



Product expertise

Drilling, threading,  
milling

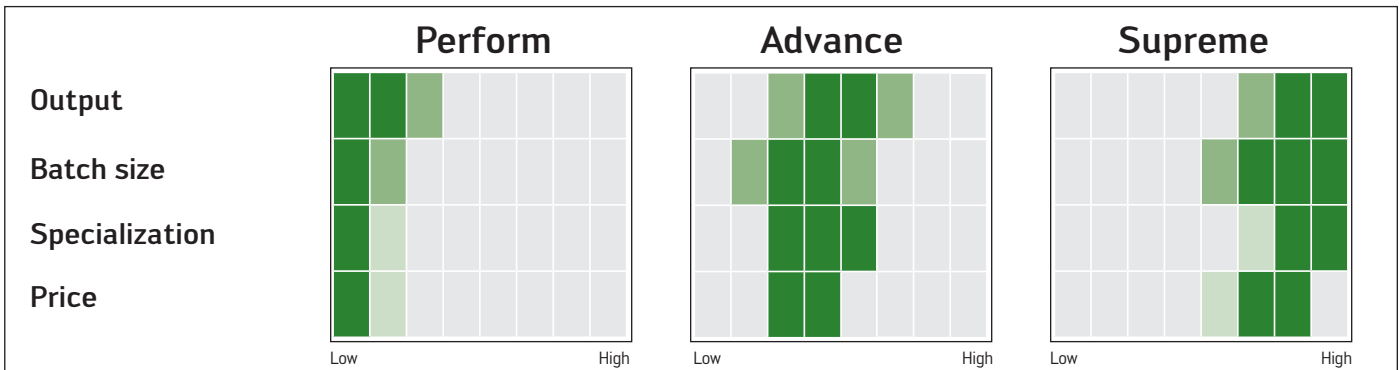
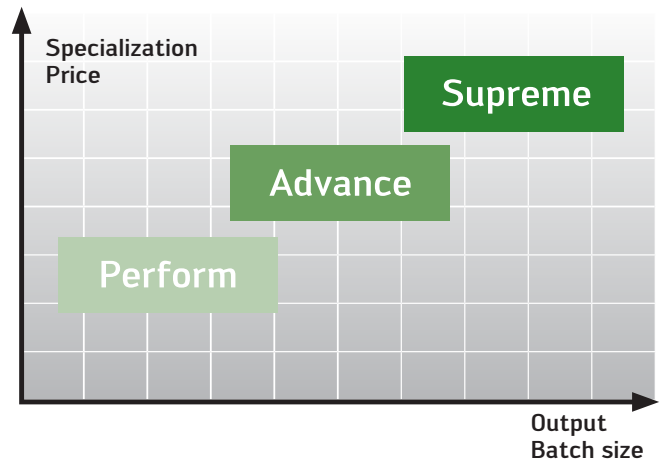
\_EXPERTISE IN MACHINING

# Walter Perform line – the new standard for small and medium batch sizes.



# The Walter product lines – Expertise to the power of three.

All Walter tools are characterized by maximum precision and process reliability. You can create real added value by finding a product range which precisely meets all of your requirements. With three product lines in its premium segment, Walter has the solution to match your requirements.



## SUPREME

Within the Supreme line, you will find tools with optimized machining qualities. These tools are always the first choice wherever high cutting speeds and long tool life for processing large batch sizes are required. Supreme tools are designed for machining very specific material groups, and often far exceed the performance of comparable tools.

## ADVANCE

Are you looking to strike the ideal balance between the most cost-effective production possible and long tool life? The key strengths of the tools in the Advance line really come into play in volume production applications of medium batch size. They offer three key benefits: Modest investment costs, excellent performance data and a wide range of different models.

## PERFORM

The tools in the Perform line help you to ensure excellent profitability and cover an impressively wide range of applications. They are ideal for use with a wide variety materials, for processing small to medium batch sizes.

# Walter Premium quality and cost efficiency.

Users with small and medium batch sizes are rarely looking for a tool to process large quantities – rather, they want a tool that provides flexibility in terms of application as well as cost efficiency. The Perform line from Walter offers you ideal solutions: They can be used for the most diverse types of material, and are designed precisely for achieving high-quality results at a reasonable price.

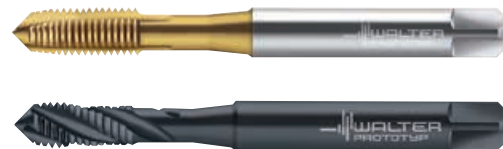
## DRILLING WITH DC150 PERFORM – EVERYTHING UNDER CONTROL, 100% PROCESS RELIABILITY

Users faced with a wide range of workpiece materials and machining conditions have to cope with many challenges – and therefore require tools that offer exceptional flexibility. The new solid carbide drills from the Perform line's DC150 product family are perfectly designed for this: They can be used universally and offer Walter's proven quality – all at a reasonable price.



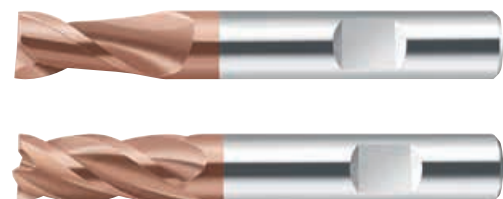
## THREADING WITH TC115/TC216 PERFORM – CUSTOMIZED COST EFFICIENCY

When it comes to cost-effective tapping, reliable processes and tools that can be used universally are basic requirements because machining conditions can vary dramatically depending on the material and workpiece. With geometries and coatings that are perfectly suited to the application, TC115 and TC216 taps cope easily with this challenge.









## MILLING WITH MC232 PERFORM – UNIVERSAL USE IN ISO P, M AND K

Suitable for any number of varying milling operations, a long tool life and excellent wear resistance, suitable for use in a wide variety of applications and in a broad diameter range: The MC232 Perform offers an economical solution when it comes to milling small and medium batch sizes.

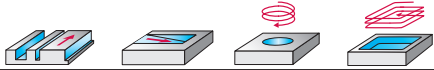





# The products from Walter's Perform line.











## DC150 Perform

Machining					
Drilling depth	3 x D <sub>c</sub>		5 x D <sub>c</sub>	8 x D <sub>c</sub>	12 x D <sub>c</sub>
Designation	DC150 Perform				
Dimensions	DIN 6537 short		DIN 6537 long	Walter standard	
Grade	WJ30RE			WJ30TA	
Shank	HA	HA	HA	HA	HA
Cooling	External cooling		Internal cooling		
Dia. range (mm)	3.00–20.00				
Technical information	Page 6				
Cutting data	Page 36				
Reconditioning	Page 9				
Order pages	10	13	16	20	23
					

## MC232 Perform

Machining			
Helix angle	35°		
Designation	MC232 Perform		
Dia. range (mm)	2–20		
Z	2	3	4
Corner radius	0		
Standard	DIN 6527 L		
Shank	DIN 6535 HA/DIN 6535 HB		
Technical information	Page 8		
Cutting data	Page 40		
Reconditioning	Page 9		
Order pages	32, 34	32, 34	33, 35
			

## TC115 / TC216 Perform

Machining												
Thread type	M		MF		UNC		M		MF		UNC	
Designation	TC115 Perform						TC216 Perform					
Thread depth	3 x D <sub>N</sub>						3.5 x D <sub>N</sub>					
Cooling	External cooling						External cooling					
Chamfer form	C						B					
Helix angle	45°						0°					
Tolerance	6H			2B			6H			2B		
Standard	DIN371/DIN376				DIN/ANSI		DIN371/DIN376				DIN/ANSI	
Dimensions	M3–M20		M8 x 1–M18 x 1		UNC6–UNC3/4		M3–M20		M8 x 1–M18 x 1		UNC6–UNC3/4	
Grade	WY80AA	WY80FC	WY80AA	WY80FC	WY80AA	WY80FC	WY80AA	WY80FC	WY80AA	WY80FC	WY80AA	WY80FC
Technical information	Page 7						Page 7					
Cutting data	Page 39						Page 39					
Order pages	28	28	30	30	26	26	29	29	31	31	27	26
												

# Walter Titex DC150 Perform – flexible in use and very wear-resistant.

## THE APPLICATION

- ISO material groups P, M, K, N, S, H, O
- Can be used with oil and emulsion
- Areas of use: General mechanical engineering, mold and die making, and the energy and automotive industries

## THE TOOL

- Solid carbide twist drill
- Grades: WJ30RE and WJ30TA; K30F-TiAlN
- 140° point angle
- Diameter range 3-20 mm
- Diameter range 0.125-0.75 inch

## THE DIMENSIONS

- Grade: WJ30RE, K30F, TiAlN:
  - DIN 6537 short  $3 \times D_c$  with and without internal cooling
  - DIN 6537 long  $5 \times D_c$  with internal cooling
  - Shank in accordance with DIN 6535 HA and HE
- Grade: WJ30TA, K30F, TiAlN:
  - Walter standard  $8 \times D_c$  with internal cooling
  - Walter standard  $12 \times D_c$  with internal cooling
  - Shank in accordance with DIN 6535 HA



Walter Titex DC150 Perform

## BENEFITS FOR YOU

- Cost-efficient machining of small and medium batch sizes
- Universal in its use on all materials
- Shank variants for all adaptors typically used in drilling, such as: Whistle Notch toolholders, hydraulic expansion chucks, collet chucks, shrink-fit chucks and power clamping chucks

# Walter Prototyp TC115 / TC216 Perform – ideal for the most diverse of materials.

## THE APPLICATION

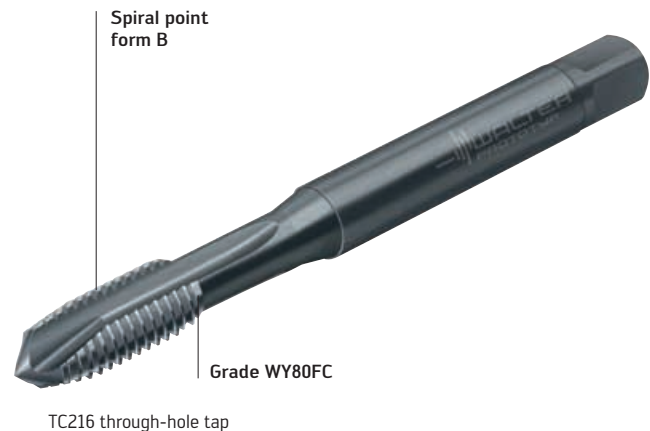
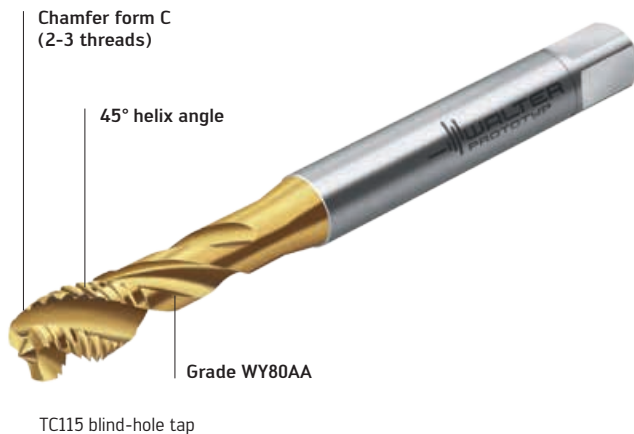
- Blind-hole and through-hole threads
- Dimension ranges:
  - M3-M20
  - MF: M8 x 1-M18 x 1.5
  - UNC: UNC6-UNC $\frac{1}{4}$  (DIN/ANSI)\*
- Primary application:
  - ISO P: 300-1000 N/mm<sup>2</sup>
  - ISO M: < 800 N/mm<sup>2</sup>
  - ISO K: GJS (GGG)
  - ISO N: Al wrought alloy, AISi < 4% silicon\*\*

\* Overall length  $\hat{=}$  DIN  
Shank diameter  $\hat{=}$  ANSI

\*\* Secondary application with TC115

## THE TOOL

- HSS-E machine taps
- TC115: For blind holes up to 3 x D<sub>N</sub>
- TC216: For through holes up to 3.5 x D<sub>N</sub>
- ISO 2/6H tolerances
- Two variants: TiN-coated or vaporized



Walter Prototyp TC115 / TC216 Perform

## BENEFITS FOR YOU

- TiN coating: Long tool life
- Vaporized: Very good chip control; minimizes weld formation
- Flexibility through a wide range of applications with a variety of materials
- High process reliability

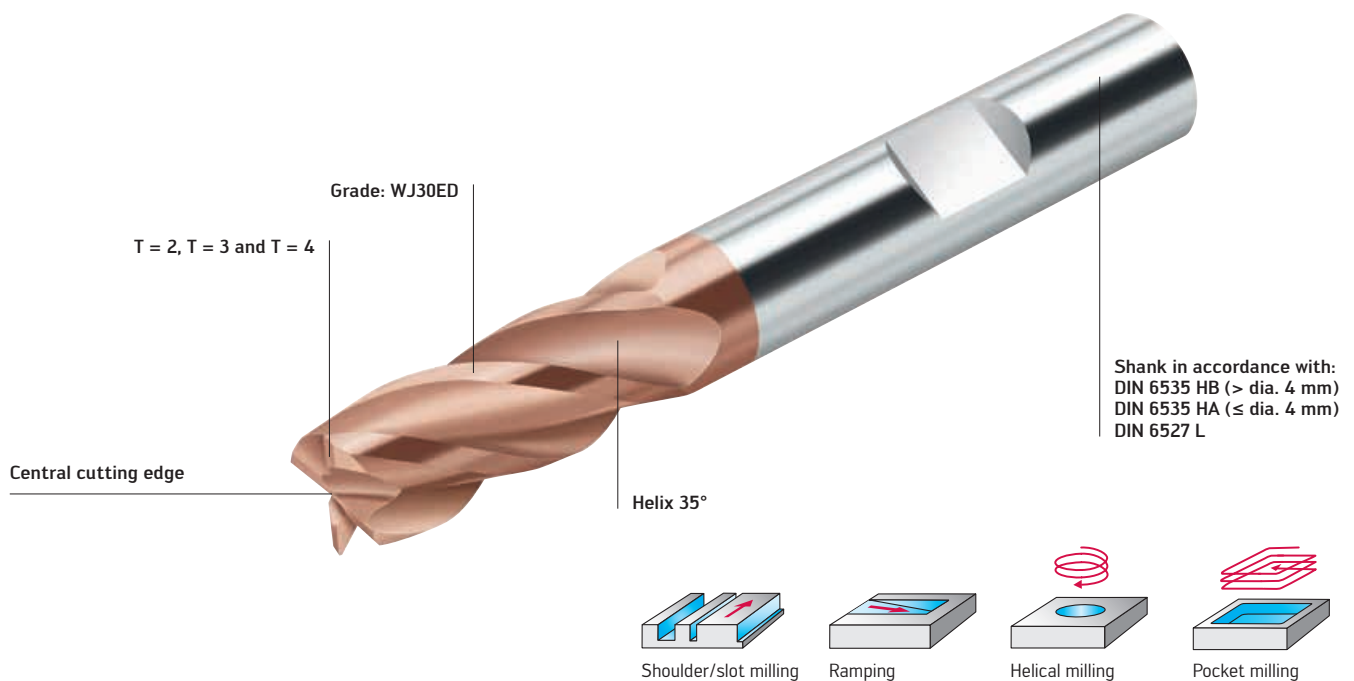
# Walter Prototyp MC232 Perform – universal use in ISO P, M and K.

## THE APPLICATION

- ISO material groups P, M and K
- Lateral milling, full slotting, pocket milling, helical plunging, ramping
- Areas of use: General mechanical engineering, mold and die making, and the automotive and energy industries

## THE TOOLS

- Solid carbide cutters from the Perform line
- Three cutter types; 51 dimensions
- With 2, 3 or 4 cutting edges
- Diameter range 2-20 mm
- Diameter range 0.125-0.625 inch



Walter Prototyp MC232 Perform

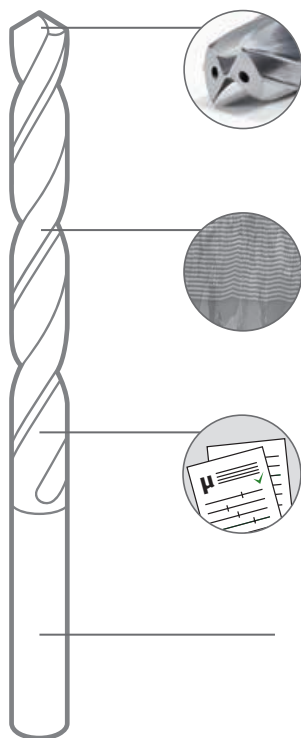
## BENEFITS FOR YOU

- Universal applicability
- Wide range of applications
- High level of cost efficiency for small and medium batch sizes



# Reconditioning to the original manufacturer quality really pays off.

The Reconditioning Service from Walter MultiPLY makes a significant contribution towards lowering your production costs. This service can offer you Walter Titex and Walter Prototyp tools that are as good as new, to the original manufacturer quality and all at an attractive price-performance ratio.



