺	
DC150-05-10.800A0-	10,8		56	118	71	45	12	☺	
DC150-05-11.000A0-	11		56	118	71	45	12	☺	
DC150-05-11.113A0-	11,113	7/16"	56	118	71	45	12	☺	
DC150-05-11.200A0-	11,2		56	118	71	45	12	☺	

Ordering example for the WJ30TA grade: DC150-05-03.000A0-WJ30TA

Continued



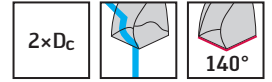
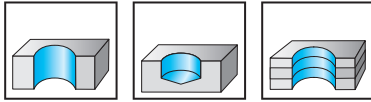
B 1

Continued

	Designation	D _c m7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30TA
	Shank DIN 6535 HA								
	DC150-05-11.500A0-	11,5		56	118	71	45	12	⊕
	DC150-05-11.800A0-	11,8		56	118	71	45	12	⊕
	DC150-05-11.906A0-	11,906	15/32"	56	118	71	45	12	⊕
	DC150-05-12.000A0-	12		56	118	71	45	12	⊕
	DC150-05-12.200A0-	12,2		60	124	77	45	14	⊕
	DC150-05-12.300A0-	12,3		60	124	77	45	14	⊕
	DC150-05-12.400A0-	12,4		60	124	77	45	14	⊕
	DC150-05-12.500A0-	12,5		60	124	77	45	14	⊕
	DC150-05-12.600A0-	12,6		60	124	77	45	14	⊕
	DC150-05-12.700A0-	12,7	1/2"	60	124	77	45	14	⊕
	DC150-05-13.000A0-	13		60	124	77	45	14	⊕
	DC150-05-13.200A0-	13,2		60	124	77	45	14	⊕
	DC150-05-13.494A0-	13,494	17/32"	60	124	77	45	14	⊕
	DC150-05-13.500A0-	13,5		60	124	77	45	14	⊕
	DC150-05-13.800A0-	13,8		60	124	77	45	14	⊕
	DC150-05-14.000A0-	14		60	124	77	45	14	⊕
	DC150-05-14.200A0-	14,2		63	133	83	48	16	⊕
	DC150-05-14.288A0-	14,288	9/16"	63	133	83	48	16	⊕
	DC150-05-14.500A0-	14,5		63	133	83	48	16	⊕
DC150-05-15.000A0-	15		63	133	83	48	16	⊕	
DC150-05-15.500A0-	15,5		63	133	83	48	16	⊕	
DC150-05-15.800A0-	15,8		63	133	83	48	16	⊕	
DC150-05-16.000A0-	16		63	133	83	48	16	⊕	
DC150-05-16.500A0-	16,5		71	143	93	48	18	⊕	
DC150-05-17.000A0-	17		71	143	93	48	18	⊕	
DC150-05-17.500A0-	17,5		71	143	93	48	18	⊕	
DC150-05-18.000A0-	18		71	143	93	48	18	⊕	
DC150-05-19.000A0-	19		77	153	101	50	20	⊕	
DC150-05-19.500A0-	19,5		77	153	101	50	20	⊕	
DC150-05-20.000A0-	20		77	153	101	50	20	⊕	

Ordering example for the WJ30TA grade: DC150-05-03.000A0-WJ30TA

Solid carbide micro pilot drill DB131 Supreme



WJ30EL	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Designation	D _c p7 mm	D _c Inch/no.	L _c mm	l ₁ mm	l ₂ mm	l ₅ mm	d ₁ h6 mm	WJ30EL
Shank DIN 6535 HA								
DB131-02-00.500A0-	0,5		2,2	47	3	37	3	●
DB131-02-00.600A0-	0,6		2,1	47	3	37	3	●
DB131-02-00.700A0-	0,7		2,9	48	4	39	3	●
DB131-02-00.750A0-	0,75		2,8	48	4	37	3	●
DB131-02-00.794A0-	0,794	1/32"	2,8	48	4	37	3	●
DB131-02-00.800A0-	0,8		2,8	48	4	37	3	●
DB131-02-00.850A0-	0,85		3,6	50	5	38	3	●
DB131-02-00.900A0-	0,9		3,6	50	5	38	3	●
DB131-02-00.950A0-	0,95		3,5	50	5	38	3	●
DB131-02-01.000A0-	1		3,5	50	5	38	3	●
DB131-02-01.050A0-	1,05		4	51	6	39	3	●
DB131-02-01.100A0-	1,1		4	51	6	39	3	●
DB131-02-01.150A0-	1,15		4	51	6	39	3	●
DB131-02-01.191A0-	1,191	3/64"	4	51	6	39	3	●
DB131-02-01.200A0-	1,2		4	51	6	39	3	●
DB131-02-01.250A0-	1,25		4	51	6	39	3	●
DB131-02-01.300A0-	1,3		5	53	7	40	3	●
DB131-02-01.350A0-	1,35		4	53	7	40	3	●
DB131-02-01.400A0-	1,4		4	53	7	40	3	●
DB131-02-01.450A0-	1,45		5	53	8	39	3	●
DB131-02-01.500A0-	1,5		5	53	8	39	3	●
DB131-02-01.550A0-	1,55		5	54	8	41	3	●
DB131-02-01.588A0-	1,588	1/16"	5	54	8	41	3	●
DB131-02-01.600A0-	1,6		5	54	8	41	3	●
DB131-02-01.650A0-	1,65		6	54	9	40	3	●
DB131-02-01.700A0-	1,7		6	54	9	40	3	●
DB131-02-01.750A0-	1,75		6	54	9	40	3	●
DB131-02-01.800A0-	1,8		6	54	9	40	3	●
DB131-02-01.850A0-	1,85		7	57	10	42	3	●
DB131-02-01.900A0-	1,9		7	57	10	42	3	●
DB131-02-01.950A0-	1,95		7	57	10	42	3	●
DB131-02-01.984A0-	1,984	5/64"	7	57	10	42	3	●

Ordering example for the WJ30EL grade: DB131-02-00.500A0-WJ30EL

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions





●● Primary application

● Other application

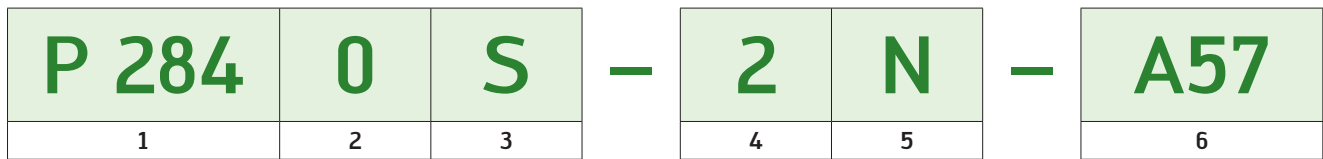
Product range overview of indexable inserts for drilling from solid

B 1



Application	Insert shape	Description	Page
Drilling from solid		P6001 .. P6003 .. P6004 .. P6005 ..	For drilling from solid 264
		T	For chamfering 268
		P484 ..	For drilling from solid 270
		P284 ..	For drilling from solid 271

Designation key for square indexable inserts for drilling from solid



1
Walter indexable insert designation
P284 For the D3120 drill
P484 For the D4120 and B421... drills

2
Version
0 Ground
1 Sintered

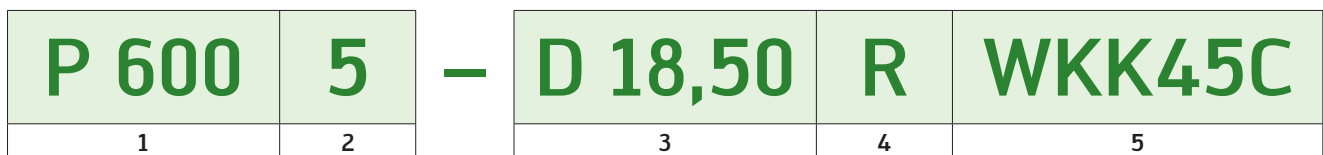
3
Position
C Centre insert
P Outer insert
S Centre insert and outer insert identical size

4
Insert size
P284
1 D _C = 16,00–20,00
2 D _C = 21,00–25,00
3 D _C = 26,00–30,00
4 D _C = 31,00–36,00
5 D _C = 37,00–42,00
P484
1 D _C = 13,50–16,00
2 D _C = 16,50–20,00
3 D _C = 20,50–24,00
4 D _C = 24,50–29,00
5 D _C = 29,50–35,00
6 D _C = 36,00–42,00
7 D _C = 43,00–50,00
8 D _C = 51,00–59,00

5
Cutting direction
R RH-cutting
N Neutral

6
Walter geometry
A57 The stable one
E57 The universal one
E67 The sharp one

Designation key for exchangeable-tip drills for drilling from solid



1
Walter indexable insert designation
P600 For drills D4140 / D4240 / B401...

2
Walter geometry
1 For ISO P
3 For ISO M and ISO S
4 For ISO N
5 For ISO K

3
Insert diameter
D In mm

4
Cutting direction
R RH-cutting

5
Coating

B 1

Designation key in accordance with ISO 1832 for indexable inserts for drilling from solid

L	C	M	X	06	T2	04	—	D57
1	2	3	4	5	6	7		8

B 1

1
Insert shape

2
Clearance angle

3			
Tolerances			
Permissible deviation in mm for			
	d	m	s
E	$\pm 0,025$	$\pm 0,025$	$\pm 0,025$
M	$\pm 0,05-0,15^2$	$\pm 0,08-0,20^2$	$\pm 0,130$
	¹ Inserts with ground planar cutting edges ² Depending on the insert size (see ISO standard 1832)		

4
Machining and fastening features
X Drawing or precise description of the indexable insert is required

5
Cutting edge length

6	
Insert thickness	
	02 s = 2,38 T2 s = 2,78 03 s = 3,18 T3 s = 3,97 04 s = 4,76 05 s = 5,56 06 s = 6,35

7	
Corner radius	
	02 r = 0,2 04 r = 0,4 08 r = 0,8

8	
Manufacturer specifications	
The ISO code includes nine symbols. The eighth and/or ninth symbols should only be used when required. The manufacturer can add other symbols which can be combined with the ISO code by means of a hyphen (e.g. for the chip breaker form).	
Drilling from solid	A 57, B 57, D 57, E 57, E 67

Designation key for cutting material grades for drilling from solid

W	K	P	25	S
Walter	1	2	3	4

1	2	3	4
1. Primary application or coating type	2. Primary application	ISO application range	Generation
<p>P Steel</p> <p>M Stainless steel</p> <p>K Cast iron</p> <p>N NF metals</p> <p>S Materials with difficult cutting properties</p> <p>H Hard materials</p> <p>A CVD aluminium coating</p> <p>X PVD coating</p>	<p>P Steel</p> <p>M Stainless steel</p> <p>K Cast iron</p> <p>N NF metals</p> <p>S Materials with difficult cutting properties</p> <p>H Hard materials</p>	<p>Wear resistance</p> <p>01 10 15 20 25 30 35 45</p> <p>Toughness</p>	<p>S Tiger-tec® Silver</p> <p>C Color Select</p>

B 1

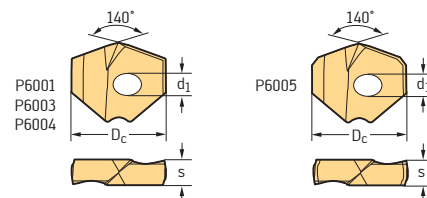
Geometry designation key for indexable inserts for drilling from solid

B	5	7
1	2	3

1	2	3
Chip breaker groove	Cutting edge	Flank face design
<p>Smaller</p> <p>Larger</p> <p>A = 0°</p> <p>B = 6°</p> <p>D = 10°</p> <p>E = 15°</p> <p>F = 16°</p> <p>G = 20°</p> <p>K = 25°</p>	<p>Heavily ground down</p> <p>Sharp</p> <p>2</p> <p>5</p> <p>8</p>	<p>5</p> <p>6</p> <p>7</p> <p>8</p>

Drill inserts





P6001 / P6003 / P6004 / P6005



P6001;P6003;P6004;P6005

Drill inserts

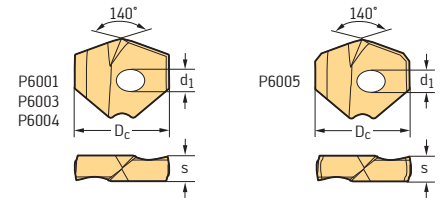
B 1

Designation	Number of cutting edges	D _c mm	D _c Inch/ no.	Seat size	d ₁ mm	s mm	P6001		P6003		P6003	P6005	P6004	P6003	
							P	P	M	K	N	S			
							WPP45C	HC WMP35	HC WMP35	HC WKK45C	HC WNN25	HC WMP35			
 P6001	P60.-D12,00R	2	12	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,10R	2	12,1	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,20R	2	12,2	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,30R	2	12,3	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,40R	2	12,4	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
 P6003	P60.-D12,50R	2	12,5	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,60R	2	12,6	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,70R	2	12,7	1/2"	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,80R	2	12,8	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D12,90R	2	12,9	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
 P6004	P60.-D12,95R	2	12,95	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,00R	2	13	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,10R	2	13,1	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,11R	2	13,11	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,20R	2	13,2	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
 P6005	P60.-D13,25R	2	13,25	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,30R	2	13,3	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,30R	2	13,3	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,40R	2	13,4	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,49R	2	13,49	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,50R	2	13,5	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,60R	2	13,6	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,70R	2	13,7	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,80R	2	13,8	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D13,89R	2	13,89	35/64"	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺
	P60.-D13,90R	2	13,9	A	3	3,6	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D14,00R	2	14	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D14,10R	2	14,1	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D14,20R	2	14,2	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺	
	P60.-D14,29R	2	14,29	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺	
P60.-D14,30R	2	14,3	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,40R	2	14,4	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,50R	2	14,5	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,60R	2	14,6	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,68R	2	14,68	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,70R	2	14,7	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,80R	2	14,8	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D14,90R	2	14,9	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,00R	2	15	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,08R	2	15,08	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,09R	2	15,09	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,10R	2	15,1	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,20R	2	15,2	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		
P60.-D15,30R	2	15,3	B	3	4	☺	☺	☺	☺	☺	☺	☺	☺		

Ordering example: P60.-D13.00R is available as P6003 in the WMP35 grade (ISO P, ISO M and ISO S); P6003-D13.00R WMP35 or as P6001 in the WPP45C grade (ISO P): P6001-D13.00R WPP45C

HC = Coated carbide

Drill inserts P6001 / P6003 / P6004 / P6005



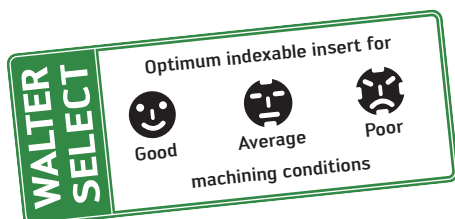
P6001;P6003;P6004;P6005

Drill inserts

Designation	Number of cutting edges	D _c mm	D _c Inch/ no.	Seat size	d ₁ mm	s mm	P6001		P6003		P6004		P6005	
							P	HC	P	HC	N	HC	K	HC
							WPP45C	WMP35	WMP35	WMP35	WNN25	WMP35	WKK45C	WMP35
P6001 	P60.-D15,40R	2	15,4	B	3	4	☺	☺	☺	☺				
	P60.-D15,47R	2	15,47	B	3	4	☺	☺	☺	☺				
	P60.-D15,48R	2	15,48	B	3	4								
	P60.-D15,50R	2	15,5	B	3	4	☺	☺	☺	☺	☺			
	P60.-D15,60R	2	15,6	B	3	4	☺	☺	☺	☺	☺			
P6003 	P60.-D15,70R	2	15,7	B	3	4	☺	☺	☺	☺				
	P60.-D15,80R	2	15,8	B	3	4	☺	☺	☺	☺				
	P60.-D15,87R	2	15,87	B	3	4	☺	☺	☺	☺				
	P60.-D15,88R	2	15,88	B	3	4								
	P60.-D15,90R	2	15,9	B	3	4								
P6004 	P60.-D16,00R	2	16	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D16,13R	2	16,13	C	4	4,5	☺	☺	☺	☺				
	P60.-D16,26R	2	16,26	C	4	4,5	☺	☺	☺	☺				
	P60.-D16,27R	2	16,27	C	4	4,5								
	P60.-D16,43R	2	16,43	C	4	4,5	☺	☺	☺	☺				
P6005 	P60.-D16,50R	2	16,5	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D16,66R	2	16,66	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D16,67R	2	16,67	C	4	4,5								
	P60.-D16,70R	2	16,7	C	4	4,5	☺	☺	☺	☺				
	P60.-D16,80R	2	16,8	C	4	4,5								
	P60.-D17,00R	2	17	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,07R	2	17,07	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,20R	2	17,2	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,45R	2	17,45	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,46R	2	17,46	C	4	4,5								
	P60.-D17,50R	2	17,5	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,70R	2	17,7	C	4	4,5	☺	☺	☺	☺	☺			
	P60.-D17,80R	2	17,8	C	4	4,5								
	P60.-D17,86R	2	17,86	45/64"	C	4	4,5	☺	☺	☺	☺			
	P60.-D18,00R	2	18		D	4	5	☺	☺	☺	☺	☺		
P60.-D18,24R	2	18,24		D	4	5	☺	☺	☺	☺				
P60.-D18,26R	2	18,26		D	4	5								
P60.-D18,50R	2	18,5		D	4	5	☺	☺	☺	☺	☺			
P60.-D18,65R	2	18,65		D	4	5	☺	☺	☺	☺	☺			
P60.-D18,70R	2	18,7		D	4	5	☺	☺	☺	☺				
P60.-D18,80R	2	18,8		D	4	5	☺	☺	☺	☺				
P60.-D19,00R	2	19		D	4	5	☺	☺	☺	☺	☺			
P60.-D19,05R	2	19,05	3/4"	D	4	5	☺	☺	☺	☺				
P60.-D19,20R	2	19,2		D	4	5	☺	☺	☺	☺				

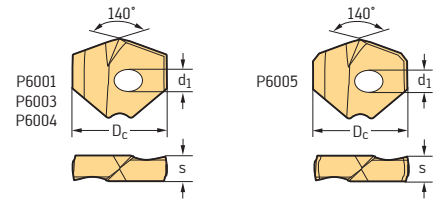
Ordering example: P60.-D13,00R is available as P6003 in the WMP35 grade (ISO P, ISO M and ISO S); P6003-D13,00R WMP35 or as P6001 in the WPP45C grade (ISO P): P6001-D13,00R WPP45C

HC = Coated carbide



Drill inserts

P6001 / P6003 / P6004 / P6005



P6001;P6003;P6004;P6005

Drill inserts

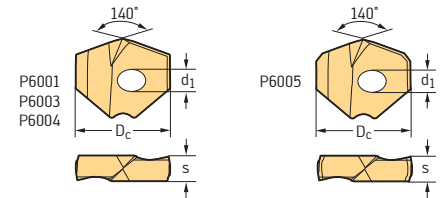
B 1

Designation	Number of cutting edges	D _c mm	D _c Inch/ no.	Seat size	d ₁ mm	s mm	P6001		P6003		P6003	P6005	P6004	P6003	
							P	P	M	K	N	S			
							HC		HC	HC	HC	HC	HC	HC	
							WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35			
	P60..-D19,25R	2	19,25		D	4	5	☹	☹	☹	☹			☹	
	P60..-D19,30R	2	19,3		D	4	5	☹	☹	☹	☹			☹	
	P60..-D19,43R	2	19,43		D	4	5	☹	☹	☹	☹			☹	
	P60..-D19,45R	2	19,45		D	4	5				☹				
	P60..-D19,50R	2	19,5		D	4	5	☹	☹	☹	☹	☹		☹	
	P60..-D19,60R	2	19,6		D	4	5	☹	☹	☹	☹			☹	
	P60..-D19,70R	2	19,7		D	4	5	☹	☹	☹	☹	☹		☹	
	P60..-D19,80R	2	19,8		D	4	5				☹				
	P60..-D19,84R	2	19,84		D	4	5	☹	☹	☹	☹	☹		☹	
	P60..-D20,00R	2	20		E	5	5,5	☹	☹	☹	☹	☹		☹	
	P60..-D20,20R	2	20,2		E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D20,24R	2	20,24	51/64"	E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D20,50R	2	20,5		E	5	5,5	☹	☹	☹	☹	☹		☹	
	P60..-D20,62R	2	20,62		E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D20,64R	2	20,64		E	5	5,5				☹				
	P60..-D20,70R	2	20,7		E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D21,00R	2	21		E	5	5,5	☹	☹	☹	☹	☹		☹	
	P60..-D21,41R	2	21,41		E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D21,43R	2	21,43		E	5	5,5				☹				
	P60..-D21,50R	2	21,5		E	5	5,5	☹	☹	☹	☹	☹		☹	
	P60..-D21,70R	2	21,7		E	5	5,5	☹	☹	☹	☹	☹		☹	
	P60..-D21,83R	2	21,83		E	5	5,5	☹	☹	☹	☹			☹	
	P60..-D22,00R	2	22		F	5	6	☹	☹	☹	☹	☹		☹	
	P60..-D22,22R	2	22,22		F	5	6	☹	☹	☹	☹			☹	
	P60..-D22,23R	2	22,23		F	5	6				☹				
	P60..-D22,42R	2	22,42		F	5	6	☹	☹	☹	☹			☹	
	P60..-D22,47R	2	22,47		F	5	6	☹	☹	☹	☹			☹	
	P60..-D22,50R	2	22,5		F	5	6	☹	☹	☹	☹	☹		☹	
	P60..-D22,62R	2	22,62		F	5	6	☹	☹	☹	☹			☹	
	P60..-D22,70R	2	22,7		F	5	6	☹	☹	☹	☹			☹	
P60..-D22,77R	2	22,77		F	5	6	☹	☹	☹	☹			☹		
P60..-D23,00R	2	23		F	5	6	☹	☹	☹	☹	☹		☹		
P60..-D23,02R	2	23,02		F	5	6				☹					
P60..-D23,39R	2	23,39		F	5	6	☹	☹	☹	☹			☹		
P60..-D23,50R	2	23,5		F	5	6	☹	☹	☹	☹	☹		☹		
P60..-D23,70R	2	23,7		F	5	6	☹	☹	☹	☹			☹		
P60..-D23,80R	2	23,8		F	5	6	☹	☹	☹	☹			☹		
P60..-D23,81R	2	23,81		F	5	6				☹					
P60..-D24,00R	2	24		G	5	6,5	☹	☹	☹	☹	☹		☹		
P60..-D24,21R	2	24,21	61/64"	G	5	6,5	☹	☹	☹	☹			☹		
P60..-D24,50R	2	24,5		G	5	6,5	☹	☹	☹	☹	☹		☹		
P60..-D24,59R	2	24,59		G	5	6,5	☹	☹	☹	☹			☹		
P60..-D24,61R	2	24,61		G	5	6,5				☹					

Ordering example: P60..-D13.00R is available as
P6003 in the WMP35 grade (ISO P, ISO M and ISO S): P6003-D13.00R WMP35 or as
P6001 in the WPP45C grade (ISO P): P6001-D13.00R WPP45C





HC = Coated carbide

Drill inserts P6001 / P6003 / P6004 / P6005



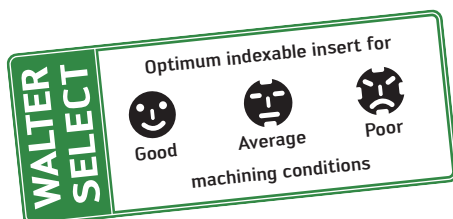
P6001;P6003;P6004;P6005

Drill inserts

Designation	Number of cutting edges	D _c mm	D _c Inch/ no.	Seat size	d ₁ mm	s mm	P6001		P6003		P6004		P6005	
							P	HC	P	HC	N	HC	K	HC
							WPP45C	WMP35	WMP35	WMP35	WNN25	WMP35	WKK45C	WMP35
P6001 	P60..-D24,70R	2	24,7	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,00R	2	25	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,25R	2	25,25	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,40R	2	25,4	1"	G	5	6,5	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,50R	2	25,5		G	5	6,5	☹	☹	☹	☹	☹	☹	☹
P6003 	P60..-D25,65R	2	25,65	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,70R	2	25,7	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D25,80R	2	25,8	G	5	6,5	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D26,00R	2	26	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D26,25R	2	26,25	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
P6004 	P60..-D26,50R	2	26,5	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D26,59R	2	26,59	1 3/64"	H	6	7,1	☹	☹	☹	☹	☹	☹	☹
	P60..-D27,00R	2	27	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D27,38R	2	27,38	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D27,50R	2	27,5	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
P6005 	P60..-D27,78R	2	27,78	H	6	7,1	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D28,00R	2	28	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D28,17R	2	28,17	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D28,50R	2	28,5	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D28,57R	2	28,57	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D29,00R	2	29	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D29,37R	2	29,37	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D29,50R	2	29,5	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D29,77R	2	29,77	J	6	7,7	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D30,00R	2	30	K	6	8	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D30,15R	2	30,15	K	6	8	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D30,50R	2	30,5	K	6	8	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D31,00R	2	31	K	6	8	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D31,50R	2	31,5	K	6	8	☹	☹	☹	☹	☹	☹	☹	☹
	P60..-D31,75R	2	31,75	1 1/4"	K	6	8	☹	☹	☹	☹	☹	☹	☹
P60..-D31,99R	2	31,99		K	6	8	☹	☹	☹	☹	☹	☹	☹	
P60..-D32,00R	2	32	M	6	8,3	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D32,10R	2	32,1	M	6	8,3	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D33,00R	2	33	M	6	8,3	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D34,00R	2	34	N	6	8,6	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D35,00R	2	35	N	6	8,6	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D36,00R	2	36	P	6	8,9	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D37,00R	2	37	P	6	8,9	☹	☹	☹	☹	☹	☹	☹	☹	
P60..-D37,99R	2	37,99	P	6	8,9	☹	☹	☹	☹	☹	☹	☹	☹	

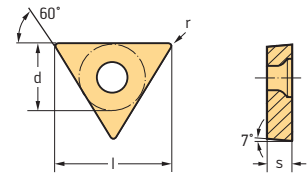
Ordering example: P60..-D13,00R is available as P6003 in the WMP35 grade (ISO P, ISO M and ISO S); P6003-D13,00R WMP35 or as P6001 in the WPP45C grade (ISO P): P6001-D13,00R WPP45C

HC = Coated carbide



B 1

Positive triangular 60° TCMT Tiger-tec® Silver



Indexable inserts

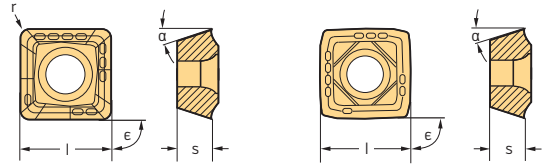
B 1

Designation	l mm	r mm	P		M					K		N		S			
			HE	HC	HC					HC	HC	HC					
			WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM10S	WSM20S	WSM30S	WSM21	WKK10S	WKK20S	WNN10	WSM10S	WSM20S
TCMT06T102-FM4	6,87	0,2															
TCMT06T104-FM4	6,87	0,4															
TCMT090202-FM4	9,62	0,2															
TCMT090204-FM4	9,62	0,4															
TCMT090208-FM4	9,62	0,8															
TCMT110202-FM4	11,00	0,2															
TCMT110204-FM4	11,00	0,4															
TCMT110208-FM4	11,00	0,8															
TCMT16T302-FM4	16,50	0,2															
TCMT16T304-FM4	16,50	0,4															
TCMT16T308-FM4	16,50	0,8															
TCMT06T102-FP4	6,87	0,2															
TCMT06T104-FP4	6,87	0,4															
TCMT090202-FP4	9,62	0,2															
TCMT090204-FP4	9,62	0,4															
TCMT090208-FP4	9,62	0,8															
TCMT110202-FP4	11,00	0,2															
TCMT110204-FP4	11,00	0,4															
TCMT110208-FP4	11,00	0,8															
TCMT16T302-FP4	16,50	0,2															
TCMT16T304-FP4	16,50	0,4															
TCMT16T308-FP4	16,50	0,8															
TCMT090204-MP4	9,62	0,4															
TCMT090208-MP4	9,62	0,8															
TCMT110204-MP4	11,00	0,4															
TCMT110208-MP4	11,00	0,8															
TCMT16T304-MP4	16,50	0,4															
TCMT16T308-MP4	16,50	0,8															
TCMT220408-MP4	22,00	0,8															






See the ISO 1832 designation key for dimensions

 HE = Coated cermet
 HC = Coated carbide

Square P484 . Tiger-tec® Silver



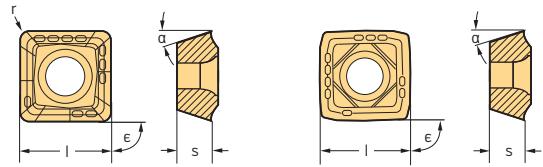
Indexable inserts

Designation	Number of cutting edges	l mm	s mm	r mm	α	ε	P					M			K			N		S	
							HC					HC			HC			HC		HC	
							WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45
 P4840P-1R-A57	4	4,55	1,96	0,29	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-2R-A57	4	5,52	2,28	0,34	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-3R-A57	4	6,5	2,8	0,4	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-4R-A57	4	7,8	3,36	0,48	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-5R-A57	4	9,56	4,12	0,59	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-6R-A57	4	11,75	4,87	0,7	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-7R-A57	4	14,03	5,53	0,8	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-8R-A57	4	16,5	5,53	1	11°	90°	☉	☉	☉			☉			☉	☉			☉		
 P4840P-1R-E57	4	4,55	1,96	0,29	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-2R-E57	4	5,52	2,28	0,34	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-3R-E57	4	6,5	2,8	0,4	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-4R-E57	4	7,8	3,36	0,48	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-5R-E57	4	9,56	4,12	0,59	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-6R-E57	4	11,75	4,87	0,7	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-7R-E57	4	14,03	5,53	0,8	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4840P-8R-E57	4	16,5	5,53	1	11°	90°	☉	☉	☉			☉			☉	☉			☉		
 P4840P-1R-E67	4	4,55	1,96	0,29	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-2R-E67	4	5,52	2,28	0,34	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-3R-E67	4	6,5	2,8	0,4	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-4R-E67	4	7,8	3,36	0,48	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-5R-E67	4	9,56	4,12	0,59	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-6R-E67	4	11,75	4,87	0,7	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-7R-E67	4	14,03	5,53	0,8	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
P4840P-8R-E67	4	16,5	5,53	1	11°	90°	☉	☉	☉			☉			☉	☉	☉		☉		
 P4841P-1R-A57	4	4,55	1,96	0,29	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-2R-A57	4	5,52	2,28	0,34	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-3R-A57	4	6,5	2,8	0,4	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-4R-A57	4	7,8	3,36	0,48	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-5R-A57	4	9,56	4,12	0,59	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-6R-A57	4	11,75	4,87	0,7	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-7R-A57	4	14,03	5,53	0,8	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-8R-A57	4	16,5	5,53	1	11°	90°	☉	☉	☉			☉			☉	☉			☉		
 P4841P-1R-E57	4	4,55	1,96	0,29	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-2R-E57	4	5,52	2,28	0,34	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-3R-E57	4	6,5	2,8	0,4	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-4R-E57	4	7,8	3,36	0,48	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-5R-E57	4	9,56	4,12	0,59	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-6R-E57	4	11,75	4,87	0,7	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-7R-E57	4	14,03	5,53	0,8	11°	90°	☉	☉	☉			☉			☉	☉			☉		
P4841P-8R-E57	4	16,5	5,53	1	11°	90°	☉	☉	☉			☉			☉	☉			☉		

HC = Coated carbide




B 1

Square P484 . Tiger-tec® Silver



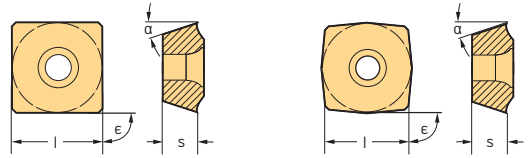
Indexable inserts

B 1

Designation	Number of cutting edges	l mm	s mm	r mm	α	ε	P					M			K			N		S	
							HC					HC			HC			HC		HC	
							WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45
 P4841C-1R-A57	4	4,9	1,96	0,29	11°	90°	☒	☒												☒	
P4841C-2R-A57	4	5,95	2,38	0,34	11°	90°	☒	☒													☒
P4841C-3R-A57	4	7	2,8	0,4	11°	90°	☒	☒													☒
P4841C-4R-A57	4	8,4	3,36	0,48	11°	90°	☒	☒													☒
P4841C-5R-A57	4	10,29	4,12	0,59	11°	90°	☒	☒													☒
P4841C-6R-A57	4	12,24	4,87	0,7	11°	90°	☒	☒													☒
P4841C-7R-A57	4	14,69	5,53	0,8	11°	90°	☒	☒													☒
P4841C-8R-A57	4	17,49	5,53	1	11°	90°	☒	☒													☒
 P4841C-1R-E57	4	4,9	1,96	0,29	11°	90°	☒	☒													☒
P4841C-2R-E57	4	5,95	2,38	0,34	11°	90°	☒	☒													☒
P4841C-3R-E57	4	7	2,8	0,4	11°	90°	☒	☒													☒
P4841C-4R-E57	4	8,4	3,36	0,48	11°	90°	☒	☒													☒
P4841C-5R-E57	4	10,29	4,12	0,59	11°	90°	☒	☒													☒
P4841C-6R-E57	4	12,24	4,87	0,7	11°	90°	☒	☒													☒
P4841C-7R-E57	4	14,69	5,53	0,8	11°	90°	☒	☒													☒
P4841C-8R-E57	4	17,49	5,53	1	11°	90°	☒	☒													☒
 P4840C-1R-E67	4	4,9	1,96	0,29	11°	90°	☒	☒													☒
P4840C-2R-E67	4	5,95	2,38	0,34	11°	90°	☒	☒													☒
P4840C-3R-E67	4	7	2,8	0,4	11°	90°	☒	☒													☒
P4840C-4R-E67	4	8,4	3,36	0,48	11°	90°	☒	☒													☒
P4840C-5R-E67	4	10,29	4,12	0,59	11°	90°	☒	☒													☒
P4840C-6R-E67	4	12,24	4,87	0,7	11°	90°	☒	☒													☒
P4840C-7R-E67	4	14,69	5,53	0,8	11°	90°	☒	☒													☒
P4840C-8R-E67	4	17,49	5,53	1	11°	90°	☒	☒													☒

HC = Coated carbide

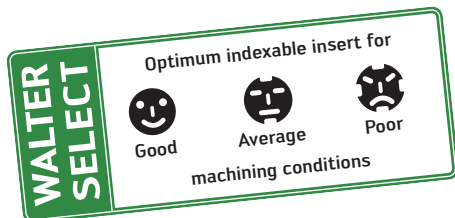
Square P284..



Indexable inserts

Designation	Number of cutting edges	l mm	s mm	α	ε	P					M			K			N		S				
						WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S	WXP40	
P2840S-1N-A57	4	6,35	2,38	14°	90°	HC	HC	HC	HC	HC													
P2840S-2N-A57	4	7,8	3,18	14°	90°	HC	HC	HC	HC	HC													
P2840S-3N-A57	4	9,52	3,97	11°	96°	HC	HC	HC	HC	HC													
P2840S-4N-A57	4	11	3,97	11°	96°	HC	HC	HC	HC	HC													
P2840S-5N-A57	4	12,7	4,76	11°	96°	HC	HC	HC	HC	HC													
P2840S-6N-A57	4	15	4,76	11°	96°	HC	HC	HC	HC	HC													
P2840S-7N-A57	4	17,6	5,56	11°	96°	HC	HC	HC	HC	HC													
P2840S-1N-E67	4	6,35	2,38	14°	90°	HC	HC	HC	HC	HC													
P2840S-2N-E67	4	7,8	3,18	14°	90°	HC	HC	HC	HC	HC													
P2840S-3N-E67	4	9,52	3,97	11°	96°	HC	HC	HC	HC	HC													
P2840S-4N-E67	4	11	3,97	11°	96°	HC	HC	HC	HC	HC													
P2840S-5N-E67	4	12,7	4,76	11°	96°	HC	HC	HC	HC	HC													
P2840S-6N-E67	4	15	4,76	11°	96°	HC	HC	HC	HC	HC													
P2840S-7N-E67	4	17,6	5,56	11°	96°	HC	HC	HC	HC	HC													
P2841S-1N-A57	4	6,35	2,38	14°	90°	HC	HC	HC	HC	HC													
P2841S-2N-A57	4	7,8	3,18	14°	90°	HC	HC	HC	HC	HC													
P2841S-3N-A57	4	9,52	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-4N-A57	4	11	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-5N-A57	4	12,7	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-6N-A57	4	15	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-7N-A57	4	17,6	5,56	11°	96°	HC	HC	HC	HC	HC													
P2841S-1N-E57	4	6,35	2,38	14°	90°	HC	HC	HC	HC	HC													
P2841S-2N-E57	4	7,8	3,18	14°	90°	HC	HC	HC	HC	HC													
P2841S-3N-E57	4	9,52	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-4N-E57	4	11	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-5N-E57	4	12,7	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-6N-E57	4	15	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-7N-E57	4	17,6	5,56	11°	96°	HC	HC	HC	HC	HC													
P2841S-1N-E67	4	6,35	2,38	14°	90°	HC	HC	HC	HC	HC													
P2841S-2N-E67	4	7,8	3,18	14°	90°	HC	HC	HC	HC	HC													
P2841S-3N-E67	4	9,52	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-4N-E67	4	11	3,97	11°	96°	HC	HC	HC	HC	HC													
P2841S-5N-E67	4	12,7	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-6N-E67	4	15	4,76	11°	96°	HC	HC	HC	HC	HC													
P2841S-7N-E67	4	17,6	5,56	11°	96°	HC	HC	HC	HC	HC													

HC = Coated carbide
HW = Uncoated carbide



B 1

Product range overview of exchangeable-tip drills/indexable insert drills

B 1

Drilling depth	$2,5 \times D_c$	$1,3 \times D_c$	$3 \times D_c$	$5 \times D_c$	$7 \times D_c$	$10 \times D_c$
Designation	D4240-02	D4140-01	D4140-03	D4140-05	D4140-07	D4140-10
Dia. range [mm]	12–29.99	12–25.99	12–37.99	12–37.99	12–37.99	18–24.99
Page	274	276	278	286	294	300

Drilling depth	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$5 \times D_c$
Designation	D4120-02	D4120-03	D4120-04	D4120-05
Dia. range [mm]	14–59	14–59	17–59	17–59
Page	302	308	316	322

Drilling depth	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$
Designation	D3120-02	D3120-03	D3120-04
Dia. range [mm]	16–42	16–42	16–42
Page	326	328	332

Designation key for Walter drilling tools with indexable inserts

D	4	1	40	—	03	—	12.00	F16	—	A
1	2	3	4	5	6		7	8		9

1
Tool group
D Drilling

2
Generation

3
Tool type
1 Cylindrical drill
2 Chamfer drills
5 Chamfering tool

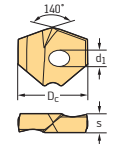



4
Tool type
20 Indexable insert drill with square indexable insert
40 Indexable insert drill with P600x exchangeable insert
80 Compact chamfering tool

5
1. Delimiters
— Metric
. Inch

6
Drilling depth/ chamfer angle
01 $1,3 \times D_c$
02 $2 \times D_c / 2,5 \times D_c$
03 $3 \times D_c$
04 $4 \times D_c$
05 $5 \times D_c$
07 $7 \times D_c$
10 $10 \times D_c$
45 45° chamfer angle

7
Cutting diameter/ clamping diameter Chamfering tool

8
Shank type and size, cylindrical
F16 16 mm
F20 20 mm
F25 25 mm
F32 32 mm
F40 40 mm
A12 12 mm
A16 16 mm
A20 20 mm
A25 25 mm
A13 0.500 inch
A15 0.625 inch
A19 0.750 inch
A26 1.000 inch

9			
Insert size/ interface size			
	Seat size	d ₁ [mm]	s [mm]
	A	3,0	3,6
	B	3,0	4,0
	C	4,0	4,5
	D	4,0	5,0
	E	5,0	5,5
	F	5,0	6,0
	G	5,0	6,5
	H	6,0	7,1
	J	6,0	7,7
	K	6,0	8,0
	M	6,0	8,3
	N	6,0	8,6
	P	6,0	8,9
	P41	P484	Size 1
	.	.	.
	P48	P484	Size 8
	.	.	.
	P21	P284	Size 1
	.	.	.
	P25	P284	Size 5

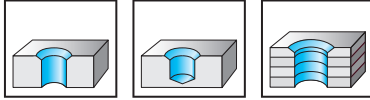
B 1

Exchangeable Tip Drills

D4240-02 mm



B 1



D_c 12– 29,99	$2,5 \times D_c$	90°	140°	$Z=2$
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	P	M	K	N	S	H	O
D4240-02	●	●	●	●	●		

Tool	Designation	D_c mm	D_1 mm	L_c mm	l_4 mm	l_5 mm	d_1 mm	d_4 mm	kg	No. of index- able inserts	Seat size	Type
Parallel shank with flat 	D4240-02-12.00F20-A	12	23,7	35,2	68	50	20	30	0,22	1 2	A	P600 . -D12, .. TC .. 11020 ..
	D4240-02-14.00F20-B	14	25,7	40,6	76	50	20	30	0,26	1 2	B	P600 . -D14, .. TC .. 11020 ..
	D4240-02-15.00F20-B	15	26,7	46,7	80	50	20	30	0,25	1 2	B	P600 . -D15, .. TC .. 11020 ..
	D4240-02-17.00F20-C	17	28,7	48,6	88	50	20	30	0,30	1 2	C	P600 . -D17, .. TC .. 11020 ..
	D4240-02-19.00F20-D	19	30,7	52,5	96	50	20	30	0,34	1 2	D	P600 . -D19, .. TC .. 11020 ..
Parallel shank with flat 	D4240-02-21.00F20-E	21	32,7	55,3	104	50	20	30	0,37	1 2	E	P600 . -D21, .. TC .. 11020 ..
	D4240-02-24.00F25-G	24	43,4	61,4	117	56	25	35	0,63	1 2	G	P600 . -D24, .. TC .. 16T3 ..
	D4240-02-26.00F25-H	26	45,4	66,7	125	56	25	35	0,68	1 2	H	P600 . -D26, .. TC .. 16T3 ..
	D4240-02-29.00F32-J	29	48,4	72,3	138	60	32	42	1,08	1 2	J	P600 . -D29, .. TC .. 16T3 ..

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

Assembly parts

D _c [mm]	12	14-15	17	19	21	24	26	29	
	Clamping screw for P600 drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm
	Clamping screw for TC chamfering insert	FS2061 (Torx 7IP)	FS2061 (Torx 7IP)	FS2061 (Torx 7IP)	FS2061 (Torx 7IP)	FS2061 (Torx 7IP)	FS2063 (Torx 15IP)	FS2063 (Torx 15IP)	FS2063 (Torx 15IP)
	Tightening torque	0,9 Nm	0,9 Nm	0,9 Nm	0,9 Nm	0,9 Nm	3,0 Nm	3,0 Nm	3,0 Nm

Accessories

D _c [mm]	12	14-17	19	21-24	26-29
	Torque screwdriver, analogue	FS2001	FS2003	FS2003	FS2003
	Tightening torque	0,4-1,2 Nm	1,5-5,0 Nm	1,5-5,0 Nm	1,5-5,0 Nm
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)
					FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	Material					Coating							
			P	M	K	N	S	HC	HC	HC	HC	HC			
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35							
P6001-D..	12-29,77	A-J	●												
P6003-D..	12-29,77	A-J		●	●										
P6004-D..	12-29,5	A-J					●								
P6005-D..	12-29,77	A-J				●									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

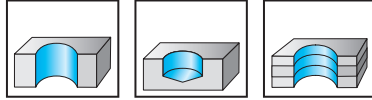
●● Primary application

● Other application

Exchangeable Tip Drills

D4140-01 mm

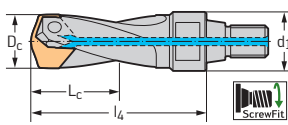

D_c 12- 25,99	$1,3 \times D_c$	140°	$Z=2$
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	P	M	K	N	S	H	O
D4140-01	●	●	●	●	●		

Tool

ScrewFit



Designation	D_c mm	L_c mm	l_4 mm	d_1	Z	kg	No. of indexable inserts	Seat size	Type
D4140-01-12.00T14-A	12	18	47,6	T14	2	0,1	1	A	P600 . -D12, ..
D4140-01-13.00T14-A	13	19	49,9	T14	2	0,1	1	A	P600 . -D13, ..
D4140-01-14.00T14-B	14	21	52,2	T14	2	0,1	1	B	P600 . -D14, ..
D4140-01-15.00T18-B	15	22	54,5	T18	2	0,1	1	B	P600 . -D15, ..
D4140-01-16.00T18-C	16	24	56,8	T18	2	0,1	1	C	P600 . -D16, ..
D4140-01-17.00T18-C	17	25	59,1	T18	2	0,1	1	C	P600 . -D17, ..
D4140-01-18.00T18-D	18	27	61,4	T18	2	0,1	1	D	P600 . -D18, ..
D4140-01-19.00T22-D	19	28	63,7	T22	2	0,1	1	D	P600 . -D19, ..
D4140-01-20.00T22-E	20	30	66	T22	2	0,1	1	E	P600 . -D20, ..
D4140-01-21.00T22-E	21	31	68,3	T22	2	0,1	1	E	P600 . -D21, ..
D4140-01-22.00T22-F	22	33	71,6	T22	2	0,2	1	F	P600 . -D22, ..
D4140-01-23.00T28-F	23	34	73,9	T28	2	0,2	1	F	P600 . -D23, ..
D4140-01-24.00T28-G	24	36	76,2	T28	2	0,2	1	G	P600 . -D24, ..
D4140-01-25.00T28-G	25	37	78,6	T28	2	0,3	1	G	P600 . -D25, ..

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

B 1

Assembly parts

D _c [mm]	12–13	14–15	16–17	18–19	20–21	22–23	24–25
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm

Accessories

D _c [mm]	12–13	14–17	18–19	20–25
Torque screwdriver, analogue	FS2001	FS2003	FS2003	FS2003
Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Drill inserts

Designation	D _c mm	Seat size	P		M		K		N		S							
			HC		HC		HC		HC		HC							
			WPP45C	WMP35	WMP35	WMP35	WKK45C	WNN25	WMP35									
P6001-D..	12–25,8	A–G	☒															
P6003-D..	12–25,8	A–G		☒	☒													
P6004-D..	12–25,5	A–G							☒									
P6005-D..	12–25,8	A–G					☒											

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

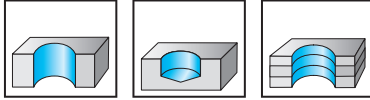
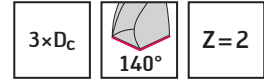
●●
Primary application

●
Other application

B 1

Exchangeable Tip Drills

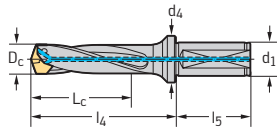
D4140-03 mm



D4140-03	P	M	K	N	S	H	O
	●	●	●	●	●		

Tool

Parallel shank with flat


Designation
D_c mm L_c mm l₄ mm l₅ mm d₁ mm d₄ mm kg No. of indexable inserts Seat size Type

D4140-03-12.00F16-A	12	36	68	48	16	20	0,13	1	A	P600 . -D12, ..
D4140-03-13.00F16-A	13	41	72	48	16	20	0,15	1	A	P600 . -D13, ..
D4140-03-14.00F16-B	14	45	76	48	16	20	0,15	1	B	P600 . -D14, ..
D4140-03-15.00F16-B	15	48	80	48	16	20	0,15	1	B	P600 . -D15, ..
D4140-03-16.00F20-C	16	51	84	50	20	25	0,25	1	C	P600 . -D16, ..
D4140-03-17.00F20-C	17	54	88	50	20	25	0,24	1	C	P600 . -D17, ..
D4140-03-18.00F20-D	18	57	92	50	20	25	0,25	1	D	P600 . -D18, ..
D4140-03-19.00F20-D	19	61	96	50	20	25	0,26	1	D	P600 . -D19, ..
D4140-03-20.00F20-E	20	64	100	50	20	25	0,28	1	E	P600 . -D20, ..
D4140-03-21.00F20-E	21	67	104	50	20	25	0,29	1	E	P600 . -D21, ..
D4140-03-22.00F25-F	22	70	109	56	25	32	0,44	1	F	P600 . -D22, ..
D4140-03-23.00F25-F	23	73	113	56	25	32	0,46	1	F	P600 . -D23, ..
D4140-03-24.00F25-G	24	76	117	56	25	32	0,48	1	G	P600 . -D24, ..
D4140-03-25.00F25-G	25	80	121	56	25	32	0,50	1	G	P600 . -D25, ..
D4140-03-26.00F25-H	26	83	125	56	25	32	0,52	1	H	P600 . -D26, ..
D4140-03-27.00F25-H	27	86	129	56	25	32	0,53	1	H	P600 . -D27, ..
D4140-03-28.00F32-J	28	89	134	60	32	40	0,80	1	J	P600 . -D28, ..
D4140-03-29.00F32-J	29	92	138	60	32	40	0,86	1	J	P600 . -D29, ..
D4140-03-30.00F32-K	30	95	142	60	32	40	0,89	1	K	P600 . -D30, ..
D4140-03-31.00F32-K	31	99	146	60	32	40	0,92	1	K	P600 . -D31, ..
D4140-03-32.00F40-M	32	102	150	70	40	50	1,31	1	M	P600 . -D32, ..
D4140-03-33.00F40-M	33	105	154	70	40	50	1,38	1	M	P600 . -D33, ..
D4140-03-34.00F40-N	34	108	158	70	40	50	1,37	1	N	P600 . -D34, ..
D4140-03-35.00F40-N	35	111	162	70	40	50	1,43	1	N	P600 . -D35, ..
D4140-03-36.00F40-P	36	115	166	70	40	50	1,46	1	P	P600 . -D36, ..
D4140-03-37.00F40-P	37	118	170	70	40	50	1,54	1	P	P600 . -D37, ..

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

Assembly parts

D _c [mm]	12-13	14-15	16-17	18-19	20-21	22-23	24-25	26-27	28-33	34-37
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [mm]	12-13	14-17	18-19	20-25	26-37
Torque T-handle Tightening torque					FS2041 4,5-14 Nm
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S						
			HC	HC	HC	HC	HC						
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35					
P6001-D..	12-37,99	A-P	☞										
P6003-D..	12-37,99	A-P		☞	☞								
P6004-D..	12-31,5	A-K				☞							
P6005-D..	12-37,99	A-P			☞								

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

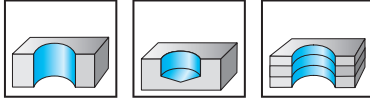
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

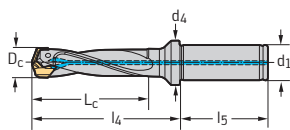
D4140.03 inch



	P	M	K	N	S	H	O
D4140.03	●	●	●	●	●		

Tool

Parallel shank with collar



Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
D4140.03-12.00A15-A	0,472	1,496	2,677	1,890	0,625	0,787	0,29	1	P600 . -D12, ..
D4140.03-13.00A15-A	0,512	1,614	2,834	1,890	0,625	0,787	0,31	1	P600 . -D13, ..
D4140.03-14.00A15-B	0,551	1,772	2,992	1,890	0,625	0,787	0,35	1	P600 . -D14, ..
D4140.03-15.00A15-B	0,591	1,890	3,149	1,890	0,625	0,787	0,35	1	P600 . -D15, ..
D4140.03-16.00A19-C	0,630	2,008	3,308	2,031	0,750	0,984	0,49	1	P600 . -D16, ..
D4140.03-17.00A19-C	0,669	2,126	3,465	2,031	0,750	0,984	0,54	1	P600 . -D17, ..
D4140.03-18.00A19-D	0,709	2,244	3,622	2,031	0,750	0,984	0,55	1	P600 . -D18, ..
D4140.03-19.00A19-D	0,748	2,362	3,779	2,031	0,750	0,984	0,56	1	P600 . -D19, ..
D4140.03-20.00A19-E	0,787	2,480	3,937	2,031	0,750	0,984	0,62	1	P600 . -D20, ..
D4140.03-21.00A19-E	0,827	2,598	4,094	2,031	0,750	0,984	0,64	1	P600 . -D21, ..
D4140.03-22.00A26-F	0,866	2,756	4,292	2,281	1,000	1,260	1,02	1	P600 . -D22, ..
D4140.03-24.00A26-G	0,945	2,992	4,606	2,281	1,000	1,260	1,26	1	P600 . -D24, ..
D4140.03-26.00A26-H	1,024	3,268	4,921	2,281	1,000	1,260	1,21	1	P600 . -D26, ..
D4140.03-28.00A31-J	1,102	3,504	5,276	2,281	1,250	1,575	1,79	1	P600 . -D28, ..
D4140.03-30.00A31-K	1,181	3,740	5,591	2,281	1,250	1,575	1,94	1	P600 . -D30, ..

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

Assembly parts		0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,866	0,945	1,024	1,102–1,181
D _c [inch]										
	Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm

Accessories		0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,945	1,024–1,181
D _c [inch]						
	Torque T-handle					FS2042
	Tightening torque					4,5–14 Nm
	Torque screwdriver, analogue	FS2002	FS2004	FS2004	FS2004	
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm	
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts					P	M	K	N	S						
					HC	HC	HC	HC	HC						
					WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35					
Designation		D _c mm	Seat size												
	P6001-D..	12–30,5	A–K		☒										
	P6003-D..	12–30,5	A–K			☒	☒								
	P6004-D..	12–30,5	A–K					☒							
	P6005-D..	12–30,5	A–K				☒								

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

😐
Moderate

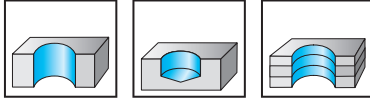
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

D4140.03 inch

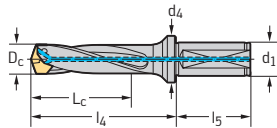


P	M	K	N	S	H	O
●	●	●	●	●		

D4140.03

Tool

Parallel shank with flat



Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
D4140.03-12.00F15-A	0,472	1,496	2,677	1,890	0,625	0,787	0,31	1	P600 . -D12, ..
D4140.03-13.00F15-A	0,512	1,614	2,834	1,890	0,625	0,787	0,32	1	P600 . -D13, ..
D4140.03-14.00F15-B	0,551	1,772	2,992	1,890	0,625	0,787	0,32	1	P600 . -D14, ..
D4140.03-15.00F15-B	0,591	1,890	3,149	1,890	0,625	0,787	0,36	1	P600 . -D15, ..
D4140.03-16.00F19-C	0,630	2,008	3,307	2,031	0,750	0,984	0,49	1	P600 . -D16, ..
D4140.03-17.00F19-C	0,669	2,126	3,465	2,031	0,750	0,984	0,51	1	P600 . -D17, ..
D4140.03-18.00F19-D	0,709	2,244	3,622	2,031	0,750	0,984	0,54	1	P600 . -D18, ..
D4140.03-19.00F19-D	0,748	2,362	3,779	2,031	0,750	0,984	0,57	1	P600 . -D19, ..
D4140.03-20.00F19-E	0,787	2,520	3,937	2,031	0,750	0,984	0,60	1	P600 . -D20, ..
D4140.03-21.00F19-E	0,827	2,638	4,094	2,031	0,750	0,984	0,63	1	P600 . -D21, ..
D4140.03-22.00F26-F	0,866	2,756	4,291	2,281	1,000	1,260	1,00	1	P600 . -D22, ..
D4140.03-23.00F26-F	0,906	2,874	4,449	2,281	1,000	1,260	1,04	1	P600 . -D23, ..
D4140.03-24.00F26-G	0,945	2,992	4,607	2,281	1,000	1,260	1,08	1	P600 . -D24, ..
D4140.03-25.00F26-G	0,984	3,150	4,764	2,281	1,000	1,260	1,13	1	P600 . -D25, ..
D4140.03-26.00F26-H	1,024	3,268	4,921	2,281	1,000	1,260	1,18	1	P600 . -D26, ..
D4140.03-27.00F26-H	1,063	3,386	5,078	2,281	1,000	1,260	1,27	1	P600 . -D27, ..
D4140.03-28.00F31-J	1,102	3,504	5,276	2,281	1,250	1,575	1,71	1	P600 . -D28, ..
D4140.03-29.00F31-J	1,142	3,622	5,433	2,281	1,250	1,575	1,84	1	P600 . -D29, ..
D4140.03-30.00F31-K	1,181	3,740	5,591	2,281	1,250	1,575	1,90	1	P600 . -D30, ..
D4140.03-31.00F31-K	1,220	3,898	5,748	2,281	1,250	1,575	1,97	1	P600 . -D31, ..
D4140.03-32.00F31-M	1,260	4,016	5,905	2,281	1,250	1,575	2,01	1	P600 . -D32, ..
D4140.03-33.00F31-M	1,299	4,134	6,062	2,281	1,250	1,575	2,10	1	P600 . -D33, ..
D4140.03-34.00F38-N	1,339	4,252	6,221	2,688	1,500	1,969	2,81	1	P600 . -D34, ..
D4140.03-35.00F38-N	1,378	4,370	6,378	2,688	1,500	1,969	2,99	1	P600 . -D35, ..
D4140.03-36.00F38-P	1,417	4,528	6,536	2,688	1,500	1,969	2,95	1	P600 . -D36, ..
D4140.03-37.00F38-P	1,457	4,646	6,693	2,688	1,500	1,969	3,15	1	P600 . -D37, ..

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

Assembly parts		0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,866–0,906	0,945–0,984	1,024–1,063	1,102–1,299	1,339–1,457
D _c [inch]											
	Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories		0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,984	1,024–1,457
D _c [inch]						
	Torque T-handle					FS2042
	Tightening torque					4,5–14 Nm
	Torque screwdriver, analogue	FS2002	FS2004	FS2004	FS2004	
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm	
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts					P	M	K	N	S						
					HC	HC	HC	HC	HC						
					WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35					
Designation		D _c mm	Seat size												
	P6001-D..	12–37,99	A–P		☑										
	P6003-D..	12–37,99	A–P			☑	☑								
	P6004-D..	12–31,5	A–K					☑							
	P6005-D..	12–37,99	A–P				☑								

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

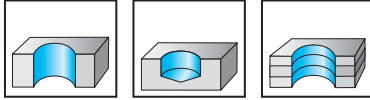
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

D4140-05 mm



	P	M	K	N	S	H	O
D4140-05	●	●	●	●	●		

Tool

	Designation	D _c mm	L _c mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of index- able inserts	Seat size	Type
Parallel shank with collar	D4140-05-12.00A16-A	12	62	92	48	16	20	0,16	1	A	P600 . -D12, ..
	D4140-05-13.00A16-A	13	67	98	48	16	20	0,16	1	A	P600 . -D13, ..
	D4140-05-14.00A16-B	14	73	104	48	16	20	0,17	1	B	P600 . -D14, ..
	D4140-05-15.00A16-B	15	78	110	48	16	20	0,16	1	B	P600 . -D15, ..
	D4140-05-16.00A20-C	16	83	116	50	20	25	0,26	1	C	P600 . -D16, ..
	D4140-05-17.00A20-C	17	88	122	50	20	25	0,26	1	C	P600 . -D17, ..
	D4140-05-18.00A20-D	18	93	128	50	20	25	0,30	1	D	P600 . -D18, ..
	D4140-05-19.00A20-D	19	98	134	50	20	25	0,29	1	D	P600 . -D19, ..
	D4140-05-20.00A20-E	20	104	140	50	20	25	0,34	1	E	P600 . -D20, ..
	D4140-05-21.00A20-E	21	109	146	50	20	25	0,38	1	E	P600 . -D21, ..
	D4140-05-22.00A25-F	22	114	153	56	25	32	0,53	1	F	P600 . -D22, ..
	D4140-05-23.00A25-F	23	119	159	56	25	32	0,56	1	F	P600 . -D23, ..
	D4140-05-24.00A25-G	24	124	165	56	25	32	0,59	1	G	P600 . -D24, ..
	D4140-05-25.00A25-G	25	130	171	56	25	32	0,62	1	G	P600 . -D25, ..
	D4140-05-26.00A25-H	26	135	177	56	25	32	0,6	1	H	P600 . -D26, ..
	D4140-05-27.00A25-H	27	140	183	56	25	32	0,70	1	H	P600 . -D27, ..
	D4140-05-28.00A32-J	28	145	190	60	32	40	0,8	1	J	P600 . -D28, ..
	D4140-05-29.00A32-J	29	150	196	60	32	40	1	1	J	P600 . -D29, ..
	D4140-05-30.00A32-K	30	155	202	60	32	40	1	1	K	P600 . -D30, ..
	D4140-05-31.00A32-K	31	161	208	60	32	40	1,14	1	K	P600 . -D31, ..

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

Assembly parts

D _c [mm]	12-13	14-15	16-17	18-19	20-21	22-23	24-25	26-27	28-31	32-37
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [mm]	12-13	14-17	18-19	20-25	26-37
Torque T-handle Tightening torque					FS2041 4,5-14 Nm
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S							
			HC	HC	HC	HC	HC							
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35						
P6001-D..	12-31,99	A-K	☑											
P6003-D..	12-31,99	A-K		☑	☑			☑						
P6004-D..	12-31,5	A-K					☑							
P6005-D..	12-31,99	A-K			☑									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

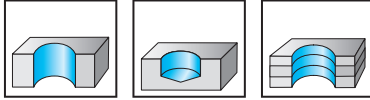
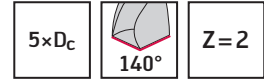
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

D4140-05 mm



	P	M	K	N	S	H	O
D4140-05	●	●	●	●	●		

Tool

Designation	D _c mm	L _c mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of index- able inserts	Seat size	Type
D4140-05-12.00F16-A	12	62	92	48	16	20	0,15	1	A	P600 . -D12, ..
D4140-05-13.00F16-A	13	67	98	48	16	20	0,15	1	A	P600 . -D13, ..
D4140-05-14.00F16-B	14	73	104	48	16	20	0,17	1	B	P600 . -D14, ..
D4140-05-15.00F16-B	15	78	110	48	16	20	0,18	1	B	P600 . -D15, ..
D4140-05-16.00F20-C	16	83	116	50	20	25	0,26	1	C	P600 . -D16, ..
D4140-05-17.00F20-C	17	88	122	50	20	25	0,28	1	C	P600 . -D17, ..
D4140-05-18.00F20-D	18	93	128	50	20	25	0,29	1	D	P600 . -D18, ..
D4140-05-19.00F20-D	19	98	134	50	20	25	0,31	1	D	P600 . -D19, ..
D4140-05-20.00F20-E	20	104	140	50	20	25	0,3	1	E	P600 . -D20, ..
D4140-05-21.00F20-E	21	109	146	50	20	25	0,37	1	E	P600 . -D21, ..
D4140-05-22.00F25-F	22	114	153	56	25	32	0,53	1	F	P600 . -D22, ..
D4140-05-23.00F25-F	23	119	159	56	25	32	0,56	1	F	P600 . -D23, ..
D4140-05-24.00F25-G	24	124	165	56	25	32	0,59	1	G	P600 . -D24, ..
D4140-05-25.00F25-G	25	130	171	56	25	32	0,62	1	G	P600 . -D25, ..
D4140-05-26.00F25-H	26	135	177	56	25	32	0,65	1	H	P600 . -D26, ..
D4140-05-27.00F25-H	27	140	183	56	25	32	0,69	1	H	P600 . -D27, ..
D4140-05-28.00F32-J	28	145	190	60	32	40	0,97	1	J	P600 . -D28, ..
D4140-05-29.00F32-J	29	150	196	60	32	40	1,00	1	J	P600 . -D29, ..
D4140-05-30.00F32-K	30	155	202	60	32	40	1,06	1	K	P600 . -D30, ..
D4140-05-31.00F32-K	31	161	208	60	32	40	1,12	1	K	P600 . -D31, ..
D4140-05-32.00F40-M	32	166	214	70	40	50	1,51	1	M	P600 . -D32, ..
D4140-05-33.00F40-M	33	171	220	70	40	50	1,56	1	M	P600 . -D33,0 ..
D4140-05-34.00F40-N	34	176	226	70	40	50	1,61	1	N	P600 . -D34,0 ..
D4140-05-35.00F40-N	35	181	232	70	40	50	1,66	1	N	P600 . -D35,0 ..
D4140-05-36.00F40-P	36	187	238	70	40	50	1,72	1	P	P600 . -D36,0 ..
D4140-05-37.00F40-P	37	192	244	70	40	50	1,78	1	P	P600 . -D37, ..

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

Assembly parts

D _c [mm]	12-13	14-15	16-17	18-19	20-21	22-23	24-25	26-27	28-31	32-37
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [mm]	12-13	14-17	18-19	20-25	26-37
Torque T-handle Tightening torque					FS2041 4,5-14 Nm
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S							
			HC	HC	HC	HC	HC							
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35						
P6001-D..	12-37,99	A-P	☒											
P6003-D..	12-37,99	A-P		☒	☒			☒						
P6004-D..	12-31,5	A-K					☒							
P6005-D..	12-37,99	A-P			☒									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

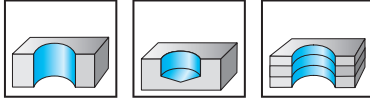
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

D4140.05 inch



	P	M	K	N	S	H	O
D4140.05	●	●	●	●	●		

Tool

	Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with collar	D4140.05-12.00A15-A	0,472	2,441	3,622	1,890	0,625	0,787	0,35	1	P600 . -D12, ..
	D4140.05-13.00A15-A	0,512	2,638	3,858	1,890	0,625	0,787	0,37	1	P600 . -D13, ..
	D4140.05-14.00A15-B	0,551	2,874	4,094	1,890	0,625	0,787	0,39	1	P600 . -D14, ..
	D4140.05-15.00A15-B	0,591	3,071	4,330	1,890	0,625	0,787	0,42	1	P600 . -D15, ..
	D4140.05-16.00A19-C	0,630	3,268	4,567	2,031	0,750	0,984	0,56	1	P600 . -D16, ..
	D4140.05-17.00A19-C	0,669	3,465	4,803	2,031	0,750	0,984	0,57	1	P600 . -D17, ..
	D4140.05-18.00A19-D	0,709	3,661	5,039	2,031	0,750	0,984	0,62	1	P600 . -D18, ..
	D4140.05-19.00A19-D	0,748	3,858	5,275	2,031	0,750	0,984	0,71	1	P600 . -D19, ..
	D4140.05-20.00A19-E	0,787	4,094	5,512	2,031	0,750	0,984	0,77	1	P600 . -D20, ..
	D4140.05-21.00A19-E	0,827	4,291	5,748	2,031	0,750	0,984	0,81	1	P600 . -D21, ..
	D4140.05-22.00A26-F	0,866	4,488	6,024	2,281	1,000	1,260	1,19	1	P600 . -D22, ..
	D4140.05-24.00A26-G	0,945	4,882	6,496	2,281	1,000	1,260	1,32	1	P600 . -D24, ..
	D4140.05-26.00A26-H	1,024	5,315	6,968	2,281	1,000	1,260	1,49	1	P600 . -D26, ..
	D4140.05-28.00A31-J	1,102	5,709	7,481	2,281	1,250	1,575	1,95	1	P600 . -D28, ..
	D4140.05-30.00A31-K	1,181	6,102	7,953	2,281	1,250	1,575	2,31	1	P600 . -D30, ..

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

Assembly parts		0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,866	0,945	1,024	1,102–1,181
D _c [inch]										
	Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm

Accessories		0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,945	1,024–1,181
D _c [inch]						
	Torque T-handle					FS2042
	Tightening torque					4,5–14 Nm
	Torque screwdriver, analogue	FS2002	FS2004	FS2004	FS2004	
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm	
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts					P	M	K	N	S						
					HC	HC	HC	HC	HC						
					WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35					
Designation		D _c mm	Seat size												
	P6001-D..	12–30,5	A–K		☒										
	P6003-D..	12–30,5	A–K			☒	☒								
	P6004-D..	12–30,5	A–K					☒							
	P6005-D..	12–30,5	A–K				☒								

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

😐
Moderate

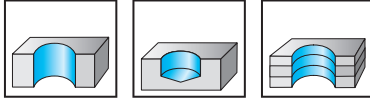
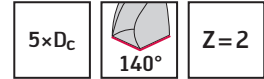
•• Primary application

• Other application

B 1

Exchangeable Tip Drills

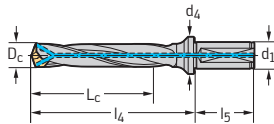
D4140.05 inch



D4140.05	P	M	K	N	S	H	O
	●	●	●	●	●		

Tool

Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
D4140.05-12.00F15-A	0,472	2,441	3,622	1,890	0,625	0,787	0,34	1	P600 . -D12, ..
D4140.05-13.00F15-A	0,512	2,638	3,858	1,890	0,625	0,787	0,36	1	P600 . -D13, ..
D4140.05-14.00F15-B	0,551	2,874	4,094	1,890	0,625	0,787	0,38	1	P600 . -D14, ..
D4140.05-15.00F15-B	0,591	3,071	4,330	1,890	0,625	0,787	0,41	1	P600 . -D15, ..
D4140.05-16.00F19-C	0,630	3,268	4,567	2,031	0,750	0,984	0,55	1	P600 . -D16, ..
D4140.05-17.00F19-C	0,669	3,465	4,803	2,031	0,750	0,984	0,60	1	P600 . -D17, ..
D4140.05-18.00F19-D	0,709	3,661	5,039	2,031	0,750	0,984	0,62	1	P600 . -D18, ..
D4140.05-19.00F19-D	0,748	3,858	5,275	2,031	0,750	0,984	0,67	1	P600 . -D19, ..
D4140.05-20.00F19-E	0,787	4,094	5,512	2,031	0,750	0,984	0,75	1	P600 . -D20, ..
D4140.05-21.00F19-E	0,827	4,291	5,748	2,031	0,750	0,984	0,80	1	P600 . -D21, ..
D4140.05-22.00F26-F	0,866	4,488	6,024	2,281	1,000	1,260	1,19	1	P600 . -D22, ..
D4140.05-23.00F26-F	0,906	4,685	6,260	2,281	1,000	1,260	1,26	1	P600 . -D23, ..
D4140.05-24.00F26-G	0,945	4,882	6,496	2,281	1,000	1,260	1,32	1	P600 . -D24, ..
D4140.05-25.00F26-G	0,984	5,118	6,732	2,281	1,000	1,260	1,40	1	P600 . -D25, ..
D4140.05-26.00F26-H	1,024	5,315	6,968	2,281	1,000	1,260	1,46	1	P600 . -D26, ..
D4140.05-27.00F26-H	1,063	5,512	7,204	2,281	1,000	1,260	1,54	1	P600 . -D27, ..
D4140.05-28.00F31-J	1,102	5,709	7,481	2,281	1,250	1,575	2,08	1	P600 . -D28, ..
D4140.05-29.00F31-J	1,142	5,906	7,717	2,281	1,250	1,575	2,18	1	P600 . -D29, ..
D4140.05-30.00F31-K	1,181	6,339	7,953	2,281	1,250	1,575	2,28	1	P600 . -D30, ..
D4140.05-31.00F31-K	1,220	6,339	8,189	2,281	1,250	1,575	2,39	1	P600 . -D31, ..
D4140.05-32.00F31-M	1,260	6,535	8,425	2,281	1,250	1,575	2,43	1	P600 . -D32, ..
D4140.05-33.00F31-M	1,299	6,732	8,661	2,281	1,250	1,575	2,55	1	P600 . -D33,0 ..
D4140.05-34.00F38-N	1,339	6,929	8,898	2,688	1,500	1,969	3,33	1	P600 . -D34,0 ..
D4140.05-35.00F38-N	1,378	7,126	9,134	2,688	1,500	1,969	3,42	1	P600 . -D35,0 ..
D4140.05-36.00F38-P	1,417	7,362	9,370	2,688	1,500	1,969	3,58	1	P600 . -D36,0 ..
D4140.05-37.00F38-P	1,457	7,559	9,606	2,688	1,500	1,969	3,70	1	P600 . -D37, ..



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

Assembly parts		0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,866–0,906	0,945–0,984	1,024–1,063	1,102–1,299	1,339–1,457
	D _c [inch]										
	Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories		0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,984	1,024–1,457
	Torque T-handle					FS2042
	Tightening torque					4,5–14 Nm
	Torque screwdriver, analogue	FS2002	FS2004	FS2004	FS2004	
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm	
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts					P	M	K	N	S								
	Designation	D _c mm	Seat size		HC	HC	HC	HC	HC								
					WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35							
				P6001-D..	12–37,99	A–P											
				P6003-D..	12–37,99	A–P											
				P6004-D..	12–31,5	A–K											
P6005-D..	12–37,99	A–P															

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

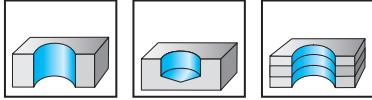
Primary application

Other application

B 1

Exchangeable Tip Drills

D4140-07 mm



	P	M	K	N	S	H	O
D4140-07	●	●	●	●	●		

Tool	Designation	D _c mm	L _c mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of index- able inserts	Seat size	Type
Parallel shank with collar 	D4140-07-12.00A16-A	12	86	116	48	16	20	0,17	1	A	P600 . -D12, ..
	D4140-07-13.00A16-A	13	93	124	48	16	20	0,18	1	A	P600 . -D13, ..
	D4140-07-14.00A16-B	14	101	132	48	16	20	0,20	1	B	P600 . -D14, ..
	D4140-07-15.00A16-B	15	108	140	48	16	20	0,23	1	B	P600 . -D15, ..
	D4140-07-16.00A20-C	16	115	148	50	20	25	0,31	1	C	P600 . -D16, ..
	D4140-07-17.00A20-C	17	122	156	50	20	25	0,33	1	C	P600 . -D17, ..
	D4140-07-18.00A20-D	18	133	164	50	20	25	0,35	1	D	P600 . -D18, ..
	D4140-07-19.00A20-D	19	136	172	50	20	25	0,37	1	D	P600 . -D19, ..
	D4140-07-20.00A20-E	20	144	180	50	20	25	0,4	1	E	P600 . -D20, ..
	D4140-07-21.00A20-E	21	151	188	50	20	25	0,43	1	E	P600 . -D21, ..
	D4140-07-22.00A25-F	22	158	197	56	25	32	0,61	1	F	P600 . -D22, ..
	D4140-07-23.00A25-F	23	165	205	56	25	32	0,65	1	F	P600 . -D23, ..
	D4140-07-24.00A25-G	24	172	213	56	25	32	0,69	1	G	P600 . -D24, ..
	D4140-07-25.00A25-G	25	180	221	56	25	32	0,76	1	G	P600 . -D25, ..
	D4140-07-26.00A25-H	26	187	229	56	25	32	0,8	1	H	P600 . -D26, ..
	D4140-07-27.00A25-H	27	194	237	56	25	32	0,85	1	H	P600 . -D27, ..
	D4140-07-28.00A32-J	28	201	246	60	32	40	1,04	1	J	P600 . -D28, ..
	D4140-07-29.00A32-J	29	208	254	60	32	40	1	1	J	P600 . -D29, ..
	D4140-07-30.00A32-K	30	215	262	60	32	40	1,24	1	K	P600 . -D30, ..
	D4140-07-31.00A32-K	31	223	270	60	32	40	1,30	1	K	P600 . -D31, ..

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

Assembly parts

D _c [mm]	12-13	14-15	16-17	18-19	20-21	22-23	24-25	26-27	28-31	32-37
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [mm]	12-13	14-17	18-19	20-25	26-37
Torque T-handle Tightening torque					FS2041 4,5-14 Nm
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S							
			HC	HC	HC	HC	HC							
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35						
P6001-D..	12-31,99	A-K	☒											
P6003-D..	12-31,99	A-K		☒	☒			☒						
P6004-D..	12-31,5	A-K					☒							
P6005-D..	12-31,99	A-K			☒									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

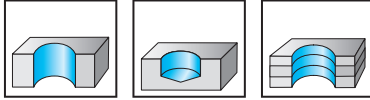
●● Primary application

● Other application

B 1

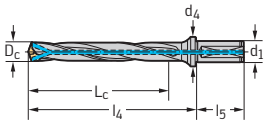
Exchangeable Tip Drills

D4140-07 mm



D4140-07	P	M	K	N	S	H	O
	●	●	●	●	●		

B 1

Tool	Designation	D _c mm	L _c mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of index- able inserts	Seat size	Type
Parallel shank with flat 	D4140-07-12.00F16-A	12	86	116	48	16	20	0,16	1	A	P600 . -D12, ..
	D4140-07-13.00F16-A	13	93	124	48	16	20	0,17	1	A	P600 . -D13, ..
	D4140-07-14.00F16-B	14	101	132	48	16	20	0,19	1	B	P600 . -D14, ..
	D4140-07-15.00F16-B	15	108	140	48	16	20	0,20	1	B	P600 . -D15, ..
	D4140-07-16.00F20-C	16	115	148	50	20	25	0,30	1	C	P600 . -D16, ..
	D4140-07-17.00F20-C	17	122	156	50	20	25	0,32	1	C	P600 . -D17, ..
	D4140-07-18.00F20-D	18	126	164	50	20	25	0,34	1	D	P600 . -D18, ..
	D4140-07-19.00F20-D	19	136	172	50	20	25	0,37	1	D	P600 . -D19, ..
	D4140-07-20.00F20-E	20	144	180	50	20	25	0,39	1	E	P600 . -D20, ..
	D4140-07-21.00F20-E	21	151	188	50	20	25	0,43	1	E	P600 . -D21, ..
	D4140-07-22.00F25-F	22	158	197	56	25	32	0,6	1	F	P600 . -D22, ..
	D4140-07-23.00F25-F	23	165	205	56	25	32	0,63	1	F	P600 . -D23, ..
	D4140-07-24.00F25-G	24	172	213	56	25	32	0,68	1	G	P600 . -D24, ..
	D4140-07-25.00F25-G	25	180	221	56	25	32	0,71	1	G	P600 . -D25, ..
	D4140-07-26.00F25-H	26	187	229	56	25	32	0,80	1	H	P600 . -D26, ..
	D4140-07-27.00F25-H	27	194	237	56	25	32	0,82	1	H	P600 . -D27, ..
	D4140-07-28.00F32-J	28	201	246	60	32	40	1,11	1	J	P600 . -D28, ..
	D4140-07-29.00F32-J	29	208	254	60	32	40	1,14	1	J	P600 . -D29, ..
	D4140-07-30.00F32-K	30	215	262	60	32	40	1,24	1	K	P600 . -D30, ..
	D4140-07-31.00F32-K	31	223	270	60	32	40	1,30	1	K	P600 . -D31, ..
	D4140-07-32.00F40-M	32	230	278	70	40	50	1,80	1	M	P600 . -D32, ..
	D4140-07-33.00F40-M	33	237	286	70	40	50	1,86	1	M	P600 . -D33,0 ..
	D4140-07-34.00F40-N	34	244	294	70	40	50	1,94	1	N	P600 . -D34,0 ..
	D4140-07-35.00F40-N	35	251	302	70	40	50	2,06	1	N	P600 . -D35,0 ..
	D4140-07-36.00F40-P	36	259	310	70	40	50	2,09	1	P	P600 . -D36,0 ..
	D4140-07-37.00F40-P	37	266	318	70	40	50	2,21	1	P	P600 . -D37, ..

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

Assembly parts

D _c [mm]	12-13	14-15	16-17	18-19	20-21	22-23	24-25	26-27	28-31	32-37
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [mm]	12-13	14-17	18-19	20-25	26-37
Torque T-handle Tightening torque					FS2041 4,5-14 Nm
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S							
			HC	HC	HC	HC	HC							
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35						
P6001-D..	12-37,99	A-P	☞											
P6003-D..	12-37,99	A-P		☞	☞									
P6004-D..	12-31,5	A-K					☞							
P6005-D..	12-37,99	A-P			☞									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

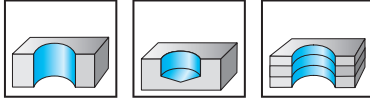
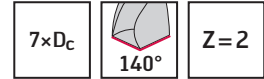
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

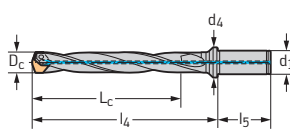
D4140.07 inch



	P	M	K	N	S	H	O
D4140.07	●	●	●	●	●		

Tool

Parallel shank with collar



Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
D4140.07-12.00A15-A	0,472	3,386	4,567	1,890	0,625	0,787	0,38	1	P600 . -D12, ..
D4140.07-13.00A15-A	0,512	3,661	4,882	1,890	0,625	0,787	0,41	1	P600 . -D13, ..
D4140.07-14.00A15-B	0,551	3,976	5,196	1,890	0,625	0,787	0,42	1	P600 . -D14, ..
D4140.07-15.00A15-B	0,591	4,252	5,511	1,890	0,625	0,787	0,47	1	P600 . -D15, ..
D4140.07-16.00A19-C	0,630	4,528	5,827	2,031	0,750	0,984	0,66	1	P600 . -D16, ..
D4140.07-17.00A19-C	0,669	4,803	6,142	2,031	0,750	0,984	0,71	1	P600 . -D17, ..
D4140.07-18.00A19-D	0,709	5,079	6,457	2,031	0,750	0,984	0,75	1	P600 . -D18, ..
D4140.07-19.00A19-D	0,748	5,354	6,771	2,031	0,750	0,984	0,80	1	P600 . -D19, ..
D4140.07-20.00A19-E	0,787	5,669	7,086	2,031	0,750	0,984	0,88	1	P600 . -D20, ..
D4140.07-21.00A19-E	0,827	5,945	7,401	2,031	0,750	0,984	0,95	1	P600 . -D21, ..
D4140.07-22.00A26-F	0,866	6,220	7,756	2,281	1,000	1,260	1,34	1	P600 . -D22, ..
D4140.07-24.00A26-G	0,945	6,772	8,386	2,281	1,000	1,260	1,54	1	P600 . -D24, ..
D4140.07-26.00A26-H	1,024	7,362	9,016	2,281	1,000	1,260	1,72	1	P600 . -D26, ..
D4140.07-28.00A31-J	1,102	7,913	9,685	2,281	1,250	1,575	2,43	1	P600 . -D28, ..
D4140.07-30.00A31-K	1,181	8,465	10,315	2,281	1,250	1,575	2,67	1	P600 . -D30, ..

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

Assembly parts

D _c [inch]	0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,945	1,024	1,102–1,181
Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)
Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm

Accessories

D _c [inch]	0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,945	1,024–1,181
Torque T-handle Tightening torque					FS2042 4,5–14 Nm
Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm	
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S							
			HC	HC	HC	HC	HC							
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35						
P6001-D..	12–30,5	A–K	☒											
P6003-D..	12–30,5	A–K		☒	☒			☒						
P6004-D..	12–30,5	A–K					☒							
P6005-D..	12–30,5	A–K			☒									

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

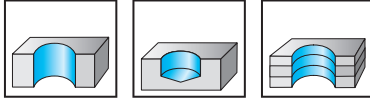
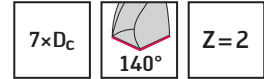
●● Primary application

● Other application

B 1

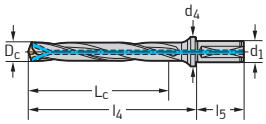
Exchangeable Tip Drills

D4140.07 inch



	P	M	K	N	S	H	O
D4140.07	●	●	●	●	●		

B 1

Tool	Designation	D _c inch	L _c inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with flat 	D4140.07-12.00F15-A	0,472	3,386	4,567	1,890	0,625	0,787	0,37	1	P600 .-D12, ..
	D4140.07-13.00F15-A	0,512	3,661	4,882	1,890	0,625	0,787	0,39	1	P600 .-D13, ..
	D4140.07-14.00F15-B	0,551	3,976	5,197	1,890	0,625	0,787	0,42	1	P600 .-D14, ..
	D4140.07-15.00F15-B	0,591	4,252	5,511	1,890	0,625	0,787	0,45	1	P600 .-D15, ..
	D4140.07-16.00F19-C	0,630	4,528	5,712	2,031	0,750	0,984	0,62	1	P600 .-D16, ..
	D4140.07-17.00F19-C	0,669	4,803	6,020	2,031	0,750	0,984	0,70	1	P600 .-D17, ..
	D4140.07-18.00F19-D	0,709	5,079	6,328	2,031	0,750	0,984	0,73	1	P600 .-D18, ..
	D4140.07-19.00F19-D	0,748	5,354	6,636	2,031	0,750	0,984	0,79	1	P600 .-D19, ..
	D4140.07-20.00F19-E	0,787	5,669	6,943	2,031	0,750	0,984	0,86	1	P600 .-D20, ..
	D4140.07-21.00F19-E	0,827	5,945	7,251	2,031	0,750	0,984	0,93	1	P600 .-D21, ..
	D4140.07-22.00F26-F	0,866	6,220	7,598	2,281	1,000	1,260	1,35	1	P600 .-D22, ..
	D4140.07-23.00F26-F	0,906	6,496	7,906	2,281	1,000	1,260	1,43	1	P600 .-D23, ..
	D4140.07-24.00F26-G	0,945	6,772	8,214	2,281	1,000	1,260	1,52	1	P600 .-D24, ..
	D4140.07-25.00F26-G	0,984	7,087	8,522	2,281	1,000	1,260	1,61	1	P600 .-D25, ..
	D4140.07-26.00F26-H	1,024	7,362	9,016	2,281	1,000	1,260	1,78	1	P600 .-D26, ..
	D4140.07-27.00F26-H	1,063	7,638	9,330	2,281	1,000	1,260	1,80	1	P600 .-D27, ..
	D4140.07-28.00F31-J	1,102	7,913	9,685	2,281	1,250	1,575	2,38	1	P600 .-D28, ..
	D4140.07-29.00F31-J	1,142	8,189	10,000	2,281	1,250	1,575	2,43	1	P600 .-D29, ..
	D4140.07-30.00F31-K	1,181	8,465	10,315	2,281	1,250	1,575	2,84	1	P600 .-D30, ..
	D4140.07-31.00F31-K	1,220	8,780	10,630	2,281	1,250	1,575	2,81	1	P600 .-D31, ..
	D4140.07-32.00F31-M	1,260	9,055	10,945	2,281	1,250	1,575	2,87	1	P600 .-D32, ..
	D4140.07-33.00F31-M	1,299	9,331	11,259	2,281	1,250	1,575	3,26	1	P600 .-D33,0 ..
	D4140.07-34.00F38-N	1,339	9,606	11,575	2,688	1,500	1,969	4,03	1	P600 .-D34,0 ..
	D4140.07-35.00F38-N	1,378	9,882	11,890	2,688	1,500	1,969	4,25	1	P600 .-D35,0 ..
	D4140.07-36.00F38-P	1,417	10,197	12,205	2,688	1,500	1,969	4,36	1	P600 .-D36,0 ..
	D4140.07-37.00F38-P	1,457	10,433	12,520	2,688	1,500	1,969	4,59	1	P600 .-D37, ..

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

Assembly parts		0,472–0,512	0,551–0,591	0,630–0,669	0,709–0,748	0,787–0,827	0,866–0,906	0,945–0,984	1,024–1,063	1,102–1,299	1,339–1,457
D _c [inch]											
	Clamping screw for drill insert	FS1396 (Torx 7IP)	FS1397 (Torx 8IP)	FS1398 (Torx 8IP)	FS1399 (Torx 15IP)	FS1400 (Torx 20IP)	FS1401 (Torx 20IP)	FS1402 (Torx 20IP)	FS1403 (Torx 25IP)	FS1404 (Torx 25IP)	FS2159 (Torx 25IP)
	Tightening torque	1,2 Nm	2,0 Nm	2,0 Nm	4,0 Nm	5,0 Nm	5,0 Nm	5,0 Nm	5,5 Nm	5,5 Nm	5,5 Nm

Accessories		0,472–0,512	0,551–0,669	0,709–0,748	0,787–0,984	1,024–1,457
D _c [inch]						
	Torque T-handle					FS2042
	Tightening torque					4,5–14 Nm
	Torque screwdriver, analogue	FS2002	FS2004	FS2004	FS2004	
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm	1,5–5,0 Nm	
	Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)	FS2049 (Torx 25IP)
	Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1487 (Torx 25IP)

Drill inserts																		
Designation		D _c mm	Seat size	WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35									
	P6001-D..	12–37,99	A–P	HC														
	P6003-D..	12–37,99	A–P		HC													
	P6004-D..	12–31,5	A–K															
	P6005-D..	12–37,99	A–P															

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

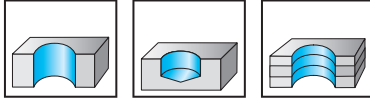
●● Primary application

● Other application

B 1

Exchangeable Tip Drills

D4140-10 mm



	P	M	K	N	S	H	O
D4140-10	●●	●	●●	●●	●		

B 1

Tool	Designation	D_c mm	L_c mm	l_4 mm	l_5 mm	d_1 mm	d_4 mm	kg	No. of indexable inserts	Seat size	Type
Parallel shank with flat 	D4140-10-18.00F20-D	18	183	218	50	20	25	0,40	1	D	P600 . -D18, ..
	D4140-10-20.00F20-E	20	204	240	50	20	25	0,48	1	E	P600 . -D20, ..
	D4140-10-22.00F25-F	22	224	263	56	25	32	0,71	1	F	P600 . -D22, ..
	D4140-10-24.00F25-G	24	244	285	56	25	32	0,83	1	G	P600 . -D24, ..

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

Assembly parts

D _c [mm]	18	20	22	24
	FS1399 (Torx 15IP) 4,0 Nm	FS1400 (Torx 20IP) 5,0 Nm	FS1401 (Torx 20IP) 5,0 Nm	FS1402 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	18	20-24
	FS2004 1,5-5,0 Nm	FS2004 1,5-5,0 Nm
	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Drill inserts

Designation	D _c mm	Seat size	P	M	K	N	S						
			HC	HC	HC	HC	HC						
			WPP45C	WMP35	WMP35	WKK45C	WNN25	WMP35					
P6001-D..	18-24,7	D-G	☑										
P6003-D..	18-24,7	D-G		☑	☑			☑					
P6004-D..	18-24,5	D-G					☑						
P6005-D..	18-24,7	D-G			☑								

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

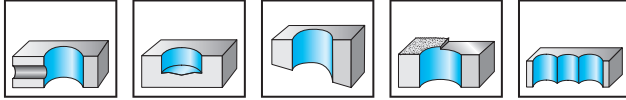
●●
Primary application

●
Other application

B 1

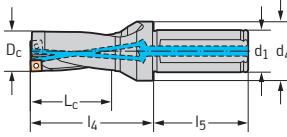
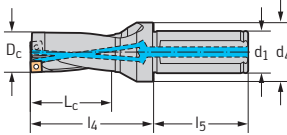
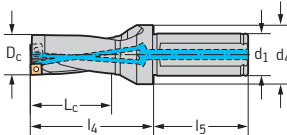
Indexable insert drills

 D4120-02 mm

2×D_C
Z=1


P	M	K	N	S	H	O
●	●	●	●	●	●	●

D4120-02

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-02-13.50F20-P41	13,5	27	47	50	20	25	0,23	1 1	P484 . P-1R- ... P484 . C-1R- ...
	D4120-02-14.00F20-P41	14	28	48	50	20	25	0,23	1 1	
	★ D4120-02-14.50F20-P41	14,5	29	49	50	20	25	0,24	1 1	
	D4120-02-15.00F20-P41	15	30	50	50	20	25	0,24	1 1	
	★ D4120-02-15.50F20-P41	15,5	31	51	50	20	25	0,23	1 1	
	D4120-02-16.00F25-P41	16	32	57	56	25	35	0,40	1 1	
Parallel shank with flat 	★ D4120-02-16.50F25-P42	16,5	33	58	56	25	35	0,42	1 1	P484 . P-2R- ... P484 . C-2R- ...
	D4120-02-17.00F25-P42	17	34	59	56	25	35	0,41	1 1	
	★ D4120-02-17.50F25-P42	17,5	35	60	56	25	35	0,40	1 1	
	D4120-02-18.00F25-P42	18	36	61	56	25	35	0,42	1 1	
	★ D4120-02-18.50F25-P42	18,5	37	62	56	25	35	0,43	1 1	
	D4120-02-19.00F25-P42	19	38	63	56	25	35	0,42	1 1	
Parallel shank with flat 	★ D4120-02-20.50F25-P43	20,5	41	66	56	25	35	0,43	1 1	P484 . P-3R- ... P484 . C-3R- ...
	D4120-02-21.00F25-P43	21	42	67	56	25	35	0,45	1 1	
	★ D4120-02-21.50F25-P43	21,5	43	68	56	25	35	0,46	1 1	
	D4120-02-22.00F25-P43	22	44	69	56	25	35	0,44	1 1	
	★ D4120-02-22.50F25-P43	22,5	45	70	56	25	35	0,46	1 1	
	D4120-02-23.00F25-P43	23	46	71	56	25	35	0,48	1 1	
★ D4120-02-23.50F25-P43	23,5	47	72	56	25	35	0,48	1 1		
D4120-02-24.00F25-P43	24	48	73	56	25	35	0,48	1 1		

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

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59
	FS2120 (Torx 6IP)	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)
Tightening torque	0,4 Nm	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59
	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P		M		K		N		S	
		HC		HC		HC		HC		HC	
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WSP45	WSP45S
	P4840P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840C-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹
Very good

☹☹
Good

☹☹☹
Moderate

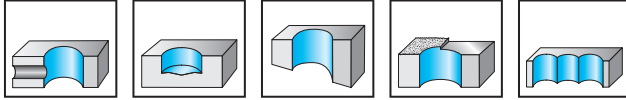
●● Primary application

● Other application

B 1

Indexable insert drills

D4120-02 mm

2×D_C
Z=1


D4120-02	P	M	K	N	S	H	O
	●	●	●	●	●		

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-02-24.50F25-P44	24,5	49	74	56	25	35	0,5	1 1	P484 . P-4R- .. P484 . C-4R- ..
	D4120-02-25.00F25-P44	25	50	75	56	25	35	0,48	1 1	
	★ D4120-02-25.50F32-P44	25,5	51	83	60	32	42	0,76	1 1	
	D4120-02-26.00F32-P44	26	52	84	60	32	42	0,72	1 1	
	★ D4120-02-26.50F32-P44	26,5	53	85	60	32	42	0,78	1 1	
	D4120-02-27.00F32-P44	27	54	86	60	32	42	0,77	1 1	
	★ D4120-02-27.50F32-P44	27,5	55	87	60	32	42	0,8	1 1	
	D4120-02-28.00F32-P44	28	56	88	60	32	42	0,81	1 1	
	★ D4120-02-28.50F32-P44	28,5	57	89	60	32	42	0,82	1 1	
	D4120-02-29.00F32-P44	29	58	90	60	32	42	0,81	1 1	
Parallel shank with flat 	★ D4120-02-29.50F32-P45	29,5	59	91	60	32	42	0,83	1 1	P484 . P-5R- .. P484 . C-5R- ..
	D4120-02-30.00F32-P45	30	60	92	60	32	42	0,84	1 1	
	D4120-02-31.00F32-P45	31	62	94	60	32	42	0,87	1 1	
	D4120-02-32.00F32-P45	32	64	96	60	32	42	0,88	1 1	
	D4120-02-33.00F32-P45	33	66	98	60	32	42	0,91	1 1	
	D4120-02-34.00F32-P45	34	68	100	60	32	42	0,94	1 1	
	D4120-02-35.00F32-P45	35	70	102	60	32	42	0,97	1 1	
Parallel shank with flat 	D4120-02-36.00F32-P46	36	72	104	60	32	42	0,96	1 1	P484 . P-6R- .. P484 . C-6R- ..
	D4120-02-37.00F40-P46	37	74	114	70	40	50	1,48	1 1	
	D4120-02-38.00F40-P46	38	76	116	70	40	50	1,52	1 1	
	D4120-02-39.00F40-P46	39	78	118	70	40	50	1,55	1 1	
	D4120-02-40.00F40-P46	40	80	120	70	40	50	1,45	1 1	
	D4120-02-41.00F40-P46	41	82	122	70	40	50	1,64	1 1	
	D4120-02-42.00F40-P46	42	84	124	70	40	50	1,67	1 1	

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59
	FS2120 (Torx 6IP)	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)
Tightening torque	0,4 Nm	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59
	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E67	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-A57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-E57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840C-.R-E67	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-A57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-E57	4-6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

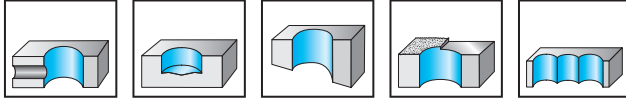
☺
Moderate

●● Primary application

● Other application

Indexable insert drills

D4120-02 mm

2×D_C
Z=1


D4120-02	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-02-43.00F40-P47	43	86	126	70	40	50	1,69	1 1	P484 . P-7R-.. P484 . C-7R-..
	★ D4120-02-44.00F40-P47	44	88	128	70	40	50	1,78	1 1	
	★ D4120-02-45.00F40-P47	45	90	130	70	40	50	1,82	1 1	
	★ D4120-02-46.00F40-P47	46	92	132	70	40	50	1,87	1 1	
	★ D4120-02-47.00F40-P47	47	94	134	70	40	50	1,92	1 1	
	★ D4120-02-48.00F40-P47	48	96	136	70	40	50	1,97	1 1	
	★ D4120-02-49.00F40-P47	49	98	138	70	40	50	2	1 1	
	★ D4120-02-50.00F40-P47	50	100	140	70	40	50	2,09	1 1	
Parallel shank with flat 	★ D4120-02-51.00F40-P48	51	102	142	70	40	50	2,09	1 1	P484 . P-8R-.. P484 . C-8R-..
	★ D4120-02-52.00F40-P48	52	104	144	70	40	50	2,04	1 1	
	★ D4120-02-53.00F40-P48	53	106	146	70	40	50	2,21	1 1	
	★ D4120-02-54.00F40-P48	54	108	148	70	40	50	2,28	1 1	
	★ D4120-02-55.00F40-P48	55	110	150	70	40	50	2,35	1 1	
	★ D4120-02-56.00F40-P48	56	112	152	70	40	50	2,42	1 1	
	★ D4120-02-57.00F40-P48	57	114	154	70	40	50	2,5	1 1	
	★ D4120-02-58.00F40-P48	58	116	156	70	40	50	2,57	1 1	
	★ D4120-02-59.00F40-P48	59	118	158	70	40	50	2,65	1 1	

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

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59	
	Clamping screw for indexable insert Tightening torque	FS2120 (Torx 6IP) 0,4 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS1454 (Torx 8IP) 1,2 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS2080 (Torx 15IP) 2,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1495 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59	
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	Screwdriver	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E67	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-A57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-E57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840C-.R-E67	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-A57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-E57	7–8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

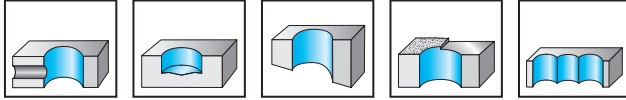
●● Primary application

● Other application

B 1

Indexable insert drills

D4120-03 mm

3×D_C
Z=1


D4120-03	P	M	K	N	S	H	O
	●	●	●	●	●		

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-03-13.50F20-P41	13,5	40,5	61	50	20	25	0,02	1 1	P484 . P-1R- ... P484 . C-1R- ...
	D4120-03-14.00F20-P41	14	42	62	50	20	25	0,17	1 1	
	★ D4120-03-14.50F20-P41	14,5	43,5	64	50	20	25	0,26	1 1	
	D4120-03-15.00F20-P41	15	45	65	50	20	25	0,25	1 1	
	★ D4120-03-15.50F20-P41	15,5	46,5	67	50	20	25	0,26	1 1	
	D4120-03-16.00F25-P41	16	48	73	56	25	35	0,39	1 1	
Parallel shank with flat 	★ D4120-03-16.50F25-P42	16,5	49,5	75	56	25	35	0,44	1 1	P484 . P-2R- ... P484 . C-2R- ...
	D4120-03-17.00F25-P42	17	51	76	56	25	35	0,35	1 1	
	★ D4120-03-17.50F25-P42	17,5	52,5	77	56	25	35	0,44	1 1	
	D4120-03-18.00F25-P42	18	54	79	56	25	35	0,44	1 1	
	★ D4120-03-18.50F25-P42	18,5	55,5	80	56	25	35	0,46	1 1	
	D4120-03-19.00F25-P42	19	57	82	56	25	35	0,45	1 1	
Parallel shank with flat 	★ D4120-03-19.50F25-P42	19,5	58,5	84	56	25	35	0,47	1 1	P484 . P-3R- ... P484 . C-3R- ...
	D4120-03-20.00F25-P42	20	60	85	56	25	35	0,46	1 1	
	★ D4120-03-20.50F25-P43	20,5	61,5	87	56	25	35	0,48	1 1	
	D4120-03-21.00F25-P43	21	63	88	56	25	35	0,39	1 1	
	★ D4120-03-21.50F25-P43	21,5	64,5	90	56	25	35	0,49	1 1	
	D4120-03-22.00F25-P43	22	66	91	56	25	35	0,50	1 1	
Parallel shank with flat 	★ D4120-03-22.50F25-P43	22,5	67,5	93	56	25	35	0,51	1 1	
	D4120-03-23.00F25-P43	23	69	94	56	25	35	0,52	1 1	
	★ D4120-03-23.50F25-P43	23,5	70,5	96	56	25	35	0,53	1 1	
	D4120-03-24.00F25-P43	24	72	97	56	25	35	0,53	1 1	

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59
	FS2120 (Torx 6IP)	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)
Tightening torque	0,4 Nm	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59
	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P		M		K		N		S	
		HC		HC		HC		HC		HC	
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WSP45	WSP45S
	P4840P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840C-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹
Very good

☹
Good

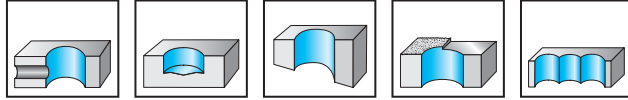
☹
Moderate

●● Primary application

● Other application

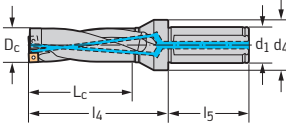
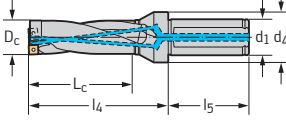
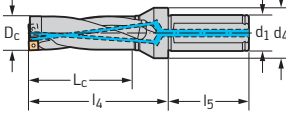
Indexable insert drills

D4120-03 mm

3×D_C
Z=1


D4120-03	P	M	K	N	S	H	O
	●	●	●	●	●		

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-03-24.50F25-P44	24,5	73,5	99	56	25	35	0,56	1 1	P484 . P-4R- .. P484 . C-4R- ..
	D4120-03-25.00F25-P44	25	75	100	56	25	35	0,43	1 1	
	★ D4120-03-25.50F32-P44	25,5	76,5	109	60	32	42	0,84	1 1	
	D4120-03-26.00F32-P44	26	78	110	60	32	42	0,84	1 1	
	★ D4120-03-26.50F32-P44	26,5	79,5	112	60	32	42	0,85	1 1	
	D4120-03-27.00F32-P44	27	81	113	60	32	42	0,85	1 1	
	★ D4120-03-27.50F32-P44	27,5	82,5	115	60	32	42	0,88	1 1	
	D4120-03-28.00F32-P44	28	84	116	60	32	42	0,89	1 1	
	★ D4120-03-28.50F32-P44	28,5	85,5	118	60	32	42	0,91	1 1	
	D4120-03-29.00F32-P44	29	87	119	60	32	42	0,92	1 1	
Parallel shank with flat 	★ D4120-03-29.50F32-P45	29,5	88,5	121	60	32	42	0,93	1 1	P484 . P-5R- .. P484 . C-5R- ..
	D4120-03-30.00F32-P45	30	90	122	60	32	42	0,94	1 1	
	D4120-03-31.00F32-P45	31	93	125	60	32	42	0,95	1 1	
	D4120-03-32.00F32-P45	32	96	128	60	32	42	1	1 1	
	D4120-03-33.00F32-P45	33	99	131	60	32	42	1,03	1 1	
	D4120-03-34.00F32-P45	34	102	134	60	32	42	1,07	1 1	
	D4120-03-35.00F32-P45	35	105	137	60	32	42	1,12	1 1	
Parallel shank with flat 	D4120-03-36.00F32-P46	36	108	140	60	32	42	1,02	1 1	P484 . P-6R- .. P484 . C-6R- ..
	D4120-03-37.00F40-P46	37	111	151	70	40	50	1,68	1 1	
	D4120-03-38.00F40-P46	38	114	154	70	40	50	1,72	1 1	
	D4120-03-39.00F40-P46	39	117	157	70	40	50	1,76	1 1	
	D4120-03-40.00F40-P46	40	120	160	70	40	50	1,82	1 1	
	D4120-03-41.00F40-P46	41	123	163	70	40	50	1,88	1 1	
	D4120-03-42.00F40-P46	42	126	166	70	40	50	1,94	1 1	

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59
	FS2120 (Torx 6IP)	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)
Tightening torque	0,4 Nm	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59
	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E67	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-A57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-E57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840C-.R-E67	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-A57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-E57	4–6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

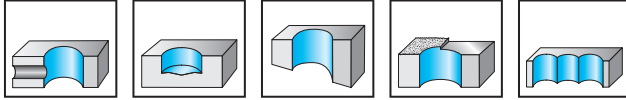
●● Primary application

● Other application

B 1

Indexable insert drills

D4120-03 mm

3×D_C
Z=1


D4120-03	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120-03-43.00F40-P47	43	129	169	70	40	50	2	1 1	P484 . P-7R-.. P484 . C-7R-..
	★ D4120-03-44.00F40-P47	44	132	172	70	40	50	2,06	1 1	
	★ D4120-03-45.00F40-P47	45	135	175	70	40	50	2,12	1 1	
	★ D4120-03-46.00F40-P47	46	138	178	70	40	50	2,19	1 1	
	★ D4120-03-47.00F40-P47	47	141	181	70	40	50	2,27	1 1	
	★ D4120-03-48.00F40-P47	48	144	184	70	40	50	2,35	1 1	
	★ D4120-03-49.00F40-P47	49	147	187	70	40	50	2,42	1 1	
	★ D4120-03-50.00F40-P47	50	150	190	70	40	50	2,51	1 1	
Parallel shank with flat 	★ D4120-03-51.00F40-P48	51	153	193	70	40	50	2,53	1 1	P484 . P-8R-.. P484 . C-8R-..
	★ D4120-03-52.00F40-P48	52	156	196	70	40	50	2,6	1 1	
	★ D4120-03-53.00F40-P48	53	159	199	70	40	50	2,7	1 1	
	★ D4120-03-54.00F40-P48	54	162	202	70	40	50	2,8	1 1	
	★ D4120-03-55.00F40-P48	55	165	205	70	40	50	2,9	1 1	
	★ D4120-03-56.00F40-P48	56	168	208	70	40	50	3	1 1	
	★ D4120-03-57.00F40-P48	57	171	211	70	40	50	3,12	1 1	
	★ D4120-03-58.00F40-P48	58	174	214	70	40	50	3,23	1 1	
	★ D4120-03-59.00F40-P48	59	177	217	70	40	50	3,36	1 1	

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

Assembly parts

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–35	36–42	43–59
	FS2120 (Torx 6IP)	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)
Tightening torque	0,4 Nm	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm

Accessories

D _c [mm]	13,5–16	16,5–20	20,5–24	24,5–29	29,5–42	43–59
	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840P-.R-E67	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-A57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841P-.R-E57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4840C-.R-E67	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-A57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	P4841C-.R-E57	7-8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

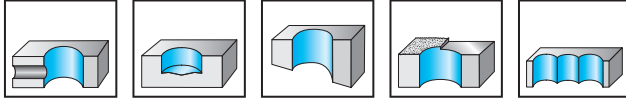
●● Primary application

● Other application

B 1

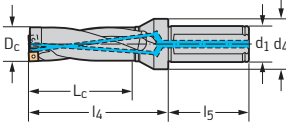
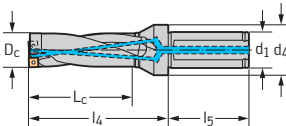
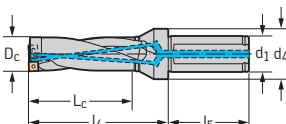
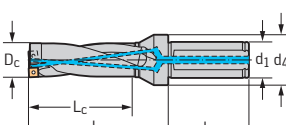
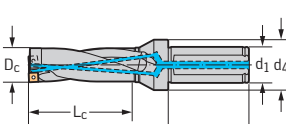
Indexable insert drills

D4120.03 inch


3×D_C
Z = 1



P	M	K	N	S	H	O
●	●	●	●	●	●	●

D4120.03

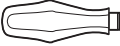



Tool	Designation	D _C inch	L _C inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120.03-14.27F19-P41	0,562	1,693	2,473	1,969	0,750	1,000	0,53	1 1	P484 . P-1R- ... P484 . C-1R- ...
	★ D4120.03-14.68F19-P41	0,578	1,732	2,521	1,969	0,750	1,000	0,54	1 1	
	★ D4120.03-15.88F19-P41	0,625	1,875	2,662	1,969	0,750	1,000	0,56	1 1	
Parallel shank with flat 	★ D4120.03-16.66F26-P42	0,656	1,969	2,970	2,205	1,000	1,260	0,95	1 1	P484 . P-2R- ... P484 . C-2R- ...
	★ D4120.03-19.05F26-P42	0,750	2,244	3,262	2,205	1,000	1,260	1,01	1 1	
	★ D4120.03-19.84F26-P42	0,781	2,323	3,352	2,205	1,000	1,260	1,07	1 1	
Parallel shank with flat 	★ D4120.03-20.62F26-P43	0,812	2,441	3,453	2,205	1,000	1,260	1,07	1 1	P484 . P-3R- ... P484 . C-3R- ...
	★ D4120.03-21.41F26-P43	0,843	2,520	3,543	2,205	1,000	1,260	1,10	1 1	
	★ D4120.03-22.23F31-P43	0,875	2,638	3,773	2,362	1,250	1,575	1,56	1 1	
Parallel shank with flat 	★ D4120.03-25.40F31-P44	1,000	3,000	4,144	2,362	1,250	1,575	1,77	1 1	P484 . P-4R- ... P484 . C-4R- ...
	★ D4120.03-26.97F31-P44	1,062	3,189	4,334	2,362	1,250	1,575	1,76	1 1	
	★ D4120.03-28.58F31-P44	1,125	3,386	4,524	2,362	1,250	1,575	1,86	1 1	
Parallel shank with flat 	★ D4120.03-31.75F31-P45	1,250	3,740	4,896	2,362	1,250	1,575	2,06	1 1	P484 . P-5R- ... P484 . C-5R- ...
	★ D4120.03-33.32F31-P45	1,312	3,937	5,086	2,362	1,250	1,575	2,20	1 1	
	★ D4120.03-34.93F31-P45	1,375	4,134	5,276	2,362	1,250	1,575	2,34	1 1	

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



Assembly parts

D _c [inch]	0,562–0,625	0,656–0,781	0,812–0,875	1,000–1,125	1,250–1,375
 Clamping screw for indexable insert Tightening torque	FS2120 (Torx 6IP) 0,4 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS1454 (Torx 8IP) 1,2 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS2080 (Torx 15IP) 2,5 Nm

Accessories

D _c [inch]	0,562–0,625	0,656–0,781	0,812–0,875	1,000–1,125	1,250–1,375
 Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2002 0,4–1,2 Nm	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)
 Screwdriver	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840P-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841P-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4840C-.R-E67	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-A57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹
	P4841C-.R-E57	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹
Very good

☹☹
Good

☹☹☹
Moderate

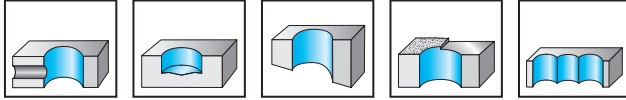
●●
Primary application

●
Other application

B 1

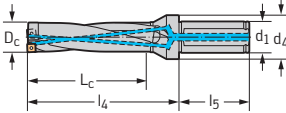
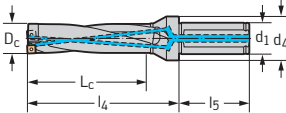
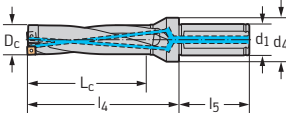
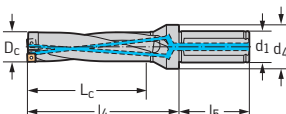
Indexable insert drills

D4120-04 mm

4×D_C
Z=1


D4120-04	P	M	K	N	S	H	O
	●	●	●	●	●		

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D4120-04-17.00F25-P42	17	68	93	56	25	35	0,45	1 1	P484 . P-2R- ... P484 . C-2R- ...
	D4120-04-18.00F25-P42	18	72	97	56	25	35	0,46	1 1	
	D4120-04-19.00F25-P42	19	76	101	56	25	35	0,47	1 1	
	D4120-04-20.00F25-P42	20	80	105	56	25	35	0,49	1 1	
Parallel shank with flat 	D4120-04-21.00F25-P43	21	84	109	56	25	35	0,51	1 1	P484 . P-3R- ... P484 . C-3R- ...
	D4120-04-22.00F25-P43	22	88	113	56	25	35	0,53	1 1	
	D4120-04-23.00F25-P43	23	92	117	56	25	35	0,55	1 1	
	D4120-04-24.00F25-P43	24	96	121	56	25	35	0,57	1 1	
Parallel shank with flat 	D4120-04-25.00F25-P44	25	100	125	56	25	35	0,58	1 1	P484 . P-4R- ... P484 . C-4R- ...
	D4120-04-26.00F32-P44	26	104	136	60	32	42	0,89	1 1	
	D4120-04-27.00F32-P44	27	108	140	60	32	42	0,93	1 1	
	D4120-04-28.00F32-P44	28	112	144	60	32	42	0,96	1 1	
Parallel shank with flat 	D4120-04-29.00F32-P44	29	116	148	60	32	42	1,00	1 1	P484 . P-5R- ... P484 . C-5R- ...
	D4120-04-30.00F32-P45	30	120	152	60	32	42	1,02	1 1	
	D4120-04-31.00F32-P45	31	124	156	60	32	42	1,07	1 1	
	D4120-04-32.00F32-P45	32	128	160	60	32	42	1,10	1 1	
	D4120-04-33.00F32-P45	33	132	164	60	32	42	1,17	1 1	
	D4120-04-34.00F32-P45	34	136	168	60	32	42	1,18	1 1	
D4120-04-35.00F32-P45	35	140	172	60	32	42	1,28	1 1		

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

Assembly parts

D _c [mm]	17-20	21-24	25-29	30-35	36-42	43-59
 Clamping screw for indexable insert Tightening torque	FS2111 (Torx 7IP) 0,9 Nm	FS1454 (Torx 8IP) 1,2 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS2080 (Torx 15IP) 2,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1495 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	17-20	21-24	25-29	30-42	43-59
 Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm
 Torque screwdriver, digital Tightening torque		FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm
 Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S				
		HC					HC			HC			HC		HC				
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40	
 P4840P-R-A57 P4840P-R-E57 P4840P-R-E67 P4841P-R-A57 P4841P-R-E57	2-5	☞	☞	☞	☞	☞				☞	☞								
	2-5	☞	☞	☞	☞	☞				☞	☞								
	2-5	☞	☞	☞	☞	☞				☞	☞			☞					
	2-5	☞	☞	☞	☞	☞				☞	☞								
	2-5	☞	☞	☞	☞	☞				☞	☞								
 P4840C-R-E67 P4841C-R-A57 P4841C-R-E57	2-5		☞			☞		☞		☞	☞		☞					☞	
	2-5		☞			☞		☞		☞	☞							☞	
	2-5		☞			☞		☞		☞	☞							☞	

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

😐
Moderate

•• Primary application

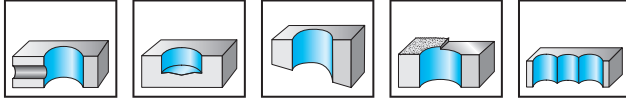
• Other application

Indexable insert drills

D4120-04 mm


4×D_C

Z=1



P	M	K	N	S	H	O
●	●	●	●	●	●	●

D4120-04

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D4120-04-36.00F32-P46	36	144	176	60	32	42	1,26	1 1	P484 . P-6R- .. P484 . C-6R- ..
	D4120-04-37.00F40-P46	37	148	188	70	40	50	1,82	1 1	
	D4120-04-38.00F40-P46	38	152	192	70	40	50	1,19	1 1	
	D4120-04-39.00F40-P46	39	156	196	70	40	50	1,96	1 1	
	D4120-04-40.00F40-P46	40	160	200	70	40	50	2,04	1 1	
	D4120-04-41.00F40-P46	41	164	204	70	40	50	2,21	1 1	
	D4120-04-42.00F40-P46	42	168	208	70	40	50	2,20	1 1	
Parallel shank with flat 	★ D4120-04-43.00F40-P47	43	172	212	70	40	50	2,23	1 1	P484 . P-7R- .. P484 . C-7R- ..
	★ D4120-04-44.00F40-P47	44	176	216	70	40	50	2,32	1 1	
	★ D4120-04-45.00F40-P47	45	180	220	70	40	50	2,4	1 1	
	★ D4120-04-46.00F40-P47	46	184	224	70	40	50	2,50	1 1	
	★ D4120-04-47.00F40-P47	47	188	228	70	40	50	2,62	1 1	
	★ D4120-04-48.00F40-P47	48	192	232	70	40	50	2,8	1 1	
	★ D4120-04-49.00F40-P47	49	196	236	70	40	50	2,9	1 1	
Parallel shank with flat 	★ D4120-04-51.00F40-P48	51	204	244	70	40	50	2,98	1 1	P484 . P-8R- .. P484 . C-8R- ..
	★ D4120-04-52.00F40-P48	52	208	248	70	40	50	3,11	1 1	
	★ D4120-04-53.00F40-P48	53	212	252	70	40	50	3,25	1 1	
	★ D4120-04-54.00F40-P48	54	216	256	70	40	50	3,32	1 1	
	★ D4120-04-55.00F40-P48	55	220	260	70	40	50	3,44	1 1	
	★ D4120-04-56.00F40-P48	56	224	264	70	40	50	3,6	1 1	
	★ D4120-04-57.00F40-P48	57	228	268	70	40	50	3,8	1 1	
	★ D4120-04-58.00F40-P48	58	232	272	70	40	50	3,97	1 1	
★ D4120-04-59.00F40-P48	59	236	276	70	40	50	4,09	1 1		

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	17–20	21–24	25–29	30–35	36–42	43–59
 Clamping screw for indexable insert Tightening torque	FS2111 (Torx 7IP) 0,9 Nm	FS1454 (Torx 8IP) 1,2 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS2080 (Torx 15IP) 2,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1495 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	17–20	21–24	25–29	30–42	43–59
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
 P4840P-R-A57 6–8 P4840P-R-E57 6–8 P4840P-R-E67 6–8 P4841P-R-A57 6–8 P4841P-R-E57 6–8		☞	☞	☞	☞	☞				☞	☞							
		☞	☞	☞	☞	☞				☞	☞							
		☞	☞	☞	☞	☞				☞	☞			☞				
		☞	☞	☞	☞	☞				☞	☞							
		☞	☞	☞	☞	☞				☞	☞							
 P4840C-R-E67 6–8 P4841C-R-A57 6–8 P4841C-R-E57 6–8			☞			☞					☞	☞		☞				☞
			☞			☞					☞	☞						☞
			☞			☞					☞	☞						☞

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

😐
Moderate

•• Primary application

• Other application

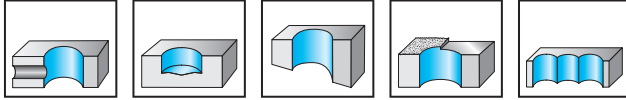
Indexable insert drills

D4120.04 inch



4×D_C

Z=1



	P	M	K	N	S	H	O
D4120.04	●	●	●	●	●		

B 1

Tool	Designation	D _C inch	L _C inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with flat 	★ D4120.04-20.62F26-P43	0,812	3,250	4,250	2,205	1,000	1,260	1,12	1 1	P484 . P-3R- ... P484 . C-3R- ...
	★ D4120.04-22.23F31-P43	0,875	3,500	4,630	2,362	1,250	1,575	1,68	1 1	
	★ D4120.04-23.80F31-P43	0,937	3,740	4,880	2,362	1,250	1,575	1,74	1 1	
Parallel shank with flat 	★ D4120.04-24.99F31-P44	0,984	3,937	5,070	2,362	1,250	1,575	1,84	1 1	P484 . P-4R- ... P484 . C-4R- ...
	★ D4120.04-25.40F31-P44	1,000	4,000	5,130	2,362	1,250	1,575	1,88	1 1	
	★ D4120.04-26.97F31-P44	1,062	4,252	5,380	2,362	1,250	1,575	1,92	1 1	
Parallel shank with flat 	★ D4120.04-30.15F31-P45	1,187	4,764	5,880	2,362	1,250	1,575	2,16	1 1	P484 . P-5R- ... P484 . C-5R- ...
	★ D4120.04-31.75F31-P45	1,250	5,000	6,130	2,362	1,250	1,575	2,31	1 1	
	★ D4120.04-34.93F31-P45	1,375	5,500	6,630	2,362	1,250	1,575	2,69	1 1	

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

Assembly parts

D _c [inch]	0,812–0,937	0,984–1,062	1,187–1,375
Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS2080 (Torx 15IP) 2,5 Nm

Accessories

D _c [inch]	0,812–0,937	0,984–1,062	1,187–1,375
Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)
Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-.R-A57	☹	☹	☹			☹				☹	☹						
	P4840P-.R-E57	☹	☹	☹			☹				☹	☹						
	P4840P-.R-E67	☹	☹	☹			☹				☹	☹		☹				
	P4841P-.R-A57	☹	☹	☹			☹				☹	☹						
	P4841P-.R-E57	☹	☹	☹			☹				☹	☹						
	P4840C-.R-E67		☹			☹		☹			☹	☹		☹				☹
	P4841C-.R-A57		☹			☹		☹			☹	☹						☹
	P4841C-.R-E57		☹			☹		☹			☹	☹						☹

HC = Coated carbide

WALTER
SELECT

Stability of machine, workpiece and clamping arrangement

☹
Very good

☹
Good

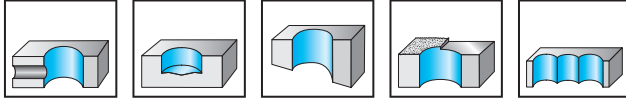
☹
Moderate

●●
Primary application

●
Other application

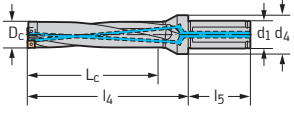
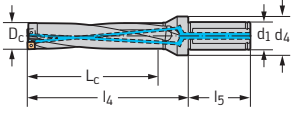
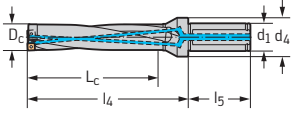
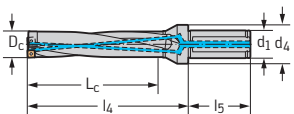
Indexable insert drills

D4120-05 mm

5×D_C
Z=1


D4120-05	P	M	K	N	S	H	O
	●		●●	●			

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D4120-05-17.00F25-P42	17	85	110	56	25	35	0,39	1 1	P484 . P-2R- ... P484 . C-2R- ...
	D4120-05-18.00F25-P42	18	90	115	56	25	35	0,47	1 1	
	D4120-05-19.00F25-P42	19	95	120	56	25	35	0,49	1 1	
	D4120-05-20.00F25-P42	20	100	125	56	25	35	0,51	1 1	
Parallel shank with flat 	D4120-05-21.00F25-P43	21	105	130	56	25	35	0,45	1 1	P484 . P-3R- ... P484 . C-3R- ...
	D4120-05-22.00F25-P43	22	110	135	56	25	35	0,58	1 1	
	D4120-05-23.00F25-P43	23	115	140	56	25	35	0,62	1 1	
	D4120-05-24.00F25-P43	24	120	145	56	25	35	0,63	1 1	
Parallel shank with flat 	D4120-05-25.00F25-P44	25	125	150	56	25	35	0,54	1 1	P484 . P-4R- ... P484 . C-4R- ...
	D4120-05-26.00F32-P44	26	130	162	60	32	42	0,95	1 1	
	D4120-05-27.00F32-P44	27	135	167	60	32	42	1,00	1 1	
	D4120-05-28.00F32-P44	28	140	172	60	32	42	1,03	1 1	
	D4120-05-29.00F32-P44	29	145	177	60	32	42	1,10	1 1	
Parallel shank with flat 	D4120-05-30.00F32-P45	30	150	182	60	32	42	1,01	1 1	P484 . P-5R- ... P484 . C-5R- ...
	D4120-05-31.00F32-P45	31	155	187	60	32	42	1,18	1 1	
	D4120-05-32.00F32-P45	32	160	192	60	32	42	1,23	1 1	
	D4120-05-33.00F32-P45	33	165	197	60	32	42	1,3	1 1	
	D4120-05-34.00F32-P45	34	170	202	60	32	42	1,37	1 1	
	D4120-05-35.00F32-P45	35	175	207	60	32	42	1,45	1 1	

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

Assembly parts

D _c [mm]	17-20	21-24	25-29	30-35	36-42	43-59	54
Clamping screw for indexable insert	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)	FS1485 (Torx 15IP)
Tightening torque	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm	

Accessories

D _c [mm]	17-20	21-24	25-29	30-42	43-59
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm
Torque screwdriver, digital Tightening torque		FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-R-A57	2-5	☒	☒	☒	☒				☒	☒							
	P4840P-R-E57	2-5	☒	☒	☒	☒				☒	☒							
	P4840P-R-E67	2-5	☒	☒	☒	☒				☒	☒			☒				
	P4841P-R-A57	2-5	☒	☒	☒	☒	☒			☒	☒							
	P4841P-R-E57	2-5	☒	☒	☒	☒	☒			☒	☒							
	P4840C-R-E67	2-5		☒		☒		☒		☒	☒		☒					☒
	P4841C-R-A57	2-5		☒		☒		☒		☒	☒							☒
	P4841C-R-E57	2-5		☒		☒		☒		☒	☒							☒

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

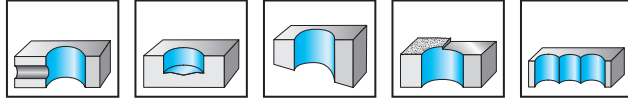
😐
Moderate

●●
Primary application

●
Other application

Indexable insert drills

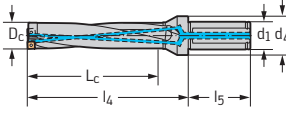
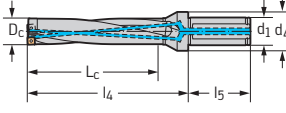
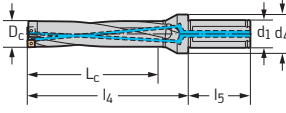
D4120-05 mm

5×D_C
Z=1


P	M	K	N	S	H	O
●	●	●	●	●	●	●

D4120-05

B 1

Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D4120-05-36.00F32-P46	36	180	212	60	32	42	1,32	1 1	P484 . P-6R- .. P484 . C-6R- ..
	D4120-05-37.00F40-P46	37	185	225	70	40	50	1,45	1 1	
	D4120-05-38.00F40-P46	38	190	230	70	40	50	2,02	1 1	
	D4120-05-39.00F40-P46	39	195	235	70	40	50	2,09	1 1	
	D4120-05-40.00F40-P46	40	200	240	70	40	50	2,17	1 1	
	D4120-05-41.00F40-P46	41	205	245	70	40	50	2,35	1 1	
	D4120-05-42.00F40-P46	42	210	250	70	40	50	2,45	1 1	
Parallel shank with flat 	★ D4120-05-43.00F40-P47	43	215	255	70	40	50	2,58	1 1	P484 . P-7R- .. P484 . C-7R- ..
	★ D4120-05-44.00F40-P47	44	220	260	70	40	50	2,68	1 1	
	★ D4120-05-45.00F40-P47	45	225	265	70	40	50	2,77	1 1	
	★ D4120-05-46.00F40-P47	46	230	270	70	40	50	2,88	1 1	
	★ D4120-05-47.00F40-P47	47	235	275	70	40	50	3,02	1 1	
	★ D4120-05-48.00F40-P47	48	240	280	70	40	50	3,08	1 1	
	★ D4120-05-49.00F40-P47	49	245	285	70	40	50	3,28	1 1	
	★ D4120-05-50.00F40-P47	50	250	290	70	40	50	3,42	1 1	
Parallel shank with flat 	★ D4120-05-51.00F40-P48	51	255	295	70	40	50	3,45	1 1	P484 . P-8R- .. P484 . C-8R- ..
	★ D4120-05-52.00F40-P48	52	260	300	70	40	50	3,61	1 1	
	★ D4120-05-53.00F40-P48	53	265	305	70	40	50	3,74	1 1	
	★ D4120-05-54.00F40-P48	54	270	310	70	40	50	3,86	1 1	
	★ D4120-05-55.00F40-P48	55	275	315	70	40	50	4,07	1 1	
	★ D4120-05-56.00F40-P48	56	280	320	70	40	50	4,22	1 1	
	★ D4120-05-57.00F40-P48	57	285	325	70	40	50	4,20	1 1	
	★ D4120-05-58.00F40-P48	58	290	330	70	40	50	4,39	1 1	
	★ D4120-05-59.00F40-P48	59	295	335	70	40	50	4,8	1 1	

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	17-20	21-24	25-29	30-35	36-42	43-59	54
Clamping screw for indexable insert	FS2111 (Torx 7IP)	FS1454 (Torx 8IP)	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1453 (Torx 15IP)	FS1495 (Torx 20IP)	FS1485 (Torx 15IP)
Tightening torque	0,9 Nm	1,2 Nm	2,0 Nm	2,5 Nm	3,5 Nm	5,0 Nm	

Accessories

D _c [mm]	17-20	21-24	25-29	30-42	43-59
Torque screwdriver, analogue Tightening torque	FS2001 0,4-1,2 Nm	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm
Torque screwdriver, digital Tightening torque		FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
Screwdriver	FS2088 (Torx 7IP)	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P					M			K			N		S			
		HC					HC			HC			HC		HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WSP45	WXP40	WSP45	WSP45S	WXP40
	P4840P-R-A57	6-8	☒	☒	☒	☒				☒	☒							
	P4840P-R-E57	6-8	☒	☒	☒	☒				☒	☒							
	P4840P-R-E67	6-8	☒	☒	☒	☒				☒	☒		☒					
	P4841P-R-A57	6-8	☒	☒	☒	☒	☒			☒	☒							
	P4841P-R-E57	6-8	☒	☒	☒	☒	☒			☒	☒							
	P4840C-R-E67	6-8		☒		☒			☒		☒	☒		☒				☒
	P4841C-R-A57	6-8		☒		☒			☒		☒	☒						☒
	P4841C-R-E57	6-8		☒		☒			☒		☒	☒						☒

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

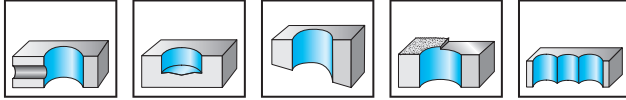
😐
Moderate

•• Primary application

• Other application

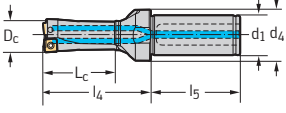
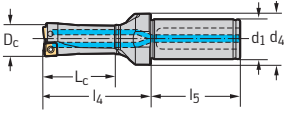
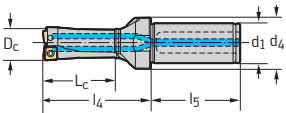
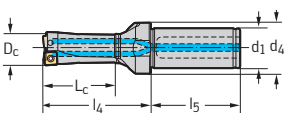
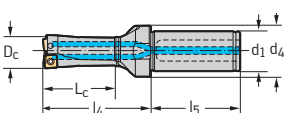
Indexable insert drills

D3120-02 mm

2×D_C
Z=1



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	P	M	K	N	S	H	O			

B 1

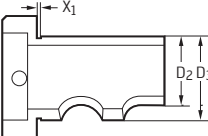




Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D3120-02-16.00F25-P21	16	32	57	56	25	32	0,30	2	P284 . S-1N- ..
	D3120-02-17.00F25-P21	17	34	59	56	25	32	0,31	2	
	D3120-02-18.00F25-P21	18	36	61	56	25	32	0,31	2	
	D3120-02-19.00F25-P21	19	38	63	56	25	32	0,32	2	
	D3120-02-20.00F25-P21	20	40	65	56	25	32	0,34	2	
Parallel shank with flat 	D3120-02-21.00F25-P22	21	42	67	56	25	32	0,36	2	P284 . S-2N- ..
	D3120-02-22.00F25-P22	22	44	69	56	25	32	0,35	2	
	D3120-02-23.00F25-P22	23	46	71	56	25	32	0,36	2	
	D3120-02-24.00F25-P22	24	48	73	56	25	32	0,37	2	
	D3120-02-25.00F25-P22	25	50	75	56	25	32	0,39	2	
Parallel shank with flat 	D3120-02-26.00F32-P23	26	52	84	60	32	40	0,62	2	P284 . S-3N- ..
	D3120-02-27.00F32-P23	27	54	86	60	32	40	0,68	2	
	D3120-02-28.00F32-P23	28	56	88	60	32	40	0,66	2	
	D3120-02-29.00F32-P23	29	58	90	60	32	40	0,69	2	
	D3120-02-30.00F32-P23	30	60	92	60	32	40	0,71	2	
Parallel shank with flat 	D3120-02-31.00F32-P24	31	62	94	60	32	40	0,69	2	P284 . S-4N- ..
	D3120-02-32.00F32-P24	32	64	96	60	32	40	0,72	2	
	D3120-02-33.00F32-P24	33	66	98	60	32	40	0,75	2	
	D3120-02-34.00F32-P24	34	68	100	60	32	40	0,78	2	
	D3120-02-35.00F32-P24	35	70	102	60	32	40	0,81	2	
	D3120-02-36.00F32-P24	36	72	104	60	32	40	0,85	2	
Parallel shank with flat 	D3120-02-37.00F40-P25	37	74	114	70	40	50	1,28	2	P284 . S-5N- ..
	D3120-02-38.00F40-P25	38	76	116	70	40	50	1,32	2	
	D3120-02-39.00F40-P25	39	78	118	70	40	50	1,36	2	
	D3120-02-40.00F40-P25	40	80	120	70	40	50	1,39	2	
	D3120-02-41.00F40-P25	41	82	122	70	40	50	1,44	2	
	D3120-02-42.00F40-P25	42	84	124	70	40	50	1,48	2	

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


Assembly parts

D _c [mm]	16–20	21–25	26–30	31–36	37–42
 Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1456 (Torx 9IP) 2,0 Nm	FS2181 (Torx 15IP) 3,0 Nm	FS2119 (Torx 15IP) 3,0 Nm	FS2139 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	16–20	21–25	26–36	37–42
 Eccentric sleeve, adjustment range -0.2 to +0.55 mm relative to diameter	FS722	FS722	FS723	FS724
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P				M			K				N		S		
		HC				HC			HC				HW	HW	HC		
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S
 P2840S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2840S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

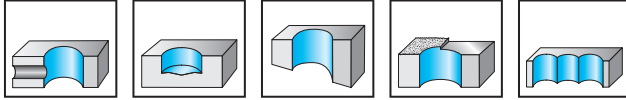
●● Primary application

● Other application

B 1

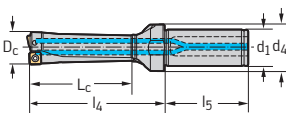
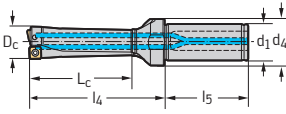
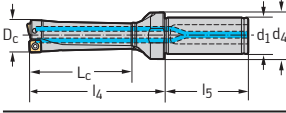
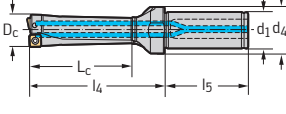
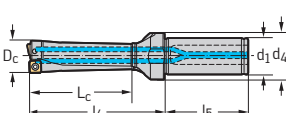
Indexable insert drills

D3120-03 mm

3×D_C
Z=1



D3120-03	P	M	K	N	S	H	O
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B 1

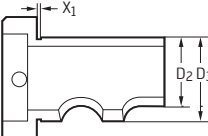



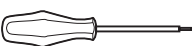
Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D3120-03-16.00F25-P21	16	48	73	56	25	32	0,31	2	P284 . S-1N- ..
	D3120-03-17.00F25-P21	17	51	76	56	25	32	0,32	2	
	D3120-03-18.00F25-P21	18	54	79	56	25	32	0,33	2	
	D3120-03-19.00F25-P21	19	57	82	56	25	32	0,34	2	
	D3120-03-20.00F25-P21	20	60	85	56	25	32	0,40	2	
Parallel shank with flat 	D3120-03-21.00F25-P22	21	63	88	56	25	32	0,36	2	P284 . S-2N- ..
	D3120-03-22.00F25-P22	22	66	91	56	25	32	0,42	2	
	D3120-03-23.00F25-P22	23	69	94	56	25	32	0,37	2	
	D3120-03-24.00F25-P22	24	72	97	56	25	32	0,42	2	
	D3120-03-25.00F25-P22	25	75	100	56	25	32	0,46	2	
Parallel shank with flat 	D3120-03-26.00F32-P23	26	78	110	60	32	40	0,67	2	P284 . S-3N- ..
	D3120-03-27.00F32-P23	27	81	113	60	32	40	0,74	2	
	D3120-03-28.00F32-P23	28	84	116	60	32	40	0,73	2	
	D3120-03-29.00F32-P23	29	87	119	60	32	40	0,76	2	
	D3120-03-30.00F32-P23	30	90	122	60	32	40	0,84	2	
Parallel shank with flat 	D3120-03-31.00F32-P24	31	93	125	60	32	40	0,78	2	P284 . S-4N- ..
	D3120-03-32.00F32-P24	32	96	128	60	32	40	0,86	2	
	D3120-03-33.00F32-P24	33	99	131	60	32	40	0,86	2	
	D3120-03-34.00F32-P24	34	102	134	60	32	40	0,9	2	
	D3120-03-35.00F32-P24	35	105	137	60	32	40	0,95	2	
	D3120-03-36.00F32-P24	36	108	140	60	32	40	1,00	2	
Parallel shank with flat 	D3120-03-37.00F40-P25	37	111	151	70	40	50	1,43	2	P284 . S-5N- ..
	D3120-03-38.00F40-P25	38	114	154	70	40	50	1,49	2	
	D3120-03-39.00F40-P25	39	117	157	70	40	50	1,64	2	
	D3120-03-40.00F40-P25	40	120	160	70	40	50	1,60	2	
	D3120-03-41.00F40-P25	41	123	163	70	40	50	1,67	2	
	D3120-03-42.00F40-P25	42	126	166	70	40	50	1,83	2	

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


Assembly parts

D _c [mm]	16–20	21–25	26–30	31–36	37–42
 Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1456 (Torx 9IP) 2,0 Nm	FS2181 (Torx 15IP) 3,0 Nm	FS2119 (Torx 15IP) 3,0 Nm	FS2139 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	16–20	21–25	26–36	37–42
 Eccentric sleeve, adjustment range -0.2 to +0.55 mm relative to diameter	FS722	FS722	FS723	FS724
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P				M			K				N		S			
		HC				HC			HC				HW	HW	HC			
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S	WXP40
 P2840S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2840S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

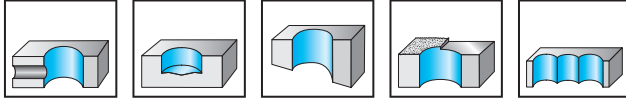
●● Primary application

● Other application

B 1

Indexable insert drills

D3120.03 inch


3×D_C
Z=1



P	M	K	N	S	H	O
●	●	●	●	●	●	●

D3120.03

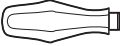



Tool	Designation	D _C inch	L _C inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with flat	★ D3120.03-19.05F26-P21	0,750	2,252	3,255	2,281	1,000	1,378	0,82	2	P284 . S-1N- ..
Parallel shank with flat	★ D3120.03-22.23F26-P22	0,875	2,626	3,629	2,281	1,000	1,378	0,90	2	P284 . S-2N- ..
	★ D3120.03-25.40F26-P22	1,000	3,000	4,004	2,281	1,000	1,378	1,05	2	
Parallel shank with flat	★ D3120.03-28.58F31-P23	1,125	3,378	4,634	2,281	1,250	1,622	1,62	2	P284 . S-3N- ..
Parallel shank with flat	★ D3120.03-31.75F31-P24	1,250	3,752	5,008	2,281	1,250	1,622	1,75	2	P284 . S-4N- ..
	★ D3120.03-34.93F31-P24	1,375	4,126	5,382	2,281	1,250	1,622	2,05	2	
Parallel shank with flat	★ D3120.03-38.10F38-P25	1,500	4,500	6,075	2,688	1,500	1,929	3,10	2	P284 . S-5N- ..

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


Assembly parts

D _c [inch]	0,750	0,875–1,000	1,125	1,250–1,375	1,500
 Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1456 (Torx 9IP) 2,0 Nm	FS2181 (Torx 15IP) 3,0 Nm	FS2119 (Torx 15IP) 3,0 Nm	FS2139 (Torx 20IP) 5,0 Nm

Accessories

D _c [inch]	0,750	0,875–1,000	1,125–1,375	1,500
 Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P				M			K			N		S				
		HC				HC			HC			HW	HW	HC				
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S	WXP40
 P2840S-.N-A57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2840S-.N-E67	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-A57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E67	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

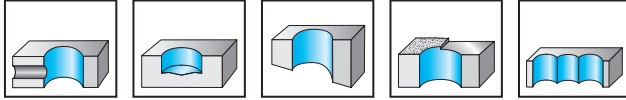
☺
Moderate

•• Primary application

• Other application

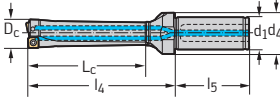
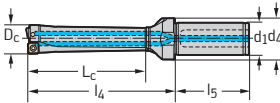
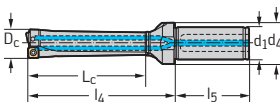
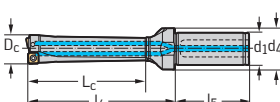
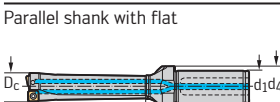
Indexable insert drills

D3120-04 mm

4×D_C
Z=1



P	M	K	N	S	H	O
●	●	●	●	●	●	●

D3120-04

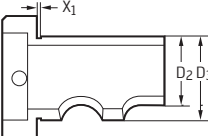




Tool	Designation	D _C mm	L _C mm	l ₄ mm	l ₅ mm	d ₁ mm	d ₄ mm	kg	No. of indexable inserts	Type
Parallel shank with flat 	D3120-04-16.00F25-P21	16	64	89	56	25	32	0,35	2	P284 . S-1N- ..
	D3120-04-17.00F25-P21	17	68	93	56	25	32	0,33	2	
	D3120-04-18.00F25-P21	18	72	97	56	25	32	0,35	2	
	D3120-04-19.00F25-P21	19	76	101	56	25	32	0,36	2	
	D3120-04-20.00F25-P21	20	80	105	56	25	32	0,38	2	
Parallel shank with flat 	D3120-04-21.00F25-P22	21	84	109	56	25	32	0,38	2	P284 . S-2N- ..
	D3120-04-22.00F25-P22	22	88	113	56	25	32	0,43	2	
	D3120-04-23.00F25-P22	23	92	117	56	25	32	0,43	2	
	D3120-04-24.00F25-P22	24	96	121	56	25	32	0,46	2	
	D3120-04-25.00F25-P22	25	100	125	56	25	32	0,49	2	
Parallel shank with flat 	D3120-04-26.00F32-P23	26	104	136	60	32	40	0,72	2	P284 . S-3N- ..
	D3120-04-27.00F32-P23	27	108	140	60	32	40	0,76	2	
	D3120-04-28.00F32-P23	28	112	144	60	32	40	0,80	2	
	D3120-04-29.00F32-P23	29	116	148	60	32	40	0,84	2	
	D3120-04-30.00F32-P23	30	120	152	60	32	40	0,88	2	
Parallel shank with flat 	D3120-04-31.00F32-P24	31	124	156	60	32	40	0,86	2	P284 . S-4N- ..
	D3120-04-32.00F32-P24	32	128	160	60	32	40	0,91	2	
	D3120-04-33.00F32-P24	33	132	164	60	32	40	0,96	2	
	D3120-04-34.00F32-P24	34	136	168	60	32	40	1,09	2	
	D3120-04-35.00F32-P24	35	140	172	60	32	40	1,08	2	
Parallel shank with flat 	D3120-04-36.00F32-P24	36	144	176	60	32	40	1,15	2	P284 . S-5N- ..
	D3120-04-37.00F40-P25	37	148	188	70	40	50	1,59	2	
	D3120-04-38.00F40-P25	38	152	192	70	40	50	1,66	2	
	D3120-04-39.00F40-P25	39	156	196	70	40	50	1,74	2	
	D3120-04-40.00F40-P25	40	160	200	70	40	50	1,89	2	
	D3120-04-41.00F40-P25	41	164	204	70	40	50	1,90	2	
	D3120-04-42.00F40-P25	42	168	208	70	40	50	1,99	2	

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


Assembly parts

D _c [mm]	16–20	21–25	26–30	31–36	37–42
 Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1456 (Torx 9IP) 2,0 Nm	FS2181 (Torx 15IP) 3,0 Nm	FS2119 (Torx 15IP) 3,0 Nm	FS2139 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]	16–20	21–25	26–36	37–42
 Eccentric sleeve, adjustment range -0.2 to +0.55 mm relative to diameter	FS722	FS722	FS723	FS724
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P				M			K				N		S		
		HC				HC			HC				HW	HW	HC		
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S
 P2840S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2840S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-A57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E57	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E67	1–5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

B 1

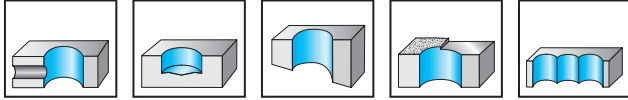
Indexable insert drills

D3120.04 inch



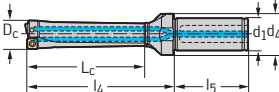
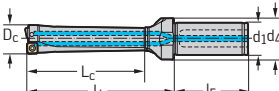
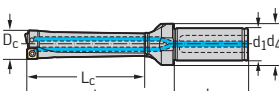
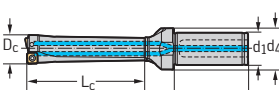
4×D_C

Z=1



D3120.04	●	●	●	●	●	●	●
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B 1

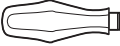



Tool	Designation	D _C inch	L _C inch	l ₄ inch	l ₅ inch	d ₁ inch	d ₄ inch	lbs	No. of indexable inserts	Type
Parallel shank with flat 	★ D3120.04-19.05F26-P21	0,750	3,000	4,003	2,281	1,000	1,378	0,87	2	P284 . S-1N- ..
Parallel shank with flat 	★ D3120.04-25.40F26-P22	1,000	4,000	5,004	2,281	1,000	1,378	1,17	2	P284 . S-2N- ..
Parallel shank with flat 	★ D3120.04-31.75F31-P24	1,250	5,000	6,256	2,281	1,250	1,622	1,95	2	P284 . S-4N- ..
Parallel shank with flat 	★ D3120.04-38.10F38-P25	1,500	6,000	7,626	2,688	1,500	1,929	3,50	2	P284 . S-5N- ..

