

Wohlhaupter Insert Grades

Uncoated Carbide

Uncoated Carbide

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WHW01 (HW)	<ul style="list-style-type: none"> Fine-grain carbide Finishing & light roughing Non-ferrous metals, cast materials & difficult-to-machine alloys 	P								
		M								
		K								
		N								
		S								
		H								
WHW16 (HW)	<ul style="list-style-type: none"> Fine-grain carbide Finishing & light roughing Non-ferrous metals, cast materials & difficult-to-machine alloys 	P								
		M								
		K								
		N								
		S								
		H								
WHW20 (HW)	<ul style="list-style-type: none"> Tough fine-grain carbide Finishing, roughing & grooving Steel & cast materials, cast steel Non-ferrous materials & difficult-to-machine alloys 	P								
		M								
		K								
		N								
		S								
		H								

Wohlhaupter Insert Grades

Coated Carbide

Coated Carbide

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WHC05 (HC)	<ul style="list-style-type: none"> PVD coating with nano-composite structure Finishing & roughing Steels, stainless steels, cast materials, & difficult-to-machine alloys 	P								
		M								
		K								
		N								
		S								
		H								
WHC18 (HC)	<ul style="list-style-type: none"> PVD-TiB2 coating Finishing & light roughing Non-ferrous metals 	P								
		M								
		K								
		N								
		S								
		H								
WHC19 (HC)	<ul style="list-style-type: none"> Multilayer PVD coating Finishing & roughing Stainless steels 	P								
		M								
		K								
		N								
		S								
		H								
WHC20 (HC)	<ul style="list-style-type: none"> Multilayer CVD coating Finishing Steels & stainless steels 	P								
		M								
		K								
		N								
		S								
		H								
WHC30 (HC)	<ul style="list-style-type: none"> CVD coating Roughing Steel & cast steel 	P								
		M								
		K								
		N								
		S								
		H								
WHC79 (HC)	<ul style="list-style-type: none"> Multilayer MT CVD coating Roughing & finishing Steels, stainless steels & cast materials 	P								
		M								
		K								
		N								
		S								
		H								
WHC81 (HC)	<ul style="list-style-type: none"> Thick MT CVD coating with adominal AL203 High cutting speeds possible Excellent choice for cast materials 	P								
		M								
		K								
		N								
		S								
		H								
WHC88 (HC)	<ul style="list-style-type: none"> Multilayer PVD coating Finishing & roughing Universal usage 	P								
		M								
		K								
		N								
		S								
		H								

Wohlhaupter Insert Grades

Coated Carbide

Coated Carbide

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WHC98 (HC)	<ul style="list-style-type: none"> PVD TiAlN coating Roughing & finishing Steels, stainless steels & difficult-to-machine materials 	P								
		M								
		K								
		N								
		S								
		H								
WHC111 (HC)	<ul style="list-style-type: none"> PVD TiAlN coating Finishing Machining of steels after heat treating with high Cr content up to 60 HRC Hard - soft transitions, difficult-to-machine alloys & stainless steels 	P								
		M								
		K								
		N								
		S								
		H								
WHC114 (HC)	<ul style="list-style-type: none"> Multilayer PVD coating Finishing & roughing Steels, stainless steels, & difficult-to-machine materials 	P								
		M								
		K								
		N								
		S								
		H								
WHC136 (HC)	<ul style="list-style-type: none"> Stronger PVD coating with improved coating adhesion High oxidation resistance allows a wide range of applications 	P								
		M								
		K								
		N								
		S								
		H								
WHC164 (HC)	<ul style="list-style-type: none"> Thick MT-CVD coating with a dominant AC₂O₃ Primarily developed for the material groups P-K & alternatively H Full & discontinuous cut High cutting speeds possible 	P								
		M								
		K								
		N								
		S								
		H								
WHC168 (HC)	<ul style="list-style-type: none"> Multilayer MT CVD coating Excellent combination of toughness & reliability Steels, cast materials & alternatively for stainless steel 	P								
		M								
		K								
		N								
		S								
		H								
WHC170 (HC)	<ul style="list-style-type: none"> Multilayer MT CVD coating Excellent toughness First choice for strong interruptions Cast materials and steel 	P								
		M								
		K								
		N								
		S								
		H								
WHC198 (HC)	<ul style="list-style-type: none"> Upgraded PVD grade with hard AlTiN coating Optimized cutting edge stability General machining of steel, stainless steel, high-temperature resistant alloys, titanium, iron, cast iron, & non-ferrous materials 	P								
		M								
		K								
		N								
		S								
		H								
WHC190 (HC)	<ul style="list-style-type: none"> Newest generation multilayer PVD coating Finishing & roughing Extremely universal & the first choice for poor machining conditions Excellent in cast steels, stainless steels, & super alloys 	P								
		M								
		K								
		N								
		S								
		H								