### ORIGINAL GEOMETRIES

Cutting edge geometries are extremely complex. During reconditioning, Walter employs its extensive engineering competence to return them to their original condition.

### ORIGINAL COATING

When it comes to tool performance, the coating is key. Only Walter uses the original coating process during reconditioning.

### ORIGINAL TOLERANCES

These tolerances and marks of quality are just as important when reconditioning as when Walter manufactures a completely new tool. To achieve this, we only use the most up-to-date measuring equipment.

### RECONDITIONING RANGE

- Solid carbide drills and milling cutters
- Solid carbide special boring tools and special milling tools
- High-performance solid carbide reaming tools
- Solid carbide thread milling cutters



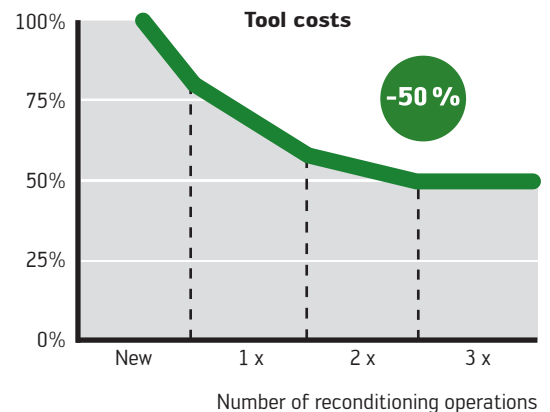
### OUR MARK OF 100% QUALITY

Look out for the "Original Walter Quality" label which indicates that a tool has been reconditioned to original manufacturer quality. It even appears in the ordering documents, meaning that you can immediately see for which tools we recommend our Reconditioning Service.

## 50% LOWER COSTS

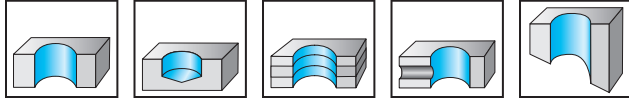
Tools are often disposed of far too early, even though the Walter Reconditioning Service can restore the tool a number of times to original manufacturer quality. You can benefit from reduced costs, reliable production processes and consistent tool life by reconditioning your tools at our Reconditioning Center, which is available worldwide. It could save you up to 50% on your tool costs!

Find out more at: [walter-tools.com/us](http://walter-tools.com/us)



# Solid carbide drill

## DC150 Perform



	P	M	K	N	S	H	O
WJ30RE	●	●	●	●	●	●	●

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
Shank DIN 6535 HA								
DC150-03-03.000A0-	3		14	62	20	36	6	●
DC150-03-03.100A0-	3.1		14	62	20	36	6	●
DC150-03-03.175A0-	3.175	1/8"	14	62	20	36	6	●
DC150-03-03.200A0-	3.2		14	62	20	36	6	●
DC150-03-03.250A0-	3.25		14	62	20	36	6	●
DC150-03-03.300A0-	3.3		14	62	20	36	6	●
DC150-03-03.400A0-	3.4		14	62	20	36	6	●
DC150-03-03.500A0-	3.5		14	62	20	36	6	●
DC150-03-03.572A0-	3.572	9/64"	14	62	20	36	6	●
DC150-03-03.600A0-	3.6		14	62	20	36	6	●
DC150-03-03.700A0-	3.7		14	62	20	36	6	●
DC150-03-03.800A0-	3.8		17	66	24	36	6	●
DC150-03-03.900A0-	3.9		17	66	24	36	6	●
DC150-03-03.969A0-	3.969	5/32"	17	66	24	36	6	●
DC150-03-04.000A0-	4		17	66	24	36	6	●
DC150-03-04.100A0-	4.1		17	66	24	36	6	●
DC150-03-04.200A0-	4.2		17	66	24	36	6	●
DC150-03-04.300A0-	4.3		17	66	24	36	6	●
DC150-03-04.366A0-	4.366	11/64"	17	66	24	36	6	●
DC150-03-04.400A0-	4.4		17	66	24	36	6	●
DC150-03-04.500A0-	4.5		17	66	24	36	6	●
DC150-03-04.600A0-	4.6		17	66	24	36	6	●
DC150-03-04.650A0-	4.65		17	66	24	36	6	●
DC150-03-04.700A0-	4.7		17	66	24	36	6	●
DC150-03-04.763A0-	4.763	3/16"	20	66	28	36	6	●
DC150-03-04.800A0-	4.8		20	66	28	36	6	●
DC150-03-04.900A0-	4.9		20	66	28	36	6	●
DC150-03-05.000A0-	5		20	66	28	36	6	●
DC150-03-05.100A0-	5.1		20	66	28	36	6	●
DC150-03-05.159A0-	5.159	13/64"	20	66	28	36	6	●
DC150-03-05.200A0-	5.2		20	66	28	36	6	●
DC150-03-05.300A0-	5.3		20	66	28	36	6	●
DC150-03-05.400A0-	5.4		20	66	28	36	6	●
DC150-03-05.500A0-	5.5		20	66	28	36	6	●
DC150-03-05.550A0-	5.55		20	66	28	36	6	●
DC150-03-05.556A0-	5.556	7/32"	20	66	28	36	6	●
DC150-03-05.600A0-	5.6		20	66	28	36	6	●
DC150-03-05.700A0-	5.7		20	66	28	36	6	●
DC150-03-05.800A0-	5.8		20	66	28	36	6	●
DC150-03-05.900A0-	5.9		20	66	28	36	6	●
DC150-03-05.953A0-	5.953	15/64"	20	66	28	36	6	●
DC150-03-06.000A0-	6		20	66	28	36	6	●
DC150-03-06.100A0-	6.1		24	79	34	36	8	●
DC150-03-06.200A0-	6.2		24	79	34	36	8	●
DC150-03-06.300A0-	6.3		24	79	34	36	8	●
DC150-03-06.350A0-	6.35	1/4"	24	79	34	36	8	●
DC150-03-06.400A0-	6.4		24	79	34	36	8	●

Ordering example for the WJ30RE grade: DC150-03-03.000A0-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

Continued



Continued

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
Shank DIN 6535 HA								
DC150-03-06.500A0-	6.5		24	79	34	36	8	☺
DC150-03-06.600A0-	6.6		24	79	34	36	8	☺
DC150-03-06.700A0-	6.7		24	79	34	36	8	☺
DC150-03-06.747A0-	6.747	17/64"	24	79	34	36	8	☺
DC150-03-06.800A0-	6.8		24	79	34	36	8	☺
DC150-03-06.900A0-	6.9		24	79	34	36	8	☺
DC150-03-07.000A0-	7		24	79	34	36	8	☺
DC150-03-07.100A0-	7.1		29	79	41	36	8	☺
DC150-03-07.144A0-	7.144	9/32"	29	79	41	36	8	☺
DC150-03-07.200A0-	7.2		29	79	41	36	8	☺
DC150-03-07.300A0-	7.3		29	79	41	36	8	☺
DC150-03-07.400A0-	7.4		29	79	41	36	8	☺
DC150-03-07.500A0-	7.5		29	79	41	36	8	☺
DC150-03-07.541A0-	7.541	19/64"	29	79	41	36	8	☺
DC150-03-07.600A0-	7.6		29	79	41	36	8	☺
DC150-03-07.700A0-	7.7		29	79	41	36	8	☺
DC150-03-07.800A0-	7.8		29	79	41	36	8	☺
DC150-03-07.900A0-	7.9		29	79	41	36	8	☺
DC150-03-07.938A0-	7.938	5/16"	29	79	41	36	8	☺
DC150-03-08.000A0-	8		29	79	41	36	8	☺
DC150-03-08.100A0-	8.1		35	89	47	40	10	☺
DC150-03-08.200A0-	8.2		35	89	47	40	10	☺
DC150-03-08.300A0-	8.3		35	89	47	40	10	☺
DC150-03-08.334A0-	8.334	21/64"	35	89	47	40	10	☺
DC150-03-08.400A0-	8.4		35	89	47	40	10	☺
DC150-03-08.500A0-	8.5		35	89	47	40	10	☺
DC150-03-08.600A0-	8.6		35	89	47	40	10	☺
DC150-03-08.700A0-	8.7		35	89	47	40	10	☺
DC150-03-08.731A0-	8.731	11/32"	35	89	47	40	10	☺
DC150-03-08.800A0-	8.8		35	89	47	40	10	☺
DC150-03-08.900A0-	8.9		35	89	47	40	10	☺
DC150-03-09.000A0-	9		35	89	47	40	10	☺
DC150-03-09.100A0-	9.1		35	89	47	40	10	☺
DC150-03-09.200A0-	9.2		35	89	47	40	10	☺
DC150-03-09.300A0-	9.3		35	89	47	40	10	☺
DC150-03-09.400A0-	9.4		35	89	47	40	10	☺
DC150-03-09.500A0-	9.5		35	89	47	40	10	☺
DC150-03-09.525A0-	9.525	3/8"	35	89	47	40	10	☺
DC150-03-09.600A0-	9.6		35	89	47	40	10	☺
DC150-03-09.700A0-	9.7		35	89	47	40	10	☺
DC150-03-09.800A0-	9.8		35	89	47	40	10	☺
DC150-03-09.900A0-	9.9		35	89	47	40	10	☺
DC150-03-09.922A0-	9.922	25/64"	35	89	47	40	10	☺
DC150-03-10.000A0-	10		35	89	47	40	10	☺
DC150-03-10.100A0-	10.1		40	102	55	45	12	☺
DC150-03-10.200A0-	10.2		40	102	55	45	12	☺
DC150-03-10.300A0-	10.3		40	102	55	45	12	☺
DC150-03-10.319A0-	10.319	13/32"	40	102	55	45	12	☺
DC150-03-10.400A0-	10.4		40	102	55	45	12	☺
DC150-03-10.500A0-	10.5		40	102	55	45	12	☺
DC150-03-10.600A0-	10.6		40	102	55	45	12	☺
DC150-03-10.716A0-	10.716	27/64"	40	102	55	45	12	☺
DC150-03-10.800A0-	10.8		40	102	55	45	12	☺
DC150-03-11.000A0-	11		40	102	55	45	12	☺

Ordering example for the WJ30RE grade: DC150-03-03.000A0-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹  
Poor

machining conditions

•• Primary application

• Other application

Continued



Continued

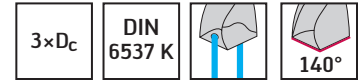
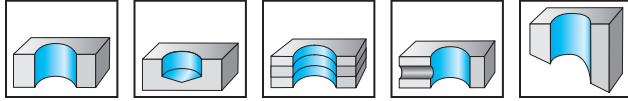
	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE	
	Shank DIN 6535 HA	DC150-03-11.100A0-	11.1		40	102	55	45	12	⊗
	DC150-03-11.113A0-	11.113	7/16"	40	102	55	45	12	12	⊗
	DC150-03-11.200A0-	11.2		40	102	55	45	12	12	⊗
	DC150-03-11.300A0-	11.3		40	102	55	45	12	12	⊗
	DC150-03-11.400A0-	11.4		40	102	55	45	12	12	⊗
	DC150-03-11.500A0-	11.5		40	102	55	45	12	12	⊗
	DC150-03-11.509A0-	11.509	29/64"	40	102	55	45	12	12	⊗
	DC150-03-11.700A0-	11.7		40	102	55	45	12	12	⊗
	DC150-03-11.800A0-	11.8		40	102	55	45	12	12	⊗
	DC150-03-11.900A0-	11.9		40	102	55	45	12	12	⊗
	DC150-03-12.000A0-	12		40	102	55	45	12	12	⊗
	DC150-03-12.100A0-	12.1		43	107	60	45	14	14	⊗
	DC150-03-12.200A0-	12.2		43	107	60	45	14	14	⊗
	DC150-03-12.250A0-	12.25		43	107	60	45	14	14	⊗
	DC150-03-12.300A0-	12.3		43	107	60	45	14	14	⊗
	DC150-03-12.303A0-	12.303	31/64"	43	107	60	45	14	14	⊗
	DC150-03-12.500A0-	12.5		43	107	60	45	14	14	⊗
	DC150-03-12.700A0-	12.7	1/2"	43	107	60	45	14	14	⊗
	DC150-03-12.800A0-	12.8		43	107	60	45	14	14	⊗
	DC150-03-13.000A0-	13		43	107	60	45	14	14	⊗
DC150-03-13.100A0-	13.1		43	107	60	45	14	14	⊗	
DC150-03-13.300A0-	13.3		43	107	60	45	14	14	⊗	
DC150-03-13.494A0-	13.494	17/32"	43	107	60	45	14	14	⊗	
DC150-03-13.500A0-	13.5		43	107	60	45	14	14	⊗	
DC150-03-14.000A0-	14		43	107	60	45	14	14	⊗	
DC150-03-14.200A0-	14.2		45	115	65	48	16	16	⊗	
DC150-03-14.288A0-	14.288	9/16"	45	115	65	48	16	16	⊗	
DC150-03-14.500A0-	14.5		45	115	65	48	16	16	⊗	
DC150-03-14.700A0-	14.7		45	115	65	48	16	16	⊗	
DC150-03-14.800A0-	14.8		45	115	65	48	16	16	⊗	
DC150-03-15.000A0-	15		45	115	65	48	16	16	⊗	
DC150-03-15.100A0-	15.1		45	115	65	48	16	16	⊗	
DC150-03-15.500A0-	15.5		45	115	65	48	16	16	⊗	
DC150-03-15.800A0-	15.8		45	115	65	48	16	16	⊗	
DC150-03-15.875A0-	15.875	5/8"	45	115	65	48	16	16	⊗	
DC150-03-16.000A0-	16		45	115	65	48	16	16	⊗	
DC150-03-16.500A0-	16.5		51	123	73	48	18	18	⊗	
DC150-03-16.750A0-	16.75		51	123	73	48	18	18	⊗	
DC150-03-17.000A0-	17		51	123	73	48	18	18	⊗	
DC150-03-17.500A0-	17.5		51	123	73	48	18	18	⊗	
DC150-03-17.800A0-	17.8		51	123	73	48	18	18	⊗	
DC150-03-18.000A0-	18		51	123	73	48	18	18	⊗	
DC150-03-19.000A0-	19		55	131	79	50	20	20	⊗	
DC150-03-20.000A0-	20		55	131	79	50	20	20	⊗	

Ordering example for the WJ30RE grade: DC150-03-03.000A0-WJ30RE

Some sizes offered with whistle notch shank. Check GPS for availability.

