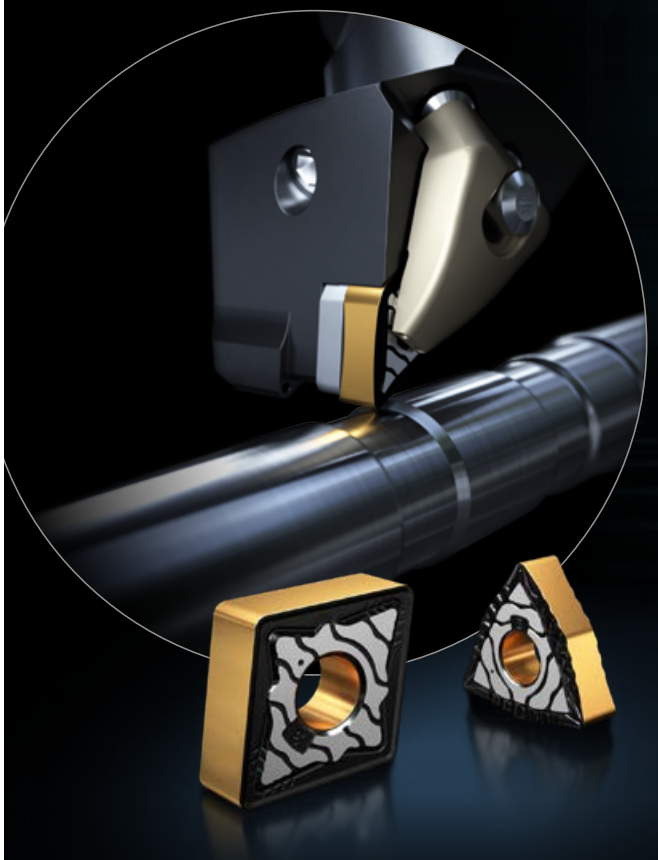
WALTER
Engineering Kompetenz

Turning

Tiger·tec® Gold
2023

Tiger·tec® Gold
Turning takes time.
A tool lifetime.



ISO turning – Indexable inserts

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: FW4, FL2, FP2, FP4, FP6/MW4, MP4, MP6/RP4/HU6
- Geometries – WL 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

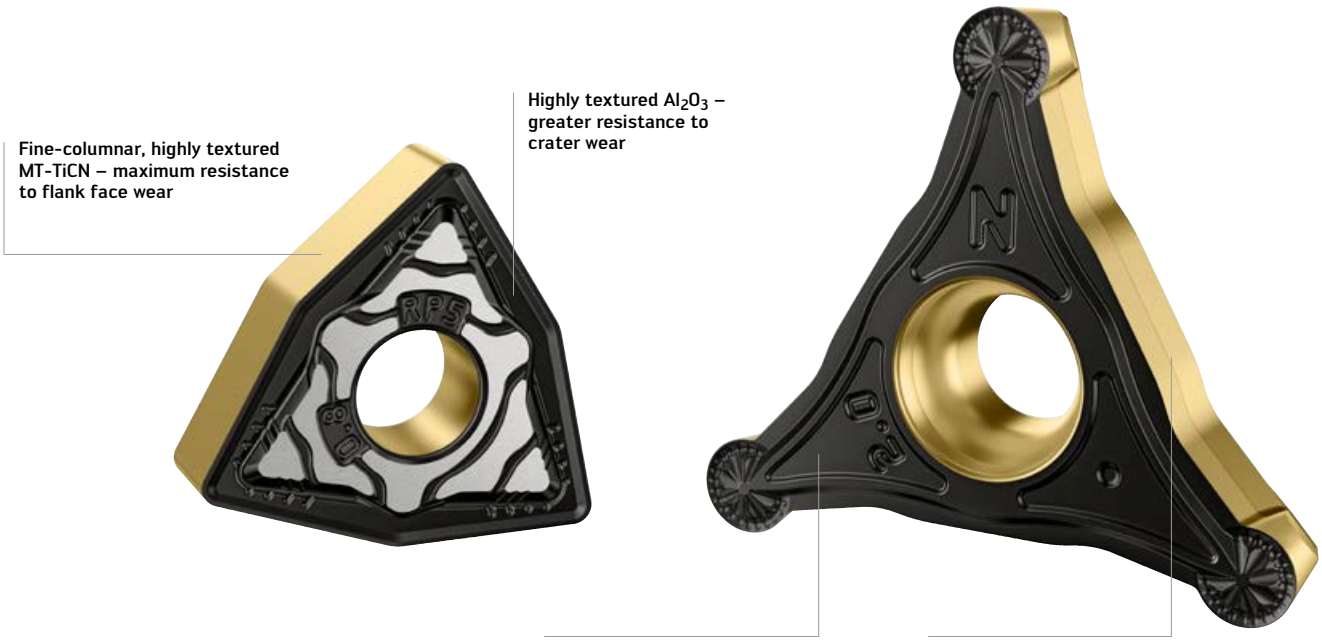
- Wear-resistant for continuous cutting and occasional interrupted cuts
- Primary application: Steel ISO P10; Secondary application: Cast iron ISO K20

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



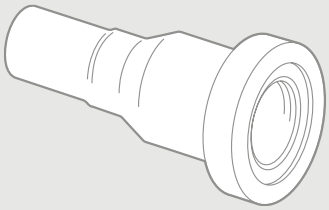
Tiger·tec® Gold

Tiger·tec® Gold turning inserts

Image: WNMG080412-RP5 WPP10G + WL25-RC0525N-MU6 WPP20G

APPLICATION EXAMPLE

**Transmission shaft –
Internal machining, dia. 29 mm**

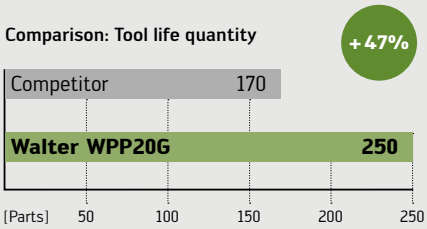


Material:	18MnCrS5/DIN 1.8720
Tensile strength:	580 N/mm²
Tool:	E20S-SDUCR11-R
Indexable insert:	DCMT11T304-FP4 WPP20G

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



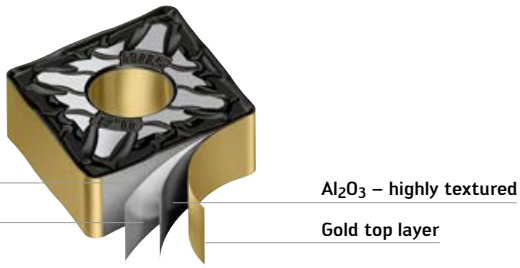
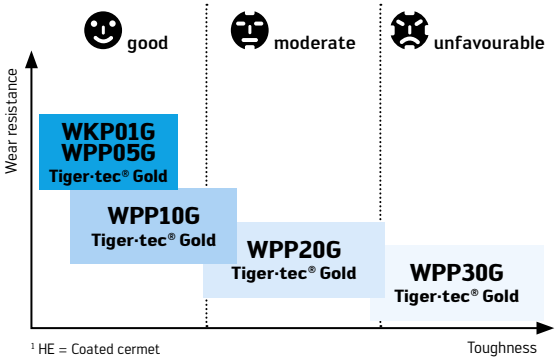


Image: TTG coating composition



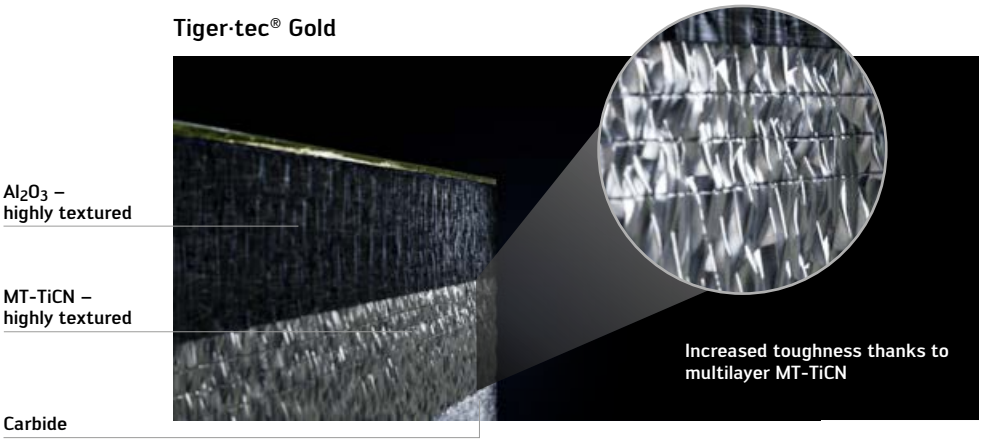
[1] HE = Coated cermet

Conventional TiCN

Tiger·tec® Gold MT-TiCN – highly textured

High wear resistance and considerable increase in tool life

Tiger·tec® Gold



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%

Two grades that are redefining speed.

THE GEOMETRY

- FW4, FW5/FP4, FP5/WL25-FP4 available in WKP01G
- MW5, MP3, MP5, MU5/RP4, RP7/HU3 available in WPP05G

THE GRADE

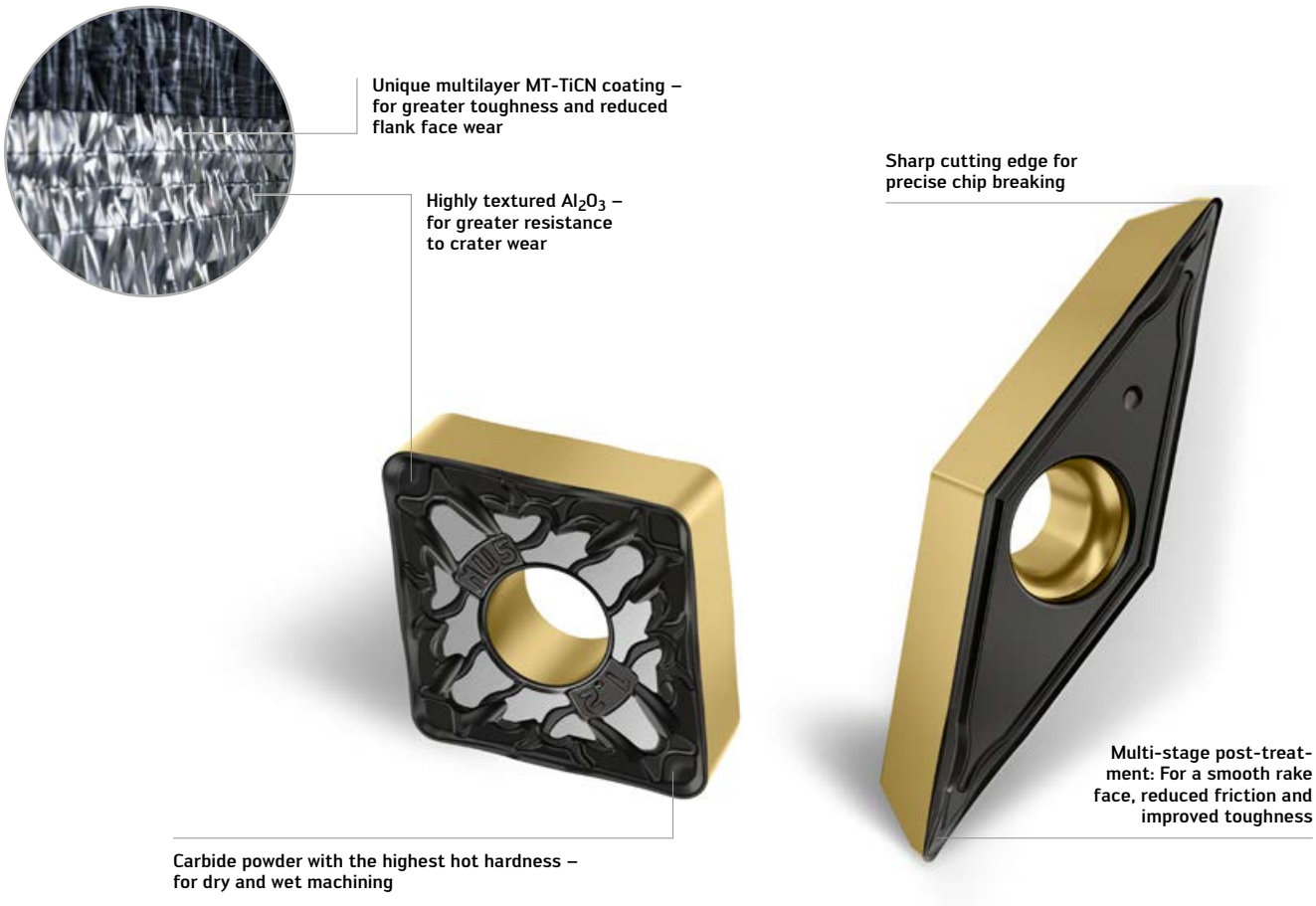
- New Tiger·tec® Gold coating: Fine-columnar, highly textured MT-TiCN – resistant to flank face wear
- Multilayer MT-TiCN structure improves the elastic property of the crystals
- Multi-stage post-treatment for a smooth rake face, reduced friction and improved toughness

