

Multiply your success – with four cutting edges.

NEW

THE INDEXABLE INSERTS

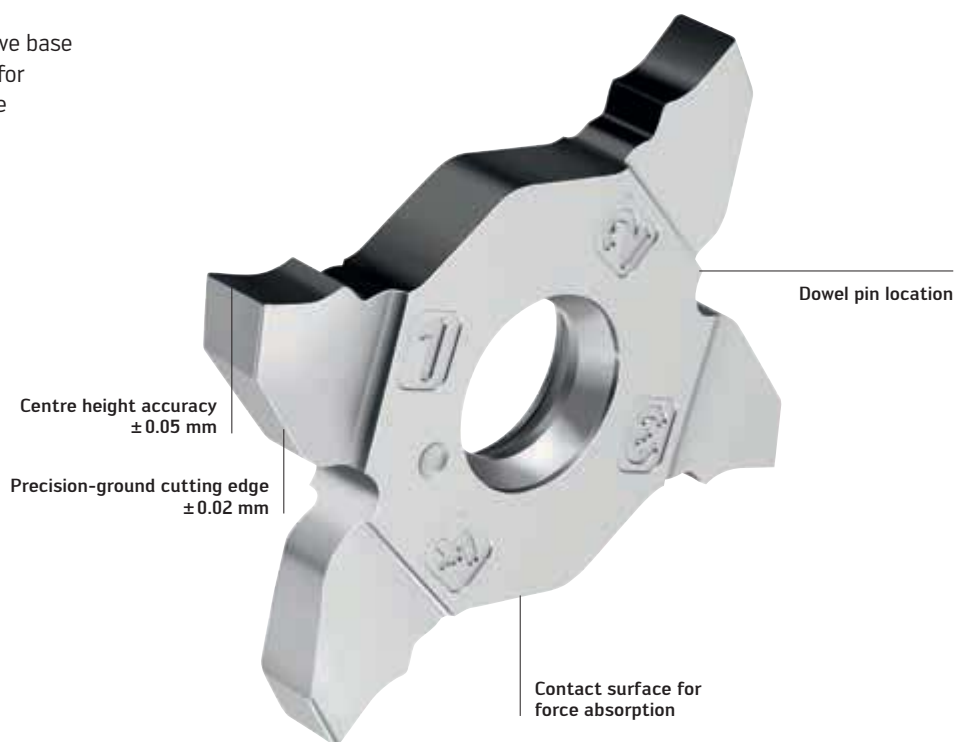
- Four precision-ground cutting edges
- Three contact points in the tool, tangentially mounted, screw fastened
- Insert widths of 1.00–3.25 mm
- Cutting depth of up to 6 mm (depending on the width of the cutting insert)
- One cutting insert for left and right tool holders

THE GEOMETRY

- GD8: Positive rake angle geometry for reduced cutting forces
- Straight cutting edge for flat groove base
- Chip formation particularly suited for special shapes up to 5.65 mm wide

THE APPLICATION

- For grooving, parting off and chamfering with four cutting edges
- For DIN 471 circlip grooves with the tolerance class H13
- Use on all types of lathes
- Ideal for precise grooves and small diameters (very precise centre height and precision-ground cutting edge)
- Can be used from 10 bar up to a maximum coolant pressure of 150 bar