# Coolant-through solid carbide drill

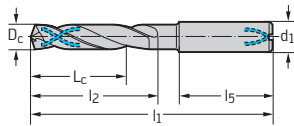
## DC150 Perform



P	M	K	N	S	H	O
●●	●	●●	●●	●●	●●	●

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
DC150-03-03.000A1-	3		14	62	20	36	6	☺
DC150-03-03.100A1-	3.1		14	62	20	36	6	☺
DC150-03-03.175A1-	3.175	1/8"	14	62	20	36	6	☺
DC150-03-03.200A1-	3.2		14	62	20	36	6	☺
DC150-03-03.250A1-	3.25		14	62	20	36	6	☺
DC150-03-03.300A1-	3.3		14	62	20	36	6	☺
DC150-03-03.400A1-	3.4		14	62	20	36	6	☺
DC150-03-03.500A1-	3.5		14	62	20	36	6	☺
DC150-03-03.572A1-	3.572	9/64"	14	62	20	36	6	☺
DC150-03-03.600A1-	3.6		14	62	20	36	6	☺
DC150-03-03.650A1-	3.65		14	62	20	36	6	☺
DC150-03-03.700A1-	3.7		14	62	20	36	6	☺
DC150-03-03.800A1-	3.8		17	66	24	36	6	☺
DC150-03-03.900A1-	3.9		17	66	24	36	6	☺
DC150-03-03.969A1-	3.969	5/32"	17	66	24	36	6	☺
DC150-03-04.000A1-	4		17	66	24	36	6	☺
DC150-03-04.100A1-	4.1		17	66	24	36	6	☺
DC150-03-04.200A1-	4.2		17	66	24	36	6	☺
DC150-03-04.300A1-	4.3		17	66	24	36	6	☺
DC150-03-04.366A1-	4.366	11/64"	17	66	24	36	6	☺
DC150-03-04.400A1-	4.4		17	66	24	36	6	☺
DC150-03-04.500A1-	4.5		17	66	24	36	6	☺
DC150-03-04.600A1-	4.6		17	66	24	36	6	☺
DC150-03-04.650A1-	4.65		17	66	24	36	6	☺
DC150-03-04.700A1-	4.7		17	66	24	36	6	☺
DC150-03-04.763A1-	4.763	3/16"	20	66	28	36	6	☺
DC150-03-04.800A1-	4.8		20	66	28	36	6	☺
DC150-03-04.900A1-	4.9		20	66	28	36	6	☺
DC150-03-05.000A1-	5		20	66	28	36	6	☺
DC150-03-05.100A1-	5.1		20	66	28	36	6	☺
DC150-03-05.159A1-	5.159	13/64"	20	66	28	36	6	☺
DC150-03-05.200A1-	5.2		20	66	28	36	6	☺
DC150-03-05.300A1-	5.3		20	66	28	36	6	☺
DC150-03-05.400A1-	5.4		20	66	28	36	6	☺
DC150-03-05.500A1-	5.5		20	66	28	36	6	☺
DC150-03-05.550A1-	5.55		20	66	28	36	6	☺
DC150-03-05.556A1-	5.556	7/32"	20	66	28	36	6	☺
DC150-03-05.600A1-	5.6		20	66	28	36	6	☺
DC150-03-05.700A1-	5.7		20	66	28	36	6	☺
DC150-03-05.800A1-	5.8		20	66	28	36	6	☺
DC150-03-05.900A1-	5.9		20	66	28	36	6	☺
DC150-03-05.953A1-	5.953	15/64"	20	66	28	36	6	☺
DC150-03-06.000A1-	6		20	66	28	36	6	☺

Shank DIN 6535 HA



Ordering example for the WJ30RE grade: DC150-03-03.000A1-WJ30RE  
Some sizes offered with whistle notch shank. Check GPS for availability.

WALTER SELECT

Best tool for

 Good
 Average
 Poor

Primary application

Other application

Continued



Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
Shank DIN 6535 HA 	DC150-03-06.100A1-	6.1		24	79	34	36	8	⊗
	DC150-03-06.200A1-	6.2		24	79	34	36	8	⊗
	DC150-03-06.300A1-	6.3		24	79	34	36	8	⊗
	DC150-03-06.350A1-	6.35	1/4"	24	79	34	36	8	⊗
	DC150-03-06.400A1-	6.4		24	79	34	36	8	⊗
	DC150-03-06.500A1-	6.5		24	79	34	36	8	⊗
	DC150-03-06.600A1-	6.6		24	79	34	36	8	⊗
	DC150-03-06.700A1-	6.7		24	79	34	36	8	⊗
	DC150-03-06.747A1-	6.747	17/64"	24	79	34	36	8	⊗
	DC150-03-06.800A1-	6.8		24	79	34	36	8	⊗
	DC150-03-06.900A1-	6.9		24	79	34	36	8	⊗
	DC150-03-07.000A1-	7		24	79	34	36	8	⊗
	DC150-03-07.100A1-	7.1		29	79	41	36	8	⊗
	DC150-03-07.144A1-	7.144	9/32"	29	79	41	36	8	⊗
	DC150-03-07.200A1-	7.2		29	79	41	36	8	⊗
	DC150-03-07.300A1-	7.3		29	79	41	36	8	⊗
	DC150-03-07.400A1-	7.4		29	79	41	36	8	⊗
	DC150-03-07.500A1-	7.5		29	79	41	36	8	⊗
	DC150-03-07.541A1-	7.541	19/64"	29	79	41	36	8	⊗
	DC150-03-07.600A1-	7.6		29	79	41	36	8	⊗
	DC150-03-07.700A1-	7.7		29	79	41	36	8	⊗
	DC150-03-07.800A1-	7.8		29	79	41	36	8	⊗
	DC150-03-07.900A1-	7.9		29	79	41	36	8	⊗
	DC150-03-07.938A1-	7.938	5/16"	29	79	41	36	8	⊗
	DC150-03-08.000A1-	8		29	79	41	36	8	⊗
	DC150-03-08.100A1-	8.1		35	89	47	40	10	⊗
	DC150-03-08.200A1-	8.2		35	89	47	40	10	⊗
	DC150-03-08.300A1-	8.3		35	89	47	40	10	⊗
	DC150-03-08.334A1-	8.334	21/64"	35	89	47	40	10	⊗
	DC150-03-08.400A1-	8.4		35	89	47	40	10	⊗
	DC150-03-08.500A1-	8.5		35	89	47	40	10	⊗
	DC150-03-08.600A1-	8.6		35	89	47	40	10	⊗
	DC150-03-08.700A1-	8.7		35	89	47	40	10	⊗
	DC150-03-08.731A1-	8.731	11/32"	35	89	47	40	10	⊗
	DC150-03-08.800A1-	8.8		35	89	47	40	10	⊗
	DC150-03-08.900A1-	8.9		35	89	47	40	10	⊗
	DC150-03-09.000A1-	9		35	89	47	40	10	⊗
	DC150-03-09.100A1-	9.1		35	89	47	40	10	⊗
DC150-03-09.128A1-	9.128	23/64"	35	89	47	40	10	⊗	
DC150-03-09.200A1-	9.2		35	89	47	40	10	⊗	
DC150-03-09.300A1-	9.3		35	89	47	40	10	⊗	
DC150-03-09.400A1-	9.4		35	89	47	40	10	⊗	
DC150-03-09.500A1-	9.5		35	89	47	40	10	⊗	
DC150-03-09.525A1-	9.525	3/8"	35	89	47	40	10	⊗	
DC150-03-09.600A1-	9.6		35	89	47	40	10	⊗	
DC150-03-09.700A1-	9.7		35	89	47	40	10	⊗	
DC150-03-09.800A1-	9.8		35	89	47	40	10	⊗	
DC150-03-09.900A1-	9.9		35	89	47	40	10	⊗	
DC150-03-09.922A1-	9.922	25/64"	35	89	47	40	10	⊗	
DC150-03-10.000A1-	10		35	89	47	40	10	⊗	
DC150-03-10.100A1-	10.1		40	102	55	45	12	⊗	
DC150-03-10.200A1-	10.2		40	102	55	45	12	⊗	
DC150-03-10.300A1-	10.3		40	102	55	45	12	⊗	
DC150-03-10.319A1-	10.319	13/32"	40	102	55	45	12	⊗	
DC150-03-10.400A1-	10.4		40	102	55	45	12	⊗	
DC150-03-10.500A1-	10.5		40	102	55	45	12	⊗	
DC150-03-10.600A1-	10.6		40	102	55	45	12	⊗	
DC150-03-10.700A1-	10.7		40	102	55	45	12	⊗	
DC150-03-10.716A1-	10.716	27/64"	40	102	55	45	12	⊗	
DC150-03-10.800A1-	10.8		40	102	55	45	12	⊗	
DC150-03-10.900A1-	10.9		40	102	55	45	12	⊗	

 Ordering example for the WJ30RE grade: DC150-03-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

Continued



Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
	DC150-03-11.000A1-	11		40	102	55	45	12	☺
	DC150-03-11.100A1-	11.1		40	102	55	45	12	☺
	DC150-03-11.113A1-	11.113	7/16"	40	102	55	45	12	☺
	DC150-03-11.200A1-	11.2		40	102	55	45	12	☺
	DC150-03-11.300A1-	11.3		40	102	55	45	12	☺
	DC150-03-11.400A1-	11.4		40	102	55	45	12	☺
	DC150-03-11.500A1-	11.5		40	102	55	45	12	☺
	DC150-03-11.509A1-	11.509	29/64"	40	102	55	45	12	☺
	DC150-03-11.600A1-	11.6		40	102	55	45	12	☺
	DC150-03-11.700A1-	11.7		40	102	55	45	12	☺
	DC150-03-11.800A1-	11.8		40	102	55	45	12	☺
	DC150-03-11.900A1-	11.9		40	102	55	45	12	☺
	DC150-03-11.906A1-	11.906	15/32"	40	102	55	45	12	☺
	DC150-03-12.000A1-	12		40	102	55	45	12	☺
	DC150-03-12.100A1-	12.1		43	107	60	45	14	☺
	DC150-03-12.200A1-	12.2		43	107	60	45	14	☺
	DC150-03-12.300A1-	12.3		43	107	60	45	14	☺
	DC150-03-12.303A1-	12.303	31/64"	43	107	60	45	14	☺
	DC150-03-12.500A1-	12.5		43	107	60	45	14	☺
	DC150-03-12.600A1-	12.6		43	107	60	45	14	☺
	DC150-03-12.700A1-	12.7	1/2"	43	107	60	45	14	☺
	DC150-03-12.800A1-	12.8		43	107	60	45	14	☺
	DC150-03-12.900A1-	12.9		43	107	60	45	14	☺
	DC150-03-13.000A1-	13		43	107	60	45	14	☺
	DC150-03-13.100A1-	13.1		43	107	60	45	14	☺
	DC150-03-13.200A1-	13.2		43	107	60	45	14	☺
	DC150-03-13.300A1-	13.3		43	107	60	45	14	☺
	DC150-03-13.494A1-	13.494	17/32"	43	107	60	45	14	☺
	DC150-03-13.500A1-	13.5		43	107	60	45	14	☺
	DC150-03-13.800A1-	13.8		43	107	60	45	14	☺
	DC150-03-14.000A1-	14		43	107	60	45	14	☺
	DC150-03-14.100A1-	14.1		45	115	65	48	16	☺
	DC150-03-14.200A1-	14.2		45	115	65	48	16	☺
	DC150-03-14.288A1-	14.288	9/16"	45	115	65	48	16	☺
	DC150-03-14.500A1-	14.5		45	115	65	48	16	☺
	DC150-03-14.600A1-	14.6		45	115	65	48	16	☺
	DC150-03-14.700A1-	14.7		45	115	65	48	16	☺
	DC150-03-15.000A1-	15		45	115	65	48	16	☺
	DC150-03-15.100A1-	15.1		45	115	65	48	16	☺
	DC150-03-15.300A1-	15.3		45	115	65	48	16	☺
DC150-03-15.500A1-	15.5		45	115	65	48	16	☺	
DC150-03-15.700A1-	15.7		45	115	65	48	16	☺	
DC150-03-15.800A1-	15.8		45	115	65	48	16	☺	
DC150-03-15.875A1-	15.875	5/8"	45	115	65	48	16	☺	
DC150-03-16.000A1-	16		45	115	65	48	16	☺	
DC150-03-16.300A1-	16.3		51	123	73	48	18	☺	
DC150-03-16.500A1-	16.5		51	123	73	48	18	☺	
DC150-03-16.700A1-	16.7		51	123	73	48	18	☺	
DC150-03-17.000A1-	17		51	123	73	48	18	☺	
DC150-03-17.500A1-	17.5		51	123	73	48	18	☺	
DC150-03-18.000A1-	18		51	123	73	48	18	☺	
DC150-03-18.500A1-	18.5		55	131	79	50	20	☺	
DC150-03-19.000A1-	19		55	131	79	50	20	☺	
DC150-03-19.050A1-	19.05	3/4"	55	131	79	50	20	☺	
DC150-03-20.000A1-	20		55	131	79	50	20	☺	

Ordering example for the WJ30RE grade: DC150-03-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹  
Poor

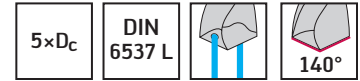
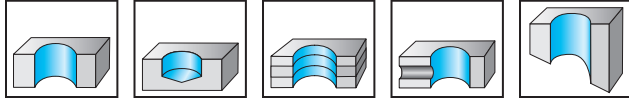
machining conditions

•• Primary application

• Other application

# Coolant-through solid carbide drill

## DC150 Perform



	P	M	K	N	S	H	O
WJ30RE	●	●	●	●	●	●	●

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
Shank DIN 6535 HA								
DC150-05-03.000A1-	3		23	66	28	36	6	●
DC150-05-03.100A1-	3.1		23	66	28	36	6	●
DC150-05-03.175A1-	3.175	1/8"	23	66	28	36	6	●
DC150-05-03.200A1-	3.2		23	66	28	36	6	●
DC150-05-03.250A1-	3.25		23	66	28	36	6	●
DC150-05-03.300A1-	3.3		23	66	28	36	6	●
DC150-05-03.400A1-	3.4		23	66	28	36	6	●
DC150-05-03.500A1-	3.5		23	66	28	36	6	●
DC150-05-03.572A1-	3.572	9/64"	23	66	28	36	6	●
DC150-05-03.600A1-	3.6		23	66	28	36	6	●
DC150-05-03.650A1-	3.65		23	66	28	36	6	●
DC150-05-03.700A1-	3.7		23	66	28	36	6	●
DC150-05-03.800A1-	3.8		29	74	36	36	6	●
DC150-05-03.900A1-	3.9		29	74	36	36	6	●
DC150-05-03.969A1-	3.969	5/32"	29	74	36	36	6	●
DC150-05-04.000A1-	4		29	74	36	36	6	●
DC150-05-04.100A1-	4.1		29	74	36	36	6	●
DC150-05-04.200A1-	4.2		29	74	36	36	6	●
DC150-05-04.300A1-	4.3		29	74	36	36	6	●
DC150-05-04.366A1-	4.366	11/64"	29	74	36	36	6	●
DC150-05-04.400A1-	4.4		29	74	36	36	6	●
DC150-05-04.500A1-	4.5		29	74	36	36	6	●
DC150-05-04.600A1-	4.6		29	74	36	36	6	●
DC150-05-04.650A1-	4.65		29	74	36	36	6	●
DC150-05-04.700A1-	4.7		29	74	36	36	6	●
DC150-05-04.763A1-	4.763	3/16"	35	82	44	36	6	●
DC150-05-04.800A1-	4.8		35	82	44	36	6	●
DC150-05-04.900A1-	4.9		35	82	44	36	6	●
DC150-05-05.000A1-	5		35	82	44	36	6	●
DC150-05-05.100A1-	5.1		35	82	44	36	6	●
DC150-05-05.159A1-	5.159	13/64"	35	82	44	36	6	●
DC150-05-05.200A1-	5.2		35	82	44	36	6	●
DC150-05-05.300A1-	5.3		35	82	44	36	6	●
DC150-05-05.400A1-	5.4		35	82	44	36	6	●
DC150-05-05.500A1-	5.5		35	82	44	36	6	●
DC150-05-05.550A1-	5.55		35	82	44	36	6	●
DC150-05-05.556A1-	5.556	7/32"	35	82	44	36	6	●
DC150-05-05.600A1-	5.6		35	82	44	36	6	●
DC150-05-05.700A1-	5.7		35	82	44	36	6	●
DC150-05-05.800A1-	5.8		35	82	44	36	6	●
DC150-05-05.900A1-	5.9		35	82	44	36	6	●
DC150-05-05.953A1-	5.953	15/64"	35	82	44	36	6	●
DC150-05-06.000A1-	6		35	82	44	36	6	●
DC150-05-06.100A1-	6.1		43	91	53	36	8	●
DC150-05-06.200A1-	6.2		43	91	53	36	8	●
DC150-05-06.300A1-	6.3		43	91	53	36	8	●
DC150-05-06.350A1-	6.35	1/4"	43	91	53	36	8	●

Ordering example for the WJ30RE grade: DC150-05-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

