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Turning, holemaking,
threading, milling

Product highlights
Edition 2025-1

_PRODUCT HIGHLIGHTS

Innovations that lead the way.





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Groov-tec™ GD

A - Milling

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Small – with excellent stability and cost-efficiency.



EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

- W1011-C Walter Capto™ tools in C3/C4 for WL17
- W1011 2525 square shank tools for WL17 and 3232 for WL25
- W1011-S-P: Inch long turning toolholders 1/2", 5/8"
- W1211: Inch boring bars 1/2", 5/8", 3/4"
- WL17... MP4 and MM4 geometries in right-hand and left-hand versions
- WL17... FP4 in the Tiger-tec® Gold WPP20G grade

THE TOOL

- Copy turning system with WL positive engagement on toolholder and indexable insert
- 50% higher indexing accuracy (compared to ISO indexable inserts)
- Neutral, right-hand and left-hand inserts can be used in the same tool

THE INDEXABLE INSERTS

- Three-edge, positive indexable inserts with WL positive engagement
- FP4, MP4, FM4 and MM4 geometry with 35° point angle



POTENTIAL BENEFITS

- High level of dimensional stability thanks to positive-locking, robust WL connection
- Maximum tool life thanks to the option of forward and reverse turning
- Cost-effective: Lower tool costs thanks to three cutting edges



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THE APPLICATION

- Copy turning of recesses up to 30° or 50°
- Forward and reverse turning operations
- High-precision components
- Replacement for ISO VBMT, VCMT, DCMT indexable inserts (with just two cutting edges and lower stability)

W1011-S-P

- Automatic lathe and multi-spindle machines having up to 150 bar of coolant pressure

W1210/W1211

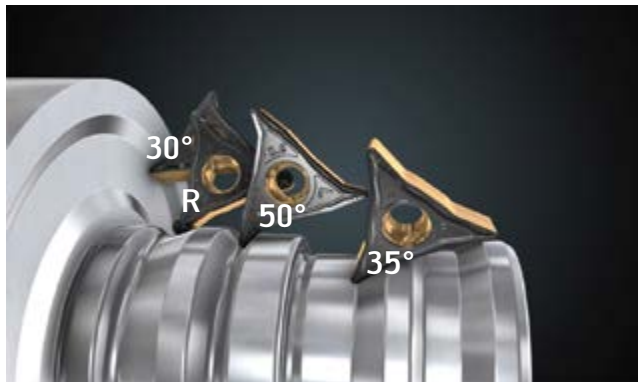
- Internal copying turning, facing and axial grooving

THE TECHNOLOGY

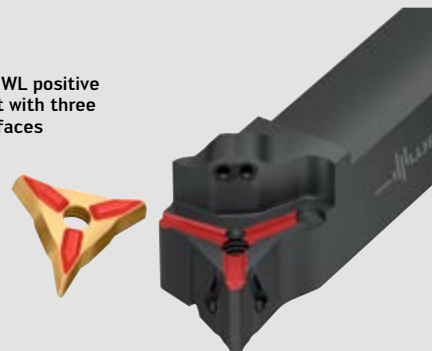


Walter Turn W1011-P copy turning tool for forward and reverse turning, uses two cutting edges and makes higher feeds possible.

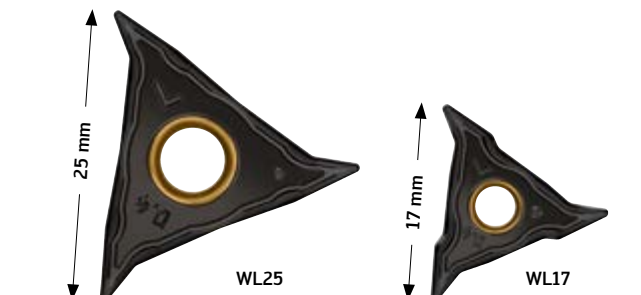
Indexable insert types and applications



Walter Turn WL positive engagement with three contact surfaces



Size comparison of insert types



Double the serration – double the reliability.



NEW

NEW ADDITION TO THE PRODUCT RANGE

- UE6 – groove turning geometry for medium machining
- RE6 – full-radius geometry for medium machining
- G5011 grooving tools with cutting depths of 26 and 33 mm

THE TOOL

- Groov-tec™ GD grooving tool G5011/G5011-P with and without precision cooling
- Indexable insert clamping can be operated from both sides
- Four cutting depths (T12, T21, T26, T33) for parting-off diameters up to 65 mm
- Shank sizes: 16x16, 20x20 and 25x25 mm and 0.625, 0.75, and 1 inch

THE INDEXABLE INSERTS

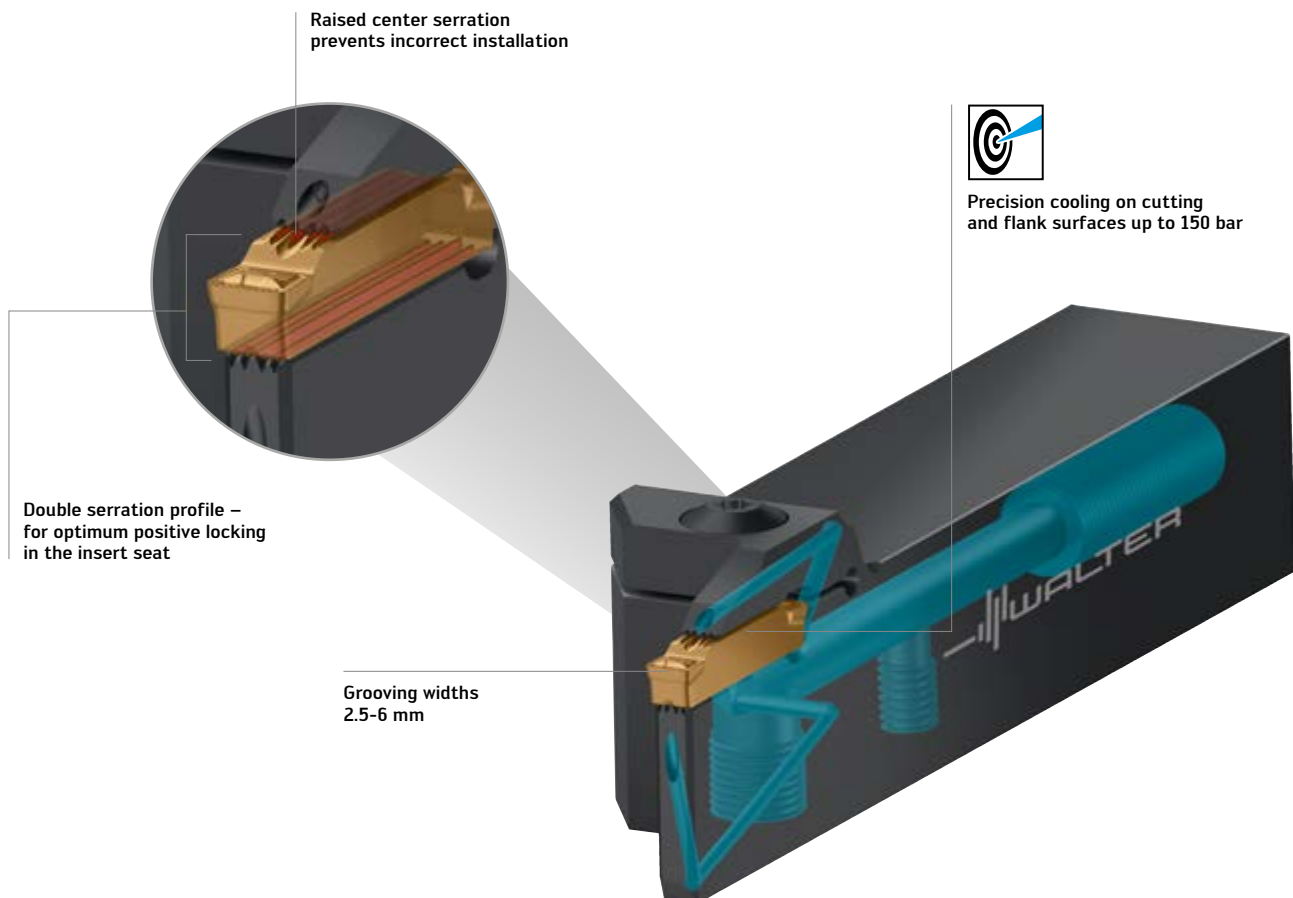
- Patent-pending, double-edged GD26 cutting inserts with double serration clamping profile
- Grooving widths: 2.5 / 3.0 / 4.0 / 5.0 / 6.0 mm

THE GEOMETRY

- Parting off and grooving: CE4, CF5, CF6, GD6 and GD3
- Groove turning: UA4, UD4, UE6, UF4 and UF8
- With full radius: RD4, RE6 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

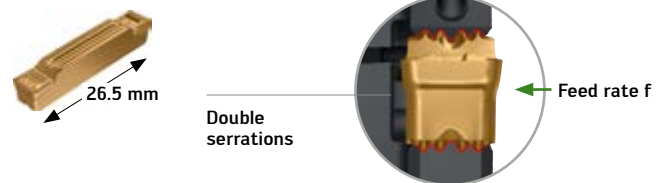
THE APPLICATION

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

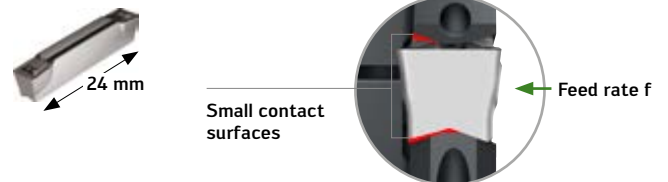
THE TECHNOLOGY

- 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.

