Double the serration – double the reliability.

NEW

THE TOOL

- Groov·tec™ GD grooving tool G5011 with and without precision cooling
- Indexable insert clamping can be operated from both sides
- 2 grooving depths 12 and 21 mm for optimum tool stability
- Shank sizes: 16x16, 20x20 and 25x25 mm

THE INDEXABLE INSERTS

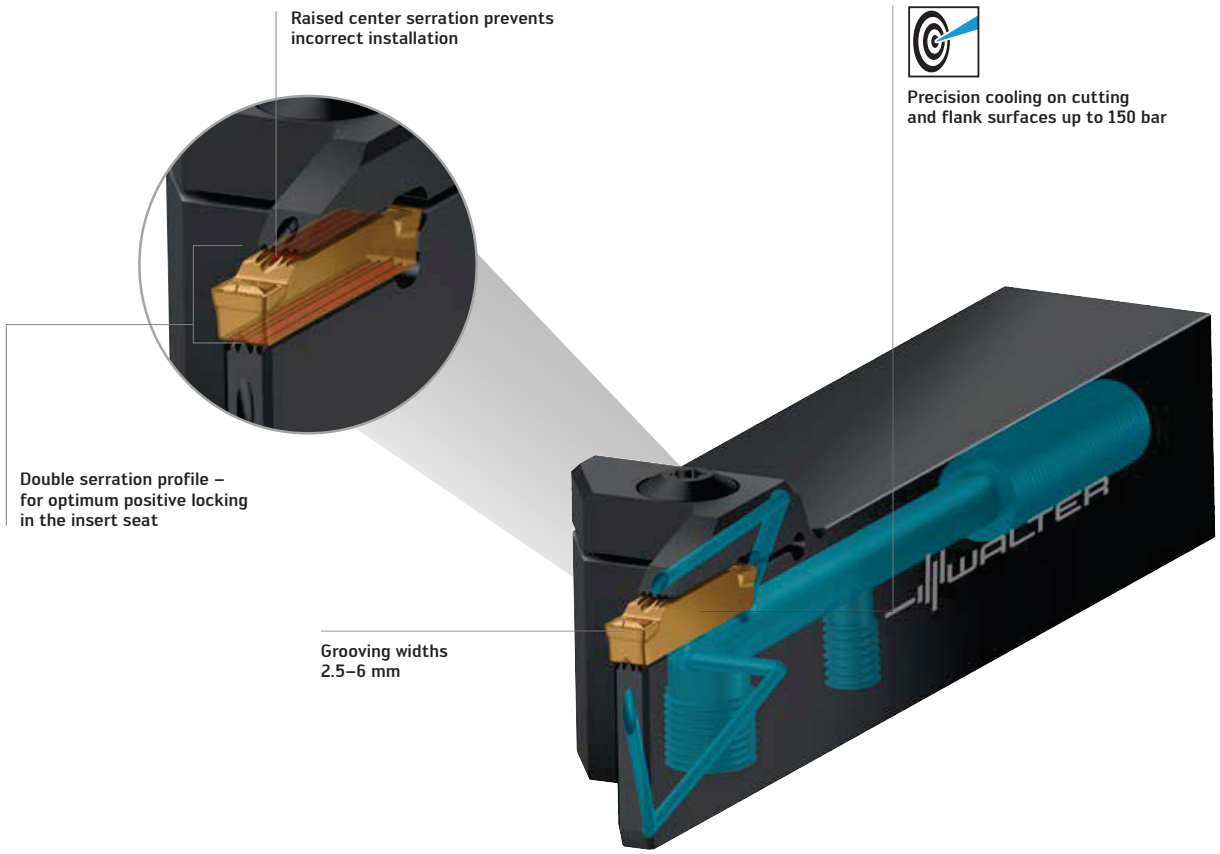
- Patent-pending, double-edged GD26 cutting inserts with double serration clamping profile
- Grooving widths: 2.5 / 3.0 / 4.0 / 5.0 / 6.0 mm

THE GEOMETRY

- Parting off and grooving: CE4, CF5, CF6, GD6 and GD3
- Parting and grooving: UA4, UD4 and UF4
- With full radius: RD4 and RF8

THE GRADE

- 4 Tiger·tec® Gold PVD grades: WSM13G, WSM23G, WSM33G and WSM43G
- For steel, stainless steels and difficult-to-machine materials
- 3 Tiger·tec® Gold CVD grades: WKP13G, WKP23G and WKP33G
- For steel and cast iron machining



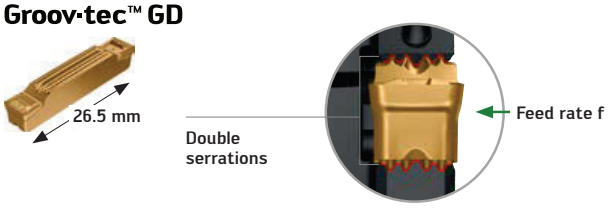
Powered by Tiger·tec® Gold

Groov·tec™ GD grooving system — Fig.: G5011-2525R-5T21GD26-P

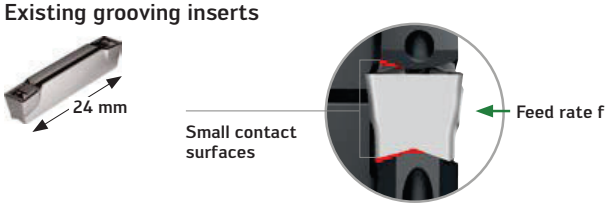
THE TECHNOLOGY

– New insert design with double serration profile. The GD26 cutting insert and tool body (insert seat) are optimally interlocked. The positive fit absorbs lateral forces better during longitudinal and copy turning
– Conventional systems (e.g. without double serrations) are significantly less stable in comparison.