Continued





Continued

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
Shank DIN 6535 HA								
DC150-05-06.400A1-	6.4		43	91	53	36	8	☹
DC150-05-06.500A1-	6.5		43	91	53	36	8	☹
DC150-05-06.600A1-	6.6		43	91	53	36	8	☹
DC150-05-06.700A1-	6.7		43	91	53	36	8	☹
DC150-05-06.747A1-	6.747	17/64"	43	91	53	36	8	☹
DC150-05-06.800A1-	6.8		43	91	53	36	8	☹
DC150-05-06.900A1-	6.9		43	91	53	36	8	☹
DC150-05-07.000A1-	7		43	91	53	36	8	☹
DC150-05-07.100A1-	7.1		43	91	53	36	8	☹
DC150-05-07.144A1-	7.144	9/32"	43	91	53	36	8	☹
DC150-05-07.200A1-	7.2		43	91	53	36	8	☹
DC150-05-07.300A1-	7.3		43	91	53	36	8	☹
DC150-05-07.400A1-	7.4		43	91	53	36	8	☹
DC150-05-07.500A1-	7.5		43	91	53	36	8	☹
DC150-05-07.541A1-	7.541	19/64"	43	91	53	36	8	☹
DC150-05-07.550A1-	7.55		43	91	53	36	8	☹
DC150-05-07.600A1-	7.6		43	91	53	36	8	☹
DC150-05-07.700A1-	7.7		43	91	53	36	8	☹
DC150-05-07.800A1-	7.8		43	91	53	36	8	☹
DC150-05-07.900A1-	7.9		43	91	53	36	8	☹
DC150-05-07.938A1-	7.938	5/16"	43	91	53	36	8	☹
DC150-05-08.000A1-	8		43	91	53	36	8	☹
DC150-05-08.100A1-	8.1		49	103	61	40	10	☹
DC150-05-08.200A1-	8.2		49	103	61	40	10	☹
DC150-05-08.300A1-	8.3		49	103	61	40	10	☹
DC150-05-08.334A1-	8.334	21/64"	49	103	61	40	10	☹
DC150-05-08.400A1-	8.4		49	103	61	40	10	☹
DC150-05-08.500A1-	8.5		49	103	61	40	10	☹
DC150-05-08.600A1-	8.6		49	103	61	40	10	☹
DC150-05-08.700A1-	8.7		49	103	61	40	10	☹
DC150-05-08.731A1-	8.731	11/32"	49	103	61	40	10	☹
DC150-05-08.800A1-	8.8		49	103	61	40	10	☹
DC150-05-08.900A1-	8.9		49	103	61	40	10	☹
DC150-05-09.000A1-	9		49	103	61	40	10	☹
DC150-05-09.100A1-	9.1		49	103	61	40	10	☹
DC150-05-09.128A1-	9.128	23/64"	49	103	61	40	10	☹
DC150-05-09.200A1-	9.2		49	103	61	40	10	☹
DC150-05-09.300A1-	9.3		49	103	61	40	10	☹
DC150-05-09.400A1-	9.4		49	103	61	40	10	☹
DC150-05-09.500A1-	9.5		49	103	61	40	10	☹
DC150-05-09.525A1-	9.525	3/8"	49	103	61	40	10	☹
DC150-05-09.550A1-	9.55		49	103	61	40	10	☹
DC150-05-09.600A1-	9.6		49	103	61	40	10	☹
DC150-05-09.700A1-	9.7		49	103	61	40	10	☹
DC150-05-09.800A1-	9.8		49	103	61	40	10	☹
DC150-05-09.900A1-	9.9		49	103	61	40	10	☹
DC150-05-09.922A1-	9.922	25/64"	49	103	61	40	10	☹
DC150-05-10.000A1-	10		49	103	61	40	10	☹
DC150-05-10.100A1-	10.1		56	118	71	45	12	☹
DC150-05-10.200A1-	10.2		56	118	71	45	12	☹
DC150-05-10.300A1-	10.3		56	118	71	45	12	☹
DC150-05-10.319A1-	10.319	13/32"	56	118	71	45	12	☹
DC150-05-10.400A1-	10.4		56	118	71	45	12	☹
DC150-05-10.500A1-	10.5		56	118	71	45	12	☹

Ordering example for the WJ30RE grade: DC150-05-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

•• Primary application

• Other application

Continued

37

9

Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE	
	Shank DIN 6535 HA	DC150-05-10.600A1-	10.6		56	118	71	45	12	⊗
		DC150-05-10.700A1-	10.7		56	118	71	45	12	⊗
		DC150-05-10.716A1-	10.716	27/64"	56	118	71	45	12	⊗
		DC150-05-10.800A1-	10.8		56	118	71	45	12	⊗
		DC150-05-10.900A1-	10.9		56	118	71	45	12	⊗
		DC150-05-11.000A1-	11		56	118	71	45	12	⊗
		DC150-05-11.100A1-	11.1		56	118	71	45	12	⊗
		DC150-05-11.113A1-	11.113	7/16"	56	118	71	45	12	⊗
		DC150-05-11.200A1-	11.2		56	118	71	45	12	⊗
		DC150-05-11.300A1-	11.3		56	118	71	45	12	⊗
		DC150-05-11.400A1-	11.4		56	118	71	45	12	⊗
		DC150-05-11.500A1-	11.5		56	118	71	45	12	⊗
		DC150-05-11.509A1-	11.509	29/64"	56	118	71	45	12	⊗
		DC150-05-11.600A1-	11.6		56	118	71	45	12	⊗
		DC150-05-11.700A1-	11.7		56	118	71	45	12	⊗
		DC150-05-11.800A1-	11.8		56	118	71	45	12	⊗
		DC150-05-11.900A1-	11.9		56	118	71	45	12	⊗
		DC150-05-11.906A1-	11.906	15/32"	56	118	71	45	12	⊗
		DC150-05-12.000A1-	12		56	118	71	45	12	⊗
		DC150-05-12.100A1-	12.1		60	124	77	45	14	⊗
		DC150-05-12.200A1-	12.2		60	124	77	45	14	⊗
		DC150-05-12.250A1-	12.25		60	124	77	45	14	⊗
		DC150-05-12.300A1-	12.3		60	124	77	45	14	⊗
		DC150-05-12.303A1-	12.303	31/64"	60	124	77	45	14	⊗
		DC150-05-12.400A1-	12.4		60	124	77	45	14	⊗
		DC150-05-12.500A1-	12.5		60	124	77	45	14	⊗
		DC150-05-12.600A1-	12.6		60	124	77	45	14	⊗
		DC150-05-12.700A1-	12.7	1/2"	60	124	77	45	14	⊗
		DC150-05-12.800A1-	12.8		60	124	77	45	14	⊗
		DC150-05-12.900A1-	12.9		60	124	77	45	14	⊗
		DC150-05-13.000A1-	13		60	124	77	45	14	⊗
		DC150-05-13.100A1-	13.1		60	124	77	45	14	⊗
		DC150-05-13.200A1-	13.2		60	124	77	45	14	⊗
		DC150-05-13.300A1-	13.3		60	124	77	45	14	⊗
		DC150-05-13.400A1-	13.4		60	124	77	45	14	⊗
		DC150-05-13.494A1-	13.494	17/32"	60	124	77	45	14	⊗
		DC150-05-13.500A1-	13.5		60	124	77	45	14	⊗
	DC150-05-13.600A1-	13.6		60	124	77	45	14	⊗	
	DC150-05-13.700A1-	13.7		60	124	77	45	14	⊗	
	DC150-05-13.800A1-	13.8		60	124	77	45	14	⊗	
	DC150-05-13.900A1-	13.9		60	124	77	45	14	⊗	
	DC150-05-14.000A1-	14		60	124	77	45	14	⊗	
	DC150-05-14.100A1-	14.1		63	133	83	48	16	⊗	
	DC150-05-14.200A1-	14.2		63	133	83	48	16	⊗	
	DC150-05-14.288A1-	14.288	9/16"	63	133	83	48	16	⊗	
	DC150-05-14.300A1-	14.3		63	133	83	48	16	⊗	
	DC150-05-14.500A1-	14.5		63	133	83	48	16	⊗	
	DC150-05-14.600A1-	14.6		63	133	83	48	16	⊗	
	DC150-05-14.700A1-	14.7		63	133	83	48	16	⊗	
	DC150-05-14.750A1-	14.75		63	133	83	48	16	⊗	
	DC150-05-14.800A1-	14.8		63	133	83	48	16	⊗	
	DC150-05-15.000A1-	15		63	133	83	48	16	⊗	
	DC150-05-15.100A1-	15.1		63	133	83	48	16	⊗	
	DC150-05-15.200A1-	15.2		63	133	83	48	16	⊗	
	DC150-05-15.300A1-	15.3		63	133	83	48	16	⊗	
	DC150-05-15.500A1-	15.5		63	133	83	48	16	⊗	
	DC150-05-15.600A1-	15.6		63	133	83	48	16	⊗	
	DC150-05-15.700A1-	15.7		63	133	83	48	16	⊗	

 Ordering example for the WJ30RE grade: DC150-05-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

Continued

Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30RE
	DC150-05-15.800A1-	15.8		63	133	83	48	16	☺
	DC150-05-15.875A1-	15.875	5/8"	63	133	83	48	16	☺
	DC150-05-16.000A1-	16		63	133	83	48	16	☺
	DC150-05-16.100A1-	16.1		71	143	93	48	18	☺
	DC150-05-16.200A1-	16.2		71	143	93	48	18	☺
	DC150-05-16.300A1-	16.3		71	143	93	48	18	☺
	DC150-05-16.500A1-	16.5		71	143	93	48	18	☺
	DC150-05-16.700A1-	16.7		71	143	93	48	18	☺
	DC150-05-16.750A1-	16.75		71	143	93	48	18	☺
	DC150-05-17.000A1-	17		71	143	93	48	18	☺
	DC150-05-17.100A1-	17.1		71	143	93	48	18	☺
	DC150-05-17.200A1-	17.2		71	143	93	48	18	☺
	DC150-05-17.300A1-	17.3		71	143	93	48	18	☺
	DC150-05-17.500A1-	17.5		71	143	93	48	18	☺
	DC150-05-17.600A1-	17.6		71	143	93	48	18	☺
	DC150-05-17.700A1-	17.7		71	143	93	48	18	☺
	DC150-05-17.800A1-	17.8		71	143	93	48	18	☺
	DC150-05-17.900A1-	17.9		71	143	93	48	18	☺
	DC150-05-18.000A1-	18		71	143	93	48	18	☺
	DC150-05-18.500A1-	18.5		77	153	101	50	20	☺
	DC150-05-18.900A1-	18.9		77	153	101	50	20	☺
	DC150-05-19.000A1-	19		77	153	101	50	20	☺
	DC150-05-19.050A1-	19.05	3/4"	77	153	101	50	20	☺
	DC150-05-19.300A1-	19.3		77	153	101	50	20	☺
	DC150-05-19.500A1-	19.5		77	153	101	50	20	☺
	DC150-05-19.700A1-	19.7		77	153	101	50	20	☺
	DC150-05-19.800A1-	19.8		77	153	101	50	20	☺
	DC150-05-20.000A1-	20		77	153	101	50	20	☺

Ordering example for the WJ30RE grade: DC150-05-03.000A1-WJ30RE  
 Some sizes offered with whistle notch shank. Check GPS for availability.

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹  
Poor

machining conditions

•• Primary application

• Other application

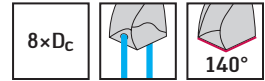
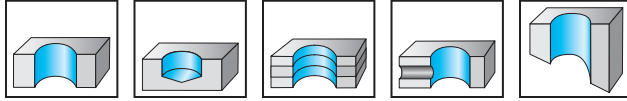
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37

9

# Coolant-through solid carbide drill

## DC150 Perform



	P	M	K	N	S	H	O
WJ30TA	●	●	●	●	●	●	●

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA
Shank DIN 6535 HA								
DC150-08-03.000A1-	3		28	74	34	36	6	⊗
DC150-08-03.100A1-	3.1		28	74	34	36	6	⊗
DC150-08-03.175A1-	3.175	1/8"	28	74	34	36	6	⊗
DC150-08-03.200A1-	3.2		28	74	34	36	6	⊗
DC150-08-03.300A1-	3.3		28	74	34	36	6	⊗
DC150-08-03.400A1-	3.4		28	74	34	36	6	⊗
DC150-08-03.500A1-	3.5		28	74	34	36	6	⊗
DC150-08-03.572A1-	3.572	9/64"	28	74	34	36	6	⊗
DC150-08-03.600A1-	3.6		28	74	34	36	6	⊗
DC150-08-03.700A1-	3.7		28	74	34	36	6	⊗
DC150-08-03.800A1-	3.8		37	85	45	36	6	⊗
DC150-08-03.900A1-	3.9		37	85	45	36	6	⊗
DC150-08-03.969A1-	3.969	5/32"	37	85	45	36	6	⊗
DC150-08-04.000A1-	4		37	85	45	36	6	⊗
DC150-08-04.100A1-	4.1		37	85	45	36	6	⊗
DC150-08-04.200A1-	4.2		37	85	45	36	6	⊗
DC150-08-04.300A1-	4.3		37	85	45	36	6	⊗
DC150-08-04.366A1-	4.366	11/64"	37	85	45	36	6	⊗
DC150-08-04.400A1-	4.4		37	85	45	36	6	⊗
DC150-08-04.500A1-	4.5		37	85	45	36	6	⊗
DC150-08-04.600A1-	4.6		37	85	45	36	6	⊗
DC150-08-04.700A1-	4.7		37	85	45	36	6	⊗
DC150-08-04.763A1-	4.763	3/16"	37	85	45	36	6	⊗
DC150-08-04.800A1-	4.8		48	97	57	36	6	⊗
DC150-08-04.900A1-	4.9		48	97	57	36	6	⊗
DC150-08-05.000A1-	5		48	97	57	36	6	⊗
DC150-08-05.100A1-	5.1		48	97	57	36	6	⊗
DC150-08-05.159A1-	5.159	13/64"	48	97	57	36	6	⊗
DC150-08-05.200A1-	5.2		48	97	57	36	6	⊗
DC150-08-05.300A1-	5.3		48	97	57	36	6	⊗
DC150-08-05.400A1-	5.4		48	97	57	36	6	⊗
DC150-08-05.500A1-	5.5		48	97	57	36	6	⊗
DC150-08-05.556A1-	5.556	7/32"	48	97	57	36	6	⊗
DC150-08-05.600A1-	5.6		48	97	57	36	6	⊗
DC150-08-05.700A1-	5.7		48	97	57	36	6	⊗
DC150-08-05.800A1-	5.8		48	97	57	36	6	⊗
DC150-08-05.900A1-	5.9		48	97	57	36	6	⊗
DC150-08-05.953A1-	5.953	15/64"	48	97	57	36	6	⊗
DC150-08-06.000A1-	6		48	97	57	36	6	⊗
DC150-08-06.100A1-	6.1		55	106	66	36	8	⊗
DC150-08-06.200A1-	6.2		55	106	66	36	8	⊗
DC150-08-06.300A1-	6.3		55	106	66	36	8	⊗
DC150-08-06.350A1-	6.35	1/4"	55	106	66	36	8	⊗
DC150-08-06.400A1-	6.4		55	106	66	36	8	⊗
DC150-08-06.500A1-	6.5		55	106	66	36	8	⊗
DC150-08-06.600A1-	6.6		55	106	66	36	8	⊗
DC150-08-06.700A1-	6.7		55	106	66	36	8	⊗