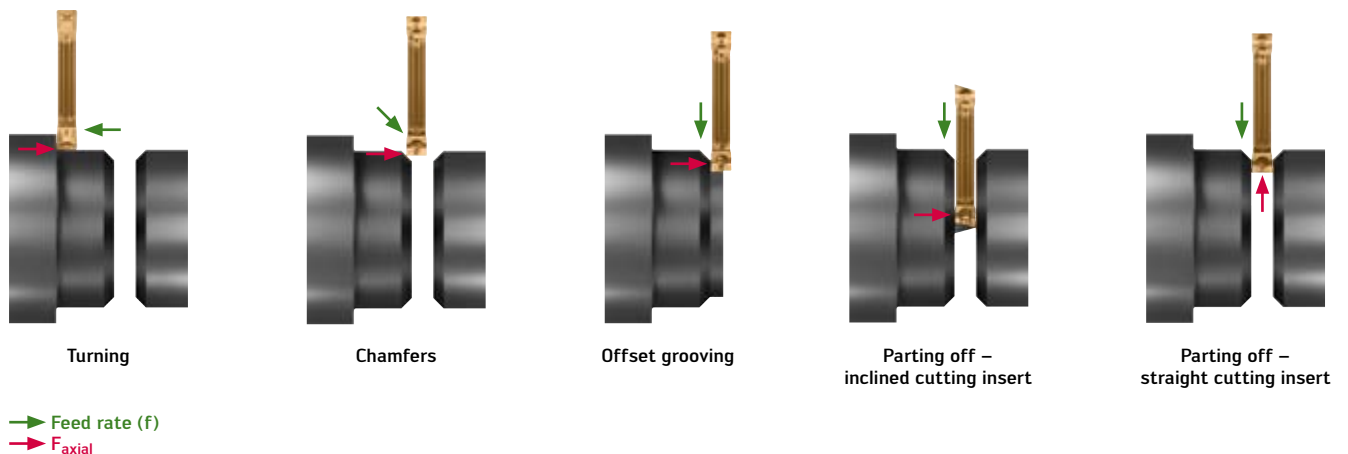
Groov-tec™ GD



Existing grooving inserts



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



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

Duo for optimum chip control.



NEW

THE GEOMETRY

- Insert width: 3–6 mm

UE6

- Good chip control in all grooving operations
- Machining parameters f : 0.04–0.40 mm; a_p : 0.1–3.5 mm
- Extremely large chip breaking range

RE6

- Full-radius insert for copy turning and relief turning
- Machining parameters f : 0.10–0.60 mm; a_p : 0.1–3.0 mm
- Excellent chip control

THE APPLICATION

UE6

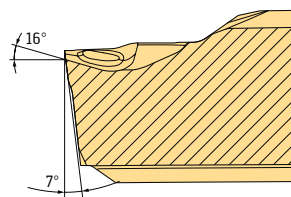
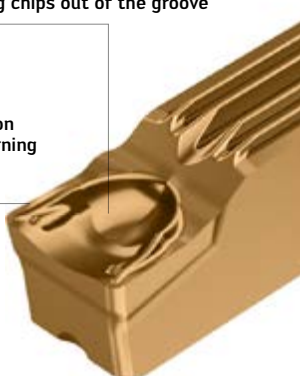
- For all grooving, parting-off and groove turning operations, radial and axial
- Ideal for machining steels, stainless steels, super alloys, and non-ferrous materials (ISO materials from groups P, M, S and N)
- Low cutting forces

RE6

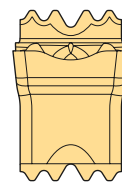
- 230° machining angle
- Grooving and copy turning, radial and axial
- For outstanding surface quality
- For reducing cycle times due to dynamic turning

Positive chip breaker groove,
good chip formation – for
guiding chips out of the groove

Positive, side
chip breaker –
soft cutting action
during groove turning



Section:
Main cutting edge



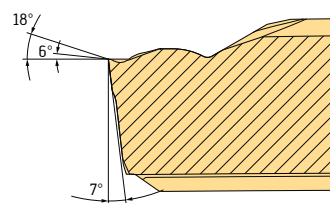
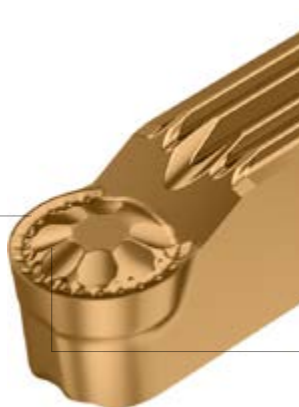
View:
Main cutting edge

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Groov-tec™ GD

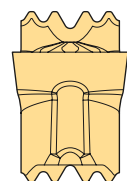
Groov-tec™ GD RE6
chip breaker

Fig.: GD26-5E500N04-UE6
WSM33G

Positive, side chip breaker –
for a soft cutting action
during copy turning



Section:
Main cutting
edge



View:
Main cutting
edge

Groov-tec™ GD RE6
chip breaker

Fig.: GD26-5E500N30-
RE6 WSM33G

High shoulders – for optimum
chip breaking during full-radius grooving

POTENTIAL BENEFITS

- Chip breaking in all directions due to UE6 geometry for all grooving and groove turning operations
- Optimum chip breaking due to RE6 geometry with full-radius grooving and copy turning chip breaker
- No production downtime caused by long chips

Wear doesn't stand a chance.



EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

- Single-edged SX cutting inserts for grooving and parting off in the WKP23G universal grade

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

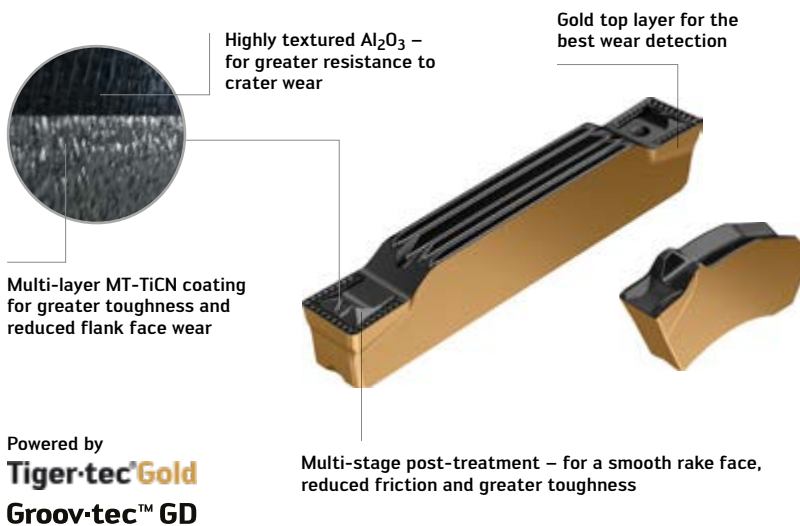
- Double-edged DX18 cutting inserts with top, bottom and back pocket support for strong insert seating
- For G4000 tool types

SX

- Single-edged SX cutting inserts with positive engagement and self-clamping system
- For G2000 tool types

THE APPLICATION

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



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Groov-tec™ GD

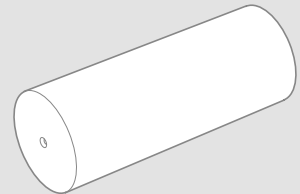
Fig.: GD26-4E400N04-UD4 WKP23G
Fig.: SX-3E300N02-CE4 WKP23G

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)

APPLICATION EXAMPLE

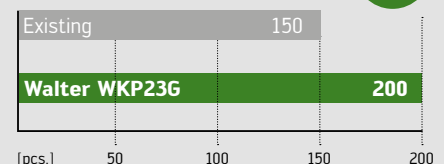
Role



Material: 100CrMo7-3 (Ovako Steel)
Strength: 700 N/mm² (~205 HRB)
Tool: G2042.32N-4T50SX
Indexable insert: SX-4E400N02-CE4 WKP23G

Cutting data:	Existing	WKP23G
v_c (m/min)	130	130
f (mm)	0.12	0.12
T (mm)	28	28
Tool life (pcs.)	150	200

Comparison:
Tool life



Thread turning with Tiger technology.