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


Assembly parts

D _c [inch]	0,750	1,000	1,250	1,500
 Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm	FS1456 (Torx 9IP) 2,0 Nm	FS2119 (Torx 15IP) 3,0 Nm	FS2139 (Torx 20IP) 5,0 Nm

Accessories

D _c [inch]	0,750	1,000	1,250	1,500
 Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2012 (Torx 8IP)	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
 Screwdriver	FS1483 (Torx 8IP)	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	Size	P		M			K			N		S						
		HC		HC			HC			HW	HW	HC						
		WKP25S	WKP35S	WSP45	WSP45S	WXP40	WSP45	WSP45S	WXP40	WAK15	WKP25S	WKP35S	WXP40	WK40	WK40	WSP45	WSP45S	WXP40
 P2840S-.N-A57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2840S-.N-E67	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-A57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E57	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
P2841S-.N-E67	1-5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good




☺
Moderate

●● Primary application

● Other application

B 1

Product range overview of HSS drills

Machining		
Drilling depth	$\sim 8 \times D_c$	Twist drill set
Designation	DA110 Perform	DA110 Perform
Standard	DIN 338	DIN 338
Dia. range [mm]	1-16	1-10,5 1-13
Page	337	340
		

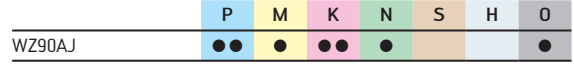
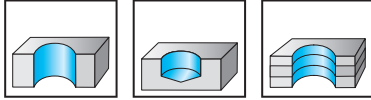
B 1

HSS twist drills

DA110 Perform



- Available as set
- Type N



	Designation	D _c h8 mm	L _c mm	l ₁ mm	l ₂ mm	d ₁ f11 mm	WZ90AJ
Parallel shank	DA110-08-01.000U0-	1	10	34	12	1	
	DA110-08-01.100U0-	1,1	12	36	14	1,1	
	DA110-08-01.200U0-	1,2	14	38	16	1,2	
	DA110-08-01.300U0-	1,3	14	38	16	1,3	
	DA110-08-01.400U0-	1,4	15	40	18	1,4	
	DA110-08-01.500U0-	1,5	15	40	18	1,5	
	DA110-08-01.600U0-	1,6	17	43	20	1,6	
	DA110-08-01.700U0-	1,7	17	43	20	1,7	
	DA110-08-01.800U0-	1,8	19	46	22	1,8	
	DA110-08-01.900U0-	1,9	19	46	22	1,9	
	DA110-08-02.000U0-	2	20	49	24	2	
	DA110-08-02.100U0-	2,1	20	49	24	2,1	
	DA110-08-02.200U0-	2,2	23	53	27	2,2	
	DA110-08-02.300U0-	2,3	23	53	27	2,3	
	DA110-08-02.400U0-	2,4	26	57	30	2,4	
	DA110-08-02.500U0-	2,5	26	57	30	2,5	
	DA110-08-02.600U0-	2,6	26	57	30	2,6	
	DA110-08-02.700U0-	2,7	28	61	33	2,7	
	DA110-08-02.800U0-	2,8	28	61	33	2,8	
	DA110-08-02.900U0-	2,9	28	61	33	2,9	
	DA110-08-03.000U0-	3	28	61	33	3	
	DA110-08-03.100U0-	3,1	30	65	36	3,1	
	DA110-08-03.200U0-	3,2	30	65	36	3,2	
	DA110-08-03.300U0-	3,3	30	65	36	3,3	
	DA110-08-03.400U0-	3,4	33	70	39	3,4	
	DA110-08-03.500U0-	3,5	33	70	39	3,5	
	DA110-08-03.600U0-	3,6	33	70	39	3,6	
	DA110-08-03.700U0-	3,7	33	70	39	3,7	
	DA110-08-03.800U0-	3,8	36	75	43	3,8	
	DA110-08-03.900U0-	3,9	36	75	43	3,9	
	DA110-08-04.000U0-	4	36	75	43	4	
	DA110-08-04.100U0-	4,1	36	75	43	4,1	
DA110-08-04.200U0-	4,2	36	75	43	4,2		
DA110-08-04.300U0-	4,3	39	80	47	4,3		
DA110-08-04.400U0-	4,4	39	80	47	4,4		
DA110-08-04.500U0-	4,5	39	80	47	4,5		
DA110-08-04.600U0-	4,6	39	80	47	4,6		
DA110-08-04.700U0-	4,7	39	80	47	4,7		
DA110-08-04.800U0-	4,8	44	86	52	4,8		
DA110-08-04.900U0-	4,9	44	86	52	4,9		
DA110-08-05.000U0-	5	44	86	52	5		
DA110-08-05.100U0-	5,1	44	86	52	5,1		
DA110-08-05.200U0-	5,2	44	86	52	5,2		
DA110-08-05.300U0-	5,3	44	86	52	5,3		
DA110-08-05.400U0-	5,4	48	93	57	5,4		
DA110-08-05.500U0-	5,5	48	93	57	5,5		
DA110-08-05.600U0-	5,6	48	93	57	5,6		

Ordering example for the WZ90AJ grade: DA110-08-01.000U0-WZ90AJ

Continued

B 1

Continued

	Designation	D _c h8 mm	L _c mm	l ₁ mm	l ₂ mm	d ₁ f11 mm	WZ90AJ
	DA110-08-05.700U0-	5,7	48	93	57	5,7	
	DA110-08-05.800U0-	5,8	48	93	57	5,8	
	DA110-08-05.900U0-	5,9	48	93	57	5,9	
	DA110-08-06.000U0-	6	48	93	57	6	
	DA110-08-06.100U0-	6,1	52	101	63	6,1	
	DA110-08-06.200U0-	6,2	52	101	63	6,2	
	DA110-08-06.300U0-	6,3	52	101	63	6,3	
	DA110-08-06.400U0-	6,4	52	101	63	6,4	
	DA110-08-06.500U0-	6,5	52	101	63	6,5	
	DA110-08-06.600U0-	6,6	52	101	63	6,6	
	DA110-08-06.700U0-	6,7	52	101	63	6,7	
	DA110-08-06.800U0-	6,8	57	109	69	6,8	
	DA110-08-06.900U0-	6,9	57	109	69	6,9	
	DA110-08-07.000U0-	7	57	109	69	7	
	DA110-08-07.100U0-	7,1	57	109	69	7,1	
	DA110-08-07.200U0-	7,2	57	109	69	7,2	
	DA110-08-07.300U0-	7,3	57	109	69	7,3	
	DA110-08-07.400U0-	7,4	57	109	69	7,4	
	DA110-08-07.500U0-	7,5	57	109	69	7,5	
	DA110-08-07.600U0-	7,6	62	117	75	7,6	
	DA110-08-07.700U0-	7,7	62	117	75	7,7	
	DA110-08-07.800U0-	7,8	62	117	75	7,8	
	DA110-08-07.900U0-	7,9	62	117	75	7,9	
	DA110-08-08.000U0-	8	62	117	75	8	
	DA110-08-08.100U0-	8,1	62	117	75	8,1	
	DA110-08-08.200U0-	8,2	62	117	75	8,2	
	DA110-08-08.300U0-	8,3	62	117	75	8,3	
	DA110-08-08.400U0-	8,4	62	117	75	8,4	
	DA110-08-08.500U0-	8,5	62	117	75	8,5	
	DA110-08-08.600U0-	8,6	66	125	81	8,6	
	DA110-08-08.700U0-	8,7	66	125	81	8,7	
	DA110-08-08.800U0-	8,8	66	125	81	8,8	
	DA110-08-08.900U0-	8,9	66	125	81	8,9	
	DA110-08-09.000U0-	9	66	125	81	9	
	DA110-08-09.100U0-	9,1	66	125	81	9,1	
	DA110-08-09.200U0-	9,2	66	125	81	9,2	
	DA110-08-09.300U0-	9,3	66	125	81	9,3	
	DA110-08-09.400U0-	9,4	66	125	81	9,4	
	DA110-08-09.500U0-	9,5	66	125	81	9,5	
	DA110-08-09.600U0-	9,6	71	133	87	9,6	
DA110-08-09.700U0-	9,7	71	133	87	9,7		
DA110-08-09.800U0-	9,8	71	133	87	9,8		
DA110-08-09.900U0-	9,9	71	133	87	9,9		
DA110-08-10.000U0-	10	71	133	87	10		
DA110-08-10.100U0-	10,1	71	133	87	10,1		
DA110-08-10.200U0-	10,2	71	133	87	10,2		
DA110-08-10.300U0-	10,3	71	133	87	10,3		
DA110-08-10.400U0-	10,4	71	133	87	10,4		
DA110-08-10.500U0-	10,5	71	133	87	10,5		
DA110-08-10.700U0-	10,7	76	142	94	10,7		
DA110-08-10.800U0-	10,8	76	142	94	10,8		
DA110-08-11.000U0-	11	76	142	94	11		
DA110-08-11.100U0-	11,1	76	142	94	11,1		
DA110-08-11.300U0-	11,3	76	142	94	11,3		
DA110-08-11.500U0-	11,5	76	142	94	11,5		
DA110-08-11.800U0-	11,8	76	142	94	11,8		
DA110-08-12.000U0-	12	87	151	101	12		

Ordering example for the WZ90AJ grade: DA110-08-01.000U0-WZ90AJ

Continued

Continued

	Designation	D _c h8 mm	L _c mm	l ₁ mm	l ₂ mm	d ₁ f11 mm	WZ90AJ
<p>Parallel shank</p>	DA110-08-12.100U0-	12,1	87	151	101	12,1	
	DA110-08-12.200U0-	12,2	87	151	101	12,2	
	DA110-08-12.500U0-	12,5	87	151	101	12,5	
	DA110-08-13.000U0-	13	87	151	101	13	
	DA110-08-13.500U0-	13,5	94	160	108	13,5	
	DA110-08-13.700U0-	13,7	94	160	108	13,7	
	DA110-08-14.000U0-	14	94	160	108	14	
	DA110-08-14.500U0-	14,5	99	169	114	14,5	
	DA110-08-15.000U0-	15	99	169	114	15	
	DA110-08-15.500U0-	15,5	104	178	120	15,5	
	DA110-08-16.000U0-	16	104	178	120	16	

Ordering example for the WZ90AJ grade: DA110-08-01.000U0-WZ90AJ

B 1

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

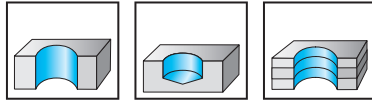
•• Primary application

• Other application

HSS – DA110 Perform twist drill – set
DA110-SET-1-10.5-WZ90AJ
DA110-SET-1-13-WZ90AJ



– Type N



	P	M	K	N	S	H	O
WZ90AJ	●●	●	●●	●			

B 1

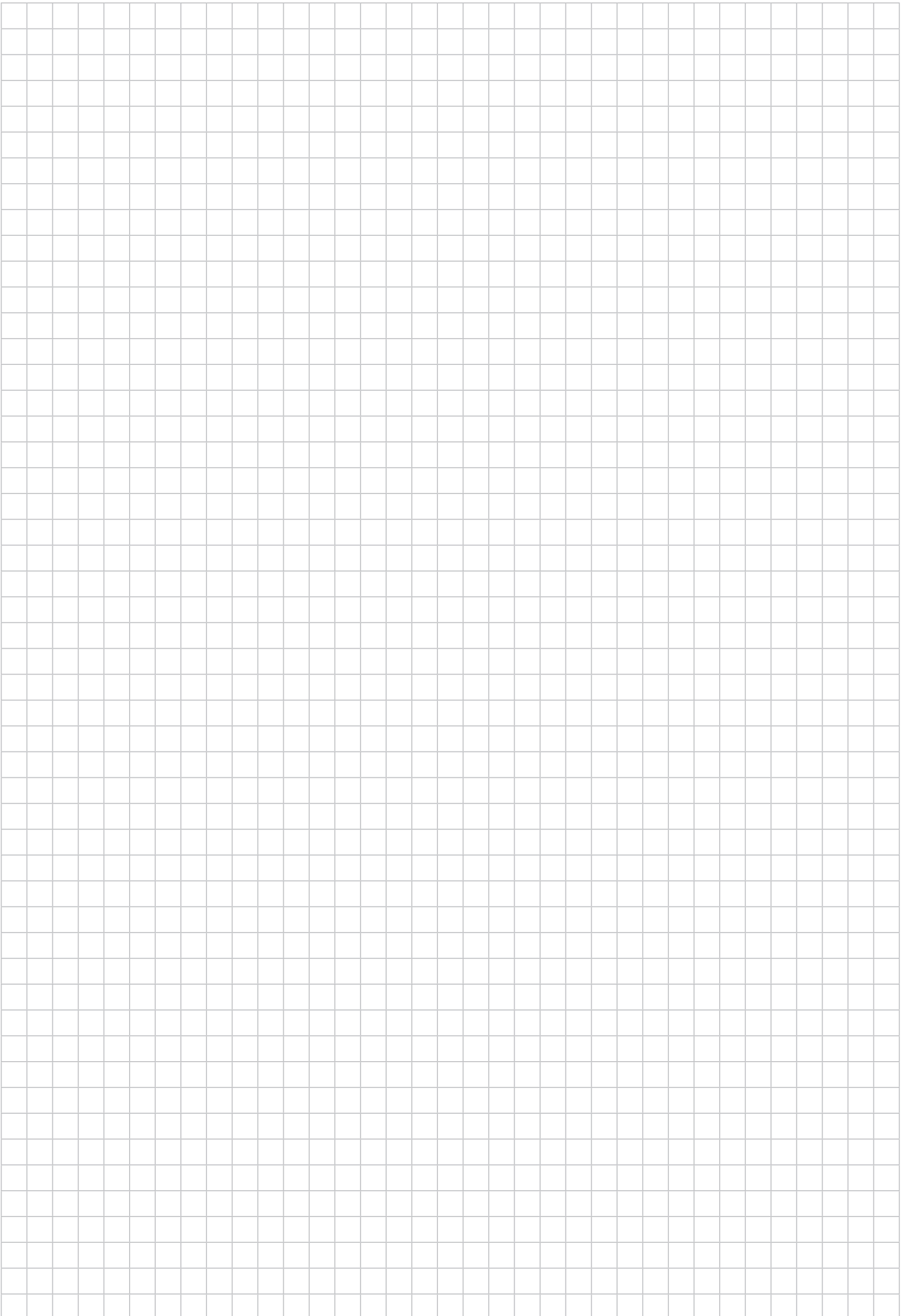
Designation	Sets Dia. [mm]	Including core-hole drill [mm]		Pitch	Quantity
DA110-SET-1-10.5-WZ90AJ	1,0–10,5	3,3	0,5	24	
		4,2			
		6,8			
		10,2			



Designation	Sets Dia. [mm]	Pitch	Quantity
DA110-SET-1-13-WZ90AJ	1,0–13,0	0,5	25



For the dimensions for the DA110 Perform twist drill, please see the ordering page.



B 1

Cutting data for solid carbide drilling and reaming tools

Solid carbide drills with internal coolant

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v_c = Cutting speed VRR = Feed rate chart VCRR = v_c rate chart * The classification of the machining groups can be found in the material group comparison table			Drilling depth			3 x D _c								
				Designation			DC260 Advance X-treme Evo			DC160 Advance X-treme Evo					
				Standard			Walter			DIN 6537 K					
				Grade			WJ30ET			WJ30ET					
Dia. range [mm]			3,3–14			3–20									
Page			203			204									
Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *										
						v_c	VRR			v_c	VRR				
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	62	P1	140	10	E0		140	10	E0		
		C > 0.25 ... ≤ 0.55%	Annealed	190	93	P2	140	12	E0		140	12	E0		
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	103	P3	140	12	E0		140	12	E0		
		C > 0.55%	Annealed	190	93	P4	140	9	E0		140	9	E0		
		C > 0.55%	Heat-treated	300	146	P5	120	10	E0		110	10	E0		
		Free-machining steel (short-chipping)	Annealed	220	109	P6	160	12	E0		160	12	E0		
	Low-alloy steel	Annealed		175	86	P7	140	10	E0		140	10	E0		
		Heat-treated		285	139	P8	100	10	E0		100	10	E0		
		Heat-treated		380	186	P9	63	8	E0		56	8	E0		
		Heat-treated		430	215	P10	71	5	E0		63	5	E0		
High-alloy steel and high-alloy tool steel	Annealed		200	99	P11	100	9	E0		90	9	E0			
	Hardened and tempered		300	146	P12	120	10	E0		110	10	E0			
Stainless steel	Hardened and tempered		380	186	P13	56	7	E0		50	7	E0			
	Ferritic/martensitic, annealed		200	99	P14	120	12	E0		120	12	E0			
	Martensitic, heat-treated		330	161	P15	63	10	E0		56	10	E0			
M	Stainless steel	Austenitic, quench hardened		200	99	M1	56	6	E0		50	6	E0		
		Austenitic, precipitation hardened (PH)		300	146	M2	50	6	E0		45	6	E0		
		Austenitic/ferritic, duplex		230	113	M3	40	5	E0		36	5	E0		
K	Malleable cast iron	Ferritic		200	58	K1	110	16	E0		110	16	E0		
		Pearlitic		260	102	K2	100	16	E0		100	16	E0		
	Grey cast iron	Low tensile strength		180	29	K3	140	16	E0		120	16	E0		
		High tensile strength/austenitic		245	51	K4	110	16	E0		110	16	E0		
	Cast iron with spheroidal graphite	Ferritic		155	58	K5	160	20	E0		140	20	E0		
		Pearlitic		265	102	K6	100	16	E0		100	16	E0		
GGV (CGI)			230	58	K7	110	16	E0		110	16	E0			
N	Wrought aluminium alloys	Not hardenable		30	-	N1	450	16	E0	M	400	16	E0	M	
		Hardenable, hardened		100	49	N2	450	16	E0	M	400	16	E0	M	
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	38	N3	280	16	E0	M	250	16	E0	M	
		≤ 12% Si, hardenable, hardened		90	45	N4	250	16	E0	M	250	16	E0	M	
		> 12% Si, not hardenable		130	65	N5	200	16	E0	M	200	16	E0	M	
	Magnesium-based alloys			70	36	N6									
Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	49	N7	200	9	E0		200	9	E0			
	Brass, bronze, red brass		90	45	N8	180	10	E0		180	10	E0			
	Cu alloys, short-chipping		110	55	N9	200	12	E0		200	12	E0			
	High tensile, Ampco		300	146	N10	50	5	E0		50	5	E0			
S	Heat-resistant alloys	Fe-based	Annealed		200	99	S1	45	4	E0		40	4	E0	
			Hardened		280	136	S2	32	4	E0		28	4	E0	
		Ni- or Co-based	Annealed		250	122	S3	36	5	E0		32	5	E0	
			Hardened		350	171	S4	14	4	E0		14	4	E0	
	Titanium alloys		Cast		320	157	S5	28	4	E0		25	4	E0	
		Pure titanium		200	99	S6	63	6	E0		56	6	E0		
		α and β alloys, hardened		375	183	S7	40	4	E0		40	4	E0		
		β alloys		410	203	S8	36	4	E0		36	4	E0		
Tungsten alloys			300	146	S9	50	5	E0		50	5	E0			
Molybdenum alloys			300	146	S10	50	5	E0		50	5	E0			
H	Hardened steel	Hardened and tempered		50 HRC	-	H1	50	3	OE		45	3	OE		
		Hardened and tempered		55 HRC	-	H2									
		Hardened and tempered		60 HRC	-	H3									
Hardened cast iron			55 HRC	-	H4										
O	Thermoplastics	Without abrasive fillers				O1	110	16	E0		110	16	E0		
	Thermosets	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								

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

B 1

3 x D _c					5 x D _c					8 x D _c					12 x D _c														
DC150 Perform					DB133 Supreme					DC160 Advance X-treme Evo					DB133 Supreme														
DIN 6537 K					Walter					DIN 6537 L					Walter														
WJ30RE					WJ30EL					WJ30ET					WJ30ER														
3-20					0,7-1,984					3-25					3-20														
245					212					213					256														
v _c	VRR	⌘	⌘	⌘	VCRR	VRR	⌘	⌘	⌘	v _c	VRR	⌘	⌘	⌘	v _c	VRR	⌘	⌘	⌘	v _c	VRR	⌘	⌘	⌘	VCRR	VRR	⌘	⌘	⌘
120	12	EO			C100	12	EO			140	10	EO			110	12	EO			C100	12	EO			140	10	EO		
100	10	EO			C80	12	EO			140	12	EO			100	10	EO			C80	12	EO			140	12	EO		
80	9	EO			C80	12	EO			120	12	EO			80	9	EO			C80	12	EO			120	12	EO		
90	9	EO			C80	12	EO			140	9	EO			90	9	EO			C80	12	EO			140	9	EO		
71	8	EO			C63	10	EO			110	10	EO			71	8	EO			C63	10	EO			110	10	EO		
120	12	EO			C100	12	EO			160	12	EO			110	12	EO			C100	12	EO			140	12	EO		
100	12	EO			C80	12	EO			140	10	EO			100	12	EO			C80	12	EO			140	10	EO		
71	9	EO			C50	10	EO			100	10	EO			71	9	EO			C50	10	EO			90	10	EO		
45	6	EO			C40	7	EO			50	8	EO			45	6	EO			C40	7	EO			50	8	EO		
40	4	EO			C40	6	EO			56	5	EO			36	4	EO			C32	6	EO			56	5	EO		
80	9	EO			C80	10	EO			90	9	EO			80	9	EO			C63	10	EO			90	9	EO		
63	10	EO			C63	10	EO			110	10	EO			63	10	EO			C63	10	EO			110	10	EO		
50	6	EO			C40	7	EO			50	7	EO			50	6	EO			C40	7	EO			45	7	EO		
80	10	EO			C80	12	EO			120	12	EO			80	10	EO			C63	12	EO			110	12	EO		
50	9	EO			C63	10	EO			56	10	EO			50	9	EO			C63	10	EO			56	10	EO		
40	5	EO			C40	8	EO			50	6	EO			40	5	EO			C32	8	EO			50	6	EO		
56	6	EO			C50	6	EO			45	6	EO			56	6	EO			C40	6	EO			45	6	EO		
32	4	EO			C25	6	EO			36	5	EO			32	4	EO			C25	6	EO			36	5	EO		
100	16	EO			C80	16	EO			110	16	EO			100	16	EO			C80	16	EO			110	16	EO		
71	16	EO			C63	12	EO			100	16	EO			71	16	EO			C63	12	EO			90	16	EO		
110	16	EO			C100	16	EO			120	16	EO			110	16	EO			C100	16	EO			120	16	EO		
90	16	EO			C80	12	EO			110	16	EO			90	16	EO			C80	12	EO			100	16	EO		
110	16	EO			C100	16	EO			140	20	EO			100	16	EO			C100	16	EO			140	20	EO		
71	16	EO			C63	12	EO			100	16	EO			71	16	EO			C63	12	EO			90	16	EO		
80	16	EO			C80	12	EO			110	16	EO			80	16	EO			C63	12	EO			100	16	EO		
400	16	EO			C125	20	EO		M	400	16	EO		M	400	16	EO			C125	20	EO		M	400	16	EO		M
400	16	EO			C125	20	EO		M	400	16	EO		M	400	16	EO			C125	20	EO		M	400	16	EO		M
250	16	EO		M	C125	20	EO		M	250	16	EO		M	250	16	EO		M	C125	20	EO		M	250	16	EO		M
220	16	EO		M	C125	20	EO		M	250	16	EO		M	220	16	EO		M	C125	20	EO		M	250	16	EO		M
200	16	EO		M	C125	16	EO		M	200	16	EO		M	200	16	EO		M	C125	16	EO		M	180	16	EO		M
180	8	EO			C80	6	EO			200	9	EO			180	8	EO			C80	6	EO			180	9	EO		
160	10	EO			C100	9	EO			180	10	EO			160	10	EO			C80	9	EO			160	10	EO		
180	16	EO			C100	16	EO			200	12	EO			180	16	EO			C80	16	EO			180	12	EO		
45	5	EO			C40	5	EO			50	5	EO			45	5	EO			C40	5	EO			45	5	EO		
32	4	EO			C32	6	EO			40	4	EO			32	4	EO			C25	6	EO			40	4	EO		
22	3	EO			C20	4	EO			28	4	EO			22	3	EO			C20	4	EO			28	4	EO		
32	4	EO			C25	6	EO			32	5	EO			32	4	EO			C25	6	EO			32	5	EO		
11	3	EO			C16	5	EO			12	4	EO			11	3	EO			C16	5	EO			12	4	EO		
18	3	EO			C16	6	EO			25	4	EO			18	3	EO			C16	6	EO			25	4	EO		
45	6	EO			C50	6	EO			50	6	EO			45	6	EO			C40	6	EO			45	6	EO		
32	4	EO			C25	4	EO			40	4	EO			32	4	EO			C25	4	EO			40	4	EO		
28	4	EO			C32	4	EO			36	4	EO			25	4	EO			C25	4	EO			32	4	EO		
18	3	EO			C16	6	EO			50	5	EO			18	3	EO			C16	6	EO			45	5	EO		
18	3	EO			C16	6	EO			50	5	EO			18	3	EO			C16	6	EO			45	5	EO		
28	3	OE			C32	3	EO			40	3	OE			28	3	OE			C32	3	EO							
90	16	EO			C100	20	EO			110	16	EO			90	16	EO			C100	20	EO			110	16	EO		

Cutting data for solid carbide drilling and reaming tools

Solid carbide drills with internal coolant

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v _c = Cutting speed VRR = Feed rate chart VCRR = v _c rate chart * The classification of the machining groups can be found in the material group comparison table			Drilling depth			12 x D _c			16 x D _c				
				Designation			DC160 Advance X-treme Evo			DC160 Advance X-treme Evo				
				Standard			Walter			Walter				
				Grade			WJ30EU			WJ30EU				
Dia. range [mm]			3-20			3-16								
Page			229			232								
Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R _m [N/mm ²]	Machining group *									
						v _c	VRR			v _c	VRR			
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	62	P1	120	10	E O					
		C > 0.25 ... ≤ 0.55%	Annealed	190	93	P2	120	12	E O		120	12	E O	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	103	P3	110	12	E O		80	10	E O	
		C > 0.55%	Annealed	190	93	P4	120	9	E O		90	10	E O	
		C > 0.55%	Heat-treated	300	146	P5	90	10	E O		71	10	E O	
		Free-machining steel (short-chipping)	Annealed	220	109	P6	140	12	E O		120	12	E O	
	Low-alloy steel	Annealed		175	86	P7	120	10	E O		110	12	E O	
		Heat-treated		285	139	P8	80	10	E O		63	10	E O	
		Heat-treated		380	186	P9	40	8	E O		56	8	E O	
		Heat-treated		430	215	P10	45	5	E O		36	7	E O	
High-alloy steel and high-alloy tool steel	Annealed		200	99	P11	80	9	E O		90	9	E O		
	Hardened and tempered		300	146	P12	90	10	E O		80	10	E O		
	Hardened and tempered		380	186	P13	36	7	E O		56	8	E O		
Stainless steel	Ferritic/martensitic, annealed		200	99	P14	100	12	E O		90	10	E O		
	Martensitic, heat-treated		330	161	P15	50	10	E O		63	9	E O		
M	Stainless steel	Austenitic, quench hardened		200	99	M1	45	6	E O		45	6	E O	
		Austenitic, precipitation hardened (PH)		300	146	M2	40	6	E O		56	6	E O	
		Austenitic/ferritic, duplex		230	113	M3	32	5	E O		40	4	E O	
K	Malleable cast iron	Ferritic		200	58	K1	100	16	E O		110	16	E O	
		Pearlitic		260	102	K2	80	16	E O		80	16	E O	
	Grey cast iron	Low tensile strength		180	29	K3	110	16	E O		140	16	E O	
		High tensile strength/austenitic		245	51	K4	90	16	E O		110	16	E O	
	Cast iron with spheroidal graphite	Ferritic		155	58	K5	120	20	E O		120	16	E O	
		Pearlitic		265	102	K6	80	16	E O		80	16	E O	
	GGV (CGI)		230	58	K7	90	16	E O		90	16	E O		
N	Wrought aluminium alloys	Not hardenable		30	-	N1	360	16	E O	M	120	20	E O	M
		Hardenable, hardened		100	49	N2	360	16	E O	M	120	20	E O	M
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	38	N3	220	16	E O	M	120	20	E O	M
		≤ 12% Si, hardenable, hardened		90	45	N4	220	16	E O	M	120	20	E O	M
		> 12% Si, not hardenable		130	65	N5	160	16	E O	M	120	16	E O	M
	Magnesium-based alloys			70	36	N6								
		Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	49	N7	160	9	E O		180	8	E O
Brass, bronze, red brass				90	45	N8	140	10	E O		160	10	E O	
Cu alloys, short-chipping				110	55	N9	160	12	E O		180	12	E O	
High tensile, Ampco			300	146	N10	40	5	E O		56	5	E O		
S	Heat-resistant alloys	Fe-based	Annealed		200	99	S1	36	4	E O		36	4	E O
			Hardened		280	136	S2	25	4	E O		22	2	E O
		Ni- or Co-based	Annealed		250	122	S3	28	5	E O		32	4	E O
			Hardened		350	171	S4	11	4	E O		12	3	E O
		Cast		320	157	S5	22	4	E O		22	3	E O	
	Titanium alloys	Pure titanium		200	99	S6	40	6	E O		56	6	E O	
		α and β alloys, hardened		375	183	S7	32	4	E O		40	4	E O	
		β alloys		410	203	S8	28	4	E O		36	4	E O	
Tungsten alloys		300	146	S9	40	5	E O		22	3	E O			
Molybdenum alloys		300	146	S10	40	5	E O		22	3	E O			
H	Hardened steel	Hardened and tempered		50 HRC	-	H1					36	3	O E	
		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	100	16	E O		110	16	E O	
	Thermosets	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							

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

B 1

20 x D _c					25 x D _c					30 x D _c				
DC160 Advance X-treme Evo					DC160 Advance X-treme Evo					DC160 Advance X-treme Evo				
Walter					Walter					Walter				
WJ30EU					WJ30EU					WJ30EU				
3-16					3-12					3-12				
233					234					235				
v _c	VRR				v _c	VRR				v _c	VRR			
120	12	E	O		120	12	E	O		120	12	E	O	
110	12	E	O		110	12	E	O		110	12	E	O	
80	10	E	O		80	10	E	O		80	10	E	O	
90	10	E	O		90	10	E	O		90	10	E	O	
71	10	E	O		71	10	E	O		71	10	E	O	
120	12	E	O		120	12	E	O		120	12	E	O	
110	12	E	O		110	12	E	O		110	12	E	O	
63	10	E	O		63	10	E	O		63	10	E	O	
56	8	E	O		56	8	E	O		56	8	E	O	
36	7	E	O		36	7	E	O		36	7	E	O	
90	9	E	O		90	9	E	O		90	9	E	O	
80	10	E	O		80	10	E	O		80	10	E	O	
56	8	E	O		56	8	E	O		56	8	E	O	
90	10	E	O		90	10	E	O		90	10	E	O	
63	9	E	O		63	9	E	O		63	9	E	O	
45	6	E	O		45	6	E	O		45	6	E	O	
56	6	E	O		56	6	E	O		56	6	E	O	
40	4	E	O		40	4	E	O		40	4	E	O	
110	16	E	O		110	16	E	O		110	16	E	O	
80	16	E	O		80	16	E	O		80	16	E	O	
140	16	E	O		140	16	E	O		140	16	E	O	
110	16	E	O		110	16	E	O		110	16	E	O	
120	16	E	O		120	16	E	O		120	16	E	O	
80	16	E	O		80	16	E	O		80	16	E	O	
90	16	E	O		90	16	E	O		90	16	E	O	
110	20	E	O	M	100	20	E	O	M	100	20	E	O	M
110	20	E	O	M	100	20	E	O	M	100	20	E	O	M
110	20	E	O	M	100	20	E	O	M	100	20	E	O	M
110	20	E	O	M	100	20	E	O	M	100	20	E	O	M
110	16	E	O	M	100	16	E	O	M	100	16	E	O	M
160	8	E	O		120	8	E	O		120	8	E	O	
140	10	E	O		110	10	E	O		110	10	E	O	
160	12	E	O		120	12	E	O		120	12	E	O	
56	5	E	O		56	5	E	O		56	5	E	O	
36	4	E	O		36	4	E	O		36	4	E	O	
22	2	E	O		22	2	E	O		22	2	E	O	
32	4	E	O		32	4	E	O		32	4	E	O	
12	3	E	O		12	3	E	O		12	3	E	O	
22	3	E	O		22	3	E	O		22	3	E	O	
56	6	E	O		56	6	E	O		56	6	E	O	
40	4	E	O		40	4	E	O		40	4	E	O	
36	4	E	O		36	4	E	O		36	4	E	O	
22	3	E	O		22	3	E	O		22	3	E	O	
22	3	E	O		22	3	E	O		22	3	E	O	
36	3	O	E		36	3	O	E		36	3	O	E	
110	16	E	O		110	16	E	O		110	16	E	O	

Cutting data for solid carbide drilling and reaming tools

Solid carbide drills without internal coolant

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v_c = Cutting speed VRR = Feed rate chart VCRR = v_c rate chart * The classification of the machining groups can be found in the material group comparison table			Drilling depth			3 x D _c									
				Designation			DC260 Advance X-treme Evo			DC160 Advance X-treme Evo						
				Standard			Walter			DIN 6537 K						
				Grade			WJ30ET			WJ30ET						
Dia. range [mm]			3,3–14,5			3–20										
Page			236			237										
Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *											
						v_c	VRR			v_c	VRR					
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	62	P1	120	12	E O			100	12	E O		
		C > 0.25 ... ≤ 0.55%	Annealed	190	93	P2	120	12	E O			110	12	E O		
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	103	P3	120	12	E O			110	12	E O		
		C > 0.55%	Annealed	190	93	P4	120	10	E O			110	10	E O		
		C > 0.55%	Heat-treated	300	146	P5	100	10	E O			80	10	E O		
		Free-machining steel (short-chipping)	Annealed	220	109	P6	120	16	E O			110	16	E O		
	Low-alloy steel	Annealed		175	86	P7	120	12	E O			110	12	E O		
		Heat-treated		285	139	P8	90	10	E O			71	10	E O		
		Heat-treated		380	186	P9	71	7	E O			56	7	E O		
		Heat-treated		430	215	P10	50	5	E O			40	5	E O		
High-alloy steel and high-alloy tool steel	Annealed		200	99	P11	90	9	E O			71	9	E O			
	Hardened and tempered		300	146	P12	100	10	E O			80	10	E O			
Stainless steel	Hardened and tempered		380	186	P13	45	7	E O			45	7	E O			
	Ferritic/martensitic, annealed		200	99	P14	110	12	E O			100	12	E O			
M	Stainless steel	Martensitic, heat-treated		330	161	P15	71	10	E O			56	10	E O		
		Austenitic, quench hardened		200	99	M1										
		Austenitic, precipitation hardened (PH)		300	146	M2										
K	Malleable cast iron	Austenitic/ferritic, duplex		230	113	M3										
		Ferritic		200	58	K1	90	16	E O			80	16	E O		
	Grey cast iron	Pearlitic		260	102	K2	90	12	E O			80	12	E O		
		Low tensile strength		180	29	K3	110	16	E O			100	16	E O		
		High tensile strength/austenitic		245	51	K4	90	16	E O			90	16	E O		
	Cast iron with spheroidal graphite	Ferritic		155	58	K5	120	16	E O			110	16	E O		
		Pearlitic		265	102	K6	90	12	E O			80	12	E O		
GGV (CGI)		230	58	K7	110	2	E O			100	2	E O				
N	Wrought aluminium alloys	Not hardenable		30	-	N1										
		Hardenable, hardened		100	49	N2										
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	38	N3	250	16	E O	M		250	16	E O	M	
		≤ 12% Si, hardenable, hardened		90	45	N4	220	16	E O	M		220	16	E O	M	
		> 12% Si, not hardenable		130	65	N5	180	12	E O	M		180	12	E O	M	
	Magnesium-based alloys			70	36	N6										
Copper and copper alloys (bronze/brass)		Unalloyed, electrolytic copper		100	49	N7	200	6	E O			180	6	E O		
		Brass, bronze, red brass		90	45	N8	180	10	E O			160	10	E O		
		Cu alloys, short-chipping		110	55	N9	200	16	E O			200	16	E O		
	High tensile, Ampco		300	146	N10	45	5	E O			45	5	E O			
S	Heat-resistant alloys	Fe-based	Annealed		200	99	S1									
			Hardened		280	136	S2									
		Ni- or Co-based	Annealed		250	122	S3									
			Hardened		350	171	S4									
			Cast		320	157	S5									
	Titanium alloys	Pure titanium		200	99	S6	45	5	E O			36	5	E O		
		α and β alloys, hardened		375	183	S7	32	3	E O			25	3	E O		
		β alloys		410	203	S8	28	3	E O			22	3	E O		
	Tungsten alloys		300	146	S9											
	Molybdenum alloys		300	146	S10											
H	Hardened steel	Hardened and tempered		50 HRC	-	H1	36	3	O E			28	3	O E		
		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	100	16	E O			100	16	E O		
	Thermosets	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										

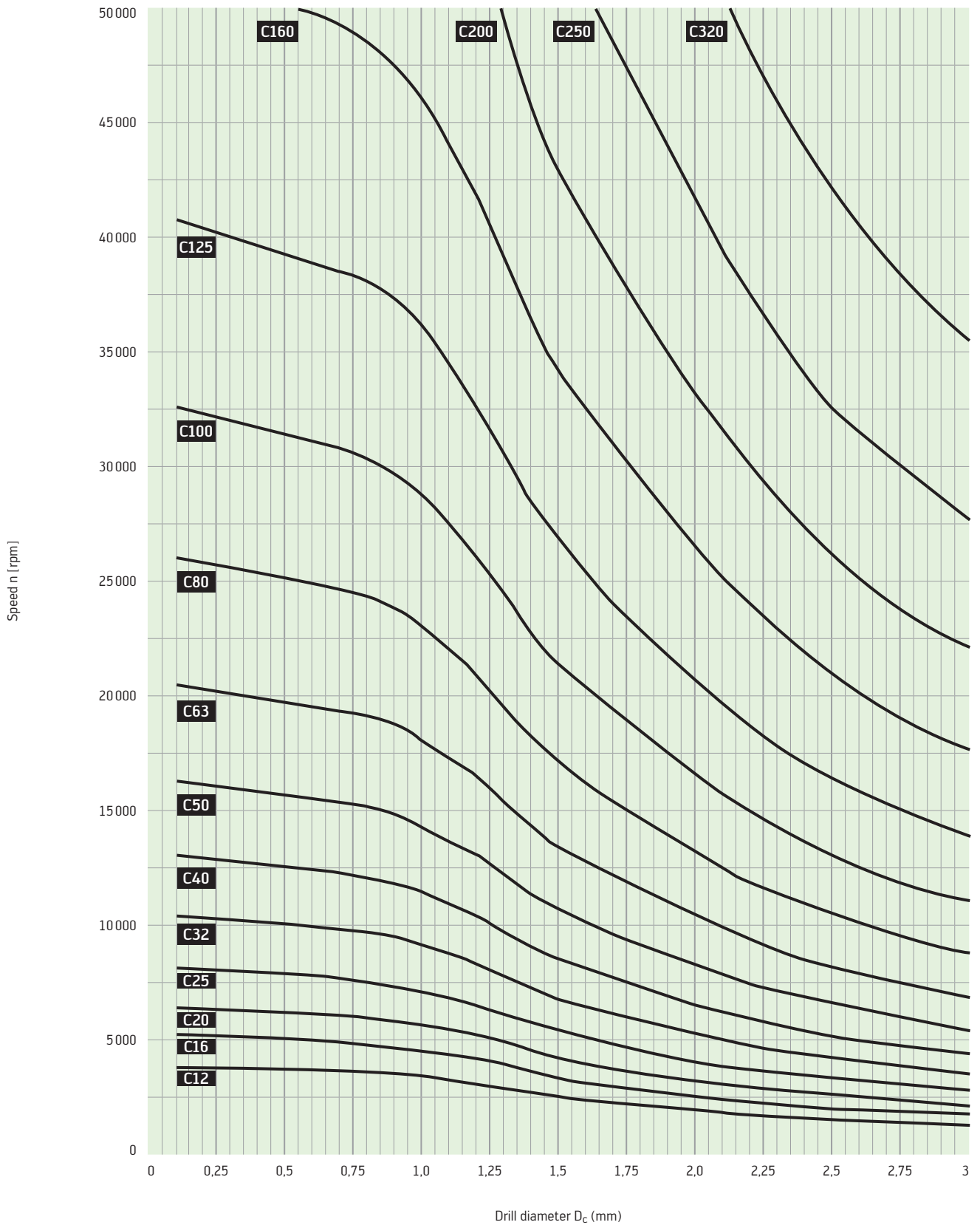
The specified cutting data are average standard values.
For specific applications, adjustment is recommended.

		3 x D _c				5 x D _c				2 x D _c															
		DC150 Perform		DC150 Perform		DB130 Advance		DC160 Advance X-treme Evo		DC150 Perform		DB131 Supreme													
		DIN 6539		DIN 6537 K		DIN 1899		DIN 6537 L		DIN 6537 L		Walter													
		WJ30RE		WJ30RE		WJ30UU		WJ30ET		WJ30TA		WJ30EL													
		1,5–2,9		3–20		0,1–1,45		3–25		3–20		0,5–1,984													
		244		245		247		249		256		259													
	VCR	VRR			v _c	VRR			VCR	VRR			v _c	VRR			VCR	VRR							
C80	12	E0			90	12	E0		C63	5	E0		100	12	E0		80	12	E0		C100	12	E0		
C80	10	E0			80	10	E0		C63	6	E0		110	12	E0		80	10	E0		C80	12	E0		
C80	10	E0			80	10	E0		C63	6	E0		100	12	E0		71	10	E0		C80	12	E0		
C63	9	E0			71	9	E0		C50	5	E0		110	10	E0		71	9	E0		C80	12	E0		
C50	8	E0			56	8	E0		C40	5	E0		71	10	E0		56	8	E0		C63	16	E0		
C80	12	E0			90	12	E0		C63	6	E0		100	16	E0		80	12	E0		C100	12	E0		
C80	12	E0			80	12	E0		C63	6	E0		110	12	E0		80	12	E0		C80	12	E0		
C50	8	E0			50	8	E0		C40	5	E0		63	10	E0		45	8	E0		C63	16	E0		
C32	6	E0			36	6	E0		C25	4	E0		50	7	E0		32	6	E0		C50	12	E0		
C25	4	E0			28	4	E0		C20	3	E0		36	5	E0		25	4	E0		C40	6	E0		
C63	9	E0			63	9	E0		C32	4	E0		71	9	E0		63	9	E0		C80	10	E0		
C50	8	E0			56	8	E0		C40	5	E0		71	10	E0		56	8	E0		C63	16	E0		
C40	6	E0			40	6	E0		C25	4	E0		45	7	E0		40	6	E0		C50	12	E0		
C63	10	E0			71	10	E0		C50	5	E0		90	12	E0		71	10	E0		C63	12	E0		
C50	8	E0			56	8	E0		C40	5	E0		50	10	E0		50	8	E0		C63	16	E0		
									C12	3	E0										C40	8	E0		
C40	5	E0			40	5	E0		C20	3	E0						40	5	E0		C63	1	E0		
									C12	2	E0										C32	6	E0		
C63	16	E0			71	16	E0		C50	6	E0		80	16	E0		71	16	E0		C160	25	E0		
C50	12	E0			56	12	E0		C40	4	E0		80	12	E0		56	12	E0		C125	20	E0		
C80	16	E0			90	16	E0		C63	7	E0		100	16	E0		80	16	E0		C160	25	E0		
C63	16	E0			71	16	E0		C50	6	E0		80	16	E0		71	16	E0		C160	25	E0		
C80	16	E0			80	16	E0		C63	7	E0		100	16	E0		71	16	E0		C160	30	E0		
C50	12	E0			56	12	E0		C40	4	E0		80	12	E0		56	12	E0		C125	20	E0		
C63	12	E0			63	12	E0		C50	5	E0		90	2	E0		56	12	E0		C125	20	E0		
C250	10	E0	M		250	10	E0	M	C160	9	E0	M					250	10	E0	M	C160	25	E0	M	
C250	10	E0	M		250	10	E0	M	C160	9	E0	M					250	10	E0	M	C160	25	E0	M	
C200	16	E0	M		220	16	E0	M	C125	9	E0	M	250	16	E0	M	220	16	E0	M	C160	25	E0	M	
C200	16	E0	M		200	16	E0	M	C100	9	E0	M	220	16	E0	M	200	16	E0	M	C160	25	E0	M	
C160	12	E0	M		160	12	E0	M	C63	8	E0	M	180	12	E0	M	160	12	E0	M	C125	20	E0	M	
									C125	9	ML														
C160	6	E0			160	6	E0		C100	6	E0		180	6	E0		160	6	E0		C100	6	E0		
C125	10	E0			140	10	E0		C80	8	E0		160	10	E0		140	10	E0		C100	10	E0		
C160	16	E0			180	16	E0		C80	8	E0		200	16	E0		180	16	E0		C100	20	E0		
C40	5	E0			45	5	E0		C20	3	E0		45	5	E0		45	5	E0		C50	6	E0		
									C12	2	E0											C32	6	E0	
																						C25	6	E0	
									C12	2	E0											C32	5	E0	
																						C16	5	E0	
																						C16	6	E0	
C32	5	E0			32	5	E0		C20	3	E0		32	5	E0		28	5	E0		C50	6	E0		
C20	3	E0			22	3	E0		C12	2	E0		22	3	E0		20	3	E0		C25	4	E0		
C16	3	E0			20	3	E0		C12	1	E0		20	3	E0		18	3	E0		C25	4	E0		
																						C16	6	E0	
																						C16	6	E0	
C20	3	OE			22	3	OE						28	3	OE		20	3	OE		C32	3	OE		
									C25	12	E0		100	16	E0		90	16	E0		C100	25	E0		
									C40	8	L														
									C40	8	L														
									C40	8	L														
									C40	8	L														

B 1

VCRR: Speed diagram
Solid carbide micro drills

B 1



VRR: Feed rate charts for solid carbide and HSS drilling and reaming tools

VRR	Feed f [mm] for diameter [mm]															
	0,05	0,06	0,08	0,1	0,12	0,15	0,2	0,25	0,4	0,5	0,6	0,8	1	1,2	1,5	2
1	0,001	0,001	0,001	0,001	0,001	0,001	0,001	0,001	0,001	0,002	0,002	0,003	0,003	0,004	0,005	0,007
2	0,001	0,001	0,001	0,001	0,001	0,001	0,001	0,002	0,003	0,003	0,004	0,005	0,007	0,008	0,010	0,013
3	0,001	0,001	0,001	0,001	0,001	0,002	0,002	0,003	0,004	0,005	0,006	0,008	0,010	0,012	0,015	0,020
4	0,001	0,001	0,001	0,001	0,002	0,002	0,003	0,003	0,005	0,007	0,008	0,011	0,013	0,016	0,020	0,027
5	0,001	0,001	0,001	0,002	0,002	0,003	0,003	0,004	0,007	0,008	0,010	0,013	0,017	0,020	0,025	0,033
6	0,001	0,001	0,002	0,002	0,002	0,003	0,004	0,005	0,008	0,010	0,012	0,016	0,020	0,024	0,030	0,040
7	0,001	0,001	0,002	0,002	0,003	0,004	0,005	0,006	0,009	0,012	0,014	0,019	0,023	0,028	0,035	0,047
8	0,001	0,002	0,002	0,003	0,003	0,004	0,005	0,007	0,011	0,013	0,016	0,021	0,027	0,032	0,040	0,053
9	0,002	0,002	0,002	0,003	0,004	0,005	0,006	0,008	0,012	0,015	0,018	0,024	0,030	0,036	0,045	0,060
10	0,002	0,002	0,003	0,003	0,004	0,005	0,007	0,008	0,013	0,017	0,020	0,027	0,033	0,040	0,050	0,067
12	0,002	0,002	0,003	0,004	0,005	0,006	0,008	0,010	0,016	0,020	0,024	0,032	0,040	0,048	0,060	0,080
16	0,003	0,003	0,004	0,005	0,006	0,008	0,011	0,013	0,021	0,027	0,032	0,043	0,053	0,064	0,080	0,11
20	0,003	0,004	0,005	0,007	0,008	0,010	0,013	0,017	0,027	0,033	0,040	0,053	0,067	0,080	0,10	0,13
25	0,004	0,005	0,007	0,008	0,010	0,013	0,017	0,021	0,033	0,042	0,050	0,067	0,083	0,100	0,125	0,167
30	0,005	0,006	0,008	0,010	0,012	0,015	0,020	0,025	0,040	0,050	0,060	0,080	0,100	0,120	0,150	0,200

VRR	Feed f [mm] for diameter [mm]															
	2,5	4	5	6	8	10	12	15	20	25	40	50	60	80	100	
1	0,008	0,013	0,017	0,018	0,021	0,024	0,026	0,029	0,033	0,037	0,047	0,053	0,058	0,067	0,075	
2	0,017	0,027	0,033	0,037	0,042	0,047	0,052	0,058	0,067	0,075	0,094	0,11	0,12	0,13	0,15	
3	0,025	0,040	0,050	0,055	0,063	0,071	0,077	0,087	0,10	0,11	0,14	0,16	0,17	0,20	0,22	
4	0,033	0,053	0,067	0,073	0,084	0,094	0,10	0,12	0,13	0,15	0,19	0,21	0,23	0,27	0,30	
5	0,042	0,067	0,083	0,091	0,11	0,12	0,13	0,14	0,17	0,19	0,24	0,26	0,29	0,33	0,37	
6	0,050	0,080	0,10	0,11	0,13	0,14	0,15	0,17	0,20	0,22	0,28	0,32	0,35	0,40	0,45	
7	0,058	0,093	0,12	0,13	0,15	0,16	0,18	0,20	0,23	0,26	0,33	0,37	0,40	0,47	0,52	
8	0,067	0,11	0,13	0,15	0,17	0,19	0,21	0,23	0,27	0,30	0,38	0,42	0,46	0,53	0,60	
9	0,075	0,12	0,15	0,16	0,19	0,21	0,23	0,26	0,30	0,34	0,42	0,47	0,52	0,60	0,67	
10	0,083	0,13	0,17	0,18	0,21	0,24	0,26	0,29	0,33	0,37	0,47	0,53	0,58	0,67	0,75	
12	0,10	0,16	0,20	0,22	0,25	0,28	0,31	0,35	0,40	0,45	0,57	0,63	0,69	0,80	0,89	
16	0,13	0,21	0,27	0,29	0,34	0,38	0,41	0,46	0,53	0,60	0,75	0,84	0,92	1,07	1,19	
20	0,17	0,27	0,33	0,37	0,42	0,47	0,52	0,58	0,67	0,75	0,94	1,05	1,15	1,33	1,49	
25	0,21	0,33	0,42	0,46	0,53	0,59	0,65	0,72	0,83	0,93	1,18	1,32	1,44	1,67	1,86	
30	0,25	0,40	0,50	0,55	0,63	0,71	0,77	0,87	1,00	1,12	1,41	1,58	1,73	2,00	2,24	

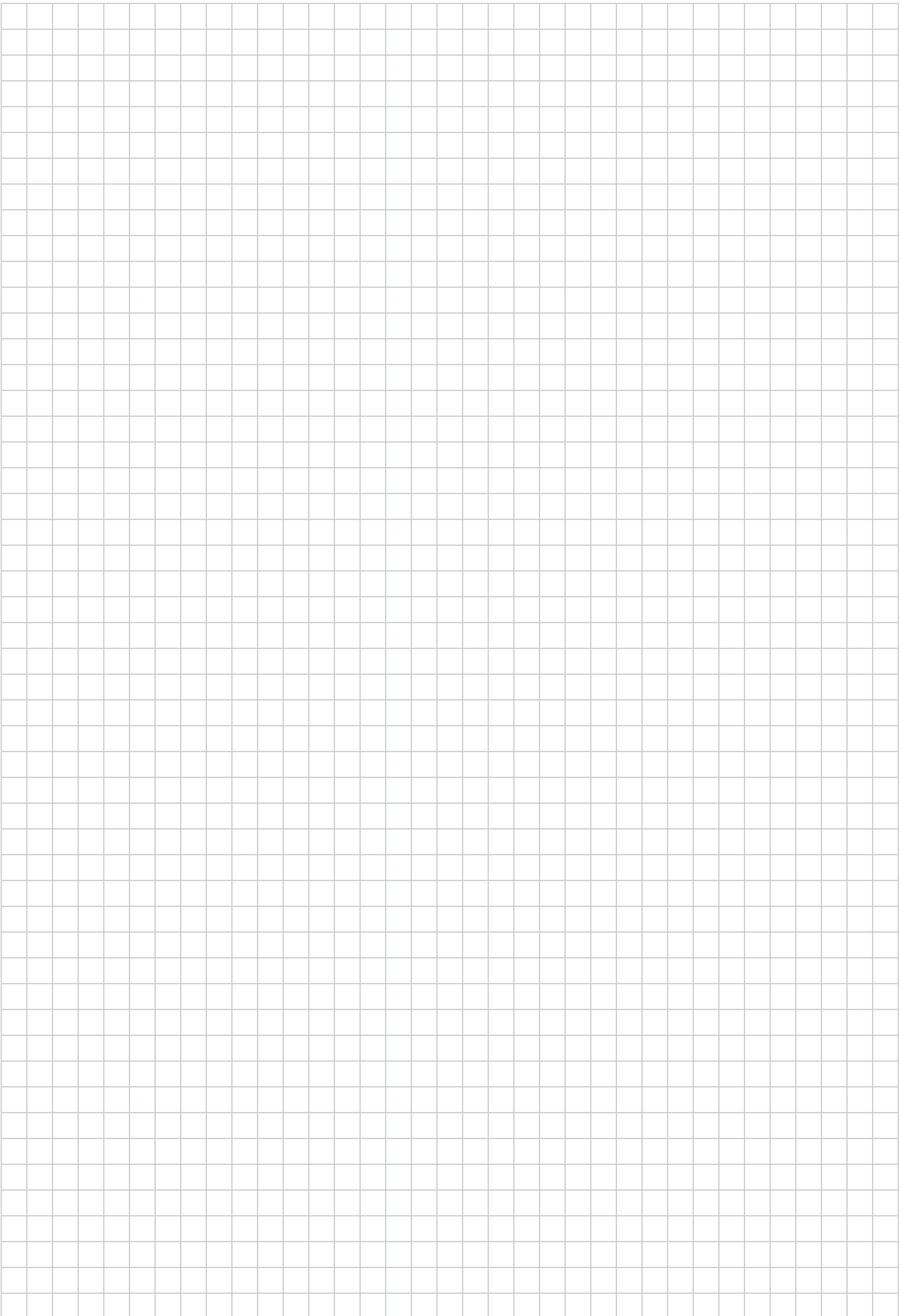
Grade description

Coated carbide

Walter grade description	Standard designation	Materials							Application range								Coating process	Coating composition	Tool example	
		P	M	K	N	S	H	O	01	05	10	15	20	25	30	35				40
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other												
WJ30EJ	HC – P 30	●●																PVD	TiNAl / AlCrN multi-layer coating	
	HC – K 30			●●																
WJ30RE	HC – 30	●●	●●	●●	●●	●●	●	●●										PVD	TiNAl multi-layer coating	
WJ30TA	HC – 30	●●	●●	●●	●●	●●	●	●●										PVD	TiNAl multi-layer coating with post-treatment	
WJ30EL	HC – 30	●●		●●	●●	●	●	●										PVD	AlCrN single-layer coating	
WJ30ER	HC – 30	●●		●●	●●	●	●	●										PVD	AlCrN single-layer point coating	
WJ30ET	HC – 30	●●	●	●●	●●	●●	●	●										PVD	TiSiAlCrN / AlTiN multi-layer coating	
WJ30EU	HC – 30	●●	●	●●	●●	●●	●	●										PVD	TiSiAlCrN / AlTiN multi-layer coating Point coating	
WJ30UU	HW – 30	●●	●●	●●	●●	●●		●●										Uncoated		

 HC = Coated carbide
 HW = Uncoated carbide

 ●● Primary application
 ● Additional application



B 1

Cutting data for D4140

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v _c = Cutting speed VRR = Feed rate chart from page 366 onwards * The classification of the machining groups can be found in the material group comparison table		Drilling depth			2,5 × D _c									
			Designation			D4240									
			Dia. range (mm)			12–29,99									
Overview of the main material groups and code letters		Binnell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *	vc	VRR			vc	VRR					
P	Non-alloyed steel	C ≤ 0.25%	125 430	P1	120	7	E O			120	7	E O			
		C > 0.25 ... ≤ 0.55%	Annealed	190 640	P2	120	7	E O			120	7	E O		
		C > 0.25 ... ≤ 0.55%	Heat-treated	210 710	P3	120	7	E O			120	7	E O		
		C > 0.55%	Annealed	190 640	P4	110	6	E O			110	6	E O		
		C > 0.55%	Heat-treated	300 1010	P5	90	7	E O			90	7	E O		
	Low-alloy steel	Free-machining steel (short-chipping)	Annealed	220 750	P6	120	7	E O			120	7	E O		
		Annealed	175 590	P7	120	7	E O			120	7	E O			
		Heat-treated	285 960	P8	71	7	E O			71	7	E O			
		Heat-treated	380 1280	P9	32	3	O E			32	3	O E			
		Heat-treated	430 1480	P10											
High-alloyed steel and high-alloyed tool steel	Annealed	200 680	P11	90	6	E O			90	6	E O				
	Hardened and tempered	300 1010	P12	90	7	E O			90	7	E O				
	Hardened and tempered	380 1280	P13	63	5	E O			63	5	E O				
Stainless steel	Ferritic/martensitic, annealed	200 680	P14	100	7	E O			100	7	E O				
	Martensitic, heat-treated	330 1110	P15	80	7	E O			80	7	E O				
M	Stainless steel	Austenitic, quench hardened	200 680	M1					71	4	E O				
		Austenitic, precipitation hardened (PH)	300 1010	M2											
		Austenitic/ferritic, duplex	230 780	M3					32	5	E O				
K	Malleable cast iron	Ferritic	200 400	K1	120	8	E O			120	8	E O			
		Pearlitic	260 700	K2	120	8	E O			120	8	E O			
	Grey cast iron	Low tensile strength	180 200	K3	140	9	E O			140	9	E O			
		High tensile strength/austenitic	245 350	K4	140	9	E O			140	9	E O			
	Cast iron with spheroidal graphite	Ferritic	155 400	K5	140	8	E O			140	8	E O			
		Pearlitic	265 700	K6	120	8	E O			120	8	E O			
	GGV (CGI)		230 400	K7	110	7	E O			110	7	E O			
N	Wrought aluminium alloys	Not hardenable	30 –	N1											
		Hardenable, hardened	100 340	N2											
	Cast aluminium alloys	≤ 12% Si, not hardenable	75 260	N3											
		≤ 12% Si, hardenable, hardened	90 310	N4											
		> 12% Si, not hardenable	130 450	N5											
	Magnesium-based alloys		70 250	N6											
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100 340	N7											
Brass, bronze, red brass		90 310	N8												
Cu alloys, short-chipping		110 380	N9												
High tensile, Ampco		300 1010	N10												
S	Heat-resistant alloys	Fe-based	Annealed	200 680	S1				56	3	E O				
			Hardened	280 940	S2										
		Ni- or Co-based	Annealed	250 840	S3					32	5	E O			
			Hardened	350 1180	S4					12	2	E O			
			Cast	320 1080	S5					20	5	E O			
	Titanium alloys	Pure titanium	200 680	S6					71	4	E O				
		α and β alloys, hardened	375 1260	S7					63	4	E O				
		β alloys	410 1400	S8					63	3	E O				
Tungsten alloys		300 1010	S9					20	5	E O					
Molybdenum alloys		300 1010	S10					20	5	E O					
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											
	Thermosets	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											

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

2,5 × D _c														1,3 × D _c													
D4240														D4140													
12–29,99														12–25,99													
P6004 WNN25				P6005 WKK45C				P6001 WPP45C				P6003 WMP35				P6004 WNN25				P6005 WKK45C							
vc	VRR			vc	VRR			vc	VRR			vc	VRR			vc	VRR			vc	VRR						
								120	7	EO		120	7	EO													
								120	7	EO		120	7	EO													
								120	7	EO		120	7	EO													
								110	6	EO		110	6	EO													
								90	7	EO		90	7	EO													
								120	7	EO		120	7	EO													
								120	7	EO		120	7	EO													
								71	7	EO		71	7	EO													
								32	3	OE		32	3	OE													
								90	6	EO		90	6	EO													
								90	7	EO		90	7	EO													
								63	5	EO		63	5	EO													
								100	7	EO		100	7	EO													
								80	7	EO		80	7	EO													
												71	4	EO													
												32	5	EO													
				120	8	EO		120	8	EO		120	8	EO						120	8	EO					
				110	8	EO		120	8	EO		120	8	EO						110	8	EO					
				160	9	EO		140	9	EO		140	9	EO						160	9	EO					
				160	9	EO		140	9	EO		140	9	EO						160	9	EO					
				140	8	EO		140	8	EO		140	8	EO						140	8	EO					
				110	8	EO		120	8	EO		120	8	EO						110	8	EO					
				110	7	EO		110	7	EO		110	7	EO						110	7	EO					
	320	16	EO												320	16	EO										
	320	16	EO												320	16	EO										
	400	9	EO	M											400	9	EO	M									
	320	9	EO	M											320	9	EO	M									
	220	9	EO	M											220	9	EO	M									
	120	4	EO												120	4	EO										
	250	10	EO												250	10	EO										
	250	10	EO												250	10	EO										
	90	5	EO												90	5	EO										
												56	3	EO													
												32	5	EO													
												12	2	EO													
												20	5	EO													
												71	4	EO													
												63	4	EO													
												63	3	EO													
												20	5	EO													
												20	5	EO													

HC = Coated carbide

B 1

Cutting data for D4140

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v _c = Cutting speed VRR = Feed rate chart from page 366 onwards * The classification of the machining groups can be found in the material group comparison table		Drilling depth		3 × D _c										
			Designation		D4140										
			Dia. range (mm)		12–37,99										
Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *	 P6001 WPP45C			 P6003 WMP35						
		vc				VRR			vc	VRR					
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	110	7	EO		110	7	EO		
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	110	7	EO		110	7	EO		
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	100	7	EO		100	7	EO		
		C > 0.55%	Annealed	190	640	P4	100	6	EO		100	6	EO		
		C > 0.55%	Heat-treated	300	1010	P5	80	7	EO		80	7	EO		
		Free-machining steel (short-chipping)	Annealed	220	750	P6	110	7	EO		110	7	EO		
	Low-alloy steel	Annealed	175	590	P7	110	7	EO		110	7	EO			
		Heat-treated	285	960	P8	71	7	EO		71	7	EO			
		Heat-treated	380	1280	P9	32	3	OE		32	3	OE			
		Heat-treated	430	1480	P10										
High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	80	6	EO		80	6	EO				
	Hardened and tempered	300	1010	P12	80	7	EO		80	7	EO				
	Hardened and tempered	380	1280	P13	63	5	EO		63	5	EO				
Stainless steel	Ferritic/martensitic, annealed	200	680	P14	90	7	EO		90	7	EO				
	Martensitic, heat-treated	330	1110	P15	71	7	EO		71	7	EO				
M	Stainless steel	Austenitic, quench hardened	200	680	M1					63	4	EO			
		Austenitic, precipitation hardened (PH)	300	1010	M2										
		Austenitic/ferritic, duplex	230	780	M3										
K	Malleable cast iron	Ferritic	200	400	K1	110	8	EO		110	8	EO			
		Pearlitic	260	700	K2	110	8	EO		110	8	EO			
	Grey cast iron	Low tensile strength	180	200	K3	140	9	EO		140	9	EO			
		High tensile strength/austenitic	245	350	K4	120	9	EO		120	9	EO			
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	120	8	EO		120	8	EO			
		Pearlitic	265	700	K6	110	8	EO		110	8	EO			
	GGV (CGI)		230	400	K7	110	7	EO		110	7	EO			
N	Wrought aluminium alloys	Not hardenable	30	–	N1										
		Hardenable, hardened	100	340	N2										
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3										
		≤ 12% Si, hardenable, hardened	90	310	N4										
		> 12% Si, not hardenable	130	450	N5										
	Magnesium-based alloys		70	250	N6										
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7										
Brass, bronze, red brass		90	310	N8											
Cu alloys, short-chipping		110	380	N9											
High tensile, Ampco		300	1010	N10											
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1					50	3	EO		
			Hardened	280	940	S2									
		Ni- or Co-based	Annealed	250	840	S3						28	5	EO	
			Hardened	350	1180	S4						11	2	EO	
			Cast	320	1080	S5						18	5	EO	
	Titanium alloys	Pure titanium	200	680	S6						63	4	EO		
		α and β alloys, hardened	375	1260	S7						56	4	EO		
		β alloys	410	1400	S8						56	3	EO		
Tungsten alloys		300	1010	S9						18	5	EO			
Molybdenum alloys		300	1010	S10						18	5	EO			
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										
	Thermosets	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									

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

B 1

3 × D _c														5 × D _c													
D4140														D4140													
12–37,99														12–37,99													
 P6004 WNN25 P6005 WKK45C														 P6001 WPP45C P6003 WMP35 P6004 WNN25 P6005 WKK45C													
vc	VRR			vc	VRR			vc	VRR			vc	VRR			vc	VRR			vc	VRR						
								100	7	EO						100	7	EO									
								100	7	EO						100	7	EO									
								100	7	EO						100	7	EO									
								90	6	EO						90	6	EO									
								71	7	EO						71	7	EO									
								100	7	EO						100	7	EO									
								100	7	EO						100	7	EO									
								63	7	EO						63	7	EO									
								32	3	OE						32	3	OE									
								80	6	EO						80	6	EO									
								71	7	EO						71	7	EO									
								63	5	EO						63	5	EO									
								90	7	EO						90	7	EO									
								71	7	EO						71	7	EO									
															63	4	EO										
															28	5	EO										
								110	8	EO						110	8	EO									
								100	8	EO						110	8	EO									
								160	9	EO						140	9	EO									
								140	9	EO						120	9	EO									
								120	8	EO						120	8	EO									
								100	8	EO						120	8	EO									
								100	8	EO						110	8	EO									
								100	7	EO						110	7	EO									
								250	16	EO						250	16	EO									
								250	16	EO						250	16	EO									
								400	9	EO	M					360	9	EO	M								
								320	9	EO	M					320	9	EO	M								
								200	9	EO	M					200	9	EO	M								
								110	4	EO						110	4	EO									
								220	10	EO						220	10	EO									
								220	10	EO						220	10	EO									
								80	5	EO						71	5	EO									
															50	3	EO										
															25	5	EO										
															10	2	EO										
															18	5	EO										
															63	4	EO										
															50	4	EO										
															50	3	EO										
															18	5	EO										
															18	5	EO										

HC = Coated carbide

Cutting data for D4140

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS v _c = Cutting speed VRR = Feed rate chart from page 366 onwards * The classification of the machining groups can be found in the material group comparison table		Drilling depth		7 × D _c								
			Designation		D4140								
			Dia. range [mm]		12–37,99								
Overview of the main material groups and code letters			Binnell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *	P6001 WPP45C		P6003 WMP35					
vc	VRR						vc	VRR					
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	100	7	EO				
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	100	7	EO				
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	100	7	EO				
		C > 0.55%	Annealed	190	640	P4	90	6	EO		90	6	EO
		C > 0.55%	Heat-treated	300	1010	P5	71	7	EO		71	7	EO
		Free-machining steel (short-chipping)	Annealed	220	750	P6	100	7	EO		100	7	EO
	Low-alloy steel	Annealed	175	590	P7	100	7	EO		100	7	EO	
		Heat-treated	285	960	P8	63	7	EO		63	7	EO	
		Heat-treated	380	1280	P9	32	3	OE		32	3	OE	
		Heat-treated	430	1480	P10								
High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	80	6	EO		80	6	EO		
	Hardened and tempered	300	1010	P12	71	7	EO		71	7	EO		
	Hardened and tempered	380	1280	P13	63	5	EO		63	5	EO		
Stainless steel	Ferritic/martensitic, annealed	200	680	P14	90	7	EO		90	7	EO		
	Martensitic, heat-treated	330	1110	P15	71	7	EO		71	7	EO		
M	Stainless steel	Austenitic, quench hardened	200	680	M1					63	4	EO	
		Austenitic, precipitation hardened (PH)	300	1010	M2								
		Austenitic/ferritic, duplex	230	780	M3								
K	Malleable cast iron	Ferritic	200	400	K1	110	8	EO		110	8	EO	
		Pearlitic	260	700	K2	110	8	EO		110	8	EO	
	Grey cast iron	Low tensile strength	180	200	K3	120	9	EO		120	9	EO	
		High tensile strength/austenitic	245	350	K4	120	9	EO		120	9	EO	
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	120	8	EO		120	8	EO	
		Pearlitic	265	700	K6	110	8	EO		110	8	EO	
	GGV (CGI)		230	400	K7	110	7	EO		110	7	EO	
N	Wrought aluminium alloys	Not hardenable	30	–	N1								
		Hardenable, hardened	100	340	N2								
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3								
		≤ 12% Si, hardenable, hardened	90	310	N4								
		> 12% Si, not hardenable	130	450	N5								
	Magnesium-based alloys		70	250	N6								
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7								
Brass, bronze, red brass		90	310	N8									
Cu alloys, short-chipping		110	380	N9									
High tensile, Ampco		300	1010	N10									
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1				50	3	EO	
			Hardened	280	940	S2							
		Ni- or Co-based	Annealed	250	840	S3				25	5	EO	
			Hardened	350	1180	S4				10	2	EO	
			Cast	320	1080	S5				18	5	EO	
	Titanium alloys	Pure titanium	200	680	S6				63	4	EO		
		α and β alloys, hardened	375	1260	S7				50	4	EO		
		β alloys	410	1400	S8				50	3	EO		
Tungsten alloys		300	1010	S9				18	5	EO			
Molybdenum alloys		300	1010	S10				18	5	EO			
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								
	Thermosets	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							

Cutting data for D4120

B 1

Material group	= Wet machining (E = emulsion, O = oil) = Dry machining is possible (M = MQL, L = dry) The cutting data must be selected from Walter GPS * The classification of the machining groups can be found in the material group comparison table		Brinell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *	Indexable insert geometry							
						Starting values for feed f [mm/rev]							
						A 57							
						Grade 1	Grade 2	Grade 3	Grade 4	Grade 5 Grade 6	Grade 7 Grade 8		
Overview of the main material groups and code letters		D _c [mm]											
		13,5–16,4	16,5–20,4	20,5–24,4	24,5–29,4	29,5–42,4	42,5–59,4						
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	0,05	0,06	0,06	0,09	0,12	0,13
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	●●	0,07	0,09	0,10	0,13	0,18	0,19
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	●●	0,07	0,09	0,10	0,13	0,18	0,19
		C > 0.55%	Annealed	190	640	P4	●●	0,07	0,09	0,10	0,13	0,18	0,19
		C > 0.55%	Heat-treated	300	1010	P5	●●	0,07	0,09	0,10	0,13	0,18	0,19
	Low-alloy steel	Free-machining steel (short-chipping)	Annealed	220	750	P6	●● ●	0,07	0,09	0,10	0,13	0,18	0,19
		Annealed	175	590	P7	●●	0,08	0,10	0,12	0,15	0,20	0,21	
		Heat-treated	285	960	P8	●●	0,07	0,09	0,10	0,13	0,15	0,16	
		Heat-treated	380	1280	P9	●●	0,07	0,09	0,10	0,13	0,15	0,16	
	High-alloyed steel and high-alloyed tool steel	Heat-treated	430	1480	P10	●●	0,05	0,06	0,06	0,09	0,12	0,13	
		Annealed	200	680	P11	●●	0,08	0,10	0,12	0,15	0,18	0,19	
		Hardened and tempered	300	1010	P12	●●	0,07	0,09	0,10	0,13	0,15	0,16	
	Stainless steel	Hardened and tempered	380	1280	P13	●●	0,06	0,08	0,09	0,12	0,14	0,15	
		Ferritic/martensitic, annealed	200	680	P14	●●	0,07	0,09	0,10	0,13	0,15	0,16	
	M	Stainless steel	Martensitic, heat-treated	330	1110	P15	●●	0,06	0,08	0,09	0,12	0,14	0,15
Austenitic, quench hardened			200	680	M1	●●	0,06	0,07	0,08	0,10	0,13	0,14	
Austenitic, precipitation hardened (PH)			300	1010	M2	●●	0,06	0,07	0,08	0,10	0,13	0,14	
K	Malleable cast iron	Austenitic/ferritic, duplex	230	780	M3	●●	0,06	0,07	0,08	0,10	0,13	0,14	
		Ferritic	200	400	K1	●● ●	0,09	0,12	0,14	0,17	0,22	0,23	
	Grey cast iron	Pearlitic	260	700	K2	●● ●	0,07	0,09	0,11	0,14	0,19	0,20	
		Low tensile strength	180	200	K3	●● ●	0,10	0,13	0,15	0,18	0,23	0,24	
		High tensile strength/austenitic	245	350	K4	●● ●	0,08	0,10	0,12	0,15	0,20	0,21	
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	●● ●	0,10	0,13	0,15	0,18	0,23	0,24	
Pearlitic		265	700	K6	●●	0,08	0,10	0,12	0,18	0,23	0,24		
GGV (CGI)		230	400	K7	●● ●	0,09	0,12	0,14	0,17	0,22	0,23		
N	Wrought aluminium alloys	Not hardenable	30	–	N1								
		Hardenable, hardened	100	340	N2	●●							
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3	●●							
		≤ 12% Si, hardenable, hardened	90	310	N4	●●							
		> 12% Si, not hardenable	130	450	N5	●● ●							
	Magnesium-based alloys		70	250	N6	●●							
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	340	N7							
Brass, bronze, red brass			90	310	N8	●●							
Cu alloys, short-chipping			110	380	N9	●● ●							
High tensile, Ampco			300	1010	N10	●● ●	0,06	0,07	0,08	0,10	0,13	0,14	
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	●●						
			Hardened	280	940	S2	●●						
		Ni- or Co-based	Annealed	250	840	S3	●●						
			Hardened	350	1180	S4	●●						
			Cast	320	1080	S5	●●						
	Titanium alloys	Pure titanium		200	680	S6							
		α and β alloys, hardened		375	1260	S7	●●						
		β alloys		410	1400	S8	●●						
Tungsten alloys		300	1010	S9	●●	0,05	0,06	0,06	0,09	0,11	0,12		
Molybdenum alloys		300	1010	S10	●●	0,05	0,06	0,06	0,09	0,11	0,12		
H	Hardened steel	Hardened and tempered	50 HRC	–	H1	●●	0,05	0,06	0,06	0,09	0,10	0,10	
		Hardened and tempered	55 HRC	–	H2	●●	0,05	0,06	0,06	0,09	0,10	0,10	
		Hardened and tempered	60 HRC	–	H3								
Hardened cast iron	Hardened and tempered	55 HRC	–	H4	●●	0,05	0,06	0,06	0,09	0,10	0,10		
O	Thermoplastics	Without abrasive fillers			O1	●● ●							
	Thermosets	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	●● ●	0,09	0,12	0,14	0,17	0,22	0,23	

- Recommended application (the specified cutting data is regarded as starting values for the recommended application)
- Possible application. Limited to 2 × D_c drilling depth. MQL (minimum quantity lubrication) or compressed air is recommended.

When using drills > 3 × D_c, the following reductions are recommended:
 > 3 × D_c: Cutting speed v_c - 20%, feed f - 30% when spot drilling, feed f - 50% when spot drilling on inclined surfaces.
 > 4 × D_c: Cutting speed v_c - 30%, feed f - 40% when spot drilling.

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

B 1

Indexable insert geometry													Cutting material grade Outer insert [P484.P..]								
Starting values for feed f [mm/rev]													Starting values for cutting speed v _c [m/min]								
E 57						E 67						HC									
Grade 1	Grade 2	Grade 3	Grade 4	Grade 5 Grade 6	Grade 7 Grade 8	Grade 1	Grade 2	Grade 3	Grade 4	Grade 5 Grade 6	Grade 7 Grade 8	WKP25S f [mm/rev]			WKP35S f [mm/rev]			WSP45 f [mm/rev]			
D _c [mm]						D _c [mm]						0,06 0,10 0,16			0,06 0,10 0,16			0,06 0,10 0,16			
13,5- 16,4	16,5- 20,4	20,5- 24,4	24,5- 29,4	29,5- 42,4	42,5- 59,4	13,5- 16,4	16,5- 20,4	20,5- 24,4	24,5- 29,4	29,5- 42,4	42,5- 59,4	0,06	0,10	0,16	0,06	0,10	0,16	0,06	0,10	0,16	
0,05	0,06	0,06	0,09	0,12	0,13	0,05	0,06	0,06	0,09	0,12	0,13	350	320		300	270		250	220		
0,06	0,07	0,08	0,11	0,17	0,18	0,06	0,07	0,08	0,11	0,17	0,18	260	240	220	220	200	180	170	160	150	
0,06	0,07	0,08	0,11	0,17	0,18							240	220	200	200	180	150	150	140	130	
0,06	0,07	0,08	0,11	0,17	0,18							220	200	180	180	150	140	140	130	120	
0,06	0,07	0,08	0,11	0,17	0,18							190	170	150	150	130	120	130	120	110	
0,06	0,07	0,08	0,11	0,17	0,18							220	200	180	180	150	140	140	130	120	
0,06	0,08	0,10	0,13	0,19	0,20	0,06	0,08	0,10	0,14	0,20	0,21	260	240	220	220	200	180	170	160	160	
0,06	0,07	0,08	0,11	0,14	0,15							230	210	190	190	170	140	140	130	120	
0,06	0,07	0,08	0,11	0,14	0,15							210	190	170	180	160	130	140	120	110	
0,05	0,06	0,06	0,09	0,11	0,12							190	170	160	170	140	130	140	120	110	
0,06	0,08	0,10	0,13	0,17	0,18	0,06	0,08	0,10	0,12	0,16	0,17	220	200	180	200	170	150	140	130	120	
0,06	0,07	0,08	0,11	0,14	0,15							200	170	150	180	140	130	130	120	110	
0,05	0,06	0,07	0,10	0,13	0,14							190	160	140	170	130	120	120	110	100	
0,06	0,07	0,08	0,11	0,14	0,15	0,06	0,07	0,08	0,11	0,14	0,15				190	170	150	140	130	120	
0,05	0,06	0,07	0,10	0,13	0,14	0,05	0,06	0,07	0,10	0,13	0,15				150	130	120	120	110	100	
0,06	0,07	0,08	0,10	0,13	0,14	0,06	0,07	0,09	0,12	0,14	0,15				220	200	180	180	170	150	
0,06	0,07	0,08	0,10	0,13	0,14	0,06	0,07	0,09	0,12	0,14	0,15				150	130	110	130	110	100	
0,06	0,07	0,08	0,10	0,13	0,14	0,06	0,07	0,09	0,12	0,14	0,15				120	100	80	100	80	70	
0,07	0,09	0,11	0,14	0,21	0,22	0,07	0,09	0,11	0,14	0,21	0,22	210	190	170	190	180	160	170	140	120	
0,05	0,07	0,08	0,11	0,18	0,19	0,05	0,07	0,09				190	140	120	130	120	110	130	120	110	
0,08	0,10	0,12	0,15	0,22	0,23	0,08	0,10	0,12	0,15	0,22	0,23	220	200	180	200	190	170	180	160	130	
0,06	0,08	0,09	0,12	0,19	0,20							180	150	130	150	130	110	150	130	110	
0,08	0,10	0,12	0,15	0,22	0,23	0,08	0,10	0,12	0,15	0,22	0,23	150	140	130	140	120	110	150	130	120	
0,06	0,08	0,09	0,12	0,22	0,23	0,06	0,08					140	130	120	120	110	100	120	110	110	
0,07	0,09	0,11	0,14	0,21	0,22	0,07	0,09	0,11	0,14	0,21	0,22	180	150	130	150	130	110	150	130	110	
0,07	0,09	0,10	0,12	0,17	0,18	0,07	0,09	0,11	0,12	0,17	0,18							450	450	450	
0,08	0,10	0,12	0,15	0,17	0,18	0,08	0,10	0,12	0,15	0,17	0,18							300	300	300	
0,08	0,10	0,12	0,15	0,17	0,18	0,08	0,10	0,12	0,15	0,17	0,18							250	250	250	
0,08	0,10	0,12	0,15	0,17	0,18	0,08	0,10	0,12	0,15	0,17	0,18							200	200	200	
0,08	0,10	0,12	0,15	0,17	0,18	0,08	0,10	0,12	0,15	0,17	0,18							300	300	300	
0,10	0,12	0,14	0,17	0,22	0,23	0,10	0,12	0,14	0,17	0,22	0,23							300	250	200	
0,10	0,12	0,14	0,17	0,22	0,23	0,10	0,12	0,14	0,17	0,22	0,23							350	300	250	
0,06	0,07	0,08	0,10	0,13	0,14	0,06	0,07	0,09	0,12	0,14	0,15				150	130	110	130	110	100	
0,05	0,06	0,07	0,10	0,13	0,14	0,05	0,06	0,07	0,10	0,13	0,14	100	100		100	100		90	90		
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12	80	80		80	80		70	70		
0,05	0,06	0,07	0,10	0,12	0,13	0,05	0,06	0,07	0,10	0,12	0,13	60	60		60	60		50	50		
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12	50	50		50	50		40	40		
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12	50	50		50	50		40	40		
0,05	0,06	0,07	0,10	0,12	0,13	0,05	0,06	0,07	0,10	0,12	0,13				50	50		50	45		
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12				50	50		40	40		
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12	70	60								
0,05	0,06	0,06	0,09	0,11	0,12	0,05	0,06	0,06	0,09	0,11	0,12	70	60								
0,05	0,06	0,06	0,09	0,10	0,10							70	60	50							
0,05	0,06	0,06	0,09	0,10	0,10							60	50	50							
0,05	0,06	0,06	0,09	0,10	0,10							60	50	50							
0,16	0,18	0,20	0,25	0,30	0,30	0,16	0,18	0,20	0,25	0,30	0,30				400	400	400	400	400	400	
0,12	0,14	0,18	0,20	0,25	0,25	0,12	0,14	0,18	0,20	0,25	0,25	300	300	300	300	300	300	300	300	300	
0,07	0,09	0,11	0,14	0,21	0,22							300	250	200	250	200	150	250	200	150	

HC = Coated carbide

Cutting data for D3120

B 1

Material group	Overview of the main material groups and code letters		Brinell hardness HB	Tensile strength R _m (N/mm ²)	Machining group *		Indexable insert geometry					
							Starting values for feed f [mm/rev]					
							A 57					
							Grade 1	Grade 2	Grade 3	Grade 4	Grade 5	
							D _c (mm)					
							16-20	21-25	26-30	31-36	37-42	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	0,05	0,06	0,06	0,09	0,12
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	●●	0,07	0,09	0,10	0,13	0,18
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	●●	0,07	0,09	0,10	0,13	0,18
		C > 0.55%	Annealed	190	640	P4	●●	0,07	0,09	0,10	0,13	0,18
		C > 0.55%	Heat-treated	300	1010	P5	●●	0,07	0,09	0,10	0,13	0,18
		Free-machining steel (short-chipping)	Annealed	220	750	P6	●● ●	0,07	0,09	0,10	0,13	0,18
	Low-alloy steel	Annealed	175	590	P7	●●	0,08	0,10	0,12	0,15	0,20	
		Heat-treated	285	960	P8	●●	0,07	0,09	0,10	0,13	0,15	
		Heat-treated	380	1280	P9	●●	0,07	0,09	0,10	0,13	0,15	
		Heat-treated	430	1480	P10	●●	0,05	0,06	0,06	0,09	0,12	
High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	●●	0,08	0,10	0,12	0,15	0,18		
	Hardened and tempered	300	1010	P12	●●	0,07	0,09	0,10	0,13	0,15		
	Hardened and tempered	380	1280	P13	●●	0,06	0,08	0,09	0,12	0,14		
Stainless steel	Ferritic/martensitic, annealed	200	680	P14	●●	0,07	0,09	0,10	0,13	0,15		
	Martensitic, heat-treated	330	1110	P15	●●	0,06	0,08	0,09	0,12	0,14		
M	Stainless steel	Austenitic, quench hardened	200	680	M1	●●	0,06	0,07	0,08	0,10	0,13	
		Austenitic, precipitation hardened (PH)	300	1010	M2	●●	0,06	0,07	0,08	0,10	0,13	
		Austenitic/ferritic, duplex	230	780	M3	●●	0,06	0,07	0,08	0,10	0,13	
K	Malleable cast iron	Ferritic	200	400	K1	●● ●	0,09	0,12	0,14	0,17	0,22	
		Pearlitic	260	700	K2	●● ●	0,07	0,09	0,11	0,14	0,19	
	Grey cast iron	Low tensile strength	180	200	K3	●● ●	0,10	0,13	0,15	0,18	0,23	
		High tensile strength/austenitic	245	350	K4	●● ●	0,08	0,10	0,12	0,15	0,20	
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	●● ●	0,10	0,13	0,15	0,18	0,23	
		Pearlitic	265	700	K6	●●	0,08	0,10	0,12	0,18	0,23	
GGV (CGI)		230	400	K7	●● ●	0,09	0,12	0,14	0,17	0,22		
N	Wrought aluminium alloys	Not hardenable	30	-	N1							
		Hardenable, hardened	100	340	N2	●●						
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3	●●						
		≤ 12% Si, hardenable, hardened	90	310	N4	●●						
		> 12% Si, not hardenable	130	450	N5	●● ●						
	Magnesium-based alloys		70	250	N6	●●						
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7							
		Brass, bronze, red brass	90	310	N8	●●						
		Cu alloys, short-chipping	110	380	N9	●● ●						
		High tensile, Ampco	300	1010	N10	●● ●	0,06	0,07	0,08	0,10	0,13	
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	●●					
			Hardened	280	940	S2	●●					
		Ni- or Co-based	Annealed	250	840	S3	●●					
			Hardened	350	1180	S4	●●					
		Cast	320	1080	S5	●●						
	Titanium alloys	Pure titanium	200	680	S6							
		α and β alloys, hardened	375	1260	S7	●●						
		β alloys	410	1400	S8	●●						
Tungsten alloys		300	1010	S9	●●	0,05	0,06	0,06	0,09	0,11		
Molybdenum alloys		300	1010	S10	●●	0,05	0,06	0,06	0,09	0,11		
H	Hardened steel	Hardened and tempered	50 HRC	-	H1	●●	0,05	0,06	0,06	0,09	0,10	
		Hardened and tempered	55 HRC	-	H2	●●	0,05	0,06	0,06	0,09	0,10	
		Hardened and tempered	60 HRC	-	H3							
	Hardened cast iron	Hardened and tempered	55 HRC	-	H4	●●	0,05	0,06	0,06	0,09	0,10	
O	Thermoplastics	Without abrasive fillers			O1	●● ●						
	Thermosets	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	●● ●	0,09	0,12	0,14	0,17	0,22

- Recommended application (the specified cutting data is regarded as starting values for the recommended application)
- Possible application, limited to 2 × D_c drilling depth, MQL (minimum quantity lubrication) or compressed air is recommended.

When using drills > 3 × D, the following reductions are recommended:
 > 3 × D: Cutting speed v_c -20%, feed f -30% when spot drilling, feed f -50% when spot drilling on inclined surfaces.
 > 4 × D: Cutting speed v_c -30%, feed f -40% when spot drilling.

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

B 1

Indexable insert geometry											Cutting material grade														
Starting values for feed f [mm/rev]											Starting values for cutting speed v _c [m/min]														
E 57					E 67					HC												HW			
Grade 1	Grade 2	Grade 3	Grade 4	Grade 5	Grade 1	Grade 2	Grade 3	Grade 4	Grade 5	WKP25S f [mm/rev]			WKP35S f [mm/rev]			WSP45S f [mm/rev]			WXP40 f [mm/rev]			WK40 f [mm/rev]			
D _c [mm]					D _c [mm]					0,06	0,10	0,16	0,06	0,10	0,16	0,06	0,10	0,16	0,06	0,10	0,16	0,06	0,10	0,16	
16-20	21-25	26-30	31-36	37-42	16-20	21-25	26-30	31-36	37-42																
0,05	0,06	0,06	0,09	0,12	0,05	0,06	0,06	0,09	0,12	350	320		300	270		250	220		200	180	160				
0,06	0,07	0,08	0,11	0,17	0,06	0,07	0,08	0,11	0,17	260	240	220	220	200	180	170	160	150	150	140	130				
0,06	0,07	0,08	0,11	0,17						240	220	200	200	180	150	150	140	130	150	140	120				
0,06	0,07	0,08	0,11	0,17						220	200	180	180	150	140	140	130	120	150	140	130				
0,06	0,07	0,08	0,11	0,17						190	170	150	150	130	120	130	120	110	120	110	100				
0,06	0,07	0,08	0,11	0,17						220	200	180	180	150	140	140	130	120	120	110	130				
0,06	0,08	0,10	0,13	0,19	0,06	0,08	0,10	0,14	0,20	260	240	220	220	200	180	170	160	150	150	140	130				
0,06	0,07	0,08	0,11	0,14						230	210	190	190	170	140	140	130	120	140	120	110				
0,06	0,07	0,08	0,11	0,14						210	190	170	180	160	130	140	120	110	140	120	90				
0,05	0,06	0,06	0,09	0,11						190	170	160	170	140	130	140	120	110	120	110	80				
0,06	0,08	0,10	0,13	0,17	0,06	0,08	0,10	0,12	0,16	220	200	180	200	170	150	140	130	120	130	120	110				
0,06	0,07	0,08	0,11	0,14						200	170	150	180	140	130	130	120	110	120	110	100				
0,05	0,06	0,07	0,10	0,13						190	160	140	170	130	120	120	110	100	110	100	80				
0,06	0,07	0,08	0,11	0,14	0,06	0,07	0,08	0,11	0,14				190	170	150	140	130	120	130	120	110				
0,05	0,06	0,07	0,10	0,13	0,05	0,06	0,07	0,10	0,13				150	130	120	120	110	100	110	100	90				
0,06	0,07	0,08	0,10	0,13	0,06	0,07	0,09	0,12	0,14				220	200	180	180	170	150	160	150	120				
0,06	0,07	0,08	0,10	0,13	0,06	0,07	0,09	0,12	0,14				150	130	110	130	110	100	110	100	75				
0,06	0,07	0,08	0,10	0,13	0,06	0,07	0,09	0,12	0,14				120	100	80	100	80	70	80	70	60				
0,07	0,09	0,11	0,14	0,21	0,07	0,09	0,11	0,14	0,21	210	190	170	190	180	160	170	140	120	160	140	140				
0,05	0,07	0,08	0,11	0,18	0,05	0,07	0,09			190	140	120	130	120	110	130	120	110	130	120	120				
0,08	0,10	0,12	0,15	0,22	0,08	0,10	0,12	0,15	0,22	220	200	180	200	190	170	180	160	130	160	140	120				
0,06	0,08	0,09	0,12	0,19						180	150	130	150	130	110	150	130	110	130	120	100				
0,08	0,10	0,12	0,15	0,22	0,08	0,10	0,12	0,15	0,22	150	140	130	140	120	110	150	130	120	130	120	110				
0,06	0,08	0,09	0,12	0,22	0,06	0,08				140	130	120	120	110	100	120	110	110	110	100	100				
0,07	0,09	0,11	0,14	0,21	0,07	0,09	0,11	0,14	0,21	180	150	130	150	130	110	150	130	110	130	120	100				
0,07	0,09	0,10	0,12	0,17	0,07	0,09	0,11	0,12	0,17							450	450	450				500	500		
0,08	0,10	0,12	0,15	0,17	0,08	0,10	0,12	0,15	0,17							300	300	300				400	400		
0,08	0,10	0,12	0,15	0,17	0,08	0,10	0,12	0,15	0,17							250	250	250				300	300		
0,08	0,10	0,12	0,15	0,17	0,08	0,10	0,12	0,15	0,17							200	200	200				200	200		
0,08	0,10	0,12	0,15	0,17	0,08	0,10	0,12	0,15	0,17							300	300	300						300	260
0,10	0,12	0,14	0,17	0,22	0,10	0,12	0,14	0,17	0,22							300	250	200						300	260
0,10	0,12	0,14	0,17	0,22	0,10	0,12	0,14	0,17	0,22							350	300	250						400	350
0,06	0,07	0,08	0,10	0,13	0,06	0,07	0,09	0,12	0,14				150	130	110	130	110	100							
0,05	0,06	0,07	0,10	0,13	0,05	0,06	0,07	0,10	0,13	100	100		100	100		90	90		80	80	70	70	70		
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11	80	80		80	80		70	70		60	60	50	50	50		
0,05	0,06	0,07	0,10	0,12	0,05	0,06	0,07	0,10	0,12	60	60		60	60		50	50		50	50	40	40	40		
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11	50	50		50	50		40	40		40	40	35	30	30		
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11	50	50		50	50		40	40		40	40	35	30	30		
0,05	0,06	0,07	0,10	0,12	0,05	0,06	0,07	0,10	0,12				50	50		50	45								
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11				50	50		40	40								
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11	70	60														
0,05	0,06	0,06	0,09	0,11	0,05	0,06	0,06	0,09	0,11	70	60														
0,05	0,06	0,06	0,09	0,10						70	60	50													
0,05	0,06	0,06	0,09	0,10						60	50	50													
0,16	0,18	0,20	0,25	0,30	0,16	0,18	0,20	0,25	0,30				400	400	400	400	400	400	400	400	400				
0,12	0,14	0,18	0,20	0,25	0,12	0,14	0,18	0,20	0,25	300	300	300	300	300	300	300	300	300	300	300	300				
0,07	0,09	0,11	0,14	0,21						300	250	200	250	200	150	250	200	150	250	200	150				

HC = Coated carbide
HW = Uncoated carbide

Cutting tool material application charts – Drilling

Grades for drilling from solid

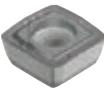
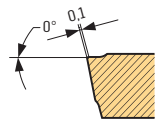

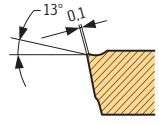

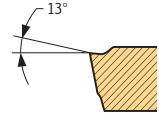

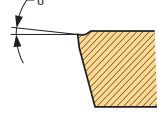

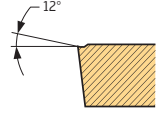

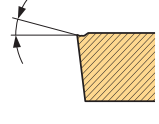
Walter grade designation	Standard designation	Material group							Application range							Coating process	Coating composition	Indexable insert example		
		P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	01	05	10	15	20	25	30				35	40
WKP25S	HC – P 25	●●																CVD	TiCN + Al ₂ O ₃ (+TiCN)	
	HC – K 25			●●																
WKP35S	HC – P 35	●●																CVD	TiCN + Al ₂ O ₃ (+TiCN)	
	HC – K 35			●●																
WSP45S	HC – P 45	●●																PVD	TiAlN + Al ₂ O ₃ (+Al)	
	HC – M 45		●●																	
	HC – S 45					●●														
WSP45	HC – P 45	●●																PVD	TiAlN + Al ₂ O ₃ (+ZrN)	
	HC – M 45		●●																	
	HC – S 45					●●														
WXP40	HC – P 40	●●																PVD	TiCN	
	HC – M 30		●●																	
	HC – K 40			●●																
	HC – S 30					●														
WXP30	HC – P 30	●●																PVD	TiAlN / TiSiN	
	HC – M 30		●																	
	HC – K 30			●●																
	HC – N 30				●															
	HC – S 30					●														
WPP45C	HC – P 45	●●																PVD	TiAlN / TiAl	
	HC – K 45			●																
WKK45C	HC – P 45	●																PVD	TiAlN / TiSiAlCrN / TiSiN	
	HC – K 45			●●																
WMP35	HC – P 35	●●																PVD	TiAlN	
	HC – M 35		●●																	
	HC – S 35					●●														
WNN25	HC – N 25				●●													PVD	ta-C (DLC)	
	HC – O 25							●												

HC = Coated carbide
 HW = Uncoated carbide

- Primary application
- Additional application

Geometry overview – Indexable inserts

Drilling from solid

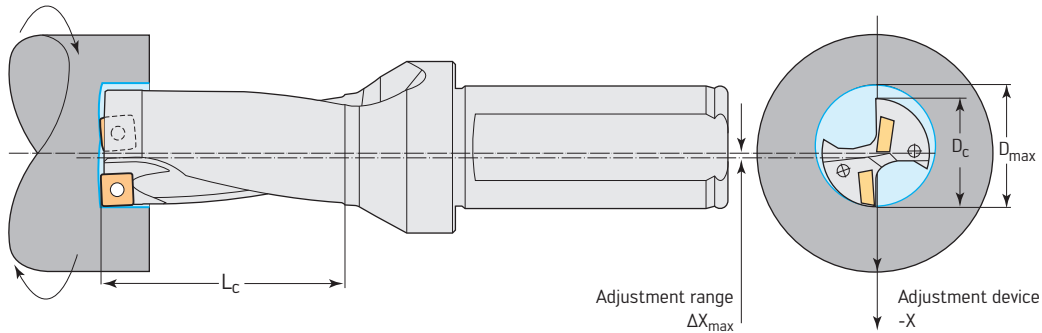
Geometry	Remarks on field of application	Material group							Main cutting edge section
		P	M	K	N	S	H	O	
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other	
	A57 – The stable one – 0° rake angle – For unfavourable machining conditions mainly for cast iron and steel materials	●●	●	●●		●			
	E57 – The universal one – 13° rake angle – For medium machining conditions – For cast iron and steel, but also for stainless materials and materials with difficult cutting properties	●●	●●	●●	●	●			
	E67 – The easy-cutting one – 13° rake angle – Special geometry for optimum chip formation – For long-chipping materials, e.g. St37 and stainless materials as well as materials with difficult cutting properties and aluminium	●●	●●		●	●●			
	LCMX-B57 – The stable one – 6° rake angle – For unfavourable machining conditions – For short-chipping materials	●●		●●					
	LCMX-D57 – The universal one – 12° rake angle – For medium machining conditions	●●	●●	●●	●	●			
	LCMX-E57 – The easy-cutting one – 15° rake angle – For good machining conditions – For long-chipping materials	●●	●●		●●	●●			

●● Primary application
 ● Additional application

B 1

Application information: Drilling with X offset for D4120 using a stationary drill with rotating workpiece

B 1

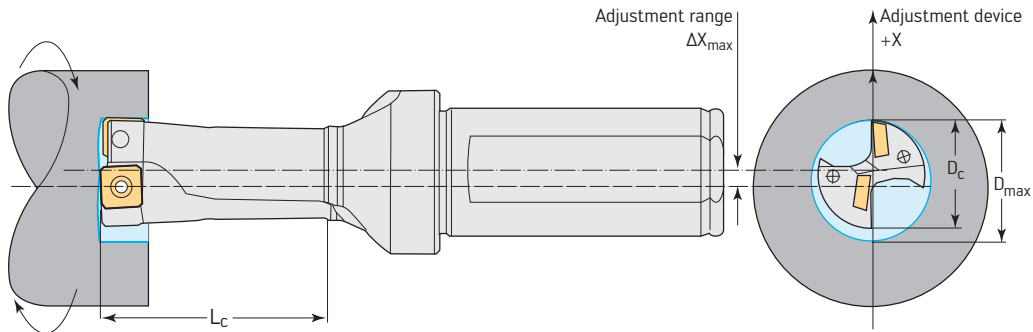


Indexable insert size	D_c mm	$(L_c / D_c) \geq 4$		$(L_c / D_c) < 4$	
		ΔX mm	D_{max} mm	ΔX_{max} mm	D_{max} mm
1	13,5	0,5	14,5	0,7	14,9
	14	0,35	14,7	0,6	15,2
	14,5	0,3	15,1	0,5	15,5
	15	0,2	15,4	0,45	15,9
	15,5	0,15	15,8	0,35	16,2
	16	0,05	16,1	0,3	16,6
	16,4	0	-	0,2	16,8
	16,5	0,6	17,7	0,9	18,3
2	17	0,5	18	0,75	18,5
	17,5	0,35	18,2	0,6	18,7
	18	0,3	18,6	0,55	19,1
	18,5	0,2	18,9	0,45	19,4
	19	0,15	19,3	0,4	19,8
	19,5	0,07	19,64	0,3	20,1
	20	0	20	0,25	20,5
	20,4*	0	-	0,15	20,7
3	20,5	0,35	21,2	0,7	21,9
	21	0,3	21,6	0,6	22,2
	21,5	0,17	21,84	0,45	22,4
	22	0,15	22,3	0,45	22,9
	22,5	0,02	22,54	0,3	23,1
	23	0	-	0,3	23,6
	23,5*	0	-	0,18	23,86
	24*	0	-	0,15	24,3
4	24,4*	0	-	0	-
	24,5	0,5	25,5	0,85	26,2
	25	0,35	25,7	0,75	26,5
	25,5	0,25	26	0,6	26,7
	26	0,15	26,3	0,55	27,1
	26,5	0,05	26,6	0,4	27,3
	27	0	-	0,4	27,8
	27,5	0	-	0,25	28
5	28*	0	-	0,25	28,5
	28,5*	0	-	0,12	28,74
	29*	0	-	0,1	29,2
	29,4*	0	-	0	-

Indexable insert size	D_c mm	$(L_c / D_c) \geq 4$		$(L_c / D_c) < 4$	
		ΔX mm	D_{max} mm	ΔX_{max} mm	D_{max} mm
5	29,5	0,7	30,9	1,1	31,7
	30	0,6	31,2	1	32
	31	0,45	31,9	0,8	32,6
	32	0,3	32,6	0,7	33,4
	33	0,15	33,3	0,5	34
	34	0	-	0,4	34,8
	35*	0	-	0,3	35,6
	35,4*	0	-	0,2	35,8
	35,5	0,8	37,1	1,4	38,3
	36	0,7	37,4	1,25	38,5
6	37	0,55	38,1	1,1	39,2
	38	0,4	38,8	0,95	39,9
	39	0,25	39,5	0,8	40,6
	40	0,1	40,2	0,65	41,3
	41	0	-	0,55	42,1
	42	0	-	0,4	42,8
	42,4	0	-	0,3	43
	42,5	0,95	44,4	1,65	45,8
	43	0,85	44,7	1,5	46
	44	0,7	45,4	1,35	46,7
7	45	0,55	46,1	1,2	47,4
	46	0,4	46,8	1,1	48,2
	47	0,25	47,5	0,95	48,9
	48	0,15	48,3	0,8	49,6
	49	0	-	0,65	50,3
	50	0	-	0,55	51,1
	50,4	0	-	0,45	51,3
	50,5	1,05	52,6	1,85	54,2
	51	0,95	52,9	1,75	54,5
	52	0,8	53,6	1,6	55,2
8	53	0,65	54,3	1,45	55,9
	54	0,55	55,1	1,35	56,7
	55	0,4	55,8	1,2	57,4
	56	0,3	56,6	1,1	58,2
	57	0,15	57,3	0,95	58,9
	58	0	-	0,8	59,6
	59	0	-	0,7	60,4
	59,4	0	-	0,6	60,6

* Outer insert with wiper edge (P4840P.) can only be used 2x.

Application information: Drilling with X offset for D3120 using a stationary drill with rotating workpiece



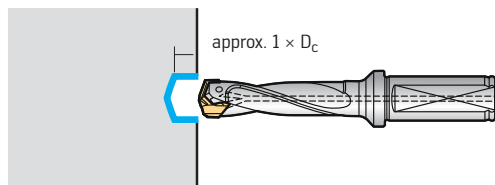
Indexable insert size	D_c mm	$(L_c / D_c) \geq 4$		$(L_c / D_c) < 4$	
		ΔX mm	D_{max} mm	ΔX_{max} mm	D_{max} mm
1	16	1,0	18,0	1,8	19,6
	17	0,8	18,6	1,5	20,0
	18	0,7	19,4	1,3	20,6
	19	0,5	20,0	1,0	21,0
	20	0,3	20,6	0,8	21,6
2	21	1,1	23,2	2,0	25,0
	22	0,9	23,8	1,7	25,4
	23	0,8	24,6	1,5	26,0
	24	0,6	25,2	1,2	26,4
	25	0,4	25,8	1,0	27,0
3	26	1,0	28,0	1,7	29,4
	27	0,8	28,6	1,4	29,8
	28	0,6	29,2	1,2	30,4
	29	0,4	29,8	0,9	30,8
	30	0,3	30,6	0,7	31,4
4	31	1,1	33,2	1,9	34,8
	32	0,9	33,8	1,6	35,2
	33	0,7	34,4	1,4	35,8
	34	0,5	35,0	1,1	36,2
	35	0,3	35,6	0,8	36,6
5	36	0,2	36,4	0,6	37,2
	37	0,9	38,8	1,8	40,6
	38	0,7	39,4	1,5	41,0
	39	0,5	40,0	1,2	41,4
	40	0,5	41,0	1,2	42,4
	41	0,4	41,8	0,9	42,8
	42	0,2	42,4	0,6	43,2

D4140 drilling strategy

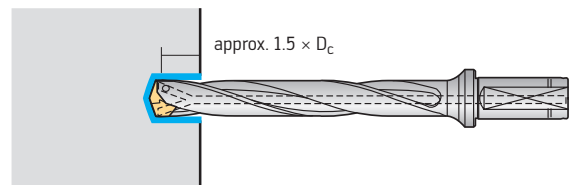
Drilling depth $> 5 \times D_c - 10 \times D_c$

Pilot hole

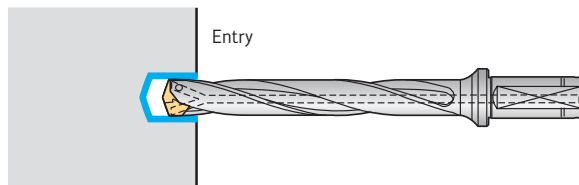
B 1



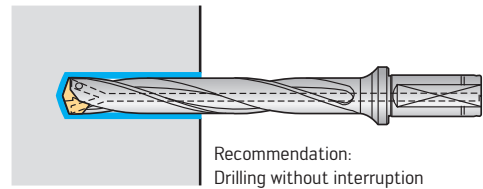
$n = -20\%$
 $f = -50\%$



max. approx. 500 rpm



$n = 100\%$
 $f = 100\%$

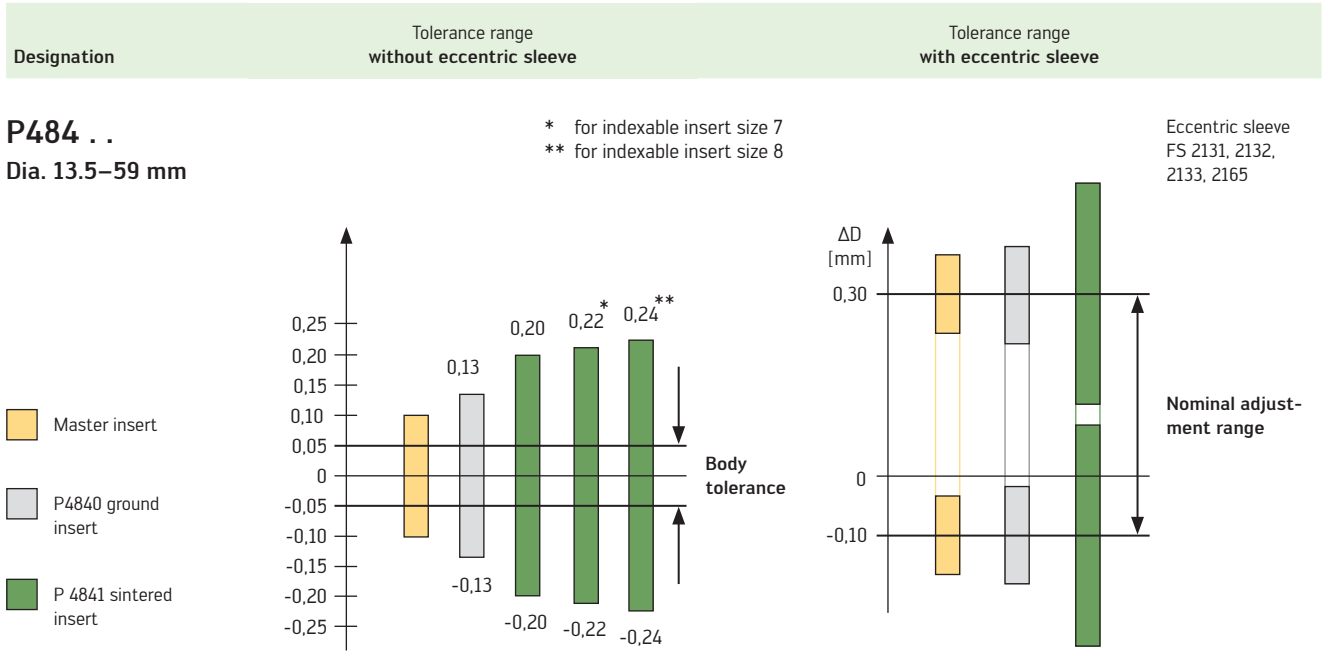


VRR: Feed rate charts for D4140

VRR	Feed f [mm] for diameter [mm]				
	12	15	20	25	40
2	0,052	0,058	0,067	0,075	0,094
3	0,077	0,087	0,10	0,11	0,14
4	0,10	0,12	0,13	0,15	0,19
5	0,13	0,14	0,17	0,19	0,24
6	0,15	0,17	0,20	0,22	0,28
7	0,18	0,20	0,23	0,26	0,33
8	0,21	0,23	0,27	0,30	0,38
9	0,23	0,26	0,30	0,34	0,42
10	0,26	0,29	0,33	0,37	0,47
12	0,31	0,35	0,40	0,45	0,57
16	0,41	0,46	0,53	0,60	0,75

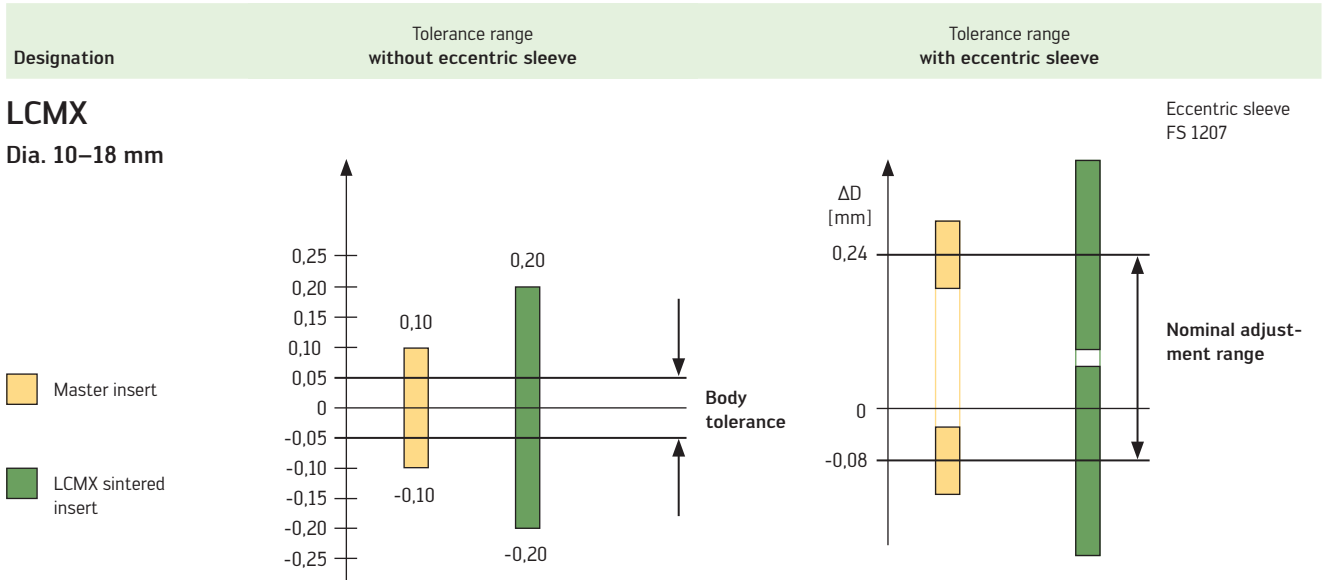
Tool diameter tolerance ranges

1. For D4120/B421 . . indexable insert drills



B 1

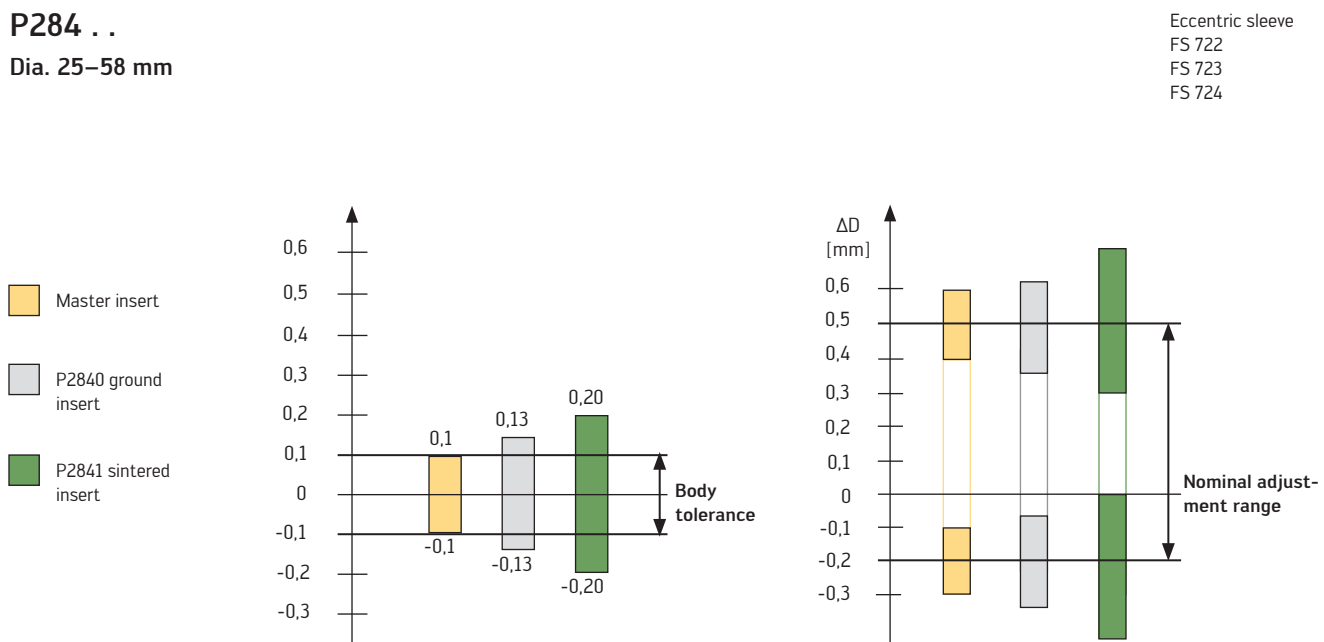
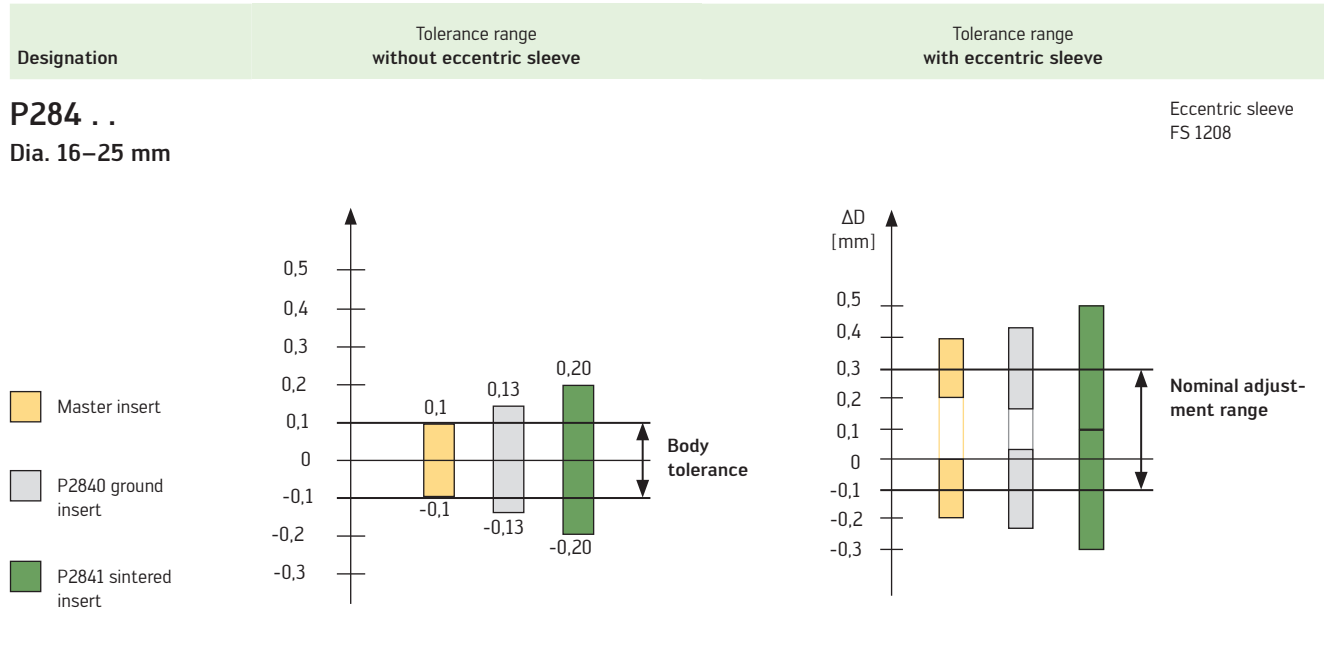
2. For B321 . . DF . . indexable insert drills



The resulting workpiece diameter may differ due to the drilling depth, workpiece material, feed rate and chip removal conditions, etc.

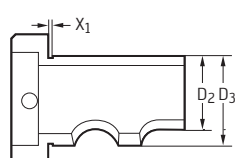
Tool diameter tolerance ranges


3. For the D3120 indexable insert drill



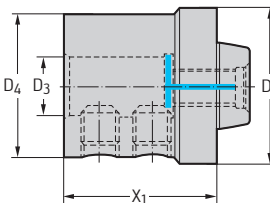
Eccentric sleeves for the D3120 indexable insert drill

Eccentric sleeve




	Eccentric sleeve designation	D _C D3120 mm	D ₂ mm	D ₃ mm	X ₁ mm
Adjustment range: -0.1 to +0.3 mm relative to the nominal diameter	FS 1208	16–25	25	32	4
	FS 722	16–25	25	32	4
Adjustment range: -0.2 to +0.55 mm relative to the nominal diameter	FS 723	26–36	32	40	4
	FS 724	37–42	40	50	4
	DIN 911 hex key	For D ₃ = 32–40 mm = SW 10		For D ₃ = 50 mm = SW 12	

Adaptor



Designation	D ₁ mm	D ₃ mm	D ₄ mm	X ₁ mm	kg
A 170 M.0.63.079.32.EX	63	32	72	79	2,0
A 170 M.0.80.079.32.EX	80	32	72	79	2,2
A 170 M.0.80.087.40.EX	80	40	78	87	2,7
A 170 M.0.80.096.50.EX	80	50	85	96	3,0

Assembly parts







	D ₃ = 32–40 mm	D ₃ = 50 mm
DIN 1835-B screw	M 20 x 2 x 20 (SW 10)	M 24 x 2 x 25 (SW 12)

B 1

HSS drill cutting data






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

B 1

Material group	Overview of the main material groups and code letters * The classification of the machining groups can be found in the material group comparison table			Drilling depth			~8 × Dc			
				Designation			DA110 Perform			
				Standard			DIN 338			
				Cooling			External coolant			
Grade			WZ90AJ							
Dia. range [mm]			1-16							
										
			vc	VRR						
	Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group *							
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	29	9	EO	
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	29	10	EO	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	23	10	EO	
		C > 0.55%	Annealed	190	640	P4	22	8	EO	
		C > 0.55%	Heat-treated	300	1010	P5	15	8	EO	
		Free-machining steel (short-chipping)	Annealed	220	750	P6	29	10	EO	
	Low-alloy steel	Annealed	175	590	P7	29	10	EO		
		Heat-treated	285	960	P8	13	8	EO		
		Heat-treated	380	1280	P9	9	3	EO		
		Heat-treated	430	1480	P10					
	High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	9	4	EO		
		Hardened and tempered	300	1010	P12	15	8	EO		
		Hardened and tempered	380	1280	P13	7	3	EO		
	Stainless steel	Ferritic/martensitic, annealed	200	680	P14	24	10	EO		
		Martensitic, heat-treated	330	1110	P15	15	8	EO		
M	Stainless steel	Austenitic, quench hardened	200	680	M1	5	4	OE		
		Austenitic, precipitation hardened (PH)	300	1010	M2	8	5	EO		
		Austenitic/ferritic, duplex	230	780	M3					
K	Malleable cast iron	Ferritic	200	400	K1	22	12	EO		
		Pearlitic	260	700	K2	17	10	EO		
	Grey cast iron	Low tensile strength	180	200	K3	28	12	EO		
		High tensile strength/austenitic	245	350	K4	22	12	EO		
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	25	12	EO		
		Pearlitic	265	700	K6	17	10	EO		
	GGV (CGI)		230	400	K7	20	10	EO		
N	Wrought aluminium alloys	Not hardenable	30	-	N1					
		Hardenable, hardened	100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3					
		≤ 12% Si, hardenable, hardened	90	310	N4					
		> 12% Si, not hardenable	130	450	N5					
	Magnesium-based alloys		70	250	N6					
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7	41	5	EO		
		Brass, bronze, red brass	90	310	N8					
		Cu alloys, short-chipping	110	380	N9	51	12	EO		
		High tensile, Ampco	300	1010	N10					
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	4	3	OE	
			Hardened	280	940	S2				
		Ni- or Co-based	Annealed	250	840	S3				
			Hardened	350	1180	S4				
			Cast	320	1080	S5				
	Titanium alloys	Pure titanium	200	680	S6					
		α and β alloys, hardened	375	1260	S7					
		β alloys	410	1400	S8					
	Tungsten alloys		300	1010	S9					
	Molybdenum alloys		300	1010	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	25	12	EO		
	Thermosets	Without abrasive fillers			O2	28	8		L	
	Plastic, glass-fibre-reinforced	GFRP			O3					
	Plastic, carbon-fibre-reinforced	CFRP			O4					
	Plastic, aramid-fibre-reinforced	AFRP			O5					
	Graphite (technical)		80 Shore		O6					

Product range overview of indexable inserts for boring and precision boring



Machining	Insert shape	Description	Page
Boring Precision boring		S For boring	374
		C For boring For precision boring	373
		P413x P416x Tangential/lateral rhombic for boring	375
		W For boring	375
		T For precision boring	378

B2

Designation key for negative indexable inserts for boring

P 413			0	2 N		E47
1			2	4 5		6

1	
Walter indexable insert designation	
P413	
P416	Negative boring

2	
Version	
0	Ground
1	Sintered

3	
Position	
C	Centre insert
P	Outer insert
S	Centre insert and outer insert identical
-	Space

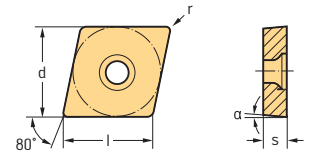
4	
Insert size	
0	08 ...
2	10 ...
3	12 ...
4	14 ...

5	
Cutting direction	
R	RH-cutting
N	Neutral
L	LH-cutting

6	
Walter geometry	
E47	The universal one

B2

**Positive rhombic 80°
CCMT / CCGT
Tiger-tec® Silver**



Indexable inserts

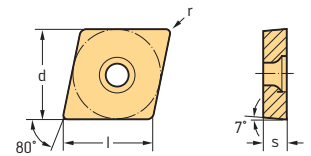
Designation	r mm	l mm	P				M				K		N	S			
			HC				HC				HC	HC	HC				
			WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S
CCMT060202-E47	0,2	6,45	☒	☒						☒	☒					☒	☒
CCMT060204-E47	0,4	6,45	☒	☒						☒	☒					☒	☒
CCMT09T302-E47	0,2	9,67	☒	☒						☒	☒					☒	☒
CCMT09T304-E47	0,4	9,67	☒	☒						☒	☒					☒	☒
CCMT09T308-E47	0,8	9,67	☒	☒						☒	☒					☒	☒
CCMT120404-E47	0,4	12,9	☒	☒						☒	☒					☒	☒
CCMT120408-E47	0,8	12,9	☒	☒						☒	☒					☒	☒
CCMT120412-E47	1,2	12,9	☒	☒						☒	☒					☒	☒
CCMT060204-MM4	0,4	6,45				☒	☒		☒						☒	☒	☒
CCMT060208-MM4	0,8	6,45				☒	☒		☒						☒	☒	☒
CCMT09T304-MM4	0,4	9,67				☒	☒		☒						☒	☒	☒
CCMT09T308-MM4	0,8	9,67				☒	☒		☒						☒	☒	☒
CCMT120404-MM4	0,4	12,90				☒	☒		☒						☒	☒	☒
CCMT120408-MM4	0,8	12,90				☒	☒		☒						☒	☒	☒
CCGT060204-MM4	0,4	6,45							☒						☒	☒	☒
CCGT060208-MM4	0,8	6,45							☒						☒	☒	☒
CCGT09T304-MM4	0,4	9,67							☒						☒	☒	☒
CCGT09T308-MM4	0,8	9,67							☒						☒	☒	☒
CCGT120408-MM4	0,8	12,90							☒						☒	☒	☒

See the ISO 1832 designation key for dimensions

HC = Coated carbide

B2

**Positive rhombic 80°
CCMT Perform**

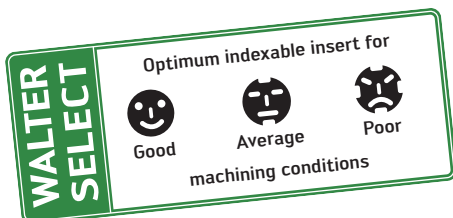


Indexable inserts

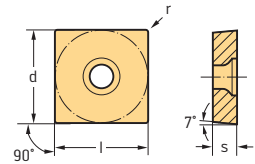
Designation	l mm	r mm	P				M				K		N	S			
			HC				HC				HC	HC	HC				
			WPP10S	WPP20S	WPP30S	WMP20S	WPV10	WPV20	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01
CCMT060204-MV4	6,45	0,4				☒	☒										
CCMT09T304-MV4	9,67	0,4				☒	☒										
CCMT09T308-MV4	9,67	0,8				☒	☒										
CCMT120408-MV4	12,90	0,8				☒	☒										

See the ISO 1832 designation key for dimensions




HC = Coated carbide



Positive square
SCMT / SCGT
Tiger-tec® Silver

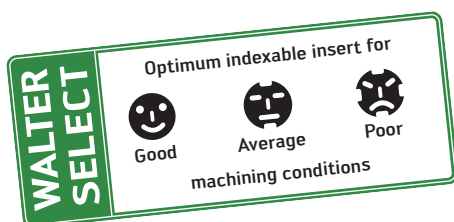


Indexable inserts

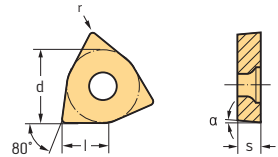
Designation	r mm	l mm	P					M				K		N		S			
			HC					HC				HC		HC		HC			
			WPP01	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S
 SCMT060204-E47	0,4	6,35		☹					☹	☹	☹						☹	☹	☹
SCMT09T304-E47	0,4	9,53		☹					☹	☹							☹	☹	
SCMT09T308-E47	0,8	9,53		☹					☹	☹	☹						☹	☹	☹
SCMT120408-E47	0,8	12,7		☹					☹	☹	☹						☹	☹	☹
 SCMT09T304-MM4	0,4	9,53					☹	☹	☹	☹	☹						☹	☹	☹
SCMT09T308-MM4	0,8	9,53					☹	☹	☹	☹	☹						☹	☹	☹
SCMT120408-MM4	0,8	12,7					☹	☹									☹		
 SCGT09T304-MM4	0,4	9,53							☹	☹						☹		☹	
SCGT09T308-MM4	0,8	9,53							☹	☹						☹		☹	
SCGT120408-MM4	0,8	12,7							☹	☹						☹		☹	

See the ISO 1832 designation key for dimensions



HC = Coated carbide



Positive Trigon 80° WCMT / WCGT Tiger-tec® Silver



Indexable inserts

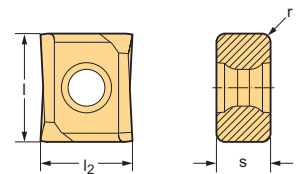
Designation	r mm	l mm	P		M			K		N		S	
			HC		HC			HC		HC		HC	
			WPP10S	WPP20S	WPP30S	WMP20S	WSM10S	WSM20S	WSM30S	WKK10S	WKK20S	WNN10	WSM10S
 WCMT030204-E47	0,4	3,5	☒	☒			☒					☒	
WCMT040204-E47	0,4	4,3	☒	☒			☒					☒	
WCMT06T304-E47	0,4	6,5	☒	☒									☒
WCMT06T308-E47	0,8	6,5					☒						☒
 WCGT030202-MN2	0,2	3,91								☒			
WCGT030204-MN2	0,4	3,91								☒			
WCGT040204-MN2	0,4	4,34								☒			
WCGT06T302-MN2	0,2	6,52								☒			
WCGT06T304-MN2	0,4	6,52								☒			
WCGT080404-MN2	0,4	8,69								☒			
WCGT080408-MN2	0,8	8,69								☒			

See the ISO 1832 designation key for dimensions



HC = Coated carbide

B2

Tangential rhombic P4440



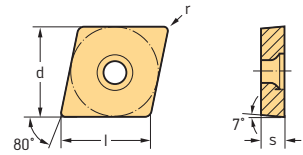
Indexable inserts

Designation	Number of cutting edges	l mm	l ₂ mm	s mm	P		K		M							
					HC		HC		HC							
					WKP30S	WKK10S	WKK20S	WSM20S								
 P4130-4R12-E47	2	10,5	14	7	☒	☒	☒									
 P4160-2R04-E47	2	8,5	10	5	☒	☒	☒									
P4160-2R/L08-E47	2	8,5	10	5	☒	☒	☒									

HC = Coated carbide

☒ / ★ New addition to the product range

Positive rhombic 80°
CCMT / CCGT
Tiger-tec® Silver



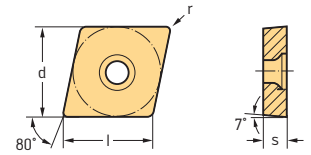
Indexable inserts

Designation	l mm	r mm	P				M					K		N		S				
			HC				HC					HC		HC		HC				
			WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S
CCMT060204-PF	6,45	0,4	☺	☺	☺					☺	☺								☺	☺
CCMT060208-PF	6,45	0,8	☺	☺	☺					☺	☺								☺	☺
CCMT09T304-PF	9,67	0,4	☺	☺	☺					☺	☺								☺	☺
CCMT09T308-PF	9,67	0,8	☺	☺	☺					☺	☺								☺	☺
CCGT060201-FN2	6,45	0,1														☺				
CCGT060202-FN2	6,45	0,2														☺				
CCGT060204-FN2	6,45	0,4														☺				
CCGT09T301-FN2	9,67	0,1														☺				
CCGT09T302-FN2	9,67	0,2														☺				
CCGT09T304-FN2	9,67	0,4														☺				
CCGT09T308-FN2	9,67	0,8														☺				
CCGT120404-FN2	12,90	0,4														☺				
CCGT120408-FN2	12,90	0,8														☺				
CCGT060201-FM2	6,45	0,1								☺										☺
CCGT060202-FM2	6,45	0,2						☺		☺										☺
CCGT060204-FM2	6,45	0,4						☺		☺										☺
CCGT09T301-FM2	9,67	0,1								☺										☺
CCGT09T302-FM2	9,67	0,2						☺		☺										☺
CCGT09T304-FM2	9,67	0,4						☺	☺	☺										☺
CCGT09T308-FM2	9,67	0,8						☺	☺	☺										☺
CCGT120404-FM2	12,90	0,4								☺										☺
CCGT120408-FM2	12,90	0,8								☺										☺
CCMT060202-FP4	6,45	0,2	☺	☺	☺															
CCMT060204-FP4	6,45	0,4	☺	☺	☺															
CCMT060208-FP4	6,45	0,8	☺	☺	☺															
CCMT09T302-FP4	9,67	0,2	☺	☺	☺															
CCMT09T304-FP4	9,67	0,4	☺	☺	☺															
CCMT09T308-FP4	9,67	0,8	☺	☺	☺															
CCMT120404-FP4	12,90	0,4	☺	☺	☺															
CCMT120408-FP4	12,90	0,8	☺	☺	☺															
CCGT060201-MN2	6,45	0,1														☺				
CCGT060202-MN2	6,45	0,2														☺	☺			
CCGT060204-MN2	6,45	0,4														☺	☺			
CCGT09T301-MN2	9,67	0,1														☺				
CCGT09T302-MN2	9,67	0,2														☺	☺			
CCGT09T304-MN2	9,67	0,4														☺	☺			
CCGT09T308-MN2	9,67	0,8														☺	☺			
CCGT120402-MN2	12,90	0,2														☺				
CCGT120404-MN2	12,90	0,4														☺				
CCGT120408-MN2	12,90	0,8														☺				


See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive rhombic 80° CCMT Perform



Indexable inserts

Designation	l mm	r mm	P					M					K		N	S				
			HC					HC					HC		HC	HC				
			WPP10S	WPP20S	WPP30S	WPV10	WPV20	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S
 CCMT060204-FV4	6,45	0,4																		
CCMT09T304-FV4	9,67	0,4				☺	☺													
CCMT09T308-FV4	9,67	0,8				☺	☺													

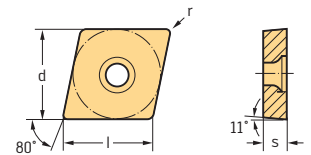
See the ISO 1832 designation key for dimensions

HC = Coated carbide




B2

Positive rhombic 80° CPMT / CPGT

Tiger-tec® Silver

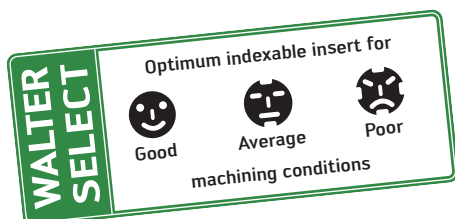


Indexable inserts

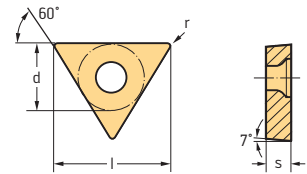
Designation	l mm	r mm	P					M					K		N	S			
			HC					HC					HC		HC	HC			
			WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S
 CPMT050204-FM4	5,64	0,4				☺	☺												
CPMT060204-FM4	6,45	0,4				☺	☺												
CPMT09T304-FM4	9,67	0,4				☺	☺												
CPMT09T308-FM4	9,67	0,8				☺	☺												
 CPMT050204-FP4	5,64	0,4	☺																
CPMT060204-FP4	6,45	0,4	☺																
CPMT09T304-FP4	9,67	0,4	☺																
CPMT09T308-FP4	9,67	0,8	☺																
 CPGT050204-MM4	5,64	0,4								☺									☺
CPGT060201-MM4	6,45	0,1								☺									☺
CPGT060202-MM4	6,45	0,2								☺									☺
CPGT060204-MM4	6,45	0,4								☺	☺								☺
CPGT060208-MM4	6,45	0,8								☺	☺								☺
CPGT09T301-MM4	9,67	0,1								☺									☺
CPGT09T304-MM4	9,67	0,4								☺	☺								☺
CPGT09T308-MM4	9,67	0,8								☺	☺								☺

See the ISO 1832 designation key for dimensions

HC = Coated carbide



Positive triangular 60° TCGT / TCMT Tiger-tec® Silver



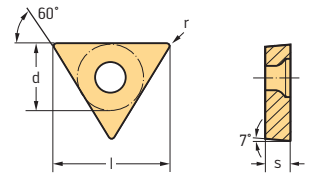
Indexable inserts

Designation	l mm	r mm	P					M					K		N	S						
			WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S	
	TCGT06T101-FN2	6,87	0,1																			
	TCGT06T102-FN2	6,87	0,2																			
	TCGT06T104-FN2	6,87	0,4																			
	TCGT090202-FN2	9,62	0,2																			
	TCGT090204-FN2	9,62	0,4																			
	TCGT110202-FN2	11,00	0,2																			
	TCGT110204-FN2	11,00	0,4																			
	TCGT16T304-FN2	16,50	0,4																			
	TCGT16T308-FN2	16,50	0,8																			
	TCGT06T101-FM2	6,87	0,1																			
	TCGT06T102-FM2	6,87	0,2																			
	TCGT06T104-FM2	6,87	0,4																			
	TCGT090202-FM2	9,62	0,2																			
	TCGT090204-FM2	9,62	0,4																			
	TCGT110201-FM2	11,00	0,1																			
	TCGT110202-FM2	11,00	0,2																			
	TCGT110204-FM2	11,00	0,4																			
	TCGT16T302-FM2	16,50	0,2																			
	TCGT16T304-FM2	16,50	0,4																			
TCGT16T308-FM2	16,50	0,8																				
	TCMT06T102-FM4	6,87	0,2																			
	TCMT06T104-FM4	6,87	0,4																			
	TCMT090202-FM4	9,62	0,2																			
	TCMT090204-FM4	9,62	0,4																			
	TCMT090208-FM4	9,62	0,8																			
	TCMT110202-FM4	11,00	0,2																			
	TCMT110204-FM4	11,00	0,4																			
	TCMT110208-FM4	11,00	0,8																			
	TCMT16T302-FM4	16,50	0,2																			
	TCMT16T304-FM4	16,50	0,4																			
TCMT16T308-FM4	16,50	0,8																				
	TCMT06T102-FP4	6,87	0,2																			
	TCMT06T104-FP4	6,87	0,4																			
	TCMT090202-FP4	9,62	0,2																			
	TCMT090204-FP4	9,62	0,4																			
	TCMT090208-FP4	9,62	0,8																			
	TCMT110202-FP4	11,00	0,2																			
	TCMT110204-FP4	11,00	0,4																			
	TCMT110208-FP4	11,00	0,8																			
	TCMT16T302-FP4	16,50	0,2																			
	TCMT16T304-FP4	16,50	0,4																			
TCMT16T308-FP4	16,50	0,8																				


See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive triangular 60° TCGT / TCMT Tiger-tec® Silver



Indexable inserts

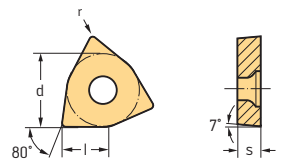
Designation	l mm	r mm	P					M					K		N	S			
			HC					HC					HC		HC	HC			
			WEP10C	WPP10S	WPP20S	WPP30S	WMP20S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S
 TCGT110201-MN2	11,00	0,1													☺				
TCGT110202-MN2	11,00	0,2													☺				
TCGT110204-MN2	11,00	0,4								☺					☺	☺			
TCGT16T302-MN2	16,50	0,2													☺				
TCGT16T304-MN2	16,50	0,4								☺					☺	☺			
TCGT16T308-MN2	16,50	0,8								☺					☺	☺			

See the ISO 1832 designation key for dimensions




HC = Coated carbide

B2

Positive Trigon 80° WCGT Tiger-tec®

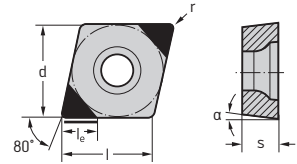


Indexable inserts





Designation	l mm	r mm	P					M					K		N	S			
			HC					HC					HC		HC	HC			
			WPP10S	WPP20S	WPP30S	WMP20S	WSM01	WSM10S	WSM20S	WSM21	WSM30S	WSM10	WKK10S	WKK20S	WNN10	WSM01	WSM10S	WSM20S	WSM30S
 WCGT020102-FN2	2,7	0,2												☺					
WCGT020104-FN2	2,7	0,4												☺					
WCGT030202-FN2	3,91	0,2												☺					
WCGT030204-FN2	3,91	0,4												☺					
WCGT040202-FN2	4,34	0,2												☺					
WCGT040204-FN2	4,34	0,4												☺					
WCGT06T304-FN2	6,52	0,4												☺					
WCGT06T308-FN2	6,52	0,8												☺					
 WCGT030202-FM2	3,91	0,2									☺								
WCGT030204-FM2	3,91	0,4									☺								
WCGT040202-FM2	4,34	0,2									☺								
WCGT040204-FM2	4,34	0,4									☺								
 WCGT030202-MN2	3,91	0,2												☺					
WCGT030204-MN2	3,91	0,4												☺					
WCGT040204-MN2	4,34	0,4												☺					
WCGT06T302-MN2	6,52	0,2												☺					
WCGT06T304-MN2	6,52	0,4												☺					
WCGT080404-MN2	8,69	0,4												☺					
WCGT080408-MN2	8,69	0,8												☺					

See the ISO 1832 designation key for dimensions

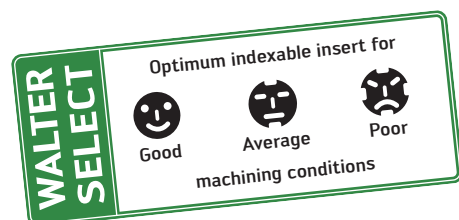
HC = Coated carbide

**CBN – Positive rhombic 80°
CCGW**

Indexable inserts

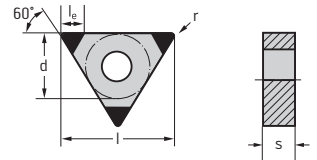
B2

Designation	l _e mm	r mm	K		N		S		H		O	
			CN	BH	HC	DP	BH	BL		DP		
			WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 Wiper CCGW09T304TS-MW2 CCGW09T308TM-MW2	2,8	0,4							☺	☺		
	2,7	0,8							☺	☺		
 CCGW060202EM-2 CCGW060204EM-2 CCGW09T304EM-2 CCGW09T304EM-2	2,8	0,2					☺					
	2,8	0,4					☺					
	2,8	0,4					☺					
	2,8	0,4					☺					
 CCGW060202TS-2 CCGW060204TS-2 CCGW09T304TS-2 CCGW060208TS-2 CCGW09T308TS-2	2,8	0,2		☹				☺	☺			
	2,8	0,4		☹								
	2,8	0,4		☹								
	2,7	0,8		☹								
	2,7	0,8		☹								
 CCGW060204TM-2 CCGW09T304TM-2 CCGW060208TM-2 CCGW09T308TM-2	2,8	0,4						☺	☺	☺		
	2,8	0,4							☺	☺	☺	
	2,7	0,8							☺	☺	☺	
	2,7	0,8							☺	☺	☺	

See the ISO 1832 designation key for dimensions

 CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 HC = Coated carbide
 DP = Polycrystalline diamond
 BL = CBN with low CBN content


CBN – Positive triangular 60° TCGW



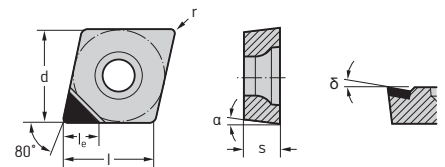
Indexable inserts

Designation	l _e mm	r mm	K		N		S		H		O	
			CN	BH	DP	BH	BL	BL	DP			
			WCK10	WBK20	WBK30	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10	
 TCGW110202TS-3 TCGW110204TS-3	2,8	0,2		★								
	2,8	0,4		★								

CN = Silicon nitride Si₃N₄
 BH = CBN with high CBN content
 HC = Coated carbide
 DP = Polycrystalline diamond
 BL = CBN with low CBN content

B2

PCD – Positive rhombic 80° CPGW



Indexable inserts

Designation	l _e mm	r mm	K		N		S		H		O	
			BH	CN	DP	BH	BL	BL	DP			
			WCB80	WCK10	WDN10	WBS10	WBH10C	WBH10	WBH20	WDN10		
 CPGW050204FS-1 CPGW060204FS-1 CPGW09T304FS-1 CPGW09T308FS-1 CPGW120408FS-1	3	0,4			★							
	3,5	0,4			★							
	4	0,4			★							
	4	0,8			★							
	4	0,8			★							

See the ISO 1832 designation key for dimensions

BH = CBN with high CBN content
 CN = Silicon nitride Si₃N₄
 DP = Polycrystalline diamond
 BL = CBN with low CBN content



Product range overview of boring tools with indexable inserts for boring and precision boring

Machining			
Diameter range D _c [mm]	20–153	20–153	150–640
Designation	B3220 Walter Boring ^{MEDIUM}	B3220 Walter Boring ^{MEDIUM}	B3220 / B3224 Walter Boring ^{MAXI}
Shank (page)	ScrewFit 384 NCT 384	Walter Capto™ 384	Walter Capto™ 386 NCT 388

Machining					
Diameter range D _c [mm]	2–45	2–45	15–203	33–153	150–640
Designation	B3230 Walter Precision ^{MINI}	B4030 Walter Precision ^{MINI}	B3230 Walter Precision ^{MEDIUM}	B4030/B4031 Walter Precision ^{MEDIUM}	B3230 / B3234 Walter Precision ^{MAXI}
Shank (page)	Walter Capto™ 390 ScrewFit 390 NCT 410	Walter Capto™ 390 ScrewFit 390 NCT 410	Walter Capto™ 400 ScrewFit 398 NCT 416	Walter Capto™ 402/404 ScrewFit 402 NCT 420	Walter Capto™ 406 NCT 422
Balance type	Standard	Balanceable	Standard	Standard	Standard
Analogue/digital	Analogue	Analogue	Analogue	Analogue	Analogue
Indexable inserts	TC..06T1.. TC..1102..	TC..06T1.. TC..1102..	CP..0502.. CC..0602.. TC..06T1.. TC..1102..	CP..0502.. CC0..602.. TC..06T1..	CC..0602.. TC..1102..

