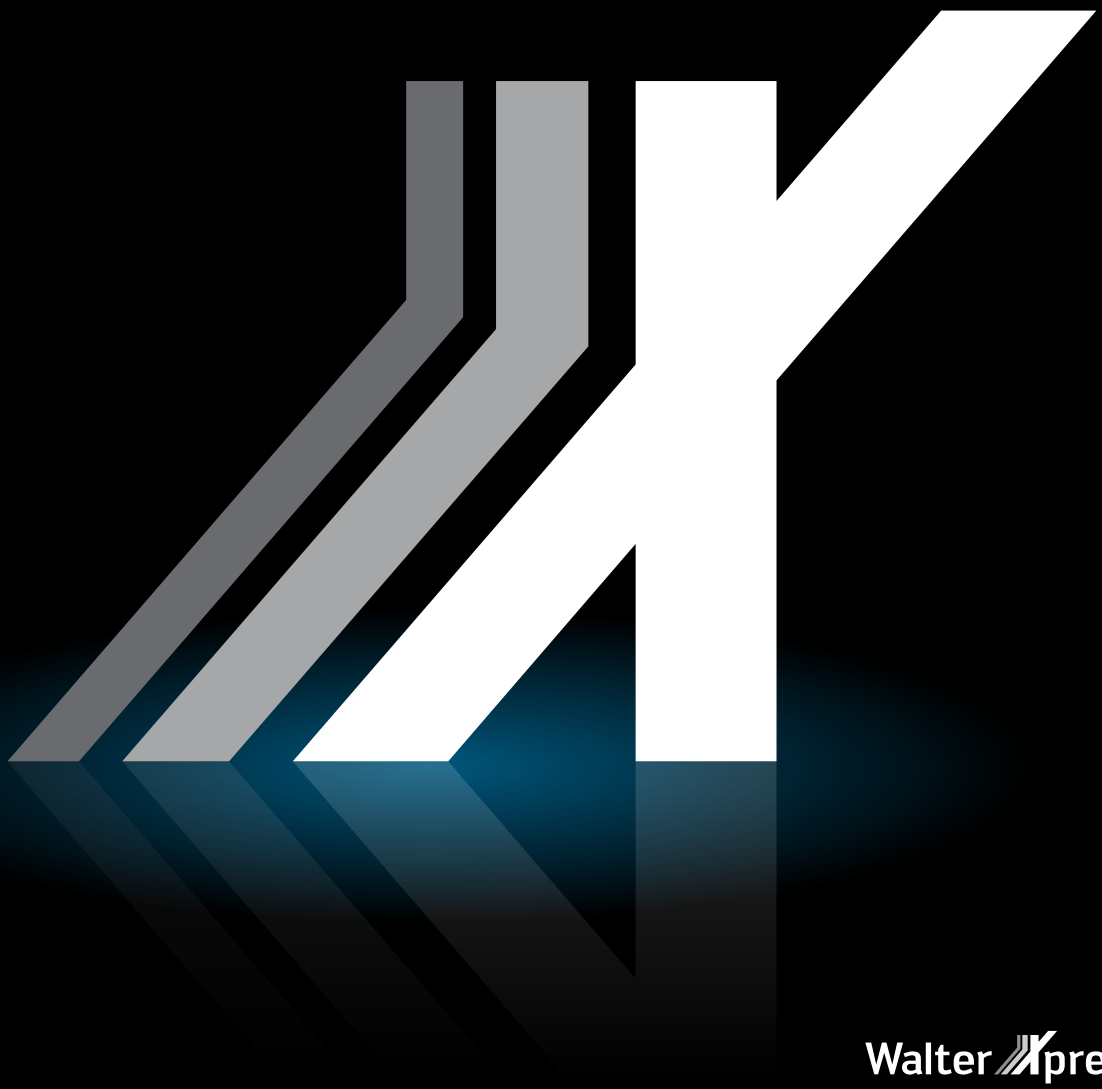
New!
EXTENDED RANGE

Walter Xpress

Edition 2026

_FULL SPEED AHEAD WITH WALTER XPRESS

Invest in savings.



Walter Xpress™

Walter GPS

Your navigation system for the best machining solution.

Find the right tool with a click of the mouse.
In just four clicks, Walter GPS takes you from the definition of your target to the most cost-efficient tool and machining solution. Walter GPS is surprisingly comprehensive. Be it holemaking, threading, turning or milling: Full information on all tools from Walter, Walter Titex and Walter Prototyp can be displayed in an instant. Access essential usage data, such as accurate cutting data or precise cost-efficiency calculations, on your screen.

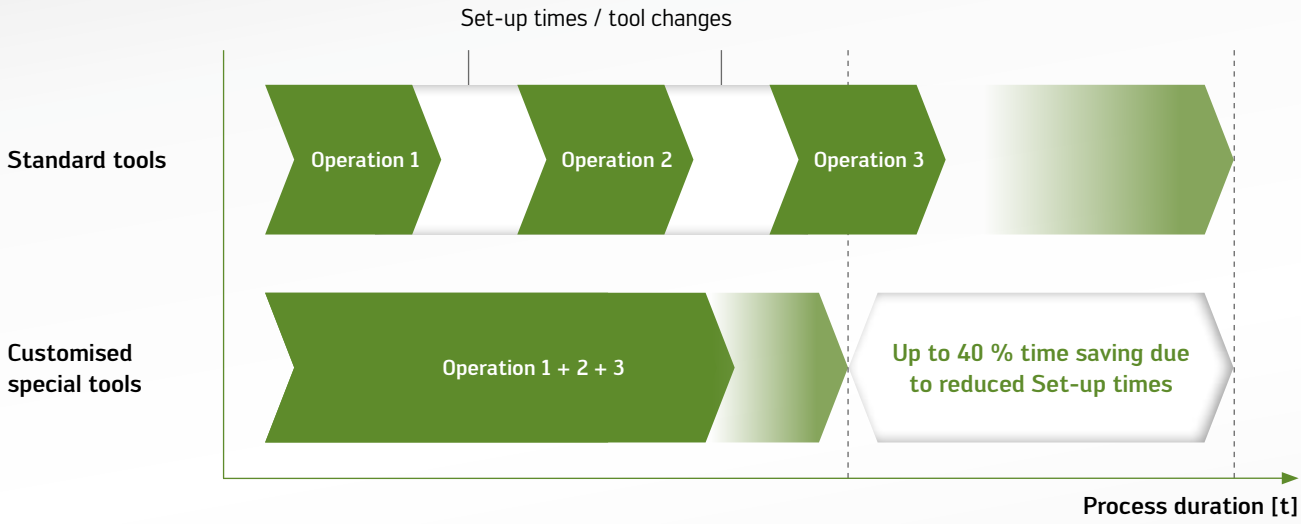
Walter GPS is now also available for smartphones and tablet PCs. This means that you are able to access all the required tool information at any time, wherever you are, even without a PC: In the workshop, at the machine or on the move.

walter-tools.com

WALTER
Engineering Kompetenz

BRING TOGETHER WHAT BELONGS TOGETHER: EFFICIENCY AND ECONOMY.

Customised special tools let you perform multiple operations with a single tool.
This enables you to avoid unproductive tool changes and streamline your entire machining process.



OPTIMISE YOUR PROCESS PRECISELY IN THE AREA WHERE PRODUCTIVITY IS LACKING: DURING SET-UP TIMES

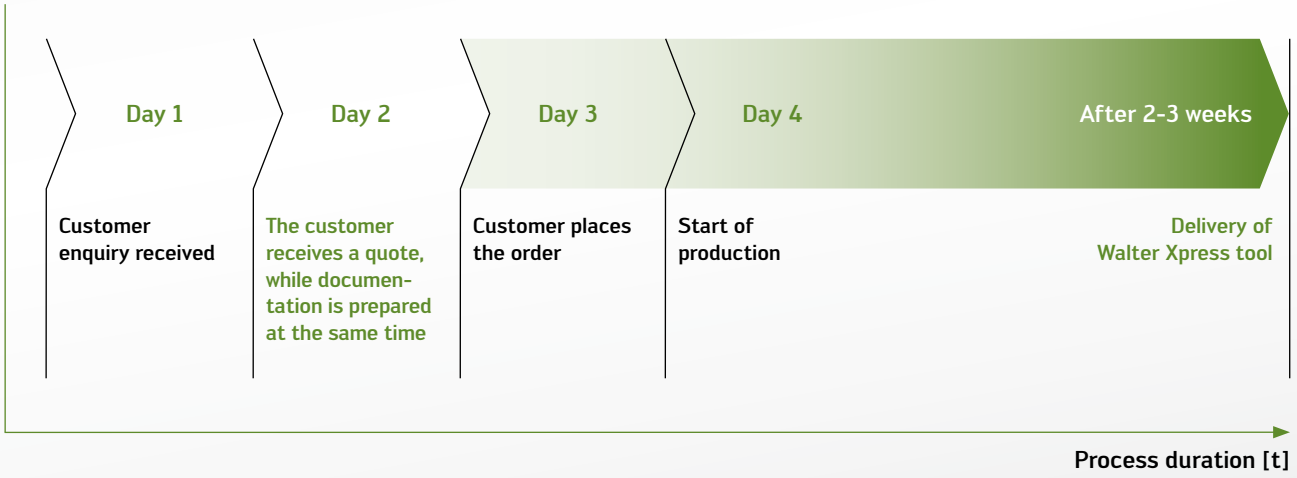
Special tools let you perform multiple machining operations with a single tool
Let's assume you have a particular machining task. Even before you start work, Walter will determine an approach to the solution that will optimise your process. Whereas previously, for example, you needed a solid drill and chamfering tool, you can now work much more efficiently by carrying out both operations using a single tool. This is because both machining operations are combined within the tool. The advantage for you? Your process becomes significantly more streamlined.

