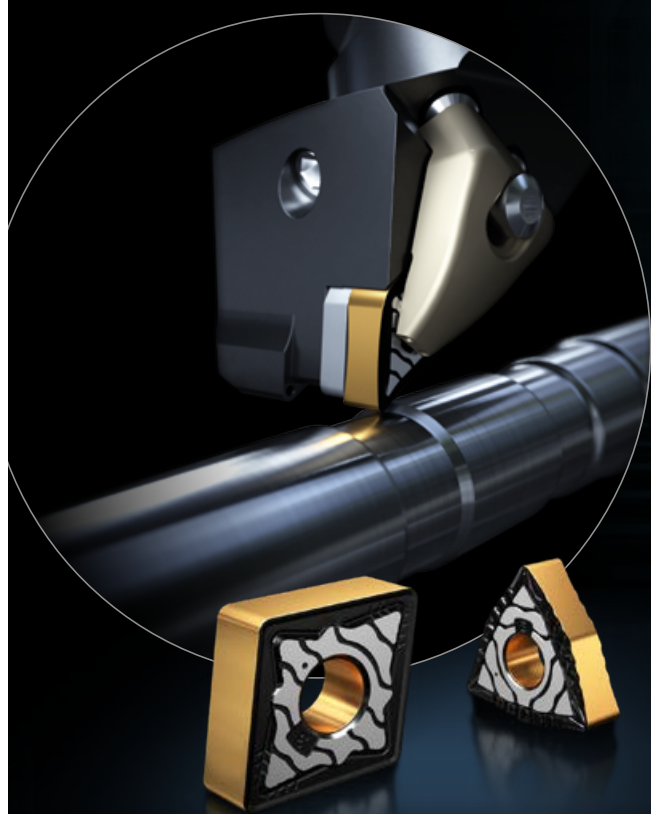


Tiger-tec® Gold

Turning takes time. A tool lifetime.





ISO turning – Indexable inserts

Product description	Tiger-tec® Gold turning grades WPP10G, WPP20G, WPP30G	4
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	Positive basic shape	33
	Copy turn system inserts – WL	34
Cutting data	Negative basic shape	36
	Positive basic shape	38

Powerful in steel and against wear.

THE GEOMETRY

- Negative geometries: FW5, FP5/MP3, MS3, MW5, MP5, MU5/RM5, RP5, RP7/HU3, HU5, HU7
- Positive geometries: FP4, FP6/MP4, MP6/RP4/HU6
- Geometries – WL25 copy turning system: FP4/MP4/MU6

THE GRADE

- New Tiger-tec® Gold coating: Fine-columnar, highly textured MT-TiCN – resistant to flank face wear
- Multilayer MT-TiCN structure improves the elastic property of the crystals
- Highly textured Al_2O_3 – for greater resistance to crater wear
- Multi-stage post-treatment for a smooth rake face, reduced friction and improved toughness

THE APPLICATION

WPP10G

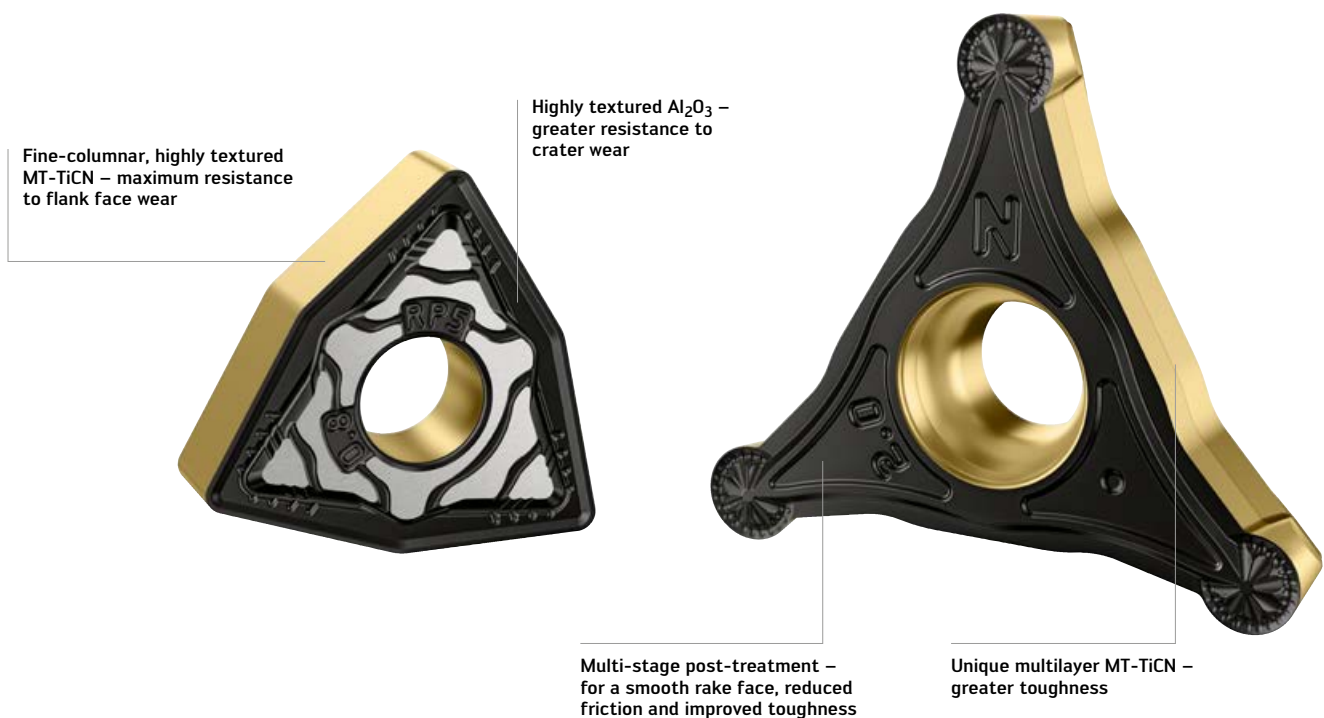
- Wear-resistant for continuous cutting and slightly interrupted cuts
- Primary application: Steel ISO P10;
Secondary application: Cast iron ISO K20

WPP20G

- Universal grade with long tool life and high level of process reliability for approx. 50% of all applications
- Primary application: Steel ISO P20;
Secondary application: Cast iron ISO K30

WPP30G

- Tough grade for interrupted cuts, unstable or unfavourable conditions
- Primary application: Steel ISO P30;
Secondary application: Cast iron ISO K40 and stainless steel ISO M20



Tiger-tec®Gold

Tiger-tec® Gold turning inserts

Fig.: WNMG080412-RP5 WPP10G and
WL25-RC0525N-MU6 WPP20G

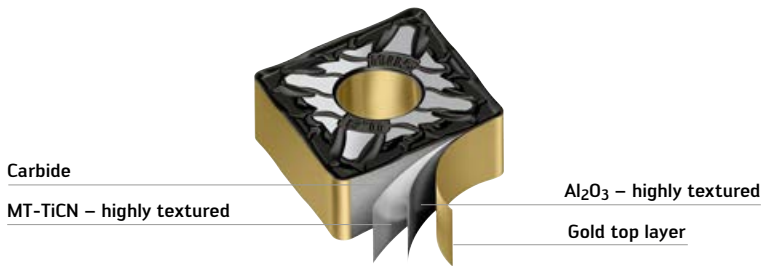
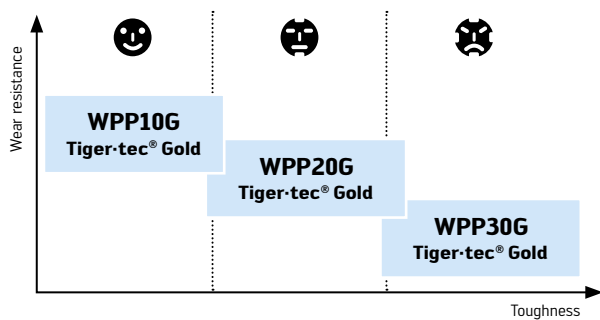
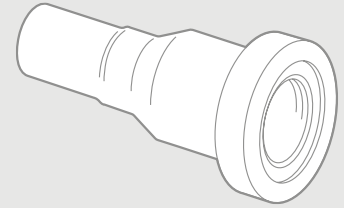


Fig.: TIG coating composition



APPLICATION EXAMPLE

Transmission shaft –
Internal machining, dia. 29 mm



Material: 18MnCrS5/DIN 1.8720

Tensile strength: 580 N/mm²

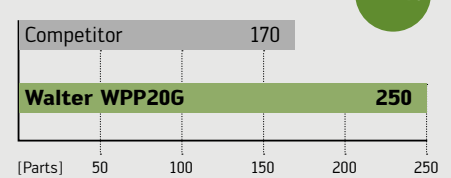
Tool: E20S-SDUCR11-R

Indexable insert: DCMT11T304-FP4 WPP20G

Cutting data

	Competitor ISO P20	Walter WPP20G Tiger-tec® Gold
v_c (m/min)	320	320
f (mm)	0.13	0.13
a_p (mm)	0.4	0.4
Cooling	Emulsion 15 bar	Emulsion 15 bar
Tool life (parts)	170	250

Comparison: Tool life quantity



Conventional TiCN



Tiger-tec® Gold
MT-TiCN –
highly textured



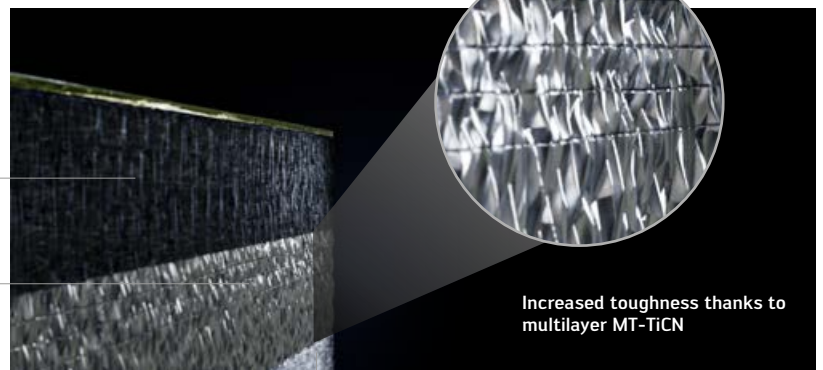
High wear resistance and
considerable increase in
tool life

