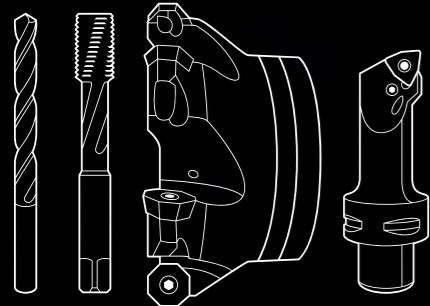


Walter AG

Derendinger Straße 53, 72072 Tübingen
Postfach 2049, 72010 Tübingen
Germany

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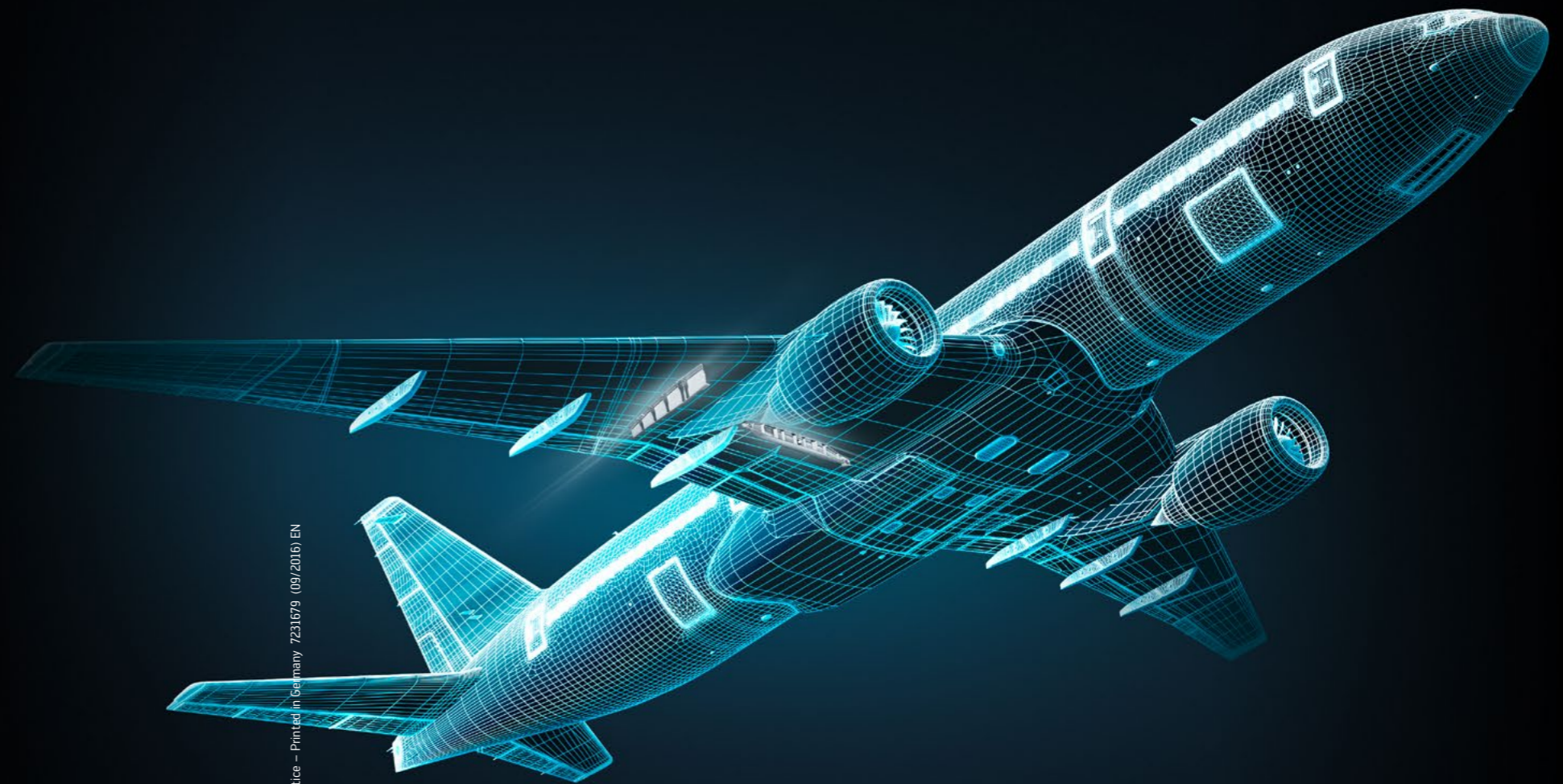