WKP01G

- Optimised cutting edge rounding for better surfaces when finishing

WPP05G

- Highly textured Al_2O_3 to minimise crater wear



WKP01G and WPP05G high-performance cutting tool materials

Image: CNMG120412-MU5 WPP05G
Image: VCMT160404-FP4 WKP01G

THE APPLICATION

- Ideal for large-scale production (e.g. gearbox components, gears, rotor hubs)
- Extremely wear-resistant for continuous cutting and occasional interrupted cuts
- Materials with increased tensile strength from 900–1400 N/mm²

WKP01G

- Finishing operations at the highest cutting speed
- Primary application: Steel (ISO P01); cast iron (ISO K01)

WPP05G

- Medium machining and roughing operations at the highest cutting speed
- Dry or wet machining
- Primary application: Steel (ISO P05);
  Secondary application: Cast iron (ISO K10)

THE TECHNOLOGY

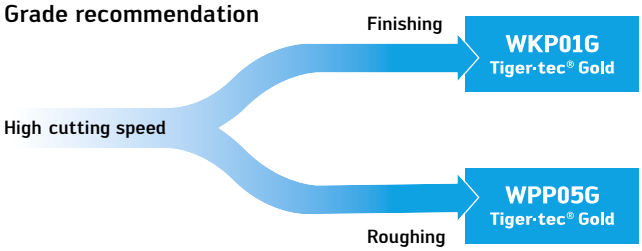
Conventional TiCN
Competitor

Wears more quickly because individual crystals detach from the compound.

Highly textured MT-TiCN
Tiger·tec® Gold

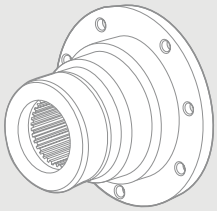
Higher wear resistance, as aligned crystals offer more resistance.

Grade recommendation



APPLICATION EXAMPLE

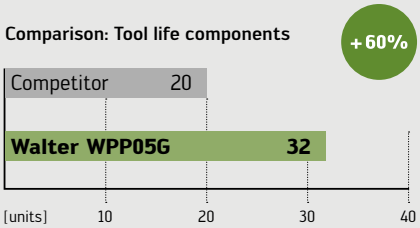
Splined flange – external roughing



Material:	C45 / DIN 1.0503
Tensile strength:	750 N/mm²
Tool:	DCLNR2525M12
Indexable insert:	CNMG120412-MU5 WPP05G
Tool life criteria:	Cutting force monitoring on the machine

Cutting data	Competitor ISO P10	**Walter WPP05G Tiger·tec® Gold**
v_c (m/min)	260	290
a_p (mm)	3.0	3.0
f (mm)	0.4	0.4
Cooling	Emulsion	Emulsion
Tool life (units)	20	32

Comparison: Tool life components



BENEFITS FOR YOU

- Increased productivity, shorter machining time – ideal for mass production
- Universal application on steel and cast iron materials
- High level of cost-efficiency due to highly textured Tiger·tec® Gold coating – average tool life increase of around 50%

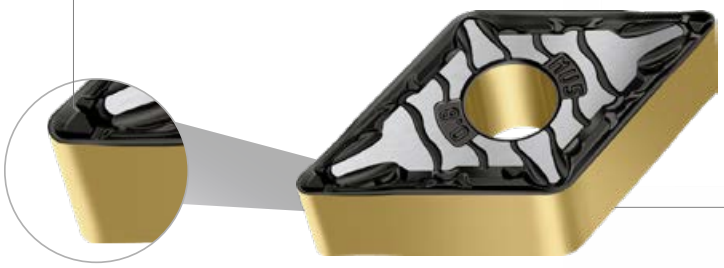
DRIVE SHAFT

Longitudinal turning – optimisation recommendations

Bullet design

MP3 geometry – medium machining
Long-chipping materials
- Forged parts, e.g. gears, ball studs, transmission shafts, etc.
- "Bullet design" gives chips additional rigidity for optimal chip breaking

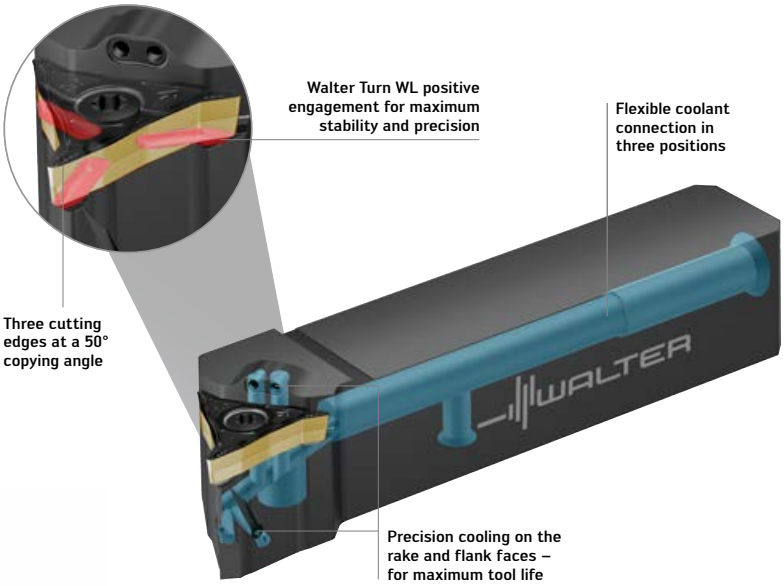
New V-shaped chip breaker design
for the best chip breaking properties

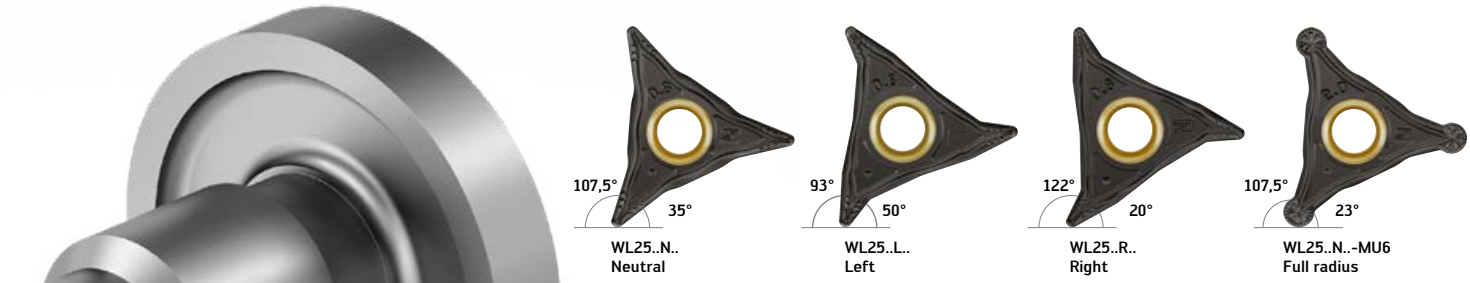


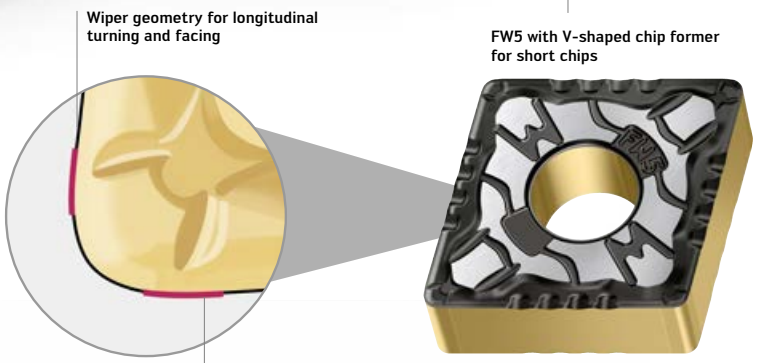
MU5 geometry – medium machining
Universal for steel and stainless materials
- Soft cutting action and maximum resistance to crater wear in the medium cutting area
- Curved cutting edge for best surface quality when copy turning

Walter WL25/WL17 copy turning system

- High level of dimensional stability due to positive-locking, robust WL connection
- Longer tool life when copy turning
- 50% higher indexing accuracy compared to ISO indexable inserts
- High level of flexibility: Four indexable insert types fit in the same tool
- Cost-effective: Lower tool costs due to three cutting edges







FW5 wiper geometries

- Finishing with excellent surfaces at high feeds
- Reduced cutting pressure (e.g. for thin shafts and internal machining)
- a_p: 0.3–3.0 mm; f: 0.10–0.55 mm

MW5 wiper geometries

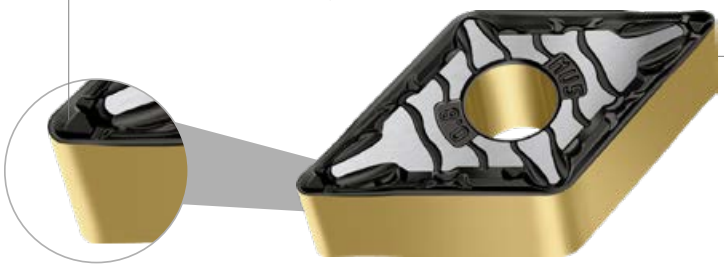
- Medium machining with excellent surfaces at maximum feeds
- Increase in productivity through maximum feeds
- a_p: 0.8–5.0 mm; f: 0.15–0.70 mm

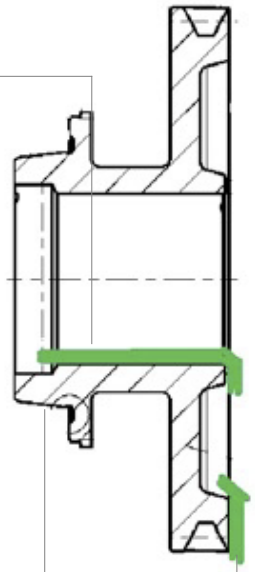
Wiper

PULLEY

Facing and internal turning – optimisation recommendations

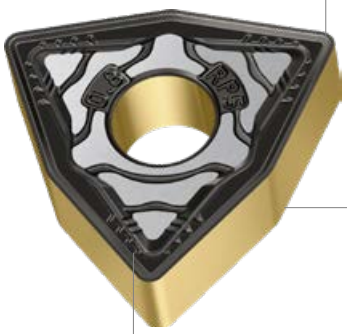
New V-shaped chip breaker design
for the best chip breaking properties