More integrated operations means more efficiency
Performing more than one operation with one tool – that is the logical conclusion of our all-encompassing understanding of how processes work. Our objective is to organise your processes in a way that is demonstrably more efficient.

Minimise set-up times and downtime
You too can reduce non-productive time during machining operations. Combining individual steps reduces the number of tool changes and enables simultaneous machining operations. The result: Your productivity increases.

Walter Xpress™

If you place an enquiry concerning a Walter Xpress tool today, you will have all the essential data on your desk by tomorrow.



MAXIMUM DELIVERY TIME OF FOUR WEEKS: FULL SPEED AHEAD WITH WALTER XPRESS

Reduce the number of tools you have in circulation
The name itself says it all. Walter Xpress stands out thanks to extremely short delivery times. For you, this means: Four weeks after placing your order – usually much sooner – you will receive custom-designed tools from the Walter Xpress tool range. This helps keep your tool inventories low and reduces the amount of capital you have tied up.

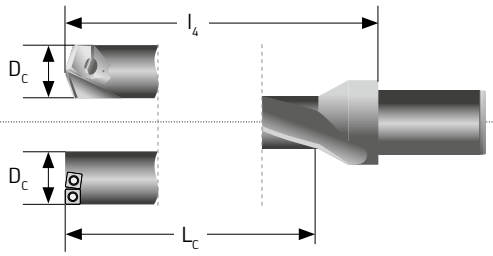
Reap the benefits even before delivery
With Walter Xpress, you benefit from an extremely high degree of certainty when planning – right from the very start. That's because the simulation is available as soon as the quote is provided.

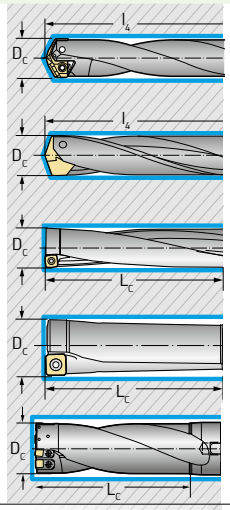
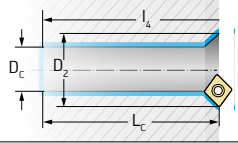
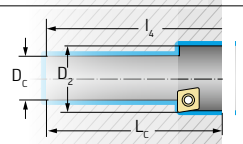
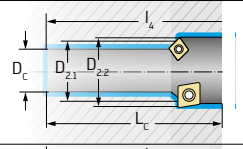
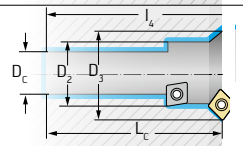
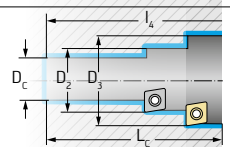
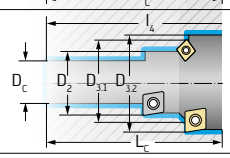
Save cash with Walter Xpress
Walter Xpress is fast, efficient and individually designed. These are qualities through which – depending on the number of machining operations – you can make enormous savings in comparison to conventional machining strategies.

Make use of the time for your core area of expertise
Increasing your productivity with Walter Xpress gives you a remarkable degree of freedom. The time you gain can be used to obtain considerable leverage, if you decide to use it for your core areas of expertise, for example.

Drilling from solid

with Indexable insert tools

		Tolerances	Max. Number of different Indexable insert seating
D4140 / D5142		Core drilling: Sintered: ± 0.15 mm Ground: ± 0.10 mm Under optimum conditions, a hole tolerance of IT8 of the Solid drill diameter can be achieved.*	5
D4120 / D3120		Sintered: ± 0.15 mm Ground: ± 0.10 mm	6

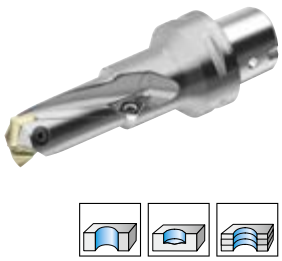
Operation Max. two indexable insert seats per step possible		$D_{min, max}$	L_C mm	l_4 mm
Drilling from solid		**D5 . 42** D_c =12.00-31.99 mm D_c= 0.472-1.259 in	8 × D_C	≤ 300
		D4 . 40 D_c =12.00-37.99 mm D_c= 0.472-1.496 in	8 × D_C	≤ 300
		D4 . 20 D_c =13.50-59.00 mm D_c =0.531-2.25 in	5 × D_C	≤ 300
		D3 . 20 D_c =16.00-58.00 mm D_c = 0.630-2.25 in	4 × D_C	≤ 300
		D4170 D_c =59.00-120.00 mm D_c =2.32-4.72 in	4.5× D_C	≤ 270
1st step: Drilling from solid + chamfering		$D_{2\,max} = D_C + 15$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300
1st step: Drilling from solid + boring		$D_{2\,max} = D_C + 22$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300
1st step: Drilling from solid + boring and chamfering		$D_{2.1\,max} = D_C + 15$ $D_{2.2\,max} = D_{2.1} + 22$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300
2nd step: ... + Chamfering		$D_{3\,max} = D_2 + 15$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300
2nd step: ... + boring		$D_{3\,max} = D_2 + 22$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300
2nd step: ... + boring and chamfering		$D_{3.1\,max} = D_2 + 15$ $D_{3.2\,max} = D_{3.1} + 22$	**Symmetrical drill** 5 × D_C **Asymmetrical drill** 5 × D_C	7 × D_C ≤ 300

* The resulting workpiece diameter may differ due to the drilling depth, workpiece material, feed rate and chip removal conditions, etc.

Example tools

D5142

D4 . 40

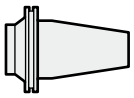
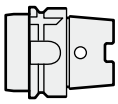
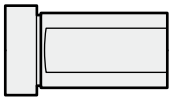
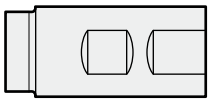
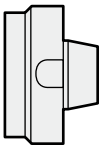
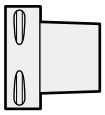
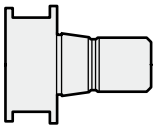
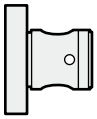
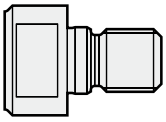


D3 . 20

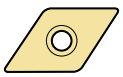
D4 . 20

D4170

Possible adaptors

 SK DIN 69871 ANSI/CAT JIS (MAS-BT)	 HSK DIN 69893, Form A
 Cylindrical shank ISO 9766	 Cylindrical shank DIN 1835
 NCT	 WalterCapto™
 ScrewFit	 AC
 TC	

Possible Indexable inserts - Boring

 Form CC.. / CP..	 Form DC.. / DP..
 Form SC.. / SP..	 Form TC.. / TP..
 Form MP..	 Form P484..
 Form P284..	

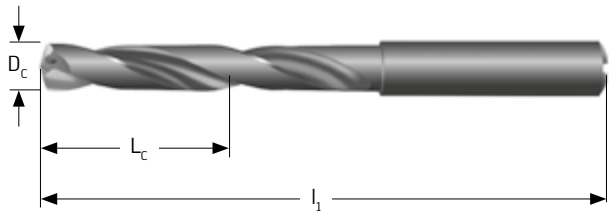
Drilling from solid

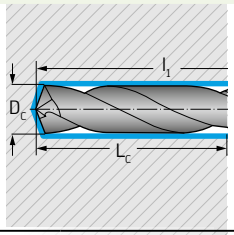
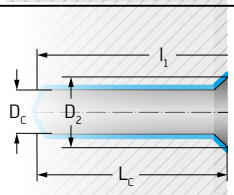
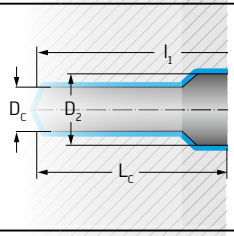
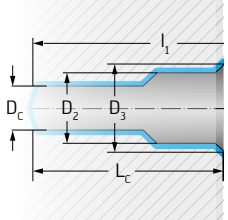
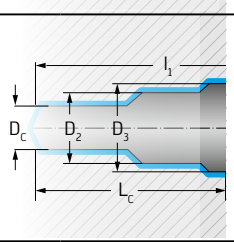
with solid carbide/HSS-E tools

Tolerances

$D_{min, max}$ ≥ IT6

l_3-Step length ± 0.05



Operation		$D_{min, max}$ mm	L_C mm	l_3-Step length mm	l_1 mm	Point angle min, max	Countersink step min, max
Drilling from solid		**Solid carbide:** D_c =3.00-20.00	35 × D_C		≤ 430	90°-150°	
		HSS / HSS-E: D_c =3.00-16.00			≤ 470		
1st step: Drilling from solid + chamfering		**Solid carbide:** $D_{2\,max}$ = D_C ×~ 1.5	10 × D_C	10 × D_C	≤ 330	90°-150°	60°-180°
1st step: Drilling from solid + boring		**Solid carbide:** $D_{2\,max}$ = D_C ×~ 1.5	12 × D_C	10 × D_C	≤ 330	90°-150°	60°-180°
2nd step: ... + Chamfering		**Solid carbide:** $D_{3\,max}$ = D_C ×~ 1.5	12 × D_C	10 × D_C	≤ 330	90°-150°	60°-180°
2nd step: ... + boring		**Solid carbide:** $D_{3\,max}$ = D_C ×~ 1.5	12 × D_C	10 × D_C	≤ 330	90°-150°	60°-180°

