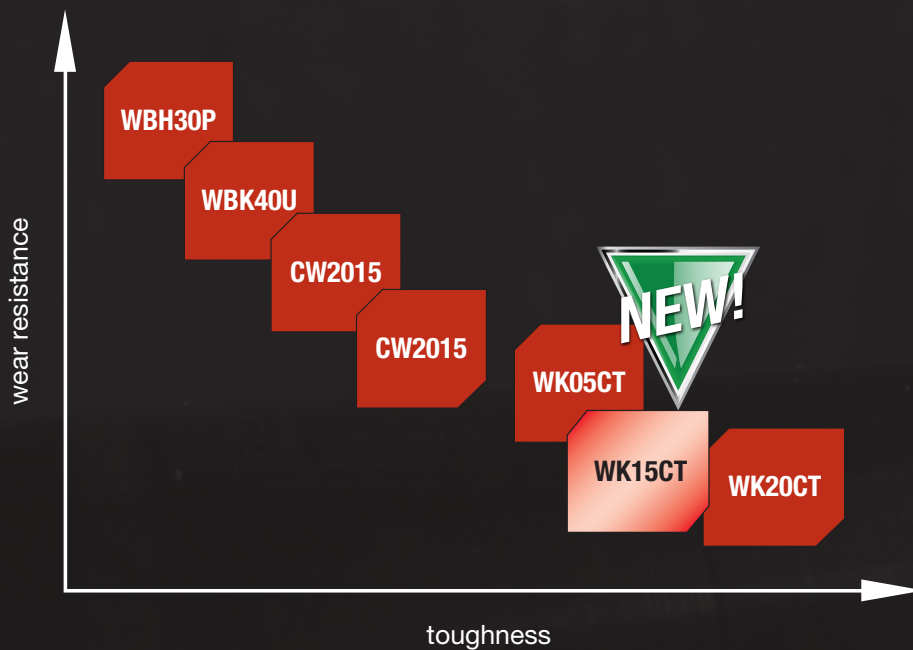


# WK15CT



NEW VICTORY™ GRADE  
FOR CAST IRON TURNING





## Coating

NEW: Substrate and Victory™ coating.

Multilayer CVD coating of TiCN and Al<sub>2</sub>O<sub>3</sub> with pre and post-coat treatment providing improved edge toughness and long predictable tool life at elevated cutting speeds.



## Machining Capabilities

Developed to perform in roughing, semi-finishing, and finishing in all types of grey cast iron.

Also suitable for: Different types of nodular iron



WK15CT in cast iron turning not only helps in cost reduction, but also cycle time reduction through improved cutting parameters and better productivity.

# WK15CT

High-Performance Inserts • WIDIA™ Victory™

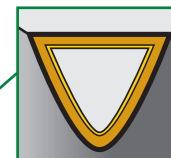


WK15CT provides consistent performance at high cutting speeds and feeds in machining grey cast iron and ductile irons in roughing to finishing applications.

## Features:

- Improved productivity and reduced cycle times.
- Post-coat grinding provides secure seating surface.
- A multi-layer CVD coated grade with TiN-TiCN-Al<sub>2</sub>O<sub>3</sub> over a wear-resistant substrate specially developed to give consistent performance and superior tool life while machining cast irons.
- The wear-resistant substrate resists deformation while machining at elevated cutting speeds.
- The thick CVD coating with post-coat treatment provides long and consistent tool life.
- Can be applied in both continuous and lightly interrupted cuts for grey and ductile irons.

Post-coat treatment improves edge toughness and provides long predictable tool life.



TiN-TiCN-Al<sub>2</sub>O<sub>3</sub>

Wear-resistant coating provides better tool life at elevated cutting speeds.

WK15CT replaces the old grades TN5120, HK150. Available in most popular geometries in both negative and positive ISO insert styles.