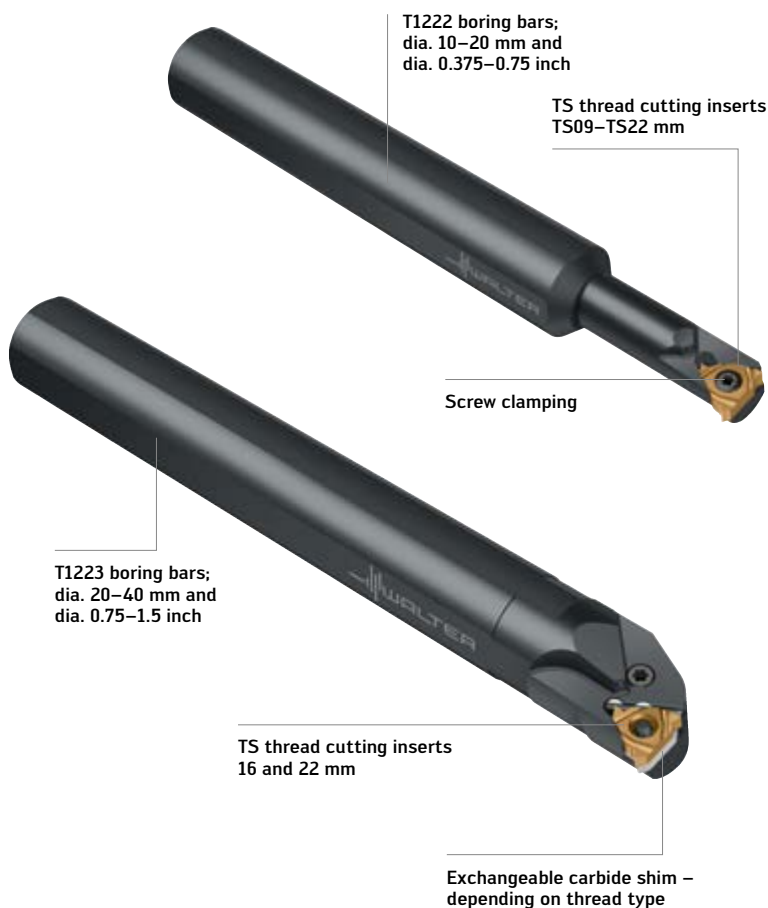
NEW

THE TOOL

- T1221 internal thread boring bars with rigid clamping
- T1221-C internal thread Capto boring bars with rigid clamping
- T1222 internal thread boring bars with screw clamping
- T1223 internal thread boring bars with toggle clamp

THE INDEXABLE INSERTS

- TS thread turning indexable inserts in sizes TS09/TS11/TS16 and TS22 mm
- Precision-ground multi-tooth indexable inserts for high accuracy and productivity
- Chip breaker geometries F5 and M5
- Large standard program; specials on request



Stable rigid clamping for
optimum indexable insert
attachment



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TS threading system

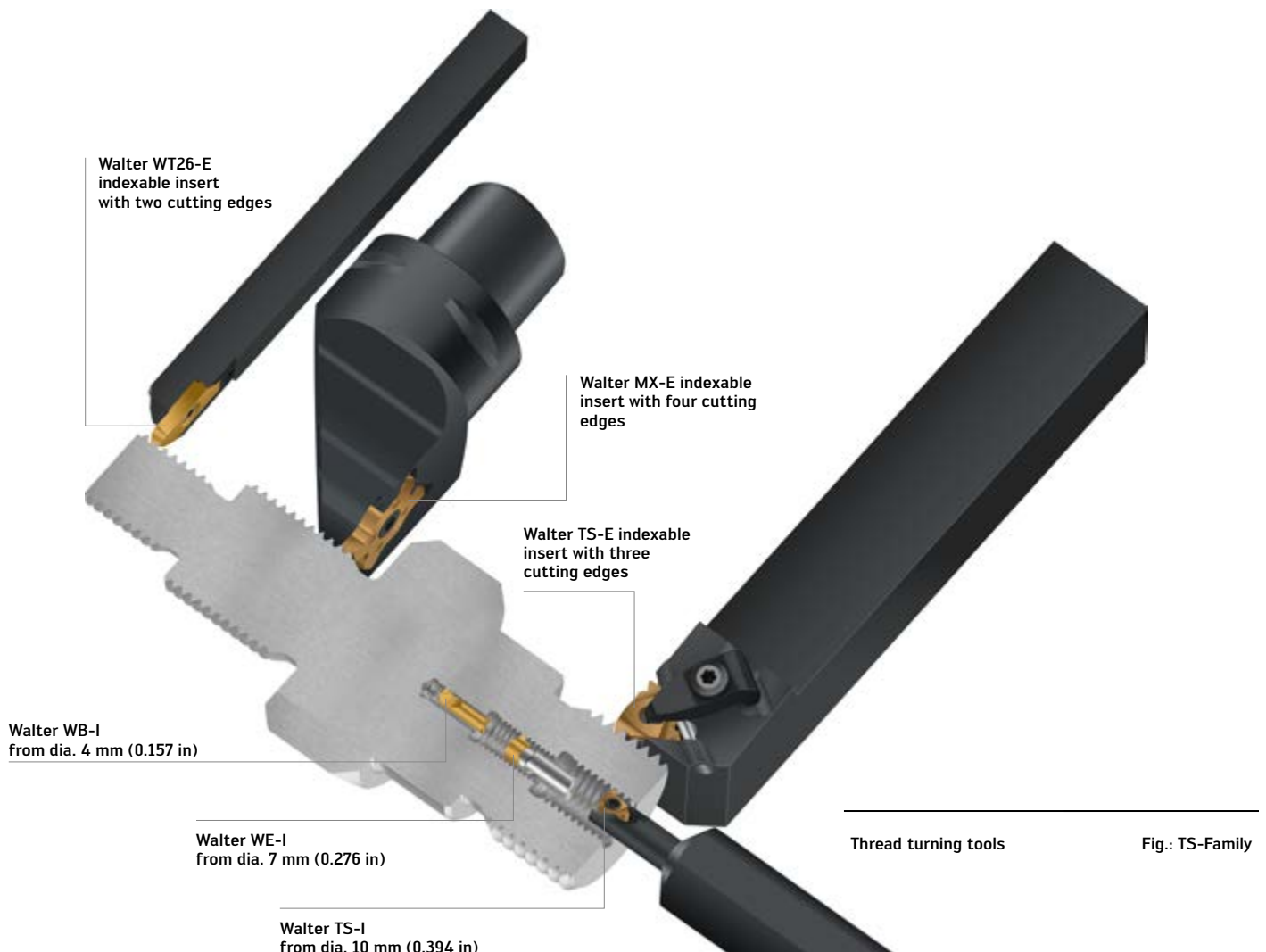
Fig.: T1222-A16KL-12-TS11
Fig.: T1223-A25RL-29-TS16

Fig.: T1221-A20QR-24-TS16
Fig.: T1221-C5R-17070-TS16

THE APPLICATION

- Reusable full-profile threads: ISO, UN and UNJ
- Permanent full-profile threads for pipes and fittings: W, BSPT, NPT/NPTF, RD
- Motion-transmitting full-profile threads: TR, ACME, BUTT
- Partial profile thread: 55° and 60° V-profile

Size comparison



POTENTIAL BENEFITS

- High level of cost-efficiency due to small TS09 indexable inserts with three cutting edges from D_{min} 10 mm
- Wide selection of different thread production systems
- Maximum productivity and service life thanks to multi-tooth inserts and Tiger-tec® Gold grades

The new face in drilling.



NEW

THE TOOL

- DD170 Supreme solid carbide drill with internal coolant
- Dia. 3–20 mm (including fractional inch sizes)

Dimensions – standard:

- $3 \times D_c$ in accordance with DIN 6537 short
- $5 \times D_c$ in accordance with DIN 6537 long
- $8 \times D_c$ in accordance with Walter standard
- $12 \times D_c$ in accordance with Walter Norm

Dimensions – Walter Xpress:

- Up to $12 \times D_c$
- Chamfer drill
- Step drill
- WJ30EY: K30F, AlTiN multi-layer tip coating

THE APPLICATION

- ISO material groups P and K (steels and cast irons)
- Can be used with emulsion, oil and MQL
- Areas of use: Automotive industry, aerospace industry, energy industry, mold and die making, general mechanical engineering

Stronger than ever – thanks to maximum volume of carbide material

12 grooves – for more possible regrinding operations

Grade: WJ30EY

140° point angle

Coolant grooves with a new profile – for greater process reliability in soft materials

Powered by
Krato-tec®

Fig.: DD170-12-08.500A1-WJ30EY



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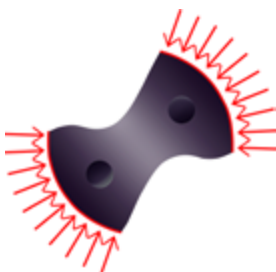


Shank in accordance with
DIN 6535 HA; shank end in
accordance with DIN 69090

360° cooling



Continuous guidance



Raised tip –
for the best centring

APPLICATION EXAMPLE

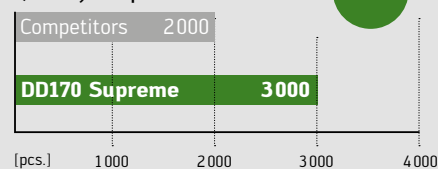
Drive shaft



Material: 16MnCr5 (AISI 5115) - Bar material
Strength: 207 HB
Tool: DD170 Supreme
DD170-12-11.000A1-WJ30EY
powered by Krato-tec®
Cooling: Emulsion 220 psi (15 bar)

Cutting data:	Competitors	Walter DD170 Supreme
v_c (m/min)	120	120
n (mm ⁻¹)	3 474	3 474
f (mm/U)	0.25	0.25
vf (mm/min)	869	869
Drilling depth (mm)	100	100
Components (pcs.)	2 000	3 000

Comparison:
Quantity Components



Regrinding scale for maximum cost-efficiency



POTENTIAL BENEFITS

- Maximum process reliability in difficult applications such as those involving cross holes or inclined exits
- Maximum productivity due to Krato-tec® coating technology
- Best positioning due to innovative new tip geometry – no pilot drilling up to $12 \times D_c$

Also available as

Walter Xpress

The world's first replaceable tip drill with two cutting edges.