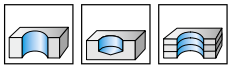
Example tools

DC180

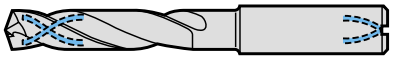
DD370

DC166

DC160 30 × D



Cooling variant



Internal cooling (IC)

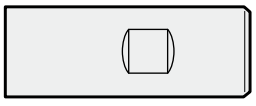
External coolant supply

MQL (minimum quantity lubrication)

Shank variant

DIN 6535 HA

DIN 6535 HE



DIN 6535 HB

Drilling from solid

with high-performance indexable inserts

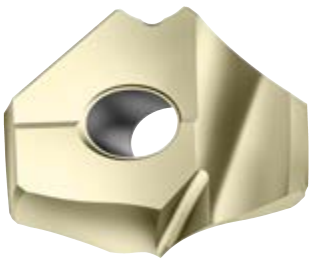
Example tools

WMP35

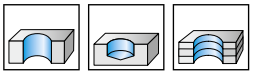
WNN25

WKK45C

WPP25

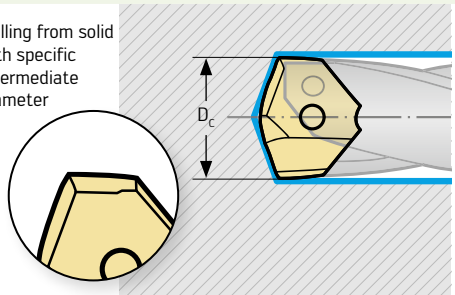
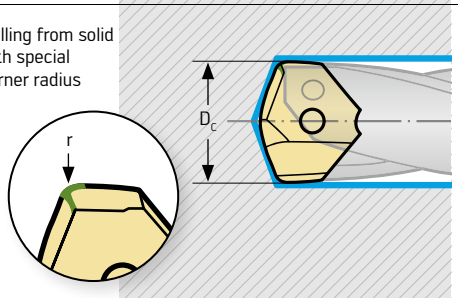
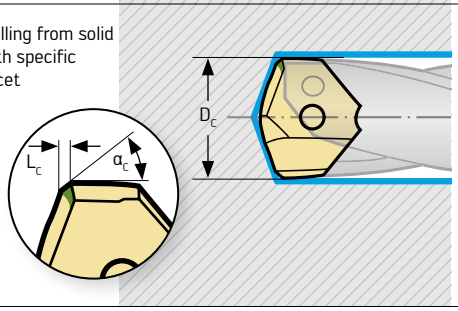


Application



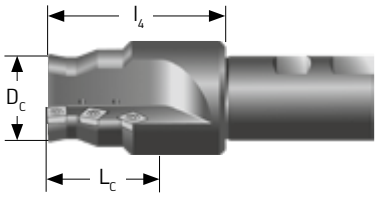
Material groups

P	K	N
	S	M

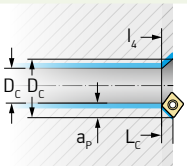
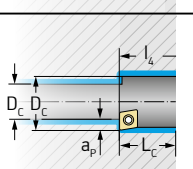
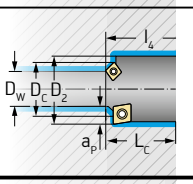
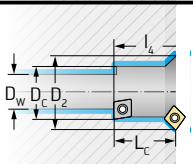
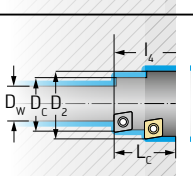
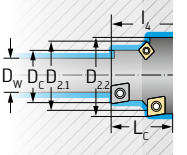
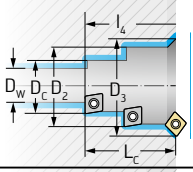
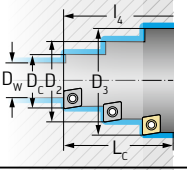
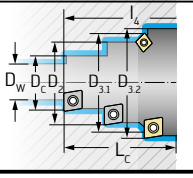
Operation	Diameter D_c mm	Corner radius r mm	Facet L mm	Point angle
Drilling from solid with specific intermediate diameter 	$D_{c\,min}$ = 12.00 $D_{c\,max}$ = 37.99			140°
Drilling from solid with special corner radius 	$D_{c\,min}$ = 12.00 $D_{c\,max}$ = 37.99	r_{min} = 0.3 r_{max} = 0.15 × D_c		140°
Drilling from solid with specific facet 	$D_{c\,min}$ = 12.00 $D_{c\,max}$ = 37.99		$L_{c\,min}$ = 0.3 $L_{c\,max}$ = 1.0 $\alpha_{c\,min}$ = 30° $\alpha_{c\,max}$ = 60°	140°

Boring

with indexable insert tools



Possible Number of teeth per step	Max. step jump in relation to D_C
Diameter 0-25: Z = 1 Diameter 25-50: Z = 2 Diameter 50-75: Z = 3 Diameter > 75: Z = 4	1. Chamfering: D_C + 15 mm 2. Boring: D_C + 22 mm 3. Chamfering + boring D_C + 37 mm

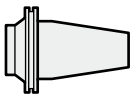
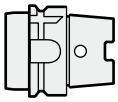
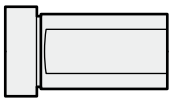
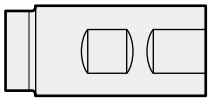
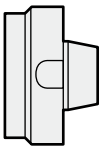
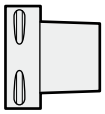
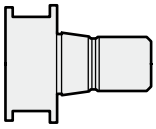
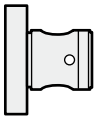
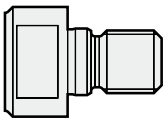
Operation Max. four indexable insert/cartridge seats per step possible		$D_{min, max}$ **mm**	**Angle**	$a_{p\ max}$ **mm**	L_C **mm**	l_4 **mm**
1st step: Chamfering		D_c =16-250	90°-3°	7.5	≤ 5 × D_C	≤ 300
1st step: Boring		D_c =16-250	90°-3°	11	≤ 5 × D_C	≤ 300
1st step: Boring + Chamfering		D_c =16-250	90°-3°	18.5	≤ 5 × D_C	≤ 300
2nd step: ... + Chamfering		$D_{2\ max}$ = D_C + 15	90°-3°		≤ 5 × D_C	≤ 300
2nd step: ... + core drills		$D_{2\ max}$ = D_C + 22	90°-3°		≤ 5 × D_C	≤ 300
2nd step: ... + boring and chamfering		$D_{2.1\ max}$ = D_C + 15 $D_{2.2\ max}$ = $D_{2.1}$ + 22	90°-3°		≤ 5 × D_C	≤ 300
3rd step: ... + Chamfering		$D_{3\ max}$ = D_2 + 15			≤ 5 × D_C	≤ 300
3rd step: ...+Boring		$D_{3\ max}$ = D_2 + 22			≤ 5 × D_C	≤ 300
3rd step: ...+ Boring and chamfering		$D_{3rd1\ max}$ = D_2 + 15 $D_{3rd2\ max}$ = D_{3rd1} + 22	90°-3°		≤ 5 × D_C	≤ 300

Example tools

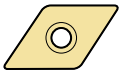
Three steps boring tool with fixed insert seats

Boring tool with ISO cartridges

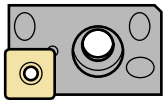
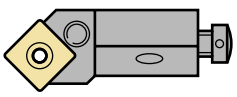
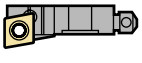
Possible adaptors

 SK DIN 69871 ANSI/CAT JIS (MAS-BT)	 HSK DIN 69893, Form A
 Cylindrical shank ISO 9766	 Cylindrical shank DIN 1835
 NCT	 WalterCapto™
 ScrewFit	 AC
 TC	

Possible Indexable inserts - boring

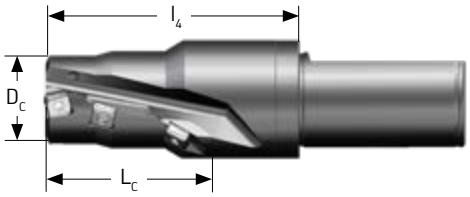
 Form CC.	 Form DC.
 Form SC..	 Form TC.
 Form MP..	 Form P484..
 Form P284..	

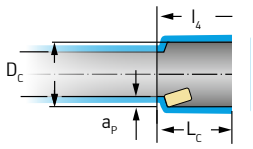
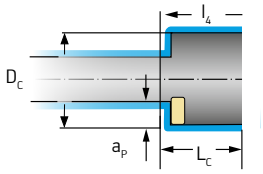
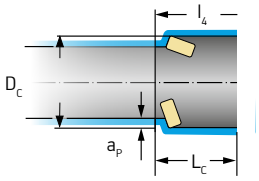
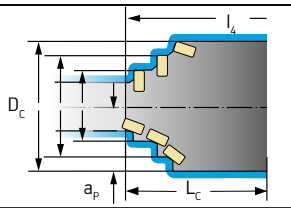
Possible cartridges

 κ: 95°, 90°, 75°, 60°, 45°, 30°, 15° Walter Mini toolholder: $D_{C\ min}$ = 40 mm	 κ: 95°, 90°, 75°, 60°, 45°, 30°, 15° ISO cartridges: $D_{C\ min}$ = 40 mm
 κ: 95°, 90°, 75°, 60°, 45°, 30°, 15° Mini cartridges: $D_{C\ min}$ = 20 mm	