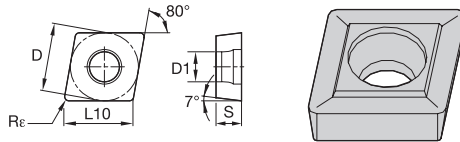
| Negative style inserts | Geometry     |
|------------------------|--------------|
| CNMA                   | MA           |
| CNMG                   | STD, -5, -RH |
| WNMA                   | MA           |
| WNMG                   | STD, -5, -RH |
| TNMA                   | MA           |
| TNMG                   | STD, -RH     |
| SNMA                   | MA           |
| SNMG                   | STD          |
| DNMG                   | STD, -RH     |

| Positive style inserts | Geometry |
|------------------------|----------|
| CCMT                   | STD, MP  |
| DCMT                   | STD      |
| SCMT                   | MP       |
| TCMT                   | MP       |
| VBMT                   | STD      |
| VCMT                   | STD      |



# High-Performance Inserts • WIDIA™ Victory™

## CCMT

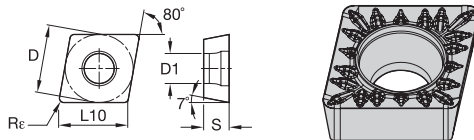


- first choice
- alternate choice

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| H | <input type="radio"/>            |

| ISO catalogue number | D    | L10  | S    | Rε  | D1   | WK15CT  |
|----------------------|------|------|------|-----|------|---------|
| CCMT060204           | 6,35 | 6,45 | 2,38 | 0,4 | 2,80 | 6671876 |
| CCMT090304           | 9,53 | 9,67 | 3,18 | 0,4 | 4,40 | 6671877 |
| CCMT09T304           | 9,53 | 9,67 | 3,97 | 0,4 | 4,40 | 6613610 |
| CCMT09T308           | 9,53 | 9,67 | 3,97 | 0,8 | 4,40 | 6613604 |

## CCMT-MP

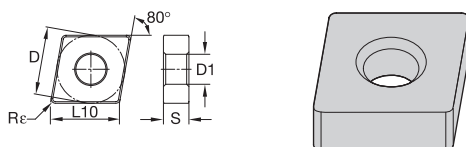


- first choice
- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| CCMT120408MP         | 12,70 | 12,90 | 4,76 | 0,8 | 5,50 | 6730909 |
| CCMT120412MP         | 12,70 | 12,90 | 4,76 | 1,2 | 5,50 | 6730910 |

## CNMA



- first choice
- alternate choice

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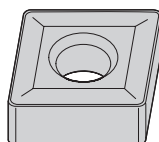
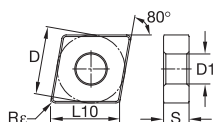
| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| CNMA120408           | 12,70 | 12,90 | 4,76 | 0,8 | 5,16 | 6287922 |
| CNMA120412           | 12,70 | 12,90 | 4,76 | 1,2 | 5,16 | 6287923 |



# WK15CT

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## CNMG

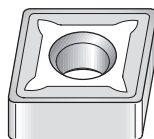
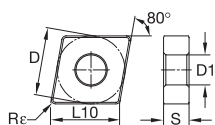


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- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
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| CNMG120404           | 12,70 | 12,90 | 4,76 | 0,4 | 5,16 | 6613606 |

## CNMG-5

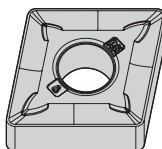
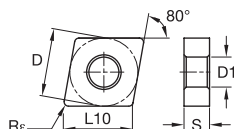


- first choice
- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| CNMG120408-5         | 12,70 | 12,90 | 4,76 | 0,8 | 5,16 | 6287924 |
| CNMG120412-5         | 12,70 | 12,90 | 4,76 | 1,2 | 5,16 | 6287925 |

## CNMG-RH



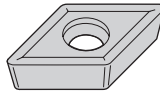
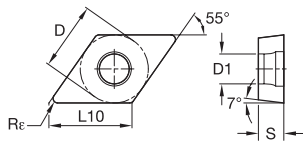
- first choice
- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| CNMG120408RH         | 12,70 | 12,90 | 4,76 | 0,8 | 5,16 | 6288264 |
| CNMG120412RH         | 12,70 | 12,90 | 4,76 | 1,2 | 5,16 | 6288265 |