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solutions

Aerospace

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Istanbul, Türkiye
+90 (0) 216 528 1900 Pbx, service.tr@walter-tools.com

Walter Wuxi Co. Ltd.
Wuxi, Jiangsu, P.R. China
+86 (510) 853 72199, service.cn@walter-tools.com

Walter AG Singapore Pte. Ltd.
+65 6773 6180, service.sg@walter-tools.com

Walter Korea Ltd.
Anyang-si Gyeonggi-do, Korea
+82 (31) 337 6100, service.kr@walter-tools.com

Walter Tools India Pvt. Ltd.
Pune, India
+91 (20) 3045 7300, service.in@walter-tools.com

Walter (Thailand) Co., Ltd.
Bangkok, 10120, Thailand
+66 2 687 0388, service.th@walter-tools.com

Walter Malaysia Sdn. Bhd.
Selangor D.E., Malaysia
+60 (3) 5624 4265, service.my@walter-tools.com

Walter Japan K.K.
Nagoya, Japan
+81 (52) 533 6135, service.jp@walter-tools.com

Walter USA, LLC
Waukesha WI, USA
+1 800-945-5554, service.us@walter-tools.com

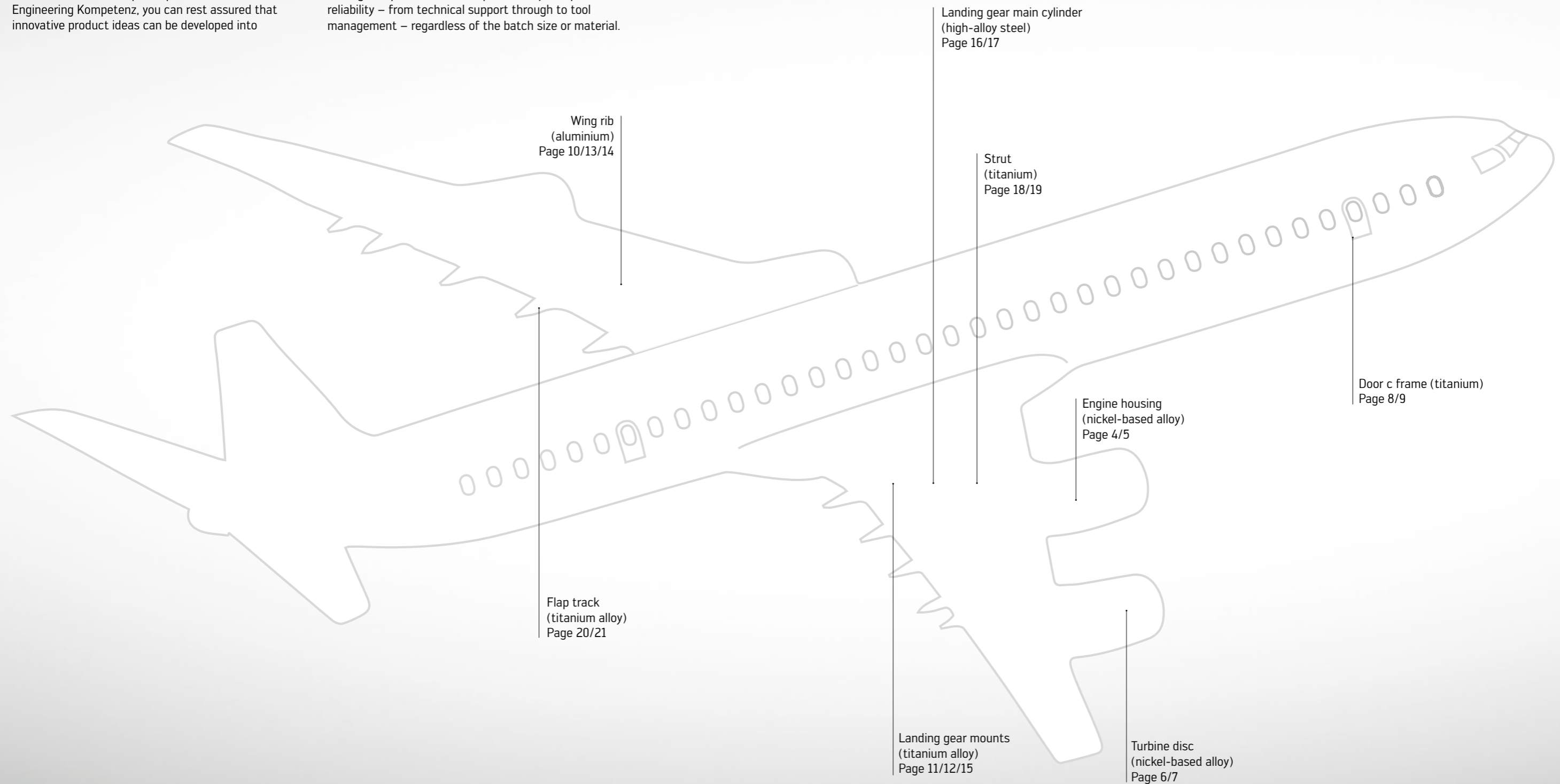
Walter Canada
Mississauga, Canada
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COMPREHENSIVE KNOWLEDGE OF COMPONENTS