MU5 geometry – medium machining
Universal for steel and stainless materials
- Soft cutting action and maximum resistance to crater wear in the medium cutting area
- Curved cutting edge for best surface quality when copy turning

Stable, positive
3° chamfer

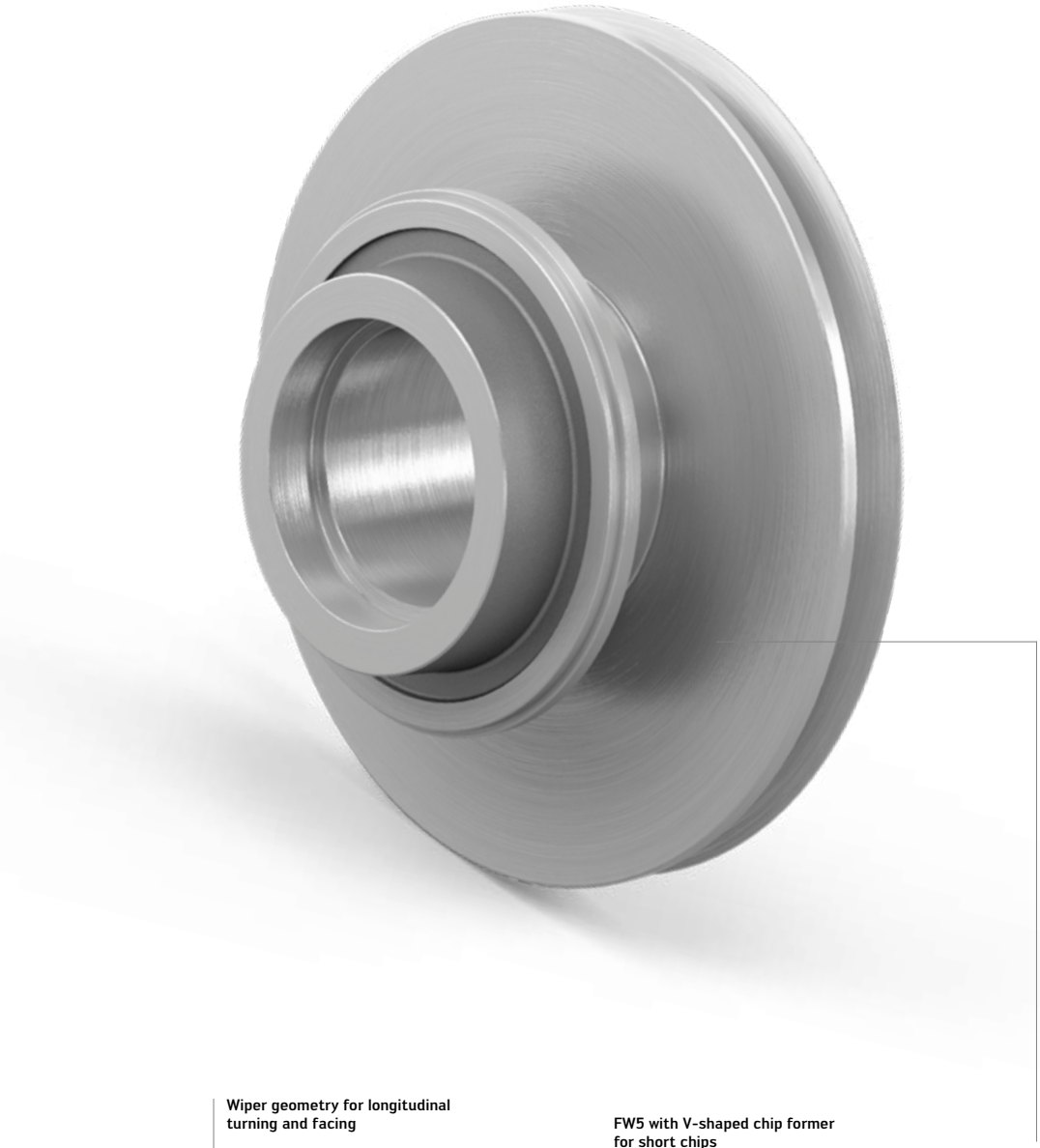


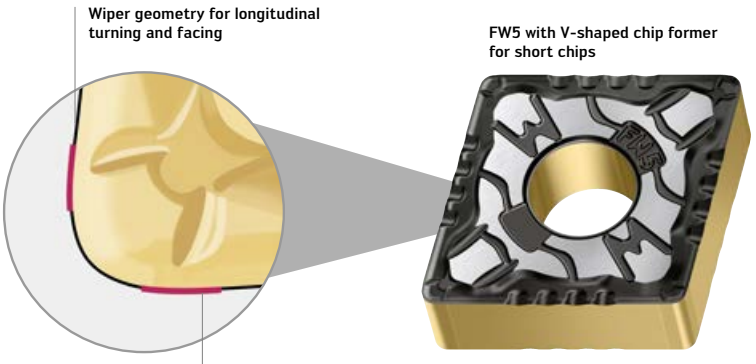
RP5 geometry – roughing
- The stable, positive 3° chamfer for roughing operations with a low power requirement
- Open chip groove design produces a low cutting temperature and reduces wear
- Greater chamfer width in the depth of cut area prevents fractures when machining scale

Open, deep and wide
chip breaker groove

HU6 geometry – high-feed roughing
- Forged parts, e.g. gears, pulleys, etc.
- Up to 40% reduction in process time
- No downtime caused by long chips
- Maximum tool life due to new Tiger·tec® Gold cutting tool material
- High process reliability
- Stable cutting edge design for high feeds and interrupted cuts

Ideal chip formation due to
a special chip groove design





FW5 wiper geometries

- Finishing with excellent surfaces at high feeds
- Reduced cutting pressure (e.g. for thin shafts and internal machining)
- a_p: 0.3–3.0 mm; f: 0.10–0.55 mm

MW5 wiper geometries

- Medium machining with excellent surfaces at maximum feeds
- Increase in productivity through maximum feeds
- a_p: 0.8–5.0 mm; f: 0.15–0.70 mm

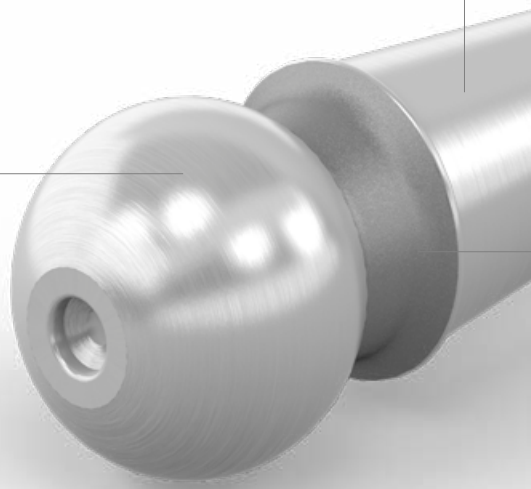
Wiper

BALL STUDS

Contour turning – optimisation recommendations

V-shaped chip former
for good chip breaking
when finishing

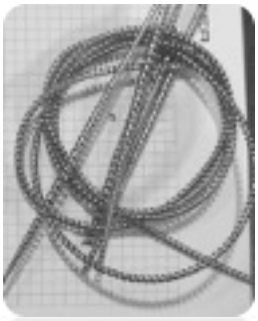
FP5 geometry – finishing
- V-shaped chip breaker ensures reliable chip control when longitudinal turning and facing from a depth of cut of 0.2 mm
- Positive, curved cutting edge for reduced tendency to vibrate and best surface quality
- Wave-shaped chip deflectors prevent swarf packing when copy turning or facing using a draw cut



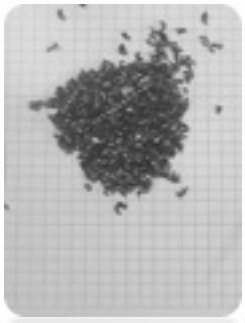
Bullet design

MP3 geometry – medium machining
Long-chipping materials
- Forged parts, e.g. gears, ball studs, transmission shafts, etc.
- "Bullet design" gives chips additional rigidity for optimal chip breaking

Competitor

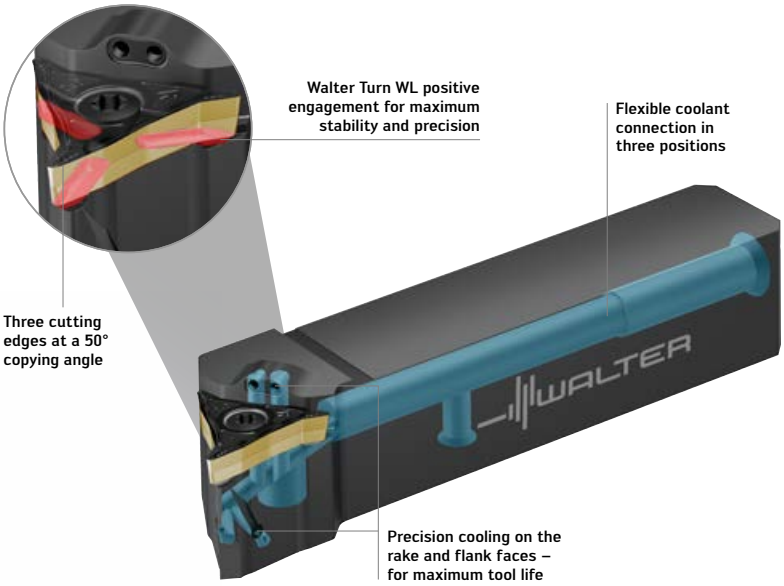


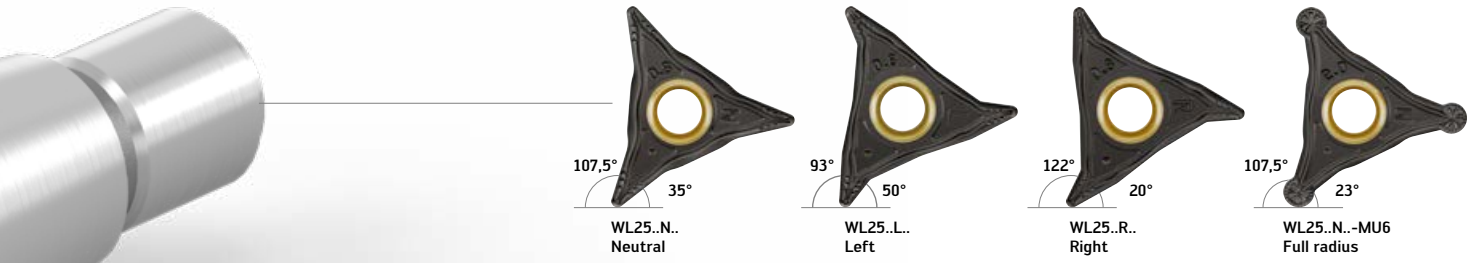
Walter MP3

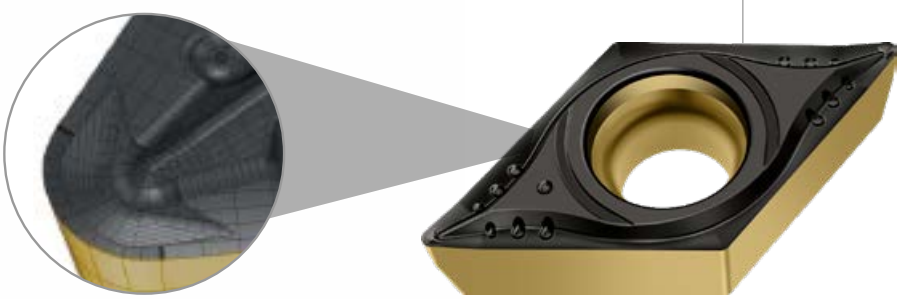


Walter WL25/WL17 copy turning system

- High level of dimensional stability due to positive-locking, robust WL connection
- Longer tool life when copy turning
- 50% higher indexing accuracy compared to ISO indexable inserts
- High level of flexibility: Four indexable insert types fit in the same tool
- Cost-effective: Lower tool costs due to three cutting edges