# High-Performance Inserts • WIDIA™ Victory™

## DCMT

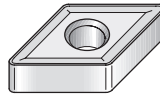
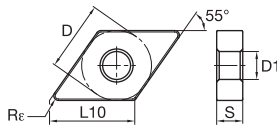


- first choice
- alternate choice

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| ISO catalogue number | D    | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|------|-------|------|-----|------|---------|
| DCMT11T308           | 9,53 | 11,63 | 3,97 | 0,8 | 4,45 | 6671913 |

## DNMG

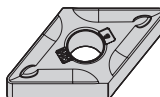
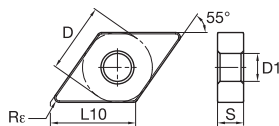


- first choice
- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| DNMG150608           | 12,70 | 15,50 | 6,35 | 0,8 | 5,16 | 6671912 |

## DNMG-RH



- first choice
- alternate choice

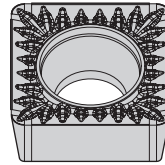
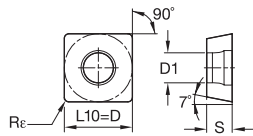
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| H | <input type="radio"/>            |

| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| DNMG150608RH         | 12,70 | 15,50 | 6,35 | 0,8 | 5,16 | 6730880 |
| DNMG150612RH         | 12,70 | 15,50 | 6,35 | 1,2 | 5,16 | 6730901 |

# WK15CT

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## SCMT-MP

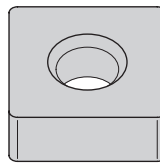
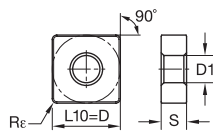


- first choice
- alternate choice

|   |                                  |
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| H | <input type="radio"/>            |

| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| SCMT09T304MP         | 9,53  | 9,53  | 3,97 | 0,4 | 4,40 | 6730906 |
| SCMT09T308MP         | 9,53  | 9,53  | 3,97 | 0,8 | 4,40 | 6730907 |
| SCMT120408MP         | 12,70 | 12,70 | 4,76 | 0,8 | 5,50 | 6730908 |

## SNMA

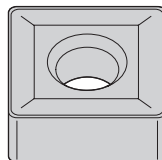
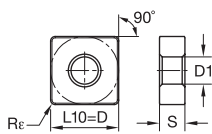


- first choice
- alternate choice

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| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|-------|-------|------|-----|------|---------|
| SNMA120408           | 12,70 | 12,70 | 4,76 | 0,8 | 5,16 | 6287926 |
| SNMA120412           | 12,70 | 12,70 | 4,76 | 1,2 | 5,16 | 6287927 |

## SNMG

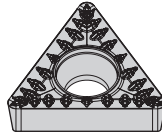
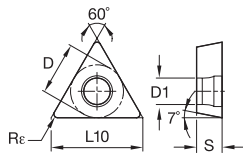


- first choice
- alternate choice

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| N | <input type="radio"/>            |
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| H | <input type="radio"/>            |

| ISO catalogue number | D     | L10   | S    | Rε  | D1   | WK15CT  |
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| SNMG120408           | 12,70 | 12,70 | 4,76 | 0,8 | 5,16 | 6613608 |

### TCMT-MP

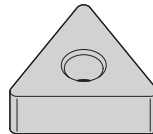
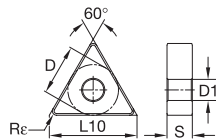


- first choice
- alternate choice

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| ISO catalogue number | D    | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|------|-------|------|-----|------|---------|
| TCMT110208MP         | 6,35 | 11,00 | 2,38 | 0,8 | 2,80 | 6730905 |
| TCMT16T308MP         | 9,53 | 16,50 | 3,97 | 0,8 | 4,40 | 6730904 |

### TNMA

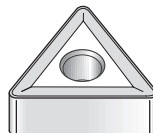
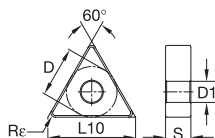