Wohlhaupter Insert Grades

Uncoated Cermet | Coated Cermet

Uncoated Cermet

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WHT10 (HT)	<ul style="list-style-type: none"> Uncoated cermet Finishing Steels, stainless steels & cast materials 	P								
		M								
		K								
		N								
		S								
WHT12 (HC)	<ul style="list-style-type: none"> Uncoated cermet Finishing Steels, cast materials, sintered metals, & non-ferrous metals 	P								
		M								
		K								
		N								
		S								
WHT32 (HC)	<ul style="list-style-type: none"> Uncoated cermet Finishing Steels & cast materials 	P								
		M								
		K								
		N								
		S								

Coated Cermet

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WTC15 (TC)	<ul style="list-style-type: none"> New PVD brilliant coating Reduce friction coefficient in turning applications Coated cermet general purpose grade for material group Achieves excellent surface finish with excellent wear resistance Usable in stainless steels 	P								
		M								
		K								
		N								
		S								
WTC121 (TC)	<ul style="list-style-type: none"> PVD coated cermet Finishing of steels & stainless steels 	P								
		M								
		K								
		N								
		S								

Wohlhaupter Insert Grades

Uncoated Cubic Boron Nitride | Coated Cubic Boron Nitride

Uncoated Cubic Boron Nitride

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WBN150 (BN)	<ul style="list-style-type: none"> Uncoated CBN grade Roughing & finishing smooth & slightly discontinuous cuts Hardened steels 52 - 64 HRC Grain size 2 µm CBN content: 50% 	P								
		M								
		K								
		N								
		S								
		H								
WBN200 (BN)	<ul style="list-style-type: none"> Uncoated CBN grade Roughing & finishing highly discontinuous cuts Hardened steels 52 - 64 HRC Grain size 3 µm CBN content: 65% 	P								
		M								
		K								
		N								
		S								
		H								
WBN300 (BN)	<ul style="list-style-type: none"> Uncoated CBN grade Roughing & finishing smooth cuts Hardened steels 52 - 64 HRC Grain size 0.5 - 1.0 µm CBN content: approximately 50% 	P								
		M								
		K								
		N								
		S								
		H								
WBN450 (BN)	<ul style="list-style-type: none"> Uncoated CBN grade Roughing & finishing smooth & discontinuous cuts Pearlite grey cast iron & sintered metals Grain size 2 µm CBN content: 90% 	P								
		M								
		K								
		N								
		S								
		H								
WBN448 (BN)	<ul style="list-style-type: none"> Uncoated CBN grade Roughing & finishing smooth & discontinuous cuts Pearlite grey cast iron & sintered metals and ductile iron CBN content: 90% 	P								
		M								
		K								
		N								
		S								
		H								

Coated Cubic Boron Nitride

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WBC300 (BC)	<ul style="list-style-type: none"> Coated CBN Roughing and finishing smooth cuts Hardened steels 52 - 64 HRC Grain size 1 µm CBN content: 50% 	P								
		M								
		K								
		N								
		S								
		H								

Wohlhaupter Insert Grades

Polycrystalline Diamond | Ceramic Cutting Material

Polycrystalline Diamond

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
PCD D30 (DP)	<ul style="list-style-type: none"> PCD medium grain grade Finishing Al alloys & Mg alloys up to 12% Si Grain size 10 µm 	P								
		M								
		K								
		N								
		S								
		H								
PCD D50 (DP)	<ul style="list-style-type: none"> PCD mixed-grain grade Finishing CFRP, GRP, MMC, Al alloys over 12% Si Grain size 2 - 30 µm 	P								
		M								
		K								
		N								
		S								
		H								

Ceramic Cutting Material

Cutting Material	Description	Material	ISO Application							
			05	10	15	20	25	30	35	40
WCN06 (CN)	<ul style="list-style-type: none"> Uncoated silicon-nitride ceramic Roughing Pearlite grey cast iron 	P								
		M								
		K								
		N								
		S								
		H								