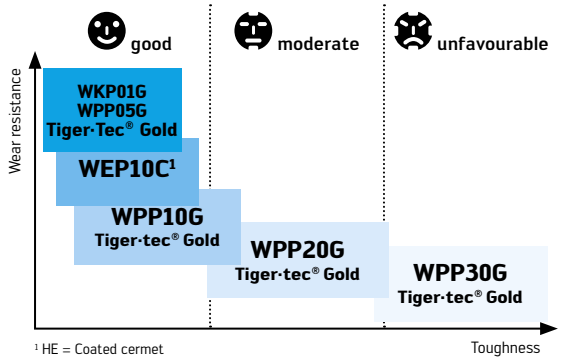


MP4 geometry – medium machining

- Best chip breaking when copy turning
- Machining of long-chipping materials
- Can be used universally in a wide application range: a_p 0.4–3.5 mm; f: 0.08–0.35 mm
- Curved cutting edge for best surface quality when copy turning

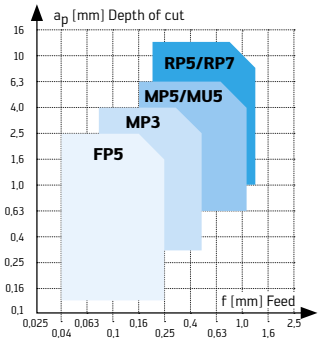
Product range overview of indexable inserts for ISO turning: Carbide – Grades and geometries

Machining steel ISO P



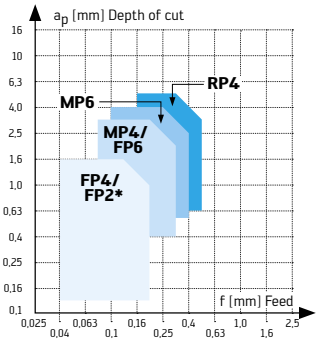
¹ HE = Coated cermet

Negative basic shape
double-sided



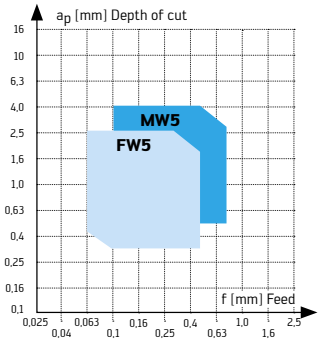
MP5: For universal machining
MU5: Easy-cutting – for ISO P and ISO M
RP5: For universal machining
RP7: For interrupted cuts, cast skin/forged skin

Positive basic shape

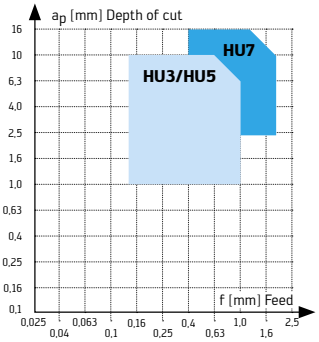


MP4: For universal machining, copy turning
FP6: For semi-finishing operations
* Fully ground circumference

Wiper



Negative basic shape
single-sided



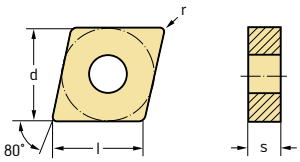
HU3: For universal machining
HU5: Easy-cutting

WALTER SELECT Optimum indexable insert for → Good = → Average = → Poor = machining conditions

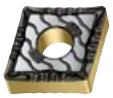
Negative rhombic 80°

CNMG / CNMM

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	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	☺		☺	😐			☺
	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			☺	😐			
 Wiper	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		☺	☺	😐			
	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				😐			
	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-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-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			☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: CNMG120404-FW5 WKP01G

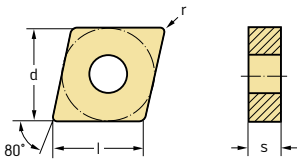
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Negative rhombic 80°

CNMG / CNMM

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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		☺	☺	😐	☹		
	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			☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: CNMG120404-FW5 WKP01G

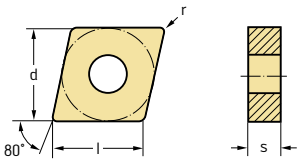
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for ➔ Good = ☺ ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Negative rhombic 80°

CNMG / CNMM

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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			☺	😐	☹		
	CNMM190624-HU7	19,34	2,4	0,60–1,60	3,0–13,0			☺	😐	☹		
	CNMM250924-HU7	25,79	2,4	0,60–1,60	3,0–17,0				😐	☹		

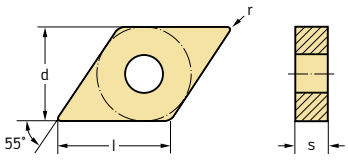
See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: CNMG120404-FW5 WKP01G

HC = Coated carbide
HE = Coated cermet

Negative rhombic 55°

DNMG / DNMM

Tiger·tec® Gold



Indexable inserts

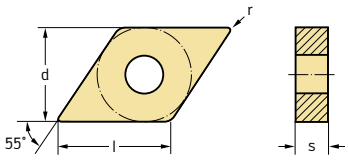
	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	DNMG110404-FW5	11,63	0,4	0,10–0,35	0,3–2,0	☺		☺	😐			☺
	DNMG110408-FW5	11,63	0,8	0,15–0,50	0,4–2,0	☺		☺	😐			☺
	DNMG150404-FW5	15,5	0,4	0,10–0,40	0,3–3,0			☺				
	DNMG150408-FW5	15,5	0,8	0,15–0,50	0,4–3,0	☺		☺				☺
	DNMG150604-FW5	15,5	0,4	0,10–0,40	0,3–3,0	☺		☺	😐			☺
	DNMG150608-FW5	15,5	0,8	0,15–0,50	0,4–3,0	☺		☺	😐			☺
	DNMG110402-FP5	11,63	0,2	0,04–0,12	0,1–0,5			☺	😐		☺	
	DNMG110404-FP5	11,63	0,4	0,04–0,20	0,1–1,5	☺		☺	😐		☺	☺
	DNMG110408-FP5	11,63	0,8	0,08–0,25	0,2–2,0	☺		☺	😐		☺	☺
	DNMG110412-FP5	11,63	1,2	0,10–0,25	0,5–2,5			☺	😐			
	DNMG150404-FP5	15,5	0,4	0,05–0,20	0,1–1,5	☺		☺	😐		☺	☺
	DNMG150408-FP5	15,5	0,8	0,08–0,25	0,2–2,0	☺		☺	😐		☺	☺
	DNMG150412-FP5	15,5	1,2	0,10–0,25	0,5–2,5			☺	😐		☺	
	DNMG150604-FP5	15,5	0,4	0,05–0,20	0,1–1,5	☺		☺	😐		☺	☺
	DNMG150608-FP5	15,5	0,8	0,08–0,25	0,2–2,0	☺		☺	😐		☺	☺
	DNMG150612-FP5	15,5	1,2	0,10–0,25	0,5–2,5	☺		☺	😐		☺	☺

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: DNMG110404-FW5 WKP01G

HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Negative rhombic 55°
DNMG / DNMM
Tiger·tec® Gold



Indexable inserts

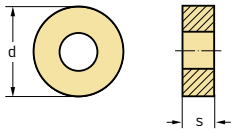
	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	DNMG110408-MW5	11,63	0,8	0,15–0,50	0,8–3,0		☺	☺	😐			
	DNMG110412-MW5	11,63	1,2	0,20–0,60	1,5–3,0			☺	😐			
	DNMG150408-MW5	15,5	0,8	0,15–0,55	0,8–4,0			☺				
	DNMG150412-MW5	15,5	1,2	0,20–0,65	1,5–4,0			☺				
	DNMG150608-MW5	15,5	0,8	0,15–0,55	1,5–4,0		☺	☺	😐			
	DNMG150612-MW5	15,5	1,2	0,20–0,65	1,5–4,0		☺	☺	😐			
	DNMG110408-MS3	11,63	0,8	0,12–0,30	0,8–2,5				😐			
	DNMG150608-MS3	15,5	0,8	0,15–0,30	0,8–2,5				😐			
	DNMG110404-MP3	11,63	0,4	0,08–0,22	0,3–2,2			☺	😐			
	DNMG110408-MP3	11,63	0,8	0,12–0,32	0,6–3,0		☺	☺	😐	☹		
	DNMG110412-MP3	11,63	1,2	0,16–0,40	0,8–3,2			☺	😐			
	DNMG150404-MP3	15,5	0,4	0,08–0,22	0,3–2,5			☺	😐			
	DNMG150408-MP3	15,5	0,8	0,12–0,32	0,6–3,2		☺	☺	😐	☹		
	DNMG150412-MP3	15,5	1,2	0,16–0,40	0,8–3,5		☺	☺	😐	☹		
	DNMG150604-MP3	15,5	0,4	0,08–0,22	0,3–2,5			☺	😐	☹		
	DNMG150608-MP3	15,5	0,8	0,12–0,32	0,6–3,2		☺	☺	😐	☹		
	DNMG150612-MP3	15,5	1,2	0,16–0,40	0,8–3,5		☺	☺	😐			
	DNMG110404-MP5	11,63	0,4	0,16–0,25	0,5–4,0			☺	😐	☹		
	DNMG110408-MP5	11,63	0,8	0,18–0,35	0,6–4,0		☺	☺	😐	☹		
	DNMG110412-MP5	11,63	1,2	0,20–0,40	1,0–4,0			☺	😐	☹		
	DNMG150404-MP5	15,5	0,4	0,16–0,25	0,5–4,0			☺	😐	☹		
	DNMG150408-MP5	15,5	0,8	0,18–0,35	0,6–5,0		☺	☺	😐	☹		
	DNMG150412-MP5	15,5	1,2	0,20–0,40	1,0–5,0		☺	☺	😐	☹		
	DNMG150604-MP5	15,5	0,4	0,16–0,25	0,5–4,0			☺	😐	☹		
	DNMG150608-MP5	15,5	0,8	0,18–0,35	0,6–5,0		☺	☺	😐	☹		
	DNMG150612-MP5	15,5	1,2	0,20–0,40	1,0–5,0		☺	☺	😐	☹		
	DNMG150616-MP5	15,5	1,6	0,25–0,45	1,2–5,0			☺	😐			
	DNMG110408-MU5	11,63	0,8	0,18–0,35	0,6–4,0			☺	😐			
	DNMG150408-MU5	15,5	0,8	0,18–0,35	0,6–5,0		☺	☺	😐			
	DNMG150608-MU5	15,5	0,8	0,18–0,35	0,6–5,0		☺	☺	😐			
	DNMG150612-MU5	15,5	1,2	0,20–0,45	1,0–5,0		☺	☺	😐			
	DNMG150616-MU5	15,5	1,6	0,25–0,50	1,2–5,0			☺	😐			
	DNMG110408-RP5	11,63	0,8	0,18–0,35	0,8–4,0			☺	😐	☹		
	DNMG110412-RP5	11,63	1,2	0,20–0,40	1,0–4,0		☺	☺	😐	☹		
	DNMG150408-RP5	15,5	0,8	0,18–0,35	0,8–5,0		☺	☺	😐	☹		
	DNMG150412-RP5	15,5	1,2	0,20–0,40	1,0–5,0			☺	😐	☹		
	DNMG150608-RP5	15,5	0,8	0,15–0,35	0,8–5,0		☺	☺	😐	☹		
	DNMG150612-RP5	15,5	1,2	0,20–0,55	1,0–5,0		☺	☺	😐	☹		
	DNMG150616-RP5	15,5	1,6	0,25–0,65	1,6–5,0		☺	☺	😐	☹		
	DNMM150608-HU3	15,5	0,8	0,25–0,45	0,8–5,0			☺	😐	☹		
	DNMM150612-HU3	15,5	1,2	0,30–0,50	1,2–5,0			☺	😐	☹		
	DNMM150616-HU3	15,5	1,6	0,35–0,60	1,6–5,0		☺	☺	😐			
	DNMM150608-HU5	15,5	0,8	0,25–0,45	1,0–5,0				😐			
	DNMM150612-HU5	15,5	1,2	0,30–0,50	1,5–5,0				😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: DNMG110404-FW5 WKP01G

HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Negative round
RNMG
Tiger·tec® Gold



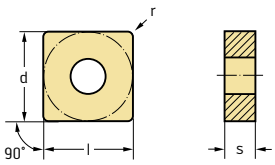
Indexable inserts

	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
Ordering example for the WPP20G grade: RNMG120400-RP5 WPP20G

HC = Coated carbide

Negative square
SNMG / SNMM
Tiger·tec® Gold



Indexable inserts

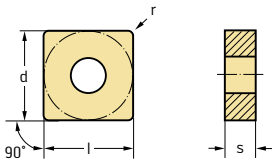
	Designation	r mm	f mm	a_p mm	P HC WPP05G	WPP10G	WPP20G	WPP30G
	SNMG090308-FP5	0,8	0,06–0,20	0,2–1,5		😊	😐	
	SNMG120404-FP5	0,4	0,04–0,22	0,1–1,8		😊	😐	
	SNMG120408-FP5	0,8	0,08–0,25	0,2–2,0		😊	😐	
	SNMG120412-FP5	1,2	0,10–0,25	0,5–2,5			😐	
	SNMG090308-MP3	0,8	0,10–0,32	0,6–3,0		😊	😐	
	SNMG120404-MP3	0,4	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
Ordering example for the WPP10G grade: SNMG090308-FP5 WPP10G

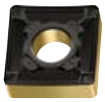
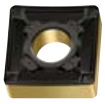
HC = Coated carbide

WALTER SELECT Optimum indexable insert for ➔ Good = 😊 ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Negative square
SNMG / SNMM
Tiger·tec® Gold



Indexable inserts

	Designation	r mm	f mm	a_p mm	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC 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
Ordering example for the WPP10G grade: SNMG090308-FP5 WPP10G

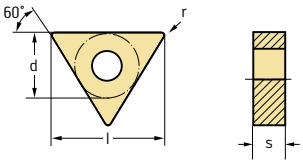
HC = Coated carbide

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

Negative triangular 60°

TNMG / TNMM

Tiger·tec® Gold



Indexable inserts

	Designation	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	TNMG160404-FW5	0,4	0,10–0,40	0,3–3,0			☺	😐			
	TNMG160408-FW5	0,8	0,15–0,50	0,4–3,0			☺	😐			
	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-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				😐			
 Wiper	TNMG160408-MW5	0,8	0,15–0,55	0,8–4,0			☺	😐			
	TNMG160412-MW5	1,2	0,20–0,65	1,5–4,0			☺	😐			
	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			☺	😐	☹		
	TNMG270616-MP5	1,6	0,35–0,55	1,2–7,0				😐			
	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		☺	☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WPP10G grade: TNMG160404-FW5 WPP10G

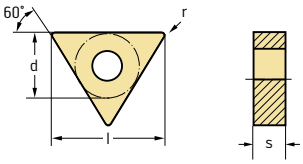
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for ➔ Good = ☺ ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Negative triangular 60°

TNMG / TNMM

Tiger·tec® Gold



Indexable inserts

	Designation	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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				😐	☹		
	TNMG270616-RP7	1,6	0,35–0,75	1,5–9,0				😐			
	TNMG270624-RP7	2,4	0,55–1,00	3,0–9,0				😐			
	TNMM160408-HU3	0,8	0,30–0,45	0,8–6,0				😐			
	TNMM160412-HU3	1,2	0,35–0,50	1,2–6,0			☺	😐			
	TNMM220408-HU3	0,8	0,30–0,50	0,8–7,0				😐	☹		
	TNMM220412-HU3	1,2	0,35–0,60	1,2–7,0				😐			
	TNMM220416-HU3	1,6	0,40–0,80	1,6–7,0			☺	😐			
	TNMM270612-HU3	1,2	0,35–0,65	1,2–8,0				😐			
	TNMM270616-HU7	1,6	0,50–1,10	2,0–13,0				😐	☹		

See the ISO 1832 designation key for dimensions
Ordering example for the WPP10G grade: TNMG160404-FW5 WPP10G

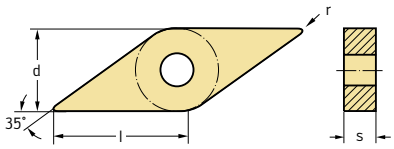
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for ➔ Good = ☺ ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Negative rhombic 35°

VNMG

Tiger·tec® Gold



Indexable inserts

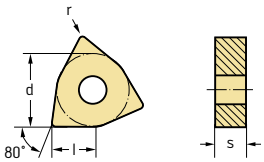
	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	VNMG160404-FP5	16,61	0,4	0,04–0,22	0,1–1,5	☺		☺	😐		☺	☺
	VNMG160408-FP5	16,61	0,8	0,08–0,25	0,2–2,0	☺		☺	😐		☺	☺
	VNMG160412-FP5	16,61	1,2	0,12–0,28	0,3–2,5			☺	😐			
	VNMG160404-MP3	16,61	0,4	0,08–0,22	0,3–2,2			☺	😐			
	VNMG160408-MP3	16,61	0,8	0,12–0,32	0,6–3,0			☺	😐	☹		
	VNMG160412-MP3	16,61	1,2	0,16–0,35	0,8–3,2			☺	😐			
	VNMG160404-MP5	16,61	0,4	0,10–0,18	0,5–2,0			☺	😐	☹		
	VNMG160408-MP5	16,61	0,8	0,18–0,35	0,6–4,0		☺	☺	😐	☹		
	VNMG160412-MP5	16,61	1,2	0,20–0,40	0,8–4,0		☺	☺	😐	☹		
	VNMG220408-MP5	22,14	0,8	0,18–0,35	0,6–4,0			☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WEP10C grade: VNMG160404-FP5 WEP10C

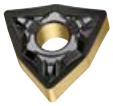
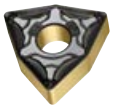
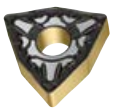
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Negative Trigon 80°
WNMG / WNMM
Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	WNMG060404-FW5	6,52	0,4	0,10–0,35	0,3–2,0	☺		☺	😐			☺
	WNMG060408-FW5	6,52	0,8	0,15–0,50	0,4–2,0			☺	😐			
	WNMG080404-FW5	8,69	0,4	0,10–0,40	0,3–3,0	☺		☺	😐			☺
	WNMG080408-FW5	8,69	0,8	0,15–0,60	0,4–3,0	☺		☺	😐			☺
	WNMG080412-FW5	8,69	1,2	0,25–0,65	0,6–3,0	☺		☺	😐			☺
	WNMG060404-FP5	6,52	0,4	0,04–0,20	0,1–1,5			☺	😐			
	WNMG060408-FP5	6,52	0,8	0,08–0,25	0,2–2,0	☺		☺	😐			☺
	WNMG080404-FP5	8,69	0,4	0,05–0,20	0,1–1,5	☺		☺	😐		☺	☺
	WNMG080408-FP5	8,69	0,8	0,08–0,25	0,2–2,0	☺		☺	😐		☺	☺
	WNMG080412-FP5	8,69	1,2	0,10–0,25	0,5–2,5			☺	😐			
 Wiper	WNMG060408-MW5	6,52	0,8	0,15–0,50	0,8–3,0			☺	😐			
	WNMG060412-MW5	6,52	1,2	0,20–0,60	1,5–3,0			☺	😐			
	WNMG080408-MW5	8,69	0,8	0,20–0,65	0,8–4,0		☺	☺	😐			
	WNMG080412-MW5	8,69	1,2	0,25–0,70	1,5–4,0		☺	☺	😐			
	WNMG080408-MS3	8,69	0,8	0,15–0,30	0,8–3,0				😐			
	WNMG060404-MP3	6,52	0,4	0,08–0,22	0,3–2,2			☺	😐			
	WNMG060408-MP3	6,52	0,8	0,12–0,32	0,6–3,0			☺	😐			
	WNMG060412-MP3	6,52	1,2	0,16–0,35	0,8–3,2				😐			
	WNMG080404-MP3	8,69	0,4	0,08–0,22	0,3–2,5				😐	☹		
	WNMG080408-MP3	8,69	0,8	0,12–0,32	0,6–3,2		☺	☺	😐	☹		
	WNMG080412-MP3	8,69	1,2	0,16–0,40	0,8–3,5		☺	☺	😐	☹		
	WNMG060404-MP5	6,52	0,4	0,16–0,25	0,5–4,0			☺	😐	☹		
	WNMG060408-MP5	6,52	0,8	0,18–0,35	0,6–4,0		☺	☺	😐	☹		
	WNMG060412-MP5	6,52	1,2	0,20–0,40	1,0–4,0			☺	😐			
	WNMG080404-MP5	8,69	0,4	0,16–0,25	0,5–4,0			☺	😐	☹		
	WNMG080408-MP5	8,69	0,8	0,18–0,40	0,6–5,0		☺	☺	😐	☹		
	WNMG080412-MP5	8,69	1,2	0,20–0,45	1,0–5,0		☺	☺	😐	☹		
	WNMG080416-MP5	8,69	1,6	0,25–0,50	1,2–5,0			☺	😐			
	WNMG100608-MP5	10,86	0,8	0,25–0,40	0,8–7,0			☺	😐			
	WNMG100612-MP5	10,86	1,2	0,30–0,50	1,0–7,0			☺	😐			
	WNMG060408-MU5	6,52	0,8	0,15–0,35	0,6–3,0			☺	😐			
	WNMG080404-MU5	8,69	0,4	0,15–0,30	0,5–4,0			☺	😐			
	WNMG080408-MU5	8,69	0,8	0,15–0,40	0,6–5,0		☺	☺	😐			
	WNMG080412-MU5	8,69	1,2	0,20–0,50	1,0–5,0		☺	☺	😐			
	WNMG080416-MU5	8,69	1,6	0,25–0,55	1,2–5,0		☺	☺	😐			
	WNMG080408-RM5	8,69	0,8	0,20–0,40	1,2–4,5			☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: WNMG060404-FW5 WKP01G