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|----------------------|------|-------|------|-----|------|---------|
| TNMA160408           | 9,53 | 16,50 | 4,76 | 0,8 | 3,81 | 6287930 |
| TNMA160412           | 9,53 | 16,50 | 4,76 | 1,2 | 3,81 | 6287951 |

### TNMG



- first choice

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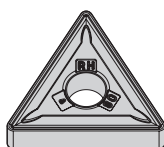
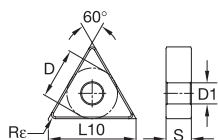
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| TNMG160404           | 9,53 | 16,50 | 4,76 | 0,4 | 3,81 | 6671911 |
| TNMG160408           | 9,53 | 16,50 | 4,76 | 0,8 | 3,81 | 6617524 |
| TNMG160412           | 9,53 | 16,50 | 4,76 | 1,2 | 3,81 | 6671880 |



# WK15CT

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## TNMG-RH

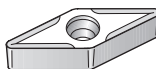
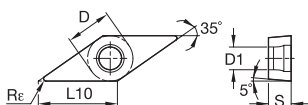


- first choice
- alternate choice

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| ISO catalogue number | D    | L10   | S    | Rε  | D1   | WK15CT  |
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| TNMG160408RH         | 9,53 | 16,50 | 4,76 | 0,8 | 3,81 | 6673946 |

## VBMT

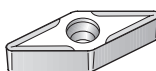
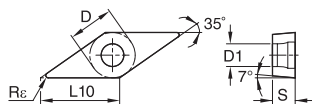


- first choice
- alternate choice

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| ISO catalogue number | D    | L10   | S    | Rε  | D1   | WK15CT  |
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| VBMT160408           | 9,53 | 16,61 | 4,76 | 0,8 | 4,40 | 6671879 |

## VCMT



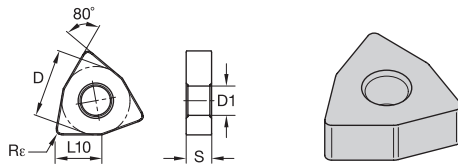
- first choice
- alternate choice

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| ISO catalogue number | D    | L10   | S    | Rε  | D1   | WK15CT  |
|----------------------|------|-------|------|-----|------|---------|
| VCMT16T308           | 9,53 | 16,61 | 3,97 | 0,8 | 4,40 | 6672411 |

# High-Performance Inserts • WIDIA™ Victory™

## WNMA

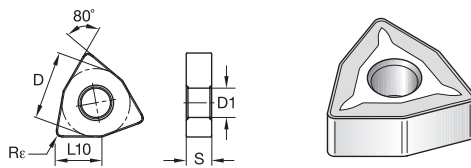


- first choice
- alternate choice

|   |                                  |
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| ISO catalogue number | D     | L10  | S    | Re  | D1   | WK15CT  |
|----------------------|-------|------|------|-----|------|---------|
| WNMA080408           | 12,70 | 8,69 | 4,76 | 0,8 | 5,16 | 6288267 |
| WNMA080412           | 12,70 | 8,69 | 4,76 | 1,2 | 5,16 | 6288268 |

## WNMG-5

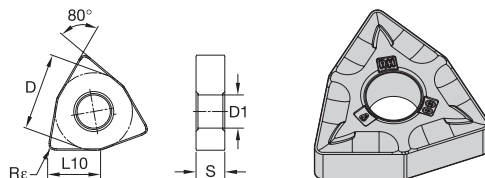


- first choice
- alternate choice

|   |                                  |
|---|----------------------------------|
| P | <input type="radio"/>            |
| M | <input type="radio"/>            |
| K | <input checked="" type="radio"/> |
| N | <input type="radio"/>            |
| S | <input type="radio"/>            |
| H | <input type="radio"/>            |

| ISO catalogue number | D     | L10  | S    | Re  | D1   | WK15CT  |
|----------------------|-------|------|------|-----|------|---------|
| WNMG080408-5         | 12,70 | 8,69 | 4,76 | 0,8 | 5,16 | 6613603 |