Tiger-tec® Gold

Al_2O_3 –
highly textured

MT-TiCN –
highly textured

Carbide

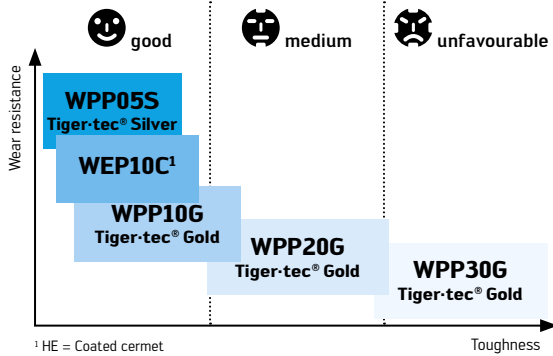


BENEFITS FOR YOU

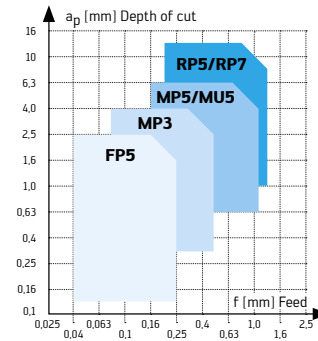
- High level of productivity and process reliability thanks to multi-stage post-treatment and unique, multilayer MT-TiCN structure
- Grades and benchmark geometries for short chips with versatile application
- High level of cost-efficiency due to highly textured Tiger-tec® Gold coating – average tool life increase of around 50%

Product range overview of indexable inserts for ISO turning: Carbide – Grades and Geometries

Machining steel ISO P

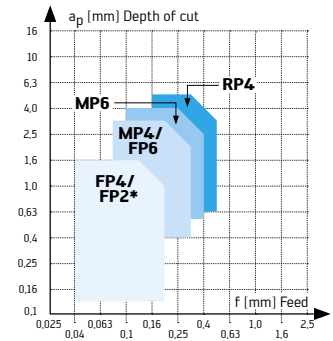


Negative basic shape double-sided



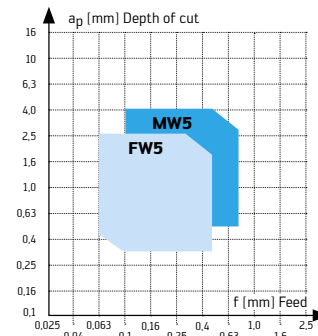
MP5: For universal machining
MU5: Easy-cutting – for ISO P and ISO M
RP5: For universal machining
RP7: For interrupted cuts, cast skin/forged skin

Positive basic shape

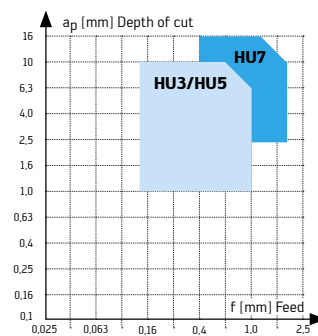


MP4: For universal machining, copy turning
FP6: For semi-finishing operations
* Fully ground circumference

Wiper



Negative basic shape single-sided



HU3: For universal machining
HU5: Easy-cutting

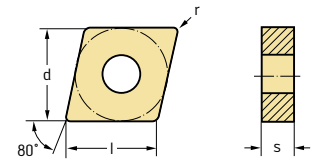
WALTER SELECT

Optimum indexable insert for → Good = 😊 → Average = 😐 → Poor = ☹️ machining conditions

Negative rhombic 80°

CNMG / CNMM

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P				
						WPP05S	HC	WPP10G	WPP20G	HE
	CNMG090304-FP5	9,67	0,4	0,04–0,20	0,1–1,5					
	CNMG090308-FP5	9,67	0,8	0,08–0,25	0,2–2,0					
	CNMG120402-FP5	12,9	0,2	0,04–0,12	0,1–0,5					
	CNMG120404-FP5	12,9	0,4	0,04–0,20	0,1–1,5					
	CNMG120408-FP5	12,9	0,8	0,08–0,25	0,2–2,0					
	CNMG120412-FP5	12,9	1,2	0,10–0,25	0,5–2,5					
	CNMG120404-FW5	12,9	0,4	0,10–0,40	0,3–3,0					
	CNMG120408-FW5	12,9	0,8	0,15–0,60	0,4–3,0					
Wiper										
	CNMG090304-MP3	9,67	0,4	0,06–0,20	0,3–2,2					
	CNMG090308-MP3	9,67	0,8	0,10–0,28	0,6–3,0					
	CNMG120404-MP3	12,9	0,4	0,08–0,22	0,3–2,5					
	CNMG120408-MP3	12,9	0,8	0,12–0,32	0,6–3,2					
	CNMG120412-MP3	12,9	1,2	0,16–0,40	0,8–3,5					
	CNMG120404-MP5	12,9	0,4	0,16–0,25	0,5–4,0					
	CNMG120408-MP5	12,9	0,8	0,18–0,40	0,6–5,0					
	CNMG120412-MP5	12,9	1,2	0,20–0,45	1,0–5,0					
	CNMG120416-MP5	12,9	1,6	0,25–0,50	1,2–5,0					
	CNMG160608-MP5	16,12	0,8	0,25–0,40	0,8–7,0					
	CNMG160612-MP5	16,12	1,2	0,30–0,50	1,0–7,0					
	CNMG160616-MP5	16,12	1,6	0,35–0,55	1,2–7,0					
	CNMG120404-MS3	12,9	0,4	0,12–0,25	0,6–3,0					
	CNMG120408-MS3	12,9	0,8	0,15–0,30	0,8–3,0					
	CNMG120412-MS3	12,9	1,2	0,15–0,40	1,0–3,5					
	CNMG120404-MU5	12,9	0,4	0,15–0,30	0,5–4,0					
	CNMG120408-MU5	12,9	0,8	0,15–0,40	0,6–5,0					
	CNMG120412-MU5	12,9	1,2	0,20–0,50	1,0–5,0					
	CNMG120416-MU5	12,9	1,6	0,25–0,55	1,2–5,0					
	CNMG160612-MU5	16,12	1,2	0,30–0,55	1,0–7,0					
	CNMG160616-MU5	16,12	1,6	0,35–0,55	1,2–7,0					
	CNMG120408-MW5	12,9	0,8	0,20–0,65	0,8–4,0					
	CNMG120412-MW5	12,9	1,2	0,25–0,70	1,5–4,0					
Wiper										
	CNMG120408-RM5	12,9	0,8	0,20–0,40	1,2–5,0					
	CNMG120412-RM5	12,9	1,2	0,25–0,50	1,5–5,0					
	CNMG120408-RP5	12,9	0,8	0,20–0,40	0,8–6,0					
	CNMG120412-RP5	12,9	1,2	0,25–0,60	1,0–6,0					
	CNMG120416-RP5	12,9	1,6	0,35–0,70	1,6–6,0					
	CNMG160608-RP5	16,12	0,8	0,25–0,50	1,0–8,0					
	CNMG160612-RP5	16,12	1,2	0,35–0,65	1,2–8,0					
	CNMG160616-RP5	16,12	1,6	0,40–0,70	1,6–8,0					
	CNMG160624-RP5	16,12	2,4	0,40–0,90	2,0–8,0					
	CNMG190608-RP5	19,34	0,8	0,25–0,50	1,0–10,0					
	CNMG190612-RP5	19,34	1,2	0,30–0,70	1,2–10,0					

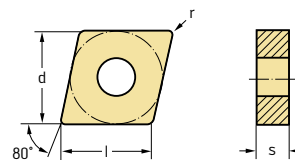
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet
HW = Uncoated carbide

Negative rhombic 80°

CNMG / CNMM

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P				
						WPP05S	HC	WPP10G	WPP20G	WPP30G
	CNMG190616-RP5	19,34	1,6	0,35–0,80	1,6–10,0					
	CNMG190624-RP5	19,34	2,4	0,45–1,00	2,0–10,0					
	CNMG250924-RP5	25,79	2,4	0,45–1,20	2,0–12,0					
	CNMG120408-RP7	12,9	0,8	0,18–0,40	0,8–5,0					
	CNMG120412-RP7	12,9	1,2	0,25–0,50	1,2–5,0					
	CNMG120416-RP7	12,9	1,6	0,35–0,50	1,5–5,0					
	CNMG160608-RP7	16,12	0,8	0,30–0,50	0,8–6,0					
	CNMG160612-RP7	16,12	1,2	0,35–0,60	1,2–6,0					
	CNMG160616-RP7	16,12	1,6	0,40–0,60	1,5–6,0					
	CNMG190612-RP7	19,34	1,2	0,35–0,60	1,2–7,0					
	CNMG190616-RP7	19,34	1,6	0,35–0,75	1,5–7,0					
	CNMG250924-RP7	25,79	2,4	0,45–1,00	3,0–9,0					
	CNMM120408-HU3	12,9	0,8	0,30–0,50	0,8–7,0					
	CNMM120412-HU3	12,9	1,2	0,35–0,70	1,2–7,0					
	CNMM120416-HU3	12,9	1,6	0,40–0,80	1,6–7,0					
	CNMM160612-HU3	16,12	1,2	0,35–0,70	1,2–9,0					
	CNMM160616-HU3	16,12	1,6	0,40–0,90	1,6–9,0					
	CNMM160624-HU3	16,12	2,4	0,45–1,00	2,4–9,0					
	CNMM190612-HU3	19,34	1,2	0,35–0,70	1,2–10,0					
	CNMM190616-HU3	19,34	1,6	0,40–0,90	1,6–10,0					
	CNMM190624-HU3	19,34	2,4	0,45–1,10	2,4–10,0					
	CNMM250924-HU3	25,79	2,4	0,45–1,20	2,4–12,0					
	CNMM120408-HU5	12,9	0,8	0,25–0,55	1,0–7,0					
	CNMM120412-HU5	12,9	1,2	0,30–0,70	1,5–7,0					
	CNMM160612-HU5	16,12	1,2	0,35–0,70	1,5–9,0					
	CNMM160616-HU5	16,12	1,6	0,40–0,80	2,0–9,0					
	CNMM190612-HU5	19,34	1,2	0,35–0,70	1,5–10,0					
	CNMM190616-HU5	19,34	1,6	0,40–0,90	2,0–10,0					
	CNMM190624-HU5	19,34	2,4	0,45–1,00	2,0–10,0					
	CNMM120412-HU7	12,9	1,2	0,40–0,80	1,5–8,0					
	CNMM160612-HU7	16,12	1,2	0,50–0,90	2,0–10,0					
	CNMM160616-HU7	16,12	1,6	0,50–1,10	2,0–10,0					
	CNMM160624-HU7	16,12	2,4	0,50–1,30	2,0–10,0					
	CNMM190612-HU7	19,34	1,2	0,50–0,90	2,0–13,0					
	CNMM190616-HU7	19,34	1,6	0,50–1,10	2,0–13,0					
	CNMM250924-HU7	25,79	2,4	0,60–1,60	3,0–17,0					

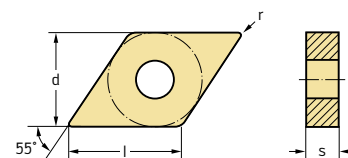
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet
HW = Uncoated carbide