NEW

THE TOOL

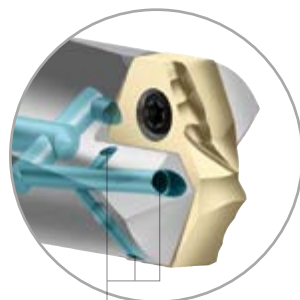
- Drion-tec® D-Spade D5142 double-sided replaceable tip drill
- Drilling depths: 3 and 5 × D_c
- Easy handling due to radial clamping screws
- Three coolant channels per tooth for maximum cooling
- Ground chip clearance for quick and reliable chip removal
- DS42 double-sided replaceable tip (symmetrical)
- Four margins for excellent surface quality
- F58 geometry
- Dia. 12–25.70 mm (including inch-nominal sizes)

THE GRADE

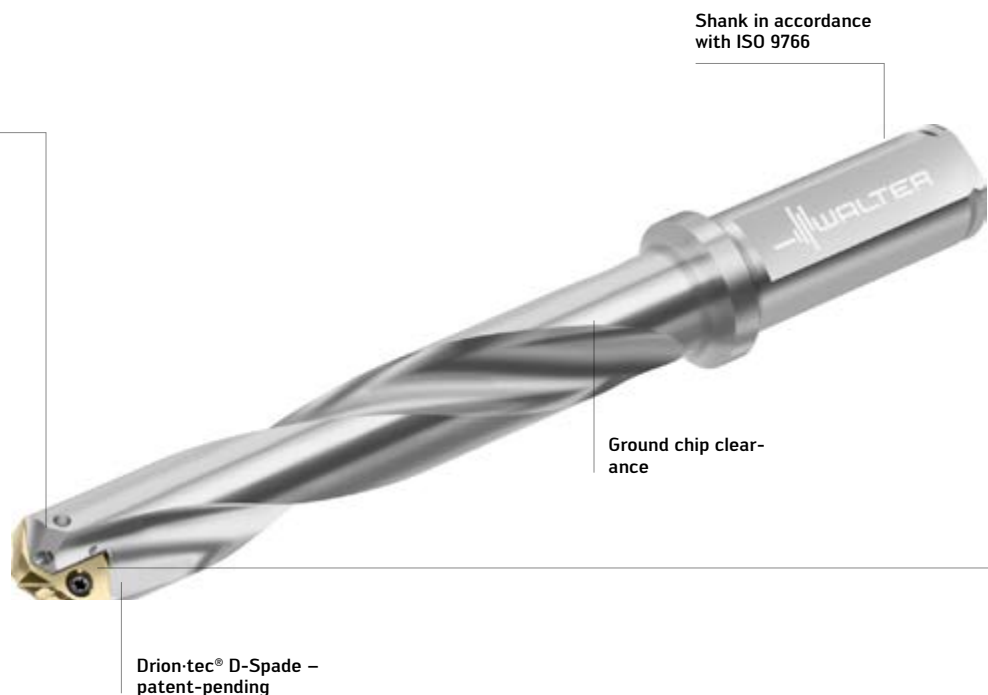
- WPP25: Fine-grained substrate and HIPIMS AlTiN coating for high wear resistance
- Gold-colored top layer for the best wear detection

THE APPLICATION

- Drilling blind holes and through holes from solid
- Suitable for stack drilling (laminar drilling)
- Primary application: ISO P (steels)
- Secondary application: ISO K and ISO N (cast irons and non-ferrous materials)



Precision cooling:
Three coolant outlets per tooth –
on the main cutting edge,
chisel edge and circumference



Drion-tec® replaceable tip drill

Fig.: D5142-05-18.00F20-G



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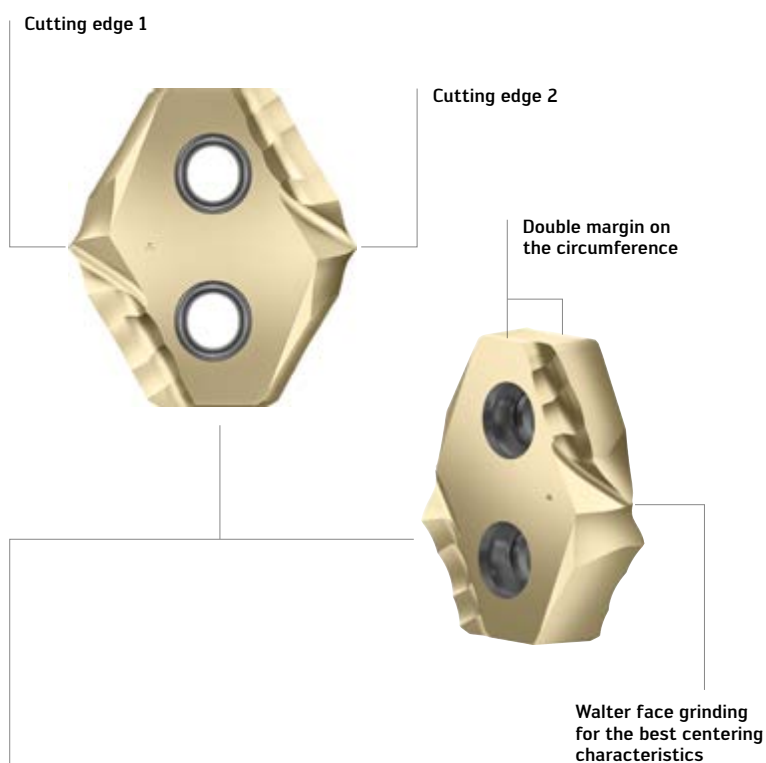
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THE TECHNOLOGY

- Symmetrical Drion-tec® D-Spade design with two cutting edges per replaceable tip
- The flank face of the first cutting edge forms the pocket support surface of the second cutting edge
- Secure clamping due to two radial screws

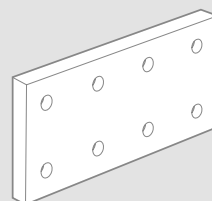


Double-sided replaceable tip

Fig.: DS42-F58-18.00G WPP25

APPLICATION EXAMPLE

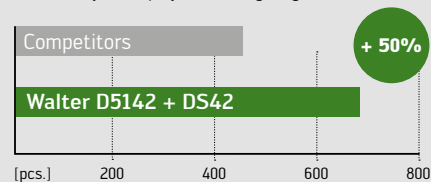
Connecting plate - holemaking: $\varnothing 17.5$



Material: S355 (St-52 low carbon steel)
Strength: 520 N/mm² (~160 HB)
Tool: D5142-03-17.00F20-F
Indexable insert: DS42-17.50F-F58 WPP25

Cutting data:	Competitors	Walter D5142 + DS42
v_c (m/min)	265	125
n (min ⁻¹)	4820	2274
f_n (mm)	0.07	0.18
v_f	313	409
Drilling depth (mm)	15	15
Cooling	Internal coolant	Internal coolant
Adaptors	SK50 Weldon $\varnothing 20$ mm	SK50 Weldon $\varnothing 20$ mm
Tool life quantity (pcs.)	448	672

Comparison:
Tool life quantity (per cutting edge)



POTENTIAL BENEFITS

- Maximum cost-efficiency due to two cutting edges per replaceable tip
- Excellent surfaces due to double margins on the circumference (within IT8)
- Precise holes due to the best centering characteristics
- Maximum process reliability due to optimum cooling effect and chip removal
- High level of stability due to two radial clamping screws

Reduced cutting pressure and vibration, greater cost-efficiency.