Boring

with tangential indexable insert tools



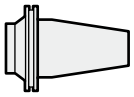
Operation Max. eight indexable inserts per step possible		**D_C** **mm**	**Angle**	**$a_{p\ max}$** **mm**	**Z_{eff} D_{min}**
1. Boring with tangential arrangement		D_c = 24-250	71.3°	2.4	3
2. Boring with lateral arrangement		D_c = 30-250	0°-90°	7.6	3
3. Boring with lateral and tangential arrangement		D_c = 30-250	71.3°	2.4	2
4. ... up to three steps and six indexable insert positions possible		D_c =24-250	0°-90°	37.5	3

Example tools

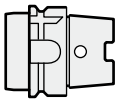
Tangential boring tool with bore adaption

Tangential boring tool with HSK adaptor

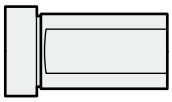
Possible adaptors



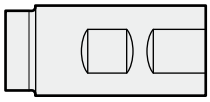
SK DIN 69871
ANSI/CAT JIS (MAS-BT)



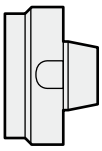
HSK
DIN 69893, Form A



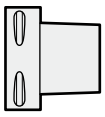
Cylindrical shank
ISO 9766



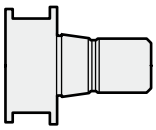
Cylindrical shank
DIN 1835



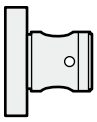
NCT



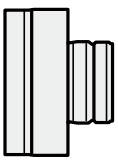
WalterCapto™



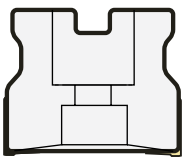
ScrewFit



AC

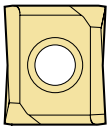


Varilock

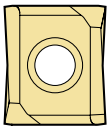


Transverse keyway
cylindrical bore DIN 138-A

Possible indexable inserts - boring

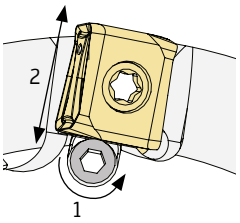


P4160-E47...



P4460-G88..

Additional function



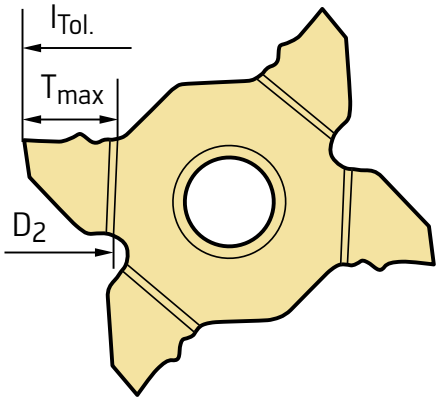
Adjustable screw
k: 90°
$D_{C\,min}$ = 33 mm

Hint

- Only for rotating tools
- Bore adaptation only possible with one step

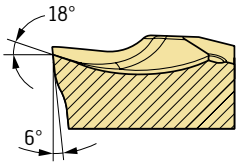
Grooving

with Walter Cut MX multi-edge grooving system

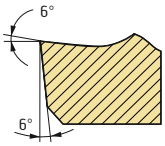


Example tools

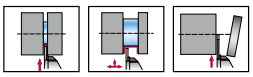
CF5 geometry



GD8 geometry

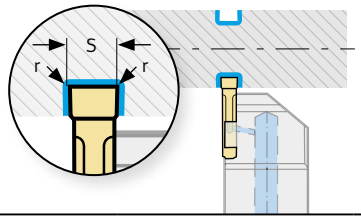
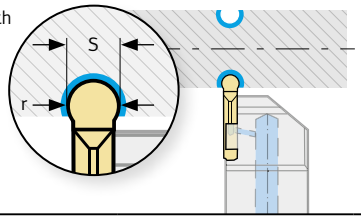
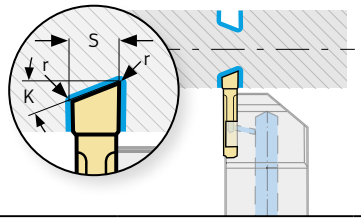
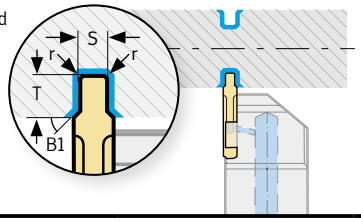


Application



Material groups

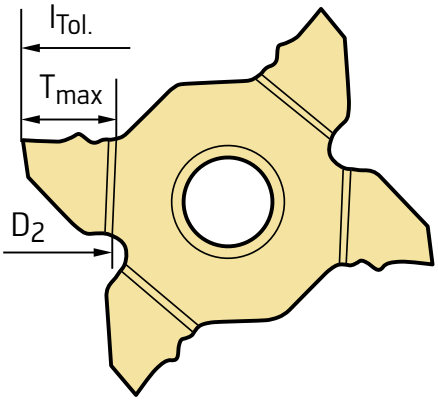
P **M** **K** **S**

Operation	Insert width S mm	Cutting depth T mm	Corner radius r mm	Approach angle	Chamfer angle
Grooving 	S_{min} = 0.5 S_{max} = 5.5	T_{min} = 1 T_{max} = 6	r_{min} = 0.05 r_{max} = (r1+r2=S)		
Grooving with full radius 	S_{min} = 0.5 S_{max} = 5.5	T_{min} = 1 T_{max} = 6	r = S/2		
Parting-off 	S_{min} = 0.5 S_{max} = 5.5	T_{min} = 1 T_{max} = 6	r_{min} = 0.05 r_{max} = (r1+r2=S)	K_{min} = 3° K_{max} = 20°	
Grooving and chamfering 	S_{min} = 1 S_{max} = 5.5	T_{min} = 1 T_{max} = 5.5	r_{min} = 0.05 r_{max} = 0.50		$B1_{min}$ = 30° $B1_{max}$ = 60°

Cutting width tolerances:±0.02 mm.

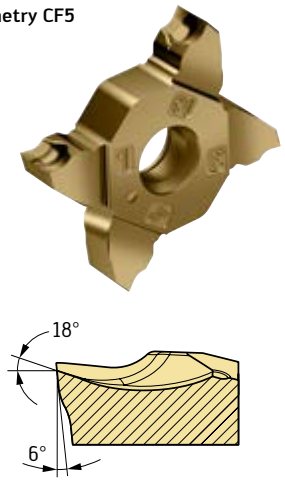
Grooving

with multiple cutting edges Grooving system Walter Cut MX

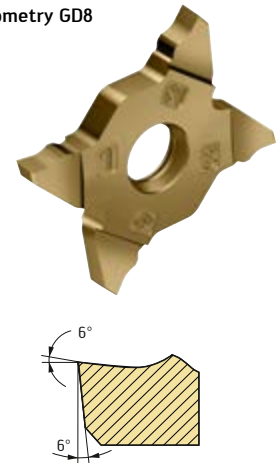


Example tools

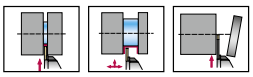
Geometry CF5



Geometry GD8

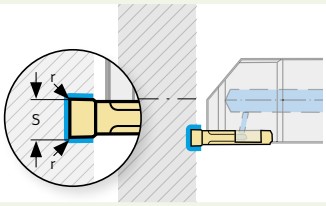


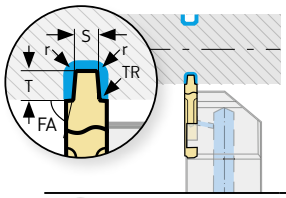
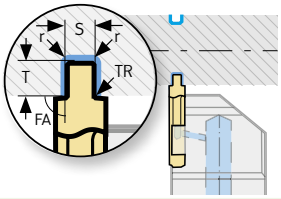
Application

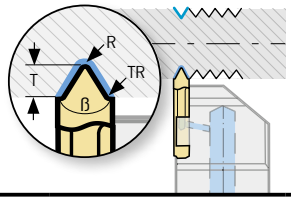


Material groups

P M K S

Operation	Insert width S mm	Cutting depth T mm	Corner radius r mm
Axial grooving 	S_{min} = 1.5 S_{max} = 5.15	T_{min} = 1.0 T_{max} = 5.0	r_{min} = 0.05 r_{max} = (r1+r2=S)

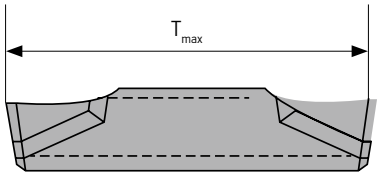
Operation	Insert width S mm	Cutting depth T mm	Corner radius r mm	Transition radius TR	Flank angle FA
Grooving and Chamfering with transition radius 	S_{min} = 1.0 S_{max} = 3.5	T_{min} = 1.0 T_{max} = 4.9	r_{min} = 0.05 r_{max} = 0.50	$T_{R\,min}$ = 0.2 $T_{R\,max}$ = 0.4	$F_{a\,max}$ = 0° $F_{a\,max}$ = 5°
	S_{min} = 1.0 S_{max} = 3.5	T_{min} = 1.0 T_{max} = 4.9	r_{min} = 0.05 r_{max} = 0.50	$T_{R\,min}$ = 0.2 $T_{R\,max}$ = 0.4	$F_{a\,max}$ = 0° $F_{a\,max}$ = 0°

Operation	Thread depth T mm	Tip radius R mm	Transition radius TR	Flank angle ß
Thread turning 	T_{min} = 0.5 T_{max} = 4.0	R_{min} = 0.05 R_{max} = 0.50	$T_{R\,min}$ = 0.15 $T_{R\,max}$ = 0.50	ß min = 55° ß max = 60°