MX grooving insert with four cutting edges

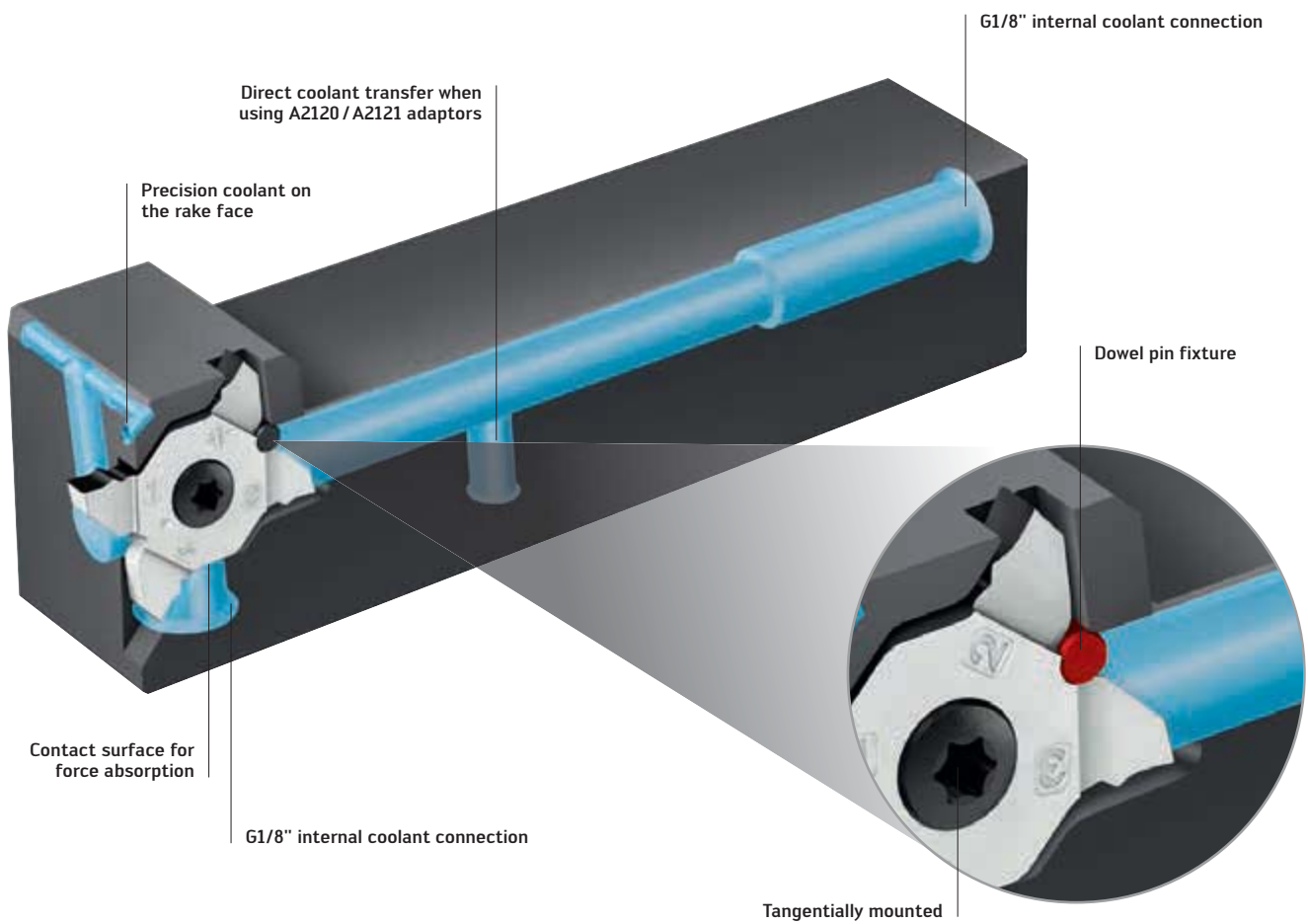
Fig.: MX22...-GD8

BENEFITS FOR YOU

- Tangential arrangement enables outstanding flatness and surface quality
- Very user friendly thanks to self-aligning tangential clamping
- Maximum change accuracy thanks to dowel pin location in insert seat
- Safe and easy to use: Cutting edge cannot be fitted incorrectly
- If one cutting edge breaks, the other cutting edges remain useable
- Maximum tool life thanks to the newest Tiger-tec® Silver PVD cutting tool material

THE TOOL

- Grooving and parting off tool with precision coolant
- Toolholder protected by the insert core
(insert seat is not damaged if a cutting edge breaks)
- Stable tangential insert clamping for optimal force absorption



MX monoblock tool with precision coolant

Fig.: G3011-P

Watch product video:
Scan this QR code or go directly to
<http://goo.gl/dRWff7>



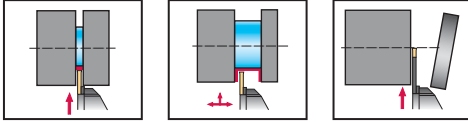
Shank tool – Radial grooving

G3011...-P

Walter Cut





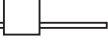
- Screw clamping
- Precision coolant



Tool	Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f ₁ mm	l ₁ mm	l ₄ mm	Type
	★ G3011-1616R/L-MX22-2-P	1-3,25	6	16	16	14,3	125	25	MX22-2E ..
	★ G3011-2020R/L-MX22-2-P	1-3,25	6	20	20	18,3	125	25	MX22-2E ..
	★ G3011-2525R/L-MX22-2-P		6	25	25	23,3	125	25	

f = f₁ + s/2
 For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for internal coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3011-1616R-MX22-2-P / ordering example, left-hand tool: G3011-1616L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