Negative rhombic 55°

DNMG / DNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					WPP05S	WPP10G	WPP20G	WPP30G	WEP10C
	DNMG110402-FP5	0,2	0,04–0,12	0,1–0,5		☺	☺	☺	☺
	DNMG110404-FP5	0,4	0,04–0,20	0,1–1,5		☺	☺	☺	☺
	DNMG110408-FP5	0,8	0,08–0,25	0,2–2,0		☺	☺	☺	☺
	DNMG110412-FP5	1,2	0,10–0,25	0,5–2,5		☺	☺	☺	
	DNMG150404-FP5	0,4	0,05–0,20	0,1–1,5		☺	☺	☺	☺
	DNMG150408-FP5	0,8	0,08–0,25	0,2–2,0		☺	☺	☺	☺
	DNMG150412-FP5	1,2	0,10–0,25	0,5–2,5		☺	☺	☺	☺
	DNMG150604-FP5	0,4	0,05–0,20	0,1–1,5		☺	☺	☺	☺
	DNMG150608-FP5	0,8	0,08–0,25	0,2–2,0		☺	☺	☺	☺
	DNMG150612-FP5	1,2	0,10–0,25	0,5–2,5		☺	☺	☺	☺
 Wiper	DNMG110404-FW5	0,4	0,10–0,35	0,3–2,0		☺	☺		
	DNMG110408-FW5	0,8	0,15–0,50	0,4–2,0		☺	☺		
	DNMG150404-FW5	0,4	0,10–0,40	0,3–3,0		☺			
	DNMG150408-FW5	0,8	0,15–0,50	0,4–3,0		☺			
	DNMG150604-FW5	0,4	0,10–0,40	0,3–3,0		☺	☺		
	DNMG150608-FW5	0,8	0,15–0,50	0,4–3,0		☺	☺		
	DNMG110404-MP3	0,4	0,08–0,22	0,3–2,2		☺	☺		
	DNMG110408-MP3	0,8	0,12–0,32	0,6–3,0	☺	☺	☺	☺	
	DNMG110412-MP3	1,2	0,16–0,40	0,8–3,2		☺	☺		
	DNMG150404-MP3	0,4	0,08–0,22	0,3–2,5		☺	☺		
	DNMG150408-MP3	0,8	0,12–0,32	0,6–3,2	☺	☺	☺	☺	
	DNMG150412-MP3	1,2	0,16–0,40	0,8–3,5	☺	☺	☺	☺	
	DNMG150604-MP3	0,4	0,08–0,22	0,3–2,5		☺	☺	☺	
	DNMG150608-MP3	0,8	0,12–0,32	0,6–3,2	☺	☺	☺	☺	
	DNMG150612-MP3	1,2	0,16–0,40	0,8–3,5	☺	☺	☺		
	DNMG110404-MP5	0,4	0,16–0,25	0,5–4,0		☺	☺	☺	
	DNMG110408-MP5	0,8	0,18–0,35	0,6–4,0		☺	☺	☺	
	DNMG110412-MP5	1,2	0,20–0,40	1,0–4,0		☺	☺	☺	
	DNMG150404-MP5	0,4	0,16–0,25	0,5–4,0		☺	☺	☺	
	DNMG150408-MP5	0,8	0,18–0,35	0,6–5,0		☺	☺	☺	
	DNMG150412-MP5	1,2	0,20–0,40	1,0–5,0	☺	☺	☺	☺	
	DNMG150604-MP5	0,4	0,16–0,25	0,5–4,0		☺	☺	☺	
	DNMG150608-MP5	0,8	0,18–0,35	0,6–5,0	☺	☺	☺	☺	
	DNMG150612-MP5	1,2	0,20–0,40	1,0–5,0	☺	☺	☺	☺	
	DNMG110408-MS3	0,8	0,12–0,30	0,8–2,5			☺		
	DNMG150608-MS3	0,8	0,15–0,30	0,8–2,5			☺		
	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		☺	☺		

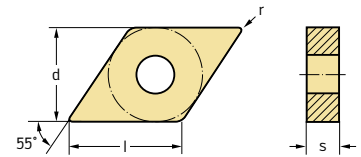
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Negative rhombic 55°

DNMG / DNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					WPP05S	HC			HE
 Wiper	DNMG110408-MW5	0,8	0,15–0,50	0,8–3,0		⊗	⊗		
	DNMG110412-MW5	1,2	0,20–0,60	1,5–3,0		⊗	⊗		
	DNMG150408-MW5	0,8	0,15–0,55	0,8–4,0		⊗			
	DNMG150412-MW5	1,2	0,20–0,65	1,5–4,0		⊗			
	DNMG150608-MW5	0,8	0,15–0,55	1,5–4,0	⊗	⊗	⊗		
	DNMG150612-MW5	1,2	0,20–0,65	1,5–4,0	⊗	⊗	⊗		
	DNMG110408-RP5	0,8	0,18–0,35	0,8–4,0		⊗	⊗	⊗	
	DNMG110412-RP5	1,2	0,20–0,40	1,0–4,0		⊗	⊗	⊗	
	DNMG150408-RP5	0,8	0,18–0,35	0,8–5,0	⊗	⊗	⊗	⊗	
	DNMG150412-RP5	1,2	0,20–0,40	1,0–5,0		⊗	⊗	⊗	
	DNMG150608-RP5	0,8	0,15–0,35	0,8–5,0	⊗	⊗	⊗	⊗	
	DNMG150612-RP5	1,2	0,20–0,55	1,0–5,0	⊗	⊗	⊗	⊗	
	DNMG150616-RP5	1,6	0,25–0,65	1,6–5,0	⊗	⊗	⊗	⊗	
	DNMM150608-HU3	0,8	0,25–0,45	0,8–5,0		⊗	⊗	⊗	
	DNMM150612-HU3	1,2	0,30–0,50	1,2–5,0		⊗	⊗	⊗	
	DNMM150616-HU3	1,6	0,35–0,60	1,6–5,0		⊗	⊗		
	DNMM150608-HU5	0,8	0,25–0,45	1,0–5,0			⊗		
	DNMM150612-HU5	1,2	0,30–0,50	1,5–5,0			⊗		

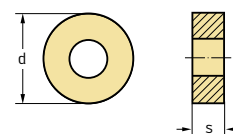
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Negative round

RNMG

Tiger-tec® Gold



Cutting inserts

	Designation	d mm	f mm	a _p mm	P HC
					WPP20G
	RNMG120400-RP5	12,7	0,20–0,60	1,2–5,0	

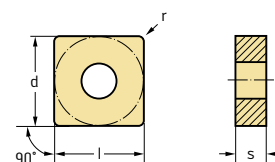
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Negative square

SNMG / SNMM

Tiger-tec® Gold



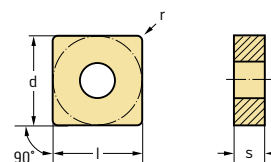
Cutting inserts

	Designation	r mm	f mm	a _p mm	P HC			
					WPP05S	WPP10G	WPP20G	WPP30G
	SNMG090308-FP5	0,8	0,06–0,20	0,2–1,5				
	SNMG120404-FP5	0,4	0,04–0,22	0,1–1,8				
	SNMG120408-FP5	0,8	0,08–0,25	0,2–2,0				
	SNMG120412-FP5	1,2	0,10–0,25	0,5–2,5				
	SNMG090308-MP3	0,8	0,10–0,32	0,6–3,0				
	SNMG120404-MP3	0,4	0,08–0,25	0,3–2,5				
	SNMG120408-MP3	0,8	0,12–0,35	0,6–3,2				
	SNMG120412-MP3	1,2	0,16–0,40	0,8–3,5				
	SNMG090308-MP5	0,8	0,14–0,32	0,6–3,0				
	SNMG120408-MP5	0,8	0,18–0,40	0,6–5,0				
	SNMG120412-MP5	1,2	0,20–0,45	1,0–5,0				
	SNMG120416-MP5	1,6	0,25–0,50	1,2–5,0				
	SNMG150608-MP5	0,8	0,25–0,50	0,8–8,0				
	SNMG150612-MP5	1,2	0,30–0,50	1,0–8,0				
	SNMG150616-MP5	1,6	0,35–0,55	1,2–8,0				
	SNMG120408-MU5	0,8	0,18–0,45	0,6–5,0				

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Negative square SNMG / SNMM Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P			
					HC			
					WPP05S	WPP10G	WPP20G	WPP30G
	SNMG120408-RP5	0,8	0,20–0,55	0,8–6,0		☑	☑	☑
	SNMG120412-RP5	1,2	0,25–0,65	1,0–6,0	☑	☑	☑	☑
	SNMG120416-RP5	1,6	0,35–0,75	1,6–6,0		☑	☑	☑
	SNMG150612-RP5	1,2	0,25–0,70	1,2–8,0	☑	☑	☑	☑
	SNMG150616-RP5	1,6	0,35–0,80	1,6–8,0	☑	☑	☑	☑
	SNMG190612-RP5	1,2	0,30–0,70	1,2–10,0		☑	☑	☑
	SNMG190616-RP5	1,6	0,35–0,80	1,6–10,0			☑	☑
	SNMG190624-RP5	2,4	0,44–1,20	2,0–10,0			☑	
	SNMG250924-RP5	2,4	0,55–1,20	2,5–12,0			☑	☑
	SNMG120408-RP7	0,8	0,25–0,45	0,8–5,0			☑	☑
	SNMG120412-RP7	1,2	0,30–0,50	1,2–5,0			☑	☑
	SNMG120416-RP7	1,6	0,35–0,60	1,5–5,0		☑	☑	☑
	SNMG150612-RP7	1,2	0,35–0,60	1,2–6,0		☑	☑	☑
	SNMG150616-RP7	1,6	0,40–0,70	1,5–6,0		☑	☑	☑
	SNMG190612-RP7	1,2	0,35–0,60	1,2–7,0			☑	☑
	SNMG190616-RP7	1,6	0,40–0,70	1,5–7,0		☑	☑	☑
	SNMG190624-RP7	2,4	0,40–0,80	2,5–7,0			☑	☑
	SNMG250924-RP7	2,4	0,55–1,00	3,0–10,0			☑	
	SNMM120408-HU3	0,8	0,30–0,50	0,8–7,0			☑	☑
	SNMM120412-HU3	1,2	0,35–0,70	1,2–7,0			☑	
	SNMM120416-HU3	1,6	0,40–0,90	1,6–7,0		☑	☑	
	SNMM150612-HU3	1,2	0,35–0,75	1,2–9,0			☑	
	SNMM150616-HU3	1,6	0,40–0,90	1,6–9,0		☑	☑	
	SNMM150624-HU3	2,4	0,45–1,10	2,0–9,0				
	SNMM190612-HU3	1,2	0,35–0,75	1,2–10,0		☑	☑	☑
	SNMM190616-HU3	1,6	0,40–1,00	1,6–10,0		☑	☑	☑
	SNMM190624-HU3	2,4	0,45–1,20	2,0–10,0			☑	
	SNMM250724-HU3	2,4	0,55–1,20	2,5–12,0			☑	
	SNMM250916-HU3	1,6	0,45–1,00	1,6–12,0			☑	
	SNMM250924-HU3	2,4	0,55–1,20	2,5–12,0			☑	
	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			☑	
	SNMM150616-HU7	1,6	0,45–1,00	2,0–12,0		☑	☑	
	SNMM150624-HU7	2,4	0,50–1,40	2,5–12,0		☑	☑	
	SNMM190612-HU7	1,2	0,50–1,00	2,0–13,0			☑	☑
	SNMM190616-HU7	1,6	0,50–1,10	2,5–13,0			☑	☑
	SNMM190624-HU7	2,4	0,60–1,60	3,0–13,0		☑	☑	☑
	SNMM250716-HU7	1,6	0,50–1,10	2,5–17,0			☑	
	SNMM250724-HU7	2,4	0,60–1,60	3,0–17,0			☑	☑
	SNMM250924-HU7	2,4	0,60–1,60	3,0–17,0		☑	☑	☑