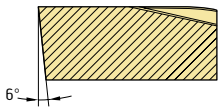
Grooving

with Walter Cut GX multi-edge grooving system

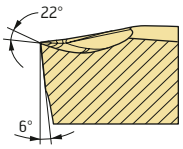
Example tools



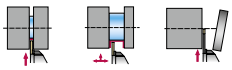
UA4 Geometry



UF8 Geometry

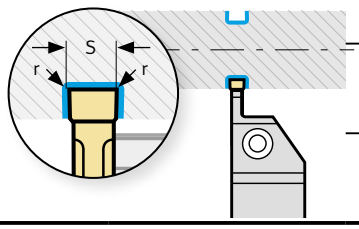
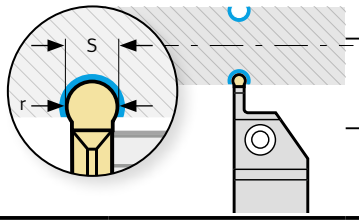
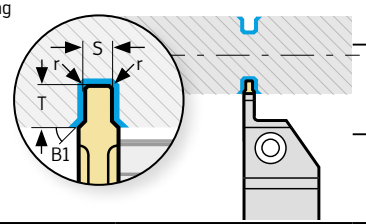


Application



Material groups

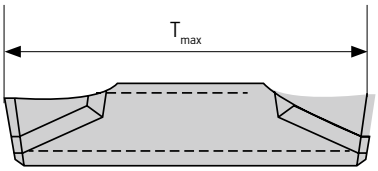
P	M	K	S

Operation	Cutting edge length L mm	Insert width S mm	Cutting depth T mm	Corner radius r mm	Chamfer angle
Grooving 	GX09	S_{min} = 1.50 S_{max} = 2.99		r_{min} = 0.05 r_{max} = (S/2)	
	GX16	S_{min} = 1.60 S_{max} = 8.00		r_{min} = 0.05 r_{max} = (S/2)	
	GX24	S_{min} = 2.30 S_{max} = 10.0		r_{min} = 0.05 r_{max} = (S/2)	
Grooving with full radius 	GX09	S_{min} = 1.50 S_{max} = 2.99		r = (S/2)	
	GX16	S_{min} = 1.60 S_{max} = 8.00		r = (S/2)	
	GX24	S_{min} = 2.30 S_{max} = 10.0		r = (S/2)	
Grooving and chamfering 	GX09	S_{min} = 1.50 S_{max} = 2.99	T_{min} = 0.5 T_{max} = 1.3	r_{min} = 0.05 r_{max} = 0.5	$B_{1\ rpm}$ = 30° $B_{1\ max}$ = 60°
	GX16	S_{min} = 1.5 S_{max} = 4.59	T_{min} = 0.5 T_{max} = 1.9	r_{min} = 0.05 r_{max} = 0.5	$B_{1\ rpm}$ = 30° $B_{1\ max}$ = 60°
	GX24	S_{min} = 3.00 S_{max} = 6.50	T_{min} = 0.5 T_{max} = 4.5	r_{min} = 0.05 r_{max} = 0.5	$B_{1\ rpm}$ = 30° $B_{1\ max}$ = 60°

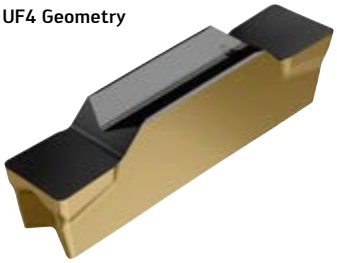
Grooving

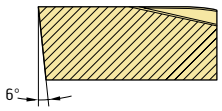
with Walter Cut DX multi-edge grooving system

Example tools

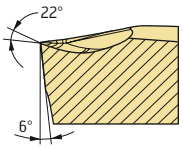


UF4 Geometry

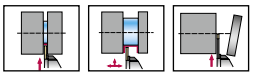




UF8 Geometry

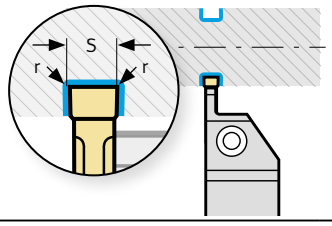
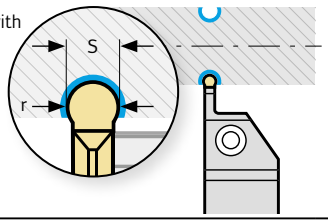
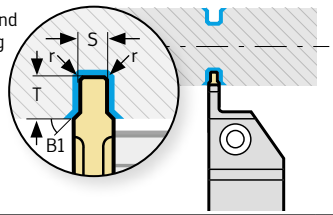


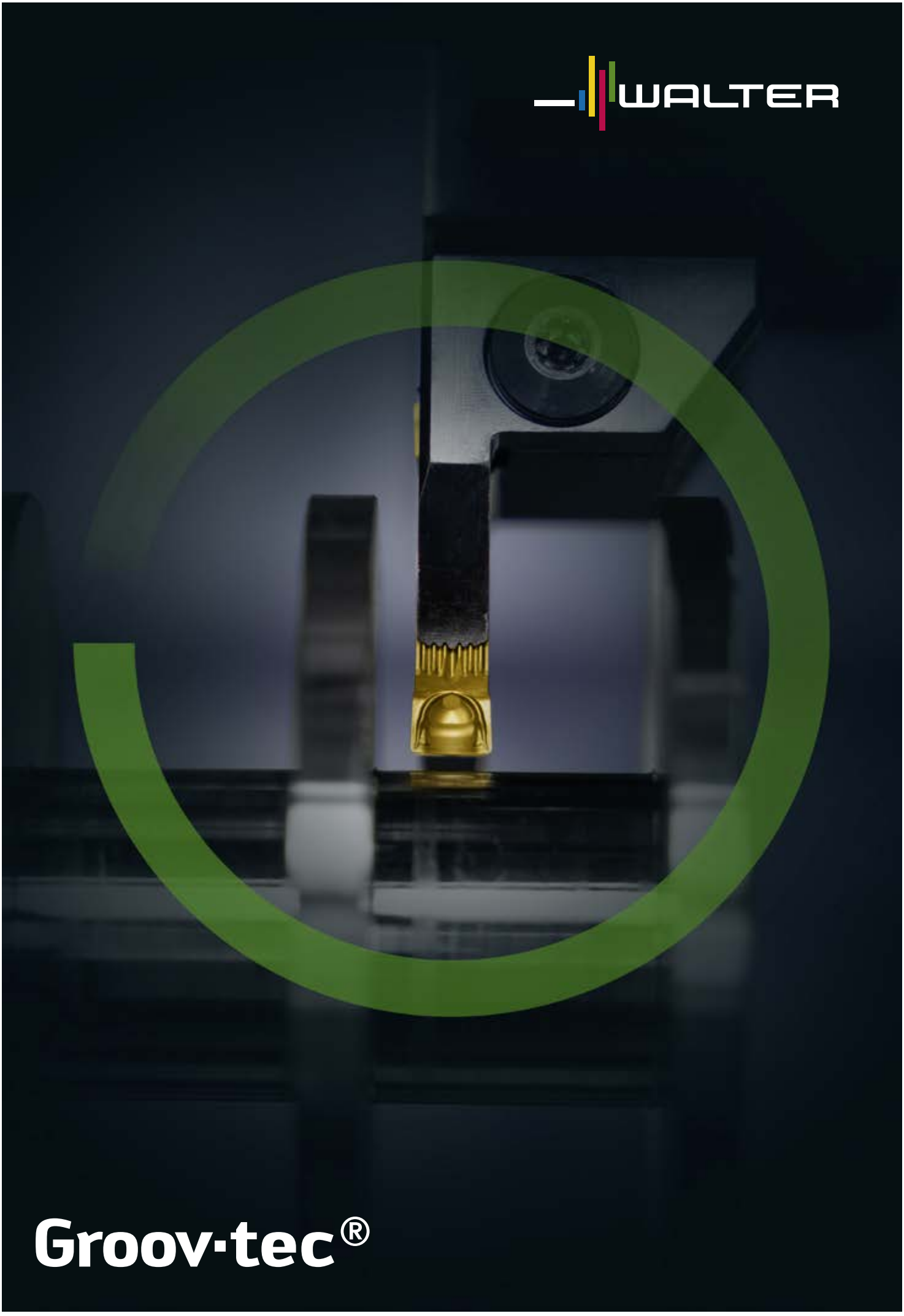
Application



Material groups

P M K S

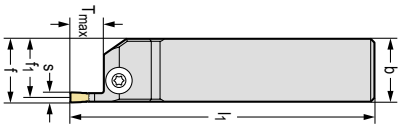
Operation	Cutting edge length L mm	Insert width S mm	Cutting depth T mm	Corner radius r mm	Chamfer angle
Grooving 	DX18	S_{min} = 2.00 S_{max} = 7.99		r_{min} = 0.05 r_{max} = (S/2)	
Grooving with full radius 	DX18	S_{min} = 2.00 S_{max} = 7.99		r_{min} = 0.05 r_{max} = (S/2)	
Grooving and chamfering 	DX18	S_{min} = 2.00 S_{max} = 4.59	T_{min} =0.5 T_{max} = 3.5	r_{min} = 0.05 r_{max} = 0.50	$B_{1\,rpm}$ = 30° $B_{1\,max}$ = 60°


WALTER
Groov·tec®

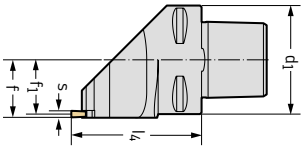
Tool holder
for external machining

Example tools

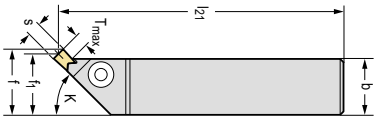
Shank tools



Capto lancing holder



Shank tools - Universal 45°

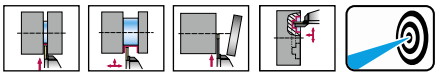


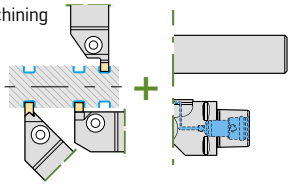
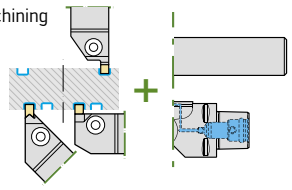
Indexable inserts