## WNMG-RH



- first choice
- alternate choice

|   |                                  |
|---|----------------------------------|
| P | <input type="radio"/>            |
| M | <input type="radio"/>            |
| K | <input checked="" type="radio"/> |
| N | <input type="radio"/>            |
| S | <input type="radio"/>            |
| H | <input type="radio"/>            |

| ISO catalogue number | D     | L10  | S    | Re  | D1   | WK15CT  |
|----------------------|-------|------|------|-----|------|---------|
| WNMG060408RH         | 9,53  | 6,52 | 4,76 | 0,8 | 3,81 | 6673948 |
| WNMG080408RH         | 12,70 | 8,69 | 4,76 | 0,8 | 5,16 | 6290495 |
| WNMG080412RH         | 12,70 | 8,69 | 4,76 | 1,2 | 5,16 | 6288269 |



# WIDIA™ Tools for Railway Wheel Machining

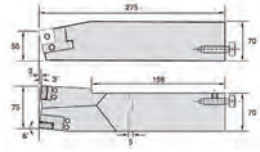
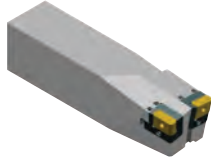
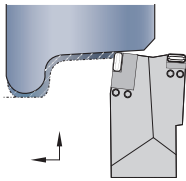
WIDIA offers toolholders and indexable inserts for all types of wheel lathes being used in the Industry.

- The tooling for wheelset reprofiling/reconditioning has been developed in close cooperation with machine tool builders and railway workshops.
- The wheel profile wears during usage and also due to skidding, mismatched wheels, etc.
- Different chipbreaker profile and grades are available to machine the wheels with different wear condition.
- The upended design of inserts enhances the insert strength and the chipbreakers are designed to provide optimum performance with efficient chipbreaking while machining the profile.
- The toolholders adopt the robust lever clamping system.

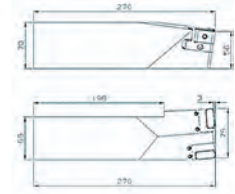
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WIDIA tooling solutions for heavy-duty turning have a proven history of success in these extremely demanding applications around the world. Customers looking for maximum material removal and improved productivity can rely on WIDIA to provide the right tool, inserts, and grades for their workpiece, machine tool, and applications.

## Railway Holders



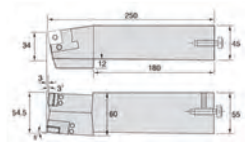
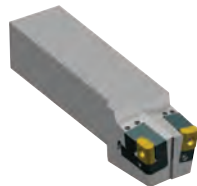
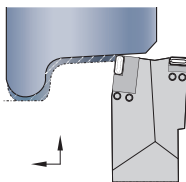
Right Hand Toolholder  
69 391 458 10



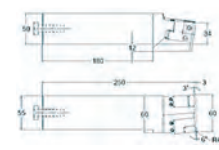
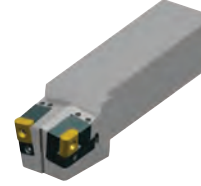
Left Hand Toolholder  
69 391 458 21

| catalogue number  | description                  | insert        | turning cassette | facing cassette | retaining screw | allen key 1 | locking screw | allen key 2 | adjusting screw |
|-------------------|------------------------------|---------------|------------------|-----------------|-----------------|-------------|---------------|-------------|-----------------|
| <b>Right Hand</b> |                              |               |                  |                 |                 |             |               |             |                 |
| 69 391 458 20     | LS compound tool holder (LH) | LNUX 30 19 40 | 69 393 186 20    | 69 393 220 20   | 73 085 863      | 73 398 965  | 73 398 589    | 73 398 931  | 73 398 577      |
| <b>Left Hand</b>  |                              |               |                  |                 |                 |             |               |             |                 |
| 69 391 458 20     | LS compound tool holder (LH) | LNUX 30 19 40 | 69 393 186 20    | 69 393 220 20   | 73 085 863      | 73 398 965  | 73 398 589    | 73 398 931  | 73 398 577      |

\*Additional sizes available as specials.