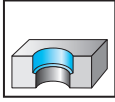
B 2

Two flute boring tool

B3220

Walter Boring^{MEDIUM}

D_c 41-153	$\kappa=90^\circ$	Z=2
-----------------	-------------------	-----



	P	M	K	N	S	H	O
B3220	●●	●●	●●	●	●●		

B2

Tool	Basic body designation	d_1 mm	D_c mm	l_4 mm	$l_{4,1}$ ARS mm
ScrewFit 	B3220G.T36.41-55.Z2	T36	41-55	65	65,3
	B3220G.C4.041-056.Z2	C4		80	80,3
	B3220G.N4.041-056.Z2	N4		80	80,3
	B3220G.T45.55-70.Z2	T45	55-70	80	80,3
B3220G.C5.055-073.Z2	C5	100		100,3	
Walter Capto™ 	B3220G.N5.055-073.Z2	N5	70-90	100	100,3
	B3220G.N6.070-093.Z2	C6		110	110,3
	B3220G.C6.070-93.Z2	N6	90-110	100	100,3
	B3220G.C8.090-113.Z2	C8		110	110,3
NCT 	B3220G.N8.090-113.Z2	N8	110-133	100	100,3
	B3220G.C8.110-153.Z2	C8		110	110,3
	B3220G.N8.110-153.Z2	N8	130-153	100	100,3
	B3220G.C8.110-153.Z2	C8		110	110,3
	B3220G.N8.110-153.Z2	N8		100	100,3

For assembly aids, see page D 154 of the Walter General Catalogue 2017

© ARS cartridge for axial and radial offset roughing. For this, a cartridge © of the complete tool with CC insert seat must be replaced.

 $l_{4,1}$ For the projection length when using the ARS boring method, see "Technical information"

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



Cartridge ① designation	ARS cartridge ② designation	Type 	Complete tool designation with C insert
EB207-208.CC09	EB207-208-1.CC09 (ARS)	CC09	B3220.T36.41-55.Z2.CC09*
			B3220.C4.041-055.Z2.CC09
			B3220.N4.041-055.Z2.CC09
EB209-210.CC09	EB209-210-1.CC09 (ARS)		B3220.T45.55-70.Z2.CC09*
			B3220.C5.055-070.Z2.CC09
			B3220.N5.055-070.Z2.CC09
EB211-212.CC12	EB211-212-1.CC12 (ARS)	CC12 CC16	B3220.C6.070-090.Z2.CC12 B3220.N6.070-090.Z2.CC12
EB211-212.CC16	EB211-212-1.CC16 (ARS)		B3220.C6.070-090.Z2.CC16 B3220.N6.070-090.Z2.CC16
EB213-214.CC12 EB213-214.CC16	EB213-214-1.CC12 (ARS) EB213-214-1.CC16 (ARS)		B3220.C8.090-110.Z2.CC12 B3220.C8.090-110.Z2.CC16
			B 3220.N8.090-110.Z2.CC12 B 3220.N8.090-110.Z2.CC16
EB215.CC12 EB215.CC16	EB215-1.CC12 (ARS) EB215-1.CC16 (ARS)		B3220.C8.110-133.Z2.CC12 B3220.C8.110-133.Z2.CC16
			B 3220.N8.110-133.Z2.CC12 B 3220.N8.110-133.Z2.CC16
EB216.CC12 EB216.CC16	EB216-1.CC12 (ARS) EB216-1.CC16 (ARS)		B3220.C8.130-153.Z2.CC12 B3220.C8.130-153.Z2.CC16
			B 3220.N8.130-153.Z2.CC12 B 3220.N8.130-153.Z2.CC16

* Important: The projection of the cartridges must be sufficient for chip removal when used with extension in blind-hole bores.

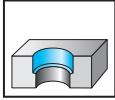
B2

Two flute boring tool

B3223 / B3224

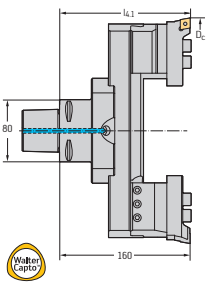
Walter Boring^{MEDIUM}

D_c 150- 640	$\kappa=90^\circ$	Z = 2
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	P	M	K	N	S	H	O
B3223 / B3224	●●	●●	●●	●	●●		

B2

Tool	Basic body designation	d_1 mm	D_c mm	l_4 mm	$l_{4,1}$ ARS mm	Bridge designation
Walter Capto™ 		C8	150-220	160	160,3	EB134AL
		N8		150	150,3	
		C8	220-290	160	160,3	EB135AL
		N8		150	150,3	
		C8	290-360	160	160,3	EB136AL
		N8		150	150,3	
		C8	360-430	160	160,3	EB137AL
		N8		150	150,3	

For assembly aids, see page D 154 of the Walter General Catalogue 2017

© ARS cartridge for axial and radial offset roughing. For this, a cartridge © of the complete tool with CC insert seat must be replaced.

 $l_{4,1}$ For the projection length when using the ARS boring method, see "Technical information"

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



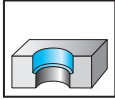
Cartridge holder designation	Cartridge ① designation	ARS cartridge ② designation	 Type	Complete tool designation with C insert
EB122	EB217.CC12 EB217.CC16	EB217-1.CC12 (ARS) EB217-1.CC16 (ARS)	CC12 CC16	B3220.C8.150-220.Z2.CC12 B3220.C8.150-220.Z2.CC16
				B3224.C8.150-220.Z2.CC12 B3224.C8.150-220.Z2.CC16
				B 3220.N8.150-220.Z2.CC12 B 3220.N8.150-220.Z2.CC16
				B 3224.N8.150-220.Z2.CC12 B 3224.N8.150-220.Z2.CC16
				B3220.C8.220-290.Z2.CC12 B3220.C8.220-290.Z2.CC16
				B3224.C8.220-290.Z2.CC12 B3224.C8.220-290.Z2.CC16
				B3220.N8.220-290.Z2.CC12 B3220.N8.220-290.Z2.CC16
				B3224.N8.220-290.Z2.CC12 B3224.N8.220-290.Z2.CC16
				B3220.C8.290-360.Z2.CC12 B3220.C8.290-360.Z2.CC16
				B3224.C8.290-360.Z2.CC12 B3224.C8.290-360.Z2.CC16
				B3220.N8.290-360.Z2.CC12 B3220.N8.290-360.Z2.CC16
				B3224.N8.290-360.Z2.CC12 B3224.N8.290-360.Z2.CC16
				B3220.C8.360-430.Z2.CC12 B3220.C8.360-430.Z2.CC16
				B3224.C8.360-430.Z2.CC12 B3224.C8.360-430.Z2.CC16

B2

Two flute boring tool B3223 / B3224

Walter Boring^{MEDIUM}

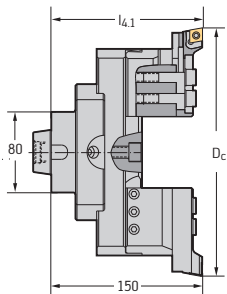
D_c 150- 640	$\kappa=90^\circ$	Z = 2
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	P	M	K	N	S	H	O
B3223 / B3224	●●	●●	●●	●	●●		

B2

Tool	Basic body designation	d_1 mm	D_c mm	l_4 mm	$l_{4,1}$ ARS mm	Bridge designation
NCT		N8	360-430	150	150,3	EB137AL
		C8	430-500	160	160,3	EB138AL
		N8		150	150,3	
	B3223G.N8.150-640 B3224G.N8.150-640	C8	500-570	160	160,3	EB139AL
		N8		150	150,3	
		C8	570-640	160	160,3	EB140AL
		N8		150	150,3	



B3223G.N8.150-640
B3224G.N8.150-640

For assembly aids, see page D 154 of the Walter General Catalogue 2017

⊙ ARS cartridge for axial and radial offset roughing. For this, a cartridge ⊙ of the complete tool with CC insert seat must be replaced.

$l_{4,1}$ For the projection length when using the ARS boring method, see "Technical information"

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



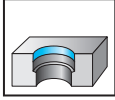
Cartridge holder designation	Cartridge ① designation	ARS cartridge ② designation	 Type	Complete tool designation with C insert
EB122	EB217.CC12 EB217.CC16	EB217-1.CC12 (ARS) EB217-1.CC16 (ARS)	CC12 CC16	B3220.N8.360-430.Z2.CC12 B3220.N8.360-430.Z2.CC16
				B3224.N8.360-430.Z2.CC12 B3224.N8.360-430.Z2.CC16
				B3220.C8.430-500.Z2.CC12 B3220.C8.430-500.Z2.CC16
				B3224.C8.430-500.Z2.CC12 B3224.C8.430-500.Z2.CC16
				B3220.N8.430-500.Z2.CC12 B3220.N8.430-500.Z2.CC16
				B3224.N8.430-500.Z2.CC12 B3224.N8.430-500.Z2.CC16
				B3220.C8.500-570.Z2.CC12 B3220.C8.500-570.Z2.CC16
				B3224.C8.500-570.Z2.CC12 B3224.C8.500-570.Z2.CC16
				B3220.N8.500-570.Z2.CC12 B3220.N8.500-570.Z2.CC16
				B3224.N8.500-570.Z2.CC12 B3224.N8.500-570.Z2.CC16
				B3220.C8.570-640.Z2.CC12 B3220.C8.570-640.Z2.CC16
				B3224.C8.570-640.Z2.CC12 B3224.C8.570-640.Z2.CC16
				B3220.N8.570-640.Z2.CC12 B3220.N8.570-640.Z2.CC16
				B 3224.N8.570-640.Z2.CC12 B 3224.N8.570-640.Z2.CC16

B2

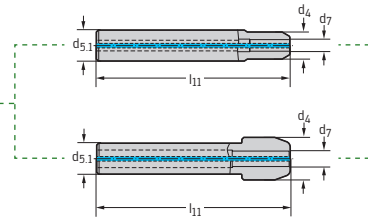
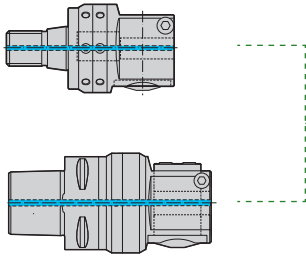
Precision boring tool B3230 / B4030

Walter Precision^{MINI}

D_c 2,0-9,5	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●		
B4030	●	●	●	●	●	●	●

Basic body
Extension


B2

Tool	Basic body Designation	d_1 mm	D_c mm	Designation	d_7 mm	d_4 mm	$d_{5.1}$ mm	l_{11} mm	
ScrewFit 	B4030G.T45.02-20.Z1 Balanceable	T45	2,0-3,5	EB501	4	12	12	85	
			3,0-6,0						
			5,8-7,5	EB502	5	12	12	85	
			7,3-9,5	EB503	6	22	12	85	
Walter Capto™ 	B3230G.C6.02-45.Z1 Standard B4030G.C6.02-45.Z1 Balanceable	C6	2,0-3,5	EB101	4	12	16	100	
			3,0-6,0						
			5,8-7,5	EB102	5	13	16	100	
			7,3-9,5	EB103	6	14	16	100	

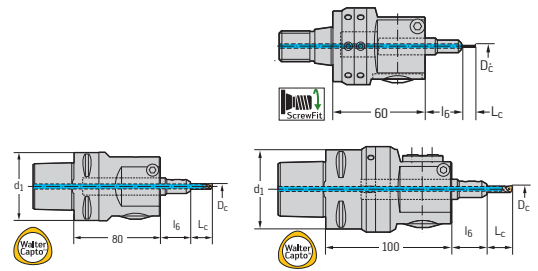
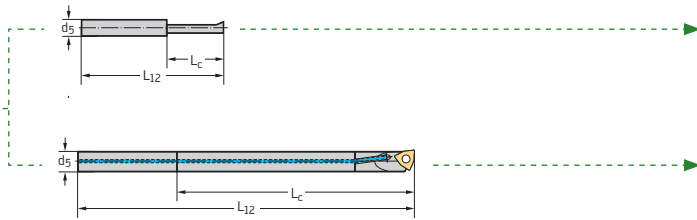
For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Designation	$d_1 = T45$		$d_1 = C6$	
		Designation	Tightening torque	Designation	Tightening torque
	Clamping screw for basic body	FS1084 (SW 4)	6,0 Nm	FS1085 (SW 5)	10 Nm
	Clamping screw for extension	FS2039 (SW 4)	5,0 Nm	FS2040 (SW 5)	10 Nm
	Clamping screw for extension	FS1110 (SW 2)	1,0 Nm	FS1110 (SW 2)	1,0 Nm
	Clamping screw for indexable insert with $D_c = 5.8-9.5$ mm	FS2245 (Torx 6IP)	0,5 Nm	FS2245 (Torx 6IP)	0,6 Nm
	Clamping screw for balancing rings	FS2037 (SW 2)		FS2246 (SW 2) for B4030	0,5 Nm



Insert holder

Complete tool

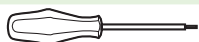


B2

Designation	d ₅ mm	L ₁₂ mm	Type	L _c min mm	L _c max mm	l ₆ mm	kg	Complete tool Designation	Complete tool, balanceable Designation
EB301 WK10*	4	30	—	9	—	30–53	0,8		B4030.T45.02-03.Z1.WK10
EB302 WK10*	4	35	—	14	—	30–53	0,8		B4030.T45.03-06.Z1.WK10
EB303.WC02.CS	5	85	WC . . 0201 . .	20	60	30–53	0,8		B4030.T45.06-07.Z1.WC02
EB304.WC02.CS	6	95	WC . . 0201 . .	20	65	30–53	0,8		B4030.T45.07-09.Z1.WC02
EB301 WK10*	4	30	—	9	—	28–60	1,8	B3230.C6.02-03.Z1.WK10	B4030.C6.02-03.Z1.WK10
EB302 WK10*	4	35	—	14	—	28–60	1,8	B3230.C6.03-06.Z1.WK10	B4030.C6.03-06.Z1.WK10
EB303.WC02.CS	5	85	WC . . 0201 . .	20	60	28–60	1,8	B3230.C6.06-07.Z1.WC02	B4030.C6.06-07.Z1.WC02
EB304.WC02.CS	6	95	WC . . 0201 . .	20	65	28–60	1,8	B3230.C6.07-09.Z1.WC02	B4030.C6.07-09.Z1.WC02

* Solid carbide boring bar
 EB . . . CS = Solid carbide shank
 Advantages: Increased rigidity, reduced deflection, neutralised vibrations

Accessories



Screwdriver for clamping screw FS2086 (Torx 6IP)



DIN 911 hex key SW 2 / SW 4 / SW 5



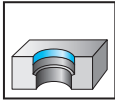
One-piece boring bar For D_c 5.8–9.5, see page B 548

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool B3230 / B4030

Walter Precision^{MINI}

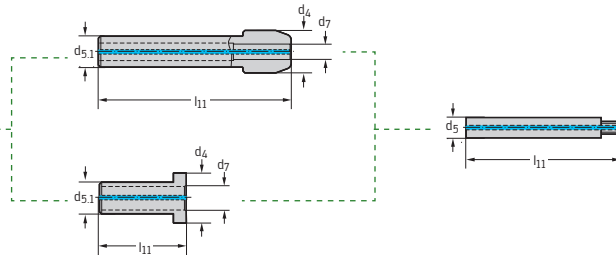
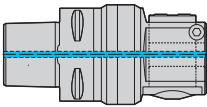
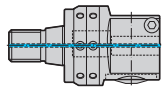
D_c 8,8–20	$\kappa=93^\circ$	Z=1
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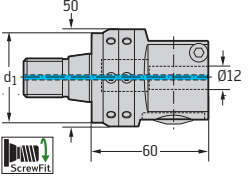

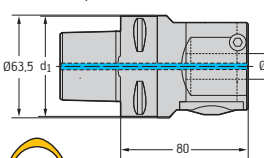
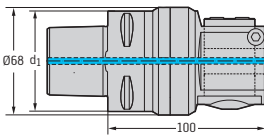
	P	M	K	N	S	H	O
B3230	●	●	●	●	●		
B4030	●	●	●	●	●	●	●

Basic body

Extension



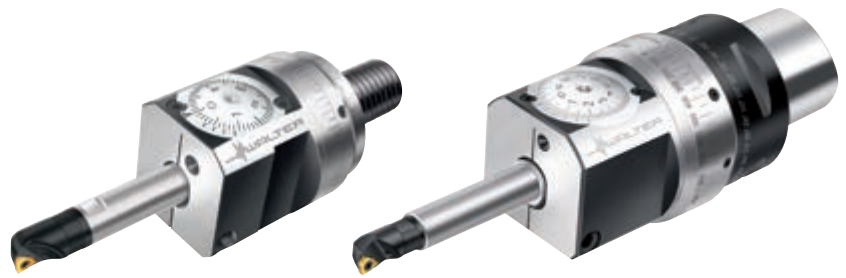
B2

Tool	Basic body Designation	d_1 mm	D_c mm	Designation	d_7 mm	d_4 mm	$d_{5,1}$ mm	l_{11} mm	Designation	d_5 mm	l_{11} mm		
ScrewFit  	B4030G.T45.02-20.Z1 Balanceable	T45	8,8–12,5	EB504	8	14	12	30	EB106	8	47		
										EB107.CS	8	87	
			11,8–14,5	EB505	10	14	12	30		EB108	10	52	
											EB109.CS	10	97
			13,8–16,5	—							EB508	12	77
											EB509.CS	12	97
Walter Capto™   	B3230G.C6.02-45.Z1 Standard B4030G.C6.02-45.Z1 Balanceable	C6	8,8–12,5	EB104	8	22	16	100	EB106	8	47		
										EB107.CS	8	87	
			11,8–14,5	EB105	10	24	16	100		EB108	10	52	
										EB109.CS	10	97	
			13,8–16,5	EB506	12	17	16	36		EB508	12	77	
										EB509.CS	12	97	
			15,8–20,0	EB507	14	17	16	36		EB510	14	87	
										EB511.CS	14	117	

EB... CS = Solid carbide shank

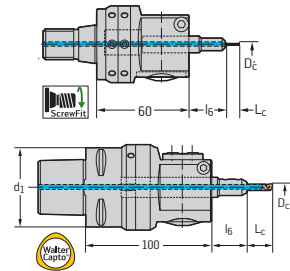
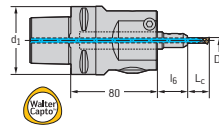
Advantages: Increased rigidity, reduced deflection, neutralised vibrations

Assembly parts	$d_1 = T45$		$d_1 = C6$		
	Designation	Tightening torque	Designation	Tightening torque	
	Clamping screw for basic body	FS1084 (SW 4)	6,0 Nm	FS1085 (SW 5)	10 Nm
	Clamping screw for extension	FS2039 (SW 4)	5,0 Nm	FS2240	10 Nm
	Clamping screw for extension	FS1110 (SW 2)	1,0 Nm	FS1111 (SW 3)	2,5 Nm
	Clamping screw for indexable insert	\emptyset 8,8–12,5 mm = FS2147 (Torx 6IP) \emptyset 11,8–20 mm = FS2148 (Torx 6IP)	0,6 Nm	\emptyset 8,8–12,5 mm = FS2147 (Torx 6IP) \emptyset 11,8–20 mm = FS2148 (Torx 6IP)	0,6 Nm
	Clamping screw for balancing rings	FS2037 (SW 2)	0,5 Nm	FS2246 (SW 2) for B4030	0,5 Nm



Insert holder

Complete tool

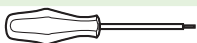


B2

Designation	l ₁₂ mm	Type	L _c min mm	L _c max mm	l ₆ mm	kg	Complete tool Designation	Complete tool, balanceable Designation
EB305.TC06	18	TC...0601...	18	33	2	0,8		B4030.T45.09-12.Z1.TC06.S*
			35	73	2	0,8		B4030.T45.09-12.Z1.TC06.L*
EB306.TC06	23	TC...0601...	23	43	2	0,8		B4030.T45.12-14.Z1.TC06.S
			45	68	2	0,8		B4030.T45.12-14.Z1.TC06.L
EB307.TC06	23	TC...0601...	45	68	—	0,8		B4030.T45.14-16.Z1.TC06.S
			65	88	—	0,9		B4030.T45.14-16.Z1.TC06.L
EB512.TC06	23	TC...0601...	45	68	—	0,8		B4030.T45.16-20.Z1.TC06.S
			65	88	—	0,9		B4030.T45.16-20.Z1.TC06.L
EB305.TC06	18	TC...0601...	20	35	34-60	1,9	B3230.C6.09-12.Z1.TC06.S*	B4030.C6.09-12.Z1.TC06.S*
			20	73	34-60	1,9	B3230.C6.09-12.Z1.TC06.L*	B4030.C6.09-12.Z1.TC06.L*
EB306.TC06	23	TC...0601...	25	45	34-60	1,9	B3230.C6.12-14.Z1.TC06.S	B4030.C6.12-14.Z1.TC06.S
			25	70	34-60	1,9	B3230.C6.12-14.Z1.TC06.L	B4030.C6.12-14.Z1.TC06.L
EB307.TC06	23	TC...0601...	34	60	2	1,9	B3230.C6.14-16.Z1.TC06.S	B4030.C6.14-16.Z1.TC06.S
			54	80	2	1,9	B3230.C6.14-16.Z1.TC06.L	B4030.C6.14-16.Z1.TC06.L
EB512.TC06	23	TC...0601...	44	70	2	1,9	B3230.C6.16-20.Z1.TC06.S	B4030.C6.16-20.Z1.TC06.S
			74	100	2	1,9	B3230.C6.16-20.Z1.TC06.L	B4030.C6.16-20.Z1.TC06.L

* When using the TC...06T1...-FN2 indexable insert, manually shorten the indexable insert clamping screw by 1 mm.

Accessories



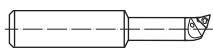
Screwdriver for clamping screw

FS2086 (Torx 6IP)



DIN 911 hex key

SW 2 / SW 4 / SW 5



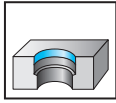
One-piece boring bar

For D_c 8.8-20, see page B 548

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool B3230 / B4030

Walter Precision^{MINI}

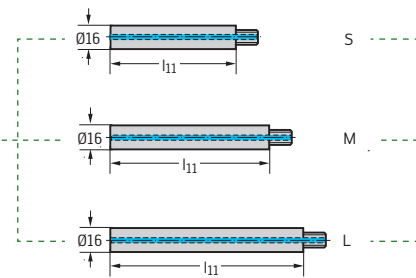
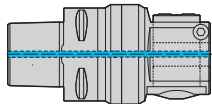


D_c 17,8– 45,5	$\kappa=93^\circ$	$Z=1$
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	P	M	K	N	S	H	O
B3230 / B4030	●	●	●	●	●	●	●

Basic body

Extension



B2

Tool	Basic body Designation	d_1 mm	D_c mm	Designation	l_{11} mm	
Walter Capto™	B3230G.C6.02-45.Z1 Standard	C6	17,8–22,5	EB110	88	(S)
				EB111.CS	108	(M)
				EB112.CS	168	(L)
			21,8–25,5	EB110	88	(S)
				EB111.CS	108	(M)
				EB112.CS	168	(L)
			24,8–28,5	EB110	88	(S)
				EB111.CS	108	(M)
				EB112.CS	168	(L)
	27,8–32,5	EB110	88	(S)		
		EB111.CS	108	(M)		
		EB112.CS	168	(L)		
	31,8–36,5	EB110	88	(S)		
		EB111.CS	108	(M)		
		EB112.CS	168	(L)		
	B4030G.C6.02-45.Z1 Balanceable	C6	35,8–40,5	EB110	88	(S)
				EB111.CS	108	(M)
				EB112.CS	168	(L)
39,8–45,5			EB110	88	(S)	
			EB111.CS	108	(M)	
			EB112.CS	168	(L)	

EB...CS = Solid carbide shank

Advantages: Increased rigidity, reduced deflection, neutralised vibrations

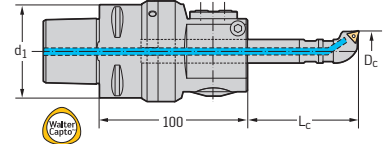
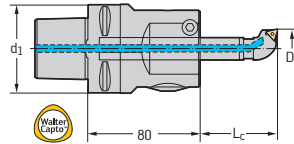
Assembly parts

		Designation	Tightening torque
	Clamping screw for basic body	FS1085 (SW 5)	10 Nm
	Clamping screw for extension	FS2040	10 Nm
	Clamping screw for indexable insert	FS1454 (Torx 8IP)	1,2 Nm
	Clamping screw for balancing rings	FS2246 for B4030	



Insert holder

Complete tool

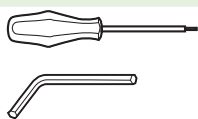


B2

Designation	l ₁₂ mm	Type	L _c min mm	L _c max mm	kg	Complete tool Designation	Complete tool, balanceable Designation
EB308.TC11	27	TC . . 1102 . .	55	80	1,8	B3230.C6.18-22.Z1.TC11.S	B4030.C6.18-22.Z1.TC11.S
			75	100	2,0	B3230.C6.18-22.Z1.TC11.M	B4030.C6.18-22.Z1.TC11.M
			135	160	2,2	B3230.C6.18-22.Z1.TC11.L	B4030.C6.18-22.Z1.TC11.L
EB309.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.22-25.Z1.TC11.S	B4030.C6.22-25.Z1.TC11.S
			75	100	2,5	B3230.C6.22-25.Z1.TC11.M	B4030.C6.22-25.Z1.TC11.M
			135	160	2,7	B3230.C6.22-25.Z1.TC11.L	B4030.C6.22-25.Z1.TC11.L
EB310.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.25-28.Z1.TC11.S	B4030.C6.25-28.Z1.TC11.S
			75	100	2,5	B3230.C6.25-28.Z1.TC11.M	B4030.C6.25-28.Z1.TC11.M
			135	160	2,7	B3230.C6.25-28.Z1.TC11.L	B4030.C6.25-28.Z1.TC11.L
EB311.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.28-32.Z1.TC11.S	B4030.C6.28-32.Z1.TC11.S
			75	100	2,5	B3230.C6.28-32.Z1.TC11.M	B4030.C6.28-32.Z1.TC11.M
			135	160	2,7	B3230.C6.28-32.Z1.TC11.L	B4030.C6.28-32.Z1.TC11.L
EB312.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.32-36.Z1.TC11.S	B4030.C6.32-36.Z1.TC11.S
			75	100	2,5	B3230.C6.32-36.Z1.TC11.M	B4030.C6.32-36.Z1.TC11.M
			135	160	2,7	B3230.C6.32-36.Z1.TC11.L	B4030.C6.32-36.Z1.TC11.L
EB313.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.36-40.Z1.TC11.S	B4030.C6.36-40.Z1.TC11.S
			75	100	2,5	B3230.C6.36-40.Z1.TC11.M	B4030.C6.36-40.Z1.TC11.M
			135	160	2,7	B3230.C6.36-40.Z1.TC11.L	B4030.C6.36-40.Z1.TC11.L
EB314.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.C6.40-45.Z1.TC11.S	B4030.C6.40-45.Z1.TC11.S
			75	100	2,5	B3230.C6.40-45.Z1.TC11.M	B4030.C6.40-45.Z1.TC11.M
			135	160	2,7	B3230.C6.40-45.Z1.TC11.L	B4030.C6.40-45.Z1.TC11.L

For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Accessories

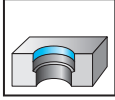


Screwdriver	FS1483 (Torx 8IP)
DIN 911 hex key	SW 5

For torque screwdriver with interchangeable blades, see page B 702.

EB . . . boring bar

κ=93°

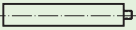


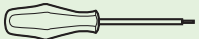


Tool

	Designation	D _c min mm	d ₅ mm	f mm	l ₁ mm	l ₅ mm	L _c mm	λ	Type
One-piece 	EB301 WK10	2,0	4	1,0	30	21			Solid carbide WK10
	EB302 WK10	3,0	4	1,5	35	21			
One-piece 	EB513	5,8	16				17		WC . . 0201 . .
	EB514.CS	5,8	16				30		
	EB515	7,3	16				21		
	EB516.CS	7,3	16				36		
	EB551	8,8	16				28		
	EB552.CS	8,8	16				47		
	EB553	11,8	16				35		
	EB554.CS	11,8	16				60		
	EB555	13,8	16				42		
	EB556.CS	13,8	16				72		
With insert holder 	EB303.WC02.CS	5,8	5	2,9	85	70			WC . . 0201 . .
	EB304.WC02.CS	7,3	6	3,65	95	75			
	EB353.TC06	8,8	8	4,5	65	47		-10°	
	EB354.TC06.CS	8,8	8	4,5	105	87		-10°	TC . . 06T1 . .
	EB355.TC06	11,8	10	6,0	75	52		-7°	
	EB356.TC06.CS	11,8	10	6,0	120	97		-7°	
	EB357.TC06	13,8	10	6,9	75	52		-5°	
	EB358.TC06.CS	13,8	10	6,9	120	97		-5°	
	EB359.TC11	17,8	16	8,9	115	88		-3°	
	EB360.TC11.CS	17,8	16	8,9	135	108		-3°	
	EB361.TC11.CS	17,8	16	8,9	195	168		-3°	
	EB362.TC11	21,8	16	10,9	115	88		-2,5°	
	EB363.TC11.CS	21,8	16	10,9	135	108		-2,5°	
	EB364.TC11.CS	21,8	16	10,9	195	168		-2,5°	TC . . 1102 . .
	EB365.TC11	24,8	16	12,4	115	88		0°	
	EB366.TC11.CS	24,8	16	12,4	135	108		0°	
	EB367.TC11.CS	24,8	16	12,4	195	168		0°	
	EB368.TC11	27,8	16	13,9	115	88		0°	
	EB369.TC11.CS	27,8	16	13,9	135	108		0°	
	EB370.TC11.CS	27,8	16	13,9	195	168		0°	
	EB371.TC11	31,8	16	15,9	115	88		0°	
	EB372.TC11.CS	31,8	16	15,9	135	108		0°	
	EB373.TC11.CS	31,8	16	15,9	195	168		0°	
	EB374.TC11	35,8	16	17,9	115	88		0°	
	EB375.TC11.CS	35,8	16	17,9	135	108		0°	
	EB376.TC11.CS	35,8	16	17,9	195	168		0°	
	EB377.TC11	39,8	16	19,9	115	88		0°	
	EB378.TC11.CS	39,8	16	19,9	135	108		0°	
	EB379.TC11.CS	39,8	16	19,9	195	168		0°	

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



Assembly parts				Accessories	
 Extension	 Insert holder	 Clamping screw for indexable insert	Tightening torque	 Screwdriver	
		FS2245 (Torx 6IP)	0,6 Nm	FS2086 (Torx 6IP)	
		FS2147 (Torx 6IP)			
		FS2148 (Torx 6IP)	0,9 Nm	FS2086 (Torx 6IP)	
—	EB303.WC02.CS	FS2245 (Torx 6IP)	0,6 Nm	FS2086 (Torx 6IP)	
—	EB304.WC02.CS				
EB106	EB305.TC06*	FS2147 (Torx 6IP)	0,6 Nm	FS2086 (Torx 6IP)	
EB107.CS	EB305.TC06*				
EB108	EB306.TC06				
EB109.CS	EB306.TC06	FS2148 (Torx 6IP)	0,9 Nm	FS2086 (Torx 6IP)	
EB108	EB307.TC06				
EB109.CS	EB307.TC06				
EB110	EB308.TC11	FS1454 (Torx 8IP)	1,2 Nm	FS1483 (Torx 8IP)	
EB111.CS	EB308.TC11				
EB112.CS	EB308.TC11				
EB110	EB309.TC11				
EB111.CS	EB309.TC11				
EB112.CS	EB309.TC11				
EB110	EB310.TC11				
EB111.CS	EB310.TC11				
EB112.CS	EB310.TC11				
EB110	EB311.TC11				
EB111.CS	EB311.TC11				
EB112.CS	EB311.TC11				
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EB110	EB313.TC11				
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EB110	EB314.TC11				
EB111.CS	EB314.TC11				
EB112.CS	EB314.TC11				

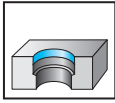
EB . . . CS = Solid carbide shank

Advantages: Increased rigidity, reduced deflection, neutralised vibrations

* When using the WC . . . 0302 . . .-PM2 indexable insert, manually shorten the indexable insert clamping screw by 1 mm.

B2

Precision boring tool B3230

Walter Precision^{MEDIUM}


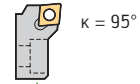
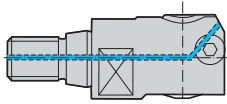
D_c 15-33	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●	●	●

Basic body




Cartridge with C insert

B2



Tool	Basic body Designation	d_1 mm	D_c mm	Cartridge no.	Designation	Type
ScrewFit 	B3230G.T14.15-21.Z1	T14	15-18,5	1		
			18-21,5	2		
	B3230G.T18.20-26.Z1	T18	20-26	1	EB321.CP05	CP .. 0502 ..
	B3230G.T22.26-33.Z1	T22	26-33	1	EB323.CP05	CP .. 0502 ..

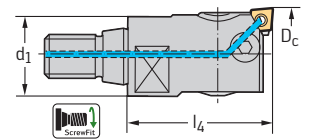
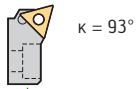
For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts	T14	T18	T22	
	15-21,5	for D_c min-max [mm]		
	20-26	26-33		
	Clamping screw for basic body Tightening torque	FS2244 (SW 1,5)	FS2251 (Torx 9IP)	FS1082 (SW 2,5) 2,0 Nm
	Clamping screw for cartridge Tightening torque	FS2066 (Torx 7IP) 0,9 Nm	FS1457 (Torx 9IP) 0,9 Nm	FS2080 (Torx 15IP) 2,0 Nm
	Clamping screw for indexable insert Tightening torque	FS2245 (Torx 6IP) 0,6 Nm	CP .. 0502 .. = FS2084 (Torx 7IP) 0,8 Nm TC .. 06T1 .. = FS2148 (Torx 6IP) 0,6 Nm	



Cartridge with W insert

Complete tool



B2

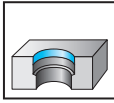
Designation	Indexable insert type	d ₁ mm	l ₄ mm	kg	Complete tool Designation with C insert	Complete tool Designation with T insert/W insert
EB549.WC02	WC . . 0201 . .	14	30	0,10		B3230.T14.15-18.Z1.WC02
EB550.WC02	WC . . 0201 . .	14	30	0,10		B3230.T14.18-21.Z1.WC02
EB341.TC06	TC . . 06T1 . .	18	35	0,10	B3230.T18.20-26.Z1.CP05	B3230.T18.20-26.Z1.TC06
EB343.TC06	TC . . 06T1 . .	22	40	0,15	B3230.T22.26-33.Z1.CP05	B3230.T22.26-33.Z1.TC06

Accessories		T14	T18	T22
		15-21,5	for D _c min-max [mm] 20-26 26-33	
	Screwdriver for clamping screw	FS2086 (Torx 6IP)	CP . . 0502 . . = FS2088 (Torx 7IP) TC . . 06T1 . . = FS2086 (Torx 6IP)	
	DIN 911 hex key for clamping screw	SW 1,5		SW 2,5
	Key for cartridge clamping	FS2088 (Torx 7IP)	FS1486 (Torx 20IP)	FS1485 (Torx 15IP)

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool B3230

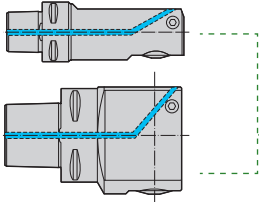
Walter Precision^{MEDIUM}



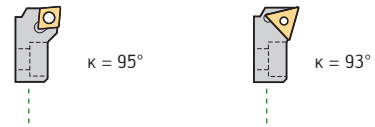
D _c 20-203	κ=95°	κ=93°	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●	●	●

Basic body



Cartridge with C and W insert



B2

Tool	Basic body Designation	d ₁ mm	D _c mm	Cartridge no.	Designation			
						Type	Designation	
Walter Capto™ 	B3230G.C3.20-38.Z1	C3	20-26,5	1	EB321.CP05	CP .. 0502 ..	EB341.TC06	TC .. 06T1 ..
			(28) ¹ 26-32,5*	2	EB523.CP05		EB536.TC06	
			32-38,5*	3	EB524.CP05		EB537.TC06	
	B3230G.C3.26-47.Z1	C3	26-33,5	1	EB323.CP05	CP .. 0502 ..	EB343.TC06	TC .. 06T1 ..
			(34) ¹ 33-40,5*	2	EB525.CP05		EB538.TC06	
			40-47,5*	3	EB526.CP05		EB539.TC06	
	B3230G.C3.33-57.Z1	C3	33-41,5	1	EB325.CP05	CP .. 0502 ..	EB345.TC06	TC .. 06T1 ..
			41-49,5*	2	EB527.CP05		EB540.TC06	
			49-57,5*	3	EB528.CP05		EB541.TC06	
	B3230G.C4.41-83.Z1	C4	41-55,5	1	EB327.CC06	CC .. 0602 ..	EB347.TC06	TC .. 06T1 ..
			55-69,5*	2	EB532.CC06		EB545.TC06	
			69-83,5*	3	EB533.CC06		EB546.TC06	
B3230G.C5.55-100.Z1	C5	55-70,5	1	EB329.CC06	CC .. 0602 ..	EB349.TC11	TC .. 1102 ..	
		70-85,5*	2	EB534.CC06		EB547.TC11		
		85-100,5*	3	EB535.CC06		EB548.TC11		
B3230G.C6.070-120.Z1	C6	70-90,5	1	EB329.CC06	CC .. 0602 ..	EB349.TC11	TC .. 1102 ..	
		85-105,5*	2	EB534.CC06		EB547.TC11		
		100-120,5*	3	EB535.CC06		EB548.TC11		
B3230G.C6.090-166.Z1	C6	90-116*	1	EB529.CC06	CC .. 0602 ..	EB542.TC11	TC .. 1102 ..	
		115-141*	2	EB530.CC06		EB543.TC11		
		140-166*	3	EB531.CC06		EB544.TC11		
B3230G.C8.090-166.Z1	C8	90-116*	1	EB529.CC06	CC .. 0602 ..	EB542.TC11	TC .. 1102 ..	
		115-141*	2	EB530.CC06		EB543.TC11		
		140-166*	3	EB531.CC06		EB544.TC11		
B3230G.C6.110-203.Z1	C6	110-153*	1	EB529.CC06	CC .. 0602 ..	EB542.TC11	TC .. 1102 ..	
		135-178*	2	EB530.CC06		EB543.TC11		
		160-203*	3	EB531.CC06		EB544.TC11		
B3230G.C8.110-203.Z1	C8	110-153*	1	EB529.CC06	CC .. 0602 ..	EB542.TC11	TC .. 1102 ..	
		135-178*	2	EB530.CC06		EB543.TC11		
		160-203*	3	EB531.CC06		EB544.TC11		

¹ D_{min} for reverse machining.

For assembly aids, see page D 1.

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

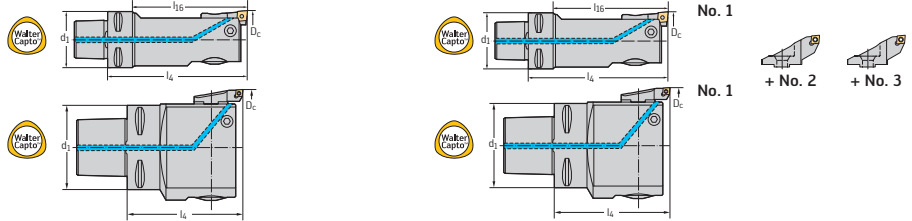
* Reverse machining possible

Assembly parts		for D _c min-max [mm]							
		C3		C4		C5		C6 / C8	
		20-38,5	26-47,5	33-57,5	41-83,5	55-100,5	70-120,5	90-203	
	Clamping screw	FS2251 (Torx 9IP)	FS1082 (SW 2,5)	FS1083 (SW 3)	FS1084 (SW 4)	FS1085 (SW 5)	FS1086 (SW 6)	FS1087 (SW 6)	
	Tightening torque		2,5 Nm	2,5 Nm	4,0 Nm	10,0 Nm	25,0 Nm	25,0 Nm	
	Clamping screw for cartridge	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1495 (Torx 20IP)	FS1091 (SW 3)	FS1092 (SW 5)	FS1092 (SW 5)	FS2150 (Torx 30IP)	
	Tightening torque	1,5 Nm	2,5 Nm	5,0 Nm	2,5 Nm	12,0 Nm	12,0 Nm	10,0 Nm	
	Clamping screw for indexable insert	CP .. 0502 .. = FS2084 (Torx 7IP) 0,8 Nm				FS1454 (Torx 8IP) 1,2 Nm			
	Tightening torque	TC .. 06T1 .. = FS2148 (Torx 6IP) 0,6 Nm							



Complete tool

Precision set

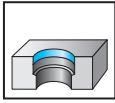


B2

	d ₁ mm	l ₄ mm	l ₁₆ mm	kg	Complete tool Designation with C insert	Complete tool Designation with W insert	Precision set Designation with C insert	Precision set Designation with T insert
	32	80	60	0,23	B3230.C3.020-026.Z1.CP05	B3230.C3.020-026.Z1.TC06	B3230.C3.020-038.Z1.CP05	B3230.C3.020-038.Z1.TC06
0,23				B3230.C3.026-032.Z1.CP05	B3230.C3.026-032.Z1.TC06			
0,24				B3230.C3.032-038.Z1.CP05	B3230.C3.032-038.Z1.TC06			
	32	80		0,29	B3230.C3.026-033.Z1.CP05	B3230.C3.026-033.Z1.TC06	B3230.C3.026-047.Z1.CP05	B3230.C3.026-047.Z1.TC06
0,30				B3230.C3.033-040.Z1.CP05	B3230.C3.033-040.Z1.TC06			
0,30				B3230.C3.040-047.Z1.CP05	B3230.C3.040-047.Z1.TC06			
0,42				B3230.C3.033-041.Z1.CP05	B3230.C3.033-041.Z1.TC06			
	32	80		0,42	B3230.C3.041-049.Z1.CP05	B3230.C3.041-049.Z1.TC06	B3230.C3.033-057.Z1.CP05	B3230.C3.033-057.Z1.TC06
0,42				B3230.C3.049-057.Z1.CP05	B3230.C3.049-057.Z1.TC06			
0,7				B3230.C4.041-055.Z1.CC06	B3230.C4.041-055.Z1.TC06			
	40	80		0,7	B3230.C4.055-069.Z1.CC06	B3230.C4.055-069.Z1.TC06	B3230.C4.041-083.Z1.CC06	B3230.C4.041-083.Z1.TC06
0,7				B3230.C4.069-083.Z1.CC06	B3230.C4.069-083.Z1.TC06			
1,4				B3230.C5.055-070.Z1.CC06	B3230.C5.055-070.Z1.TC11			
	50	100		1,4	B3230.C5.070-085.Z1.CC06	B3230.C5.070-085.Z1.TC11	B3230.C5.055-100.Z1.CC06	B3230.C5.055-100.Z1.TC11
1,4				B3230.C5.085-100.Z1.CC06	B3230.C5.085-100.Z1.TC11			
2,1				B3230.C6.070-090.Z1.CC06	B3230.C6.070-090.Z1.TC11			
	63	100		2,2	B3230.C6.085-105.Z1.CC06	B3230.C6.085-105.Z1.TC11	B3230.C6.070-120.Z1.CC06	B3230.C6.070-120.Z1.TC11
2,1				B3230.C6.100-120.Z1.CC06	B3230.C6.100-120.Z1.TC11			
3,2				B3230.C6.090-116.Z1.CC06	B3230.C6.090-116.Z1.TC11			
	63	110		3,2	B3230.C6.115-141.Z1.CC06	B3230.C6.115-141.Z1.TC11	B3230.C6.090-166.Z1.CC06	B3230.C6.090-166.Z1.TC11
3,2				B3230.C6.140-166.Z1.CC06	B3230.C6.140-166.Z1.TC11			
4,0				B3230.C8.090-116.Z1.CC06	B3230.C8.090-116.Z1.TC11			
	80	110		4,0	B3230.C8.115-141.Z1.CC06	B3230.C8.115-141.Z1.TC11	B3230.C8.090-166.Z1.CC06	B3230.C8.090-166.Z1.TC11
4,0				B3230.C8.140-166.Z1.CC06	B3230.C8.140-166.Z1.TC11			
4,1				B3230.C6.110-153.Z1.CC06	B3230.C6.110-153.Z1.TC11			
	63	110		4,1	B3230.C6.135-178.Z1.CC06	B3230.C6.135-178.Z1.TC11	B3230.C6.110-203.Z1.CC06	B3230.C6.110-203.Z1.TC11
4,1				B3230.C6.160-203.Z1.CC06	B3230.C6.160-203.Z1.TC11			
4,8				B3230.C8.110-153.Z1.CC06	B3230.C8.110-153.Z1.TC11			
	63	110		4,8	B3230.C8.135-178.Z1.CC06	B3230.C8.135-178.Z1.TC11	B3230.C8.110-203.Z1.CC06	B3230.C8.110-203.Z1.TC11
4,8				B3230.C8.160-203.Z1.CC06	B3230.C8.160-203.Z1.TC11			

Accessories	C3							C4		C5		C6		C6 / C8	
	for D _c min-max [mm]														
	20-38,5		26-47,5		33-57,5		41-83,5		55-100,5		70-120,5		90-203		
	Screwdriver for clamping screw		CP . . 0502 . . = FS2088 (Torx 7IP) TC . . 06T1 . . = FS2086 (Torx 6IP)				CC . . 06 = FS1483 (Torx 8IP) TC . . 1102 . . = FS1483 (Torx 8IP)								
	Screwdriver for clamping screw		FS1484 (Torx 9IP)												
	DIN 911 hex key for clamping screw				SW 2,5		SW 3		SW 4		SW 5		SW 6		
	Key for cartridge clamping		FS1484 (Torx 9IP)		FS1485 (Torx 15IP)		FS1486 (Torx 20IP)						FS2109 (Torx 30IP)		
	DIN 911 hex key for cartridge clamping								SW 3		SW 5		SW 5		

Self-balancing precision boring tool B4030

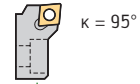
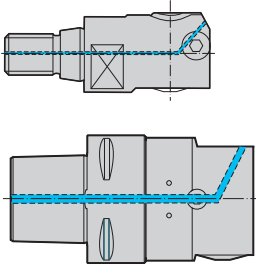
Walter Precision^{MEDIUM}


D_c 33-153	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B4030	●	●	●	●	●	●	●

Basic body

Cartridge with C insert



B2

Tool	Basic body Designation	d_1 mm	D_c mm	Designation	Type
ScrewFit 	B4030G.T28.33-41.Z1	T 28	33-41	EB323.CP 05	CP . . 0502 . .
	B4030G.T36.41-55.Z1	T 36	41-55	EB325.CP05	CP . . 0502 . .
	B4030G.T45.55-70.Z1	T 45	55-70	EB327.CC06	CC . . 0602 . .
Walter Capto™ 	B4030G.C3.33-41.Z1	C3	33-41	EB323.CP05	CP . . 0502 . .
	B4030G.C4.41-55.Z1	C4	41-55	EB325.CP05	CP . . 0502 . .
	B4030G.C5.55-70.Z1	C5	55-70	EB327.CC06	CC . . 0602 . .
	B4030G.C6.070-090.Z1	C6	70-90		
	B4030G.C6.090-110.Z1	C6	90-110		
	B4030G.C8.090-110.Z1	C8	90-110		
	B4030G.C6.110-153.Z1	C6	110-153		
	B4030G.C8.110-153.Z1	C8	110-153		

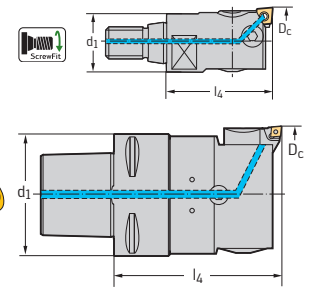
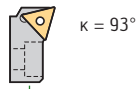
For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts	D_c min-max [mm]						
	33-41	41-55	55-70	70-90	90-110	110-153	
Clamping screw	FS2031 (SW 2,5)	FS2032 (SW 3)	FS2033 (SW 4)	FS2034 (SW 5)	FS2035 (SW 6)	FS2036 (SW 6)	
Tightening torque	2,5 Nm	3,0 Nm	6,0 Nm	12 Nm	15 Nm	15 Nm	
Clamping screw for cartridge	FS2080 (Torx 15IP)	FS1495 (Torx 20IP)	FS1091 (SW 3)				
Tightening torque	2,5 Nm	2,5 Nm	2,5 Nm				
Clamping screw for indexable insert	CP . . 0502 . . = FS2084 (Torx 7IP) 0,8 Nm		CC . . 0602 . . = FS1454 (Torx 8IP) 0,8 Nm				
Tightening torque	TC . . 06T1 . . = FS2148 (Torx 6IP) 0,6 Nm		TC . . 06T1 . . = FS2148 (Torx 6IP) 0,6 Nm				



Cartridge with W insert

Complete tool



B2

Designation	Type	d ₁ mm	l ₁ mm	kg	Complete tool, balanceable Designation with C insert	Complete tool, balanceable Designation with T insert
EB343.TC06	TC . . 06T1 . .	28	55	0,3	B4030.T28.33-41.Z1.CP05	B4030.T28.33-41.Z1.TC06
EB345.TC06	TC . . 06T1 . .	36	65	0,6	B4030.T36.41-55.Z1.CP05	B4030.T36.41-55.Z1.TC06
EB347.TC06	TC . . 06T1 . .	45	80	1,0	B4030.T45.55-70.Z1.CC06	B4030.T45.55-70.Z1.TC06
EB343.TC06	TC . . 06T1 . .	32	80	0,4	B4030.C3.033-041.Z1.CP05	B4030.C3.033-041.Z1.TC06
EB345.TC06	TC . . 06T1 . .	40	80	0,75	B4030.C4.041-055.Z1.CP05	B4030.C4.041-055.Z1.TC06
EB347.TC06	TC . . 06T1 . .	50	100	1,4	B4030.C5.055-070.Z1.CP05	B4030.C5.055-070.Z1.TC06
		63	100	1,5	B4030.C6.070-090.Z1.CC06	B4030.C6.070-090.Z1.TC06
		63	110	1,6	B4030.C6.090-110.Z1.CC06	B4030.C6.090-110.Z1.TC06
		80	110	1,6	B4030.C8.090-110.Z1.CC06	B4030.C8.090-110.Z1.TC06
		63	110	2,0	B4030.C6.110-153.Z1.CC06	B4030.C6.110-153.Z1.TC06
		80	110	2,0	B4030.C8.110-153.Z1.CC06	B4030.C8.110-153.Z1.TC06

Accessories

for D_c min-max [mm]

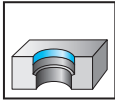
		33-41	41-55	55-70	70-90	90-153
	Screwdriver for clamping screw	CP . . 0502 . . = FS1484 (Torx 7IP) TC . . 06T1 . . = FS2086 (Torx 6IP)		CC . . 0602 . . = FS1483 (Torx 8IP) TC . . 06T1 . . = FS2086 (Torx 6IP)		
	DIN 911 hex key for clamping screw	SW 2,5	SW 3	SW 4	SW 5	SW 6
	Key for cartridge clamping	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)			
	DIN 911 hex key for cartridge clamping				SW 3	

For torque screwdriver with interchangeable blades, see page B 702.

Self-balancing precision boring tool

B4031.C

Walter Precision^{MEDIUM}



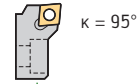
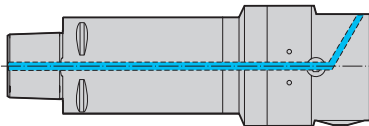
D_c 90-153	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B4031.C	●	●	●	●	●	●	●

Basic body

Cartridge with C insert

B2



Tool	Basic body Designation	d_1 mm	D_c mm	Designation	Type
Walter Capto™ 	B4031G.C6.090-110.Z1.AL*	C6	90-110	EB327.CC06	CC . . 0602 . .
	B4031G.C6.110-153.Z1.AL*	C6	110-153		

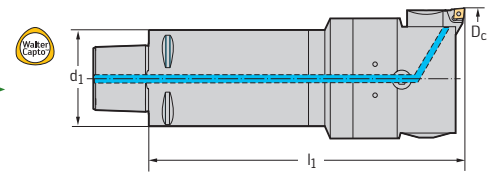
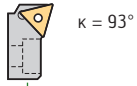
* Reduced-weight aluminium version
 For assembly aids, see page D 1.
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	D_c min-max [mm]	
	90-110	110-153
 Clamping screw Tightening torque	FS2035 (SW 6) 15 Nm	FS2036 (SW 6) 15 Nm
	Clamping screw for indexable insert CC . . 0602 . . = FS1454 (Torx 8IP) 0,8 Nm TC . . 06T1 . . = FS2148 (Torx 6IP) 0,6 Nm	



Cartridge with T insert

Complete tool



B2

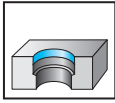
Designation	Type	d ₁ mm	l ₁ mm	kg	Complete tool Designation with C insert	Complete tool Designation with T insert
EB347.TC06	TC...06T1...	60	230	3,4	B4031.C6.090-110Z1.CC06	B4031.C6.090-110.Z1.TC06
		60	230	3,8	B4031.C6.110-153Z1.CC06	B4031.C6.110-153.Z1.TC06

Accessories		for D _c min-max [mm]	
		70-90	90-153
	Screwdriver for clamping screw	CC...0602... = FS1483 (Torx 8IP) TC...06T1... = FS2086 (Torx 6IP)	
	DIN 911 hex key for clamping screw	SW 5	SW 6

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool with bridge design B3230

Walter Precision^{MAXI}

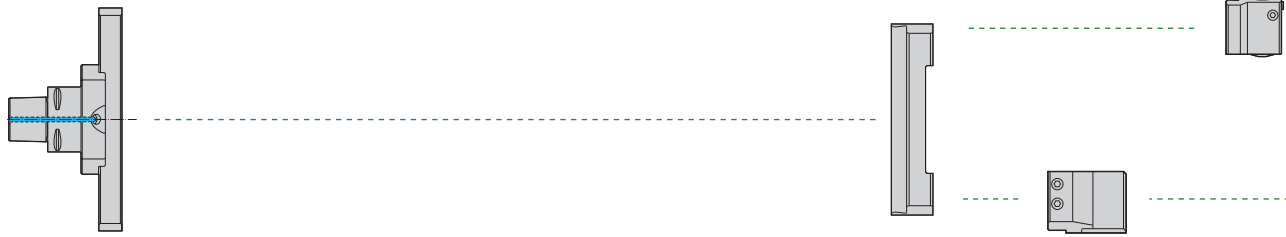


– Aluminium bridge

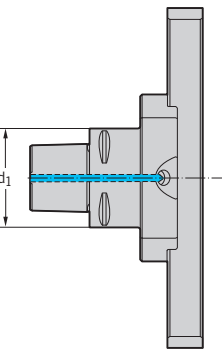
D_c 150– 640	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●	●	●

Basic body


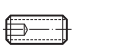



B2

Tool	Basic body Designation	d_1 mm	D_c mm	Bridge	Balance compensation	Cartridge holder
Walter Capto™ 	B3223G.C8.150-640	C8	150–220	EB134AL	EB121	EB123
			220–290	EB135AL		
			290–360	EB136AL		
			360–430	EB137AL		
			430–500	EB138AL		
			500–570	EB139AL		
			570–640	EB140AL		

For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts

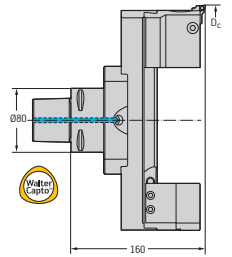
	Designation	Tightening torque
	Clamping screw for bridge FS1114 (SW 10)	120 Nm
	Clamping screw for balance compensation slide FS1086 (SW 6)	25 Nm
	Clamping screw for cartridge holder and balance compensation FS1113 (SW 6)	25 Nm
	Clamping screw for cartridge FS1092 (SW 5)	12 Nm
	Clamping screw for indexable insert FS1454 (Torx 8IP)	1,2 Nm



Cartridge with C insert

Cartridge with T insert

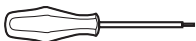
Complete tool



B2

Cartridge Designation	Type	Cartridge Designation	Type	kg	Complete tool Designation with C insert	Complete tool Designation with T insert
EB329.CC06	CC...0602...	EB349.TC11	TC...1102...	6,3	B3230.C8.150-220.Z1.CC06	B3230.C8.150-220.Z1.TC11
				6,8	B3230.C8.220-290.Z1.CC06	B3230.C8.220-290.Z1.TC11
				7,2	B3230.C8.290-360.Z1.CC06	B3230.C8.290-360.Z1.TC11
				7,5	B3230.C8.360-430.Z1.CC06	B3230.C8.360-430.Z1.TC11
				7,9	B3230.C8.430-500.Z1.CC06	B3230.C8.430-500.Z1.TC11
				8,2	B3230.C8.500-570.Z1.CC06	B3230.C8.500-570.Z1.TC11
				8,4	B3230.C8.570-640.Z1.CC06	B3230.C8.570-640.Z1.TC11

Accessories



Screwdriver for clamping screw



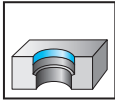
DIN 911 hex key

SW 5 / SW 6 / SW 10

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool with bridge design B3234

Walter Precision^{MAXI}



- Cutting edge orientation rotated by 90° in relation to B3230G.C...
- Aluminium bridge

D_c 150-640	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3234	●	●	●	●	●	●	●

Basic body



B2

Tool	Basic body Designation	d_1 mm	D_c mm	Bridge	Balance compensation	Cartridge holder
Walter Capto™	 B3224G.C8.150-640	C8	150-220	EB134AL	EB121	EB123
			220-290	EB135AL		
			290-360	EB136AL		
			360-430	EB137AL		
			430-500	EB138AL		
			500-570	EB139AL		
			570-640	EB140AL		

For assembly aids, see page D 1.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts

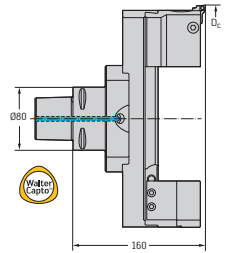
		Designation	Tightening torque
	Clamping screw for bridge	FS1114 (SW 10)	120 Nm
	Clamping screw for balance compensation slide	FS1086 (SW 6)	25 Nm
	Clamping screw for cartridge holder and balance compensation	FS1113 (SW 6)	25 Nm
	Clamping screw for cartridge	FS1092 (SW 5)	12 Nm
	Clamping screw for indexable insert	FS1454 (Torx 8IP)	1,2 Nm



Cartridge with C insert

Cartridge with T insert

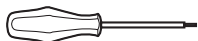
Complete tool



B2

Cartridge Designation	Type	Cartridge Designation	Type	kg	Complete tool Designation with C insert	Complete tool Designation with T insert
EB329.CC06	CCGT 06 ..	EB349.TC11	TC .. 1102 ..	6,3	B3234.C8.150-220.Z1.CC06	B3234.C8.150-220.Z1.TC11
				6,8	B3234.C8.220-290.Z1.CC06	B3234.C8.220-290.Z1.TC11
				7,2	B3234.C8.290-360.Z1.CC06	B3234.C8.290-360.Z1.TC11
				7,5	B3234.C8.360-430.Z1.CC06	B3234.C8.360-430.Z1.TC11
				7,9	B3234.C8.430-500.Z1.CC06	B3234.C8.430-500.Z1.TC11
				8,2	B3234.C8.500-570.Z1.CC06	B3234.C8.500-570.Z1.TC11
				8,4	B3234.C8.570-640.Z1.CC06	B3234.C8.570-640.Z1.TC11

Accessories



Screwdriver for clamping screw

FS1483 (Torx 8IP)



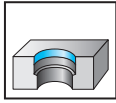
DIN 911 hex key

SW 5 / SW 6 / SW 10

For torque screwdriver with interchangeable blades, see page B 702.

Precision boring tool B3230 / B4030

Walter Precision^{MINI}

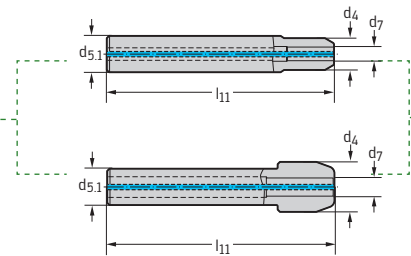
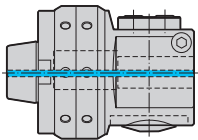


D_c 2,0-9,5	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230 / B4030	●	●	●	●	●	●	●

Basic body

Reducer



B2

Tool

Designation	d_1 mm	D mm	Designation	d_7 mm	d_4 mm	$d_{5,1}$ mm	l_{11} mm
NCT B3230G.N6.002-045.Z1 Standard	NCT63	2,0-3,5	EB101	4	12	16	100
		3,0-6,0					
 B4030G.N6.02-45.Z1 Balanceable	NCT63	5,8-7,5	EB102	5	13	16	100
		7,3-9,5					

For assembly aids, see page 215.

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

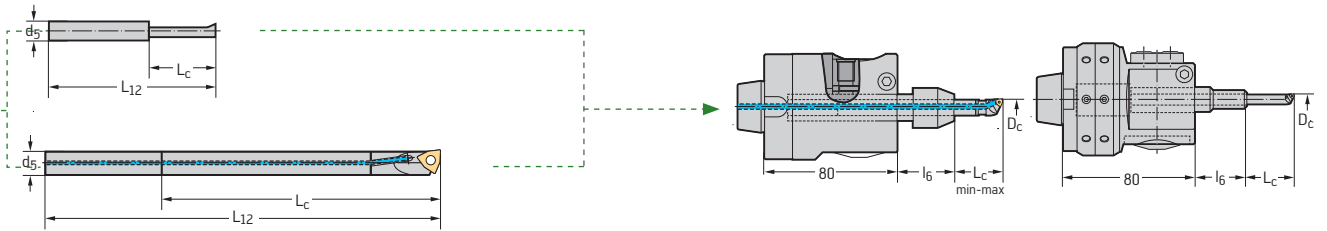
Assembly parts

	Designation	Tightening torque
	Clamping screw FS1085 (SW 5)	10 Nm
	Clamping screw for reducer FS2040	10 Nm
	Clamping screw for insert holder FS1110 (SW 2)	1,9 Nm
	Clamping screw for indexable insert with $D_c = 5.8-9.5$ mm FS2245 (Torx 6IP)	0,6 Nm
	Clamping screw for balancing rings FS2246 for B4030	0,5 Nm



Insert holder

Complete tool



B2

Designation	d ₅ mm	L ₁₂ mm	Type	L _c min mm	L _c max mm	l ₆ mm	kg	Standard Designation	Balanceable Designation
EB301 WK10*	4	30	—	9	—	28–60	1,8	B3230.N6.02-03.Z1.WK10	B4030.N6.02-03.Z1.WK10
EB302 WK10*	4	35	—	14	—	28–60	1,8	B3230.N6.03-06.Z1.WK10	B4030.N6.03-06.Z1.WK10
EB303.WC02.CS	5	85	WC ... 0201 ...	20	60	28–60	1,8	B3230.N6.06-07.Z1.WC02	B4030.N6.06-07.Z1.WC02
EB304.WC02.CS	6	95	WC ... 0201 ...	20	65	28–60	1,8	B3230.N6.07-09.Z1.WC02	B4030.N6.07-09.Z1.WC02

* Solid carbide boring bar
 EB ... CS = Solid carbide shank
 Advantages: Increased rigidity, reduced deflection, neutralised vibrations

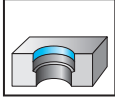
Accessories

	Screwdriver for clamping screw	FS1063 (Torx 6)
	DIN 911 hex key	SW 2 / SW 4 / SW 5
	One-piece boring bar	For D _c 5.8–9.5, see page 215

Precision boring tool B3230 / B4030

Walter Precision^{MINI}

D_c 8,8–20	$\kappa=93^\circ$	Z=1
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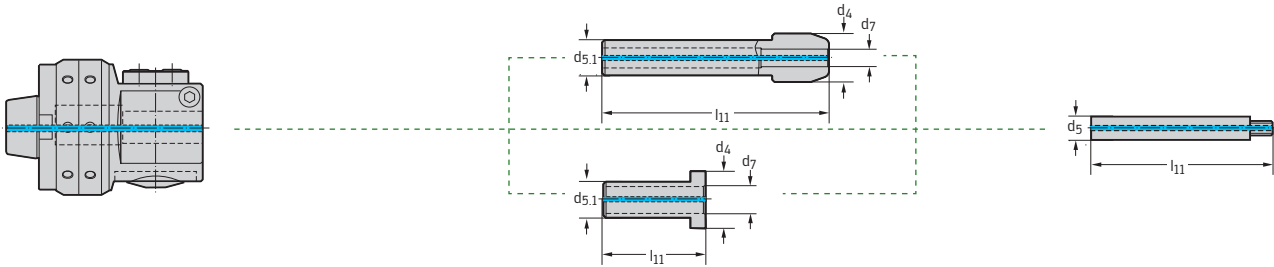


	P	M	K	N	S	H	O
B3230 / B4030	●	●	●	●	●	●	●

Basic body

Reducer

Extension



B2

Tool

Designation	d_1 mm	D_c mm	Designation	d_7 mm	d_4 mm	$d_{5.1}$ mm	l_{11} mm	Designation	d_5 mm	l_{11} mm
NCT B3230G.N6.002-045.Z1 Standard		8,8–12,5	EB104	8	22	16	100	EB106	8	47
			EB107.CS	8	87					
		11,8–14,5	EB105	10	24	16	100	EB108	10	52
			EB109.CS	10	97					
NCT63 B4030G.N6.02-45.Z1 Balanceable		13,8–16,5	EB506	12	17	16	36	EB508	12	77
			EB509.CS	12	97					
		15,8–20,0	EB507	14	17	16	36	EB510	14	87
			EB511.CS	14	117					

EB... CS = Solid carbide shank

Advantages: Increased rigidity, reduced deflection, neutralised vibrations

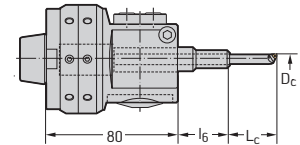
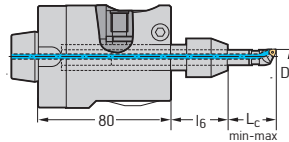
Assembly parts

	Designation	Tightening torque
	Clamping screw FS1085 (SW 5)	10 Nm
	Clamping screw for reducer FS2040	10 Nm
	Clamping screw for extension FS1111 (SW 3)	2,5 Nm
	Clamping screw for indexable insert \emptyset 8,8–12,5 mm = FS2147 (Torx 6IP) \emptyset 11,8–20 mm = FS2148 (Torx 6IP)	
	Clamping screw for balancing rings FS2246 (SW 2) for B4030	0,5 Nm



Insert holder

Complete tool



B2

Designation	l ₁₂ mm	Type	L _c min mm	L _c max mm	l ₆ mm	kg	Standard Designation	Balanceable Designation
EB305.TC06	18	TC...06T1...	20	35	34-60	1,9	B3230.N6.09-12.Z1.TC06.S*	B4030.N6.09-12.Z1.TC06.S*
			20	73	34-60	1,9	B3230.N6.09-12.Z1.TC06.L*	B4030.N6.09-12.Z1.TC06.L
EB306.TC06	23	TC...06T1...	25	45	34-60	1,9	B3230.N6.12-14.Z1.TC06.S	B4030.N6.12-14.Z1.TC06.S*
			25	70	34-60	1,9	B3230.N6.12-14.Z1.TC06.L	B4030.N6.12-14.Z1.TC06.L
EB307.TC06	23	TC...06T1...	34	60	2	1,9	B3230.N6.14-16.Z1.TC06.S	B4030.N6.14-16.Z1.TC06.S
			54	80	2	1,9	B3230.N6.14-16.Z1.TC06.L	B4030.N6.14-16.Z1.TC06.L
EB512.TC06	23	TC...06T1...	44	70	2	1,9	B3230.N6.16-20.Z1.TC06.S	B4030.N6.16-20.Z1.TC06.S
			74	100	2	1,9	B3230.N6.16-20.Z1.TC06.L	B4030.N6.16-20.Z1.TC06.L

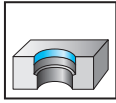
* When using the TC...06T1...-FN2 indexable insert, manually shorten the indexable insert clamping screw by 1 mm.

Accessories

	Screwdriver for clamping screw	FS2086 (Torx 6IP)
	DIN 911 hex key	SW 2 / SW 4 / SW 5
	One-piece boring bar	For D _c 8.8-15.8, see page 217

Precision boring tool B3230 / B4030

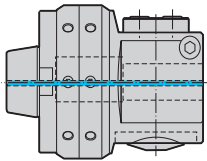
Walter Precision^{MINI}



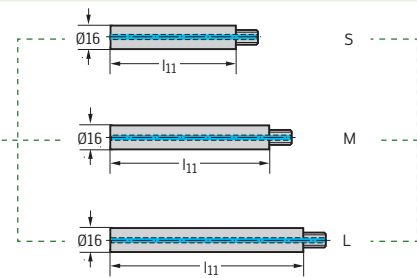
D_c 17,8– 45,5	$\kappa=93^\circ$	$Z=1$
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	P	M	K	N	S	H	O
B3230 / B4030	●	●	●	●	●	●	●

Basic body



Extension



B2

Tool	Designation	d_1 mm	D_c mm	Designation	l_{11} mm		
NCT 	B3230G.N6.02-45.Z1 Standard	NCT63	17,8–22,5	EB110	88	(S)	
				EB111.CS	108	(M)	
				EB112.CS	168	(L)	
			21,8–25,5	EB110	88	(S)	
				EB111.CS	108	(M)	
				EB112.CS	168	(L)	
	B4030G.N6.02-45.Z1 Balanceable	24,8–28,5	NCT63	27,8–32,5	EB110	88	(S)
					EB111.CS	108	(M)
					EB112.CS	168	(L)
		31,8–36,5	NCT63	31,8–36,5	EB110	88	(S)
					EB111.CS	108	(M)
					EB112.CS	168	(L)
35,8–40,5	NCT63	35,8–40,5	EB110	88	(S)		
			EB111.CS	108	(M)		
			EB112.CS	168	(L)		
39,8–45,5	NCT63	39,8–45,5	EB110	88	(S)		
			EB111.CS	108	(M)		
			EB112.CS	168	(L)		

EB...CS = Solid carbide shank

Advantages: Increased rigidity, reduced deflection, neutralised vibrations

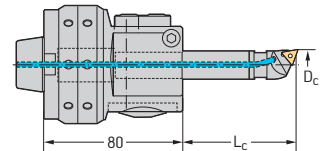
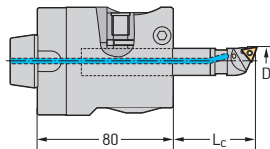
Assembly parts

	Designation	Tightening torque
	Clamping screw FS1085 (SW 5)	10 Nm
	Clamping screw for extension FS2040	10 Nm
	Clamping screw for indexable insert FS1454 (Torx 8IP)	1,2 Nm
	Clamping screw for balancing rings FS2246 (SW 2) for B4030	0,5 Nm



Insert holder

Complete tool



B2

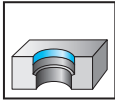
Designation	l ₁₂ mm	Type	L _c min mm	L _c max mm	kg	Standard Designation	Balanceable Designation
EB308.TC11	27	TC . . 1102 . .	55	80	1,8	B3230.N6.18-22.Z1.TC11.S	B4030.N6.18-22.Z1.TC11.S
			75	100	2,0	B3230.N6.18-22.Z1.TC11.M	B4030.N6.18-22.Z1.TC11.M
			135	160	2,2	B3230.N6.18-22.Z1.TC11.L	B4030.N6.18-22.Z1.TC11.L
EB309.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.22-25.Z1.TC11.S	B4030.N6.22-25.Z1.TC11.S
			75	100	2,5	B3230.N6.22-25.Z1.TC11.M	B4030.N6.22-25.Z1.TC11.M
			135	160	2,7	B3230.N6.22-25.Z1.TC11.L	B4030.N6.22-25.Z1.TC11.L
EB310.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.25-28.Z1.TC11.S	B4030.N6.25-28.Z1.TC11.S
			75	100	2,5	B3230.N6.25-28.Z1.TC11.M	B4030.N6.25-28.Z1.TC11.M
			135	160	2,7	B3230.N6.25-28.Z1.TC11.L	B4030.N6.25-28.Z1.TC11.L
EB311.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.28-32.Z1.TC11.S	B4030.N6.28-32.Z1.TC11.S
			75	100	2,5	B3230.N6.28-32.Z1.TC11.M	B4030.N6.28-32.Z1.TC11.M
			135	160	2,7	B3230.N6.28-32.Z1.TC11.L	B4030.N6.28-32.Z1.TC11.L
EB312.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.32-36.Z1.TC11.S	B4030.N6.32-36.Z1.TC11.S
			75	100	2,5	B3230.N6.32-36.Z1.TC11.M	B4030.N6.32-36.Z1.TC11.M
			135	160	2,7	B3230.N6.32-36.Z1.TC11.L	B4030.N6.32-36.Z1.TC11.L
EB313.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.36-40.Z1.TC11.S	B4030.N6.36-40.Z1.TC11.S
			75	100	2,5	B3230.N6.36-40.Z1.TC11.M	B4030.N6.36-40.Z1.TC11.M
			135	160	2,7	B3230.N6.36-40.Z1.TC11.L	B4030.N6.36-40.Z1.TC11.L
EB314.TC11	27	TC . . 1102 . .	55	80	2,3	B3230.N6.40-45.Z1.TC11.S	B4030.N6.40-45.Z1.TC11.S
			75	100	2,5	B3230.N6.40-45.Z1.TC11.M	B4030.N6.40-45.Z1.TC11.M
			135	160	2,7	B3230.N6.40-45.Z1.TC11.L	B4030.N6.40-45.Z1.TC11.L

For assembly aids, see page 218.
Bodies and assembly parts are included in the scope of delivery.

Accessories

	Screwdriver	FS1483 (Torx 8IP)
	DIN 911 hex key	SW 5

Precision boring tool B3230

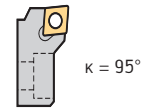
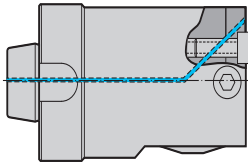
Walter Precision^{MEDIUM}


D_c 20-153	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●	●	●

Basic body

Cartridge with C insert



B2

Tool	Designation	d_1 mm	D_c mm	Designation	Type	
	NCT	B3230G.N2.020-026.Z1	NCT25	20-26	EB321.CP05	CP . . 0502 . .
		B3230G.N2.026-033.Z1	NCT25	26-33	EB323.CP05	CP . . 0502 . .
		B3230G.N3.033-041.Z1	NCT32	33-41	EB325.CP05	CP . . 0502 . .
		B3230G.N4.041-055.Z1	NCT40	41-55	EB327.CC06	CC . . 0602 . .
		B3230G.N5.055-070.Z1	NCT50	55-70	EB329.CC06	CC . . 0602 . .
		B3230G.N6.070-090.Z1	NCT63	70-90		
		B3230G.N8.090-110.Z1	NCT80	90-110		
		B3230G.N8.110-153.Z1	NCT80	110-153		

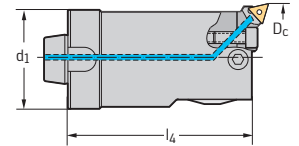
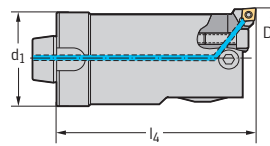
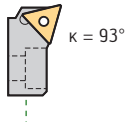
 For assembly aids, see page 221.
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		D_c min-max [mm]						
		20-26	26-33	33-41	41-55	55-70	70-90	90-153
	Clamping screw	FS2251 (Torx 9IP)	FS1082 (SW 2,5)	FS1083 (SW 3)	FS1084 (SW 4)	FS1085 (SW 5)	FS1086 (SW 6)	FS1087 (SW 6)
	Tightening torque	1,2 Nm	2,0 Nm	3,0 Nm	4,0 Nm	10,0 Nm	25,0 Nm	25,0 Nm
	Clamping screw for cartridge	FS1457 (Torx 9IP)	FS2080 (Torx 15IP)	FS1495 (Torx 20IP)	FS1091 (SW 3)	FS1092 (SW 5)		
	Tightening torque	0,9 Nm	2,0 Nm	2,5 Nm	2,5 Nm	12,0 Nm		
	Drive pin (only with NCT 25)	FK311		FK312	FK313			
	Screw for drive pin (only with NCT 25)	FS502		FS503	FS504			
	Clamping screw for indexable insert	CP . . 0502 . . = FS2084 (Torx 7IP) 0,8 Nm TC . . 06T1 . . = FS2148 (Torx 6IP) 0,6 Nm			CC . . 0602 . . = FS1454 (Torx 8IP) 1,2 Nm TC . . 06T1 . . = FS2148 (Torx 6IP) 0,6 Nm			
	Tightening torque							



Cartridge with T insert

Complete tool



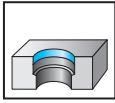
B2

Designation	Type	d ₁ mm	l ₄ mm	kg	Standard Designation with C insert	Standard Designation with T insert
EB341.TC06	TC...06T1..	25*	80	0,2	B3230.N2.020-026.Z1.CP05	B3230.N2.020-026.Z1.TC06
EB343.TC06	TC...06T1..	25	80	0,3	B3230.N2.026-033.Z1.CP05	B3230.N2.026-033.Z1.TC06
EB345.TC06	TC...06T1..	32	80	0,5	B3230.N3.033-041.Z1.CP05	B3230.N3.033-041.Z1.TC06
EB347.TC06	TC...06T1..	40	80	0,8	B3230.N4.041-055.Z1.CC06	B3230.N4.041-055.Z1.TC06
EB349.TC11	TC...1102..	50	100	1,6	B3230.N5.055-070.Z1.CC06	B3230.N5.055-070.Z1.TC11
		63	100	2,5	B3230.N6.070-090.Z1.CC06	B3230.N6.070-090.Z1.TC11
		80	100	4,0	B3230.N8.090-110.Z1.CC06	B3230.N8.090-110.Z1.TC11
		80	100	5,0	B3230.N8.110-153.Z1.CC06	B3230.N8.110-153.Z1.TC11

* Maximum drilling depth = 65 mm

Accessories		for D _c min-max [mm]					
		20-26	26-33	33-41	41-55	55-70	70-153
	Screwdriver for clamping screw	CP...0502... = FS2088 (Torx 7IP) TC...06T1... = FS2086 (Torx 6IP)			CC...0602... = FS1483 Torx 8IP TC...06T1... = FS2086 (Torx 6IP)		
	Torx key for clamping screw	FS1484 (Torx 9IP)					
	DIN 911 hex key for clamping screw		SW 2,5	SW 3	SW 4	SW 5	SW 6
	Key for cartridge clamping	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)			FS2108 (Torx 30IP)
	DIN 911 hex key for cartridge clamping				SW 3	SW 5	SW 5

Self-balancing precision boring tool B4030

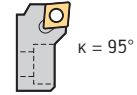
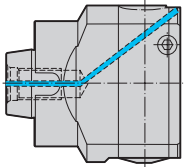
Walter Precision^{MEDIUM}


D_c 70-153	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B4030	●	●	●	●	●		●

Basic body

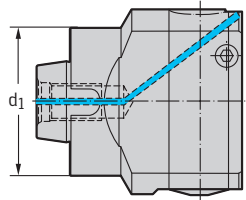
Cartridge with C insert



B2

Tool

NCT



Designation	d_1 mm	D_c mm	Designation	Type
B4030G.N6.070-090.Z1	NCT63	70-90		
B4030G.N8.090-110.Z1*	NCT80	90-110	EB327.CC06	CC...0602...
B4030G.N8.110-153.Z1*	NCT80	110-153		

* Aluminium design

For assembly aids, see page 223.

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

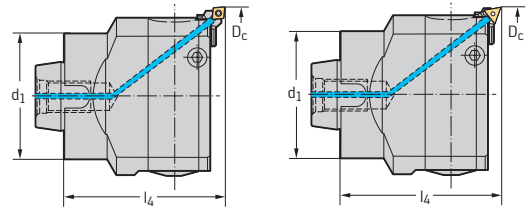
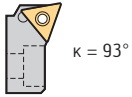
Assembly parts
 D_c min-max [mm]

		33-41	41-55	55-70	70-90	90-110	110-153
	Clamping screw	FS2031 (SW 2,5)	FS2032 (SW 3)	FS2033 (SW 4)	FS2034 (SW 5)	FS2035 (SW 6)	FS2036 (SW 6)
	Tightening torque	2,5 Nm	3,0 Nm	6,0 Nm	10 Nm	12 Nm	12 Nm
	Clamping screw for cartridge	FS2080 (Torx 15IP)	FS1495 (Torx 20IP)	FS1091 (SW 3)			
	Tightening torque	2,5 Nm	2,5 Nm	2,5 Nm			
	Clamping screw for indexable insert	CC...0602... = FS1454 (Torx 8IP) 1,2 Nm					
	Tightening torque	TC...06T1... = FS2148 (Torx 6IP) 0,6 Nm					



Cartridge with T insert

Complete tool



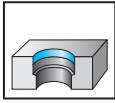
B2

Designation	Type	d ₁ mm	l ₄ mm	kg	Designation with C insert	Designation with T insert
EB347.TC06	TC...06T1...	63	100	2,5	B4030.N6.070-090.Z1.CC06	B4030.N6.070-090.Z1.TC06
		80	100	1,6	B4030.N8.090-110.Z1.CC06	B4030.N8.090-110.Z1.TC06
		80	100	2,0	B4030.N8.110-153.Z1.CC06	B4030.N8.110-153.Z1.TC06

Accessories		for D _c min-max [mm]				
		33-41	41-55	55-70	70-90	90-153
	Screwdriver for clamping screw	CC...0602... = FS1483 (Torx 8IP) TC...06T1... = FS2086 (Torx 6IP)				
	DIN 911 hex key for clamping screw	SW 2,5	SW 3	SW 4	SW 5	SW 6
	Key for cartridge clamping	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)			
	DIN 911 hex key for cartridge clamping				SW 3	

Precision boring tool with bridge design B3230

Walter Precision^{MAXI}

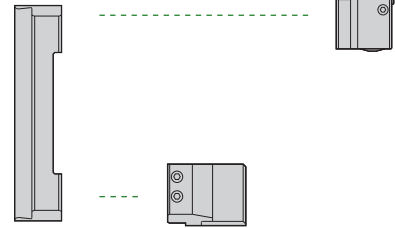
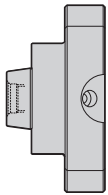


– 0.01 mm adjustment accuracy

D_c 150– 640	$\kappa=95^\circ$	$\kappa=93^\circ$	Z=1
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	P	M	K	N	S	H	O
B3230	●	●	●	●	●	●	●

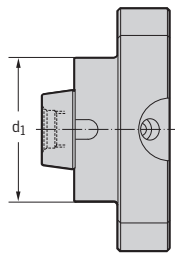
Basic body



B2

Tool

NCT



Designation	d_1 mm	D_c mm	Bridge	Balance compensation	Cartridge holder
B3223G.N8.150-640	NCT80	150–220	EB 124	EB121	EB123
		220–290	EB 125		
		290–360	EB 126		
		360–430	EB 127		
		430–500	EB 128		
		500–570	EB 129		
		570–640	EB 130		

For assembly aids, see page 225.

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

Assembly parts

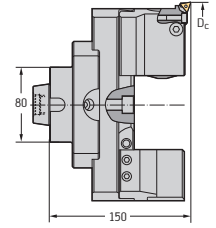
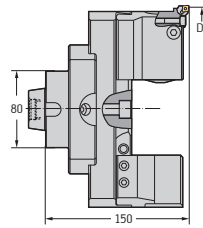
	Designation	Tightening torque
	Clamping screw for bridge FS1114 (SW 10)	120 Nm
	Clamping screw for balance compensation slide FS1086 (SW 6)	25 Nm
	Clamping screw for cartridge holder and balance compensation FS1113 (SW 6)	15 Nm
	Clamping screw for cartridge FS1092 (SW 5)	12 Nm
	Clamping screw for indexable insert FS1454 (Torx 8IP)	1,2 Nm



Cartridge with C insert

Cartridge with W insert

Complete tool



B2

Designation	Type	Designation	Type	Standard Designation with C insert	Standard Designation with T insert	
EB329.CC06	CCGT 06 ..	EB 349.TC11	TC .. 1102 ..	7,9	B3230.N8.150-220.Z1.CC06	B3230.N8.150-220.Z1.TC11
				9,2	B3230.N8.220-290.Z1.CC06	B3230.N8.220-290.Z1.TC11
				10,5	B3230.N8.290-360.Z1.CC06	B3230.N8.290-360.Z1.TC11
				11,7	B3230.N8.360-430.Z1.CC06	B3230.N8.360-430.Z1.TC11
				13,0	B3230.N8.430-500.Z1.CC06	B3230.N8.430-500.Z1.TC11
				14,3	B3230.N8.500-570.Z1.CC06	B3230.N8.500-570.Z1.TC11
				15,5	B3230.N8.570-640.Z1.CC06	B3230.N8.570-640.Z1.TC11

Accessories



Screwdriver for clamping screw

FS1483 (Torx 8IP)

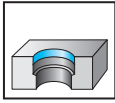


DIN 911 hex key

SW 5 / SW 6 / SW 10

Precision boring tool with bridge design B3234

Walter Precision^{MAXI}

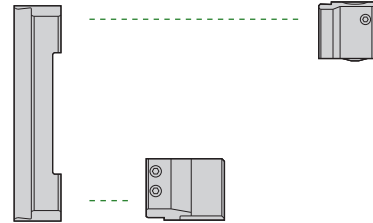
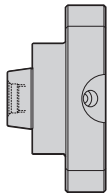


- 0.01 mm adjustment accuracy
- Cutting edge orientation rotated by 90° in relation to B3230

D _c 150- 640	κ=95°	κ=93°	Z=1
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	P	M	K	N	S	H	O
B3224	●	●	●	●	●	●	●

Basic body



B2

Tool

Designation	d ₁ mm	D _c mm	Bridge	Balance compensation	Cartridge holder
NCT B3224G.N8.150-640	NCT80	150-220	EB124	EB121	EB123
		220-290	EB125		
		290-360	EB126		
		360-430	EB127		
		430-500	EB128		
		500-570	EB129		
		570-640	EB130		

For assembly aids, see page 226.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	Designation	Tightening torque
	Clamping screw for bridge FS1114 (SW 10)	120 Nm
	Clamping screw for balance compensation slide FS1086 (SW 6)	25 Nm
	Clamping screw for cartridge holder and balance compensation FS1113 (SW 6)	15 Nm
	Clamping screw for cartridge FS1092 (SW 5)	12 Nm
	Clamping screw for indexable insert FS1454 (Torx 8IP)	1,2 Nm



Cartridge with C insert

Cartridge with T insert

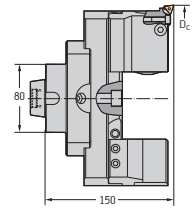
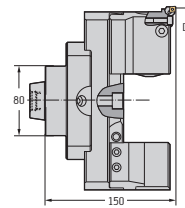
Complete tool



$\kappa = 95^\circ$



$\kappa = 93^\circ$



B2

Designation	Type	Designation	Type	kg	Standard Designation with C insert	Standard Designation with T insert
EB329.CC06	CCGT 06 ..	EB349.TC11	TC .. 1102 ..	7,9	B3234.N8.150-220.Z1.CC06	B3234.N8.150-220.Z1.TC11
				9,2	B3234.N8.220-290.Z1.CC06	B3234.N8.220-290.Z1.TC11
				10,5	B3234.N8.290-360.Z1.CC06	B3234.N8.290-360.Z1.TC11
				11,7	B3234.N8.360-430.Z1.CC06	B3234.N8.360-430.Z1.TC11
				13,0	B3234.N8.430-500.Z1.CC06	B3234.N8.430-500.Z1.TC11
				14,3	B3234.N8.500-570.Z1.CC06	B3234.N8.500-570.Z1.TC11
				15,5	B3234.N8.570-640.Z1.CC06	B3234.N8.570-640.Z1.TC11

Accessories



Screwdriver for clamping screw

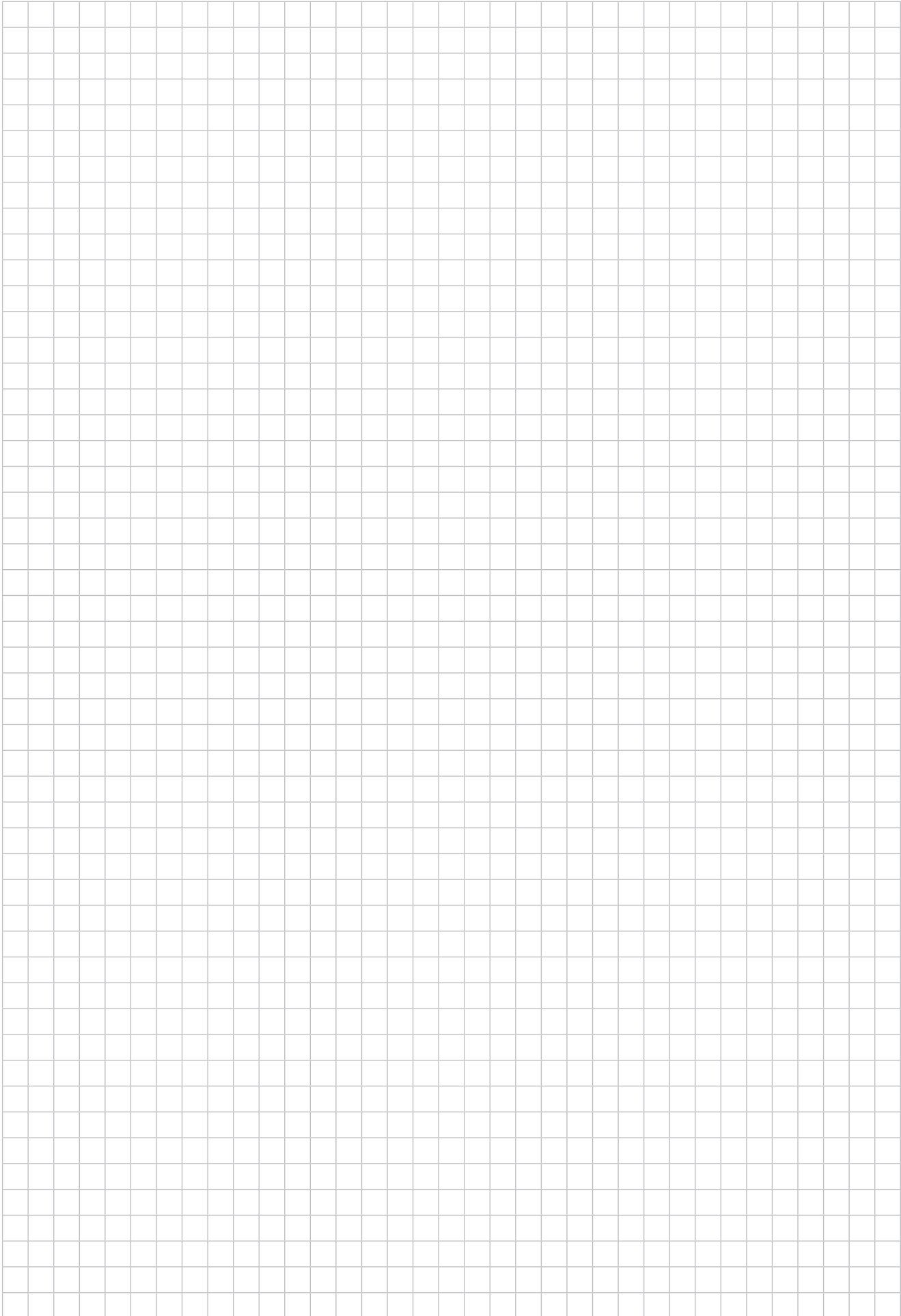
FS1483 (Torx 8IP)



DIN 911 hex key

SW 5 / SW 6 / SW 10

B2



Cartridges product range overview

Machining	Boring and counterboring							
Lead angle κ [°]	45°			75°				
Designation	PSSN R/L			PSKN R/L				
Standard	ISO 5611							
D _c min [mm]	50			40/50/60/70/100				
Page	426			427				
Machining	Boring and counterboring							
Lead angle κ [°]	90°/95°							
Designation	PCFN R/L	PTFN R/L	STFC R/L	PCLN R/L				
Standard	ISO 5611							
D _c min [mm]	50	50	25/40	50				
Page	428	429	430	431				
Machining	Precision boring							
Lead angle κ [°]	90°				95°			
Designation	FR/FL 710	FR/FL 709	FR 760	FR 761	FR/FL 711	FR/FL 717	FR 763	
Standard	Walter							
Adjustment accuracy [mm]	0,01		0,002		0,01		0,002	
D _c min [mm]	28	36	28		28			
Page	432	432	432	432	433	433	433	

B2

ISO cartridges

 PCFN


B2

Tool	Designation	h_1 mm	b mm	$D_{c \min}$ mm	d_8 mm	l_{13} mm	f mm	h mm	l_1 mm	l_5 mm	t mm	Type
	PCFNR12CA-12	12	13,3	50	7	20	20	20	47	32	6	CN .. 1204 ..

Measured with master insert: CN .. 120408
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	CN .. 1204 ..
	Lever	KN109
	Clamping screw for indexable insert Tightening torque	FS332 (SW 2,5) 2,5 Nm
	Adjusting screw, axial	FS335
	Adjusting screw, radial	FS334
	Fastening screw	FS977 (Torx 30)

Accessories	Type	CN .. 1204 ..
	ISO 2936 key	ISO2936-2,5 (SW 2,5)
	Handle key	FS1175 (Torx 30)

ISO cartridges

PCLN



Tool	Designation	h ₁ mm	b mm	D _{c min} mm	d ₈ mm	l ₁₃ mm	f mm	h mm	l ₁ mm	l ₅ mm	t mm	Type	
	PCLNR/L12CA-12	12	16	50	7	20	20	20	55	28	6	CN .. 1204 ..	
	PCLNR/L16CA-12	16	20	60	9	25	25	25	63	35	0		
	PCLNR/L20CA-16	20	20	70	9	30	25	30	70	40	0		CN .. 1606 ..
	PCLNR25CA-19	25	25	100	11	30	32	33	90	62	0		CN .. 1906 ..

Measured with master insert: CN .. 120408 / CN .. 160612 / CN .. 190612
 Ordering example, right-hand tool: PCLNR12CA-12/ordering example, left-hand tool: PCLNL12CA-12
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type h ₁ [mm]	CN .. 1204 .. 12	CN .. 1204 .. 16	CN .. 1204 .. / CN .. 1606 .. 20	CN .. 1906 .. 25
	Lever	KN109	KN121	KN104	KN106
	Shim for radius		AP134-CN1216 r ≤ 1,6 mm	AP135-CN1624 r ≤ 2,4 mm	AP136-CN1924 r ≤ 2,4 mm
	Clamping screw for indexable insert Tightening torque	FS332 (SW 2,5) 2,5 Nm	FS2129 (SW 3) 5,0 Nm	FS354 (SW 3) 5,0 Nm	FS356 (SW 4) 10,0 Nm
	Shim pin		RS102	RS103	RS104
	Tapered assembly pin		MD101	MD102	MD102
	Adjusting screw, axial	FS335	FS338	FS339	FS2575
	Adjusting screw, radial	FS334	FS337	FS337	FS974 (SW 3)
	Fastening screw	FS977 (Torx 30)	FS975 (Torx 40)	FS975 (Torx 40)	FS2578 (Torx 45)

Accessories	Type h ₁ [mm]	CN .. 1204 .. 12	CN .. 1204 .. 16-20	CN .. 1606 .. 20	CN .. 1906 .. 25
	ISO 2936 key	ISO2936-2.5 (SW 2.5)	ISO2936-3 (SW 3)	ISO2936-3 (SW 3)	ISO2936-4 (SW 4)
	Handle key	FS1175 (Torx 30)	FS1176 (Torx 40)	FS1176 (Torx 40)	FS2577 (Torx 45)

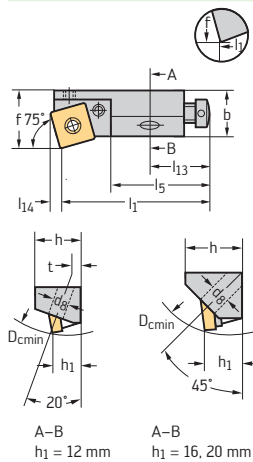
B2

ISO cartridges

 PSKN mm


B2

Tool



Designation	l_{14} mm	h_1 mm	b mm	$D_{c \text{ min}}$ mm	d_8 mm	l_{13} mm	f mm	h mm	l_1 mm	l_5 mm	t mm	Type
PSKNR10CA-09	2,2	10	10	40	7	20	14	15	44	17	5	SN .. 0903 ..
PSKNR/L12CA-12	3,1	12	16	50	7	20	20	20	55	32	6	SN .. 1204 ..
PSKNR/L16CA-12	3,1	16	20	60	9	25	25	25	63	37	0	
PSKNR/L20CA-15	3,8	20	20	70	9	30	25	30	70	40	0	SN .. 1506 ..
PSKNR25CA-19	4,6	25	25	100	11	30	32	33	90	63	0	SN .. 1906 ..

Measured with master insert: SN .. 090308 / SN .. 120408 / SN .. 150612 / SN .. 190612
 Ordering example, right-hand tool: PSKNR12CA-12/ordering example, left-hand tool: PSKNL12CA-12
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type h_1 [mm]	SN .. 0903 .. 10	SN .. 1204 .. 12	SN .. 1204 .. 16	SN .. 1506 .. 20	SN .. 1906 .. 25
Shim for radius				AP141-SN1216 $r \leq 1,6$ mm	AP142-SN1524 $r \leq 2,4$ mm	AP143-SN1924 $r \leq 2,4$ mm
Lever		KN126	KN109	KN121	KN104	KN106
Clamping screw for indexable insert Tightening torque		FS2182 (SW 2) 2,0 Nm	FS332 (SW 2,5) 2,5 Nm	FS2129 (SW 3) 5,0 Nm	FS354 (SW 3) 5,0 Nm	FS356 (SW 4) 10,0 Nm
Shim pin				RS102	RS103	RS104
Tapered assembly pin				MD101	MD102	MD102
Adjusting screw, axial		FS335	FS335	FS338	FS339	FS2575
Adjusting screw, radial		FS333	FS333	FS337	FS337	FS974 (SW 3)
Fastening screw		FS976 (Torx 30)	FS977 (Torx 30)	FS975 (Torx 40)	FS975 (Torx 40)	FS2578 (Torx 45)

Accessories	Type h_1 [mm]	SN .. 0903 .. 10	SN .. 1204 .. 12	SN .. 1204 .. 16	SN .. 1506 .. 20	SN .. 1906 .. 25
ISO 2936 key		ISO2936-2 (SW 2)	ISO2936-2,5 (SW 2,5)	ISO2936-3 (SW 3)	ISO2936-3 (SW 3)	ISO2936-4 (SW 4)
Handle key		FS1175 (Torx 30)	FS1175 (Torx 30)	FS1176 (Torx 40)	FS1176 (Torx 40)	FS2577 (Torx 45)

ISO cartridges

PSSN



Tool	Designation	l_{14} mm	h_1 mm	b mm	$D_{c\ min}$ mm	d_8 mm	l_{13} mm	f mm	h mm	l_1 mm	l_5 mm	t mm	Type
	PSSNR12CA-12	8,3	12	15,5	50	7	20	20	20	38	30	6	SN .. 1204 ..

Measured with master insert: SN .. 120408
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	SN .. 1204 ..
	Lever	KN109
	Clamping screw for indexable insert Tightening torque	FS332 (SW 2,5) 2,5 Nm
	Adjusting screw, axial	FS335
	Adjusting screw, radial	FS333
	Fastening screw	FS977 (Torx 30)

Accessories	Type	SN .. 1204 ..
	ISO 2936 key	ISO2936-2,5 (SW 2,5)
	Handle key	FS1175 (Torx 30)

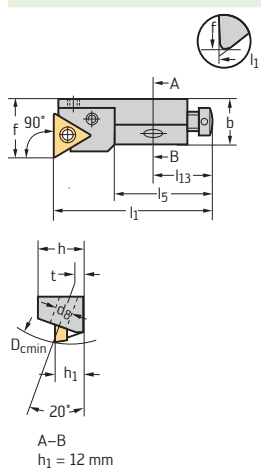
B 2

ISO cartridges

 PTFN


B2

Tool	Designation	h ₁ mm	b mm	D _{c min} mm	d ₈ mm	l ₁₃ mm	f mm	h mm	l ₁ mm	l ₅ mm	t mm	Type
	PTFNR/L12CA-16	12	15	50	7	20	20	20	55	33	6	TN .. 1604 ..
	PTFNR20CA-22	20	20	70	9	30	25	30	70	40	0	TN .. 2204 ..



Measured with master insert: TN .. 160408 / TN .. 220408
 Ordering example, right-hand tool: PTFNR12CA-16/ordering example, left-hand tool: PTFNL12CA-16
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Type	TN .. 1604 ..	TN .. 2204 ..
	Shim for radius		AP138-TN2216 r ≤ 1,6 mm
	Lever	KN108	KN102
	Clamping screw for indexable insert Tightening torque	FS331 (SW 2) 2,0 Nm	FS352 (SW 3) 5,0 Nm
	Shim pin		RS102
	Tapered assembly pin		MD101
	Adjusting screw, axial	FS335	FS338
	Adjusting screw, radial	FS333	FS337
	Fastening screw	FS977 (Torx 30)	FS977 (Torx 30)

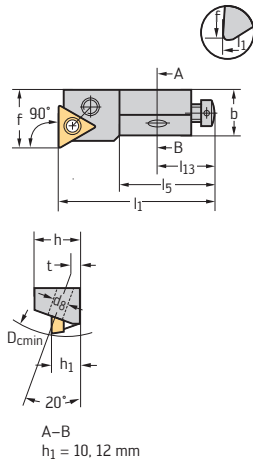
Accessories	Type	TN .. 1604 ..	TN .. 2204 ..
	ISO 2936 key	ISO2936-2 (SW 2)	ISO2936-3 (SW 3)
	Handle key	FS1175 (Torx 30)	FS1176 (Torx 40)

ISO cartridges

STFC



Tool



Designation	h ₁ mm	b mm	D _{c min} mm	d ₈ mm	l ₁₃ mm	f mm	h mm	l ₁ mm	l ₅ mm	t mm	Type
STFCR/L08CA-09	8	6,6	25	5	17	10	9	32	22	5	TC .. 0902 ..
STFCR/L10CA-11	10	11	40	7	20	14	15	50	33	5	TC .. 1102 ..

Measured with master insert: TC .. 090204 / TC .. 110204
 Ordering example, right-hand tool: STFCR08CA-09/ordering example, left-hand tool: STFCL08CA-09
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

Type	TC .. 0902 ..	TC .. 1102 ..
Clamping screw for indexable insert Tightening torque	FS2149 (Torx 7IP) 0,9 Nm	FS375 (Torx 7) 0,8 Nm
Adjusting screw, axial	FS1023	FS335
Adjusting screw, radial	FS493	FS369
Fastening screw	FS2106 (Torx 15IP)	FS976 (Torx 30)

Accessories

Type	TC .. 0902 ..	TC .. 1102 ..
Screwdriver	FS2088 (Torx 7IP)	FS309 (Torx 7)
Handle key	FS1485 (Torx 15IP)	FS1175 (Torx 30)

B2

Precision boring cartridges



– 0.01 and 0.002 mm adjustment accuracy

Tool	Designation	D _c min mm	d _g mm	l ₁₃ mm	f mm	h ₁ mm	l ₁ mm	t mm	Set mm	Indexable insert type
κ = 90°	FR709 / FL709	36	4,5	9,25	20	8,5	49,8	1	0,01	TC . . 1102 . .
	FR760	36	5,5	13,5	20	8,5	49,5	1	0,002	TC . . 1102 . .
κ = 90°	FR710 / FL710	28	4,5	9,25	16	8,5	49,5	1	0,01	CC . . 0602 . .
	FR761	28	5,5	13,5	16	8,5	49,5	1	0,002	CC . . 0602 . .

Measured with master insert TC . . 110204 and CC . . 060204

For radial/axial adjustment range, see page B 641 in the Walter General Catalogue 2017

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

Assembly parts	Indexable insert type	TC . . 1102 . .	CC . . 0602 . .
	Clamping screw	FS1129 (Torx 8)	FS1129 (Torx 8)
	Clamping screw for cartridge	FS1354	FS1354
	Compression piece	FK369	FK369
	Adjusting screw, axial	FS1355	FS1355
	Adjusting screw, radial	FS1356	FS1356

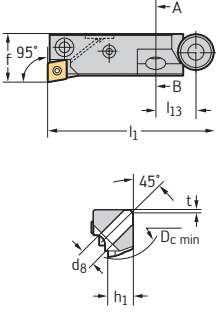
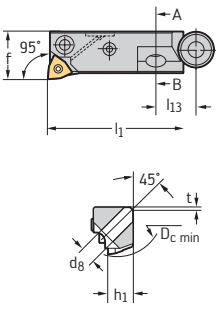
Accessories	Indexable insert type	TC . . 1102 . .
	Screwdriver	FS257 (Torx 8)

B2

Precision boring cartridges








- 0.01 and 0.002 mm adjustment accuracy

Tool	Designation	D _c min mm	d ₈ mm	l ₁₃ mm	f mm	h ₁ mm	l ₁ mm	t mm	Set mm	Indexable insert type
κ = 95° 	FR717 / FL717	28	4,5	9,25	16	8,5	49,5	1	0,01	CC . . 0602 . .
	FR763	28	5,5	13,5	16	8,5	49,5	1	0,002	CC . . 0602 . .
κ = 95° 	FR711 / FL711	28	4,5	9,25	16	8,5	49,8	1	0,01	WC . . 0402 . .

Measured with master insert CC . . 060204

For radial/axial adjustment range, see page B 641 in the Walter General Catalogue 2017

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

Assembly parts	Indexable insert type	CC . . 0602 . .
	Clamping screw	FS1129 (Torx 8)
	Clamping screw for cartridge	FS1354
	Compression piece	FK369
	Adjusting screw, axial	FS1355
	Adjusting screw, radial	FS1356

Accessories	Indexable insert type	TC . . 1102 . .
	Screwdriver	FS257 (Torx 8)

B2

Cutting data for boring and precision boring

Material group	Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	Boring			
							Negative basic shape			
							Indexable insert geometry		Starting values for feed f [mm/rev]	
							-E47	-G88		
fz [mm]		fz [mm]								
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	428	P1	●●		0.25	
		C > 0.25 ... ≤ 0.55%	Annealed	190	639	P2	●●		0.20	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	708	P3	●●		0.19	
		C > 0.55%	Annealed	190	639	P4	●●		0.18	
		C > 0.55%	Heat-treated	300	1013	P5	●●		0.15	
	Free-machining steel (short-chipping)	Annealed	220	745	P6	●●	●	0.19		
	Low-alloy steel	Annealed		175	591	P7	●●		0.25	
		Heat-treated		300	1013	P8	●●		0.18	
		Heat-treated		380	1282	P9	●●		0.15	
		Heat-treated		430	1477	P10	●●		0.13	
	High-alloy steel and high-alloy tool steel	Annealed		200	675	P11	●●		0.18	
		Hardened and tempered		300	1013	P12	●●		0.16	
		Hardened and tempered		400	1361	P13	●●		0.13	
	Stainless steel	Ferritic/martensitic, annealed		200	675	P14	●●		0.15	
		Martensitic, heat-treated		330	1114	P15	●●		0.15	
M	Stainless steel	Austenitic, quench hardened		200	675	M1	●●		0.16	
		Austenitic, precipitation hardened (PH)		300	1013	M2	●●		0.16	
		Austenitic/ferritic, duplex		230	778	M3	●●		0.16	
K	Malleable cast iron	Ferritic		200	675	K1	●●	●	0.23	
		Pearlitic		260	867	K2	●●	●	0.20	
	Grey cast iron	Low tensile strength		180	602	K3	●●	●	0.25	
		High tensile strength/austenitic		245	825	K4	●●	●	0.20	
	Cast iron with spheroidal graphite	Ferritic		155	518	K5	●●	●	0.25	
		Pearlitic		265	885	K6	●●	●	0.20	
GGV (CGI)			200	675	K7	●●	●	0.23		
N	Wrought aluminium alloys	Not hardenable		30	-	N1	●●			0.25
		Hardenable, hardened		100	343	N2	●●			0.25
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3	●●	●		0.25
		≤ 12% Si, hardenable, hardened		90	314	N4	●●	●		0.25
	Magnesium-based alloys ³	> 12% Si, not hardenable		130	447	N5	●●	●		0.25
		Unalloyed, electrolytic copper		100	343	N7	●●			0.25
		Copper and copper alloys (bronze/brass)	Brass, bronze, red brass		90	314	N8	●●	●	
Cu alloys, short-chipping			110	382	N9	●●	●		0.25	
	High tensile, Ampco		300	1013	N10	●●				
S	Heat-resistant alloys	Fe-based	Annealed		200	675	S1	●●		0.13
			Hardened		280	943	S2	●●		0.13
		Ni- or Co-based	Annealed		250	839	S3	●●		0.13
			Hardened		350	1177	S4	●●		0.13
			Cast		320	1076	S5	●●		0.13
	Titanium alloys	Pure titanium		200	675	S6				
		α and β alloys, hardened		375	1262	S7	●●		0.17	
		β alloys		410	1396	S8	●●		0.15	
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			55 HRC	-	H4				
O	Thermoplastics	Without abrasive fillers				O1				
	Thermosets	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 is regarded as starting values for the recommended application)
- Possible application, reduce cutting data by 30–50% (increase by approx. 70–80% for ISO M)

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

Note: If dry machining is possible, the tool life is reduced by 20–30% on average. For specific applications, adjustment is recommended.

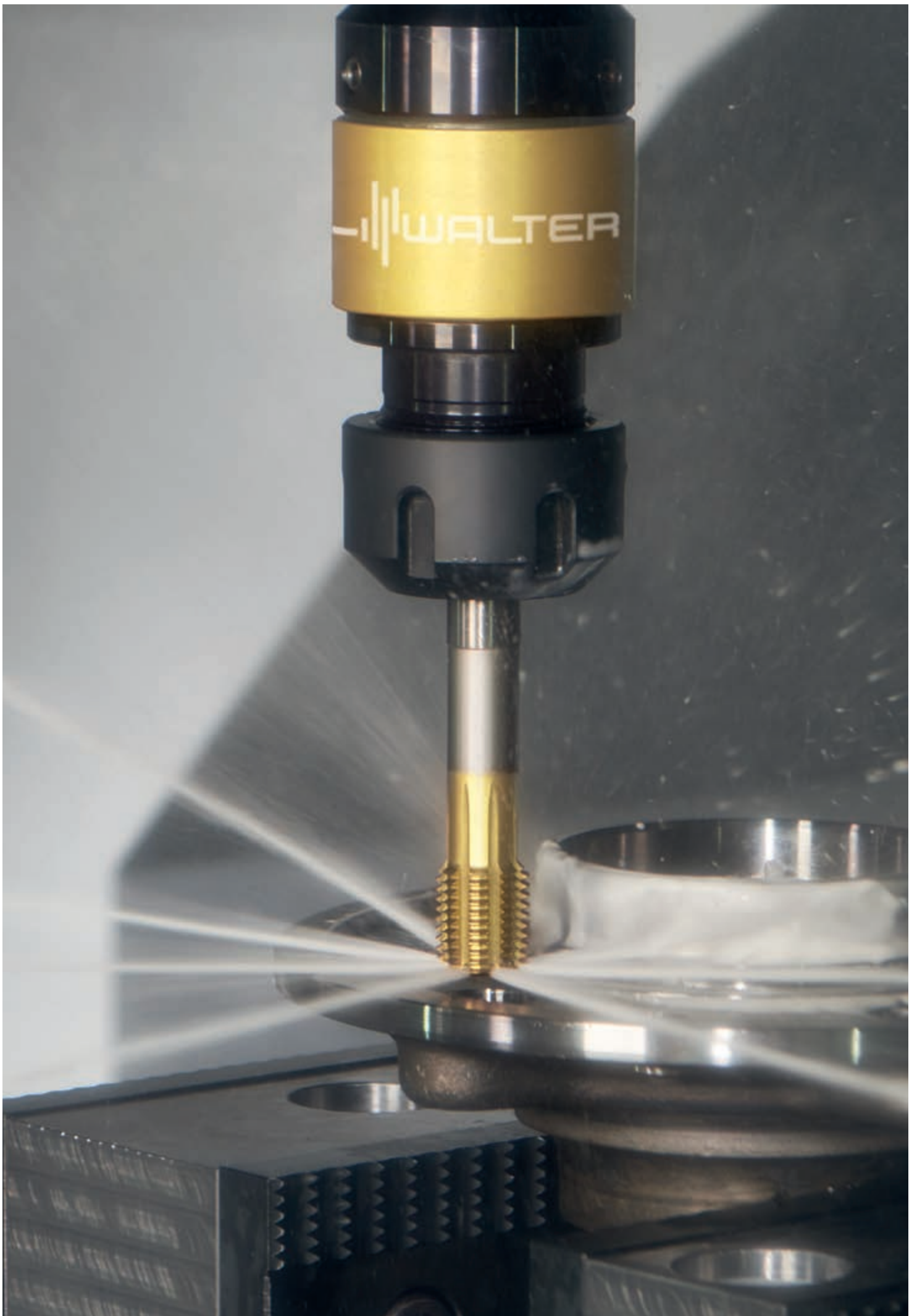
¹ The classification of the machining groups can be found from page B 1174 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

Boring Negative basic shape														Precision boring Positive basic shape								
Cutting material grade														Cermet								
Starting values for cutting speed v_c [m/min]														Starting values for cutting speed v_c [m/min]								
WKK10S			WKK20S			WKP30S			WSM20S			WK10			WNN10			HE				
L/D			L/D			L/D			L/D			L/D			L/D			f [mm/rev]				
$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$2 \times D_c$	$3 \times D_c$	$4 \times D_c$	$3 \times D_c$	$4 \times D_c$	$6 \times D_c$		
			300	270	120	260	240	120	240	220								●●	●	288	261	162
			280	220	100	220	200	100	180	160								●●	●	270	216	135
			250	200	90	200	180	90	140	120								●●	●	243	198	126
			240	190	90	180	160	90	160	140								●●	●	234	189	117
			210	170	80	140	130	80										●●	●	207	171	108
			250	200	90	200	180	90	160	140								●●	●	243	198	126
			280	220	100	220	200	100										●●	●	270	216	135
			230	180	80	180	160	80										●●	●	225	180	117
			200	160	70	130	120	70										●●	●	198	162	99
			170	130	60	120	100	60										●●	●	171	135	72
			230	170	100	180	160	100										●●	●	225	171	117
			190	160	80	160	150	80										●●	●	189	162	99
			180	140	70	120	100	70										●●	●	180	144	81
			230	180	100	160	130	100										●●	●	225	180	117
			170	150	80	130	110	80										●●	●	171	153	90
						230	210	100	200	180	100							●●	●	207	162	108
						190	170	80	150	120	80							●●	●	153	117	99
						210	190	100	170	140	100							●●	●	171	135	81
	280	250	210	190	130	190	170	130										●●	●	225	189	108
	220	200	170	150	130	170	150	130										●●	●	180	153	99
	390	350	350	320	150	210	190	150										●●	●	243	207	126
	250	220	190	170	130	170	150	130										●●	●	180	153	99
	260	230	200	180	130	160	150	130										●●	●	225	180	117
	190	170	150	130	120	150	140	120										●●	●	207	162	108
	190	160	160	140	120													●●	●			
												1000	850	650	1000	850	650	●●	●			
												800	700	600	900	820	600	●●	●			
												500	450	400	600	550	400	●●	●			
												400	350	300	500	450	400	●●	●			
												300	260	230	400	360	320	●●	●			
												500	450	400	600	550	400	●●	●			
												450	400	350	550	250	200	●●	●			
												400	350	300	500	450	400	●●	●			
												350	300	250	400	350	300	●●	●			
									80	70	60							●●	●			
									60	50	45							●●	●			
									50	45	40							●●	●			
									40	35	30							●●	●			
									40	35	30							●●	●			
									50	45	40	45	40	35	50	45	40	●●	●			
									40	35	30	40	35	30	40	35	30	●●	●			
																		●	●●			
																		●	●●			
																		●	●●			
																		●	●●			
																		●	●●			

HC = Coated carbide
HE = Coated cermet

B2



Tapping – B3

HSS-E(-PM) taps	Product range overview	438
	Designation key	440
	M – Metric thread	441
	MF – Metric fine-pitch thread	455
	UNC	458
	UNF	464
	NPT	467

Solid carbide taps	Product range overview	468
	M – Metric thread	469
	G	471

Thread forming – B4

HSS-E-PM and solid carbide thread formers	Product range overview	472
	Designation key	474
	M – Metric thread	475
	MF – Metric fine-pitch thread	499
	UNC	505
	UNF	506
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Thread milling – B5

Thread milling cutters	Product range overview	508
	Designation key	510
	Solid carbide thread milling cutters	511
	Designation key	517
	Indexable insert thread milling cutter	518

Technical information B3–B5

Cutting data	534
Radius correction values	539
Tool application	541

Product range overview of HSS-E(-PM) taps M – Metric thread

Machining						
Thread depth	3 x D _N			1,5 x D _N		2,5 x D _N
Designation	TC216 Perform	TC216 Perform set 1	TC216 + DA110 Perform set 2*	TC122 Supreme	Paradur® Ni	TC121 Supreme
Dimension range	M 1.6-M 20	M 3-M 12	M 3-M 12	M 3-M 20	M 2-M 20	M 2-M 20
Tolerance	6H	6H	6H	6HX	6HX	6HX
Coolant supply	external	external	external	external	external	external/axial
Chamfer form	B	B	B	C	C	C
Coating/grade	WY80FC / WY80AA	WY80FC / WY80AA	WY80FC / WY80AA	WW60BC	TiCN/uncoated	WW60RG / WY80BD
Page	441	442	443	452	454	450










Machining					
Thread depth	2,5 x D _N	3 x D _N			
Designation	TC122 Supreme	TC115 Perform	TC115 Perform set 1	TC115 + DA110 Perform set 2*	TC120 Supreme
Dimension range	M 5-M 20	M 1.6-M 20	M 3-M 12	M 3-M 12	M 3-M 30
Tolerance	6HX	6H	6H	6H	6HX
Coolant supply	axial	external	external	external	external/axial
Chamfer form	C	C / E	C	C	C
Coating/grade	WW60BC	WY80FC / WY80AA	WY80FC / WY80AA	WY80FC / WY80AA	WW60AG
Page	453	444	446	447	448



Product range overview of HSS-E(-PM) taps MF – Metric fine-pitch thread

Machining			
Thread depth	2 x D _N	3,5 x D _N	3 x D _N
Designation	Prototex® TiNi	TC216 Perform	TC115 Perform
Dimension range	MF 8x0.75– MF 16x1	MF 8x1– MF 18x1.5	MF 8x1– MF 18x1.5
Tolerance	6HX	6H	6H
Coolant supply	external	external	external
Chamfer form	B	B	C
Coating/grade	TiCN/uncoated	WY80FC / WY80AA	WY80FC / WY80AA
Page	456	455	457



* Incl. core-hole drill

Product range overview of HSS-E(-PM) taps UNC / UNF / UNEF / UN-8 / UNS

Machining						
Thread depth	2 x D _N	3,5 x D _N	1,5 x D _N	3 x D _N	3,5 x D _N	2 x D _N
Designation	Prototex® TiNi	TC216 Perform	Paradur® Ni	TC115 Perform	Paradur® HT	Prototex® TiNi
Dimension range	UNC 2-56– UNC 3/4-10	UNC 6-32– UNC 3/4-10	UNC 2-56– UNC 3/4-10	UNC 6-32– UNC 3/4-10	UNC 1/4-20– UNC 1"-8	UNF 4-48– UNF 5/8-18
Tolerance	3B / 2B	2B	2B	2B	2B	3B / 2B
Coolant supply	external	external	external	external	axial	external
Chamfer form	B	B	C	C	C	B
Coating/grade	TiCN/uncoated	WY80AA	TiCN/uncoated	WY80AA	TIN	TiCN/uncoated
Page	456	458	463	461	462	464
						

Machining	
Thread depth	1,5 x D _N
Designation	Paradur® Ni
Dimension range	UNF 8-36– UNF 5/8-18
Tolerance	3B
Coolant supply	external
Chamfer form	C
Coating/grade	TiCN/uncoated
Page	466
	

Product range overview of HSS-E(-PM) taps NPT / NPTF

Machining	
Thread depth	–
Designation	Paradur® Ni
Dimension range	NPT 1/16-27– NPT 1"-11.5
Tolerance	NORMAL
Coolant supply	external
Chamfer form	C
Coating/grade	TiCN/uncoated
Page	467
	

Designation key Taps

Example:

T	C	1	20	-	M10	-	C	1	-	W	W	60	AG
1	2	3	4	5	6		7	8		Grade			

1	2	3	4									
Tool group	Generation	Tool type	Tool type									
T Threading		1 Blind hole taps 2 Through hole taps 3 Blind and through hole taps	<table border="1"> <tr> <td>15 Universal, Perform 45° helix angle 300–1000 N/mm²</td> <td>20 ISO P, Supreme 45° helix angle 350–800 N/mm²</td> <td>42 ISO M, Supreme 50° helix angle < 1000 N/mm</td> </tr> <tr> <td>16 Universal, Perform Straight-fluted, spiral point 300–1000 N/mm²</td> <td>21 ISO P, Supreme 40° helix angle 800–1250 N/mm²</td> <td>88 ISO H, Supreme Straight-fluted 50–58 HRC</td> </tr> <tr> <td>17 Universal, Supreme 500–1200 N/mm</td> <td>22 ISO P, Supreme 15° helix angle 1000–1400 N/mm²</td> <td>89 ISO H, Supreme Straight-fluted 55–65 HRC</td> </tr> </table>	15 Universal, Perform 45° helix angle 300–1000 N/mm ²	20 ISO P, Supreme 45° helix angle 350–800 N/mm ²	42 ISO M, Supreme 50° helix angle < 1000 N/mm	16 Universal, Perform Straight-fluted, spiral point 300–1000 N/mm ²	21 ISO P, Supreme 40° helix angle 800–1250 N/mm ²	88 ISO H, Supreme Straight-fluted 50–58 HRC	17 Universal, Supreme 500–1200 N/mm	22 ISO P, Supreme 15° helix angle 1000–1400 N/mm ²	89 ISO H, Supreme Straight-fluted 55–65 HRC
15 Universal, Perform 45° helix angle 300–1000 N/mm ²	20 ISO P, Supreme 45° helix angle 350–800 N/mm ²	42 ISO M, Supreme 50° helix angle < 1000 N/mm										
16 Universal, Perform Straight-fluted, spiral point 300–1000 N/mm ²	21 ISO P, Supreme 40° helix angle 800–1250 N/mm ²	88 ISO H, Supreme Straight-fluted 50–58 HRC										
17 Universal, Supreme 500–1200 N/mm	22 ISO P, Supreme 15° helix angle 1000–1400 N/mm ²	89 ISO H, Supreme Straight-fluted 55–65 HRC										

5	6	7	8						
1. Delimiters	Thread dimensions	Tolerance/shank type	Modification						
- Metric . DIN / ANSI		<table border="1"> <tr> <td>B 4HX, 3B Reinforced shank</td> <td>K 4HX, 3B Reduced shank</td> </tr> <tr> <td>C 6HX, 2B Reinforced shank</td> <td>L 6HX, 2B Reduced shank</td> </tr> <tr> <td>G 2B/3B Reinforced shank</td> <td>R 2B, 3B Reduced shank</td> </tr> </table>	B 4HX, 3B Reinforced shank	K 4HX, 3B Reduced shank	C 6HX, 2B Reinforced shank	L 6HX, 2B Reduced shank	G 2B/3B Reinforced shank	R 2B, 3B Reduced shank	0 External coolant 1 Axial internal coolant D Chamfer form D E Chamfer form E
B 4HX, 3B Reinforced shank	K 4HX, 3B Reduced shank								
C 6HX, 2B Reinforced shank	L 6HX, 2B Reduced shank								
G 2B/3B Reinforced shank	R 2B, 3B Reduced shank								

Grade designation key for solid carbide and HSS-E(-PM) cutting tool materials

Example:

W	W	60	AG
Walter	1	2	3

1	2	3																								
Substrate	Application range	Coating																								
<table border="1"> <tr> <td rowspan="3">Solid carbide</td> <td>E</td> </tr> <tr> <td>J</td> </tr> <tr> <td>W</td> </tr> <tr> <td>HSS-E-PM</td> <td>W</td> </tr> <tr> <td>HSS-E</td> <td>Y</td> </tr> </table>	Solid carbide	E	J	W	HSS-E-PM	W	HSS-E	Y		<table border="1"> <tr> <td>AA</td> <td>TiN</td> </tr> <tr> <td>AG</td> <td>TiNK/vap</td> </tr> <tr> <td>BA</td> <td>TiCN</td> </tr> <tr> <td>BD</td> <td>TiCN</td> </tr> <tr> <td>BC</td> <td>TiCN</td> </tr> <tr> <td>FC</td> <td>vap</td> </tr> <tr> <td>RB</td> <td>TiALN</td> </tr> <tr> <td>RG</td> <td>TiAlN</td> </tr> </table>	AA	TiN	AG	TiNK/vap	BA	TiCN	BD	TiCN	BC	TiCN	FC	vap	RB	TiALN	RG	TiAlN
Solid carbide		E																								
		J																								
	W																									
HSS-E-PM	W																									
HSS-E	Y																									
AA	TiN																									
AG	TiNK/vap																									
BA	TiCN																									
BD	TiCN																									
BC	TiCN																									
FC	vap																									
RB	TiALN																									
RG	TiAlN																									

B3

HSS-E machine taps

TC216 Perform mm



– For long-chipping materials

≤
3×DN

B=3,5-5

32HRC
1000
-350
N/mm²

M
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●	●	●	●			
WY80FC	●	●	●	●			

DIN 371											WY80AA	WY80FC
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WY80AA	WY80FC
TC216-M1.6-C0-	M 1.6	0,35	40	7	7	2,5	2,1	5	2			
TC216-M2-C0-	M 2	0,4	45	6	9	2,8	2,1	5	2			
TC216-M2.5-C0-	M 2.5	0,45	50	8	12,5	2,8	2,1	5	2			
TC216-M3-C0-	M 3	0,5	56	9	18	3,5	2,7	6	2			
TC216-M4-C0-	M 4	0,7	63	12	21	4,5	3,4	6	3			
TC216-M5-C0-	M 5	0,8	70	13	25	6	4,9	8	3			
TC216-M6-C0-	M 6	1	80	15	30	6	4,9	8	3			
TC216-M8-C0-	M 8	1,25	90	18	35	8	6,2	9	3			
TC216-M10-C0-	M 10	1,5	100	20	39	10	8	11	3			

Ordering example for the WY80FC grade: TC216-M3-C0-WY80FC

DIN 376											WY80AA	WY80FC
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WY80AA	WY80FC
TC216-M12-L0-	M 12	1,75	110	23	83	9	7	10	3			
TC216-M14-L0-	M 14	2	110	25	81	11	9	12	4			
TC216-M16-L0-	M 16	2	110	25	68	12	9	12	4			
TC216-M20-L0-	M 20	2,5	140	30	95	16	12	15	4			

Ordering example for the WY80FC grade: TC216-M12-L0-WY80FC

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

B3

HSS-E tap set 1

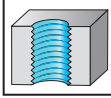
TC216 Perform



– Universal tap set

M
DIN 13

ISO2/6H




$\leq 3 \times DN$

$B=3,5-5$

32HRC
1000
-350
N/mm²

	P	M	K	N	S	H	O
WY80AA	●●	●●	●●	●●			

Tool	Designation	D _N mm	Quantity	WY80AA
	TC216-SET1-M3-M12-	M3	7	✘
		M4		
		M5		
		M6		
		M8		
		M10		
		M12		

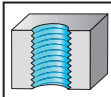
Ordering example for the WY80AA grade: TC216-SET1-M3-M12-WY80AA



– Universal tap set

M
DIN 13

ISO2/6H




$\leq 3 \times DN$

$B=3,5-5$

32HRC
1000
-350
N/mm²

	P	M	K	N	S	H	O
WY80FC	●●	●●	●●	●●			

Tool	Designation	D _N mm	Quantity	WY80FC
	TC216-SET1-M3-M12-	M3	7	✘
		M4		
		M5		
		M6		
		M8		
		M10		
		M12		

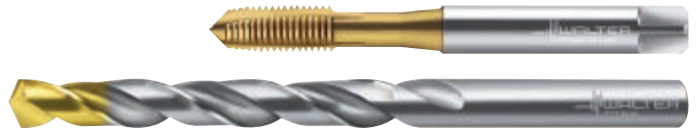
Ordering example for the WY80FC grade: TC216-SET1-M3-M12-WY80FC

Please refer to the corresponding order pages for the tool dimensions and suitability for the intended application.

✘ ✘ ✘ / ★ New addition to the product range

HSS-E tap set 2

TC216 + DA110 Perform mm



- Universal tap set
- Incl. core-hole drill

$\leq 3 \times DN$

$B=3,5-5$

32HRC
1000-350
N/mm²

M
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●	●	●	●			

Tool	Designation	D _N mm	Core hole dia. mm	Quantity	WY80AA
	TC216-SET2-M3-M12-	M3	2,5	14	
		M4	3,3		
		M5	4,2		
		M6	5,0		
		M8	6,8		
		M10	8,5		
		M12	10,2		

Ordering example for the WY80AA grade: TC216-SET2-M3-M12-WY80AA

B3



- Universal tap set
- Incl. core-hole drill

$\leq 3 \times DN$

$B=3,5-5$

32HRC
1000-350
N/mm²

M
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80FC	●	●	●	●			

Tool	Designation	D _N mm	Core hole dia. mm	Quantity	WY80FC
	TC216-SET2-M3-M12-	M3	2,5	14	
		M4	3,3		
		M5	4,2		
		M6	5,0		
		M8	6,8		
		M10	8,5		
		M12	10,2		

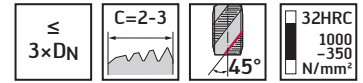
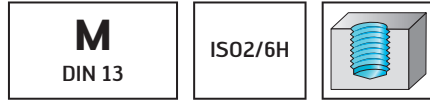
Ordering example for the WY80FC grade: TC216-SET1-M3-M12-WY80FC

Please refer to the corresponding order pages for the tool dimensions and suitability for the intended application.

HSS-E machine taps
TC115 Perform

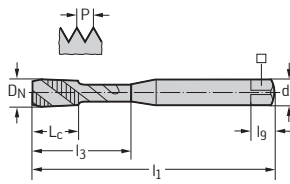


- For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			
WY80FC	●	●	●	●			

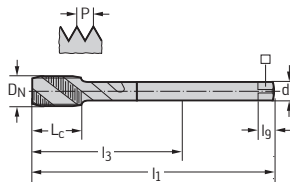
DIN 371



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AA	WY80FC
TC115-M1.6-C0-	M 1.6	0,35	40	6	6	2,5	2,1	5	2	●	●
TC115-M2-C0-	M 2	0,4	45	4	9	2,8	2,1	5	3	●	●
TC115-M2.5-C0-	M 2.5	0,45	50	4	12,5	2,8	2,1	5	3	●	●
TC115-M3-C0-	M 3	0,5	56	6	18	3,5	2,7	6	3	●	●
TC115-M4-C0-	M 4	0,7	63	7	21	4,5	3,4	6	3	●	●
TC115-M5-C0-	M 5	0,8	70	8	25	6	4,9	8	3	●	●
TC115-M6-C0-	M 6	1	80	10	30	6	4,9	8	3	●	●
TC115-M8-C0-	M 8	1,25	90	12	35	8	6,2	9	3	●	●
TC115-M10-C0-	M 10	1,5	100	15	39	10	8	11	3	●	●

Ordering example for the WY80FC grade: TC115-M3-C0-WY80FC

DIN 376



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AA	WY80FC
TC115-M12-L0-	M 12	1,75	110	16	83	9	7	10	3	●	●
TC115-M14-L0-	M 14	2	110	20	81	11	9	12	3	●	●
TC115-M16-L0-	M 16	2	110	20	68	12	9	12	3	●	●
TC115-M20-L0-	M 20	2,5	140	25	95	16	12	15	4	●	●

Ordering example for the WY80FC grade: TC115-M12-L0-WY80FC

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

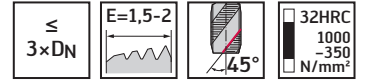
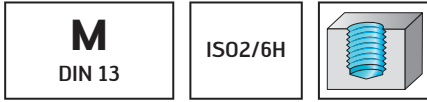
● Other application

HSS-E machine taps

TC115 Perform

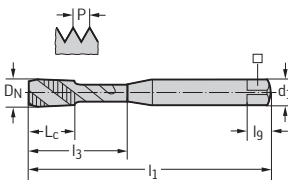


– For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			

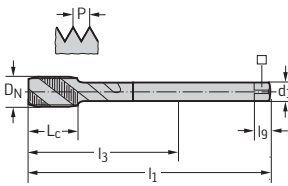
DIN 371



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WY80AA
TC115-M3-CE-	M 3	0,5	56	6	18	3,5	2,7	6	3	
TC115-M4-CE-	M 4	0,7	63	7	21	4,5	3,4	6	3	
TC115-M5-CE-	M 5	0,8	70	8	25	6	4,9	8	3	
TC115-M6-CE-	M 6	1	80	10	30	6	4,9	8	3	
TC115-M8-CE-	M 8	1,25	90	12	35	8	6,2	9	3	
TC115-M10-CE-	M 10	1,5	100	15	39	10	8	11	3	

Ordering example for the WY80AA grade: TC115-M3-CE-WY80AA

DIN 376



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WY80AA
TC115-M12-LE-	M 12	1,75	110	16	83	9	7	10	3	
TC115-M14-LE-	M 14	2	110	20	81	11	9	12	3	
TC115-M16-LE-	M 16	2	110	20	68	12	9	12	3	
TC115-M20-LE-	M 20	2,5	140	25	95	16	12	15	4	

Ordering example for the WY80AA grade: TC115-M12-LE-WY80AA

B3

HSS-E tap set 1

TC115 Perform



– Universal tap set

M
DIN 13

ISO2/6H

$\leq 3 \times D_N$

C=2-3

$\angle 45^\circ$

32HRC
1000
–350
N/mm²

	P	M	K	N	S	H	O
WY80AA	●	●	●	●	●	●	●

Tool	Designation	D _N	Quantity	WY80AA
	TC115-SET1-M3-M12-	M3	7	✘
		M4		
		M5		
		M6		
		M8		
		M10		
		M12		

Ordering example for the WY80AA grade: TC115-SET1-M3-M12-WY80AA



– Universal tap set

M
DIN 13

ISO2/6H

$\leq 3 \times D_N$

C=2-3

$\angle 45^\circ$

32HRC
1000
–350
N/mm²

	P	M	K	N	S	H	O
WY80FC	●	●	●	●	●	●	●

Tool	Designation	D _N	Quantity	WY80FC
	TC115-SET1-M3-M12-	M3	7	✘
		M4		
		M5		
		M6		
		M8		
		M10		
		M12		

Ordering example for the WY80FC grade: TC115-SET1-M3-M12-WY80FC

Please refer to the corresponding order pages for the tool dimensions and suitability for the intended application.

✘ ✘ ✘ / ★ New addition to the product range

B3

HSS-E tap set 2

TC115 + DA110 Perform mm



- Universal tap set
- Incl. core-hole drill

$\leq 3 \times DN$

$C=2-3$

45°

32HRC
1000
-350
N/mm ²

M
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●	●	●	●	●	●	●

Tool	Designation	D _N	Core hole dia. mm	Quantity	WY80AA
	TC115-SET2-M3-M12-	M3	2,5	14	
		M4	3,3		
		M5	4,2		
		M6	5,0		
		M8	6,8		
		M10	8,5		
		M12	10,2		

Ordering example for the WY80AA grade: TC115-SET2-M3-M12-WY80AA

B3



- Universal tap set
- Incl. core-hole drill

$\leq 3 \times DN$

$C=2-3$

45°

32HRC
1000
-350
N/mm ²

M
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80FC	●	●	●	●	●	●	●

Tool	Designation	D _N	Core hole dia. mm	Quantity	WY80FC
	TC115-SET2-M3-M12-	M3	2,5	14	
		M4	3,3		
		M5	4,2		
		M6	5,0		
		M8	6,8		
		M10	8,5		
		M12	10,2		

Ordering example for the WY80FC grade: TC115-SET2-M3-M12-WY80FC

Please refer to the corresponding order pages for the tool dimensions and suitability for the intended application.