GD

Groov·tec® GD

Application

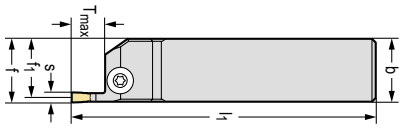


Operation	Insert width S mm	Cutting depth T mm	Dmin mm	Approach angle	Shank/Capto size mm	Total length mm
External machining Radial GD: 	S_{min} = 2.50 S_{max} = 6.00	T_{min} = 3 T_{max} = 33		K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250
External machining Axial GD: 	S_{min} = 2.50 S_{max} = 6.00	T_{min} = 5 T_{max} = 33	Dmin: 34mm Dmin max: 2500mm	K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250

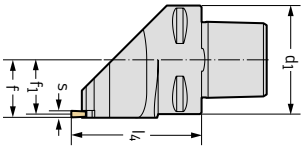
Tool holder
for external machining

Example tools

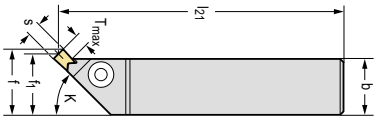
Shank tools



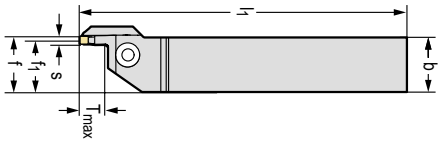
Capto holder



Shank tools - Universal 45°



Shank tools - axial grooving



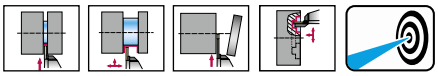
Indexable inserts

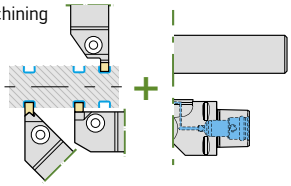
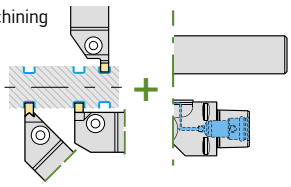
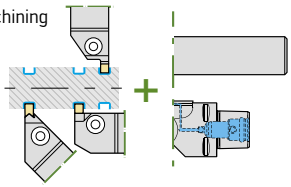
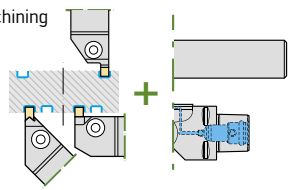

MX


DX


GX

Application

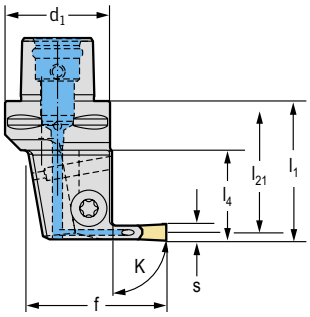


Operation	Insert width S mm	Cutting depth T mm	Dmin mm	Approach angle	Shank/Capto size mm	Total length mm
External machining Radial MX: 	S_{min} = 0.50 S_{max} = 5.56	T_{min} = 1 T_{max} = 6		K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250
External machining Radial DX: 	S_{min} = 1.00 S_{max} = 4.25	T_{min} = 5 T_{max} = 17		K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250
External machining Radial GX: 	S_{min} = 2.00 S_{max} = 8.00	T_{min} = 5 T_{max} = 33		K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250
External machining Axial GX: 	S_{min} = 2.00 S_{max} = 8.00	T_{min} = 5 T_{max} = 33	Dmin: 34mm Dmin max: 2500mm	K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50	<= 120 <= 250

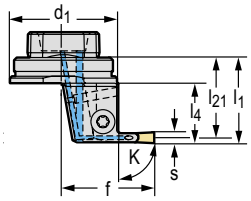
Tool holder
internal machining

Example tools

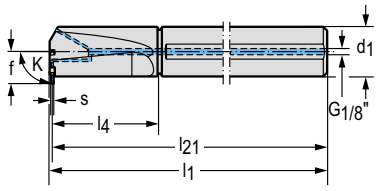
Capto holder - Internal grooving



QuadFit head - Internal grooving



Boring bar for internal grooving

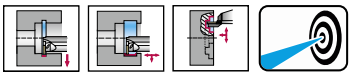


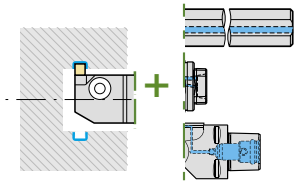
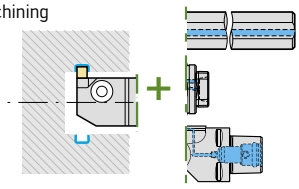
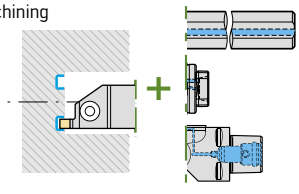
Indexable inserts

DX

GX

Application

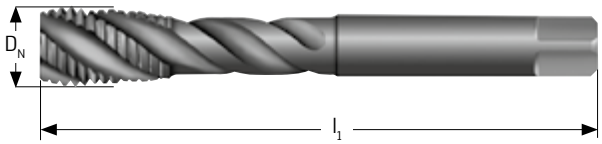


Operation	Insert width Smm	Cutting depth T mm	Dmin mm	Approach angle	Shank/Capto size mm	Total length mm
Internal machining Radial DX: 	S_{min} = 1.00 S_{max} = 4.25	T_{min} = 5 T_{max} = 17	Dmin: 27mm Dmin max: 2500mm	K_{min} = 85° K_{max} = 95°	Capto: C3-C8 Square Shank: 10 - 50 QuadFit Q25-Q50	<= 120 <= 250
Internal machining Radial /Axial GX: 	S_{min} = 2.00 S_{max} = 8.00	T_{min} = 5 T_{max} = 33	Dmin: 25mm Dmin max: 2500mm	K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50 QuadFit Q25-Q50	<= 120 <= 250
Internal machining Axial GX: 	S_{min} = 2.00 S_{max} = 8.00	T_{min} = 5 T_{max} = 33	Dmin: 34mm Dmin max: 2500mm	K_{min} = 0° K_{max} = 90°	Capto: C3-C8 Square Shank: 10 - 50 QuadFit Q25-Q50	<= 120 <= 250

Threading
with HSS-E/HSS-E-PM tools

Variants

Right- and left-hand cutting version



Standard/Operation	Thread types	$D_{N\ min,\ max}$ mm	Chamfer form*
Metric Thread cutting and Thread forming: blind and through hole	M MF EGM EG MF	3-20mm	Form A (6-7 threads) Form B (4-5 threads) Spiral point Form C (2-3 threads) Form D (4-5 threads) Form E (1.5-2 threads) Form F (1-1.5 threads)
UTS Thread cutting and Thread forming: blind and through hole	UN UNC UNF UNEF STIUN STIUNC STIUNF STIUNEF	No. 5-15/16" (3.175mm - 20.995mm)	Form A (6-7 threads) Form B (4-5 threads) Spiral point Form C (2-3 threads) Form D (4-5 threads) Form E (1.5-2 threads) Form F (1-1.5 threads)
G Thread cutting and Thread forming: blind and through hole	G	1/8- 1/2 (9.728mm- 20.995mm)	Form A (6-7 threads) Form B (4-5 threads) Spiral point Form C (2-3 threads) Form D (4-5 threads) Form E (1.5-2 threads) Form F (1-1.5 threads)

* Depending on the models

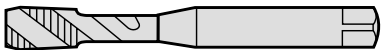
Example tools

TC130 tap for blind-hole machining

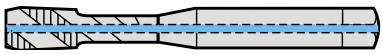
Prototex® tap for through-hole machining

TC420 Thread former

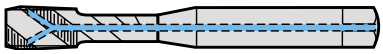
Tap coolant variant



External

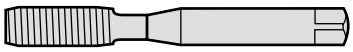


Axial outlet

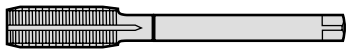


Radial exit

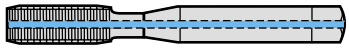
Thread former coolant variant



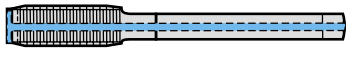
External without Lubrication grooves



External with Lubrication grooves



Axial exit



Radial exit

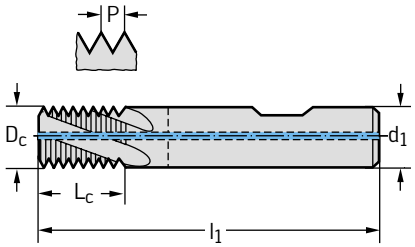
Shank variant

With square

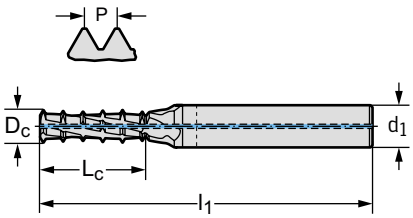
Thread milling

with Solid carbide tools

TC610



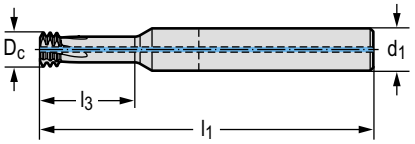
TC620



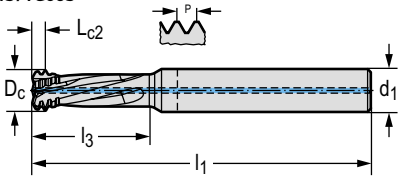
Thread types

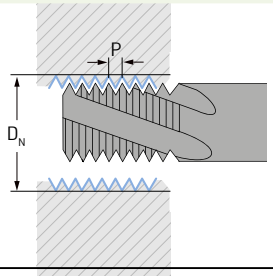
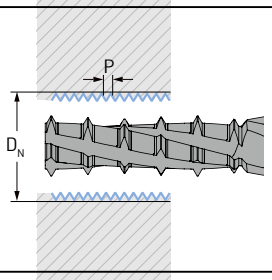
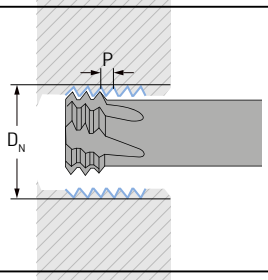
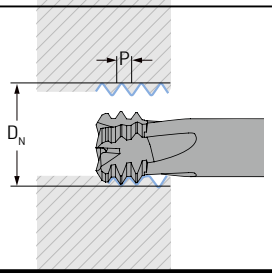
M	STIM
MF	STIMF
UN	STIUN
UNC	STIUNC
UNF	STIUNF
UNEF	
UNS	