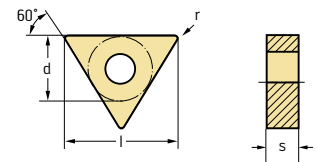
See the ISO 1832 designation key for dimensions

HC = Coated carbide

Negative triangular 60°

TNMG / TNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					WPP05S	HC	WPP10G	WPP20G	HE
	TNMG110304-FP5	0,4	0,04–0,15	0,1–1,2					
	TNMG110308-FP5	0,8	0,08–0,20	0,2–1,5					
	TNMG160404-FP5	0,4	0,04–0,20	0,1–1,5					
	TNMG160408-FP5	0,8	0,08–0,25	0,2–2,0					
	TNMG160412-FP5	1,2	0,10–0,25	0,5–2,5					
	TNMG160404-FW5	0,4	0,10–0,40	0,3–3,0					
	TNMG160408-FW5	0,8	0,15–0,50	0,4–3,0					
Wiper									
	TNMG110304-MP3	0,4	0,06–0,18	0,3–2,0					
	TNMG110308-MP3	0,8	0,10–0,25	0,6–2,2					
	TNMG160304-MP3	0,4	0,08–0,22	0,3–2,2					
	TNMG160404-MP3	0,4	0,08–0,22	0,3–2,2					
	TNMG160408-MP3	0,8	0,12–0,32	0,6–3,0					
	TNMG160412-MP3	1,2	0,16–0,40	0,8–3,2					
	TNMG220408-MP3	0,8	0,12–0,32	0,6–3,2					
	TNMG220412-MP3	1,2	0,16–0,40	0,8–3,5					
	TNMG160308-MP5	0,8	0,18–0,35	0,6–4,0					
	TNMG160404-MP5	0,4	0,16–0,25	0,5–4,0					
	TNMG160408-MP5	0,8	0,18–0,35	0,6–4,0					
	TNMG160412-MP5	1,2	0,20–0,40	1,0–4,0					
	TNMG220404-MP5	0,4	0,16–0,25	0,7–4,0					
	TNMG220408-MP5	0,8	0,18–0,35	0,8–5,0					
	TNMG220412-MP5	1,2	0,20–0,40	1,0–5,0					
	TNMG220416-MP5	1,6	0,25–0,45	1,2–5,0					
	TNMG270608-MP5	0,8	0,25–0,45	0,8–7,0					
	TNMG270612-MP5	1,2	0,30–0,50	1,0–7,0					
	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-MU5	0,4	0,15–0,30	0,5–4,0					
	TNMG160408-MU5	0,8	0,18–0,35	0,6–4,0					
	TNMG160412-MU5	1,2	0,20–0,45	1,0–4,0					
	TNMG160408-MW5	0,8	0,15–0,55	0,8–4,0					
	TNMG160412-MW5	1,2	0,20–0,65	1,5–4,0					
Wiper									
	TNMG160408-RP5	0,8	0,20–0,40	0,8–5,0					
	TNMG160412-RP5	1,2	0,25–0,55	1,0–5,0					
	TNMG220408-RP5	0,8	0,20–0,45	0,8–7,0					
	TNMG220412-RP5	1,2	0,25–0,60	1,0–7,0					
	TNMG220416-RP5	1,6	0,35–0,70	1,6–7,0					
	TNMG270612-RP5	1,2	0,30–0,70	1,6–10,0					
	TNMG270616-RP5	1,6	0,35–0,80	2,0–10,0					
	TNMG330924-RP5	2,4	0,45–1,20	2,5–13,0					

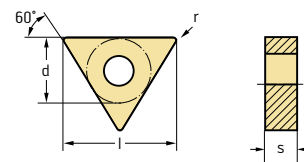
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Negative triangular 60°

TNMG / TNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					WPP05S	WPP10G	WPP20G	WPP30G	WEP10C
	TNMG270616-RP7	1,6	0,35–0,75	1,5–9,0			HC		
	TNMG270624-RP7	2,4	0,55–1,00	3,0–9,0			HC		
	TNMM160408-HU3	0,8	0,30–0,45	0,8–6,0			HC		
	TNMM160412-HU3	1,2	0,35–0,50	1,2–6,0			HC		
	TNMM220408-HU3	0,8	0,30–0,50	0,8–7,0			HC	HC	
	TNMM220412-HU3	1,2	0,35–0,60	1,2–7,0			HC	HC	
	TNMM220416-HU3	1,6	0,40–0,80	1,6–7,0			HC	HC	
	TNMM270612-HU3	1,2	0,35–0,65	1,2–8,0			HC	HC	
	TNMM270616-HU7	1,6	0,50–1,10	2,0–13,0			HC	HC	

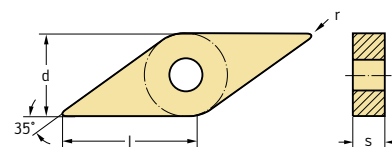
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Negative rhombic 35°

VNMG

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P			
					WPP10G	HC	WPP20G	WPP30G
	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-MP3	0,4	0,08–0,22	0,3–2,2	☺	☺	☺	☺
	VNMG160408-MP3	0,8	0,12–0,32	0,6–3,0	☺	☺	☺	☺
	VNMG160412-MP3	1,2	0,16–0,35	0,8–3,2	☺	☺	☺	☺
	VNMG160404-MP5	0,4	0,10–0,18	0,5–2,0	☺	☺	☺	☺
	VNMG160408-MP5	0,8	0,18–0,35	0,6–4,0	☺	☺	☺	☺
	VNMG160412-MP5	1,2	0,20–0,40	0,8–4,0	☺	☺	☺	☺
	VNMG220408-MP5	0,8	0,18–0,35	0,6–4,0	☺	☺	☺	☺

See the ISO 1832 designation key for dimensions

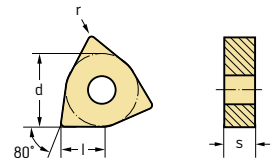
HE = Coated cermet

HC = Coated carbide

Negative Trigon 80°

WNMG / WNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					WPP05S	HC			HE
	WNMG060404-FP5	0,4	0,04–0,20	0,1–1,5		☒	☒		
	WNMG060408-FP5	0,8	0,08–0,25	0,2–2,0		☒	☒		
	WNMG080404-FP5	0,4	0,05–0,20	0,1–1,5		☒	☒		☒
	WNMG080408-FP5	0,8	0,08–0,25	0,2–2,0		☒	☒		☒
	WNMG080412-FP5	1,2	0,10–0,25	0,5–2,5		☒	☒		
 Wiper	WNMG060404-FW5	0,4	0,10–0,35	0,3–2,0		☒	☒		
	WNMG060408-FW5	0,8	0,15–0,50	0,4–2,0		☒	☒		
	WNMG080404-FW5	0,4	0,10–0,40	0,3–3,0		☒	☒		
	WNMG080408-FW5	0,8	0,15–0,60	0,4–3,0		☒	☒		
	WNMG080412-FW5	1,2	0,25–0,65	0,6–3,0		☒	☒		
	WNMG060404-MP3	0,4	0,08–0,22	0,3–2,2		☒	☒		
	WNMG060408-MP3	0,8	0,12–0,32	0,6–3,0		☒	☒		
	WNMG060412-MP3	1,2	0,16–0,35	0,8–3,2			☒		
	WNMG080404-MP3	0,4	0,08–0,22	0,3–2,5			☒	☒	
	WNMG080408-MP3	0,8	0,12–0,32	0,6–3,2	☒	☒	☒	☒	
	WNMG080412-MP3	1,2	0,16–0,40	0,8–3,5	☒	☒	☒	☒	
	WNMG060404-MP5	0,4	0,16–0,25	0,5–4,0		☒	☒	☒	
	WNMG060408-MP5	0,8	0,18–0,35	0,6–4,0	☒	☒	☒	☒	
	WNMG060412-MP5	1,2	0,20–0,40	1,0–4,0		☒	☒		
	WNMG080404-MP5	0,4	0,16–0,25	0,5–4,0		☒	☒	☒	
	WNMG080408-MP5	0,8	0,18–0,40	0,6–5,0	☒	☒	☒	☒	
	WNMG080412-MP5	1,2	0,20–0,45	1,0–5,0	☒	☒	☒	☒	
	WNMG080416-MP5	1,6	0,25–0,50	1,2–5,0		☒	☒		
	WNMG100608-MP5	0,8	0,25–0,40	0,8–7,0		☒	☒		
	WNMG100612-MP5	1,2	0,30–0,50	1,0–7,0		☒	☒		
	WNMG080408-MS3	0,8	0,15–0,30	0,8–3,0			☒		
	WNMG060408-MU5	0,8	0,15–0,35	0,6–3,0		☒	☒		
	WNMG080404-MU5	0,4	0,15–0,30	0,5–4,0		☒	☒		
	WNMG080408-MU5	0,8	0,15–0,40	0,6–5,0		☒	☒		
	WNMG080412-MU5	1,2	0,20–0,50	1,0–5,0	☒	☒	☒		
	WNMG080416-MU5	1,6	0,25–0,55	1,2–5,0		☒	☒		
	WNMG060408-MW5	0,8	0,15–0,50	0,8–3,0		☒	☒		
	WNMG060412-MW5	1,2	0,20–0,60	1,5–3,0		☒	☒		
 Wiper	WNMG080408-MW5	0,8	0,20–0,65	0,8–4,0	☒	☒	☒		
	WNMG080412-MW5	1,2	0,25–0,70	1,5–4,0	☒	☒	☒		
	WNMG080408-RM5	0,8	0,20–0,40	1,2–4,5		☒	☒		