Ordering example for the WJ30TA grade: DC150-08-03.000A1-WJ30TA

Continued



Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA	
	DC150-08-06.747A1-	6.747	17/64"	55	106	66	36	8	☺☺	
	DC150-08-06.800A1-	6.8		55	106	66	36	8	☺☺	
	DC150-08-06.900A1-	6.9		55	106	66	36	8	☺☺	
	DC150-08-07.000A1-	7		55	106	66	36	8	☺☺	
	DC150-08-07.100A1-	7.1		64	116	76	36	8	☺☺	
	DC150-08-07.144A1-	7.144	9/32"	64	116	76	36	8	☺☺	
	DC150-08-07.200A1-	7.2		64	116	76	36	8	☺☺	
	DC150-08-07.300A1-	7.3		64	116	76	36	8	☺☺	
	DC150-08-07.400A1-	7.4		64	116	76	36	8	☺☺	
	DC150-08-07.500A1-	7.5		64	116	76	36	8	☺☺	
	DC150-08-07.541A1-	7.541	19/64"	64	116	76	36	36	8	☺☺
	DC150-08-07.600A1-	7.6		64	116	76	36	36	8	☺☺
	DC150-08-07.700A1-	7.7		64	116	76	36	36	8	☺☺
	DC150-08-07.800A1-	7.8		64	116	76	36	36	8	☺☺
	DC150-08-07.900A1-	7.9		64	116	76	36	36	8	☺☺
	DC150-08-07.938A1-	7.938	5/16"	64	116	76	36	36	8	☺☺
	DC150-08-08.000A1-	8		64	116	76	36	36	8	☺☺
	DC150-08-08.100A1-	8.1		80	139	95	40	10	10	☺☺
	DC150-08-08.200A1-	8.2		80	139	95	40	10	10	☺☺
	DC150-08-08.300A1-	8.3		80	139	95	40	10	10	☺☺
	DC150-08-08.334A1-	8.334	21/64"	80	139	95	40	10	10	☺☺
	DC150-08-08.400A1-	8.4		80	139	95	40	10	10	☺☺
	DC150-08-08.500A1-	8.5		80	139	95	40	10	10	☺☺
	DC150-08-08.600A1-	8.6		80	139	95	40	10	10	☺☺
	DC150-08-08.700A1-	8.7		80	139	95	40	10	10	☺☺
	DC150-08-08.731A1-	8.731	11/32"	80	139	95	40	10	10	☺☺
	DC150-08-08.800A1-	8.8		80	139	95	40	10	10	☺☺
	DC150-08-08.900A1-	8.9		80	139	95	40	10	10	☺☺
	DC150-08-09.000A1-	9		80	139	95	40	10	10	☺☺
	DC150-08-09.100A1-	9.1		80	139	95	40	10	10	☺☺
	DC150-08-09.128A1-	9.128	23/64"	80	139	95	40	10	10	☺☺
	DC150-08-09.200A1-	9.2		80	139	95	40	10	10	☺☺
	DC150-08-09.300A1-	9.3		80	139	95	40	10	10	☺☺
DC150-08-09.400A1-	9.4		80	139	95	40	10	10	☺☺	
DC150-08-09.500A1-	9.5		80	139	95	40	10	10	☺☺	
DC150-08-09.525A1-	9.525	3/8"	80	139	95	40	10	10	☺☺	
DC150-08-09.600A1-	9.6		80	139	95	40	10	10	☺☺	
DC150-08-09.700A1-	9.7		80	139	95	40	10	10	☺☺	
DC150-08-09.800A1-	9.8		80	139	95	40	10	10	☺☺	
DC150-08-09.900A1-	9.9		80	139	95	40	10	10	☺☺	
DC150-08-09.922A1-	9.922	25/64"	80	139	95	40	10	10	☺☺	
DC150-08-10.000A1-	10		80	139	95	40	10	10	☺☺	
DC150-08-10.100A1-	10.1		96	163	114	45	12	12	☺☺	
DC150-08-10.200A1-	10.2		96	163	114	45	12	12	☺☺	
DC150-08-10.300A1-	10.3		96	163	114	45	12	12	☺☺	
DC150-08-10.319A1-	10.319	13/32"	96	163	114	45	12	12	☺☺	
DC150-08-10.400A1-	10.4		96	163	114	45	12	12	☺☺	
DC150-08-10.500A1-	10.5		96	163	114	45	12	12	☺☺	
DC150-08-10.700A1-	10.7		96	163	114	45	12	12	☺☺	
DC150-08-10.716A1-	10.716	27/64"	96	163	114	45	12	12	☺☺	
DC150-08-10.800A1-	10.8		96	163	114	45	12	12	☺☺	
DC150-08-10.900A1-	10.9		96	163	114	45	12	12	☺☺	
DC150-08-11.000A1-	11		96	163	114	45	12	12	☺☺	
DC150-08-11.100A1-	11.1		96	163	114	45	12	12	☺☺	

Ordering example for the WJ30TA grade: DC150-08-03.000A1-WJ30TA

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹☹  
Poor

machining conditions

•• Primary application

• Other application

Continued

37

9

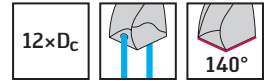
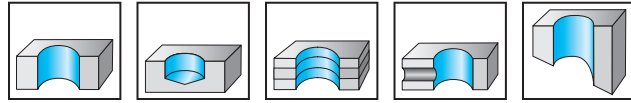
Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA
	Shank DIN 6535 HA								
	DC150-08-11.113A1-	11.113	7/16"	96	163	114	45	12	⊗
	DC150-08-11.200A1-	11.2		96	163	114	45	12	⊗
	DC150-08-11.300A1-	11.3		96	163	114	45	12	⊗
	DC150-08-11.500A1-	11.5		96	163	114	45	12	⊗
	DC150-08-11.600A1-	11.6		96	163	114	45	12	⊗
	DC150-08-11.700A1-	11.7		96	163	114	45	12	⊗
	DC150-08-11.800A1-	11.8		96	163	114	45	12	⊗
	DC150-08-11.900A1-	11.9		96	163	114	45	12	⊗
	DC150-08-11.906A1-	11.906	15/32"	96	163	114	45	12	⊗
	DC150-08-12.000A1-	12		96	163	114	45	12	⊗
	DC150-08-12.303A1-	12.303	31/64"	119	182	133	45	14	⊗
	DC150-08-12.500A1-	12.5		119	182	133	45	14	⊗
	DC150-08-12.700A1-	12.7	1/2"	119	182	133	45	14	⊗
	DC150-08-13.000A1-	13		119	182	133	45	14	⊗
	DC150-08-13.494A1-	13.494	17/32"	119	182	133	45	14	⊗
	DC150-08-13.500A1-	13.5		119	182	133	45	14	⊗
	DC150-08-14.000A1-	14		119	182	133	45	14	⊗
	DC150-08-14.288A1-	14.288	9/16"	136	204	152	48	16	⊗
	DC150-08-14.500A1-	14.5		136	204	152	48	16	⊗
DC150-08-15.000A1-	15		136	204	152	48	16	⊗	
DC150-08-15.500A1-	15.5		136	204	152	48	16	⊗	
DC150-08-15.875A1-	15.875	5/8"	136	204	152	48	16	⊗	
DC150-08-16.000A1-	16		136	204	152	48	16	⊗	
DC150-08-16.500A1-	16.5		153	223	171	48	18	⊗	
DC150-08-17.000A1-	17		153	223	171	48	18	⊗	
DC150-08-17.500A1-	17.5		153	223	171	48	18	⊗	
DC150-08-18.000A1-	18		153	223	171	48	18	⊗	
DC150-08-18.500A1-	18.5		170	244	190	50	20	⊗	
DC150-08-19.000A1-	19		170	244	190	50	20	⊗	
DC150-08-19.050A1-	19.05	3/4"	170	244	190	50	20	⊗	
DC150-08-19.500A1-	19.5		170	244	190	50	20	⊗	
DC150-08-20.000A1-	20		170	244	190	50	20	⊗	

Ordering example for the WJ30TA grade: DC150-08-03.000A1-WJ30TA

# Coolant-through solid carbide drill

## DC150 Perform



	P	M	K	N	S	H	O
WJ30TA	●●	●	●●	●●	●●	●●	●

Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA
Shank DIN 6535 HA								
DC150-12-03.000A1-	3		48	92	54	36	6	☺
DC150-12-03.100A1-	3.1		48	92	54	36	6	☺
DC150-12-03.175A1-	3.175	1/8"	48	92	54	36	6	☺
DC150-12-03.200A1-	3.2		48	92	54	36	6	☺
DC150-12-03.300A1-	3.3		48	92	54	36	6	☺
DC150-12-03.400A1-	3.4		48	92	54	36	6	☺
DC150-12-03.500A1-	3.5		48	92	54	36	6	☺
DC150-12-03.572A1-	3.572	9/64"	48	92	54	36	6	☺
DC150-12-03.600A1-	3.6		48	92	54	36	6	☺
DC150-12-03.700A1-	3.7		48	92	54	36	6	☺
DC150-12-03.800A1-	3.8		56	102	64	36	6	☺
DC150-12-03.900A1-	3.9		56	102	64	36	6	☺
DC150-12-03.969A1-	3.969	5/32"	56	102	64	36	6	☺
DC150-12-04.000A1-	4		56	102	64	36	6	☺
DC150-12-04.100A1-	4.1		56	102	64	36	6	☺
DC150-12-04.200A1-	4.2		56	102	64	36	6	☺
DC150-12-04.300A1-	4.3		56	102	64	36	6	☺
DC150-12-04.366A1-	4.366	11/64"	56	102	64	36	6	☺
DC150-12-04.400A1-	4.4		56	102	64	36	6	☺
DC150-12-04.500A1-	4.5		56	102	64	36	6	☺
DC150-12-04.600A1-	4.6		56	102	64	36	6	☺
DC150-12-04.700A1-	4.7		56	102	64	36	6	☺
DC150-12-04.763A1-	4.763	3/16"	74	121	83	36	6	☺
DC150-12-04.800A1-	4.8		74	121	83	36	6	☺
DC150-12-04.900A1-	4.9		74	121	83	36	6	☺
DC150-12-05.000A1-	5		74	121	83	36	6	☺
DC150-12-05.100A1-	5.1		74	121	83	36	6	☺
DC150-12-05.159A1-	5.159	13/64"	74	121	83	36	6	☺
DC150-12-05.200A1-	5.2		74	121	83	36	6	☺
DC150-12-05.300A1-	5.3		74	121	83	36	6	☺
DC150-12-05.400A1-	5.4		74	121	83	36	6	☺
DC150-12-05.500A1-	5.5		74	121	83	36	6	☺
DC150-12-05.550A1-	5.55		74	121	83	36	6	☺
DC150-12-05.556A1-	5.556	7/32"	74	121	83	36	6	☺
DC150-12-05.600A1-	5.6		74	121	83	36	6	☺
DC150-12-05.700A1-	5.7		74	121	83	36	6	☺
DC150-12-05.800A1-	5.8		74	121	83	36	6	☺
DC150-12-05.900A1-	5.9		74	121	83	36	6	☺
DC150-12-06.000A1-	6		74	121	83	36	6	☺
DC150-12-06.100A1-	6.1		98	148	110	36	8	☺
DC150-12-06.200A1-	6.2		98	148	110	36	8	☺
DC150-12-06.300A1-	6.3		98	148	110	36	8	☺
DC150-12-06.350A1-	6.35	1/4"	98	148	110	36	8	☺

Ordering example for the WJ30TA grade: DC150-12-03.000A1-WJ30TA

**WALTER SELECT**

Best tool for machining conditions

☺ Good    ☺ Average    ☺ Poor

●● Primary application

● Other application

Continued



Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA	
	Shank DIN 6535 HA	DC150-12-06.400A1-	6.4		98	148	110	36	8	⊗
	DC150-12-06.500A1-	6.5		98	148	110	36	8	8	⊗
	DC150-12-06.600A1-	6.6		98	148	110	36	8	8	⊗
	DC150-12-06.700A1-	6.7		98	148	110	36	8	8	⊗
	DC150-12-06.747A1-	6.747	17/64"	98	148	110	36	8	8	⊗
	DC150-12-06.800A1-	6.8		98	148	110	36	8	8	⊗
	DC150-12-06.900A1-	6.9		98	148	110	36	8	8	⊗
	DC150-12-07.000A1-	7		98	148	110	36	8	8	⊗
	DC150-12-07.100A1-	7.1		98	148	110	36	8	8	⊗
	DC150-12-07.144A1-	7.144	9/32"	98	148	110	36	8	8	⊗
	DC150-12-07.200A1-	7.2		98	148	110	36	8	8	⊗
	DC150-12-07.300A1-	7.3		98	148	110	36	8	8	⊗
	DC150-12-07.400A1-	7.4		98	148	110	36	8	8	⊗
	DC150-12-07.500A1-	7.5		98	148	110	36	8	8	⊗
	DC150-12-07.541A1-	7.541	19/64"	98	148	110	36	8	8	⊗
	DC150-12-07.800A1-	7.8		98	148	110	36	8	8	⊗
	DC150-12-07.900A1-	7.9		98	148	110	36	8	8	⊗
	DC150-12-07.938A1-	7.938	5/16"	98	148	110	36	8	8	⊗
	DC150-12-08.000A1-	8		98	148	110	36	8	8	⊗
	DC150-12-08.100A1-	8.1		123	180	138	40	10	10	⊗
	DC150-12-08.200A1-	8.2		123	180	138	40	10	10	⊗
	DC150-12-08.300A1-	8.3		123	180	138	40	10	10	⊗
	DC150-12-08.400A1-	8.4		123	180	138	40	10	10	⊗
	DC150-12-08.500A1-	8.5		123	180	138	40	10	10	⊗
	DC150-12-08.600A1-	8.6		123	180	138	40	10	10	⊗
	DC150-12-08.700A1-	8.7		123	180	138	40	10	10	⊗
	DC150-12-08.731A1-	8.731	11/32"	123	180	138	40	10	10	⊗
	DC150-12-08.800A1-	8.8		123	180	138	40	10	10	⊗
	DC150-12-09.000A1-	9		123	180	138	40	10	10	⊗
	DC150-12-09.128A1-	9.128	23/64"	123	180	138	40	10	10	⊗
	DC150-12-09.200A1-	9.2		123	180	138	40	10	10	⊗
	DC150-12-09.300A1-	9.3		123	180	138	40	10	10	⊗
	DC150-12-09.500A1-	9.5		123	180	138	40	10	10	⊗
	DC150-12-09.525A1-	9.525	3/8"	123	180	138	40	10	10	⊗
	DC150-12-09.600A1-	9.6		123	180	138	40	10	10	⊗
	DC150-12-09.700A1-	9.7		123	180	138	40	10	10	⊗
	DC150-12-09.800A1-	9.8		123	180	138	40	10	10	⊗
	DC150-12-09.922A1-	9.922	25/64"	123	180	138	40	10	10	⊗
	DC150-12-10.000A1-	10		123	180	138	40	10	10	⊗
	DC150-12-10.100A1-	10.1		140	206	158	45	12	12	⊗
DC150-12-10.200A1-	10.2		140	206	158	45	12	12	⊗	
DC150-12-10.300A1-	10.3		140	206	158	45	12	12	⊗	
DC150-12-10.319A1-	10.319	13/32"	140	206	158	45	12	12	⊗	
DC150-12-10.500A1-	10.5		140	206	158	45	12	12	⊗	
DC150-12-10.716A1-	10.716	27/64"	140	206	158	45	12	12	⊗	
DC150-12-10.800A1-	10.8		140	206	158	45	12	12	⊗	
DC150-12-11.000A1-	11		140	206	158	45	12	12	⊗	
DC150-12-11.100A1-	11.1		140	206	158	45	12	12	⊗	
DC150-12-11.113A1-	11.113	7/16"	140	206	158	45	12	12	⊗	
DC150-12-11.200A1-	11.2		140	206	158	45	12	12	⊗	
DC150-12-11.500A1-	11.5		140	206	158	45	12	12	⊗	
DC150-12-11.509A1-	11.509	29/64"	140	206	158	45	12	12	⊗	
DC150-12-11.700A1-	11.7		140	206	158	45	12	12	⊗	
DC150-12-11.800A1-	11.8		140	206	158	45	12	12	⊗	
DC150-12-11.906A1-	11.906	15/32"	140	206	158	45	12	12	⊗	
DC150-12-12.000A1-	12		140	206	158	45	12	12	⊗	
DC150-12-12.100A1-	12.1		168	230	182	45	14	14	⊗	
DC150-12-12.200A1-	12.2		168	230	182	45	14	14	⊗	

Ordering example for the WJ30TA grade: DC150-08-03.000A1-WJ30TA

Continued





Continued

	Designation	D <sub>c</sub> m7 mm	D <sub>c</sub> Inch/no.	L <sub>c</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>5</sub> mm	d <sub>1</sub> h6 mm	WJ30TA
	Shank DIN 6535 HA								
	DC150-12-12.300A1-	12.3		168	230	182	45	14	☺
	DC150-12-12.303A1-	12.303	31/64"	168	230	182	45	14	☺
	DC150-12-12.500A1-	12.5		168	230	182	45	14	☺
	DC150-12-12.600A1-	12.6		168	230	182	45	14	☺
	DC150-12-12.700A1-	12.7	1/2"	168	230	182	45	14	☺
	DC150-12-13.000A1-	13		168	230	182	45	14	☺
	DC150-12-13.494A1-	13.494	17/32"	168	230	182	45	14	☺
	DC150-12-13.500A1-	13.5		168	230	182	45	14	☺
	DC150-12-14.000A1-	14		168	230	182	45	14	☺
	DC150-12-14.288A1-	14.288	9/16"	192	260	208	48	16	☺
	DC150-12-14.500A1-	14.5		192	260	208	48	16	☺
	DC150-12-15.000A1-	15		192	260	208	48	16	☺
	DC150-12-15.500A1-	15.5		192	260	208	48	16	☺
	DC150-12-15.875A1-	15.875	5/8"	192	260	208	48	16	☺
	DC150-12-16.000A1-	16		192	260	208	48	16	☺
	DC150-12-16.500A1-	16.5		216	285	234	48	18	☺
	DC150-12-17.000A1-	17		216	285	234	48	18	☺
	DC150-12-17.500A1-	17.5		216	285	234	48	18	☺
	DC150-12-18.000A1-	18		216	285	234	48	18	☺
DC150-12-19.000A1-	19		238	310	258	50	20	☺	
DC150-12-20.000A1-	20		238	310	258	50	20	☺	