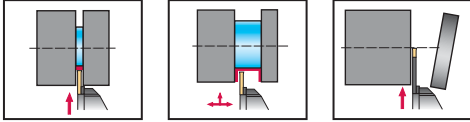
	h = h ₁ [mm]	16	20-25
	Clamping screw for grooving insert Tightening torque	FS1495 (Torx 20IP) 5,0 Nm	FS1495 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)	FS2258 (SW 5)
	M6 threaded plug		FS2288 (SW 3)
	Torx key	FS1464 (Torx 20IP)	FS1464 (Torx 20IP)

Shank tool – Radial grooving

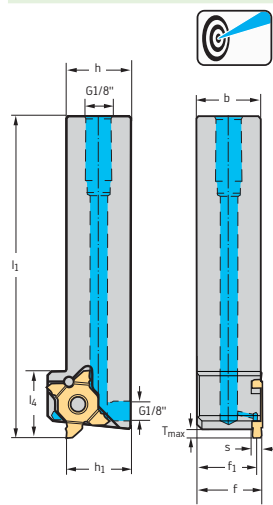
G3011...-P inch

Walter Cut

- Screw clamping
- Precision coolant



Tool



Designation	s Inches	T _{max} Inches	h = h ₁ Inches	b Inches	f Inches	l ₄ Inches	l ₂₁ Inches	Type
★ G3011.12R/L-MX22-2-P	0,039– 0,128	0,236	0,750	0,750	0,684	0,984	5,906	MX22-2E ..
★ G3011.16R/L-MX22-2-P		0,236	1,000	1,000	0,934	0,984	5,906	

$f = f_1 + s/2$
 For information on the maximum cutting depth T_{max} , see "Cutting inserts"
 For the connection set for internal coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3011.12R-MX22-2-P / ordering example, left-hand tool: G3011.12L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

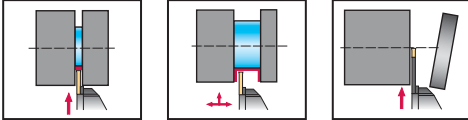
Assembly parts

	h = h ₁ [inches]	0,750-1,000
	Clamping screw for grooving insert Tightening torque	FS1495 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)
	Torx key	FS1464 (Torx 20IP)

Shank tool – 90° radial grooving G3021...-P

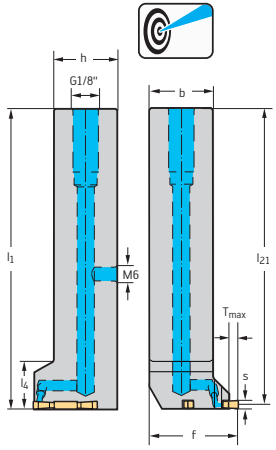
Walter Cut

- Screw clamping
- Precision coolant



Tool

Designation	s mm	T _{max} mm	h = h ₁ mm	b mm	f mm	l ₄ mm	l ₂₁ mm	Type
★ G3021-2020R/L-MX22-2-P	1-3,25	6	20	20	30	20	116,3	MX22-2E ..
★ G3021-2525R/L-MX22-2-P		6	25	25	35	20	116,3	



l₁ = l₂₁ + s/2
 For information on the maximum cutting depth T_{max}, see "Cutting inserts"
 For the connection set for internal coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3021-2020R-MX22-2-P / ordering example, left-hand tool: G3021-2020L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts	h = h ₁ [mm]	20-25
	Clamping screw for grooving insert Tightening torque	FS1495 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)
	Torx key	FS1464 (Torx 20IP)