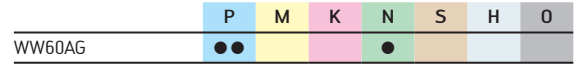
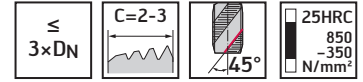
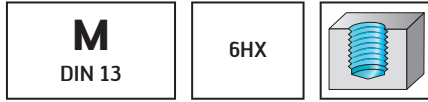
/ ★ New addition to the product range

HSS-E-PM machine taps

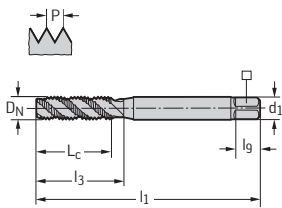
TC120 Supreme



- For long-chipping materials



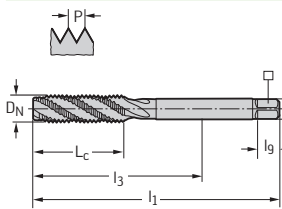
DIN 371



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60AG
TC120-M3-C0-	M 3	0,5	56	10	18	3,5	2,7	6	3	
TC120-M4-C0-	M 4	0,7	63	13,5	21	4,5	3,4	6	3	
TC120-M5-C0-	M 5	0,8	70	16,5	25	6	4,9	8	3	
TC120-M6-C0-	M 6	1	80	20	30	6	4,9	8	3	
TC120-M8-C0-	M 8	1,25	90	26,5	35	8	6,2	9	3	
TC120-M10-C0-	M 10	1,5	100	33	39	10	8	11	3	

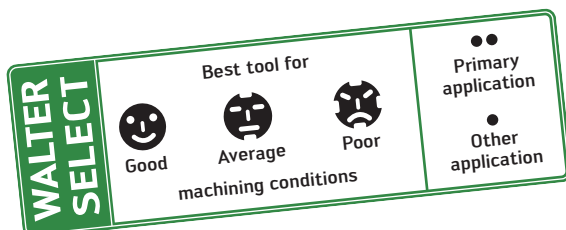
Ordering example for the WW60AG grade: TC120-M3-C0-WW60AG

DIN 376



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60AG
TC120-M12-L0-	M 12	1,75	110	39,5	83	9	7	10	4	
TC120-M16-L0-	M 16	2	120	52	78	12	9	12	4	
TC120-M20-L0-	M 20	2,5	140	65	95	16	12	15	4	
TC120-M24-L0-	M 24	3	160	78	113	18	14,5	17	4	
TC120-M30-L0-	M 30	3,5	205	97	140	22	18	21	4	

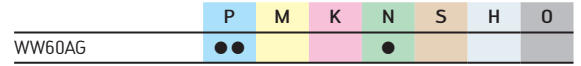
Ordering example for the WW60AG grade: TC120-M12-L0-WW60AG



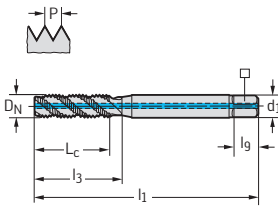
HSS-E-PM machine taps TC120 Supreme



- For long-chipping materials

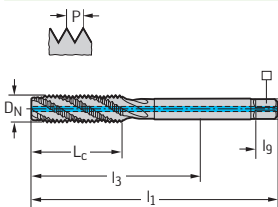


DIN 371											WW60AG
Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_g mm	N		
TC120-M8-C1-	M 8	1,25	90	26,5	35	8	6,2	9	3		
TC120-M10-C1-	M 10	1,5	100	33	39	10	8	11	3		



Ordering example for the WW60AG grade: TC120-M8-C1-WW60AG

DIN 376											WW60AG
Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_g mm	N		
TC120-M12-L1-	M 12	1,75	110	39,5	83	9	7	10	4		
TC120-M16-L1-	M 16	2	120	52	78	12	9	12	4		



Ordering example for the WW60AG grade: TC120-M12-L1-WW60AG

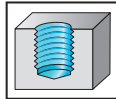
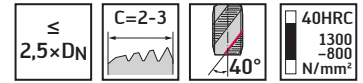
B3

HSS-E(-PM) machine taps

TC121 Supreme

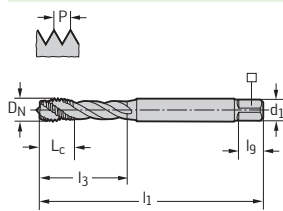


- WW60RG = HSS-E-PM + TiAlN
- WY80BD = HSS-E + TiCN



	P	M	K	N	S	H	O
WW60RG	●	●	●	●			
WY80BD	●	●	●	●			

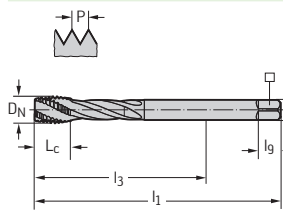
DIN 371



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60RG	WY80BD
TC121-M2-C0-	M 2	0,4	45	4	7,6	2,8	2,1	5	3	●	●
TC121-M3-C0-	M 3	0,5	56	6	11	3,5	2,7	6	3	●	●
TC121-M4-C0-	M 4	0,7	63	7	14,8	4,5	3,4	6	3	●	●
TC121-M5-C0-	M 5	0,8	70	8	20,7	6	4,9	8	3	●	●
TC121-M6-C0-	M 6	1	80	10	25	6	4,9	8	3	●	●
TC121-M8-C0-	M 8	1,25	90	12	35	8	6,2	9	3	●	●
TC121-M10-C0-	M 10	1,5	100	15	39	10	8	11	3	●	●

Ordering example for the WW60RG grade: TC121-M2-C0-WW60RG

DIN 376



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60RG	WY80BD
TC121-M12-L0-	M 12	1,75	110	16	83	9	7	10	4	●	●
TC121-M14-L0-	M 14	2	110	20	81	11	9	12	4	●	●
TC121-M16-L0-	M 16	2	110	20	68	12	9	12	4	●	●
TC121-M20-L0-	M 20	2,5	140	25	95	16	12	15	4	●	●

Ordering example for the WW60RG grade: TC121-M12-L0-WW60RG

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

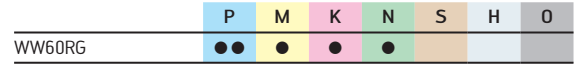
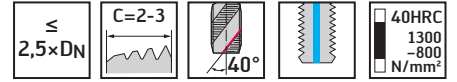
●● Primary application

● Other application

HSS-E(-PM) machine taps TC121 Supreme



- WW60RG = HSS-E-PM + TiAlN
- For long-chipping materials



DIN 371		Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_g mm	N	WW60RG
		TC121-M5-C1-	M 5	0,8	70	8	20,7	6	4,9	8	3	
		TC121-M6-C1-	M 6	1	80	10	25	6	4,9	8	3	
		TC121-M8-C1-	M 8	1,25	90	12	35	8	6,2	9	3	
		TC121-M10-C1-	M 10	1,5	100	15	39	10	8	11	3	

Ordering example for the WW60RG grade: TC121-M5-C1-WW60RG

DIN 376		Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_g mm	N	WW60RG
		TC121-M12-L1-	M 12	1,75	110	16	83	9	7	10	4	
		TC121-M14-L1-	M 14	2	110	20	81	11	9	12	4	
		TC121-M16-L1-	M 16	2	110	20	68	12	9	12	4	
		TC121-M20-L1-	M 20	2,5	140	25	95	16	12	15	4	

Ordering example for the WW60RG grade: TC121-M12-L1-WW60RG

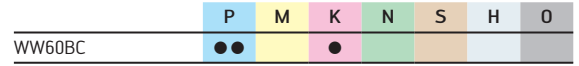
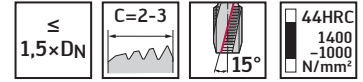
B3

HSS-E-PM machine taps

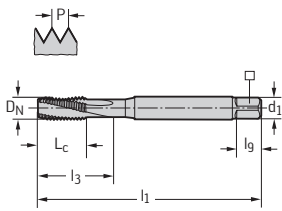
TC122 Supreme mm



- For long-chipping materials



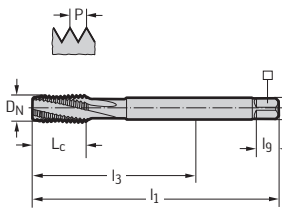
DIN 371



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60BC
TC122-M3-C0-	M 3	0,5	56	10	10	3,5	2,7	6	3	☼
TC122-M4-C0-	M 4	0,7	63	13	13	4,5	3,4	6	3	☼
TC122-M5-C0-	M 5	0,8	70	16	16	6	4,9	8	3	☼
TC122-M6-C0-	M 6	1	80	15	30	6	4,9	8	3	☼
TC122-M8-C0-	M 8	1,25	90	18	35	8	6,2	9	3	☼
TC122-M10-C0-	M 10	1,5	100	20	39	10	8	11	3	☼

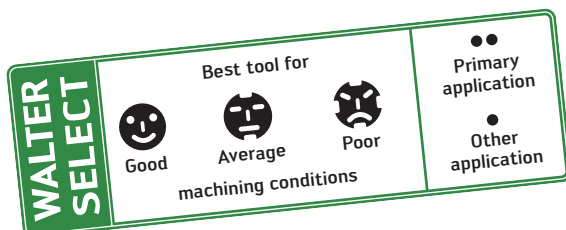
Ordering example for the WW60BC grade: TC122-M3-C0-WW60BC

DIN 376



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60BC
TC122-M12-L0-	M 12	1,75	110	23	83	9	7	10	4	☼
TC122-M14-L0-	M 14	2	110	25	81	11	9	12	4	☼
TC122-M16-L0-	M 16	2	110	25	68	12	9	12	4	☼
TC122-M20-L0-	M 20	2,5	140	30	95	16	12	15	4	☼

Ordering example for the WW60BC grade: TC122-M12-L0-WW60BC

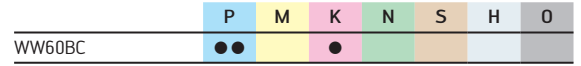


HSS-E-PM machine taps

TC122 Supreme mm



– For long-chipping materials



DIN 371											WW60BC
Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_9 mm	N		
TC122-M5-C1-	M 5	0,8	70	16	16	6	4,9	8	3		
TC122-M6-C1-	M 6	1	80	15	30	6	4,9	8	3		
TC122-M8-C1-	M 8	1,25	90	18	35	8	6,2	9	3		
TC122-M10-C1-	M 10	1,5	100	20	39	10	8	11	3		

Ordering example for the WW60BC grade: TC122-M5-C1-WW60BC

DIN 376											WW60BC
Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_9 mm	N		
TC122-M12-L1-	M 12	1,75	110	23	83	9	7	10	4		
TC122-M14-L1-	M 14	2	110	25	81	11	9	12	4		
TC122-M16-L1-	M 16	2	110	25	68	12	9	12	4		
TC122-M20-L1-	M 20	2,5	140	30	95	16	12	15	4		

Ordering example for the WW60BC grade: TC122-M12-L1-WW60BC

B3

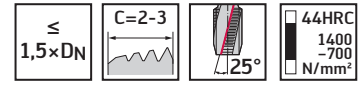
HSS-E-PM machine taps

mm

Paradur® Ni

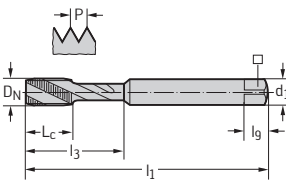


- For long-chipping materials



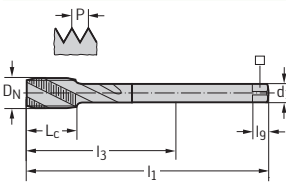
	P	M	K	N	S	H	O
TICN	●	●	●	●	●	●	●
Uncoated	●	●	●	●	●	●	●

~DIN 371



Designation TICN	Designation Uncoated	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
20410206-M2	204102-M2	M 2	0,4	45	8	8	2,8	2,1	5	3
20410206-M2.5	204102-M2.5	M 2.5	0,45	50	9	30	2,8	2,1	5	3
20410206-M3	204102-M3	M 3	0,5	56	10	35	3,5	2,7	6	3
20410206-M4	204102-M4	M 4	0,7	63	13	42	4,5	3,4	6	3
20410206-M5	204102-M5	M 5	0,8	70	16	16	6	4,9	8	3
20410206-M6	204102-M6	M 6	1	80	15	23	6	4,9	8	3
20410206-M8	204102-M8	M 8	1,25	90	18	29,5	8	6,2	9	3
20410206-M10	204102-M10	M 10	1,5	100	20	33,5	10	8	11	4

DIN 376



Designation TICN	Designation Uncoated	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
	204602-M12	M 12	1,75	110	23	83	9	7	10	4
	204602-M14	M 14	2	110	25	81	11	9	12	4
	204602-M16	M 16	2	110	25	68	12	9	12	4
	204602-M18	M 18	2,5	125	30	81	14	11	14	5
	204602-M20	M 20	2,5	140	30	95	16	12	15	5

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E machine taps

TC216 Perform mm



– For long-chipping materials

$\leq 3 \times DN$

$B=3,5-5$

32HRC
 1000-350
 N/mm²

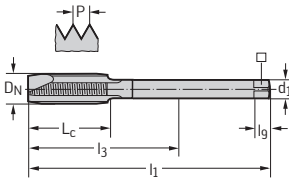
MF
 DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●●	●●	●●	●●			
WY80FC	●●	●●	●●	●●			

DIN 374											WY80AA	WY80FC
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N			
TC216-M8X1-L0-	MF 8x1	1	90	18	67	6	4,9	8	3			
TC216-M10X1-L0-	MF 10x1	1	90	20	67	7	5,5	8	3			
TC216-M10X1.25-L0-	MF 10x1.25	1,25	100	20	77	7	5,5	8	3			
TC216-M12X1.25-L0-	MF 12x1.25	1,25	100	21	73	9	7	10	4			
TC216-M12X1.5-L0-	MF 12x1.5	1,5	100	21	73	9	7	10	4			
TC216-M14X1.5-L0-	MF 14x1.5	1,5	100	21	71	11	9	12	4			
TC216-M16X1.5-L0-	MF 16x1.5	1,5	100	21	58	12	9	12	4			
TC216-M18X1.5-L0-	MF 18x1.5	1,5	110	24	66	14	11	14	4			

Ordering example for the WY80FC grade: TC216-M8X1-L0-WY80FC



B3

HSS-E-PM machine taps

mm

Prototex® TiNi



- Recommended with oil
- For long-chipping materials

$\leq 2 \times DN$

$B=3,5-5$

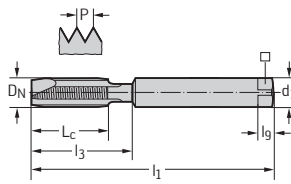
44HRC
 1400
 -700
 N/mm²

MF
DIN 13

6HX

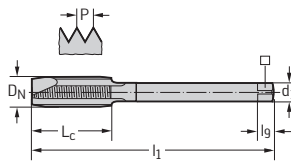
	P	M	K	N	S	H	O
TICN	●●	●●	●●	●●	●●	●●	●●
Uncoated	●●	●●	●●	●●	●●	●●	●●

~DIN 371



Designation TICN	Designation Uncoated	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
21216106-M8X0.75	212161-M8X0.75	MF 8x0.75	0,75	80	10	29	8	6,2	9	3
21216106-M8X1	212161-M8X1	MF 8x1	1	90	12	29	8	6,2	9	3

DIN 374



Designation TICN	Designation Uncoated	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
21266106-M10X1.25	212661-M10X1.25	MF 10x1.25	1,25	100	20	77	7	5,5	8	3
21266106-M12X1	212661-M12X1	MF 12x1	1	100	16	73	9	7	10	4
21266106-M12X1.25	212661-M12X1.25	MF 12x1.25	1,25	100	21	73	9	7	10	4
21266106-M12X1.5	212661-M12X1.5	MF 12x1.5	1,5	100	21	73	9	7	10	4
21266106-M14X1	212661-M14X1	MF 14x1	1	100	16	71	11	9	12	4
21266106-M14X1.5	212661-M14X1.5	MF 14x1.5	1,5	100	21	71	11	9	12	4
21266106-M16X1	212661-M16X1	MF 16x1	1	100	18	58	12	9	12	4

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E machine taps

TC115 Perform



– For long-chipping materials

≤
3×DN

C=2-3

45°

32HRC
1000
-350
N/mm²

MF
DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●	●	●	●			
WY80FC	●	●	●	●			

DIN 374		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AA	WY80FC
		TC115-M8X1-L0-	MF 8x1	1	90	12	67	6	4,9	8	3		
		TC115-M10X1-L0-	MF 10x1	1	90	12	67	7	5,5	8	3		
		TC115-M10X1.25-L0-	MF 10x1.25	1,25	100	15	77	7	5,5	8	3		
		TC115-M12X1.25-L0-	MF 12x1.25	1,25	100	13	73	9	7	10	4		
		TC115-M12X1.5-L0-	MF 12x1.5	1,5	100	13	73	9	7	10	4		
		TC115-M14X1.5-L0-	MF 14x1.5	1,5	100	15	71	11	9	12	4		
		TC115-M16X1.5-L0-	MF 16x1.5	1,5	100	15	58	12	9	12	4		
	TC115-M18X1.5-L0-	MF 18x1.5	1,5	110	17	66	14	11	14	4			

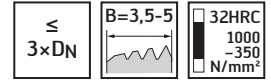
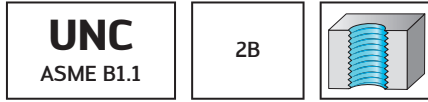
Ordering example for the WY80FC grade: TC115-M8X1-L0-WY80FC

B3

HSS-E machine taps
TC216 Perform mm

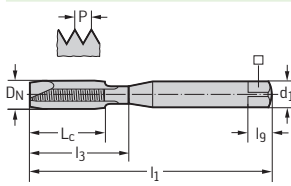


– For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			

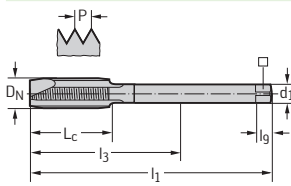
DIN 371



Designation	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N	WY80AA
TC216-UNC6-C0-	UNC 6-32	3,505	56	11	20	4	3	6	3	●
TC216-UNC8-C0-	UNC 8-32	4,166	63	12	21	4,5	3,4	6	3	●
TC216-UNC10-C0-	UNC 10-24	4,826	70	13	25	6	4,9	8	3	●
TC216-UNC1/4-C0-	UNC 1/4-20	6,35	80	15	30	7	5,5	8	3	●
TC216-UNC5/16-C0-	UNC 5/16-18	7,938	90	18	35	8	6,2	9	3	●
TC216-UNC3/8-C0-	UNC 3/8-16	9,525	100	20	39	10	8	11	3	●

Ordering example for the WY80AA grade: TC216-UNC6-C0-WY80AA

DIN 376



Designation	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N	WY80AA
TC216-UNC1/2-L0-	UNC 1/2-13	12,7	110	23	83	9	7	10	4	●
TC216-UNC5/8-L0-	UNC 5/8-11	15,875	110	25	68	12	9	12	4	●
TC216-UNC3/4-L0-	UNC 3/4-10	19,05	125	30	81	14	11	14	4	●

Ordering example for the WY80AA grade: TC216-UNC1/2-L0-WY80AA

B3

HSS-E-PM machine taps

mm

Prototex® TiNi



- Recommended with oil
- For long-chipping materials

$\leq 2 \times DN$

$B=3,5-5$

44HRC
 1400
 -700
 N/mm²

UNC
 ASME B1.1

3B

	P	M	K	N	S	H	O
TICN	●	●	●	●	●		
Uncoated	●	●	●	●	●		

~DIN 2184-1	Designation	Designation	D _N -P	D _N	l ₁	L _c	l ₃	d ₁	□	l _g	N
	TICN	Uncoated		mm	h9						
	2220706-UNC2	22207-UNC2	UNC 2-56	2,184	45	9	9	2,8	2,1	5	2
	2220706-UNC4	22207-UNC4	UNC 4-40	2,845	56	10	10	3,5	2,7	6	2
	2220706-UNC6	22207-UNC6	UNC 6-32	3,505	56	12	12	4	3	6	3
	2220706-UNC8	22207-UNC8	UNC 8-32	4,166	63	13	13	4,5	3,4	6	3
	2220706-UNC10	22207-UNC10	UNC 10-24	4,826	70	16	16	6	4,9	8	3
	2220706-UNC1/4	22207-UNC1/4	UNC 1/4-20	6,35	80	15	25	7	5,5	8	3
	2220706-UNC5/16	22207-UNC5/16	UNC 5/16-18	7,938	90	18	29,5	8	6,2	9	3
	2220706-UNC3/8	22207-UNC3/8	UNC 3/8-16	9,525	100	20	33,5	10	8	11	3

≤ UNC 10: Without reduced neck after the thread

DIN 2184-1	Designation	Designation	D _N -P	D _N	l ₁	L _c	l ₃	d ₁	□	l _g	N
	TICN	Uncoated		mm	h9						
	2225706-UNC7/16	22257-UNC7/16	UNC 7/16-14	11,113	100	20	76	8	6,2	9	4
	2225706-UNC1/2	22257-UNC1/2	UNC 1/2-13	12,7	110	23	83	9	7	10	4
	2225706-UNC5/8	22257-UNC5/8	UNC 5/8-11	15,875	110	25	68	12	9	12	4

WALTER
 SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

B3

HSS-E-PM machine taps

mm

Prototex® TiNi



- Recommended with oil
- For long-chipping materials

$\leq 2 \times DN$

$B=3,5-5$

44HRC
1400-700
N/mm²

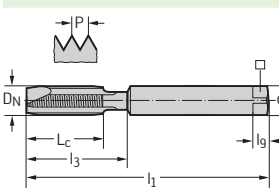
UNC

ASME B1.1

2B

	P	M	K	N	S	H	O
TICN	●	●	●	●	●	●	●
Uncoated	●	●	●	●	●	●	●

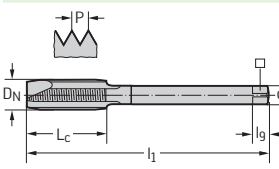
~DIN 2184-1



Designation TICN	Designation Uncoated	D _N -P	D _N mm	h ₉ mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l ₉ mm	N
2221706-UNC2	22217-UNC2	UNC 2-56	2,184	45	9	9	2,8	2,1	5	2
2221706-UNC4	22217-UNC4	UNC 4-40	2,845	56	10	10	3,5	2,7	6	2
2221706-UNC5	22217-UNC5	UNC 5-40	3,175	56	10	10	3,5	2,7	6	2
2221706-UNC6	22217-UNC6	UNC 6-32	3,505	56	12	12	4	3	6	3
2221706-UNC8	22217-UNC8	UNC 8-32	4,166	63	13	13	4,5	3,4	6	3
2221706-UNC10	22217-UNC10	UNC 10-24	4,826	70	16	16	6	4,9	8	3
2221706-UNC1/4	22217-UNC1/4	UNC 1/4-20	6,35	80	15	25	7	5,5	8	3
2221706-UNC5/16	22217-UNC5/16	UNC 5/16-18	7,938	90	18	29,5	8	6,2	9	3
2221706-UNC3/8	22217-UNC3/8	UNC 3/8-16	9,525	100	20	33,5	10	8	11	3

≤ UNC 10: Without reduced neck after the thread

DIN 2184-1



Designation TICN	Designation Uncoated	D _N -P	D _N mm	h ₉ mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l ₉ mm	N
2226706-UNC7/16	22267-UNC7/16	UNC 7/16-14	11,113	100	20	76	8	6,2	9	4
2226706-UNC1/2	22267-UNC1/2	UNC 1/2-13	12,7	110	23	83	9	7	10	4
2226706-UNC9/16	22267-UNC9/16	UNC 9/16-12	14,288	110	25	81	11	9	12	4
2226706-UNC5/8	22267-UNC5/8	UNC 5/8-11	15,875	110	25	68	12	9	12	4
2226706-UNC3/4	22267-UNC3/4	UNC 3/4-10	19,05	125	30	81	14	11	14	4

B3

HSS-E machine taps

TC115 Perform



– For long-chipping materials

UNC
ASME B1.1

2B

$\leq 3 \times DN$

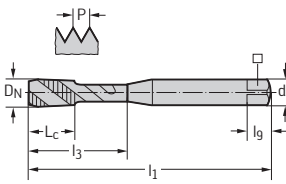
$C=2-3$

45°

32HRC
1000
-350
N/mm²

	P	M	K	N	S	H	O
WY80AA	●	●	●	●	●	●	●

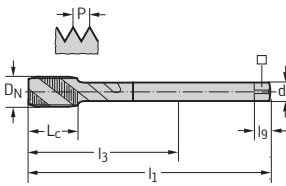
DIN 371



Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N	WY80AA
TC115-UNC6-C0-	UNC 6-32	3,505	56	6,5	20	4	3	6	3	
TC115-UNC8-C0-	UNC 8-32	4,166	63	7	21	4,5	3,4	6	3	
TC115-UNC10-C0-	UNC 10-24	4,826	70	8	25	6	4,9	8	3	
TC115-UNC1/4-C0-	UNC 1/4-20	6,35	80	10	30	7	5,5	8	3	
TC115-UNC5/16-C0-	UNC 5/16-18	7,938	90	12	35	8	6,2	9	3	
TC115-UNC3/8-C0-	UNC 3/8-16	9,525	100	15	39	10	8	11	3	

Ordering example for the WY80AA grade: TC115-UNC6-C0-WY80AA

DIN 376



Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N	WY80AA
TC115-UNC1/2-L0-	UNC 1/2-13	12,7	110	18	83	9	7	10	3	
TC115-UNC5/8-L0-	UNC 5/8-11	15,875	110	20	68	12	9	12	3	
TC115-UNC3/4-L0-	UNC 3/4-10	19,05	125	25	81	14	11	14	4	

Ordering example for the WY80AA grade: TC115-UNC1/2-L0-WY80AA

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

B3

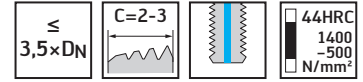
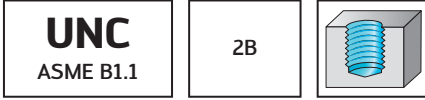
HSS-E machine taps

mm

Paradur® HT

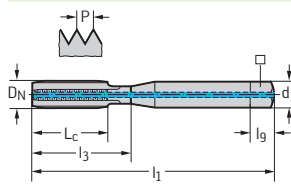


- For long-chipping and short-chipping materials



TIN	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

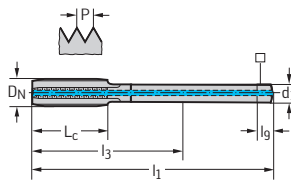
DIN 2184-1



Designation TIN	D _N -P	D _N mm	l ₁ mm	L _C mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
2231115-UNC1/4	UNC 1/4-20	6,35	80	15	30	7	5,5	8	3
2231115-UNC5/16	UNC 5/16-18	7,938	90	18	35	8	6,2	9	3
2231115-UNC3/8	UNC 3/8-16	9,525	100	20	39	10	8	11	3

B3

DIN 2184-1

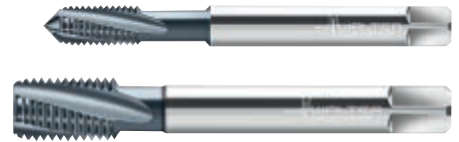


Designation TIN	D _N -P	D _N mm	l ₁ mm	L _C mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
2236115-UNC1/2	UNC 1/2-13	12,7	110	23	83	9	7	10	3
2236115-UNC5/8	UNC 5/8-11	15,875	110	25	68	12	9	12	3
2236115-UNC3/4	UNC 3/4-10	19,05	125	30	81	14	11	14	3
2236115-UNC1	UNC 1"-8	25,4	160	36	113	18	14,5	17	4

HSS-E-PM machine taps

mm

Paradur® Ni



- For long-chipping materials

≤
1,5×DN

C=2-3

25°

44HRC
1400
-700
N/mm²

UNC
ASME B1.1

2B

	P	M	K	N	S	H	O
TICN	●				●●		
Uncoated	●				●●		

~DIN 2184-1	Designation	Designation	D _N -P	D _N	l ₁	L _c	l ₃	d ₁	□	l _g	N
	TICN	Uncoated		mm	mm	mm	mm	h9	mm	mm	
	22410206-UNC2	224102-UNC2	UNC 2-56	2,184	45	9	9	2,8	2,1	5	3
	22410206-UNC3	224102-UNC3	UNC 3-48	2,515	50	9	9	2,8	2,1	5	3
	22410206-UNC4	224102-UNC4	UNC 4-40	2,845	56	10	10	3,5	2,7	6	3
	22410206-UNC6	224102-UNC6	UNC 6-32	3,505	56	12	12	4	3	6	3
	22410206-UNC8	224102-UNC8	UNC 8-32	4,166	63	13	13	4,5	3,4	6	3
	22410206-UNC10	224102-UNC10	UNC 10-24	4,826	70	16	16	6	4,9	8	3
	22410206-UNC1/4	224102-UNC1/4	UNC 1/4-20	6,35	80	15	25	7	5,5	8	3
	22410206-UNC5/16	224102-UNC5/16	UNC 5/16-18	7,938	90	18	29,5	8	6,2	9	3
	22410206-UNC3/8	224102-UNC3/8	UNC 3/8-16	9,525	100	20	33,5	10	8	11	4

≤ UNC 10: Without reduced neck after the thread

DIN 2184-1	Designation	Designation	D _N -P	D _N	l ₁	L _c	l ₃	d ₁	□	l _g	N
	TICN	Uncoated		mm	mm	mm	mm	h9	mm	mm	
	22460206-UNC7/16	224602-UNC7/16	UNC 7/16-14	11,113	100	20	76	8	6,2	9	4
	22460206-UNC1/2	224602-UNC1/2	UNC 1/2-13	12,7	110	23	83	9	7	10	4
	22460206-UNC5/8	224602-UNC5/8	UNC 5/8-11	15,875	110	25	68	12	9	12	4
	22460206-UNC3/4	224602-UNC3/4	UNC 3/4-10	19,05	125	30	81	14	11	14	5

WALTER SELECT

●● Primary application

● Other application

B3

HSS-E-PM machine taps

mm

Prototex® TiNi



- Recommended with oil
- For long-chipping materials

≤
2×DN

B=3,5-5

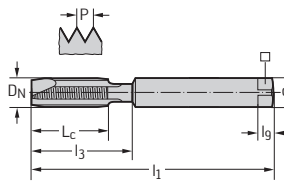
44HRC
1400
-700
N/mm²

UNF
ASME B1.1

3B

	P	M	K	N	S	H	O
TiCN	●	●	●	●	●	●	●
Uncoated	●	●	●	●	●	●	●

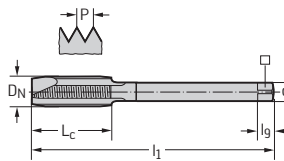
~DIN 2184-1



Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N
2320706-UNF4	23207-UNF4	UNF 4-48	2,845	56	10	10	3,5	2,7	6	2
2320706-UNF5	23207-UNF5	UNF 5-44	3,175	56	10	10	3,5	2,7	6	2
2320706-UNF6	23207-UNF6	UNF 6-40	3,505	56	12	12	4	3	6	3
2320706-UNF8	23207-UNF8	UNF 8-36	4,166	63	13	13	4,5	3,4	6	3
2320706-UNF10	23207-UNF10	UNF 10-32	4,826	70	16	16	6	4,9	8	3
2320706-UNF1/4	23207-UNF1/4	UNF 1/4-28	6,35	80	15	25	7	5,5	8	3
2320706-UNF5/16	23207-UNF5/16	UNF 5/16-24	7,938	90	18	29,5	8	6,2	9	3
2320706-UNF3/8	23207-UNF3/8	UNF 3/8-24	9,525	100	20	33,5	10	8	11	3

≤ UNF 10: Without reduced neck after the thread

DIN 2184-1



Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N
2325706-UNF7/16	23257-UNF7/16	UNF 7/16-20	11,113	100	20	76	8	6,2	9	4
2325706-UNF1/2	23257-UNF1/2	UNF 1/2-20	12,7	100	23	73	9	7	10	4
2325706-UNF5/8	23257-UNF5/8	UNF 5/8-18	15,875	100	25	58	12	9	12	4

B3

HSS-E-PM machine taps

mm

Prototex® TiNi



- Recommended with oil
- For long-chipping materials

≤
2×DN

B=3,5-5

44HRC
1400
-700
N/mm²

UNF
ASME B1.1

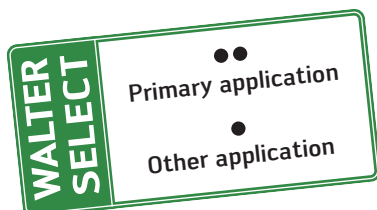
2B

	P	M	K	N	S	H	O
TiCN	●	●	●	●	●	●	●
Uncoated	●	●	●	●	●	●	●

~DIN 2184-1	Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N
	2321706-UNF5	23217-UNF5	UNF 5-44	3,175	56	10	10	3,5	2,7	6	2
	2321706-UNF6	23217-UNF6	UNF 6-40	3,505	56	12	12	4	3	6	3
	2321706-UNF10	23217-UNF10	UNF 10-32	4,826	70	16	16	6	4,9	8	3
	2321706-UNF1/4	23217-UNF1/4	UNF 1/4-28	6,35	80	15	25	7	5,5	8	3
	2321706-UNF5/16	23217-UNF5/16	UNF 5/16-24	7,938	90	18	29,5	8	6,2	9	3
	2321706-UNF3/8	23217-UNF3/8	UNF 3/8-24	9,525	100	20	33,5	10	8	11	3

≤ UNF 10: Without reduced neck after the thread

DIN 2184-1	Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ h9 mm	L _c mm	l ₃ mm	d ₁ mm	□ mm	l _g mm	N
	2326706-UNF7/16	23267-UNF7/16	UNF 7/16-20	11,113	100	20	76	8	6,2	9	4
	2326706-UNF1/2	23267-UNF1/2	UNF 1/2-20	12,7	100	23	73	9	7	10	4
	2326706-UNF5/8	23267-UNF5/8	UNF 5/8-18	15,875	100	25	58	12	9	12	4

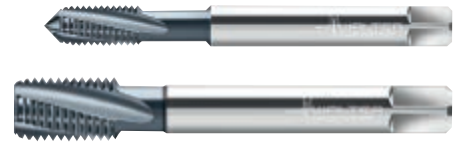


B3

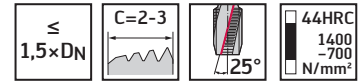
HSS-E-PM machine taps

mm

Paradur® Ni

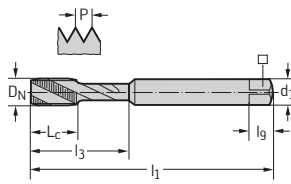


- For long-chipping materials



	P	M	K	N	S	H	O
TiCN	●	●	●	●	●	●	●
Uncoated	●	●	●	●	●	●	●

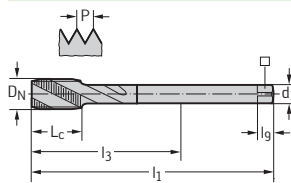
~DIN 2184-1



Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N
23410406-UNF8	234104-UNF8	UNF 8-36	4,166	63	13	42	4,5	3,4	6	3
23410406-UNF10	234104-UNF10	UNF 10-32	4,826	70	16	16	6	4,9	8	3
23410406-UNF12	234104-UNF12	UNF 12-28	5,486	80	15	23	6	4,9	8	3
23410406-UNF1/4	234104-UNF1/4	UNF 1/4-28	6,35	80	15	25	7	5,5	8	3
23410406-UNF5/16	234104-UNF5/16	UNF 5/16-24	7,938	90	18	29,5	8	6,2	9	3
23410406-UNF3/8	234104-UNF3/8	UNF 3/8-24	9,525	100	20	33,5	10	8	11	4

≤ UNF 10: Without reduced neck after the thread

DIN 2184-1



Designation TiCN	Designation Uncoated	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N
23460406-UNF7/16	234604-UNF7/16	UNF 7/16-20	11,113	100	20	76	8	6,2	9	4
23460406-UNF1/2	234604-UNF1/2	UNF 1/2-20	12,7	100	23	73	9	7	10	4
23460406-UNF5/8	234604-UNF5/8	UNF 5/8-18	15,875	100	25	58	12	9	12	4

B3

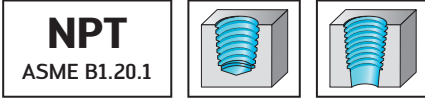
HSS-E machine taps

mm



Paradur® Ni

– For long-chipping materials



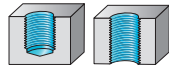


	P	M	K	N	S	H	O
TICN	●				●●		
Uncoated	●				●●		

PROTOTYPE TOOLS STANDARD	Designation	Designation	D _N -P	D _N mm	Threads per inch	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N
	TICN	Uncoated										
	2546706-NPT1/16	25467-NPT1/16	NPT 1/16-27	7,717	27	80	14	56	8	6,2	6	3
	2546706-NPT1/8	25467-NPT1/8	NPT 1/8-27	10,065	27	90	14	61	11	9	9	4
	2546706-NPT1/4	25467-NPT1/4	NPT 1/4-18	13,372	18	100	20	56	14	11	11	4
	2546706-NPT3/8	25467-NPT3/8	NPT 3/8-18	16,812	18	110	20	65	16	12	12	5
	2546706-NPT1/2	25467-NPT1/2	NPT 1/2-14	20,947	14	125	26	78	18	14,5	15	5
	2546706-NPT3/4	25467-NPT3/4	NPT 3/4-14	26,292	14	140	26	75	22	18	18	5
	2546706-NPT1	25467-NPT1	NPT 1"-11.5	32,914	12	150	31	81	28	22	22	5

Taper ratio 1:16

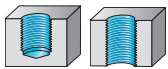

B3

Solid carbide taps product range overview M – Metric thread

Machining		
Thread depth	2 x D _N	
Designation	TC388 Supreme	TC389 Supreme
Dimension range	M 3–M 16	M 3–M 16
Tolerance	6HX	6HX
Coolant supply	external	external
Chamfer form	C	D
Coating/grade	WJ30BA	WE10BA
Version length	M	M
Page	469	470
		

B3

Solid carbide taps product range overview G

Machining	
Thread depth	2 x D _N
Designation	TC388 Supreme
Dimension range	G 1/8-28– G 1/4-19
Tolerance	NORMAL
Coolant supply	external
Chamfer form	C
Coating/grade	WJ30BA
Version length	M
Page	471
	

Solid carbide machine taps

TC388 Supreme



- Taps for hardened materials
- Drill core hole at upper tolerance end

≤
2×DN

C=2-3

63HRC
50HRC

M
DIN 13

6HX

WJ30BA

P	M	K	N	S	H	O
---	---	---	---	---	---	---

~DIN 371

	Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WJ30BA
	TC388-M3-C0-	M 3	0,5	56	8	35	3,5	2,7	6	4	☺
	TC388-M4-C0-	M 4	0,7	63	11	42	4,5	3,4	6	5	☺
	TC388-M5-C0-	M 5	0,8	70	13,5	47	6	4,9	8	5	☺
	TC388-M6-C0-	M 6	1	80	16,5	57	6	4,9	8	5	☺
	TC388-M8-C0-	M 8	1,25	90	21,5	66	8	6,2	9	5	☺
	TC388-M10-C0-	M 10	1,5	100	27	72	10	8	11	5	☺
	TC388-M12-C0-	M 12	1,75	110	32	68	12	9	12	6	☺
TC388-M16-C0-	M 16	2	110	41	65	16	12	15	6	☺	

Without reduced neck after the thread
 Ordering example for the WJ30BA grade: TC388-M3-C0-WJ30BA

B3

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

Solid carbide machine taps

TC389 Supreme



- Taps for hardened materials
- Drill core hole at upper tolerance end

≤
2×DN

D=3,5-5

65HRC
 55HRC

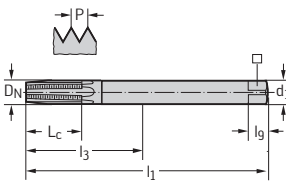
M
DIN 13

6HX

WE10BA

P	M	K	N	S	H	O
---	---	---	---	---	---	---

~DIN 371



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WE10BA
TC389-M3-CD-	M 3	0,5	56	9	35	3,5	2,7	6	4	☺
TC389-M4-CD-	M 4	0,7	63	12	42	4,5	3,4	6	5	☺
TC389-M5-CD-	M 5	0,8	70	14,5	47	6	4,9	8	5	☺
TC389-M6-CD-	M 6	1	80	18	57	6	4,9	8	5	☺
TC389-M8-CD-	M 8	1,25	90	23,5	66	8	6,2	9	5	☺
TC389-M10-CD-	M 10	1,5	100	29	72	10	8	11	5	☺
TC389-M12-CD-	M 12	1,75	110	34,5	68	12	9	12	6	☺
TC389-M16-CD-	M 16	2	110	44	65	16	12	15	6	☺

Without reduced neck after the thread
 Ordering example for the WE10BA grade: TC389-M3-CD-WE10BA

B3

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

•• Primary application

• Other application

Solid carbide machine taps

TC388 Supreme

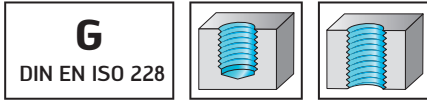


- Taps for hardened materials
- Drill core hole at upper tolerance end

≤
2×DN

C=2-3

63HRC
50HRC



WJ30BA	P	M	K	N	S	H	O
--------	---	---	---	---	---	---	---

~DIN 371	Designation	D _N -P	D _N mm	Threads per inch	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WJ30BA
	TC388-G1/8-C0-	G 1/8-28	9,728	28	90	23,5	62	10	8	11	5	⊕
	TC388-G1/4-C0-	G 1/4-19	13,157	19	100	32,5	56	14	11	14	6	⊕

Without reduced neck after the thread
 Ordering example for the WJ30BA grade: TC388-G1/8-C0-WJ30BA

B3

Product range overview of HSS-E(-PM) and solid carbide thread formers M – Metric thread




Machining						
Thread depth	3,5 × D _N				3,5 × D _N	
Designation	TC410 Advance	TC410 Advance	TC420 Supreme	TC470 Supreme	TC410 Advance	TC420 Supreme
Dimension range	M 1–M 24	M 3 LH–M 16 LH	M 2–M 20	M 3–M 10	M 2–M 24	M 2–M 20
Tolerance	6HX / 6GX / 7GX	6HX	6HX / 6GX	6HX	6HX / 6GX / 7GX	6HX / 6GX
Coolant supply	external	external	external	external	external	external/radial
Chamfer form	C / D	C	C	C	C	C
Coating/grade	WY80AD	WY80AD	WW60AD / WW60BA	WG20EL	WY80AD	WW60AD / WW60BA
Cutting tool material	HSS-E	HSS-E	HSS-E-PM	Solid carbide	HSS-E	HSS-E-PM
Page	475	477	483	496	480	486

Machining						
Thread depth	3,5 × D _N			3,5 × D _N		
Designation	TC430 Supreme	TC470 Supreme	TC420 Supreme	TC420 Supreme	TC430 Supreme	TC470 Supreme
Dimension range	M 3–M 16	M 3–M 10	M 5–M 16	M 2–M 16	M 8–M 16	M 5–M 10
Tolerance	6HX / 6GX	6HX	6HX	6HX / 6GX	6HX	6HX
Coolant supply	external/radial	external/radial	axial	external	axial	axial
Chamfer form	C	C	C	E	C	C / E
Coating/grade	WW60AD / WW60EL	WG20EL	WW60AD / WW60BA	WW60AD / WW60BA	WW60AD	WG20EL
Cutting tool material	HSS-E-PM	Solid carbide	HSS-E-PM	HSS-E-PM	HSS-E-PM	Solid carbide
Page	493	496	484	485	494	497

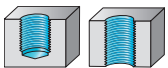


Product range overview of HSS-E(-PM) and solid carbide thread formers MF – Metric fine-pitch thread

Machining						
Thread depth	3,5 × D _N				3,5 × D _N	
Designation	TC410 Advance	TC420 Supreme	TC430 Supreme	TC470 Supreme	TC410 Advance	TC420 Supreme
Dimension range	MF 4x0.5– MF 30x2	MF 8x1– MF 16x1.5	MF 8x1– MF 16x1.5	MF 12x1.5– MF 16x1.5	MF 10x1– MF 16x1.5	MF 8x1– MF 14x1.5
Tolerance	6HX	6HX / 6GX	6HX	6HX	6GX	6HX
Coolant supply	external	external/radial	external/radial	radial	external	axial
Chamfer form	C	C	C	C	E	C
Coating/grade	WY80AD	WW60AD / WW60BA	WW60AD / WW60EL	WG20EL	WY80AD	WW60AD
Cutting tool material	HSS-E	HSS-E-PM	HSS-E-PM	Solid carbide	HSS-E-PM	HSS-E-PM
Page	499	500	502	504	500	502

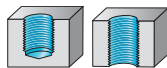

Product range overview of HSS-E(-PM) thread formers MF – Metric fine-pitch thread

Machining		
Thread depth	$3,5 \times D_N$	
Designation	TC430 Supreme	TC470 Supreme
Dimension range	MF 8x1– MF 16x1.5	MF 10x1– MF 16x1.5
Tolerance	6HX	6HX
Coolant supply	axial	axial
Chamfer form	C	C
Coating/grade	WW60AD	WG20EL
Cutting tool material	HSS-E-PM	Solid carbide
Page	503	504
		

Product range overview of HSS-E(-PM) thread formers UNC / UNF

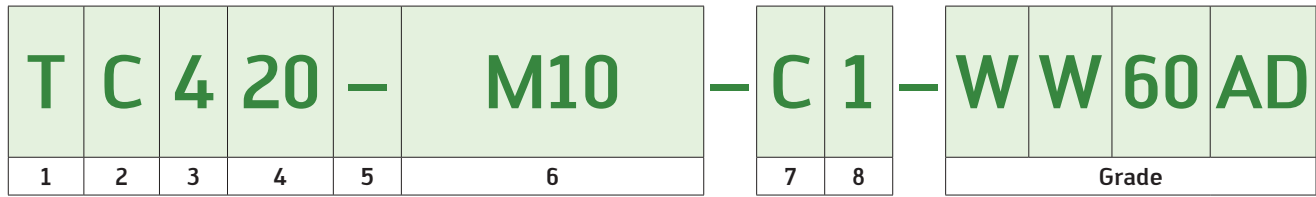
Machining		
Thread depth	$3,5 \times D_N$	
Designation	TC410 Advance	TC410 Advance
Dimension range	UNC 2-56– UNC 5/8-11	UNF 2-64– UNF 5/8-18
Tolerance	2BX	2BX
Coolant supply	external	external
Chamfer form	C	C
Coating/grade	WY80AD	WY80AD
Cutting tool material	HSS-E	HSS-E
Page	505	506
		

Product range overview of HSS-E(-PM) thread formers G

Machining	
Thread depth	$3,5 \times D_N$
Designation	TC410 Advance
Dimension range	G 1/8-28– G 1" -11
Tolerance	NORMAL
Coolant supply	external
Chamfer form	C
Coating/grade	WY80AD
Cutting tool material	HSS-E
Page	507
	

Designation key HSS-E(-PM) and solid carbide thread formers

Example:



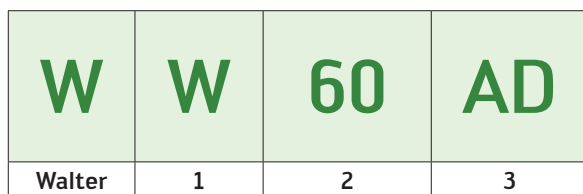
1	2	3	4				
Tool group	Generation	Tool type	Tool type				
T Threading		4 Thread formers	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">10 Universal, Advance</td> <td style="width: 50%;">30 ISO-P, Supreme</td> </tr> <tr> <td>20 Universal, Supreme</td> <td>70 ISO-P, Supreme</td> </tr> </table>	10 Universal, Advance	30 ISO-P, Supreme	20 Universal, Supreme	70 ISO-P, Supreme
10 Universal, Advance	30 ISO-P, Supreme						
20 Universal, Supreme	70 ISO-P, Supreme						

5	6	7	8																												
1. Delimiters	Thread dimensions	Tolerance/shank type	Modification																												
– Metric . DIN/ANSI		<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">C</td> <td style="width: 15%;">6HX, 2BX</td> <td>Reinforced shank</td> </tr> <tr> <td>E</td> <td>6GX</td> <td>Reinforced shank</td> </tr> <tr> <td>F</td> <td>7GX</td> <td>Reinforced shank</td> </tr> <tr> <td>L</td> <td>6HX, 2BX</td> <td>Reduced shank</td> </tr> <tr> <td>N</td> <td>6GX</td> <td>Reduced shank</td> </tr> <tr> <td>P</td> <td>7GX</td> <td>Reduced shank</td> </tr> </table>	C	6HX, 2BX	Reinforced shank	E	6GX	Reinforced shank	F	7GX	Reinforced shank	L	6HX, 2BX	Reduced shank	N	6GX	Reduced shank	P	7GX	Reduced shank	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">0 External coolant without lubrication grooves</td> <td style="width: 50%;">D Chamfer form D</td> </tr> <tr> <td>1 Axial internal coolant, without lubrication grooves</td> <td>E Chamfer form E</td> </tr> <tr> <td>2 Radial internal coolant</td> <td>L Left-hand thread</td> </tr> <tr> <td>5 Axial internal coolant with lubrication grooves</td> <td>H Extended shank XL</td> </tr> <tr> <td>6 External cooling with lubrication grooves</td> <td></td> </tr> </table>	0 External coolant without lubrication grooves	D Chamfer form D	1 Axial internal coolant, without lubrication grooves	E Chamfer form E	2 Radial internal coolant	L Left-hand thread	5 Axial internal coolant with lubrication grooves	H Extended shank XL	6 External cooling with lubrication grooves	
C	6HX, 2BX	Reinforced shank																													
E	6GX	Reinforced shank																													
F	7GX	Reinforced shank																													
L	6HX, 2BX	Reduced shank																													
N	6GX	Reduced shank																													
P	7GX	Reduced shank																													
0 External coolant without lubrication grooves	D Chamfer form D																														
1 Axial internal coolant, without lubrication grooves	E Chamfer form E																														
2 Radial internal coolant	L Left-hand thread																														
5 Axial internal coolant with lubrication grooves	H Extended shank XL																														
6 External cooling with lubrication grooves																															

B4

Grade designation key for solid carbide and HSS-E(-PM) cutting tool materials

Example:



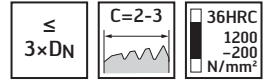
3	2	3												
Substrate	Application range	Coating												
<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">G</td> <td>Solid carbide</td> </tr> <tr> <td>W</td> <td>HSS-E-PM</td> </tr> <tr> <td>Y</td> <td>HSS-E</td> </tr> </table>	G	Solid carbide	W	HSS-E-PM	Y	HSS-E		<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">AD</td> <td>TiN</td> </tr> <tr> <td>BA</td> <td>TiCN</td> </tr> <tr> <td>EL</td> <td>AlCrN</td> </tr> </table>	AD	TiN	BA	TiCN	EL	AlCrN
G	Solid carbide													
W	HSS-E-PM													
Y	HSS-E													
AD	TiN													
BA	TiCN													
EL	AlCrN													

HSS-E machine thread formers

TC410 Advance



– For long-chipping materials

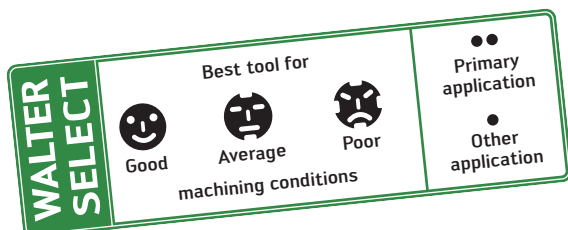


DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
	TC410-M1-C0-	M 1	0,25	40	5	5	2,5	2,1	5	3		
	TC410-M1.1-C0-	M 1.1	0,25	40	5	5	2,5	2,1	5	3		
	TC410-M1.2-C0-	M 1.2	0,25	40	5	5	2,5	2,1	5	3		
	TC410-M1.4-C0-	M 1.4	0,3	40	7	7	2,5	2,1	5	3		
	TC410-M1.6-C0-	M 1.6	0,35	40	7	7	2,5	2,1	5	3		
	TC410-M1.7-C0-	M 1.7	0,35	40	7	7	2,5	2,1	5	3		
	TC410-M1.8-C0-	M 1.8	0,35	40	7	7	2,5	2,1	5	3		
	TC410-M2-C0-	M 2	0,4	45	6	11	2,8	2,1	5	3		
	TC410-M2.2-C0-	M 2.2	0,45	45	7	12	2,8	2,1	5	3		
	TC410-M2.3-C0-	M 2.3	0,4	45	7	12	2,8	2,1	5	3		
TC410-M2.5-C0-	M 2.5	0,45	50	8	13	2,8	2,1	5	3			
TC410-M2.6-C0-	M 2.6	0,45	50	8	14	2,8	2,1	5	3			
TC410-M3-C0-	M 3	0,5	56	9	18	3,5	2,7	6	4			
TC410-M3.5-C0-	M 3.5	0,6	56	11	20	4	3	6	4			
TC410-M4-C0-	M 4	0,7	63	12	21	4,5	3,4	6	5			
TC410-M5-C0-	M 5	0,8	70	13	25	6	4,9	8	5			
TC410-M6-C0-	M 6	1	80	15	30	6	4,9	8	5			
TC410-M7-C0-	M 7	1	80	15	30	7	5,5	8	5			
TC410-M8-C0-	M 8	1,25	90	18	35	8	6,2	9	5			
TC410-M10-C0-	M 10	1,5	100	20	39	10	8	11	6			

Ordering example for the WY80AD grade: TC410-M1-C0-WY80AD

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
	TC410-M12-L0-	M 12	1,75	110	23	83	9	7	10	6		
	TC410-M14-L0-	M 14	2	110	25	81	11	9	12	6		
	TC410-M16-L0-	M 16	2	110	25	68	12	9	12	6		
	TC410-M18-L0-	M 18	2,5	125	30	81	14	11	14	7		
	TC410-M20-L0-	M 20	2,5	140	30	95	16	12	15	7		
	TC410-M24-L0-	M 24	3	160	36	113	18	14,5	17	8		

Ordering example for the WY80AD grade: TC410-M12-L0-WY80AD



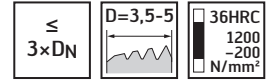
B4

HSS-E machine thread formers

TC410 Advance



- For long-chipping materials



DIN 2174											WY80AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		
TC410-M2-CD-	M 2	0,4	45	6	11	2,8	2,1	5	3	●	
TC410-M3-CD-	M 3	0,5	56	9	18	3,5	2,7	6	4	●	
TC410-M4-CD-	M 4	0,7	63	12	21	4,5	3,4	6	5	●	
TC410-M5-CD-	M 5	0,8	70	13	25	6	4,9	8	5	●	
TC410-M6-CD-	M 6	1	80	15	30	6	4,9	8	5	●	
TC410-M8-CD-	M 8	1,25	90	18	35	8	6,2	9	5	●	

Ordering example for the WY80AD grade: TC410-M2-CD-WY80AD

B4

WALTER SELECT

Best tool for machining conditions

😊
Good
😐
Average
😞
Poor

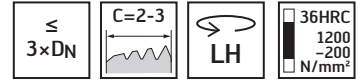
●●
Primary application
●
Other application

HSS-E machine thread formers

TC410 Advance



– For long-chipping materials



	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
		TC410-M3-CL-	M 3 - LH	0,5	56	9	18	3,5	2,7	6	4	
		TC410-M4-CL-	M 4 - LH	0,7	63	12	21	4,5	3,4	6	5	
		TC410-M5-CL-	M 5 - LH	0,8	70	13	25	6	4,9	8	5	
		TC410-M6-CL-	M 6 - LH	1	80	15	30	6	4,9	8	5	
		TC410-M8-CL-	M 8 - LH	1,25	90	18	35	8	6,2	9	5	
		TC410-M10-CL-	M 10 - LH	1,5	100	20	39	10	8	11	6	

Ordering example for the WY80AD grade: TC410-M3-CL-WY80AD

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
		TC410-M12-LL-	M 12 - LH	1,75	110	23	83	9	7	10	6	
		TC410-M16-LL-	M 16 - LH	2	110	25	68	12	9	12	6	

Ordering example for the WY80AD grade: TC410-M12-LL-WY80AD

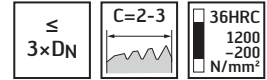
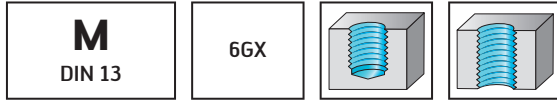
B4

HSS-E machine thread formers

TC410 Advance

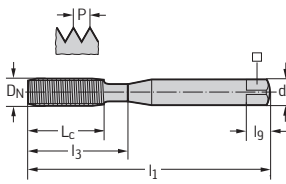


- For long-chipping materials



	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2174

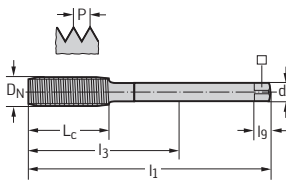


Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M2-E0-	M 2	0,4	45	6	11	2,8	2,1	5	3	●
TC410-M2.5-E0-	M 2.5	0,45	50	8	14	2,8	2,1	5	3	●
TC410-M3-E0-	M 3	0,5	56	9	18	3,5	2,7	6	4	●
TC410-M3.5-E0-	M 3.5	0,6	56	11	20	4	3	6	4	●
TC410-M4-E0-	M 4	0,7	63	12	21	4,5	3,4	6	5	●
TC410-M5-E0-	M 5	0,8	70	13	25	6	4,9	8	5	●
TC410-M6-E0-	M 6	1	80	15	30	6	4,9	8	5	●
TC410-M8-E0-	M 8	1,25	90	18	35	8	6,2	9	5	●
TC410-M10-E0-	M 10	1,5	100	20	39	10	8	11	6	●

Ordering example for the WY80AD grade: TC410-M2-E0-WY80AD

B4

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M12-N0-	M 12	1,75	110	23	83	9	7	10	6	●

Ordering example for the WY80AD grade: TC410-M12-N0-WY80AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E machine thread formers

TC410 Advance



– For long-chipping materials

$\leq 3 \times D_N$

$C=2-3$

36HRC
 1200
 -200
 N/mm²

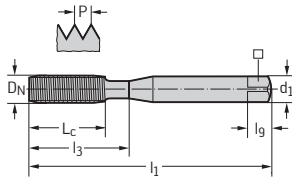
M
 DIN 13

7GX

WY80AD	P	M	K	N	S	H	O
	●	●	●	●	●		

DIN 2174											WY80AD
Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	mm	l_g mm	N		
TC410-M2-F0-	M 2	0,4	45	6	11	2,8	2,1	5	3		
TC410-M2.5-F0-	M 2.5	0,45	50	8	14	2,8	2,1	5	3		
TC410-M3-F0-	M 3	0,5	56	9	18	3,5	2,7	6	4		
TC410-M4-F0-	M 4	0,7	63	12	21	4,5	3,4	6	5		
TC410-M5-F0-	M 5	0,8	70	13	25	6	4,9	8	5		
TC410-M6-F0-	M 6	1	80	15	30	6	4,9	8	5		
TC410-M8-F0-	M 8	1,25	90	18	35	8	6,2	9	5		
TC410-M10-F0-	M 10	1,5	100	20	39	10	8	11	6		

Ordering example for the WY80AD grade: TC410-M2-F0-WY80AD



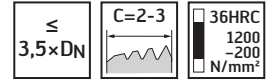
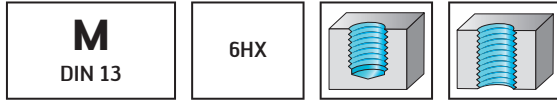
B4

HSS-E machine thread formers

TC410 Advance

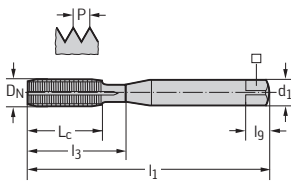


– For long-chipping materials



	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2174

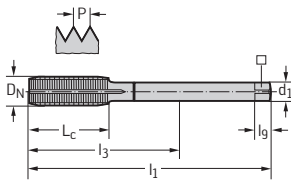


Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M2-C6-	M 2	0,4	45	6	11	2,8	2,1	5	3	●
TC410-M2.5-C6-	M 2.5	0,45	50	8	13	2,8	2,1	5	3	●
TC410-M3-C6-	M 3	0,5	56	9	18	3,5	2,7	6	4	●
TC410-M3.5-C6-	M 3.5	0,6	56	11	20	4	3	6	4	●
TC410-M4-C6-	M 4	0,7	63	12	21	4,5	3,4	6	5	●
TC410-M5-C6-	M 5	0,8	70	13	25	6	4,9	8	5	●
TC410-M6-C6-	M 6	1	80	15	30	6	4,9	8	5	●
TC410-M7-C6-	M 7	1	80	15	30	7	5,5	8	5	●
TC410-M8-C6-	M 8	1,25	90	18	35	8	6,2	9	5	●
TC410-M10-C6-	M 10	1,5	100	20	39	10	8	11	6	●

Ordering example for the WY80AD grade: TC410-M2-C6-WY80AD

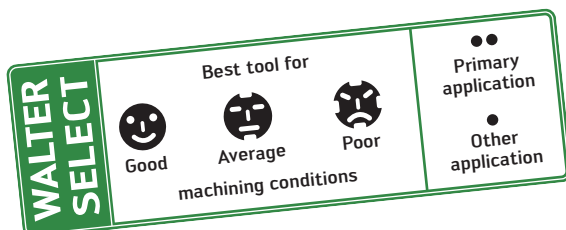
B4

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M12-L6-	M 12	1,75	110	23	83	9	7	10	6	●
TC410-M14-L6-	M 14	2	110	25	81	11	9	12	6	●
TC410-M16-L6-	M 16	2	110	25	68	12	9	12	6	●
TC410-M18-L6-	M 18	2,5	125	30	81	14	11	14	7	●
TC410-M20-L6-	M 20	2,5	140	30	95	16	12	15	7	●
TC410-M24-L6-	M 24	3	160	36	113	18	14,5	17	8	●

Ordering example for the WY80AD grade: TC410-M12-L6-WY80AD

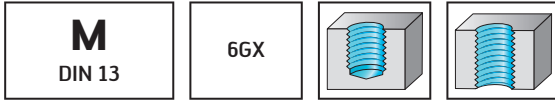


HSS-E machine thread formers

TC410 Advance



– For long-chipping materials



$\leq 3,5 \times D_N$

$C=2-3$

36HRC
1200
-200
N/mm²

	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
		TC410-M2-E6-	M 2	0,4	45	6	11	2,8	2,1	5	3	
		TC410-M2.5-E6-	M 2.5	0,45	50	8	14	2,8	2,1	5	3	
		TC410-M3-E6-	M 3	0,5	56	9	18	3,5	2,7	6	4	
		TC410-M3.5-E6-	M 3.5	0,6	56	11	20	4	3	6	4	
		TC410-M4-E6-	M 4	0,7	63	12	21	4,5	3,4	6	5	
		TC410-M5-E6-	M 5	0,8	70	13	25	6	4,9	8	5	
		TC410-M6-E6-	M 6	1	80	15	30	6	4,9	8	5	
		TC410-M8-E6-	M 8	1,25	90	18	35	8	6,2	9	5	
		TC410-M10-E6-	M 10	1,5	100	20	39	10	8	11	6	

Ordering example for the WY80AD grade: TC410-M2-E6-WY80AD

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
		TC410-M12-N6-	M 12	1,75	110	23	83	9	7	10	6	

Ordering example for the WY80AD grade: TC410-M12-N6-WY80AD

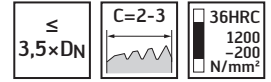
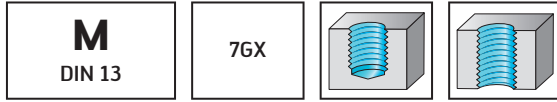
B4

HSS-E machine thread formers

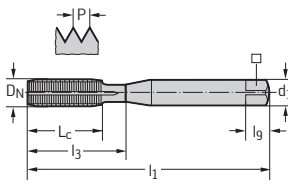
TC410 Advance



– For long-chipping materials



DIN 2174

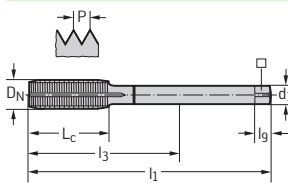


Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M2-F6-	M 2	0,4	45	6	11	2,8	2,1	5	3	☞
TC410-M2.5-F6-	M 2.5	0,45	50	8	14	2,8	2,1	5	3	☞
TC410-M3-F6-	M 3	0,5	56	9	18	3,5	2,7	6	4	☞
TC410-M4-F6-	M 4	0,7	63	12	21	4,5	3,4	6	5	☞
TC410-M5-F6-	M 5	0,8	70	13	25	6	4,9	8	5	☞
TC410-M6-F6-	M 6	1	80	15	30	6	4,9	8	5	☞
TC410-M8-F6-	M 8	1,25	90	18	35	8	6,2	9	5	☞
TC410-M10-F6-	M 10	1,5	100	20	39	10	8	11	6	☞

Ordering example for the WY80AD grade: TC410-M2-F6-WY80AD

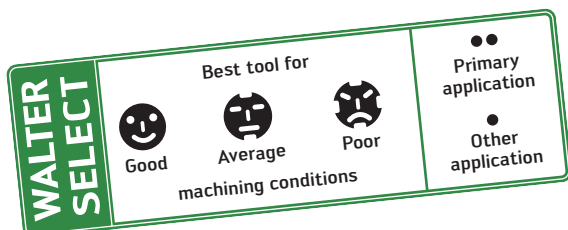
B4

DIN 2174



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M12-P6-	M 12	1,75	110	23	83	9	7	10	6	☞

Ordering example for the WY80AD grade: TC410-M12-P6-WY80AD



HSS-E-PM machine thread formers

TC420 Supreme



– For long-chipping materials

≤
3×DN

C=2-3

36HRC
1200
-200
N/mm²

M
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M2-C0-	M 2	0,4	45	4	11	2,8	2,1	5	3			
TC420-M2.5-C0-	M 2.5	0,45	50	4	14	2,8	2,1	5	3			
TC420-M3-C0-	M 3	0,5	56	6	18	3,5	2,7	6	4			
TC420-M3.5-C0-	M 3.5	0,6	56	7	20	4	3	6	4			
TC420-M4-C0-	M 4	0,7	63	7	21	4,5	3,4	6	5			
TC420-M5-C0-	M 5	0,8	70	8	25	6	4,9	8	5			
TC420-M6-C0-	M 6	1	80	10	30	6	4,9	8	5			
TC420-M8-C0-	M 8	1,25	90	12	35	8	6,2	9	5			
TC420-M10-C0-	M 10	1,5	100	15	39	10	8	11	6			

Ordering example for the WW60AD grade: TC420-M2-C0-WW60AD

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M12-L0-	M 12	1,75	110	16	83	9	7	10	6			
TC420-M14-L0-	M 14	2	110	20	81	11	9	12	6			
TC420-M16-L0-	M 16	2	110	20	68	12	9	12	6			
TC420-M20-L0-	M 20	2,5	140	25	95	16	12	15	7			

Ordering example for the WW60AD grade: TC420-M12-L0-WW60AD

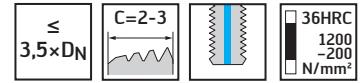
B4

HSS-E-PM machine thread formers

TC420 Supreme mm

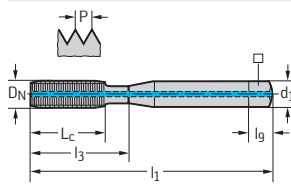


- For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174

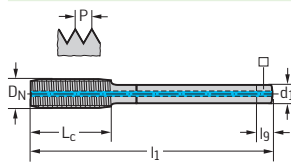


Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60AD	WW60BA
TC420-M5-C1-	M 5	0,8	70	8	25	6	4,9	8	5	●	●
TC420-M6-C1-	M 6	1	80	10	30	6	4,9	8	5	●	●
TC420-M8-C1-	M 8	1,25	90	12	35	8	6,2	9	5	●	●
TC420-M10-C1-	M 10	1,5	100	15	39	10	8	11	6	●	●

Ordering example for the WW60AD grade: TC420-M5-C1-WW60AD

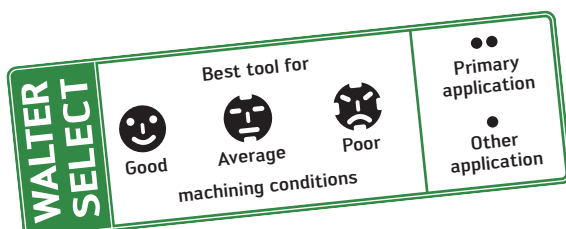
B4

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N	WW60AD	WW60BA
TC420-M12-L1-	M 12	1,75	110	16	83	9	7	10	6	●	●
TC420-M14-L1-	M 14	2	110	20	81	11	9	12	6	●	●
TC420-M16-L1-	M 16	2	110	20	68	12	9	12	6	●	●

Ordering example for the WW60AD grade: TC420-M12-L1-WW60AD



HSS-E-PM machine thread formers

TC420 Supreme



– For long-chipping materials

≤
3×DN

C=2-3

36HRC
1200
-200
N/mm²

M
DIN 13

6GX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M2-E0-	M 2	0,4	45	4	11	2,8	2,1	5	3			
TC420-M2.5-E0-	M 2.5	0,45	50	4	14	2,8	2,1	5	3			
TC420-M3-E0-	M 3	0,5	56	6	18	3,5	2,7	6	4			
TC420-M3.5-E0-	M 3.5	0,6	56	7	20	4	3	6	4			
TC420-M4-E0-	M 4	0,7	63	7	21	4,5	3,4	6	5			
TC420-M5-E0-	M 5	0,8	70	8	25	6	4,9	8	5			
TC420-M6-E0-	M 6	1	80	10	30	6	4,9	8	5			
TC420-M8-E0-	M 8	1,25	90	12	35	8	6,2	9	5			
TC420-M10-E0-	M 10	1,5	100	15	39	10	8	11	6			

Ordering example for the WW60AD grade: TC420-M2-E0-WW60AD

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M12-N0-	M 12	1,75	110	16	83	9	7	10	6			
TC420-M14-N0-	M 14	2	110	20	81	11	9	12	6			
TC420-M16-N0-	M 16	2	110	20	68	12	9	12	6			

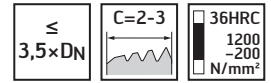
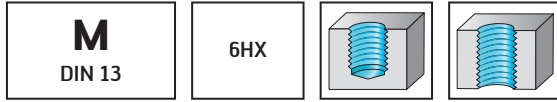
Ordering example for the WW60AD grade: TC420-M12-N0-WW60AD

HSS-E-PM machine thread formers

TC420 Supreme

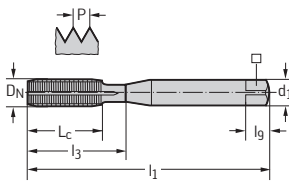


- For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174

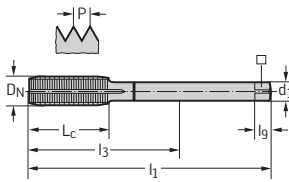


Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
TC420-M2-C6-	M 2	0,4	45	4	11	2,8	2,1	5	3	●	●
TC420-M2.5-C6-	M 2.5	0,45	50	4	14	2,8	2,1	5	3	●	●
TC420-M3-C6-	M 3	0,5	56	6	18	3,5	2,7	6	4	●	●
TC420-M3.5-C6-	M 3.5	0,6	56	7	20	4	3	6	4	●	●
TC420-M4-C6-	M 4	0,7	63	7	21	4,5	3,4	6	5	●	●
TC420-M5-C6-	M 5	0,8	70	8	25	6	4,9	8	5	●	●
TC420-M6-C6-	M 6	1	80	10	30	6	4,9	8	5	●	●
TC420-M8-C6-	M 8	1,25	90	12	35	8	6,2	9	5	●	●
TC420-M10-C6-	M 10	1,5	100	15	39	10	8	11	6	●	●

Ordering example for the WW60AD grade: TC420-M2-C6-WW60AD

B4

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
TC420-M12-L6-	M 12	1,75	110	16	83	9	7	10	6	●	●
TC420-M14-L6-	M 14	2	110	20	81	11	9	12	6	●	●
TC420-M16-L6-	M 16	2	110	20	68	12	9	12	6	●	●
TC420-M20-L6-	M 20	2,5	140	25	95	16	12	15	7	●	●

Ordering example for the WW60AD grade: TC420-M12-L6-WW60AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

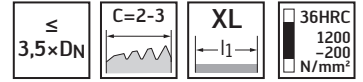
● Other application

HSS-E-PM machine thread formers

TC420 Supreme



– For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		

~DIN 371 XL											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC420-M3-CH-	M 3	0,5	125	6	18	3,5	2,7	6	4		
TC420-M4-CH-	M 4	0,7	125	7	21	4,5	3,4	6	5		
TC420-M5-CH-	M 5	0,8	140	8	25	6	4,9	8	5		
TC420-M6-CH-	M 6	1	160	10	30	6	4,9	8	5		

Ordering example for the WW60AD grade: TC420-M3-CH-WW60AD

~DIN 376 XL											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC420-M8-LH-	M 8	1,25	180	13	157	6	4,9	8	5		
TC420-M10-LH-	M 10	1,5	200	15	177	7	5,5	8	6		
TC420-M12-LH-	M 12	1,75	220	16	193	9	7	10	6		
TC420-M16-LH-	M 16	2	220	20	178	12	9	12	6		

Ordering example for the WW60AD grade: TC420-M8-LH-WW60AD

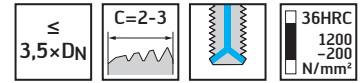
B4

HSS-E-PM machine thread formers

TC420 Supreme



- For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
		TC420-M5-C2-	M 5	0,8	70	8	25	6	4,9	8	5	●	●
		TC420-M6-C2-	M 6	1	80	10	30	6	4,9	8	5	●	●
		TC420-M8-C2-	M 8	1,25	90	12	35	8	6,2	9	5	●	●
		TC420-M10-C2-	M 10	1,5	100	15	39	10	8	11	6	●	●

Ordering example for the WW60AD grade: TC420-M5-C2-WW60AD

B4

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
		TC420-M12-L2-	M 12	1,75	110	16	83	9	7	10	6	●	●
		TC420-M14-L2-	M 14	2	110	20	81	11	9	12	6	●	●
		TC420-M16-L2-	M 16	2	110	20	68	12	9	12	6	●	●
		TC420-M20-L2-	M 20	2,5	140	25	95	16	12	15	7	●	●

Ordering example for the WW60AD grade: TC420-M12-L2-WW60AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E-PM machine thread formers

TC420 Supreme



– For long-chipping materials

≤
3,5×DN

E=1,5-2

36HRC
1200
-200
N/mm²

M
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M2-CE-	M 2	0,4	45	4	11	2,8	2,1	5	3			
TC420-M2.5-CE-	M 2.5	0,45	50	4	14	2,8	2,1	5	3			
TC420-M3-CE-	M 3	0,5	56	6	18	3,5	2,7	6	4			
TC420-M3.5-CE-	M 3.5	0,6	56	7	20	4	3	6	4			
TC420-M4-CE-	M 4	0,7	63	7	21	4,5	3,4	6	5			
TC420-M5-CE-	M 5	0,8	70	8	25	6	4,9	8	5			
TC420-M6-CE-	M 6	1	80	10	30	6	4,9	8	5			
TC420-M8-CE-	M 8	1,25	90	12	35	8	6,2	9	5			
TC420-M10-CE-	M 10	1,5	100	15	39	10	8	11	6			

Ordering example for the WW60AD grade: TC420-M2-CE-WW60AD

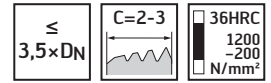
DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M12-LE-	M 12	1,75	110	16	83	9	7	10	6			
TC420-M14-LE-	M 14	2	110	20	81	11	9	12	6			
TC420-M16-LE-	M 16	2	110	20	68	12	9	12	6			

Ordering example for the WW60AD grade: TC420-M12-LE-WW60AD

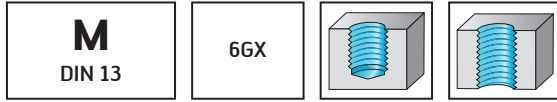
B4

HSS-E-PM machine thread formers

TC420 Supreme

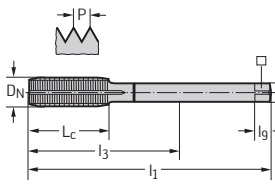


– For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174

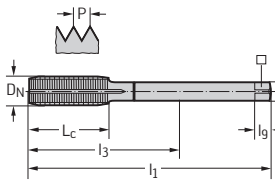


Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
TC420-M2-E6-	M 2	0,4	45	4	11	2,8	2,1	5	3	●	●
TC420-M2.5-E6-	M 2.5	0,45	50	4	14	2,8	2,1	5	3	●	●
TC420-M3-E6-	M 3	0,5	56	6	18	3,5	2,7	6	4	●	●
TC420-M3.5-E6-	M 3.5	0,6	56	7	20	4	3	6	4	●	●
TC420-M4-E6-	M 4	0,7	63	7	21	4,5	3,4	6	5	●	●
TC420-M5-E6-	M 5	0,8	70	8	25	6	4,9	8	5	●	●
TC420-M6-E6-	M 6	1	80	10	30	6	4,9	8	5	●	●
TC420-M8-E6-	M 8	1,25	90	12	35	8	6,2	9	5	●	●
TC420-M10-E6-	M 10	1,5	100	15	39	10	8	11	6	●	●

Ordering example for the WW60AD grade: TC420-M2-E6-WW60AD

B4

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
TC420-M12-N6-	M 12	1,75	110	16	83	9	7	10	6	●	
TC420-M14-N6-	M 14	2	110	20	81	11	9	12	6	●	
TC420-M16-N6-	M 16	2	110	20	68	12	9	12	6	●	

Ordering example for the WW60AD grade: TC420-M12-N6-WW60AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E-PM machine thread formers

TC420 Supreme



- For long-chipping materials

$\leq 3,5 \times DN$

$E=1,5-2$

36HRC
1200
-200
N/mm ²

M
DIN 13

6GX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M2-EE-	M 2	0,4	45	4	11	2,8	2,1	5	3		●	●
TC420-M2.5-EE-	M 2.5	0,45	50	4	14	2,8	2,1	5	3		●	●
TC420-M3-EE-	M 3	0,5	56	6	18	3,5	2,7	6	4		●	●
TC420-M4-EE-	M 4	0,7	63	7	21	4,5	3,4	6	5		●	●
TC420-M5-EE-	M 5	0,8	70	8	25	6	4,9	8	5		●	●
TC420-M6-EE-	M 6	1	80	10	30	6	4,9	8	5		●	●
TC420-M8-EE-	M 8	1,25	90	12	35	8	6,2	9	5		●	●
TC420-M10-EE-	M 10	1,5	100	15	39	10	8	11	6		●	●

Ordering example for the WW60AD grade: TC420-M2-EE-WW60AD

DIN 2174											WW60AD	WW60BA
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		WW60AD	WW60BA
TC420-M12-NE-	M 12	1,75	110	16	83	9	7	10	6		●	
TC420-M14-NE-	M 14	2	110	20	81	11	9	12	6		●	
TC420-M16-NE-	M 16	2	110	20	68	12	9	12	6		●	

Ordering example for the WW60AD grade: TC420-M12-NE-WW60AD

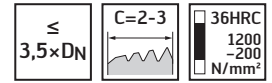
B4

HSS-E-PM machine thread formers

TC430 Supreme mm

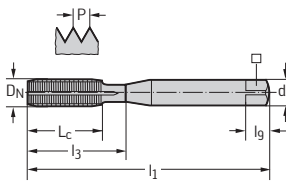


- For long-chipping materials
- ISO-M with oil only



	P	M	K	N	S	H	O
WW60EL	●	●	●	●			
WW60AD	●	●	●	●			

DIN 2174

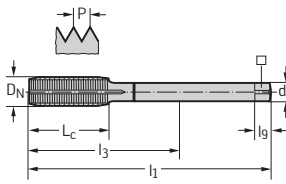


Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60EL	WW60AD
TC430-M3-C6-	M 3	0,5	56	6	18	3,5	2,7	6	4	●	
TC430-M4-C6-	M 4	0,7	63	7	21	4,5	3,4	6	5	●	
TC430-M5-C6-	M 5	0,8	70	8	25	6	4,9	8	5	●	
TC430-M6-C6-	M 6	1	80	10	30	6	4,9	8	5	●	
TC430-M8-C6-	M 8	1,25	90	12	35	8	6,2	9	6	●	
TC430-M10-C6-	M 10	1,5	100	15	39	10	8	11	7	●	●

Ordering example for the WW60AD grade: TC430-M8-C6-WW60AD

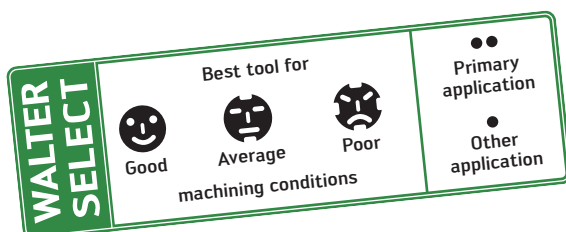
B4

DIN 2174



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60EL	WW60AD
TC430-M12-L6-	M 12	1,75	110	16	83	9	7	10	8	●	●
TC430-M16-L6-	M 16	2	110	20	68	12	9	12	8	●	●

Ordering example for the WW60AD grade: TC430-M12-L6-WW60AD

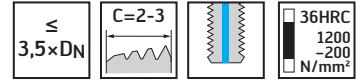


HSS-E-PM machine thread formers

TC430 Supreme



- For long-chipping materials
- ISO-M with oil only



	P	M	K	N	S	H	O
WW60AD	●	●	●	●			

DIN 2174											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC430-M8-C1-	M 8	1,25	90	12	35	8	6,2	9	6		
TC430-M10-C1-	M 10	1,5	100	15	39	10	8	11	7		

Ordering example for the WW60AD grade: TC430-M8-C1-WW60AD

DIN 2174											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC430-M12-L1-	M 12	1,75	110	16	83	9	7	10	8		
TC430-M16-L1-	M 16	2	110	20	68	12	9	12	8		

Ordering example for the WW60AD grade: TC430-M12-L1-WW60AD

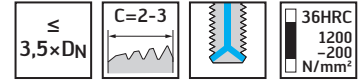
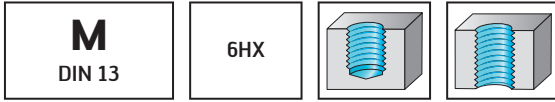
B4

HSS-E-PM machine thread formers

TC430 Supreme mm



- For long-chipping materials
- ISO-M with oil only



P	M	K	N	S	H	O
●	●	●	●			

DIN 2174											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC430-M8-C2-	M 8	1,25	90	12	35	8	6,2	9	6		
TC430-M10-C2-	M 10	1,5	100	15	39	10	8	11	7		

Ordering example for the WW60AD grade: TC430-M8-C2-WW60AD

B4

DIN 2174											WW60AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N		
TC430-M12-L2-	M 12	1,75	110	16	83	9	7	10	8		
TC430-M16-L2-	M 16	2	110	20	68	12	9	12	8		

Ordering example for the WW60AD grade: TC430-M12-L2-WW60AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

•• Primary application

• Other application

HSS-E-PM machine thread formers

TC430 Supreme



- For long-chipping materials
 - ISO-M with oil only

$\leq 3,5 \times D_N$

$C=2-3$

36HRC
 1200
 -200
 N/mm²

M
 DIN 13

6GX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●	●	●

DIN 2174		Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	\square mm	l_g mm	N	WW60AD
		TC430-M8-E6-	M 8	1,25	90	12	35	8	6,2	9	6	☸
		TC430-M10-E6-	M 10	1,5	100	15	39	10	8	11	7	☸

Ordering example for the WW60AD grade: TC430-M8-E6-WW60AD

DIN 2174		Designation	D_N	P mm	l_1 mm	L_c mm	l_3 mm	d_1 h9 mm	\square mm	l_g mm	N	WW60AD
		TC430-M12-N6-	M 12	1,75	110	16	83	9	7	10	8	☸
		TC430-M16-N6-	M 16	2	110	20	68	12	9	12	8	☸

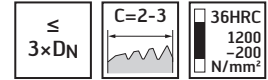
Ordering example for the WW60AD grade: TC430-M12-N6-WW60AD

B4

Solid carbide machine thread formers TC470 Supreme

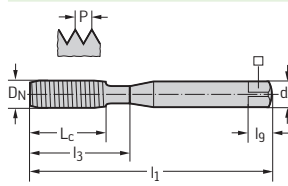


– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●	●	●	●			

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	mm	l _g mm	N	WG20EL
TC470-M3-C0-	M 3	0,5	56	10	10	3,5	2,7	6	4	🔴
TC470-M4-C0-	M 4	0,7	63	13	13	4,5	3,4	6	5	🔴
TC470-M5-C0-	M 5	0,8	70	16	16	6	4,9	8	5	🔴
TC470-M6-C0-	M 6	1	80	10	30	6	4,9	8	5	🔴
TC470-M8-C0-	M 8	1,25	90	12	35	8	6,2	9	6	🔴
TC470-M10-C0-	M 10	1,5	100	15	39	10	8	11	7	🔴

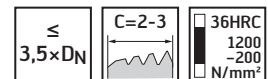
Ordering example for the WG20EL grade: TC470-M3-C0-WG20EL

B4

Solid carbide machine thread formers TC470 Supreme

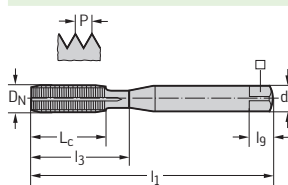


– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●	●	●	●			

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	mm	l _g mm	N	WG20EL
TC470-M3-C6-	M 3	0,5	56	10	10	3,5	2,7	6	4	🔴
TC470-M4-C6-	M 4	0,7	63	13	13	4,5	3,4	6	5	🔴
TC470-M5-C6-	M 5	0,8	70	16	16	6	4,9	8	5	🔴
TC470-M6-C6-	M 6	1	80	10	30	6	4,9	8	5	🔴
TC470-M8-C6-	M 8	1,25	90	12	35	8	6,2	9	6	🔴
TC470-M10-C6-	M 10	1,5	100	15	39	10	8	11	7	🔴

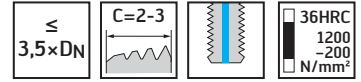
Ordering example for the WG20EL grade: TC470-M3-C6-WG20EL

🔴🔴🔴 / ★ New addition to the product range

Solid carbide machine thread formers TC470 Supreme



– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●●		●	●			

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WG20EL
		TC470-M5-C5-	M 5	0,8	70	16	16	6	4,9	8	5	●●
		TC470-M6-C5-	M 6	1	80	10	30	6	4,9	8	5	●●
		TC470-M8-C5-	M 8	1,25	90	12	35	8	6,2	9	6	●●
		TC470-M10-C5-	M 10	1,5	100	15	39	10	8	11	7	●●

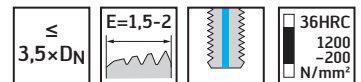
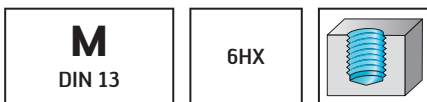
Ordering example for the WG20EL grade: TC470-M6-C5-WG20EL

B4

Solid carbide machine thread formers TC470 Supreme



– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●●		●	●			

DIN2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WG20EL
		TC470-M5-CE-	M 5	0,8	70	16	16	6	4,9	8	5	●●
		TC470-M6-CE-	M 6	1	80	10	30	6	4,9	8	5	●●
		TC470-M8-CE-	M 8	1,25	90	12	35	8	6,2	9	6	●●
		TC470-M10-CE-	M 10	1,5	100	15	39	10	8	11	7	●●

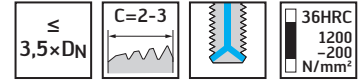
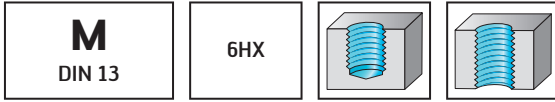
Ordering example for the WG20EL grade: TC470-M5-CE-WG20EL

Solid carbide machine thread formers

TC470 Supreme

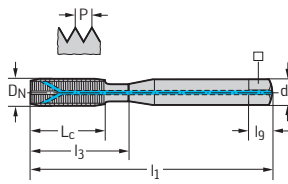


- For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●	●	●	●	●	●	●

DIN 2174



Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WG20EL
TC470-M6-C2-	M 6	1	80	10	30	6	4,9	8	5	●
TC470-M8-C2-	M 8	1,25	90	12	35	8	6,2	9	6	●
TC470-M10-C2-	M 10	1,5	100	15	39	10	8	11	7	●

Ordering example for the WG20EL grade: TC470-M6-C2-WG20EL

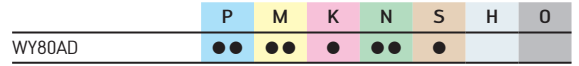
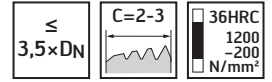
B4

HSS-E machine thread formers

TC410 Advance mm



– For long-chipping materials

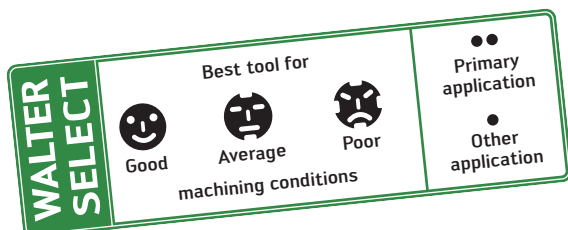


DIN 2174											WY80AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		
TC410-M4X0.5-C6-	MF 4x0.5	0,5	63	12	21	4,5	3,4	6	5		
TC410-M5X0.5-C6-	MF 5x0.5	0,5	70	13	25	6	4,9	8	5		
TC410-M6X0.5-C6-	MF 6x0.5	0,5	80	15	30	6	4,9	8	5		
TC410-M6X0.75-C6-	MF 6x0.75	0,75	80	15	30	6	4,9	8	5		
TC410-M7X0.75-C6-	MF 7x0.75	0,75	80	15	30	7	5,5	8	5		

Ordering example for the WY80AD grade: TC410-M4X0.5-C6-WY80AD

DIN 2174											WY80AD
Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N		
TC410-M8X0.5-L6-	MF 8x0.5	0,5	80	15	15	6	4,9	8	5		
TC410-M8X0.75-L6-	MF 8x0.75	0,75	80	15	15	6	4,9	8	5		
TC410-M8X1-L6-	MF 8x1	1	90	18	18	6	4,9	8	5		
TC410-M10X1-L6-	MF 10x1	1	90	20	20	7	5,5	8	6		
TC410-M10X1.25-L6-	MF 10x1.25	1,25	100	20	20	7	5,5	8	6		
TC410-M12X1-L6-	MF 12x1	1	100	21	73	9	7	10	6		
TC410-M12X1.25-L6-	MF 12x1.25	1,25	100	21	73	9	7	10	6		
TC410-M12X1.5-L6-	MF 12x1.5	1,5	100	21	73	9	7	10	6		
TC410-M14X1.5-L6-	MF 14x1.5	1,5	100	21	71	11	9	12	6		
TC410-M16X1.5-L6-	MF 16x1.5	1,5	100	21	58	12	9	12	6		
TC410-M18X1.5-L6-	MF 18x1.5	1,5	110	24	66	14	11	14	7		
TC410-M20X1.5-L6-	MF 20x1.5	1,5	125	24	80	16	12	15	7		
TC410-M20X2-L6-	MF 20x2	2	140	30	95	16	12	15	7		
TC410-M22X1.5-L6-	MF 22x1.5	1,5	125	24	78	18	14,5	17	7		
TC410-M24X1.5-L6-	MF 24x1.5	1,5	140	26	93	18	14,5	17	8		
TC410-M24X2-L6-	MF 24x2	2	140	26	93	18	14,5	17	8		
TC410-M27X1.5-L6-	MF 27x1.5	1,5	140	26	77	20	16	19	8		
TC410-M27X2-L6-	MF 27x2	2	140	26	77	20	16	19	8		
TC410-M30X1.5-L6-	MF 30x1.5	1,5	150	26	85	22	18	21	8		
TC410-M30X2-L6-	MF 30x2	2	150	26	85	22	18	21	8		

Ordering example for the WY80AD grade: TC410-M8X0.5-L6-WY80AD



B4

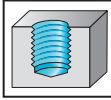
HSS-E machine thread formers TC410 Advance



- For long-chipping materials

MF
DIN 13

6GX



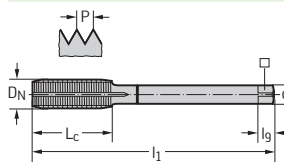
$\leq 3,5 \times DN$

$E=1,5-2$

36HRC
1200
-200
N/mm²

	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-M10X1-NE-	MF 10x1	1	90	20	20	7	5,5	8	6	●
TC410-M12X1.5-NE-	MF 12x1.5	1,5	100	21	73	9	7	10	6	●
TC410-M14X1.5-NE-	MF 14x1.5	1,5	100	21	71	11	9	12	7	●
TC410-M16X1.5-NE-	MF 16x1.5	1,5	100	21	58	12	9	12	7	●

Ordering example for the WY80AD grade: TC410-M10X1-NE-WY80AD

B4

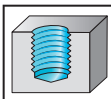
HSS-E-PM machine thread formers TC420 Supreme



- For long-chipping materials

MF
DIN 13

6HX



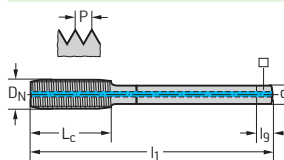
$\leq 3,5 \times DN$

$C=2-3$

36HRC
1200
-200
N/mm²

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		

DIN 2174





Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD
TC420-M8X1-L1-	MF 8x1	1	90	12	67	6	4,9	8	5	●
TC420-M10X1-L1-	MF 10x1	1	90	12	67	7	5,5	8	6	●
TC420-M12X1-L1-	MF 12x1	1	100	13	73	9	7	10	6	●
TC420-M12X1.5-L1-	MF 12x1.5	1,5	100	13	73	9	7	10	6	●
TC420-M14X1.5-L1-	MF 14x1.5	1,5	100	15	71	11	9	12	6	●


Ordering example for the WW60AD grade: TC420-M8X1-L1-WW60AD

WALTER SELECT

Best tool for


Good


Average


Poor

machining conditions

●● Primary application

● Other application

HSS-E-PM machine thread formers TC420 Supreme



– For long-chipping materials

≤
3,5×DN

C=2-3

36HRC
1200
-200
N/mm²

MF
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD							
WW60BA							

DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N	WW60AD	WW60BA
		TC420-M8X1-L6-	MF 8x1	1	90	12	67	6	4,9	8	5		
		TC420-M10X1-L6-	MF 10x1	1	90	12	67	7	5,5	8	6		
		TC420-M12X1-L6-	MF 12x1	1	100	13	73	9	7	10	6		
		TC420-M12X1.5-L6-	MF 12x1.5	1,5	100	13	73	9	7	10	6		
		TC420-M14X1-L6-	MF 14x1	1	100	15	71	11	9	12	6		
		TC420-M14X1.25-L6-	MF 14x1.25	1,25	100	15	71	11	9	12	6		
		TC420-M14X1.5-L6-	MF 14x1.5	1,5	100	15	71	11	9	12	6		
	TC420-M16X1.5-L6-	MF 16x1.5	1,5	100	15	58	12	9	12	6			

Ordering example for the WW60AD grade: TC420-M8X1-L6-WW60AD

B4

HSS-E-PM machine thread formers TC420 Supreme



– For long-chipping materials

≤
3,5×DN

C=2-3

36HRC
1200
-200
N/mm²

MF
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD							
WW60BA							

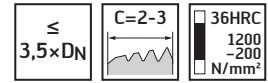
DIN 2174		Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l ₉ mm	N	WW60AD	WW60BA
		TC420-M8X1-L2-	MF 8x1	1	90	12	67	6	4,9	8	5		
		TC420-M10X1-L2-	MF 10x1	1	90	12	67	7	5,5	8	6		
		TC420-M12X1-L2-	MF 12x1	1	100	13	73	9	7	10	6		
		TC420-M12X1.5-L2-	MF 12x1.5	1,5	100	13	73	9	7	10	6		
		TC420-M14X1.5-L2-	MF 14x1.5	1,5	100	15	71	11	9	12	6		
		TC420-M16X1.5-L2-	MF 16x1.5	1,5	100	15	58	12	9	12	6		

Ordering example for the WW60AD grade: TC420-M8X1-L2-WW60AD

HSS-E-PM machine thread formers TC420 Supreme

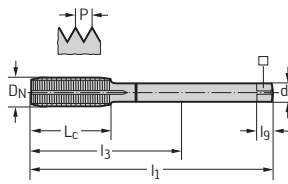


– For long-chipping materials



	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		
WW60BA	●	●	●	●	●		

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD	WW60BA
TC420-M8X1-N6-	MF 8x1	1	90	12	67	6	4,9	8	5	●	●
TC420-M10X1-N6-	MF 10x1	1	90	12	67	7	5,5	8	6	●	●
TC420-M12X1-N6-	MF 12x1	1	100	13	73	9	7	10	6	●	●
TC420-M12X1.5-N6-	MF 12x1.5	1,5	100	13	73	9	7	10	6	●	●
TC420-M14X1.5-N6-	MF 14x1.5	1,5	100	15	71	11	9	12	6	●	●
TC420-M16X1.5-N6-	MF 16x1.5	1,5	100	15	58	12	9	12	6	●	●

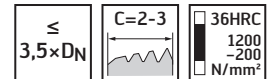
Ordering example for the WW60AD grade: TC420-M8X1-N6-WW60AD

B4

HSS-E-PM machine thread formers TC430 Supreme

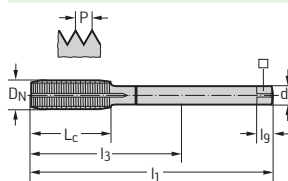


– For long-chipping materials
– ISO-M with oil only



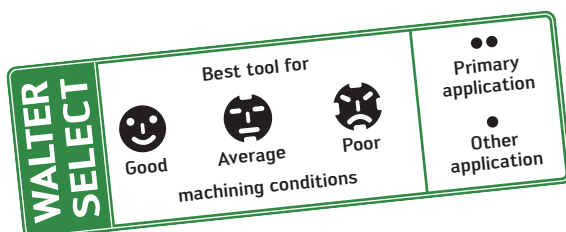
	P	M	K	N	S	H	O
WW60EL	●	●	●	●			
WW60AD	●	●	●	●			

DIN 2174



Designation	DN	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60EL	WW60AD
TC430-M8X1-L6-	MF 8x1	1	90	12	67	6	4,9	8	6	●	●
TC430-M10X1-L6-	MF 10x1	1	90	12	67	7	5,5	8	7	●	●
TC430-M10X1.25-L6-	MF 10x1.25	1,25	100	15	77	7	5,5	8	7	●	●
TC430-M12X1-L6-	MF 12x1	1	100	13	73	9	7	10	8	●	●
TC430-M12X1.25-L6-	MF 12x1.25	1,25	100	13	73	9	7	10	8	●	●
TC430-M12X1.5-L6-	MF 12x1.5	1,5	100	13	73	9	7	10	8	●	●
TC430-M14X1.5-L6-	MF 14x1.5	1,5	100	15	71	11	9	12	8	●	●
TC430-M16X1.5-L6-	MF 16x1.5	1,5	100	15	58	12	9	12	8	●	●

Ordering example for the WW60AD grade: TC430-M8X1-L6-WW60AD



HSS-E-PM machine thread formers TC430 Supreme



- For long-chipping materials
- ISO-M with oil only

≤
3,5×DN

C=2-3

36HRC
1200
-200
N/mm²

MF
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		

DIN 2174	Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD
	TC430-M8X1-L1-	MF 8x1	1	90	12	67	6	4,9	8	6	
	TC430-M10X1-L1-	MF 10x1	1	90	12	67	7	5,5	8	7	
	TC430-M10X1.25-L1-	MF 10x1.25	1,25	100	15	77	7	5,5	8	7	
	TC430-M12X1-L1-	MF 12x1	1	100	13	73	9	7	10	8	
	TC430-M12X1.25-L1-	MF 12x1.25	1,25	100	13	73	9	7	10	8	
	TC430-M12X1.5-L1-	MF 12x1.5	1,5	100	13	73	9	7	10	8	
	TC430-M14X1.5-L1-	MF 14x1.5	1,5	100	15	71	11	9	12	8	
	TC430-M16X1.5-L1-	MF 16x1.5	1,5	100	15	58	12	9	12	8	

Ordering example for the WW60AD grade: TC430-M8X1-L1-WW60AD

HSS-E-PM machine thread formers TC430 Supreme



- For long-chipping materials
- ISO-M with oil only

≤
3,5×DN

C=2-3

36HRC
1200
-200
N/mm²

MF
DIN 13

6HX

	P	M	K	N	S	H	O
WW60AD	●	●	●	●	●		

DIN 2174	Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WW60AD
	TC430-M8X1-L2-	MF 8x1	1	90	12	67	6	4,9	8	6	
	TC430-M10X1-L2-	MF 10x1	1	90	12	67	7	5,5	8	7	
	TC430-M10X1.25-L2-	MF 10x1.25	1,25	100	15	77	7	5,5	8	7	
	TC430-M12X1-L2-	MF 12x1	1	100	13	73	9	7	10	8	
	TC430-M12X1.25-L2-	MF 12x1.25	1,25	100	13	73	9	7	10	8	
	TC430-M12X1.5-L2-	MF 12x1.5	1,5	100	13	73	9	7	10	8	
	TC430-M14X1.5-L2-	MF 14x1.5	1,5	100	15	71	11	9	12	8	
	TC430-M16X1.5-L2-	MF 16x1.5	1,5	100	15	58	12	9	12	8	

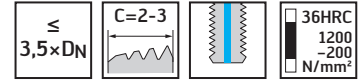
Ordering example for the WW60AD grade: TC430-M8X1-L2-WW60AD

B4

Solid carbide machine thread formers TC470 Supreme



– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●	●	●	●	●	●	●

DIN 2174

Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WG20EL
TC470-M10X1-L5-	MF 10x1	1	90	14	67	7	5,5	8	7	⚙️
TC470-M12X1.5-L5-	MF 12x1.5	1,5	100	13	73	9	7	10	8	⚙️
TC470-M14X1.5-L5-	MF 14x1.5	1,5	100	15	58	11	9	12	8	⚙️
TC470-M16X1.5-L5-	MF 16x1.5	1,5	100	15	58	12	9	12	8	⚙️

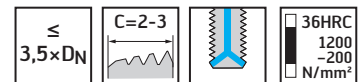
Ordering example for the WG20EL grade: TC470-M10X1-L5-WG20EL

B4

Solid carbide machine thread formers TC470 Supreme



– For long-chipping materials



	P	M	K	N	S	H	O
WG20EL	●	●	●	●	●	●	●

DIN 2174

Designation	D _N	P mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h6 mm	□ mm	l _g mm	N	WG20EL
TC470-M12X1.5-L2-	MF 12x1.5	1,5	100	13	73	9	7	10	8	⚙️
TC470-M14X1.5-L2-	MF 14x1.5	1,5	100	15	58	11	9	12	8	⚙️
TC470-M16X1.5-L2-	MF 16x1.5	1,5	100	15	58	12	9	12	8	⚙️

Ordering example for the WG20EL grade: TC470-M12X1.5-L2-WG20EL

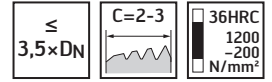
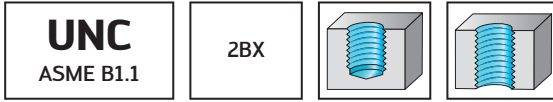
⚙️ ⚙️ ⚙️ / ★ New addition to the product range

HSS-E machine thread formers

TC410 Advance

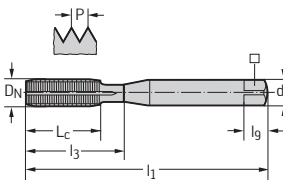


– For long-chipping materials



	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

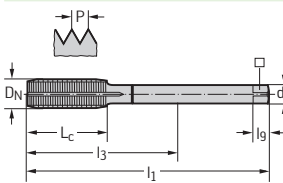
DIN 2184-1



Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-UNC2-C6-	UNC 2-56	2,184	45	7	12	2,8	2,1	5	3	●
TC410-UNC4-C6-	UNC 4-40	2,845	56	9	18	3,5	2,7	6	3	●
TC410-UNC6-C6-	UNC 6-32	3,505	56	11	20	4	3	6	4	●
TC410-UNC8-C6-	UNC 8-32	4,166	63	12	21	4,5	3,4	6	5	●
TC410-UNC10-C6-	UNC 10-24	4,826	70	13	25	6	4,9	8	5	●
TC410-UNC1/4-C6-	UNC 1/4-20	6,35	80	15	30	7	5,5	8	5	●
TC410-UNC5/16-C6-	UNC 5/16-18	7,938	90	18	35	8	6,2	9	5	●
TC410-UNC3/8-C6-	UNC 3/8-16	9,525	100	20	39	10	8	11	5	●

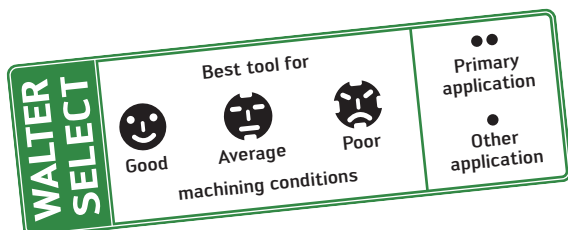
Ordering example for the WY80AD grade: TC410-UNC2-C6-WY80AD

DIN 2184-1



Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-UNC7/16-L6-	UNC 7/16-14	11,113	100	20	76	8	6,2	9	6	●
TC410-UNC1/2-L6-	UNC 1/2-13	12,7	110	23	83	9	7	10	6	●
TC410-UNC5/8-L6-	UNC 5/8-11	15,875	110	25	68	12	9	12	6	●

Ordering example for the WY80AD grade: TC410-UNC7/16-L6-WY80AD



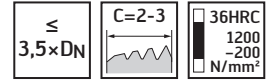
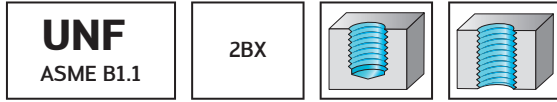
B4

HSS-E machine thread formers

TC410 Advance

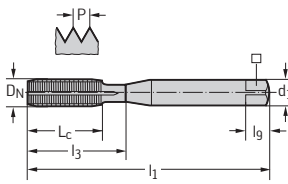


- For long-chipping materials



	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2184-1

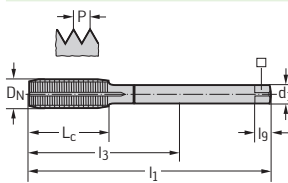


Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-UNF2-C6-	UNF 2-64	2,184	45	7	12	2,8	2,1	5	3	●
TC410-UNF4-C6-	UNF 4-48	2,845	56	9	18	3,5	2,7	6	3	●
TC410-UNF6-C6-	UNF 6-40	3,505	56	11	20	4	3	6	4	●
TC410-UNF8-C6-	UNF 8-36	4,166	63	12	21	4,5	3,4	6	5	●
TC410-UNF10-C6-	UNF 10-32	4,826	70	13	25	6	4,9	8	5	●
TC410-UNF1/4-C6-	UNF 1/4-28	6,35	80	15	30	7	5,5	8	5	●
TC410-UNF5/16-C6-	UNF 5/16-24	7,938	90	18	35	8	6,2	9	5	●
TC410-UNF3/8-C6-	UNF 3/8-24	9,525	90	20	39	10	8	11	5	●

Ordering example for the WY80AD grade: TC410-UNF2-C6-WY80AD

B4

DIN 2184-1



Designation	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
TC410-UNF7/16-L6-	UNF 7/16-20	11,113	100	20	76	8	6,2	9	6	●
TC410-UNF1/2-L6-	UNF 1/2-20	12,7	100	21	73	9	7	10	6	●
TC410-UNF5/8-L6-	UNF 5/8-18	15,875	100	21	58	12	9	12	6	●

Ordering example for the WY80AD grade: TC410-UNF7/16-L6-WY80AD

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

HSS-E machine thread formers

TC410 Advance

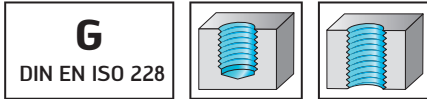


– For long-chipping materials

$\leq 3,5 \times D_N$

$C=2-3$

36HRC
 1200
 -200
 N/mm²








	P	M	K	N	S	H	O
WY80AD	●	●	●	●	●		

DIN 2189	Designation	D _N -P	D _N mm	Threads per inch	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	□ mm	l _g mm	N	WY80AD
	TC410-G1/8-N6-	G 1/8-28	9,728	28	90	20	20	7	5,5	8	5	
	TC410-G1/4-N6-	G 1/4-19	13,157	19	100	21	71	11	9	12	6	
	TC410-G3/8-N6-	G 3/8-19	16,662	19	100	21	58	12	9	12	6	
	TC410-G1/2-N6-	G 1/2-14	20,955	14	125	24	80	16	12	15	8	
	TC410-G3/4-N6-	G 3/4-14	26,441	14	140	26	77	20	16	19	8	
	TC410-G1-N6-	G 1"-11	33,249	11	160	28	93	25	20	23	8	

Ordering example for the WY80AD grade: TC410-G1/8-N6-WY80AD

B4

Product range overview of thread milling cutters

Machining	Universal				
	2 × D _N		2,5 × D _N		3 × D _N
Thread depth	2 × D _N		2,5 × D _N		3 × D _N
Designation	TC620 Supreme	T2711	TC620 Supreme	T2712	T2713
Description	Multiple-row thread milling cutter	Thread milling cutter with indexable inserts	Multiple-row thread milling cutter	Thread milling cutter with indexable inserts	Thread milling cutter with indexable inserts
Coolant supply	axial	axial/radial	axial	axial/radial	axial/radial
Coating/grade	WB10TJ	WSM37S	WB10TJ	WSM37S	WSM37S
Shank	DIN 6535 HA	DIN 1835 B	DIN 6535 HA	DIN 1835 B	DIN 1835 B / Walter Capto™
Helix angle	20°	–	20°	–	–
Thread type Page	M / MF 511 UNC 512	M / MF 518 UNC / UNF / UN 524	M / MF 511	M / MF 520 UNC / UNF / UN 526 G (BSP) 532	M / MF 522 UNC / UNF / UN 528 G (BSP) 532
					

		Specific	
		$2 \times D_N$	$2,5 \times D_N$
		TC685 Supreme	TC685 Supreme
		Orbital drill thread milling cutter for hard machining	Orbital drill thread milling cutter for hard machining
		external/axial	external/axial
		WB10RC	WB10RC
		DIN 6535 HA	DIN 6535 HA
		-15°	-15°
		M / MF UNC 513 515	M / MF UNC 514 516

Designation key Solid carbide thread milling cutters

Example:

T	C	6	85	-	M10	-	A	1	D	-	W	B	10	RC
1	2	3	4	5	6		7	8	9		Grade			

1	2	3	4	
Tool group	Generation	Tool type	Tool type	
T Threading		6 Solid carbide thread milling cutters	10 Universal, 1.5 × D _N 11 Universal, 2.0 × D _N 20 Universal, multiple-row	85 ISO H, orbital drill thread milling cutter
5	6	7	8	9
1. Delimiters	Thread dimensions	Shank type	Cooling	Thread depth
- Metric		A Parallel shank W Weldon shank	0 External coolant 1 Axial internal coolant	D 2.0 × D _N E 2.5 × D _N

B5

Grade designation key for solid carbide and HSS cutting tool materials

Example:

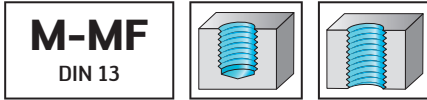
W	B	10	RC
Walter	1	2	3

1	2	3
Substrate	Application range	Coating
Solid carbide B J HSS		RC TiAlN RD TiAlN (+ ZrN) TJ TiAlN

Multiple-row thread milling cutters TC620 Supreme



- Universal multiple-row thread milling cutter
- For high cutting speeds and high feeds per tooth



	P	M	K	N	S	H	O
WB10TJ	●	●	●	●	●		●

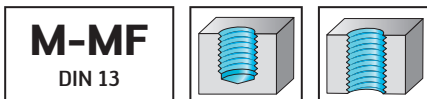
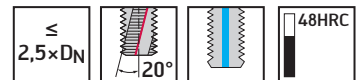
Tool	Designation	P mm	D _c mm	l ₂₁ mm	L _c mm	l ₄ mm	l ₁ mm	d ₁ mm	Z	WB10TJ
Shank DIN 6535 HA 	TC620-M4-A1D-	0,7	3,1	1,4	8,4	21	57	6	3	●
	TC620-M5-A1D-	0,8	3,9	1,6	10,4	21	57	6	3	●
	TC620-M6-A1D-	1	4,7	2	12	21	57	6	4	●
	TC620-M8-A1D-	1,25	6,3	2,5	16,3	27	63	8	4	●
	TC620-M10-A1D-	1,5	7,9	3	21	27	63	8	4	●
	TC620-M12-A1D-	1,75	9,6	3,5	24,5	32	72	10	4	●
	TC620-M14-A1D-	2	11,2	4	28	38	83	12	4	●
	TC620-M16-A1D-	2	13,1	4	32	44	92	16	5	●
	TC620-M20-A1D-	2,5	16,4	5	40	58	106	18	5	●

Ordering example for the WB10TJ grade: TC620-M4-A1D-WB10TJ

Multiple-row thread milling cutters TC620 Supreme



- Universal multiple-row thread milling cutter
- For high cutting speeds and high feeds per tooth



	P	M	K	N	S	H	O
WB10TJ	●	●	●	●	●		●

Tool	Designation	P mm	D _c mm	l ₂₁ mm	L _c mm	l ₄ mm	l ₁ mm	d ₁ mm	Z	WB10TJ
Shank DIN 6535 HA 	TC620-M4-A1E-	0,7	3,1	2,1	10,5	21	57	6	3	●
	TC620-M5-A1E-	0,8	3,9	2,4	12,8	21	57	6	3	●
	TC620-M6-A1E-	1	4,7	3	15	21	57	6	4	●
	TC620-M8-A1E-	1,25	6,3	3,75	20	27	63	8	4	●
	TC620-M10-A1E-	1,5	7,9	4,5	27	36	72	8	4	●
	TC620-M12-A1E-	1,75	9,6	5,25	31,5	43	83	10	4	●
	TC620-M14-A1E-	2	11,2	6	36	55	100	12	4	●
	TC620-M16-A1E-	2	13,1	6	42	58	106	16	5	●
	TC620-M20-A1E-	2,5	16,4	7,5	52,5	68	116	18	5	●

Ordering example for the WB10TJ grade: TC620-M4-A1E-WB10TJ

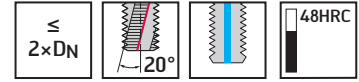
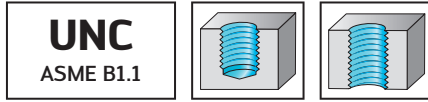
B5

Multiple-row thread milling cutters

TC620 Supreme



- Universal multiple-row thread milling cutter
- For high cutting speeds and high feeds per tooth



	P	M	K	N	S	H	O
WB10TJ	●	●	●	●	●	●	●

Tool	Designation	Threads per inch mm	D _c mm	l ₂₁ mm	L _c mm	l ₄ mm	l ₁ mm	d ₁ mm	Z	WB10TJ
Shank DIN 6535 HA 	TC620-UNC8-A1D-	32	3,1	1,59	8,7	21	57	6	3	●
	TC620-UNC10-A1D-	24	3,5	2,12	10,5	21	57	6	3	●
	TC620-UNC1/4-A1D-	20	4,7	2,54	12,7	21	57	6	3	●
	TC620-UNC5/16-A1D-	18	6,1	2,82	16,9	27	63	8	4	●
	TC620-UNC3/8-A1D-	16	7,4	3,18	19,1	27	63	8	4	●
	TC620-UNC1/2-A1D-	13	10,1	3,91	25,4	38	83	12	4	●
	TC620-UNC5/8-A1D-	11	12,7	4,62	32,3	44	92	16	4	●
	TC620-UNC3/4-A1D-	10	15,5	5,08	38,1	56	104	16	5	●
	TC620-UNC7/8-A1D-	9	18	5,64	45,2	67	115	18	5	●

Ordering example for the WB10TJ grade: TC620-UNC8-A1D-WB10TJ

B5

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

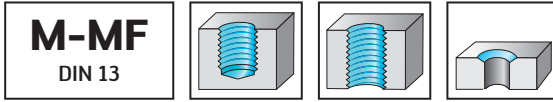
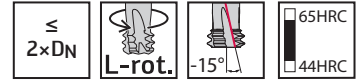
●● Primary application

● Other application

Orbital drill thread milling cutter TC685 Supreme



- Orbital drill thread milling cutter for hardened materials
- Chamfer, core hole and thread in one operation



P	M	K	N	S	H	O
●	●	●	●	●	●	●

Tool		P	D _c	L _{c2}	l ₃	l ₄	l ₁	d ₁	Z	WB10RC
Designation		mm	mm	mm	mm	mm	mm	mm		
Shank DIN 6535 HA 	TC685-M3-A0D-	0,5	2,35	0,55	6,8	14	50	6	4	●
	TC685-M4-A0D-	0,7	3,1	0,77	9,1	14	50	6	4	●
	TC685-M5-A0D-	0,8	3,9	0,89	11,2	21	57	6	4	●
Shank DIN 6535 HA 	TC685-M6-A1D-	1	4,6	1,11	13,5	21	57	6	4	●
	TC685-M8-A1D-	1,25	6,2	1,39	17,9	27	63	8	4	●
	TC685-M10-A1D-	1,5	7,8	1,68	22,3	27	63	8	4	●
	TC685-M12-A1D-	1,75	9	1,96	26,6	32	72	10	4	●
	TC685-M14-A1D-	2	10,5	2,25	31	38	83	12	4	●
	TC685-M16-A1D-	2	12,5	2,28	35	44	92	16	4	●

Maximum thread nominal diameter for fine-pitch threads: D_c × 1.94
 Example: TC685-M8.. /6.2 mm × 1.94 = 12.03 mm/MF 12x1.25 possible
 Ordering example for the WB10RC grade: TC685-M3-A0D-WB10RC

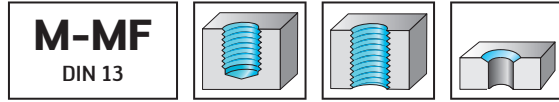
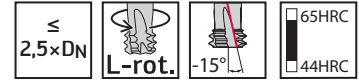
B5

Orbital drill thread milling cutter

TC685 Supreme



- Orbital drill thread milling cutter for hardened materials
- Chamfer, core hole and thread in one operation



P	M	K	N	S	H	O
●	●	●	●	●	●	●

Tool		P	D _c	L _{c2}	l ₃	l ₄	l ₁	d ₁	Z	WB10RC
Designation		mm	mm	mm	mm	mm	mm	mm		
Shank DIN 6535 HA 	TC685-M3-A0E-	0,5	2,35	0,55	8,3	14	50	6	4	●
	TC685-M4-A0E-	0,7	3,1	0,77	11,1	21	57	6	4	●
	TC685-M5-A0E-	0,8	3,9	0,89	13,7	21	57	6	4	●
Shank DIN 6535 HA 	TC685-M6-A1E-	1	4,6	1,11	16,5	21	57	6	4	●
	TC685-M8-A1E-	1,25	6,2	1,39	21,9	27	63	8	4	●
	TC685-M10-A1E-	1,5	7,8	1,68	27,3	27	63	8	4	●
	TC685-M12-A1E-	1,75	9	1,96	32,6	32	72	10	4	●
	TC685-M14-A1E-	2	10,5	2,25	38	38	83	12	4	●
	TC685-M16-A1E-	2	12,5	2,28	43	44	92	16	4	●

Maximum thread nominal diameter for fine-pitch threads: $D_c \times 1.94$
 Example: TC685-M8.. /6.2 mm x 1.94 = 12.03 mm/MF 12x1.25 possible
 Ordering example for the WB10RC grade: TC685-M3-A0E-WB10RC

B5

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

Orbital drill thread milling cutter TC685 Supreme



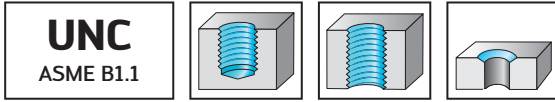
- Orbital drill thread milling cutter for hardened materials
- Chamfer, core hole and thread in one operation

≤
2×DN

L-rot.

-15°

65HRC
44HRC



	P	M	K	N	S	H	O
WB10RC	●	●	●	●	●	●	●

Tool	Designation	Threads per inch mm	D _c mm	L _{c2} mm	l ₃ mm	l ₄ mm	l ₁ mm	d ₁ mm	Z	WB10RC
Shank DIN 6535 HA 	TC685-UNC10-A0D-	24	3,55	1,15	11,3	21	57	6	4	🌟
Shank DIN 6535 HA 	TC685-UNC1/4-A1D-	20	4,75	1,39	14,7	21	57	6	4	🌟
	TC685-UNC5/16-A1D-	18	6,05	1,56	18	27	63	8	4	🌟
	TC685-UNC3/8-A1D-	16	7,3	1,76	21,5	27	63	8	4	🌟
	TC685-UNC1/2-A1D-	13	9,3	2,18	28,4	32	72	10	4	🌟
	TC685-UNC5/8-A1D-	11	11,6	2,59	35,3	38	83	12	4	🌟
	TC685-UNC3/4-A1D-	10	13,9	2,87	42	45	93	16	4	🌟

Ordering example for the WB10RC grade: TC685-UNC10-A0D-WB10RC

B5

Orbital drill thread milling cutter TC685 Supreme



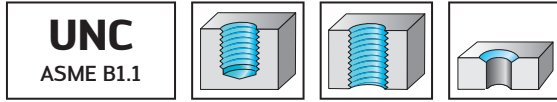
- Orbital drill thread milling cutter for hardened materials
- Chamfer, core hole and thread in one operation

≤
2,5×DN

L-rot.

-15°

65HRC
44HRC



	P	M	K	N	S	H	O
WB10RC	●	●	●	●	●	●	●

Tool		Threads per inch	D _c mm	L _{c2} mm	l ₃ mm	l ₄ mm	l ₁ mm	d ₁ mm	Z	WB10RC
Shank DIN 6535 HA	TC685-UNC10-A0E-	24	3,55	1,15	13,7	21	57	6	4	●
	TC685-UNC1/4-A1E-	20	4,75	1,39	17,8	21	57	6	4	●
	TC685-UNC5/16-A1E-	18	6,05	1,56	22	27	63	8	4	●
	TC685-UNC3/8-A1E-	16	7,3	1,76	26,2	27	63	8	4	●
	TC685-UNC1/2-A1E-	13	9,3	2,18	34,7	38	78	10	4	●
	TC685-UNC5/8-A1E-	11	11,6	2,59	43,2	38	83	12	4	●
	TC685-UNC3/4-A1E-	10	13,9	2,87	51,5	68	116	16	4	●

Ordering example for the WB10RC grade: TC685-UNC10-A0E-WB10RC

B5

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

Designation key for indexable insert thread milling cutters





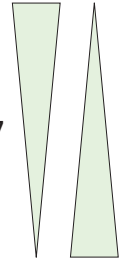
Tool:

T	2	7	11	-	29	-	W	32	-	3	-	09	-	3	-	24
1	2	3	4	5	6		7	8		9		10		11		12

1	2	3	4	5	6
Tool group	Generation	Tool type	Tool type	1. Delimiters	Cutting diameter
T Threading		7 Indexable insert thread milling cutter	11 Universal with triangular insert 2.0 × D _N 12 Universal with triangular insert 2.5 × D _N 13 Universal with triangular insert 3.0 × D _N /modular	- Metric · Inch	
7	8	9	10	11	12
Adaptor type	Adaptor size	Number of teeth	Insert size	Number of cutting rows	Cutting row spacing
W Weldon shank C Walter Capto™					

Indexable insert:

P26300	-	09	02	-	D	6	7	W	SM	37	S
1		2	3		4	5	6	Walter	7	8	9

1	2	3	4	5
Family	Insert size	Insert radius/thread specification	Chip breaker groove	Cutting edge
P26300 Thread milling cutter insert Triangular, positive P26310 Thread milling cutter insert Triangular, positive, for single-row tools	06 09 11 14 22	01 = 0,1 mm 02 = 0,2 mm 04 = 0,4 mm G11 = G thread, 11 TPI	 D = 10°	 6
6	7	8	9	
Flank face design	Application	ISO application range	Generation	
 1  7	SM Can be used universally with ISO P, M, K, N, S and H materials	37  Wear resistance Toughness Cutting tool materials for: 7 thread milling	S Tiger-tec® Silver	

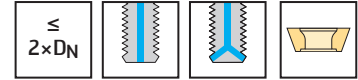
B5

Indexable insert thread milling cutter

T2711 mm



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●

Tool	Designation	D_N	P_{max} mm	D_c mm	l_{21} mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2711-19-W20-3-06-2-24	M 24	3,00	19	24	51	110	20	3	6	P26300-06 ..
	T2711-24-W25-3-09-2-31.5	M 30	3,50	24	31,5	64,5	132	25	3	6	P26300-09 ..
	T2711-52-W40-4-14-2-60	M 64	6,00	52	60	135	217	40	4	8	P26300-14 ..
Shank DIN 1835 B 	T2711-29-W32-3-09-3-24	M 36	4,00	29	24	76,5	149	32	3	9	P26300-09 ..
	T2711-35-W32-3-11-3-27	M 42	4,50	35	27	89,5	160	32	3	9	P26300-11 ..
	T2711-40-W40-3-14-3-30	M 48	5,00	40	30	103	187	40	3	9	P26300-14 ..
	T2711-44-W40-3-14-3-33	M 56	5,50	44	33	119	202	40	3	9	

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

Assembly parts

D _c [mm]		19	24–29	35	40–52
	Clamping screw for indexable insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm

Accessories

D _c [mm]		19	24–35	40–52
	Torque screwdriver, analogue	FS2001	FS2001	FS2003
	Tightening torque	0,4–1,2 Nm	0,4–1,2 Nm	1,5–5,0 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O					
							HC	HC	HC	HC	HC	HC	HC	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S
 P26300-0601-D67 P26300-0602-D67 P26300-0901-D67 P26300-0902-D67 P26300-1102-D67 P26300-1401-D67 P26300-1402-D67 P26300-1404-D67	6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC	HC					
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC	HC				
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC	HC				
	11	0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC	HC	HC				
		14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC	HC	HC			
	0,2		3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC	HC				
	0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC	HC	HC	HC				
 P26300-0601-D61 P26300-0602-D61 P26300-0901-D61 P26300-0902-D61 P26300-1101-D61 P26300-1102-D61 P26300-1401-D61 P26300-1402-D61 P26300-1404-D61 P26300-2204-D61	6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC	HC					
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC	HC				
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC	HC				
	11	0,1	1,50–2,50	18–10	10,85	3	HC	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC	HC	HC				
	14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC	HC				
	0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC	HC	HC	HC				
	22	0,4	5,50–10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	HC	HC				

HC = Coated carbide

Tool selection

Metric thread			Coarse pitch thread						Fine pitch thread												
Family	Body designation	l ₃ [mm]	M24 / M30 / M36 / M42 / M48 / M56 / M64 / M27 / M33 / M39 / M45 / M52 / M59 / M68						D _N [mm]	P [mm]											
			1,5	2	2,5	3	3,5	4		4,5	5	5,5	6								
T2711	T2711-19-W20-3-06-2-24	51	0602					≥ 24	0601	0601		0602									
	T2711-24-W25-3-09-2-31.5	64,5		0902				≥ 30	0901			0902									
	T2711-29-W32-3-09-3-24	76,5			0902			≥ 36	0901	0901		0902		0902							
	T2711-35-W32-3-11-3-27	89,5				1102		≥ 42				1102			1102						
	T2711-40-W40-3-14-3-30	103					1402	≥ 48	1401	1401	1401	1402					1402				
	T2711-44-W40-3-14-3-33	119						≥ 56	1401			1402							1404		
	T2711-52-W40-4-14-2-60	135						≥ 64	1401	1401	1401	1402		1402		1402		1402		1404	

Example: With the T2711-29-W32-3-09-3-24 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902..), an M36 or M39 thread can be produced. Additionally, this body/indexable insert combination can be used to produce fine-pitch threads with a pitch of 3 and 4 mm, when the nominal diameter is ≥ 36 mm.

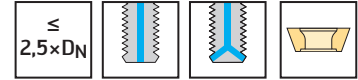
B5

Indexable insert thread milling cutter

T2712 mm



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2712	●	●	●	●	●	●	●

Tool	Designation	D_N	P_{max} mm	P_{max} TPI	D_c mm	l_{z1} mm	L_c mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2712-24-W25-3-09-2-31.5	M 30	3,50	-	24	31,5	63	79,5	147	25	3	6	P26300-09 ..
	T2712-29-W32-3-09-2-36	M 36	4,00	-	29	36	72	94,5	167	32	3	6	P26300-11 ..
	T2712-35-W32-3-11-2-40.5	M 42	4,50	-	35	40,5	81	110,5	180	32	3	6	P26300-11 ..
	T2712-40-W40-3-14-2-50	M 48	5,00	-	40	50	100	127	211	40	3	6	P26300-14 ..
Shank DIN 1835 B 	T2712-19-W20-3-06	M24	3,00	8	19	-	-	63	123	20	3	3	P26300-06 ..
	T2712-24-W25-3-09	M30	3,50	7	24	-	-	79,5	148	25	3	3	P26300-09 ..
	T2712-29-W32-3-09	M36	4,00	6	29	-	-	94,5	167	32	3	3	P26300-11 ..
	T2712-35-W32-3-11	M42	4,50	6	35	-	-	110,5	181	32	3	3	P26300-11 ..
	T2712-40-W40-3-14	M48	5,00	5	40	-	-	127	211	40	3	3	P26300-14 ..
	T2712-44-W40-3-14	M56	5,50	4,5	44	-	-	147	230	40	3	3	P26300-14 ..
	T2712-52-W40-4-14	M64	6,00	4	52	-	-	167	249	40	4	4	P26300-14 ..

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

Assembly parts

D _c [mm]	19	24-29	35	40-52	
	Clamping screw for indexable insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm

Accessories

D _c [mm]	19	24-35	40-52	
	Torque screwdriver, analogue	FS2001	FS2001	FS2003
	Tightening torque	0,4-1,2 Nm	0,4-1,2 Nm	1,5-5,0 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O						
							HC	HC	HC	HC	HC	HC	HC	WSM375	WSM375	WSM375	WSM375	WSM375	WSM375
	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC						
	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	HC						
	11	0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	HC						
		14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	HC					
	0,2		3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	HC						
	0,4	5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	HC							
	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC						
	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	HC						
	11	0,1	1,50-2,50	18-10	10,85	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	HC						
	14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	HC						
		0,2	3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	HC						
	0,4	5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	HC							
	22	0,4	5,50-10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	HC						

HC = Coated carbide

Tool selection

Metric thread			Coarse pitch thread						Fine pitch thread													
Family	Body designation	l ₃ [mm]	M24 / M27	M30 / M33	M36 / M39	M42 / M45	M48 / M52	M56 / M59	M64 / M68	D _N [mm]	P [mm]											
			1,5	2	2,5	3	3,5	4	4,5		5	5,5	6									
T2712	T2712-24-W25-3-09-2-31.5	79,5		0902						≥ 30	0901				0902							
	T2712-29-W32-3-09-2-36	94,5			0902					≥ 36	0901	0901			0902		0902					
	T2712-35-W32-3-11-2-40.5	110,5				1102				≥ 42	1101								1102			
	T2712-40-W40-3-14-2-50	127						1402		≥ 48		1401	1401								1402	
T2712	T2712-19-W20-3-06	63	0602							≥ 24		0601		0602								
	T2712-24-W25-3-09	79,5		0902						≥ 30		0901			0902							
	T2712-29-W32-3-09	94,5			0902					≥ 36		0901			0902							
	T2712-35-W32-3-11	110,5				1102				≥ 42		1101				1102						
	T2712-40-W40-3-14	127					1402			≥ 48		1401				1402						
	T2712-44-W40-3-14	147						1404		≥ 56		1401				1402						1404
	T2712-52-W40-4-14	167							1404	≥ 64		1401				1402						1404

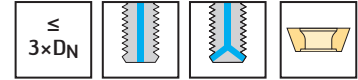
Example: With the T2712-29-W32-3-09-2-36 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902.), an M36 or M39 thread can be produced. Additionally, this body/indexable insert combination can be used to produce fine-pitch threads with a pitch of 3 and 4 mm, when the nominal diameter is ≥ 36 mm.

Indexable insert thread milling cutter

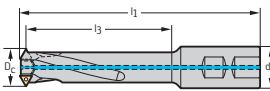
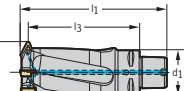
T2713



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2713	●	●	●	●	●	●	●

Tool	Designation	D _N	P _{max} mm	P _{max} TPI	D _c mm	l ₃ mm	l ₁ mm	d ₁ mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2713-19-W20-3-06	M24	3,00	8	19	75	135	20	3	3	P26300-06 ..
	T2713-24-W25-3-09	M30	3,50	7	24	94,5	163	25	3	3	P26300-09 ..
	T2713-29-W32-3-09	M36	4,00	6	29	112,5	185	32	3	3	P26300-11 ..
	T2713-35-W32-3-11	M42	4,50	6	35	131,5	202	32	3	3	P26300-11 ..
	T2713-40-W40-3-14	M48	5,00	5	40	151	235	40	3	3	P26300-14 ..
	T2713-44-W40-3-14	M56	5,50	4,5	44	175	258	40	3	3	P26300-14 ..
	T2713-52-W40-4-14	M64	6,00	4	52	199	281	40	4	4	P26300-14 ..
Walter Capto™ in accordance with ISO 26623 	T2713-60-C5-4-14	M72	6,00	4	60	115	152	50	4	4	P26300-14 ..
	T2713-73-C6-5-14	M85	6,00	4	73	125	170	63	5	5	P26300-14 ..
	T2713-94-C8-5-22	M125	10,00	4	94	140	199	80	5	5	P26300-22 ..

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

Assembly parts

D _c [mm]	19	24–29	35	40–73	94	
	Clamping screw for indexable insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)	FS1495 (Torx 20IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm	5,0 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)	FS2061 (Torx 7IP)	FS1457 (Torx 9IP)	FS1495 (Torx 20IP)
	Tightening torque	0,6 Nm	0,9 Nm	0,9 Nm	2,0 Nm	5,0 Nm

Accessories

D _c [mm]	19	24–35	40–73	94	
	Torque screwdriver, analogue	FS2001	FS2001	FS2003	FS2003
	Tightening torque	0,4–1,2 Nm	0,4–1,2 Nm	1,5–5,0 Nm	1,5–5,0 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)	FS2015 (Torx 20IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)	FS1486 (Torx 20IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O				
							HC	HC	HC	HC	HC	HC	HC	WSM37S	WSM37S	WSM37S	WSM37S
	6	0,1	1,50–2,50	18–10	6,73	3											
		0,2	3,00	8	6,58	3											
	9	0,1	1,50–2,50	18–10	9,48	3											
		0,2	3,00–4,00	8–6	9,34	3											
	11	0,2	3,00–4,50	8–6	10,71	3											
		14	0,1	1,50–2,50	18–10	13,87	3										
	0,2		3,00–5,00	8–5	13,72	3											
	0,4	5,50–6,00	4,5–4	13,43	3												
	6	0,1	1,50–2,50	18–10	6,73	3											
		0,2	3,00	8	6,58	3											
	9	0,1	1,50–2,50	18–10	9,48	3											
		0,2	3,00–4,00	8–6	9,34	3											
	11	0,1	1,50–2,50	18–10	10,85	3											
		0,2	3,00–4,50	8–6	10,71	3											
	14	0,1	1,50–2,50	18–10	13,87	3											
		0,2	3,00–5,00	8–5	13,72	3											
	0,4	5,50–6,00	4,5–4	13,43	3												
	22	0,4	5,50–10,00	4	21,38	3											

HC = Coated carbide

Tool selection

Metric thread			Coarse pitch thread						Fine pitch thread												
Family	Body designation	l ₃ [mm]	M24 / M27	M30 / M33	M36 / M39	M42 / M45	M48 / M52	M56 / M59	M64 / M68	D _N [mm]	P [mm]										
											1,5–2,5	3	3,5	4	4,5	5	5,5	6	7–10		
T2713	T2713-19-W20-3-06	75	0602							≥ 24	0601	0602									
	T2713-24-W25-3-09	94,5		0902						≥ 30	0901	0902									
	T2713-29-W32-3-09	112,5			0902					≥ 36	0901	0902									
	T2713-35-W32-3-11	131,5				1102				≥ 42	1101	1102									
	T2713-40-W40-3-14	151					1402			≥ 48	1401	1402									
	T2713-44-W40-3-14	175						1404		≥ 56	1401	1402					1404				
	T2713-52-W40-4-14	199							1404	≥ 64	1401	1402					1404				
	T2713-60-C5-4-14	115								≥ 72	1401	1402					1404				
	T2713-73-C6-5-14	125								≥ 85	1401	1402					1404				
	T2713-94-C8-5-22	140								≥ 125											2204

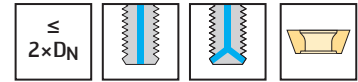
Example: With the T2713-29-W32-3-09 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902...), an M36 or M39 thread can be produced. Additionally, this body/indexable insert combination can be used to produce fine-pitch threads with a pitch of 3 and 4 mm, when the nominal diameter is ≥ 36 mm.

Indexable insert thread milling cutter

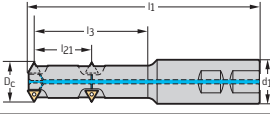
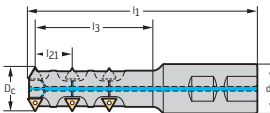
T2711 mm



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●

Tool	Designation	D _N	P _{max} TPI	D _c mm	l ₂₁ mm	l ₃ mm	l ₁ mm	d ₁ mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2711-20-W20-3-06-2-25.4	UNC 1	8	20	25,4	53,9	113	20	3	6	P26300-06 ..
	T2711-26-W25-3-09-2-32.7	UNC 1.1/4	7	26	32,66	68	135	25	3	6	P26300-09 ..
Shank DIN 1835 B 	T2711-31-W32-3-09-3-25.4	UNC 1.1/2	6	31	25,4	80,7	153	32	3	9	P26300-09 ..

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

Assembly parts

D _c [mm]		20	26-31
	Clamping screw for indexable insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0,6 Nm	0,9 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0,6 Nm	0,9 Nm

Accessories

D _c [mm]		20	26-31
	Torque screwdriver, analogue	FS2001	FS2001
	Tightening torque	0,4-1,2 Nm	0,4-1,2 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O								
							HC	HC	HC	HC	HC	HC	HC								
							WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S								
 P26300-0601-D67 P26300-0602-D67 P26300-0901-D67 P26300-0902-D67 P26300-1102-D67 P26300-1401-D67 P26300-1402-D67 P26300-1404-D67	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	HC								
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC	HC							
	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	HC	HC							
		0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	HC	HC							
	11	0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	HC	HC							
		14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	HC	HC						
	0,2		3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	HC	HC							
	0,4		5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	HC	HC							
 P26300-0601-D61 P26300-0602-D61 P26300-0901-D61 P26300-0902-D61 P26300-1101-D61 P26300-1102-D61 P26300-1401-D61 P26300-1402-D61 P26300-1404-D61 P26300-2204-D61	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	HC								
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC	HC							
	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	HC	HC							
		0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	HC	HC							
	11	0,1	1,50-2,50	18-10	10,85	3	HC	HC	HC	HC	HC	HC	HC	HC							
		0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	HC	HC							
	14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	HC	HC							
		0,2	3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	HC	HC							
		0,4	5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	HC	HC							
	22	0,4	5,50-10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	HC	HC							

HC = Coated carbide

Tool selection

UN threads		UNC			UNF					UN							
Family	Body designation	l ₃ [mm]	1"	1 1/4"	1 1/2"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	D _N	TPI					
												18*	16	14	12	8	6
T2711	T2711-20-W20-3-06-2-25.4	53,9	0602			0601	0601	0601	0601	0601	≥ 1,00"	0601	0601	0601	0601	0602	
	T2711-26-W25-3-09-2-32.7	68		0902							≥ 1,25"			0901			
	T2711-31-W32-3-09-3-25.4	80,7			0902						≥ 1,50"	0901	0901	0901	0901	0901	0902

Example: With the T2711-31-W32-3-09-3-25.4 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902.), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with 8 and 6 TPI, when their nominal diameter is ≥ 1.5".

* = UNEF

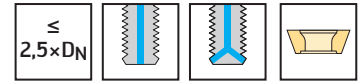
B5

Indexable insert thread milling cutter

T2712 mm



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2712	●	●	●	●	●	●	●

Tool	Designation	D _N	P _{max} TPI	P _{max} mm	D _c mm	l ₂₁ mm	L _c mm	l ₃ mm	l ₁ mm	d ₁ mm	Z	No. of index- able inserts	Type
Shank DIN 1835 B 	T2712-26-W25-3-09-2-32.7	UNC 1 1/4	7	-	26	32,66	65,32	84	151	25	3	6	P26300-09 ..
	T2712-31-W32-3-09-2-38.1	UNC 1 1/2	6	-	31	38,1	76,2	99,8	172	32	3	6	
Shank DIN 1835 B 	T2712-19-W20-3-06	1,00"	8	3,00	19	-	-	63	123	20	3	3	P26300-06 ..
	T2712-24-W25-3-09	1,25"	7	3,50	24	-	-	79,5	148	25	3	3	P26300-09 ..
	T2712-29-W32-3-09	1,50"	6	4,00	29	-	-	94,5	167	32	3	3	
	T2712-35-W32-3-11	1,75"	6	4,50	35	-	-	110,5	181	32	3	3	P26300-11 ..
	T2712-40-W40-3-14	2,00"	5	5,00	40	-	-	127	211	40	3	3	P26300-14 ..
	T2712-44-W40-3-14	2,25"	4,5	5,50	44	-	-	147	230	40	3	3	
T2712-52-W40-4-14	2,75"	4	6,00	52	-	-	167	249	40	4	4		

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

Assembly parts

D _c [mm]	19	24-31	35	40-52	
	Clamping screw for indexable insert	FS2147 (Torx 6IP) 0,6 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS2061 (Torx 7IP) 0,9 Nm	FS1457 (Torx 9IP) 2,0 Nm
	Coolant screw	FS2147 (Torx 6IP) 0,6 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS2061 (Torx 7IP) 0,9 Nm	FS1457 (Torx 9IP) 2,0 Nm

Accessories

D _c [mm]	19	24-31	40-52	
	Torque screwdriver, analogue	FS2001 0,4-1,2 Nm	FS2001 0,4-1,2 Nm	FS2003 1,5-5,0 Nm
	Tightening torque			
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O					
							HC	HC	HC	HC	HC	HC	HC	HC	WSM37S	WSM37S	WSM37S	WSM37S
	P26300-0601-D67	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0602-D67	6	0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0901-D67	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0902-D67	9	0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1102-D67	11	0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1401-D67	14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1402-D67		0,2	3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1404-D67		0,4	5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0601-D61	6	0,1	1,50-2,50	18-10	6,73	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0602-D61	6	0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0901-D61	9	0,1	1,50-2,50	18-10	9,48	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-0902-D61		0,2	3,00-4,00	8-6	9,34	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1101-D61	11	0,1	1,50-2,50	18-10	10,85	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1102-D61		0,2	3,00-4,50	8-6	10,71	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1401-D61	14	0,1	1,50-2,50	18-10	13,87	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1402-D61		0,2	3,00-5,00	8-5	13,72	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-1404-D61		0,4	5,50-6,00	4,5-4	13,43	3	HC	HC	HC	HC	HC	HC	WSM37S				
	P26300-2204-D61	22	0,4	5,50-10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	WSM37S				

HC = Coated carbide

Tool selection

UN threads			UNC					UNF					UN						
Family	Body designation	l ₃ [mm]	1"	1 1/4"	1 1/2"	2 1/4" ≥ 2 3/4"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	D _N	TPI						
													18-10	8	6	5	4,5	4	
T2712	T2712-26-W25-3-09-2-32.7	83,88		0902								≥ 1,25"							
	T2712-31-W32-3-09-2-38.1	99,75			0902						0901	≥ 1,50"	0901*	0902	0902				
T2712	T2712-19-W20-3-06	63	0602				0601	0601	0601	0601	0601	≥ 1,00"	0601	0602					
	T2712-24-W25-3-09	79,5		0902				0901	0901	0901	0901	≥ 1,25"	0901	0902					
	T2712-29-W32-3-09	94,5			0902					0901	0901	≥ 1,50"	0901	0902					
	T2712-35-W32-3-11	110,5										≥ 1,75"	1101	1102					
	T2712-40-W40-3-14	127										≥ 2,00"	1401	1402					
	T2712-44-W40-3-14	147				1404						≥ 2,25"	1401	1402		1404			
T2712-52-W40-4-14	167					1404					≥ 2,75"	1401	1402		1404				

Example: With the T2712-31-W32-3-09-2-38.1 body and the size 09 indexable insert with 0,2 mm radius (0902 -> P26300-0902.), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with 8 and 6 TPI, when their nominal diameter is ≥ 1,5".

* Exceptions: 13/11,5 and 11 TPI cannot be machined.

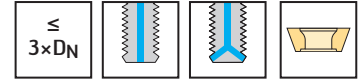
B5

Indexable insert thread milling cutter

T2713



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2713	●	●	●	●	●	●	●

Tool	Designation	D_N	P_{max} TPI	P_{max} mm	D_c mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2713-19-W20-3-06	1,00"	8	3,00	19	75	135	20	3	3	P26300-06 ..
	T2713-24-W25-3-09	1,25"	7	3,50	24	94,5	163	25	3	3	P26300-09 ..
	T2713-29-W32-3-09	1,50"	6	4,00	29	112,5	185	32	3	3	P26300-11 ..
	T2713-35-W32-3-11	1,75"	6	4,50	35	131,5	202	32	3	3	P26300-11 ..
	T2713-40-W40-3-14	2,00"	5	5,00	40	151	235	40	3	3	P26300-14 ..
	T2713-44-W40-3-14	2,25"	4,5	5,50	44	175	258	40	3	3	P26300-14 ..
	T2713-52-W40-4-14	2,75"	4	6,00	52	199	281	40	4	4	P26300-14 ..
Walter Capto™ in accordance with ISO 26623 	T2713-60-C5-4-14	3,00"	4	6,00	60	115	152	50	4	4	P26300-14 ..
	T2713-73-C6-5-14	3,50"	4	6,00	73	125	170	63	5	5	P26300-14 ..
	T2713-94-C8-5-22	5,00"	4	10,00	94	140	199	80	5	5	P26300-22 ..

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

Assembly parts

D _c [mm]	19	24–29	35	40–73	94
Clamping screw for indexable insert Tightening torque	FS2147 (Torx 6IP) 0,6 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS2061 (Torx 7IP) 0,9 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS1495 (Torx 20IP) 5,0 Nm
Coolant screw Tightening torque	FS2147 (Torx 6IP) 0,6 Nm	FS2111 (Torx 7IP) 0,9 Nm	FS2061 (Torx 7IP) 0,9 Nm	FS1457 (Torx 9IP) 2,0 Nm	FS1495 (TorxLP) 5,0 NM

Accessories

D _c [mm]	19	24–35	40–73	94
Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)	FS2015 (Torx 20IP)
Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)	FS1486 (Torx 20IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O				
							HC	HC	HC	HC	HC	HC	HC	WSM37S	WSM37S	WSM37S	WSM37S
 P26300-0601-D67 P26300-0602-D67 P26300-0901-D67 P26300-0902-D67	6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC				
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC				
P26300-1102-D67 P26300-1401-D67 P26300-1402-D67 P26300-1404-D67	11	0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC					
	14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC					
		0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC					
0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC	HC						
 P26300-0601-D61 P26300-0602-D61 P26300-0901-D61 P26300-0902-D61 P26300-1101-D61 P26300-1102-D61 P26300-1401-D61 P26300-1402-D61 P26300-1404-D61 P26300-2204-D61	6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC					
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC				
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC				
	11	0,1	1,50–2,50	18–10	10,85	3	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC	HC				
	14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC	HC				
		0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC				
		0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC	HC				
	22	0,4	5,50–10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	HC				

HC = Coated carbide

Tool selection

UN threads			UNC							UNF				UN						
Family	Body designation	l ₃ [mm]	1"	1 1/4"	1 1/2"	2 1/4"	2 3/4"	≥ 3"	≥ 3 1/2"	1"	1 1/8"	1 1/4"	≥ 1 3/8"	D _N	TPI					
			0602	0902	0902						0601	0601	0601	0601	≥ 1,00"	18–10	8	6	5	4,5
T2713	T2713-19-W20-3-06	75	0602							0601	0601	0601	0601	≥ 1,00"	0601	0602				
	T2713-24-W25-3-09	94,5		0902							0901	0901	0901	≥ 1,25"	0901	0902				
	T2713-29-W32-3-09	112,5			0902								0901	≥ 1,50"	0901	0902				
	T2713-35-W32-3-11	131,5												≥ 1,75"	1101	1102				
	T2713-40-W40-3-14	151												≥ 2,00"	1401	1402				
	T2713-44-W40-3-14	175				1404								≥ 2,25"	1401	1402	1404			
	T2713-52-W40-4-14	199					1404	1404	1404					≥ 2,75"	1401	1402		1404		
	T2713-60-C5-4-14	115						1404	1404					≥ 3,00"	1401	1402		1404		
	T2713-73-C6-5-14	125							1404					≥ 3,50"	1401	1402		1404		
	T2713-94-C8-5-22	140												≥ 5,00"						2204

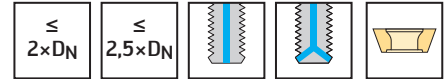
Example: With the T2713-29-W32-3-09 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902.), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with 8 to 6 TPI, when the nominal diameter is ≥ 1.5".

Indexable insert thread milling cutter

T2711 / T2712 inch



- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●
T2712	●	●	●	●	●	●	●

Tool	Designation	D_N	P_{max} TPI	P_{max} mm	D_c Inch	l_{21} Inch	l_3 Inch	l_1 Inch	d_1 Inch	Z	No. of indexable inserts	Type
Weldon-Inch 	T2711.20-W19-3-06-2-25.4	UNC 1	8	-	0,787	1,000	2,122	4,461	0,750	3	6	P26300-06 ..
	T2711.26-W26-3-09-2-32.7	UNC 1.1/4	7	-	1,024	1,286	2,677	5,299	1,000	3	6	P26300-09 ..
Weldon-Inch 	T2711.31-W31-3-09-3-25.4	UNC 1.1/2	6	-	1,220	1,000	3,177	5,892	1,250	3	9	P26300-09 ..
Weldon-Inch 	T2712.20-W19-3-06	UNC 1	8	3,00	0,787	-	2,618	4,953	0,750	3	3	P26300-06 ..
	T2712.23-W26-3-09	UNC 1 1/8	7	3,50	0,886	-	2,992	5,695	1,000	3	3	P26300-09 ..
	T2712.28-W31-3-09	UNC 1 3/8	6	4,00	1,083	-	3,622	6,482	1,250	3	3	

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

Assembly parts

D _c [Inch]		0,787	0,886–1,220
	Clamping screw for indexable insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0,6 Nm	0,9 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0,6 Nm	0,9 Nm

Accessories

D _c [Inch]		0,787	0,886 –1,220
	Torque screwdriver, analogue	FS2002	FS2002
	Tightening torque	0,4–1,2 Nm	0,4–1,2 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)

Thread milling cutter inserts P26300

Designation	Size	r mm	Pitch P mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O			
							HC	HC	HC	HC	HC	HC	HC	HC		
	6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC	HC			
		0,2	3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC			
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC			
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC			
P26300-1102-D67	11	0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC	HC			
		14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC			
			0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC		
P26300-1404-D67	14	0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC				
		6	0,1	1,50–2,50	18–10	6,73	3	HC	HC	HC	HC	HC	HC			
	0,2		3,00	8	6,58	3	HC	HC	HC	HC	HC	HC	HC			
	9	0,1	1,50–2,50	18–10	9,48	3	HC	HC	HC	HC	HC	HC	HC			
		0,2	3,00–4,00	8–6	9,34	3	HC	HC	HC	HC	HC	HC	HC			
P26300-1101-D61	11	0,1	1,50–2,50	18–10	10,85	3	HC	HC	HC	HC	HC	HC	HC			
		0,2	3,00–4,50	8–6	10,71	3	HC	HC	HC	HC	HC	HC	HC			
P26300-1401-D61	14	0,1	1,50–2,50	18–10	13,87	3	HC	HC	HC	HC	HC	HC	HC			
		0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC			
P26300-1404-D61	14	0,2	3,00–5,00	8–5	13,72	3	HC	HC	HC	HC	HC	HC	HC			
		0,4	5,50–6,00	4,5–4	13,43	3	HC	HC	HC	HC	HC	HC	HC			
P26300-2204-D61	22	0,4	5,50–10,00	4	21,38	3	HC	HC	HC	HC	HC	HC	HC			

HC = Coated carbide

Tool selection

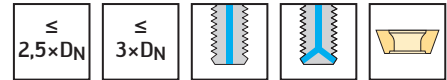
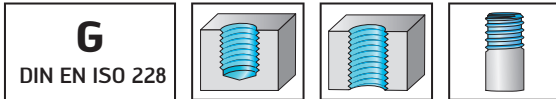
UN threads			UNC					UNF					UN			
Family	Body designation	l ₃ [inches]	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	D _N	TPI		
			0602					0601	0601	0601	0601	0601		18–10	8	6
T2711	T2711.20-W19-3-06-2-25.4	2.122"						0601	0601	0601	0601	0601	≥ 1,000"	0601	0602	
	T2711.26-W26-3-09-2-32.7	2.677"			0902								≥ 1,250"			
	T2711.31-W31-3-09-3-25.4	3.177"					0902					0901	≥ 1,500"	0901	0902	0902
T2712	T2712.20-W19-3-06	2.618"	0602					0601	0601	0601	0601	0601	≥ 1,000"	0601	0602	
	T2712.23-W26-3-09	2.992"		0902	0902				0901	0901	0901	0901	≥ 1,125"	0901	0902	
	T2712.28-W31-3-09	3.622"				0902	0902				0901	0901	≥ 1,375"	0901	0902	0902

Example: With the T2711.31-W31-3-09-3-25.4 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902...), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with 8 and 6 TPI, when the nominal diameter is ≥ 1.5".