Right Hand Toolholder  
69 391 431 10



Left Hand Toolholder  
69 391 431 20

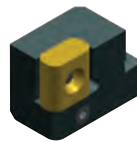
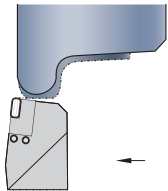
| catalogue number  | description                  | insert        | turning cassette | facing cassette | retaining screw | allen key 1 | locking screw | allen key 2 | adjusting screw |
|-------------------|------------------------------|---------------|------------------|-----------------|-----------------|-------------|---------------|-------------|-----------------|
| <b>Right Hand</b> |                              |               |                  |                 |                 |             |               |             |                 |
| 69 391 431 10     | LS compound tool holder (RH) | LNUX 30 19 40 | 69 393 186 10    | -               | 73 085 863      | 73 398 965  | -             | -           | 73 398 577      |
| <b>Left Hand</b>  |                              |               |                  |                 |                 |             |               |             |                 |
| 69 391 431 20     | LS compound tool holder (LH) | LNUX 30 19 40 | 69 393 186 20    | -               | 73 085 863      | 73 398 965  | -             | -           | 73 398 577      |

\*Additional sizes available as specials.

# Tooling for Heavy-Duty Applications

Railway Tooling

## Railway Cassettes for Toolholders: Turning



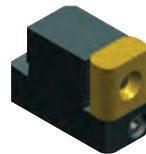
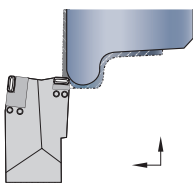
Turning Cassette  
69 393 187 10



Turning Cassette  
69 393 186 10

| catalogue number  | description           | insert        | lever      | clamp      | allen screw |
|-------------------|-----------------------|---------------|------------|------------|-------------|
| <b>Right Hand</b> |                       |               |            |            |             |
| 69 393 186 10     | Turning Cassette (RH) | LNUX 30 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| 69 393 187 10     | Turning Cassette (RH) | LNUX 19 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| <b>Left Hand</b>  |                       |               |            |            |             |
| 69 393 186 20     | Turning Cassette (LH) | LNUX 19 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| 69 393 188 20     | Turning Cassette (LH) | LNUX 30 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |

\*Additional sizes available as specials.



Facing Cassette  
69 393 189 20

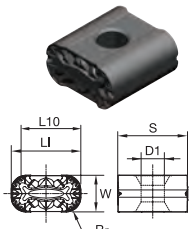
## Railway Cassettes for Toolholders: Facing

| catalogue number  | description          | insert        | lever      | clamp      | allen screw |
|-------------------|----------------------|---------------|------------|------------|-------------|
| <b>Right Hand</b> |                      |               |            |            |             |
| 69 393 190 10     | Facing Cassette (RH) | LNUX 30 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| 69 393 220 10     | Facing Cassette (RH) | LNUX 19 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| <b>Left Hand</b>  |                      |               |            |            |             |
| 69 393 189 20     | Facing Cassette (LH) | LNUX 19 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |
| 69 393 221 20     | Facing Cassette (LH) | LNUX 30 19 40 | 214 85 667 | 214 85 627 | 73 398 965  |

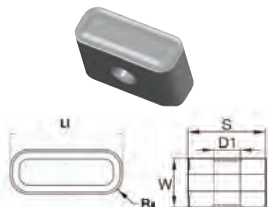
\*Additional sizes available as specials.

\*Spare parts are the same for both facing and turning cassettes.