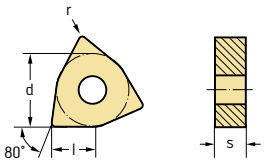
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Negative Trigon 80°

WNMG / WNMM

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP05G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	WNMG060408-RP5	6,52	0,8	0,20–0,40	0,8–4,0			☺	😐	☹		
	WNMG060412-RP5	6,52	1,2	0,25–0,50	1,0–4,0			☺	😐	☹		
	WNMG080408-RP5	8,69	0,8	0,20–0,40	0,8–6,0		☺	☺	😐	☹		
	WNMG080412-RP5	8,69	1,2	0,25–0,60	1,0–6,0		☺	☺	😐	☹		
	WNMG080416-RP5	8,69	1,6	0,35–0,70	1,6–6,0		☺	☺	😐	☹		
	WNMG100612-RP5	10,86	1,2	0,35–0,65	1,2–8,0			☺	😐	☹		
	WNMG100616-RP5	10,86	1,6	0,35–0,70	1,6–8,0			☺	😐	☹		
	WNMG080408-RP7	8,69	0,8	0,18–0,40	0,8–5,0			☺	😐	☹		
	WNMG080412-RP7	8,69	1,2	0,25–0,50	1,2–5,0			☺	😐	☹		
	WNMG100608-RP7	10,86	0,8	0,30–0,50	0,8–6,0				😐			
	WNMG100612-RP7	10,86	1,2	0,35–0,60	1,2–6,0			☺	😐	☹		
	WNMG100616-RP7	10,86	1,6	0,40–0,60	1,5–6,0				😐	☹		
	WNMM080412-HU3	8,69	1,2	0,35–0,60	1,2–6,0				😐			
	WNMM100612-HU3	10,86	1,2	0,35–0,70	1,2–8,0			☺	😐			
	WNMM100616-HU3	10,86	1,6	0,40–0,90	1,6–8,0			☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WKP01G grade: WNMG060404-FW5 WKP01G

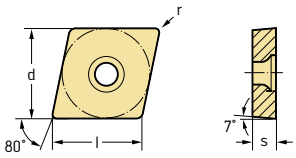
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

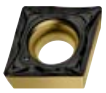
Positive rhombic 80°

CCMT / CCGT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	CCMT060202-FW4	6,45	0,2	0,03–0,15	0,1–1,5			😐			
	CCMT060204-FW4	6,45	0,4	0,05–0,30	0,2–2,0	😊	😊	😐			😊
	CCMT060208-FW4	6,45	0,8	0,09–0,35	0,3–2,0	😊	😊	😐			😊
	CCMT09T302-FW4	9,67	0,2	0,03–0,15	0,1–2,0			😐			
	CCMT09T304-FW4	9,67	0,4	0,07–0,30	0,2–2,5	😊	😊	😐			😊
	CCMT09T308-FW4	9,67	0,8	0,12–0,50	0,3–2,5	😊	😊	😐			😊
	CCGT060202-FL2	6,45	0,2	0,04–0,10	0,1–1,0			😐			
	CCGT060204-FL2	6,45	0,4	0,06–0,15	0,2–1,5			😐	☹		
	CCGT09T302-FL2	9,67	0,2	0,04–0,10	0,1–1,0			😐			
	CCGT09T304-FL2	9,67	0,4	0,06–0,15	0,2–1,5			😐	☹		
	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					😊	
	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			😐			
 Wiper	CCMT09T304-MW4	9,67	0,4	0,12–0,40	0,5–4,0		😊	😐			
	CCMT09T308-MW4	9,67	0,8	0,15–0,50	0,7–4,0		😊	😐			
	CCMT09T312-MW4	9,67	1,2	0,17–0,55	0,8–4,0			😐			
	CCMT120404-MW4	12,9	0,4	0,12–0,40	0,5–4,5			😐			
	CCMT120408-MW4	12,9	0,8	0,17–0,55	0,7–4,5		😊	😐			
	CCMT120412-MW4	12,9	1,2	0,17–0,55	0,8–4,5			😐			
	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		😊	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WPP20G grade: CCMT060202-FW4 WPP20G

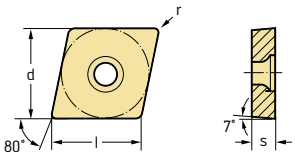
HC = Coated carbide
HE = Coated cermet

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

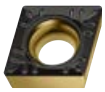
Positive rhombic 80°

CCMT / CCGT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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		😊	😐			
	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
Ordering example for the WPP20G grade: CCMT060202-FW4 WPP20G

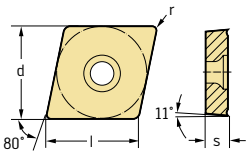
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = 😊 → Average = 😐 → Poor = 😟 machining conditions

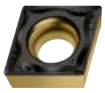
Positive rhombic 80°

CPGT / CPMT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G	P HE 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			☺
	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		😐	
	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	☺	😐	

See the ISO 1832 designation key for dimensions
Ordering example for the WEP10C grade: CPGT050202M-FP2 WEP10C

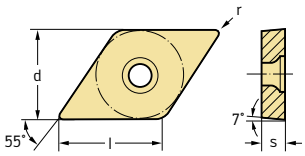
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Positive rhombic 55°

DCMT / DCGT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
Wiper	DCMT070202-FW4	7,75	0,2	0,03–0,15	0,1–1,5			😐			
	DCMT070204-FW4	7,75	0,4	0,05–0,25	0,2–2,0	😊	😊	😐			😊
	DCMT070208-FW4	7,75	0,8	0,09–0,35	0,3–2,0		😊	😐			
	DCMT11T302-FW4	11,63	0,2	0,03–0,15	0,1–2,0			😐			
	DCMT11T304-FW4	11,63	0,4	0,07–0,30	0,2–2,5	😊	😊	😐			😊
	DCMT11T308-FW4	11,63	0,8	0,12–0,40	0,3–2,5	😊	😊	😐			😊
	DCGT11T304-FL2	11,63	0,4	0,06–0,15	0,2–1,5			😐			
	DCGT11T308-FL2	11,63	0,8	0,08–0,20	0,3–1,5			😐			
	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					😊	
	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		😊	😐			
Wiper	DCMT11T304-MW4	11,63	0,4	0,12–0,40	0,5–4,0		😊	😐			
	DCMT11T308-MW4	11,63	0,8	0,15–0,50	0,5–4,0		😊	😐			
	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		😊	😐			
	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		😊	😐			
	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
Ordering example for the WPP20G grade: DCMT070202-FW4 WPP20G

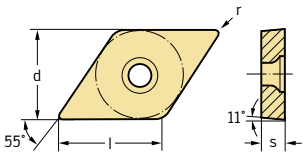
HC = Coated carbide
HE = Coated cermet

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

Positive rhombic 55°

DPMT / DPGT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G
	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		😐
	DPGT11T304-MP4	11,63	0,4	0,08–0,25	0,4–3,0		😐

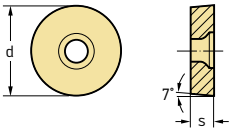
See the ISO 1832 designation key for dimensions
Ordering example for the WPP10G grade: DPMT070204-FP4 WPP10G

HC = Coated carbide

Positive round

RCMT / RCMX

Tiger·tec® Gold



Indexable inserts

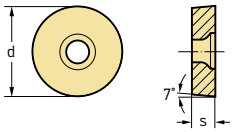
	Designation	d mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G	P HC WPP30G
	RCMT0602M0-FP4	6	0,07–0,30	0,6–2,5	☺	😐	
	RCMT0803M0-FP4	8	0,08–0,30	0,8–3,0		😐	
	RCMT10T3M0-FP4	10	0,10–0,35	1,0–4,0		😐	
	RCMT1204M0-FP4	12	0,12–0,40	1,2–5,0	☺	😐	
	RCMT0602M0-RP4	6	0,08–0,50	0,6–2,5		😐	☹
	RCMT060300-RP4	6,35	0,08–0,50	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
Ordering example for the WPP10G grade: RCMT0602M0-FP4 WPP10G

HC = Coated carbide

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Positive round
RCMT / RCMX
Tiger·tec® Gold



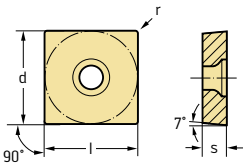
Indexable inserts

	Designation	d mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G	P HC WPP30G
	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	☺	😐	☹
	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
Ordering example for the WPP10G grade: RCMT0602M0-FP4 WPP10G

HC = Coated carbide

Positive square
SCMT / SCGT
Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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		☺	😐			

See the ISO 1832 designation key for dimensions
Ordering example for the WPP10G grade: SCMT060204-FP4 WPP10G

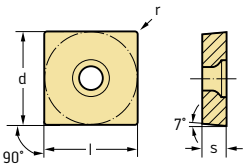
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for ➔ Good = ☺ ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Positive square

SCMT / SCGT

Tiger·tec® Gold



Indexable inserts

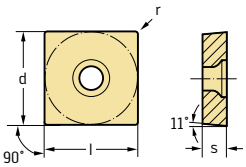
	Designation	l mm	r mm	f mm	a_p mm	P					K
							HC			HE	HC
						WKP01G	WPP10G	WPP20G	WPP30G	WEP10C	WKP01G
	SCGT09T304-MP4	9,53	0,4	0,08–0,25	0,4–3,0			😐			
	SCGT09T308-MP4	9,53	0,8	0,12–0,32	0,5–3,0			😐			
	SCGT120408-MP4	12,7	0,8	0,12–0,32	0,5–3,5			😐			
	SCMT09T304-RP4	9,53	0,4	0,12–0,25	0,4–3,0		😊	😐	☹		
	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
Ordering example for the WPP10G grade: SCMT060204-FP4 WPP10G

HC = Coated carbide
HE = Coated cermet

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

Positive square
SPMT
Tiger·tec® Gold



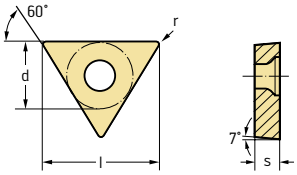
Indexable inserts

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

See the ISO 1832 designation key for dimensions
Ordering example for the WPP20G grade: SPMT09T304-MP4 WPP20G

HC = Coated carbide

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



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
 Wiper	TCMT090202-FW4	9,62	0,2	0,03–0,15	0,1–1,5			☺			
	TCMT090204-FW4	9,62	0,4	0,05–0,30	0,2–2,0		☺	☺			
	TCMT110204-FW4	11	0,4	0,07–0,30	0,2–2,5		☺	☺			
	TCMT110208-FW4	11	0,8	0,12–0,40	0,3–2,5		☺	☺			
	TCMT16T304-FW4	16,5	0,4	0,07–0,35	0,2–2,5		☺	☺			
	TCMT16T308-FW4	16,5	0,8	0,12–0,50	0,3–2,5		☺	☺			
	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					☺	

See the ISO 1832 designation key for dimensions
Ordering example for the WPP20G grade: TCMT090202-FW4 WPP20G

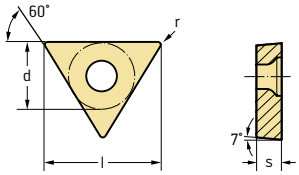
HC = Coated carbide
HE = Coated cermet

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Positive triangular 60°

TCMT / TCGT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	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			😐			
 Wiper	TCMT16T304-MW4	16,5	0,4	0,12–0,40	0,5–4,0			😐			
	TCMT16T308-MW4	16,5	0,8	0,15–0,50	0,5–4,0			😐			
	TCMT090204-MP4	9,62	0,4	0,08–0,20	0,4–2,0			😐			
	TCMT090208-MP4	9,62	0,8	0,12–0,25	0,5–2,0			😐			
	TCMT110204-MP4	11	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			😐			
	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			😐			
	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
Ordering example for the WPP20G grade: TCMT090202-FW4 WPP20G