Indexable insert thread milling cutter

 T2712 / T2713 mm


- Radius correction values: See technical information
- D67 geometry: Maximum tool life/D61 geometry: Best operational smoothness



	P	M	K	N	S	H	O
T2712 / T2713	●●	●●	●●	●	●●	●	●

Tool	Designation	D _N	P _{max} mm	P _{max} TPI	D _c mm	l ₃ mm	l ₁ mm	d ₁ mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2712-24-W25-3-09	G 1"	3,50	7	24	79,5	148	25	3	3	P26310-09G11 ..
	T2712-29-W32-3-09	G1 1/8"	4,00	6	29	94,5	167	32	3	3	
	T2712-40-W40-3-14	G 1 1/2"	5,00	5	40	127	211	40	3	3	
	T2712-44-W40-3-14	G 1 3/4"	5,50	5	44	147	230	40	3	3	P26310-14G11 ..
	T2712-52-W40-4-14	G 2"	6,00	4	52	167	249	40	4	4	

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

Tool	Designation	D _N	P _{max} mm	P _{max} TPI	D _c mm	l ₃ mm	l ₁ mm	d ₁ mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B 	T2713-24-W25-3-09	G 1"	3,50	7	24	94,5	163	25	3	3	P26310-09G11 ..
	T2713-29-W32-3-09	G1 1/8"	4,00	6	29	112,5	185	32	3	3	
	T2713-40-W40-3-14	G 1 1/2"	5,00	5	40	151	235	40	3	3	
	T2713-44-W40-3-14	G 1 3/4"	5,50	4,5	44	175	258	40	3	3	P26310-14G11 ..
	T2713-52-W40-4-14	G 2"	6,00	4	52	199	281	40	4	4	
Walter Capto™ in accordance with ISO 26623 	T2713-60-C5-4-14	G 2 1/4"	6,00	4	60	115	152	50	4	4	P26310-14G11 ..
	T2713-73-C6-5-14	G 2 3/4"	6,00	4	73	125	170	63	5	5	

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

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Assembly parts

D _c [mm]		24–29	40–73
	Clamping screw for indexable insert	FS2111 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,9 Nm	2,0 Nm
	Coolant screw	FS2111 (Torx 7IP)	FS1457 (Torx 9IP)
	Tightening torque	0,9 Nm	2,0 Nm

Accessories

D _c [mm]		24–29	40–73
	Torque screwdriver, analogue	FS2001	FS2003
	Tightening torque	0,4–1,2 Nm	1,5–5,0 Nm
	Interchangeable blade	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)
	Screwdriver for indexable insert	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)

Thread milling cutter inserts P26310

Designation	Size	r mm	Pitch P TPI	l mm	Number of cutting edges	P	M	K	N	S	H	O				
						HC	HC	HC	HC	HC	HC	HC	WSM37S	WSM37S	WSM37S	WSM37S
P26310-09G11-D61	9	0,2	11	9,34	3											
P26310-14G11-D61	14	0,2	11	13,72	3											

Partial profile indexable inserts for producing the flattened profile in accordance with DIN EN ISO 228.

HC = Coated carbide

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Tool selection

G thread (BSP)														
Family	Body designation	Insert	I3 [mm]	G 1"	G 1 1/8"	G 1 1/4"	G 1 1/2"	G 1 3/4"	G 2"	G 2 1/4"	G 2 1/2"	G 2 3/4"	G 3"	≥ G 3 1/2"
T2712	T2712-24-W25-3-09	09G11	79,5	●●	●●	●●	●●	●	●	●	●	●	●	●
	T2712-29-W32-3-09		94,5		●●	●●	●●	●●	●	●	●	●	●	●
	T2712-40-W40-3-14	14G11	127				●●	●●	●●	●●	●	●	●	●
	T2712-44-W40-3-14		147				●●	●●	●●	●●	●	●	●	●
	T2712-52-W40-4-14		167						●●	●●	●●	●	●	●
T2713	T2713-24-W25-3-09	09G11	94,5	●●	●●	●●	●●	●	●	●	●	●	●	●
	T2713-29-W32-3-09		112,5		●●	●●	●●	●●	●	●	●	●	●	●
	T2713-40-W40-3-14	14G11	151				●●	●●	●●	●●	●	●	●	●
	T2713-44-W40-3-14		175				●●	●●	●●	●●	●	●	●	●
	T2713-52-W40-4-14		199						●●	●●	●●	●	●	●
	T2713-60-C5-4-14		115							●●	●●	●●	●	●
T2713-73-C6-5-14	125										●●	●●	●●	

Example: With the T2712-29-W32-3-09 body and the P26310-09G11.. indexable insert, G threads from 1 1/8" can be produced.

- **Primary application:** High level of cost-efficiency for small and large batch sizes
- **Additional application:** Cost-effective for small batch sizes (in order to achieve a good surface quality, the feed per tooth must be reduced. This results in longer machining times.)

Cutting data

Thread forming and tapping

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

Material group	Overview of the main material groups and code letters		Birnell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	HSS-E(-PM) taps				
						Uncoated				
						v _c [m/min]				
							1,5 × D _N	2 × D _N	2,5 × D _N	
= Coolant recommended E = Emulsion O = Oil v _c = Cutting speed										
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	E	16	13	12
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	E	20	17	14
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	E	10	9	7
		C > 0.55%	Annealed	190	640	P4	E	10	9	7
		C > 0.55%	Heat-treated	300	1010	P5	E	6	5	4
	Free-machining steel (short-chipping)	Annealed	220	750	P6	E	10	9	7	
	Low-alloy steel	Annealed		175	590	P7	E	20	17	14
		Heat-treated		285	960	P8	E	5	4	4
		Heat-treated		380	1280	P9	E	3	3	2
		Heat-treated		430	1480	P10	O	3	2	2
	High-alloyed steel and high-alloyed tool steel	Annealed		200	680	P11	E	10	9	7
		Hardened and tempered		300	1010	P12	E	6	5	4
		Hardened and tempered		380	1280	P13	O	3	3	2
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	E	3	2	2
		Martensitic, heat-treated		330	1110	P15	E	3	2	2
M	Stainless steel	Austenitic, quench hardened		200	680	M1	E	4	3	3
		Austenitic, precipitation hardened (PH)		300	1010	M2	E	2	2	1
		Austenitic/ferritic, duplex		230	780	M3	E	2	2	2
K	Malleable cast iron	Ferritic		200	400	K1	E	10	9	7
		Pearlitic		260	700	K2	E	7	5	5
	Grey cast iron	Low tensile strength		180	200	K3	E	19	16	13
		High tensile strength/austenitic		245	350	K4	E	13	10	9
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	E	10	9	7
		Pearlitic		265	700	K6	E	7	5	5
	GGV (CGI)		230	400	K7	E	6	5	4	
N	Wrought aluminium alloys	Not hardenable		30	–	N1	E	10	8	7
		Hardenable, hardened		100	340	N2	E	19	16	13
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3	E	17	14	12
		≤ 12% Si, hardenable, hardened		90	310	N4	E	17	14	12
		> 12% Si, not hardenable		130	450	N5	E	16	13	11
	Magnesium-based alloys		70	250	N6	O	26	21	19	
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	340	N7	E	9	7	6
		Brass, bronze, red brass		90	310	N8	E	24	21	18
		Cu alloys, short-chipping		110	380	N9	E	31	25	21
		High tensile, Ampco		300	1010	N10	E	2		
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	E	3	3	2
			Hardened	280	940	S2	E	2	2	2
		Ni- or Co-based	Annealed	250	840	S3	E	3	3	2
			Hardened	350	1180	S4	O	2	2	2
			Cast	320	1080	S5	O	2	2	2
	Titanium alloys	Pure titanium		200	680	S6	E	10	8	7
		α and β alloys, hardened		375	1260	S7	O	3	2	2
		β alloys		410	1400	S8	O	3	2	2
	Tungsten alloys		300	1010	S9	O	2	2	2	
	Molybdenum alloys		300	1010	S10	O	5	5	4	
H	Hardened steel	Hardened and tempered		50 HRC	–	H1	O			
		Hardened and tempered		55 HRC	–	H2	O			
		Hardened and tempered		60 HRC	–	H3	O			
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4	O			
O	Thermoplastics	Without abrasive fillers				O1	E	28	23	19
	Thermosets	Without abrasive fillers				O2	E	11	9	8
	Plastic, glass-fibre-reinforced	GFRP				O3	E	6	5	4
	Plastic, carbon-fibre-reinforced	CFRP				O4	E	6	5	4
	Plastic, aramid-fibre-reinforced	AFRP				O5	E	6	5	4
	Graphite (technical)		80 Shore			O6	E	13	11	9

¹ The classification of the machining groups can be found from page B 1174 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

*For materials with a hardness of more than 63 HRC, reduce the cutting speed by 50–75%.

	HSS-E(-PM) taps				TC388 tap		TC389 tap*		HSS-E(-PM) thread formers				TC470 solid carbide thread former				
	Coated				WJ30BA		WE10BA		Coated				WG20EL				
		v _c [m/min]				v _c [m/min]			v _c [m/min]			v _c [m/min]				v _c [m/min]	
1,5 × D _N		2 × D _N	2,5 × D _N	1,5 × D _N		2 × D _N	1,5 × D _N		2 × D _N	1,5 × D _N		2 × D _N	2,5 × D _N	1,5 × D _N		2 × D _N	2,5 × D _N
E	37	30	26							E	46	37	32	E	73	60	51
E	37	31	26							E	47	38	33	E	73	60	51
E	23	19	17							E	29	23	20	E	73	60	51
E	23	19	16							E	29	23	20	E	64	52	36
E	14	12	10							E	17	14	12	E	39	31	27
E	23	19	16							E	29	23	20	E	64	52	36
E	37	30	26							E	47	38	33	E	51	42	36
E	12	10	9							E	15	12	11	E	39	31	27
E	7	6	5														
O	5																
E	23	19	16							E	29	23	20	E	64	52	36
E	14	12	10							E	17	14	12	E	39	31	27
O	7	6	5														
E	7	6	5							EO	13	10	9	E	11	9	8
E	5	4	3							O	5	4	3				
E	8	7	6							EO	15	12	11				
E	5	4	3							O	5	4	4				
E	6	5	4							EO	5	4	4				
E	22	18	16														
E	11	9	8														
E	44	36	32														
E	17	14	12														
E	22	18	16							E	29	23	20		51	42	36
E	12	10	9							E	14	12	10		48	39	33
E	10	8	7														
E	8	7	6							E	56	45	39		103	84	72
E	32	26	22							E	52	43	37		88	72	61
E	22	18	16							E	48	39	34		88	72	61
E	22	18	16							E	48	39	34		88	72	61
E	25	21	18														
O	34	28	24														
E	14	12	10							E	21	17	15		59	48	41
E	36	29	25														
E	48	40	34														
E																	
E										E	8	6	5				
E	3																
E										O	8	6	5				
O	3																
O	3																
E	8	7	6														
O	4	4															
O	4	4															
O	2	2								O	6	5	6	5			
O	7	5								O	17	14	17	14			
O										EO	10	8					
O										EO	4	3	4	3			
O										EO	1	1	2	1,5			
O										EO	4	3	4	3			
E	22	18	15														
E	13	10	9														
E	8	6	5														
E	8	6	5														
E	8	6	5														
E	19	16	13														

B5

Cutting data

Solid carbide thread milling

Material group	Overview of the main material groups and code letters		Brinell hardness HB	Tensile strength R_m N/mm ²	Machining group ¹		TC620 Supreme		
							Strategy		
							Synchronous milling	Asynchronous milling	Non-cutting pass**
P Non-alloyed steel Low-alloy steel High-alloyed steel and high-alloyed tool steel Stainless steel	C ≤ 0.25% C > 0.25 ... ≤ 0.55% C > 0.25 ... ≤ 0.55% C > 0.55% Free-machining steel (short-chipping)	Annealed	125	430	P1	E M	●	●●	●
		Annealed	190	640	P2	E M	●	●●	●
		Heat-treated	210	710	P3	E M	●	●●	●
		Annealed	190	640	P4	E M	●	●●	●
		Heat-treated	300	1010	P5	E M	●	●●	●
	Annealed Heat-treated Heat-treated Heat-treated	220	750	P6	E M	●	●●	●	
		175	590	P7	E M	●	●●	●●	
		285	960	P8	E M	●	●●	●	
		380	1280	P9	E M	●	●●	●	
	Annealed Hardened and tempered Hardened and tempered	430	1480	P10	E M	●	●●	●	
		200	680	P11	E M	●	●●	●●	
		300	1010	P12	E M	●	●●	●	
	Ferritic/martensitic, annealed Martensitic, heat-treated	380	1280	P13	E M	●	●●	●	
		200	680	P14	E M	●	●●	●●	
	330	1110	P15	E M	●	●●	●		
Austenitic, quench hardened Austenitic, precipitation hardened (PH) Austenitic/ferritic, duplex		200	680	M1	E	●●	●	●●	
	300	1010	M2	E	●●	●	●●		
	230	780	M3	E	●●	●	●●		
K Malleable cast iron Grey cast iron Cast iron with spheroidal graphite GGV (CGI)	Ferritic Pearlitic	200	400	K1	E M	●	●●	●	
		260	700	K2	E M	●	●●	●	
	Low tensile strength High tensile strength/austenitic	180	200	K3	E M	●	●●	●	
		245	350	K4	E M	●	●●	●	
	Ferritic Pearlitic	155	400	K5	E M	●	●●	●	
		265	700	K6	E M	●	●●	●	
230	400	K7	E M	●	●●	●			
N Wrought aluminium alloys Cast aluminium alloys Magnesium-based alloys ³ Copper and copper alloys (bronze/brass)	Not hardenable Hardenable, hardened	30	–	N1	E M	●●	●	●	
		100	340	N2	E M	●●	●	●	
	≤ 12% Si, not hardenable ≤ 12% Si, hardenable, hardened > 12% Si, not hardenable	75	260	N3	E M	●●	●	●	
		90	310	N4	E M	●●	●	●	
		130	450	N5	E M	●●	●	●	
	70	250	N6	A	●●	●	●		
	Unalloyed, electrolytic copper Brass, bronze, red brass Cu alloys, short-chipping High tensile, Ampco	100	340	N7	E M	●●	●	●●	
		90	310	N8	E M	●●	●	●	
		110	380	N9	E M	●●	●	●	
		300	1010	N10	E M	●●	●	●	
S Heat-resistant alloys Titanium alloys Tungsten alloys Molybdenum alloys	Fe-based Ni- or Co-based	Annealed	200	680	S1	E	●●	●	●●
		Hardened	280	940	S2	E	●●	●	●●
		Annealed	250	840	S3	E	●●	●	●●
		Hardened	350	1180	S4	E	●●	●	●●
		Cast	320	1080	S5	E	●●	●	●●
	Pure titanium α and β alloys, hardened β alloys	200	680	S6	E	●●	●	●●	
		375	1260	S7	E	●●	●	●	
		410	1400	S8	E	●●	●	●	
	300	1010	S9	E	●●	●	●		
	300	1010	S10	E	●●	●	●		
H Hardened steel Hardened cast iron	Hardened and tempered Hardened and tempered Hardened and tempered	50 HRC	–	H1	M A	●	●●	●	
		55 HRC	–	H2	M				
		60 HRC	–	H3	M				
	55 HRC	–	H4	M A					
O Thermoplastics Thermosets Plastic, glass-fibre-reinforced Plastic, carbon-fibre-reinforced Plastic, aramid-fibre-reinforced Graphite (technical)	Without abrasive fillers Without abrasive fillers GFRP CFRP AFRP				01	E M	●●	●	●
					02	E M	●●	●	●
					03	E M	●●	●	●
					04	E M	●●	●	●
					05	E M	●●	●	●
		65			06	E M	●●	●	●

¹ The classification of the machining groups can be found from page B 1174 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

* The TC685 is a left-hand cutting version. Machining is therefore performed by climb milling.

** For nickel-based alloys, leave a radial machining allowance of 0.1–0.2 mm in the first cut in order to prevent the spring pass changing the structure.

	TC620 Supreme				TC685 Supreme*			
	v_c [m/min]	f_z [mm]			v_c	f_z [mm]		
	WB10TJ	$D_c \leq 6$ mm	$D_c > 6$ mm and ≤ 12 mm	$D_c > 12$ mm	WB10RC	$D_c \leq 4$ mm	$D_c > 4$ mm and ≤ 8 mm	$D_c > 8$
	115	0,07	0,11	0,15				
	155	0,07	0,11	0,15				
	130	0,07	0,11	0,15				
	130	0,07	0,11	0,15				
	95	0,07	0,11	0,15				
	130	0,07	0,11	0,15				
	130	0,07	0,11	0,15				
	80	0,05	0,09	0,13				
	75	0,05	0,09	0,13				
	65	0,05	0,09	0,13	70	0,015	0,030	0,050
	150	0,07	0,11	0,15				
	110	0,07	0,11	0,15				
	90	0,07	0,11	0,15				
	55	0,07	0,11	0,15				
	45	0,07	0,11	0,15				
	70	0,05	0,09	0,13				
	40	0,05	0,09	0,13				
	45	0,04	0,07	0,10				
	105	0,07	0,12	0,17	90	0,020	0,045	0,070
	100	0,07	0,12	0,17	90	0,020	0,045	0,070
	130	0,07	0,12	0,17	100	0,020	0,045	0,070
	110	0,07	0,11	0,15	90	0,020	0,045	0,070
	105	0,07	0,11	0,15	90	0,020	0,045	0,070
	100	0,07	0,11	0,15	90	0,020	0,045	0,070
	85	0,07	0,11	0,15	80	0,020	0,045	0,070
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	150	0,07	0,12	0,17				
	50	0,05	0,09	0,13				
	35	0,07	0,11	0,15				
	25	0,07	0,11	0,15				
	40	0,07	0,11	0,15				
	25	0,05	0,09	0,13				
	25	0,05	0,09	0,13				
	40	0,07	0,11	0,15				
	40	0,05	0,09	0,13				
	20	0,05	0,09	0,13				
	50	0,05	0,09	0,13	30	0,010	0,020	0,050
	60	0,05	0,09	0,13	30	0,010	0,020	0,050
	55	0,05	0,09	0,13	55	0,012	0,030	0,050
					50	0,010	0,022	0,040
					45	0,008	0,020	0,030
					50	0,010	0,022	0,040
	290	0,06	0,1	0,14				
	145	0,06	0,1	0,14				
	65	0,06	0,1	0,14				
	65	0,06	0,1	0,14				
	215	0,06	0,1	0,14				

B5

Cutting data

Indexable insert thread milling

Material group	Overview of the main material groups and code letters		Birnell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹		T2711 / T2712 / T2713			
							v _c [m/min]	f _z [mm]		
								06	Insert size 09/11/14/22	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	E M	200	0,3	0,4
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	E M	200	0,3	0,4
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	E M	200	0,3	0,4
		C > 0.55%	Annealed	190	640	P4	E M	200	0,3	0,4
		C > 0.55%	Heat-treated	300	1010	P5	E M	200	0,3	0,4
		Free-machining steel (short-chipping)	Annealed	220	750	P6	E M	200	0,3	0,4
	Low-alloy steel		Annealed	175	590	P7	E M	200	0,3	0,4
			Heat-treated	285	960	P8	E M	200	0,3	0,4
			Heat-treated	380	1280	P9	E M	150	0,25	0,35
			Heat-treated	430	1480	P10	E M	100	0,2	0,3
	High-alloyed steel and high-alloyed tool steel		Annealed	200	680	P11	E M	200	0,3	0,4
			Hardened and tempered	300	1010	P12	E M	200	0,3	0,4
			Hardened and tempered	380	1280	P13	E M	150	0,3	0,4
	Stainless steel		Ferritic/martensitic, annealed	200	680	P14	E M	200	0,25	0,35
			Martensitic, heat-treated	330	1110	P15	E M	150	0,25	0,35
M	Stainless steel		Austenitic, quench hardened	200	680	M1	E	200	0,2	0,3
			Austenitic, precipitation hardened (PH)	300	1010	M2	E	150	0,2	0,3
			Austenitic/ferritic, duplex	230	780	M3	E	80	0,2	0,3
K	Malleable cast iron		Ferritic	200	400	K1	E M	200	0,3	0,4
			Pearlitic	260	700	K2	E M	200	0,3	0,4
	Grey cast iron		Low tensile strength	180	200	K3	E M	250	0,3	0,4
			High tensile strength/austenitic	245	350	K4	E M	200	0,3	0,4
	Cast iron with spheroidal graphite		Ferritic	155	400	K5	E M	200	0,3	0,4
		Pearlitic	265	700	K6	E M	200	0,3	0,4	
	GGV (CGI)		230	400	K7	E M	200	0,3	0,4	
N	Wrought aluminium alloys		Not hardenable	30	–	N1	E M	200	0,3	0,4
			Hardenable, hardened	100	340	N2	E M	200	0,3	0,4
	Cast aluminium alloys		≤ 12% Si, not hardenable	75	260	N3	E M	200	0,3	0,4
			≤ 12% Si, hardenable, hardened	90	310	N4	E M	200	0,3	0,4
		> 12% Si, not hardenable	130	450	N5	E M	200	0,3	0,4	
	Magnesium-based alloys ³			70	250	N6	A	250	0,3	0,4
		Copper and copper alloys (bronze/brass)		Unalloyed, electrolytic copper	100	340	N7	E M	200	0,3
			Brass, bronze, red brass	90	310	N8	E M	200	0,3	0,4
	Cu alloys, short-chipping		110	380	N9	E M	200	0,3	0,4	
	High tensile, Ampco		300	1010	N10	E M	50	0,3	0,4	
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	E	40	0,25	0,25
			Hardened	280	940	S2	E	25	0,15	0,15
		Ni- or Co-based	Annealed	250	840	S3	E	40	0,25	0,25
			Hardened	350	1180	S4	E	25	0,15	0,15
			Cast	320	1080	S5	E	30	0,2	0,2
	Titanium alloys		Pure titanium	200	680	S6	E	40	0,25	0,25
			α and β alloys, hardened	375	1260	S7	E	40	0,25	0,25
			β alloys	410	1400	S8	E	30	0,2	0,2
		Tungsten alloys		300	1010	S9	E	40	0,25	0,25
		Molybdenum alloys		300	1010	S10	E	40	0,25	0,25
H	Hardened steel		Hardened and tempered	50 HRC	–	H1	M A	45	0,2	0,3
			Hardened and tempered	55 HRC	–	H2	M	–	–	–
			Hardened and tempered	60 HRC	–	H3	M	–	–	–
		Hardened cast iron		55 HRC	–	H4	M A	45	0,2	0,3
O	Thermoplastics	Without abrasive fillers				O1	E M	200	0,3	0,4
	Thermosets	Without abrasive fillers				O2	E M	150	0,3	0,4
	Plastic, glass-fibre-reinforced	GFRP				O3	E M	50	0,3	0,4
	Plastic, carbon-fibre-reinforced	CFRP				O4	E M	50	0,3	0,4
	Plastic, aramid-fibre-reinforced	AFRP				O5	E M	50	0,3	0,4
	Graphite (technical)			65			O6	E M	200	0,3

¹ The classification of the machining groups can be found from page B 1174 onwards in the Walter General Catalogue 2017.

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

Machining must be performed by climb milling. The specified cutting data are target values under good machining conditions.

Remedy for vibration:


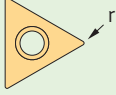
- Use indexable inserts with D61 geometry
- Reduce v_c by 25–50% and/or increase f_z by 25–50%
- Radial cutting pass

T2711/T2712: One radial cut is recommended

T2713: Radial passes may be required.

Radius correction values for thread milling Walter T2711 / T2712 / T2713


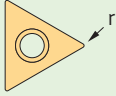
Metric thread in accordance with DIN 13

Thread nominal diameter D_N			Radius correction		
			Minimum dimension for H tolerances	Middle of the tolerance range for a 6H tolerance	Middle of the tolerance range for a 6G tolerance
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
≥ 24	1,5	0,1	-0,05	-0,10	-0,12
	2	0,1	-0,10	-0,15	-0,17
	3	0,2	-0,10	-0,16	-0,19
	3,5	0,2	-0,15	-0,22	-0,24
	4	0,2	-0,20	-0,27	-0,30
	4,5	0,2	-0,25	-0,33	-0,36
	5*	0,2	-0,30	-0,38	-0,42
		0,4	-0,10	-0,18	-0,22
	5,5	0,4	-0,15	-0,24	-0,27
	6	0,4	-0,20	-0,29	-0,33
8	0,4	-0,40	-0,51	-0,56	
10	0,4	-0,59	-0,71	-	

Based on the pitch diameter tolerances in accordance with DIN ISO 965-1. Valid from M24.

* Important: For P = 5 mm, we recommend an insert radius $r = 0.2$ mm. Please take this into account when selecting the radius correction values.


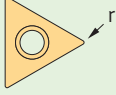
UN/UNC/UNF/UNEF thread in accordance with ASME B1.1

Thread nominal diameter D_N			Radius correction		
			Minimum dimension	Middle of the tolerance range for a 2B tolerance	Middle of the tolerance range for a 3B tolerance
[inches]	[TPI]	[mm]	[mm]	[mm]	[mm]
≥ 1"	18	0,1	-0,04	-0,08	-0,07
	16	0,1	-0,06	-0,10	-0,09
	14	0,1	-0,08	-0,12	-0,11
	12	0,1	-0,11	-0,16	-0,15
	8	0,2	-0,12	-0,17	-0,16
	7	0,2	-0,16	-0,22	-0,21
	6	0,2	-0,22	-0,29	-0,27
	5*	0,2	-0,31	-0,38	-0,36
		0,4	-0,11	-0,18	-0,16
	4,5	0,4	-0,16	-0,24	-0,22
4	0,4	-0,23	-0,32	-0,30	

Based on the pitch diameter tolerances in accordance with ASME B1.1. Valid from UNC 1.

* Important: For P = 5 TPI, we recommend an insert radius $r = 0.2$ mm. Please take this into account when selecting the radius correction values.

Pipe thread G (BSP) in accordance with DIN EN ISO 228

Thread nominal diameter D_N			Radius correction	
			Minimum dimension	Middle of the tolerance range
[inches]	[TPI]	[mm]	[mm]	[mm]
≥ 1" and < 2 1/4"	11	0,2	-0,11	-0,16
≥ 2 1/4"	11	0,2	-0,11	-0,17


Based on the pitch diameter tolerances in accordance with DIN ISO 228. Valid from $D_N 1"$.

If the measured tool radius is reduced by the value stated in the "Minimum dimension" column, the thread is still in the lower tolerance range after machining and is usually too narrow. If the thread has to be milled to bring it to the middle of the tolerance range, the measured tool radius must be reduced by the value stated in the "Middle of the tolerance range" column. The thread is generally true to gauge after machining. Radius correction values can also be determined in Walter GPS.

Example of an M36 - 6H thread	P	4 mm
	r	0,2 mm
Measured tool radius	14,53 mm	
Radius correction in the middle of the 6H tolerance range	- 0,27 mm	
Tool radius to be used	= 14.26 mm	


Radius correction values for solid carbide thread milling cutters Walter TC620 / TC685

Metric thread in accordance with DIN 13

Thread nominal diameter D_N [mm]		Radius correction		
		Minimum dimension for H tolerances	Middle of the tolerance range for a 6H tolerance	Middle of the tolerance range for a 6G tolerance
			[mm]	[mm]
≥ 3 and ≤ 22	0,50	Rprg.	-0,025	-0,035
	0,70	Rprg.	-0,030	-0,041
	0,80	Rprg.	-0,031	-0,043
	1,00	Rprg.	-0,038	-0,051
	1,25	Rprg.	-0,040	-0,054
	1,50	Rprg.	-0,045	-0,061
	1,75	Rprg.	-0,050	-0,067
	2,00	Rprg.	-0,053	-0,072
	2,50	Rprg.	-0,056	-0,077

Based on the pitch diameter tolerances in accordance with DIN ISO 965-1.

UN/UNC/UNF/UNEF thread in accordance with ASME B1.1

Thread nominal diameter D_N [inches]		Radius correction		
		Minimum dimension for H tolerances	Middle of the tolerance range for a 2B tolerance	Middle of the tolerance range for a 3B tolerance
	[TPI]		[mm]	[mm]
≥ 0.164" and ≤ 0.75"	32	Rprg.	-0,023	-0,017
	24	Rprg.	-0,027	-0,020
	20	Rprg.	-0,031	-0,023
	18	Rprg.	-0,034	-0,025
	16	Rprg.	-0,036	-0,027
	13	Rprg.	-0,041	-0,030
	11	Rprg.	-0,046	-0,034
		10	Rprg.	-0,049

Based on the pitch diameter tolerances in accordance with ASME B1.1.

The programming radius (abbreviated to "Rprg.") can be read from the tool shank and is to be entered in the tool table of the CNC control system. The milled thread is then in the lower tolerance range and is usually too narrow. If the thread has to be milled to bring it to the middle of the tolerance range, the Rprg. must be reduced by the value stated in the "Middle of the tolerance range" column. The thread is then generally true to gauge. The radius correction values can also be determined using Walter GPS.

Example of an M8 – 6H thread with P = 1.25 mm

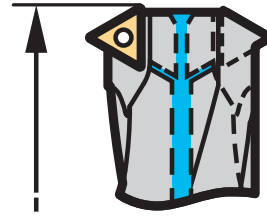
Programming radius (Rprg.)	3,07 mm
Radius correction in the middle of the 6H tolerance range	- 0,04 mm
Tool radius to be used	= 3,03 mm



Tool application Walter T2711 / T2712 / T2713

TOOL GAUGING

If the CNC program is created using Walter GPS, the tool must be gauged as shown in the diagram on the right. The thread depth that was entered is then reached.



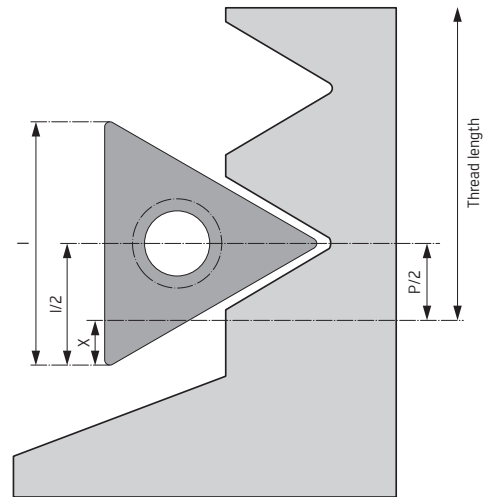
UNUSABLE LENGTH

The thread length includes the last thread ridge plus half a pitch. Since $l/2$ is greater than $P/2$, this results in an "unusable length" (X), which must be taken into consideration during programming.

This is calculated as half of the insert length ($l/2$) minus half of the thread pitch ($P/2$). When creating CNC programs, Walter GPS takes the "unusable length" into account.

Example: M36 with P26300-0902.. thread milling cutter insert.

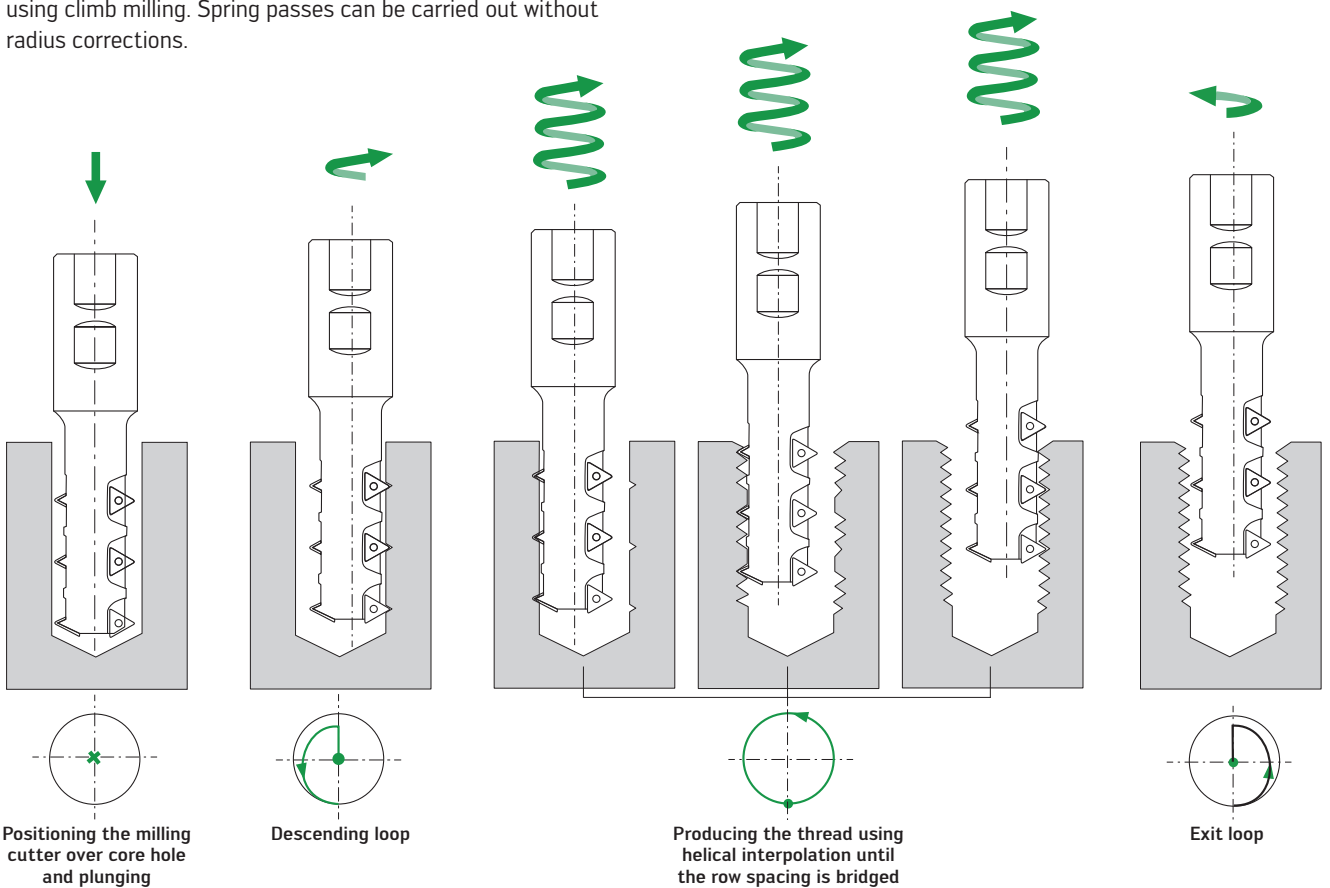
$$\text{Unusable length } X = l/2 - P/2 = \frac{9.34 \text{ mm}}{2} - \frac{4 \text{ mm}}{2} = 2.67 \text{ mm}$$



The unusable length of the T271.. families is less than the chamfer length of a tap.

THE STRATEGY

It is recommended that the thread be produced with a radial cut using climb milling. Spring passes can be carried out without radius corrections.



B5



Solid carbide and ceramic milling tools – C1

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Product range overview of solid carbide milling tools

High-feed milling cutters

Machining			
Helix angle	50°		
Designation	MD025 Supreme	MC089 Advance	MC025 Advance
Diameter range [mm] / [inch]	6-16 / 1/4-5/8	4-16	1-16 / 1/8-5/8
Z	5-6	4	2-4
Corner radius [mm] / [inch]	0,5-2 / 0.020-0.080	0,5-2	0,1-2 / 0.020-0.080
Page	548	549	550

Shoulder milling cutters

Machining				
Helix angle	35°	50°	30°	
Designation	MD133 Supreme	MC187 Advance	MC183 Advance	MC111 Advance
Diameter range [mm] / [inch]	6-20 / 1/4-3/4	3-25 / 1/8-3/4	6-16	3/32-3/4
Z	5-6	4-8	6-16	4
Corner radius [mm] / [inch]	0,3-1 / 0.015-0.030	0-3 / 0.015-0.060	0	0
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Product range overview of solid carbide milling tools

Shoulder/slot milling cutters

Machining						
Helix angle	35°	30°	50°	30°	50°	30°
Designation	AH4135217 AH4137217 Proto-max™ _{ST}	MB266 Supreme	MC388 Advance	MC281 Advance	MC326 Supreme	MC213 Advance MC216 Advance
Diameter range [mm] / [inch]	3/8–3/4	1/4–1	2–12 / 1/8–1/2	1–4	1/4–1	3/32–3/4
Z	5	3	3–4	2	4–5	2–4
Corner radius [mm] / [inch]	0.030–0.060	0.015–0.120	0–3	0,2–0,5	0.030–0.125	0–0.120
Page	556	557	558	560	562	563

Shoulder/slot milling cutters

Machining			
Helix angle	40°		35°
Designation	MC319 Advance	MC320 Advance	MC232 Perform
Diameter range [mm] / [inch]	5–25	4–25 / 1/4–3/4	2–20 / 1/8–3/4
Z	4	3–8	2–4
Corner radius [mm]	0	0	0–4 / 0–0.125
Page	564	565	567

Copy milling cutters

Machining	
Helix angle	30°
Designation	MC480 Advance MC482 Advance
Diameter range [inch]	0,4–16 / 1/8–1/2
Z	2–4
Corner radius [inch]	0,2–4 / 0.063–0.250
Page	574

C 1

Designation key Solid carbide milling tools

Example:

M	C	3	26	—	12.0	A	4	B	200	A	—	W	K	40	TF
1	2	3	4	5	6	7	8	9	10	11	Grade				

1	2	3	4
Tool group	Generation	Tool type	Tool type
M Milling		0 Face milling cutters, high-feed milling cutters 1 Shoulder milling cutters 2 Shoulder/slot/porcupine milling cutters Helix angle $\leq 39^\circ$ 3 Shoulder/slot/porcupine milling cutters Helix angle $\geq 40^\circ$ 4 Ball-nose mill/copy milling cutters 5 Profiling cutters 7 Slot drill cutters/circular interpolation cutters	00 Universal Helix angle 0° , chamfer milling cutters 60° 01 Universal Helix angle 0° , chamfer milling cutters 90° 02 Universal Helix angle 0° , chamfer milling cutters 120° 03 Universal Helix angle 0° , quadrant profiling cutters 04 Universal Helix angle 0° , front/back deburrers 11 Universal Helix angle 30° , type N 12 Universal Helix angle 30° , type HSC 13 Universal Helix angle 30° , type HSC, long version 16 Universal Helix angle 30° , type 30 19 Universal Helix angle 40° , roughing profile with internal coolant 20 Universal Helix angle 40° , roughing profile 21 Universal Helix angle 45° , short version 22 Universal Helix angle 45° , type N 24 Universal Helix angle 45° , type 45 25 Universal Helix angle 50° , high-feed 26 Universal Helix angle 50° , unequal groove depth, differential pitch 29 Universal Helix angle 60° , type N, multipurpose cutter 32 Universal Helix angle 35° 33 Universal Helix angle 35° + chip breaker 41 ISO P Helix angle 50° , HPC, differential pitch 51 ISO M Helix angle $35^\circ/38^\circ$, without internal coolant 65 ISO N Helix angle 30° , AI geometry, RAPAX G30 roughing profile, Axial internal coolant 66 ISO N Helix angle 30° , AI geometry, Axial internal coolant 80 ISO H Helix angle 30° , HSC type H = Helix angle 30° , HSC, type H 81 ISO H Helix angle 30° , mini HSC T, type H = Helix angle 30° , mini HSC T, type H 82 ISO H Helix angle 30° , mini HSC R, type H = Helix angle 30° , mini HSC R, type H 83 ISO H Helix angle 30° , multi-flute, type H = Helix angle 30° , multi-flute, type H 87 ISO H Helix angle 50° , multi-flute, type H = Helix angle 50° , multi-flute, type H 88 ISO H Helix angle 50° , HPC type H = Helix angle 50° , HPC, type H 89 ISO H Helix angle 50° , high-feed, type H = Helix angle 50° , high-feed, type H
5	6	7	
Delimiters	Cutting diameter	Shank type	
— Metric · Inch		A Parallel shank E ConeFit W Weldon shank	
8	9	10	11
Number of teeth	Design standard	Corner radius	Variant
	A DIN 6527 K B DIN 6527 L C ANSI stub D ANSI standard L P Standard L M P Standard Mini P P Standard S P Standard S X P Standard XL		A I3 XS B I3 S / $2 \times D_c^*$ C I3 M / $3 \times D_c^*$ D I3 L / $4 \times D_c^*$ E I3 XL / $5 \times D_c^*$ F I3 XXL / $6 \times D_c^*$ G I3 XXXL / $8 \times D_c^*$ H I3 XXXXL / $10 \times D_c^*$ J Lc S / $3 \times D_c^*$ K Lc M / $4 \times D_c^*$ L Lc L / $5 \times D_c^*$ V Conical neck $\alpha \leq 3^\circ$ W Conical neck $\alpha \leq 6^\circ$ X Conical neck $\alpha \leq 12^\circ$

C 1

Grade designation key for solid carbide and HSS cutting tool materials

Example:

W	K	40	TF
Walter	1	2	3

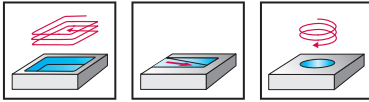
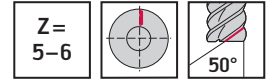
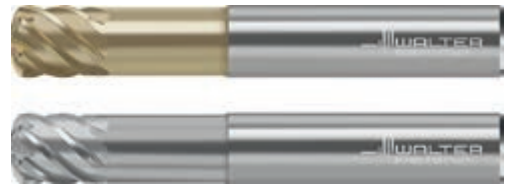
1	2	3
Substrate	Application range	Coating
Solid carbide B J K	<p style="text-align: center;">Wear resistance</p> <p style="text-align: center;">Toughness</p>	TF TiAlN UU Uncoated CA CrN RC TiAlN + AlTi TZ AlTiN + ZrN ED AlCrN TG TiAlSiN RD AlTiN + ZrN RA TiAlN + TiAl
HSS		5 10 15 20 25 30 35 40 45 50 55 60 65 70 75 80 85 90 95

C 1

Solid carbide high-feed milling cutters

MD025 Supreme /

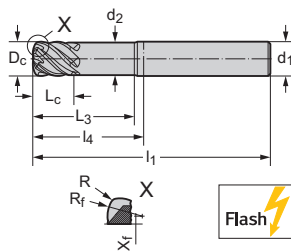
MD025 Supreme



	P	M	K	N	S	H	O
WJ30RA		●●		●	●●		
WJ30RD	●●		●				

PROTOTYP TOOLS STANDARD L

Shank DIN 6535 HA



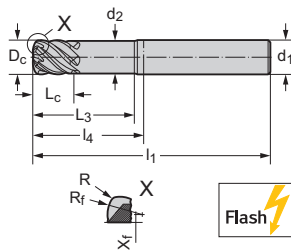
Designation	D _c h9 mm	x _f mm	R _f mm	R _{ers} mm	R mm	L _c mm	l ₁ mm	l ₃ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30RA	WJ30RD
MD025-06.0A5B050C-	6	1,4	3	0,755	0,5	6	57	19	21	6	5	⊕	⊕
MD025-08.0A5B100C-	8	1,54	4	1,379	1	8	63	25	27	8	5	⊕	⊕
MD025-10.0A5B150C-	10	1,7	5	1,998	1,5	10	72	30	32	10	5	⊕	⊕
MD025-12.0A6B150C-	12	2,25	6	2,103	1,5	12	83	36	38	12	6	⊕	⊕
MD025-16.0A6B200C-	16	3,1	8	2,747	2	16	92	42	44	16	6	⊕	⊕

Shoulder milling $a_e \leq 0.5 \times D_c$

Ordering example for the WJ30RD grade: MD025-06.0A5B050C-WJ30RD

STANDARD

Shank DIN 6535 HA



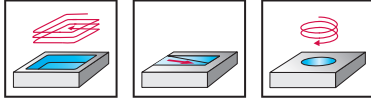
Designation	D _c h9 Inch/no.	x _f inch	R _f inch	R _{ers} inch	R inch	L _c inch	l ₁ inch	l ₃ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30RA	WJ30RD
MD025.6.35A5D051C-	1/4"	0,051	0,146	0,032	0,020	0,250	2,500	1,000	1,083	1/4	5	⊕	⊕
MD025.7.94A5D102C-	5/16"	0,059	0,165	0,054	0,040	0,313	3,000	1,250	1,437	3/8	5	⊕	⊕
MD025.9.53A5D152C-	3/8"	0,067	0,181	0,076	0,060	0,375	3,000	1,250	1,437	3/8	5	⊕	⊕
MD025.12.7A6D152C-	1/2"	0,098	0,236	0,086	0,060	0,500	3,500	1,500	1,717	1/2	6	⊕	⊕
MD025.15.9A6D203C-	5/8"	0,118	0,315	0,110	0,080	0,625	3,500	1,500	1,594	5/8	6	⊕	⊕

Shoulder milling $a_e \leq 0.5 \times D_c$

Ordering example for the WJ30RD grade: MD025.6.35A5D051C-WJ30RD

Solid carbide high-feed milling cutters

MC089 Advance



Z = 4

63HRC
48HRC

	P	M	K	N	S	H	O
WB10TG						●●	

DIN 6527 L	Designation	D_c h9 mm	a_{pf} mm	x_f mm	R_f mm	R_{ers} mm	R mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HA 	MC089-04.0A4B050-	4	0,12	0,6	4	0,618	0,5	11	57	21	6	4	☺
	MC089-05.0A4B050-	5	0,15	0,7	6	0,656	0,5	13	57	21	6	4	☺
	MC089-06.0A4B050-	6	0,2	0,7	9	0,693	0,5	15	57	21	6	4	☺
	MC089-08.0A4B100-	8	0,25	0,78	12	1,226	1	20	63	27	8	4	☺
	MC089-10.0A4B150-	10	0,3	0,8	15	1,773	1,5	26	72	32	10	4	☺
	MC089-12.0A4B150-	12	0,4	1	18	1,875	1,5	30	83	38	12	4	☺
	MC089-16.0A4B200-	16	0,5	1,5	24	2,465	2	36	92	44	16	4	☺

Shoulder milling $a_e \leq 0,5 \times D_c$
 Ordering example for the WB10TG grade: MC089-04.0A4B050-WB10TG

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

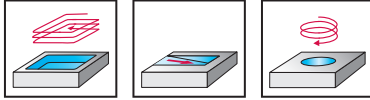
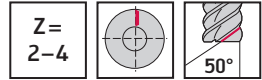
●● Primary application

● Other application

Solid carbide high-feed milling cutters

MC025 Advance /

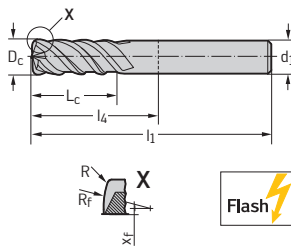
MC025 Advance



	P	M	K	N	S	H	O
WJ30TF	●	●	●	●	●		

PROTOTYP TOOLS STANDARD L

Shank DIN 6535 HA



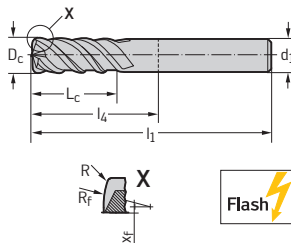
Designation	D _c h9 mm	x _f mm	R _f mm	R _{ers} mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30TF
MC025-01.0A2B010-	1	0,2	0,6	0,142	0,1	3	57	21	4	2	●
MC025-02.0A2B020-	2	0,4	1,2	0,283	0,2	6	57	21	4	2	●
MC025-03.0A2B030-	3	0,6	1,8	0,425	0,3	7	57	21	4	2	●
MC025-04.0A4B050-	4	0,8	2	0,673	0,5	11	57	21	6	4	●
MC025-05.0A4B050-	5	1,1	2,5	0,714	0,5	13	57	21	6	4	●
MC025-06.0A4B050-	6	1,4	3	0,755	0,5	15	57	21	6	4	●
MC025-08.0A4B100-	8	1,54	4	1,379	1	20	63	27	8	4	●
MC025-10.0A4B150-	10	1,7	5	1,998	1,5	26	72	32	10	4	●
MC025-12.0A4B150-	12	2,25	6	2,103	1,5	30	83	38	12	4	●
MC025-16.0A4B200-	16	3,1	8	2,747	2	36	92	44	16	4	●

Shoulder milling $a_e \leq 0.5 \times D_c$

Ordering example for the WJ30TF grade: MC025-01.0A2B010-WJ30TF

STANDARD

Shank DIN 6535 HA



Designation	D _c h9 Inch/no.	x _f inch	R _f inch	R _{ers} inch	R inch	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30TF
MC025.3.18A4D051-	1/8"	0,030	0,046	0,023	0,020	0,500	2,500	1,083	1/4	4	●
MC025.4.76A4D051-	3/16"	0,039	0,098	0,028	0,020	0,625	2,500	1,083	1/4	4	●
MC025.6.35A4D051-	1/4"	0,051	0,146	0,032	0,020	0,750	2,500	1,083	1/4	4	●
MC025.7.94A4D102-	5/16"	0,059	0,165	0,054	0,040	0,813	3,000	1,437	3/8	4	●
MC025.9.53A4D152-	3/8"	0,070	0,181	0,075	0,060	0,875	3,000	1,437	3/8	4	●
MC025.12.7A4D152-	1/2"	0,098	0,236	0,086	0,060	1,000	3,500	1,717	1/2	4	●
MC025.15.9A4D203-	5/8"	0,118	0,315	0,110	0,080	1,250	3,500	1,594	5/8	4	●

Shoulder milling $a_e \leq 0.5 \times D_c$

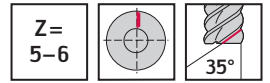
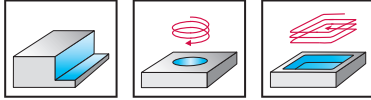
Ordering example for the WJ30TF grade: MC025.3.18A4D051-WJ30TF

Solid carbide shoulder milling cutters

MD133 Supreme /
MD133 Supreme

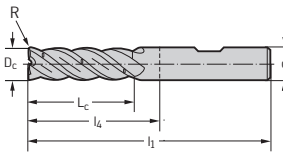


- Chip breaker



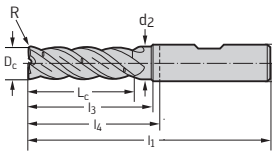
	P	M	K	N	S	H	O
WJ30RA		●●		●	●		
WJ30RD	●●		●				

PROTOTYP TOOLS STANDARD L		D _c h10 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation									
	MD133-06.0W5L030J-	6	0,3	19	65	29	6	5	☺	☹
	MD133-08.0W5L040J-	8	0,4	25	68	32	8	5	☺	☹
	MD133-10.0W5L050J-	10	0,5	32	80	40	10	5	☺	☹
	MD133-12.0W5L060J-	12	0,6	38	93	48	12	5	☺	☹
	MD133-16.0W6L080J-	16	0,8	50	115	62	16	6	☺	☹
	MD133-20.0W6L100J-	20	1	63	125	75	20	6	☺	☹



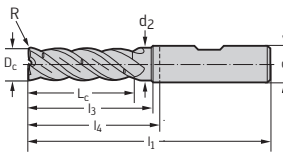
Shoulder milling $a_e \leq 0.10 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.03 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133-06.0W5L030J-WJ30RD

PROTOTYP TOOLS STANDARD L		D _c h10 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation											
	MD133-06.0W5L030D-	6	0,3	19	27	5,5	65	29	6	5	☺	☹
	MD133-08.0W5L040D-	8	0,4	25	30	7,5	68	32	8	5	☺	☹
	MD133-10.0W5L050D-	10	0,5	32	38	9,5	80	40	10	5	☺	☹
	MD133-12.0W5L060D-	12	0,6	38	46	11,4	93	48	12	5	☺	☹
	MD133-16.0W6L080D-	16	0,8	50	60	15,2	115	62	16	6	☺	☹
	MD133-20.0W6L100D-	20	1	63	73	19	125	75	20	6	☺	☹



Shoulder milling $a_e \leq 0.10 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.03 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133-06.0W5L030D-WJ30RD

PROTOTYP TOOLS STANDARD L		D _c h10 Inch/ no.	R inch	L _c inch	l ₃ inch	d ₂ inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation											
	MD133.6.35W5L038D-	1/4"	0,015	0,875	1,000	0,237	2,500	1,437	0,250	5	☺	☹
	MD133.9.53W5L038D-	3/8"	0,015	1,250	1,500	0,356	3,250	1,687	0,375	5	☺	☹
	MD133.12.7W5L076D-	1/2"	0,030	1,750	2,125	0,475	4,000	2,217	0,500	5	☺	☹
	MD133.15.9W6L076D-	5/8"	0,030	2,000	2,500	0,594	4,500	2,594	0,625	6	☺	☹
	MD133.19.1W6L076D-	3/4"	0,030	2,500	3,000	0,713	5,500	3,469	0,750	6	☺	☹



Shoulder milling $a_e \leq 0.10 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.03 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133.6.35W5L038D-WJ30RD

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

●● Primary application

● Other application

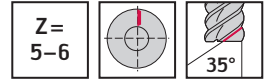
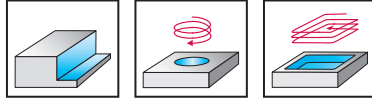
C 1

Solid carbide shoulder milling cutters

MD133 Supreme



- Chip breaker



	P	M	K	N	S	H	O
WJ30RA		••		•	•		
WJ30RD	••		•				

PROTOTYP TOOLS STANDARD L		D _c h10 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation									
	MD133-06.0W5L030K-	6	0,3	25	65	29	6	5	☺	☹
	MD133-08.0W5L040K-	8	0,4	34	80	44	8	5	☺	☹
	MD133-10.0W5L050K-	10	0,5	42	90	50	10	5	☺	☹
	MD133-12.0W5L060K-	12	0,6	50	100	55	12	5	☺	☹
	MD133-16.0W6L080K-	16	0,8	66	125	77	16	6	☺	☹
	MD133-20.0W6L100K-	20	1	83	145	95	20	6	☺	☹

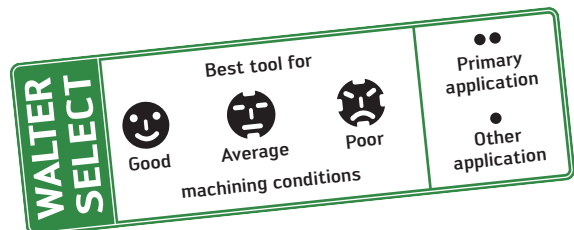
Shoulder milling $a_e \leq 0.05 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.025 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133-06.0W5L030K-WJ30RD

PROTOTYP TOOLS STANDARD XL		D _c h10 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation									
	MD133-06.0W5X030L-	6	0,3	31	80	40	6	5	☺	☹
	MD133-08.0W5X040L-	8	0,4	41	87	51	8	5	☺	☹
	MD133-10.0W5X050L-	10	0,5	52	100	60	10	5	☺	☹
	MD133-12.0W5X060L-	12	0,6	62	116	71	12	5	☺	☹
	MD133-16.0W6X080L-	16	0,8	82	141	93	16	6	☺	☹
	MD133-20.0W6X100L-	20	1	103	165	115	20	6	☺	☹

Shoulder milling $a_e \leq 0.03 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.015 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133-06.0W5X030L-WJ30RD

PROTOTYP TOOLS STANDARD XL		D _c h10 Inch/no.	R inch	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30RA	WJ30RD
Shank DIN 6535 HB	Designation									
	MD133.6.35W5X038L-	1/4"	0,015	1,375	3,000	1,937	0,250	5	☺	☹
	MD133.9.53W5X038L-	3/8"	0,015	2,000	4,000	2,437	0,375	5	☺	☹
	MD133.12.7W5X076L-	1/2"	0,030	2,750	5,000	3,217	0,500	5	☺	☹
	MD133.15.9W6X076L-	5/8"	0,030	3,250	5,500	3,594	0,625	6	☺	☹
	MD133.19.1W6X076L-	3/4"	0,030	3,875	6,500	4,469	0,750	6	☺	☹

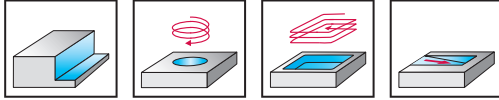
Shoulder milling $a_e \leq 0.03 \times D_c$ for ISO-P
Shoulder milling $a_e \leq 0.015 \times D_c$ for ISO-M and ISO-S
Ordering example for the WJ30RD grade: MD133.6.35W5X038L-WJ30RD



C 1

Solid carbide shoulder milling cutters

MC187 Advance /
 MC187 Advance



Z= 4-8

50°

63HRC
48HRC

P	M	K	N	S	H	O
WB10TG						●●

DIN 6527 L		D _c h10 mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WB10TG
Shank DIN 6535 HA 	Designation							
	MC187-03.0A4B-	3	8	57	21	6	4	☉
	MC187-04.0A4B-	4	11	57	21	6	4	☉
	MC187-05.0A4B-	5	13	57	21	6	4	☉
	MC187-06.0A6B-	6	13	57	21	6	6	☉
	MC187-08.0A6B-	8	19	63	27	8	6	☉
	MC187-10.0A6B-	10	22	72	32	10	6	☉
	MC187-12.0A6B-	12	26	83	38	12	6	☉
	MC187-16.0A6B-	16	32	92	44	16	6	☉
	MC187-20.0A8B-	20	38	104	54	20	8	☉
	MC187-25.0A8B-	25	45	121	65	25	8	☉

Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WB10TG grade: MC187-03.0A4B-WB10TG

PROTOTYP TOOLS STANDARD L		D _c h10 mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WB10TG
Shank DIN 6535 HA 	Designation							
	MC187-06.0A6L-	6	26	75	34	6	6	☉
	MC187-08.0A6L-	8	36	80	44	8	6	☉
	MC187-10.0A6L-	10	46	100	60	10	6	☉
	MC187-12.0A6L-	12	55	110	65	12	6	☉
	MC187-16.0A6L-	16	66	130	82	16	6	☉
	MC187-20.0A8L-	20	80	145	95	20	8	☉
	MC187-25.0A8L-	25	90	153	97	25	8	☉

Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WB10TG grade: MC187-06.0A6L-WB10TG

DIN 6527 L		D _c h9 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WB10TG
Shank DIN 6535 HA 	Designation								
	MC187-03.0A4B050-	3	0,5	8	57	21	6	4	☉
	MC187-04.0A4B050-	4	0,5	11	57	21	6	4	☉
	MC187-04.0A4B100-	4	1	11	57	21	6	4	☉
	MC187-05.0A6B050-	5	0,5	13	57	21	6	6	☉
	MC187-05.0A6B100-	5	1	13	57	21	6	6	☉
	MC187-06.0A6B050-	6	0,5	13	57	21	6	6	☉
	MC187-06.0A6B100-	6	1	13	57	21	6	6	☉
	MC187-08.0A6B050-	8	0,5	19	63	27	8	6	☉
	MC187-08.0A6B100-	8	1	19	63	27	8	6	☉
	MC187-08.0A6B200-	8	2	19	63	27	8	6	☉
	MC187-10.0A6B050-	10	0,5	22	72	32	10	6	☉
	MC187-10.0A6B100-	10	1	22	72	32	10	6	☉
	MC187-10.0A6B200-	10	2	22	72	32	10	6	☉
	MC187-12.0A6B050-	12	0,5	26	83	38	12	6	☉

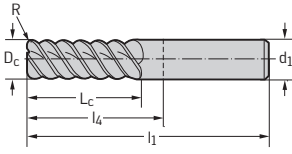
Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WB10TG grade: MC187-03.0A4B050-WB10TG

Continued

C 1

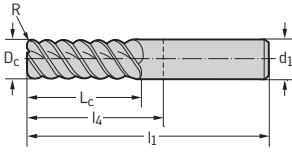
Continued

DIN 6527 L		D_c h9 mm	R mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HA	MC187-12.0A6B100-	12	1	26	83	38	12	6	⊕
	MC187-12.0A6B200-	12	2	26	83	38	12	6	⊕
	MC187-12.0A6B300-	12	3	26	83	38	12	6	⊕



Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WB10TG grade: MC187-03.0A4B050-WB10TG

STANDARD		D_c h9 Inch/no.	R inch	L_c inch	l_1 inch	l_4 inch	d_1 h5 inch	Z	WB10TG
Shank DIN 6535 HA	MC187.3.18A4D038-	1/8"	0,015	0,500	2,500	1,083	0,250	4	⊕
	MC187.4.76A4D038-	3/16"	0,015	0,625	2,500	1,083	0,250	4	⊕
	MC187.6.35A6D038-	1/4"	0,015	0,750	3,000	1,583	0,250	6	⊕
	MC187.7.94A6D051-	5/16"	0,020	0,813	3,000	1,437	0,375	6	⊕
	MC187.9.53A6D076-	3/8"	0,030	0,875	3,000	1,437	0,375	6	⊕
	MC187.12.7A6D076-	1/2"	0,030	1,000	4,500	2,717	0,500	6	⊕
	MC187.15.9A6D152-	5/8"	0,060	1,250	5,000	3,094	0,625	6	⊕
	MC187.19.1A8D152-	3/4"	0,060	1,500	5,000	2,969	0,750	8	⊕



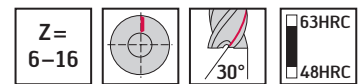
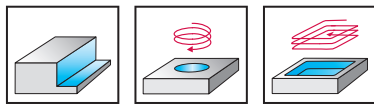
Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WB10TG grade: MC187.3.18A4D038-WB10TG

Solid carbide shoulder milling cutters

MC183 Advance

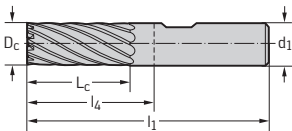


C 1



	P	M	K	N	S	H	O
WB10TG						●●	

DIN 6527 L		D_c h10 mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HB	MC183-06.0W6B-	6	13	57	21	6	6	⊕
	MC183-08.0W8B-	8	19	63	27	8	8	⊕
	MC183-10.0W10B-	10	22	72	32	10	10	⊕
	MC183-12.0W12B-	12	26	83	38	12	12	⊕
	MC183-16.0W16B-	16	32	92	44	16	16	⊕



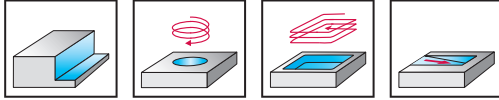
Shoulder milling $a_e \leq 0.05 \times D_c$
 Ordering example for the WB10TG grade: MC183-06.0W6B-WB10TG

Solid carbide shoulder milling cutters

MC111 Advance inch



- Type N 30



Z = 4

P	M	K	N	S	H	O
●	●	●	●	●	●	●

STANDARD		D_c h10 Inch/no.	L_c inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WJ30TF
Shank DIN 6535 HA 	MC111.2.38A4D-	3/32"	0,375	2,500	1,083	0,250	4	
	MC111.3.18A4D-	1/8"	0,500	2,500	1,083	0,250	4	
	MC111.4.76A4D-	3/16"	0,625	2,500	1,083	0,250	4	
	MC111.6.35A4D-	1/4"	0,750	2,500	1,083	0,250	4	
	MC111.7.94A4D-	5/16"	0,813	3,000	1,437	0,375	4	
	MC111.9.53A4D-	3/8"	0,875	3,000	1,437	0,375	4	
	MC111.12.7A4D-	1/2"	1,000	3,500	1,717	0,500	4	
	MC111.15.9A4D-	5/8"	1,250	3,500	1,594	0,625	4	
	MC111.19.1A4D-	3/4"	1,500	4,000	1,969	0,750	4	

Slot milling $a_p \leq 0.3 \times D_c$

Shoulder milling $a_e \leq 0.3 \times D_c$

Ordering example for the WJ30TF grade: MC111.2.38A4D-WJ30TF

WALTER SELECT

Best tool for

Good

Average

Poor

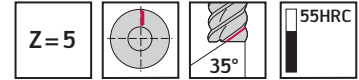
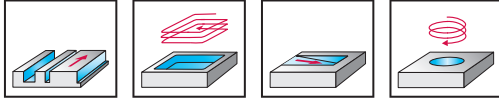
machining conditions

●● Primary application

● Other application

Solid carbide shoulder/slot milling cutters

 AH4135217 inch / AH4137217 inch

Proto-max™_{ST}


TAZ	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

STANDARD	Designation TAZ	D _c h9 Inch/no.	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z
Shank DIN 6535 HB 	AH4135217-3/8	3/8"	0,875	3,000	1,437	0,375	5
	AH4135217-1/2	1/2"	1,063	3,500	1,717	0,500	5
	AH4135217-5/8	5/8"	1,250	3,500	1,594	0,625	5
	AH4135217-3/4	3/4"	1,500	4,000	1,969	0,750	5

 Slot milling $a_p \leq 1.0 \times D_c$
 Shoulder milling $a_e \leq 0.6 \times D_c$

STANDARD	Designation TAZ	D _c h9 Inch/no.	R inch	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z
Shank DIN 6535 HB 	AH4137217-3/8-0.030	3/8"	0,030	0,875	3,000	1,437	0,375	5
	AH4137217-1/2-0.030	1/2"	0,030	1,063	3,500	1,717	0,500	5
	AH4137217-1/2-0.060	1/2"	0,060	1,063	3,500	1,717	0,500	5
	AH4137217-3/4-0.030	3/4"	0,030	1,500	4,000	1,969	0,750	5
	AH4137217-3/4-0.060	3/4"	0,060	1,500	4,000	1,969	0,750	5

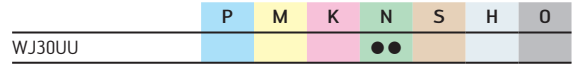
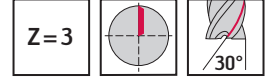
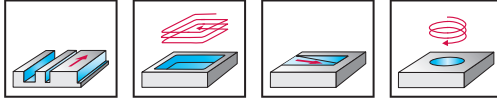
 Slot milling $a_p \leq 1.0 \times D_c$
 Shoulder milling $a_e \leq 0.6 \times D_c$

Solid carbide shoulder/slot milling cutters

MB266 Supreme inch



– Long reach

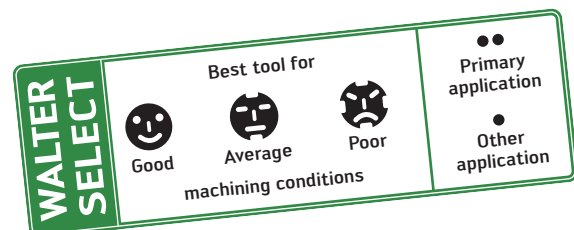


PROTOTYP TOOLS STANDARD XL		D_c h9 Inch/no.	R inch	L_c inch	l_3 inch	d_2 inch	l_1 inch	l_4 inch	d_1 h5 inch	Z	WJ30UU
Shank DIN 6535 HA											
	MB266.6.35A3X038B-	1/4"	0,015	0,375	1,500	0,236	3,000	1,583	0,250	3	☺
	MB266.6.35A3X076B-	1/4"	0,030	0,375	1,500	0,236	3,000	1,583	0,250	3	☺
	MB266.9.53A3X038B-	3/8"	0,015	0,500	1,550	0,355	3,250	1,687	0,375	3	☺
	MB266.9.53A3X076B-	3/8"	0,030	0,500	1,550	0,355	3,250	1,687	0,375	3	☺
	MB266.12.7A3X038B-	1/2"	0,015	0,625	2,125	0,470	4,000	2,217	0,500	3	☺
	MB266.12.7A3X038C-	1/2"	0,015	1,250	3,125	0,470	5,000	3,217	0,500	3	☺
	MB266.12.7A3X076B-	1/2"	0,030	0,625	2,125	0,470	4,000	2,217	0,500	3	☺
	MB266.12.7A3X076C-	1/2"	0,030	1,250	3,125	0,470	5,000	3,217	0,500	3	☺
	MB266.12.7A3X152C-	1/2"	0,060	1,250	3,125	0,470	5,000	3,217	0,500	3	☺
	MB266.12.7A3X305C-	1/2"	0,120	1,250	3,125	0,470	5,000	3,217	0,500	3	☺
	MB266.15.9A3X038C-	5/8"	0,015	1,625	3,125	0,600	5,000	3,148	0,625	3	☺
	MB266.15.9A3X076C-	5/8"	0,030	1,625	3,125	0,600	5,000	3,148	0,625	3	☺
	MB266.15.9A3X152C-	5/8"	0,060	1,625	3,125	0,600	5,000	3,148	0,625	3	☺
	MB266.15.9A3X305C-	5/8"	0,120	1,625	3,125	0,600	5,000	3,148	0,625	3	☺
	MB266.19.1A3X038C-	3/4"	0,015	1,625	3,125	0,715	5,000	3,156	0,750	3	☺
	MB266.19.1A3X076B-	3/4"	0,030	1,000	2,125	0,715	4,000	2,156	0,750	3	☺
	MB266.19.1A3X076C-	3/4"	0,030	1,625	3,125	0,715	5,000	3,156	0,750	3	☺
	MB266.19.1A3X152B-	3/4"	0,060	1,000	2,125	0,715	4,000	2,156	0,750	3	☺
	MB266.19.1A3X305C-	3/4"	0,120	1,625	3,125	0,715	5,000	3,156	0,750	3	☺
	MB266.25.4A3X038B-	1"	0,015	1,250	2,125	0,955	5,000	2,717	1,000	3	☺
	MB266.25.4A3X076B-	1"	0,030	1,250	2,125	0,955	5,000	2,717	1,000	3	☺
	MB266.25.4A3X152B-	1"	0,060	1,250	2,125	0,955	5,000	2,717	1,000	3	☺
	MB266.25.4A3X305B-	1"	0,120	1,250	2,125	0,955	5,000	2,717	1,000	3	☺

Slot milling $a_p \leq 0.9 \times D_c$

Shoulder milling $a_e \leq 0.6 \times D_c$

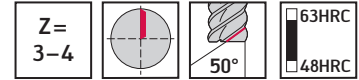
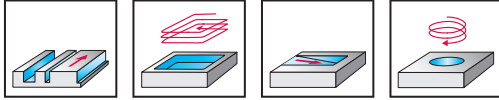
Ordering example for the WJ30UU grade: MB266.6.35A3X038B-WJ30UU



C 1

Solid carbide shoulder/slot milling cutters

 MC388 Advance /

 MC388 Advance


P	M	K	N	S	H	O
●	●	●	●	●	●	●

DIN 6527 L		D_c h10 mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HA	MC388-06.0A4B-	6	13	57	21	6	4	⊕
	MC388-08.0A4B-	8	19	63	27	8	4	⊕
	MC388-10.0A4B-	10	22	72	32	10	4	⊕
	MC388-12.0A4B-	12	26	83	38	12	4	⊕
Shank DIN 6535 HB	MC388-06.0W4B-	6	13	57	21	6	4	⊕
	MC388-08.0W4B-	8	19	63	27	8	4	⊕
	MC388-10.0W4B-	10	22	72	32	10	4	⊕
	MC388-12.0AWB-	12	26	83	38	12	4	⊕

 Slot milling $a_p \leq 0.9 \times D_c$

 Shoulder milling $a_e \leq 0.3 \times D_a$

Ordering example for the WB10TG grade: MC388-06.0A4B-WB10TG

DIN 6527 L		D_c h10 mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HA	MC388-02.0A3B-	2	7	57	21	6	3	⊕
	MC388-03.0A3B-	3	8	57	21	6	3	⊕
	MC388-04.0A3B-	4	11	57	21	6	3	⊕
	MC388-05.0A3B-	5	13	57	21	6	3	⊕
	MC388-06.0A4L-	6	13	65	29	6	4	⊕
	MC388-08.0A4L-	8	19	80	44	8	4	⊕
	MC388-10.0A4L-	10	22	100	60	10	4	⊕
	MC388-12.0A4L-	12	26	100	55	12	4	⊕

 Slot milling $a_p \leq 0.9 \times D_c$

 Shoulder milling $a_e \leq 0.3 \times D_a$

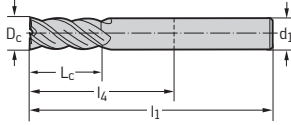
Ordering example for the WB10TG grade: MC388-02.0A3B-WB10TG

Continued

C1

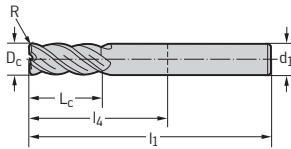
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PROTOTYP TOOLS STANDARD L		D_c h10 Inch/no.	L_c inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WB10TG
Shank DIN 6535 HA	MC388.3.18A3L-	1/8"	0,500	2,500	1,083	0,250	3	☺
	MC388.4.76A3L-	3/16"	0,625	2,500	1,083	0,250	3	☺
	MC388.6.35A4L-	1/4"	0,750	2,500	1,083	0,250	4	☺
	MC388.9.53A4L-	3/8"	0,875	3,000	1,437	0,375	4	☺
	MC388.12.7A4L-	1/2"	1,000	3,500	1,717	0,500	4	☺



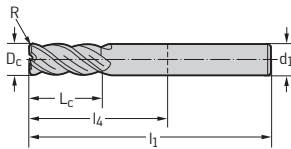
Slot milling $a_p \leq 0.9 \times D_c$
Shoulder milling $a_e \leq 0.3 \times D_a$
Ordering example for the WB10TG grade: MC388.3.18A3L-WB10TG

DIN 6527 L		D_c h9 mm	R mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WB10TG
Shank DIN 6535 HA	MC388-02.0A3B050-	2	0,5	7	57	21	6	3	☺
	MC388-03.0A3B050-	3	0,5	8	57	21	6	3	☺
	MC388-04.0A3B050-	4	0,5	11	57	21	6	3	☺
	MC388-04.0A3B100-	4	1	11	57	21	6	3	☺
	MC388-05.0A3B050-	5	0,5	13	57	21	6	3	☺
	MC388-05.0A3B100-	5	1	13	57	21	6	3	☺
	MC388-06.0A4L050-	6	0,5	13	65	29	6	4	☺
	MC388-06.0A4L100-	6	1	13	65	29	6	4	☺
	MC388-08.0A4L050-	8	0,5	19	80	44	8	4	☺
	MC388-08.0A4L100-	8	1	19	80	44	8	4	☺
	MC388-08.0A4L200-	8	2	19	80	44	8	4	☺
	MC388-10.0A4L050-	10	0,5	22	100	60	10	4	☺
	MC388-10.0A4L100-	10	1	22	100	60	10	4	☺
	MC388-10.0A4L200-	10	2	22	100	60	10	4	☺
	MC388-12.0A4L050-	12	0,5	26	100	55	12	4	☺
	MC388-12.0A4L100-	12	1	26	100	55	12	4	☺
	MC388-12.0A4L200-	12	2	26	100	55	12	4	☺
	MC388-12.0A4L300-	12	3	26	100	55	12	4	☺



Slot milling $a_p \leq 0.9 \times D_c$
Shoulder milling $a_e \leq 0.3 \times D_a$
Ordering example for the WB10TG grade: MC388-02.0A3B050-WB10TG

PROTOTYP TOOLS STANDARD L		D_c h10 Inch/no.	R inch	L_c inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WB10TG
Shank DIN 6535 HA	MC388.3.18A3L038-	1/8"	0,015	0,500	2,500	1,083	0,250	3	☺
	MC388.4.76A3L038-	3/16"	0,015	0,625	2,500	1,083	0,250	3	☺
	MC388.6.35A4L038-	1/4"	0,015	0,750	2,500	1,083	0,250	4	☺
	MC388.9.53A4L076-	3/8"	0,030	0,875	3,000	1,437	0,375	4	☺
	MC388.12.7A4L076-	1/2"	0,030	1,000	3,500	1,717	0,500	4	☺



Slot milling $a_p \leq 0.9 \times D_c$
Shoulder milling $a_e \leq 0.3 \times D_a$
Ordering example for the WB10TG grade: MC388.3.18A3L038-WB10TG

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

• Other application

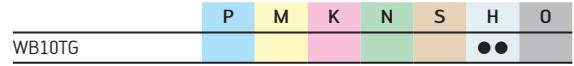
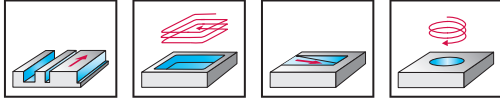
C 1

Solid carbide shoulder/slot milling cutters

MC281 Advance

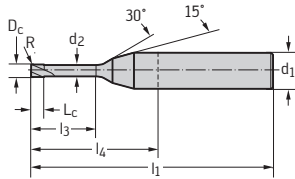


- Long reach



PROTOTYP TOOLS STANDARD MINI

Shank DIN 6535 HA



Designation	D _c h7 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG
MC281-01.0A2M020B-	1	0,2	1	2	0,97	50	22	4	2	☺
MC281-01.0A2M020F-	1	0,2	1	6	0,97	50	22	4	2	☺
MC281-01.0A2M020H-	1	0,2	1	10	0,97	50	22	4	2	☺
MC281-1.25A2M020D-	1,25	0,2	1,25	5	1,22	50	22	4	2	☺
MC281-01.5A2M020C-	1,5	0,2	1,5	4	1,47	50	22	4	2	☺
MC281-01.5A2M020E-	1,5	0,2	1,5	8	1,47	50	22	4	2	☺
MC281-01.5A2M020G-	1,5	0,2	1,5	12	1,47	50	22	4	2	☺
MC281-02.0A2M020B-	2	0,2	2	4	1,97	50	22	4	2	☺
MC281-02.0A2M020C-	2	0,2	2	6	1,97	50	22	4	2	☺
MC281-02.0A2M020F-	2	0,2	2	12	1,97	50	22	4	2	☺
MC281-02.0A2M020G-	2	0,2	2	16	1,97	50	22	4	2	☺
MC281-03.0A2M020C-	3	0,2	3	8	2,97	50	22	4	2	☺
MC281-03.0A2M020E-	3	0,2	3	16	2,97	50	22	4	2	☺
MC281-03.0A2M020F-	3	0,2	3	20	2,97	60	32	4	2	☺
MC281-04.0A2M050C-	4	0,5	4	12	3,97	65	29	6	2	☺
MC281-04.0A2M050E-	4	0,5	4	20	3,97	65	29	6	2	☺

Slot milling $a_p \leq 0.1 \times D_c$

Shoulder milling $a_e \leq 0.1 \times D_c$

Ordering example for the WB10TG grade: MC281-01.0A2M020B-WB10TG

C 1

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

●●
Primary application

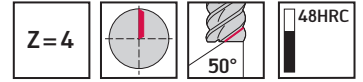
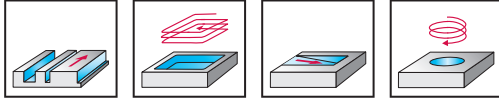
●
Other application

Solid carbide shoulder/slot milling cutters

MC326 Supreme inch



- Type N 50



P	M	K	N	S	H	O
●	●	●	●	●	●	●

WK40TF

STUB		Designation	D _c Inch/no.	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WK40TF
Shank DIN 6535 HA 		MC326.6.35A4C-	1/4"	0,375	2,000	0,583	0,250	4	●
		MC326.7.94A4C-	5/16"	0,500	2,500	0,937	0,313	4	●
		MC326.9.53A4C-	3/8"	0,500	2,500	0,937	0,375	4	●
		MC326.12.7A4C-	1/2"	0,625	3,000	1,217	0,500	4	●
		MC326.15.9A4C-	5/8"	0,750	3,000	1,094	0,625	4	●
Shank DIN 6535 HA 		MC326.7.94A4D-	5/16"	0,813	3,000	1,437	0,313	4	●
		MC326.12.7A4D-	1/2"	1,000	3,500	1,717	0,500	4	●
		MC326.12.7A4DI-	1/2"	1,250	3,500	1,717	0,500	4	●
		MC326.15.9A4D-	5/8"	1,250	3,500	1,594	0,625	4	●
		MC326.19.1A4D-	3/4"	0,750	4,000	1,969	0,750	4	●

Slot milling $a_p \leq 0.9 \times D_c$
 Shoulder milling $a_e \leq 0.3 \times D_c$
 Ordering example for the WK40TF grade: MC326.6.35A4C-WK40TF

STUB		Designation	D _c Inch/no.	R inch	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WK40TF
Shank DIN 6535 HA 		MC326.6.35A4C038-	1/4"	0,015	0,375	2,000	0,583	0,250	4	●
		MC326.6.35A4C076-	1/4"	0,030	0,375	2,000	0,583	0,250	4	●
		MC326.7.94A4C076-	5/16"	0,030	0,500	2,500	0,937	0,313	4	●
		MC326.9.53A4C038-	3/8"	0,015	0,500	2,500	0,937	0,375	4	●
		MC326.9.53A4C076-	3/8"	0,030	0,500	2,500	0,937	0,375	4	●
		MC326.12.7A4C038-	1/2"	0,015	0,625	3,000	1,217	0,500	4	●
		MC326.12.7A4C076-	1/2"	0,030	0,625	3,000	1,217	0,500	4	●
		MC326.15.9A4C076-	5/8"	0,030	0,750	3,000	1,094	0,625	4	●
		MC326.15.9A4C152-	5/8"	0,060	0,750	3,000	1,094	0,625	4	●
Shank DIN 6535 HA 		MC326.7.94A4D076-	5/16"	0,030	0,813	3,000	1,437	0,313	4	●
		MC326.12.7A4D038-	1/2"	0,015	1,000	3,500	1,717	0,500	4	●
		MC326.12.7A4DI038-	1/2"	0,015	1,250	3,500	1,717	0,500	4	●
		MC326.12.7A4D076-	1/2"	0,030	1,000	3,500	1,717	0,500	4	●
		MC326.12.7A4DI076-	1/2"	0,030	1,250	3,500	1,717	0,500	4	●
		MC326.12.7A4D152-	1/2"	0,060	1,000	3,500	1,717	0,500	4	●
		MC326.12.7A4DI152-	1/2"	0,060	1,250	3,500	1,717	0,500	4	●
		MC326.15.9A4D076-	5/8"	0,030	1,250	3,500	1,594	0,625	4	●
		MC326.15.9A4D152-	5/8"	0,060	1,250	3,500	1,594	0,625	4	●
	MC326.19.1A4D076-	3/4"	0,030	0,750	4,000	1,969	0,750	4	●	
	MC326.19.1A4D152-	3/4"	0,060	1,500	4,000	1,969	0,750	4	●	

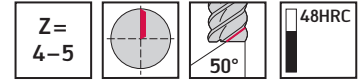
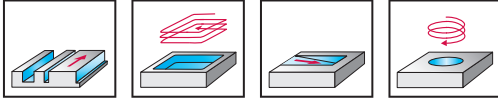
Slot milling $a_p \leq 0.9 \times D_c$
 Shoulder milling $a_e \leq 0.3 \times D_c$
 Ordering example for the WK40TF grade: MC326.6.35A4C038-WK40TF

Solid carbide shoulder/slot milling cutters

MC326 Supreme inch



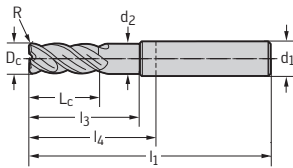
- Long reach
- Type N 50



	P	M	K	N	S	H	O
WK40TF	●	●	●	●	●		

PROTOTYP TOOLS STANDARD L

Shank DIN 6535 HA



Designation	D _c h9 Inch/no.	R inch	L _c inch	l ₃ inch	d ₂ inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WK40TF
MC326.6.35A4L076C-	1/4"	0,030	0,750	1,375	0,237	3,000	1,583	0,250	4	●
MC326.7.94A4L076C-	5/16"	0,030	0,813	1,500	0,297	3,500	1,937	0,375	4	●
MC326.9.53A4L076C-	3/8"	0,030	0,875	1,500	0,356	3,500	1,937	0,375	4	●
MC326.9.53A4L152C-	3/8"	0,060	0,875	1,500	0,356	3,500	1,937	0,375	4	●
MC326.11.1A4L076C-	7/16"	0,030	1,000	2,875	0,416	4,750	2,967	0,500	4	●
MC326.12.7A4L076C-	1/2"	0,030	1,000	2,875	0,475	4,750	2,967	0,500	4	●
MC326.12.7A4L152C-	1/2"	0,060	1,000	2,875	0,475	4,750	2,967	0,500	4	●
MC326.15.9A4L076C-	5/8"	0,030	1,250	3,000	0,594	5,000	3,217	0,625	4	●
MC326.15.9A4L152C-	5/8"	0,060	1,250	3,000	0,594	5,000	3,217	0,625	4	●
MC326.19.1A4L152C-	3/4"	0,060	1,500	3,000	0,713	5,250	3,219	0,750	4	●
MC326.25.4A5L152C-	1"	0,060	1,625	3,250	0,960	5,500	3,217	1,000	5	●
MC326.25.4A5L318C-	1"	0,125	1,625	3,250	0,960	5,500	3,217	1,000	5	●

Slot milling $a_p \leq 0.9 \times D_c$

Shoulder milling $a_e \leq 0.3 \times D_c$

Ordering example for the WK40TF grade: MC326.6.35A4L076C-WK40TF

C 1

WALTER
SELECT

Best tool for

Good

Average

Poor

machining conditions

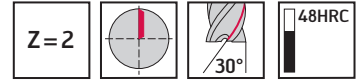
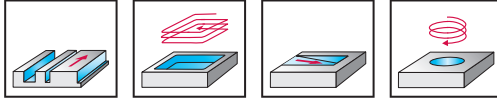
●● Primary application

● Other application

Solid carbide shoulder/slot milling cutters MC216 Advance inch



- Type 30



	P	M	K	N	S	H	O
WJ30TF	●	●	●	●	●		

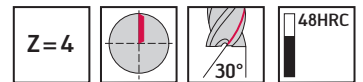
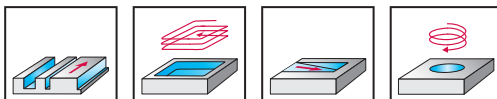
STANDARD		D _c h10 Inch/no.	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30TF
Shank DIN 6535 HA 	Designation							
	MC216.2.38A2D-	3/32"	0,375	2,500	1,083	0,250	2	⊕
	MC216.3.18A2D-	1/8"	0,500	2,500	1,083	0,250	2	⊕
	MC216.4.76A2D-	3/16"	0,625	2,500	1,083	0,250	2	⊕
	MC216.6.35A2D-	1/4"	0,750	2,500	1,083	0,250	2	⊕
	MC216.7.94A2D-	5/16"	0,813	3,000	1,437	0,375	2	⊕
	MC216.9.53A2D-	3/8"	0,875	3,000	1,437	0,375	2	⊕
	MC216.12.7A2D-	1/2"	1,000	3,500	1,717	0,500	2	⊕
	MC216.15.9A2D-	5/8"	1,250	3,500	1,594	0,625	2	⊕
	MC216.19.1A2D-	3/4"	1,500	4,000	1,969	0,750	2	⊕

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.3 \times D_c$
 Ordering example for the WJ30TF grade: MC216.2.38A2D-WJ30TF

Solid carbide shoulder/slot milling cutters MC213 Advance inch



- Long reach
 - Type HSC 30



	P	M	K	N	S	H	O
WJ30TF	●	●	●	●	●		

PROTOTYP TOOLS STANDARD L		D _c h10 Inch/no.	R inch	L _c inch	l ₃ inch	d ₂ inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30TF
Shank DIN 6535 HA 	Designation										
	MC213.6.35A4L038C-	1/4"	0,015	0,750	1,375	0,237	3,000	1,583	0,250	4	⊕
	MC213.6.35A4L076C-	1/4"	0,030	0,750	1,375	0,237	3,000	1,583	0,250	4	⊕
	MC213.9.53A4L038C-	3/8"	0,015	0,875	1,500	0,356	3,500	1,937	0,375	4	⊕
	MC213.9.53A4L076C-	3/8"	0,030	0,875	1,500	0,356	3,500	1,937	0,375	4	⊕
	MC213.12.7A4L076C-	1/2"	0,030	1,000	2,875	0,475	4,750	2,967	0,500	4	⊕
	MC213.12.7A4L152C-	1/2"	0,060	1,000	2,875	0,475	4,750	2,967	0,500	4	⊕
	MC213.12.7A4L305C-	1/2"	0,120	1,000	2,875	0,475	4,750	2,967	0,500	4	⊕
	MC213.15.9A4L076C-	5/8"	0,030	1,250	3,000	0,594	5,000	3,094	0,625	4	⊕
	MC213.15.9A4L152C-	5/8"	0,060	1,250	3,000	0,594	5,000	3,094	0,625	4	⊕
	MC213.19.1A4L152C-	3/4"	0,060	1,500	3,000	0,713	5,250	3,219	0,750	4	⊕
	MC213.19.1A4L305C-	3/4"	0,120	1,500	3,000	0,713	5,250	3,219	0,750	4	⊕

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC213.6.35A4L038C-WJ30TF

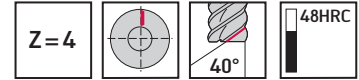
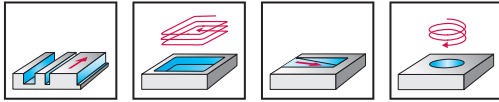
C 1

Solid carbide shoulder/slot milling cutters

MC319 Advance



- Long reach



	P	M	K	N	S	H	O
WK40TF	●	●	●	●	●		

DIN 6527 L		D _c h12 mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WK40TF
Shank DIN 6535 HB	Designation									
	MC319-05.0W4BC-	5	13	16	4,8	57	21	6	4	●
	MC319-06.0W4BC-	6	13	13	5,6	57	21	6	4	●
	MC319-07.0W4BC-	7	16	26	6,5	63	27	8	4	●
	MC319-08.0W4BC-	8	19	25	7,5	63	27	8	4	●
	MC319-09.0W4BC-	9	19	31	8,8	72	32	10	4	●
	MC319-10.0W4BC-	10	22	30	9,5	72	32	10	4	●
	MC319-11.0W4BC-	11	26	35	10,5	83	38	12	4	●
	MC319-12.0W4BC-	12	26	36	11,4	83	38	12	4	●
	MC319-13.0W4BC-	13	26	35	12,4	83	38	14	4	●
	MC319-14.0W4BC-	14	26	36	13,3	83	38	14	4	●
	MC319-15.0W4BC-	15	32	41	14,3	92	44	16	4	●
	MC319-16.0W4BC-	16	32	42	15,2	92	44	16	4	●
	MC319-18.0W4BC-	18	32	42	17,1	92	44	18	4	●
	MC319-20.0W4BC-	20	38	52	19	104	54	20	4	●
	MC319-25.0W4BC-	25	45	63	23,8	121	65	25	4	●

Slot milling $a_p \leq 2.0 \times D_c$
 Shoulder milling $a_e \leq 0.6 \times D_c$
 Ordering example for the WK40TF grade: MC319-05.0W4BC-WK40TF

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

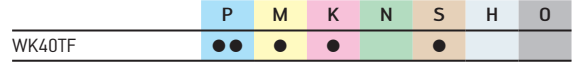
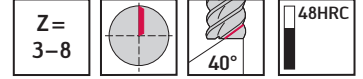
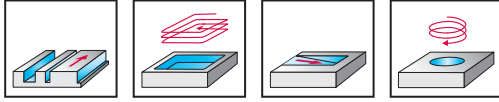
● Other application

Solid carbide shoulder/slot milling cutters

MC320 Advance /
 MC320 Advance



– Long reach



DIN 6527 L		D _c h12 mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WK40TF
Shank DIN 6535 HB										
	MC320-04.0W3BC-	4	8	15	3,8	57	21	6	3	
	MC320-04.0W4BC-	4	11	15	3,8	57	21	6	4	
	MC320-05.0W3BC-	5	10	16	4,8	57	21	6	3	
	MC320-05.0W4BC-	5	13	16	4,8	57	21	6	4	
	MC320-06.0W3BC-	6	10	19	5,5	57	21	6	3	
	MC320-06.0W4BC-	6	13	19	5,5	57	21	6	4	
	MC320-06.0W5BC-	6	13	19	5,5	57	21	6	5	
	MC320-08.0W4BC-	8	19	25	7,5	63	27	8	4	
	MC320-08.0W5BC-	8	19	25	7,5	63	27	8	5	
	MC320-10.0W4BC-	10	22	30	9,5	72	32	10	4	
	MC320-10.0W5BC-	10	22	30	9,5	72	32	10	5	
	MC320-12.0W4BC-	12	26	36	11,4	83	38	12	4	
	MC320-12.0W5BC-	12	26	36	11,4	83	38	12	5	
	MC320-14.0W4BC-	14	26	36	13,3	83	38	14	4	
	MC320-14.0W5BC-	14	26	36	13,3	83	38	14	5	
	MC320-16.0W4BC-	16	32	42	15,2	92	44	16	4	
	MC320-16.0W6BC-	16	32	42	15,2	92	44	16	6	
	MC320-18.0W4BC-	18	32	42	17,1	92	44	18	4	
	MC320-18.0W6BC-	18	32	42	17,1	92	44	18	6	
	MC320-20.0W4BC-	20	38	52	19	104	54	20	4	
	MC320-20.0W6BC-	20	38	52	19	104	54	20	6	
	MC320-20.0W8BC-	20	38	52	19	104	54	20	8	
	MC320-25.0W4BC-	25	45	63	23,8	121	65	25	4	
	MC320-25.0W6BC-	25	45	63	23,8	121	65	25	6	
	MC320-25.0W8BC-	25	45	63	23,8	121	65	25	8	

Slot milling $a_p \leq 1.5 \times D_c$
 Shoulder milling $a_e \leq 0.6 \times D_c$
 Ordering example for the WK40TF grade: MC320-04.0W3BC-WK40TF

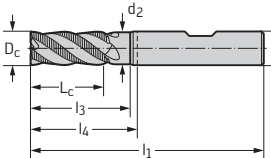
DIN 6527 K		D _c h12 mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WK40TF
Shank DIN 6535 HB								
	MC320-06.0W3A-	6	7	54	18	6	3	
	MC320-06.0W4A-	6	7	54	18	6	4	
	MC320-08.0W3A-	8	9	58	18	8	3	
	MC320-08.0W4A-	8	9	58	18	8	4	
	MC320-10.0W3A-	10	11	66	26	10	3	
	MC320-10.0W4A-	10	11	66	26	10	4	
	MC320-12.0W3A-	12	12	73	28	12	3	
	MC320-12.0W4A-	12	12	73	28	12	4	
	MC320-16.0W3A-	16	16	82	34	16	3	
	MC320-16.0W4A-	16	16	82	34	16	4	
	MC320-20.0W3A-	20	20	92	42	20	3	
	MC320-20.0W4A-	20	20	92	42	20	4	
	MC320-25.0W3A-	25	26	121	65	25	3	
	MC320-25.0W4A-	25	26	121	65	25	4	

Slot milling $a_p \leq 1.0 \times D_c$
 Shoulder milling $a_e \leq 0.6 \times D_c$
 Ordering example for the WK40TF grade: MC320-06.0W3A-WK40TF

Continued

C 1

Continued

STANDARD		D_c h12 Inch/no.	L_c inch	l_3 inch	d_2 inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WK40TF	
	Shank DIN 6535 HB	MC320.6.35W4DC-	1/4"	0,750	0,875	0,230	3,000	1,437	0,375	4	☺
		MC320.9.52W4DC-	3/8"	0,875	1,000	0,355	3,000	1,437	0,375	4	☺
		MC320.12.7W4DC-	1/2"	1,000	1,374	0,475	3,500	1,717	0,500	4	☺
		MC320.15.9W4DC-	5/8"	1,250	1,500	0,594	3,500	1,594	0,625	4	☺
		MC320.19.1W4DC-	3/4"	1,500	2,000	0,713	4,000	1,969	0,750	4	☺

Slot milling $a_p \leq 1.5 \times D_c$

Shoulder milling $a_e \leq 0.6 \times D_c$

Ordering example for the WK40TF grade: MC320.9.52W4DC-WK40TF

C 1

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

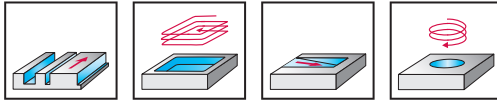
machining conditions

•• Primary application

• Other application

Solid carbide shoulder/slot milling cutters

MC232 Perform /
 MC232 Perform



Z = 2 48HRC

WJ30ED

P	M	K	N	S	H	O
●	●	●	●	●	●	●

DIN 6527 L		D _c h12 mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A2B-	2	6	57	29	4	2	
	MC232-02.5A2B-	2,5	7	57	29	4	2	
	MC232-03.0A2B-	3	7	57	29	4	2	
	MC232-03.5A2B-	3,5	7	57	29	4	2	
	MC232-04.0A2B-	4	8	57	29	4	2	
Shank DIN 6535 HB	MC232-05.0W2B-	5	10	57	21	6	2	
	MC232-06.0W2B-	6	10	57	21	6	2	
	MC232-08.0W2B-	8	16	63	27	8	2	
	MC232-10.0W2B-	10	19	72	32	10	2	
	MC232-12.0W2B-	12	22	83	38	12	2	
	MC232-16.0W2B-	16	26	92	44	16	2	
	MC232-20.0W2B-	20	32	104	54	20	2	

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232-02.0A2B-WJ30ED

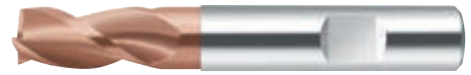
STANDARD		D _c h12 Inch/no.	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30ED
Shank DIN 6535 HA	MC232.3.18A2D-	1/8"	0,500	2,500	1,083	0,250	2	
	MC232.6.35A2D-	1/4"	0,750	2,500	1,083	0,250	2	
Shank DIN 6535 HB	MC232.9.53W2D-	3/8"	0,875	3,000	1,437	0,375	2	
	MC232.12.7W2D-	1/2"	1,000	3,500	1,717	0,500	2	
	MC232.15.9W2D-	5/8"	1,250	3,500	1,594	0,625	2	
	MC232.19.1W2D-	3/4"	1,500	4,000	1,969	0,750	2	

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232.3.18A2D-WJ30ED

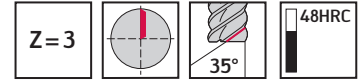
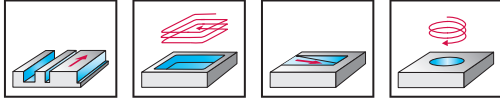
C 1

Solid carbide shoulder/slot milling cutters

MC232 Perform



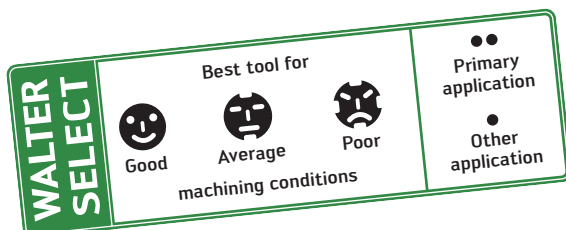
- Long reach



DIN 6527 L		D_c h12 mm	L_c mm	l_3 mm	d_2 mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A3BC-	2	6	11	1,9	57	29	4	3	☺
	MC232-02.5A3BC-	2,5	7	12	2,4	57	29	4	3	☺
	MC232-03.0A3BC-	3	7	12	2,9	57	29	4	3	☺
	MC232-03.5A3BC-	3,5	7	15	3,3	57	29	4	3	☺
	MC232-04.0A3BC-	4	8	15	3,8	57	29	4	3	☺
Shank DIN 6535 HB	MC232-05.0W3BC-	5	10	18	4,8	57	21	6	3	☺
	MC232-06.0W3BC-	6	10	19	5,7	57	21	6	3	☺
	MC232-08.0W3BC-	8	16	25	7,6	63	27	8	3	☺
	MC232-10.0W3BC-	10	19	30	9,5	72	32	10	3	☺
	MC232-12.0W3BC-	12	22	36	11,4	83	38	12	3	☺
	MC232-16.0W3BC-	16	26	42	15,2	92	44	16	3	☺
	MC232-20.0W3BC-	20	32	52	19	104	54	20	3	☺

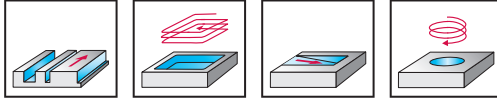
Slot milling $a_p \leq 0,5 \times D_c$
Shoulder milling $a_e \leq 0,5 \times D_c$
Ordering example for the WJ30ED grade: MC232-02.0A3BC-WJ30ED

C 1



Solid carbide shoulder/slot milling cutters

MC232 Perform /
 MC232 Perform



Z = 3 48HRC

WJ30ED	P	M	K	N	S	H	O
	●	●	●				

DIN 6527 L		D_c h12 mm	L_c mm	l_1 mm	l_4 mm	d_1 h6 mm	Z	WJ30ED
Shank DIN 6535 HA 	MC232-02.0A3B-	2	6	57	29	4	3	
	MC232-02.5A3B-	2,5	7	57	29	4	3	
	MC232-03.0A3B-	3	7	57	29	4	3	
	MC232-03.5A3B-	3,5	7	57	29	4	3	
	MC232-04.0A3B-	4	8	57	29	4	3	
Shank DIN 6535 HB 	MC232-05.0W3B-	5	10	57	21	6	3	
	MC232-06.0W3B-	6	10	57	21	6	3	
	MC232-08.0W3B-	8	16	63	27	8	3	
	MC232-10.0W3B-	10	19	72	32	10	3	
	MC232-12.0W3B-	12	22	83	38	12	3	
	MC232-16.0W3B-	16	26	92	44	16	3	
	MC232-20.0W3B-	20	32	104	54	20	3	

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232-02.0A3B-WJ30ED

STANDARD		D_c h12 Inch/no.	L_c inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WJ30ED
Shank DIN 6535 HA 	MC232.3.18A3D-	1/8"	0,500	2,500	1,083	0,250	3	
	MC232.6.35A3D-	1/4"	0,750	2,500	1,083	0,250	3	
Shank DIN 6535 HB 	MC232.9.53W3D-	3/8"	0,875	3,000	1,437	0,375	3	
	MC232.12.7W3D-	1/2"	1,000	3,500	1,717	0,500	3	
	MC232.15.9W3D-	5/8"	1,250	3,500	1,594	0,625	3	
	MC232.19.1W3D-	3/4"	1,500	4,000	1,969	0,750	3	

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232.3.18A3D-WJ30ED

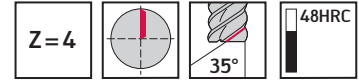
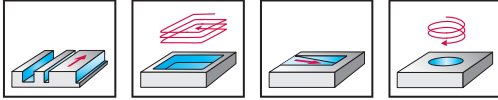
C 1

Solid carbide shoulder/slot milling cutters

 MC232 Perform /

 MC232 Perform


- Long reach



DIN 6527 L		D _c h12 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A4B020C-	2	0,2	7	11	1,85	57	29	4	4	⊕
	MC232-03.0A4B030C-	3	0,3	8	12	2,85	57	29	4	4	⊕
	MC232-04.0A4B050C-	4	0,5	11	15	3,8	57	29	4	4	⊕
Shank DIN 6535 HB	MC232-05.0W4B050C-	5	0,5	13	18	4,75	57	21	6	4	⊕
	MC232-06.0W4B050C-	6	0,5	13	19	5,7	57	21	6	4	⊕
	MC232-06.0W4B080C-	6	0,8	13	19	5,7	57	21	6	4	⊕
	MC232-06.0W4B100C-	6	1	13	19	5,7	57	21	6	4	⊕
	MC232-08.0W4B050C-	8	0,5	19	25	7,6	63	27	8	4	⊕
	MC232-08.0W4B080C-	8	0,8	19	25	7,6	63	27	8	4	⊕
	MC232-08.0W4B100C-	8	1	19	25	7,6	63	27	8	4	⊕
	MC232-08.0W4B150C-	8	1,5	19	25	7,6	63	27	8	4	⊕
	MC232-08.0W4B200C-	8	2	19	25	7,6	63	27	8	4	⊕
	MC232-10.0W4B050C-	10	0,5	22	30	9,5	72	32	10	4	⊕
	MC232-10.0W4B080C-	10	0,8	22	30	9,5	72	32	10	4	⊕
	MC232-10.0W4B100C-	10	1	22	30	9,5	72	32	10	4	⊕
	MC232-10.0W4B150C-	10	1,5	22	30	9,5	72	32	10	4	⊕
	MC232-10.0W4B200C-	10	2	22	30	9,5	72	32	10	4	⊕
	MC232-12.0W4B050C-	12	0,5	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B080C-	12	0,8	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B100C-	12	1	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B150C-	12	1,5	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B200C-	12	2	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B250C-	12	2,5	26	36	11,4	83	38	12	4	⊕
	MC232-12.0W4B300C-	12	3	26	36	11,4	83	38	12	4	⊕
	MC232-16.0W4B050C-	16	0,5	32	42	15,2	92	44	16	4	⊕
	MC232-16.0W4B100C-	16	1	32	42	15,2	92	44	16	4	⊕
	MC232-16.0W4B200C-	16	2	32	42	15,2	92	44	16	4	⊕
	MC232-16.0W4B250C-	16	2,5	32	42	15,2	92	44	16	4	⊕
	MC232-16.0W4B300C-	16	3	32	42	15,2	92	44	16	4	⊕
	MC232-16.0W4B400C-	16	4	32	42	15,2	92	44	16	4	⊕
	MC232-20.0W4B050C-	20	0,5	38	52	19	104	54	20	4	⊕
MC232-20.0W4B100C-	20	1	38	52	19	104	54	20	4	⊕	
MC232-20.0W4B200C-	20	2	38	52	19	104	54	20	4	⊕	
MC232-20.0W4B250C-	20	2,5	38	52	19	104	54	20	4	⊕	
MC232-20.0W4B300C-	20	3	38	52	19	104	54	20	4	⊕	
MC232-20.0W4B400C-	20	4	38	52	19	104	54	20	4	⊕	

 Slot milling $a_p \leq 0,5 \times D_c$

 Shoulder milling $a_e \leq 0,5 \times D_c$

Ordering example for the WJ30ED grade: MC232-02.0A4B020C-WJ30ED

Continued

C 1

Continued

STANDARD		D_c h12 Inch/no.	R inch	L_c inch	l_3 inch	d_2 inch	l_1 inch	l_4 inch	d_1 h6 inch	Z	WJ30ED
Shank DIN 6535 HA	MC232.3.18A4D038C-	1/8"	0,015	0,500	0,625	0,119	2,500	1,083	0,250	4	☺
	MC232.6.35A4D038C-	1/4"	0,015	0,750	1,000	0,237	2,500	1,083	0,250	4	☺
	MC232.6.35A4D076C-	1/4"	0,030	0,750	1,000	0,237	2,500	1,083	0,250	4	☺
Shank DIN 6535 HB	MC232.9.53W4D038C-	3/8"	0,015	0,875	1,125	0,356	3,000	1,437	0,375	4	☺
	MC232.9.53W4D076C-	3/8"	0,030	0,875	1,125	0,356	3,000	1,437	0,375	4	☺
	MC232.12.7W4D038C-	1/2"	0,015	1,000	1,500	0,475	3,500	1,717	0,500	4	☺
	MC232.12.7W4D076C-	1/2"	0,030	1,000	1,500	0,475	3,500	1,717	0,500	4	☺
	MC232.12.7W4D152C-	1/2"	0,060	1,000	1,500	0,475	3,500	1,717	0,500	4	☺
	MC232.12.7W4D318C-	1/2"	0,125	1,000	1,500	0,475	3,500	1,717	0,500	4	☺
	MC232.15.9W4D318C-	5/8"	0,125	1,250	1,563	0,594	3,500	1,594	0,625	4	☺
	MC232.19.1W4D076C-	3/4"	0,030	1,500	1,875	0,713	4,000	1,969	0,750	4	☺
	MC232.19.1W4D318C-	3/4"	0,125	1,500	1,875	0,713	4,000	1,969	0,750	4	☺

Slot milling $a_p \leq 0.5 \times D_c$

Shoulder milling $a_e \leq 0.5 \times D_c$

Ordering example for the WJ30ED grade: MC232.3.18A4D038C-WJ30ED

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

•• Primary application

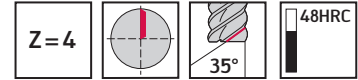
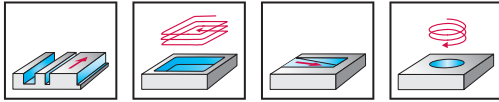
• Other application

Solid carbide shoulder/slot milling cutters

MC232 Perform



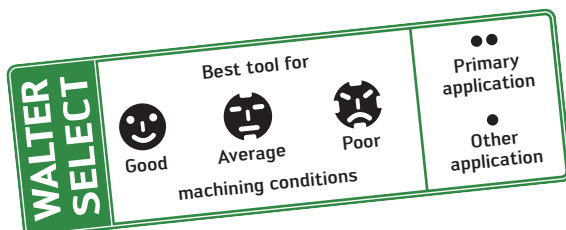
- Long reach



DIN 6527 L		D _c h12 mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A4BC-	2	7	11	1,9	57	29	4	4	●
	MC232-02.5A4BC-	2,5	8	12	2,4	57	29	4	4	●
	MC232-03.0A4BC-	3	8	12	2,9	57	29	4	4	●
	MC232-03.5A4BC-	3,5	10	15	3,3	57	29	4	4	●
	MC232-04.0A4BC-	4	11	15	3,8	57	29	4	4	●
Shank DIN 6535 HB	MC232-05.0W4BC-	5	13	18	4,8	57	21	6	4	●
	MC232-06.0W4BC-	6	13	19	5,7	57	21	6	4	●
	MC232-08.0W4BC-	8	19	25	7,6	63	27	8	4	●
	MC232-10.0W4BC-	10	22	30	9,5	72	32	10	4	●
	MC232-12.0W4BC-	12	26	36	11,4	83	38	12	4	●
	MC232-16.0W4BC-	16	32	42	15,2	92	44	16	4	●
MC232-20.0W4BC-	20	38	52	19	104	54	20	4	●	

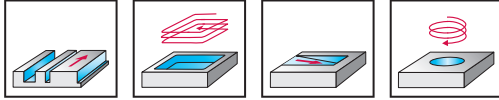
Slot milling $a_p \leq 0,5 \times D_c$
Shoulder milling $a_e \leq 0,5 \times D_c$
Ordering example for the WJ30ED grade: MC232-02.0A4BC-WJ30ED

C 1



Solid carbide shoulder/slot milling cutters

MC232 Perform /
 MC232 Perform



Z = 4 48HRC

P	M	K	N	S	H	O
●	●	●				

WJ30ED

DIN 6527 L		D _c h12 mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A4B-	2	7	57	29	4	4	
	MC232-02.5A4B-	2,5	8	57	29	4	4	
	MC232-03.0A4B-	3	8	57	29	4	4	
	MC232-03.5A4B-	3,5	10	57	29	4	4	
	MC232-04.0A4B-	4	11	57	29	4	4	
Shank DIN 6535 HB	MC232-05.0W4B-	5	13	57	21	6	4	
	MC232-06.0W4B-	6	13	57	21	6	4	
	MC232-08.0W4B-	8	19	63	27	8	4	
	MC232-10.0W4B-	10	22	72	32	10	4	
	MC232-12.0W4B-	12	26	83	38	12	4	
	MC232-16.0W4B-	16	32	92	44	16	4	
	MC232-20.0W4B-	20	38	104	54	20	4	

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232-02.0A4B-WJ30ED

STANDARD		D _c h12 Inch/no.	L _c inch	l ₁ inch	l ₄ inch	d ₁ h6 inch	Z	WJ30ED
Shank DIN 6535 HA	MC232.3.18A4D-	1/8"	0,500	2,500	1,083	0,250	4	
	MC232.6.35A4D-	1/4"	0,750	2,500	1,083	0,250	4	
Shank DIN 6535 HB	MC232.9.53W4D-	3/8"	0,875	3,000	1,437	0,375	4	
	MC232.12.7W4D-	1/2"	1,000	3,500	1,717	0,500	4	
	MC232.15.9W4D-	5/8"	1,250	3,500	1,594	0,625	4	
	MC232.19.1W4D-	3/4"	1,500	4,000	1,969	0,750	4	

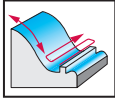
Shoulder milling $a_e \leq 0.5 \times D_c$
 Slot milling $a_p \leq 0.5 \times D_c$
 Ordering example for the WJ30ED grade: MC232.3.18A4D-WJ30ED

C 1

Solid carbide ball-nose end mills

MC482 Advance /

MC482 Advance



	P	M	K	N	S	H	O
WB10TG						●●	

DIN 6527 K		D _c h7 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG
Shank DIN 6535 HA	MC482-03.0A2B-	3	1,5	2,4	57	21	6	2	☺
	MC482-04.0A2B-	4	2	3,2	57	21	6	2	☺
	MC482-05.0A2B-	5	2,5	4	57	21	6	2	☺
	MC482-06.0A2B-	6	3	4,8	57	21	6	2	☺
	MC482-08.0A2B-	8	4	6,4	63	27	8	2	☺

Ordering example for the WB10TG grade: MC482-03.0A2B-WB10TG

DIN 6527 L		D _c h7 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG
Shank DIN 6535 HA	MC482-06.0A2L-	6	3	4,8	80	44	6	2	☺
	MC482-08.0A2L-	8	4	6,4	100	64	8	2	☺
	MC482-10.0A2L-	10	5	8	100	60	10	2	☺
	MC482-12.0A2L-	12	6	9,6	100	55	12	2	☺

Ordering example for the WB10TG grade: MC482-06.0A2L-WB10TG

C 1

DIN 6527 L		D _c h7 mm	R mm	L _c mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG
Shank DIN 6535 HA	MC482-06.0A4B-	6	3	4,8	57	21	6	4	☺
	MC482-08.0A4B-	8	4	6,4	63	27	8	4	☺
	MC482-10.0A4B-	10	5	8	72	32	10	4	☺
	MC482-12.0A4B-	12	6	9,6	83	38	12	4	☺
	MC482-16.0A4B-	16	8	12,8	92	44	16	4	☺

Ordering example for the WB10TG grade: MC482-06.0A4B-WB10TG

Continued

Continued

PROTOTYP TOOLS STANDARD XL		D _c h7 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG	
	Shank DIN 6535 HA	MC482-06.0A4BC-	6	3	4,8	18	5,9	63	27	8	4	☺
		MC482-08.0A4BC-	8	4	6,4	24	7,9	72	32	10	4	☺
		MC482-10.0A4BC-	10	5	8	30	9,9	83	38	12	4	☺
		MC482-12.0A4BC-	12	6	9,6	36	11,8	83	38	12	4	☺
		MC482-16.0A4BC-	16	8	12,8	42	15,8	92	44	16	4	☺

Ordering example for the WB10TG grade: MC482-06.0A4BC-WB10TG

PROTOTYP TOOLS STANDARD XL		D _c h7 mm	R mm	L _c mm	l ₃ mm	α	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG	
	Shank DIN 6535 HA	MC482-01.0A2PV-	1	0,5	0,8	17	2,5°	57	21	6	2	☺
		MC482-01.0A2PW-	1	0,5	0,8	17	4°	57	21	6	2	☺
		MC482-01.5A2PV-	1,5	0,8	1,2	17	2,5°	57	21	6	2	☺
		MC482-01.5A2PW-	1,5	0,8	1,2	17	4°	57	21	6	2	☺
		MC482-02.0A2PV-	2	1	1,6	18	2,5°	57	21	6	2	☺
		MC482-02.0A2PW-	2	1	1,6	18	4°	57	21	6	2	☺
		MC482-03.0A2PV-	3	1,5	2,4	19	2,5°	57	21	6	2	☺
		MC482-03.0A2PW-	3	1,5	2,4	19	4°	57	21	6	2	☺
		MC482-03.0A2LV-	3	1,5	2,4	38	2,5°	80	44	6	2	☺
		MC482-04.0A2PV-	4	2	3,2	20	2,5°	57	21	6	2	☺
		MC482-04.0A2PW-	4	2	3,2	20	4°	57	21	6	2	☺

Ordering example for the WB10TG grade: MC482-01.0A2PV-WB10TG

Tool	D _c h7 Inch/no.	R inch	L _c inch	l ₃ inch	d ₂ inch	l ₁ inch	l ₄ inch	d ₁ h5 inch	Z	WB10TG	
	MC482.3.18A2PC-	1/8"	0,063	0,125	0,375	0,121	2,500	1,083	0,250	2	☺
	MC482.4.76A2PC-	3/16"	0,094	0,188	0,500	0,184	2,500	1,083	0,250	2	☺
	MC482.6.35A2PC-	1/4"	0,125	0,250	0,875	0,246	2,500	1,083	0,250	2	☺
	MC482.9.53A2PB-	3/8"	0,188	0,375	1,000	0,369	3,000	1,437	0,375	2	☺
	MC482.12.7A2PB-	1/2"	0,250	0,500	1,375	0,492	3,500	1,717	0,500	2	☺

Ordering example for the WB10TG grade: MC482.3.18A2PC-WB10TG

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

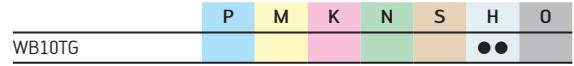
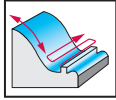
•• Primary application

• Other application

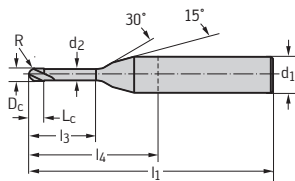
Solid carbide ball-nose end mills

 MC480 Advance


– Long reach


**PROTOTYP TOOLS
STANDARD MINI**

Shank DIN 6535 HA





Designation	D _c h7 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h5 mm	Z	WB10TG
MC480-00.4A2MC-	0,4	0,2	0,3	1	0,4	38	12	4	2	☺
MC480-00.5A2MC-	0,5	0,25	0,4	1,5	0,5	38	12	4	2	☺
MC480-00.6A2MC-	0,6	0,3	0,5	2	0,6	38	12	4	2	☺
MC480-00.8A2MC-	0,8	0,4	0,6	2	0,8	38	12	4	2	☺
MC480-01.0A2MB-	1	0,5	0,8	2	1,0	50	22	4	2	☺
MC480-01.0A2ME-	1	0,5	0,8	5	1,0	50	22	4	2	☺
MC480-01.0A2MG-	1	0,5	0,8	8	1,0	50	22	4	2	☺
MC480-01.5A2MC-	1,5	0,75	1,2	4	1,5	50	22	4	2	☺
MC480-01.5A2ME-	1,5	0,75	1,2	8	1,5	50	22	4	2	☺
MC480-01.5A2MG-	1,5	0,75	1,2	12	1,5	50	22	4	2	☺
MC480-02.0A2MB-	2	1	1,6	3	2,0	50	22	4	2	☺
MC480-02.0A2MC-	2	1	1,6	6	2,0	50	22	4	2	☺
MC480-02.0A2ME-	2	1	1,6	10	2,0	50	22	4	2	☺
MC480-02.0A2MG-	2	1	1,6	16	2,0	50	22	4	2	☺
MC480-03.0A2MC-	3	1,5	2,4	8	3,0	50	22	4	2	☺
MC480-03.0A2ME-	3	1,5	2,4	16	3,0	50	22	4	2	☺
MC480-03.0A2MG-	3	1,5	2,4	25	3,0	60	32	4	2	☺
MC480-04.0A2MC-	4	2	3,2	10	4,0	65	29	6	2	☺
MC480-04.0A2ME-	4	2	3,2	20	4,0	65	29	6	2	☺
MC480-05.0A2MD-	5	2,5	4	20	5,0	65	29	6	2	☺

Ordering example for the WB10TG grade: MC480-00.4A2MC-WB10TG




Solid carbide milling tools with ConeFit interface product range overview

High-feed milling cutters

Machining		
Helix angle	50°	
Designation	MD025	MC025
Diameter range [mm] / [inch]	10-25 / 3/8-1	10-25 / 3/8-1
Z	5-6	4
Corner radius [mm] / [inch]	1,5-3 / 0.060-0.125	1,5-3 / 0.060-0.125
Page	578	579
		

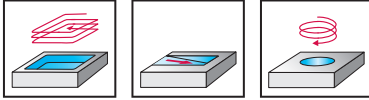
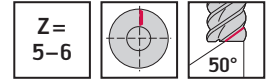
Solid carbide milling tools with ConeFit interface product range overview

Shoulder/slot milling cutters

Machining		
Helix angle	50°	40°
Designation	MC326	MC320
Diameter range [mm] / [inch]	10-25 / 3/8-1	10-25
Z	4-5	4-8
Corner radius [mm] / [inch]	0-4 / 0.015-0.125	0
Page	580	582
		

Solid carbide high-feed milling cutters

MD025 / MD025



	P	M	K	N	S	H	O
WJ30RA		●		●	●		
WJ30RD	●	●	●	●	●		

PROTOTYP TOOLS STANDARD

	Designation	D _c h9 mm	x _f mm	R _f mm	R _{ers} mm	R mm	L _c mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WJ30RA	WJ30RD
ConeFit 	MD025-10.0E5P150-	10	1,7	5	1,998	1,5	5,5	23,6	12,4	8	E10	5	☺	☺
	MD025-12.0E6P150-	12	2,25	6	2,103	1,5	6,5	28,3	14,5	10	E12	6	☺	☺
	MD025-16.0E6P200-	16	3,1	8	2,747	2	8,5	35,7	18,7	12	E16	6	☺	☺
	MD025-20.0E6P200-	20	4	10	3,072	2	11	40,8	21,3	16	E20	6	☺	☺
	MD025-25.0E6P300-	25	5	12	4,206	3	13,5	49,6	25,6	20	E25	6	☺	☺

Shoulder milling $a_e \leq 0.5 \times D_c$
Ordering example for the WJ30RD grade: MD025-10.0E5P150-WJ30RD

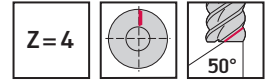
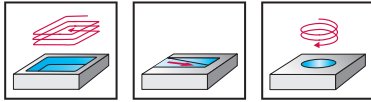
PROTOTYP TOOLS STANDARD

	Designation	D _c h9 Inch/no.	x _f inch	R _f inch	R _{ers} inch	R inch	L _c inch	l ₁ inch	l ₄ inch	SW inch	d ₁ inch	Z	WJ30RA	WJ30RD
ConeFit 	MD025.9.53E5P152-	3/8"	0,067	0,181	0,076	0,060	0,209	0,929	0,488	0,315	E10	5	☺	☺
	MD025.12.7E6P152-	1/2"	0,098	0,236	0,086	0,060	0,276	1,114	0,571	0,394	E12	6	☺	☺
	MD025.15.9E6P203-	5/8"	0,118	0,315	0,110	0,080	0,335	1,406	0,736	0,472	E16	6	☺	☺
	MD025.19.1E6P203-	3/4"	0,157	0,354	0,117	0,080	0,413	1,606	0,839	0,630	E20	6	☺	☺
	MD025.25.4E6P318-	1"	0,197	0,472	0,174	0,125	0,551	1,953	1,008	0,787	E25	6	☺	☺

Shoulder milling $a_e \leq 0.5 \times D_c$
Ordering example for the WJ30RD grade: MD025.9.53E5P152-WJ30RD

Solid carbide high-feed milling cutters

MC025 / MC025



	P	M	K	N	S	H	O
WJ30TF	●	●	●	●	●		

PROTOTYP TOOLS STANDARD		D _c h9 mm	x _f mm	R _f mm	R _{ers} mm	R mm	L _c mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WJ30TF
ConeFit 	Designation												
	MC025-10.0E4P150-	10	1,7	5	1,998	1,5	5,5	23,6	12,4	8	E10	4	●
	MC025-12.0E4P150-	12	2,25	6	2,103	1,5	6,5	28,3	14,5	10	E12	4	●
	MC025-16.0E4P200-	16	3,1	8	2,747	2	8,5	35,7	18,7	12	E16	4	●
	MC025-20.0E4P200-	20	4	10	3,072	2	11	40,8	21,3	16	E20	4	●
MC025-25.0E4P300-	25	5	12	4,206	3	13,5	49,6	25,6	20	E25	4	●	

Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC025-10.0E4P150-WJ30TF

PROTOTYP TOOLS STANDARD		D _c h9 Inch/no.	x _f inch	R _f inch	R _{ers} inch	R inch	L _c inch	l ₁ inch	l ₄ inch	SW inch	d ₁ inch	Z	WJ30TF
ConeFit 	Designation												
	MC025.9.53E4P152-	3/8"	0,067	0,181	0,076	0,060	0,209	0,929	0,488	0,315	E10	4	●
	MC025.12.7E4P152-	1/2"	0,098	0,236	0,086	0,060	0,276	1,114	0,571	0,394	E12	4	●
	MC025.15.9E4P203-	5/8"	0,118	0,315	0,110	0,080	0,335	1,406	0,736	0,472	E16	4	●
	MC025.19.1E4P203-	3/4"	0,157	0,354	0,117	0,080	0,413	1,606	0,839	0,630	E20	4	●
MC025.25.4E4P318-	1"	0,197	0,472	0,174	0,125	0,551	1,953	1,008	0,787	E25	4	●	

Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC025.9.53E4P152-WJ30TF

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

●● Primary application

● Other application

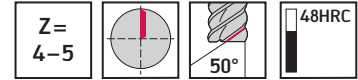
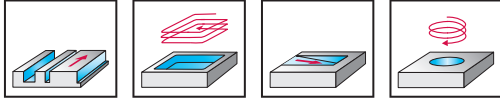
C 1

Solid carbide shoulder/slot milling cutters

MC326 / MC326



- Type N 50

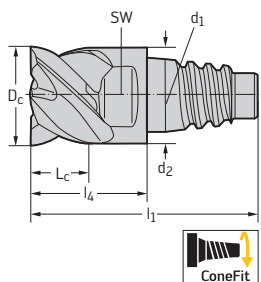


P	M	K	N	S	H	O
●	●	●	●	●	●	●

WJ30TF

PROTOTYP TOOLS STANDARD

ConeFit

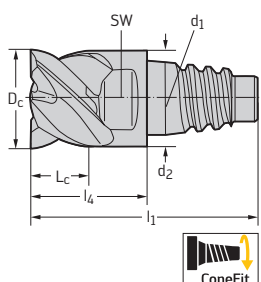


Designation	D _c h10 mm	L _c mm	d ₂ mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WJ30TF
MC326-10.0E4P-	10	5,5	9,7	23,6	12,4	8	E10	4	☺
MC326-12.0E4P-	12	6,5	11,7	28,3	14,5	10	E12	4	☺
MC326-16.0E4P-	16	8,5	15,5	35,7	18,7	12	E16	4	☺
MC326-20.0E4P-	20	11	19,3	40,8	21,3	16	E20	4	☺
MC326-25.0E5P-	25	13,5	24,2	49,6	25,6	20	E25	5	☺

Slot milling $a_p \leq 0.4 \times D_c$
Shoulder milling $a_e \leq 0.5 \times D_c$
Ordering example for the WJ30TF grade: MC326-10.0E4P-WJ30TF

PROTOTYP TOOLS STANDARD

ConeFit



Designation	D _c h9 Inch/no.	L _c inch	d ₂ inch	l ₁ inch	l ₄ inch	SW inch	d ₁ inch	Z	WJ30TF
MC326.9.53E4P-	3/8"	0,209	0,364	0,929	0,488	0,315	E10	4	☺
MC326.12.7E4P-	1/2"	0,276	0,484	1,114	0,575	0,394	E12	4	☺
MC326.15.9E4P-	5/8"	0,335	0,610	1,406	0,736	0,472	E16	4	☺
MC326.19.1E4P-	3/4"	0,413	0,728	1,606	0,839	0,630	E20	4	☺
MC326.25.4E5P-	1"	0,551	0,965	1,953	1,008	0,787	E25	5	☺

Slot milling $a_p \leq 0.4 \times D_c$
Shoulder milling $a_e \leq 0.5 \times D_c$
Ordering example for the WJ30TF grade: MC326.9.53E4P-WJ30TF

Continued

C1

Continued

PROTOTYP TOOLS STANDARD		D _c h9 mm	R mm	L _c mm	d ₂ mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WJ30TF
	Designation										
	ConeFit										
	MC326-10.0E4P050-	10	0,5	5,5	9,7	23,6	12,4	8	E10	4	☺
	MC326-10.0E4P100-	10	1	5,5	9,7	23,6	12,4	8	E10	4	☺
	MC326-10.0E4P150-	10	1,5	5,5	9,7	23,6	12,4	8	E10	4	☺
	MC326-10.0E4P200-	10	2	5,5	9,7	23,6	12,4	8	E10	4	☺
	MC326-10.0E4P300-	10	3	5,5	9,7	23,6	12,4	8	E10	4	☺
	MC326-12.0E4P050-	12	0,5	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-12.0E4P100-	12	1	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-12.0E4P150-	12	1,5	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-12.0E4P200-	12	2	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-12.0E4P300-	12	3	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-12.0E4P400-	12	4	6,5	11,7	28,3	14,5	10	E12	4	☺
	MC326-16.0E4P050-	16	0,5	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-16.0E4P100-	16	1	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-16.0E4P150-	16	1,5	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-16.0E4P200-	16	2	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-16.0E4P300-	16	3	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-16.0E4P400-	16	4	8,5	15,5	35,7	18,7	12	E16	4	☺
	MC326-20.0E4P050-	20	0,5	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-20.0E4P100-	20	1	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-20.0E4P150-	20	1,5	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-20.0E4P200-	20	2	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-20.0E4P300-	20	3	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-20.0E4P400-	20	4	11	19,3	40,8	21,3	16	E20	4	☺
	MC326-25.0E5P100-	25	1	13,5	24,2	49,6	25,6	20	E25	5	☺
	MC326-25.0E5P150-	25	1,5	13,5	24,2	49,6	25,6	20	E25	5	☺
	MC326-25.0E5P200-	25	2	13,5	24,2	49,6	25,6	20	E25	5	☺
MC326-25.0E5P300-	25	3	13,5	24,2	49,6	25,6	20	E25	5	☺	
MC326-25.0E5P400-	25	4	13,5	24,2	49,6	25,6	20	E25	5	☺	

Slot milling $a_p \leq 0.4 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC326-10.0E4P050-WJ30TF

PROTOTYP TOOLS STANDARD		D _c h9 Inch/no.	R inch	L _c inch	d ₂ inch	l ₁ inch	l ₄ inch	SW inch	d ₁ inch	Z	WJ30TF
	Designation										
	ConeFit										
	MC326.9.53E4P038-	3/8"	0,015	0,209	0,364	0,929	0,488	0,315	E10	4	☺
	MC326.9.53E4P076-	3/8"	0,030	0,209	0,364	0,929	0,488	0,315	E10	4	☺
	MC326.12.7E4P038-	1/2"	0,015	0,276	0,484	1,114	0,575	0,394	E12	4	☺
	MC326.12.7E4P076-	1/2"	0,030	0,276	0,484	1,114	0,575	0,394	E12	4	☺
	MC326.12.7E4P152-	1/2"	0,060	0,276	0,484	1,114	0,575	0,394	E12	4	☺
	MC326.15.9E4P152-	5/8"	0,060	0,335	0,610	1,406	0,736	0,472	E16	4	☺
	MC326.19.1E4P152-	3/4"	0,060	0,413	0,728	1,606	0,839	0,630	E20	4	☺
	MC326.19.1E4P318-	3/4"	0,125	0,413	0,728	1,606	0,839	0,630	E20	4	☺
	MC326.25.4E5P152-	1"	0,060	0,551	0,965	1,953	1,008	0,787	E25	5	☺
	MC326.25.4E5P318-	1"	0,125	0,551	0,965	1,953	1,008	0,787	E25	5	☺

Slot milling $a_p \leq 0.4 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC326.9.53E4P038-WJ30TF

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

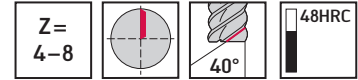
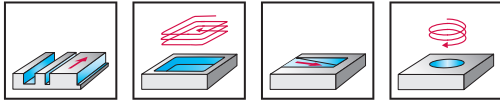
•• Primary application

• Other application

C 1

Solid carbide shoulder/slot milling cutters

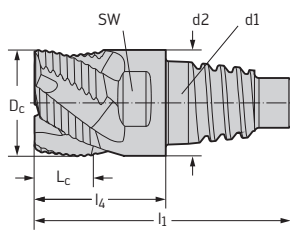
MC320



	P	M	K	N	S	H	O
WJ30TF	●	●	●	●	●		

PROTOTYP TOOLS STANDARD

ConeFit











Designation	D _c h12 mm	L _c mm	d ₂ mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WJ30TF
MC320-10.0E4P-	10	5,5	9,7	23,6	12,4	8	E10	4	●
MC320-10.0E5P-	10	5,5	9,7	23,6	12,4	8	E10	5	●
MC320-12.0E4P-	12	6,5	11,7	28,3	14,5	10	E12	4	●
MC320-12.0E5P-	12	6,5	11,7	28,3	14,5	10	E12	5	●
MC320-16.0E6P-	16	8,5	15,5	35,7	18,7	12	E16	6	●
MC320-20.0E6P-	20	11	19,3	40,8	21,3	16	E20	6	●
MC320-25.0E8P-	25	25	24,2	49,6	25,6	20	E25	8	●

Slot milling $a_p \leq 0.5 \times D_c$
 Shoulder milling $a_e \leq 0.5 \times D_c$
 Ordering example for the WJ30TF grade: MC320-10.0E4P-WJ30TF

Brazed milling tools product range overview

Shoulder/slot milling cutters

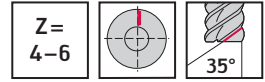
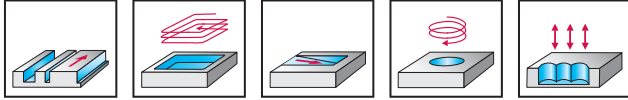
Machining				
Designation	MC275	MC075	MC275	MC075
Dia. range [mm]	8–12	8–12	12–25	16–25
Z	4–6	4	4–8	4
Shank [mm]	DIN 6535 HA	DIN 6535 HA	ConeFit	ConeFit
Page	584	585	586	587
				

Ceramic shoulder/slot milling cutters

MC275



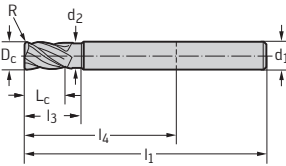
- Long reach



	P	M	K	N	S	H	O
WIS10					●●		

PROTOTYP TOOLS STANDARD

	Designation	D _c h12 mm	R mm	L _c mm	l ₃ mm	d ₂ mm	l ₁ mm	l ₄ mm	d ₁ h6 mm	Z	WIS10
Shank DIN 6535 HA	MC275-08.0A4P100C-	8	1	2	19	7,6	67	31	8	4	☺
	MC275-10.0A4P100C-	10	1	2	22	9,5	75	35	10	4	☺
	MC275-12.0A4P100C-	12	1	2	26	11,4	82	37	12	4	☺
	MC275-12.0A6P100C-	12	1	2	26	11,4	82	37	12	6	☺



Shoulder milling $a_e \leq 0.1 \times D_c$

Slot milling $a_p \leq 0.1 \times D_c$

Ordering example for the WIS10 grade: MC275-08.0A4P100C-WIS10

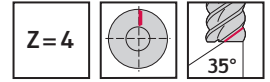
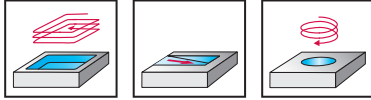
C 1

Ceramic shoulder/slot milling cutters

MC075 mm

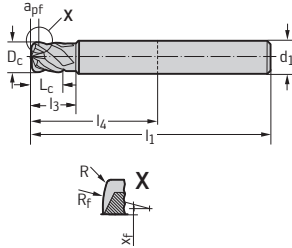


- Long reach



	P	M	K	N	S	H	O
WIS10					••		

PROTOTYP TOOLS STANDARD		D_c	a_{pf}	x_f	R_f	R_{ers}	R	L_c	l_1	l_3	l_4	d_1	Z	WIS10
Designation		h12 mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	h6 mm		
Shank DIN 6535 HA	MC075-08.0A4P100C-	8	0,25	0,78	12	1,226	1	7	67	19	31	8	4	☺
	MC075-10.0A4P150C-	10	0,3	0,8	15	1,773	1,5	7	75	22	35	10	4	☺
	MC075-12.0A4P150C-	12	0,4	1	18	1,875	1,5	7	82	26	37	12	4	☺



Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WIS10 grade: MC075-08.0A4P100C-WIS10

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

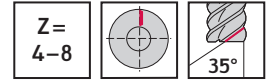
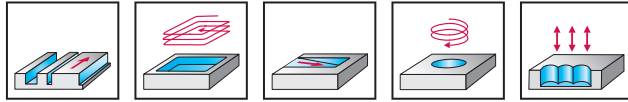
•• Primary application

• Other application

C 1

Ceramic shoulder/slot milling cutters

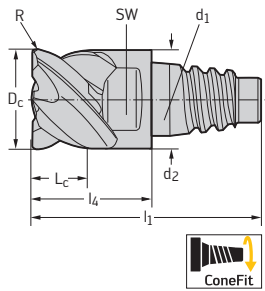
MC275



	P	M	K	N	S	H	O
WIS10					●●		

PROTOTYP TOOLS STANDARD

ConeFit

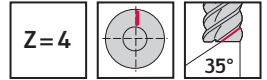
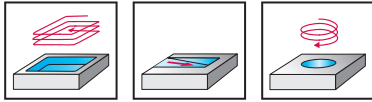


Designation	D _c h12 mm	R mm	L _c mm	d ₂ mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WIS10
MC275-12.0E4P100-	12	1	2	11,7	32,6	18,8	10	E12	4	☺
MC275-12.0E6P100-	12	1	2	11,7	32,6	18,8	10	E12	6	☺
MC275-16.0E6P150-	16	1,5	3	15,5	42,7	25,7	12	E16	6	☺
MC275-16.0E8P150-	16	1,5	3	15,5	42,7	25,7	12	E16	8	☺
MC275-20.0E6P150-	20	1,5	3	19,3	47,8	28,3	16	E20	6	☺
MC275-20.0E8P150-	20	1,5	3	19,3	47,8	28,3	16	E20	8	☺
MC275-25.0E6P150-	25	1,5	3	24,2	56,6	32,6	20	E25	6	☺
MC275-25.0E8P150-	25	1,5	3	24,2	56,6	32,6	20	E25	8	☺

Shoulder milling $a_e \leq 0.1 \times D_c$
Ordering example for the WIS10 grade: MC275-12.0E4P100-WIS10

Ceramic shoulder/slot milling cutters

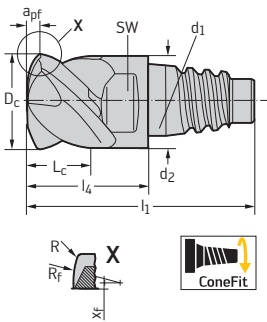
MC075 mm



	P	M	K	N	S	H	O
WIS10					●●		

PROTOTYP TOOLS STANDARD

ConeFit



Designation	D _c h12 mm	a _{pf} mm	x _f mm	R _f mm	R _{ers} mm	R mm	L _c mm	l ₁ mm	l ₄ mm	SW mm	d ₁ mm	Z	WIS10
MC075-16.0E4P200-	16	0,5	1,5	24	2,465	2	9	42,7	25,7	12	E16	4	☺
MC075-20.0E4P200-	20	0,65	2,2	30	2,607	2	9	47,8	28,3	16	E20	4	☺
MC075-25.0E4P300-	25	0,75	2,8	36	3,687	3	9	56,6	32,6	20	E25	4	☺

Shoulder milling $a_e \leq 0.1 \times D_c$
 Ordering example for the WIS10 grade: MC075-16.0E4P200-WIS10

WALTER SELECT

Best tool for

☺
Good

☹
Average

☹
Poor

machining conditions

●● Primary application

● Other application

Cutting data for high-feed milling cutters

						Product family		λ		
						MD025 Supreme MD025 ConeFit		50°		
Material group	Overview of the main material groups and code letters					Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	Ø 6–25 mm / 1/4–1 Inch	
									z = 5–6	
									WJ30RD	
									Starting values for cutting speed v _c [m/min]	
						a _e / D _c		VT ²		
						1	1/4	1/10		
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1		142	D	
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2		224	D	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3		224	D	
		C > 0.55%	Annealed	190	640	P4		191	D	
		C > 0.55%	Heat-treated	300	1010	P5		135	D	
		Free-machining steel (short-chipping)	Annealed	220	750	P6		191	D	
	Low-alloy steel	Annealed		175	590	P7		191	D	
		Heat-treated		285	960	P8		135	D	
		Heat-treated		380	1280	P9		111	D	
		Heat-treated		430	1480	P10		94	D	
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11		191	D	
		Hardened and tempered		300	1010	P12		135	D	
		Hardened and tempered		380	1280	P13		111	D	
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14		68	D	
		Martensitic, heat-treated		330	1110	P15		46	D	
M	Stainless steel	Austenitic, quench hardened		200	680	M1				
		Austenitic, precipitation hardened (PH)		300	1010	M2				
		Austenitic/ferritic, duplex		230	780	M3				
K	Malleable cast iron	Ferritic		200	400	K1		165	D	
		Pearlitic		260	700	K2		129	D	
	Grey cast iron	Low tensile strength		180	200	K3		165	D	
		High tensile strength/austenitic		245	350	K4		139	D	
	Cast iron with spheroidal graphite	Ferritic		155	400	K5		165	D	
		Pearlitic		265	700	K6		129	D	
	GGV (CGI)			230	400	K7		110	D	
N	Wrought aluminium alloys	Not hardenable		30	–	N1				
		Hardenable, hardened		100	340	N2				
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3				
		≤ 12% Si, hardenable, hardened		90	310	N4				
		> 12% Si, not hardenable		130	450	N5				
	Magnesium-based alloys			70	250	N6				
		Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper		100	340	N7			
		Brass, bronze, red brass		90	310	N8				
		Cu alloys, short-chipping		110	380	N9				
		High tensile, Ampco		300	1010	N10				
S	Heat-resistant alloys	Fe-based	Annealed		200	680	S1			
			Hardened		280	940	S2			
		Ni- or Co-based	Annealed		250	840	S3			
			Hardened		350	1180	S4			
			Cast		320	1080	S5			
	Titanium alloys	Pure titanium		200	680	S6				
		α and β alloys, hardened		375	1260	S7				
		β alloys		410	1400	S8				
	Tungsten alloys			300	1010	S9				
	Molybdenum alloys			300	1010	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				
	Thermosets	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			

¹ The classification of the machining groups can be found in the General Catalogue from page C671 onwards.

² The corresponding feed values can be found in the General Catalogue from page C256 onwards.

Product family		λ	Product family		λ	Product family		λ			
MD025 Supreme MD025 ConeFit		50°	MC089 Advance		50°	MC025 Advance MC025 ConeFit		50°			
Ø 6–20 mm / 1/4–1 Inch				Ø 4–16 mm				Ø 1–25 mm / 1/8–1 Inch			
z = 5–6				z = 4				z = 2–4			
WJ30RA				WB10TG				WJ30TF			
Starting values for cutting speed v_c [m/min]			VT²	Starting values for cutting speed v_c [m/min]			VT²	Starting values for cutting speed v_c [m/min]			VT²
a_e / D_c				a_e / D_c				a_e / D_c			
1	1/4	1/10		1	1/4	1/10		1	1/4	1/10	
									105	127	D
									143	174	D
									122	149	D
									122	149	D
									87	105	D
									122	149	D
									122	149	D
									76	92	D
									72	87	D
									61	74	D
									122	149	D
									87	105	D
									72	87	D
									52	64	D
										42	D
		88	B						73	88	D
		50	B							44	D
		68	B						49	59	D
									141	172	D
									110	134	D
									141	172	D
									118	144	D
									141	172	D
									110	134	D
									94	115	D
		556	D								
		556	D								
		185	D								
		60	D								
		40	B						40	48	D
		24	B						24	29	D
		40	B						40	48	D
		24	B						24	29	D
		24	B						24	29	D
		42	B						42	51	D
		22	B						22	27	D
		56	B						55	67	D
		56	B						55	67	D
						90	B	130			
						35	B	55			
						35	B	55			
						80	B	115			

C 1

Cutting data for shoulder milling cutters

						Product family		λ		
						MD133 Supreme		35°		
Material group	Overview of the main material groups and code letters					Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	Ø 6–20 mm / 1/4–3/4 Inch	
									z = 5–6	
									WJ30RD	
									Starting values for cutting speed v _c [m/min]	
						3 x D _c		fz 3xD _c [mm] per tooth		
						PHIS [°]	VC			
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	40	225	0.10	
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	40	355	0.10	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	40	355	0.10	
		C > 0.55%	Annealed	190	640	P4	40	300	0.10	
		C > 0.55%	Heat-treated	300	1010	P5	40	215	0.09	
		Free-machining steel (short-chipping)	Annealed	220	750	P6	40	300	0.10	
	Low-alloy steel	Annealed	175	590	P7	40	300	0.10		
		Heat-treated	285	960	P8	35	220	0.10		
		Heat-treated	380	1280	P9	40	180	0.08		
		Heat-treated	430	1480	P10	35	160	0.12		
	High-alloy steel and high-alloy tool steel	Annealed	200	680	P11	35	310	0.09		
		Hardened and tempered	300	1010	P12	30	240	0.11		
		Hardened and tempered	380	1280	P13	30	195	0.10		
	Stainless steel	Ferritic/martensitic, annealed	200	680	P14					
		Martensitic, heat-treated	330	1110	P15					
M	Stainless steel	Austenitic, quench hardened	200	680	M1					
		Austenitic, precipitation hardened (PH)	300	1010	M2					
		Austenitic/ferritic, duplex	230	780	M3					
K	Malleable cast iron	Ferritic	200	400	K1	40	260	0.11		
		Pearlitic	260	700	K2	35	210	0.10		
	Grey cast iron	Low tensile strength	180	200	K3	40	260	0.11		
		High tensile strength/austenitic	245	350	K4	35	225	0.10		
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	40	260	0.11		
		Pearlitic	265	700	K6	30	220	0.11		
	GGV (CGI)		230	400	K7	40	175	0.10		
N	Wrought aluminium alloys	Not hardenable	30	–	N1					
		Hardenable, hardened	100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3					
		≤ 12% Si, hardenable, hardened	90	310	N4					
		> 12% Si, not hardenable	130	450	N5					
	Magnesium-based alloys		70	250	N6					
		Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7				
			Brass, bronze, red brass	90	310	N8				
Cu alloys, short-chipping	110		380	N9						
High tensile, Ampco	300		1010	N10						
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1				
			Hardened	280	940	S2				
		Ni- or Co-based	Annealed	250	840	S3				
			Hardened	350	1180	S4				
			Cast	320	1080	S5				
	Titanium alloys	Pure titanium	200	680	S6					
		α and β alloys, hardened	375	1260	S7					
		β alloys	410	1400	S8					
	Tungsten alloys		300	1010	S9					
	Molybdenum alloys		300	1010	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					
	Thermosets	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					

¹ The classification of the machining groups can be found in the General Catalogue from page C671 onwards.