TC630



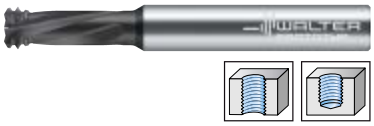
TC645/TC685



Standard/Operation		$D_{N\ min,\ max}$ mm	P mm	Number of teeth	LC / L3 mm
TC610/TC611		M4-M16 UNC8-UNC5/8 UNF10-UNF5/8	0,7-2,5	4-6	max. $2xD_N$
TC620		M4-M16 UNC8-UNC5/8 UNF10-UNF5/8	0,7-2,5	3-6	max. $3xD_N$
TC630		M4-M16 UNC8-UNC5/8 UNF10-UNF5/8	0,5-2,5	4-6	max. $4xD_N$
TC645/TC685		M4-M16 UNC8-UNC5/8 UNF10-UNF5/8	0,7-2,5	4-5	max. $3xD_N$

Example tools

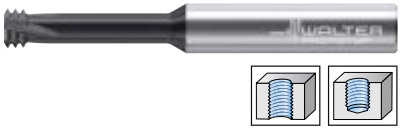
TC645/TC685

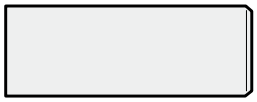
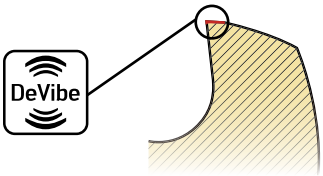
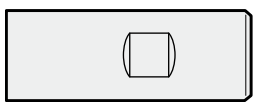


TC610

TC620

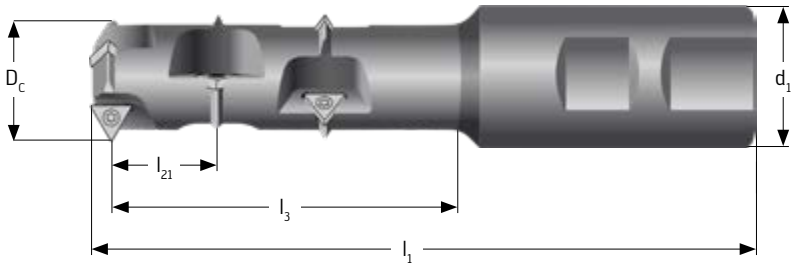
TC630



Variant Cooling Thread milling cutter:	Modifications:	Shank variant
 External	 Countersinking and levelling stage	 DIN 6535 HA
 Axial outlet	 Deburring cutting edge	 DIN 6535 HE
 Externally via the shart	 DeVibe	 DIN 6535 HB

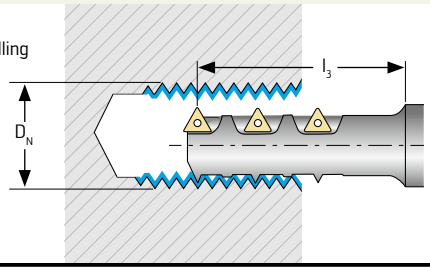
Thread milling

with indexable insert tools



Thread types

M	STIM	G
MF	STIMF	
UN	STIUN	
UNC	STIUNC	
UNF	STIUNF	
UNEF		
UNS		

Operation	D_N mm	P mm	l_3 mm	Number of teeth	Indexable inserts
Thread milling 	From M 16/UNC 3/4 From G1"	0.9-10 mm 24-3 TPI 14-11 TPI	3 × D_N (max. 250 mm)	3-9	P26300-06 P26300-09 P26300-11 P26300-14 P26300-22 P26310-09 P26310-14 P26310-22

Example tools

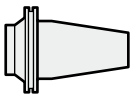
T2710

T2711

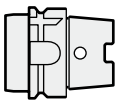
T2712

T2713

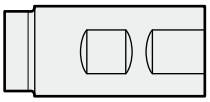
Possible adaptors



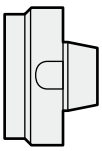
SK DIN 69871
ANSI/CAT JIS (MAS-BT)



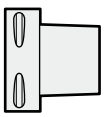
HSK
DIN 69893, Form A



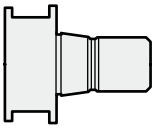
Cylindrical shank
DIN 1835



NCT



WalterCapto™

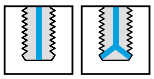


ScrewFit

D_c-Area:

19-62 mm for cylindrical shank and ScrewFit
19-100 mm for HSK, SK and NCT

Adjustable Coolant supply



Possible indexable inserts

Form P26300, P26310

Walter geometry index

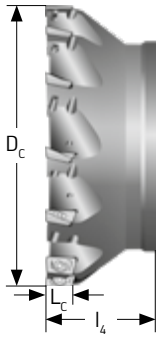
D67 easy-cutting, maximum life quantity

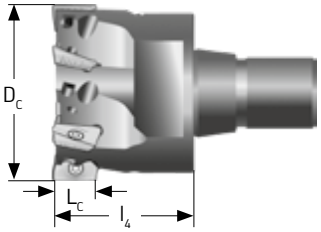
D61 vibration damped, best operational smoothness

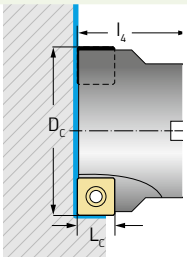
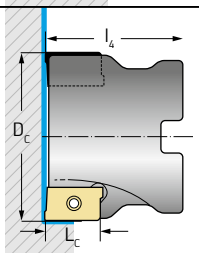
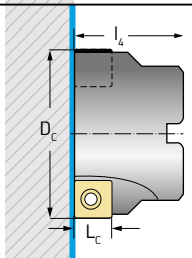
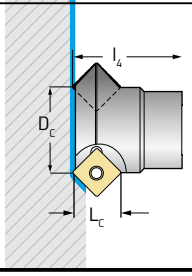
Milling
with M4000 indexable insert tools

	Tolerances	Diameter
	Using sintered indexable insert	± 0.15 mm
	Using ground indexable insert:	± 0.1 mm

Shoulder milling cutter

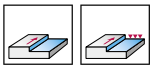


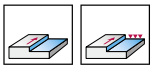


Operation		$D_{C\ min,\ max}$ mm	$L_{C\ min,\ max}$ mm	$l_{4\ min,\ max}$ mm	Approach angle [κ]	Indexable inserts
Shoulder milling (M4132)		15-250	0.1-11	≤ 125	89.5°	SD..06 SD..09 SD..12
Shoulder milling (M4130)		16-250	0.1-16	≤ 125	90°	LD..08 LD..14 LD..17
Face milling (M4000)		15-250	0.1-11	≤ 125	10°-89.5°	SD..06 SD..09 SD..12
Chamfering (M4000)		8-240	0.1-10	≤ 125	15°-75°	SD..06 SD..09 SD..12

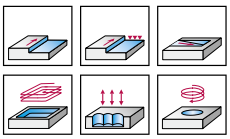
Example tools

Shoulder milling cutter



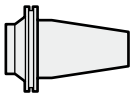


Face milling cutter

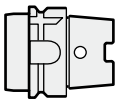


Chamfer milling cutter

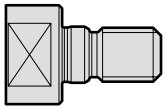
Possible adaptors



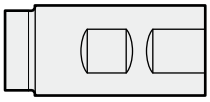
SK DIN 69871
ANSI/CAT JIS (MAS-BT)



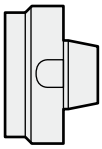
HSK
DIN 69893, Form A



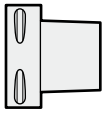
TC



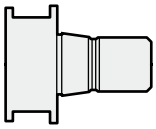
Cylindrical shank
DIN 1835



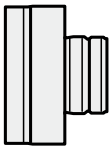
NCT



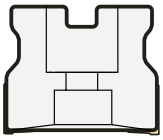
WalterCapto™



ScrewFit



Varilock



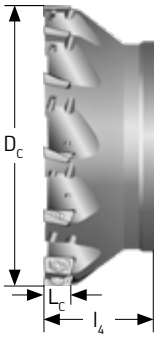
Cylinder bore Transverse keyway DIN 138-A