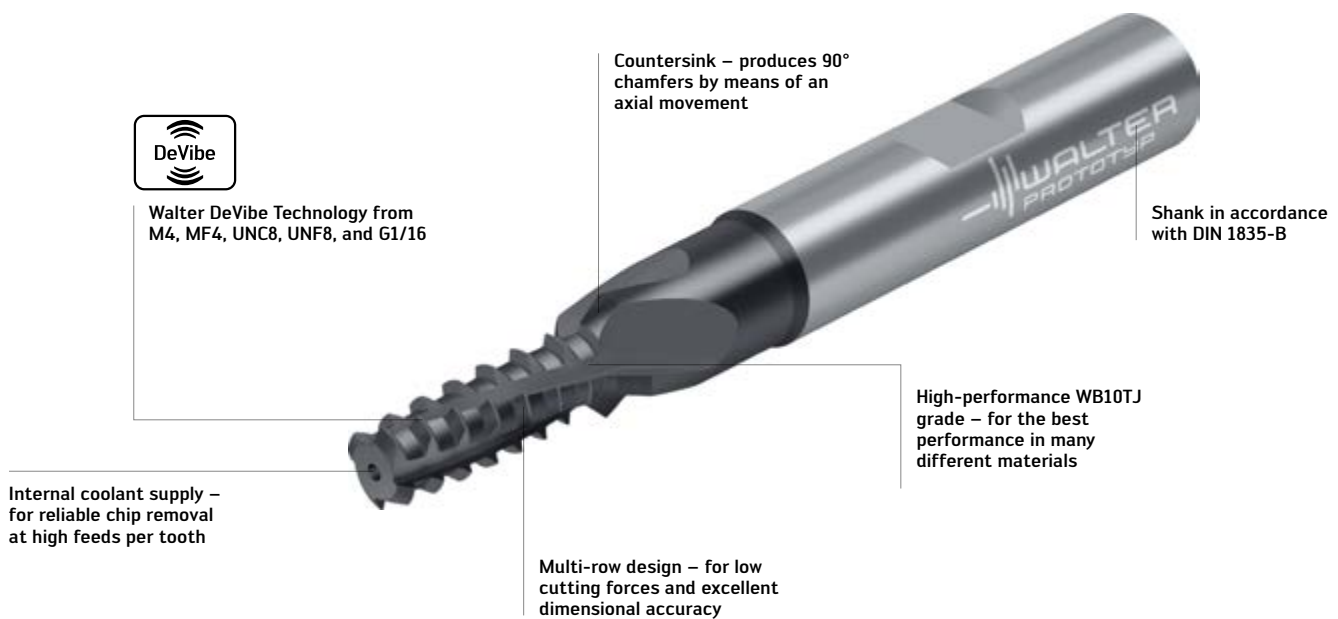
NEW

NEW ADDITION TO THE PRODUCT RANGE

- Multi-row thread milling cutters with countersink
- M3–M20
- M4×0.5–M20×1.5
- UNC8–UNC3/4
- UNF10–UNF3/4
- G1/16–G1/2

THE TOOL

- Multi-row thread milling cutter
- Walter DeVibe technology for vibration damping
- Chamfer for 90° countersinks



Multi-row solid carbide thread milling cutter

Fig.: TC620-M10-WVD-WB10TJ

POTENTIAL BENEFITS

- Low cost per thread thanks to fast machining time and high tool life quantity
- High level of process reliability and easy handling due to extremely infrequent radius corrections
- Walter DeVibe technology: Reliable machining, even in extreme conditions
- Extensive product range – now also with countersink
- Universal application in many different materials



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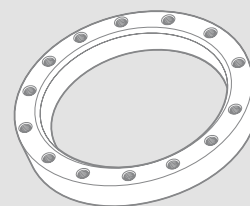
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THE APPLICATION

- Blind-hole and through-hole threads
- ISO materials P, M, K, N and S up to 48 HRC
- Thread depths $2 \times D_N$
- Ideal for strict requirements on process reliability (e.g. for expensive components)

APPLICATION EXAMPLE

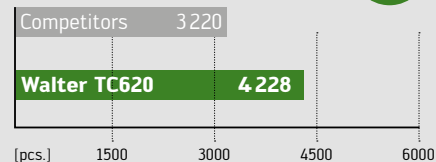
Gasket



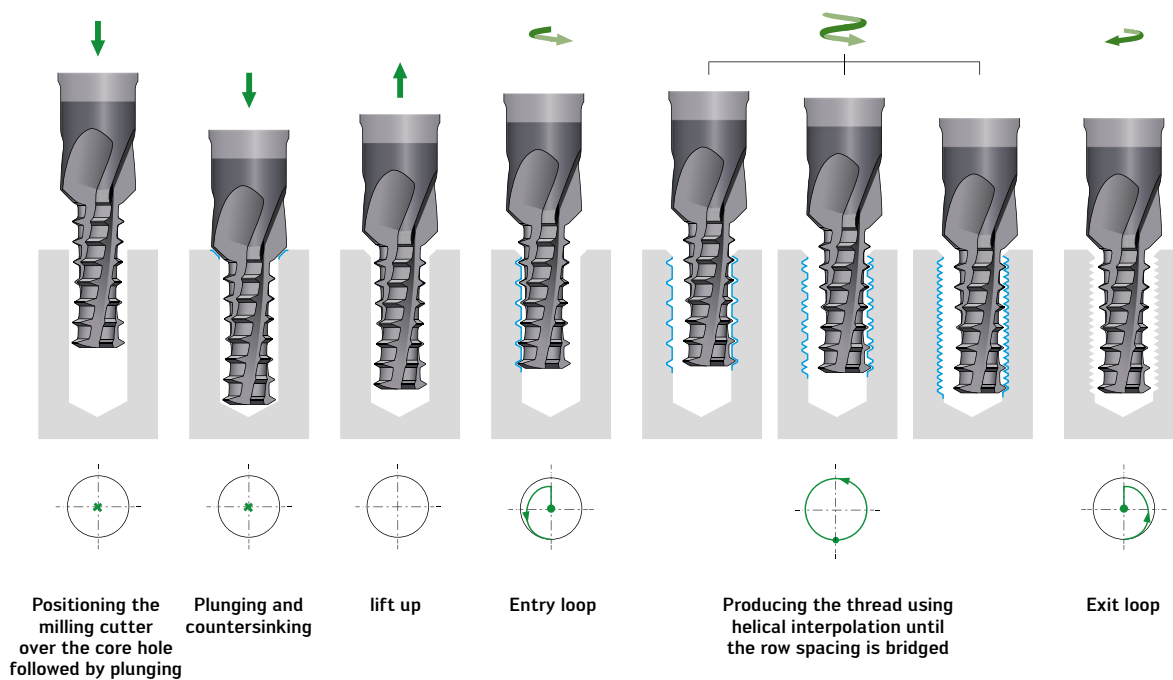
Material: 42CrMo4 (4140)
Strength: 820 N/mm² (22Rc)
Thread size: M6
Thread depth: 12 mm
Blind/through hole: Through hole
Cooling: Emulsion

Cutting data:	Competitors	TC620-M6-WVD-WB10TJ
v_c (m/min)	110	124
f_z (mm)	0.045	0.0785
Number of radial cutting edges	2	1
Number of axial cutting edges	1	2
Processing time (s)	6	3
Tool life No. Thread	3 220	4 228

Comparison:
Tool life



THE STRATEGY



Thrill-tec™ – the 3-in-1 solution for fast thread milling.



EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

- M4×0.5–M20×1.5
- UNF8–UNF3/4

THE TOOL

- Orbital drill/thread mill for universal machining
- Creation of core hole and thread in one operation
- Can also be used for chamfering (120/110° – depending on the thread profile)
- IMPORTANT: Left-hand cutting tool

THE APPLICATION

- Blind-hole and through-hole threads
- Can be used universally with ISO P, M, K, N and S up to 48 HRC
- Thread depths $2 \times D_N$

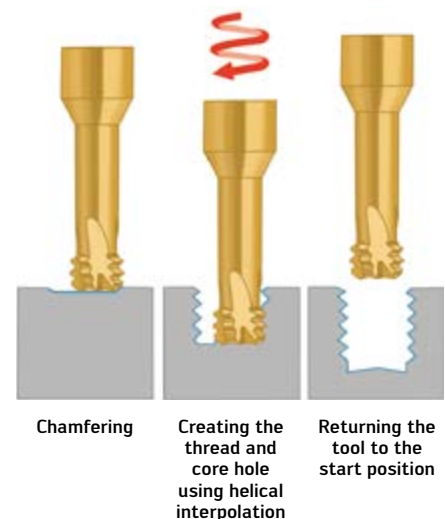


Thrill-tec™

Solid carbide orbital drill/thread mill

Fig.: TC645-M16X1.5-A1D-WB10TJ

THE STRATEGY



POTENTIAL BENEFITS

- Maximum process reliability due to high tool stability
- Very low cost per thread (high tool life quantity, fast machining time)
- Reduces the number of tool positions and the tool change time
- Universal use

The benchmark for indexable insert thread milling



EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

- Insert sizes and radii:
- Pitch range: 0.9–1.5 mm / 18–28 TPI (60° thread profiles)
- Pitch range: 14 TPI (55° thread profiles)

THE GRADE

- Tiger-tec® Gold thread milling grade WSM37G
- The only PVD Al_2O_3 coating technology of its kind in the world
- Extremely smooth rake face for low friction
- Wear-resistant, universal grade