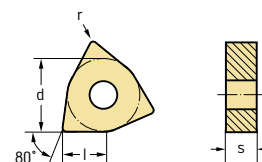
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Negative Trigon 80°

WNMG / WNMM

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	f mm	a _p mm	P				
					HC				HE
					WPP05S	WPP10G	WPP20G	WPP30G	WEP10C
	WNMG060408-RP5	0,8	0,20-0,40	0,8-4,0		☺	☺	☺	
	WNMG060412-RP5	1,2	0,25-0,50	1,0-4,0		☺	☺	☺	
	WNMG080408-RP5	0,8	0,20-0,40	0,8-6,0	☺	☺	☺	☺	
	WNMG080412-RP5	1,2	0,25-0,60	1,0-6,0	☺	☺	☺	☺	
	WNMG080416-RP5	1,6	0,35-0,70	1,6-6,0		☺	☺	☺	
	WNMG100612-RP5	1,2	0,35-0,65	1,2-8,0		☺	☺	☺	
	WNMG100616-RP5	1,6	0,35-0,70	1,6-8,0		☺	☺	☺	
	WNMG080408-RP7	0,8	0,18-0,40	0,8-5,0		☺	☺	☺	
	WNMG080412-RP7	1,2	0,25-0,50	1,2-5,0		☺	☺	☺	
	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			☺	☺	
	WNMM080412-HU3	1,2	0,35-0,60	1,2-6,0			☺		
	WNMM100612-HU3	1,2	0,35-0,70	1,2-8,0		☺	☺		
	WNMM100616-HU3	1,6	0,40-0,90	1,6-8,0		☺	☺		

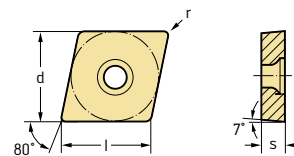
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Positive rhombic 80°

CCGT / CCMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						WPP10G	WPP20G	WPP30G	WEP10C
	CCGT060201M-FP2	6,45	0,07	0,02–0,06	0,1–1,5				☺
	CCGT060202M-FP2	6,45	0,17	0,05–0,12	0,2–2,0				☺
	CCGT060204M-FP2	6,45	0,37	0,08–0,25	0,2–2,5				☺
	CCGT09T301M-FP2	9,67	0,07	0,02–0,06	0,1–1,5				☺
	CCGT09T302M-FP2	9,67	0,17	0,05–0,12	0,2–2,0				☺
	CCGT09T304M-FP2	9,67	0,37	0,08–0,25	0,2–2,5				☺
	CCGT09T308M-FP2	9,67	0,77	0,10–0,30	0,3–3,0				☺
	CCGT060204-MP4	6,45	0,4	0,08–0,20	0,4–2,0		☺		
	CCGT09T304-MP4	9,67	0,4	0,08–0,25	0,4–3,0	☺	☺		
	CCGT09T308-MP4	9,67	0,8	0,12–0,32	0,5–3,0	☺	☺		
	CCGT120408-MP4	12,9	0,8	0,12–0,32	0,5–3,5	☺	☺		
	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	12,9	0,4	0,05–0,16	0,1–1,5	☺	☺		
	CCMT120408-FP4	12,9	0,8	0,08–0,20	0,1–1,5	☺	☺		
	CCMT060204-FP6	6,45	0,4	0,06–0,18	0,3–2,0	☺	☺		
	CCMT060208-FP6	6,45	0,8	0,10–0,20	0,5–2,0		☺		
	CCMT09T304-FP6	9,67	0,4	0,08–0,20	0,3–2,0	☺	☺		
	CCMT09T308-FP6	9,67	0,8	0,12–0,32	0,5–2,0	☺	☺		
	CCMT120404-FP6	12,9	0,4	0,10–0,25	0,3–2,5		☺		
	CCMT120408-FP6	12,9	0,8	0,12–0,32	0,5–2,5		☺		
	CCMT060204-MP4	6,45	0,4	0,08–0,20	0,4–2,0	☺	☺		
	CCMT060208-MP4	6,45	0,8	0,12–0,25	0,5–2,0	☺	☺		
	CCMT09T304-MP4	9,67	0,4	0,08–0,25	0,4–3,0	☺	☺		
	CCMT09T308-MP4	9,67	0,8	0,12–0,32	0,5–3,0	☺	☺		
	CCMT120404-MP4	12,9	0,4	0,12–0,25	0,4–3,5	☺	☺		
	CCMT120408-MP4	12,9	0,8	0,12–0,32	0,5–3,5	☺	☺		
	CCMT060204-MP6	6,45	0,4	0,10–0,20	0,4–2,5	☺	☺	☺	
	CCMT090304-MP6	9,67	0,4	0,10–0,25	0,4–3,5		☺		
	CCMT090308-MP6	9,67	0,8	0,15–0,32	0,6–3,5		☺		
	CCMT09T304-MP6	9,67	0,4	0,08–0,25	0,4–3,0	☺	☺	☺	
	CCMT09T308-MP6	9,67	0,8	0,12–0,32	0,5–3,0	☺	☺	☺	
	CCMT120408-MP6	12,9	0,8	0,15–0,35	0,6–4,0	☺	☺	☺	
	CCMT160508-MP6	16,12	0,8	0,15–0,40	0,8–4,0		☺	☺	
	CCMT060204-RP4	6,45	0,4	0,12–0,25	0,4–2,5	☺	☺	☺	
	CCMT060208-RP4	6,45	0,8	0,16–0,30	0,6–2,5		☺	☺	
	CCMT09T304-RP4	9,67	0,4	0,12–0,25	0,4–3,0	☺	☺	☺	
	CCMT09T308-RP4	9,67	0,8	0,16–0,35	0,6–4,0	☺	☺	☺	
	CCMT120404-RP4	12,9	0,4	0,12–0,30	0,4–4,0	☺	☺	☺	
	CCMT120408-RP4	12,9	0,8	0,16–0,40	0,6–5,0	☺	☺	☺	
	CCMT120412-RP4	12,9	1,2	0,20–0,50	0,8–5,0	☺	☺	☺	

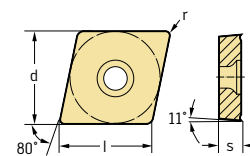
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 80°

CPGT / CPMT

Tiger·tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P		
						HC	HE	
						WPP10G	WPP20G	WEP10C
	CPGT050202M-FP2	5,64	0,17	0,05–0,12	0,2–2,0			⊗
	CPGT050204M-FP2	5,64	0,37	0,08–0,20	0,2–2,0			⊗
	CPGT050204-MP4	5,64	0,4	0,08–0,20	0,4–1,5		⊗	
	CPGT060204-MP4	6,45	0,4	0,08–0,20	0,4–2,0	⊗	⊗	
	CPGT09T304-MP4	9,67	0,4	0,08–0,25	0,4–3,0	⊗	⊗	
	CPGT09T308-MP4	9,67	0,8	0,12–0,32	0,5–3,0	⊗	⊗	
	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-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		⊗	

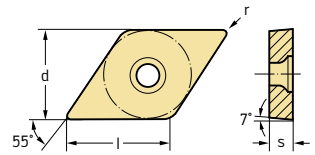
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 55°

DCGT / DCMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						WPP10G	HC	WPP30G	HE
	DCGT070202M-FP2	7,75	0,17	0,05–0,12	0,2–2,0				⊗
	DCGT070204M-FP2	7,75	0,37	0,08–0,25	0,2–2,5				⊗
	DCGT11T3005M-FP2	11,63	0,03	0,01–0,04	0,1–1,0				⊗
	DCGT11T301M-FP2	11,63	0,07	0,02–0,06	0,1–1,5				⊗
	DCGT11T302M-FP2	11,63	0,17	0,05–0,12	0,2–2,0				⊗
	DCGT11T304M-FP2	11,63	0,37	0,08–0,25	0,2–2,5				⊗
	DCGT11T308M-FP2	11,63	0,77	0,10–0,30	0,3–3,0				⊗
	DCGT070204-MP4	7,75	0,4	0,08–0,20	0,4–2,0		⊗		
	DCGT11T304-MP4	11,63	0,4	0,08–0,25	0,4–3,0	⊗	⊗		
	DCGT11T308-MP4	11,63	0,8	0,12–0,32	0,5–3,0	⊗	⊗		
	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-FP6	7,75	0,4	0,06–0,18	0,3–2,0	⊗	⊗		
	DCMT11T304-FP6	11,63	0,4	0,08–0,20	0,3–2,0	⊗	⊗		
	DCMT11T308-FP6	11,63	0,8	0,10–0,25	0,5–2,0	⊗	⊗		
	DCMT070204-MP4	7,75	0,4	0,08–0,20	0,4–2,0	⊗	⊗		
	DCMT070208-MP4	7,75	0,8	0,12–0,25	0,5–2,0	⊗	⊗		
	DCMT11T304-MP4	11,63	0,4	0,08–0,25	0,4–3,0	⊗	⊗		
	DCMT11T308-MP4	11,63	0,8	0,12–0,32	0,5–3,0	⊗	⊗		
	DCMT11T312-MP4	11,63	1,2	0,15–0,35	0,5–3,0	⊗	⊗		
	DCMT11T304-MP6	11,63	0,4	0,10–0,25	0,4–3,5	⊗	⊗	⊗	
	DCMT11T308-MP6	11,63	0,8	0,15–0,32	0,6–3,5	⊗	⊗	⊗	
	DCMT150404-MP6	15,5	0,4	0,10–0,25	0,4–4,0		⊗		
	DCMT150408-MP6	15,5	0,8	0,12–0,36	0,6–4,0		⊗	⊗	
	DCMT070204-RP4	7,75	0,4	0,12–0,20	0,4–2,0	⊗	⊗	⊗	
	DCMT070208-RP4	7,75	0,8	0,16–0,30	0,6–2,0	⊗	⊗	⊗	
	DCMT11T304-RP4	11,63	0,4	0,12–0,25	0,4–3,0	⊗	⊗	⊗	
	DCMT11T308-RP4	11,63	0,8	0,16–0,35	0,6–4,0	⊗	⊗	⊗	
	DCMT11T312-RP4	11,63	1,2	0,20–0,40	0,8–4,0	⊗	⊗	⊗	

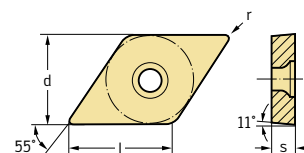
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive rhombic 55°

DPGT / DPMT

Tiger·tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P	
						HC	
						WPP10G	WPP20G
	DPGT11T304-MP4	11,63	0,4	0,08–0,25	0,4–3,0		
	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		
	DPMT070204-MP4	7,75	0,4	0,08–0,20	0,4–2,0		
	DPMT11T304-MP4	11,63	0,4	0,08–0,25	0,4–3,0		
	DPMT11T308-MP4	11,63	0,8	0,12–0,32	0,5–3,0		