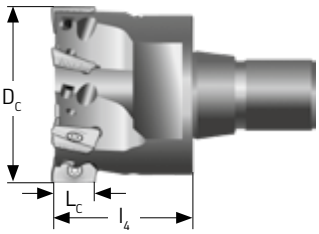
D_c-Area:

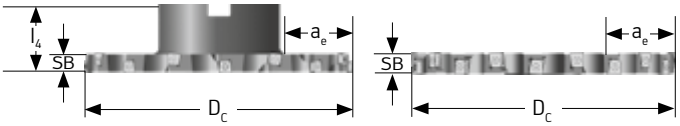
15-62 mm for cylindrical shank and ScrewFit
15-84 mm for HSK, SK and NCT
40-250 mm for bore adaptions

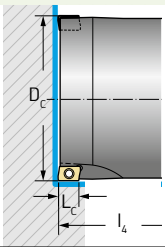
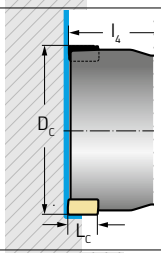
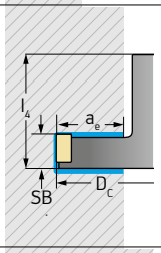
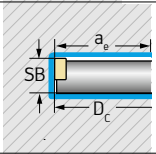
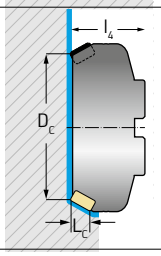
Milling
with indexable insert tools

	Tolerances	Diameter	Cutting widths
Shoulder milling cutter	Using sintered indexable insert:	± 0.20 mm	
	Using ground indexable insert:	± 0.12 mm	
	Using restricted tolerance:	± 0.07 mm	
Slotting cutter	Using Sintered WSP	± 0.30 mm	± 0.34 mm
	Using Ground WSP:	± 0.23 mm	± 0.16 mm
	Using restricted tolerance:	± 0.09 mm	± 0.11 mm



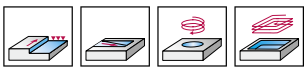




Operation		$D_{C\ min,\ max}$ mm	$L_{C\ min,\ max}$ mm	$l_{4\ min,\ max}$ mm	$a_{e\ max}$ mm	SB mm	Approach angle [κ]	Indexable inserts
Shoulder milling Xtra·tec® XT		10.00-250.00	0.1-16.0	≤ 125			82° 85°	AC...0602 BC...0903 BC...1204 BC...1605
Shoulder milling Walter BLAXX		21.90-250.00	0.1-15.0	≤125			90°	LN..0904 LN..1306 LN..1607
Slot milling		80.00-350.00	11.0-31.0	≤ 100	0.3 × D_C	11-30		CN..0805 CN..1206 CN..1608
Slot milling Xtra-tec®		80.00-350.00	11.0-30.0	≤100	0.3 × D_C	11-30		LN..0804 LN..1005 LN..1206 LN..1608
Face milling for heavy-duty machining		125.00-315.00	0.1-16.0	≤125			15° 45° 60° 75° 90°	LN..2010

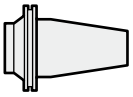
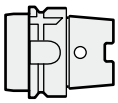
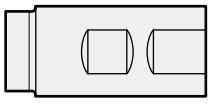
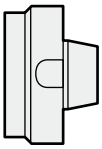
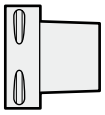
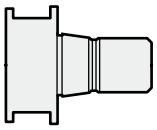
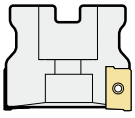
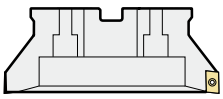
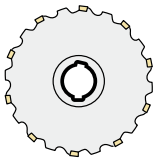
Example tools

Shoulder milling cutter



Slotting cutter

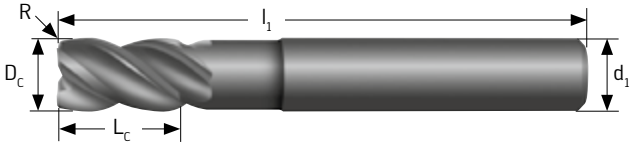
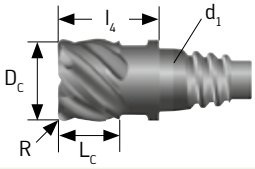
Possible adaptors

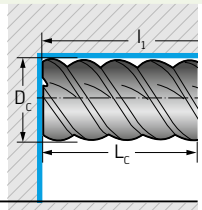
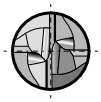
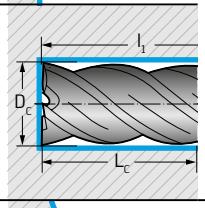
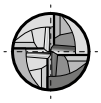
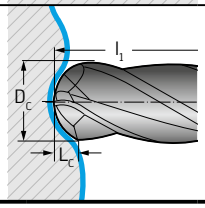
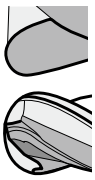
 SK DIN 69871 ANSI/CAT JIS (MAS-BT)	 HSK DIN 69893, Form A	 Cylindrical shank DIN 1835
 NCT	 WalterCapto™	 ScrewFit
 Transverse keyway cylindrical bore DIN 138-A	 Transverse keyway cylindrical bore DIN 138-A	 Cylindrical bore with DIN 138-L longitudinal keyway

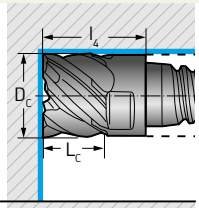
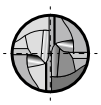
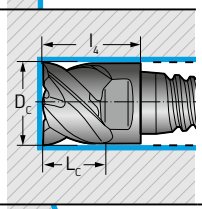
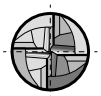
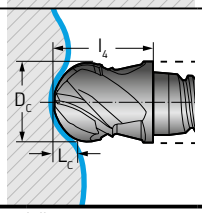
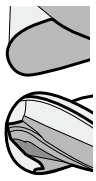
D_c-Area:

10-62 mm for cylindrical shank and ScrewFit
10-84 mm for HSK, SK and NCT
40-350 mm for bore adaptions

Milling
with solid carbide tools

		Helix angle	Number of teeth	Tolerances
Solid carbide end milling cutter		Depending on the product range	2-10*	IT8 - IT11
Modular solid carbide cutter ConeFit		Depending on the product range	2-10*	IT8 - IT11

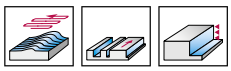
Solid carbide end milling cutter Operation		$D_{C, min, max}$ mm	L_C mm	$l_{1, max}$ mm	Cutting edge type		End-face geometry	
Shoulder milling		2.00-25.00	3 × D_C	125 [$D_C \le 6$ mm] 160 [$D_C \le 16$ mm] 225 [$D_C > 16$ mm]		$R_{max} = 0.3 \times D_C$ $R_{min} = 0.1$ mm [$D_C \le 12$ mm] $R_{min} = 0.2$ mm [$D_C > 12$ mm] 45° Chamfer angle Chamfer $width_{max} = 0.25 \times D_C$		with centre cut
Slot milling								without centre cut
Copy milling		2.00-25.00	3 × D_C	125 [$D_C \le 6$ mm] 160 [$D_C \le 16$ mm] 225 [$D_C > 16$ mm]		$R_{max} = 0.3 \times D_C$ $R_{min} = 0.1$ mm [$D_C \le 12$ mm] $R_{min} = 0.2$ mm [$D_C > 12$ mm]		

ConeFit solid carbide milling cutter Operation		$D_{C\ min, max}$ mm	$L_{C\ min, max}$ mm	$l_{4\ min, max}$ mm	Cutting edge type		End-face geometry	
Shoulder milling		6.00-25.40	0.4 × D_1-1.5 × D_1	10.9-49.6		$R_{max} = 0.3 \times D_C$ $R_{min} = 0.1$ mm [$D_C \le 12$ mm] $R_{min} = 0.2$ mm [$D_C > 12$ mm] Chamfer angle 45° Chamfer $width_{max} = 0.25 \times D_C$		With centre cut
Slot milling								Without centre cut
Copy milling		6.00-25.40	0.4 × D_1-1.5 × D_1	10.9-49.6		$R_{max} = 0.3 \times D_C$ $R_{min} = 0.1$ mm [$D_C \le 12$ mm] $R_{min} = 0.2$ mm [$D_C > 12$ mm]		

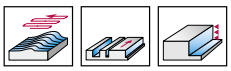
* Depending on type and diameter

Example tools

Solid carbide end milling cutter

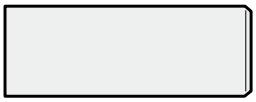


ConeFit modular solid carbide milling cutter

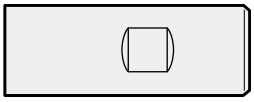


Shank sizes d_1 h6: 6, 8, 10, 12, 14, 16, 18, 20, 25

HA

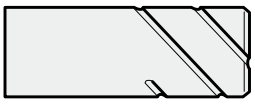


HB



HE

Safelock™
(from D_c 12 mm)



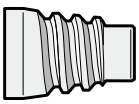
Variant - Cooling

Cooling grooves on the shaft

Axial exit

Two or three helical cooling openings
with front outlets

ConeFit sizes d_1:E10, E12, E16, E20, E25



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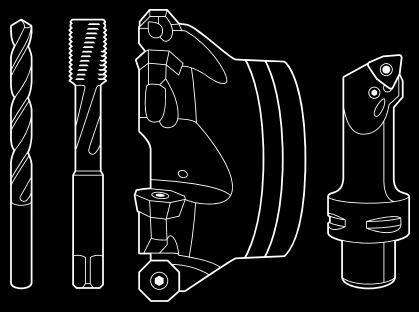

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