for your machining tasks

Any discussion on machining in the aerospace industry inevitably involves high-tech solutions and innovations. This is because the ability to machine new materials with a high level of process reliability and precision is not the only thing that matters – the development of technically and economically viable solutions is of equal importance. With Walter's Engineering Kompetenz, you can rest assured that innovative product ideas can be developed into

competitive series-production solutions. Walter offers you the most comprehensive range of metal cutting tools for metal and composite materials available from a single source global supplier. Flexible machining solutions for the aerospace industry that set benchmarks, whether for turning, drilling, threading or milling, with the highest possible levels of productivity and process reliability – from technical support through to tool management – regardless of the batch size or material.

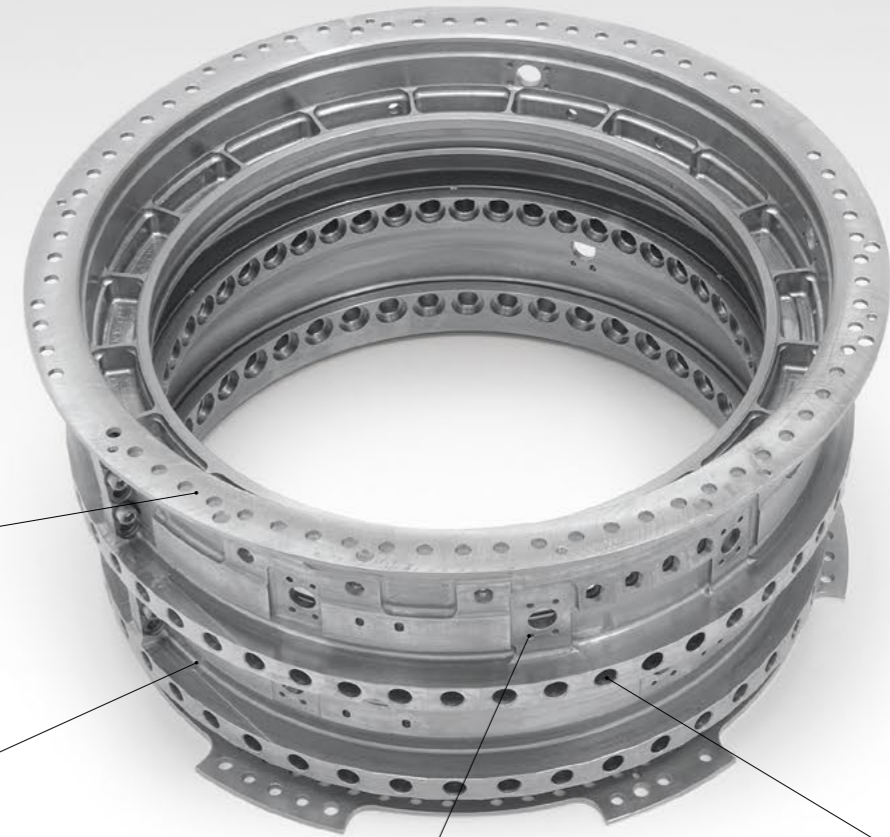


ENGINE HOUSING

Nickel-based alloy

Turbine housings are designed for maximum stability. They are therefore manufactured using materials such as Inconel, titanium alloys or Waspaloy. Nickel-based alloys in particular are very difficult to machine due to their high toughness and temperature stability. In addition, it must be ensured that finishing work does

not cause any structural changes or damage to the edge zones. Multi-axis turn/mill centres and vertical turret lathes are primarily used for machining these materials. Our turning, milling, drilling and threading tools enable you to machine engine housings with maximum efficiency, precision and process reliability.



YOUR APPLICATION

Roughing housing mating faces

OUR SOLUTION

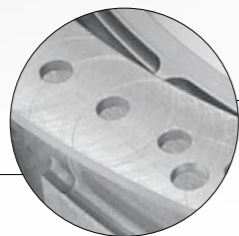