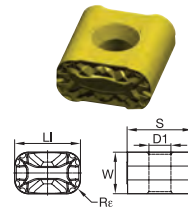
## Inserts



LNUX191940RRP



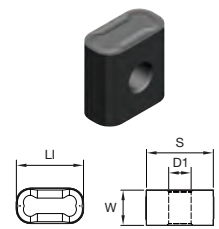
LNUX191940-16,  
LNUX301940-16



LNUX191940-13,  
LNUX301940-13



LNUX191940T,  
LNUX301940T



LNUX191940DB

| catalogue number | w/t | LI    | S     | R | D1   |
|------------------|-----|-------|-------|---|------|
| LNUX191940-13    | 10  | 19,05 | 19,05 | 4 | 6,35 |
| LNUX191940-16    | 10  | 19,05 | 19,05 | 4 | 6,35 |
| LNUX191940DB     | 10  | 19,05 | 19,05 | 4 | 6,35 |
| LNUX191940RRP    | 10  | 19,05 | 19,05 | 4 | 6,35 |
| LNUX191940T      | 10  | 19,05 | 19,05 | 1 | 6,35 |
| LNUX301940-13    | 12  | 30    | 19,05 | 4 | 6,35 |
| LNUX301940-16    | 12  | 30    | 19,05 | 4 | 6,35 |
| LNUX301940T      | 12  | 30    | 19,05 | 4 | 6,35 |



## WIDIA™ Tools for Bar Peeling Applications

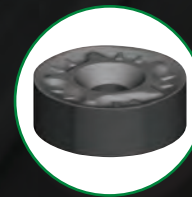
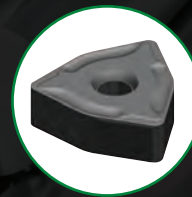
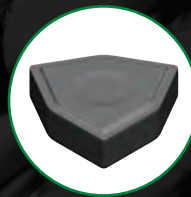
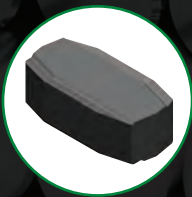
Bar peeling is a unique and economical machining operation for the production of cylindrical surfaces on blank bars (e.g., round bars, wires, blocks, and pipes) with high surface finishes and dimensional accuracies.

During the bar peeling process, scales, cracks, and sand inclusion are removed. Bar peeling is faster than conventional turning. Used when high volumes, high quality, and high productivity with good surface finish are required.



New bar peeling machines demand high performance from cutting tools. WIDIA offers a wide variety of inserts in different grades for cost-effective bar peeling operations in different types of steels, stainless steels, etc. WIDIA also offers toolholders and cartridges for bar peeling as a custom solution.

- Ideal in high feed rate applications, WIDIA bar peeling tools enable economical machining operations for the production of cylindrical surfaces on bright bars.
- High surface finishes, dimensional accuracy, and most efficient removal of scales, cracks, sand enclosures, and other errors.



### Application Range of WIDIA™ Bar Peeling Tools

Bar peeling machines require a high level of utilisation and demand high performance from the cutting tools. WIDIA offers specially developed WIDIA tools with indexable inserts for bar peeling, which are capable of meeting these demands, making manufacturing more cost-efficient.

### WIDIA Victory™ CVD Coated Grades

#### WP15CT

Coated carbide. MT-CVD/CVD — TiN-TiCN-Al<sub>2</sub>O<sub>3</sub>-ZrCN. Good balance of wear resistance and toughness properties. High productivity machining on smooth to lightly interrupted cuts. For steels.

#### WP25CT

Coated carbide. MT-CVD/CVD — TiN-TiCN-Al<sub>2</sub>O<sub>3</sub>-ZrCN. Good toughness properties. Excellent first choice for steel machining, high productivity metal removal for all but the harshest interrupted cuts.

#### WP35CT

Coated carbide. MT-CVD/CVD — TiN-TiCN-Al<sub>2</sub>O<sub>3</sub>-ZrCN. Proven on all roughing and heavy roughing operations, wet or dry, on interrupted and uninterrupted cuts.

#### WM25CT

Coated carbide. MT-CVD/CVD — TiN-TiCN-Al<sub>2</sub>O<sub>3</sub>-ZrCN. Good balance of wear resistance and toughness properties. Light and medium machining. For austenitic stainless steel AISI series.

*For more information on heavy-duty tooling, contact your local sales representative.*