Ordering example for the WJ30TA grade: DC150-12-03.000A1-WJ30TA

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹  
Poor

machining conditions

•• Primary application

• Other application

37

9

# HSS-E machine taps

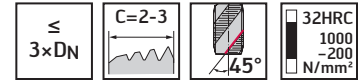
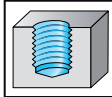
## TC115 Perform



– For long-chipping materials

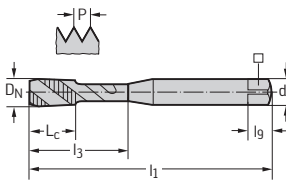
**UNC**  
ASME B1.1

**2B**



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			

### DIN/ANSI

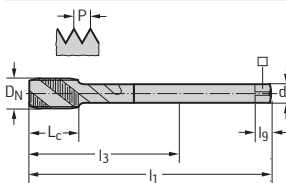


Designation	D <sub>N</sub> -P	D <sub>N</sub> inch	l <sub>1</sub> inch	L <sub>c</sub> inch	l <sub>3</sub> inch	d <sub>1</sub> h9 inch	□ inch	l <sub>g</sub> Inches/ no.	N	WY80AA
TC115DUNC6-C0-	UNC 6-32	0.138	2.205	0.256	0.787	0.141	0.110	3/16"	3	☼
TC115DUNC8-C0-	UNC 8-32	0.164	2.480	0.276	0.827	0.168	0.131	1/4"	3	☼
TC115DUNC10-C0-	UNC 10-24	0.190	2.756	0.315	0.984	0.194	0.152	1/4"	3	☼
TC115DUNC1/4-C0-	UNC 1/4-20	0.250	3.150	0.394	1.181	0.255	0.191	5/16"	3	☼
TC115DUNC5/16-C0-	UNC 5/16-18	0.313	3.543	0.472	1.378	0.318	0.238	3/8"	3	☼
TC115DUNC3/8-C0-	UNC 3/8-16	0.375	3.937	0.591	1.535	0.381	0.286	7/16"	3	☼

DIN length/ANSI shank

Ordering example for the WY80FC grade: TC115DUNC6-C0-WY80AA

### DIN/ANSI



Designation	D <sub>N</sub> -P	D <sub>N</sub> inch	l <sub>1</sub> inch	L <sub>c</sub> inch	l <sub>3</sub> inch	d <sub>1</sub> h9 inch	□ inch	l <sub>g</sub> Inches/ no.	N	WY80AA
TC115DUNC1/2-L0-	UNC 1/2-13	0.500	4.331	0.709	3.224	0.367	0.275	7/16"	3	☼
TC115DUNC5/8-L0-	UNC 5/8-11	0.625	4.331	0.787	2.587	0.480	0.360	9/16"	3	☼
TC115DUNC3/4-L0-	UNC 3/4-10	0.750	4.921	0.984	3.051	0.590	0.442	11/16"	4	☼

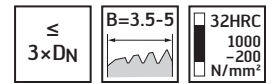
DIN length/ANSI shank

Ordering example for the WY80AA grade: TC115DUNC1/2-L0-WY80AA

# HSS-E machine taps TC216 Perform



- For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			

DIN/ANSI	Designation	D <sub>N</sub> -P	D <sub>N</sub> inch	l <sub>1</sub> h9 inch	L <sub>c</sub> inch	l <sub>3</sub> inch	d <sub>1</sub> inch	□ inch	l <sub>g</sub> Inches/ no.	N	WY80AA
	TC216DUNC6-C0-	UNC 6-32	0.138	2.205	0.433	0.787	0.141	0.110	3/16"	3	☼
	TC216DUNC8-C0-	UNC 8-32	0.164	2.480	0.472	0.827	0.168	0.131	1/4"	3	☼
	TC216DUNC10-C0-	UNC 10-24	0.190	2.756	0.512	0.984	0.194	0.152	1/4"	3	☼
	TC216DUNC1/4-C0-	UNC 1/4-20	0.250	3.150	0.591	1.181	0.255	0.191	5/16"	3	☼
	TC216DUNC5/16-C0-	UNC 5/16-18	0.313	3.543	0.709	1.378	0.318	0.238	3/8"	3	☼
	TC216DUNC3/8-C0-	UNC 3/8-16	0.375	3.937	0.787	1.535	0.381	0.286	7/16"	3	☼

DIN length/ANSI shank  
Ordering example for the WY80AA grade: TC216DUNC6-C0-WY80AA

DIN/ANSI	Designation	D <sub>N</sub> -P	D <sub>N</sub> inch	l <sub>1</sub> h9 inch	L <sub>c</sub> inch	l <sub>3</sub> inch	d <sub>1</sub> inch	□ inch	l <sub>g</sub> Inches/ no.	N	WY80AA
	TC216DUNC1/2-L0-	UNC 1/2-13	0.500	4.331	0.906	3.224	0.367	0.275	7/16"	4	☼
	TC216DUNC5/8-L0-	UNC 5/8-11	0.625	4.331	0.984	2.587	0.480	0.360	9/16"	4	☼
	TC216DUNC3/4-L0-	UNC 3/4-10	0.750	4.921	1.181	3.051	0.590	0.442	11/16"	4	☼

DIN length/ANSI shank  
Ordering example for the WY80AA grade: TC216DUNC1/2-L0-WY80AA

WALTER SELECT

Best tool for

Good

Average

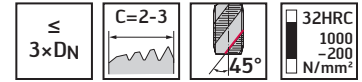
Poor

machining conditions

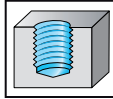
●● Primary application

● Other application

# HSS-E machine taps TC115 Perform

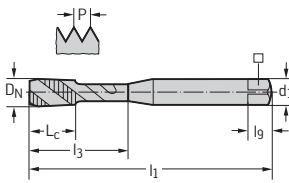


- For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			
WY80FC	●	●	●	●			

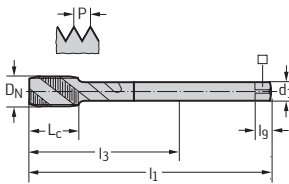
## DIN 371



Designation	D <sub>N</sub>	P mm	l <sub>1</sub> mm	L <sub>c</sub> mm	l <sub>3</sub> mm	d <sub>1</sub> h9 mm	□ mm	l <sub>g</sub> mm	N	WY80AA	WY80FC
TC115-M3-C0-	M 3	0.5	56	6	18	3.5	2.7	6	3	●	●
TC115-M4-C0-	M 4	0.7	63	7	21	4.5	3.4	6	3	●	●
TC115-M5-C0-	M 5	0.8	70	8	25	6	4.9	8	3	●	●
TC115-M6-C0-	M 6	1	80	10	30	6	4.9	8	3	●	●
TC115-M8-C0-	M 8	1.25	90	12	35	8	6.2	9	3	●	●
TC115-M10-C0-	M 10	1.5	100	15	39	10	8	11	3	●	●

Ordering example for the WY80FC grade: TC115-M3-C0-WY80FC

## DIN 376



Designation	D <sub>N</sub>	P mm	l <sub>1</sub> mm	L <sub>c</sub> mm	l <sub>3</sub> mm	d <sub>1</sub> h9 mm	□ mm	l <sub>g</sub> mm	N	WY80AA	WY80FC
TC115-M12-L0-	M 12	1.75	110	16	83	9	7	10	3	●	●
TC115-M14-L0-	M 14	2	110	20	81	11	9	12	3	●	●
TC115-M16-L0-	M 16	2	110	20	68	12	9	12	3	●	●
TC115-M20-L0-	M 20	2.5	140	25	95	16	12	15	4	●	●

Ordering example for the WY80FC grade: TC115-M12-L0-WY80FC

# HSS-E machine taps TC216 Perform



- For long-chipping materials

$\leq 3 \times DN$

$B=3.5-5$

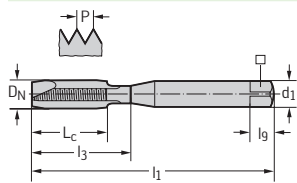
$32HRC$   
 $1000-200$   
 $N/mm^2$

**M**  
 DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●●	●●	●●	●●			
WY80FC	●●	●●	●●	●●			

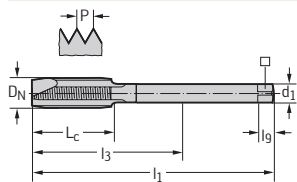
## DIN 371



Designation	$D_N$	P mm	$l_1$ mm	$L_c$ mm	$l_3$ mm	$d_1$ h9 mm	mm	$l_g$ mm	N	WY80AA	WY80FC
TC216-M3-C0-	M 3	0.5	56	9	18	3.5	2.7	6	2	●●	●●
TC216-M4-C0-	M 4	0.7	63	12	21	4.5	3.4	6	3	●●	●●
TC216-M5-C0-	M 5	0.8	70	13	25	6	4.9	8	3	●●	●●
TC216-M6-C0-	M 6	1	80	15	30	6	4.9	8	3	●●	●●
TC216-M8-C0-	M 8	1.25	90	18	35	8	6.2	9	3	●●	●●
TC216-M10-C0-	M 10	1.5	100	20	39	10	8	11	3	●●	●●

Ordering example for the WY80FC grade: TC216-M3-C0-WY80FC

## DIN 376



Designation	$D_N$	P mm	$l_1$ mm	$L_c$ mm	$l_3$ mm	$d_1$ h9 mm	mm	$l_g$ mm	N	WY80AA	WY80FC
TC216-M12-L0-	M 12	1.75	110	23	83	9	7	10	3	●●	●●
TC216-M14-L0-	M 14	2	110	25	81	11	9	12	4	●●	●●
TC216-M16-L0-	M 16	2	110	25	68	12	9	12	4	●●	●●
TC216-M20-L0-	M 20	2.5	140	30	95	16	12	15	4	●●	●●

Ordering example for the WY80FC grade: TC216-M12-L0-WY80FC

WALTER SELECT

Best tool for

Good

Average

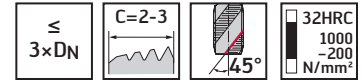
Poor

machining conditions

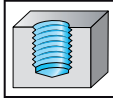
●● Primary application

● Other application

# HSS-E machine taps TC115 Perform



- For long-chipping materials



	P	M	K	N	S	H	O
WY80AA	●	●	●	●			
WY80FC	●	●	●	●			

DIN 374	Designation	D <sub>N</sub>	P mm	l <sub>1</sub> mm	L <sub>c</sub> mm	l <sub>3</sub> mm	d <sub>1</sub> h9 mm	□ mm	l <sub>g</sub> mm	N	WY80AA	WY80FC
	TC115-M8X1-L0-	MF 8x1	1	90	12	67	6	4.9	8	3		
	TC115-M10X1-L0-	MF 10x1	1	90	12	67	7	5.5	8	3		
	TC115-M12X1.25-L0-	MF 12x1.25	1.25	100	13	73	9	7	10	4		
	TC115-M12X1.5-L0-	MF 12x1.5	1.5	100	13	73	9	7	10	4		
	TC115-M14X1.5-L0-	MF 14x1.5	1.5	100	15	71	11	9	12	4		
	TC115-M16X1.5-L0-	MF 16x1.5	1.5	100	15	58	12	9	12	4		
	TC115-M18X1.5-L0-	MF 18x1.5	1.5	110	17	66	14	11	14	4		

Ordering example for the WY80FC grade: TC115-M8X1-L0-WY80FC

# HSS-E machine taps TC216 Perform



$\leq 3 \times DN$

$B=3.5-5$

32HRC  
 1000  
 -200  
 N/mm<sup>2</sup>

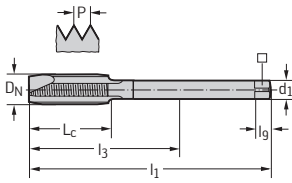
- For long-chipping materials

**MF**  
 DIN 13

ISO2/6H

	P	M	K	N	S	H	O
WY80AA	●●	●●	●●	●●			
WY80FC	●●	●●	●●	●●			

## DIN 374



Designation	D <sub>N</sub>	P mm	l <sub>1</sub> mm	L <sub>c</sub> mm	l <sub>3</sub> mm	d <sub>1</sub> h9 mm	□ mm	l <sub>9</sub> mm	N	WY80AA	WY80FC
TC216-M8X1-L0-	MF 8x1	1	90	18	67	6	4.9	8	3	☼	☼
TC216-M10X1-L0-	MF 10x1	1	90	20	67	7	5.5	8	3	☼	☼
TC216-M12X1.25-L0-	MF 12x1.25	1.25	100	21	73	9	7	10	4	☼	☼
TC216-M12X1.5-L0-	MF 12x1.5	1.5	100	21	73	9	7	10	4	☼	☼
TC216-M14X1.5-L0-	MF 14x1.5	1.5	100	21	71	11	9	12	4	☼	☼
TC216-M16X1.5-L0-	MF 16x1.5	1.5	100	21	58	12	9	12	4	☼	☼
TC216-M18X1.5-L0-	MF 18x1.5	1.5	110	24	66	14	11	14	4	☼	☼

Ordering example for the WY80FC grade: TC216-M8X1-L0-WY80FC

WALTER  
 SELECT

Best tool for

Good

Average

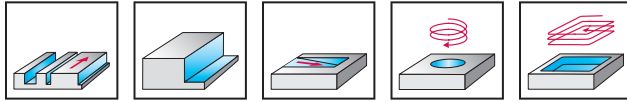
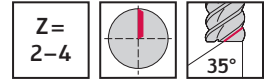
Poor

machining conditions

●● Primary application

● Other application

## Solid carbide shoulder/slot milling cutter

 MC232 Perform\* inch


	P	M	K	N	S	H	O
WJ30ED	●	●	●	●	●	●	●

DIN 6527 L		$D_c$ h12 inch	$L_c$ inch	$l_1$ inch	$l_4$ inch	$d_1$ h6 inch	Z	WJ30ED
Shank DIN 6535 HA 	MC232.3.18A2D-	0.125	0.500	2.500	1.083	0.250	2	⊕
	MC232.6.35A2D-	0.250	0.750	2.500	1.083	0.250	2	⊕
Shank DIN 6535 HB 	MC232.9.53W2D-	0.375	0.875	3.000	1.437	0.375	2	⊕
	MC232.12.7W2D-	0.500	1.000	3.500	1.717	0.500	2	⊕
	MC232.15.9W2D-	0.625	1.250	3.500	1.594	0.625	2	⊕

Ordering example for the WJ30ED grade: MC232.3.18A2D-WJ30ED

DIN 6527 L		$D_c$ h12 inch	$L_c$ inch	$l_1$ inch	$l_4$ inch	$d_1$ h6 inch	Z	WJ30ED
Shank DIN 6535 HA 	MC232.3.18A3D-	0.125	0.500	2.500	1.083	0.250	3	⊕
	MC232.6.35A3D-	0.250	0.750	2.500	1.083	0.250	3	⊕
Shank DIN 6535 HB 	MC232.9.53W3D-	0.375	0.875	3.000	1.437	0.375	3	⊕
	MC232.12.7W3D-	0.500	1.000	3.500	1.717	0.500	3	⊕
	MC232.15.9W3D-	0.625	1.250	3.500	1.594	0.625	3	⊕

Ordering example for the WJ30ED grade: MC232.3.18A3D-WJ30ED

Continued

\*Available starting July 2016





Continued

DIN 6527 L		$D_c$ h12 inch	$L_c$ inch	$l_1$ inch	$l_4$ inch	$d_1$ h6 inch	Z	WJ30ED
Shank DIN 6535 HA 	MC232.3.18A4D-	0.125	0.500	2.500	1.083	0.250	4	☺
	MC232.6.35A4D-	0.250	0.750	2.500	1.083	0.250	4	☺
Shank DIN 6535 HB 	MC232.9.53W4D-	0.375	0.875	3.000	1.437	0.375	4	☺
	MC232.12.7W4D-	0.500	1.000	3.500	1.717	0.500	4	☺
	MC232.15.9W4D-	0.625	1.250	3.500	1.594	0.625	4	☺

Ordering example for the WJ30ED grade: MC232.3.18A4D-WJ30ED

WALTER SELECT

Best tool for

☺  
Good

☹  
Average

☹  
Poor

machining conditions

•• Primary application

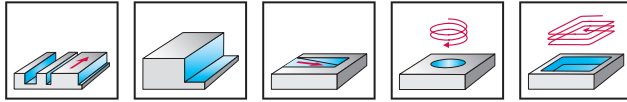
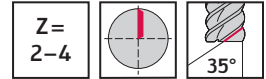
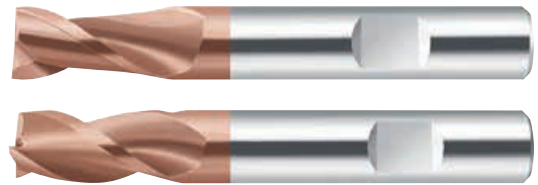
• Other application