² The corresponding feed values can be found in the General Catalogue from page C256 onwards.

Cutting data for shoulder/slot milling cutters

						Product family			λ		
						H4135217		H4137217	35°		
Material group	Overview of the main material groups and code letters					Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹	Ø 6–25 mm / 3/8–3/4 Inch		
									z = 5		
									TAZ		
									Starting values for cutting speed v _c [m/min]		
						a _e / D _c			VT ²		
						1/1	1/2	1/10			
P	Non-alloyed steel	C ≤ 0.25%		Annealed	125	430	P1	170	211	302	A
		C > 0.25 ... ≤ 0.55%		Annealed	190	640	P2	234	290	415	A
		C > 0.25 ... ≤ 0.55%		Heat-treated	210	710	P3	199	248	354	A
		C > 0.55%		Annealed	190	640	P4	199	248	354	A
		C > 0.55%		Heat-treated	300	1010	P5	141	175	250	A
	Free-machining steel (short-chipping)		Annealed	220	750	P6	199	248	354	A	
	Low-alloy steel	Annealed		175	590	P7	199	248	354	A	
		Heat-treated		285	960	P8	124	154	220	A	
		Heat-treated		380	1280	P9					
		Heat-treated		430	1480	P10				A	
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11	199	248	354	A	
		Hardened and tempered		300	1010	P12	141	175	250	A	
		Hardened and tempered		380	1280	P13					
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	68	85	121	A	
Martensitic, heat-treated		330	1110	P15	58	70	99	A			
M	Stainless steel	Austenitic, quench hardened		200	680	M1	74	92	131	B	
		Austenitic, precipitation hardened (PH)		300	1010	M2	46	57	82	B	
		Austenitic/ferritic, duplex		230	780	M3	63	78	111	B	
K	Malleable cast iron	Ferritic		200	400	K1					
		Pearlitic		260	700	K2					
	Grey cast iron	Low tensile strength		180	200	K3					
		High tensile strength/austenitic		245	350	K4					
	Cast iron with spheroidal graphite	Ferritic		155	400	K5					
		Pearlitic		265	700	K6					
	GGV (CGI)			230	400	K7					
N	Wrought aluminium alloys	Not hardenable		30	–	N1					
		Hardenable, hardened		100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3					
		≤ 12% Si, hardenable, hardened		90	310	N4					
		> 12% Si, not hardenable		130	450	N5					
	Magnesium-based alloys			70	250	N6					
		Unalloyed, electrolytic copper		100	340	N7					
Brass, bronze, red brass		90	310	N8							
Copper and copper alloys (bronze/brass)	Cu alloys, short-chipping		110	380	N9						
	High tensile, Ampco		300	1010	N10						
S	Heat-resistant alloys	Fe-based		Annealed	200	680	S1				
				Hardened	280	940	S2				
		Ni- or Co-based		Annealed	250	840	S3				
				Hardened	350	1180	S4				
				Cast	320	1080	S5				
	Titanium alloys	Pure titanium		200	680	S6					
		α and β alloys, hardened		375	1260	S7					
		β alloys		410	1400	S8					
	Tungsten alloys			300	1010	S9					
	Molybdenum alloys			300	1010	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					
	Thermosets	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					

¹ The classification of the machining groups can be found in the General Catalogue from page C671 onwards.

² The corresponding feed values can be found in the General Catalogue from page C256 onwards.

Cutting data for shoulder/slot milling cutters

						Product family			λ	
						MC326 Supreme MC326 ConeFit			50°	
Material group	Overview of the main material groups and code letters				Brinell hardness HB	Tensile strength R_m N/mm ²	Machining group ¹	Ø 2–25 mm / 1/4–1 Inch		
								z = 4–5		
								WK40TF		
								Starting values for cutting speed v_c [m/min]		
								a_g / D_c		
							1/1	1/2	1/10	VT ²
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	150	185	264	A
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2	206	253	363	A
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3	175	216	310	A
		C > 0.55%	Annealed	190	640	P4	175	216	310	A
		C > 0.55%	Heat-treated	300	1010	P5	124	153	219	A
		Free-machining steel (short-chipping)	Annealed	220	750	P6	175	216	310	A
	Low-alloy steel	Annealed	175	590	P7	175	216	310	A	
		Heat-treated	285	960	P8	109	135	192	A	
		Heat-treated	380	1280	P9	102	127	181	A	
		Heat-treated	430	1480	P10	87	107	153	A	
	High-alloy steel and high-alloy tool steel	Annealed	200	680	P11	175	216	310	A	
		Hardened and tempered	300	1010	P12	124	153	219	A	
		Hardened and tempered	380	1280	P13	102	127	181	A	
	Stainless steel	Ferritic/martensitic, annealed	200	680	P14	60	74	106	A	
		Martensitic, heat-treated	330	1110	P15	49	61	87	A	
M	Stainless steel	Austenitic, quench hardened	200	680	M1	71	87	125	B	
		Austenitic, precipitation hardened (PH)	300	1010	M2	44	55	78	B	
		Austenitic/ferritic, duplex	230	780	M3	61	75	107	B	
K	Malleable cast iron	Ferritic	200	400	K1	164	203	290	A	
		Pearlitic	260	700	K2	129	159	226	A	
	Grey cast iron	Low tensile strength	180	200	K3	164	203	290	A	
		High tensile strength/austenitic	245	350	K4	138	170	243	A	
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	164	203	290	A	
		Pearlitic	265	700	K6	129	159	226	A	
	GGV (CGI)		230	400	K7	110	136	194	A	
N	Wrought aluminium alloys	Not hardenable	30	–	N1					
		Hardenable, hardened	100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3					
		≤ 12% Si, hardenable, hardened	90	310	N4					
		> 12% Si, not hardenable	130	450	N5					
	Magnesium-based alloys		70	250	N6					
		Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	340	N7				
	Brass, bronze, red brass		90	310	N8					
	Cu alloys, short-chipping		110	380	N9					
	High tensile, Ampco		300	1010	N10					
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1	46	57	81	B
			Hardened	280	940	S2	29	35	50	B
		Ni- or Co-based	Annealed	250	840	S3	46	57	81	B
			Hardened	350	1180	S4	29	35	50	B
			Cast	320	1080	S5	29	35	50	B
	Titanium alloys	Pure titanium	200	680	S6	49	61	87	B	
		α and β alloys, hardened	375	1260	S7	49	61	87	B	
		β alloys	410	1400	S8	26	32	46	B	
	Tungsten alloys		300	1010	S9	65	80	114	B	
	Molybdenum alloys		300	1010	S10	65	80	114	B	
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					
	Thermosets	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				

¹ The classification of the machining groups can be found in the General Catalogue from page C671 onwards.

² The corresponding feed values can be found in the General Catalogue from page C256 onwards.

Product family		λ	Product family		λ	Product family		λ			
MC213 Advance MC216 Advance		30°	MC319 Advance MC320 Advance MC320 ConeFit		40°	MC232 Perform		35°			
Ø 0,6–20 mm / 3/32–3/4 Inch			Ø 4–25 mm / 1/4–3/4			Ø 2–20 mm / 1/8–3/4 Inch					
z = 2–4			z = 3–8			z = 2–4					
WJ30TF			WK40TF			WJ30ED					
Starting values for cutting speed v_c [m/min]				Starting values for cutting speed v_c [m/min]				Starting values for cutting speed v_c [m/min]			
a_e / D_c			VT²	a_e / D_c			VT²	a_e / D_c			VT²
1/1	1/2	1/10		1	1/2	1/10		1/1	1/2	1/10	
123	180	219	A	123	153	218	A	89	111	158	A
175	247	300	A	169	210	300	A	122	151	216	A
149	210	256	A	144	179	256	A	104	130	185	A
149	210	256	A	144	179	256	A	104	130	185	A
105	149	181	A	102	127	181	A	74	92	131	A
149	210	256	A	144	179	256	A	104	130	185	A
149	210	256	A	144	179	256	A	104	130	185	A
92	130	158	A	90	111	159	A	65	81	115	A
87	122	149	A	84	105	150	A	61	76	108	A
73	103	126	A	71	88	126	A	52	64	92	A
149	210	256	A	144	179	256	A	104	130	185	A
107	149	181	A	102	127	181	A	77	92	131	A
89	122	149	A	84	105	150	A	63	76	108	A
64	90	110	A	49	61	88	A	44	55	79	A
43	59	72	A	41	50	72	A	31		52	A
76	107	130	B	58	73	104	B	62	77	110	B
38	53	64	B	37	46	65	B	32	40	55	B
51	72	87	B	50	62	88	B	42	52	75	B
142	207	252	A	135	168	240	A	120	149	213	A
114	161	196	A	106	131	188	A	94	117	167	A
142	207	252	A	135	168	240	A	120	149	213	A
123	174	211	A	113	141	201	A	101	125	179	A
142	207	252	A	135	168	240	A	120	149	213	A
114	161	196	A	106	131	188	A	94	117	167	A
98	138	168	A	91	112	161	A	80	100	142	A
				522	649	927	C				
				522	649	927	C				
				376	467	667	C				
				376	467	667	C				
				51	63	90	C				
41	58	71	B								
25	35	43	B								
41	58	71	B								
26	35	43	B								
26	35	43	B								
43	62	76	B								
42	61	75	B								
23	32	39	B								
58	81	99	B								
58	81	99	B								

C 1

Cutting data for ball-nose end mills

						Product family			λ	
						MC482 Advance			30°	
Material group	Overview of the main material groups and code letters					Ø 1–16 [1/8–1/2 Inch]				
						Z = 2–4				
						WB10TG				
						Starting values for cutting speed v_c [m/min]			VT ²	
						a_g / D_c				
						1/5	1/20	1/50		
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1				
		C > 0.25 ... ≤ 0.55%	Annealed	190	640	P2				
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	710	P3				
		C > 0.55%	Annealed	190	640	P4				
		C > 0.55%	Heat-treated	300	1010	P5				
		Free-machining steel (short-chipping)	Annealed	220	750	P6				
	Low-alloy steel	Annealed		175	590	P7				
		Heat-treated		285	960	P8				
		Heat-treated		380	1280	P9				
		Heat-treated		430	1480	P10				
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11				
		Hardened and tempered		300	1010	P12				
		Hardened and tempered		380	1280	P13				
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14				
		Martensitic, heat-treated		330	1110	P15				
M	Stainless steel	Austenitic, quench hardened		200	680	M1				
		Austenitic, precipitation hardened (PH)		300	1010	M2				
		Austenitic/ferritic, duplex		230	780	M3				
K	Malleable cast iron	Ferritic		200	400	K1				
		Pearlitic		260	700	K2				
	Grey cast iron	Low tensile strength		180	200	K3				
		High tensile strength/austenitic		245	350	K4				
	Cast iron with spheroidal graphite	Ferritic		155	400	K5				
		Pearlitic		265	700	K6				
	GGV (CGI)			230	400	K7				
N	Wrought aluminium alloys	Not hardenable		30	–	N1				
		Hardenable, hardened		100	340	N2				
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3				
		≤ 12% Si, hardenable, hardened		90	310	N4				
		> 12% Si, not hardenable		130	450	N5				
	Magnesium-based alloys			70	250	N6				
		Unalloyed, electrolytic copper		100	340	N7				
	Copper and copper alloys (bronze/brass)	Brass, bronze, red brass		90	310	N8				
		Cu alloys, short-chipping		110	380	N9				
		High tensile, Ampco		300	1010	N10				
S	Heat-resistant alloys	Fe-based	Annealed		200	680	S1			
			Hardened		280	940	S2			
		Ni- or Co-based	Annealed		250	840	S3			
			Hardened		350	1180	S4			
			Cast		320	1080	S5			
	Titanium alloys	Pure titanium		200	680	S6				
		α and β alloys, hardened		375	1260	S7				
		β alloys		410	1400	S8				
	Tungsten alloys			300	1010	S9				
	Molybdenum alloys			300	1010	S10				
H	Hardened steel	Hardened and tempered		50 HRC	–	H1	245	305	260	B
		Hardened and tempered		55 HRC	–	H2	100	125	150	B
		Hardened and tempered		60 HRC	–	H3	100	125	150	B
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4	220	145	320	B
O	Thermoplastics	Without abrasive fillers				O1				
	Thermosets	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						

¹ The classification of the machining groups can be found in the General Catalogue from page C671 onwards.

² The corresponding feed values can be found in the General Catalogue from page C256 onwards.

High-feed geometry

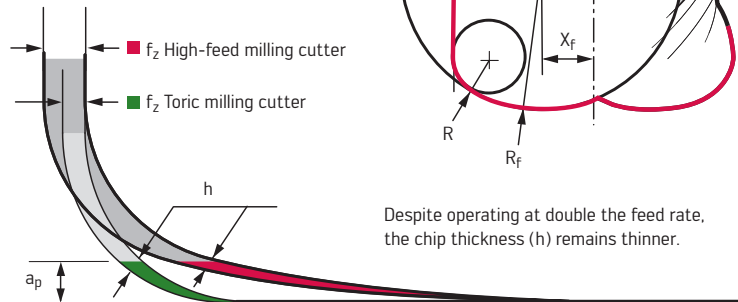
High-feed milling cutter

MD025 Supreme & MD025 ConeFit
(WJ30RD = ISO P & K; WJ30RA = M & S)

MC025 Advance & MC025 ConeFit
(WJ30TF = ISO P, M, K, S ---> Universal)

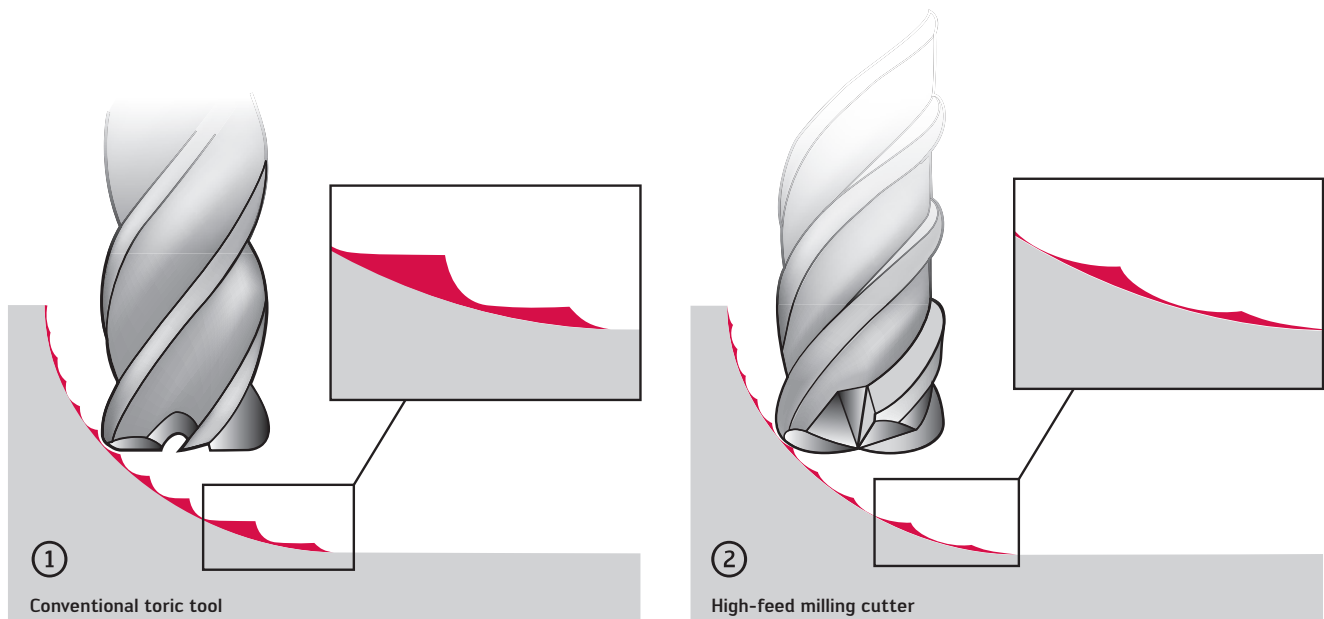
MC089 Advance (WB10TG = ISO H)
MC075 Ceramic and MC075 ConeFit
Ceramic (WIS10 = ISO S)

The chip thickness "h" is reduced thanks to the special end-face geometry. Extremely high feeds are possible. Forces are diverted axially towards the centre of the tool. This stabilises the machining process.



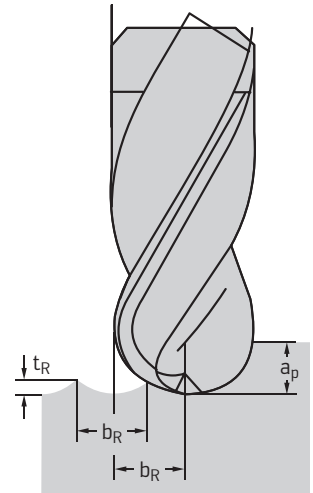
In comparison with conventional toric tools (figure 1), the high-feed milling cutter (figure 2) reduces the amount of residual material produced. This is due to the special geometry that minimises the machining of residual material and increases the tool life of the subsequent finishing tool.

C 1



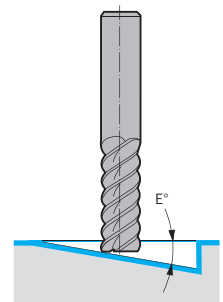
Usage recommendations for copying and finishing with the MC480 / MC482 Advance

Tool diameter D_c (mm)	Row width (b_R) for groove depth $t_R = 5 \mu\text{m}$	Row width (b_R) for groove depth $t_R = 2 \mu\text{m}$
0,4	0,09	0,05
0,5	0,10	0,06
0,6	0,11	0,07
0,8	0,12	0,08
1,0	0,14	0,09
1,5	0,17	0,11
2,0	0,20	0,12
2,5	0,22	0,14
3,0	0,25	0,16
4,0	0,28	0,18
5,0	0,31	0,20
6,0	0,34	0,22
8,0	0,40	0,25
10,0	0,45	0,28
12,0	0,49	0,31
16,0	0,56	0,36



Maximum feed angle [°] on MC183 Advance, MC187 Advance, MC281 Advance, MC388 Advance

Material groups	Material	Number of teeth					
		2	3	4	5	6-8	8
H	Hard materials	2	2	1,5	1,5	1,5	1



C 1

Coated carbide

Walter grade designation	Standard designation	Material groups						Application range							Coating process	Coating composition	Tool example	
		P	M	K	N	S	H	O	01	05	10	15	20	25				30
WB10TG	HC - P 10	●														PVD	TiAlSiN	
	HC - H 10						●●											

Indexable inserts for milling product range overview



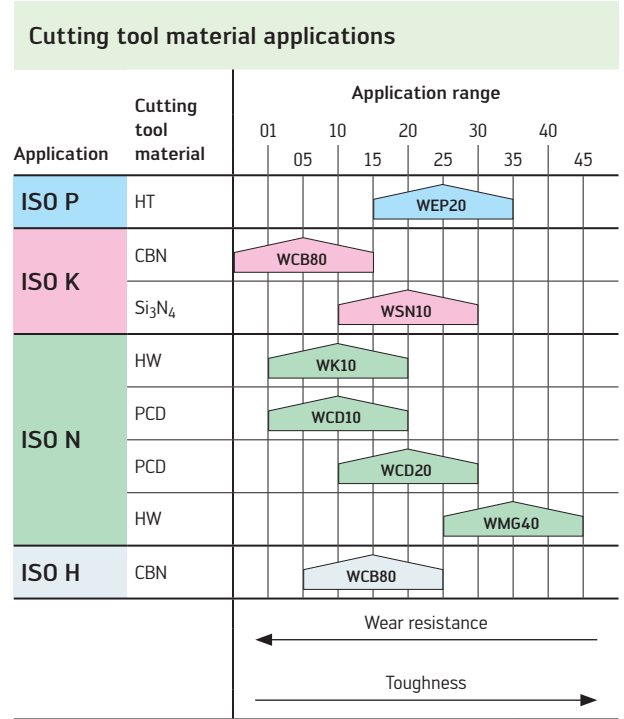
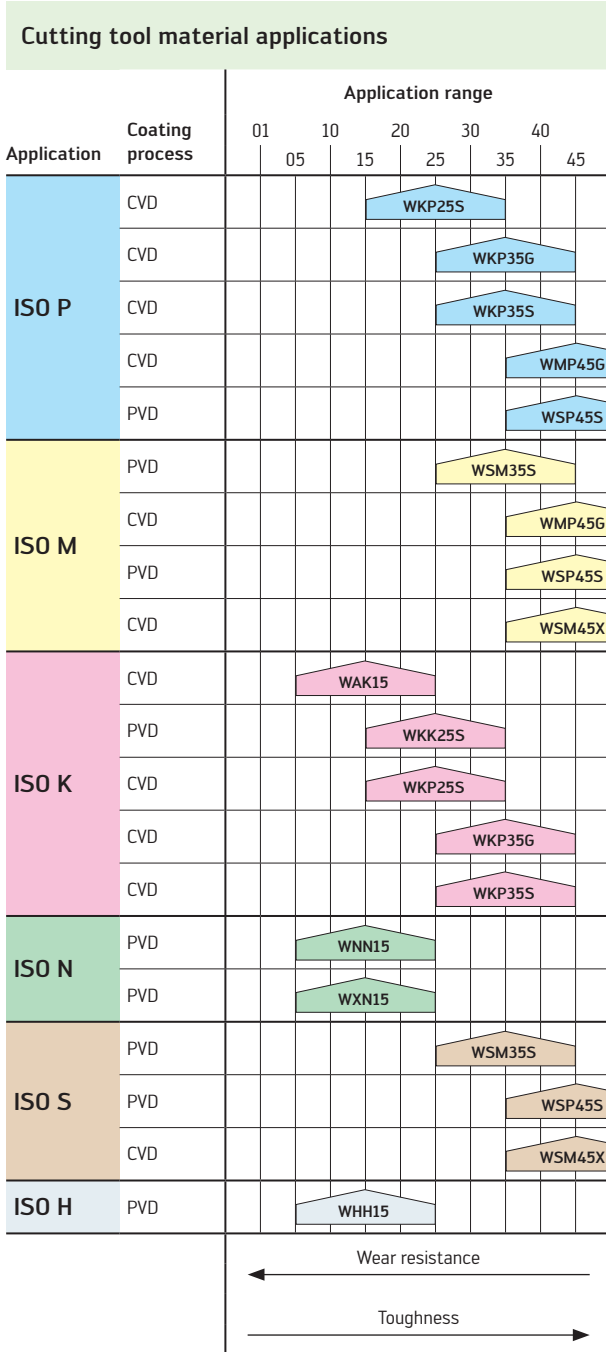
Insert shape	Description	Page
	A Positive rhombic for Xtra-tec®	603
	B Positive rhombic for Xtra-tec® XT	607
	C Tangential rhombic	647
	E Double-sided rhombic for Xtra-tec® XT	633
	Positive rhombic	609
	Double-sided rhombic for Xtra-tec®	633
	Tangential rhombic	647
	Tangential rhombic for Xtra-tec®	648
	Tangential rhombic for Walter BLAXX	648
	M Positive rhombic	610
	Positive octagonal for Xtra-tec®	611
	Finishing inserts	630
	Double-sided octagonal	634
	Positive round	615
	Double-sided round	635
	Positive square	617
	Double-sided square for Xtra-tec®/Xtra-tec® XT	636
	Positive triangular	640
	Double-sided triangular for Xtra-tec® XT	641
	Double-sided heptagon for Xtra-tec®	641
	Double-sided heptagon for Walter BLAXX	642
	X Tangential for Walter BLAXX	651
	X Positive form inserts for copy milling cutters	626
	Z Positive rhombic	628

Insert shape	Description	Page
	SX . . Indexable inserts for Walter BLAXX slitting cutters	653
	P 23 . . Wendelnovex® inserts	634
	P 236 . . Double-sided triangular for Xtra-tec® high-feed milling cutters	635
	Positive triangular for high-feed milling cutters	612
	for copy milling cutters	613
	P 32 . . Indexable inserts for profile milling cutters	614
	P 44 . . Tangential rhombic	652
	Positive finishing inserts	632
	Double-sided finishing inserts	

Cutting tool materials for milling product range overview

Cutting tool materials:
Coated carbide

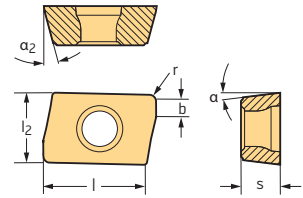
Cutting tool materials:
Uncoated carbide, cermet, ceramic, CBN and PCD











- Si₃N₄ = Silicon nitride ceramic
- HW = Uncoated carbide
- HT = Cermet
- CBN = Cubic boron nitride
- PCD = Polycrystalline diamond

C 2

Positive rhombic
ACGT / ACMT
Tiger-tec® Gold

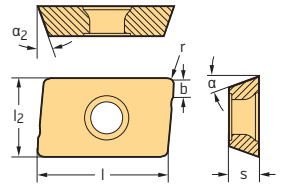


Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K			N		S			
										HC				HC		HC			HC	HW	HC			
										WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15	WK10	WSM355	WSP455
 ACGT060204R-G65	G	2	4,4	6,7	2,38	7°	15°	0,4	0,9	☺	☺	☺	☺	☺	☺			☺	☺	☺				☺
 ACGT060204R-M85	G	2	4,4	6,7	2,38	7°	15°	0,4	0,9												☺	☺		
 ACMT060202R-G55	M	2	4,4	6,7	2,38	7°	15°	0,2	1		☺	☺	☺	☺	☺									☺
 ACMT060204R-G55	M	2	4,4	6,7	2,38	7°	15°	0,4	0,9	☺	☺	☺	☺	☺	☺	☺								☺
 ACMT060208R-G55	M	2	4,4	6,7	2,38	7°	15°	0,8	0,8		☺	☺	☺	☺	☺									☺
 ACMT060212R-G55	M	2	4,4	6,7	2,38	7°	15°	1,2	0,6		☺	☺	☺	☺	☺									☺
 ACMT060216R-G55	M	2	4,4	6,7	2,38	7°	15°	1,6	0,1		☺	☺	☺	☺	☺									☺
 ACMT060204R-K55	M	2	4,4	6,7	2,38	7°	15°	0,4	0,9	☺	☺	☺	☺	☺	☺					☺	☺			☺

HC = Coated carbide
HW = Uncoated carbide

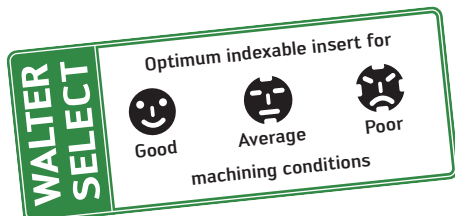
Positive rhombic ADGT / ADHT / ADKT Tiger-tec® Gold



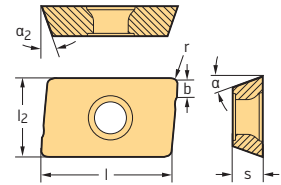
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K				N		S		
										HC				HC		HC				HC	HW	HC		
										WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
ADGT0803PER-D51	G	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1204PER-D51	G	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1606PER-D51	G	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1807PER-D51	G	2	14,5	19	7,94	15°	17°	1,2	1,8	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT0803PER-D56	G	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1204PER-D56	G	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1606PER-D56	G	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1807PER-D56	G	2	14,5	19	7,94	15°	17°	1,2	1,8	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT10T3PER-D67	G	2	7,25	11,3	3,8	15°	15°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT10T316R-D67	G	2	7,25	11,3	3,8	15°	15°	1,6	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT10T330R-D67	G	2	7,25	11,3	3,8	15°	15°	3	0,8	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1204PER-D67	G	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT120416R-D67	G	2	8,4	13,6	4,76	15°	20°	1,6	1	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1606PER-D67	G	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160616R-D67	G	2	10,8	17,5	6,15	15°	20°	1,6	1	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT0803PER-F56	G	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT120404R-F56	G	2	8,4	13,6	4,76	15°	20°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1204PER-F56	G	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT120440R-F56	G	2	8,4	13,6	4,76	15°	20°	4	0,4	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1606PER-F56	G	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160612R-F56	G	2	10,8	17,5	6,15	15°	20°	1,2	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160616R-F56	G	2	10,8	17,5	6,15	15°	20°	1,6	1,4	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160620R-F56	G	2	10,8	17,5	6,15	15°	20°	2	1,4	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160632R-F56	G	2	10,8	17,5	6,15	15°	20°	3,2	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT160640R-F56	G	2	10,8	17,5	6,15	15°	20°	4	1	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT10T3PER-G77	G	2	7,25	11,3	3,8	15°	15°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1204PER-G77	G	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
ADGT1606PER-G77	G	2	10,8	17,5	6,15	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉



HC = Coated carbide
HW = Uncoated carbide



Positive rhombic ADGT / ADHT / ADKT Tiger-tec® Gold

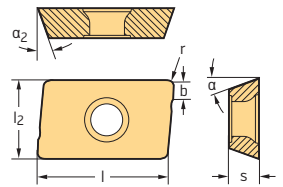


Indexable inserts


Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K				N		S	
										HC				HC		HC				HC	HW	HC	
										WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15	WK10	WSM355
 ADHT0803PER-G88	H	2	6,75	9,52	3,35	15°	20°	0,4	1,2											☺	☺		
ADHT0803PEL-G88	H	2	6,75	9,52	3,35	15°	20°	0,4	1,2											☺			
ADHT10T3PER-G88	H	2	7,25	11,3	3,8	15°	15°	0,8	1,2											☺	☺		
ADHT1204PER-G88	H	2	8,4	13,6	4,76	15°	20°	0,8	1,2											☺	☺		
ADHT1204PEL-G88	H	2	8,4	13,6	4,76	15°	20°	0,8	1,2											☺			
ADHT120416R-G88	H	2	8,4	13,6	4,76	15°	20°	1,6	1											☺	☺		
ADHT120416L-G88	H	2	8,4	13,6	4,76	15°	20°	1,6	1											☺			
ADHT120430R-G88	H	2	8,4	13,6	4,76	15°	20°	3	0,8											☺			
ADHT120430L-G88	H	2	8,4	13,6	4,76	15°	20°	3	0,8											☺			
ADHT120440R-G88	H	2	8,4	13,6	4,76	15°	20°	4	0,4											☺			
ADHT120440L-G88	H	2	8,4	13,6	4,76	15°	20°	4	0,4											☺			
ADHT1606PER-G88	H	2	10,8	17,5	6,15	15°	20°	0,8	1,6											☺	☺		
ADHT1606PEL-G88	H	2	10,8	17,5	6,15	15°	20°	0,8	1,6											☺			
ADHT160616R-G88	H	2	10,8	17,5	6,15	15°	20°	1,6	1,4											☺	☺		
ADHT160616L-G88	H	2	10,8	17,5	6,15	15°	20°	1,6	1,4											☺			
ADHT160630R-G88	H	2	10,8	17,5	6,15	15°	20°	3	1,2											☺			
 ADKT0803PER-F56	K	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☺	☺					☺	☺	☺					
ADKT0803PEL-F56	K	2	6,75	9,52	3,35	15°	20°	0,4	1,2		☺	☺	☺					☺					☺
ADKT10T3PER-F56	K	2	7,25	11,3	3,8	15°	15°	0,8	1,2	☺	☺	☺	☺					☺					☺
ADKT1204PER-F56	K	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☺	☺	☺	☺					☺					☺
ADKT1204PEL-F56	K	2	8,4	13,6	4,76	15°	20°	0,8	1,2		☺	☺	☺					☺					☺
ADKT1606PER-F56	K	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☺	☺	☺	☺					☺					☺
ADKT1606PEL-F56	K	2	10,8	17,5	6,15	15°	20°	0,8	1,6		☺	☺	☺					☺					☺

HC = Coated carbide
HW = Uncoated carbide

**Positive rhombic
ADMT
Tiger-tec® Gold**



Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P			M			K			S					
										HC			HC			HC			HC					
										WKP255	WKP356	WKP355	WSP455	WSM355	WSM45X	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WSM355	WSM45X	WSP455
 ADMT080304R-D56	M	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
ADMT120408R-D56	M	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	
ADMT160608R-D56	M	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	
ADMT180712R-D56	M	2	14,5	19	7,94	15°	17°	1,2	1,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

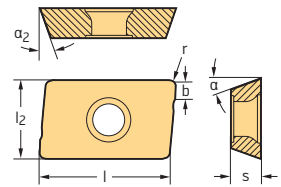
WALTER SELECT

Optimum indexable insert for



☺ Good ☺ Average ☺ Poor

machining conditions

Positive rhombic ADMT Tiger-tec® Gold

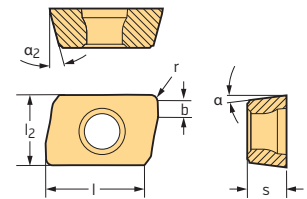


Indexable inserts


Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K			S			
										HC				HC		HC			HC		HC	
										WKP255	WKP356	WKP355	WSP455	WSM355	WSM45X	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WSM355
 ADMT160640L-F56	M	2	10,8	17,5	6,15	15°	20°	4	1	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT160650R-F56	M	2	10,8	17,5	6,15	15°	20°	5		☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT160660R-F56	M	2	10,8	17,5	6,15	15°	20°	6		☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT180712R-F56	M	2	14,5	19	7,94	15°	17°	1,2	1,8	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
 ADMT080304R-G56	M	2	6,75	9,52	3,35	15°	20°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT10T308R-G56	M	2	7,25	11,3	3,8	15°	15°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT120408R-G56	M	2	8,4	13,6	4,76	15°	20°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
ADMT160608R-G56	M	2	10,8	17,5	6,15	15°	20°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	

HC = Coated carbide

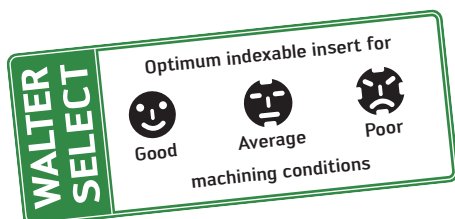
Positive rhombic BCGT / BCHT / BCMT Tiger-tec® Gold



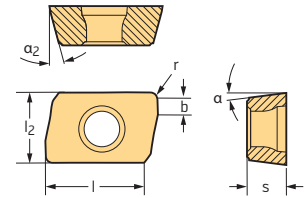
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K			N		S	
										HC				HC		HC			HC HW		HC	
										WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15	WK10
 BCGT120408R-G55	G	2	7,6	13,8	4,8	7°	15°	0,8	1,3	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	
BCGT160508R-G55	G	2	9,9	17,3	5,75	7°	15°	0,8	2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	





HC = Coated carbide
HW = Uncoated carbide



Positive rhombic BCGT / BCHT / BCMT Tiger-tec® Gold



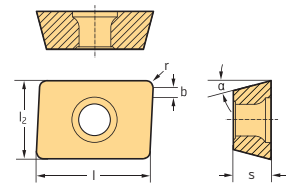
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	α ₂	r mm	b mm	P				M		K				N		S		
										HC				HC		HC				HC	HW	HC		
										WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKP255	WKP356	WKP355	WXN15	WK10	WSM355	WSP455	
 BCGT120408R-K85	H	2	7,6	13,8	4,8	7°	15°	0,8	1,3															
BCGT120412R-K85	H	2	7,6	13,8	4,8	7°	15°	1,2	1,2															
BCGT120416R-K85	H	2	7,6	13,8	4,8	7°	15°	1,6	1,1															
BCGT120420R-K85	H	2	7,6	13,8	4,8	7°	15°	2	1,2															
BCGT120425R-K85	H	2	7,6	13,8	4,8	7°	15°	2,5	1															
BCGT120430R-K85	H	2	7,6	13,8	4,8	7°	15°	3	0,7															
BCGT120440R-K85	H	2	7,6	13,8	4,8	7°	15°	4	0,4															
BCGT160508R-K85	H	2	9,9	17,3	5,75	7°	15°	0,8	2															
BCGT160512R-K85	H	2	9,9	17,3	5,75	7°	15°	1,2	1,7															
BCGT160516R-K85	H	2	9,9	17,3	5,75	7°	15°	1,6	1,7															
BCGT160520R-K85	H	2	9,9	17,3	5,75	7°	15°	2	1,5															
BCGT160525R-K85	H	2	9,9	17,3	5,75	7°	15°	2,5	1,4															
BCGT160530R-K85	H	2	9,9	17,3	5,75	7°	15°	3	1,2															
BCGT160540R-K85	H	2	9,9	17,3	5,75	7°	15°	4	1,1															
 BCMT120408R-F55	M	2	7,6	13,8	4,8	7°	15°	0,8	1,3	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺					☺
BCMT160508R-F55	M	2	9,9	17,3	5,75	7°	15°	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺					☺
 BCMT120404R-G55	M	2	7,6	13,8	4,8	7°	15°	0,4	1,3		☺	☺	☺	☺	☺									☺
BCMT120408R-G55	M	2	7,6	13,8	4,8	7°	15°	0,8	1,3	☺	☺	☺	☺	☺	☺									☺
BCMT120412R-G55	M	2	7,6	13,8	4,8	7°	15°	1,2	1,2		☺	☺	☺	☺	☺									☺
BCMT120416R-G55	M	2	7,6	13,8	4,8	7°	15°	1,6	1,1		☺	☺	☺	☺	☺									☺
BCMT120420R-G55	M	2	7,6	13,8	4,8	7°	15°	2	1,2		☺	☺	☺	☺	☺									☺
BCMT120425R-G55	M	2	7,6	13,8	4,8	7°	15°	2,5	1		☺	☺	☺	☺	☺									☺
BCMT120430R-G55	M	2	7,6	13,8	4,8	7°	15°	3	0,7		☺	☺	☺	☺	☺									☺
BCMT120432R-G55	M	2	7,6	13,8	4,8	7°	15°	3,2	0,5		☺	☺	☺	☺	☺									☺
BCMT120440R-G55	M	2	7,6	13,8	4,8	7°	15°	4	0,4		☺	☺	☺	☺	☺									☺
BCMT160508R-G55	M	2	9,9	17,3	5,75	7°	15°	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺					☺
BCMT160512R-G55	M	2	9,9	17,3	5,75	7°	15°	1,2	1,7		☺	☺	☺	☺	☺									☺
BCMT160516R-G55	M	2	9,9	17,3	5,75	7°	15°	1,6	1,5		☺	☺	☺	☺	☺									☺
BCMT160520R-G55	M	2	9,9	17,3	5,75	7°	15°	2	1,5		☺	☺	☺	☺	☺									☺
BCMT160525R-G55	M	2	9,9	17,3	5,75	7°	15°	2,5	1,4		☺	☺	☺	☺	☺									☺
BCMT160530R-G55	M	2	9,9	17,3	5,75	7°	15°	3	1,2		☺	☺	☺	☺	☺									☺
BCMT160532R-G55	M	2	9,9	17,3	5,75	7°	15°	3,2	1,1		☺	☺	☺	☺	☺									☺
BCMT160540R-G55	M	2	9,9	17,3	5,75	7°	15°	4	1,1		☺	☺	☺	☺	☺									☺
BCMT160550R-G55	M	2	9,9	17,3	5,75	7°	15°	5	0,7		☺	☺	☺	☺	☺									☺
BCMT160560R-G55	M	2	9,9	17,3	5,75	7°	15°	6	0,1		☺	☺	☺	☺	☺									☺
 BCMT120408R-K55	M	2	7,6	13,8	4,8	7°	15°	0,8	1,3		☺	☺	☺	☺	☺									☺
BCMT160508R-K55	M	2	9,9	17,3	5,75	7°	15°	0,8	2		☺	☺	☺	☺	☺									☺

HC = Coated carbide
HW = Uncoated carbide

☺ / ★ New addition to the product range

Positive rhombic LDMW / LDMT Tiger-tec® Gold

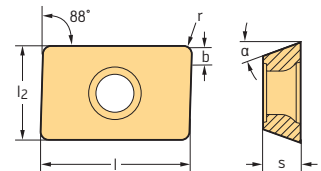


Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P				M		K			S			
									HC				HC		HC			HC			
									WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSP45S
LDMW08T204R-A57	M	2	6,1	8,88	2,58	15°	0,4	0,8	⊗	⊗	⊗	⊗				⊗	⊗	⊗			
LDMW14T308R-A57	M	2	9,68	14,1	4,08	15°	0,8	1,2	⊗	⊗	⊗	⊗				⊗	⊗	⊗			
LDMW170408R-A57	M	2	11,78	17,24	4,92	15°	0,8	1,6	⊗	⊗	⊗	⊗				⊗	⊗	⊗			
LDMT08T204R-D51	M	2	6,1	8,88	2,58	15°	0,4	0,8	⊗	⊗	⊗	⊗				⊗	⊗	⊗		⊗	
LDMT14T308R-D51	M	2	9,68	14,1	4,08	15°	0,8	1,2	⊗	⊗	⊗	⊗				⊗	⊗	⊗		⊗	
LDMT170408R-D51	M	2	11,78	17,24	4,92	15°	0,8	1,6	⊗	⊗	⊗	⊗				⊗	⊗	⊗		⊗	
LDMT170412R-D51	M	2	11,78	17,24	4,92	15°	1,2	1,6	⊗	⊗	⊗	⊗				⊗	⊗	⊗		⊗	
LDMT08T204R-D57	M	2	6,1	8,88	2,58	15°	0,4	0,8	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗	⊗	⊗	⊗
LDMT14T308R-D57	M	2	9,68	14,1	4,08	15°	0,8	1,2	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗	⊗	⊗	⊗
LDMT170408R-D57	M	2	11,78	17,24	4,92	15°	0,8	1,6	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗	⊗	⊗	⊗
LDMT08T204R-F57	M	2	6,1	8,88	2,58	15°	0,4	0,8	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗	⊗
LDMT14T308R-F57	M	2	9,68	14,1	4,08	15°	0,8	1,2	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗	⊗
LDMT170408R-F57	M	2	11,78	17,24	4,92	15°	0,8	1,6	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗	⊗

HC = Coated carbide

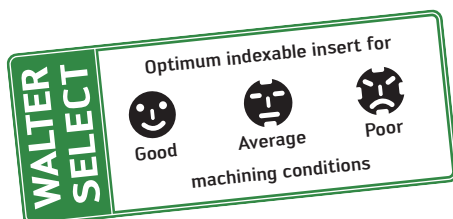
Positive rhombic LPGW / LPGT / LPMW / LPMT Tiger-tec® Silver



Indexable inserts

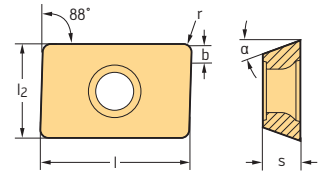
Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P				M		K			S	
									HC				HC		HC			HC	
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WSM35S	WSP45S	
LPGW15T308R-A57	G	2	9,52	15	3,97	11°	0,8	1,4	⊗	⊗				⊗	⊗	⊗			
LPGW150412R-A57	G	2	12,7	15,88	4,76	11°	1,2	1,6	⊗	⊗				⊗	⊗	⊗			
LPGT070304R-F55	G	2	6,35	7,94	3,18	11°	0,4	1,2	⊗	⊗				⊗	⊗				
LPGT15T308R-F55	G	2	9,52	15	3,97	11°	0,8	1,4	⊗	⊗				⊗	⊗				
LPGT150412R-F55	G	2	12,7	15,88	4,76	11°	1,2	1,6	⊗	⊗				⊗	⊗				
LPMW15T308TR-A27	M	2	9,52	15	3,97	11°	0,8		⊗	⊗				⊗	⊗				
LPMW150412TR-A27	M	2	12,7	15,88	4,76	11°	1,2		⊗	⊗				⊗	⊗				
LPMW150612TR-A27	M	2	12,7	15,88	6,35	11°	1,2		⊗	⊗				⊗	⊗				

HC = Coated carbide



C 2

Positive rhombic
LPGW / LPGT / LPMW / LPMT
Tiger-tec® Silver

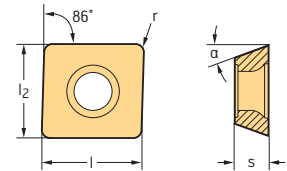


Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P		M		K		S	
									HC		HC		HC		HC	
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S
LPMT070304R-D51	M	2	6,35	7,94	3,18	11°	0,4	1,2	⊕	⊕			⊕	⊕		
LPMT15T308R-D51	M	2	9,52	15	3,97	11°	0,8	1,4	⊕	⊕	⊕		⊕	⊕	⊕	
LPMT150412R-D51	M	2	12,7	15,88	4,76	11°	1,2	1,6	⊕	⊕	⊕	⊕	⊕	⊕	⊕	
LPMT150612R-D51	M	2	12,7	15,88	6,35	11°	1,2		⊕	⊕	⊕		⊕	⊕	⊕	
LPMT150612R-D57	M	2	12,7	15,88	6,35	11°	1,2		⊕	⊕	⊕		⊕	⊕	⊕	

HC = Coated carbide

Positive rhombic
MPHX / MPHW / MPHT / MPMX / MPMT
Tiger-tec® Gold



Indexable inserts

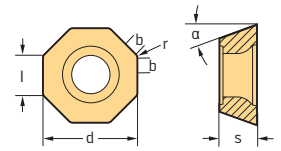
Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	P		M		K		N	S
								HC		HC		HC		HC	HC
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S
MPHX060304-A57	H	2	6,35	6,35	3,18	11°	0,4	⊕	⊕			⊕	⊕	⊕	
MPHX080305-A57	H	2	8,3	8,3	3,18	11°	0,5	⊕	⊕			⊕	⊕	⊕	
MPHW120408-A57	H	2	12,7	12,7	4,76	11°	0,8	⊕	⊕			⊕	⊕	⊕	
MPHX060304-G88	H	2	6,35	6,35	3,18	11°	0,4							⊕	
MPHX080305-G88	H	2	8,3	8,3	3,18	11°	0,5							⊕	
MPHT120408-G88	H	2	12,7	12,7	4,76	11°	0,8							⊕	
MPMX060304-F57	M	2	6,35	6,35	3,18	11°	0,4	⊕	⊕	⊕		⊕	⊕	⊕	
MPMX080305-F57	M	2	8,3	8,3	3,18	11°	0,5	⊕	⊕	⊕		⊕	⊕	⊕	
MPMT120408-F57	M	2	12,7	12,7	4,76	11°	0,8	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕

HC = Coated carbide

C 2

Positive octagonal ODHW / ODHT / ODMT / ODMW

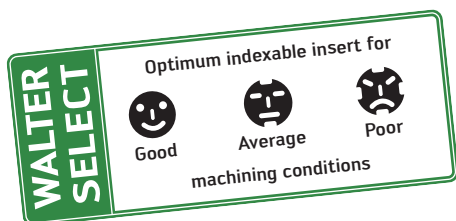
Tiger-tec® Gold



Indexable inserts

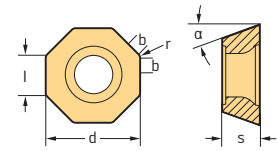
Designation	Tolerance class	Number of cutting edges	l mm	d mm	s mm	α	r mm	b mm	P				M			K				N			S						
									WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSN10	WXN15	WK10	WSM35S	WSM45X	WSP45S			
ODHW050408-A57	H	8	5,26	12,7	4,76	15°	0,8		☒	☒																			
ODHW060512-A57	H	8	6,58	15,88	5,56	15°	1,2		☒																				
ODHW050412-A57	H	8	5,26	12,7	4,76	15°	1,2														☒								
ODHW060516-A57	H	8	6,58	15,88	5,56	15°	1,6														☒								
ODHT050408-F57	H	8	5,26	12,7	4,76	15°	0,8			☒	☒	☒																	
ODHT060512-F57	H	8	6,58	15,88	5,56	15°	1,2			☒	☒	☒																	
ODHW0504ZZN-A57	H	8	5,26	12,7	4,76	15°	0,8	1,2	☒	☒	☒										☒								
ODHW0605ZZN-A57	H	8	6,58	15,88	5,56	15°	0,8	1,6	☒	☒	☒										☒								
ODHT0504ZZN-F57	H	8	5,26	12,7	4,76	15°	0,8	1,2	☒	☒	☒	☒																	
ODHT0605ZZN-F57	H	8	6,58	15,88	5,56	15°	0,8	1,6	☒	☒	☒	☒																	
ODHT0605ZZN-G77	H	8	6,58	15,88	5,56	15°	0,8	1,6																					
ODHT0504ZZN-G77	H	8	5,26	12,7	4,76	15°	0,8	1,6																					
ODHT0605ZZN-G88	H	8	6,58	15,88	5,56	15°	0,8	1,6																					
ODHT0504ZZN-G88	H	8	5,26	12,7	4,76	15°	0,8	1,2																					
ODMT050408-D57	M	8	5,26	12,7	4,76	15°	0,8			☒	☒	☒	☒																
ODMT060512-D57	M	8	6,58	15,88	5,56	15°	1,2			☒	☒	☒	☒																
ODMT0504ZZN-D57	M	8	5,26	12,7	4,76	15°	0,8	1,2	☒	☒	☒	☒	☒																
ODMT0605ZZN-D57	M	8	6,58	15,88	5,56	15°	0,8	1,6	☒	☒	☒	☒	☒																

HC = Coated carbide
 CN = Silicon nitride Si₃N₄
 HW = Uncoated carbide




Positive octagonal ODHW / ODHT / ODMT / ODMW

Tiger-tec® Gold



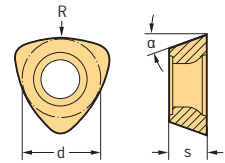
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	d mm	s mm	α	r mm	b mm	P				M			K				N			S			
									HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC		
									WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSN10	WXN15	WK10	WSM35S	WSM45X	WSP45S
 ODMW050408T-A27	M	8	5,26	12,7	4,76	15°	0,8		☉	☉	☉					☉	☉	☉	☉	☉						
ODMW060508T-A27	M	8	6,58	15,88	5,56	15°	0,8		☉	☉	☉					☉	☉	☉	☉	☉						
ODMW050408-A57	M	8	5,26	12,7	4,76	15°	0,8		☉	☉	☉					☉	☉	☉	☉	☉						
ODMW060508-A57	M	8	6,58	15,88	5,56	15°	0,8		☉	☉	☉					☉	☉	☉	☉	☉						




HC = Coated carbide
CN = Silicon nitride Si₃N₄
HW = Uncoated carbide

Positive triangular P26315 / P26325

Tiger-tec® Silver



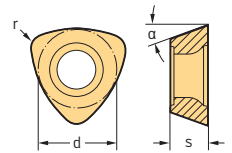
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	R mm	P		M		K		S		
							HC	HC	HC	HC	HC	HC			
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WSM35S	WSP45S
 P26315R10	M	3	6,75	2,78	14°	10	☉	☉	☉		☉	☉	☉	☉	
P26315R12	M	3	8,5	3,18	14°	12,5	☉	☉	☉		☉	☉	☉	☉	
P26315R15	M	3	10,5	3,97	14°	15	☉	☉	☉		☉	☉	☉	☉	
P26315R16	M	3	10,5	3,97	14°	16	☉	☉	☉		☉	☉	☉	☉	
P26315R20	M	3	12,5	4,76	11°	20	☉	☉	☉		☉	☉	☉	☉	
P26315R25	M	3	12,7	4,76	11°	25	☉	☉	☉		☉	☉	☉	☉	
P26315R31	M	3	12,7	4,76	11°	31,5	☉	☉	☉		☉	☉	☉	☉	
 P26315R12.7	M	3	8,5	3,18	14°	12,7	☉	☉				☉			
P26315R19.05	M	3	12,5	4,76	11°	19,1	☉	☉				☉			
 P26325R31	M	3	12,7	4,76		31,5	☉	☉	☉		☉	☉	☉	☉	




HC = Coated carbide

Positive triangular P26335 / P26337 / P26339

Tiger-tec® Gold



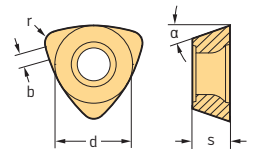
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	r mm	P			M		K			S	
							HC			HC		HC			HC	
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S
 P26335R10	M	3	6,75	3,18	14°	0,8	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26335R14	M	3	9,52	3,97	14°	1,2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26335R25	M	3	13	5,56	14°	2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
 P26337R10	M	3	6,75	3,18	14°	0,8	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26337R14	M	3	9,52	3,97	14°	1,2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26337R25	M	3	13	5,56	14°	2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
 P26339R10	M	3	6,75	3,18	14°	0,8	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26339R14	M	3	9,52	3,97	14°	1,2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
P26339R25	M	3	13	5,56	14°	2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗


HC = Coated carbide

Positive triangular P26379

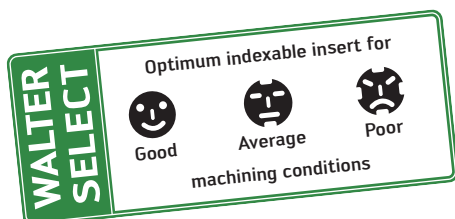
Tiger-tec® Gold



Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	r mm	b mm	P			M		K			S	
								HC			HC		HC			HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S
 P26379-R10	M	3	6,75	3,18	14°	0,8	0,9	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
P26379-R14	M	3	9,52	3,97	14°	1,2	1	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	
P26379-R25	M	3	13	5,56	14°	2	1,1	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	

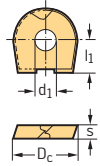
HC = Coated carbide



C 2

Profile milling inserts

P3204 / P3201

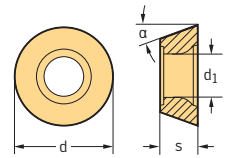


Indexable inserts

Designation	Tolerance class	Number of cutting edges	D _c ^{-0.03} mm	s mm	l ₁ mm	d ₁ mm	P						M				K			S		H						
							HC						HC				HC			HC		HC						
							WKP25S	WKP25	WKP35S	WKP35	WSP45S	WSP46	WSM35S	WSM36	WSP45S	WSP46	WKP25	WKP25S	WKP35S	WKP35	WSM35S	WSM36	WSP45S	WSP46	WHH15			
	P3204-D08	H	8	2	4	3																						
	P3204-D10	H	10	2,5	5	4																						
	P3204-D12	H	12	2,5	6	5																						
	P3204-D16	H	16	3	6	5																						
	P3204-D20	H	20	3	6	5																						
	P3204-D25	H	25	4	9	6																						
	P3204-D30	H	30	5	10	8																						
	P3204-D32	H	32	5	10	8																						
	P3204-D09.52	H	9,53	2,5	5	4																						
	P3204-D12.7	H	12,7	2,5	6	5																						
	P3204-D15.87	H	15,88	3	6	5																						
	P3204-D19.05	H	19,05	3	6	5																						
	P3204-D25.4	H	25,4	4	9	6																						
	P3204-D31.75	H	31,75	5	10	8																						
	P3201-D08	H	8	2	4	3																						
	P3201-D10	H	10	2,5	5	4																						
	P3201-D12	H	12	2,5	6	5																						
	P3201-D16	H	16	3	6	5																						
	P3201-D20	H	20	3	6	5																						
	P3201-D25	H	25	4	9	6																						
	P3201-D30	H	30	5	10	8																						
	P3201-D32	H	32	5	10	8																						
	P3201-D12.7	H	12,7	2,5	6	5																						
	P3201-D19.05	H	19,05	3	6	5																						
	P3201-D25.4	H	25,4	4	9	6																						

HC = Coated carbide

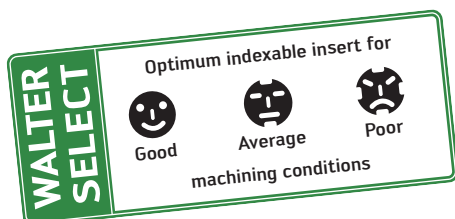
**Positive round
ROHX / ROMX
Tiger-tec® Gold**



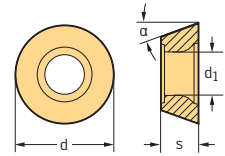
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	d ₁ mm	P				M			K			S		
							HC				HC			HC			HC		
							WKP25S	WKP35G	WKP35S	WMP45G	WSP45S	WMP45G	WSM35S	WSM45X	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S
	ROHX10T3M0T-A27	H	4	10	3,97	11°	4,4	✘	✘	✘					✘	✘	✘		
	ROHX1204M0T-A27	H	4	12	4,76	11°	4,4	✘	✘	✘					✘	✘	✘		
	ROHX1605M0T-A27	H	6	16	5,56	15°	5,5	✘	✘	✘					✘	✘	✘		
	ROHX2006M0T-A27	H	8	20	6,35	15°	6,5	✘	✘	✘					✘	✘	✘		
	ROHX0803M0-D57	H	4	8	3,18	11°	3,4	✘	✘	✘	✘				✘	✘	✘		
	ROHX10T3M0-D57	H	4	10	3,97	11°	4,4	✘	✘	✘	✘	✘			✘	✘	✘		
	ROHX1204M0-D57	H	4	12	4,76	11°	4,4	✘	✘	✘	✘	✘	✘		✘	✘	✘		
	ROHX1605M0-D57	H	6	16	5,56	15°	5,5	✘	✘	✘	✘	✘	✘	✘	✘	✘	✘		
	ROHX2006M0-D57	H	8	20	6,35	15°	6,5	✘	✘	✘	✘	✘	✘	✘	✘	✘	✘		
	ROHX0803M0-D67	H	4	8	3,18	11°	3,4				✘				✘		✘		
	ROHX10T3M0-D67	H	4	10	3,97	11°	4,4			✘	✘	✘			✘	✘	✘		
	ROHX1204M0-D67	H	4	12	4,76	11°	4,4			✘	✘	✘			✘	✘	✘		
	ROHX1605M0-D67	H	6	16	5,56	15°	5,5			✘	✘	✘			✘	✘	✘		
	ROHX10T3M0-F67	H	4	10	3,97	11°	4,4	✘		✘	✘	✘			✘	✘	✘		
	ROHX1204M0-F67	H	4	12	4,76	11°	4,4	✘		✘	✘	✘			✘	✘	✘		
	ROMX0803M0-D57	M	4	8	3,18	11°	3,4	✘	✘	✘		✘			✘	✘	✘		
	ROMX10T3M0-D57	M	4	10	3,97	11°	4,4	✘	✘	✘	✘	✘			✘	✘	✘		
	ROMX1204M0-D57	M	4	12	4,76	11°	4,4	✘	✘	✘	✘	✘	✘		✘	✘	✘		
	ROMX1605M0-D57	M	6	16	5,56	15°	5,5	✘	✘	✘	✘	✘	✘	✘	✘	✘	✘		
	ROMX2006M0-D57	M	8	20	6,35	15°	6,5	✘	✘	✘	✘	✘	✘	✘	✘	✘	✘		
	ROMX10T3M0-D67	M	4	10	3,97	11°	4,4			✘	✘	✘			✘	✘	✘		
	ROMX1204M0-D67	M	4	12	4,76	11°	4,4			✘	✘	✘			✘	✘	✘		
	ROMX10T3M0-F67	M	4	10	3,97	11°	4,4			✘		✘				✘	✘		
	ROMX1204M0-F67	M	4	12	4,76	11°	4,4			✘		✘				✘	✘		







HC = Coated carbide



Positive round
RDGT / RDHW / RDMW / RDMT
Tiger-tec® Gold

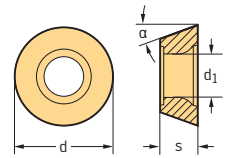


Indexable inserts




Designation	Tolerance class	d mm	s mm	α	d ₁ mm	P			M		K			N			S		H	O
						HC			HC		HC			HC			HC		HC	HF
						WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35G	WKP35S	WXN15	WK10	WMG40	WSM35S	WSP45S
 RDGT1204M0-G85 RDGT2006M0-G85	G	12	4,76	15°	4,4														⊕	
	G	20	6,35	15°	6,5															⊕
 RDGT0803M0-G88 RDGT10T3M0-G88 RDGT1204M0-G88 RDGT1605M0-G88 RDGT2006M0-G88	G	8	3,18	15°	3,4								⊕	⊕						
	G	10	3,97	15°	4,4								⊕	⊕						
	G	12	4,76	15°	4,4								⊕	⊕						
	G	16	5,56	15°	5,5								⊕	⊕						
	G	20	6,35	15°	6,5								⊕	⊕						
 RDHW0803M0-A27 RDHW10T3M0-A27 RDHW1204M0-A27 RDHW1605M0-A27 RDHW2006M0-A27	H	8	3,18	15°	3,4			⊗												
	H	10	3,97	15°	4,4		⊗	⊗												
	H	12	4,76	15°	4,4	⊗	⊗	⊗				⊗	⊗	⊗						
	H	16	5,56	15°	5,5	⊗	⊗	⊗				⊗	⊗	⊗						
	H	20	6,35	15°	6,5	⊗	⊗	⊗				⊗	⊗	⊗						
 RDHW0803M0-A57 RDHW10T3M0-A57 RDHW1204M0-A57 RDHW1605M0-A57 RDHW2006M0-A57	H	8	3,18	15°	3,4														⊕	
	H	10	3,97	15°	4,4															⊕
	H	12	4,76	15°	4,4															⊕
	H	16	5,56	15°	5,5	⊕					⊕									⊕
	H	20	6,35	15°	6,5	⊕					⊕									⊕
 RDMW0803M0-A27 RDMW10T3M0-A27 RDMW1204M0-A27 RDMW1605M0-A27 RDMW2006M0-A27	M	8	3,18	15°	3,4			⊗												
	M	10	3,97	15°	4,4	⊗	⊗	⊗												
	M	12	4,76	15°	4,4	⊗	⊗	⊗				⊗	⊗	⊗						
	M	16	5,56	15°	5,5	⊗	⊗	⊗				⊗	⊗	⊗						
	M	20	6,35	15°	6,5	⊗	⊗	⊗				⊗	⊗	⊗						
 RDMT0803M0-D57 RDMT10T3M0-D57 RDMT1204M0-D57 RDMT1605M0-D57 RDMT2006M0-D57	M	8	3,18	15°	3,4			⊗	⊗	⊗										
	M	10	3,97	15°	4,4	⊕	⊕	⊕	⊕	⊕										
	M	12	4,76	15°	4,4	⊕	⊕	⊕	⊕	⊕										
	M	16	5,56	15°	5,5	⊕	⊕	⊕	⊕	⊕										
	M	20	6,35	15°	6,5	⊕	⊕	⊕	⊕	⊕										

HC = Coated carbide
HW = Uncoated carbide
HF = Uncoated fine-grained carbide

Positive round RDHX / RDMX Tiger-tec® Gold

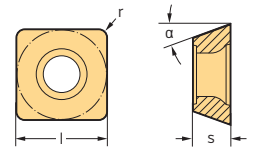


Indexable inserts


Designation	Tolerance class	d mm	s mm	α	d ₁ mm	P				M		K			S		H
						HC				HC		HC			HC	HC	HC
						WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S	WSP45S	WHH15
 RDHX1003M0T-A27	H	10	3,18	15°	4,4	☉	☉	☉				☉	☉	☉			
RDHX12T3M0T-A27	H	12	3,97	15°	4,4	☉	☉	☉				☉	☉	☉			
RDHX1604M0T-A27	H	16	4,76	15°	5,5	☉	☉	☉				☉	☉	☉			
RDHX2006M0T-A27	H	20	5,97	15°	5,5			☉				☉		☉			
 RDHX0501M0-A57	H	5	1,59	15°	2,2	☉						☉					☉
RDHX07T1M0-A57	H	7	1,98	15°	2,8												☉
RDHX0702M0-A57	H	7	2,35	15°	2,8												☉
RDHX1003M0-A57	H	10	3,18	15°	4,4												☉
RDHX12T3M0-A57	H	12	3,97	15°	4,4												☉
RDHX1604M0-A57	H	16	4,76	15°	5,5												☉
 RDMX1003M0T-A27	M	10	3,18	15°	4,4	☉	☉	☉				☉	☉	☉			
RDMX12T3M0T-A27	M	12	3,97	15°	4,4	☉	☉	☉				☉	☉	☉			
RDMX1604M0T-A27	M	16	4,76	15°	5,5	☉	☉	☉				☉	☉	☉			

HC = Coated carbide

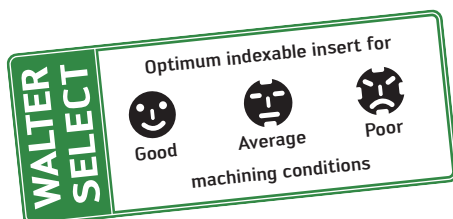
Positive square SDGT / SDMW / SDMT Tiger-tec® Gold



Indexable inserts

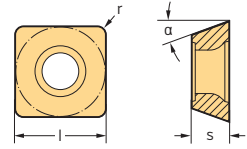
Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	P				M		K			N		S			
							HC				HC		HC			HC	HW	HC			
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
 SDHT06T204-G88	H	4	6,35	2,78	15°	0,4											☉	☉			
SDHT09T304-G88	H	4	9,52	3,97	15°	0,4											☉	☉			
SDHT09T308-G88	H	4	9,52	3,97	15°	0,8											☉	☉			
SDHT120408-G88	H	4	12,7	4,76	15°	0,8											☉	☉			

HC = Coated carbide
HW = Uncoated carbide







C 2

Positive square
SDGT / SDMW / SDMT
Tiger-tec® Gold

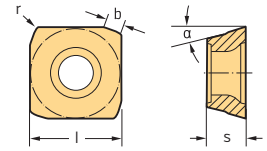


Indexable inserts


Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	P				M			K				N		S		
							HC				HC			HC				HC	HW	HC		
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
 SDMW06T204-A57	M	4	6,35	2,78	15°	0,4	⊕	⊕	⊕	⊕						⊕	⊕	⊕				
SDMW09T308-A57	M	4	9,52	3,97	15°	0,8	⊕	⊕	⊕	⊕						⊕	⊕	⊕				
SDMW09T320-A57	M	4	9,52	3,97	15°	2	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMW120408-A57	M	4	12,7	4,76	15°	0,8	⊕	⊕	⊕	⊕						⊕	⊕	⊕			⊕	⊕
SDMW120425-A57	M	4	12,7	4,76	15°	2,5	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
 SDMT06T204-D51	M	4	6,35	2,78	15°	0,4	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT09T308-D51	M	4	9,52	3,97	15°	0,8	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT120408-D51	M	4	12,7	4,76	15°	0,8	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
 SDMT06T204-D57	M	4	6,35	2,78	15°	0,4	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT09T308-D57	M	4	9,52	3,97	15°	0,8	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT120408-D57	M	4	12,7	4,76	15°	0,8	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
 SDMT06T204-F57	M	4	6,35	2,78	15°	0,4	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT06T208-F57	M	4	6,35	2,78	15°	0,8	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT06T212-F57	M	4	6,35	2,78	15°	1,2	⊕	⊕	⊕	⊕	⊕		⊕			⊕	⊕	⊕			⊕	⊕
SDMT09T304-F57	M	4	9,52	3,97	15°	0,4	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT09T308-F57	M	4	9,52	3,97	15°	0,8	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT09T312-F57	M	4	9,52	3,97	15°	1,2	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT09T316-F57	M	4	9,52	3,97	15°	1,6	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT09T320-F57	M	4	9,52	3,97	15°	2	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT120408-F57	M	4	12,7	4,76	15°	0,8	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕
SDMT120412-F57	M	4	12,7	4,76	15°	1,2	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT120416-F57	M	4	12,7	4,76	15°	1,6	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT120420-F57	M	4	12,7	4,76	15°	2	⊕	⊕	⊕	⊕			⊕			⊕	⊕	⊕				⊕
SDMT120425-F57	M	4	12,7	4,76	15°	2,5	⊕	⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕			⊕	⊕

HC = Coated carbide
HW = Uncoated carbide

**Positive square
SDMT
Tiger-tec® Gold**

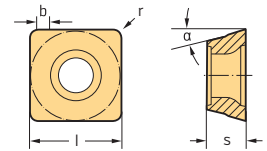


Indexable inserts


Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P				M		K			S	
								HC				HC		HC			HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S	WSP45S
 SDMT06T2ZDR-D57	M	4	6,4	2,78	15°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
SDMT09T3ZDR-D57	M	4	9,5	3,97	15°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
SDMT1204ZDR-D57	M	4	12,7	4,76	15°	0,8	1,8	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉

HC = Coated carbide

**Positive square
SDGT
Tiger-tec® Gold**



Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P				M		K			S	
								HC				HC		HC			HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G	WKP35S	WSM35S	WSP45S
 SDGT06T2PDR-D57	G	4	6,4	2,78	15°	0,4	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
SDGT09T3PDR-D57	G	4	9,5	3,97	15°	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉
SDGT1204PDR-D57	G	4	12,7	4,76	15°	0,8	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉

HC = Coated carbide

WALTER SELECT

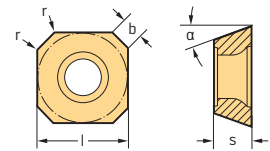
Optimum indexable insert for

☉ Good ☉ Average ☉ Poor







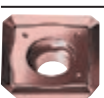
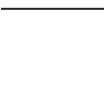




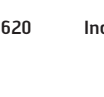
machining conditions

Positive square SDMW / SDMT / SDET / SDGT

Tiger-tec® Gold

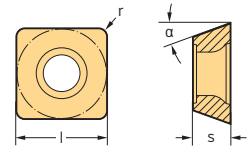


Indexable inserts


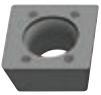
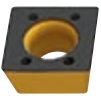

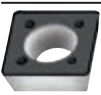


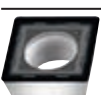





Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	Material															
								P					M		K				N		S		
								HT	HC				HC		HC				HC	HW	HC		
WEP20	WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S						
 SDMW09T3AZN-A57	M	4	9,5	3,97	15°	0,3	1,2	☉	☉	☉	☉			☉	☉	☉	☉						
 SDMW1204AZN-A57	M	4	12,7	4,76	15°	0,3	1,4	☉	☉	☉			☉	☉	☉								
 SDMT09T3AZN-D57	M	4	9,5	3,97	15°	0,3	1,2	☉	☉	☉	☉	☉						☉	☉				
 SDMT1204AZN-D57	M	4	12,7	4,76	15°	0,3	1,4	☉	☉	☉	☉	☉						☉	☉				
 SDET09T3AZN-F57	E	4	9,5	3,97	15°	0,3	1,4	☹															
 SDET1204AZN-F57	E	4	12,7	4,76	15°	0,3	1,8	☹															
 SDMT09T3AZN-F57	M	4	9,5	3,97	15°	0,3	1,4	☉	☉	☉	☉							☉	☉				
 SDMT1204AZN-F57	M	4	12,7	4,76	15°	0,3	1,8	☉	☉	☉	☉							☉	☉				
 SDGT09T3AZN-F57	G	4	9,5	3,97	15°	0,3	1,4	☉	☉	☉	☉	☉						☉	☉				
 SDGT1204AZN-F57	G	4	12,7	4,76	15°	0,3	1,8	☉	☉	☉	☉	☉						☉	☉				
 SDGT09T3AZN-G77	G	4	9,5	3,97	15°	0,3	1,2					☉							☉				
 SDGT1204AZN-G77	G	4	12,7	4,76	15°	0,3	1,4					☉							☉				
 SDHT09T3AZN-G88	H	4	9,5	3,97	15°	0,3	1,2											☉	☉				
SDHT1204AZN-G88	H	4	12,7	4,76	15°	0,3	1,4											☉	☉				

HT = Cermet
HC = Coated carbide
HW = Uncoated carbide

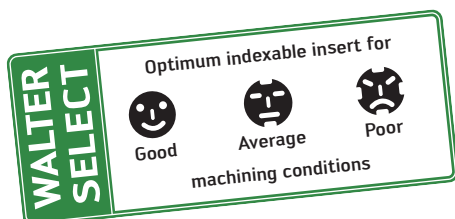
Positive square
SPGT / SPHW / SPHT / SPMW / SPMT
Tiger-tec® Gold



Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	P			M		K			N		S		
							HC			HC		HC			CN	HC	HW	HC	
							WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKP255	WKP356	WKP355	WSN10	WXN15	WK10
 SPGT120606-F57	G	4	12,7	6,35	11°	0,6													
 SPHW120412-A57	H	4	12,7	4,76	11°	1,2													
 SPHW120416-A57	H	4	12,7	4,76	11°	1,6													
 SPHW120606-A57	H	4	12,7	6,35	11°	0,6													
 SPHT060304-G88	H	4	6,35	3,18	11°	0,4													
 SPHT09T308-G88	H	4	9,52	3,97	11°	0,8													
 SPHT120408-G88	H	4	12,7	4,76	11°	0,8													
 SPMW060304T-A27	M	4	6,35	3,18	11°	0,4													
 SPMW09T308T-A27	M	4	9,52	3,97	11°	0,8													
 SPMW120408T-A27	M	4	12,7	4,76	11°	0,8													
 SPMW120606T-A27	M	4	12,7	6,35	11°	0,6													
 SPMW060304-A57	M	4	6,35	3,18	11°	0,4													
 SPMW09T308-A57	M	4	9,52	3,97	11°	0,8													
SPMW120408-A57	M	4	12,7	4,76	11°	0,8													
SPMT060304-D51	M	4	6,35	3,18	11°	0,4													
SPMT09T308-D51	M	4	9,52	3,97	11°	0,8													
SPMT120408-D51	M	4	12,7	4,76	11°	0,8													
SPMT120606-D51	M	4	12,7	6,35	11°	0,6													
SPMT120606-D57	M	4	12,7	6,35	11°	0,6													
SPMT060304-F55	M	4	6,35	3,18	11°	0,4													
SPMT09T308-F55	M	4	9,52	3,97	11°	0,8													
SPMT120408-F55	M	4	12,7	4,76	11°	0,8													

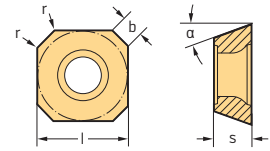
HC = Coated carbide
CN = Silicon nitride Si₃N₄
HW = Uncoated carbide















C 2

Positive square
 SPGT / SPKT / SPMW / SPMT / SDGT

Tiger-tec® Silver

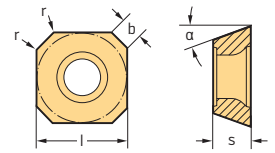


Indexable inserts



Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P		M		K		N		S			
								HC		HC		HC		HC	HW	HC			
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S
 SPGT1204AEN-K88	G	4	12,7	4,76	11°		1,5												
 SPKT1204AZN	K	4	12,7	4,76	11°		1,4	☉	☉	☉	☉	☉					☉	☉	
 SPKT1504AZN	K	4	15,9	4,76			1,7	☉				☉							
 SPMW1204AEN-A57	M	4	12,7	4,76	11°	0,5	1,4	☉	☉			☉	☉						
 SPMT1204AEN	M	4	12,7	4,76	11°	0,5	1,4	☉	☉	☉		☉	☉					☉	
 SDGT09T3AEN-F57	G	4	9,5	3,97	15°	0,3	1,2	☉	☉	☉	☉	☉	☉					☉	☉
 SDGT09T3AEN-G88	G	4	9,5	3,97	15°	0,3	1,2									☉	☉		
 SDHW09T3AEN-A57	H	4	9,5	3,97	15°	0,3	1,2	☉	☉			☉	☉	☉					
 SDMW09T3AEN-A57	M	4	9,5	3,97	15°	0,5	1,2	☉	☉			☉	☉						
 SDMT09T3AEN-D57	M	4	9,5	3,97	15°	0,5	1,2		☉	☉	☉	☉						☉	☉
 SEHW1204AFN	H	4	12,7	4,76	20°	0,8	2	☉	☉			☉	☉	☉					
 SEHW1504AFN	H	4	15,9	4,76	20°	0,8	2,1		☉			☉							

 HC = Coated carbide
 HW = Uncoated carbide

Positive square
SPGT / SPKT / SPMW / SPMT / SDGT
Tiger-tec® Silver

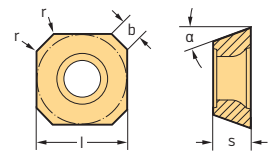


Indexable inserts




Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P			M		K		N		S	
								HC			HC		HC		HC	HW	HC	
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WXN15	WK10	WSM35S
 SEHT1204AFN	H	4	12,7	4,76	20°	0,8	2	☒	☒	☒	☒							
 SEHT1204AFN-K88	H	4	12,7	4,76	20°	0,8	1,8									☒		

HC = Coated carbide
 HW = Uncoated carbide

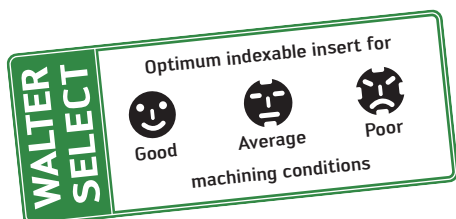
Positive square
SPJW / SPGT
Tiger-tec® Silver



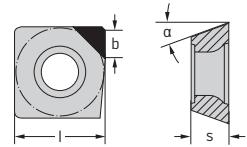
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P			M		K		S	
								HC			HC		HC		HC	
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WSM35S
 SPJW1204EDR	J	4	12,7	4,76	11°		1,4	☒	☒			☒	☒			
 SPJW1504EDR	J	4	15,9	4,76	11°		1,5	☒	☒			☒	☒			
 SPGT1204EDR-F55	G	4	12,7	4,76	11°	0,5	1,3	☒	☒	☒	☒	☒	☒	☒	☒	



HC = Coated carbide



Positive square SPHW

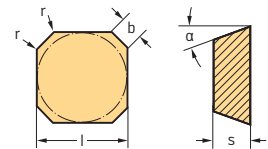


Indexable inserts






Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	b mm	P		M		K		N	S	
							HC		HC		HC		DP	HC	
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WCD10	WSM35S
 SPHW1204EDR-A88	H	1	12,7	4,76	11°	1,5							☺		
 SPHW1204PDR-A88	H	1	12,7	4,76	11°	1,5							☺		

HC = Coated carbide
DP = Polycrystalline diamond

Positive square SEKN / SEKR / SEMR Tiger-tec® Silver

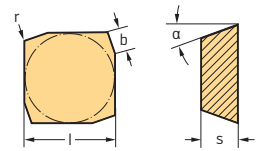


Indexable inserts








Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P		M		K		S	
								HC		HC		HC		HC	
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WSM35S
 SEKN1203AFN	K	4	12,7	3,18	20°	0,63	1,9	☺				☺			
 SEKN1504AFN	K	4	15,9	4,76	20°	0,35	2	☺				☺			
 SEKR1203AFTN	K	4	12,7	3,18	20°	0,43	1,9	☺				☺			
 SEKR1204AFN	K	4	12,7	4,76	20°	0,34	1,9	☺				☺			
 SEMR1203AFTN	M	4	12,7	3,18	20°	0,5	1,9	☺				☺			

HC = Coated carbide

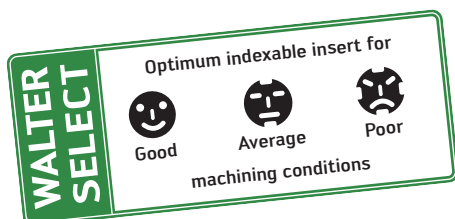
Positive square
SPFN / SPFR / SPKN / SPMN
Tiger-tec® Silver



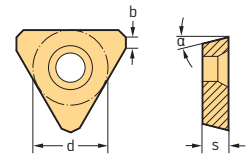
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	r mm	b mm	P			M			K			S		
								HC			HC			HC			HC		
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WSM35S	WSP45S		
 SPFN1204EDN	F	4	12,7	4,76	11°	0,5	1,7	☒						☒					
 SPFR1204EDR	F	4	12,7	4,76	11°	0,5	2						☒						
 SPFR1204ZPN	F	4	12,7	4,76	11°	0,8	1,7	☒						☒					
 SPKN1203EDR	K	4	12,7	3,18	11°		1,4	☒						☒					
 SPKN1204EDR	K	4	12,7	4,76	11°		1,4	☒						☒					
 SPKN1504EDR	K	4	15,9	4,76	11°		1,5	☒						☒					
 SPMN1203EDR	M	4	12,7	3,18	11°	0,2	1,4	☒						☒					



HC = Coated carbide



Positive triangular TPAW / TPJW Tiger-tec® Silver

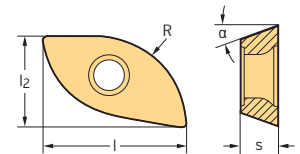


Indexable inserts














Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	b mm	P		M		K		S	
							HC		HC		HC		HC	
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S
 TPAW1604PPN	A	3	9,52	4,76	11°	1,2	☒	☒			☒	☒		
 TPJW1604PPN	J	3	9,52	4,76	11°	1,2	☒	☒			☒	☒		
TPJW2204PPN	J	3	12,7	4,76	11°	1,2	☒	☒			☒			

HC = Coated carbide

Positive form inserts XDGT / XDMT Tiger-tec® Gold

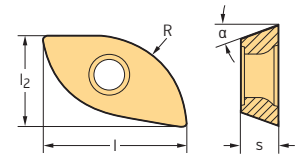


Indexable inserts



Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	R mm	P		M		K		S	
								HC		HC		HC		HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G
 XDGT1303080R-D57	G	2	8,5	13,12	3	15°	8		☒	☒			☒	☒	
 XDGT16T3100R-D57	G	2	9	15,93	3,74	15°	10		☒	☒			☒	☒	
 XDGT2004125R-D57	G	2	11,3	19,94	4,68	15°	12,5		☒	☒			☒	☒	
 XDGT2405150R-D57	G	2	13,5	23,94	5,62	15°	15		☒	☒			☒	☒	
 XDGT2506160R-D57	G	2	14,4	25,54	6	15°	16		☒	☒			☒	☒	
 XDGT3207200R-D57	G	2	18	31,95	7,5	15°	20		☒	☒			☒	☒	
 XDGT4009250R-D57	G	2	22,5	39,95	9,39	15°	25		☒	☒			☒	☒	
 XDGT1303079R-D57	G	2	8,5	13,12	3	15°	7,84		☒	☒			☒	☒	
 XDGT16T3095R-D57	G	2	9	15,93	3,74	15°	9,53		☒	☒			☒	☒	
 XDGT2004127R-D57	G	2	11,3	19,94	4,68	15°	12,7		☒	☒			☒	☒	
 XDGT2506159R-D57	G	2	14,4	25,54	6	15°	15,88		☒	☒			☒	☒	
 XDGT3207191R-D57	G	2	18	31,95	7,5	15°	19,05		☒	☒			☒	☒	
 XDGT4009254R-D57	G	2	22,5	39,95	9,39	15°	25,4		☒	☒			☒	☒	

HC = Coated carbide

Positive form inserts XDGT / XDMT Tiger-tec® Gold

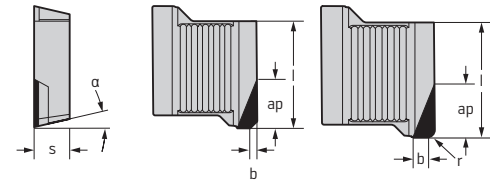


Indexable inserts




Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	R mm	P		M		K		S	
								HC		HC		HC		HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35G
 XDMT1303080R-F55	M	2	8,5	13,12	3	15°	8	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT16T3100R-F55	M	2	9	15,93	3,74	15°	10	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT2004125R-F55	M	2	11,3	19,94	4,68	15°	12,5	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT2405150R-F55	M	2	13,5	23,94	5,62	15°	15	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT2506160R-F55	M	2	14,4	25,54	6	15°	16	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT3207200R-F55	M	2	18	31,95	7,5	15°	20	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT4009250R-F55	M	2	22,5	39,95	9,39	15°	25	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
 XDMT1303079R-F55	M	2	8,5	13,12	3	15°	7,92	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT16T3095R-F55	M	2	9	15,93	3,74	15°	9,53	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT2004127R-F55	M	2	11,3	19,94	4,68	15°	12,7	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT2506159R-F55	M	2	14,4	25,54	6	15°	15,88	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT3207191R-F55	M	2	18	31,95	7,5	15°	19,05	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
XDMT4009254R-F55	M	2	22,5	39,95	9,39	15°	25,4	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗

HC = Coated carbide

PCD indexable inserts XOEN



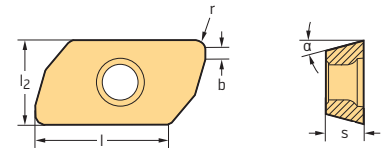
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	a _p mm	b mm	r mm	P		M		K		N	S
									HC		HC		HC		DP	HC
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WDN20
 XOEN12T308R-A-A88	E	1	12,11	4	13°	5	1,2	0,8	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
 XOEN12T3AZR-A-A88	E	1	12,21	4	13°	5,1	0,8							⊗		
 XOEN12T308R-F-A88	E	1	12,11	4	13°	10,3	1,2	0,8						⊗		

HC = Coated carbide
DP = Polycrystalline diamond

C 2

Positive rhombic ZDGT



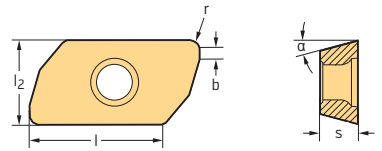
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P		M		K		N			S	
									HC		HC		HC		HC	HW	HC		
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WXN15	WNN15	WK10	WSM35S
ZDGT150404R-K85	G	2	10,5	16,2	4,76	15°	0,4	1,2								☺	☺		
ZDGT150408R-K85	G	2	10,5	16,2	4,76	15°	0,8	1,2								☺	☺		
ZDGT150412R-K85	G	2	10,5	16,2	4,76	15°	1,2	1,2								☺	☺		
ZDGT150416R-K85	G	2	10,5	16,2	4,76	15°	1,6	1,2								☺	☺		
ZDGT150420R-K85	G	2	10,5	16,2	4,76	15°	2	1,2								☺	☺		
ZDGT150425R-K85	G	2	10,5	16,2	4,76	15°	2,5	1,2								☺	☺		
ZDGT150430R-K85	G	2	10,5	16,2	4,76	15°	3	1,2								☺	☺		
ZDGT150440R-K85	G	2	10,5	16,2	4,76	15°	4	1,2								☺	☺		
ZDGT200508R-K85	G	2	14	21,2	5,56	15°	0,8	1,2								☺	☺		
ZDGT200512R-K85	G	2	14	21,2	5,56	15°	1,2	1,2								☺	☺		
ZDGT200516R-K85	G	2	14	21,2	5,56	15°	1,6	1,2								☺	☺		
ZDGT200520R-K85	G	2	14	21,2	5,56	15°	2	1,2								☺	☺		
ZDGT200530R-K85	G	2	14	21,2	5,56	15°	3	1,2								☺	☺		
ZDGT200540R-K85	G	2	14	21,2	5,56	15°	4	1,2								☺	☺		
ZDGT200550R-K85	G	2	14	21,2	5,56	15°	5	1,2								☺	☺		
ZDGT200560R-K85	G	2	14	21,2	5,56	15°	6	1,2								☺	☺		
ZDGT200564R-K85	G	2	14	21,2	5,56	15°	6,4	1,2								☺	☺		

ZDGT1504 and ZDGT2005 can be used in the M2131 ramping milling cutter

 HC = Coated carbide
 HW = Uncoated carbide

Positive rhombic ZDGT

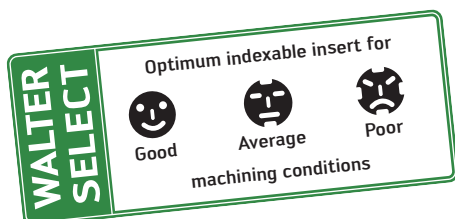


Indexable inserts

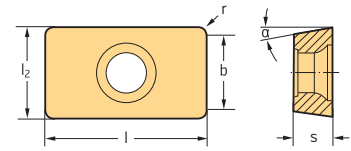
Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P			M			K		N	S		O
									HC			HC			HC		HF	HC		HF
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WMG40	WSM35S	WSP45S	WMG40	
ZDGT15A404R-K85	G	2	10,5	16,2	4,76	15°	0,4	1,2									⊗			⊗
ZDGT15A408R-K85	G	2	10,5	16,2	4,76	15°	0,8	1,2									⊗			⊗
ZDGT15A412R-K85	G	2	10,5	16,2	4,76	15°	1,2	1,2									⊗			⊗
ZDGT15A416R-K85	G	2	10,5	16,2	4,76	15°	1,6	1,2									⊗			⊗
ZDGT15A420R-K85	G	2	10,5	16,2	4,76	15°	2	1,2									⊗			⊗
ZDGT15A425R-K85	G	2	10,5	16,2	4,76	15°	2,5	1,2									⊗			⊗
ZDGT15A430R-K85	G	2	10,5	16,2	4,76	15°	3	1,2									⊗			⊗
ZDGT15A440R-K85	G	2	10,5	16,2	4,76	15°	4	1,2									⊗			⊗
ZDGT20A508R-K85	G	2	14	21,2	5,56	15°	0,8	1,2									⊗			⊗
ZDGT20A512R-K85	G	2	14	21,2	5,56	15°	1,2	1,2									⊗			⊗
ZDGT20A516R-K85	G	2	14	21,2	5,56	15°	1,6	1,2									⊗			⊗
ZDGT20A520R-K85	G	2	14	21,2	5,56	15°	2	1,2									⊗			⊗
ZDGT20A530R-K85	G	2	14	21,2	5,56	15°	3	1,2									⊗			⊗
ZDGT20A540R-K85	G	2	14	21,2	5,56	15°	4	1,2									⊗			⊗
ZDGT20A550R-K85	G	2	14	21,2	5,56	15°	5	1,2									⊗			⊗
ZDGT20A560R-K85	G	2	14	21,2	5,56	15°	6	1,2									⊗			⊗
ZDGT20A564R-K85	G	2	14	21,2	5,56	15°	6,4	1,2									⊗			⊗

ZDGT15A4 and ZDGT20A5 can be used in the M2131 and M2331 ramping milling cutters

HC = Coated carbide
HF = Uncoated fine-grained carbide



Positive rhombic BCGX Tiger-tec®



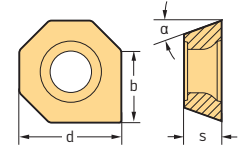
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	α	r mm	b mm	P			M		K		S		H	O	
									HC	HC	HC	HC	HC	HC	HC	HC	HC	HC		
									WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WSM35S	WSP45S	WHH15	WXM15
BCGX1605PDR-G55	G	2	9,9	17,3	5,81	7°	0,8	8						☺					☺	☺



HC = Coated carbide

Finishing inserts ODHX Tiger-tec® Gold



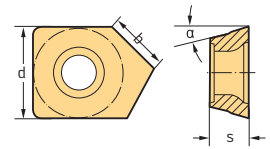
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	b mm	P			M		K		S		H	O					
							HC	HC	HC	HC	HC	HC	HC	HC	HC	HC						
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35G	WKP35S	WSM35S	WSP45S	WHH15	WXM15		
ODHX0504ZZR-A57	H	1	12,7	4,76	15°	7,2	☺	☺					☺							☺		
ODHX0605ZZR-A57	H	1	15,88	5,56	15°	9,4	☺	☺					☺							☺		
ODHX0605ZZN-A57	H	8	15,88	5,56	15°	6							☺								☺	
ODHX0605ZZN-A88	H	8	15,88	5,56	15°	6							☺								☺	☺

* ZZN for κ = 45° only

HC = Coated carbide

Positive square SDHX Tiger-tec®

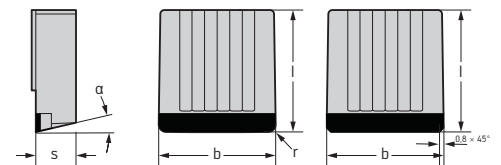


Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	b mm	P			M		K		S		H		O	
							HC	HC	HC	HC	HC	HC	HC	HC	HC	HC			
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKP25S	WKP35S	WSM35S	WSP45S	WHH15	WXM15	
SDHX09T3AZR-A88	H	1	9,52	3,97	15°	5,6						☺						☺	☺
SDHX1204AZR-A88	H	1	12,7	4,76	15°	7,5						☺						☺	☺

HC = Coated carbide

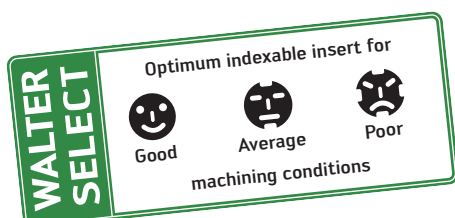
PCD finishing inserts XOEX



Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	α	b mm	P			M		K		N		S	
							HC	HC	HC	HC	HC	DP	HC	HC			
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WKP25S	WKP35S	WDN20	WSM35S	WSP45S	
XOEX12T3AZR-F-A88	F	1	12,16	4	13°	11,8								☺			
XOEX12T308N-F-A88	F	1	12,16	4	13°	11,8							☺				

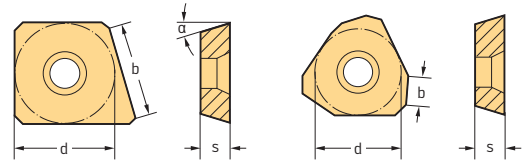
HC = Coated carbide
DP = Polycrystalline diamond







Finishing inserts

P2901 / P2903 / P2905 / SPHX

Tiger-tec®

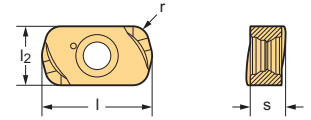


Indexable inserts



Designation	Tolerance class	Number of cutting edges	d mm	s mm	α	b mm	P		M		K		N		S		H	O
							HC		HC		HC		HW	DP	HC		HC	HC
							WKP255	WKP355	WSP455	WSM355	WSP455	WAK15	WKP255	WKP355	WK10	WCD10	WSM355	WSP455
 P2901-1R	H	1	12,7	4,76	11°	11					☺						☺	☺
 P2903-2R	A	3	9,52	4,76	11°	3,5					☺		☺				☺	☺
 P2905-1	F	4	12,7	4,76	11°	10					☺		☺				☺	☺
 SPHX1204PDR-A88	H	1	12,7	4,76	11°	3,5							☺					

HC = Coated carbide
 HW = Uncoated carbide
 DP = Polycrystalline diamond

Negative rhombic ENMX Tiger-tec® Gold

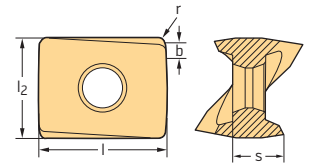


Indexable inserts



Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P				M		K				N		S		H			
							HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC					
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15		
 ENMX08T316R-D27	M	4	6	11	3,2	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉	☉		
 ENMX08T316R-F47	M	4	6	11	3,2	1,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉	☉		

HC = Coated carbide
HW = Uncoated carbide

Negative rhombic LNGX Tiger-tec® Gold



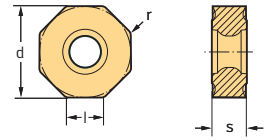
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	b mm	P				M		K				N		S				
								HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC					
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S		
 LNGX130708R-L55 LNGX130712R-L55 LNGX130716R-L55 LNGX130720R-L55 LNGX130725R-L55 LNGX130730R-L55	G	4	11	13,7	7,74	0,8	1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
	G	4	11	13,7	7,74	1,2	1	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
	G	4	11	13,7	7,74	1,6	0,9	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
	G	4	11	13,7	7,74	2	0,7	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
	G	4	11	13,7	7,74	2,5	0,6	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
	G	4	11	13,7	7,74	3	0,7	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉		
 LNGX130708R-L88	G	4	11	13,7	7,74	0,8	1,2												☉	☉				

HC = Coated carbide
HW = Uncoated carbide

☉ ☉ ☉ / ★ New addition to the product range

Negative octagonal ONHU / ONMU Tiger-tec® Gold

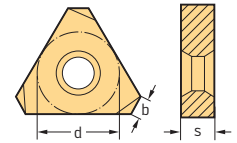


Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	P				M		K			N		S					
							HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HW						
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S		
ONHU050408-F57	H	16	12,7	5,26	4,86	0,8	☒	☒	☒	☒					☒	☒	☒					☒	
ONHU050408-F67	H	16	12,7	5,26	4,86	0,8	☒	☒	☒	☒					☒	☒	☒					☒	☒
ONMU050408-D57	M	16	12,7	5,26	4,86	0,8	☒	☒	☒	☒					☒	☒	☒					☒	

HC = Coated carbide
HW = Uncoated carbide

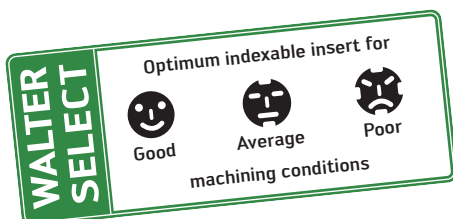
Wendelnovex® inserts P2352 / P23522 Tiger-tec® Silver



Indexable inserts

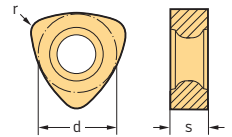
Designation	Tolerance class	Number of cutting edges	d mm	s mm	b mm	P		M		K			N		S				
						HC	HC	HC	HC	HC	HC	HC	HW	HC	HW				
						WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	
P2352-1R	A	6	15	4,5	1,1	☒	☒						☒	☒					
P2352-2R	A	6	18	4,5	1,1		☒							☒					
P23522-1R	A	6	15	4,5	1,1		☒							☒					

HC = Coated carbide
HW = Uncoated carbide




Negative triangular P23696

Tiger-tec® Gold



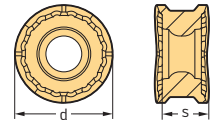
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	r mm	P				M		K				N		S	
						HC				HC		HC				HC	HW	HC	
						WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
 P23696-1.0 P23696-2.0	M	6	0	5,31	1,2	☉	☉	☉	☉	☉	☉		☉	☉	☉	☉		☉	☉
	M	6	13,5	7,41	1,6	☉	☉	☉	☉	☉	☉		☉	☉	☉	☉		☉	☉



HC = Coated carbide
HW = Uncoated carbide

Negative round RNMX

Tiger-tec® Silver

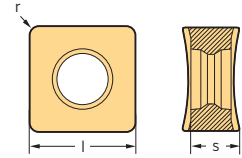


Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	P			M		K				N		S	
					HC			HC		HC				HC	HW	HC	
					WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S
 RNMX1005M0-G57 RNMX1206M0-G57	M	8	10	4,69		☉	☉	☉								☉	☉
	M	8	12	5,64		☉	☉	☉								☉	☉
 RNMX1005M0-K67 RNMX1206M0-K67	M	8	10	4,69		☉	☉	☉								☉	☉
	M	8	12	5,64		☉	☉	☉								☉	☉

HC = Coated carbide
HW = Uncoated carbide

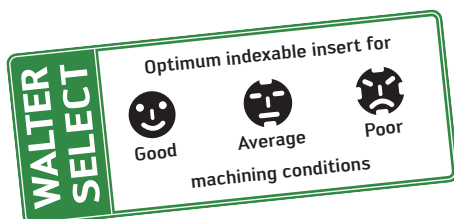
Negative square SNGX / SNMX Tiger-tec® Gold



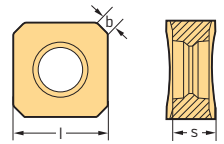
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	P				M		K				N		S	
						HC				HC		HC				HC	HW	HC	
						WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
SNGX120512-F57	G	8	12,7	5,60	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SNMX120512-D27	M	8	12,7	5,55	1,2	☺	☺	☺			☺	☺	☺	☺					
SNMX120520-D27	M	8	12,7	5,55	2	☺	☺	☺			☺	☺	☺	☺					
SNMX160620-D27	M	8	16	6,38	2	☺	☺	☺			☺	☺	☺	☺					
SNMX160640-D27	M	8	16	6,38	4	☺	☺	☺			☺	☺	☺	☺					
SNMX090408-F27	M	8	9,52	4,87	0,8	☺	☺	☺			☺	☺	☺	☺					
SNMX120512-F27	M	8	12,7	5,65	1,2	☺	☺	☺			☺	☺	☺	☺					
SNMX160620-F27	M	8	16	6,38	2	☺	☺	☺			☺	☺	☺	☺					
SNMX090408-F57	M	8	9,52	4,85	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX120512-F57	M	8	12,7	5,50	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX120520-F57	M	8	12,7	5,50	2	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX160620-F57	M	8	16	6,38	2	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX160640-F57	M	8	16	6,38	4	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX090408-F67	M	8	9,52	4,87	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNMX120512-F67	M	8	12,7	5,63	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	








HC = Coated carbide
HW = Uncoated carbide



Negative square SNGX / SNHX / SNMX Tiger-tec® Gold

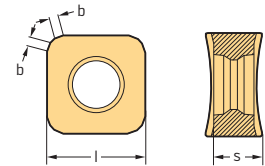


Indexable inserts

Designation	Number of cutting edges	l mm	s mm	b mm	P				M		K				N		S		
					HC				HC		HC				HC	HW	HC		
					WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
 SNGX1205ANN-F27	8	12,7	5,59	1,5	☉	☉	☉							☉	☉	☉			
 SNGX0904ANN-F57	8	9,52	4,69	1,2	☉	☉	☉	☉	☉				☉	☉	☉	☉		☉	☉
SNGX1205ANN-F57	8	12,7	5,54	1,5	☉	☉	☉	☉	☉				☉	☉	☉	☉		☉	☉
SNGX1606ANN-F57	8	16	6,3	1,8		☉	☉	☉	☉				☉	☉	☉	☉			☉
 SNGX0904ANN-F67	8	9,52	4,72	1,2	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉		☉	☉
SNGX1205ANN-F67	8	12,7	5,54	1,5	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉		☉	☉
 SNHX0904ANN-K88	8	9,52	4,68	1,5												☉	☉		
SNHX1205ANN-K88	8	12,7	5,54	1,5												☉	☉		
 SNMX0904ANN-F27	8	9,52	4,72	1,2	☉	☉	☉						☉	☉	☉	☉			
SNMX1205ANN-F27	8	12,7	5,59	1,5	☉	☉	☉						☉	☉	☉	☉			
 SNMX0904ANN-F57	8	9,52	4,69	1,2	☉	☉	☉						☉	☉	☉	☉			
SNMX1205ANN-F57	8	12,7	5,54	1,5	☉	☉	☉						☉	☉	☉	☉			
 SNMX0904ANN-F67	8	9,52	4,72	1,2	☉	☉	☉						☉	☉	☉	☉			
SNMX1205ANN-F67	8	12,7	5,54	1,5	☉	☉	☉						☉	☉	☉	☉			

HC = Coated carbide
HW = Uncoated carbide

Negative square SNGX Tiger-tec® Gold

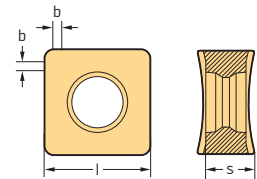


Indexable inserts

Designation	Number of cutting edges	l mm	s mm	b mm	P				M		K			N		S		
					HC				HC		HC			HC	HW	HC		
					WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
SNGX1205ENN-F27	8	12,7	5,65	1,2	☺	☹	☹	☹				☹	☹	☹				
SNGX1205ENN-F57	8	12,7	5,61	1,2	☺	☹	☹	☹	☹	☹		☹	☹	☹			☹	☹
SNGX1205ENN-F67	8	12,7	5,64	1,2	☺	☹	☹	☹	☹	☹	☺	☹	☹	☹			☹	☹

HC = Coated carbide
HW = Uncoated carbide

Negative square SNGX / SNHX / SNMX Tiger-tec® Gold

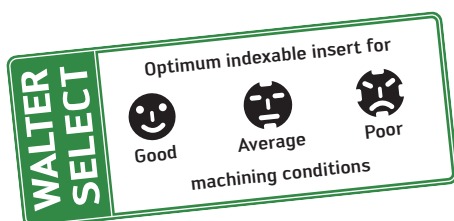


Indexable inserts

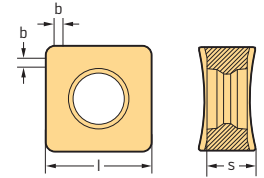
Designation	Number of cutting edges	l mm	s mm	b mm	P				M		K			N		S		
					HC				HC		HC			HC	HW	HC		
					WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
SNGX1205ZNN-F27	8	12,7	5,77	1,2	☺	☹	☹	☹				☹	☹	☹				
SNGX0904ZNN-F57	8	9,52	4,9	1	☺	☹	☹	☹	☹	☹	☹	☹	☹	☹			☹	☹
SNGX1205ZNN-F57	8	12,7	5,77	1,2	☺	☹	☹	☹	☹	☹		☹	☹	☹			☹	☹

HC = Coated carbide
HW = Uncoated carbide





C 2



Negative square SNGX / SNHX / SNMX Tiger-tec® Gold

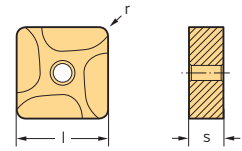


Indexable inserts



Designation	Number of cutting edges	l mm	s mm	b mm	P		M		K			N		S		
					HC		HC		HC			HC	HW	HC		
					WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15
 SNGX0904ZNN-F67	8	9,52	4,93	1	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺
SNGX1205ZNN-F67	8	12,7	5,80	1,2	☺	☺	☺	☺	☺	☺	☺			☺	☺	
SNHX0904ZNN-K88	8	9,52	5,01	1									☺	☺		
 SNMX0904ZNN-F27	8	9,52	4,93	1	☺	☺	☺			☺	☺	☺				
 SNMX0904ZNN-F57	8	9,52	4,91	1	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺
 SNMX0904ZNN-F67	8	9,52	4,93	1	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺

HC = Coated carbide
HW = Uncoated carbide

Negative square SNEF Tiger-tec® Gold

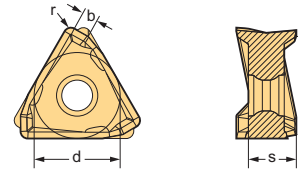


Indexable inserts


Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	b mm	P				M		K				N		S			
							HC				HC		HC				HC	HW	HC			
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	
 SNEF120408R-B67	E	8	12,7	4,76	0,8	2,1								☺	☺	☺	☺					
 SNEF120408R-D67	E	8	12,7	4,76	0,8	2,1							☺									

HC = Coated carbide
HW = Uncoated carbide

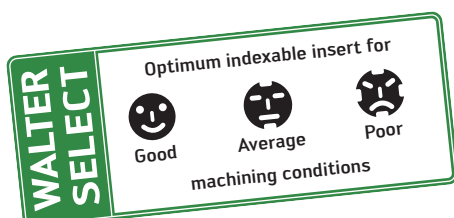
Negative triangular TNMU Tiger-tec® Gold



Indexable inserts

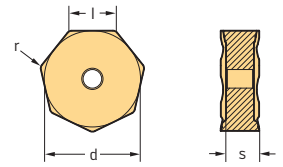
Designation	Tolerance class	Number of cutting edges	d mm	s mm	b mm	r mm	P				M		K				N		S		
							HC				HC		HC				HC	HW	HC		
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
 TNMU160508R-G57	M	6	9,6	5,35	1,6	0,8	☹	☹	☹	☹	☹			☹	☹	☹					☹

HC = Coated carbide
HW = Uncoated carbide



Negative heptagonal XNHF / XNMF

Tiger-tec® Gold

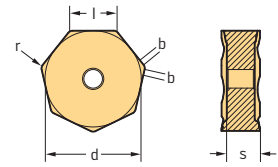


Indexable inserts




Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	P				M		K				N		S	
							HC				HC		HC				HC	HW	HC	
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
XNHF070508-D27	H	7	14,5	7	5	0,8							☉	☉	☉	☉				
	XNHF090612-D27	H	14	19,05	9	5,68	1,2							☉	☉	☉	☉			
XNHF070508-D57	H	7	14,5	7	5	0,8							☉	☉	☉	☉				
	XNHF090612-D57	H	14	19,05	9	5,68	1,2							☉	☉	☉	☉			
XNHF070508-D67	H	7	14,5	7	5	0,8							☉	☉	☉	☉				
XNMF070508-D27	M	7	14,5	7	4,74	0,8							☉	☉	☉	☉				
	XNMF090612-D27	M	14	19,05	9	5,68	1,2							☉	☉	☉	☉			
XNMF070508-D57	M	7	14,5	7	4,74	0,8							☉	☉	☉	☉				
	XNMF090612-D57	M	14	19,05	9	5,68	1,2							☉	☉	☉	☉			
XNMF070508-F57	M	7	14,5	7	4,74	0,8							☉	☉	☉	☉				
	XNMF090612-F57	M	14	19,05	9	5,68	1,2							☉	☉	☉	☉			

HC = Coated carbide
HW = Uncoated carbide

Negative heptagonal XNHF Tiger-tec® Gold

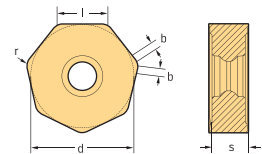


Indexable inserts



Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	b mm	P				M		K				N		S			
								HC				HC		HC				HC	HW	HC			
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	
 XNHF0705ANN-D27 XNHF0906ANN-D27	H	7	14,5	7	5	0,8	1,1								☉	☉	☉	☉					
	H	14	19,05	9	5,68	0,8	1,4								☉	☉	☉	☉					
 XNHF0705ANN-D57 XNHF0906ANN-D57	H	7	14,5	7	5	0,8	1,1								☉	☉	☉	☉					
	H	14	19,05	9	5,68	0,8	1,4								☉	☉	☉	☉					
 XNHF0705ANN-D67 XNHF0906ANN-D67	H	7	14,5	7	5	0,8	1,1							☉	☉	☉	☉						
	H	14	19,05	9	5,68	0,8	1,4							☉	☉	☉	☉						

HC = Coated carbide
HW = Uncoated carbide

Negative heptagonal XNGU / XNMU Tiger-tec® Gold

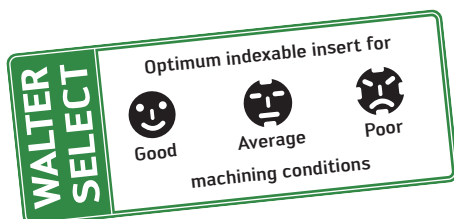


Indexable inserts

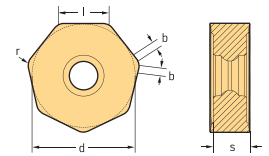
Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	b mm	P				M		K				N		S				
								HC				HC		HC				HC	HW	HC				
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
 XNGU0705ANN-F57	G	7	14,5	6,98	5	0,8	1,1	☉	☉	☉	☉	☉		☉		☉	☉	☉						
 XNGU0705ANN-F67	G	7	14,5	6,98	5	0,8	1,1					☉												

HC = Coated carbide
HW = Uncoated carbide




C 2



Negative heptagonal XNGU / XNMU Tiger-tec® Gold

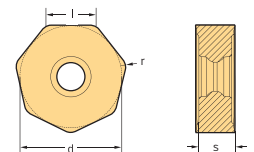


Indexable inserts


Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	b mm	P				M		K				N		S					
								HC	HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HW	HC			
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S	
 XNMMU0705ANN-F27 XNMMU0906ANN-F27	M	7	14,5	6,98	5	0,8	1,1	☉	☉	☉						☉	☉	☉	☉						
	M	7	19,05	9,18	5,88	0,8	1,4	☉	☉	☉						☉	☉	☉	☉						
 XNMMU0705ANN-F57 XNMMU0906ANN-F57	M	7	14,5	6,98	5	0,8	1,1	☉	☉	☉	☉		☉			☉	☉	☉							
	M	7	19,05	9,18	5,88	0,8	1,4	☉	☉	☉	☉	☉	☉			☉	☉	☉					☉		
 XNMMU0705ANN-F67 XNMMU0906ANN-F67	M	7	14,5	6,98	5	0,8	1,1	☉	☉	☉		☉	☉			☉	☉	☉					☉	☉	
	M	7	19,05	9,18	5,88	0,8	1,4	☉	☉	☉		☉	☉			☉	☉	☉					☉	☉	

HC = Coated carbide
HW = Uncoated carbide

Negative heptagonal XNMU Tiger-tec® Gold



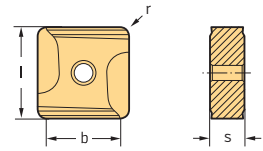
Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	l mm	s mm	r mm	P				M		K				N		S					
							HC	HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HW	HC			
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S			
 XNMMU070508-F57 XNMMU090612-F57	M	7	14,5	6,98	5	0,8	☉	☉	☉	☉	☉	☉			☉	☉	☉							
	M	7	19,05	9,18	5,88	1,2	☉	☉	☉	☉	☉	☉			☉	☉	☉						☉	

HC = Coated carbide
HW = Uncoated carbide

C2

Finishing inserts SNEF Tiger-tec®

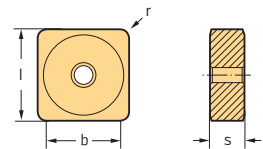


Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	b mm	P		M		K			N		S	
							HC		HC		HC			HC	HW	HC	
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10
SNEF1204PNR-B67	E	4	12,7	4,76	0,8	10,8					☺						

HC = Coated carbide
HW = Uncoated carbide

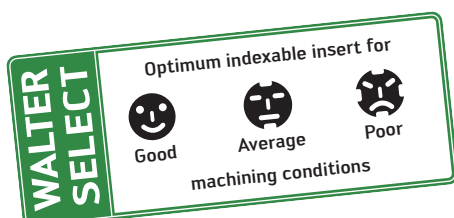
Finishing inserts SNEF Tiger-tec®



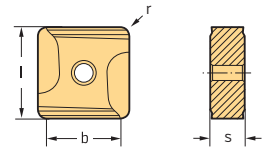
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	b mm	P		M		K			N		S		H
							HC		HC		HC			HC	HW	HC		HC
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S
SNEF1204PNN-A27	E	8	12,7	4,76	1,2	10,3					☺							☺

HC = Coated carbide
HW = Uncoated carbide



Finishing inserts
SNEX
Tiger-tec®



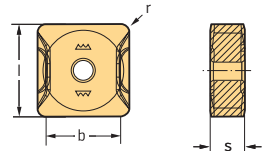
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	b mm	P		M		K			N		S		H			
							HC	HC	HC	HC	HC	HC	HW	HC	HC	HC					
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	
SNEX1204PNR-B67	E	4	12,7	4,76	0,8	10,8						⊕									⊕



HC = Coated carbide
HW = Uncoated carbide

Finishing inserts
SNEX
Tiger-tec®



Indexable inserts

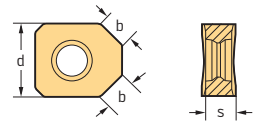
Designation	Tolerance class	Number of cutting edges	l mm	s mm	r mm	b mm	P		M		K			N		S		H			
							HC	HC	HC	HC	HC	HC	HW	HC	HC	HC					
							WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	
SNEX1204PNN-A27	E	4	12,7	4,76	1,2	10,3						⊕									⊕



HC = Coated carbide
HW = Uncoated carbide

Finishing inserts XNGX

Tiger-tec®

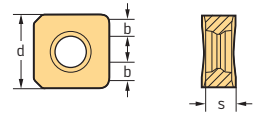


Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	b mm	P			M			K			N		S		H		O	
						WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	WXM15	HC	HC
XNGX0904ANN-F67	G	2	9,52	4,68	5						⊕									⊕	⊕	
XNGX1205ANN-F67	G	2	12,7	5,39	4,7						⊕									⊕	⊕	

Finishing inserts XNGX

Tiger-tec®

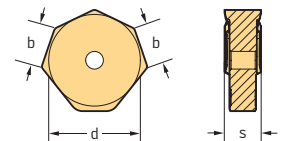


Indexable inserts

Designation	Tolerance class	Number of cutting edges	d mm	s mm	b mm	P			M			K			N		S		H		O	
						WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	WXM15	HC	HC
XNGX0904ZNN-F67	G	2	9,52	4,83	3,5						⊕									⊕	⊕	
XNGX1205ZNN-F67	G	2	12,7	5,62	4						⊕									⊕	⊕	

Finishing inserts XNHX

Tiger-tec®



Indexable inserts

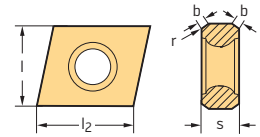
Designation	Tolerance class	Number of cutting edges	d mm	s mm	b mm	P			M			K			N		S		H	
						WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	HC
XNHX0906ANN-D67	H	4	19,05	5,57	7,5						⊕									⊕

HC = Coated carbide
HW = Uncoated carbide

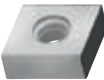


⊕ / ★ New addition to the product range

Tangential rhombic CNHQ / CNHU / CNMU

Tiger-tec® Silver



Indexable inserts

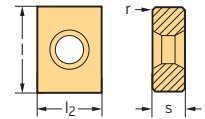
Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	b mm	P		M		K			N		S	
								HC		HC		HC			HC	HW	HC	
								WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10
 CNHQ0805PPN-A57T	H	2	9	8	5	0,8	1,2	⊗	⊗									
 CNHU0805PPN-D57T	H	2	9	8	5	0,8	1,2	⊗	⊗	⊗			⊗	⊗				⊗
CNHU1206PPN-D57T	H	2	13	12	6,5	0,8	1,5	⊗	⊗	⊗			⊗	⊗				⊗
 CNMU080508-D57T	M	2	9	8	5	0,8		⊗	⊗	⊗	⊗							⊗
CNMU120608-D57T	M	2	13	12	6,5	0,8		⊗	⊗	⊗								⊗
CNMU160812-D57T	M	2	15	16	8	1,2		⊗	⊗	⊗								⊗

Note: l₂ = Width of cut



HC = Coated carbide
HW = Uncoated carbide

Tangential rhombic LNMU

Tiger-tec® Gold



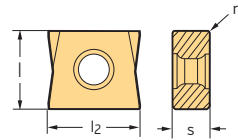
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P		M		K			N		S	
							HC		HC		HC			HC	HW	HC	
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S
 LNMU150812T-F27T	M	4	14	15	8	1,2	⊗	⊗	⊗				⊗	⊗			
LNMU201012T-F27T	M	4	16	20	10	1,2	⊗	⊗				⊗	⊗				
 LNMU150812-F57T	M	4	14	15	8	1,2	⊗	⊗	⊗	⊗							⊗
LNMU201012-F57T	M	4	16	20	10	1,2	⊗	⊗	⊗								⊗

HC = Coated carbide
HW = Uncoated carbide

C2

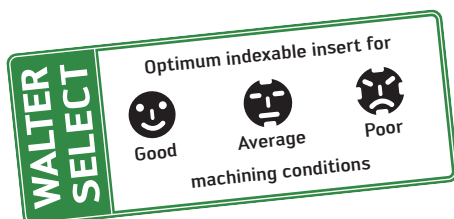
Tangential rhombic LNHU / LNMU Tiger-tec® Gold



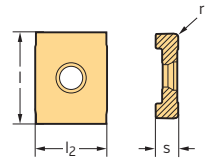
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P				M		K			N		S	
							HC				HC		HC			HC	HW	HC	
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10
 LNHU080304-B57T LNHU080404-B57T LNHU100508-B57T LNHU120608-B57T LNHU160812-B57T	H	4	9	8	3,5	0,4		☒	☒	☒				☒	☒	☒			
	H	4	9,4	8	4,5	0,4		☒	☒	☒				☒	☒	☒			
	H	4	12,3	10	5,5	0,8			☒	☒	☒			☒	☒	☒			
	H	4	13,9	12	6,5	0,8			☒	☒	☒			☒	☒	☒			
	H	4	16,9	16	8	1,2			☒	☒	☒			☒	☒	☒			
 LNHU080304-F57T LNHU080404-F57T LNHU100508-F57T LNHU120608-F57T LNHU160812-F57T	H	4	9	8	3,5	0,4	☒	☒	☒	☒	☒			☒	☒	☒			☒
	H	4	9,4	8	4,5	0,4	☒	☒	☒	☒	☒			☒	☒	☒			☒
	H	4	12,3	10	5,5	0,8	☒	☒	☒	☒	☒			☒	☒	☒			☒
	H	4	13,9	12	6,5	0,8	☒	☒	☒	☒	☒			☒	☒	☒			☒
	H	4	16,9	16	8	1,2	☒	☒	☒	☒	☒			☒	☒	☒			☒
 LNMU080304-B57T LNMU080404-B57T LNMU100508-B57T LNMU120608-B57T LNMU160812-B57T	M	4	9	8	3,5	0,4		☒	☒	☒				☒	☒	☒			
	M	4	9,4	8	4,5	0,4		☒	☒	☒				☒	☒	☒			
	M	4	12,3	10	5,5	0,8		☒	☒	☒				☒	☒	☒			
	M	4	13,9	12	6,5	0,8		☒	☒	☒				☒	☒	☒			
	M	4	16,9	16	8	1,2		☒	☒	☒				☒	☒	☒			
 LNMU080304-F57T LNMU080404-F57T LNMU100508-F57T LNMU120608-F57T LNMU160812-F57T	M	4	9	8	3,5	0,4	☒	☒	☒	☒	☒			☒	☒	☒			☒
	M	4	9,4	8	4,5	0,4	☒	☒	☒	☒	☒			☒	☒	☒			☒
	M	4	12,3	10	5,5	0,8	☒	☒	☒	☒	☒			☒	☒	☒			☒
	M	4	13,9	12	6,5	0,8	☒	☒	☒	☒	☒			☒	☒	☒			☒
	M	4	16,9	16	8	1,2	☒	☒	☒	☒	☒			☒	☒	☒			☒




HC = Coated carbide
HW = Uncoated carbide



Tangential rhombic LNHX / LNMX Tiger-tec® Gold

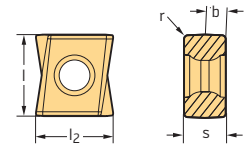


Indexable inserts




Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P				M		K			N		S	
							HC				HC		HC			HC	HW	HC	
							WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10
 LNHX070204-F57T	H	4	7	9	2,4	0,4	⊕	⊕	⊕	⊕				⊕	⊕			⊕	
 LNMX070204-D57T	M	4	7	9	2,4	0,4	⊕	⊕					⊕	⊕	⊕				
 LNMX070204-F57T	M	4	7	9	2,4	0,4	⊕	⊕	⊕					⊕	⊕			⊕	

HC = Coated carbide
HW = Uncoated carbide

Tangential rhombic LNHU / LNMU Tiger-tec® Gold



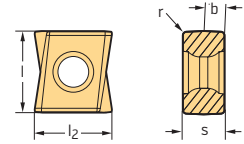
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	b mm	P				M		K			N		S	
								HC				HC		HC			HC	HW	HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10
 LNHU090404R-L55T	H	4	8,5	9	4,5	0,4	1,5	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU090408R-L55T	H	4	8,5	9	4,5	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU090412R-L55T	H	4	8,5	9	4,5	1,2	0,8	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU090416R-L55T	H	4	8,5	9	4,5	1,6		⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU090420R-L55T	H	4	8,5	9	4,5	2		⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130608R-L55T	H	4	12	13	6,8	0,8	2,2	⊕	⊕	⊕	⊕	⊕	⊕	⊕				⊕	⊕	
LNHU130612R-L55T	H	4	12	13	6,8	1,2	1,9	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130616R-L55T	H	4	12	13	6,8	1,6	1,5	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130620R-L55T	H	4	12	13	6,8	2	1,2	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130625R-L55T	H	4	12	13	6,8	2,5	0,7	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130630R-L55T	H	4	12	13	6,8	3		⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU130632R-L55T	H	4	12	13	6,8	3,2		⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU160708R-L55T	H	4	15,5	16	7,2	0,8	2,3	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
LNHU160712R-L55T	H	4	15,5	16	7,2	1,2	1,9	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
 LNMU090404R-L55T	M	4	8,5	9	4,5	0,4	1,5	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	
 LNMU130608R-L55T	M	4	12	13	6,8	0,8	2,2	⊕	⊕	⊕	⊕	⊕	⊕					⊕	⊕	



HC = Coated carbide
HW = Uncoated carbide

C2

Tangential rhombic LNHU / LNMU Tiger-tec® Gold

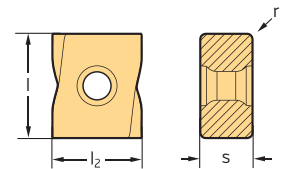


Indexable inserts



Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	b mm	P				M		K				N		S				
								HC				HC		HC				HC	HW	HC				
								WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15	WK10	WSM355	WSP455		
 LNHU090404R-L65T	H	4	8,5	9	4,5	0,4	1,5				☒	☒											☒	
LNHU130608R-L65T	H	4	12	13	6,8	0,8	2,2				☒	☒												☒
LNHU160708R-L65T	H	4	15,5	16	7,2	0,8	2,3				☒	☒												☒
 LNMU090404R-L85T	H	4	8,5	9	4,5	0,4	1,5												☒	☒				
LNMU130608R-L85T	H	4	12	13	6,8	0,8	2,2												☒	☒				

HC = Coated carbide
HW = Uncoated carbide

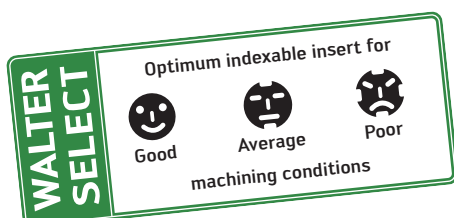
Tangential rhombic LNMX Tiger-tec® Gold



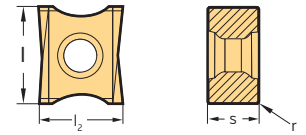
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P				M		K				N		S				
							HC				HC		HC				HC	HW	HC				
							WKP255	WKP356	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP356	WKP355	WXN15	WK10	WSM355	WSP455		
 LNMX201012R-F27T	M	4	17,05	20	10	1,2	☒	☒	☒						☒	☒	☒						
 LNMX201012R-F57T	M	4	17,05	20	10	1,2	☒	☒	☒	☒	☒				☒	☒	☒						

HC = Coated carbide
HW = Uncoated carbide



Tangential rhombic LNHX Tiger-tec® Silver



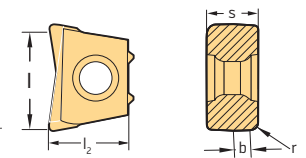
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P			M			K			N		S		
							HC			HC			HC			HC	HW	HC		
							WKP25S	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSM45X
LNHX120604R-L65T	H	4	11	12,7	6,8	0,4														



HC = Coated carbide
HW = Uncoated carbide

Tangential rhombic XNHX Tiger-tec® Silver



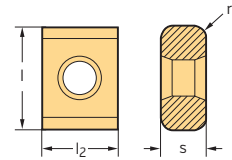
Indexable inserts

Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	b mm	P			M			K			N		S		
								HC			HC			HC			HC	HW	HC		
								WKP25S	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSM45X
XNHX130608R-L65T	H	2	10,5	14	6,8	0,8	2														
XNHX130612R-L65T	H	2	10,5	14	6,8	1,2	2														
XNHX130616R-L65T	H	2	10,5	14	6,8	1,6	2														
XNHX130620R-L65T	H	2	10,5	14	6,8	2	2														
XNHX130624R-L65T	H	2	10,5	14	6,8	2,4	2														
XNHX130630R-L65T	H	2	10,5	14	6,8	3	1,4														
XNHX130632R-L65T	H	2	10,5	14	6,8	3,2	1,3														
XNHX130640R-L65T	H	2	10,5	14	6,8	4	0,5														



HC = Coated carbide
HW = Uncoated carbide

Tangential rhombic P44280 / P44290 Tiger-tec® Silver

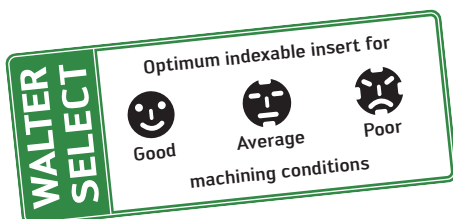


Indexable inserts

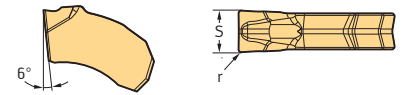
Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P		M		K		N		S	
							HC		HC		HC		HC	HW	HC	
							WKP25S	WKP35S	WSP45S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10
P44280-1R08-D57 P44280-1R10-D57 P44280-1R125-D57 P44280-1R15-D57 P44280-1R20-D57 P44280-2R25-D57 P44280-2R30-D57 P44280-2R40-D57	H	8	9,52	12,7	5,5	0,8	☺		☺						☺	
	H	8	9,52	12,7	5,5	1	☺		☺						☺	
	H	8	9,52	12,7	5,5	1,25	☺		☺						☺	
	H	8	9,52	12,7	5,5	1,5			☺						☺	
	H	8	9,52	12,7	5,5	2	☺		☺						☺	
	H	8	9,52	12,7	6,35	2,5	☺		☺						☺	
	H	8	9,52	12,7	6,35	3	☺		☺						☺	
	H	4	4	9,52	12,7	6,35	4			☺					☺	
P44290-1R08-D57 P44290-1R10-D57 P44290-1R125-D57 P44290-1R20-D57 P44290-2R25-D57 P44290-2R30-D57 P44290-2R40-D57	M	8	9,52	12,7	5,5	0,8	☺		☹						☹	
	M	8	9,52	12,7	5,5	1	☺									
	M	8	9,52	12,7	5,5	1,25	☺									
	M	8	9,52	12,7	5,5	2	☺									
	M	8	9,52	12,7	6,35	2,5	☺									
	M	8	9,52	12,7	6,35	3	☺		☹						☹	
	M	8	9,52	12,7	6,35	3	☺		☹						☹	
	M	4	4	9,52	12,7	6,35	4			☹					☹	

P44280: Tolerance class H
P44290: Tolerance class M

HC = Coated carbide
HW = Uncoated carbide



Slitting SX cutting inserts Tiger-tec® Silver



Cutting inserts







Designation	s mm	r mm	S _{Tol} mm	l _{Tol} mm	P					M					K				N			S				
					HC					HC					HC				HW			HC				
					WKP23S	WKP25S	WSM33S	WKP35S	WSM43S	WSP45S	WSM23S	WSM33S	WSM35S	WSM43S	WSP45S	WAK15	WKP23S	WKK25S	WKP25S	WKP35S	WXN15	WK10	WK1	WSM23S	WSM33S	WSM35S
SX-1E150N01-SF5	1,5	0,15	±0,05	±0,1			☺																			
SX-2E200N02-SF5	2	0,2	±0,05	±0,1			☺		☺																	
SX-3E300N02-SF5	3	0,2	±0,05	±0,1			☺		☺																	
SX-4E400N02-SF5	4	0,2	±0,05	±0,1			☺		☺																	
SX-5E500N04-SF5	5	0,4	±0,05	±0,1			☺		☺																	
SX-1E150N01-CE4	1,5	0,15	±0,05	±0,1			☺																			
SX-2E200N02-CE4	2	0,2	±0,05	±0,1	☺		☺		☺					☺												
SX-3E300N02-CE4	3	0,2	±0,05	±0,1	☺		☺		☺					☺												
SX-4E400N02-CE4	4	0,2	±0,05	±0,1	☺		☺		☺					☺												
SX-5E500N04-CE4	5	0,4	±0,05	±0,1	☺		☺		☺					☺												
SX-2E200N02-CF6	2	0,2	±0,05	±0,1			☺		☺																	
SX-3E300N02-CF6	3	0,2	±0,05	±0,1			☺		☺																	
SX-1E150N01-SK8	1,5	0,1	±0,02	±0,05																☺						
SX-2E200N02-SK8	2	0,2	±0,02	±0,05																☺						
SX-3E300N02-SK8	3	0,2	±0,02	±0,05																☺						
SX-4E400N02-SK8	4	0,2	±0,02	±0,05																☺						
SX-5E500N04-SK8	5	0,4	±0,02	±0,05																☺						

l_{Tol} = Repeat accuracy when changing indexable inserts within the same indexable insert batch
Radius tolerance r_{Tol} = ± 0.05 mm







HC = Coated carbide
HW = Uncoated carbide




Indexable insert milling cutters product range overview

Face milling cutters





Machining					
Lead angle κ	45°				88°
Designation	F2010	M3024 Walter BLAXX	M4003	M5009 Xtra-tec® XT	M5012 Xtra-tec® XT
D _c [mm]	80–315	40–160	19–160	25–100	32–100
D _c [inch]	–	2,000–6,000	0,750–6,000	1,000–4,000	–
Page	656	660	668	676	680
					

Shoulder milling cutters







Machining					
Lead angle κ	90°				
Designation	F2010	M2136	M2331	M4130	M4132*
D _c [mm]	80–315	50–160	32–50	16–100	16–125
D _c [inch]	–	2,000–6,000	1,500–2,000	–	0,625–5,000
Page	696	700	704	708	710
					 * $\kappa = 89^{\circ}45'$

Machining		
Lead angle κ	90°	
Designation	M5130 Xtra-tec® XT	M5137 Xtra-tec® XT
D _c [mm]	10–160	50–100
D _c [inch]	0,500–6,000	–
Page	716	738
		



High-feed milling cutters

Machining			
Lead angle κ	15°		
Designation	F2010	M4002	M5008 Xtra-tec® XT
D _a [mm]	93–328	20–125	16–66
D _a [inch]	–	0,750–4,000	0,625–2,500
Page	682	684	690
			



Slot milling cutters

Machining				
Lead angle κ	90°			90°
Designation	M4791	M3255 Walter BLAXX	M4258	F5055 Walter BLAXX
D _c [mm]	–	50–80	50–80	63–500
D _c [inch]	0,750–1,500	2,000–3,000	2,000–3,000	2,480–6,299
Page	740	742	746	758
				

Copy milling cutters

Machining	
Lead angle κ	
Designation	M2471
D _a [mm]	25–63
D _a [inch]	2,000–2,500
Page	764
	

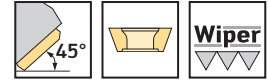
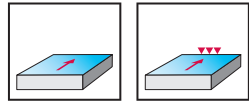
Profiling cutters

Machining	
Lead angle κ	45°
Designation	M4574
D _c [mm]	12–40
D _c [inch]	0,500–1,500
Page	768
	

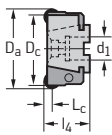
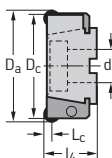
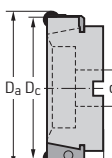
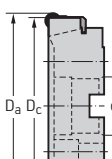
Face milling cutters

F2010 mm
SD .. 1204AZN


- Adjustable runout
- Four cutting edges per indexable insert



	P	M	K	N	S	H	O
F2010	●	●	●	●	●	●	●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	F2010.B.080.Z06.06.R758M	80	94	27	50	6	6	1,2	6	SD .. 1204AZN SDHX1204AZR
Parallel bore DIN 138 transverse keyway 	F2010.B.100.Z07.06.R758M	100	114	32	50	6	7	1,8	7	SD .. 1204AZN SDHX1204AZR
	F2010.B.125.Z08.06.R758M	125	139	40	63	6	8	3,5	8	SDHX1204AZR
Parallel bore DIN 138 transverse keyway 	F2010.B.160.Z10.06.R758M	160	174	40/40 B	63	6	10	5,5	10	SD .. 1204AZN SDHX1204AZR
	F2010.B.200.Z12.06.R758M	200	214	60/50 B	63	6	12	8,3	12	
	F2010.B.250.Z12.06.R758M	250	264	60/50 B	63	6	12	14,7	12	
	F2010.B.250.Z16.06.R758M	250	264	60/50 B	63	6	16	14,6	16	
Parallel bore DIN 138 transverse keyway 	F2010.B.315.Z14.06.R758M	315	329	60/50-60 BB	80	6	14	26,3	14	SD .. 1204AZN SDHX1204AZR
	F2010.B.315.Z18.06.R758M	315	329	60/50-60 BB	80	6	18	26,2	18	

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

/ ★ New addition to the product range

Assembly parts

		D _c [mm]	80–315
	Cartridge for tool body		FR758M
	Clamping screw for cartridge Tightening torque		FS247 (SW 4) 8,0 Nm
	Clamping screw for indexable insert Tightening torque		FS1453 (Torx 15IP) 3,5 Nm
	Adjusting pin		FS303 (Torx 20)

Accessories

		D _c [mm]	80–315
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
	Interchangeable blade for indexable insert		FS2014 (Torx 15IP)
	Torque T-handle Tightening torque		FS2041 4,5–14 Nm
	Interchangeable blade for cartridge		FS2051 (SW 4)
	Screwdriver for indexable insert		FS1485 (Torx 15IP)
	Screwdriver for adjusting pin		FS228 (Torx 20)
	ISO 2936 Allen key for cartridge		ISO2936-4 (SW 4)

Indexable inserts

Designation	r mm	b mm	HT		P					M			K				N		S			H	O
			WE	EP	HC	HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HC	HC	HC	HC	HC			
			20	25S	35G	35S	45S	35S	45X	45S	15	25S	25S	35G	35S	N15	K10	35S	45X	45S	H15	M15	
SDHX1204AZR-A88		7,5												☺								☺	☺
SDET1204AZN-F57	0,3	1,8	☺																				
SDGT1204AZN-F57	0,3	1,8	☺	☺	☺	☺	☺	☺						☺									
SDGT1204AZN-G77	0,3	1,4																					
SDHT1204AZN-G88	0,3	1,4																					
SDMT1204AZN-D57	0,3	1,4		☺	☺	☺	☺	☺	☺					☺	☺								
SDMT1204AZN-F57	0,3	1,8		☺	☺	☺	☺	☺	☺														
SDMW1204AZN-A57	0,3	1,4		☺	☺	☺	☺	☺						☺									

HT = Cermet
 HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

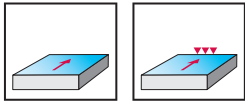
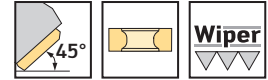
• Other application

C 2

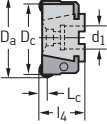
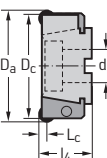
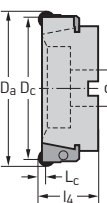
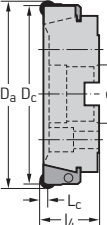
Face milling cutters

F2010
XN . U0705 ..


- Adjustable runout
- 14 cutting edges per indexable insert



	P	M	K	N	S	H	O
F2010	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	F2010.B.080.Z06.04.R759M	80	90	27	50	4	6	1,2	6	XN . U0705 .. XNGX0705ANN
Parallel bore DIN 138 transverse keyway 	F2010.B.100.Z07.04.R759M	100	110	32	50	4	7	1,8	7	XN . U0705 .. XNGX0705ANN
	F2010.B.125.Z08.04.R759M	125	135	40	63	4	8	3,5	8	XN . U0705 .. XNGX0705ANN
Parallel bore DIN 138 transverse keyway 	F2010.B.160.Z10.04.R759M	160	170	40/40 B	63	4	10	5,5	10	XN . U0705 .. XNGX0705ANN
	F2010.B.200.Z12.04.R759M	200	210	60/50 B	63	4	12	8,3	12	
	F2010.B.250.Z12.04.R759M	250	260	60/50 B	63	4	12	14,7	12	
	F2010.B.250.Z16.04.R759M	250	260	60/50 B	63	4	16	16,4	16	
Parallel bore DIN 138 transverse keyway 	F2010.B.315.Z14.04.R759M	315	325	60/50-60 BB	80	4	14	26,3	14	XN . U0705 .. XNGX0705ANN
	F2010.B.315.Z18.04.R759M	315	325	60/50-60 BB	80	4	18	26,2	18	

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

C 2

Assembly parts

		D _c [mm]	80–315
	Cartridge for tool body		FR759M
	Clamping screw for cartridge Tightening torque		FS247 (SW 4) 8,0 Nm
	Clamping screw for indexable insert Tightening torque		FS2119 (Torx 15IP) 3,0 Nm
	Adjusting pin		FS303 (Torx 20)

Accessories

		D _c [mm]	80–315
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
	Interchangeable blade for indexable insert		FS2014 (Torx 15IP)
	Torque T-handle Tightening torque		FS2041 4,5–14 Nm
	Screwdriver for indexable insert		FS1485 (Torx 15IP)
	Screwdriver for adjusting pin		FS228 (Torx 20)
	Interchangeable blade for cartridge		FS2051 (SW 4)
	ISO 2936 Allen key for cartridge		ISO2936-4 (SW 4)

Indexable inserts

Designation	r mm	b mm	P				M			K				N		S			H	O	
			HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S	WHH15	WXM15
	XNGU0705ANN-F57	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕							
	XNGU0705ANN-F67	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕							
	XNGX0705ANN-F67		5,7							⊕										⊕	⊕
	XNMU070508-F57	0,8		⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕			⊕				
	XNMU0705ANN-F27	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕			⊕				
	XNMU0705ANN-F57	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕			⊕				
	XNMU0705ANN-F67	0,8	1,1	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕			⊕	⊕			

XNGX0705ANN-F67 wiper insert only in combination with XNGU0705ANN . .

HC = Coated carbide
HW = Uncoated carbide

C 2

Heptagon face milling cutters

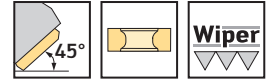
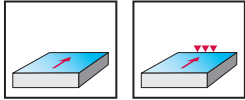
M3024

XN . U0705 ..

Walter BLAXX



- 14 cutting edges per indexable insert



	P	M	K	N	S	H	O
M3024	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3024-040-B16-03-04	40	50	16	40	4	3	0,5	3	XN . U0705 .. XNGX0705ANN
	M3024-050-B22-04-04	50	60	22	40	4	4	0,5	4	
	M3024-050-B22-05-04	50	60	22	40	4	5	0,5	5	
	M3024-063-B22-05-04	63	73	22	40	4	5	0,8	5	
	M3024-063-B22-06-04	63	73	22	40	4	6	0,8	6	
	M3024-080-B27-06-04	80	90	27	50	4	6	1,5	6	
	M3024-080-B27-07-04	80	90	27	50	4	7	1,5	7	
	M3024-100-B32-07-04	100	110	32	50	4	7	2,7	7	
	M3024-100-B32-08-04	100	110	32	50	4	8	2,7	8	
	M3024-125-B40-08-04	125	135	40	63	4	8	4,3	8	
M3024-125-B40-10-04	125	135	40	63	4	10	4,3	10		
Parallel bore DIN 138 transverse keyway 	M3024-160-B40-09-04	160	170	40/40 B	63	4	9	6,5	9	XN . U0705 .. XNGX0705ANN
	M3024-160-B40-12-04	160	170	40/40 B	63	4	12	6,5	12	

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

Assembly parts

D _c [mm]		40–160
	Shim for indexable insert	AP800-XN0705 H81
	Clamping screw for shim	FS2068 (SW 3,5)
	Clamping screw for indexable insert Tightening torque	FS2279 (Torx 15IP) 3,0 Nm

Accessories

D _c [mm]		40–125	160
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)	FS1485 (Torx 15IP)
	Key for screw for shim	ISO2936-3,5 (SW 3,5)	ISO2936-3,5 (SW 3,5)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

Designation	r mm	b mm	P			M			K			N		S			H	O
			HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC		
	XNGU0705ANN-F57	0,8	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNGU0705ANN-F67	0,8	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNGX0705ANN-F67		5,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNMMU070508-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNMMU0705ANN-F27	0,8	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNMMU0705ANN-F57	0,8	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	XNMMU0705ANN-F67	0,8	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

XNGX0705ANN-F67 wiper insert only in combination with XNGU0705ANN . .

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

• Other application

C 2

Heptagon face milling cutters

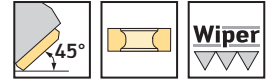
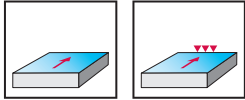
M3024 inch

XN . U0705 ..

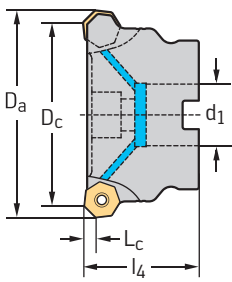
Walter BLAXX



– 14 cutting edges per indexable insert



	P	M	K	N	S	H	O
M3024	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3024.051-B19-04-04	2,000	2,386	0,750	1,575	0,157	4	1,3	4	XN . U0705 .. XNGX0705ANN
	M3024.064-B26-06-04	2,500	2,886	1,000	1,575	0,157	6	1,8	6	
	M3024.076-B26-07-04	3,000	3,386	1,000	1,969	0,157	7	3,0	7	
	M3024.102-B31-08-04	4,000	4,386	1,250	1,969	0,157	8	4,8	8	
	M3024.127-B38-10-04	5,000	5,386	1,500	2,480	0,157	10	9,9	10	
	M3024.152-B38-12-04	6,000	6,386	1,500	2,480	0,157	12	15,7	12	

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

Assembly parts		D _c [inch]	2,000	2,500–3,000	4,000	5,000–6,000
	Shim for indexable insert		AP800-XN0705 H81	AP800-XN0705 H81	AP800-XN0705 H81	AP800-XN0705 H81
	Clamping screw for shim		FS2068 (SW 3,5)	FS2068 (SW 3,5)	FS2068 (SW 3,5)	FS2068 (SW 3,5)
	Clamping screw for indexable insert		FS2279 (Torx 15IP)	FS2279 (Torx 15IP)	FS2279 (Torx 15IP)	FS2279 (Torx 15IP)
	Tightening torque		3,0 Nm	3,0 Nm	3,0 Nm	3,0 Nm
	Clamping screw for arbour-mounted tools			FS1519	FS1339	FS1583

Accessories		D _c [inch]	2,000–6,000
	Torque screwdriver, analogue		FS2004
	Tightening torque		1,5–5,0 Nm
	Torque screwdriver, digital		FS2248
	Tightening torque		1,0–6,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)
	Screwdriver		FS1485 (Torx 15IP)
	Key for screw for shim		ISO2936-3,5 (SW 3,5)

Designation	r mm	b mm	P			M			K				N		S			H	O		
			HC	HC	HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC					
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S	WHH15	WXM15
	XNGU0705ANN-F57	0,8	1,1	☉	☉	☉	☉	☉	☉			☉	☉	☉							
	XNGU0705ANN-F67	0,8	1,1	☉	☉	☉	☉	☉	☉			☉	☉	☉							
	XNGX0705ANN-F67		5,7							☉										☉	☉
	XNMU070508-F57	0,8		☉	☉	☉	☉	☉	☉			☉	☉	☉			☉				
	XNMU0705ANN-F27	0,8	1,1	☉	☉	☉	☉	☉	☉			☉	☉	☉			☉				
	XNMU0705ANN-F57	0,8	1,1	☉	☉	☉	☉	☉	☉			☉	☉	☉			☉				
	XNMU0705ANN-F67	0,8	1,1	☉	☉	☉	☉	☉	☉			☉	☉	☉			☉	☉			

XNGX0705ANN-F67 wiper insert only in combination with XNGU0705ANN . .