Groov·tec™ GD



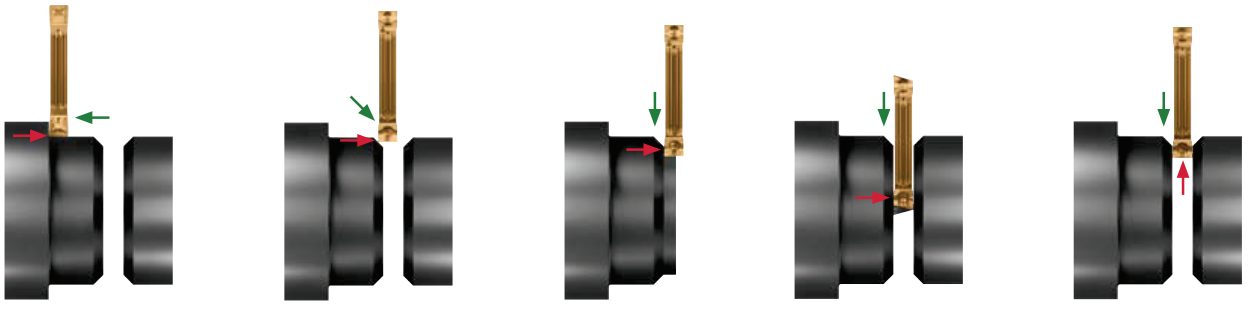
Existing grooving inserts



THE APPLICATION

– Radial grooving and parting off, recess turning and copy turning up to 26 mm grooving depth
– Universal use on lathes of all kinds

Greater stability in all applications – with Groov·tec™ GD



Turning | Chamfers | Offset grooving | Parting off – inclined cutting insert | Parting off – straight cutting insert

→ Feed rate (f)
→ F_{axial}

POTENTIAL BENEFITS

– Increased stability and process reliability thanks to Groov·tec™ GD serration profile
– Increased cutting parameters thanks to new serration profile and precision cooling
– Maximum productivity and service life thanks to wear-resistant Tiger·tec® Gold grades

Wear doesn't stand a chance.

NEW

THE INDEXABLE INSERTS

GD26 Groove·tec™ GD
- Patent-pending, double-edged GD26 cutting inserts with double serration profile for perfect positive engagement in the insert seat
- For G5000 tool types

DX18
- Double-edged DX18 cutting inserts with top, bottom and back pocket support for strong insert seating
- For G4000 tool types

THE APPLICATION

- CVD grades; primary application: Groove turning, copy turning and grooving

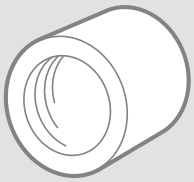
WKP13G (ISO P10 ; ISO K20)
- High wear resistance and cutting speed
- Continuous cut

WKP23G (ISO P20 ; ISO K25)
- High wear resistance and cutting speed
- Continuous to occasional interrupted cut
- Universal grade for approx. 80% of all applications

WKP33G (ISO P30 ; ISO K30)
- Excellent wear resistance and toughness
- For unfavorable conditions and interrupted cuts
- Steel and cast iron materials

APPLICATION EXAMPLE

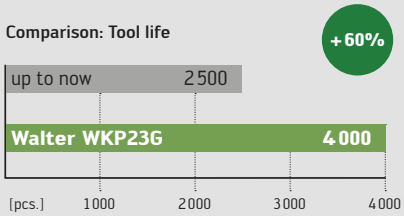
Cut-off ring Ø 30.5 mm



Material:	38MnVS6 / 1.1303
Strength:	800 N/mm²
Machine:	Index MS40
Indexable insert:	GD26-3E300N03-UD4 WKP23G
Tool:	G5011-2020L-3T21GD26-P

Cutting data	up to now	Walter WKP23G
s (mm)	3	3
v_c (m/min)	130	130
f (mm)	0.13	0.13
T (mm)	4	4
Cooling	Oil, 40 bar	Oil, 40 bar
Tool life	2500	4000

Comparison: Tool life



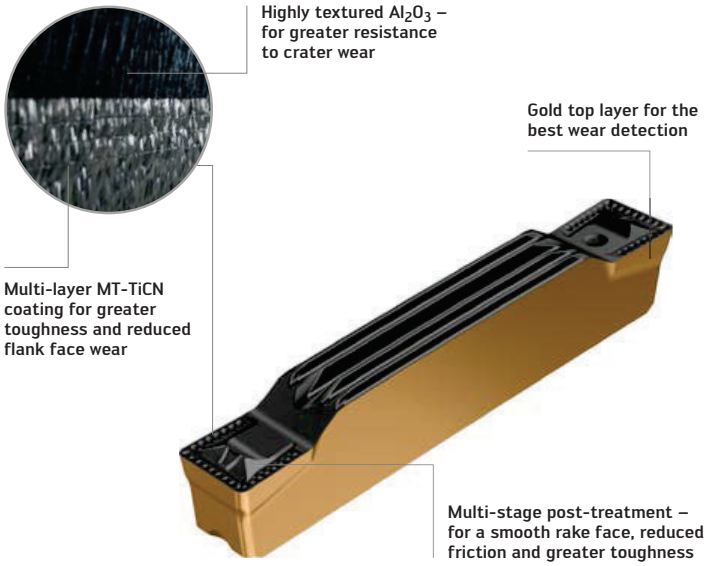


Fig.: GD26-4E400N04-UD4 WKP23G

POTENTIAL BENEFITS

- High level of cost-efficiency due to Tiger·tec® Gold coating
- Average increase in tool life of around 50%
- High productivity, short machining times – ideal for mass production
- Wear-resistant cutting tool material (alternative to WSM grades)