












Wohlhaupter Insert Geometries

Cermet | Carbide












Cermet | Carbide

Geometry	Description	Application	Available Form
108 	<ul style="list-style-type: none"> Sintered chip breaker for higher feeds Suitable for highly discontinuous cuts 	▼▼▼ ▼	F101, F103, F104, F112, F113
109 	<ul style="list-style-type: none"> Sintered geometry with V-shaped chip breaker for roughing & finishing Good chip control even for shallow depth of cut 	▼▼▼ ▼	F101, F103, F104
112 	<ul style="list-style-type: none"> Sintered chip breaker Finishing & light roughing 	▼▼▼ ▼	F101, F103
121 	<ul style="list-style-type: none"> Positive geometry with stable cutting edge Finishing in different material groups Good chip control 	▼▼▼	F20, F211
122 	<ul style="list-style-type: none"> Sintered chip breaker Good chip control - even with long-chipping materials 	▼▼▼	F101, F103, F161
126 	<ul style="list-style-type: none"> Sintered version with a wide range of applications 	▼	F105
127 	<ul style="list-style-type: none"> Highly positive sintered geometry For non-ferrous metals & cast iron 	▼▼▼ ▼	F37, F39, F101, F103, F104, F112, F113
128 	<ul style="list-style-type: none"> Highly positive sintered geometry Polished for finishing non-ferrous metals, cast iron, & steel 	▼▼▼	F20
129 	<ul style="list-style-type: none"> Highly positive chip breaking geometry Polished for non-ferrous metals, cast iron, & steel Ideal for structural steel applications 	▼▼▼ ▼	F37, F39, F101, F103
145 	<ul style="list-style-type: none"> Geometry for finishing in smooth & discontinuous cut Good chip control - even with long-chipping materials 	▼▼▼ ▼	F101, F103, F112, F113, F161
146 	<ul style="list-style-type: none"> Positive geometry with stable cutting edge Universal usage for roughing, finishing and chamfering 	▼▼▼ ▼	F037, F039, F101, F103, F104, F112, F113,

Wohlhaupter Insert Geometries

Cermet | Carbide



Cermet | Carbide

Geometry	Description	Application	Available Form
155 	<ul style="list-style-type: none"> Positive sintered geometry Special cutting edge design in combination with the chip breaker design enables exceptional chip control even at shallow cutting depths & light feeds 	▼▼▼	F20, F101, F103, F39
158 	<ul style="list-style-type: none"> Stable sintered geometry for roughing & finishing with & without discontinuous cuts 	▼▼▼ ▼	F101, F103, F104, F105, F113, F114, F163
174W 	<ul style="list-style-type: none"> Wiper geometry for highly productive turning & boring Can be used with pitch angle 92° - 95° Good chip breaking properties even at lower feed rates 	▼▼▼ ▼	F101, F103
192 	<ul style="list-style-type: none"> Sintered version for a variety of applications Low cutting pressure because of sharp cutting edge prep 	▼▼▼ ▼	F39, F101, F103, F104, F112, F113, F163, F161, F262, F264
199 	<ul style="list-style-type: none"> Positive sintered geometry for wide variety of applications Special chip breaker allows chip control with different radial depth of cut 	▼▼▼ ▼	F101, F103, F104, F112, F113
200 	<ul style="list-style-type: none"> Highly positive sintered geometry Applicable for various material groups for low cutting pressure 	▼▼▼ ▼	F39, F101, F103, F104, F264
650 	<ul style="list-style-type: none"> Obliquely ground chip breaker reduces cutting forces Finishing & smooth interrupted cuts 	▼▼▼	F20, F211
711 	<ul style="list-style-type: none"> Negative geometry with 0 rake suitable for fine finishing and semi roughing Machined materials in groups K & H Continuous and moderately interrupted cut 	▼▼▼ ▼	F101, F103, F104, F113, F163
840 	<ul style="list-style-type: none"> Parallel ground chip breaker For finish operations with stable cutting edge 	▼▼▼	F20
850 	<ul style="list-style-type: none"> Parallel ground chip breaker Good chip control with short to medium feeds 	▼▼▼	F161
860 	<ul style="list-style-type: none"> Parallel ground chip breaker reduces cutting forces Stable for a wide range of applications 	▼▼▼ ▼	F101, F103, F104, F105, F325


Wohlhaupter Insert Geometries

Tangential | Ceramic

Tangential

Geometry	Description	Application	Available Form
880 	<ul style="list-style-type: none"> Large parallel ground chip breaker with 10° rake angle for reduced cutting force 	▼	F04, F05
811 	<ul style="list-style-type: none"> Smooth geometry without additional ground chip breaker Reinforced cutting edges provide stability Excellent for cast materials 	▼	F05




Ceramic

Geometry	Description	Application	Available Form
711 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle High cutting edge stability particularly in discontinuous cuts 	▼	F75, F103, F104, F123

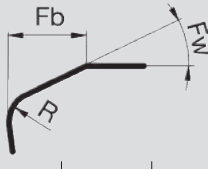







Wohlhaupter Insert Geometries

PCD | CBN

PCD

Geometry	Description	Application	Available Form
720 	<ul style="list-style-type: none"> Smooth geometry in positive version with 7° rake angle for PCD Sharp cutting edge 	▼▼▼	F20, F101, F103
730 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for PCD Sharp cutting edge 	▼▼▼	F20, F39, F75, F101, F103, F123, F211, F262, F264
735 	<ul style="list-style-type: none"> Smooth geometry Laser-cut chip breaker for PCD Suitable for long-chipping aluminium wrought alloys 	▼▼▼	F20, F39, F101, F103, F211, F262, F264

CBN

Geometry	Description				Application	Available Form
		R	Fb	Fw		
741 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge with 30° chamfer 	0.015	0.15	30°	▼▼▼	F20, F101, F103
742 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge with 15° chamfer 	0.015	0.1	15°	▼▼▼	F20, F101, F103
745 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge with 30° chamfer 	0.015	0.05	30°	▼▼▼	F20, F211
747 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge with a small 20° chamfer 	0.015	0.1	20°	▼▼▼	F39, F104, F262, F264
748 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge No chamfer 	0.015	0.2	20°	▼▼▼	F20, F101, F103, F211
749 	<ul style="list-style-type: none"> Smooth geometry with 0° rake angle for CBN Rounded cutting edge with a large 20° chamfer 	0.015	0.2	20°	▼▼▼ ▼	F75, F123, F264
768 	<ul style="list-style-type: none"> Smooth geometry with 7° rake angle for CBN Rounded cutting edge 	0.015	-	-	▼▼▼	F20, F101, F103