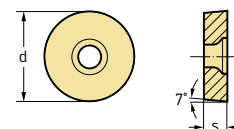
See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive round

RCMT / RCMX

Tiger·tec® Gold



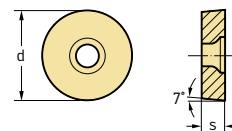
Cutting inserts

	Designation	d mm	f mm	a _p mm	P		
					HC		
					WPP10G	WPP20G	WPP30G
	RCMT0602M0-FP4	6	0,07–0,30	0,6–2,5			
	RCMT0803M0-FP4	8	0,08–0,30	0,8–3,0			
	RCMT10T3M0-FP4	10	0,10–0,35	1,0–4,0			
	RCMT1204M0-FP4	12	0,12–0,40	1,2–5,0			
	RCMT10T3M0-HU6	10	0,12–0,80	1,0–4,0			
	RCMT1204M0-HU6	12	0,12–1,20	1,2–5,0			
	RCMT1606M0-HU6	16	0,15–1,20	1,6–7,0			
	RCMT0602M0-RP4	6	0,08–0,50	0,6–2,5			
	RCMT060300-RP4	6,35	0,08–0,50	0,6–2,5			
	RCMT0803M0-RP4	8	0,10–0,60	0,8–3,0			
	RCMT09T300-RP4	9,525	0,10–0,60	0,8–3,0			
	RCMT10T3M0-RP4	10	0,12–0,80	1,0–4,0			
	RCMT120400-RP4	12,7	0,12–1,00	1,2–5,0			
	RCMT1204M0-RP4	12	0,12–1,00	1,2–5,0			
	RCMT1605M0-RP4	16	0,15–1,20	1,6–7,0			
	RCMT1606M0-RP4	16	0,15–1,20	1,6–7,0			

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive round RCMT / RCMX Tiger·tec® Gold



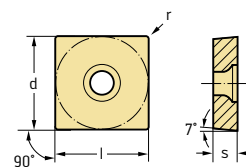
Cutting inserts

	Designation	d mm	f mm	a _p mm	P		
					HC		
					WPP10G	WPP20G	WPP30G
	RCMX2006M0-HU6	20	0,25–1,40	2,0–9,0	☞	☞	☞
	RCMX2507M0-HU6	25	0,30–1,60	2,5–11,0	☞	☞	☞
	RCMX3209M0-HU6	32	0,30–1,70	3,2–15,0	☞	☞	☞

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive square SCGT / SCMT Tiger·tec® Gold



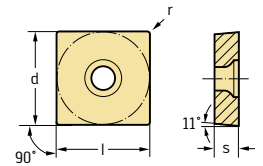
Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						HC	WPP10G	WPP20G	WPP30G
	SCGT09T304-MP4	9,53	0,4	0,08–0,25	0,4–3,0	⊗	⊗	⊗	⊗
	SCGT09T308-MP4	9,53	0,8	0,12–0,32	0,5–3,0	⊗	⊗	⊗	⊗
	SCGT120408-MP4	12,7	0,8	0,12–0,32	0,5–3,5	⊗	⊗	⊗	⊗
	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-FP6	9,53	0,4	0,08–0,20	0,3–2,0	⊗	⊗	⊗	⊗
	SCMT09T308-FP6	9,53	0,8	0,10–0,25	0,5–2,0	⊗	⊗	⊗	⊗
	SCMT120408-FP6	12,7	0,8	0,12–0,32	0,5–2,5	⊗	⊗	⊗	⊗
	SCMT09T304-MP4	9,53	0,4	0,08–0,25	0,4–3,0	⊗	⊗	⊗	⊗
	SCMT09T308-MP4	9,53	0,8	0,12–0,32	0,5–3,0	⊗	⊗	⊗	⊗
	SCMT120408-MP4	12,7	0,8	0,12–0,32	0,5–3,5	⊗	⊗	⊗	⊗
	SCMT09T304-RP4	9,53	0,4	0,12–0,25	0,4–3,0	⊗	⊗	⊗	⊗
	SCMT09T308-RP4	9,53	0,8	0,16–0,35	0,6–4,0	⊗	⊗	⊗	⊗
	SCMT09T312-RP4	9,53	1,2	0,20–0,45	0,8–5,0	⊗	⊗	⊗	⊗
	SCMT120404-RP4	12,7	0,4	0,12–0,25	0,4–3,0	⊗	⊗	⊗	⊗
	SCMT120408-RP4	12,7	0,8	0,16–0,40	0,6–5,0	⊗	⊗	⊗	⊗
	SCMT120412-RP4	12,7	1,2	0,20–0,50	0,8–5,0	⊗	⊗	⊗	⊗

See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Positive square SPMT Tiger·tec® Gold



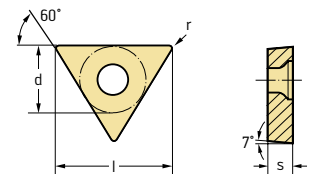
Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P
						HC
	SPMT09T304-MP4	9,53	0,4	0,08–0,25	0,4–3,0	WPP20G
	SPMT09T308-MP4	9,53	0,8	0,12–0,32	0,5–3,0	WPP20G

See the ISO 1832 designation key for dimensions

HC = Coated carbide

Positive triangular 60° TCGT / TCMT Tiger·tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						WPP10G	HC	WPP30G	HE
	TCGT06T104M-FP2	6,87	0,37	0,08–0,25	0,2–2,0				⊕
	TCGT090204M-FP2	9,62	0,37	0,08–0,25	0,2–2,5				⊕
	TCGT110202M-FP2	11	0,17	0,05–0,12	0,2–2,0				⊕
	TCGT110204M-FP2	11	0,37	0,08–0,25	0,2–2,5				⊕
	TCGT090204-MP4	9,62	0,4	0,08–0,20	0,4–2,0	⊕	⊕		
	TCGT110204-MP4	11	0,4	0,08–0,20	0,4–2,0	⊕	⊕		
	TCGT110208-MP4	11	0,8	0,12–0,30	0,5–2,0	⊕	⊕		
	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	0,2	0,04–0,12	0,1–1,0	⊕	⊕		
	TCMT110204-FP4	11	0,4	0,05–0,16	0,1–1,5	⊕	⊕		⊕
	TCMT110208-FP4	11	0,8	0,08–0,20	0,1–1,5	⊕	⊕		
	TCMT16T302-FP4	16,5	0,2	0,04–0,12	0,1–1,0		⊕		
	TCMT16T304-FP4	16,5	0,4	0,05–0,16	0,1–1,5	⊕	⊕		
	TCMT16T308-FP4	16,5	0,8	0,08–0,20	0,1–1,5	⊕	⊕		⊕
	TCMT110204-FP6	11	0,4	0,06–0,18	0,3–2,0		⊕		
	TCMT110208-FP6	11	0,8	0,10–0,20	0,5–2,0		⊕		
	TCMT16T304-FP6	16,5	0,4	0,08–0,20	0,3–2,0		⊕		
	TCMT16T308-FP6	16,5	0,8	0,10–0,25	0,5–2,0		⊕		

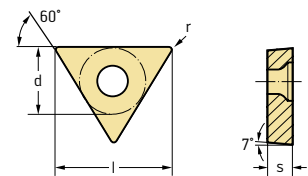
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive triangular 60°

TCGT / TCMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						WPP10G	HC	HE	
	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	0,4	0,08–0,20	0,4–2,0				
	TCMT110208-MP4	11	0,8	0,12–0,30	0,5–2,0				
	TCMT16T304-MP4	16,5	0,4	0,08–0,25	0,4–3,0				
	TCMT16T308-MP4	16,5	0,8	0,12–0,32	0,5–3,0				
	TCMT220408-MP4	22	0,8	0,12–0,32	0,5–3,5				
	TCMT110204-MP6	11	0,4	0,10–0,20	0,4–2,5				
	TCMT110304-MP6	11	0,4	0,12–0,25	0,4–3,0				
	TCMT16T304-MP6	16,5	0,4	0,10–0,25	0,4–3,5				
	TCMT16T308-MP6	16,5	0,8	0,15–0,32	0,6–3,5				
	TCMT090204-RP4	9,62	0,4	0,12–0,25	0,4–3,0				
	TCMT090208-RP4	9,62	0,8	0,16–0,30	0,6–3,0				
	TCMT110204-RP4	11	0,4	0,12–0,25	0,4–3,0				
	TCMT110208-RP4	11	0,8	0,16–0,30	0,6–3,0				
	TCMT16T304-RP4	16,5	0,4	0,12–0,25	0,4–3,0				
	TCMT16T308-RP4	16,5	0,8	0,16–0,35	0,6–4,0				
	TCMT16T312-RP4	16,5	1,2	0,20–0,40	0,8–4,0				

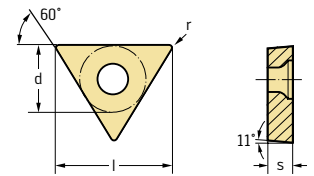
See the ISO 1832 designation key for dimensions

HE = Coated cermet
HC = Coated carbide

Positive triangular 60°

TPGN / TPGT / TPMR / TPMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P	
						HC	
						WPP10G	WPP20G
	TPGN160304	16,5	0,4	0,10–0,25	0,4–3,0		
	TPGN160308	16,5	0,8	0,12–0,30	0,8–3,0		
	TPGT090204-MP4	9,62	0,4	0,08–0,20	0,4–2,0		
	TPGT110204-MP4	11	0,4	0,08–0,20	0,4–2,0		
	TPGT16T304-MP4	16,5	0,4	0,08–0,25	0,4–3,0		
	TPGT16T308-MP4	16,5	0,8	0,12–0,32	0,5–3,0		
	TPMR110304	11	0,4	0,12–0,25	0,4–3,0		
	TPMR110308	11	0,8	0,12–0,25	0,4–3,0		
	TPMR160304	16,5	0,4	0,12–0,25	0,4–3,0		
	TPMR160308	16,5	0,8	0,16–0,30	0,6–4,0		
	TPMT110204-FP4	11	0,4	0,05–0,16	0,1–1,5		
	TPMT16T304-FP4	16,5	0,4	0,05–0,16	0,1–1,5		
	TPMT090204-MP4	9,62	0,4	0,08–0,20	0,4–2,0		
	TPMT110204-MP4	11	0,4	0,08–0,20	0,4–2,0		
	TPMT110208-MP4	11	0,8	0,12–0,30	0,5–2,0		
	TPMT16T304-MP4	16,5	0,4	0,08–0,25	0,4–3,0		
	TPMT16T308-MP4	16,5	0,8	0,12–0,32	0,5–3,0		