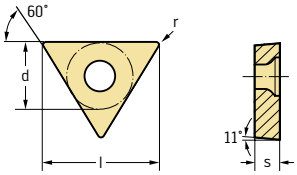
HC = Coated carbide
HE = Coated cermet

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

Positive triangular 60°

TPMT / TPGT / TPMR / TPGN

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G
	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		😐
	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		😐
	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		😐

See the ISO 1832 designation key for dimensions
Ordering example for the WPP10G grade: TPMT110204-FP4 WPP10G

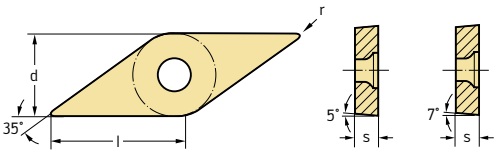
HC = Coated carbide

WALTER SELECT Optimum indexable insert for ➔ Good = ☺ ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Positive rhombic 35°

VBGT / VCGT / VCMT / VBMT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	P HC WPP30G	P HE WEP10C	K HC WKP01G
	VBGT110302-FL2	11,07	0,2	0,04–0,10	0,1–1,0			😐			
	VBGT110304-FL2	11,07	0,4	0,06–0,15	0,2–1,5			😐			
	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	😊	😊	😐		😊	😊
	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		😊	😐			
	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		😊	😐			
	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		😊	😐			
	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
Ordering example for the WPP20G grade: VBGT110302-FL2 WPP20G

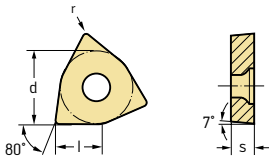
HC = Coated carbide
HE = Coated cermet

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

Positive Trigon 80°

WCMT

Tiger·tec® Gold



Indexable inserts

	Designation	l mm	r mm	f mm	a_p mm	P HC WPP10G	P HC WPP20G	P HC WPP30G
	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

Ordering example for the WPP10G grade: WCMT040202-FP4 WPP10G

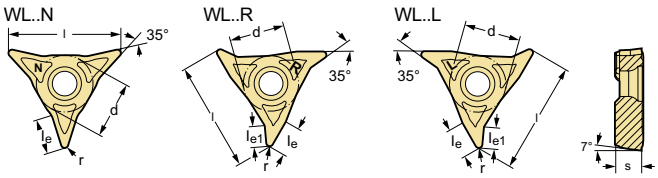
HC = Coated carbide

WALTER SELECT Optimum indexable insert for → Good = ☺ → Average = 😐 → Poor = ☹ machining conditions

Indexable inserts for copy turning system

WL...-VC...

Tiger·tec® Gold



Indexable inserts

	Designation	r mm	l mm	l_e mm	l_{e1} mm	f mm	a_p mm	P HC WKP01G	P HC WPP10G	P HC WPP20G	K HC WKP01G
	WL17-VC0504N-FP4	0,4	17	5		0,05–0,20	0,1–1,8			😐	
	WL17-VC0508N-FP4	0,8	17	5,7		0,08–0,25	0,2–1,8			😐	
	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-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-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	😊	😊	😐	😊
	WL17-VC0504N-MP4	0,4	17	5		0,05–0,20	0,1–1,8			😐	
	WL17-VC0508N-MP4	0,8	17	5,7		0,12–0,30	0,5–2,0			😐	
	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-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		😊	😐	
	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		😊	😐	

Ordering example for the WPP20G grade: WL17-VC0504N-FP4 WPP20G

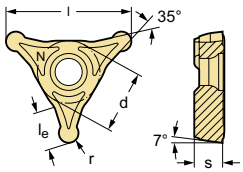
HC = Coated carbide

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

Indexable inserts for copy turning system

WL...-RC...

Tiger·tec® Gold



Indexable 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	😐

Ordering example for the WPP20G grade: WL25-RC0420N-MU6 WPP20G

HC = Coated carbide

WALTER SELECT Optimum indexable insert for ➔ Good = 😊 ➔ Average = 😐 ➔ Poor = ☹ machining conditions

Cutting tool material application charts – Turning

Carbide

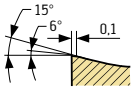
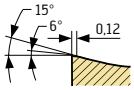
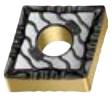
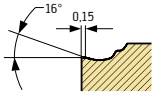
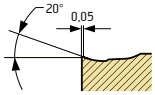
Walter grade designation	Standard designation	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Application range 01 05 10 15 20 25 30 35 40 45	Coating process	Coating composition	Indexable insert example
WKP01G	HC – P 01	●●								CVD	TiCN + Al_2O_3 (+ TiN)	
	HC – K 01			●●								
WPP05G	HC – P 05	●●								CVD	TiCN + Al_2O_3 (+ TiN)	
	HC – K 05			●								
WPP10G	HC – P 10	●●								CVD	TiCN + Al_2O_3 (+ TiN)	
	HC – K 20			●								
WPP20G	HC – P 20	●●								CVD	TiCN + Al_2O_3 (+ TiN)	
	HC – K 30			●								
WPP30G	HC – P 30	●●								CVD	TiCN + Al_2O_3 (+ TiN)	
	HC – M 20		●									
	HC – K 40			●								

HC = Coated carbide

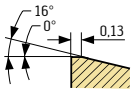
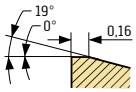
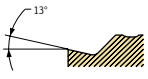
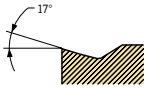
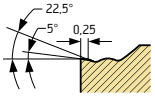
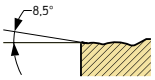
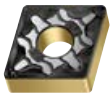
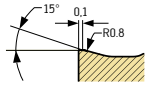
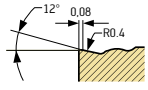
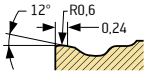
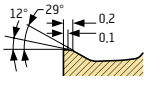
●● Primary application
● Additional application

Geometry overview of turning inserts – Negative basic shape

Finishing operation

Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
 Wiper	**FW5** – 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

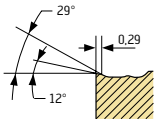
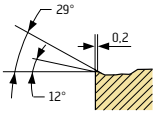
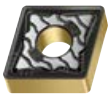
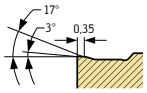
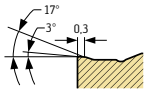
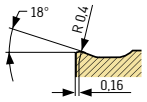
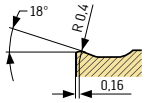
Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
 Wiper	**MW5** – Medium machining with wiper technology – Double the feed rate – the same high surface quality – Maximum feeds thanks to long radiused wiper 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

Remark: Sectional views show CNMG120408 . .

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

Roughing operation – Double-sided indexable inserts

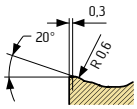
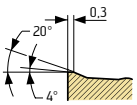
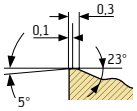
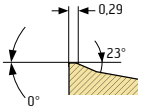
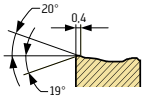
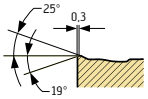
Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
	**RM5** – Roughing operations in stainless materials and high-temperature 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

Remark: Sectional views show CNMG120408 . .

Geometry overview of turning inserts – Negative basic shape

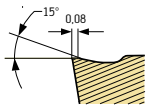
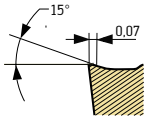
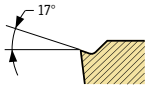
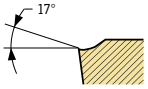
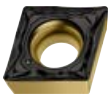
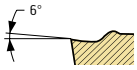
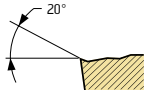
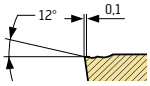
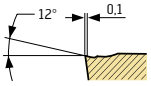
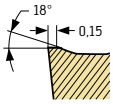
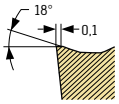
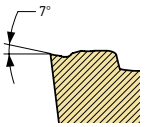
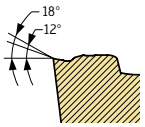
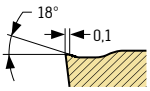
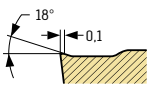
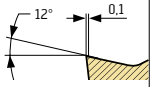
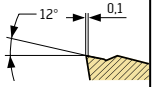
Roughing operation – Single-sided indexable inserts

Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
	**HU3** – Single-sided roughing geometry, for universal application – Curved cutting edge for low cutting forces – V-shaped chip former 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

Remark: Sectional views show SNMM190616 . .

Geometry overview of turning inserts – Positive basic shape

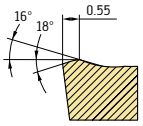
Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
Finishing operation												
	**FW4** – Finishing with wiper technology – Double the feed rate – the same high surface quality – Reduced cutting pressure thanks to short radiused wiper cutting edge	●●	●●	●●		●					0,1–2,5	0,03–0,50
	**FL2** – Finishing insert with fully ground circumference for long-chipping materials – Can also be used for precision boring – Extremely narrow chip breaker groove	●●	●●	●		●					0,10–1,5	0,04–0,20
	**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												
	**MW4** – Medium machining with wiper technology – Double the feed rate – the same high surface quality – Maximum feeds thanks to long radiused wiper cutting edge	●●	●	●●		●					0,5–4,0	0,12–0,60
	**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

●● Primary application
● Additional application

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

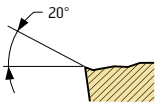
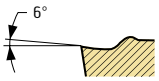
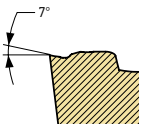
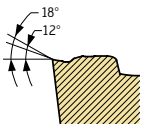
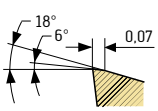
Geometry overview of turning inserts – Positive basic shape

Heavy machining

Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
	**HU6** – Heavy-duty roughing – Excellent chip breaking – Machining of forged parts – For use in train wheel machining	●●		●●							1,0–15,0	0,12–1,7

Geometry overview of system inserts – WL

Finishing and medium machining

Geometry	Remarks/application area	Material groups P Steel	M Stainless steel	K Cast iron	N NF metals	S Materials with difficult cutting properties	H Hard materials	O Other	Main cutting edge section	Corner radius section	a_p [mm]	f [mm]
	**FP4** – Finishing geometry 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

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

Cutting data for turning inserts – Negative basic shape Carbide grades

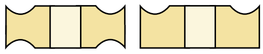
= Cutting data for wet machining
= Dry machining is possible