THE GEOMETRY

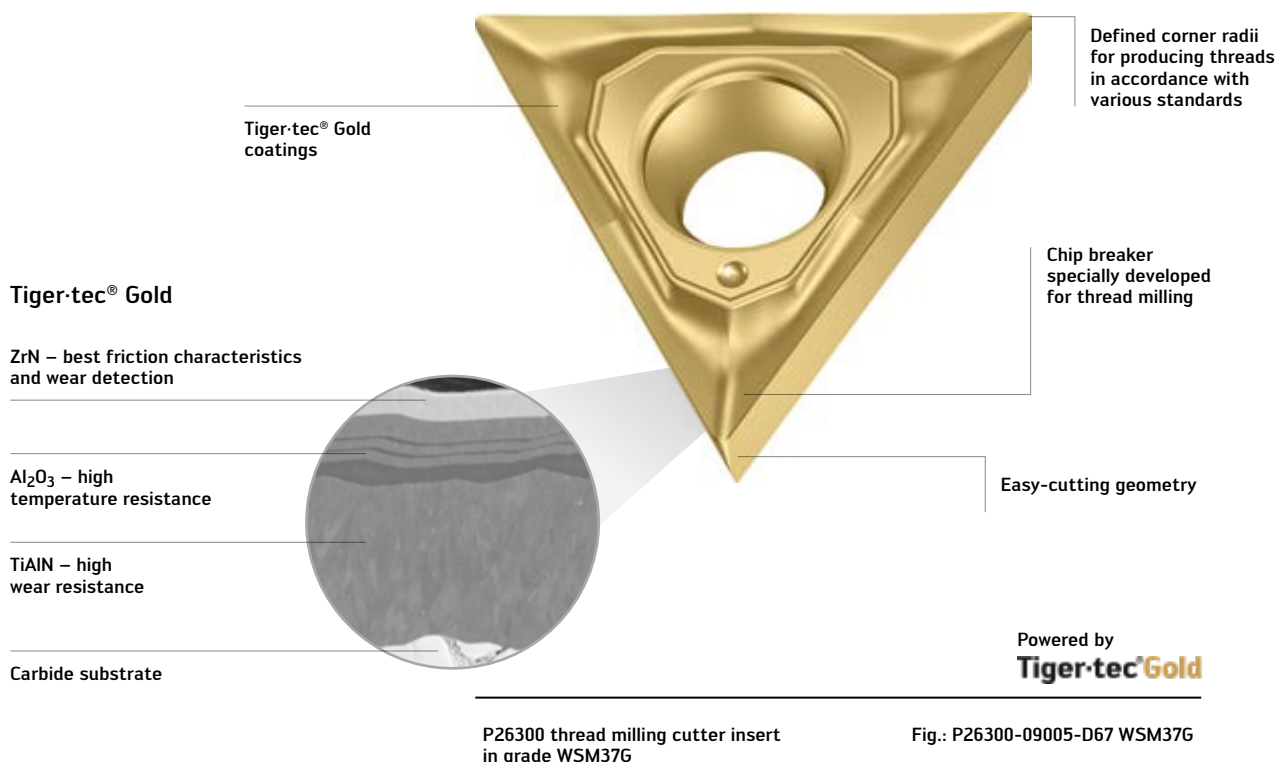
- Positive basic shape with three cutting edges
- D67 universal geometry for maximum tool life quantity
- D61 with anti-vibration land for a high level of operational smoothness when using large projection lengths or under difficult conditions

THE TOOL

- Compatible with all Walter T2710–T2713 thread milling cutters

THE APPLICATION

- Threads with a nominal diameter from 16 mm or UNC 3/4
- Pitch range: 0.9–10 mm / 3–28 TPI / 11–14 TPI
- Can be used universally with ISO P, M, K, N, S and H up to 55 HRC



POTENTIAL BENEFITS

- Process reliability due to the perfect balance between wear resistance and toughness
- High tool life due to unique PVD Al_2O_3 coating
- Universal application even under difficult conditions
- High productivity due to optimal cutting parameters
- Best wear detection due to the gold-colored top layer

The perfect pairing in ISO P.



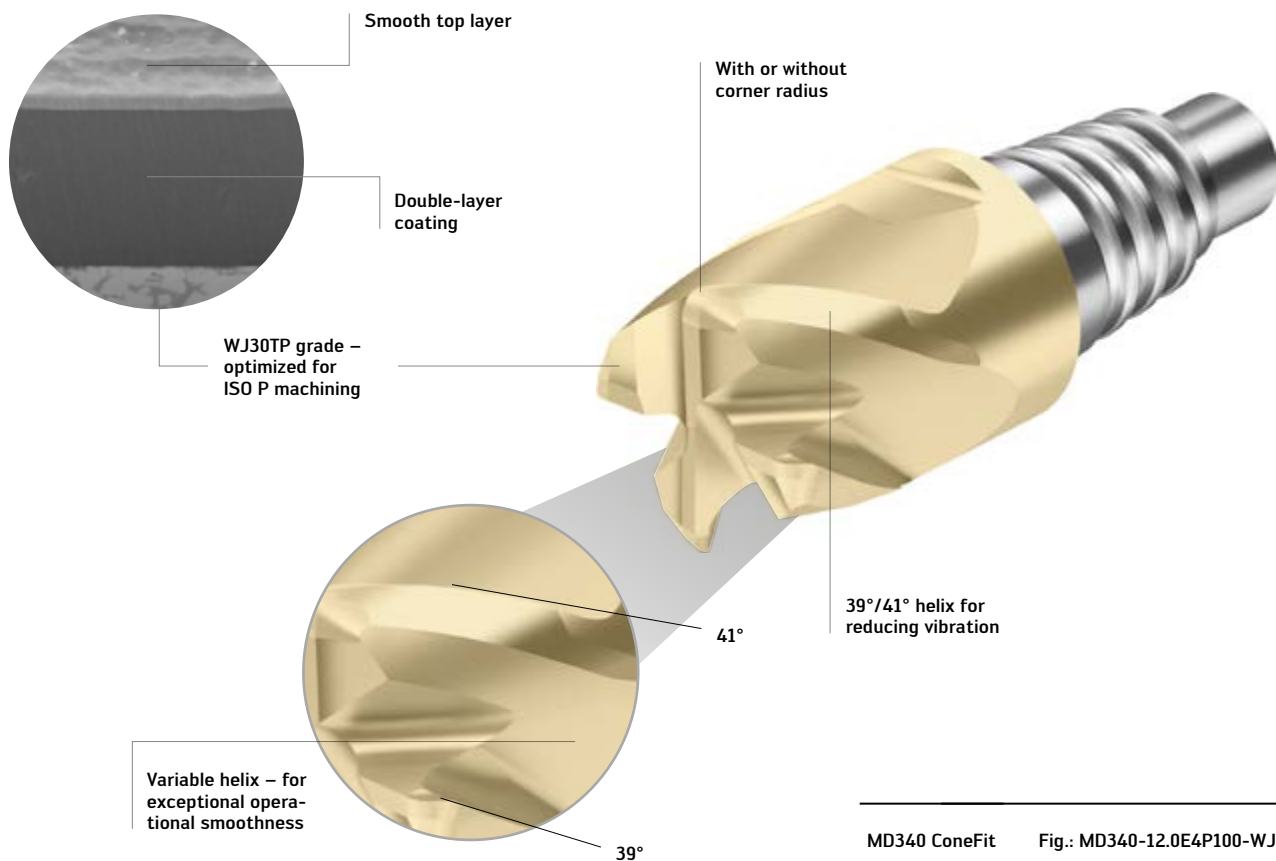
NEW

THE TOOL

- Developed for machining ISO P materials
- Variable helix
- $D_c = 10-20$ mm
- z4
- With or without corner radius

THE GRADE

- WJ30TP with TiAlN and ZrN coating
- Excellent wear detection due to ZrN top layer
- Universal application



MD340 ConeFit

Fig.: MD340-12.0E4P100-WJ30TP

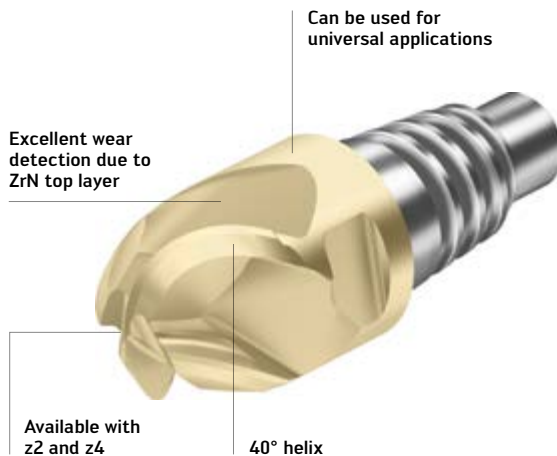
POTENTIAL BENEFITS

- Exceptional performance in machining processes involving ISO P materials due to the grade developed in-house at Walter
- Optimal operational smoothness and tool life increase due to special geometry
- WJ30TP universal grade for the best wear detection
- Flexibility – multiple ConeFit heads can be used in a single adaptor (depending on the interface size)
- ConeFit interface – self-centering thread for ultimate precision when changing tools

Overcome your challenges – with maximum flexibility.