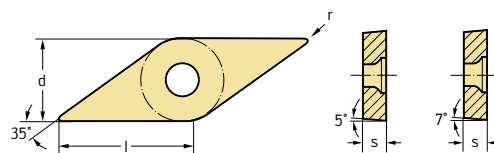
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HW = Uncoated carbide

Positive rhombic 35°

VBMT / VCGT / VCMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P			
						WPP10G	HC	WPP30G	HE
	VBMT110304-FP6	11,07	0,4	0,06–0,18	0,3–2,0	☺	☺		
	VBMT110308-FP6	11,07	0,8	0,10–0,20	0,5–2,0	☺	☺		
	VBMT160404-FP6	16,61	0,4	0,08–0,20	0,3–2,0	☺	☺		
	VBMT160406-FP6	16,61	0,6	0,10–0,25	0,4–2,0	☺	☺		
	VBMT160408-FP6	16,61	0,8	0,10–0,25	0,5–2,0	☺	☺		
	VBMT160412-FP6	16,61	1,2	0,12–0,30	0,6–2,0	☺	☺		
	VBMT110304-MP4	11,07	0,4	0,08–0,20	0,4–1,5	☺	☺		
	VBMT110308-MP4	11,07	0,8	0,12–0,25	0,5–1,5	☺	☺		
	VBMT160404-MP4	16,61	0,4	0,08–0,20	0,4–2,0	☺	☺		
	VBMT160406-MP4	16,61	0,6	0,12–0,25	0,5–2,0	☺	☺		
	VBMT160408-MP4	16,61	0,8	0,12–0,30	0,5–2,0	☺	☺		
	VBMT160412-MP4	16,61	1,2	0,12–0,32	0,5–2,0	☺	☺		
	VBMT160404-MP6	16,61	0,4	0,10–0,25	0,4–2,5	☺	☺		
	VBMT160408-MP6	16,61	0,8	0,15–0,30	0,6–2,5	☺	☺		
	VCGT1103005M-FP2	11,07	0,03	0,01–0,04	0,1–1,0				☺
	VCGT110301M-FP2	11,07	0,07	0,02–0,06	0,1–1,5				☺
	VCGT110302M-FP2	11,07	0,17	0,05–0,12	0,2–2,0				☺
	VCGT110304M-FP2	11,07	0,37	0,08–0,25	0,2–2,5				☺
	VCGT160402M-FP2	16,61	0,17	0,05–0,12	0,2–2,0				☺
	VCGT160404M-FP2	16,61	0,37	0,08–0,25	0,2–2,5				☺
	VCGT160408M-FP2	16,61	0,77	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	☺	☺		☺
	VCMT160412-FP4	16,61	1,2	0,12–0,35	0,2–2,0	☺	☺		☺
	VCMT160404-MP4	16,61	0,4	0,08–0,20	0,4–2,0	☺	☺		
	VCMT160408-MP4	16,61	0,8	0,12–0,30	0,5–2,0	☺	☺		
	VCMT110304-RP4	11,07	0,4	0,12–0,20	0,4–2,5	☺	☺	☺	
	VCMT110308-RP4	11,07	0,8	0,16–0,25	0,6–3,0	☺	☺	☺	
	VCMT160404-RP4	16,61	0,4	0,12–0,25	0,4–2,5	☺	☺	☺	
	VCMT160406-RP4	16,61	0,6	0,15–0,25	0,6–3,0	☺	☺	☺	
	VCMT160408-RP4	16,61	0,8	0,16–0,30	0,6–3,0	☺	☺	☺	
	VCMT160412-RP4	16,61	1,2	0,20–0,35	0,8–3,0	☺	☺	☺	

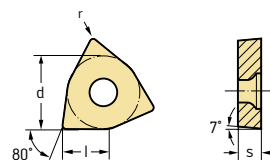
See the ISO 1832 designation key for dimensions

HC = Coated carbide
HE = Coated cermet

Positive Trigon 80°

WCMT

Tiger-tec® Gold



Cutting inserts

	Designation	l mm	r mm	f mm	a _p mm	P		
						HC	WPP10G	WPP20G
	WCMT040202-FP4	4,34	0,2	0,04–0,12	0,1–1,0		⊗	⊗
	WCMT040204-FP4	4,34	0,4	0,05–0,16	0,1–1,5		⊗	⊗
	WCMT040208-FP4	4,34	0,8	0,08–0,20	0,1–1,5			⊗
	WCMT06T302-FP4	6,52	0,2	0,04–0,12	0,1–1,0			⊗
	WCMT06T304-FP4	6,52	0,4	0,05–0,16	0,1–1,5			⊗
	WCMT06T308-FP4	6,52	0,8	0,08–0,20	0,1–1,5			⊗
	WCMT080404-FP4	8,69	0,4	0,05–0,16	0,1–1,5			⊗
	WCMT080408-FP4	8,69	0,8	0,08–0,20	0,1–1,5			⊗
	WCMT040204-FP6	4,34	0,4	0,06–0,18	0,3–2,0			⊗
	WCMT040208-FP6	4,34	0,8	0,10–0,20	0,5–2,0			⊗
	WCMT06T304-MP4	6,52	0,4	0,08–0,25	0,4–2,5			⊗
	WCMT06T308-MP4	6,52	0,8	0,12–0,32	0,5–2,5			⊗
	WCMT030202-RP4	3,91	0,2	0,08–0,12	0,2–1,5			⊗
	WCMT040204-RP4	4,34	0,4	0,12–0,25	0,4–2,5			⊗
	WCMT06T304-RP4	6,52	0,4	0,12–0,25	0,4–3,0			⊗
	WCMT06T308-RP4	6,52	0,8	0,16–0,35	0,6–3,0			⊗
	WCMT080404-RP4	8,69	0,4	0,12–0,25	0,4–3,0			⊗
	WCMT080408-RP4	8,69	0,8	0,16–0,40	0,6–4,0			⊗
	WCMT080412-RP4	8,69	1,2	0,20–0,45	0,8–4,0			⊗

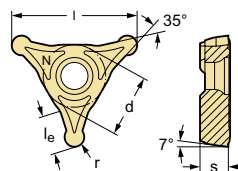
See the ISO 1832 designation key for dimensions

HC = Coated carbide

Indexable inserts for copy turning system

WL...-RC...

Tiger-tec® Gold



Cutting inserts

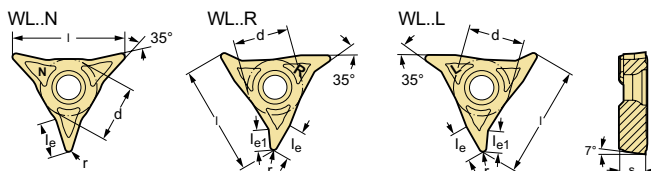
	Designation	r mm	l mm	l _e mm	f mm	a _p mm	P	
							HC	WPP20G
	WL25-RC0420N-MU6	2	25	7,2	0,12–0,40	0,5–2,0		
	WL25-RC0525N-MU6	2,5	25	6,9	0,12–0,45	0,5–2,5		

HC = Coated carbide

Indexable inserts for copy turning system

WL...-VC...

Tiger-tec® Gold



Cutting inserts

	Designation	r mm	l mm	l _e mm	l _{e1} mm	f mm	a _p mm	P	
								WPP10G	WPP20G
	WL25-VC0704L-FP4	0,4	25	6,2	3,9	0,05–0,20	0,1–2,0		
	WL25-VC0708L-FP4	0,8	25	6,6	4,6	0,08–0,25	0,2–2,0		
	WL25-VC0704L-MP4	0,4	25	6,2	3,9	0,08–0,25	0,4–2,5		
	WL25-VC0708L-MP4	0,8	25	6,6	4,6	0,12–0,32	0,5–2,5		
	WL25-VC0704N-FP4	0,4	25	6,3		0,05–0,20	0,1–2,0		
	WL25-VC0708N-FP4	0,8	25	7,1		0,08–0,25	0,2–2,0		
	WL25-VC0704N-MP4	0,4	25	6,3		0,08–0,25	0,4–2,5		
	WL25-VC0708N-MP4	0,8	25	7,1		0,12–0,32	0,5–2,5		
	WL25-VC0712N-MP4	1,2	25	7,4		0,12–0,35	0,5–2,5		
	WL25-VC0716N-MP4	1,6	25	8,7		0,12–0,40	0,5–2,5		
	WL25-VC0704R-FP4	0,4	25	6,2	3,9	0,05–0,20	0,1–2,0		
	WL25-VC0708R-FP4	0,8	25	6,6	4,6	0,08–0,25	0,2–2,0		
	WL25-VC0704R-MP4	0,4	25	6,2	3,9	0,08–0,25	0,4–2,5		
	WL25-VC0708R-MP4	0,8	25	6,6	4,6	0,12–0,32	0,5–2,5		

HC = Coated carbide

Cutting tool material application charts – Turning

Carbide

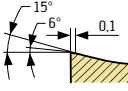
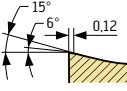
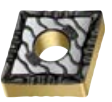
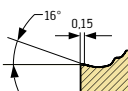
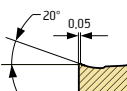
Walter grade designation	Standard designation	Material groups							Application range							Coating process	Coating composition	Indexable insert example
		P	M	K	N	S	H	O	01	10	20	30	40					
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other	05	15	25	35	45					
WPP10G	HC – P 10	●●							▲					CVD	TiCN + Al ₂ O ₃ (+ TiN)			
	HC – K 20			●					▲									
WPP20G	HC – P 20	●●							▲				CVD	TiCN + Al ₂ O ₃ (+ TiN)				
	HC – K 30			●						▲								
WPP30G	HC – P 30	●●								▲			CVD	TiCN + Al ₂ O ₃ (+ TiN)				
	HC – M 20		●						▲									
	HC – K 40			●							▲							

HC = Coated carbide

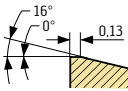
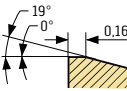
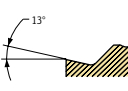
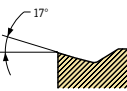
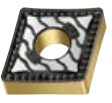
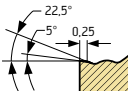
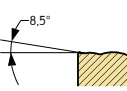
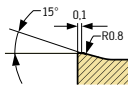
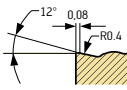
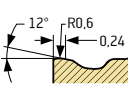
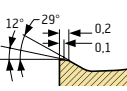
- Primary application
- Additional application