Material group	Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R_m N/mm²	Machining group [1]			Cutting material grades		
									Starting values for cutting speed v_c [m/min]		
									HE		
									WEP10C		
									f [mm/rev]		
									0,10	0,20	0,30
P	Non-alloyed steel	C ≤ 0,25 %	Annealed	125	430	P1	●●	●	490	440	400
		C > 0,25... ≤ 0,55 %	Annealed	190	640	P2	●●	●	390	360	320
		C > 0,25... ≤ 0,55 %	Heat-treated	210	710	P3	●●	●	290	260	250
		C > 0,55 %	Annealed	190	640	P4	●●	●	350	330	310
		C > 0,55 %	Heat-treated	300	1010	P5	●●	●	220	180	150
		Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	450	420	400
	Low-alloy steel	Annealed		175	590	P7	●●	●	360	330	320
		Heat-treated		285	960	P8	●●	●	200	170	160
		Heat-treated		380	1280	P9	●●	●	120	100	90
		Heat-treated		430	1480	P10	●●	●			
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11	●●	●	340	310	300
		Hardened and tempered		300	1010	P12	●●	●	200	180	160
		Hardened and tempered		380	1280	P13	●●	●	70	60	
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	●●	●	280	250	230
		Martensitic, heat-treated		330	1110	P15	●●	●	120	100	90
M	Stainless steel	Austenitic, quench hardened		200	680	M1	●●	●	210	190	160
		Austenitic, precipitation hardened (PH)		300	1010	M2	●●	●	150	130	110
		Austenitic/ferritic, duplex		230	780	M3	●●	●	160	140	110
K	Malleable cast iron	Ferritic		200	400	K1	●●	●	220	200	180
		Pearlitic		260	700	K2	●●	●	190	170	150
	Grey cast iron	Low strength		180	200	K3	●●	●	420	390	360
		High strength/austenitic		245	350	K4	●●	●	220	200	180
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●	●	240	220	200
		Pearlitic		265	700	K6	●●	●	170	140	130
	CGI			230	400	K7	●●	●	220	180	170
N	Wrought aluminium alloys	Not hardenable		30	–	N1					
		Hardenable, hardened		100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3					
		≤ 12% Si, hardenable, hardened		90	310	N4					
		> 12% Si, not hardenable		130	450	N5					
	Magnesium-based alloys			70	250	N6					
	Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper		100	340	N7					
		Brass, bronze, red brass		90	310	N8					
		Copper alloys, short-chipping		110	380	N9					
		High tensile, Ampco		300	1010	N10					
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1					
			Hardened	280	940	S2					
		Ni- or Co-based	Annealed	250	840	S3					
			Hardened	350	1180	S4					
			Cast	320	1080	S5					
	Titanium alloys	Pure titanium		200	680	S6					
		α and β alloys, hardened		375	1260	S7					
		β alloys		410	1400	S8					
	Tungsten alloys			300	1010	S9					
	Molybdenum alloys			300	1010	S10					
H	Hardened steel	Hardened and tempered		50 HRC		H1					
		Hardened and tempered		55 HRC		H2					
		Hardened and tempered		60 HRC		H3					
	Hardened cast iron	Hardened and tempered		55 HRC		H4					
O	Thermoplastics	Without abrasive fillers				O1					
	Thermosetting plastics	Without abrasive fillers				O2					
	Plastic, glass-fibre reinforced	GFRP				O3					
	Plastic, carbon-fibre reinforced	CFRP				O4					
	Plastic, aramid-fibre reinforced	AFRP				O5					
	Graphite (technical)			80 Shore		O6					

●● Recommended application (the specified cutting data 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.

[1] The assignment of the machining groups can be found in Technical Compendium F – General Information.



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

	Cutting material grades														
	Starting values for cutting speed v_c [m/min]														
	HC														
	WKP01G			WPP05G			WPP10G			WPP20G			WPP30G		
	f [mm/rev]			f [mm/rev]			f [mm/rev]			f [mm/rev]			f [mm/rev]		
	0,10	0,20	0,40	0,10	0,40	0,60	0,10	0,40	0,60	0,10	0,40	0,60	0,10	0,40	0,60
	560	500	420	560	420	330	530	400	310	450	330	270	380	260	220
	440	390	320	440	320	250	420	300	240	350	250	190	300	200	160
	340	300	260	340	260	220	320	250	210	260	210	170	220	180	130
	370	320	260	370	260	210	350	250	200	300	210	160	250	160	130
	280	250	210	280	210	200	270	200	190	220	160	150	180	120	100
	510	450	370	510	370	290	490	350	280	410	290	220	350	230	180
	400	360	290	400	290	250	380	280	240	320	240	190	260	190	170
	240	220	190	240	190	170	230	180	160	190	140	120	150	100	80
	190	170	150	190	150	110	180	140	100	140	100	80	100	70	50
	130	120	110	130	110		120	100							
	360	310	250	360	250	170	340	240	160	290	200	120	220	160	90
	250	210	150	250	150	130	240	140	120	190	120	90	120	90	70
	130	120	110	130	110		120	100							
	290	270	230	290	230	210	280	220	200	230	190	150	180	150	110
	210	180	150	210	150	130	200	140	120	160	110	80	120	80	70
													260	210	130
													160	140	
													170	150	110
	320	270	210	320	210	160	300	200	150	270	170	130	240	160	130
	270	230	170	270	170	120	260	160	110	230	140	100	200	120	90
	600	520	400	600	400	290	570	380	280	490	350	240	490	300	210
	320	270	220	320	220	150	300	210	140	270	170	130	230	170	110
	340	300	240	340	240	180	320	230	170	290	200	150	250	180	130
	240	210	180	240	180	150	230	170	140	200	150	120	180	130	110
	320	260	200	320	200										

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

Cutting data for turning inserts – Positive basic shape Carbide grades

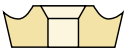
= Cutting data for wet machining
= Dry machining is possible

Material group	Overview of the main material groups and code letters			Brinell hardness HB	Tensile strength R_m N/mm²	Machining group [1]			Cutting material grades		
									Starting values for cutting speed v_c [m/min]		
									HE		
									WEP10C		
									f [mm/rev]		
									0,10	0,20	0,30
P	Non-alloyed steel	C ≤ 0,25 %	Annealed	125	430	P1	●●	●	490	440	400
		C > 0,25... ≤ 0,55 %	Annealed	190	640	P2	●●	●	390	360	320
		C > 0,25... ≤ 0,55 %	Heat-treated	210	710	P3	●●	●	290	260	250
		C > 0,55 %	Annealed	190	640	P4	●●	●	350	330	310
		C > 0,55 %	Heat-treated	300	1010	P5	●●	●	220	180	150
		Free-machining steel (short-chipping)	Annealed	220	750	P6	●●	●	450	420	400
	Low-alloy steel	Annealed		175	590	P7	●●	●	360	330	320
		Heat-treated		285	960	P8	●●	●	200	170	160
		Heat-treated		380	1280	P9	●●	●	120	100	90
		Heat-treated		430	1480	P10	●●	●			
	High-alloy steel and high-alloy tool steel	Annealed		200	680	P11	●●	●	340	310	300
		Hardened and tempered		300	1010	P12	●●	●	200	180	160
		Hardened and tempered		380	1280	P13	●●	●	70	60	
	Stainless steel	Ferritic/martensitic, annealed		200	680	P14	●●	●	280	250	230
		Martensitic, heat-treated		330	1110	P15	●●	●	120	100	90
M	Stainless steel	Austenitic, quench hardened		200	680	M1	●●	●	210	190	160
		Austenitic, precipitation hardened (PH)		300	1010	M2	●●	●	150	130	110
		Austenitic/ferritic, duplex		230	780	M3	●●	●	160	140	110
K	Malleable cast iron	Ferritic		200	400	K1	●●	●	220	200	180
		Pearlitic		260	700	K2	●●	●	190	170	150
	Grey cast iron	Low strength		180	200	K3	●●	●	420	390	360
		High strength/austenitic		245	350	K4	●●	●	220	200	180
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	●●	●	240	220	200
		Pearlitic		265	700	K6	●●	●	170	140	130
	CGI			230	400	K7	●●	●	220	180	170
N	Wrought aluminium alloys	Not hardenable		30	–	N1					
		Hardenable, hardened		100	340	N2					
	Cast aluminium alloys	≤ 12% Si, not hardenable		75	260	N3					
		≤ 12% Si, hardenable, hardened		90	310	N4					
		> 12% Si, not hardenable		130	450	N5					
	Magnesium-based alloys			70	250	N6					
	Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper		100	340	N7					
		Brass, bronze, red brass		90	310	N8					
		Copper alloys, short-chipping		110	380	N9					
		High tensile, Ampco		300	1010	N10					
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1					
			Hardened	280	940	S2					
		Ni- or Co-based	Annealed	250	840	S3					
			Hardened	350	1180	S4					
			Cast	320	1080	S5					
	Titanium alloys	Pure titanium		200	680	S6					
		α and β alloys, hardened		375	1260	S7					
		β alloys		410	1400	S8					
	Tungsten alloys			300	1010	S9					
	Molybdenum alloys			300	1010	S10					
H	Hardened steel	Hardened and tempered		50 HRC	–	H1					
		Hardened and tempered		55 HRC	–	H2					
		Hardened and tempered		60 HRC	–	H3					
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4					
O	Thermoplastics	Without abrasive fillers				O1					
	Thermosetting plastics	Without abrasive fillers				O2					
	Plastic, glass-fibre reinforced	GFRP				O3					
	Plastic, carbon-fibre reinforced	CFRP				O4					
	Plastic, aramid-fibre reinforced	AFRP				O5					
	Graphite (technical)			80 Shore		O6					

●● Recommended application (the specified cutting data 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.

[1] The assignment of the machining groups can be found in Technical Compendium F – General Information.



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

	Cutting material grades											
	Starting values for cutting speed v_c [m/min]											
	HC											
	WKP01G			WPP10G			WPP20G			WPP30G		
	f [mm/rev]			f [mm/rev]			f [mm/rev]			f [mm/rev]		
	0,10	0,20	0,30	0,10	0,20	0,40	0,10	0,20	0,40	0,10	0,20	0,40
	500	450	400	480	430	350	400	360	290	330	300	240
	390	350	310	370	330	270	310	280	220	260	230	180
	290	270	250	280	260	220	230	210	180	200	180	150
	330	290	250	310	280	220	270	230	180	220	190	140
	240	230	210	230	220	190	190	170	150	150	140	110
	460	410	360	440	390	310	370	320	250	310	270	200
	350	320	280	330	300	250	280	260	210	230	210	170
	210	200	180	200	190	160	160	150	120	130	110	90
	160	140	102	150	130	110	120	110	90	90	70	60
	70	60	50	70	60	50						
	330	280	240	310	270	200	270	220	160	200	170	120
	210	190	150	200	180	130	170	140	100	100	90	70
	70	60	60	60	50	50						
	250	240	220	240	230	200	210	190	160	160	150	120
	180	170	150	170	160	130	140	120	90	100	90	70
										240	210	160
										140	130	120
										150	140	120
	280	240	200	270	230	170	240	210	160	210	180	140
	240	200	170	230	190	140	210	170	120	170	150	110
	510	420	400	490	400	350	430	350	310	420	330	280
	280	240	200	270	230	170	240	210	150	210	180	130
	300	260	230	290	250	200	260	230	180	220	200	150
	210	190	170	200	180	150	180	160	130	160	140	110
	250	220	150									

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

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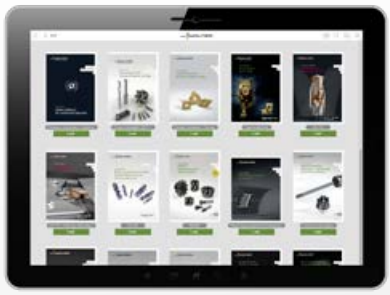

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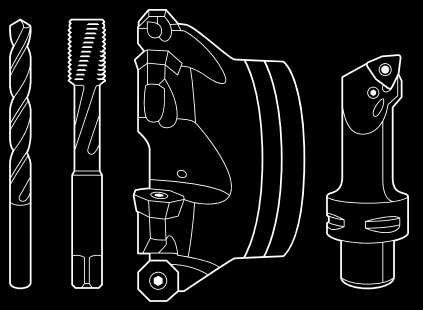

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