40

9

# Solid carbide shoulder/slot milling cutter

## MC232 Perform



	P	M	K	N	S	H	O
WJ30ED	●	●	●				

DIN 6527 L		$D_c$ h12 mm	$L_c$ mm	$l_1$ mm	$l_4$ mm	$d_1$ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A2B-	2	6	57	21	4	2	
	MC232-02.5A2B-	2.5	7	57	21	4	2	
	MC232-03.0A2B-	3	7	57	21	4	2	
	MC232-03.5A2B-	3.5	7	57	21	4	2	
	MC232-04.0A2B-	4	8	57	21	4	2	
Shank DIN 6535 HB	MC232-05.0W2B-	5	10	57	21	6	2	
	MC232-06.0W2B-	6	10	57	21	6	2	
	MC232-08.0W2B-	8	16	63	27	8	2	
	MC232-10.0W2B-	10	19	72	32	10	2	
	MC232-12.0W2B-	12	22	83	38	12	2	
	MC232-16.0W2B-	16	26	92	44	16	2	
	MC232-20.0W2B-	20	32	104	54	20	2	

Ordering example for the WJ30ED grade: MC232-02.0A2B-WJ30ED

DIN 6527 L		$D_c$ h12 mm	$L_c$ mm	$l_1$ mm	$l_4$ mm	$d_1$ h6 mm	Z	WJ30ED
Shank DIN 6535 HA	MC232-02.0A3B-	2	6	57	21	4	3	
	MC232-02.5A3B-	2.5	7	57	21	4	3	
	MC232-03.0A3B-	3	7	57	21	4	3	
	MC232-03.5A3B-	3.5	7	57	21	4	3	
	MC232-04.0A3B-	4	8	57	21	4	3	
Shank DIN 6535 HB	MC232-05.0W3B-	5	10	57	21	6	3	
	MC232-06.0W3B-	6	10	57	21	6	3	
	MC232-08.0W3B-	8	16	63	27	8	3	
	MC232-10.0W3B-	10	19	72	32	10	3	
	MC232-12.0W3B-	12	22	83	38	12	3	
	MC232-16.0W3B-	16	26	92	44	16	3	
	MC232-20.0W3B-	20	32	104	54	20	3	

Ordering example for the WJ30ED grade: MC232-02.0A3B-WJ30ED

Continued



Continued

DIN 6527 L		$D_c$ h12 mm	$L_c$ mm	$l_1$ mm	$l_4$ mm	$d_1$ h6 mm	Z	WJ30ED
Shank DIN 6535 HA 	MC232-02.0A4B-	2	7	57	21	4	4	☺
	MC232-02.5A4B-	2.5	8	57	21	4	4	☺
	MC232-03.0A4B-	3	8	57	21	4	4	☺
	MC232-03.5A4B-	3.5	10	57	21	4	4	☺
	MC232-04.0A4B-	4	11	57	21	4	4	☺
Shank DIN 6535 HB 	MC232-05.0W4B-	5	13	57	21	6	4	☺
	MC232-06.0W4B-	6	13	57	21	6	4	☺
	MC232-08.0W4B-	8	19	63	27	8	4	☺
	MC232-10.0W4B-	10	22	72	32	10	4	☺
	MC232-12.0W4B-	12	26	83	38	12	4	☺
	MC232-16.0W4B-	16	32	92	44	16	4	☺
	MC232-20.0W4B-	20	38	104	54	20	4	☺

Ordering example for the WJ30ED grade: MC232-02.0A4B-WJ30ED

WALTER SELECT

Best tool for

Good

Average

Poor

machining conditions

•• Primary application

• Other application

40

9

# Cutting data for solid carbide drills

= Cutting data for wet machining = Dry machining is possible, cutting data must be selected from Walter GPS E = Emulsion $v_c$ = Cutting speed (SFM) O = Oil <sup>1)</sup> VRR = Feed rate chart on page 38 M = MQL L = Dry		Drilling depth			3 × D <sub>c</sub>			
		Product family	DC150			DIN 6537 short		
Material group		Dimensions			Dia. range (mm)			
		Cooling			External cooling			
		Cutting tool material			WJ30RE			
		Page			10			
Overview of the main material groups and code letters		Brinell hardness HB	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Machining group <sup>3)</sup>				
Material					$v_c$	<sup>1)</sup> VRR	Cooling	
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125 430 P1	330	10	E O	M L
		C > 0.25... ≤ 0.55%	Annealed	190 640 P2	300	10	E O	M L
		C > 0.25... ≤ 0.55%	Heat-treated	210 710 P3	280	10	E O	M L
		C > 0.55%	Annealed	190 640 P4	300	10	E O	M L
		C > 0.55%	Heat-treated	300 1010 P5	210	8	E O	M L
		Free cutting steel (short-chipping)	Annealed	220 750 P6	330	10	E O	M L
	Low-alloyed steel	Annealed	175 590 P7	300	10	E O	M L	
		Heat-treated	285 960 P8	210	8	E O	M L	
		Heat-treated	380 1280 P9	140	5	O E		
		Heat-treated	430 1480 P10	110	3	O E		
	High-alloyed steel and high-alloyed tool steel	Annealed	200 680 P11	180	7	E O		
		Hardened and tempered	300 1010 P12	170	6	E O		
	Stainless steel	Hardened and tempered	380 1280 P13	110	3	O E		
		Ferritic/martensitic, annealed	200 680 P14	190	7	E O		
	Stainless steel	Martensitic, heat-treated	330 1110 P15	120	5	E O		
Austenitic, quench hardened		200 680 M1						
M	Stainless steel	Austenitic, precipitation hardened (PH)	300 1010 M2	150	5	E O		
		Austenitic/ferritic, duplex	230 780 M3					
K	Malleable cast iron	Ferritic	200 400 K1	280	16	E O	M L	
		Pearlitic	260 700 K2	210	12	E O	M L	
	Grey cast iron	Low tensile strength	180 200 K3	330	16	E O	M L	
		High tensile strength/austenitic	245 350 K4	280	16	E O	M L	
	Cast iron with spheroidal graphite	Ferritic	155 400 K5	280	16	E O	M L	
		Pearlitic	265 700 K6	210	12	E O	M L	
	GGV (CGI)	230 400 K7	250	16	E O	M L		
N	Aluminum wrought alloys	Cannot be hardened	30 - N1					
		Hardenable, hardened	100 340 N2					
	Cast aluminum alloys	≤ 12% Si, cannot be hardened	75 260 N3	720	16	E O		
		≤ 12% Si, hardenable, hardened	90 310 N4	660	16	E O		
		> 12% Si, cannot be hardened	130 450 N5	520	12	E O		
	Magnesium alloys		70 250 N6					
Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper	100 340 N7	620	6	E O	M		
	Brass, bronze, red brass	90 310 N8	520	10	E O			
	Cu alloys, short-chipping	110 380 N9	590	16	E O	M L		
	High-strength, Ampco	300 1010 N10	220	7	E O	M L		
S	Heat-resistant alloys	Fe-based	Annealed	200 680 S1				
			Hardened	280 940 S2				
		Ni or Co base	Annealed	250 840 S3				
			Hardened	350 1180 S4				
			Cast	320 1080 S5				
	Titanium alloys	Pure titanium	200 680 S6	130	5	O E		
	α and β alloys, hardened	375 1260 S7	110	4	O E			
	β alloys	410 1400 S8						
	Tungsten alloys	300 1010 S9	220	8	E O			
	Molybdenum alloys	300 1010 S10	220	8	E O			
H	Hardened steel	Hardened and tempered	50 HRC - H1	90	3	O E		
		Hardened and tempered	55 HRC - H2	70	3	O E		
		Hardened and tempered	60 HRC - H3					
	Hardened cast iron	55 HRC - H4	70	3	O E			
O	Thermoplastics	Without abrasive fillers	O1	280	16	E O		
	Thermosetting plastics	Without abrasive fillers	O2					
	Plastic, glass-fiber reinforced	GFRP	O3					
	Plastic, carbon-fiber reinforced	CFRP	O4					
	Plastic, aramid-fiber reinforced	AFRP	O5					
	Graphite (technical)		80 Shore O6					

The specified cutting data are average recommended values.  
For special applications, adjustment is recommended.

3 × D <sub>c</sub>					5 × D <sub>c</sub>					8 × D <sub>c</sub>					12 × D <sub>c</sub>				
DC150					DC150					DC150					DC150				
DIN 6537 short					DIN 6537 long					Walter standard					Walter standard				
3.00–20.00					3.00–20.00					3.00–20.00					3.00–20.00				
Internal cooling					Internal cooling					Internal cooling					Internal cooling				
WJ30RE					WJ30RE					WJ30TA					WJ30TA				
13					16					20					23				
v <sub>c</sub>	<sup>1)</sup> VRR	Cooling			v <sub>c</sub>	<sup>1)</sup> VRR	Cooling			v <sub>c</sub>	<sup>1)</sup> VRR	Cooling			v <sub>c</sub>	<sup>1)</sup> VRR	Cooling		
380	10	E O	ML		370	10	E O	ML		340	10	E O	ML		330	10	E O	ML	
310	10	E O	ML		310	10	E O	ML		280	10	E O	ML		270	10	E O	ML	
300	10	E O	ML		290	10	E O	ML		270	10	E O	ML		260	10	E O	ML	
310	10	E O	ML		310	10	E O	ML		280	10	E O	ML		270	10	E O	ML	
230	8	E O	ML		220	8	E O	ML		200	7	E O	ML		190	7	E O	ML	
380	12	E O	ML		370	12	E O	ML		340	12	E O	ML		330	12	E O	ML	
310	10	E O	ML		310	10	E O	ML		280	10	E O	ML		270	10	E O	ML	
220	8	E O	ML		220	8	E O	ML		200	7	E O	ML		190	7	E O	ML	
150	6	O E			150	6	O E			140	6	O E			130	6	O E		
120	4	O E			120	4	O E			110	4	O E			100	4	O E		
200	8	E O			190	8	E O			180	8	E O			170	8	E O		
180	7	E O			170	7	E O			160	6	E O			150	6	E O		
120	5	O E			120	4	O E			110	4	O E			100	3	O E		
200	8	E O			190	8	E O			180	8	E O			170	8	E O		
130	7	E O			120	7	E O			110	6	E O			110	6	E O		
130	5	E O			130	5	E O			120	5	E O			120	5	E O		
170	6	E O			170	6	E O			160	6	E O			150	6	E O		
110	5	E O			100	5	E O			100	5	E O			100	5	E O		
290	16	E O	ML		290	16	E O	ML		250	12	E O	ML		240	12	E O	ML	
220	16	E O	ML		210	12	E O	ML		190	12	E O	ML		180	12	E O	ML	
370	16	E O	ML		360	16	E O	ML		320	12	E O	ML		310	12	E O	ML	
290	16	E O	ML		290	16	E O	ML		260	12	E O	ML		240	12	E O	ML	
290	16	E O	ML		290	16	E O	ML		260	12	E O	ML		240	12	E O	ML	
220	16	E O	ML		210	12	E O	ML		190	12	E O	ML		180	12	E O	ML	
260	16	E O	ML		260	16	E O	ML		240	12	E O	ML		220	12	E O	ML	
1310	16	E O	M		1310	16	E O	M		1250	16	E O	M		1250	16	E O	M	
1310	16	E O	M		1310	16	E O	M		1250	16	E O	M		1250	16	E O	M	
790	16	E O	M		740	16	E O	M		710	16	E O	M		670	16	E O	M	
750	16	E O	M		720	16	E O	M		680	16	E O	M		640	16	E O	M	
600	16	E O	M		560	16	E O	M		530	16	E O	M		510	16	E O	M	
750	16		ML		720	16		ML		680	16		ML		640	16		ML	
570	9	E O	M		540	8	E O	M		510	7	E O	M		480	7	E O	M	
470	10	E O			450	10	E O			420	9	E O			400	9	E O		
600	16	E O	M		560	16	E O	M		530	12	E O	M		510	12	E O	M	
180	7	E O			170	7	E O			160	7	E O			150	6	E O		
130	5	E O			130	5	E O			130	5	E O			120	5	E O		
80	4	O E			80	4	O E			70	4	O E			70	4	O E		
100	4	E O			90	4	E O			90	4	E O			90	4	E O		
50	3	O E			50	3	O E			50	3	O E			40	3	O E		
60	3	O E			60	3	O E			60	3	O E			60	3	O E		
150	6	O E			150	6	O E			150	6	O E			150	6	O E		
130	5	O E			120	5	O E			120	5	O E			120	5	O E		
40	3	O E			40	3	O E			40	3	O E			40	3	O E		
180	7	E O			180	7	E O			170	7	E O			170	7	E O		
180	7	E O			180	7	E O			170	7	E O			170	7	E O		
90	3	O E			90	3	O E			90	3	O E			80	3	O E		
80	3	O E			80	3	O E			70	3	O E			70	3	O E		
80	3	O E			80	3	O E			70	3	O E			70	3	O E		
330	16	E O			330	16	E O			310	16	E O			310	16	E O		

## VRR: Feed rate charts for drills

VRR	Feed f (inch/rev) for dia. (inch)								
	0.098	0.157	0.197	0.236	0.315	0.394	0.472	0.591	0.787
1	0.0003	0.0005	0.0007	0.0007	0.0008	0.0009	0.0010	0.0011	0.0013
2	0.0007	0.0011	0.0013	0.0015	0.0017	0.0019	0.0020	0.0023	0.0026
3	0.0010	0.0016	0.0020	0.0022	0.0025	0.0028	0.0030	0.0034	0.0039
4	0.0013	0.0021	0.0026	0.0029	0.0033	0.0037	0.0039	0.0047	0.0051
5	0.0017	0.0026	0.0033	0.0036	0.0043	0.0047	0.0051	0.0055	0.0067
6	0.0020	0.0031	0.0039	0.0043	0.0051	0.0055	0.0059	0.0067	0.0079
7	0.0023	0.0037	0.0047	0.0051	0.0059	0.0063	0.0071	0.0079	0.0091
8	0.0026	0.0043	0.0051	0.0059	0.0067	0.0075	0.0083	0.0091	0.0106
9	0.0030	0.0047	0.0059	0.0063	0.0075	0.0083	0.0091	0.0102	0.0118
10	0.0033	0.0051	0.0067	0.0071	0.0083	0.0094	0.0102	0.0114	0.0130
12	0.0039	0.0063	0.0079	0.0087	0.0098	0.0110	0.0122	0.0138	0.0157
16	0.0051	0.0083	0.0106	0.0114	0.0134	0.0150	0.0161	0.0181	0.0209
20	0.0067	0.0106	0.0130	0.0146	0.0165	0.0185	0.0205	0.0228	0.0264
25	0.0083	0.0130	0.0165	0.0181	0.0209	0.0232	0.0256	0.0283	0.0327
30	0.0098	0.0157	0.0197	0.0217	0.0248	0.0280	0.0303	0.0343	0.0394

VRR	Feed f (mm/rev) for dia. (mm)								
	2.5	4	5	6	8	10	12	15	20
1	0.008	0.013	0.017	0.018	0.021	0.024	0.026	0.029	0.033
2	0.017	0.027	0.033	0.037	0.042	0.047	0.052	0.058	0.067
3	0.025	0.040	0.050	0.055	0.063	0.071	0.077	0.087	0.10
4	0.033	0.053	0.067	0.073	0.084	0.094	0.10	0.12	0.13
5	0.042	0.067	0.083	0.091	0.11	0.12	0.13	0.14	0.17
6	0.050	0.080	0.10	0.11	0.13	0.14	0.15	0.17	0.20
7	0.058	0.093	0.12	0.13	0.15	0.16	0.18	0.20	0.23
8	0.067	0.11	0.13	0.15	0.17	0.19	0.21	0.23	0.27
9	0.075	0.12	0.15	0.16	0.19	0.21	0.23	0.26	0.30
10	0.083	0.13	0.17	0.18	0.21	0.24	0.26	0.29	0.33
12	0.10	0.16	0.20	0.22	0.25	0.28	0.31	0.35	0.40
16	0.13	0.21	0.27	0.29	0.34	0.38	0.41	0.46	0.53
20	0.17	0.27	0.33	0.37	0.42	0.47	0.52	0.58	0.67
25	0.21	0.33	0.42	0.46	0.53	0.59	0.65	0.72	0.83
30	0.25	0.40	0.50	0.55	0.63	0.71	0.77	0.87	1.00

# Cutting data for taps

The specified cutting data are average recommended values.  
For special applications, adjustment is recommended.