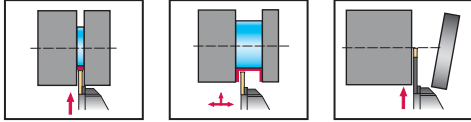


Shank tool – 90° radial grooving

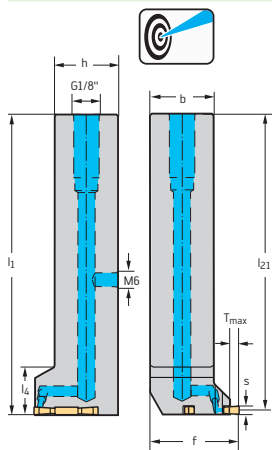
G3021...-P inch

Walter Cut

- Screw clamping
- Precision coolant



Tool



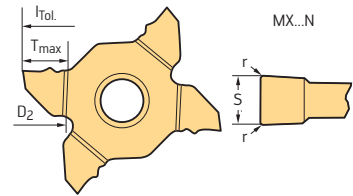
Designation	s Inches	T _{max} Inches	h = h ₁ Inches	b Inches	f Inches	l ₄ Inches	l ₂₁ Inches	Type
★ G3021.16R/L-MX22-2-P	0,039– 0,128	0,236	1,000	1,000	1,394	0,787	4,580	MX22-2E ..

$l_1 = l_{21} + s/2$
 For information on the maximum cutting depth T_{max} , see "Cutting inserts"
 For the connection set for internal coolant supply with G1/8" thread, see "Assembly parts and accessories"
 The maximum recommended coolant pressure is 150 bar (2175 psi)
 Ordering example, right-hand tool: G3021.16R-MX22-2-P / ordering example, left-hand tool: G3021.16L-MX22-2-P
 Bodies and assembly parts are included in the scope of delivery.

Assembly parts

	h = h ₁ [inches]	1,000
	Clamping screw for grooving insert Tightening torque	FS1495 (Torx 20IP) 5,0 Nm
	G 1/8" threaded plug	FS2258 (SW 5)
	Torx key	FS1464 (Torx 20IP)

Grooving and parting off MX cutting inserts Tiger-tec® Silver



Cutting inserts

Designation	s mm	r mm	T _{max} mm	D ₂ mm	l mm	f mm	S _{Tol} mm	l _{Tol} mm	P		M		K		S		
									HC		HC		HC		HC		
									WKP23S	WSM33S	WSM43S	WSM23S	WSM33S	WSM43S	WKP23S	WSM23S	WSM33S
MX22-2E100N01-GD8	1	0,1	3,5	130	22	0,03-0,06	±0,02	±0,03									
MX22-2E120N01-GD8	1,2	0,1	3,5	130	22	0,03-0,07	±0,02	±0,03									
MX22-2E140N01-GD8	1,4	0,1	4	130	22	0,03-0,08	±0,02	±0,03									
MX22-2E150N01-GD8	1,5	0,1	4	130	22	0,03-0,09	±0,02	±0,03									
MX22-2E157N02-GD8	1,57	0,2	4,5	130	22	0,03-0,10	±0,02	±0,03									
MX22-2E170N02-GD8	1,7	0,2	5	130	22	0,03-0,10	±0,02	±0,03									
MX22-2E185N02-GD8	1,85	0,2	5,5	130	22	0,04-0,10	±0,02	±0,03									
MX22-2E196N02-GD8	1,96	0,2	6	100	22	0,04-0,10	±0,02	±0,03									
MX22-2E200N02-GD8	2	0,2	6	100	22	0,04-0,10	±0,02	±0,03									
MX22-2E224N02-GD8	2,24	0,2	6	100	22	0,04-0,12	±0,02	±0,03									
MX22-2E239N02-GD8	2,39	0,2	6	100	22	0,04-0,14	±0,02	±0,03									
MX22-2E275N02-GD8	2,75	0,2	6	100	22	0,04-0,14	±0,02	±0,03									
MX22-2E300N02-GD8	3	0,2	6	100	22	0,04-0,14	±0,02	±0,03									
MX22-2E318N02-GD8	3,18	0,2	6	100	22	0,04-0,14	±0,02	±0,03									
MX22-2E325N02-GD8	3,25	0,2	6	100	22	0,04-0,15	±0,02	±0,03									

 l_{Tol} = Repeat accuracy when changing indexable insert

 Radius tolerance r_{Tol} = ± 0.05 mm

 For information on T_{max} with diameters larger than D₂, see "Technical information – Grooving"

HC = Coated carbide