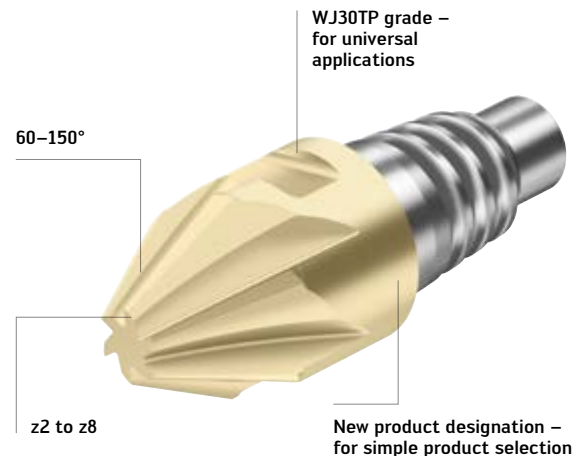


NEW



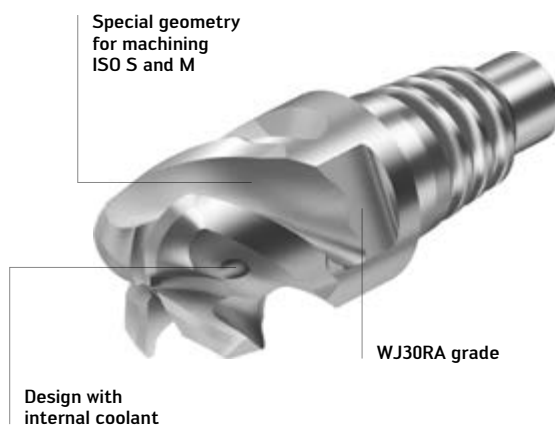
MC430 ConeFit

Fig.: MC430-12.0E4P-WJ30TP



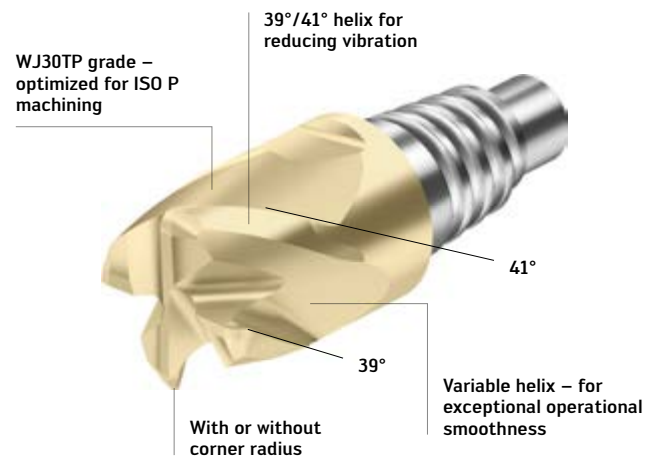
MC500 ConeFit

Fig.: MC500-12.0E6P060-WJ30TP



MD070 ConeFit

Fig.: MD070-12.0E4P150-WJ30RA



MD340 ConeFit

Fig.: MD340-12.0E4P100-WJ30TP

POTENTIAL BENEFITS

- Universal application due to wide selection of milling cutter heads and adaptors
- ConeFit interface – self-centering thread for ultimate precision when changing tools
- Flexibility – multiple ConeFit heads can be used in a single adaptor (depending on the interface size)
- Minimized downtime – the ConeFit milling cutter can be changed in a matter of seconds (no need for retooling)

Specializes in steel, delivers top performance in cast iron.

NEW

THE INDEXABLE INSERTS

- Indexable inserts for shoulder, face, high-feed, profile, copy and slot milling
- For all standard milling cutters from the Walter range (e.g. Xtra-tec® XT, Walter BLAXX, M4000)

THE GRADE

- Wear-resistant Tiger-tec® Gold CVD coating: Fine-matrix, highly textured MT-TiCN
- Multi-layer MT-TiCN structure with optimized elastic properties of the crystals
- Multi-stage post-treatment for improved toughness and reduced friction thanks to the smooth rake face
- Highly textured Al₂O₃ top layer on the rake face reduces adhesion (e.g. with ISO K)

Fig.: TNMU160508R-
G27 WPP35G

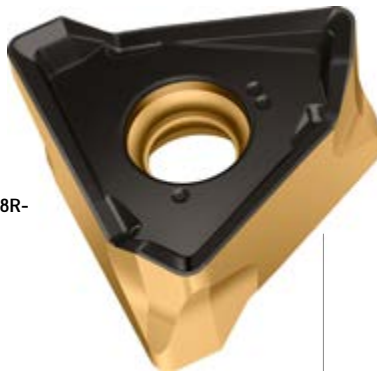


Fig.: SDMT120408-
F57 WPP35G



Fig.: LNU130612R-
L55T WPP35G



Powered by
Tiger-tec®Gold

Versatile: The new Tiger-tec® Gold WPP35G milling grade

Fig.: Walter Xtra-tec® XT, Walter BLAXX & M4000



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THE APPLICATION

- Roughing steel and cast iron materials at moderate to high cutting speeds
- For average to good machining conditions
- Dry machining (especially for steel) or with cooling lubricant
- Areas of use: General mechanical engineering, mold and die making, aerospace, energy and automotive industries

Conventional TiCN Competitor



Wears more quickly because individual crystals detach from the compound.

Highly textured MT-TiCN Tiger-tec® Gold



Higher wear resistance, as aligned crystals offer more resistance.

APPLICATION EXAMPLE

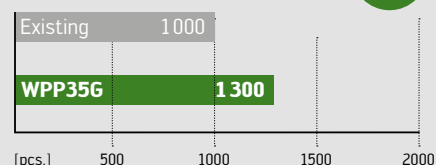
Face compressor shaft –
Face milling cutter



Material: Steel C45R
Strength: 220 HB
Tool: M5009-063-B22-08-06
Indexable insert: SNMX1205ANN-F57

Cutting data:	Existing	Walter WPP35G
v_c (m/min)	300	300
f_z (mm)	0.34	0.34
v_f (mm/min)	3500	3500
a_p (mm)	0.75	0.75
a_u (mm)	32	32
Cooling	Emulsion - internal	

Comparison:
Quantity Components

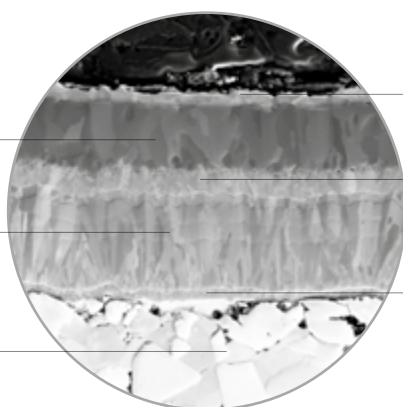


Cross section:
Tiger-tec® Gold WPP35G milling grade

Al_2O_3 aluminium oxide layer –
wear-resistant heat shield

MT-TiCN base layer –
with ultimate hardness, resistant
to wear caused by chemicals

Carbide substrate with high level of toughness



Gold-colored
TiN top layer on
the flank face

Bonding layer

Bonding layer

POTENTIAL BENEFITS

- Reliable coating, ideal for mostly automated production and mass production
- High level of cost-efficiency due to Tiger-tec® Gold coating
- Resistant to flank face wear due to fine-matrix, highly textured MT-TiCN
- Simple wear detection due to gold-colored TiN layer on the flank face

For the very highest feeds in ISO M and S.



EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

G67

- First choice for machining ISO M and S materials
- Highly positive rake angle for low machining forces
- Sharp geometry for reduced built-up edges



G67 geometry – first choice for ISO M and S materials

P	M	K	N	S	H	O
●	●●	●	●	●●	●	●

ENMX indexable insert for M5008 high-feed milling cutter
Xtra-tec® XT M5008 high-feed milling cutter

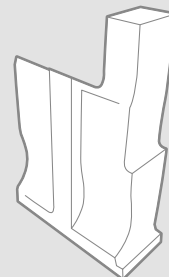
Fig.: ENMX08T316R-G67 WSP45G
Fig.: M5008-025-T22-05-01

THE TOOL

- Double-sided indexable inserts with four cutting edges
- Rhombic basic shape for small tool diameters and high number of teeth
- Stable indexable insert clamping due to large contact surface in the insert seat
- Curved cutting edges for maximum stability
- Combines stability with easy-cutting geometries
- Tiger-tec® cutting tool materials for optimum cutting data and tool life

APPLICATION EXAMPLE

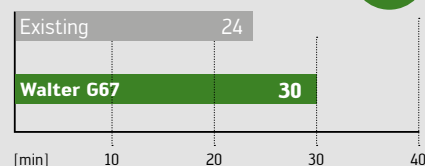
Packaging machine



Material: 1.4301 (304 ss)
Strength: 700 N/mm² (210 HB)
Tool: M5008-032-TC16-05-01
Indexable insert: ENMX08T316R-G67 WSP45G

Cutting data:	Existing	Walter G67
D _c (mm)	32	32
z	5	5
v _c (m/min)	130	130
f _z (mm)	0.6	0.6
v _f (mm/min)	3900	3900
a _p (mm)	0.6	0.6
a _e (mm)	<13	<13
TL (min)	24	30

Comparison:
Tool life (min)



POTENTIAL BENEFITS

- High process reliability due to rigid and stable indexable insert
- Reduced process costs thanks to Tiger-tec® cutting tool materials and four cutting edges
- High machining volume thanks to the combination of low depths of cut and high feed per tooth rates
- Optimum productivity thanks to extremely closely pitched tools

Ultra precise right down to the groove base.