Material group	Overview of the main material groups and code letters		Designation			Perform (Surface Speed SFM)								
			Standard			TC115 / TC216								
			Brinell hardness HB	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Machining group	DIN 371 / DIN 376			WY80AA			WY80FC		
						1.5 × D <sub>N</sub>	2 × D <sub>N</sub>	2.5 × D <sub>N</sub>	1.5 × D <sub>N</sub>	2 × D <sub>N</sub>	2.5 × D <sub>N</sub>			
<b>P</b>	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	100	80	---	40	30	30		
		C > 0.25... ≤ 0.55%	Annealed	190	640	P2	60	50	40	50	40	40		
		C > 0.25... ≤ 0.55%	Heat-treated	210	710	P3	60	50	40	20	20	20		
		C > 0.55%	Annealed	190	640	P4	60	50	40	20	20	20		
		C > 0.55%	Heat-treated	300	1010	P5	40	30	30	10	10	10		
	Low-alloyed steel	Free cutting steel (short-chipping)	Annealed	220	750	P6	60	50	40	20	20	20		
		Annealed	175	590	P7	60	50	40	20	20	20			
		Heat-treated	300	1010	P8	40	40	30	10	10	10			
		Heat-treated	380	1280	P9	40	40	30	10	10	10			
	High-alloyed steel and high-alloyed tool steel	Heat-treated	430	1480	P10	40	40	30	10	10	10			
		Annealed	200	680	P11	60	50	40	20	20	20			
		Hardened and tempered	300	1010	P12									
	Stainless steel	Hardened and tempered	400	1360	P13									
		Ferritic/martensitic, annealed	200	680	P14	20	10		10	10	10			
	<b>M</b>	Stainless steel	Martensitic, heat-treated	330	1110	P15								
Austenitic, quench hardened			200	680	M1	20	20		10	10	10			
Austenitic, precipitation hardened (PH)			300	1010	M2									
<b>K</b>	Malleable cast iron	Austenitic/ferritic, duplex	230	780	M3	10	10		10	10	10			
		Ferritic	200	680	K1	70	50	50	20	20	20			
	Grey cast iron	Pearlitic	260	870	K2	30	30	20	20	10	10			
		Low tensile strength	180	600	K3	130	100	90	50	40	30			
	Cast iron with spheroidal graphite	High tensile strength/austenitic	245	830	K4	50	40	30	30	30	20			
Ferritic		155	520	K5	70	50	50	20	20	20				
GGV (CGI)	Pearlitic	265	890	K6	30	30	20	20	10	10				
<b>N</b>	Aluminum wrought alloys		200	680	K7									
		Cannot be hardened	30	-	N1									
	Cast aluminum alloys	Hardenable, hardened	100	340	N2	90	80	60	50	40	30			
		≤ 12% Si, cannot be hardened	75	260	N3	60	50	40	40	30	30			
		≤ 12% Si, hardenable, hardened	90	310	N4	60	50	40	40	30	30			
	Magnesium alloys	> 12% Si, cannot be hardened	130	450	N5									
		70	250	N6										
Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper	100	340	N7	40	30	30	20	20	10				
	Brass, bronze, red brass	90	310	N8	100	80	70	60	50	40				
	Cu alloys, short-chipping	110	380	N9	130	100	90	80	70	60				
	High-strength, Ampco	300	1010	N10										
<b>S</b>	Heat-resistant alloys		Annealed	200	680	S1								
			Hardened	280	940	S2								
			Annealed	250	840	S3								
		Ni or Co base	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									
<b>H</b>	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									
<b>O</b>	Thermoplastics	Without abrasive fillers			O1									
	Thermosetting plastics	Without abrasive fillers			O2									
	Plastic, glass-fiber reinforced	GFRP			O3									
	Plastic, carbon-fiber reinforced	CFRP			O4									
	Plastic, aramid-fiber reinforced	AFRP			O5									
	Graphite (technical)		80 Shore			O6								

# Cutting data for solid carbide milling cutters

The specified cutting data are average recommended values.  
For special applications, adjustment is recommended.

Material group	Overview of the main material groups and code letters  Brinell hardness HB Tensile strength R <sub>m</sub> N/mm <sup>2</sup> Machining group					Perform				
						Dimensions acc. to	Product family	λ	Pages	
						DIN 6527 L	MC232	35°	32–35	
						Dia. range (mm)		Ø 2–20 mm		
Number of teeth		2–4		WJ30ED						
						Starting values for cutting speed v <sub>c</sub> [SFM]				
						a <sub>e</sub> / D <sub>c</sub>			VT	
						1/1	1/2	1/10		
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	430	P1	160	190	240	A
		C > 0.25... ≤ 0.55%	Annealed	190	640	P2	15	180	220	A
		C > 0.25... ≤ 0.55%	Heat-treated	210	710	P3	130	160	190	A
		C > 0.55%	Annealed	190	640	P4	130	160	190	A
		C > 0.55%	Heat-treated	300	1010	P5	90	110	140	A
	Free cutting steel (short-chipping)	Annealed	220	750	P6	130	160	190	A	
	Low-alloyed steel	Annealed	175	590	P7	130	160	190	A	
		Heat-treated	285	960	P8					
		Heat-treated	380	1280	P9					
		Heat-treated	430	1480	P10					
	High-alloyed steel and high-alloyed tool steel	Annealed	200	680	P11	130	160	190	A	
		Hardened and tempered	300	1010	P12					
		Hardened and tempered	380	1280	P13					
	Stainless steel	Ferritic/martensitic, annealed	200	680	P14	60	80	100	A	
		Martensitic, heat-treated	330	1110	P15	30	40	50	A	
M	Stainless steel	Austenitic, quench hardened	200	680	M1	60	70	100	B	
		Austenitic, precipitation hardened (PH)	300	1010	M2	30	40	50	B	
		Austenitic/ferritic, duplex	230	780	M3	30	40	50	B	
K	Malleable cast iron	Ferritic	200	400	K1	130	150	180	A	
		Pearlitic	260	700	K2	100	120	140	A	
	Grey cast iron	Low tensile strength	180	200	K3	130	150	180	A	
		High tensile strength/austenitic	245	350	K4	100	120	140	A	
	Cast iron with spheroidal graphite	Ferritic	155	400	K5	130	150	180	A	
		Pearlitic	265	700	K6	100	120	140	A	
	GGV (CGI)		230	400	K7	130	150	180	A	
N	Aluminum wrought alloys	Cannot be hardened	30	–	N1					
		Hardenable, hardened	100	340	N2					
	Cast aluminum alloys	≤ 12% Si, cannot be hardened	75	260	N3					
		≤ 12% Si, hardenable, hardened	90	310	N4					
		> 12% Si, cannot be hardened	130	450	N5					
	Magnesium alloys		70	250	N6					
	Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper	100	340	N7					
Brass, bronze, red brass		90	310	N8						
Cu alloys, short-chipping		110	380	N9						
High-strength, Ampco		300	1010	N10						
S	Heat-resistant alloys	Fe-based	Annealed	200	680	S1				
			Hardened	280	940	S2				
		Ni or Co base	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-fiber reinforced	GFRP			O3					
	Plastic, carbon-fiber reinforced	CFRP			O4					
	Plastic, aramid-fiber reinforced	AFRP			O5					
	Graphite (technical)		80 Shore		O6					



# Feed matrices – f<sub>z</sub> table inch

The specified cutting data are average recommended values.  
For special applications, adjustment is recommended.

## A Material groups ISO P, ISO K and titanium alloys

Feed per tooth in inches f <sub>z</sub> [inch]														
a <sub>e</sub> [inch]*	Dia. 1/64	Dia. 1/32	Dia. 1/16	Dia. 1/8	Dia. 3/16	Dia. 1/4	Dia. 5/16	Dia. 3/8	Dia. 1/2	Dia. 9/16	Dia. 5/8	Dia. 11/16	Dia. 3/4	Dia. 1
0.0005	0.0008	0.0012	0.0024	0.0035	0.0047	0.0059	0.0059	0.0079						
0.0020	0.0006	0.0010	0.0016	0.0028	0.0039	0.0047	0.0059	0.0079						
0.0040	0.0005	0.0008	0.0014	0.0020	0.0031	0.0039	0.0059	0.0079	0.0079	0.0079	0.0079			
0.0080	0.0004	0.0006	0.0012	0.0016	0.0024	0.0031	0.0059	0.0071	0.0079	0.0079	0.0079	0.0079	0.0098	
0.0156	0.0004	0.0005	0.0010	0.0012	0.0020	0.0028	0.0047	0.0059	0.0059	0.0059	0.0059	0.0079	0.0098	0.0098
0.0312		0.0004	0.0010	0.0012	0.0016	0.0024	0.0035	0.0047	0.0047	0.0047	0.0047	0.0059	0.0079	0.0098
0.0625			0.0008	0.0012	0.0012	0.0020	0.0031	0.0043	0.0047	0.0047	0.0047	0.0059	0.0079	0.0079
0.1250				0.0008	0.0010	0.0018	0.0030	0.0041	0.0047	0.0047	0.0047	0.0053	0.0069	0.0079
0.1875					0.0008	0.0016	0.0028	0.0039	0.0047	0.0047	0.0047	0.0047	0.0059	0.0079
0.2500						0.0012	0.0024	0.0031	0.0039	0.0039	0.0047	0.0047	0.0059	0.0079
0.3125							0.0020	0.0028	0.0035	0.0039	0.0047	0.0047	0.0059	0.0079
0.3750								0.0024	0.0031	0.0039	0.0047	0.0047	0.0055	0.0063
0.5000									0.0028	0.0035	0.0043	0.0047	0.0055	0.0063
0.5625										0.0031	0.0039	0.0047	0.0051	0.0059
0.6250											0.0035	0.0039	0.0047	0.0059
0.6875												0.0039	0.0043	0.0051
0.7500													0.0039	0.0047
1.0000														0.0039

## B Material groups ISO M, ISO H, heat-resistant alloys, tungsten alloys and molybdenum alloys

Feed per tooth in inches f <sub>z</sub> [inch]														
a <sub>e</sub> [inch]*	Dia. 1/64	Dia. 1/32	Dia. 1/16	Dia. 1/8	Dia. 3/16	Dia. 1/4	Dia. 5/16	Dia. 3/8	Dia. 1/2	Dia. 9/16	Dia. 5/8	Dia. 11/16	Dia. 3/4	Dia. 1
0.0005	0.0006	0.0012	0.0020	0.0031	0.0039	0.0047	0.0047	0.0063						
0.0020	0.0005	0.0008	0.0016	0.0024	0.0031	0.0039	0.0047	0.0063						
0.0040	0.0004	0.0006	0.0012	0.0016	0.0024	0.0031	0.0047	0.0063	0.0063	0.0063	0.0063			
0.0080	0.0003	0.0005	0.0010	0.0014	0.0020	0.0024	0.0047	0.0055	0.0063	0.0063	0.0063	0.0063	0.0079	
0.0156	0.0003	0.0004	0.0008	0.0010	0.0016	0.0024	0.0039	0.0047	0.0047	0.0047	0.0047	0.0063	0.0079	0.0079
0.0312		0.0004	0.0008	0.0010	0.0012	0.0019	0.0031	0.0039	0.0039	0.0039	0.0039	0.0047	0.0063	0.0079
0.0625			0.0006	0.0008	0.0010	0.0020	0.0028	0.0035	0.0039	0.0039	0.0039	0.0047	0.0063	0.0063
0.1250				0.0006	0.0009	0.0018	0.0026	0.0033	0.0039	0.0039	0.0039	0.0043	0.0055	0.0063
0.1875					0.0008	0.0016	0.0024	0.0031	0.0039	0.0039	0.0039	0.0039	0.0047	0.0063
0.2500						0.0012	0.0020	0.0028	0.0031	0.0031	0.0039	0.0039	0.0047	0.0063
0.3125							0.0016	0.0024	0.0031	0.0031	0.0039	0.0039	0.0047	0.0063
0.3750								0.0020	0.0028	0.0031	0.0039	0.0039	0.0047	0.0055
0.5000									0.0024	0.0028	0.0035	0.0039	0.0047	0.0055
0.5625										0.0028	0.0031	0.0039	0.0047	0.0055
0.6250											0.0028	0.0031	0.0039	0.0047
0.6875												0.0031	0.0039	0.0047
0.7500													0.0031	0.0039
1.0000														0.0039

## Feed matrices – $f_z$ table metric

The specified cutting data are average recommended values.  
For special applications, adjustment is recommended.

### A ISO P, ISO K material groups

$a_e$ [mm]*	Feed per tooth $f_z$ [mm]								
	Ø 2 mm	Ø 3 mm	Ø 4 mm	Ø 6 mm	Ø 8 mm	Ø 10 mm	Ø 12 mm	Ø 16 mm	Ø 20 mm
0.01	0.06	0.09	0.12	0.15	0.15	0.20			
0.05	0.04	0.07	0.10	0.12	0.15	0.20			
0.1	0.03	0.05	0.08	0.10	0.15	0.20	0.20	0.20	
0.2	0.03	0.04	0.06	0.08	0.15	0.18	0.20	0.20	0.25
0.5	0.02	0.03	0.05	0.07	0.12	0.15	0.15	0.15	0.25
1	0.02	0.03	0.04	0.06	0.09	0.12	0.12	0.12	0.20
2	0.02	0.03	0.03	0.05	0.08	0.11	0.12	0.12	0.20
3		0.02	0.02	0.04	0.07	0.10	0.12	0.12	0.18
5			0.02	0.04	0.07	0.10	0.12	0.12	0.15
6				0.03	0.06	0.08	0.10	0.12	0.15
8					0.05	0.07	0.09	0.12	0.15
10						0.06	0.08	0.12	0.14
12							0.07	0.11	0.14
14								0.10	0.13
16								0.09	0.12
18									0.11
20									0.10
25									
32									
40									
50									
63									
80									
100									
160									
200									

### B ISO M material groups

$a_e$ [mm]*	Feed per tooth $f_z$ [mm]								
	Ø 2 mm	Ø 3 mm	Ø 4 mm	Ø 6 mm	Ø 8 mm	Ø 10 mm	Ø 12 mm	Ø 16 mm	Ø 20 mm
0.01	0.05	0.07	0.10	0.12	0.12	0.16			
0.05	0.03	0.06	0.08	0.10	0.12	0.16			
0.1	0.03	0.04	0.06	0.08	0.12	0.16	0.16	0.16	
0.2	0.02	0.03	0.05	0.06	0.12	0.14	0.16	0.16	0.20
0.5	0.02	0.02	0.04	0.06	0.10	0.12	0.12	0.12	0.20
1	0.02	0.02	0.03	0.05	0.07	0.10	0.10	0.10	0.16
2	0.02	0.02	0.02	0.04	0.06	0.09	0.10	0.10	0.16
3		0.02	0.02	0.04	0.06	0.08	0.10	0.10	0.14
5			0.02	0.03	0.06	0.08	0.10	0.10	0.12
6				0.02	0.05	0.06	0.08	0.10	0.12
8					0.04	0.06	0.07	0.10	0.12
10						0.05	0.06	0.10	0.11
12							0.06	0.09	0.11
14								0.08	0.10
16								0.07	0.10
18									0.09
20									0.08
25									
32									
40									
50									
63									
80									
100									
160									
200									

\* Radial feed in mm



## Walter USA, LLC

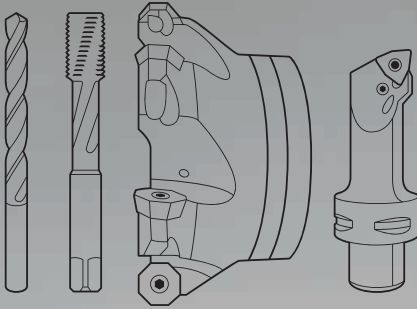
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N22W23855 RidgeView Parkway West  
Waukesha, WI 53188, USA

Phone: 800-945-5554 Fax: 262-347-2500  
service.us@walter-tools.com

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### Walter Canada

service.ca@walter-tools.com

### Walter Tools S.A. de C.V.

Carr. Estatal KM 2.22 #431, Módulo 3, Interior 19 y 20  
El Colorado Galindo, Municipio El Marqués,  
Querétaro, C.P. 76246, México  
Phone: +52 (442) 478-3500  
service.mx@walter-tools.com

### TDM Systems Inc.

1901 N. Roselle Rd. Suite 800  
Schaumburg, IL 60195, USA  
Phone: 847-605-1269  
info@tdmsystems.com  
www.tdmsystems.com

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