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☹️
Very good

😊
Good

😐
Moderate

☉☉ Primary application

☉ Other application

Heptagon face milling cutters

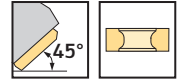
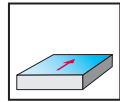
M3024

XNMU0906 ..

Walter BLAXX



- 14 cutting edges per indexable insert



	P	M	K	N	S	H	O
M3024	●●	●●	●●	●	●●	●	●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3024-063-B22-05-06	63	76	22	40	6	5	0,6	5	XNMU0906 ..
	M3024-080-B27-06-06	80	93	27	50	6	6	1,4	6	
	M3024-100-B32-07-06	100	113	32	50	6	7	2,7	7	
	M3024-125-B40-08-06	125	138	40	63	6	8	4,2	8	
Parallel bore DIN 138 transverse keyway 	M3024-160-B40-09-06	160	173	40/40 B	63	6	9	6,5	9	XNMU0906 ..

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

Assembly parts

D _c [mm]		63–160
	Shim for indexable insert	AP800-XN0906 H81
	Clamping screw for shim	FS2091 (SW 5)
	Clamping screw for indexable insert Tightening torque	FS2112 (Torx 20IP) 5,0 Nm

Accessories

D _c [mm]		63–125	160
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2015 (Torx 20IP)	FS2015 (Torx 20IP)
	Screwdriver	FS1486 (Torx 20IP)	FS1486 (Torx 20IP)
	Key for screw for shim	ISO2936-5 (SW 5)	ISO2936-5 (SW 5)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S			
			HC				HC		HC				HC	HW	HC			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
XNMU090612-F57	1,2		☺	☺	☺	☺		☺		☺	☺	☺	☺					
XNMU0906ANN-F27	0,8	1,4	☺	☺	☺	☺			☺	☺	☺	☺						
XNMU0906ANN-F57	0,8	1,4	☺	☺	☺	☺	☺		☺	☺	☺	☺				☺		
XNMU0906ANN-F67	0,8	1,4	☺	☺	☺		☺		☺	☺	☺						☺	

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

• Other application

Heptagon face milling cutters

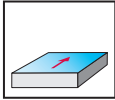
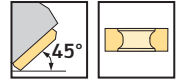
M3024 inch

XNMU0906 ..

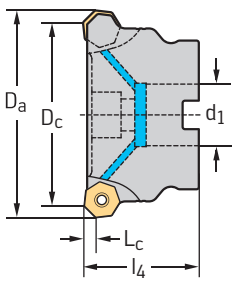
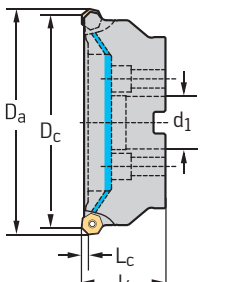
Walter BLAXX



- 14 cutting edges per indexable insert



	P	M	K	N	S	H	O
M3024	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3024.064-B26-05-06	2,500	3,006	1,000	1,575	0,236	5	1,8	5	XNMU0906 ..
	M3024.076-B26-06-06	3,000	3,506	1,000	1,969	0,236	6	2,9	6	
	M3024.102-B31-07-06	4,000	4,506	1,250	1,969	0,236	7	6,2	7	
	M3024.127-B38-08-06	5,000	5,506	1,500	2,480	0,236	8	9,8	8	
Parallel bore DIN 138 transverse keyway 	M3024.152-B38-09-06	6,000	6,506	1,500	2,480	0,236	9	15,7	9	XNMU0906 ..

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

Assembly parts

D _c [inch]	2,500	3,000	4,000	5,000–6,000
	AP800-XN0906 H81	AP800-XN0906 H81	AP800-XN0906 H81	AP800-XN0906 H81
	FS2091 (SW 5)	FS2091 (SW 5)	FS2091 (SW 5)	FS2091 (SW 5)
	FS2112 (Torx 20IP) Tightening torque 5,0 Nm	FS2112 (Torx 20IP) Tightening torque 5,0 Nm	FS2112 (Torx 20IP) Tightening torque 5,0 Nm	FS2112 (Torx 20IP) Tightening torque 5,0 Nm
	FS1586	FS1519	FS1339	FS1583

Accessories

D _c [inch]	2,500–6,000
	FS2004 Tightening torque 1,5–5,0 Nm
	FS2248 Tightening torque 1,0–6,0 Nm
	FS2015 (Torx 20IP)
	FS1486 (Torx 20IP)
	ISO2936-5 (SW 5)

Indexable inserts

Designation	r mm	b mm	P				M			K				N		S		
			HC				HC			HC				HC	HW	HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
XNMU090612-F57	1,2		☺	☺	☺	☺			☺									
XNMU0906ANN-F27	0,8	1,4	☺	☺	☺	☺				☺	☺	☺	☺					
XNMU0906ANN-F57	0,8	1,4	☺	☺	☺	☺	☺		☺							☺		
XNMU0906ANN-F67	0,8	1,4	☺	☺	☺	☺			☺									☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

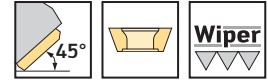
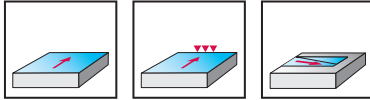
Face milling cutters

M4003 mm

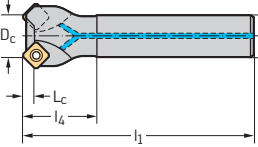
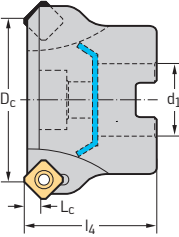
SD .. 09T3AZN



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4003	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel shank 	M4003-020-A20-02-4.5	20	20	35	110	4,5	2	0,3	2	SD .. 09T3AZN SDHX09T3AZR
	M4003-025-A25-03-4.5	25	25	35	110	4,5	3	0,5	3	
	M4003-032-A32-04-4.5	32	32	35	110	4,5	4	0,7	4	
Parallel bore DIN 138 transverse keyway 	M4003-032-B16-04-4.5	32	16	40		4,5	4	0,3	4	SD .. 09T3AZN SDHX09T3AZR
	M4003-032-B16-05-4.5	32	16	40		4,5	5	0,3	5	
	M4003-040-B16-04-4.5	40	16	40		4,5	4	0,4	4	
	M4003-040-B16-06-4.5	40	16	40		4,5	6	0,3	6	
	M4003-050-B22-06-4.5	50	22	40		4,5	6	0,5	6	
	M4003-050-B22-08-4.5	50	22	40		4,5	8	0,5	8	
	M4003-063-B22-07-4.5	63	22	40		4,5	7	0,7	7	
	M4003-063-B22-10-4.5	63	22	40		4,5	10	0,7	10	
	M4003-080-B27-08-4.5	80	27	50		4,5	8	1,3	8	
	M4003-080-B27-12-4.5	80	27	50		4,5	12	1,1	12	
	M4003-100-B32-09-4.5	100	32	50		4,5	9	2,0	9	
M4003-100-B32-14-4.5	100	32	50		4,5	14	2,0	14		

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

Assembly parts

D _c [mm]		20–100
	Clamping screw for indexable insert Tightening torque	FS2266 (Torx 10IP) 2,0 Nm

Accessories

D _c [mm]		20–100
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2268 (Torx 10IP)
	Screwdriver	FS2267 (Torx 10IP)

Indexable inserts

Designation	r mm	b mm	HT		P					M			K				N		S			H	O	
			WEP20	WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WYN15	WK10	WSM35S	WSM45X	WSP45S	WHH15	WXM15		
SDHX09T3AZR-A88		5,6												☺									☺	☺
SDET09T3AZN-F57	0,3	1,4	☺																					
SDGT09T3AZN-F57	0,3	1,4		☺	☺	☺	☺	☺	☺					☺										
SDGT09T3AZN-G77	0,3	1,2																						
SDHT09T3AZN-G88	0,3	1,2																	☺	☺				
SDMT09T3AZN-D57	0,3	1,2		☺	☺	☺	☺	☺	☺					☺	☺	☺	☺	☺						
SDMT09T3AZN-F57	0,3	1,4		☺	☺	☺	☺	☺	☺					☺	☺	☺	☺	☺						
SDMW09T3AZN-A57	0,3	1,2		☺	☺	☺	☺	☺	☺					☺										

HT = Cermet
 HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

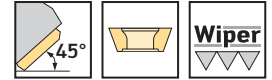
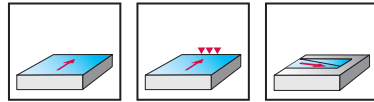
Face milling cutters

M4003 mm

SD .. 1204AZN



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4003	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel shank 	M4003-025-A25-02-6.5	25	25	35	110	6,5	2	0,5	2	SD .. 1204AZN SDHX1204AZR
	M4003-032-A32-03-6.5	32	32	35	110	6,5	3	0,7	3	
	M4003-040-A32-04-6.5	40	32	35	110	6,5	4	0,9	4	
Parallel bore DIN 138 transverse keyway 	M4003-040-B16-03-6.5	40	16	40		6,5	3	0,4	3	SD .. 1204AZN SDHX1204AZR
	M4003-040-B16-04-6.5	40	16	40		6,5	4	0,4	4	
	M4003-050-B22-04-6.5	50	22	40		6,5	4	0,5	4	
	M4003-050-B22-05-6.5	50	22	40		6,5	5	0,5	5	
	M4003-063-B22-05-6.5	63	22	40		6,5	5	0,7	5	
	M4003-063-B22-07-6.5	63	22	40		6,5	7	0,6	7	
	M4003-080-B27-06-6.5	80	27	50		6,5	6	1,2	6	
	M4003-080-B27-09-6.5	80	27	50		6,5	9	1,3	9	
	M4003-100-B32-07-6.5	100	32	50		6,5	7	2,1	7	
	M4003-100-B32-11-6.5	100	32	50		6,5	11	2,0	11	
	M4003-125-B40-08-6.5	125	40	63		6,5	8	3,4	8	
M4003-125-B40-13-6.5	125	40	63		6,5	13	3,4	13		
Parallel bore DIN 138 transverse keyway 	M4003-160-B40-09-6.5	160	40/40 B	63		6,5	9	4,3	9	SD .. 1204AZN SDHX1204AZR
	M4003-160-B40-15-6.5	160	40/40 B	63		6,5	15	4,3	15	

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

/ ★ New addition to the product range

Assembly parts

D _c [mm]	25-160	
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm

Accessories

D _c [mm]	25-125	160	
	Torque screwdriver, analogue Tightening torque	FS2003 1,5-5,0 Nm	FS2003 1,5-5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0-6,0 Nm	FS2248 1,0-6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)	FS1485 (Torx 15IP)
	Sealing disc set (incl. gasket and screws)	FS936 COMPLETE SET	
	Gasket	O-R 96X4	

Indexable inserts

Designation	r mm	b mm	P		M			K				N		S			H	O					
			HT	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC									
			WEP20	WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S	WHH15	WXM15	
SDHX1204AZR-A88		7,5									⊕											⊕	⊕
SDET1204AZN-F57	0,3	1,8	⊕																				
SDGT1204AZN-F57	0,3	1,8		⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕	⊕	⊕			⊕		⊕			
SDGT1204AZN-G77	0,3	1,4					⊕			⊕											⊕		
SDHT1204AZN-G88	0,3	1,4													⊕	⊕							
SDMT1204AZN-D57	0,3	1,4		⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕	⊕	⊕			⊕		⊕			
SDMT1204AZN-F57	0,3	1,8		⊕	⊕	⊕	⊕		⊕	⊕		⊕	⊕	⊕	⊕				⊕	⊕			
SDMW1204AZN-A57	0,3	1,4		⊕	⊕	⊕					⊕	⊕	⊕	⊕	⊕								

HT = Cermet
 HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

•• Primary application

• Other application

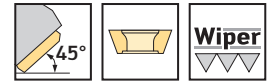
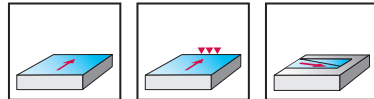
Face milling cutters

M4003 inch

SD .. 09T3AZN



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4003	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel shank 	M4003.019-A19-02-4.5	0,750	0,750	1,378	4,331	0,177	2	0,6	2	SD .. 09T3AZN SDHX09T3AZR
	M4003.026-A26-03-4.5	1,000	1,000	1,378	4,331	0,177	3	1,1	3	
	M4003.031-A31-04-4.5	1,250	1,250	1,378	4,331	0,177	4	1,6	4	
Parallel bore DIN 138 transverse keyway 	M4003.031-B13-04-4.5	1,250	1/2	1,575		0,177	4	0,5	4	SD .. 09T3AZN SDHX09T3AZR
	M4003.038-B19-04-4.5	1,500	3/4	1,575		0,177	4	0,7	4	
	M4003.051-B19-06-4.5	2,000	3/4	1,575		0,177	6	1,1	6	
	M4003.064-B26-07-4.5	2,500	1,000	1,969		0,177	7	1,9	7	
	M4003.076-B26-08-4.5	3,000	1,000	1,969		0,177	8	2,6	8	
	M4003.102-B38-09-4.5	4,000	1 1/2	2,480		0,177	9	6,4	9	

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

Assembly parts

D _c [inch]	0,750–2,000	1,500	2,500–3,000	4,000
	Clamping screw for indexable insert Tightening torque FS2266 (Torx 10IP) 2,0 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS2266 (Torx 10IP) 2,0 Nm
	Clamping screw for arbour-mounted tools	FS1523	FS1519	FS1583

Accessories

D _c [inch]	0,750–4,000
	Torque screwdriver, analogue Tightening torque FS2004 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque FS2248 1,0–6,0 Nm
	Interchangeable blade FS2268 (Torx 10IP)
	Screwdriver FS2267 (Torx 10IP)

Indexable inserts

Designation	r mm	b mm	P		M			K			N		S			H	O	
			HT	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC			
SDHX09T3AZR-A88		5,6	☹														☹	☹
SDET09T3AZN-F57	0,3	1,4	☹															
SDGT09T3AZN-F57	0,3	1,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
SDGT09T3AZN-G77	0,3	1,2				☺												
SDHT09T3AZN-G88	0,3	1,2										☺	☺					
SDMT09T3AZN-D57	0,3	1,2		☺	☺	☺	☺	☺	☺	☺	☺			☺				
SDMT09T3AZN-F57	0,3	1,4		☺	☺	☺	☺	☺	☺	☺	☺			☺	☺			
SDMW09T3AZN-A57	0,3	1,2		☺	☺	☺	☺	☺	☺	☺	☺			☺	☺			

HT = Cermet
 HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

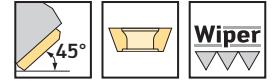
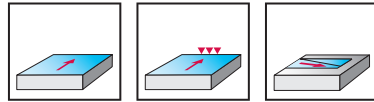
Face milling cutters

M4003 inch

SD .. 1204AZN



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4003	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel shank 	M4003.026-A26-02-6.5	1,000	1,000	1,378	4,331	0,256	2	1,1	2	SD .. 1204AZN SDHX1204AZR
	M4003.031-A31-03-6.5	1,250	1,250	1,378	4,331	0,256	3	1,6	3	
	M4003.038-A31-04-6.5	1,500	1,250	1,378	4,331	0,256	4	1,8	4	
Parallel bore DIN 138 transverse keyway 	M4003.038-B19-03-6.5	1,500	3/4	1,575		0,256	3	0,7	3	SD .. 1204AZN SDHX1204AZR
	M4003.051-B19-04-6.5	2,000	3/4	1,575		0,256	4	1,1	4	
	M4003.064-B26-05-6.5	2,500	1,000	1,969		0,256	5	1,9	5	
	M4003.076-B26-06-6.5	3,000	1,000	1,969		0,256	6	2,7	6	
	M4003.102-B38-07-6.5	4,000	1 1/2	2,480		0,256	7	6,9	7	
	M4003.127-B38-08-6.5	5,000	1 1/2	2,480		0,256	8	8,3	8	
	M4003.152-B38-09-6.5	6,000	1 1/2	2,480		0,256	9	11,4	9	

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

Assembly parts

D _c [inch]	1,000–2,000	2,500–3,000	4,000–6,000
Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
Clamping screw for arbour-mounted tools		FS1519	FS1583

Accessories

D _c [inch]	1,000–6,000
Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2014 (Torx 15IP)
Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P		M			K			N		S			H	O
			HT	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC			
SDHX1204AZR-A88		7,5															
SDET1204AZN-F57	0,3	1,8	☹														
SDGT1204AZN-F57	0,3	1,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDGT1204AZN-G77	0,3	1,4			☺		☺								☺		
SDHT1204AZN-G88	0,3	1,4					☺				☺	☺					
SDMT1204AZN-D57	0,3	1,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT1204AZN-F57	0,3	1,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW1204AZN-A57	0,3	1,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HT = Cermet
 HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

••
Primary application

•
Other application

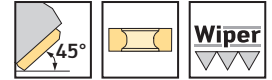
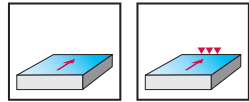
Face milling cutters

M5009 mm

SN.X0904 ..
Xtra-tec® XT



– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	M5009-025-T22-03-05	25	T22	35	5	3	0,1	3	SNMX090408 SN . X0904ANN XNGX0904ANN
	M5009-032-T28-04-05	32	T28	40	5	4	0,2	4	
	M5009-032-T28-05-05	32	T28	40	5	5	0,2	5	
	M5009-040-T36-04-05	40	T36	40	5	4	0,4	4	
	M5009-040-T36-06-05	40	T36	40	5	6	0,4	6	
Parallel bore DIN 138 transverse keyway 	M5009-040-B16-04-05	40	16	40	5	4	0,3	4	SNMX090408 SN . X0904ANN XNGX0904ANN
	M5009-040-B16-06-05	40	16	40	5	6	0,3	6	
	M5009-050-B22-06-05	50	22	40	5	6	0,4	6	
	M5009-050-B22-08-05	50	22	40	5	8	0,4	8	
	M5009-063-B22-07-05	63	22	40	5	7	0,6	7	
	M5009-063-B22-09-05	63	22	40	5	9	0,6	9	
	M5009-080-B27-08-05	80	27	50	5	8	1,4	8	
	M5009-080-B27-11-05	80	27	50	5	11	1,4	11	
	M5009-100-B32-09-05	100	32	50	5	9	1,9	9	
	M5009-100-B32-13-05	100	32	50	5	13	1,8	13	

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

Assembly parts

	D_c [mm]	25–100
	Clamping screw for indexable insert Tightening torque	FS2579 (Torx 8IP) 1,2 Nm

Accessories

	D_c [mm]	25–100
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2012 (Torx 8IP)
	Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S		H	O
			HC				HC		HC				HC	HW	HC		HC	HC
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15
SNHX0904ANN-K88		1,5										☉	☉					
SNGX0904ANN-F57		1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉			
SNMX0904ANN-F57		1,2	☉	☉	☉				☉	☉	☉	☉						
SNMX0904ANN-F27		1,2	☉	☉	☉				☉	☉	☉	☉						
SNGX0904ANN-F67		1,2	☉	☉	☉	☉	☉	☉	☉	☉	☉			☉	☉			
SNMX0904ANN-F67		1,2	☉	☉	☉			☉	☉	☉	☉							
SNMX090408-F57	0,8		☉	☉	☉	☉	☉		☉	☉	☉	☉			☉	☉		
SNMX090408-F67	0,8		☉	☉	☉	☉	☉		☉	☉	☉	☉			☉	☉		
SNMX090408-F27	0,8		☉	☉	☉				☉	☉	☉	☉						
XNGX0904ANN-F67		5						☉									☉	☉

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

●● Primary application

● Other application

Face milling cutters

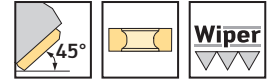
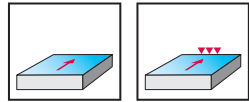
M5009 inch

SN.X0904 ..

Xtra-tec® XT



– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	M5009.026-T22-03-05	1,000	T22	1,378	0,197	3	0,3	3	SNMX090408 SN . X0904ANN XNGX0904ANN
	M5009.031-T28-04-05	1,250	T28	1,575	0,197	4	0,5	4	
	M5009.031-T28-05-05	1,250	T28	1,575	0,197	5	0,5	5	
	M5009.038-T36-04-05	1,500	T36	1,575	0,197	4	0,9	4	
	M5009.038-T36-06-05	1,500	T36	1,575	0,197	6	0,8	6	
Parallel bore DIN 138 transverse keyway 	M5009.038-B19-04-05	1,500	0,750	1,500	0,197	4	0,6	4	SNMX090408 SN . X0904ANN XNGX0904ANN
	M5009.038-B19-06-05	1,500	0,750	1,500	0,197	6	0,6	6	
	M5009.051-B19-06-05	2,000	0,750	1,500	0,197	6	0,9	6	
	M5009.051-B19-08-05	2,000	0,750	1,500	0,197	8	0,9	8	
	M5009.064-B26-07-05	2,500	1,000	2,000	0,197	7	1,9	7	
	M5009.064-B26-09-05	2,500	1,000	2,000	0,197	10	1,8	10	
	M5009.076-B26-08-05	3,000	1,000	2,000	0,197	8	2,4	8	
	M5009.076-B26-11-05	3,000	1,000	2,000	0,197	11	22,2	11	
	M5009.102-B38-09-05	4,000	1,500	2,500	0,197	9	6,5	9	
	M5009.102-B38-13-05	4,000	1,500	2,500	0,197	13	6,5	13	

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

Assembly parts

D _c [inch]	1,000–2,000	2,500–3,000	4,000
Clamping screw for indexable insert Tightening torque	FS2579 (Torx 8IP) 1,2 Nm	FS2579 (Torx 8IP) 1,2 Nm	FS2579 (Torx 8IP) 1,2 Nm
Clamping screw for arbour-mounted tools		FS1519	FS1583

Accessories

D _c [inch]	1,000–4,000
Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm
Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2012 (Torx 8IP)
Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	r mm	b mm	P				M		K			N		S		H	O
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
SNHX0904ANN-K88		1,5										☺	☺				
SNGX0904ANN-F57		1,2	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺		☺	☺	
SNMX0904ANN-F57		1,2	☺	☺	☺					☺	☺	☺	☺				
SNMX0904ANN-F27		1,2	☺	☺	☺					☺	☺	☺	☺				
SNGX0904ANN-F67		1,2	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺		☺	☺	
SNMX0904ANN-F67		1,2	☺	☺	☺				☺	☺	☺	☺	☺				
SNMX090408-F57	0,8		☺	☺	☺	☺	☺	☺		☺	☺	☺	☺		☺	☺	
SNMX090408-F67	0,8		☺	☺	☺	☺	☺	☺		☺	☺	☺	☺		☺	☺	
SNMX090408-F27	0,8		☺	☺	☺					☺	☺	☺	☺				
XNGX0904ANN-F67		5							☺							☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

Face milling cutters

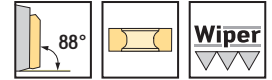
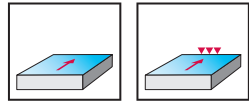
M5012 mm

SN.X0904 ..

Xtra-tec® XT



– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M5012	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
ScrewFit	★ M5012-032-T28-03-08	32	T28	40	8	3	0,2	3	SNMX090408
	★ M5012-040-T36-04-08	40	T36	40	8	4	0,4	4	SN . X0904ZNN XNGX0904ZNN
Parallel bore DIN 138 transverse keyway	★ M5012-040-B16-04-08	40	16	40	8	4	0,2	4	SNMX090408 SN . X0904ZNN XNGX0904ZNN
	★ M5012-050-B22-05-08	50	22	40	8	5	0,4	5	
	★ M5012-050-B22-06-08	50	22	40	8	6	0,4	6	
	★ M5012-063-B22-06-08	63	22	40	8	6	0,5	6	
	★ M5012-063-B22-08-08	63	22	40	8	8	0,5	8	
	★ M5012-063-B27-06-08	63	27	40	8	6	0,6	6	
	★ M5012-063-B27-08-08	63	27	40	8	8	0,6	8	
	★ M5012-080-B27-07-08	80	27	50	8	7	1,1	7	
	★ M5012-080-B27-10-08	80	27	50	8	10	1,1	10	
	★ M5012-100-B32-08-08	100	32	50	8	8	1,8	8	
	★ M5012-100-B32-12-08	100	32	50	8	12	1,8	12	

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

Assembly parts

	D_c [mm]	32–100
	Clamping screw for indexable insert Tightening torque	FS2579 (Torx 8IP) 1,2 Nm

Accessories

	D_c [mm]	32–100
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2012 (Torx 8IP)
	Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	r mm	b mm	P		M		K			N		S		H	O		
			HC		HC		HC			HC	HW	HC		HC	HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
SNGX0904ZNN-F57		1	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNMX0904ZNN-F57		1	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNGX0904ZNN-F67		1	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNMX0904ZNN-F67		1	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNMX0904ZNN-F27		1	⊕	⊕	⊕			⊕	⊕	⊕	⊕			⊕	⊕		
SNHX0904ZNN-K88		1									⊕	⊕					
SNMX090408-F57	0,8		⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNMX090408-F67	0,8		⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
SNMX090408-F27	0,8		⊕	⊕	⊕			⊕	⊕	⊕	⊕			⊕	⊕		
XNGX0904ZNN-F67		3,5						⊕								⊕	⊕

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

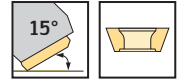
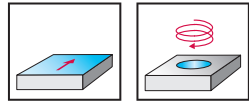
●● Primary application

● Other application

High-feed milling cutters

F2010 mm
SDM . 1204 ..


- Adjustable runout
- Four cutting edges per indexable insert



	P	M	K	N	S	H	O
F2010	●●	●●	●●	●●	●●	●●	●

Tool	Designation	D _c mm	D _a * mm	d ₁ mm	l ₄ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type	
Parallel bore DIN 138 transverse keyway 	F2010.B.080.Z06.08.R755M	70	93	27	50	2	11,4	6	1,3	6	SDM . 1204 ..	
Parallel bore DIN 138 transverse keyway 	F2010.B.100.Z07.08.R755M	90	113	32	50	2	11,4	7	1,9	7	SDM . 1204 ..	
	F2010.B.125.Z08.08.R755M	115	138	40	63	2	11,4	8	3,6	8		
Parallel bore DIN 138 transverse keyway 	F2010.B.160.Z10.08.R755M	150	173	40/40 B	63	2	11,4	10	5,6	10	SDM . 1204 ..	
	F2010.B.200.Z12.08.R755M	190	213	60/50 B	63	2	11,4	12	9,9	12		
	F2010.B.250.Z12.08.R755M	240	263	60/50 B	63	2	11,4	12	14,8	12		
	F2010.B.250.Z16.08.R755M	240	263	60/50 B	63	2	11,4	16	14,6	16		
Parallel bore DIN 138 transverse keyway 	F2010.B.315.Z14.08.R755M	305	328	60/50-60 BB	80	2	11,4	14	26,3	14	SDM . 1204 ..	
	F2010.B.315.Z18.08.R755M	305	328	60/50-60 BB	80	2	11,4	18	26,2	18		

* Measured against SDM.120408

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

Assembly parts

		D _c [mm]	70–305
	Cartridge for tool body		FR755M
	Clamping screw for cartridge Tightening torque		FS247 (SW 4) 8,0 Nm
	Clamping screw for indexable insert Tightening torque		FS1453 (Torx 15IP) 3,5 Nm
	Adjusting pin		FS303 (Torx 20)

Accessories

		D _c [mm]	70–305
	Torque screwdriver, analogue Tightening torque		FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
	Interchangeable blade for indexable insert		FS2014 (Torx 15IP)
	Torque T-handle Tightening torque		FS2041 4,5–14 Nm
	Interchangeable blade for cartridge		FS2051 (SW 4)
	Screwdriver for indexable insert		FS1485 (Torx 15IP)
	Screwdriver for adjusting pin		FS228 (Torx 20)
	ISO 2936 Allen key for cartridge		ISO2936-4 (SW 4)

Indexable inserts

Designation	r mm	b mm	P			M			K			S				
			HC			HC			HC			HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X
SDMT1204ZDR-D57	0,8	1,8	☒	☒	☒						☒	☒				☒
SDMT120408-D57	0,8		☒	☒	☒	☒	☒			☒	☒	☒	☒			☒
SDMT120408-F57	0,8		☒	☒	☒	☒	☒	☒	☒		☒	☒	☒			☒
SDMT120425-F57	2,5										☒	☒	☒			☒
SDMW120408-A57	0,8		☒	☒	☒						☒	☒	☒			☒
SDMW120425-A57	2,5										☒	☒	☒			☒

SD..1204... : If the corner radius is r > 0.8 mm, the corner area of the cartridge must be reworked.

HC = Coated carbide

R_(body) = r_(indexable insert)

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

• Other application

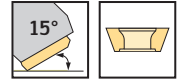
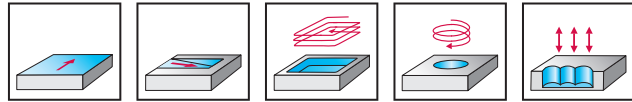
C 2

High-feed milling cutters

M4002 mm



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4002	●	●	●	●	●	●	●

Tool	Designation	D _c mm	D _a * mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	M4002-020-T18-02-01	8	20	T18	30		1	5,7	2	0,1	2	SD .. 06T2 ..
	M4002-025-T22-02-01,5	8	25	T22	40		1,5	8,4	2	0,1	2	SD .. 09T3 ..
	M4002-025-T22-03-01	13	25	T22	35		1	5,7	3	0,1	3	SD .. 06T2 ..
	M4002-032-T28-03-01,5	15	32	T28	40		1,5	8,4	3	0,2	3	SD .. 09T3 ..
	M4002-032-T28-04-01	20	32	T28	40		1	5,7	4	0,2	4	SD .. 06T2 ..
	M4002-035-T28-03-01,5	18	35	T28	40		1,5	8,4	3	0,2	3	SD .. 09T3 ..
	M4002-035-T28-03-01	23	35	T28	40		1	5,7	3	0,2	3	SD .. 06T2 ..
	M4002-035-T28-04-01	23	35	T28	40		1	5,7	4	0,2	4	SD .. 06T2 ..
	M4002-040-T36-04-01,5	23	40	T36	40		1,5	8,4	4	0,3	4	SD .. 09T3 ..
	M4002-040-T36-05-01	28	40	T36	40		1	5,7	5	0,4	5	SD .. 06T2 ..
	M4002-042-T36-03-01,5	25	42	T36	40		1,5	8,4	3	0,3	3	SD .. 09T3 ..
	M4002-042-T36-04-01	30	42	T36	40		1	5,7	4	0,4	4	SD .. 06T2 ..
M4002-042-T36-05-01	30	42	T36	40		1	5,7	5	0,4	5	SD .. 06T2 ..	
Cylindrical, modular 	★ M4002-020-TC10-02-01	8	20	M10	30		1	5,7	2	0,1	2	SD .. 06T2 ..
	★ M4002-025-TC12-02-01,5	8	25	M12	40		1,5	8,4	2	0,1	2	SD .. 09T3 ..
	★ M4002-025-TC12-03-01	13	25	M12	35		1	5,7	3	0,1	3	SD .. 06T2 ..
	★ M4002-032-TC16-03-01,5	15	32	M16	40		1,5	8,4	3	0,1	3	SD .. 09T3 ..
	★ M4002-032-TC16-04-01	20	32	M16	40		1	5,7	4	0,2	4	SD .. 06T2 ..
	★ M4002-035-TC16-03-01	18	35	M16	40		1	5,7	3	0,2	3	SD .. 06T2 ..
	★ M4002-035-TC16-04-01	18	35	M16	40		1	5,7	4	0,2	4	SD .. 06T2 ..
★ M4002-035-TC16-03-01,5	23	35	M16	40		1,5	8,4	3	0,2	3	SD .. 09T3 ..	
Parallel shank 	M4002-020-A20-02-01	8	20	20	30	200	1	5,7	2	0,5	2	
	M4002-025-A25-03-01	13	25	25	35	200	1	5,7	3	0,8	3	SD .. 06T2 ..
	M4002-032-A32-04-01	20	32	32	40	250	1	5,7	4	1,5	4	

* Measured using SDM.06T204, SDM.09T308, SDM.120408
 Bodies and assembly parts are included in the scope of delivery.

/ ★ New addition to the product range

Assembly parts

Type	SD .. 06T2 ..	SD .. 09T3 ..
 Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm

Accessories

Type	SD .. 06T2 ..	SD .. 09T3 ..
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)
 Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S				
			HC				HC		HC				HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
 SDMT06T2ZDR-D57 SDMT09T3ZDR-D57	0,4	1,2		☺	☺	☺			☺				☺	☺					☺
	0,8	1,2		☺	☺	☺			☺				☺	☺					☺
 SDHT06T204-G88 SDMT06T204-D57 SDMT06T204-F57 SDMT06T212-F57 SDMW06T204-A57 SDHT09T308-G88 SDMT09T308-D57 SDMT09T308-F57 SDMT09T320-F57 SDMW09T308-A57 SDMW09T320-A57	0,4														☺	☺			
	0,4		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺			☺		☺
	0,4		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺			☺	☺	☺
	1,2			☺	☺	☺	☺	☺	☺				☺	☺			☺	☺	☺
	0,4		☺	☺	☺							☺	☺	☺					☺
	0,8														☺	☺			
	0,8		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺			☺		☺
	0,8		☺	☺	☺	☺	☺	☺	☺	☺		☺	☺	☺			☺	☺	☺
	2			☺	☺	☺	☺	☺	☺								☺	☺	☺
	0,8		☺	☺	☺							☺	☺	☺					☺
	2			☺	☺	☺	☺	☺	☺		☺	☺	☺	☺				☺	☺

For SD..120425 indexable inserts, the circumference of the body must be reworked.
 $R_{(body)} = r_{(indexable\ insert)}$

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●●
Primary application

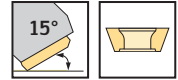
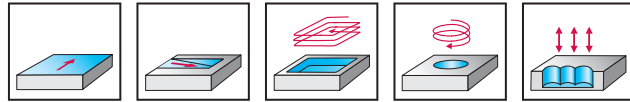
●
Other application

High-feed milling cutters

M4002 mm



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4002	●	●	●	●	●	●	●

Tool	Designation	D _c mm	D _a * mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M4002-040-B16-05-01	28	40	16	40		1	5,7	5	0,2	5	SD .. 06T2 ..
	M4002-042-B16-04-01,5	25	42	16	40		1,5	8,4	4	0,2	4	SD .. 09T3 ..
	M4002-042-B16-04-01	30	42	16	40		1	5,7	4	0,2	4	SD .. 06T2 ..
	M4002-042-B16-05-01	30	42	16	40		1	5,7	5	0,2	5	SD .. 06T2 ..
	M4002-050-B22-04-02	27	50	22	40		2	11,4	4	0,3	4	SD .. 1204 ..
	M4002-050-B22-05-02	27	50	22	40		2	11,4	5	0,3	5	SD .. 1204 ..
	M4002-050-B22-05-01,5	33	50	22	40		1,5	8,4	5	0,3	5	SD .. 09T3 ..
	M4002-050-B22-07-01	38	50	22	40		1	5,7	7	0,4	7	SD .. 06T2 ..
	M4002-052-B22-03-02	29	52	22	40		2	11,4	3	0,4	3	SD .. 1204 ..
	M4002-052-B22-04-02	29	52	22	40		2	11,4	4	0,3	4	SD .. 1204 ..
	M4002-052-B22-05-02	29	52	22	40		2	11,4	5	0,4	5	SD .. 1204 ..
	M4002-052-B22-04-01,5	35	52	22	40		1,5	8,4	4	0,4	4	SD .. 09T3 ..
	M4002-052-B22-05-01,5	35	52	22	40		1,5	8,4	5	0,4	5	SD .. 09T3 ..
	M4002-052-B22-06-01	40	52	22	40		1	5,7	6	0,4	6	SD .. 06T2 ..
	M4002-052-B22-07-01	40	52	22	40		1	5,7	7	0,4	7	SD .. 06T2 ..
	M4002-063-B22-05-02	40	63	22	40		2	11,4	5	0,6	5	SD .. 1204 ..
	M4002-063-B22-06-02	40	63	22	40		2	11,4	6	0,5	6	SD .. 1204 ..
	M4002-063-B22-06-01,5	46	63	22	50		1,5	8,4	6	0,8	6	SD .. 09T3 ..
	M4002-063-B22-08-01	51	63	22	40		1	5,7	8	0,6	8	SD .. 06T2 ..
	M4002-066-B27-04-02	43	66	27	50		2	11,4	4	0,8	4	SD .. 1204 ..
	M4002-066-B27-05-02	43	66	27	50		2	11,4	5	0,8	5	SD .. 1204 ..
	M4002-066-B27-06-02	43	66	27	50		2	11,4	6	0,8	6	SD .. 1204 ..
	M4002-066-B27-05-01,5	49	66	27	50		1,5	8,4	5	0,8	5	SD .. 09T3 ..
	M4002-066-B27-06-01,5	49	66	27	50		1,5	8,4	6	0,8	6	SD .. 09T3 ..
	M4002-066-B27-07-01	54	66	27	50		1	5,7	7	0,9	7	SD .. 06T2 ..
	M4002-066-B27-08-01	54	66	27	40		1	5,7	8	0,8	8	SD .. 06T2 ..
	M4002-080-B27-06-02	57	80	27	50		2	11,4	6	1,3	6	SD .. 1204 ..
	M4002-080-B27-08-02	57	80	27	50		2	11,4	8	1,3	8	SD .. 1204 ..
	M4002-085-B27-05-02	62	85	27	50		2	11,4	5	1,5	5	SD .. 1204 ..
	M4002-085-B27-06-02	62	85	27	50		2	11,4	6	1,4	6	SD .. 1204 ..
	M4002-085-B27-08-02	62	85	27	50		2	11,4	8	1,5	8	SD .. 1204 ..
	M4002-100-B32-07-02	77	100	32	60		2	11,4	7	2,6	7	SD .. 1204 ..
	M4002-100-B32-09-02	77	100	32	60		2	11,4	9	2,6	9	SD .. 1204 ..
M4002-125-B40-08-02	102	125	40	60		2	11,4	8	3,0	8	SD .. 1204 ..	

* Measured using SDM.06T204, SDM.09T308, SDM.120408
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

Type	SD .. 06T2 ..	SD .. 09T3 ..	SD .. 1204 ..
Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	SD .. 06T2 ..	SD .. 09T3 ..	SD .. 1204 ..
Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M		K			N		S					
			HC	HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HC	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
SDMT06T2ZDR-D57	0,4	1,2	☺	☺	☺	☺			☺										☺
SDMT09T3ZDR-D57	0,8	1,2	☺	☺	☺	☺			☺										☺
SDMT1204ZDR-D57	0,8	1,8	☺	☺	☺	☺			☺										☺
SDHT06T204-G88	0,4														☺	☺			
SDMT06T204-D57	0,4		☺	☺	☺	☺	☺		☺										☺
SDMT06T204-F57	0,4		☺	☺	☺	☺	☺	☺	☺										☺
SDMT06T212-F57	1,2		☺	☺	☺	☺	☺	☺	☺										☺
SDMW06T204-A57	0,4		☺	☺	☺														☺
SDHT09T308-G88	0,8														☺	☺			
SDMT09T308-D57	0,8		☺	☺	☺	☺	☺		☺										☺
SDMT09T308-F57	0,8		☺	☺	☺	☺	☺	☺	☺										☺
SDMT09T320-F57	2		☺	☺	☺	☺	☺	☺	☺										☺
SDMW09T308-A57	0,8		☺	☺	☺														☺
SDMW09T320-A57	2		☺	☺	☺														☺
SDHT120408-G88	0,8														☺	☺			
SDMT120408-D57	0,8		☺	☺	☺	☺	☺		☺										☺
SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺										☺
SDMT120425-F57	2,5		☺	☺	☺	☺	☺	☺	☺										☺
SDMW120408-A57	0,8		☺	☺	☺														☺
SDMW120425-A57	2,5		☺	☺	☺														☺

For SD..120425 indexable inserts, the circumference of the body must be reworked.
R_(body) = r_(indexable insert)

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●●
Primary application

●
Other application

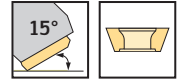
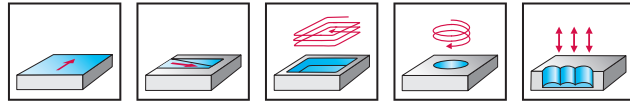
C 2

High-feed milling cutters

M4002 inch



– Four cutting edges per indexable insert



M4002	●	●	●	●	●	●	●
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Tool	Designation	D _c inch	D _a * inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	a _r inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	M4002.019-T18-02-01	0,291	0,750	0,728	1,181		0,039	0,224	2	0,1	2	SD .. 06T2 ..
	M4002.026-T22-02-01,5	0,339	1,000	0,866	1,575		0,059	0,331	2	0,0	2	SD .. 09T3 ..
	M4002.026-T22-03-01	0,543	1,000	0,866	1,378		0,039	0,224	3	0,2	3	SD .. 06T2 ..
	M4002.031-T28-03-01,5	0,593	1,250	1,102	1,575		0,059	0,331	3	0,4	3	SD .. 09T3 ..
	M4002.031-T28-04-01	0,795	1,250	1,102	1,575		0,039	0,224	4	0,5	4	SD .. 06T2 ..
	M4002.038-T36-04-01,5	0,843	1,500	1,417	1,575		0,059	0,331	4	0,6	4	SD .. 09T3 ..
	M4002.038-T36-05-01	1,043	1,500	1,417	1,575		0,039	0,224	5	0,8	5	SD .. 06T2 ..
Cylindrical, modular 	★ M4002.019-TC10-02-01	0,291	0,750	0,728	1,181		0,039	0,224	2	0,1	2	SD .. 06T2 ..
	★ M4002.026-TC12-02-01,5	0,334	1,000	0,866	1,575		0,059	0,331	2	0,2	2	SD .. 09T3 ..
	★ M4002.026-TC12-03-01	0,543	1,000	0,866	1,378		0,039	0,224	3	0,2	3	SD .. 06T2 ..
	★ M4002.031-TC16-03-01,5	0,584	1,250	1,102	1,575		0,059	0,331	3	0,3	3	SD .. 09T3 ..
	★ M4002.031-TC16-04-01	0,795	1,250	1,102	1,575		0,039	0,224	4	0,4	4	SD .. 06T2 ..
Parallel shank 	M4002.019-A19-02-01	0,291	0,750	0,750	1,181	7,874	0,039	0,224	2	0,9	2	SD .. 06T2 ..
	M4002.026-A26-03-01	0,543	1,000	1,000	1,378	7,874	0,039	0,224	3	1,7	3	
	M4002.031-A31-04-01	0,795	1,250	1,250	1,575	9,843	0,039	0,224	4	3,2	4	
Parallel bore DIN 138 transverse keyway 	M4002.038-B13-05-01	1,043	1,500	0,500	1,378		0,039	0,224	5	0,4	5	SD .. 06T2 ..
	M4002.051-B19-04-02	1,094	2,000	0,750	1,575		0,079	0,449	4	0,8	4	SD .. 1204 ..
	M4002.051-B19-05-01,5	1,337	2,000	0,750	1,575		0,059	0,331	5	0,8	5	SD .. 09T3 ..
	M4002.051-B19-07-01	1,543	2,000	0,750	1,575		0,039	0,224	7	0,8	7	SD .. 06T2 ..
	M4002.064-B19-05-02	1,594	2,500	0,750	1,969		0,079	0,449	5	1,3	5	SD .. 1204 ..
	M4002.064-B19-06-01,5	1,843	2,500	0,750	1,969		0,059	0,331	6	1,8	6	SD .. 09T3 ..
	M4002.064-B26-08-01	2,043	2,500	1,000	1,969		0,039	0,224	8	1,7	8	SD .. 06T2 ..
	M4002.076-B26-06-02	2,094	3,000	1,000	1,969		0,079	0,449	6	2,6	6	SD .. 1204 ..
M4002.102-B38-07-02	3,094	4,000	1,500	2,480		0,079	0,449	7	5,8	7		

* Measured using SDM.06T204, SDM.09T308, SDM.120408
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Type D _c [inch]	SD .. 06T2 .. 0,291–1,543	SD .. 06T2 .. 2,043	SD .. 09T3 .. 0,334–1,843	SD .. 1204 .. 1,094–1,594	SD .. 1204 .. 2,094	SD .. 1204 .. 3,094
	Clamping screw for indexable insert Tightening torque		FS2084 (Torx 7IP) 0,9 Nm	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
	Clamping screw for arbour-mounted tools			FS1519			FS1519	FS1583

Accessories		Type	SD .. 06T2 ..	SD .. 09T3 ..	SD .. 1204 ..
	Torque screwdriver, analogue Tightening torque		FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque			FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade		FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
	Screwdriver		FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Designation	r mm	b mm	P				M			K				N		S		
			HC				HC			HC				HC	HW	HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
	SDMT06T2ZDR-D57	0,4	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T3ZDR-D57	0,8	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT1204ZDR-D57	0,8	1,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDHT06T204-G88	0,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT06T204-D57	0,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT06T204-F57	0,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT06T212-F57	1,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW06T204-A57	0,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDHT09T308-G88	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T308-D57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T308-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T320-F57	2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW09T308-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW09T320-A57	2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDHT120408-G88	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120425-F57	2,5		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120425-A57	2,5		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

For SD..120425 indexable inserts, the circumference of the body must be reworked.
R_(body) = r_(indexable insert)

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺☺
Good

☺☺☺
Moderate

●● Primary application

● Other application

C 2

High-feed milling cutters

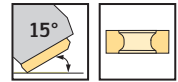
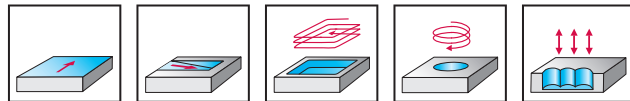
M5008 mm

ENMX08T316R

Xtra-tec® XT



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M5008	●	●	●	●	●	●	●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	★ M5008-016-T14-02-01	10,1	16	T14	25		1	3	2	0,0	2	ENMX08T316R
	★ M5008-020-T18-03-01	14,1	20	T18	30		1	3	3	0,0	3	
	★ M5008-020-T18-04-01	14,1	20	T18	30		1	3	4	0,0	4	
	★ M5008-025-T22-04-01	19,1	25	T22	35		1	3	4	0,1	4	
	★ M5008-025-T22-05-01	19,1	25	T22	35		1	3	5	0,1	5	
	★ M5008-030-T28-04-01	24,1	30	T28	40		1	3	4	0,2	4	
	★ M5008-030-T28-05-01	24,1	30	T28	40		1	3	5	0,2	5	
	★ M5008-032-T28-05-01	26,1	32	T28	40		1	3	5	0,2	5	
	★ M5008-032-T28-06-01	26,1	32	T28	40		1	3	6	0,2	6	
	★ M5008-035-T28-05-01	29,1	35	T28	40		1	3	5	0,2	5	
	★ M5008-035-T28-06-01	29,1	35	T28	40		1	3	6	0,2	6	
	★ M5008-040-T36-06-01	34,1	40	T36	40		1	3	6	0,3	6	
	★ M5008-040-T36-08-01	34,1	40	T36	40		1	3	8	0,3	8	
	★ M5008-042-T36-06-01	36,1	42	T36	40		1	3	6	0,3	6	
★ M5008-042-T36-08-01	36,1	42	T36	40		1	3	8	0,3	8		
Cylindrical, modular 	★ M5008-016-TC08-02-01	10,1	16	M8	25		1	3	2	0,0	2	ENMX08T316R
	★ M5008-020-TC10-03-01	14,1	20	M10	30		1	3	3	0,0	3	
	★ M5008-020-TC10-04-01	14,1	20	M10	30		1	3	4	0,0	4	
	★ M5008-025-TC12-04-01	19,1	25	M12	35		1	3	4	0,1	4	
	★ M5008-025-TC12-05-01	19,1	25	M12	35		1	3	5	0,1	5	
	★ M5008-030-TC16-04-01	24,1	30	M16	40		1	3	4	0,2	4	
	★ M5008-030-TC16-05-01	24,1	30	M16	40		1	3	5	0,2	5	
	★ M5008-032-TC16-05-01	26,1	32	M16	40		1	3	5	0,2	5	
	★ M5008-032-TC16-06-01	26,1	32	M16	40		1	3	6	0,2	6	
	★ M5008-035-TC16-05-01	29,1	35	M16	40		1	3	5	0,2	5	
★ M5008-035-TC16-06-01	29,1	35	M16	40		1	3	6	0,2	6		
Parallel shank 	★ M5008-016-A16-02-01	10,1	16	16	30	100	1	3	2	0,1	2	ENMX08T316R
	★ M5008-020-A20-03-01	14,1	20	20	50	130	1	3	3	0,3	3	
	★ M5008-020-A20-04-01	14,1	20	20	50	130	1	3	4	0,3	4	
	★ M5008-025-A25-04-01	19,1	25	25	60	140	1	3	4	0,5	4	
	★ M5008-025-A25-05-01	19,1	25	25	60	140	1	3	5	0,5	5	
	★ M5008-032-A32-05-01	26,1	32	32	70	150	1	3	5	0,8	5	
	★ M5008-032-A32-06-01	26,1	32	32	70	150	1	3	6	0,8	6	





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

/ ★ New addition to the product range


Assembly parts

D _c [mm]		10–36,1
	Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm

Accessories

D _c [mm]		10–36,1
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2012 (Torx 8IP)
	Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	s mm	r mm	P		M		K			N		S		H		
			HC		HC		HC			HC	HW	HC		HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
 ENMX08T316R-D27	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ENMX08T316R-F47	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

High-feed milling cutters

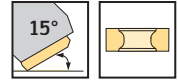
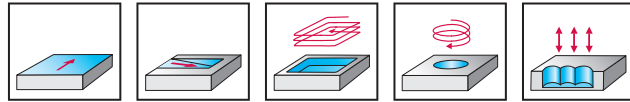
M5008 mm

ENMX08T316R

Xtra-tec® XT



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M5008	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	★ M5008-032-B16-05-01	26,1	32	16	40		1	3	5	0,1	5	ENMX08T316R
	★ M5008-032-B16-06-01	26,1	32	16	40		1	3	6	0,1	6	
	★ M5008-035-B16-05-01	29,1	35	16	40		1	3	5	0,1	5	
	★ M5008-035-B16-06-01	29,1	35	16	40		1	3	6	0,1	6	
	★ M5008-040-B16-06-01	34,1	40	16	40		1	3	6	0,2	6	
	★ M5008-040-B16-08-01	34,1	40	16	40		1	3	8	0,2	8	
	★ M5008-042-B16-06-01	36,1	42	16	40		1	3	6	0,2	6	
	★ M5008-042-B16-08-01	36,1	42	16	40		1	3	8	0,2	8	
	★ M5008-050-B22-07-01	44,1	50	22	40		1	3	7	0,4	7	
	★ M5008-050-B22-09-01	44,1	50	22	40		1	3	9	0,4	9	
	★ M5008-052-B22-07-01	46,1	52	22	40		1	3	7	0,4	7	
	★ M5008-052-B22-09-01	46,1	52	22	40		1	3	9	0,4	9	
	★ M5008-063-B22-08-01	57,1	63	22	40		1	3	8	0,5	8	
	★ M5008-063-B22-10-01	57,1	63	22	40		1	3	10	0,5	10	
	★ M5008-066-B27-08-01	60,1	66	27	50		1	3	8	0,8	8	
	★ M5008-066-B27-10-01	60,1	66	27	50		1	3	10	0,8	10	

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

Assembly parts

D _c [mm]		26,1–60,1
	Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm

Accessories

D _c [mm]		26,1–60,1
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2012 (Torx 8IP)
	Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	s mm	r mm	P		M		K			N		S		H			
			HC		HC		HC			HC	HW	HC		HC			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
	ENMX08T316R-D27	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	ENMX08T316R-F47	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

High-feed milling cutters

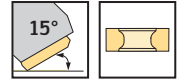
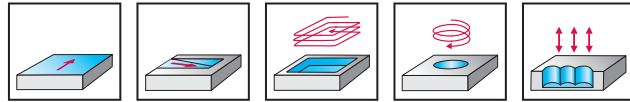
M5008 inch

ENMX08T316R

Xtra-tec® XT



– Four cutting edges per indexable insert



M5008	P	M	K	N	S	H	O
	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	a _r inch	Z	lbs	No. of indexable inserts	Type
	★ M5008.015-T14-02-01	0,394	0,625	0,571	0,984		0,039	0,118	2	0,1	2	ENMX08T316R
	★ M5008.019-T18-03-01	0,516	0,750	0,728	1,181		0,039	0,118	3	0,1	3	
	★ M5008.026-T22-04-01	0,768	1,000	0,866	1,378		0,039	0,118	4	0,2	4	
	★ M5008.026-T22-05-01	0,768	1,000	0,866	1,378		0,039	0,118	5	0,2	5	
	★ M5008.031-T28-05-01	1,016	1,250	1,102	1,575		0,039	0,118	5	0,4	5	
	★ M5008.031-T28-06-01	1,016	1,250	1,102	1,575		0,039	0,118	6	0,4	6	
	★ M5008.038-T36-06-01	1,268	1,500	1,417	1,575		0,039	0,118	6	0,7	6	
	★ M5008.038-T36-08-01	1,268	1,500	1,417	1,575		0,039	0,118	8	0,7	8	
	★ M5008.015-A15-02-01	0,394	0,625	0,625	0,750	4,000	0,039	0,118	2	0,3	2	ENMX08T316R
	★ M5008.019-A19-03-01	0,516	0,750	0,750	1,000	5,000	0,039	0,118	3	0,5	3	
	★ M5008.026-A26-04-01	0,768	1,000	1,000	1,000	5,500	0,039	0,118	4	1,1	4	
	★ M5008.026-A26-05-01	0,768	1,000	1,000	1,000	5,500	0,039	0,118	5	1,1	5	
	★ M5008.038-B19-06-01	1,268	1,500	0,750	1,500		0,039	0,118	6	0,4	6	ENMX08T316R
	★ M5008.038-B19-08-01	1,268	1,500	0,750	1,500		0,039	0,118	8	0,4	8	
	★ M5008.051-B19-07-01	1,768	2,000	0,750	1,500		0,039	0,118	7	0,6	7	
	★ M5008.051-B19-09-01	1,768	2,000	0,750	1,500		0,039	0,118	9	0,6	9	
	★ M5008.064-B26-08-01	2,268	2,500	1,000	1,500		0,039	0,118	8	1,2	8	
	★ M5008.064-B26-10-01	2,268	2,500	1,000	1,500		0,039	0,118	10	1,1	10	

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

/ ★ New addition to the product range

Assembly parts

D _c [inch]		0,394–2,268
	Clamping screw for indexable insert Tightening torque	FS1454 (Torx 8IP) 1,2 Nm

Accessories

D _c [inch]		0,394–2,268
	Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2012 (Torx 8IP)
	Screwdriver	FS1483 (Torx 8IP)

Indexable inserts

Designation	s mm	r mm	P		M		K			N		S		H		
			HC		HC		HC			HC	HW	HC		HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
	ENMX08T316R-D27	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	ENMX08T316R-F47	3,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

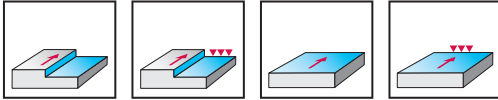
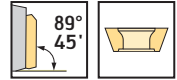
••
Primary application

•
Other application

Shoulder milling cutters

F2010 mm
SD .. 09T3 ..


- Adjustable runout
- Four cutting edges per indexable insert



	P	M	K	N	S	H	O
F2010	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	F2010.B.080.Z06.08.R756M	80	27	50	8,4	6	1,3	6	SD .. 09T3 ..
Parallel bore DIN 138 transverse keyway 	F2010.B.100.Z07.08.R756M	100	32	50	8,4	7	1,9	7	SD .. 09T3 ..
	F2010.B.125.Z08.08.R756M	125	40	63	8,4	8	3,6	8	
Parallel bore DIN 138 transverse keyway 	F2010.B.160.Z10.08.R756M	160	40/40 B	63	8,4	10	5,6	10	SD .. 09T3 ..
	F2010.B.200.Z12.08.R756M	200	60/50 B	63	8,4	12	8,3	12	
	F2010.B.250.Z12.08.R756M	250	60/50 B	63	8,4	12	14,8	12	
	F2010.B.250.Z16.08.R756M	250	60/50 B	63	8,4	16	14,6	16	
Parallel bore DIN 138 transverse keyway 	F2010.B.315.Z14.08.R756M	315	60/50-60 BB	80	8,4	14	26,3	14	SD .. 09T3 ..
	F2010.B.315.Z18.08.R756M	315	60/50-60 BB	80	8,4	18	26,2	18	

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

Assembly parts

D _c [mm]		80–315
	Cartridge for tool body	FR756M
	Clamping screw for cartridge Tightening torque	FS247 (SW 4) 8,0 Nm
	Clamping screw for indexable insert Tightening torque	FS2266 (Torx 10IP) 2,0 Nm
	Adjusting pin	FS303 (Torx 20)

Accessories

D _c [mm]		80–315
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade for indexable insert	FS2268 (Torx 10IP)
	Torque T-handle Tightening torque	FS2041 4,5–14 Nm
	Interchangeable blade for cartridge	FS2051 (SW 4)
	Screwdriver for indexable insert	FS2267 (Torx 10IP)
	Screwdriver for adjusting pin	FS228 (Torx 20)
	ISO 2936 Allen key for cartridge	ISO2936-4 (SW 4)

Indexable inserts

Designation	r mm	b mm	P				M			K				N		S			
			HC	HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
SDGT09T3PDR-D57	0,8	1,2	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺			☺		☺
SDHT09T304-G88	0,4														☺	☺			
SDHT09T308-G88	0,8														☺	☺			
SDMT09T308-D51	0,8		☺	☺	☺	☺			☺		☺	☺	☺	☺					☺
SDMT09T308-D57	0,8		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺					☺
SDMT09T308-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺					☺
SDMT09T320-F57	2			☺	☺	☺	☺	☺	☺										☺
SDMW09T308-A57	0,8		☺	☺	☺	☺					☺	☺	☺	☺					☺
SDMW09T320-A57	2			☺	☺	☺	☺	☺	☺										☺

SD..09T3.. : If the corner radius is r > 0.8 mm, the corner area of the cartridge must be reworked.
R_(body) = r_(indexable insert)

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

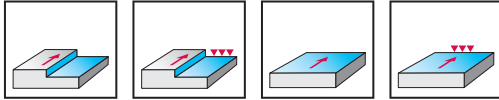
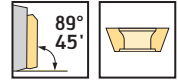
● Other application

C 2

Shoulder milling cutters

F2010 mm
SD .. 1204 ..


- Adjustable runout
- Four cutting edges per indexable insert



	P	M	K	N	S	H	O
F2010	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type		
Parallel bore DIN 138 transverse keyway 	F2010.B.080.Z06.08.R757M	80	27	50	11,6	6	1,3	6	SD .. 1204 ..		
Parallel bore DIN 138 transverse keyway 	F2010.B.100.Z07.08.R757M	100	32	50	11,6	7	1,9	7	SD .. 1204 ..		
	F2010.B.125.Z08.08.R757M	125	40	63	11,6	8	3,6	8	SD .. 1204 ..		
Parallel bore DIN 138 transverse keyway 	F2010.B.160.Z10.08.R757M	160	40/40 B	63	11,6	10	5,6	10	SD .. 1204 ..		
	F2010.B.200.Z12.08.R757M	200	60/50 B	63	11,6	12	8,3	12			
	F2010.B.250.Z12.08.R757M	250	60/50 B	63	11,6	12	14,8	12			
	F2010.B.250.Z16.08.R757M	250	60/50 B	63	11,6	16	14,6	16			
Parallel bore DIN 138 transverse keyway 	F2010.B.315.Z14.08.R757M	315	60/50-60 BB	80	11,6	14	26,3	14	SD .. 1204 ..		
	F2010.B.315.Z18.08.R757M	315	60/50-60 BB	80	11,6	18	26,2	18			

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

Assembly parts

D _c [mm]		80–315
	Cartridge for tool body	FR757M
	Clamping screw for cartridge Tightening torque	FS247 (SW 4) 8,0 Nm
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm
	Adjusting pin	FS303 (Torx 20)

Accessories

D _c [mm]		80–315
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade for indexable insert	FS2014 (Torx 15IP)
	Torque T-handle Tightening torque	FS2041 4,5–14 Nm
	Interchangeable blade for cartridge	FS2051 (SW 4)
	Screwdriver for indexable insert	FS1485 (Torx 15IP)
	Screwdriver for adjusting pin	FS228 (Torx 20)
	ISO 2936 Allen key for cartridge	ISO2936-4 (SW 4)

Indexable inserts

Designation	r mm	b mm	P				M			K			N		S				
			HC	HC	HC	HC	HC	HC	HW	HC	HW	HC	HW	HC					
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
SDGT1204PDR-D57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺			☺	☺	☺
SDHT120408-G88	0,8														☺	☺			
SDMT120408-D51	0,8		☺	☺	☺	☺			☺		☺	☺	☺	☺					☺
SDMT120408-D57	0,8		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺					☺
SDMT120408-F57	0,8		☺	☺	☺	☺	☺		☺		☺	☺	☺	☺					☺
SDMT120425-F57	2,5			☺	☺	☺	☺	☺	☺			☺	☺	☺					☺
SDMW120408-A57	0,8		☺	☺	☺	☺					☺	☺	☺	☺					☺
SDMW120425-A57	2,5			☺	☺	☺	☺	☺	☺			☺	☺	☺					☺

SD..1204.. : If the corner radius is $r > 0.8$ mm, the corner area of the cartridge must be reworked.
 $R_{(body)} = r_{(indexable\ insert)}$

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●●
Primary application

●
Other application

C 2

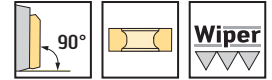
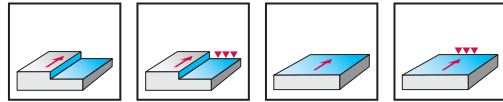
Close pitch cutter

M2136 mm

SNEF120408R



– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M2136			●●				

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M2136-050-B22-06-06	50	22	50	6,5	6	0,56	6	SNEF120408R SNEX1204PN ..
	M2136-063-B22-08-06	63	22	50	6,5	8	0,76	8	
	M2136-080-B27-12-06	80	27	50	6,5	12	1,2	12	
	M2136-100-B32-16-06	100	32	50	6,5	16	1,79	16	
	M2136-125-B40-20-06	125	40	63	6,5	20	3,42	20	
Parallel bore DIN 138 transverse keyway 	M2136-160-B40-24-06	160	40/40 B	63	6,5	24	6,05	24	SNEF120408R SNEX1204PN ..

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

Assembly parts

	Clamping wedge	FK377
	Clamping screw for clamping wedge Tightening torque	FS2185 (Torx 10IP) 4 Nm

Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2268 (Torx 10IP)
	Screwdriver	FS2267 (Torx 10IP)

Indexable inserts

Designation	r mm	b mm	P		M		K				N		S		H	
			HC		HC		HC				HC	HW	HC		HC	
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
SNEF120408R-B67	0,8	2,1						⊕	⊕	⊕	⊕					
SNEF120408R-D67	0,8	2,1						⊕	⊕	⊕	⊕					
SNEX1204PNR-B67	0,8	10,8						⊕								⊕
SNEX1204PNN-A27	1,2	10,3						⊕								⊕

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

•• Primary application

• Other application

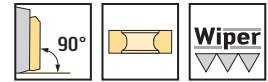
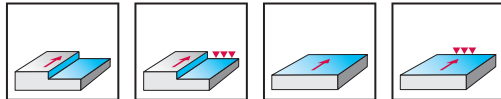
Close pitch cutter

M2136 inch

SNEF120408R



– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M2136			●●				

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M2136.051-B19-06-06	2,000	0,750	1,969	0,256	6	1,21	6	SNEF120408R SNEX1204PN ..
	M2136.064-B19-08-06	2,500	0,750	1,969	0,256	8	2,04	8	
	M2136.076-B26-12-06	3,000	1,000	1,969	0,256	12	2,59	12	
	M2136.102-B31-16-06	4,000	1,250	1,969	0,256	16	4,23	16	
	M2136.127-B38-20-06	5,000	1,500	2,480	0,256	20	9,24	20	
	M2136.152-B38-24-06	6,000	1,500	2,480	0,256	24	13,64	24	

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

Assembly parts		D _c [inch]	2,000–2,500	3,000	4,000	5,000–6,000
	Clamping wedge		FK377	FK377	FK377	FK377
	Clamping screw for clamping wedge Tightening torque		FS2185 (Torx 10IP) 4 Nm	FS2185 (Torx 10IP) 4 Nm	FS2185 (Torx 10IP) 4 Nm	FS2185 (Torx 10IP) 4 Nm
	Clamping screw for arbour-mounted tools			FS1519	FS1339	FS1583

Accessories		D _c [inch]	2,000–6,000
	Torque screwdriver, analogue Tightening torque		FS2002 0,4–1,2 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
	Interchangeable blade		FS2268 (Torx 10IP)
	Screwdriver		FS2267 (Torx 10IP)

Designation	r mm	b mm	P		M		K				N		S		H		
			HC		HC		HC				HC	HW	HC		HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S
SNEF120408R-B67	0,8	2,1							☺	☺	☺						
SNEF120408R-D67	0,8	2,1						☺	☺	☺							
SNEX1204PNR-B67	0,8	10,8						☺									☺
SNEX1204PNN-A27	1,2	10,3						☺									☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

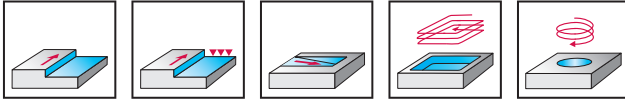
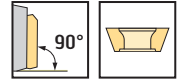
• Other application

Ramping milling cutter

M2331 mm



- For pocket machining
- Two cutting edges per indexable insert



M2331	P	M	K	N	S	H	O
				●●			●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁₆ mm	L _c mm	Z	kg	No. of indexable inserts	Type
HSK DIN 69893-1 A 	M2331-032-H80F-02-15-MA	32	HSK-A80/A63	110	65	15	2	1,5	2	ZDGT15A4 .. R
	M2331-040-H80F-02-20-MA	40	HSK-A80/A63	110	65	20	2	1,6	2	ZDGT20A5 .. R
	M2331-040-H80F-03-15-MA	40	HSK-A80/A63	110	65	15	3	1,6	3	ZDGT15A4 .. R
	M2331-050-H80F-03-20-MA	50	HSK-A80/A63	110	80	20	3	1,9	3	ZDGT20A5 .. R
	M2331-050-H80F-04-15-MA	50	HSK-A80/A63	110	80	15	4	1,9	4	ZDGT15A4 .. R
Parallel bore DIN 138 transverse keyway 	M2331-040-B16-03-15	40	16	50		15	3	0,2	3	ZDGT15A4 .. R
	M2331-050-B22-03-20	50	22	60		20	3	0,4	3	ZDGT20A5 .. R
	M2331-050-B22-04-15	50	22	50		15	4	0,3	4	ZDGT15A4 .. R
	M2331-050-B22-02-20	50	22	60		20	2	0,5	2	ZDGT20A5 .. R
	M2331-050-B22-02-15	50	22	50		15	2	0,4	2	ZDGT15A4 .. R
	M2331-050-B22-03-15	50	22	50		15	3	0,4	3	

Pre-balanced tools

For information on high-speed applications, see "Technical information/Information on high-speed applications"

Tools with HSK have a residual imbalance of 3 gmm – with RFID chip hole, without RFID chip

M2331-...-MA special interface for Makino (similar to HSK-A DIN 69893)

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

Assembly parts		Type	ZDGT15A4 .. R	ZDGT15A4 .. R	ZDGT15A4 .. R	ZDGT20A5 .. R	ZDGT20A5 .. R
		D _c [mm]	32	40	50	40	50
	Clamping screw for indexable insert		FS1222 (Torx 15IP)	FS1453 (Torx 15IP)	FS1453 (Torx 15IP)	FS2281 (Torx 20IP)	FS2281 (Torx 20IP)
	Tightening torque		3,5 Nm	3,5 Nm	3,5 Nm	5,0 Nm	5,0 Nm
	Clamping screw for arbour-mounted tools			M08X040 ISO4762	M10X035 ISO4762		M10X040 ISO4762
				12.9	12.9		12.9

Accessories		Type	ZDGT15A4 .. R	ZDGT20A5 .. R
	Torque screwdriver, analogue		FS2003	FS2003
	Tightening torque		1,5–5,0 Nm	1,5–5,0 Nm
	Torque screwdriver, digital		FS2248	FS2248
	Tightening torque		1,0–6,0 Nm	1,0–6,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	Screwdriver		FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	r mm	b mm	P		M		K		N		S		O	
			HC		HC		HC		HF		HC		HF	
			WKP255	WKP355	WSP455	WSM355	WSP455	WKP255	WKP355	WMG40	WSM355	WSP455	WMG40	
ZDGT15A404R-K85	0,4	1,2							☒					☒
ZDGT15A408R-K85	0,8	1,2							☒					☒
ZDGT15A412R-K85	1,2	1,2							☒					☒
ZDGT15A416R-K85	1,6	1,2							☒					☒
ZDGT15A420R-K85	2	1,2							☒					☒
ZDGT15A425R-K85	2,5	1,2							☒					☒
ZDGT15A430R-K85	3	1,2							☒					☒
ZDGT15A440R-K85	4	1,2							☒					☒
ZDGT20A508R-K85	0,8	1,2							☒					☒
ZDGT20A512R-K85	1,2	1,2							☒					☒
ZDGT20A516R-K85	1,6	1,2							☒					☒
ZDGT20A520R-K85	2	1,2							☒					☒
ZDGT20A530R-K85	3	1,2							☒					☒
ZDGT20A540R-K85	4	1,2							☒					☒
ZDGT20A550R-K85	5	1,2							☒					☒
ZDGT20A560R-K85	6	1,2							☒					☒
ZDGT20A564R-K85	6,4	1,2							☒					☒

If the corner radius r = 2.0 mm or above, the corner area of the body must be reworked:
 R (body) = r (indexable insert) - 1 mm

HC = Coated carbide
 HF = Uncoated fine-grained carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

😊
Good

😐
Moderate

●● Primary application

● Other application

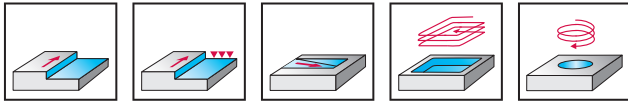
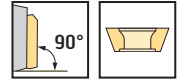
C 2

Ramping milling cutter

M2331 inch



- For pocket machining
- Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M2331				●●			●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁₆ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	M2331.051-T45-03-15	2,000	T45	2,000		0,591	3	1,3	3	ZDGT15A4 .. R
	M2331.051-T45-03-20	2,000	T45	2,000		0,787	3	1,1	3	ZDGT20A5 .. R
HSK DIN 69893-1 A 	M2331.038-H80F-03-15-MA	1,500	80,000	4,331	2,524	0,591	3	3,5	3	ZDGT15A4 .. R
	M2331.051-H80F-03-20-MA	2,000	80,000	4,331	3,150	0,787	3	4,2	3	ZDGT20A5 .. R
	M2331.051-H80F-04-15-MA	2,000	80,000	4,331	3,150	0,591	4	4,2	4	ZDGT15A4 .. R
Parallel bore DIN 138 transverse keyway 	M2331.051-B19-03-15	2,000	0,750	2,000		0,591	3	1,0	3	ZDGT15A4 .. R
	M2331.051-B19-02-20	2,000	0,750	2,000		0,787	2	1,0	2	ZDGT20A5 .. R
	M2331.051-B19-02-15	2,000	0,750	2,000		0,591	2	1,1	2	ZDGT15A4 .. R

Pre-balanced tools

For information on high-speed applications, see "Technical information/Information on high-speed applications"

Tools with HSK have a residual imbalance of 3 gmm – with RFID chip hole, without RFID chip

M2331-...-MA special interface for Makino (similar to HSK-A DIN 69893)

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

Assembly parts		ZDGT15A4 .. R 1,500	ZDGT15A4 .. R 2,000	ZDGT20A5 .. R 2,000
	Type D _c [inch] Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS2281 (Torx 20IP) 5,0 Nm
	Type Clamping screw for arbour-mounted tools		FS1338	FS1338

Accessories		ZDGT15A4 .. R	ZDGT20A5 .. R
	Type Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
	Type Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Type Interchangeable blade	FS2014 (Torx 15IP)	FS2015 (Torx 20IP)
	Type Screwdriver	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)

Indexable inserts

Designation	r mm	b mm	P		M		K		N		S		O	
			HC		HC		HC		HF		HC		HF	
			WKP255	WKP355	WSP455	WSM355	WSP455	WKP255	WKP355	WMG40	WSM355	WSP455	WMG40	
ZDGT15A404R-K85	0,4	1,2							☒					☒
ZDGT15A408R-K85	0,8	1,2							☒					☒
ZDGT15A412R-K85	1,2	1,2							☒					☒
ZDGT15A416R-K85	1,6	1,2							☒					☒
ZDGT15A420R-K85	2	1,2							☒					☒
ZDGT15A425R-K85	2,5	1,2							☒					☒
ZDGT15A430R-K85	3	1,2							☒					☒
ZDGT15A440R-K85	4	1,2							☒					☒
ZDGT20A508R-K85	0,8	1,2							☒					☒
ZDGT20A512R-K85	1,2	1,2							☒					☒
ZDGT20A516R-K85	1,6	1,2							☒					☒
ZDGT20A520R-K85	2	1,2							☒					☒
ZDGT20A530R-K85	3	1,2							☒					☒
ZDGT20A540R-K85	4	1,2							☒					☒
ZDGT20A550R-K85	5	1,2							☒					☒
ZDGT20A560R-K85	6	1,2							☒					☒
ZDGT20A564R-K85	6,4	1,2							☒					☒

If the corner radius r = 2.0 mm or above, the corner area of the body must be reworked:
 R (body) = r (indexable insert) - 1 mm

HC = Coated carbide
 HF = Uncoated fine-grained carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

😊
Good

😐
Moderate

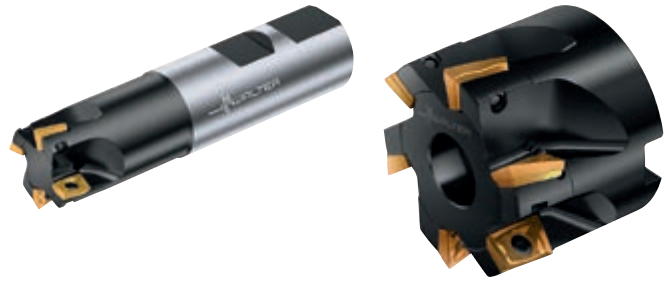
•• Primary application

• Other application

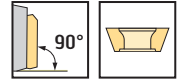
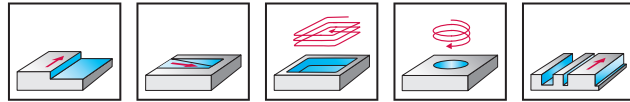
C 2

Shoulder milling cutters

M4130



– Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M4130	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Shank DIN 1835 B 	M4130-016-W16-02-08	16	16	40	90	8	2	0,1	2	LDM . 08T204R
	M4130-020-W20-03-08	20	20	38	90	8	3	0,2	3	
	M4130-025-W25-04-08	25	25	42	100	8	4	0,3	4	
	M4130-032-W32-04-13	32	32	49	110	13	4	0,6	4	
Parallel bore DIN 138 transverse keyway 	M4130-040-B16-05-13	40	16	40		13	5	0,2	5	LDM . 14T308R
	M4130-050-B22-06-13	50	22	40		13	6	0,3	6	
	M4130-050-B22-05-16	50	22	40		16	5	0,3	5	LDM . 1704 .. R
	M4130-063-B27-06-16	63	27	50		16	6	0,6	6	
	M4130-080-B27-07-16	80	27	50		16	7	0,9	7	
	M4130-100-B32-08-16	100	32	50		16	8	1,7	8	

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

Assembly parts

Type	LDM . 08T204R	LDM . 14T308R	LDM . 1704 .. R
Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	LDM . 08T204R	LDM . 14T308R	LDM . 1704 .. R
Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				S	
			HC				HC		HC				HC	
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S
LDMT08T204R-D51	0,4	0,8	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT08T204R-D57	0,4	0,8	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT08T204R-F57	0,4	0,8	☉	☉	☉	☉	☉	☉	☉		☉	☉	☉	☉
LDMW08T204R-A57	0,4	0,8	☉	☉	☉	☉					☉	☉	☉	☉
LDMT14T308R-D51	0,8	1,2	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT14T308R-D57	0,8	1,2	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT14T308R-F57	0,8	1,2	☉	☉	☉	☉	☉	☉	☉		☉	☉	☉	☉
LDMW14T308R-A57	0,8	1,2	☉	☉	☉	☉					☉	☉	☉	☉
LDMT170408R-D51	0,8	1,6	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT170408R-D57	0,8	1,6	☉	☉	☉	☉	☉	☉			☉	☉	☉	☉
LDMT170408R-F57	0,8	1,6	☉	☉	☉	☉	☉	☉	☉		☉	☉	☉	☉
LDMT170412R-D51	1,2	1,6		☉	☉	☉					☉	☉	☉	☉
LDMW170408R-A57	0,8	1,6	☉	☉	☉	☉					☉	☉	☉	☉

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

●● Primary application

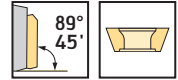
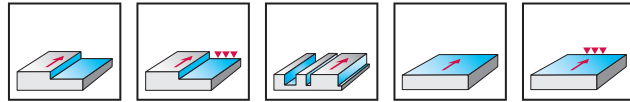
● Other application

Shoulder milling cutters

M4132 mm



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4132	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	M4132-016-T14-02-06*	16	T14	25	5,6		2	1,1	2	
	M4132-020-T18-02-06	20	T18	30	5,6		2	0,07	2	SD .. 06T2 ..
	M4132-020-T18-03-06*	20	T18	30	5,6		3	0,07	3	
	M4132-025-T22-02-09*	25	T22	35	8,4		2	0,12	2	SD .. 09T3 ..
	M4132-025-T22-03-06	25	T22	35	5,6		3	0,11	3	SD .. 06T2 ..
	M4132-025-T22-04-06*	25	T22	35	5,6		4	0,13	4	
	M4132-032-T28-02-09	32	T28	40	8,4		2	0,22	2	
	M4132-032-T28-03-09*	32	T28	40	8,4		3	0,21	3	
	M4132-040-T36-03-09	40	T36	40	8,4		3	0,23	3	SD .. 09T3 ..
	M4132-040-T36-04-09*	40	T36	40	8,4		4	0,36	4	
M4132-050-T45-04-09	50	T45	40	8,4		4	0,37	4		
M4132-050-T45-06-09*	50	T45	40	8,4		6	0,37	6		
Cylindrical, modular 	★ M4132-016-TC08-02-06	16	M8	25	5,6		2	0,03	2	
	★ M4132-020-TC10-02-06	20	M10	30	5,6		2	0,06	2	SD .. 06T2 ..
	★ M4132-020-TC10-03-06	20	M10	30	5,6		3	0,06	3	
	★ M4132-025-TC12-02-09	25	M12	35	8,4		2	0,10	2	SD .. 09T3 ..
	★ M4132-025-TC12-03-06	25	M12	35	5,6		3	0,10	3	SD .. 06T2 ..
	★ M4132-025-TC12-04-06	25	M12	35	5,6		4	0,10	4	
	★ M4132-032-TC16-02-09	32	M16	40	8,4		2	0,20	2	SD .. 09T3 ..
★ M4132-032-TC16-03-09	32	M16	40	8,4		3	0,18	3		
Shank DIN 1835 B 	M4132-016-W16-02-06*	16	16	31	5,6	80	2	0,12	2	
	M4132-020-W20-02-06	20	20	39	5,6	90	2	0,20	2	SD .. 06T2 ..
	M4132-020-W20-03-06*	20	20	39	5,6	90	3	0,20	3	
	M4132-025-W25-02-09*	25	25	43	8,4	100	2	0,35	2	SD .. 09T3 ..
	M4132-025-W25-03-06	25	25	43	5,6	100	3	0,35	3	SD .. 06T2 ..
	M4132-025-W25-04-06*	25	25	43	5,6	100	4	0,35	4	
	M4132-032-W32-02-09	32	32	49	8,4	110	2	0,61	2	
	M4132-032-W32-03-09	32	32	49	8,4	110	3	0,60	3	SD .. 09T3 ..
	M4132-040-W40-03-09	40	40	49	8,4	120	3	1,08	3	
	M4132-040-W40-04-09*	40	40	49	8,4	120	4	1,05	4	

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

* Without internal coolant supply

Assembly parts

Type	SD .. 06T2 ..	SD .. 09T3 ..
 Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm

Accessories

Type	SD .. 06T2 ..	SD .. 09T3 ..
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)
 Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)

Indexable inserts

Designation	r mm	b mm	P				M			K				N		S			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
 SDGT06T2PDR-D57 SDGT09T3PDR-D57	0,4	1,2	☺	☺	☺	☺	☺				☺	☺	☺			☺		☺	
	0,8	1,2	☺	☺	☺	☺	☺				☺	☺	☺			☺		☺	
 SDHT06T204-G88 SDMT06T204-D51 SDMT06T204-D57 SDMT06T204-F57 SDMT06T208-F57 SDMT06T212-F57 SDMW06T204-A57 SDHT09T304-G88 SDHT09T308-G88 SDMT09T304-F57 SDMT09T308-D51 SDMT09T308-D57 SDMT09T308-F57 SDMT09T312-F57 SDMT09T316-F57 SDMT09T320-F57 SDMW09T308-A57 SDMW09T320-A57	0,4													☺	☺				
	0,4		☺	☺	☺	☺					☺	☺	☺						
	0,4		☺	☺	☺	☺	☺				☺	☺	☺			☺		☺	
	0,4		☺	☺	☺	☺	☺			☺	☺	☺	☺			☺		☺	
	0,8			☺	☺	☺					☺	☺	☺					☺	
	1,2			☺	☺	☺					☺	☺	☺					☺	
	0,4			☺	☺	☺					☺	☺	☺					☺	
	0,4														☺	☺			
	0,8														☺	☺			
	0,4				☺	☺						☺	☺	☺					☺
	0,8			☺	☺	☺	☺				☺	☺	☺			☺		☺	
	0,8			☺	☺	☺	☺				☺	☺	☺			☺		☺	
	1,2				☺	☺	☺					☺	☺	☺					☺
	1,6				☺	☺	☺					☺	☺	☺					☺
	2				☺	☺	☺					☺	☺	☺			☺		☺
	0,8			☺	☺	☺						☺	☺	☺			☺		☺
	2			☺	☺	☺						☺	☺	☺			☺		☺

SD..06T2.. : If the corner radius is $r > 0.4$ mm, the corner area of the body must be reworked.
 SD..09T3.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.
 SD..1204.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.

$R_{(body)} = r_{(indexable\ insert)}$

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

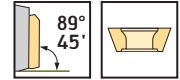
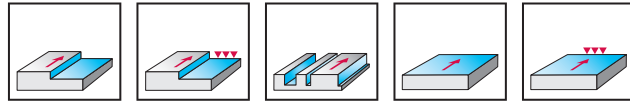
C 2

Shoulder milling cutters

M4132



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4132	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M4132-040-B16-04-09*	40	16	40	8,4		4	0,22	4	
	M4132-040-B16-05-09*	40	16	40	8,4		5	0,22	5	SD .. 09T3 ..
	M4132-050-B22-04-09*	50	22	40	8,4		4	0,35	4	
	M4132-050-B22-04-12*	50	22	40	11,6		4	0,26	4	SD .. 1204 ..
	M4132-050-B22-05-12*	50	22	40	11,6		5	0,29	5	
	M4132-050-B22-06-09*	50	22	40	8,4		6	0,33	6	SD .. 09T3 ..
	M4132-063-B22-05-09*	63	22	40	8,4		5	0,55	5	
	M4132-063-B22-05-12*	63	22	40	11,6		5	0,52	5	SD .. 1204 ..
	M4132-063-B22-06-12*	63	22	40	11,6		6	0,54	6	
	M4132-063-B22-07-09*	63	22	40	8,4		7	0,57	7	SD .. 09T3 ..
	M4132-080-B27-06-12	80	27	50	11,6		6	1,00	6	SD .. 1204 ..
	M4132-080-B27-06-09*	80	27	50	8,4		6	1,14	6	SD .. 09T3 ..
	M4132-080-B27-08-09	80	27	50	8,4		8	1,17	8	
	M4132-080-B27-08-12	80	27	50	11,6		8	1,12	8	
	M4132-100-B32-07-12	100	32	50	11,6		7	1,8	7	
	M4132-100-B32-09-12	100	32	50	11,6		9	1,83	9	SD .. 1204 ..
	M4132-125-B40-08-12	125	40	63	11,6		8	3,37	8	
	M4132-125-B40-10-12	125	40	63	11,6		10	3,42	10	

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

* Without internal coolant supply

Assembly parts

Type	SD .. 09T3 ..	SD .. 1204 ..
 Clamping screw for indexable insert Tightening torque	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	SD .. 09T3 ..	SD .. 1204 ..
 Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
 Screwdriver	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M			K				N		S			
			HC				HC			HC				HC	HW	HC			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S	
SDGT09T3PDR-D57	0,8	1,2	☺	☺	☺	☺	☺												
SDGT1204PDR-D57	0,8	1,6	☺	☺	☺	☺	☺												
SDHT09T304-G88	0,4												☺	☺					
SDHT09T308-G88	0,8												☺	☺					
SDMT09T304-F57	0,4			☺	☺	☺													☺
SDMT09T308-D51	0,8		☺	☺	☺	☺													☺
SDMT09T308-D57	0,8		☺	☺	☺	☺	☺												☺
SDMT09T308-F57	0,8		☺	☺	☺	☺	☺	☺											☺
SDMT09T312-F57	1,2			☺	☺	☺													☺
SDMT09T316-F57	1,6			☺	☺	☺													☺
SDMT09T320-F57	2			☺	☺	☺	☺	☺											☺
SDMW09T308-A57	0,8		☺	☺	☺														☺
SDMW09T320-A57	2		☺	☺	☺	☺	☺												☺
SDHT120408-G88	0,8												☺	☺					
SDMT120408-D51	0,8		☺	☺	☺	☺													☺
SDMT120408-D57	0,8		☺	☺	☺	☺	☺												☺
SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺											☺
SDMT120412-F57	1,2			☺	☺	☺													☺
SDMT120416-F57	1,6			☺	☺	☺													☺
SDMT120420-F57	2			☺	☺	☺													☺
SDMT120425-F57	2,5			☺	☺	☺	☺	☺											☺
SDMW120408-A57	0,8		☺	☺	☺														☺
SDMW120425-A57	2,5		☺	☺	☺	☺	☺												☺

SD..06T2.. : If the corner radius is $r > 0.4$ mm, the corner area of the body must be reworked.
 SD..09T3.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.
 SD..1204.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.

$R_{(body)} = r_{(indexable\ insert)}$

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●●
Primary application

●
Other application

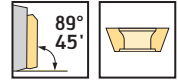
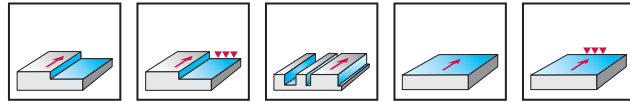
C 2

Shoulder milling cutters

M4132 inch



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4132	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Shank DIN 1835 B 	M4132.015-W15-02-06	0,625	0,625	2,851	0,945	0,220	2	0,2	2	SD .. 06T2 ..
	M4132.019-W19-03-06	0,750	0,750	2,976	0,945	0,220	3	0,3	3	
	M4132.026-W26-02-09	1,000	1,000	3,622	1,339	0,331	2	0,1	2	
	M4132.031-W31-03-09	1,250	1,250	3,701	1,417	0,331	3	0,1	3	SD .. 09T3 ..
	M4132.038-W38-04-09	1,500	1,500	4,185	1,496	0,331	4	0,2	4	
Parallel bore DIN 138 transverse keyway 	M4132.038-B13-05-09	1,500	0,500	1,575	1,575	0,331	5	0,0	5	SD .. 09T3 ..
	M4132.051-B19-06-09	2,000	0,750	1,575	1,575	0,331	6	0,1	6	
	M4132.051-B19-04-12	2,000	0,750	1,500	1,500	0,457	4	0,8	4	SD .. 1204 ..
	M4132.064-B26-07-09	2,500	1,000	1,575	1,575	0,331	7	0,1	7	SD .. 09T3 ..
	M4132.064-B26-05-12	2,500	1,000	1,575	1,575	0,457	5	1,1	5	SD .. 1204 ..
	M4132.076-B26-08-09	3,000	1,000	1,969	1,969	0,331	8	2,3	8	SD .. 09T3 ..
	M4132.076-B26-06-12	3,000	1,000	1,969	1,969	0,457	6	2,0	6	
	M4132.102-B31-07-12	4,000	1,250	1,969	1,969	0,457	7	3,9	7	SD .. 1204 ..
M4132.127-B38-08-12	5,000	1,500	2,480	2,480	0,457	8	8,0	8		

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

Assembly parts		SD .. 06T2 .. 0,625–0,750	SD .. 09T3 .. 1,000–2,000	SD .. 09T3 .. 2,500–3,000	SD .. 1204 .. 2,000	SD .. 1204 .. 2,500–3,000	SD .. 1204 .. 4,000	SD .. 1204 .. 5,000
	Type D _c [inch] Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
	Type Clamping screw for arbour-mounted tools			FS1519		FS1519	FS1339	FS1583

Accessories		SD .. 06T2 ..	SD .. 09T3 ..	SD .. 1204 ..
	Type Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
	Type Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Type Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
	Type Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M			K			N		S			
			HC				HC			HC			HC	HW	HC			
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
	SDGT06T2PDR-D57	0,4	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDGT09T3PDR-D57	0,8	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDGT1204PDR-D57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDHT06T204-G88	0,4											☺	☺				
	SDMT06T204-D51	0,4		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT06T204-D57	0,4		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT06T204-F57	0,4		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT06T208-F57	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT06T212-F57	1,2		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMW06T204-A57	0,4		☺	☺	☺				☺	☺	☺						☺
	SDHT09T304-G88	0,4											☺	☺				
	SDHT09T308-G88	0,8											☺	☺				
	SDMT09T304-F57	0,4		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T308-D51	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T308-D57	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T308-F57	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T312-F57	1,2		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T316-F57	1,6		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT09T320-F57	2		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMW09T308-A57	0,8		☺	☺	☺				☺	☺	☺						☺
	SDMW09T320-A57	2		☺	☺	☺				☺	☺	☺						☺
	SDHT120408-G88	0,8											☺	☺				
	SDMT120408-D51	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120408-D57	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120408-F57	0,8		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120412-F57	1,2		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120416-F57	1,6		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120420-F57	2		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMT120425-F57	2,5		☺	☺	☺	☺		☺	☺	☺	☺						☺
	SDMW120408-A57	0,8		☺	☺	☺				☺	☺	☺						☺
	SDMW120425-A57	2,5		☺	☺	☺				☺	☺	☺						☺

SD..06T2.. : If the corner radius is $r > 0.4$ mm, the corner area of the body must be reworked.
 SD..09T3.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.
 SD..1204.. : If the corner radius is $r > 0.8$ mm, the corner area of the body must be reworked.
 $R_{(body)} = r_{(indexable\ insert)}$

HC = Coated carbide
 HW = Uncoated carbide

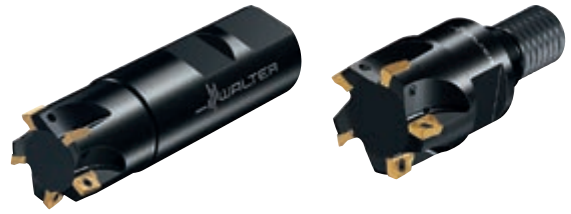
C2

Shoulder milling cutters

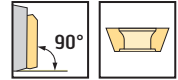
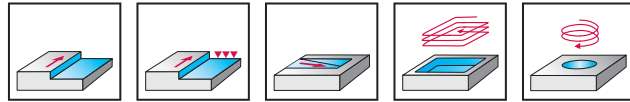
M5130

AC . T0602 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



M5130	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	M5130-010-T09-02-05	10	T09	20	5		2	0,02	2	AC . T0602 .. R
	M5130-012-T09-03-05	12	T09	20	5		3	0,02	3	
	M5130-016-T14-03-05	16	T14	25	5		3	0,04	3	
	M5130-016-T14-04-05	16	T14	25	5		4	0,03	4	
	M5130-020-T18-04-05	20	T18	25	5		4	0,05	4	
	M5130-020-T18-05-05	20	T18	25	5		5	0,05	5	
	M5130-025-T22-05-05	25	T22	30	5		5	0,1	5	
	M5130-025-T22-07-05	25	T22	30	5		7	0,1	7	
	M5130-032-T28-06-05	32	T28	35	5		6	0,19	6	
	M5130-032-T28-08-05	32	T28	35	5		8	0,20	8	
M5130-040-T36-07-05	40	T36	35	5		7	0,34	7		
M5130-040-T36-10-05	40	T36	35	5		10	0,35	10		
Cylindrical, modular 	★ M5130-010-TC06-02-05	10	M6	20	5		2	0,01	2	AC . T0602 .. R
	★ M5130-012-TC06-03-05	12	M6	20	5		3	0,01	3	
	★ M5130-016-TC08-03-05	16	M8	25	5		3	0,03	3	
	★ M5130-016-TC08-04-05	16	M8	25	5		4	0,03	4	
	★ M5130-020-TC10-04-05	20	M10	25	5		4	0,05	4	
	★ M5130-020-TC10-05-05	20	M10	25	5		5	0,05	5	
	★ M5130-025-TC12-05-05	25	M12	30	5		5	0,10	5	
	★ M5130-025-TC12-07-05	25	M12	30	5		7	0,1	7	
	★ M5130-032-TC16-06-05	32	M16	35	5		6	0,19	6	
	★ M5130-032-TC16-08-05	32	M16	35	5		8	0,20	8	
★ M5130-040-TC16-07-05	40	M16	35	5		7	0,34	7		
★ M5130-040-TC16-10-05	40	M16	35	5		10	0,35	10		
Shank DIN 1835 B 	M5130-010-W10-02-05	10	10	16	5	60	2	0,03	2	AC . T0602 .. R
	M5130-010-W16-02-05	10	16	30	5	80	2	0,09	2	
	M5130-012-W12-03-05	12	12	19	5	65	3	0,05	3	
	M5130-012-W16-03-05	12	16	30	5	80	3	0,09	3	
	M5130-016-W16-03-05	16	16	21	5	70	3	0,09	3	
	M5130-016-W16-04-05	16	16	21	5	70	4	0,11	4	
	M5130-020-W20-04-05	20	20	24	5	75	4	0,16	4	
	M5130-020-W20-05-05	20	20	24	5	75	5	0,16	5	
	M5130-025-W25-05-05	25	25	26	5	85	5	0,29	5	
	M5130-025-W25-07-05	25	25	26	5	85	7	0,29	7	




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

/ ★ New addition to the product range

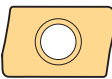
Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2560 (Torx 6IP) 0,6 Nm
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Accessories

	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Interchangeable blade	SD2001-6IP
	Screwdriver	SD1001-6IP

Indexable inserts

Designation	r mm	b mm	P		M		K			N		S				
			HC		HC		HC			HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
 ACGT060204R-G65	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACGT060204R-M85	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060202R-G55	0,2	1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060204R-G55	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060204R-K55	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060208R-G55	0,8	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060212R-G55	1,2	0,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
ACMT060216R-G55	1,6	0,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

Shoulder milling cutters

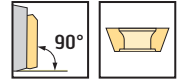
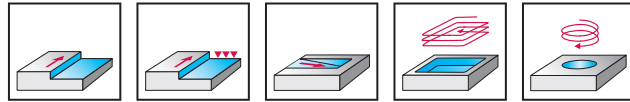
M5130 mm

AC . T0602 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
Parallel shank 	M5130-010-A10-02-05	10	10	16	5	60	2	0,03	2	AC . T0602 .. R
	M5130-010-A16-02-05	10	16	30	5	80	2	0,10	2	
	M5130-012-A12-03-05	12	12	19	5	70	3	0,05	3	
	M5130-012-A16-03-05	12	16	30	5	80	3	0,09	3	
	M5130-014-A16-03-05	14	16	30	5	80	3	0,06	3	
	M5130-016-A16-03-05	16	16	21	5	90	3	0,12	3	
	M5130-016-A16-04-05	16	16	21	5	90	4	0,13	4	
	M5130-018-A16-03-05	18	16	21	5	90	3	0,13	3	
	M5130-020-A20-04-05	20	20	24	5	110	4	0,24	4	
	M5130-020-A20-05-05	20	20	24	5	110	5	0,24	5	
	M5130-022-A20-04-05	22	20	24	5	110	4	0,25	4	
	M5130-025-A25-05-05	25	25	26	5	120	5	0,42	5	
M5130-025-A25-07-05	25	25	26	5	120	7	0,42	7		
Parallel bore DIN 138 transverse keyway 	M5130-032-B16-06-05	32	16	40	5		6	0,14	6	AC . T0602 .. R
	M5130-032-B16-08-05	32	16	40	5		8	0,14	8	
	M5130-040-B16-07-05	40	16	40	5		7	0,27	7	
	M5130-040-B16-10-05	40	16	40	5		10	0,27	10	
	M5130-050-B22-09-05	50	22	40	5		9	0,42	9	
	M5130-050-B22-12-05	50	22	40	5		12	0,42	12	
	M5130-063-B22-11-05	63	22	40	5		11	0,54	11	
	M5130-063-B22-14-05	63	22	40	5		14	0,54	14	

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

C 2

Assembly parts

	D_c [mm]	10–63
	Clamping screw for indexable insert Tightening torque	FS2560 (Torx 6IP) 0,6 Nm

Accessories

	D_c [mm]	10–63
	Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm
	Interchangeable blade	SD2001-6IP
	Screwdriver	SD1001-6IP

Indexable inserts

Designation	r mm	b mm	P		M		K			N		S				
			HC		HC		HC			HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
ACGT060204R-G65	0,4	0,9	☺	☺	☺	☺	☺									☺
ACGT060204R-M85	0,4	0,9										☺	☺			
ACMT060202R-G55	0,2	1		☺	☺	☺	☺									☺
ACMT060204R-G55	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺				☺	☺
ACMT060204R-K55	0,4	0,9		☺	☺	☺	☺			☺	☺				☺	☺
ACMT060208R-G55	0,8	0,8		☺	☺	☺	☺			☺	☺					☺
ACMT060212R-G55	1,2	0,6		☺	☺	☺	☺			☺	☺					☺
ACMT060216R-G55	1,6	0,1		☺	☺	☺	☺			☺	☺					☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

Shoulder milling cutters

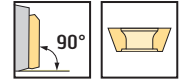
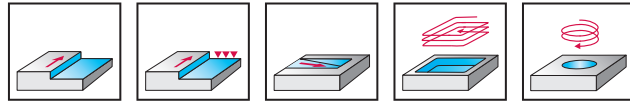
M5130 inch

AC . T0602 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	M5130.013-T09-03-05	0,500	T09	0,787		0,197	3	0,0	3	AC . T0602 .. R
	M5130.015-T14-03-05	0,625	T14	0,984		0,197	3	0,1	3	
	M5130.015-T14-04-05	0,625	T14	0,984		0,197	4	0,1	4	
	M5130.019-T18-04-05	0,750	T18	0,984		0,197	4	0,1	4	
	M5130.019-T18-05-05	0,750	T18	0,984		0,197	5	0,1	5	
	M5130.026-T22-05-05	1,000	T22	1,181		0,197	5	0,2	5	
	M5130.026-T22-07-05	1,000	T22	1,181		0,197	7	0,2	7	
	M5130.031-T28-06-05	1,250	T28	1,378		0,197	6	0,4	6	
	M5130.031-T28-08-05	1,250	T28	1,378		0,197	8	0,4	8	
	M5130.038-T36-07-05	1,500	T36	1,378		0,197	7	0,8	7	
M5130.038-T36-10-05	1,500	T36	1,378		0,197	10	0,8	10		
Shank DIN 1835 B 	M5130.013-W13-03-05	0,500	1/2	0,700	2,281	0,197	3	0,1	3	AC . T0602 .. R
	M5130.015-W15-03-05	0,625	0,625	0,750	2,656	0,197	3	0,2	3	
	M5130.015-W15-04-05	0,625	0,625	0,750	2,656	0,197	4	0,2	4	
	M5130.019-W19-04-05	0,750	0,750	0,945	2,781	0,197	4	0,3	4	
	M5130.019-W19-05-05	0,750	0,750	0,945	2,781	0,197	5	0,3	5	
	M5130.026-W26-05-05	1,000	1,000	1,000	3,281	0,197	5	0,6	5	
M5130.026-W26-07-05	1,000	1,000	1,000	3,281	0,197	7	0,6	7		
Parallel shank 	M5130.013-A13-03-05	0,500	1/2	0,750	2,531	0,197	3	0,1	3	AC . T0602 .. R
	M5130.015-A15-03-05	0,625	0,625	0,750	3,566	0,197	3	0,3	3	
	M5130.015-A15-04-05	0,625	0,625	0,750	3,566	0,197	4	0,3	4	
	M5130.019-A19-04-05	0,750	0,750	1,000	4,250	0,197	4	0,5	4	
	M5130.019-A19-05-05	0,750	0,750	1,000	4,250	0,197	5	0,5	5	
	M5130.026-A26-05-05	1,000	1,000	1,000	4,750	0,197	5	1,0	5	
	M5130.026-A26-07-05	1,000	1,000	1,000	4,750	0,197	7	1,0	7	

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

Assembly parts

	D_c [inch]	0,500–1,500
	Clamping screw for indexable insert Tightening torque	FS2560 (Torx 6IP) 0,6 Nm

Accessories

	D_c [inch]	0,500–1,500
	Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm
	Interchangeable blade	SD2001-6IP
	Screwdriver	SD1001-6IP

Indexable inserts

Designation	r mm	b mm	P		M		K			N		S				
			HC		HC		HC			HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
ACGT060204R-G65	0,4	0,9	☺	☺	☺	☺	☺									☺
ACGT060204R-M85	0,4	0,9										☺	☺			
ACMT060202R-G55	0,2	1		☺	☺	☺				☺	☺					☺
ACMT060204R-G55	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺				☺	☺
ACMT060204R-K55	0,4	0,9		☺	☺	☺	☺			☺	☺				☺	☺
ACMT060208R-G55	0,8	0,8		☺	☺	☺				☺	☺					☺
ACMT060212R-G55	1,2	0,6		☺	☺	☺				☺	☺					☺
ACMT060216R-G55	1,6	0,1		☺	☺	☺				☺	☺					☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

Shoulder milling cutters

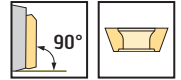
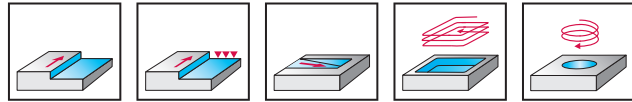
M5130 inch

AC . T0602 .. R

Xtra-tec® XT



- Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●●	●●	●●	●●	●●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M5130.051-B19-09-05	2,000	0.750	1,575		0,197	9	0,9	9	AC . T0602 .. R
	M5130.051-B19-12-05	2,000	0.750	1,575		0,197	12	0,9	12	
	M5130.064-B26-11-05	2,500	1,000	1,575		0,197	11	1,4	11	
	M5130.064-B26-14-05	2,500	1,000	1,575		0,197	14	1,5	14	

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

Assembly parts

	D _c [inch]	2,000	2,500
	Clamping screw for indexable insert Tightening torque	FS2560 (Torx 6IP) 0,6 Nm	FS2560 (Torx 6IP) 0,6 Nm
	Clamping screw for arbour-mounted tools		FS1519

Accessories

	D _c [inch]	2,000–2,500
	Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm
	Interchangeable blade	SD2001-6IP
	Screwdriver	SD1001-6IP

Indexable inserts

Designation	r mm	b mm	P		M		K			N		S			
			HC		HC		HC			HC	HW	HC			
			WKP255	WKP35G	WKP355	WSP455	WSM355	WSP455	WAK15	WKK255	WKP255	WKP35G	WKP355	WXN15	WK10
ACGT060204R-G65	0,4	0,9	☺	☹	☹	☹	☹		☹	☹	☹				☹
ACGT060204R-M85	0,4	0,9										☺	☺		
ACMT060202R-G55	0,2	1		☹	☹	☹	☹			☹	☹				☹
ACMT060204R-G55	0,4	0,9	☺	☹	☹	☹		☺	☹	☹	☹				☹
ACMT060204R-K55	0,4	0,9		☺	☺	☹				☺	☹				☺
ACMT060208R-G55	0,8	0,8		☹	☹	☹				☹	☹				☹
ACMT060212R-G55	1,2	0,6		☹	☹	☹				☹	☹				☹
ACMT060216R-G55	1,6	0,1		☹	☹	☹				☹	☹				☹

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

• Other application

Shoulder milling cutters

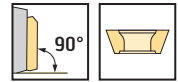
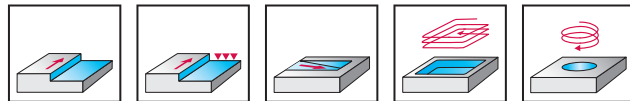
M5130

BC . T1204 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



M5130	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	★ M5130-025-T22-03-12	25	T22	35	12		3	0,09	3	BC . T1204 .. R
	★ M5130-032-T28-03-12	32	T28	40	12		3	0,17	3	
	★ M5130-032-T28-04-12	32	T28	40	12		4	0,18	4	
	★ M5130-040-T36-03-12	40	T36	40	12		3	0,31	3	
	★ M5130-040-T36-06-12	40	T36	40	12		6	0,32	6	
Cylindrical, modular 	★ M5130-025-TC12-03-12	25	M12	35	12		3	0,08	3	BC . T1204 .. R
	★ M5130-032-TC16-03-12	32	M16	40	12		3	0,16	3	
	★ M5130-032-TC16-04-12	32	M16	40	12		4	0,17	4	
	★ M5130-040-TC16-03-12	40	M16	40	12		3	0,21	3	
	★ M5130-040-TC16-06-12	40	M16	40	12		6	0,22	6	
Shank DIN 1835 B 	★ M5130-025-W25-03-12	25	25	43	12	100	3	0,30	3	BC . T1204 .. R
	★ M5130-032-W32-03-12	32	32	49	12	110	3	0,53	3	
	★ M5130-032-W32-04-12	32	32	49	12	110	4	0,54	4	
	★ M5130-040-W32-06-12	40	32	49	12	110	6	0,65	6	
Parallel shank 	★ M5130-022-A20-02-12	22	20	38	12	200	2	0,45	2	BC . T1204 .. R
	★ M5130-025-A25-02-12	25	25	38	12	200	2	0,69	2	
	★ M5130-025-A25-03-12	25	25	38	12	200	3	0,68	3	
	★ M5130-032-A32-03-12	32	32	39	12	250	3	1,40	3	
	★ M5130-032-A32-04-12	32	32	39	12	250	4	1,42	4	
	★ M5130-040-A40-04-12	40	40	44	12	250	4	2,25	4	
★ M5130-040-A32-05-12	40	32	44	12	250	5	1,51	5		

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

/ ★ New addition to the product range

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2573 (Torx 9IP) 2 Nm
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Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2013 (Torx 9IP)
	Screwdriver	FS1484 (Torx 9IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S	
			HC				HC		HC				HC	HW	HC	
			WKP255	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
BCGT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	
BCHT120408R-K85	0,8	1,3											⊕	⊕		
BCHT120412R-K85	1,2	1,2											⊕	⊕		
BCHT120416R-K85	1,6	1,1											⊕	⊕		
BCHT120420R-K85	2	1,2											⊕	⊕		
BCHT120425R-K85	2,5	1											⊕	⊕		
BCHT120430R-K85	3	0,7											⊕	⊕		
BCHT120440R-K85	4	0,4											⊕	⊕		
BCMT120404R-G55	0,4	1,3		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120408R-F55	0,8	1,3	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕				⊕	
BCMT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	
BCMT120408R-K55	0,8	1,3		⊕	⊕	⊕	⊕			⊕	⊕			⊕	⊕	
BCMT120412R-G55	1,2	1,2		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120416R-G55	1,6	1,1		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120420R-G55	2	1,2		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120425R-G55	2,5	1		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120430R-G55	3	0,7		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120432R-G55	3,2	0,5		⊕	⊕	⊕	⊕			⊕	⊕				⊕	
BCMT120440R-G55	4	0,4		⊕	⊕	⊕	⊕			⊕	⊕				⊕	

If the corner radius $r = 2.5$ mm or above, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1$ mm

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

●● Primary application

● Other application

C 2

Shoulder milling cutters

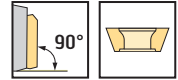
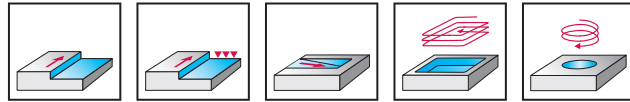
M5130

BC . T1204 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	★ M5130-040-B16-03-12	40	16	40	12		3	0,17	3	BC . T1204 .. R
	★ M5130-040-B16-04-12	40	16	40	12		4	0,18	4	
	★ M5130-040-B16-06-12	40	16	40	12		6	0,19	6	
	★ M5130-050-B22-03-12	50	22	40	12		3	0,32	3	
	★ M5130-050-B22-04-12	50	22	40	12		4	0,29	4	
	★ M5130-050-B22-07-12	50	22	40	12		7	0,31	7	
	★ M5130-063-B22-04-12	63	22	40	12		4	0,45	4	
	★ M5130-063-B27-04-12	63	27	40	12		4	0,66	4	
	★ M5130-063-B22-05-12	63	22	40	12		5	0,47	5	
	★ M5130-063-B27-05-12	63	27	40	12		5	0,67	5	
	★ M5130-063-B22-08-12	63	22	40	12		8	0,50	8	
	★ M5130-063-B27-08-12	63	27	40	12		8	0,71	8	
	★ M5130-080-B27-05-12	80	27	50	12		5	0,91	5	
	★ M5130-080-B27-06-12	80	27	50	12		6	0,94	6	
	★ M5130-080-B27-09-12	80	27	50	12		9	1,00	9	

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

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2573 (Torx 9IP) 2 Nm
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Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2013 (Torx 9IP)
	Screwdriver	FS1484 (Torx 9IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S	
			HC				HC		HC				HC	HW	HC	
			WKP255	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
BCGT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕		⊕	
BCHT120408R-K85	0,8	1,3												⊕	⊕	
BCHT120412R-K85	1,2	1,2												⊕	⊕	
BCHT120416R-K85	1,6	1,1												⊕	⊕	
BCHT120420R-K85	2	1,2												⊕	⊕	
BCHT120425R-K85	2,5	1												⊕	⊕	
BCHT120430R-K85	3	0,7												⊕	⊕	
BCHT120440R-K85	4	0,4												⊕	⊕	
BCMT120404R-G55	0,4	1,3		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120408R-F55	0,8	1,3	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕	⊕			⊕	
BCMT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	
BCMT120408R-K55	0,8	1,3		⊕	⊕	⊕	⊕				⊕	⊕		⊕	⊕	
BCMT120412R-G55	1,2	1,2		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120416R-G55	1,6	1,1		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120420R-G55	2	1,2		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120425R-G55	2,5	1		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120430R-G55	3	0,7		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120432R-G55	3,2	0,5		⊕	⊕	⊕	⊕				⊕	⊕			⊕	
BCMT120440R-G55	4	0,4		⊕	⊕	⊕	⊕				⊕	⊕			⊕	

If the corner radius $r = 2.5$ mm or above, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1$ mm

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

•• Primary application

• Other application

C 2

Shoulder milling cutters

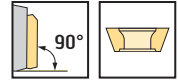
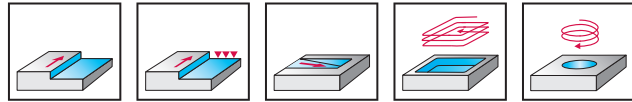
M5130 inch

BC . T1204 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert




M5130	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	★ M5130.026-T22-03-12	1,000	T22	1,378		0,472	3	0,2	3	BC . T1204 .. R
	★ M5130.031-T28-04-12	1,250	T28	1,575		0,472	4	0,4	4	
	★ M5130.031-T28-03-12	1,250	T28	1,575		0,472	3	0,4	3	
	★ M5130.038-T36-06-12	1,500	T36	1,575		0,472	6	0,7	6	
	★ M5130.051-T45-07-12	2,000	T45	1,575		0,472	7	1,1	7	
Shank DIN 1835 B 	★ M5130.019-W19-02-12	0,750	0,750	1,024	3,059	0,472	2	0,3	2	BC . T1204 .. R
	★ M5130.026-W26-03-12	1,000	1,000	1,339	3,280	0,472	3	0,6	3	
	★ M5130.031-W31-04-12	1,250	1,250	1,417	3,697	0,472	4	1,0	4	
Parallel shank 	★ M5130.019-A19-02-12	0,750	0,750	1,024	7,528	0,472	2	0,8	2	BC . T1204 .. R
	★ M5130.026-A26-03-12	1,000	1,000	1,496	8,000	0,472	3	1,6	3	
	★ M5130.031-A31-04-12	1,250	1,250	1,630	1,630	0,472	4	3,1	4	
Parallel bore DIN 138 transverse keyway 	★ M5130.038-B19-06-12	1,500	0,750	1,575		0,472	6	0,3	6	BC . T1204 .. R
	★ M5130.051-B19-04-12	2,000	0,750	1,575		0,472	4	0,6	4	
	★ M5130.051-B19-07-12	2,000	0,750	1,575		0,472	7	0,8	7	
	★ M5130.064-B26-05-12	2,500	1,000	1,575		0,472	5	1,2	5	
	★ M5130.064-B26-08-12	2,500	1,000	1,575		0,472	8	1,2	8	
	★ M5130.076-B26-06-12	3,000	1,000	2,000		0,472	6	2,0	6	
	★ M5130.076-B26-09-12	3,000	1,000	2,000		0,472	9	2,1	9	




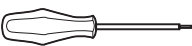
Bodies and assembly parts are included in the scope of delivery.

/ ★ New addition to the product range

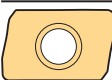
Assembly parts

D _c [inch]	0,750–3,000
 Clamping screw for indexable insert Tightening torque	FS2573 (Torx 9IP) 2 Nm

Accessories

D _c [inch]	0,750–3,000
 Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2013 (Torx 9IP)
 Screwdriver	FS1484 (Torx 9IP)

Indexable inserts


Designation	r mm	b mm	P		M		K			N		S			
			HC		HC		HC			HC	HW	HC			
			WKP255	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10
 BCGT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕				⊕
BCHT120408R-K85	0,8	1,3										⊕	⊕		
BCHT120412R-K85	1,2	1,2										⊕	⊕		
BCHT120416R-K85	1,6	1,1										⊕	⊕		
BCHT120420R-K85	2	1,2										⊕	⊕		
BCHT120425R-K85	2,5	1										⊕	⊕		
BCHT120430R-K85	3	0,7										⊕	⊕		
BCHT120440R-K85	4	0,4										⊕	⊕		
BCMT120404R-G55	0,4	1,3		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120408R-F55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕				⊕
BCMT120408R-G55	0,8	1,3	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕				⊕
BCMT120408R-K55	0,8	1,3		⊕	⊕	⊕	⊕			⊕	⊕			⊕	⊕
BCMT120412R-G55	1,2	1,2		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120416R-G55	1,6	1,1		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120420R-G55	2	1,2		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120425R-G55	2,5	1		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120430R-G55	3	0,7		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120432R-G55	3,2	0,5		⊕	⊕	⊕	⊕			⊕	⊕				⊕
BCMT120440R-G55	4	0,4		⊕	⊕	⊕	⊕			⊕	⊕				⊕


If the corner radius r = 2.5 mm or above, the corner area of the body must be reworked.
R (body) = r (indexable insert) – 1 mm


HC = Coated carbide
HW = Uncoated carbide


WALTER SELECT


Stability of machine, workpiece and clamping arrangement


Very good


Good


Moderate


Primary application


Other application

C 2

Shoulder milling cutters

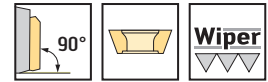
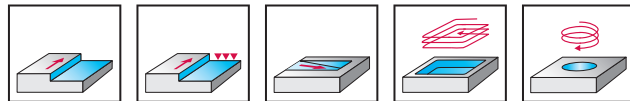
M5130

BC .. 1605 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



M5130	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	M5130-032-T28-03-15	32	T28	40	15		3	0,16	3	BC .. 1605 .. R
	M5130-040-T36-03-15	40	T36	40	15		3	0,31	3	
	M5130-040-T36-04-15	40	T36	40	15		4	0,31	4	
	M5130-050-T45-03-15	50	T45	40	15		3	0,45	3	
	M5130-050-T45-06-15	50	T45	40	15		6	0,45	6	
Cylindrical, modular 	★ M5130-032-TC16-03-15	32	M16	40	15		3	0,15	3	BC .. 1605 .. R
	★ M5130-040-TC16-03-15	40	M16	40	15		3	0,21	3	
	★ M5130-040-TC16-04-15	40	M16	40	15		4	0,20	4	
Shank DIN 1835 B 	M5130-025-W25-02-15	25	25	43	15	100	2	0,30	2	BC .. 1605 .. R
	M5130-032-W32-03-15	32	32	49	15	110	3	0,56	3	
Parallel shank 	M5130-025-A25-02-15	25	25	38	15	200	2	0,68	2	BC .. 1605 .. R
	M5130-028-A25-02-15	28	25	38	15	200	2	0,70	2	
	M5130-032-A32-03-15	32	32	39	15	250	3	1,43	3	
	M5130-035-A32-03-15	35	32	39	15	250	3	1,46	3	

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

/ ★ New addition to the product range

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2300 (Torx 15IP) 3,5 Nm
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Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M		K			N		S		H	O
			HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC		
BCGT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160508R-K85	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160512R-K85	1,2	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160516R-K85	1,6	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160520R-K85	2	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160525R-K85	2,5	1,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160530R-K85	3	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160540R-K85	4	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-F55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-K55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160512R-G55	1,2	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160516R-G55	1,6	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160520R-G55	2	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160525R-G55	2,5	1,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160530R-G55	3	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160532R-G55	3,2	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160540R-G55	4	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160550R-G55	5	0,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160560R-G55	6	0,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCGX1605PDR-G55	0,8	8							☺							☺	☺

If the corner radius $r = 2,5$ mm or above, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1$ mm
 BCGX1605PDR-F56-G55 wiper insert only in combination with BCGT160508-G55.

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

C 2

Shoulder milling cutters

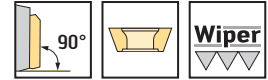
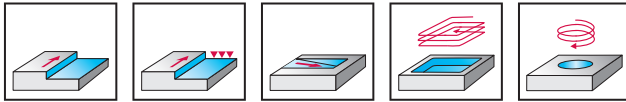
M5130

BC .. 1605 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M5130-040-B16-03-15	40	16	40	15		3	0,15	3	BC .. 1605 .. R
	M5130-040-B16-04-15	40	16	40	15		4	0,14	4	
	M5130-042-B16-03-15	42	16	40	15		3	0,17	3	
	M5130-050-B22-03-15	50	22	40	15		3	0,31	3	
	M5130-050-B22-06-15	50	22	40	15		6	0,31	6	
	M5130-054-B22-03-15	54	22	40	15		3	0,34	3	
	M5130-063-B22-04-15	63	22	40	15		4	0,43	4	
	M5130-063-B27-04-15	63	27	50	15		4	0,66	4	
	M5130-063-B22-07-15	63	22	40	15		7	0,45	7	
	M5130-063-B27-07-15	63	27	50	15		7	0,68	7	
	M5130-066-B27-04-15	66	22	50	15		4	0,72	4	
	M5130-080-B27-05-15	80	27	50	15		5	0,92	5	
	M5130-080-B27-08-15	80	27	50	15		8	0,97	8	
	M5130-085-B27-05-15	85	27	50	15		5	1,03	5	
	M5130-100-B32-05-15	100	32	50	15		5	1,55	5	
	M5130-100-B32-08-15	100	32	50	15		8	1,62	8	
	M5130-125-B40-07-15	125	40	63	15		7	2,47	7	
	M5130-125-B40-10-15	125	40	63	15		10	2,67	10	

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

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2300 (Torx 15IP) 3,5 Nm
--	--	------------------------------

Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M		K			N		S		H	O
			HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC		
BCGT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160508R-K85	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160512R-K85	1,2	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160516R-K85	1,6	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160520R-K85	2	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160525R-K85	2,5	1,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160530R-K85	3	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160540R-K85	4	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-F55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160508R-K55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160512R-G55	1,2	1,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160516R-G55	1,6	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160520R-G55	2	1,5	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160525R-G55	2,5	1,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160530R-G55	3	1,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160532R-G55	3,2	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160540R-G55	4	1,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160550R-G55	5	0,7	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCMT160560R-G55	6	0,1	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCGX1605PDR-G55	0,8	8							☺							☺	☺

If the corner radius $r = 2,5$ mm or above, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1$ mm
 BCGX1605PDR-F56-G55 wiper insert only in combination with BCGT160508-G55.

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

C 2

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2300 (Torx 15IP) 3,5 Nm
--	--	------------------------------

Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)
	Sealing disc set (incl. gasket and screws)	FS936 COMPLETE SET
	Gasket	O-R 96X4

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S		H	O	
			HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC		
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	WXM15
BCGT160508R-G55	0,8	2	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕				
BCHT160508R-K85	0,8	2												⊕	⊕				
BCHT160512R-K85	1,2	1,7												⊕	⊕				
BCHT160516R-K85	1,6	1,7												⊕	⊕				
BCHT160520R-K85	2	1,5												⊕	⊕				
BCHT160525R-K85	2,5	1,4												⊕	⊕				
BCHT160530R-K85	3	1,2												⊕	⊕				
BCHT160540R-K85	4	1,1												⊕	⊕				
BCMT160508R-F55	0,8	2	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
BCMT160508R-G55	0,8	2	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
BCMT160508R-K55	0,8	2		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160512R-G55	1,2	1,7		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160516R-G55	1,6	1,5		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160520R-G55	2	1,5		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160525R-G55	2,5	1,4		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160530R-G55	3	1,2		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160532R-G55	3,2	1,1		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160540R-G55	4	1,1		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160550R-G55	5	0,7		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCMT160560R-G55	6	0,1		⊕	⊕	⊕	⊕	⊕								⊕	⊕		
BCGX1605PDR-G55	0,8	8							⊕									⊕	⊕

If the corner radius $r = 2,5$ mm or above, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1$ mm
 BCGX1605PDR-F56-G55 wiper insert only in combination with BCGT160508-G55.

HC = Coated carbide
 HW = Uncoated carbide

C 2

Shoulder milling cutters

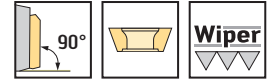
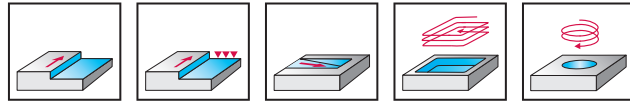
M5130 inch

BC .. 1605 .. R

Xtra-tec® XT



– Two cutting edges per indexable insert



M5130	P	M	K	N	S	H	O
	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
ScrewFit 	M5130.038-T36-03-15	1,500	T36	1,500		0,591	3	0,7	3	BC .. 1605 .. R
	M5130.038-T36-04-15	1,500	T36	1,500		0,591	4	0,7	4	
	M5130.051-T45-06-15	2,000	T45	1,575		0,591	6	1,0	6	
Shank DIN 1835 B 	M5130.026-W26-02-15	1,000	1,000	1,850	4,131	0,591	2	0,7	3	BC .. 1605 .. R
	M5130.031-W31-03-15	1,250	1,250	1,500	3,781	0,591	3	1,0	3	
	M5130.038-W31-04-15	1,500	1,250	1,730	4,008	0,591	4	1,3	3	
Parallel shank 	M5130.026-A26-02-15	1,000	1,000	1,850	8,350	0,591	2	1,6	2	BC .. 1605 .. R
	M5130.031-A31-03-15	1,250	1,250	1,500	92,547	0,591	3	3,1	3	
Parallel bore DIN 138 transverse keyway 	M5130.051-B19-03-15	2,000	0,750	1,575		0,591	3	0,7	3	BC .. 1605 .. R
	M5130.051-B19-06-15	2,000	0,750	1,575		0,591	6	0,7	6	
	M5130.064-B26-04-15	2,500	1,000	1,575		0,591	4	1,1	4	
	M5130.064-B26-07-15	2,500	1,000	1,575		0,591	7	1,1	7	
	M5130.076-B26-05-15	3,000	1,000	2,000		0,591	5	2,5	5	
	M5130.076-B26-08-15	3,000	1,000	2,000		0,591	8	2,3	8	
	M5130.102-B38-05-15	4,000	1,500	2,500		0,591	5	5,3	5	
	M5130.102-B38-08-15	4,000	1,500	2,500		0,591	8	6,0	8	
	M5130.127-B38-07-15	5,000	1,500	2,500		0,591	7	7,5	7	
	M5130.127-B38-10-15	5,000	1,500	2,500		0,591	10	8,2	10	
	M5130.152-B38-08-15	6,000	1,500	2,500		0,591	8	10,4	8	
	M5130.152-B38-12-15	6,000	1,500	2,500		0,591	12	10,2	12	

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

C 2

Assembly parts

D _c [inch]	1,000–2,000	2,500–3,000	4,000–6,000
Clamping screw for indexable insert Tightening torque	FS2300 (Torx 15IP) 3,5 Nm	FS2300 (Torx 15IP) 3,5 Nm	FS2300 (Torx 15IP) 3,5 Nm
Clamping screw for arbour-mounted tools		FS1519	FS1583

Accessories

D _c [inch]	1,000–6,000
Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2014 (Torx 15IP)
Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P				M		K				N		S		H	O	
			HC	HC	HC	HC	HC	HC	HC	HW	HC	HC	HC	HC	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSP45S	WHH15	WXM15
BCGT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		
BCHT160508R-K85	0,8	2												☺	☺				
BCHT160512R-K85	1,2	1,7												☺	☺				
BCHT160516R-K85	1,6	1,7												☺	☺				
BCHT160520R-K85	2	1,5												☺	☺				
BCHT160525R-K85	2,5	1,4												☺	☺				
BCHT160530R-K85	3	1,2												☺	☺				
BCHT160540R-K85	4	1,1												☺	☺				
BCMT160508R-F55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺				☺		
BCMT160508R-G55	0,8	2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺		
BCMT160508R-K55	0,8	2		☺	☺	☺	☺	☺								☺	☺		
BCMT160512R-G55	1,2	1,7		☺	☺	☺	☺	☺									☺		
BCMT160516R-G55	1,6	1,5		☺	☺	☺	☺	☺									☺		
BCMT160520R-G55	2	1,5		☺	☺	☺	☺	☺									☺		
BCMT160525R-G55	2,5	1,4		☺	☺	☺	☺	☺									☺		
BCMT160530R-G55	3	1,2		☺	☺	☺	☺	☺									☺		
BCMT160532R-G55	3,2	1,1		☺	☺	☺	☺	☺									☺		
BCMT160540R-G55	4	1,1		☺	☺	☺	☺	☺									☺		
BCMT160550R-G55	5	0,7		☺	☺	☺	☺	☺									☺		
BCMT160560R-G55	6	0,1		☺	☺	☺	☺	☺									☺		
BCGX1605PDR-G55	0,8	8							☺										☺

If the corner radius r = 2.5 mm or above, the corner area of the body must be reworked.
 R (body) = r (indexable insert) - 1 mm
 BCGX1605PDR-F56-G55 wiper insert only in combination with BCGT160508-G55.

HC = Coated carbide
 HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

C 2

Shoulder milling cutters

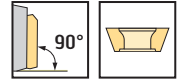
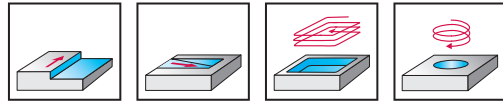
M5137

TNMMU160508R

Xtra-tec® XT



– Six cutting edges per indexable insert



	P	M	K	N	S	H	O
M5137	●	●	●	●	●		

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	★ M5137-050-B22-04-08	50	22	40	8	4	0,26	4	TNMMU160508R
	★ M5137-050-B22-05-08	50	22	40	8	5	0,25	5	
	★ M5137-063-B22-05-08	63	22	40	8	5	0,45	5	
	★ M5137-063-B22-07-08	63	22	40	8	7	0,42	7	
	★ M5137-080-B27-07-08	80	27	50	8	7	0,94	7	
	★ M5137-080-B27-09-08	80	27	50	8	9	0,94	9	
	★ M5137-100-B32-08-08	100	32	50	8	8	1,63	8	
	★ M5137-100-B32-11-08	100	32	50	8	11	1,62	11	

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

Assembly parts

	Clamping screw for indexable insert Tightening torque	FS2079 (Torx 9IP) 2,0 Nm
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Accessories

	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2013 (Torx 9IP)
	Screwdriver	FS1484 (Torx 9IP)

Indexable inserts

Designation	b mm	r mm	P		M		K			N		S				
			HC		HC		HC			HC	HW	HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S
TNMU160508R-G57	1,6	0,8	☞	☞	☞	☞	☞		☞	☞	☞					☞

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

☹
Moderate

•• Primary application

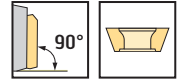
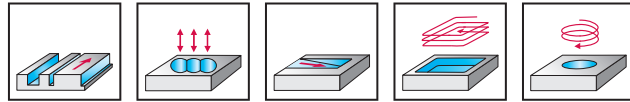
• Other application

Routing cutters

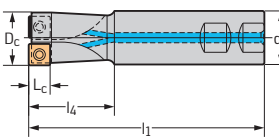
M4791 inch



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4791	●	●	●	●	●	●	●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Shank DIN 1835 B	M4791.019-W19-01-06	0,750	0,750	1,529	3,560	0,220	1	0,3	2	SD .. 06T204
	M4791.026-W26-01-09	1,000	1,000	2,844	5,125	0,331	1	0,9	2	SD .. 09T30 ..
	M4791.031-W31-01-12	1,250	1,250	3,219	5,500	0,457	1	1,4	2	SD .. 120408
	M4791.038-W31-01-12	1,500	1,250	3,219	5,500	0,457	1	1,5	2	

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

Assembly parts

Type	SD .. 06T204	SD .. 09T30 ..	SD .. 120408
Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	SD .. 06T204	SD .. 09T30 ..	SD .. 120408
Torque screwdriver, analogue Tightening torque	FS2002 0,4–1,2 Nm	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	P				M			K			N		S			
		HC				HC			HC			HC	HW	HC			
		WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X
SDHT06T204-G88	0,4												☺	☺			
SDMT06T204-D51	0,4	☺	☺	☺	☺		☺			☺	☺	☺					☺
SDMT06T204-D57	0,4	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺			☺		☺
SDMT06T204-F57	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺
SDMW06T204-A57	0,4	☺	☺	☺						☺	☺	☺					
SDHT09T304-G88	0,4												☺	☺			
SDHT09T308-G88	0,8												☺	☺			
SDMT09T308-D51	0,8	☺	☺	☺	☺		☺			☺	☺	☺					☺
SDMT09T308-D57	0,8	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺			☺		☺
SDMT09T308-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺
SDMW09T308-A57	0,8	☺	☺	☺						☺	☺	☺					
SDHT120408-G88	0,8												☺	☺			
SDMT120408-D51	0,8	☺	☺	☺	☺		☺			☺	☺	☺					☺
SDMT120408-D57	0,8	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺			☺		☺
SDMT120408-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺
SDMW120408-A57	0,8	☺	☺	☺						☺	☺	☺					

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

•• Primary application

• Other application

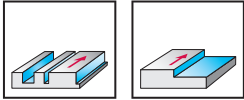
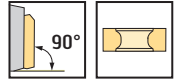
Porcupine milling cutters

M3255 mm

XNHX1306 .. R
Walter BLAXX



- Full effective design
- Two or four cutting edges per indexable insert, tangential arrangement



	P	M	K	N	S	H	O
M3255					●●		

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3255-050-B22-04-46	50	22	65	46	4	0,5	4 12	XNHX1306 .. R LNHX120604R
	M3255-050-B22-05-46	50	22	65	46	5	0,5	5 15	
	M3255-063-B27-05-46	63	27	70	46	5	1,0	5 15	
	M3255-063-B27-06-46	63	27	70	46	6	1,0	6 18	
	M3255-080-B32-05-58	80	32	85	58	5	2,0	5 20	
	M3255-080-B32-06-58	80	32	85	58	6	2,0	6 24	

The FS2250 coolant nozzle must be secured to prevent it from coming loose.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts		D _c [mm]	50	63	80
	Clamping screw for indexable insert Tightening torque		FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm
	Clamping screw for arbour-mounted tools		M10X045 ISO4762 12.9	M12X050 ISO4762 12.9	M16X060 ISO4762 12.9
	Coolant nozzle		FS2250 (SW 1,5)	FS2250 (SW 1,5)	FS2250 (SW 1,5)

Accessories		D _c [mm]	50-80
	Torque screwdriver, analogue Tightening torque		FS2003 1,5-5,0 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0-6,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)
	Screwdriver		FS1485 (Torx 15IP)

Designation	r mm	b mm	P			M			K			N		S			
			HC			HC			HC			HC	HW	HC			
			WKP25S	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
LNHX120604R-L65T	0,4															☼	☼
XNHX130608R-L65T	0,8	2														☼	☼
XNHX130612R-L65T	1,2	2														☼	☼
XNHX130616R-L65T	1,6	2														☼	☼
XNHX130620R-L65T	2	2														☼	☼
XNHX130624R-L65T	2,4	2														☼	☼
XNHX130630R-L65T	3	1,4														☼	☼
XNHX130632R-L65T	3,2	1,3														☼	☼
XNHX130640R-L65T	4	0,5														☼	☼

XNHX1306 . . indexable inserts can only be used as front inserts.

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

😊
Good

😐
Moderate

•• Primary application

• Other application

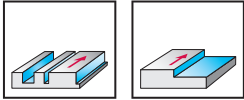
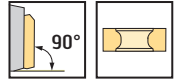
Porcupine milling cutters

M3255 inch

XNHX1306 .. R
Walter BLAXX



- Full effective design
- Two or four cutting edges per indexable insert, tangential arrangement



	P	M	K	N	S	H	O
M3255					●●		

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	M3255.051-B19-04-46	2,000	0.750	2,559	1,811	4	1,28	4 12	XNHX1306 .. R LNHX120604R
	M3255.051-B19-05-46	2,000	0.750	2,559	1,811	5	1,11	5 15	
	M3255.051-B26-04-57	2,000	1,000	3,375	2,244	4	1,83	4 16	
	M3255.051-B26-05-57	2,000	1,000	3,375	2,244	5	1,47	5 20	
	M3255.064-B26-05-46	2,500	1,000	2,756	1,811	5	2,30	5 15	
	M3255.064-B26-06-46	2,500	1,000	2,756	1,811	6	2,29	6 18	
	M3255.064-B26-05-68	2,500	1,000	3,550	2,677	5	2,72	5 25	
	M3255.076-B31-05-58	3,000	1,250	3,346	2,283	5	4,37	5 20	
	M3255.076-B31-06-58	3,000	1,250	3,346	2,283	6	4,20	6 24	
	M3255.076-B31-05-80	3,000	1,250	4,250	3,150	5	5,07	5 30	
	M3255.076-B31-06-80	3,000	1,250	4,250	3,150	6	5,17	6 36	

The FS2250 coolant nozzle must be secured to prevent it from coming loose.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts		D _c [inch]	2,000	2,000	2,500	2,500	3,000	3,000
		L _c [inch]	1,811	2,244	1,811	2,677	2,283	3,150
	Clamping screw for indexable insert Tightening torque		FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm	FS2299 (Torx 15IP) 4 Nm
	Coolant nozzle		FS2250 (SW 1,5)	FS2250 (SW 1,5)	FS2250 (SW 1,5)	FS2250 (SW 1,5)	FS2250 (SW 1,5)	FS2250 (SW 1,5)
	Clamping screw for arbour-mounted tools		FS1528	FS1614	FS1614	FS2567	FS2599	FS2568

Accessories		D _c [inch]	2,000-3,000
	Torque screwdriver, analogue Tightening torque		FS2004 1,5-5,0 Nm
	Torque screwdriver, digital Tightening torque		FS2248 1,0-6,0 Nm
	Interchangeable blade		FS2014 (Torx 15IP)
	Screwdriver		FS1485 (Torx 15IP)

Indexable inserts		r	b	P			M			K			N		S			
		mm	mm	HC			HC			HC			HC	HW	HC			
Designation				WKP25S	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45S
	LNHX120604R-L65T	0,4																
	XNHX130608R-L65T	0,8	2															
	XNHX130612R-L65T	1,2	2															
	XNHX130616R-L65T	1,6	2															
	XNHX130620R-L65T	2	2															
	XNHX130624R-L65T	2,4	2															
	XNHX130630R-L65T	3	1,4															
	XNHX130632R-L65T	3,2	1,3															
	XNHX130640R-L65T	4	0,5															

XNHX1306 . . . indexable inserts can only be used as front inserts.

HC = Coated carbide
HW = Uncoated carbide

WALTER
SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

•• Primary application

• Other application

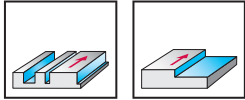
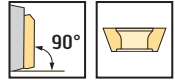
Porcupine milling cutters

M4258 mm

SDM . 120408



- Two or four cutting edges per indexable insert
- Half effective design with corner front piece



	P	M	K	N	S	H	O
M4258	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁₆ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Walter Capto™ in acc. with ISO 26623	M4258-050-C6-02-75-M	50	C6	110	88	77	2	1,3	14 2	SDM . 120408
	M4258-063-C8-02-96-M	63	C8	150	115	98	2	3,1	18 2	LDM . 1704 .. R
Walter Capto™ similar to ISO 26623 (without gripper groove)	M4258-080-C8-03-116-M	80	C8	150	150	118	3	3,9	33 3	SDM . 120408
										LDM . 1704 .. R

Body with 80 mm diameter: Adaptor without gripper groove
Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	D _c [mm]	50	63–80
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
	Clamping screw for front piece Tightening torque	FS370 (SW 10) 40 Nm	FS373 (SW 12) 120,0 Nm

Accessories

	D _c [mm]	50–80
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

	Designation	r mm	b mm	P			M			K				S		
				HC			HC			HC				HC		
				WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S
	LDMT170408R-D51	0,8	1,6	☺	☺	☺	☺									
	LDMT170408R-D57	0,8	1,6	☺	☺	☺	☺	☺								
	LDMT170408R-F57	0,8	1,6	☺	☺	☺	☺	☺	☺							
	LDMT170412R-D51	1,2	1,6		☺	☺	☺									☺
	LDMW170408R-A57	0,8	1,6	☺	☺	☺	☺									
	SDMT120408-D51	0,8		☺	☺	☺	☺									
	SDMT120408-D57	0,8		☺	☺	☺	☺									
	SDMT120408-F57	0,8		☺	☺	☺	☺									
	SDMW120408-A57	0,8		☺	☺	☺	☺		☺							

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

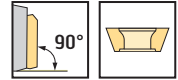
●● Primary application

● Other application

Porcupine milling cutter basic bodies

M4258 mm

SDM . 120408

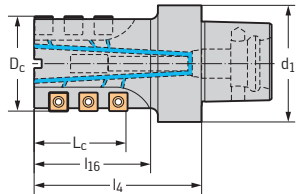
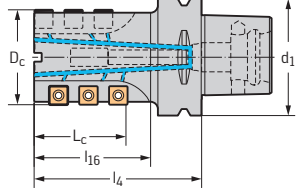


- Two or four cutting edges per indexable insert
- Basic body for porcupine milling cutters


	P	M	K	N	S	H	O
M4258	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁₆ mm	L _c mm	Z	kg	No. of indexable inserts	Type
Walter Capto™ in acc. with ISO 26623	M4258-050-C6-02-50-B	50	C6	85	62	52	2	1,2	10	SDM . 120408
	M4258-063-C8-02-60-B	63	C8	115	80	63	2	2,8	12	
Walter Capto™ similar to ISO 26623 (without gripper groove)	M4258-080-C8-03-80-B	80	C8	115	115	83	3	3,3	24	SDM . 120408





Body with 80 mm diameter: Adaptor without gripper groove
 Bodies and assembly parts are included in the scope of delivery.




Assembly parts

D _c [mm]		50–80
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm

Accessories

D _c [mm]		50–80
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	P			M			K			S					
		HC			HC			HC			HC					
		WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X	WSP45S
 SDMT120408-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW120408-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

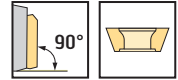
••
Primary application

•
Other application

Porcupine milling cutter front piece

M4258

SDM . 120408



- Two or four cutting edges per indexable insert
- Half effective design with corner front piece

	P	M	K	N	S	H	O
M4258	●●	●●	●●		●●		

Tool	Designation	D _c mm	L _c mm	Z	kg	No. of indexable inserts		Type
	M4258-050-P20-02-25-F	50	25	2	0,1	4	2	SDM . 120408 LDM . 1704 .. R
	M4258-063-P30-02-36-F	63	35	2	0,3	6	2	
	M4258-080-P40-03-36-F	80	35	3	0,6	9	3	

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

Assembly parts

D _c [mm]		50–80
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm

Accessories

D _c [mm]		50–80
	Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P			M			K			S				
			HC			HC			HC			HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X
	LDMT170408R-D51	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-D57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-F57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170412R-D51	1,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMW170408R-A57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D51	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●●
Primary application

●
Other application

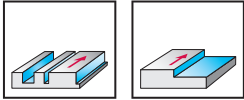
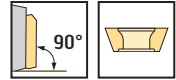
Porcupine milling cutters

M4258 inch

SDM . 120408



- Two or four cutting edges per indexable insert
- Half effective design with corner front piece



	P	M	K	N	S	H	O
M4258	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁₆ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Walter Capto™ in acc. with ISO 26623	M4258.051-C6-02-75-M	2,000	C6	4,331	3,445	3,031	2	2,9	14 2	SDM . 120408
	M4258.064-C8-02-96-M	2,500	C8	5,906	4,528	3,858	2	7,0	18 2	LDM . 1704 .. R
Walter Capto™ similar to ISO 26623 (without gripper groove)	M4258.076-C8-03-116-M	3,000	C8	5,906	5,906	4,646	3	8,0	33 3	SDM . 120408 LDM . 1704 .. R

Body with 3" diameter: Adaptor without gripper groove
Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	D _c [inch]	2,000	2,500-3,000
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
	Clamping screw for front piece Tightening torque	FS370 (SW 10) 40 Nm	FS373 (SW 12) 120,0 Nm

Accessories

	D _c [inch]	2,000-3,000
	Torque screwdriver, analogue Tightening torque	FS2004 1,5-5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0-6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

	Designation	r mm	b mm	P			M			K				S		
				HC			HC			HC				HC		
				WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S
	LDMT170408R-D51	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-D57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-F57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170412R-D51	1,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMW170408R-A57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMW170408R-A57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D51	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

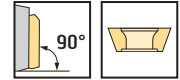
●● Primary application

● Other application

Porcupine milling cutter basic bodies

M4258 inch

SDM . 120408



- Two or four cutting edges per indexable insert
- Basic body for porcupine milling cutters

	P	M	K	N	S	H	O
M4258	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁₆ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Walter Capto™ in acc. with ISO 26623	M4258.051-C6-02-50-B	2,000	C6	3,346	2,441	2,047	2	2,6	10	SDM . 120408
	M4258.064-C8-02-60-B	2,500	C8	4,528	3,150	2,480	2	6,2	12	
Walter Capto™ similar to ISO 26623 (without gripper groove)	M4258.076-C8-03-80-B	3,000	C8	4,528	4,528	3,268	3	6,8	24	SDM . 120408

Body with 3" diameter: Adaptor without gripper groove
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

D _c [inch]		2,000-3,000
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm

Accessories

D _c [inch]		2,000-3,000
	Torque screwdriver, analogue Tightening torque	FS2004 1,5-5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0-6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	P			M			K			S					
		HC			HC			HC			HC					
		WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X	WSP45S
SDMT120408-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW120408-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

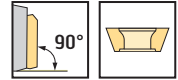
•• Primary application

• Other application

Porcupine milling cutter front piece

M4258 inch

SDM . 120408



- Two or four cutting edges per indexable insert
- Half effective design with corner front piece

	P	M	K	N	S	H	O
M4258	●●	●●	●●		●●		

Tool	Designation	D _c inch	L _c inch	Z	lbs	No. of indexable inserts		Type
	M4258.051-P20-02-25-F	2,000	0,984	2	0,3	4	2	SDM . 120408 LDM . 1704 .. R
	M4258.064-P30-02-36-F	2,500	1,378	2	0,7	6	2	
	M4258.076-P40-03-36-F	3,000	1,378	3	1,3	9	3	

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

Assembly parts

D _c [inch]		2,000–3,000
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm

Accessories

D _c [inch]		2,000–3,000
	Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	b mm	P			M			K			S				
			HC			HC			HC			HC				
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X
	LDMT170408R-D51	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-D57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170408R-F57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMT170412R-D51	1,2	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	LDMW170408R-A57	0,8	1,6	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D51	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

Accessories		D _c [mm]	63	63	80	80	80	100	100	100	125	125	125	160	160	200	250	500
		SB [mm]	1,5-2	3-4	1,5	2	3-4	1,5	2	3-4	1,5	2	3-4	2	3-4	3-4	3-4	5
	Drive collar		FS1346	FS2291	FS1347	FS2292		FS1348			FS1349				FS1350			
	Mounting wrench		FS2249			FS1494	FS2249	FS1494	FS2249		FS1494							
	Ergonomic mounting wrench					FS2290		FS2290			FS2290		FS2290					
	Clamping screw for retaining washer Tightening torque															FS966 (SW 5) 8,0 Nm		
	Retaining washer instead of drive collar															FS1351		
	Key for clamping screw																ISO2936-5 (SW 5)	

Drive collars and retaining washers should always be ordered in pairs (two pieces).
Clamping screws for retaining washers are included in the scope of delivery.