Geometry overview of turning inserts – Negative basic shape

Finishing operation

Geometry	Remarks/application area	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
 FW5 Wiper – Finishing with wiper technology – Double the feed rate – the same high surface quality – Reduced cutting pressure thanks to short radiused wiper cutting edge		••	••	••	•						0,3–3,0	0,10–0,60
 FP5 – Finishing steel materials – Can also be used in semi-finishing as an alternative to MP3 – Curved cutting edge for low cutting forces		••									0,1–2,5	0,04–0,25

Medium machining

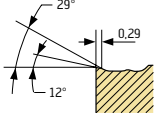
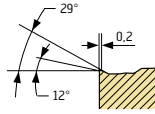
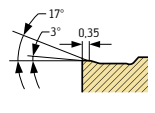
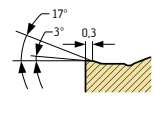
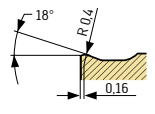
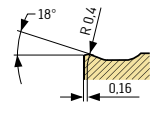
 MW5 Wiper – Medium machining with wiper technology – Double the feed rate – the same high surface quality – Maximum feeds thanks to long wiper curved cutting edge		••	••	••	•						0,8–4,0	0,15–0,75
 MS3 – For unstable or thin-walled components – Low cutting forces due to sharp cutting edge design – Circumference precision-ground – Circumference precision-sintered		•	•		•	••					0,2–3,0	0,02–0,30
 MP3 – Medium machining of long-chipping steel materials – Low cutting forces due to curved cutting edge – Machining forged parts with low material removal		••									0,3–4,0	0,06–0,40
 MP5 – Universal geometry for steel materials – Reinforced chip breakers – Extremely wide application range		••									0,5–8,0	0,16–0,55
 MU5 – Universal geometry for steel and stainless materials – Low cutting forces and reduced heat generation when machining		••	••	•	•						0,5–6,0	0,15–0,60

- Primary application
- Additional application

Note: Sectional views show CNMG120408 . .

Geometry overview of turning inserts – Negative basic shape (continued)

Roughing operations – Double-sided indexable inserts

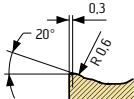
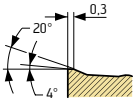
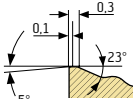
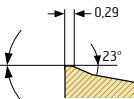
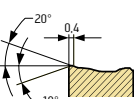
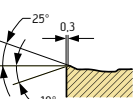
Geometry	Remarks/application area	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
	RM5 – Roughing operations in stainless materials and high-temperature alloys		••			••					1,2–8,0	0,20–0,80
	RP5 – Roughing steel materials – Stable, positive cutting edge – Open chip groove for a low cutting temperature	••		•							0,8–12,0	0,2–1,20
	RP7 – Interrupted cuts – Cast skins/forged skins – Stable cutting edge	••		••							0,8–8,0	0,16–0,70

- Primary application
- Additional application

Note: Sectional views show CNMG120408 . .

Geometry overview of turning inserts – Negative basic shape

Roughing operations – Single-sided indexable inserts

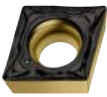
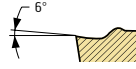
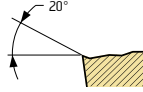
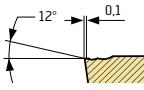
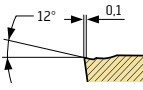
Geometry Remarks/application area	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
	P	M	K	N	S	H	O				
	Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
 HU3 – Single-sided roughing geometry, for universal application – Curved cutting edge for low cutting forces – V chip formation for optimised chip breaking even with small depths of cut and fluctuating material removal – Reinforced double chip breaker groove on the main cutting edge	●●	●	●							0,8–12,0	0,25–1,20
 HU5 – Single-sided roughing geometry, for universal application – Curved cutting edge and deep chip breaker groove for low cutting forces – Open chip breaker groove design for reduced heat generation	●	●●	●		●●					2,5–10,0	0,30–1,00
 HU7 – Single-sided geometry for challenging roughing operations – Straight cutting edge with negative protective chamfer for maximum stability – Chip breaker for reduced friction	●●	●	●●							2,0–17,0	0,50–1,60

●● Primary application
● Additional application

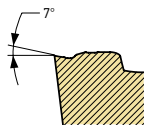
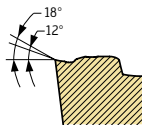
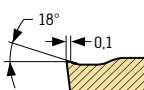
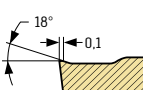
Note: Sectional views show SNMM190616 . .

Geometry overview of turning inserts – Positive basic shape

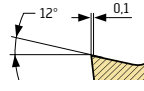
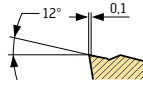
Finishing operation

Geometry	Remarks/application area	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
	FP4 – Finishing insert – Excellent chip control – Can also be used for precision boring	●●	●	●		●					0,1–2,5	0,04–0,20
	FP6 – Universal insert for finishing and medium machining operations – Can also be used for boring	●●	●	●		●					0,3–2,5	0,08–0,32

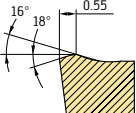
Medium machining

	MP4 – Machining of long-chipping materials – Can be used universally in a wide application range – Circumference precision-ground – Circumference precision-sintered – Straight cutting edge for C, S and T basic shapes, for use as a chamfer insert in boring tools	●●	●	●		●					0,4–3,5	0,08–0,32
	MP6 – Medium machining of steel – Positive geometry with good chip control with very stable cutting edge	●●	●	●		●					0,4–4,0	0,10–0,35

Roughing operation

	RP4 – Universal geometry for roughing and medium machining operations – Extremely large chip breaking range – Maximum metal removal rate and tool life	●●	●	●		●					0,6–5,0	0,12–0,50
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Heavy machining

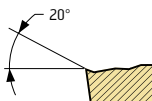
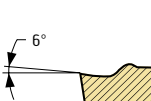
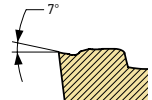
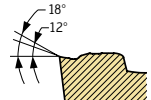
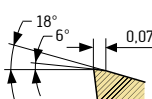
	HU6 – Heavy roughing – Excellent chip breaking – Machining of forged parts – For use in train wheel machining	●●		●●							1,0–15,0	0,12–1,7
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- Primary application
- Additional application

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

Geometry overview of Copy Turn System inserts – WL

Finishing and medium machining

Geometry	Remarks/application area	Material groups							Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
		P	M	K	N	S	H	O				
		Steel	Stainless steel	Cast iron	NF metals	Materials with difficult cutting properties	Hard materials	Other				
	FP4 – Finishing geometries for minimal depths of cut – Excellent chip control – Developed for copy turning	●●	●			●					0,1–2,0	0,05–0,25
	MP4 – Medium machining – with a large application range – Machining for long-chipping materials – Developed for copy turning	●●	●	●		●					0,4–2,5	0,08–0,35
	MU6 – Full-radius geometry for copy turning – Soft cutting action with excellent chip breaking – Chip breaking in all feed directions	●●	●●	●●		●●	●				0,4–2,5	0,1–0,40

●● Primary application
 ● Additional application

Note: Sectional views show WL25-VC0708 . . and WL25-RC0420 . .

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Cutting data for turning inserts – Negative basic shape



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

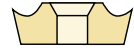
Material group	Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R_m N/mm ²	Machining group ¹			Cutting material grades		
									Starting values for cutting speed v_c [m/min]		
									HC		
									WPP10G f [mm/rev]		
									0,10	0,40	0,60
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	●	530	400	310
		C > 0.25% to ≤ 0.55%	Annealed	190	640	P2	●●	●	420	300	240
		C > 0.25% to ≤ 0.55%	Heat-treated	210	710	P3	●●	●	320	250	210
		C > 0.55%	Annealed	190	640	P4	●●	●	350	250	200
		C > 0.55%	Heat-treated	300	1010	P5	●●	●	270	200	190
		Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	490	350	280
	Low-alloy steel	Annealed		175	590	P7	●●	●	380	280	240
		Heat-treated		285	960	P8	●●	●	230	180	160
		Heat-treated		380	1280	P9	●●	●	180	140	100
		Heat-treated		430	1480	P10	●●	●	120	100	
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11	●●	●	340	240	160
		Hardened and tempered		300	1010	P12	●●	●	240	140	120
		Hardened and tempered		380	1280	P13	●●	●	120	100	
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	●●	●	280	220	200
		Martensitic, heat-treated		330	1110	P15	●●	●	200	140	120
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	●●	●	300	200	150
		Pearlitic		260	700	K2	●●	●	260	160	110
	Grey cast iron	Low strength		180	200	K3	●●	●	570	380	280
		High strength/austenitic		245	350	K4	●●	●	300	210	140
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●	●	320	230	170
		Pearlitic		265	700	K6	●●	●	230	170	140
	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					
				100	340	N7	●●	●			
				90	310	N8	●●	●			
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	●●	●			
				200	680	S6	●●	●			
	Titanium alloys	Pure titanium		375	1260	S7	●●	●			
		α and β alloys, hardened		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					

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

Note:

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

Cutting data for turning inserts – Positive basic shape



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

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			
									WPP10G			
									f [mm/rev]			
									0,10	0,20	0,40	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	●●	●	480	430	350	
		C > 0.25% to ≤ 0.55%	Annealed	190	640	P2	●●	●	370	330	270	
		C > 0.25% to ≤ 0.55%	Heat-treated	210	710	P3	●●	●	280	260	220	
		C > 0.55%	Annealed	190	640	P4	●●	●	310	280	220	
		C > 0.55%	Heat-treated	300	1010	P5	●●	●	230	220	190	
		Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	440	390	310	
	Low-alloy steel	Annealed		175	590	P7	●●	●	230	220	190	
		Heat-treated		285	960	P8	●●	●	330	300	250	
		Heat-treated		380	1280	P9	●●	●	200	190	160	
		Heat-treated		430	1480	P10	●●	●	70	60	50	
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11	●●	●	310	270	200	
		Hardened and tempered		300	1010	P12	●●	●	200	180	130	
		Hardened and tempered		380	1280	P13	●●	●	60	50	50	
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	●●	●	240	230	200	
		Martensitic, heat-treated		330	1110	P15	●●	●	170	160	130	
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	●●	●	270	230	170	
		Pearlitic		260	700	K2	●●	●	230	190	140	
	Grey cast iron	Low strength		180	200	K3	●●	●	490	400	350	
		High strength/austenitic		245	350	K4	●●	●	270	230	170	
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●	●	290	250	200	
		Pearlitic		265	700	K6	●●	●	200	180	150	
	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							
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

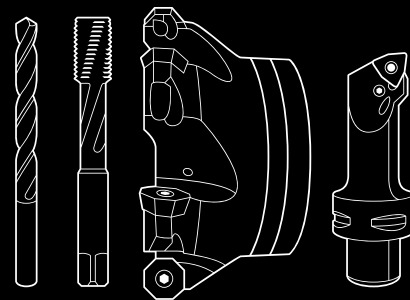
Note:

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

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