NEW

NEW ADDITION TO THE PRODUCT RANGE

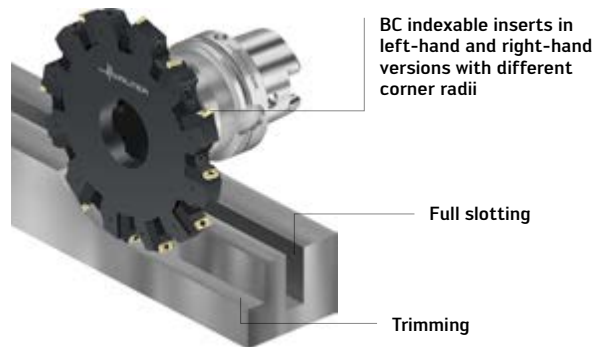
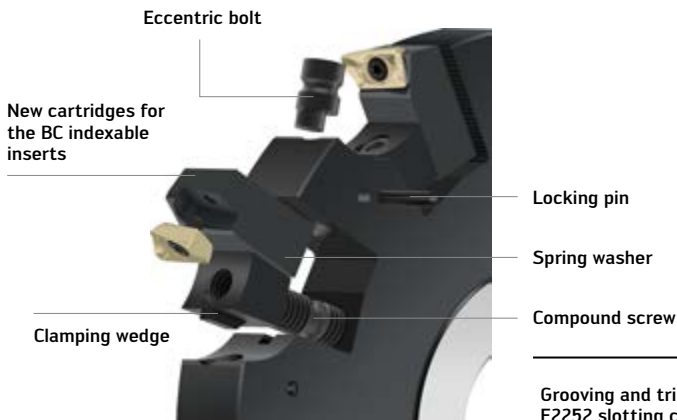
- Cartridges and BC indexable inserts for F2252 slotting cutter: In three sizes; left-hand and right-hand versions available

THE APPLICATION

- Universal application in ISO P, M, K, N and S (due to the WKP35G, WSP45G, WXN15G milling grades)
- Slot milling with staggered cutting edges
- Forward and reverse milling possible

THE TOOL

- F2252 milling cutter with bore adaption; longitudinal or transverse keyway in accordance with DIN 138
- BC indexable inserts with all standard corner radii; left-hand and right-hand versions available
- Eccentric bolt and serration in an axial direction – for adjustable cutting widths
- 90° approach angle



Grooving and trimming with the new F2252 slotting cutters and BC indexable inserts

Fig.: BC.T1204..L/R..
F2252.BN.200.Z06.19.S767
AB001-H100-B40-100

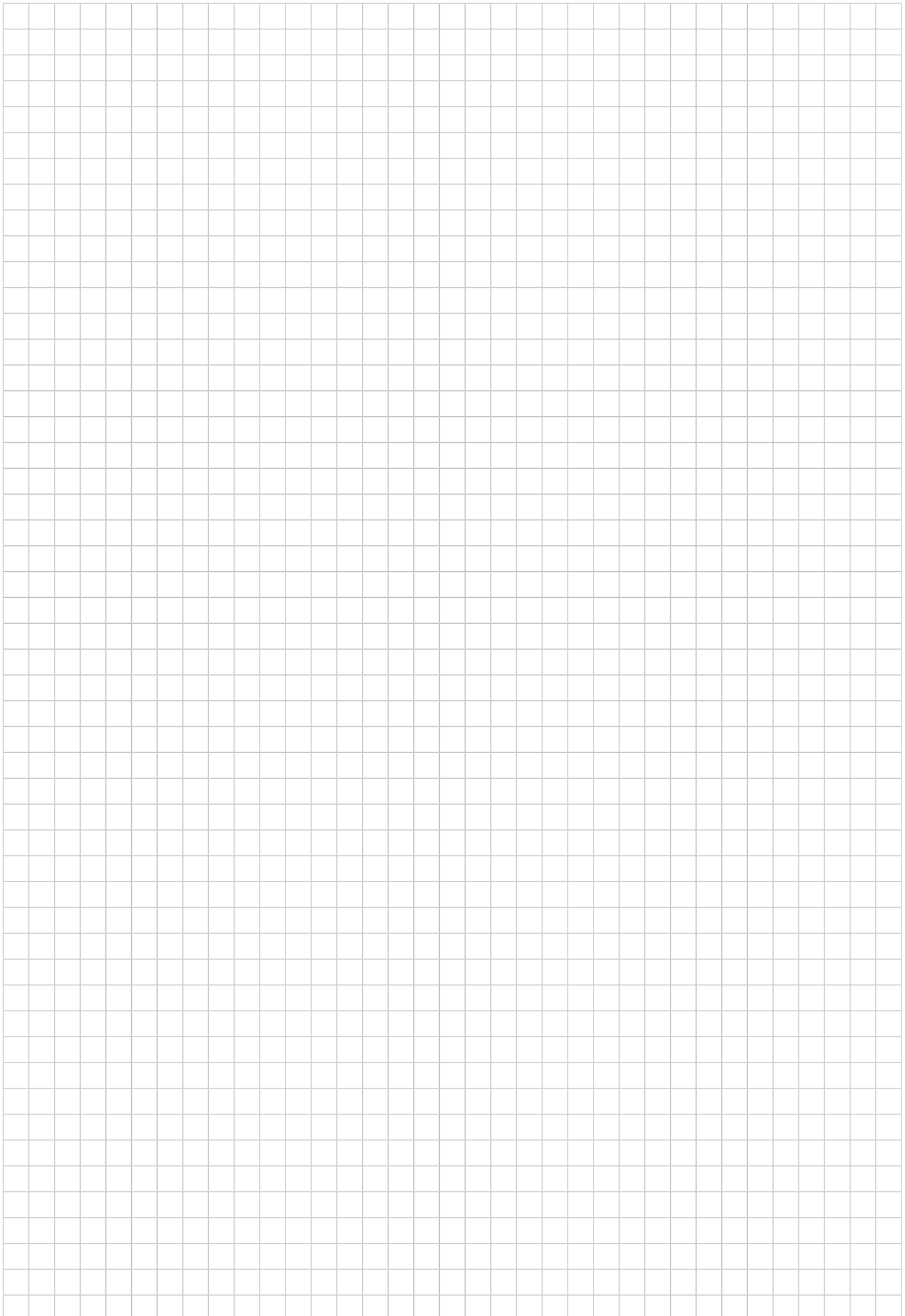
AVAILABLE BC INDEXABLE INSERTS AND CORNER RADII

	r mm											
	0.2	0.4	0.8	1.2	1.6	2.0	2.5	3.0	3.2	4.0	5.0	6.0
BC.T09..R..	●	●	●	●	●	●						
BC.T12..R..		●	●	●	●	●	●	●	●	●		
BC.T16..R..			●	●	●	●	●	●	●	●	●	●
BC.T09..L..		●	●									
BC.T12..L..		●	●	●	●	●		●		●		
BC.T16..L..			●	●	●	●		●		●	●	●

● = New addition to the product range

POTENTIAL BENEFITS

- High level of flexibility as BC indexable inserts can also be used in Xtra-tec® XT M5130 and M5250 milling cutters
- Maximum stability due to new installation position with reinforced insert pocket
- Cutting width is easy to adjust using eccentric bolt and serration at the rear of the cartridges
- High level of accuracy in the groove base



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Universal eXcellence in milling.

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Xill-tec®



With Xill-tec®, the solid carbide milling cutters from the MC230 Advance range, Walter offers you unprecedented universality and excellence in milling: Universal, due to versatility for virtually any application and any material. Excellent, due to the unique combination of a new high-performance geometry with Walter's own wear-resistant WK40TF high-performance grade. This makes Xill-tec® a byword for the greatest operational smoothness, tool life increases and process reliability. And all with outstanding cost-effectiveness.

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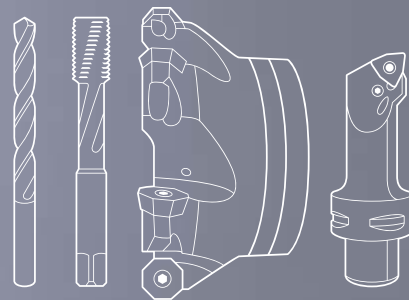
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