Cutting inserts

Designation	s mm	r mm	P					M					K				N			S					
			HC					HC					HC				HC			HC					
			WKP23S	WKP25S	WSM33S	WKP35S	WSM43S	WSP45S	WSM23S	WSM33S	WSM35S	WSM43S	WSP45S	WAK15	WKP23S	WKK25S	WKP25S	WKP35S	WXN15	WK10	WK1	WSM23S	WSM33S	WSM35S	WSM43S
SX-2E200N02-CE4	2	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-3E300N02-CE4	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-1E150N01-CE4	1,5	0,15		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-4E400N02-CE4	4	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-5E500N04-CE4	5	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-2E200N02-CF6	2	0,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-3E300N02-CF6	3	0,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-2E200N02-SF5	2	0,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-3E300N02-SF5	3	0,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-1E150N01-SF5	1,5	0,15		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-4E400N02-SF5	4	0,2		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-5E500N04-SF5	5	0,4		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-2E200N02-SK8	2	0,2																		☺					
SX-3E300N02-SK8	3	0,2																		☺					
SX-1E150N01-SK8	1,5	0,1																		☺					
SX-4E400N02-SK8	4	0,2																		☺					
SX-5E500N04-SK8	5	0,4																		☺					

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

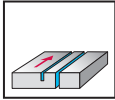
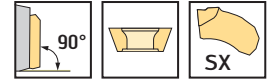
● Other application

C 2

Slitting and slot milling cutters

F5055 mm
Walter BLAXX


– One cutting edge per indexable insert



	P	M	K	N	S	H	O
F5055	●	●	●	●	●		

Tool	Designation	D _c mm	d ₁ mm	d ₆ mm	l ₄ mm	SB mm	a _e mm	Z	kg	No. of indexable inserts	Type	
ScrewFit 	F5055.T36.063.Z04.3,0R	63	T36		75	3	15	4	0,6	4	SX-3	
	F5055.T36.063.Z04.4,0R	63	T36		76	4	15	4	0,6	4	SX-4	
	F5055.T45.080.Z06.3,0R	80	T45		85	3	19	6	0,8	6	SX-3	
	F5055.T45.080.Z06.4,0R	80	T45		86	4	19	6	0,8	6	SX-4	
Parallel bore DIN 138 transverse keyway 	F5055.BN16.063.Z04.3,0R	63	16	35	40	3	15	4	0,03	4	SX-3	
	F5055.BN16.080.Z06.3,0R	80	16	40	40	3	19	6	0,06	6		
	F5055.BN22.100.Z09.3,0R	100	22	48	40	3	25	9	0,10	9		
	F5055.BN32.125.Z11.3,0R	125	32	58	50	3	33	11	1	11		
	F5055.BN40.160.Z14.3,0R	160	40	80	63	3	38	14	0,25	14		
												SX-4
	F5055.BN16.063.Z04.4,0R	63	16	35	41	4	15	4	0,05	4		
	F5055.BN16.080.Z06.4,0R	80	16	40	41	4	19	6	0,46	6		
	F5055.BN22.100.Z09.4,0R	100	22	48	41	4	25	9	0,14	9		
	F5055.BN32.125.Z11.4,0R	125	32	58	51	4	33	11	0,24	11		
	F5055.BN40.160.Z14.4,0R	160	40	80	64	4	38	14	0,40	14		

For fitting the indexable insert, use the FS1494 or FS2249 mounting wrench
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Type D _c [mm]	SX-3/SX-4 63	SX-3/SX-4 80	SX-3/SX-4 100	SX-3/SX-4 125	SX-3/SX-4 160
	Bore adaptor part		AA704-B16-G16-040-A	AA704-B16-G16-040-B	AA704-B22-G22-040-B	AA704-B32-G32-050-B	AA704-B40-G40-063-B
	NCT ScrewFit adaptor		AA766-T36-G16-040	AA766-T45-G16-050			

Accessories		Type D _c [mm]	SX-3/SX-4 63	SX-3/SX-4 80-100	SX-3/SX-4 125	SX-3/SX-4 160
	Clamping screw for adaptor		FS938 (SW 6)	FS938 (SW 6)	FS938 (SW 6)	FS938 (SW 6)
	Clamping screw for milling cutter		FS2270 (Torx 15IP)	FS2270 (Torx 15IP)	FS2271 (Torx 20IP)	FS2272 (Torx 30IP)
	Tightening torque		6,5 Nm	6,5 Nm	7 Nm	8 Nm
	Mounting wrench for cutting insert		FS2249	FS1494	FS1494	FS1494
	Ergonomic mounting wrench			FS2290	FS2290	FS2290
	Torque T-handle		FS2041	FS2041	FS2041	FS2041
	Tightening torque		4,5-14 Nm	4,5-14 Nm	4,5-14 Nm	4,5-14 Nm
	Screwdriver		FS1485 (Torx 15IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1175 (Torx 30)
	Adaptor clamping screw Allen key		ISO2936-6 (SW 6)	ISO2936-6 (SW 6)	ISO2936-6 (SW 6)	ISO2936-6 (SW 6)
	Interchangeable blade		FS2047 (Torx 15IP)	FS2047 (Torx 15IP)	FS2048 (Torx 20IP)	FS2046 (Torx 30)

Cutting inserts		s	r	P						M					K				N			S					
Designation		mm	mm	HC						HC					HC				HC			HC					
				WKP23S	WKP25S	WSM33S	WKP35S	WSM43S	WSP45S	WSM23S	WSM33S	WSM35S	WSM43S	WSP45S	WAK15	WKP23S	WKK25S	WKP25S	WKP35S	WXN15	WK10	WK1	WSM23S	WSM33S	WSM35S	WSM43S	WSP45S
	SX-3E300N02-CE4	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-4E400N02-CE4	4	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-3E300N02-CF6	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-3E300N02-SF5	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-4E400N02-SF5	4	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-3E300N02-SK8	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SX-4E400N02-SK8	4	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

C 2

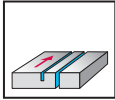
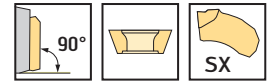
Slitting and slot milling cutters

F5055 inch

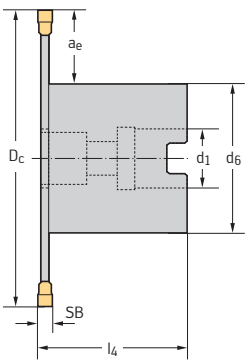
Walter BLAXX



– One cutting edge per indexable insert



	P	M	K	N	S	H	O
F5055	●	●	●	●	●	●	●

Tool	Designation	D _c Inch	d ₁ Inch	d ₆ Inch	l ₄ Inch	SB Inch	a _e Inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway 	F5055.UBN16.063.Z04.3.0R	2,480	0,500	1,378	1,575	0,118	0,591	4	0,6	4	SX-3
	F5055.UBN16.080.Z06.3.0R	3,150	0,500	1,575	1,575	0,118	0,748	6	0,9	6	
	F5055.UBN22.100.Z09.3.0R	3,937	0,750	1,575	1,575	0,118	0,984	9	1,3	9	
	F5055.UBN32.125.Z11.3.0R	4,921	1,000	3,150	1,969	0,118	1,299	11	2,3	11	
	F5055.UBN40.160.Z14.3.0R	6,299	1,500	2,283	2,480	0,118	1,496	14	4,8	14	
	F5055.UBN16.063.Z04.4.0R	2,480	0,500	1,378	1,614	0,157	0,591	4	0,6	4	
	F5055.UBN16.080.Z06.4.0R	3,150	0,500	3,150	1,614	0,157	0,748	6	1,0	6	
	F5055.UBN22.100.Z09.4.0R	3,937	0,750	1,890	1,614	0,157	0,984	9	1,4	9	
	F5055.UBN32.125.Z11.4.0R	4,921	1,000	1,890	2,008	0,157	1,299	11	4,4	11	
	F5055.UBN40.160.Z14.4.0R	6,299	1,500	2,283	2,520	0,157	1,496	14	5,1	14	

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

Assembly parts		Type D _c [inch]	SX-3/SX-4 2,480	SX-3/SX-4 3,150	SX-3/SX-4 3,937	SX-3/SX-4 4,921	SX-3/SX-4 6,299
	Bore adaptor part		AA704.B13-G16-040-A	AA704.B13-G16-040-B	AA704.B19-G22-040-B	AA704.B26-G32-050-B	AA704.B38-G40-062-B

Accessories		Type D _c [inch]	SX-3/SX-4 2,480	SX-3/SX-4 3,150	SX-3/SX-4 3,937	SX-3/SX-4 4,921	SX-3/SX-4 6,299
	Clamping screw for adaptor		FS938 (SW 6)	FS938 (SW 6)	FS939 (SW 8)	FS941 (SW 14)	FS942 (SW 17)
	Clamping screw for milling cutter		FS2270 (Torx 15IP)	FS2270 (Torx 15IP)	FS2270 (Torx 15IP)	FS2271 (Torx 20IP)	FS2272 (Torx 30IP)
	Tightening torque		6,5 Nm	6,5 Nm	6,5 Nm	7 Nm	8 Nm
	Mounting wrench for cutting insert		FS2249	FS1494	FS1494	FS1494	FS1494
	Ergonomic mounting wrench			FS2290	FS2290	FS2290	FS2290
	Adaptor clamping screw Allen key		ISO2936-6 (SW 6)	ISO2936-6 (SW 6)	ISO2936-6 (SW 6)	ISO2936-6 (SW 6)	ISO2936-6 (SW 6)
	Torque T-handle		FS2041	FS2041	FS2041	FS2041	FS2041
	Tightening torque		4,5–14 Nm	4,5–14 Nm	4,5–14 Nm	4,5–14 Nm	4,5–14 Nm
	Screwdriver		FS1485 (Torx 15IP)	FS1485 (Torx 15IP)	FS1485 (Torx 15IP)	FS1486 (Torx 20IP)	FS1175 (Torx 30)
	Interchangeable blade		FS2047 (Torx 15IP)	FS2047 (Torx 15IP)	FS2047 (Torx 15IP)	FS2048 (Torx 20IP)	FS2046 (Torx 30)

Designation	s mm	r mm	P						M					K				N			S				
			HC						HC					HC				HC			HC				
			WKP23S	WKP25S	WSM33S	WKP35S	WSM43S	WSP45S	WSM23S	WSM33S	WSM35S	WSM43S	WSP45S	WAK15	WKP23S	WKK25S	WKP25S	WKP35S	WXN15	WK10	WK1	WSM23S	WSM33S	WSM35S	WSM43S
SX-3E300N02-CE4	3	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-4E400N02-CE4	4	0,2	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SX-3E300N02-CF6	3	0,2			☺	☺																☺	☺	☺	☺
SX-3E300N02-SF5	3	0,2			☺	☺																☺	☺	☺	☺
SX-4E400N02-SF5	4	0,2			☺	☺																☺	☺	☺	☺
SX-3E300N02-SK8	3	0,2																	☺						
SX-4E400N02-SK8	4	0,2																☺							

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

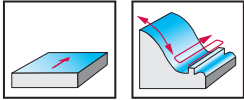
●● Primary application

● Other application

Copy milling cutters with round inserts

M2471 mm


– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M2471	●●	●●	●	●	●●	●	●

Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	l ₁ mm	Z	kg	No. of indexable inserts	Type
ScrewFit 	★ M2471-025-T22-03-05	5	25	T22	35	5		3	0,1	3	RNMX1005M0
	★ M2471-032-T28-04-05	5	32	T28	40	5		4	0,2	4	RNMX1005M0
	M2471-032-T28-03-06	6	32	T28	40	6		3	0,2	3	RNMX1206M0
	M2471-040-T36-04-06	6	40	T36	40	6		4	0,3	4	RNMX1206M0
Parallel shank 	★ M2471-025-A25-03-05-L	5	25	25	60	5	150	3	0,5	3	RNMX1005M0
	★ M2471-032-A32-04-05	5	32	32	70	5	131	4	0,7	4	RNMX1005M0
Parallel bore DIN 138 transverse keyway 	★ M2471-040-B16-05-05	5	40	16	40	5		5	0,2	5	RNMX1005M0
	★ M2471-050-B22-06-05	5	50	22	40	5		6	0,4	6	RNMX1005M0
	M2471-050-B22-05-06	6	50	22	40	6		5	0,5	5	RNMX1206M0
	★ M2471-052-B22-06-05	5	52	22	40	5		6	0,4	6	RNMX1005M0
	M2471-052-B22-05-06	6	52	22	40	6		5	0,4	5	RNMX1206M0
	M2471-063-B22-07-06	6	63	22	40	6		7	0,4	7	RNMX1206M0

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

Assembly parts

Type	RNMX1005M0	RNMX1206M0
 Clamping screw for indexable insert Tightening torque	FS2079 (Torx 9IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	RNMX1005M0	RNMX1206M0
 Torque screwdriver, analogue Tightening torque	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2013 (Torx 9IP)	FS2014 (Torx 15IP)
 Screwdriver	FS1484 (Torx 9IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	d mm	P		M		K			N		S		
		HC		HC		HC			HC	HW	HC		
		WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S
RNMX1005M0-G57	10			✘	✘	✘						✘	✘
RNMX1005M0-K67	10			✘	✘	✘						✘	✘
RNMX1206M0-G57	12			✘	✘	✘						✘	✘
RNMX1206M0-K67	12			✘	✘	✘						✘	✘

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

Very good

Good

Moderate

•• Primary application

• Other application

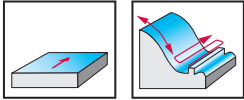
Copy milling cutters with round inserts

M2471 inch

RNMX1206M0

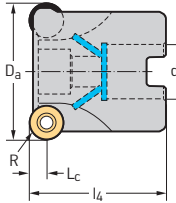


– Eight cutting edges per indexable insert



	P	M	K	N	S	H	O
M2471	●●	●●	●	●	●●	●	●

Tool	Designation	R inch	D _a inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
Parallel bore DIN 138 transverse keyway	M2471.051-B19-05-06	0,236	2,000	0,750	1,500	0,236	5	0,6	5	RNMX1206M0
	M2471.064-B26-07-06	0,236	2,500	1,000	1,750	0,236	7	1,3	7	



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

Assembly parts

D _a [inch]		2,000	2,500
	Clamping screw for indexable insert Tightening torque	FS1453 (Torx 15IP) 3,5 Nm	FS1453 (Torx 15IP) 3,5 Nm
	Clamping screw for arbour-mounted tools	FS1523	FS1586

Accessories

D _a [inch]		2,000–2,500
	Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2014 (Torx 15IP)
	Screwdriver	FS1485 (Torx 15IP)

Indexable inserts

Designation	d mm	P		M		K		N		S			
		HC		HC		HC		HC	HW	HC			
		WKP25S	WKP35S	WSP45S	WSM35S	WSP45S	WAK15	WKK25S	WKP25S	WKP35S	WXN15	WK10	WSM35S
	RNMX1206M0-G57			☒	☒							☒	☒
	RNMX1206M0-K67			☒	☒							☒	☒

HC = Coated carbide
HW = Uncoated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☹
Good

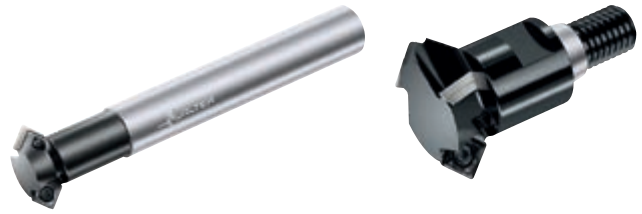
☹
Moderate

●● Primary application

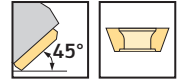
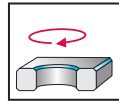
● Other application

Chamfer milling cutter

M4574



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4574	●●	●●	●●	●●	●●		

Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type	
ScrewFit 	M4574-012-T09-02-03	12	20,3	T09	20		3,5	2	0,03	2	SDM . 06T204	
	M4574-016-T14-03-03	16	24,3	T14	25		3,5	3	0,28	3		
	M4574-020-T18-02-05	20	32,8	T18	30		5,5	2	0,09	2		
		M4574-025-T22-03-05	25	37,8	T22	35		5,5	3	0,14	3	SDM . 09T308
		M4574-032-T28-03-05	32	44,8	T28	40		5,5	3	0,24	3	
		M4574-032-T28-03-07	32	48,6	T28	40		7,5	3	0,23	3	SDM . 120408
Cylindrical, modular 	★ M4574-012-TC06-02-03	12	20,3	M6	20		3,5	2	0,04	2	SDM . 06T204	
	★ M4574-016-TC08-03-03	16	24,3	M8	25		3,5	3	0,03	3		
	★ M4574-020-TC10-02-05	20	32,8	M10	30		5,5	2	0,07	2		
		★ M4574-025-TC12-03-05	32	37,8	M12	35		5,5	3	0,11	3	SDM . 09T308
		★ M4574-032-TC16-03-05	32	44,8	M16	40		5,5	3	0,21	3	
		★ M4574-032-TC16-03-07	32	48,6	M16	40		7,5	3	0,19	3	SDM . 120408
Parallel shank 	M4574-008-A12-01-03	8	16,3	12	30	120	3,5	1	0,11	1	SDM . 06T204	
	M4574-010-A12-01-03	10	18,3	12	30	120	3,5	1	0,11	1		
	M4574-012-A16-02-03	12	20,3	16	40	160	3,5	2	0,24	2		
		M4574-012-A16-01-05	12	24,8	16	40	160	5,5	1	0,25	1	SDM . 09T308
		M4574-016-A16-03-03	16	24,3	16	40	160	3,5	3	0,24	3	SDM . 06T204
		M4574-016-A16-02-05	16	28,8	16	40	160	5,5	2	0,25	2	
		M4574-020-A20-02-05	20	32,8	20	40	200	5,5	2	0,50	2	SDM . 09T308
		M4574-025-A25-03-05	25	37,8	25	40	200	5,5	3	0,75	3	
		M4574-025-A25-02-07	25	41,6	25	40	200	7,5	2	0,75	2	SDM . 120408
		M4574-032-A32-03-05	32	44,8	32	40	250	5,5	3	1,52	3	SDM . 09T308
		M4574-032-A32-03-07	32	48,6	32	40	250	7,5	3	1,54	3	SDM . 120408
		M4574-040-A32-04-05	40	52,8	32	40	250	5,5	4	1,56	4	SDM . 09T308
		M4574-040-A32-03-07	40	56,6	32	40	250	7,5	3	1,63	3	SDM . 120408

Tools with parallel shank can be shortened depending on the application.
Bodies and assembly parts are included in the scope of delivery.

/ ★ New addition to the product range

Assembly parts

Type	SDM . 06T204	SDM . 09T308	SDM . 120408
 Clamping screw for indexable insert Tightening torque	FS2084 (Torx 7IP) 0,9 Nm	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories

Type	SDM . 06T204	SDM . 09T308	SDM . 120408
 Torque screwdriver, analogue Tightening torque	FS2001 0,4–1,2 Nm	FS2003 1,5–5,0 Nm	FS2003 1,5–5,0 Nm
 Torque screwdriver, digital Tightening torque		FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
 Interchangeable blade	FS2011 (Torx 7IP)	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
 Screwdriver	FS2088 (Torx 7IP)	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts

Designation	r mm	P			M			K			S					
		HC			HC			HC			HC					
		WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X	WSP45S
SDMT06T204-D51	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT06T204-D57	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT06T204-F57	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW06T204-A57	0,4	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT09T308-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT09T308-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT09T308-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW09T308-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMT120408-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
SDMW120408-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

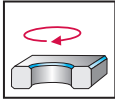
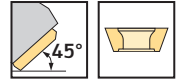
● Other application

Chamfer milling cutter

M4574 inch



– Four cutting edges per indexable insert



	P	M	K	N	S	H	O
M4574	●	●	●	●	●		

Tool	Designation	D_c	D_a	d_1	l_4	l_1	L_c	Z	lbs	No. of indexable inserts	Type
		inch	inch	inch	inch	inch	inch				
Parallel shank 	M4574.013-A15-01-05	0,500	0,976	0,625	1,575	6,299	0,217	1	0,53	1	SDM . 09T308
	M4574.019-A19-02-05	0,750	1,224	0,750	1,575	7,874	0,217	2	1,02	2	
	M4574.026-A26-03-05	1,000	1,476	1,000	1,575	7,874	0,217	3	1,64	3	
	M4574.031-A31-03-05	1,250	1,724	1,250	1,575	9,843	0,217	3	3,25	3	
	M4574.038-A38-03-07	1,500	2,154	1,500	1,575	9,843	0,295	3	4,64	3	SDM . 120408

Tools with parallel shank can be shortened depending on the application.
Bodies and assembly parts are included in the scope of delivery.

Assembly parts		SDM . 09T308	SDM . 120408
	Type Clamping screw for indexable insert Tightening torque	FS2266 (Torx 10IP) 2,0 Nm	FS1453 (Torx 15IP) 3,5 Nm

Accessories		SDM . 09T308	SDM . 120408
	Torque screwdriver, analogue Tightening torque	FS2004 1,5–5,0 Nm	FS2004 1,5–5,0 Nm
	Torque screwdriver, digital Tightening torque	FS2248 1,0–6,0 Nm	FS2248 1,0–6,0 Nm
	Interchangeable blade	FS2268 (Torx 10IP)	FS2014 (Torx 15IP)
	Screwdriver	FS2267 (Torx 10IP)	FS1485 (Torx 15IP)

Indexable inserts			P			M			K			S					
			HC			HC			HC			HC					
			WKP25S	WKP35G	WKP35S	WSP45S	WSM35S	WSM45X	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WSM35S	WSM45X	WSP45S
Designation		r mm															
	SDMT09T308-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T308-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT09T308-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW09T308-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D51	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-D57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMT120408-F57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
	SDMW120408-A57	0,8	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

HC = Coated carbide

WALTER SELECT

Stability of machine, workpiece and clamping arrangement

☺
Very good

☺
Good

☺
Moderate

●● Primary application

● Other application

Cutting data for roughing

WKP35G / WMP45G / WEP 20

Material group	Overview of the 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]		
							HT Face milling	WEP20 a _e / D _c *	
							1/1 1/2	1/5	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	428	P1	● ●●	250	300
		C > 0.25 ... ≤ 0.55%	Annealed	190	639	P2	● ●●	200	250
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	708	P3	● ●●	200	250
		C > 0.55%	Annealed	190	639	P4	● ●●	200	250
		C > 0.55%	Heat-treated	300	1013	P5	● ●●	150	210
		Free-machining steel (short-chipping)	Annealed	220	745	P6	● ●●	200	250
	Low-alloy steel		Annealed	175	591	P7	● ●●	150	210
			Heat-treated	300	1013	P8	● ●●	150	210
			Heat-treated	380	1282	P9	● ●●	150	210
			Heat-treated	430	1477	P10	● ●●	200	250
	High-alloyed steel and high-alloyed tool steel		Annealed	200	675	P11	● ●●	150	210
			Hardened and tempered	300	1013	P12	● ●●	150	210
			Hardened and tempered	400	1361	P13	● ●●	150	210
	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	● ●●			
N	Wrought aluminium alloys	Not hardenable	30	-	N1	●●			
		Hardenable, hardened	100	343	N2	●●			
	Cast aluminium alloys	≤ 12% Si, not hardenable	75	260	N3	●●			
		≤ 12% Si, hardenable, hardened	90	314	N4	●●			
		> 12% Si, not hardenable	130	447	N5	●●			
	Magnesium-based alloys ³		70	250	N6	●●			
	Copper and copper alloys (bronze/brass)	Unalloyed, electrolytic copper	100	343	N7	●●			
		Brass, bronze, red brass	90	314	N8	●●			
		Cu alloys, short-chipping	110	382	N9	●●			
		High tensile, Ampco	300	1013	N10	●●			
S	Heat-resistant alloys	Fe-based	Annealed	200	675	S1	●●		
			Hardened	280	943	S2	●●		
		Ni- or Co-based	Annealed	250	839	S3	●●		
			Hardened	350	1177	S4	●●		
			Cast	320	1076	S5	●●		
	Titanium alloys	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			O1	●● ●			
	Thermosets	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 is regarded as starting values for the recommended application)
- Possible application, reduce cutting data by 30–50% (increase by approx. 70–80% for ISO M)

¹ The classification of the machining groups can be found from page C 671 onwards in the Walter General Catalogue 2017.

² Cutting data can also be used without coolant.

* a_e / D_c = 1 / 10, v_c = 10% higher than 1 / 5

³ Water-miscible coolants must not be used when machining magnesium-based alloys.

Feed determination (starting values)

Cutter type	M3024	M4003	M5008	
	<p>Feed per tooth f_{z0} for $a_e = D_c$ $a_p = a_{p \max} = L_c$</p>			
Material group				
Lead angle κ	43°	45°		0°–20°
Tool diameter or diameter range [mm]	f_{z0} [mm] 63–160	f_{z0} [mm] 20–100	f_{z0} [mm] 25–160	f_{z0} [mm] 16–66
Maximum depth of cut $a_{p \max} = L_c$ [mm]	6.0	4.5	6.5	1
P Non-alloyed steel ¹	0,45	0,20	0,25	0,80
Low-alloy steel	0,40	0,15	0,20	0,80
High-alloyed steel and tool steel	0,32	0,15	0,20	0,72
Stainless steel	0,22	0,12	0,15	0,32
M Stainless steel ²	0,17	0,10	0,12	0,24
Malleable cast iron	0,32	0,20	0,25	0,24
K Grey cast iron	0,55	0,25	0,30	0,96
Cast iron with spheroidal graphite	0,45	0,20	0,25	0,80
GGV (CGI)	0,27	0,17	0,20	0,80
N Wrought aluminium alloys		0,12	0,15	
Cast aluminium alloys		0,12	0,15	
Magnesium-based alloys		0,10	0,12	
Copper and copper alloys (bronze/brass)		0,10	0,12	
S Heat-resistant alloys		0,10	0,12	0,32
Titanium alloys		0,10	0,12	0,32
Tungsten alloys		0,10	0,12	0,32
Molybdenum alloys		0,10	0,12	0,32
H Hardened steel				0,24
Hardened cast iron				0,26
O Thermoplastics		0,10	0,15	
Plastic, carbon-fibre-reinforced			0,15	
Graphite (technical)		0,10		
Indexable insert types	XNMU0906..	SD..09T3AZN..	SD..1204AZN..	ENMX08T316R..
Correction factor K_{a_e}	$a_e / D_c =$	1,0	1,0	1,0
	1/1–1/2	1,1	1,1	1,1
	1/5	1,2	1,2	1,2
For the feed per tooth depending on the ratio of width of cut a_e to milling cutter diameter D_c	1/10	1,3	1,3	1,3
	1/20			
	1/50			
Correction factor K_{a_p} for the feed per tooth depending on the depth of cut a_p	$a_p =$			
	1			
	2			
	3			
	4			
	6			
	8			
$f_z = f_{z0} \cdot K_{a_e} \cdot K_{a_p}$	$a_{p \max} = L_c$			

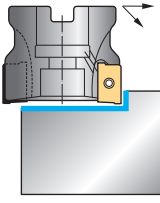
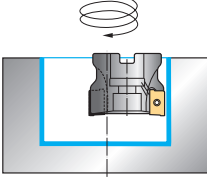
¹ and cast steel

² and austenitic/ferritic

* only possible if $a_p < 0.75 \times D_c$

** Only with $a_e/D_c < 1/5$

Feed determination (starting values)

Material group	Cutter type	M4130																																															
	Feed per tooth f_{z0} for $a_e = D_c$ $a_p = a_{p\max} = L_c$ Lead angle k	 For shoulder milling operations			 For circular interpolation milling operations																																												
		90°			90°																																												
		f_{z0} [mm]	f_{z0} [mm]	f_{z0} [mm]	f_{z0} [mm]	f_{z0} [mm]	f_{z0} [mm]																																										
	Tool diameter or diameter range [mm]	16–25	32–50	50–100	16–20	25–50	50–100																																										
	Maximum depth of cut $a_{p\max} = L_c$ [mm]	8	13	16	8	13	16																																										
P	Non-alloyed steel ¹	0.15	0.20	0.25	0.13	0.17	0.22																																										
	Low-alloy steel	0.10	0.15	0.17	0.09	0.13	0.17																																										
	High-alloyed steel and tool steel	0.10	0.15	0.17	0.09	0.13	0.17																																										
	Stainless steel	0.08	0.12	0.15	0.07	0.10	0.13																																										
M	Stainless steel ²	0.08	0.10	0.12	0.07	0.09	0.10																																										
K	Malleable cast iron	0.12	0.20	0.25	0.10	0.17	0.22																																										
	Grey cast iron	0.15	0.25	0.30	0.13	0.22	0.27																																										
	Cast iron with spheroidal graphite	0.12	0.20	0.25	0.10	0.17	0.22																																										
	GGV (CGI)	0.10	0.15	0.17	0.10	0.17	0.22																																										
N	Wrought aluminium alloys																																																
	Cast aluminium alloys																																																
	Magnesium-based alloys																																																
	Copper and copper alloys (bronze/brass)																																																
S	Heat-resistant alloys	0.08	0.12	0.15	0.07	0.10	0.13																																										
	Titanium alloys	0.08	0.12	0.15	0.07	0.10	0.13																																										
	Tungsten alloys	0.08	0.12	0.15	0.07	0.10	0.13																																										
	Molybdenum alloys	0.08	0.12	0.15	0.07	0.10	0.13																																										
H	Hardened steel																																																
	Hardened cast iron																																																
O	Thermoplastics	0.12	0.17	0.20	0.12	0.17	0.20																																										
	Plastic, carbon-fibre-reinforced																																																
	Graphite (technical)	0.10	0.15	0.15	0.10	0.15	0.15																																										
	Indexable insert types	LD..08T2..	LD..14T3..	LD..1704..	LD..08T2..	LD..14T3..	LD..1704..																																										
	Correction factor K_{a_e}	$a_e / D_c =$ <table border="1"> <tr><td>1/1–1/2</td><td>1.0</td><td>1.0</td><td>1.0</td><td>1.0</td><td>1.0</td><td>1.0</td></tr> <tr><td>1/5</td><td>1.1</td><td>1.1</td><td>1.1</td><td>1.1</td><td>1.1</td><td>1.1</td></tr> <tr><td>1/10</td><td>1.2</td><td>1.2</td><td>1.2</td><td>1.2</td><td>1.2</td><td>1.2</td></tr> <tr><td>1/20</td><td>1.3</td><td>1.3</td><td>1.3</td><td>1.3</td><td>1.3</td><td>1.3</td></tr> <tr><td>1/50</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> </table>						1/1–1/2	1.0	1.0	1.0	1.0	1.0	1.0	1/5	1.1	1.1	1.1	1.1	1.1	1.1	1/10	1.2	1.2	1.2	1.2	1.2	1.2	1/20	1.3	1.3	1.3	1.3	1.3	1.3	1/50													
1/1–1/2	1.0	1.0	1.0	1.0	1.0	1.0																																											
1/5	1.1	1.1	1.1	1.1	1.1	1.1																																											
1/10	1.2	1.2	1.2	1.2	1.2	1.2																																											
1/20	1.3	1.3	1.3	1.3	1.3	1.3																																											
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	For the feed per tooth depending on the ratio of width of cut a_e to milling cutter diameter D_c																																																
	Correction factor K_{a_p} for the feed per tooth depending on the depth of cut a_p	$a_p =$ <table border="1"> <tr><td>1</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr><td>2</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr><td>3</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr><td>4</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr><td>6</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr><td>8</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> </table>						1							2							3							4							6							8						
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¹ and cast steel
² and austenitic/ferritic
^{*} only possible if $a_p < 0.75 \times D_c$
^{**} Only with $a_e/D_c < 1/5$

Feed determination (starting values)

The specified feed rates are average standard values.
For specific applications, adjustment is recommended.

Cutter type		F5055				
Material group	Feed per tooth f_{z0} for plunging, central positioning					
	Lead angle κ	90°				
		f_{z0} [mm]				
	Tool diameter or diameter range [mm]	63–125	63–160	63–250	63–250	500
	Maximum cutting width SB [mm]	1,5	2,0	3,0	4,0	5,0
P	Non-alloyed steel ¹	0,06	0,08	0,10	0,12	0,12
	Low-alloy steel	0,06	0,07	0,09	0,11	0,10
	High-alloyed steel and tool steel	0,06	0,07	0,09	0,11	0,10
	Stainless steel	0,05	0,06	0,08	0,09	0,05
M	Stainless steel ²	0,05	0,06	0,08	0,09	0,05
K	Malleable cast iron	0,06	0,07	0,09	0,11	0,12
	Grey cast iron	0,06	0,08	0,10	0,12	0,14
	Cast iron with spheroidal graphite GGV (CGI)	0,06	0,07	0,09	0,11	0,12
						0,10
N	Wrought aluminium alloys					0,12
	Cast aluminium alloys					0,10
	Magnesium-based alloys ³					0,10
	Copper and copper alloys (bronze/brass)					0,10
S	Heat-resistant alloys	0,05	0,06	0,08	0,09	0,05
	Titanium alloys	0,05	0,06	0,08	0,09	0,05
	Tungsten alloys	0,05	0,06	0,08	0,09	0,05
	Molybdenum alloys	0,05	0,06	0,08	0,09	0,05
H	Hardened steel					
	Hardened cast iron					
O	Thermoplastics					
	Plastic, carbon-fibre-reinforced					
	Graphite (technical)					
Indexable insert types		SX-1E15..	SX-2E20..	SX-3E30..	SX-4E40..	SX-5E50..
Correction factor K_{ae} for the feed per tooth depending on the ratio of depth of cut a_e to milling cutter diameter D_c	central	1,5	1,5	1,5	1,5	
	$a_e / D_c = 1/3$	1,8	1,8	1,8	1,8	1,0
	$1/5$	2,5	2,5	2,5	2,5	1,2
	$1/10$	3,3	3,3	3,3	3,3	1,4
	$1/20$	5,8	5,8	5,8	5,8	1,5
	$1/50$	5,8	5,8	5,8	5,8	5,8
$f_z = f_{z0} \cdot K_{ae}$						

¹ and cast steel

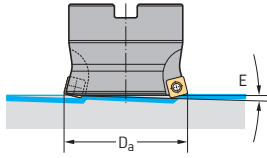
² and austenitic/ferritic

³ Water-miscible coolants must not be used when machining magnesium-based alloys

Please note: The feed per tooth f_z should not exceed 0.6 mm

Application information for M4002/F2010 high-feed face milling cutters

Ramping



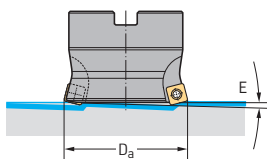
Maximum feed angle E [°]

D _a [mm]	SD..06T2..						ZDR
	r = 0,4	r = 0,8	r = 1,2	r = 1,6	r = 2,0	r = 2,5	
20	3,7	2,9	2,2				1,5
25	2,2	1,8	1,4				0,6
32	1,3	1	0,7				0,4
35	1,2	1	0,7				0,5
40	1,1	0,9	0,7				0,3
42	0,8	0,7	0,5				0,3
50	0,8	0,7	0,5				0,3
52	0,7	0,6	0,5				0,3
63	0,6	0,4	0,3				0,2
66	0,5	0,4	0,3				0,2

D _a [mm]	SD..09T3..						ZDR
	r = 0,4	r = 0,8	r = 1,2	r = 1,6	r = 2,0	r = 2,5	
25	4,3	3,5	2,8	2,3	1,2		1,2
32	3,6	3,1	2,7	2,3	1,9		1,8
35	2,9	2,5	2,2	1,9	1,5		1,6
40	2,2	1,9	1,6	1,4	1,2		1,2
42	2	1,7	1,5	1,3	1		1
50	1,5	1,3	1,1	1	0,8		0,8
52	1,3	1,2	1	0,8	0,7		0,7
63	1	0,8	0,7	0,6	0,5		0,5
66	0,9	0,8	0,7	0,6	0,4		0,4

D _a [mm]	SD..120408..						ZDR
	r = 0,4	r = 0,8	r = 1,2	r = 1,6	r = 2,0	r = 2,5	
50		1,9	1,7	1,5	1,3	1	1
52		1,8	1,6	1,4	1,2	0,9	0,9
63		1,2	1,1	0,9	0,8	0,6	0,6
66		1,1	1	0,9	0,7	0,6	0,6
80		0,8	0,7	0,6	0,5	0,4	0,4
85		0,7	0,7	0,6	0,5	0,4	0,3
100		0,5	0,4	0,4	0,3	0,2	0,2
125		0,4	0,4	0,3	0,3	0,2	0,2

Ramping



Maximum feed angle E [°]

D _a [inch]	SD..06T2..						ZDR
	r = 0.016	r = 0.031	r = 0.047	r = 0.063	r = 0.079	r = 0.098	
0.750	4,2	3,3	2,5				1,5
1.000	2,2	1,6	1,2				0,7
1.250	1,4	1,1	0,8				0,5
1.500	1,2	0,9	0,7				0,3
2.000	0,7	0,6	0,4				0,3
2.500	0,4	0,3	0,2				0,1

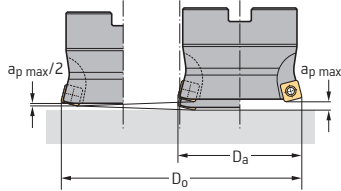
D _a [inch]	SD..09T3..						ZDR
	r = 0.016	r = 0.031	r = 0.047	r = 0.063	r = 0.079	r = 0.098	
1.000	4	3,3	2,6	1,9	1,3		1,2
1.250	3,6	3,2	2,8	2,3	2		2
1.500	2,4	2,1	1,8	1,5	1,3		1,3
2.000	1,4	1,2	1	0,9	0,7		0,7
2.500	1	0,8	0,7	0,6	0,5		0,5

D _a [inch]	SD..1204..						ZDR
	r = 0.0157	r = 0.0315	r = 0.0472	r = 0.0623	r = 0.0787	r = 0.0984	
2.000		1,9	1,6	1,4	1,2	1,0	1,0
2.500		1,2	1,1	0,9	0,8	0,6	0,6
3.000		0,9	0,8	0,7	0,6	0,5	0,4
4.000		0,5	0,4	0,3	0,3	0,2	0,2

Application information for M4002/F2010 high-feed face milling cutters

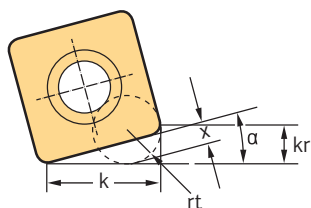
Circular interpolation of a drilled hole into solid material

Diameter range for milling a drilled hole in one pass [mm]/[inch]



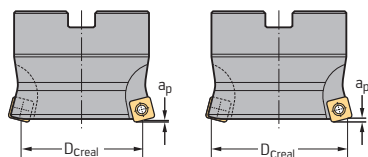
D _a [mm]	Indexable insert					
	SD..06T204		SD..09T308		SD..120408	
	D _{0 min} [mm]	D _{0 max} [mm]	D _{0 min} [mm]	D _{0 max} [mm]	D _{0 min} [mm]	D _{0 max} [mm]
20	28.6	40				
25	38.6	50	33.26	50		
32	52.6	64	47.26	64		
35	58.6	70	53.26	70		
40	68.6	80	63.26	80		
42	72.6	84	67.26	84		
50	88.6	100	83.26	100	77.12	100
52	92.6	104	87.26	104	81.12	104
63	114.6	126	109.26	126	103.12	126
66	120.6	132	115.26	132	109.12	132
80					137.12	160
85					147.12	170
100					177.12	200
125					227.12	250
D _a [inch]	D _{0 min} [inch]	D _{0 max} [inch]	D _{0 min} [inch]	D _{0 max} [inch]	D _{0 min} [inch]	D _{0 max} [inch]
0.75	1.051	1.500				
1.00	1.551	2.000	1.341	2.000		
1.25	2.051	2.500	1.841	2.500		
1.50	2.551	3.000	2.341	3.000		
2.00	3.551	4.000	3.341	4.000	3.099	4.000
2.50	4.551	5.000	4.341	5.000	4.099	5.000
3.00					5.099	6.000
4.00					7.099	8.000

Programming information



Indexable insert	α [°]	rt		x		kr		k	
		[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
SD..06T212	15	2,1	0.083	0,68	0.027	2,2	0.087	4,86	0.191
SD..06T22DR	15	1,3	0.051	0,72	0.028	2,63	0.104	4,29	0.169
SD..06T204	15	1,7	0.067	1	0.039	1,83	0.072	5,7	0.224
SD..09T320	15	3,3	0.130	0,94	0.037	3,41	0.134	7,07	0.278
SD..09T3ZDR	15	2,4	0.094	1,09	0.043	3,65	0.144	6,9	0.272
SD..09T308	15	2,7	0.106	1,43	0.056	2,83	0.111	8,37	0.330
SD..120425	15	4,3	0.169	1,32	0.052	4,46	0.176	9,61	0.378
SD..1204ZDR	15	3,1	0.122	1,58	0.062	4,85	0.191	9,31	0.367
SD..120408	15	3,5	0.138	2,02	0.080	3,65	0.144	11,44	0.450

Increase in productivity



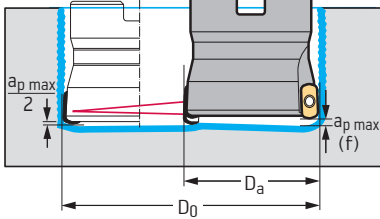
$$D_{c \text{ real}} \approx D_c + 8 \cdot a_p$$

- In order to achieve an increase in productivity, it is recommended to use the $D_{c \text{ real}}$ when calculating the cutting data.
- The $D_{c \text{ real}}$ depends on the depth of cut a_p (see figure).

Application information for the M5008 high-feed face milling cutter

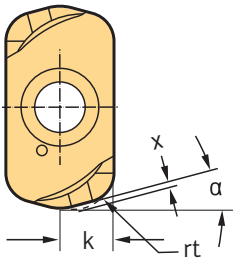
Circular interpolation of a drilled hole into solid material

Diameter range for milling a drilled hole in one pass



D _a [mm]	ENMX08T316R..				
	D _{0min} [mm]	D _{0min} [mm]	D _a [inch]	D _{0min} [inch]	D _{0min} [inch]
16	26,2	32	0.625	1,022	1,250
20	34,2	40	0.750	1,272	1,500
25	44,2	50	1.000	1,772	2,000
30	54,2	60	1.250	2,272	2,500
32	58,2	64	1.500	2,772	3,000
35	64,2	70	2.000	3,772	4,000
40	74,2	80	2.500	4,772	5,000
42	78,2	84			
50	94,2	100			
52	98,2	104			
63	120,2	126			
66	126,2	132			

Programming information

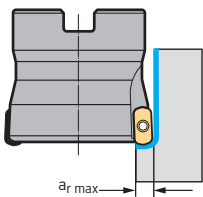


Indexable insert	rt		X		k		α
	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[°]
ENMX08T316R..	2	0,157	0,79	0,031	3,0	0,114	17,7

Programming the theoretical tool radius "rt" results in a maximum deviation from the final contour as shown. The minimum difference (only in the corners) is corrected by the subsequent tools for the remaining machining operations.

Plunge milling

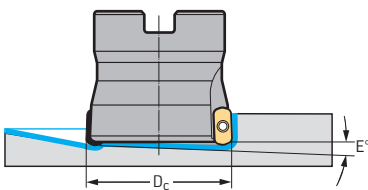
Maximum plunging depth a_r



	ENMX08T316R..
a _r [mm]	3,0
a _r [inch]	0,118

Ramping

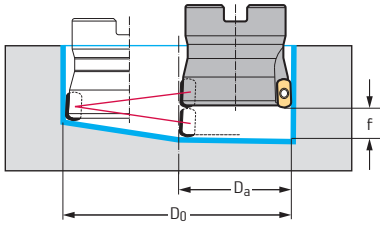
Maximum feed angle E [°]



D _a [mm]	ENMX08T316R..	D _a [inch]	ENMX08T316R..
16	2,20	0.625	2,3
20	1,50	0.750	1,6
25	1,10	1.000	1,1
30	0,80	1.250	0,8
32	0,75	1.500	0,6
35	0,60	2.000	0,4
40	0,55	2.500	0,3
42	0,53		
50	0,43		
52	0,40		
63	0,33		
66	0,30		

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Application information for the M5008 high-feed face milling cutter – continued

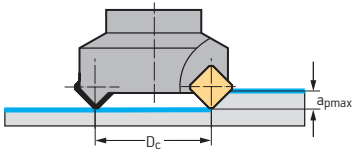
**Circular interpolation
of a drilled hole**
Maximum axial feed per tool revolution ("thread pitch") f [mm]


Premachined hole diameter D_0 [mm]	ENMX08T316R.. D_a [mm]											
	16	20	25	30	32	35	40	42	50	52	63	66
15												
20	0,5											
30	1,0	0,8	0,3									
40	1,0	1,0	0,8	0,4	0,3	0,2						
50	1,0	1,0	1,0	0,9	0,7	0,5	0,3	0,2				
60	1,0	1,0	1,0	1,0	1,0	0,8	0,6	0,5	0,2	0,2		
70	1,0	1,0	1,0	1,0	1,0	1,0	0,9	0,8	0,5	0,4	0,1	0,1
80	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,7	0,6	0,3	0,2
90	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,9	0,8	0,5	0,4
100	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,7	0,6
120	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,9
150	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
180	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
200	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
250	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0

Application information for M4003/F2010 face milling cutters

Face milling

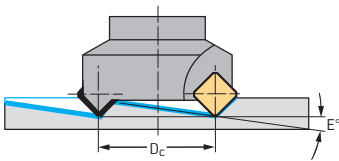
Maximum milling depth a_p [mm]



	SD..09T3AZN	SD..1204AZN
a_p	4,5	6,5

Ramping

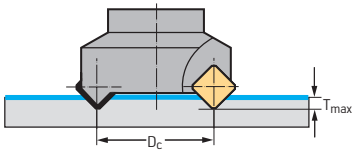
Maximum feed angle E [°]



D_c [mm]	metric		inch			
	SD..09T3AZN..	SD..1204AZN..	D_c [mm]	D_c [inch]	SD..09T3AZN..	SD..1204AZN..
20	23,2		19,05	0,75	25,0	
25	16,9	25,9	25,4	1	16,5	25,3
32	12,1	17,9	31,75	1,25	12,3	18,1
40	9,1	13,2	38,1	1,5	9,7	14,0
50	7,0	9,8	50,8	2	6,8	9,6
63	5,3	7,4	63,5	2,5	5,3	7,3
80	4,0	5,6	76,2	3	4,3	5,9
100	3,1	4,3	101,6	4	3,1	4,2
125		3,4	127	5		3,3
160	6,8	2,6	152,4	6		2,7

Vertical plunging

Maximum plunging depth T_{max} [mm]

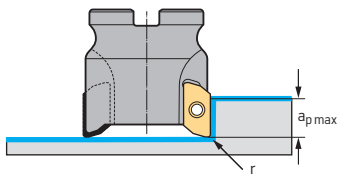


	SD..09T3AZN..	SD..1204AZN..
T_{max}	4,5	6,0

Application information for M2331 ramping milling cutters

Shoulder milling

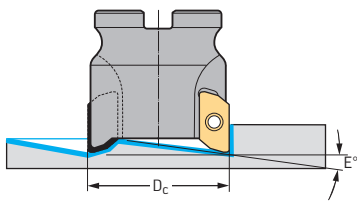
Maximum milling depth $a_{p\max}$ [mm]



Corner radius r [mm]	ZDGT15A4..	ZDGT20A5..
0,4	16,0	21,3
0,8	16,0	21,3
1,2	15,9	21,2
1,6	15,8	21,0
2,0	15,7	20,9
2,5	15,5	20,8
3,0	15,4	20,6
4,0	15,1	20,3
5,0		20,0
6,0		19,8
6,4		19,7

Ramping

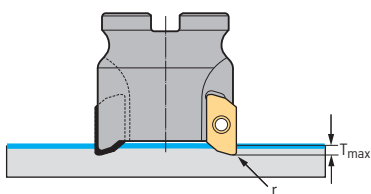
Maximum feed angle E [°]



D_c [mm]	ZDGT15A4..	ZDGT20A5..
32	11	
40	7	12
50	5	8
D_c [inch]		
1.500	8	
2.000	5,4	8,6

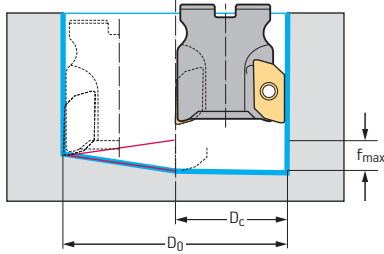
Vertical plunging

Maximum plunging depth T_{\max} [mm]



Corner radius r [mm]	ZDGT15A4..	ZDGT20A5..
0,4	4,5	6,0
0,8	4,5	6,0
1,2	4,4	5,9
1,6	4,2	5,7
2,0	4,1	5,6
2,5	4,0	5,5
3,0	3,8	5,3
4,0	3,5	5,0
5,0		4,7
6,0		4,5
6,4		4,4

Circular interpolation of a bore into solid material



Possible hole diameters and axial feeds [mm]/[inch]

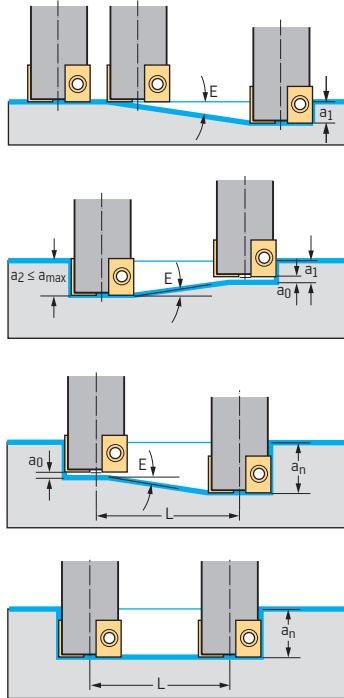
Milling cutter dia.	ZDGT15A4..			ZDGT20A5..		
	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	f_{\max} [mm]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	f_{\max} [mm]
32	45	64	7,9			
40	61	80	8,1	54	80	9,3
50	81	100	8,5	74	100	10,6
D_c [inch]	$D_{0\min}$ [inch]	$D_{0\max}$ [inch]	f_{\max} [inch]	$D_{0\min}$ [inch]	$D_{0\max}$ [inch]	f_{\max} [inch]
1.500	2.244	3.000	0.325			
2.000	3.244	4.000	0.368	2.968	4.000	0.455

Tightening screws

Designation	Tightening screw for adaptor
M2331-040-B16-03-15	M8 × 40 (SW6)
M2331-050-B22-02-15	M10 × 35 (SW8)
M2331-050-B22-03-15	M10 × 35 (SW8)
M2331-050-B22-04-15	M10 × 35 (SW8)
M2331-050-B22-02-20	M10 × 40 (SW8)
M2331-050-B22-03-20	M10 × 40 (SW8)

Application information for M4130 shoulder milling cutter

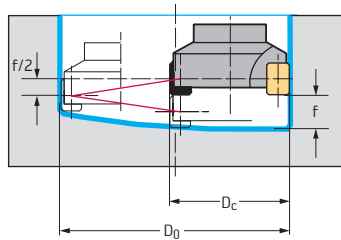
Ramping and circular plunging into solid material



Maximum feed angle E [°]

D _c [mm]	LD..08T204R..	LD..14T308R..	LD..170408R
16	4,6		
20	2,7		
25	1,9	5,5	
32		2,9	
40		1,9	
50		1,4	1,9
63		1,0	1,3
80			1
100			0,7

Circular interpolation of a bore into solid material



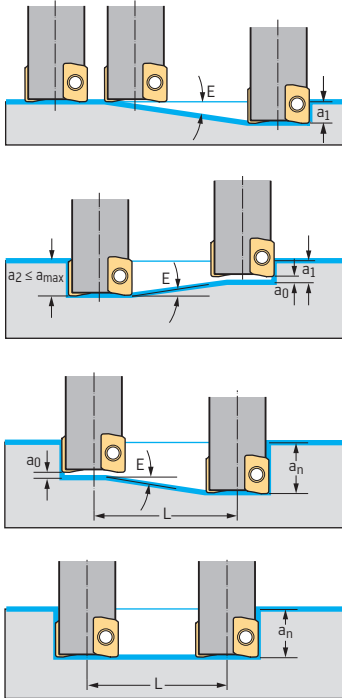
Maximum axial feed per tool revolution ("thread pitch") f [mm]

Premachined hole diameter		Maximum axial feed per tool revolution ("thread pitch") f [mm]														
D _{0 min} [mm]	D _{0 max} [mm]	LD..08T204R.. D _c [mm]			LD..14T308R.. D _c [mm]					LD..170408R.. D _c [mm]						
		16	20	25	25	32	40	50	63	40	50	63	80	100	125	
20,6	32	5,7														
28,6	40	5,7	5,7													
38,6	50	5,7	5,7	5,7												
31,6	50	5,7	5,7	5,7	9,2											
45,6	64	5,7	5,7	5,7	9,2	9,2										
61,6	80	5,7	5,7	5,7	9,2	9,2	9,2									
81,6	100	5,7	5,7	5,7	9,2	9,2	9,2	9,2								
107,6	126	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2							
57,6	80	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2						
77,6	100	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2	11,2					
103,6	126	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2	11,2	11,2				
137,6	160	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2	11,2	11,2	11,2			
177,6	200	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2	11,2	11,2	11,2	11,2		
227,6	250	5,7	5,7	5,7	9,2	9,2	9,2	9,2	9,2	11,2	11,2	11,2	11,2	11,2	11,2	

Application information for M5130 shoulder milling cutter

Ramping and circular plunging into solid material

Plunging with M5130 shoulder milling cutter/plunging angle E_{max} [°]

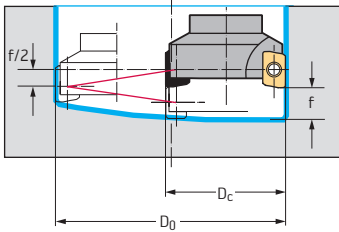


Milling cutter dia. D_c [mm]	AC.0602.. $a_p \text{ max} = 5 \text{ mm}$				BC..1204.. $a_p \text{ max} = 12 \text{ mm}$				BC1605.. $a_p \text{ max} = 15 \text{ mm}$			
	E_{max} [°]	$D_{0 \text{ min}}$ [mm]	$D_{0 \text{ max}}$ [mm]	a_0 [mm]	E_{max} [°]	$D_{0 \text{ min}}$ [mm]	$D_{0 \text{ max}}$ [mm]	a_0 [mm]	E_{max} [°]	$D_{0 \text{ min}}$ [mm]	$D_{0 \text{ max}}$ [mm]	a_0 [mm]
10	6,7	15	20	0,58								
12	4,0	18	24	0,57								
14	3,7	21	28	0,57								
16	3,0	25	32	0,56								
18	2,5	29	36	0,56								
20	2,1	33	40	0,56								
22	1,9	37	44	0,56	7,1	30	44	1,6				
25	1,6	43	50	0,56	5,8	36	50	1,6	8,8	32	50	2
28									7,1	38	56	2
32	1,2	57	64	0,56	3,8	50	64	1,5	5,8	46	64	2
35									5,0	52	70	2
40	0,9	73	80	0,56	2,8	66	80	1,5	4,1	62	80	2
42									3,8	66	84	2
50	0,7	73	100	0,56	2,1	86	100	1,5	3,0	82	100	2
52									2,9	86	104	2
63	0,5	119	126	0,56	1,6	112	126	1,5	2,3	108	126	2
66									2,1	114	132	2
80					1,2	146	160	1,5	1,7	142	160	2
85									1,6	152	170	2
100									1,3	182	200	2
125									1,0	232	250	2
160									0,8	302	320	2
	$a_p \text{ max} = 0.197 \text{ inch}$				$a_p \text{ max} = 0.472 \text{ inch}$				$a_p \text{ max} = 0.591 \text{ inch}$			
D_c [inch]	E_{max} [°]	$D_{0 \text{ min}}$ [inch]	$D_{0 \text{ max}}$ [inch]	a_0 [inch]	E_{max} [°]	$D_{0 \text{ min}}$ [inch]	$D_{0 \text{ max}}$ [inch]	a_0 [inch]	E_{max} [°]	$D_{0 \text{ min}}$ [inch]	$D_{0 \text{ max}}$ [inch]	a_0 [inch]
0,500	4,4	0,709	1,000	0,022								
0,625	3,0	0,974	1,250	0,022								
0,750	2,3	1,224	1,500	0,022	9,2	0,949	1,500	0,063				
1,000	1,6	1,724	2,000	0,022	5,7	1,449	2,000	0,063	8,5	1,291	2,000	0,079
1,250	1,2	2,224	2,500	0,022	3,8	1,949	2,500	0,059	5,8	1,791	2,500	0,079
1,500	1	2,724	3,000	0,022	3	2,449	3,000	0,059	4,4	2,291	3,000	0,079
2,000	0,7	3,724	4,000	0,022	2,1	3,449	4,000	0,059	3,0	3,291	4,000	0,079
2,500	0,5	4,724	5,000	0,022	1,6	4,449	5,000	0,059	2,2	4,291	5,000	0,079
3,000					1,3	5,449	6,000	0,059	1,8	5,291	6,000	0,079
4,000									1,3	7,291	8,000	0,079
5,000									1,0	9,291	10,000	0,079
6,000									0,8	11,291	12,000	0,079

C 2

Application information for M5130 shoulder milling cutter

Circular interpolation of a bore into solid material



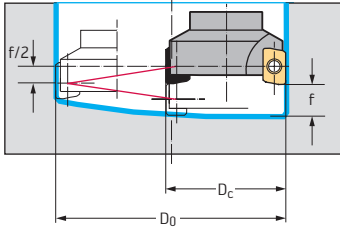
Max. axial feed per tool revolution ("thread pitch") f [mm]

Machined drilled hole diameter D_0 [mm]	AC..0602.. D_c [mm]											
	10	12	14	16	18	20	22	25	32	40	50	63
15	1,8											
20	3,7	2,1										
30	5,0	4,7	3,3	2,3	1,6							
40	5,0	5,0	5,0	4,0	3,0	2,3	1,9					
50	5,0	5,0	5,0	5,0	4,4	3,5	2,9	2,2				
60	5,0	5,0	5,0	5,0	5,0	4,6	4,0	3,1	1,8			
70	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,9	2,5			
80	5,0	5,0	5,0	5,0	5,0	5,0	5,0	4,8	3,2	2,0		
90	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8	2,5		
100	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	4,5	3,0	1,9	
120	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,9	2,7	1,6
150	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8	2,4
180	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,2
200	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8
250	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined drilled hole diameter D_0 [inch]	AC..0602.. D_c [inch]											
	0.500	0.625	0.750	1.000	1.500	2.000	2.500	3.000				
0.591												
0.787	0,069											
1.181	0,165	0,092										
1.575	0,197	0,156	0,104									
1.969	0,197	0,197	0,154	0,085								
2.362	0,197	0,197	0,197	0,120	0,073							
2.756	0,197	0,197	0,197	0,154	0,099	0,069						
3.150	0,197	0,197	0,197	0,189	0,125	0,090						
3.543	0,197	0,197	0,197	0,197	0,151	0,112	0,059					
3.937	0,197	0,197	0,197	0,197	0,177	0,134	0,074					
4.724	0,197	0,197	0,197	0,197	0,197	0,177	0,105	0,061				
5.906	0,197	0,197	0,197	0,197	0,197	0,197	0,150	0,093				
7.087	0,197	0,197	0,197	0,197	0,197	0,197	0,195	0,126				
7.874	0,197	0,197	0,197	0,197	0,197	0,197	0,197	0,147				
9.843	0,197	0,197	0,197	0,197	0,197	0,197	0,197	0,197				

Circular interpolation of a bore into solid material



Max. axial feed per tool revolution ("thread pitch") f [mm]

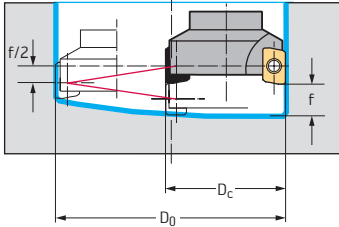
Machined drilled hole diameter D ₀ [mm]	BC..1204.. D _c [mm]						
	22	25	32	40	50	63	80
30	3,1						
40	7,0	4,8					
50	11,0	8,0	3,8				
60	12,0	11,2	5,8				
80	12,0	12,0	7,9	4,6			
100	12,0	12,0	10,0	6,1			
120	12,0	12,0	12,0	7,7	4,6		
150	12,0	12,0	12,0	9,2	5,8		
180	12,0	12,0	12,0	12,0	8,1	5,0	
200	12,0	12,0	12,0	12,0	11,5	7,6	4,6
250	12,0	12,0	12,0	12,0	12,0	10,3	6,6
300	12,0	12,0	12,0	12,0	12,0	12,0	7,9
350	12,0	12,0	12,0	12,0	12,0	12,0	11,2
400	12,0	12,0	12,0	12,0	12,0	12,0	12,0
450	12,0	12,0	12,0	12,0	12,0	12,0	12,0
500	12,0	12,0	12,0	12,0	12,0	12,0	12,0

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined drilled hole diameter D ₀ [inch]	BC..1204.. D _c [inch]						
	0,750	1,000	1,250	1,500	2,000	2,500	3,000
0,984							
1,181	0,219						
1,575	0,420	0,180					
1,969	0,472	0,304	0,150				
2,362	0,472	0,427	0,232				
2,756	0,472	0,472	0,314	0,207			
3,150	0,472	0,472	0,396	0,272			
3,543	0,472	0,472	0,472	0,336	0,178		
3,937	0,472	0,472	0,472	0,401	0,223		
4,724	0,472	0,472	0,472	0,472	0,314	0,195	
5,906	0,472	0,472	0,472	0,472	0,450	0,299	0,207
7,087	0,472	0,472	0,472	0,472	0,472	0,403	0,291
7,874	0,472	0,472	0,472	0,472	0,472	0,472	0,347
9,843	0,472	0,472	0,472	0,472	0,472	0,472	0,472
11,8110	0,472	0,472	0,472	0,472	0,472	0,472	0,472
13,7795	0,472	0,472	0,472	0,472	0,472	0,472	0,472
15,7480	0,472	0,472	0,472	0,472	0,472	0,472	0,472
17,7165	0,472	0,472	0,472	0,472	0,472	0,472	0,472
19,6850	0,472	0,472	0,472	0,472	0,472	0,472	0,472

C 2

Application information for M5130 shoulder milling cutter – continued

Circular interpolation of a bore into solid material

Max. axial feed per tool revolution ("thread pitch") f [mm]

Machined drilled hole diameter D ₀ [mm]	BC..1605.. D _c [mm]														
	25	28	32	35	40	42	50	52	63	66	80	85	100	125	160
15															
20															
30															
40	7,3	4,7													
50	12,2	8,6	5,7	4,1											
60	15,0	12,5	8,9	6,9											
70	15,0	15,0	12,1	9,6	6,8	5,8									
80	15,0	15,0	15,0	12,4	9,0	7,9									
90	15,0	15,0	15,0	15,0	11,3	10,0	6,6	6,0							
100	15,0	15,0	15,0	15,0	13,5	12,1	8,2	7,6							
120	15,0	15,0	15,0	15,0	15,0	15,0	11,5	10,8	7,2	6,2					
150	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	11,0	9,7	6,5	5,7			
180	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,8	13,1	9,3	8,3			
200	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	11,2	10,1	7,1		
250	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,5	10,7	6,9	
300	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,3	9,6	
350	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	12,3	8,3
400	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	10,5
450	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	12,7
500	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,9

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined drilled hole diameter D ₀ [inch]	BC..1605.. D _c [inch]														
	1,000	1,250	1,500	2,000	2,500	3,000	4,000	5,000	6,000						
0.591															
0.787															
1.181	0,085														
1.575	0,270	0,104													
1.969	0,455	0,229	0,113												
2.362	0,591	0,355	0,208												
2.756	0,591	0,481	0,304	0,124											
3.150	0,591	0,591	0,399	0,189											
3.543	0,591	0,591	0,494	0,254	0,126										
3.937	0,591	0,591	0,589	0,319	0,173										
4.724	0,591	0,591	0,591	0,448	0,268	0,170									
5.906	0,591	0,591	0,591	0,591	0,411	0,287	0,136								
7.087	0,591	0,591	0,591	0,591	0,554	0,404	0,220								
7.874	0,591	0,591	0,591	0,591	0,591	0,481	0,276	0,158							
9.843	0,591	0,591	0,591	0,591	0,591	0,591	0,417	0,266	0,169						
11.811	0,591	0,591	0,591	0,591	0,591	0,591	0,557	0,373	0,255						
13.780	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,481	0,341						
15.748	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,589	0,428						
17.717	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,514						
19.685	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591						

Notes on high-speed cutting

- Maximum permissible speeds:
The limit values specified in the tables should not be exceeded. Otherwise correct operation and/or reliability are no longer guaranteed.
- Only use original Walter indexable inserts and assembly parts (screws, etc.). New screws should be used after having replaced the indexable inserts five times at the most.
- Observe the torques specified in the catalogue.
- Balancing:
Balancing in two steps is required when milling at fast speeds (> 6000 rpm) or at circumferential speeds of > 1000 m/min:
 - Basic balancing of the tool body including indexable inserts (can be carried out by Walter if required). In this case, tool adaptors that have been balanced separately beforehand must be used.
 - Fine balancing of the tool when fully mounted on the adaptor. The fine balancing operation is strongly recommended, as even the smallest concentricity fault can seriously affect the balance status.
- Short projection lengths reduce concentricity faults, and increase spindle service life. The specified speeds only apply to the use of tools without additional extensions and for tools with a neck length of $\leq 2.2 \times D_c$. For tools with longer neck lengths, the speeds must be reduced upon consultation with Walter.

Part 1: Metric

		n _{max} [1/min] with D											
Tool	Safety-related parts	In relation to	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20	Ø 22	Ø 25	Ø 28	Ø 32	Ø 35
M3024	XN.U0705...	D _c											
	XN.U0906...	D _c											
M4002	SD..06T2...	D _a						28.300		25.300		22.400	
	SD..09T3...	D _a								34.900		30.800	29.500
	SD..1204...	D _a											
M4003	SD..09T3...	D _c						40.000		38.000		33.600	
	SD..1204...	D _c								33.300		29.400	
M2331	ZD..15A4..	D _c										40.000	
	ZD..20A5..	D _c											
M4130	LD..08T204...	D _c				40000		34.300		29.400			
	LD..14T308...	D _c								40.000		33.600	
	LD..170408...	D _c											
M5130	AC.T0602..	D _c	40.000	40.000	40.000	40.000	40.000	40.000	40.000	40.000		36.600	
	BC . T1204..	D _c								28.100		24.400	
	BC.T1605..	D _c								22.300	20.900	19.300	18.300
M5008	ENMX08T316R..	D _a					32.700	29.200		26.100		23.100	22.100
M5009	SN.X0904..	D _c								34.100		30.100	
M5012	SN.X0904..	D _c										27.300	
M2136	SNEF1204..	D _c											
M4258	SD..1204..	D _c											
	LD..1704..	D _c											
M2471	RNMX1005..	D _c								27.200		23.400	
	RNMX1206..	D _c										26.600	

6. Safety guard:

Appropriate safety guards or machine encapsulations must be used to safely collect particles which spin off, such as chips or cutting edge parts that are broken as a result of collisions.

7. Damaged tools:

The operating speed must be specified for the repair of an HSC tool. The table values only apply to tools with a condition equivalent to new condition following repair.

8. Application of standards:

Walter recommends using the balancing standard DIN 69888, which describes the balancing of tools and the requirements in the cutting area. DIN 69888 is tailored to the needs of the cutting area, and describes the tool balancing requirements in a practical way. DIN ISO 1940, which was previously often used, describes balancing for all areas of mechanical engineering.

The requirements when working at circumferential speeds of > 1000 m/min are described in DIN ISO 15641.

n_{max} [1/min] with D

	Ø 40	Ø 42	Ø 50	Ø 52	Ø 63	Ø 66	Ø 80	Ø 85	Ø 100	Ø 125	Ø 160	Ø 200	Ø 250	Ø 315
	12.500		11.200		10.000		8.800		7.900	7.000	6.200	4.200	3.800	3.350
					8.500		7.400		6.500	5.200	4.100			
	20.000		17.900	17.600	16.000	15.600								
	27.600		24.600	24.200	22.000	21.400								
			17.900	17.600	16.000	15.600	14.100		12.600	11.300		4.200	3.800	3.350
	30.100		26.900		24.000		21.200		19.000			4.200	3.800	3.350
	26.300		23.500		21.000		18.600		16.600	14.900	13.100	4.200	3.800	3.350
	39.800		34.400											
	40.000		34.000											
	28.800		25.000											
			17.300		15.000		12.900		11.400	10.000				
	32.500		28.900		25.700									
	21.500		19.100		16.900		14.800							
	16.900	16.500	14.900	14.600	13.200	12.800	11.600	11.200	10.300	9.100	8.000			
	20.700	20.200	18.500	18.100	16,500	16,100								
	26.900		24.100		21,500		19,000		17,000					
	24.400		21.800		19,500		17,300		15,400					
			11.200		10.000		8.800		7.900	7.000	6.200			
			17.300		15.000		12.900							
			17.300		15.000		12.900							
	20.500		18.100	17.700										
	23.300		20.400	20.000	18.000									

Notes on high-speed cutting – continued

Part 2: Inch

n _{max} [1/min] with D										
Tool	Safety-related parts	In relation to	Ø 0,375	Ø 0,5	Ø 0,625	Ø 0,750	Ø 1,000	Ø 1,250	Ø 1,500	
M3024	XN.U0705...	D _c							12,800	
	XN.U0906...	D _c								
M4002	SD..06T2...	D _a	28,300				25,300	22,400	20,000	
	SD..09T3...	D _a					34,900	30,800	27,600	
	SD..1204...	D _a								
M4003	SD..09T3...	D _c	40,000				37,700	33,800	30,800	
	SD..1204...	D _c					33,000	29,500	27,000	
M2331	ZD..15A4..	D _c							40,000	
	ZD..20A5..	D _c								
M2136	SNEF1204..	D _c								
M5130	AC.T0602..	D _c		40.000	40.000	40.000	40.000	36.800	33.400	
	BC.T1204..	D _c				33,100	27,900	24,500	22,100	
	BC.T1605..	D _c					22,100	19,300	17,400	
M5008	ENMX08T316R..	D _a			32,800	30,000	25,900	23,200	21,200	
M5009	SN.X0904..	D _c					33,800	30,200	27,600	
M4258	SD..1204..	D _c								
	LD..1704..	D _c								
M2471	RNMX1206..	D _a								

n_{\max} [1/min] with D

	Ø 2,000	Ø 2,500	Ø 3,000	Ø 4,000	Ø 5,000	Ø 6,000	Ø 8,000	Ø 10,000	Ø 12,000
	11,100	9,900	9,000	7,800	7,000	6,400	4,200	3,800	3,350
		8,400	7,600	6,500	5,100	4,300			
	17,900	16,000							
	24,600	22,000							
	17,900	16,000	14,100	12,600			4,200	3,800	3,350
	26,700	23,900	21,800	18,800			4,200	3,800	3,350
	23,300	20,900	19,000	16,500	14,700	13,500	4,200	3,800	3,350
	34,100								
	33,600								
	11,100	9,900	9,000	7,800	7,000	6,400			
	28,700	25,500							
	18,900	16,800	15,200						
	14,800	13,100	11,900	10,200	9,100	8,200			
	18,300	16,400							
	23,900	21,400	19,500	16,900					
	17,100	14,900	13,300						
	17,100	14,900	13,300						
	20,300	17,900							

Torque screwdriver with interchangeable blades

Torque screwdriver



Designation	Size		Scale range
FS2001	1	4	0,4–1,2 Nm
FS2003	3	4	1,5–5,0 Nm
FS2002	1	4	3,5–10,6 in lbs
FS2004	3	4	13,3–44 in lbs



Designation	Size		Scale range
FS2248	3	4	1,0–6,0 Nm

Interchangeable blades	Designation	Torx	
 Torx interchangeable blades Blade length 175 mm	FS2005	6	4
	FS2006	7	
	FS2007	8	
	FS2008	10	
	FS2009	15	
	FS2010	20	
 Torx Plus interchangeable blades Blade length 175 mm	FS2085	6IP	4
	FS2011	7IP	
	FS2012	8IP	
	FS2013	9IP	
	FS2268	10IP	
	FS2014	15IP	
 Torx Plus interchangeable blades with retaining function Blade length 175 mm	FS2015	20IP	4
	FS2016	25IP	
 Torx Plus interchangeable blades with retaining function Blade length 175 mm	SD2001-6IP	6IP	4
	Complete blade set (FS2005–FS2016) Blade length 175 mm	FS2017	

IP = Torx Plus

Torque T-handle

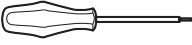


Designation		Scale range
FS2041	6	4,5–14 Nm
FS2042	6	40–123 in lbs


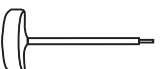
Interchangeable blades	Designation	Torx/WAF	
 Torx interchangeable blades Blade length 130 mm	FS2043	15	6
	FS2044	20	
	FS2045	25	
	FS2046	30	
 Torx Plus interchangeable blades Blade length 130 mm	FS2047	15IP	6
	FS2048	20IP	
	FS2049	25IP	
	FS2109	30IP	
 Hexagonal interchangeable blades Blade length 130 mm	FS2050	SW3	6
	FS2566	SW3,5	
	FS2051	SW4	
	FS2052	SW5	
Complete blade set (FS2043–FS2052) Blade length 130 mm	FS2053		6


IP = Torx Plus

Screwdriver


Screwdriver types	Designation	Torx
 Screwdriver	FS1063	6
	FS2086	6IP
	SD1001-6IP *	6IP
	FS309	7
	FS2088	7IP
	FS230	8
	FS1483	8IP
	FS1128	9
	FS1484	9IP
	FS2267	10IP
	FS229	15
	FS1485	15IP
	FS228	20
	FS1486	20IP
	FS2167	25
	FS1487	25IP
	FS396	30
	FS2109	30IP

* with retaining function/IP = Torx Plus

Screwdriver types	Designation	Torx
 Handle key, small	FS1047	15
	FS1048	20
	FS1049	25
 Handle key, large	FS1172	15
	FS1173	20
	FS1174	25
	FS1175	30

Screwdriver types	Designation	Torx	WAF	
 Torx key	FS2146	6IP	-	
	FS2087	6IP	-	
	FS325	7	-	
	FS1490	7IP	-	
	FS257	8	-	
	FS1466	9IP	-	
	FS1050	10	-	
	FS255	15	-	
	FS1465	15IP	3,5	
	FS1496	15IP	4,0	
	FS256	20	-	
	FS1154	-	2,0	
	FS1155	-	2,5	

IP = Torx Plus

Allen key	Designation	Torx	WAF	
	ISO 2936-1,3	-	1,3	
	ISO 2936-1,5	-	1,5	
	ISO 2936-2	-	2	
	ISO 2936-2,5	-	2,5	
	ISO 2936-3	-	3	
	ISO 2936-3,5	-	3,5	
	ISO 2936-4	-	4	
	ISO 2936-5	-	5	
	ISO 2936-6	-	6	
	FS1464	20IP	-	
	FS1592	25IP	-	

IP = Torx Plus



Stationary adaptors – D1

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Product range overview Walter Capto™ adaptors

Designation	A2120-C...-P	A2121-C...-P	A3000-C
Tool type	Axial adaptor	Radial adaptor	Accure-tec adaptor
Machine-side	Walter Capto™ in acc. with ISO 26623	Walter Capto™ in acc. with ISO 26623	Walter Capto™ in acc. with ISO 26623
Tool-side	Square shanks	Square shanks	QuadFit
Alignment	straight	angled	straight
Page	802	802	808
			




VDI adaptors, one-piece

Designation	A2120-V...-P	A2110-V...-P
Tool type	Square shank adaptor	Parting blade adaptor
Machine-side	VDI DIN 69880	VDI DIN 69880
Tool-side	Square shanks	Parting blades
Alignment	straight	straight
Page	803	804
		

Machine-specific adaptors, one-piece

Designation	A2120-D0...-P	A2120-BT...-P	A2121-D0...-P	A2110-V...-P	A2110-NA...-P
Tool type	Square shank adaptors			Parting blade adaptors	
Machine-side	Doosan	BMT	Doosan	VDI DIN 69880/Traub	Nakamura
Tool-side	Square shanks	Square shanks	Square shanks	Parting blades	Parting blades
Alignment	straight	straight	angled	straight	straight
Page	805	805	806	804	807
					

Accure-tec vibration-damped boring bar/adaptors

Designation	A3000	A3000-C	A3000-HSK-T
Tool type	Accure-tec adaptors		
Machine-side	Parallel shank	Walter Capto™ in acc. with ISO 26623	HSK DIN 69893-7
Tool-side	QuadFit	QuadFit	QuadFit
Alignment	straight	straight	straight
Page	809	810	811
			

Walter Capto™ – Axial adaptor

A2120-C...-P



– Precision cooling

Tool		Designation	Size	h mm	b ₁ mm	b ₂ mm	d ₁₄ mm	f mm	h ₂ mm	h ₃ mm	l ₃ mm	l ₄ mm	kg
		Walter Capto™ in acc. with ISO 26623 A2120-C5-20R/L-095-P	C5	20	26	30	85	10	32	37	20	95	1,6
		A2120-C6-20R/L-105-P	C6	20	32	30	85	10	32	37	22	105	2,3
		A2120-C6-25R/L-122-P	C6	25	38	32	100	13	32	46	22	122	3

Important: Adaptors are designed for machines with an automatic tool changing system.

The maximum recommended coolant pressure is 80 bar (1160 psi)

Coolant outlet to the nozzle can be set by turning a valve to the left/right

Ordering example, right-hand tool: A2120-C5-20R-095-P/ordering example, left-hand tool: A2120-C5-20L-095-P

Walter Capto™ – Radial adaptor

A2121-C...-P



– Precision cooling

Tool		Designation	Size	h mm	b ₂ mm	h ₂ mm	d ₁₄ mm	l ₄ mm	l ₅ mm	kg
		Walter Capto™ in acc. with ISO 26623 A2121-C5-20N-064-P	C5	20	25	32	85	65	45	1,4
		A2121-C6-25N-076-P	C6	25	32	38	100	80	55	2,5

Important: Adaptors are designed for machines with an automatic tool changing system.

The maximum recommended coolant pressure is 80 bar (1160 psi)

Coolant outlet to the nozzle can be set by turning a valve to the left/right

VDI adaptor – Shank tools

A2120-V...-P



– Precision cooling

Tool	Designation	d ₁	h	b ₁	b ₂	b ₃	f	l ₄	l ₆	h ₂	h ₃	kg
VDI DIN 69880	A2120-V25-20N-055-P	VDI25	20	39	30	20	19	70	35	35	35	1,3
	A2120-V30-20N-070-P	VDI30	20	55,5	30	39,5	35,5	70	48	35	35	1,7
	A2120-V40-25N-085-P	VDI40	25	50,5	42	45	25,5	85	45	44	44	3,2
	A2120-V50-25N-100-P	VDI50	25	55,5	50	50	30,5	100	70	44	44	3,2

The maximum recommended coolant pressure is 80 bar (1160 psi)

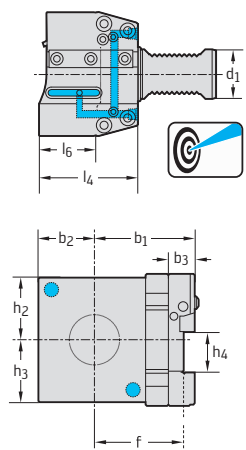
VDI adaptor – Parting blades

A2110-V...-P



– Precision cooling

Tool	Designation	d_1	h_4 mm	b_1 mm	b_2 mm	b_3 mm	f mm	l_4 mm	l_6 mm	h_2 mm	h_3 mm	kg
VDI DIN 69880	A2110-V25-26R/L-083-P	VDI25	26	43	30	17	38	83	52	37	37	1,2
	A2110-V30-26R/L-090-P	VDI30	26	50	35	17	45	90	52	37	37	1,5
	A2110-V30-32R/L-084-P	VDI30	32	51	35	17	46	84	52	39	39	1,6
	A2110-V40-32R/L-080-P	VDI40	32	76	42,5	20	67,5	80	46	50	50	3,1



The maximum recommended coolant pressure is 80 bar (1160 psi)
 Ordering example, right-hand tool: A2110-V25-26R-083-P/ordering example, left-hand tool: A2110-V25-26L-083-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	h_4 [mm] d_1	26 VDI25	26-32 VDI30	32 VDI40
	Screw 1	M05X010 ISO14579 8.8	M05X010 ISO14579 8.8	M05X016 ISO14581 8.8
	Screw 2	M08X016 ISO4762 12.9	M06X020 DIN7984 10.9	M08X025 ISO4762 12.9
	Screw 3			FS2278
	Wedge	FK383	FK383	FK384
	Coolant nozzle	FS1477	FS1477	FS1477
	Parallel pin	06,0M6X012 DIN7	06,0M6X012 DIN7	08,0M6X020 ISO8735
	Eccentric pin	FS2275	FS2275	FS2275
	O-ring 1	O-RING 23.52X1.78 70/75	O-RING 28,3X1.78 70/75	O-RING 37,77X2.62 70/75
	O-ring 2	O-RING 24X2 70/80	O-RING 24X2 70/80	O-RING 27X2

D 1

Accessories	h_4 [mm]	26	32
	Key	FS1592 (Torx 25IP)	FS1592 (Torx 25IP)
	ISO 2936-4 key	ISO2936-4 (SW 4)	ISO2936-4 (SW 4)
	ISO 2936-5 key	ISO2936-5 (SW 5)	
	ISO 2936-6 key		ISO2936-6 (SW 6)

Doosan adaptor – Shank tools

A2120-DO...-P



- Precision cooling
- For Doosan machines

Tool	Designation	d ₁	h mm	b ₁ mm	b ₂ mm	b ₃ mm	f mm	l ₄ mm	l ₆ mm	h ₂ mm	h ₃ mm	kg
	A2120-DO-25N-072-P	D0	25	51	35	31	26	72	47	51	51	3

The maximum recommended coolant pressure is 80 bar (1160 psi)

BMT adaptor – Shank tools

A2120-BT...-P



- Precision cooling
- For BMT machines

Tool	Designation	d ₁	h mm	b ₁ mm	b ₂ mm	b ₃ mm	f mm	l ₄ mm	l ₆ mm	h ₂ mm	h ₃ mm	kg
	A2120-BT45-20N-063-P	BT45	20	62	40	42	34	63	38	38	38	2,2
	A2120-BT55-25N-060-P	BT55	25	81	44	56	56	60	35	49	49	3,9

The maximum recommended coolant pressure is 80 bar (1160 psi)

Doosan adaptor – Shank tools

A2121-DO...-P



- Precision cooling
- For Doosan machines

Tool	Designation	d ₁	h mm	b ₁ mm	b ₂ mm	l ₄ mm	l ₅ mm	h ₂ mm	h ₃ mm	kg
	A2121-DO-25N-050-P	DO	25	50	7	57	32	51	51	3,1

The maximum recommended coolant pressure is 80 bar (1160 psi)

VDI adaptor – Parting blades

A2110-V...-P



- Precision cooling
- For Traub machines

Tool	Designation	d ₁	h ₄ mm	b ₁ mm	b ₂ mm	b ₃ mm	f mm	l ₄ mm	l ₆ mm	h ₂ mm	h ₃ mm	kg	
	VDI DIN 69880												
	A2110-V25T-26R/L-083-P	VDI25	26	50,5	30	17	38,5	83	50	37	37	1,2	
	A2110-V30T-32R/L-080-P	VDI30	32	66,5	35	20	58	80	52	50	50	2,3	

Ordering example, right-hand tool: A2110-V25T-26R-083-P/ordering example, left-hand tool: A2110-V25T-26L-083-P

D 1

Boring Bar / adaptor – vibration-damped

A3000

Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁ mm	d ₁₁	l ₄ mm	l ₅ mm	l ₁ mm	d ₁₃	kg	
	★ A3000-32-Q32-160	32	Q32	160	128	293	G 1/4	1,8	
	★ A3000-32-Q32-224	32	Q32	224	128	357	G 1/4	2,3	
	★ A3000-40-Q40-208	40	Q40	208	160	374	G 1/4	3,8	
	★ A3000-40-Q40-288	40	Q40	288	160	454	G 1/4	4,6	
	★ A3000-50-Q50-268	50	Q50	268	200	475	G 1/4	7,5	
	★ A3000-50-Q50-368	50	Q50	368	200	575	G 1/4	9,1	
	★ A3000-40-Q40-368	40	Q40	368	160	534	G 1/4	5,5	
	★ A3000-50-Q50-468	50	Q50	468	200	675	G 1/4	11	

QuadFit exchangeable heads – see the "Turning" section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque	SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories	d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque	SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench	SD6000-Q32	SD6000-Q40	SD6000-Q50

Boring Bar / adaptor – vibration-damped

A3000 inch

Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁ inch	d ₁₁	l ₄ inch	l ₅ inch	l ₁ inch	d ₁₃	lbs
	Parallel shank							
	★ A3000.20-Q32-165	1,250	Q32	6,500	5,000	11,713	G 1/4	3,97
	★ A3000.20-Q32-229	1,250	Q32	9,000	5,000	14,213	G 1/4	5,07
	★ A3000.24-Q40-203	1,500	Q40	8,000	6,000	14,252	G 1/4	7,72
	★ A3000.24-Q40-279	1,500	Q40	11,000	6,000	17,252	G 1/4	9,48
	★ A3000.32-Q50-267	2,000	Q50	10,500	8,000	18,791	G 1/4	16,76
	★ A3000.32-Q50-368	2,000	Q50	14,496	8,000	22,791	G 1/4	20,28
	★ A3000.24-Q40-356	1,500	Q40	14,000	6,000	20,252	G 1/4	11,46
	★ A3000.32-Q50-470	2,000	Q50	18,500	8,000	26,791	G 1/4	24,69

QuadFit exchangeable heads – see the "Turning" section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque	SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories	d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque	SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench	SD6000-Q32	SD6000-Q40	SD6000-Q50

Walter Capto™ adaptor – vibration-damped

 A3000-C mm
Accure-tec


- For QuadFit exchangeable heads
- With preset vibration damping

Tool	Designation	d ₁	d ₁₁	d ₁₂ mm	l ₄ mm	l ₁₆ mm	l ₁₇ mm	n _{max}	kg
	★ A3000-C6-Q32-160	C6	Q32	32	160	129	135	10000	1,8
	★ A3000-C6-Q32-224	C6	Q32	32	224	193	199	8000	2,1
	★ A3000-C6-Q32-288	C6	Q32	32	288	257	263	6000	2,6
	★ A3000-C6-Q40-208	C6	Q40	40	208	177	183	8000	2,9
	★ A3000-C6-Q40-288	C6	Q40	40	288	257	263	6000	3,7
	★ A3000-C6-Q40-368	C6	Q40	40	368	337	343	5000	4,5
	★ A3000-C6-Q50-268	C6	Q50	50	268	238	243	6000	5
	★ A3000-C6-Q50-368	C6	Q50	50	368	338	343	4000	6,6
	★ A3000-C6-Q50-468	C6	Q50	50	468	438	443	2500	8,5
	★ A3000-C8-Q32-224	C8	Q32	32	224	181	191	8000	3,2
	★ A3000-C8-Q32-288	C8	Q32	32	288	245	255	6000	3,6
	★ A3000-C8-Q40-288	C8	Q40	40	288	245	255	6000	4,7
	★ A3000-C8-Q40-368	C8	Q40	40	368	325	335	5000	5,6
	★ A3000-C8-Q50-268	C8	Q50	50	268	225	235	6000	5,9
	★ A3000-C8-Q50-368	C8	Q50	50	368	325	335	4000	7,5
	★ A3000-C8-Q50-468	C8	Q50	50	468	425	435	2500	9,4

QuadFit exchangeable heads – see the "Turning" section
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts		d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque		SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm

Accessories		d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque		SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench		SD6000-Q32	SD6000-Q40	SD6000-Q50


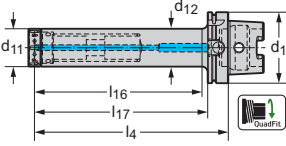
HSK-T adaptor – vibration-damped

A3000-HSK-T




Accure-tec



- For QuadFit exchangeable heads
- With preset vibration damping



Tool	Designation	d ₁ mm	d ₁₁	d ₁₂ mm	l ₄ mm	l ₁₆ mm	l ₁₇ mm	n _{max}	
	★ A3000-H100T-Q32-224	100	Q32	32	224	189	195	8000	3,4
	★ A3000-H100T-Q32-288	100	Q32	32	288	253	259	6000	3,8
	★ A3000-H100T-Q40-288	100	Q40	40	288	253	259	6000	4,9
	★ A3000-H100T-Q40-368	100	Q40	40	368	333	339	5000	5,8
	★ A3000-H100T-Q50-268	100	Q50	50	268	234	239	6000	6,2
	★ A3000-H100T-Q50-368	100	Q50	50	368	334	339	4000	7,8
	★ A3000-H100T-Q50-468	100	Q50	50	468	434	439	25000	9,7

QuadFit exchangeable heads – see the “Turning” section
 Bodies and assembly parts are included in the scope of delivery.


Assembly parts		d ₁₁	Q32	Q40	Q50
	Hook wrench Tightening torque		SD9000-Q32 25 Nm	SD9000-Q40 35 Nm	SD9000-Q50 55 Nm
Accessories		d ₁₁	Q32	Q40	Q50
	Torque wrench with hook Tightening torque		SD4000-Q32-25 25 Nm	SD4000-Q40-35 35 Nm	SD4000-Q50-55 55 Nm
	Hook for torque wrench		SD6000-Q32	SD6000-Q40	SD6000-Q50

Product range overview of:


Walter Capto™ adaptors

Designation	AB035-C	AC001-C
Tool type	Synchronous tapping adaptor	Accure-tec adaptor
Machine-side	Walter Capto™ in acc. with ISO 26623	Walter Capto™ in acc. with ISO 26623
Tool-side	ER11 / ER20 / ER25 / ER40	16 / 22 / 27 / 32 / 40
Page	814	822
		






Walter NCT adaptors

Designation	AB035-N
Tool type	Synchronous tapping adaptor
Machine-side	Modular NCT adaptor
Tool-side	ER20 / ER25
Page	815
	

Walter ScrewFit adaptors

Designation	AK530	AK580.C
Tool type	ScrewFit adaptors	
Machine-side	HSK DIN 69893-1 A	Walter Capto™ in acc. with ISO 26623
Tool-side	T09–T45	T09–T45
Page	816	817
		

Walter adaptors, one-piece – HSK, SK

Designation	AC001-H	AB035-H	AB035-W	AC001-S	AC001-J
Tool type	Accure-tec adaptor	Synchronous Tapping Adaptors		Accure-tec adaptors	
Machine-side	HSK DIN 69893-1 A	HSK DIN 69893-1 A	Combishank DIN 1835, Form B and D	SK DIN 69871 AD/B	JIS B 6339 AD/B
Tool-side	16 / 22 / 27 / 32 / 40	ER20 / ER25 / ER40	ER11 / ER20 / ER25	16 / 22 / 27 / 32 / 40	
Page	823	818	819	824	825
					

Designation	AB035-S	AB035-J
Tool type	Synchronous tapping adaptors	
Machine-side	SK DIN 69871	JIS B 6339
Tool-side	ER20 / ER25 / ER40	ER11 / ER20 / ER25 / ER40
Page	820	821
		

Accure-tec vibration-damped milling cutter adaptors

Designation	AC001-C	AC001-H	AC001-S	AC001-J
Tool type	Accure-tec adaptors			
Machine-side	Walter Capto™ in acc. with ISO 26623	HSK DIN 69893-1 A	SK DIN 69871 AD/B	JIS B 6339 AD/B
Tool-side	B16 / B22 / B27 / B32 / B40			
Page	822	823	824	825
				

Synchronous tapping adaptor

AB035-C mm


- Integrated minimum compensation in axial and radial directions
- ISO 26623

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	Collets	kg
Walter Capto™ in acc. with ISO 26623	AB035-C4-ER11-080	C4	M4-M5	24	80	ER11	0,4
	AB035-C4-ER20-102	C4	M4-M12	34	102	ER20	0,7
	AB035-C4-ER25-122	C4	M8-M20	42	122	ER25	1,0
	AB035-C5-ER20-103	C5	M4-M12	34	103	ER20	0,9
	AB035-C5-ER25-122	C5	M8-M20	42	122	ER25	1,2
	AB035-C5-ER40-154	C5	M16-M30	63	154	ER40	2,7
	AB035-C6-ER20-105	C6	M4-M12	34	105	ER20	1,2
	AB035-C6-ER25-124	C6	M8-M20	42	124	ER25	1,6
	AB035-C6-ER40-154	C6	M16-M30	63	154	ER40	2,9
	★ AB035-C8-ER20-112	C8	M4-M12	34	107	ER20	2,2
	★ AB035-C8-ER25-131	C8	M8-M20	42	126	ER25	2,6
	★ AB035-C8-ER40-161	C8	M16-M30	63	155	ER40	4

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used. The clamping nut can be damaged if the chuck is used without a sealing disc. For collets, see "Assembly parts and accessories". Bodies and assembly parts are included in the scope of delivery.

Assembly parts		ER11	ER11	ER20	ER25	ER40
	Clamping nut for internal coolant supply	FS2556	FS2557	FS1359	FS1449	FS1450
	Tensioning key	FS2554		FS2553	FS1544	FS1546

FS2556 corresponds to ER11-4.5

FS2557 corresponds to ER11-6

Synchronous tapping adaptor

AB035-N



– Integrated minimum compensation in axial and radial directions

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	Collets	kg
Modular NCT adaptor	AB035-N40-ER20-105	NCT 40	4-10	35	105	ER20	0,7
	AB035-N50-ER25-125	NCT 50	8-16	42	125	ER25	1,2

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used
 The clamping nut can be damaged if the chuck is used without a sealing disc.
 For collets, see "Assembly parts and accessories"
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	Collets	ER20	ER25
	Clamping nut for internal coolant supply	FS1359	FS1449
	Tensioning key	FS2553	FS1544

DIN 69893-1 A adaptor

AK530



– For ScrewFit front pieces

Tool	Designation	d ₁	d ₁₁	d ₁₄ mm	l ₄ mm	l ₁₆ mm	l ₁₈ mm	kg
	AK530.H100A.T09.055	HSK-A100	T09	9,7	55	15	10	2,06
	AK530.H100A.T14.055	HSK-A100	T14	14,5	55	15	10	2,09
	AK530.H100A.T18.055	HSK-A100	T18	18,5	55	15	10	2,12
	AK530.H100A.T22.100	HSK-A100	T22	22	100	38	10	2,31
	AK530.H100A.T22.150	HSK-A100	T22	22	150	38	10	2,63
	AK530.H100A.T22.200	HSK-A100	T22	22	200	38	10	3,02
	AK530.H100A.T22.055CO	HSK-A100	T22	22	55	16	10	2,16
	AK530.H100A.T28.110	HSK-A100	T28	28	110	48	10	2,49
	AK530.H100A.T28.160	HSK-A100	T28	28	160	48	10	2,96
	AK530.H100A.T28.210	HSK-A100	T28	28	210	48	10	3,49
	AK530.H100A.T28.260	HSK-A100	T28	28	260	48	10	4,17
	AK530.H100A.T28.060CO	HSK-A100	T28	28	60	23	10	2,17
	AK530.H100A.T36.120	HSK-A100	T36	36	120	48	10	2,84
	AK530.H100A.T36.170	HSK-A100	T36	36	170	48	10	3,53
	AK530.H100A.T36.220	HSK-A100	T36	36	220	48	10	4,32
	AK530.H100A.T36.270	HSK-A100	T36	36	270	48	10	5,31
	AK530.H100A.T36.070CO	HSK-A100	T36	36	70	33	10	2,33
	AK530.H100A.T45.120	HSK-A100	T45	45	120	57	10	3,30
	AK530.H100A.T45.170	HSK-A100	T45	45	170	57	10	4,28
	AK530.H100A.T45.220	HSK-A100	T45	45	220	57	10	5,40
	AK530.H100A.T45.070CO	HSK-A100	T45	45	70	33	10	2,53

Balance class: G6.3 where n = 16,000 rpm

...CO = Interface is manufactured to be cutting edge-oriented. For the use of B4030.T and B3230.T.

For accessories for HSK, see "Assembly parts and accessories"

For the tightening torques of screw-fit front pieces, see "Rotating adaptors/Assembly parts and accessories"

Walter Capto™ adaptor

AK580.C



– For ScrewFit front pieces
– ISO 26623

Tool	Designation	d ₁	d ₁₁	l ₄ mm	l ₁₆ mm	l ₁₈ mm	kg	
	Walter Capto™ in acc. with ISO 26623	AK580.C3.T14.45CO	C3	T14	45	27	10	0,16
	AK580.C3.T18.45CO	C3	T18	45	27	10	0,18	
	AK580.C3.T22.45CO	C3	T22	45	27	10	0,2	
	AK580.C3.T28.55CO	C3	T28	55	40	10	0,28	
	AK580.C4.T14.45CO	C4	T14	45	22	10	0,3	
	AK580.C4.T18.45CO	C4	T18	45	22	10	0,31	
	AK580.C4.T22.45CO	C4	T22	45	22	10	0,32	
	AK580.C4.T28.55CO	C4	T28	55	32	10	0,39	
	AK580.C4.T36.55CO	C4	T36	55	35	10	0,46	
	AK580.C4.T45.55CO	C4	T45	55		35	0,6	
	AK580.C5.T14.45	C5	T14	45	22	10	0,48	
	AK580.C5.T18.45	C5	T18	45	22	10	0,49	
	AK580.C5.T22.45	C5	T22	45	22	10	0,51	
	AK580.C5.T28.55	C5	T28	55	32	10	0,58	
	AK580.C5.T36.55	C5	T36	55	32	10	0,65	
	AK580.C5.T45.55	C5	T45	55	35	10	0,81	
	AK580.C6.T09.48	C6	T09	48	23	10	0,77	
	AK580.C6.T14.50	C6	T14	50	25	10	0,84	
	AK580.C6.T18.50	C6	T18	50	25	10	0,85	
	AK580.C6.T22.50	C6	T22	50	25	10	0,87	
	AK580.C6.T28.60	C6	T28	60	35	10	0,94	
	AK580.C6.T36.60	C6	T36	60	35	10	1,01	
	AK580.C6.T45.60CO	C6	T45	60	35	10	1,19	
	AK580.C8.T09.56	C8	T09	56	23	10	1,75	
	AK580.C8.T14.56	C8	T14	56	23	10	1,76	
	AK580.C8.T18.56	C8	T18	56	23	10	1,77	
	AK580.C8.T22.56	C8	T22	56	23	10	1,78	
	AK580.C8.T28.60	C8	T28	60	27	10	1,82	
	AK580.C8.T36.60	C8	T36	60	27	10	1,87	
	AK580.C8.T45.60CO	C8	T45	60	27	10	2	

For the tightening torques of screw-fit front pieces, see "Rotating adaptors/Assembly parts and accessories"
...CO = Interface is manufactured to be cutting edge-oriented. For the use of B4030.T and B3230.T.

Synchronous tapping adaptor

AB035-H



– Integrated minimum compensation in axial and radial directions

Tool	Designation	d_1	d_{11} mm	d_{12} mm	l_4 mm	Collets	kg	
	HSK DIN 69893-1 A	AB035-H63-ER20-108	HSK-A63	M4-M12	35	108	ER20	1,1
		AB035-H63-ER25-128	HSK-A63	M8-M20	44	128	ER25	1,5
		AB035-H63-ER40-160	HSK-A63	M16-M30	62	160	ER40	3,8
		AB035-H100-ER20-115	HSK-A100	M4-M12	35	145	ER20	2,5
		AB035-H100-ER25-134	HSK-A100	M8-M20	44	134	ER25	2,9
		AB035-H100-ER40-164	HSK-A100	M16-M30	62	163	ER40	4,4

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used. The clamping nut can be damaged if the chuck is used without a sealing disc.

For collets, see "Assembly parts and accessories"

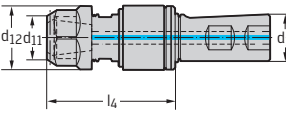
Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Collets	ER20	ER25	ER40
	Clamping nut for internal coolant supply		FS1359	FS1449	FS1450
	Tensioning key		FS2553	FS1544	FS1546

Synchronous tapping adaptor

AB035-W


– Integrated minimum compensation in axial and radial directions



Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	Collets	kg
DIN 6535 HE, turned 180° DIN 6535 HB	AB035-W25-ER11-052	25	M2-M5	19	52	ER11	0,4
	AB035-W25-ER20-069	25	M4-M12	34	69	ER20	0,8
	AB035-W25-ER25-088	25	M8-M20	42	88	ER25	1,3
							

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used

The clamping nut can be damaged if the chuck is used without a sealing disc.

For collets, see "Assembly parts and accessories"

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

Assembly parts	Collets	ER11	ER11	ER20	ER25
	Clamping nut for internal coolant supply	FS2556	FS2557	FS1359	FS1449
	Tensioning key	FS2554		FS2553	FS1544

FS2556 corresponds to ER11-4.5

FS2557 corresponds to ER11-6

Synchronous tapping adaptor

AB035-S



- Integrated minimum compensation in axial and radial directions
- ISO 7388-1

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	d ₁₃ mm	l ₄ mm	Collets	kg
SK DIN 69871 	AB035-S40-ER20-102	SK40	M4-M12	35	M16	102	ER20	1,3
	AB035-S40-ER25-122	SK40	M8-M20	44	M16	122	ER25	1,6
	AB035-S50-ER20-106	SK50	M4-M12	35	M24	106	ER20	3,1
	AB035-S50-ER25-126	SK50	M8-M20	44	M24	126	ER25	3,5
	AB035-S50-ER40-155	SK50	M16-M30	62	M24	155	ER40	4,9

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used

The clamping nut can be damaged if the chuck is used without a sealing disc.

For collets, see "Assembly parts and accessories"

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

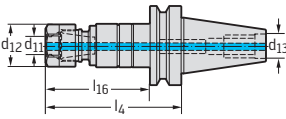
Assembly parts		ER20	ER25	ER40
	Clamping nut for internal coolant supply	FS1359	FS1449	FS1450
	Tensioning key	FS2553	FS1544	FS1546

Synchronous tapping adaptor



AB035-J



- Integrated minimum compensation in axial and radial directions
- ISO 7388-2

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	d ₁₃ mm	l ₄ mm	Collets	kg	
	JIS B 6339	AB035-J30-ER11-082	BT30	M2-M5	24	M12	82	ER11	0,6
		AB035-J30-ER20-105	BT30	M4-M12	35	M12	105	ER20	0,9
		AB035-J30-ER25-125	BT30	M8-M20	44	M12	125	ER25	1,2
		AB035-J40-ER20-110	BT40	M4-M12	35	M16	110	ER20	1,4
		AB035-J40-ER25-130	BT40	M8-M20	44	M16	130	ER25	1,8
		AB035-J50-ER20-125	BT50	M4-M12	35	M24	125	ER20	4,1
		AB035-J50-ER25-145	BT50	M8-M20	44	M24	145	ER25	4,5
		AB035-J50-ER40-174	BT50	M16-M30	62	M24	174	ER40	5,9

If collet chucks are used for the internal coolant supply, the sealing discs under "Assembly parts and accessories" must be used.
The clamping nut can be damaged if the chuck is used without a sealing disc.
For collets, see "Assembly parts and accessories"
Bodies and assembly parts are included in the scope of delivery.

Assembly parts		Collets	ER11	ER11	ER20	ER25	ER40
	Clamping nut for internal coolant supply		FS2556	FS2557	FS1359	FS1449	FS1450
	Tensioning key		FS2554		FS2553	FS1544	FS1546

FS2556 corresponds to ER11-4.5

FS2557 corresponds to ER11-6

Walter Capto™ adaptor – vibration-damped

AC001-C mm

Accure-tec



– For milling tools with parallel bore according to DIN 138
 – ISO 26623

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	l ₁₉ mm	kg
Walter Capto™ in acc. with ISO 26623 	★ AC001-C6-B16-160	C6	16	38	160	17	2,12
	★ AC001-C6-B22-210	C6	22	48	210	19	3,64
	★ AC001-C6-B27-260	C6	27	60	260	21	6,78
	★ AC001-C8-B22-210	C8	22	48	210	19	4,54
	★ AC001-C8-B27-260	C8	27	60	260	21	7,62
	★ AC001-C8-B32-330	C8	32	78	330	24	14,4
	★ AC001-C8-B40-350	C8	40	89	350	27	18,99

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

Assembly parts	d ₁₁ [mm]	16	22	27	32	40
ISO 4762 tightening screw		FS938 (SW 6)	FS939 (SW 8)	FS940 (SW 10)	FS941 (SW 14)	FS942 (SW 17)

Accessories	d ₁₁ [mm]	16	22	27	32	40
ISO 2936 key		ISO2936-6 (SW 6)	ISO2936-8 (SW 8)	ISO2936-10 (SW 10)	ISO2936-14 (SW 14)	ISO2936-17 (SW 17)

/ ★ New addition to the product range

HSK adaptor – vibration-damped AC001-H

Accure-tec



– For milling tools with parallel bore according to DIN 138

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	l ₁₉ mm	kg	
	HSK DIN 69893-1 A	★ AC001-H63-B16-160	HSK-A63	16	38	160	17	2,4
	★ AC001-H63-B22-210	HSK-A63	22	48	210	19	3,54	
	★ AC001-H63-B27-260	HSK-A63	27	60	260	21	6,56	
	★ AC001-H100-B22-210	HSK-A100	22	48	210	19	4,8	
	★ AC001-H100-B27-260	HSK-A100	27	60	260	21	7,92	
	★ AC001-H100-B32-330	HSK-A100	32	78	330	24	14,42	
	★ AC001-H100-B40-350	HSK-A100	40	89	350	27	19,34	

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

Assembly parts	d ₁₁ [mm]	16	22	27	32	40
	ISO 4762 tightening screw	FS938 (SW 6)	FS939 (SW 8)	FS940 (SW 10)	FS941 (SW 14)	FS942 (SW 17)

Accessories	d ₁₁ [mm]	16	22	27	32	40
	ISO 2936 key	ISO2936-6 (SW 6)	ISO2936-8 (SW 8)	ISO2936-10 (SW 10)	ISO2936-14 (SW 14)	ISO2936-17 (SW 17)

SK adaptor – vibration-damped

AC001-S

Accure-tec



– For milling tools with parallel bore according to DIN 138
 – ISO 7388-1

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	l ₁₉ mm	d ₁₃	kg
SK DIN 69871 AD/B 	★ AC001-S40-B16-160	SK40	16	38	160	17	M16	2,12
	★ AC001-S40-B22-210	SK40	22	48	210	19	M16	3,74
	★ AC001-S50-B22-210	SK50	22	48	210	19	M24	5,36
	★ AC001-S50-B27-260	SK50	27	60	260	21	M24	8,52
	★ AC001-S50-B32-330	SK50	32	78	330	24	M24	14,96
	★ AC001-S50-B40-350	SK50	40	89	350	27	M24	20,36

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

Assembly parts	d ₁₁ [mm]	16	22	27	32	40
	ISO 4762 tightening screw	FS938 (SW 6)	FS939 (SW 8)	FS940 (SW 10)	FS941 (SW 14)	FS942 (SW 17)

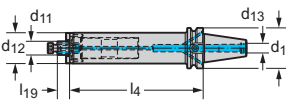
Accessories	d ₁₁ [mm]	16	22	27	32	40
	ISO 2936 key	ISO2936-6 (SW 6)	ISO2936-8 (SW 8)	ISO2936-10 (SW 10)	ISO2936-14 (SW 14)	ISO2936-17 (SW 17)

MAS-BT adaptor – vibration-damped AC001-J


Accure-tec




- For milling tools with parallel bore according to DIN 138
- ISO 7388-2

Tool	Designation	d ₁	d ₁₁ mm	d ₁₂ mm	l ₄ mm	l ₁₉ mm	d ₁₃	kg	
	JIS B 6339 AD/B	★ AC001-J40-B16-160	BT40	16	38	160	17	M16	2,22
	★ AC001-J40-B22-210	BT40	22	48	210	19	M16	3,78	
	★ AC001-J40-B27-260	BT40	27	60	260	21	M16	6,86	
	★ AC001-J50-B22-210	BT50	22	48	210	19	M24	6,08	
	★ AC001-J50-B27-260	BT50	27	60	260	21	M24	9,06	
	★ AC001-J50-B32-330	BT50	32	78	330	24	M24	15,34	
	★ AC001-J50-B40-350	BT50	40	89	350	27	M24	20,7	

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

Assembly parts	d ₁₁ [mm]	16	22	27	32	40
	ISO 4762 tightening screw	FS938 (SW 6)	FS939 (SW 8)	FS940 (SW 10)	FS941 (SW 14)	FS942 (SW 17)

Accessories	d ₁₁ [mm]	16	22	27	32	40
	ISO 2936 key	ISO2936-6 (SW 6)	ISO2936-8 (SW 8)	ISO2936-10 (SW 10)	ISO2936-14 (SW 14)	ISO2936-17 (SW 17)

Product range overview of assembly parts and accessories for adaptors

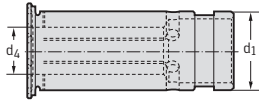
Designation	SL00..	SL00..
Tool type	Adaptor sleeves for peripheral cooling	Adaptor sleeves for internal cooling
Machine-side	Hydro-expansion	Hydro-expansion
Tool-side [mm]	3,2–25,4	3,2–25,4
Page	827	827
		
Designation	C340	GL00..
Tool type	Tapping collet	Cooling nozzle
Machine-side	ER11–ER40	ER collets
Tool-side [mm]	2,8–22	3,0–25
Page	828	829
		
Designation	AB735-ER	AB735-ER-R
Tool type	Synchronous Collet	Synchronous Collet
Machine-side	ER16–ER32	8,0–19
Tool-side [mm]		3,5–12
Page	830	830
		

Adaptor sleeves for peripheral cooling

inch



Tool	Designation	d ₁ inch	d ₄ inch	kg
For tools with shank in accordance with DIN 1835 Form A	SL0017	0,472	0,125	0,02
	SL0018	0,472	0,188	0,02
	SL0019	0,472	0,250	0,1
	SL0020	0,472	0,375	0,02
	SL0021	0,787	0,125	0,08
	SL0022	0,787	0,188	0,1
	SL0023	0,787	0,250	0,08
	SL0024	0,787	0,375	0,08
	SL0025	0,787	0,500	0,08
	SL0026	0,787	0,625	0,05
	SL0027	1,260	0,500	0,26
	SL0028	1,260	0,625	0,25
	SL0029	1,260	0,750	0,22
	SL0030	1,260	1,000	0,14

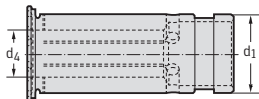


Adaptor sleeves for internal cooling

inch



Tool	Designation	d ₁ inch	d ₄ inch	kg
For tools with shank in accordance with DIN 1835 Form A	SL0001	0,472	0,125	0,03
	SL0002	0,472	0,188	0,03
	SL0003	0,472	0,250	0,03
	SL0004	0,472	0,375	0,1
	SL0005	0,787	0,125	0,93
	SL0006	0,787	0,188	0,1
	SL0007	0,787	0,250	0,10
	SL0008	0,787	0,375	0,08
	SL0009	0,787	0,500	0,06
	SL0010	0,787	0,625	0,04
	SL0011	1,260	0,250	0,28
	SL0012	1,260	0,375	0,28
	SL0013	1,260	0,500	0,28
	SL0014	1,260	0,625	0,25
	SL0015	1,260	0,750	0,25
	SL0016	1,260	1,000	0,17



ER tapping collets DIN 6499

C340 mm

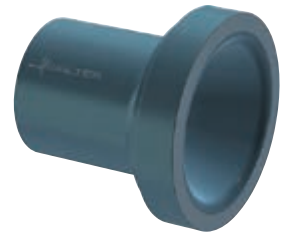


– ER – GB in accordance with DIN 6499

Tool	Designation	Collets	d ₁₁ mm	l ₁ mm	SW mm	kg
DIN 6499 	C340.11.028	ER11	2,8	18	2,1	0,01
	C340.11.035	ER11	3,5	18	2,7	0,01
	C340.11.045	ER11	4,5	18	3,4	0,01
	C340.11.060	ER11	6	18	4,9	0,01
	C340.20.045	ER20	4,5	31,5	3,4	0,05
	C340.20.060	ER20	6	31,5	4,9	0,04
	C340.20.070	ER20	7	31,5	5,5	0,04
	C340.20.080	ER20	8	31,5	6,2	0,04
	C340.20.090	ER20	9	31,5	7	0,04
	C340.20.100	ER20	10	31,5	8	0,04
	C340.25.045	ER25	4,5	34	3,4	0,01
	C340.25.060	ER25	6	34	4,9	0,01
	C340.25.070	ER25	7	34	5,5	0,01
	C340.25.080	ER25	8	34	6,2	0,08
	C340.25.090	ER25	9	34	7	0,08
	C340.25.100	ER25	10	34	8	0,07
	C340.25.110	ER25	11	34	9	0,07
	C340.25.120	ER25	12	34	9	0,07
	C340.25.140	ER25	14	34	11	0,06
	C340.25.160	ER25	16	34	12	0,05
	C340.32.045	ER32	4,5	40	3,4	0,16
	C340.32.060	ER32	6	40	4,9	0,15
	C340.32.070	ER32	7	40	5,5	0,15
	C340.32.080	ER32	8	40	6,2	0,16
	C340.32.090	ER32	9	40	7	0,15
	C340.32.100	ER32	10	40	8	0,15
	C340.32.110	ER32	11	40	9	0,15
	C340.32.120	ER32	12	40	9	0,15
	C340.32.140	ER32	14	40	11	0,14
	C340.32.160	ER32	16	40	12	0,13
	C340.40.120	ER40	12	46	9	0,28
	C340.40.140	ER40	14	46	11	0,28
	C340.40.160	ER40	16	46	12	0,26
	C340.40.180	ER40	18	46	14,5	0,25
C340.40.200	ER40	20	46	16	0,23	
C340.40.220	ER40	22	46	18	0,21	

Cooling nozzles for ER collets

GL00..



Tool	Designation	Collets	d ₁₁ mm	d ₁ mm	d ₁₂ mm	l ₄ mm	l ₁ mm	kg
	GL0001	ER16	3	6,4	13	11	15	0,006
	GL0002	ER16	4	7,4	13	11	15	0,006
	GL0003	ER16	5	8,4	13	11	15	0,006
	GL0004	ER16	6	9,4	13	11	15	0,006
	GL0005	ER16	7	11	13	12	15	0,006
	GL0006	ER16	8	11	13	12	15	0,006
	GL0007	ER16	9	11	13	3	6	0,004
	GL0008	ER16	10	11	13	3	6	0,004
	GL0009	ER20	6	9,4	16	11	15	0,008
	GL0010	ER20	7	10,4	16	11	15	0,004
	GL0011	ER20	8	11,4	16	11	15	0,008
	GL0012	ER20	9	12,4	16	11	15	0,008
	GL0013	ER20	10	14	16	12	15	0,008
	GL0014	ER20	12	14	16	3	6	0,005
	GL0015	ER25	6	9,4	21	11	15	0,01
	GL0016	ER25	7	10,4	21	11	15	0,01
	GL0017	ER25	8	11,4	21	11	15	0,01
	GL0018	ER25	9	12,4	21	11	15	0,01
	GL0019	ER25	10	13,4	21	11	15	0,01
	GL0020	ER25	12	15,4	21	11	15	0,01
	GL0021	ER25	14	17,4	21	11	15	0,01
	GL0022	ER25	16	19	21	12	15	0,01
	GL0023	ER32	6	9,4	27	11	15	0,016
	GL0024	ER32	7	10,4	27	11	15	0,016
	GL0025	ER32	8	11,4	27	11	15	0,016
	GL0026	ER32	9	12,4	27	11	15	0,016
	GL0027	ER32	10	13,4	27	11	15	0,016
	GL0028	ER32	12	15,4	27	11	15	0,016
	GL0029	ER32	14	17,4	27	11	15	0,016
	GL0030	ER32	16	19,4	27	11	15	0,016

Synchronised quick-change ER collet

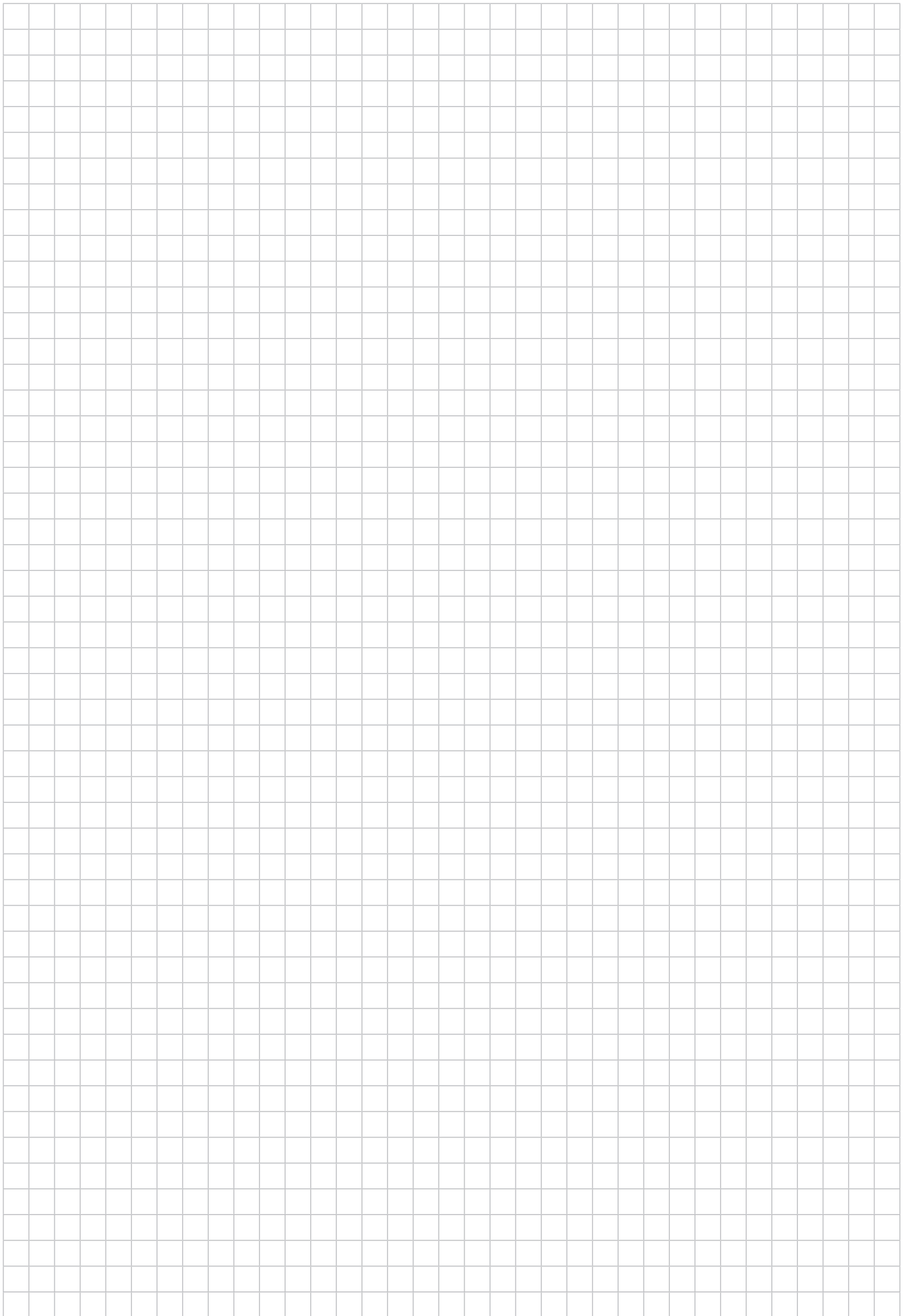
 AB735-ER


Tool	Designation	Collets	d ₁₁ mm	l ₁ mm	kg
DIN 6499 	★ AB735-ER16	ER16	17	26	0,03
	★ AB735-ER20	ER20	20,8	31,5	0,04
	★ AB735-ER25	ER25	25,8	34	0,05
	★ AB735-ER32	ER32	32,8	40	0,06

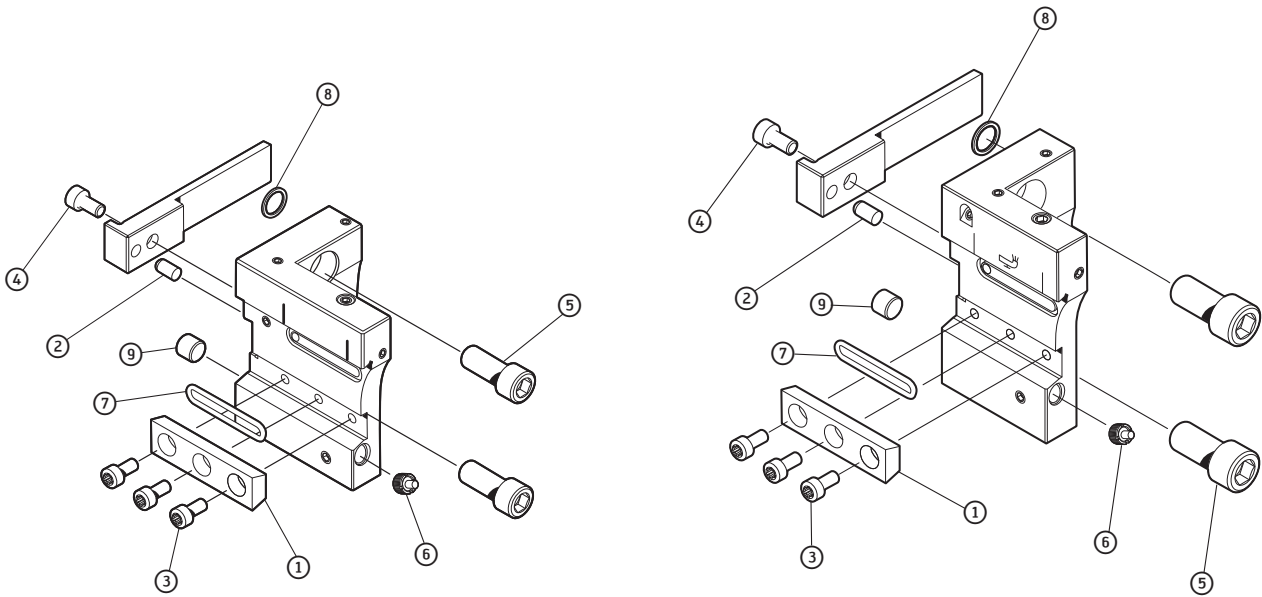
Synchronised quick-change collet

 AB735-ER-R


Tool	Designation	d ₁ mm	d ₁₁ mm	d ₁₂ mm	l ₄ mm	l ₁₇ mm	SW mm	Collet size	kg
Parallel shank 	★ AB735-ER16-R035-024	8	3,5	12,7	24	20,3	2,7	8	0,1
	★ AB735-ER16-R045-024	8	4,5	12,7	24	20,3	3,4	8	0,1
	★ AB735-ER16-R050-024	8	5,5	12,7	24	20,3	4,3	8	0,1
	★ AB735-ER20-R060-035	11	6	15,8	35	23	4,9	11	0,1
	★ AB735-ER20-R070-035	11	7	15,8	35	23	5,5	11	0,1
	★ AB735-ER25-R070-030	14	7	19	30	25,5	5,5	14	0,1
	★ AB735-ER25-R080-030	14	8	19	30	25,5	6,2	14	0,1
	★ AB735-ER25-R090-040	14	9	19	40	25,5	7	14	0,1
	★ AB735-ER32-R080-037	19	8	25	37	32	6,2	19	0,1
	★ AB735-ER32-R090-037	19	9	25	37	32	7	19	0,1
	★ AB735-ER32-R100-037	19	10	25	37	32	8	19	0,1
	★ AB735-ER32-R110-037	19	11	25	37	32	9	19	0,1
	★ AB735-ER32-R120-037	19	12	25	37	32	9	19	0,1



Assembly parts and accessories for Nakamura Type A2110-NA55-32R-076-P



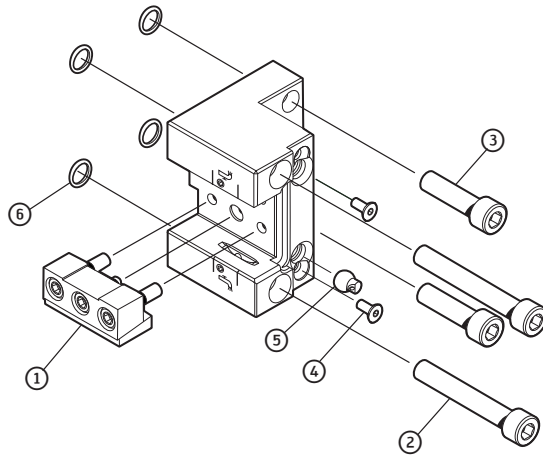
Assembly parts

	55/32	65/32
① Wedge	FK383	FK383
② Parallel pin	06,0M6x012 DIN7	06,0M6x012 DIN7
③ Screw	M05x010 ISO14579 14.9	M05x010 ISO14579 14.9
④ Screw	M06x012 ISO4762 12.9	M06x012 ISO4762 12.9
⑤ Screw	M10x025 ISO4762 12.9	M10x025 ISO4762 12.9
⑥ Nozzle	FS1477	FS1477
⑦ O-ring	O-ring 27x2 70 / 80	O-ring 27x2 70 / 80
⑧ Gasket	FS2563	FS2563
⑨ Plug	R1/8 DIN906	R1/8 DIN906

D 1

D 2

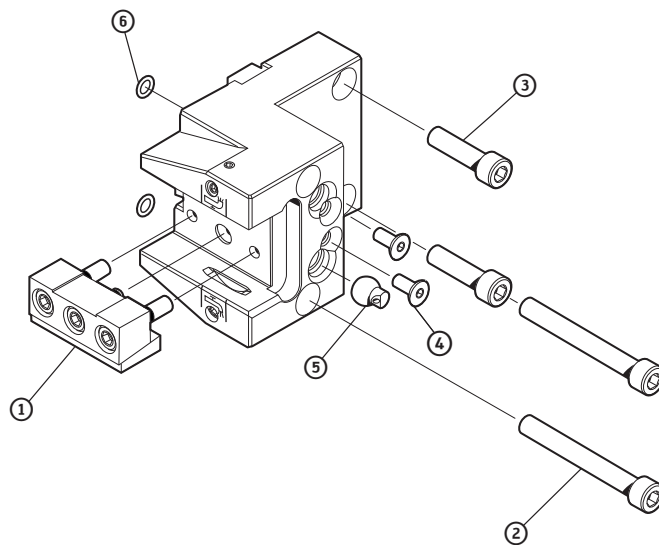
Assembly parts and accessories for Doosan A2120-DO-25N-072-P



Assembly parts

Assembly parts		Do
①	Wedge	FK393
②	Screw	M12x075 ISO4762 12.9
③	Screw	M12x040 ISO4762 12.9
④	Screw	M06x012 DIN7991 10.9
⑤	Nozzle	FS2561
⑥	O-ring	10x1,5-NBR 70

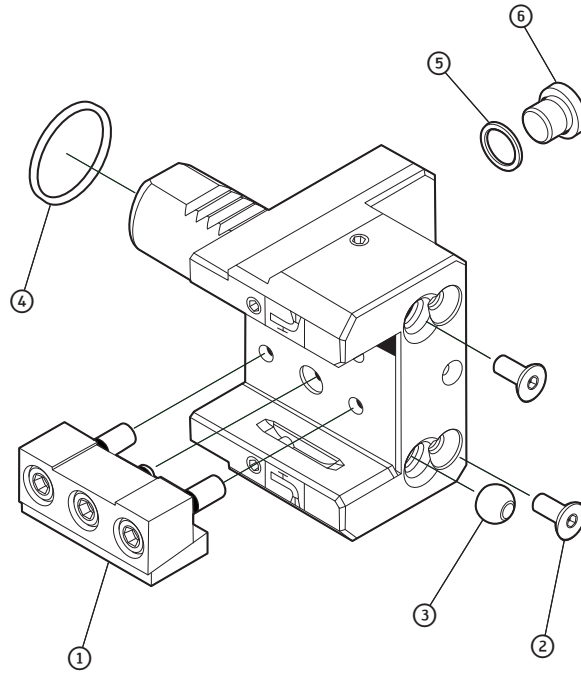
Assembly parts and accessories for BMT A2120-BT45-20N-063-P



Assembly parts

		BT45
①	Wedge	FK392
②	Screw	M08x065 ISO4762 12.9
③	Screw	M08x030 ISO4762 12.9
④	Screw	M06x012 DIN7991 10.9
⑤	Nozzle	FS2561
⑥	O-ring	6x1,5-NBR 70

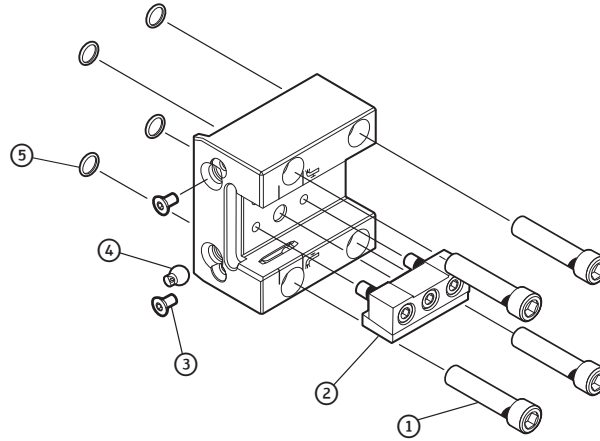
Assembly parts and accessories for VDI A2120-V25-20N-055-P



Assembly parts

Assembly parts		V25
①	Wedge	FK385
②	Screw	M05x012 DIN7991 10.9
③	Nozzle	FS2562
④	O-ring	23,52x1,78
⑤	Gasket	FS2564
⑥	Plug	G1/8 DIN908

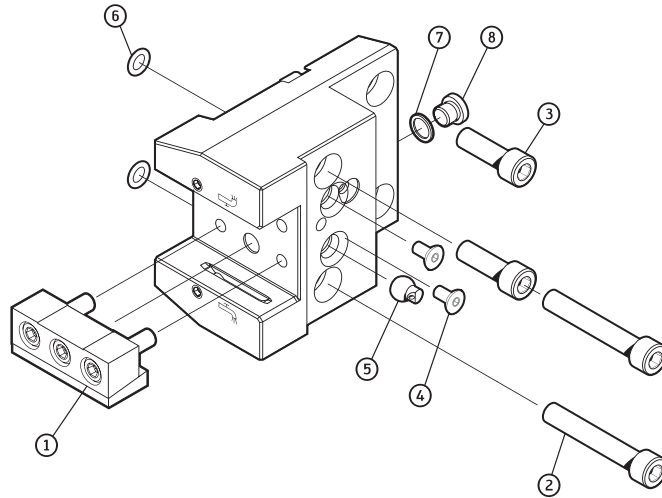
Assembly parts and accessories for Doosan A2121-DO-25N-050-P



Assembly parts

		Do
①	Wedge	FK393
②	Screw	M12x055 ISO4762 12.9
③	Screw	M06x012 DIN7991 10.9
④	Nozzle	FS2561
⑤	O-ring	10x1,5-NBR 70

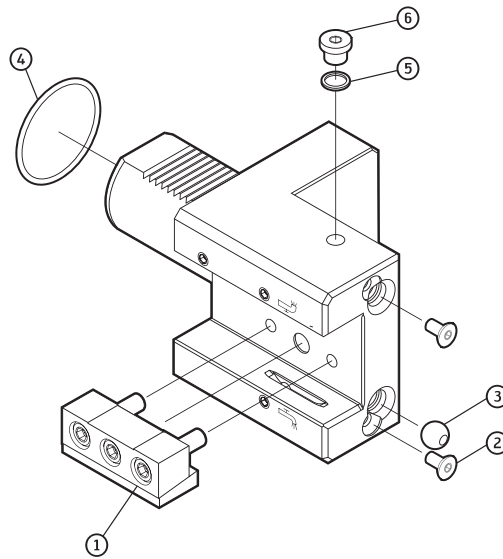
Assembly parts and accessories for BMT A2120-BT55-25N-060-P



Assembly parts

		BT55
①	Wedge	FK393
②	Screw	M10x60 ISO4762 12.9
③	Screw	M10x30 ISO4762 12.9
④	Screw	M06x012 DIN7991 10.9
⑤	Nozzle	FS2561
⑥	O-ring	8.00x2.00 NBR 70
⑦	Gasket	FS2564
⑧	Plug	M10x1 DIN908

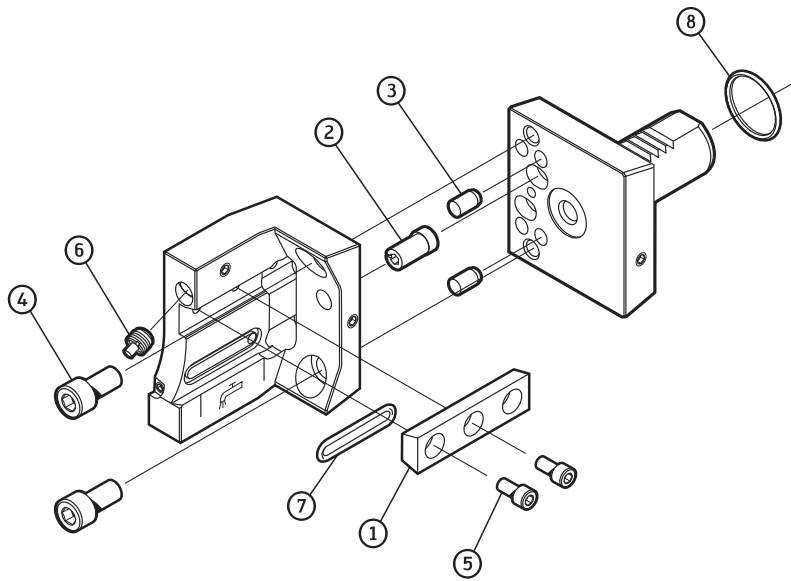
Assembly parts and accessories for VDI A2120-V50-25N-100-P



Assembly parts

		V50
①	Wedge	FK393
②	Screw	M06x012 DIN7991 10.9
③	Nozzle	FS2562
④	O-ring	O-ring 47.29x2.62 70/75
⑤	Gasket	FS2564
⑥	Plug	G1/8 DIN908

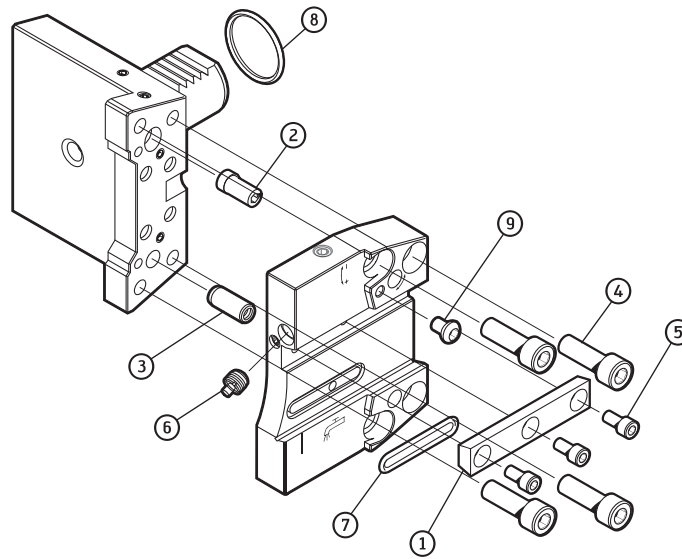
Assembly parts and accessories for Traub VDI A2110-V25T-26R/L-083-P



Assembly parts

		V25T
①	Wedge	FK383
②	Eccentric pin	FS2275
③	Parallel pin	06,0M6X012 ISO8734
④	Screw	M08X016 ISO4762 12.9
⑤	Screw	M05X010 ISO14579 8.8
⑥	Nozzle	FS1477
⑦	O-ring	O-ring 24X2 70 / 80
⑧	O-ring	O-ring 23.52X1.78 70/75

Assembly parts and accessories for Traub VDI A2110-V30-32R/L-080-P



Assembly parts

		V30
①	Wedge	FK384
②	Eccentric pin	FS2275
③	Parallel pin	08,0M6X20 ISO8735
④	Screw	M08X025 ISO4762 12.9
⑤	Screw	M05X010 ISO14579 8.8
⑥	Nozzle	FS1477
⑦	O-ring	O-ring 24X2 70 / 80
⑧	O-ring	O-ring 28.3X1.78 70/75
⑨	Plug	M05X08 ISO7380 10.9-Torx

Application information: Accure-tec AC001 – Vibration-damped adaptors for shell-end milling cutters Operating instructions

1.–3. Securing a milling cutter

The Accure-tec adaptors for milling cutters feature dynamic passive vibration damping in order to increase the dynamic rigidity of milling tools with a long projection length. They enable higher cutting parameters than conventional milling cutter adaptors. For optimal use of Accure-tec adaptors, please ensure you follow the operating instructions below.

Note:

Vibration-damped Accure tec milling cutter adaptors are instantly ready for use. No adjustments are required.

Please take the following steps for higher cutting parameters and conditions:

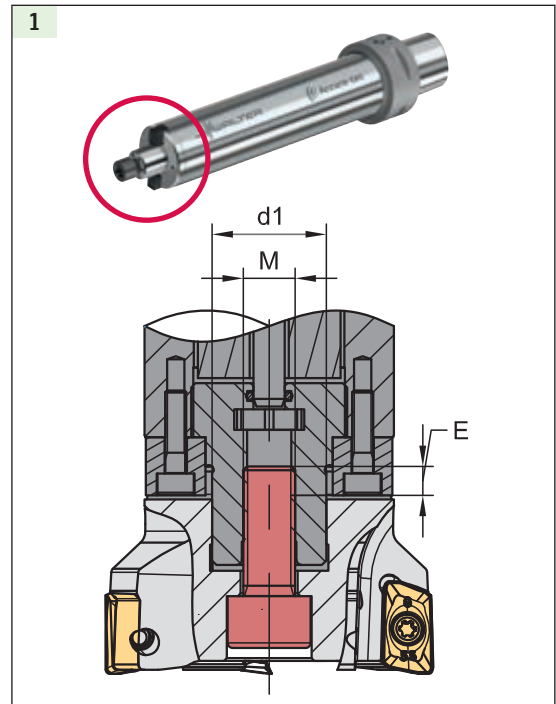
Axial tightening screw with suitable screw length

For optimum clamping, the screw (strength class 12.9) must project out of the milling cutter end face by at least the projection value E specified in Table 2.

Tightening screw torque: See Table 3.

Note:

The Accure-tec shell-end milling cutter arbors with $d_1 = \text{dia. } 40 \text{ mm}$ feature one central screw and four threaded holes for securing the milling cutter using four screws. When mounting the milling cutter, four suitable fastening screws should be used. These can vary depending on the milling cutter type.



2		Screw protrusion value (E)				
		Ø mm				
d_1		16	22	27	32	40
M		8 mm	10 mm	12 mm	16 mm	20 mm
E_{\min}		3 mm	6 mm	8 mm	12 mm	15 mm
E_{\max}		4 mm	8 mm	10 mm	16 mm	20 mm

3		Tightening torque				
		Ø mm				
d_1		16	22	27	32	40
Nm		30 Nm	40 Nm	60 Nm	80 Nm	110 Nm

4. Recommended machining parameters

The specified maximum speed (see Table 4 or label on the adaptor) must not be exceeded.

Machining parameters that are too large can create strong vibration that can reduce the functionality of the damping element. That is why the machining parameters must always be set such that no vibration occurs.

Optimising cutting data, order:

- Cutting speed v_c and feed per tooth f_z :**
Select the start values depending on the milling cutter and indexable insert (see Walter General Catalogue or Walter GPS tool navigation system).
- Select the maximum depth of cut a_p and cutting width a_e values.**
The width and depth of cut can be increased, bearing in mind the specified recommendations for milling cutters and indexable inserts, so long as no vibration occurs.

Important:

Contrary to the use of conventional shell-end milling cutter arbors, machining cannot be stabilised by increasing the radial cutting force (e.g. increasing the feed).

4		Maximum speed				
		Ø mm				
d_1		16	22	27	32	40
n_{\max} [rpm]		8 000	8 000	6 000	4 000	3 000

5. Maximum temperature of use

The temperature of use of the Accure-tec adaptor must not exceed the maximum permissible temperature (see Table 5), as this would damage the damping system.

Maximum temperature of use = 80 °C/176 °F

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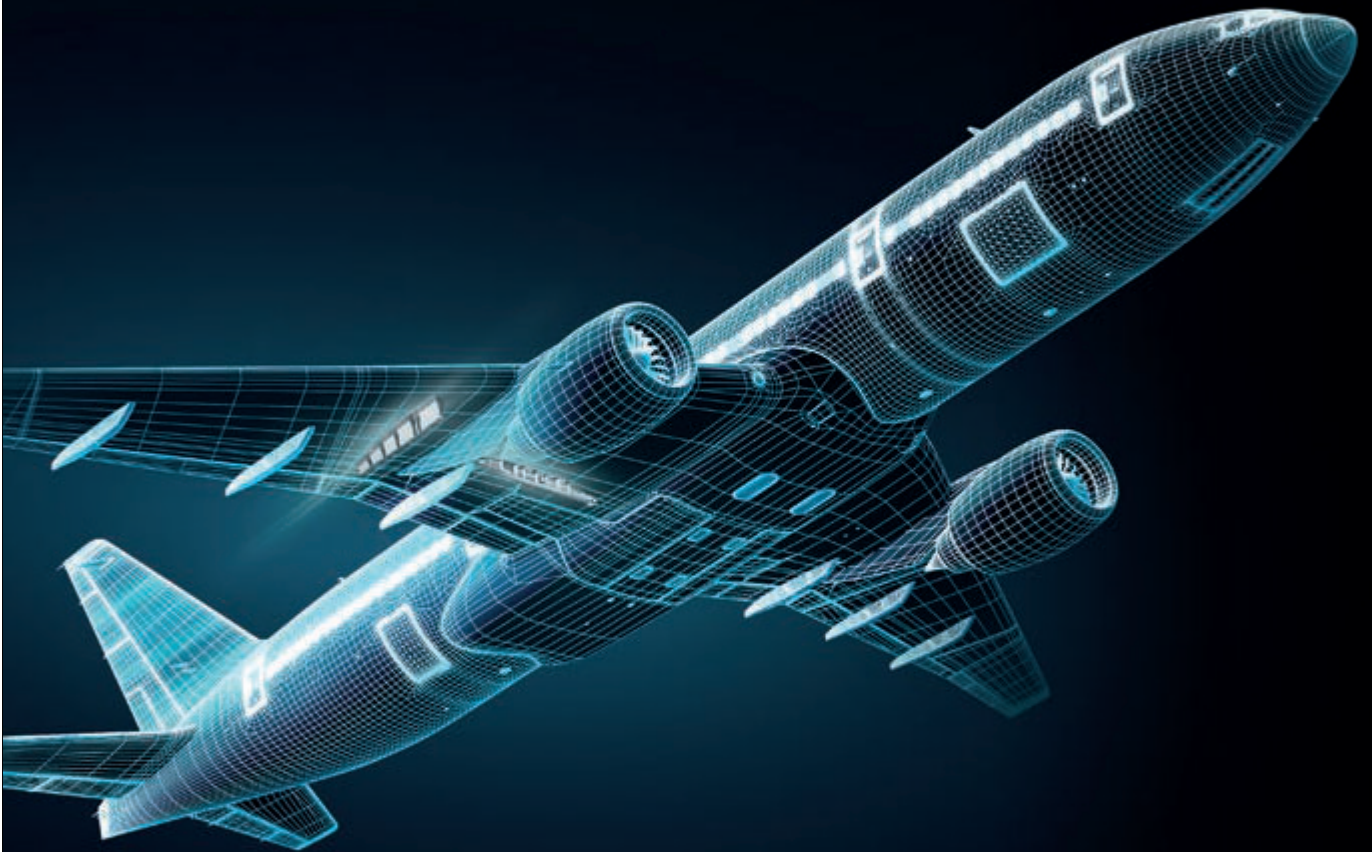
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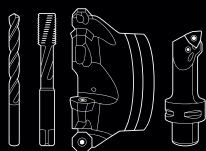
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Can we stop lighter planes being a weighty issue?




The number of passenger aircraft is set to double to more than 40,000 by 2030. Twenty-first-century long-haul aeroplanes have a take-off weight of up to 500 tonnes. The task of lifting these goliaths into the air economically is about more than keeping the weight of materials and components down – our future needs require stepping up process reliability and quality when machining them too. This is presenting suppliers to the aviation and aerospace industries with a huge challenge. Having a tool partner that keeps costs firmly on the ground is therefore crucial.

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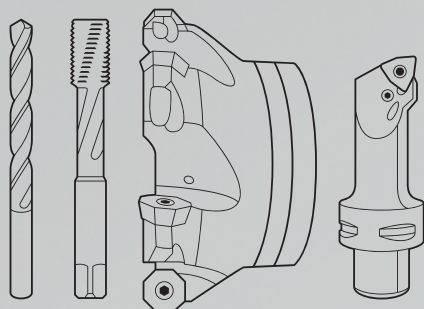
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