Walter BLAXX M3024 heptagon face milling cutter



- 14 cutting edges per indexable insert
- Stable, negative indexable inserts
- Optimum support face and high feed per tooth thanks to solid carbide shim
- High cutting depth
- Powered by Tiger-tec® Silver

BENEFITS FOR YOU

Extremely reliable and, above all, cost-efficient tool with high stability and process reliability.



YOUR APPLICATION

Roughing external surfaces

OUR SOLUTION

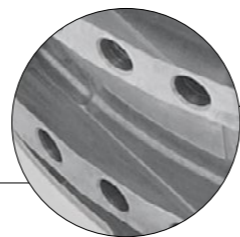
Walter Cut turning toolholder with precision cooling



- CNGN1207 ceramic insert
- Rake face cooling for ideal surface quality
- Extremely high cutting speeds

BENEFITS FOR YOU

Can be used universally with high machining speed and long tool life. Perfect surface quality thanks to high stability and optimum cooling in the cutting zone.



YOUR APPLICATION

Thread tapping the mating face

OUR SOLUTION

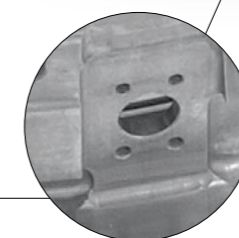
Walter Prototyp Prototex® TiNi Plus



- Innovative hard material coating and stable cutting edges
- Special geometry for machining ISO S alloys with emulsion
- High flank clearance angle reduces friction in materials that tend to cause jamming
- Wear-resistant, titanium-free ACN coating prevents weld formations

BENEFITS FOR YOU

Flexible machining of nickel and titanium alloys with just one tool. Long tool life and high process reliability due to tool stability.

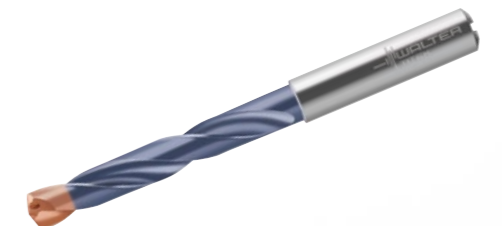


YOUR APPLICATION

Drilling the connecting bores

OUR SOLUTION

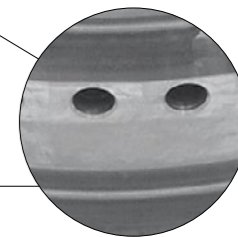
Walter Titex X-treme Plus



- Wear-resistant DPL coating
- Stable main cutting edge for maximum tool life and process reliability

BENEFITS FOR YOU

Drilling and reaming tool for universal use, guaranteeing the best possible surface quality on the workpiece thanks to high cutting data.

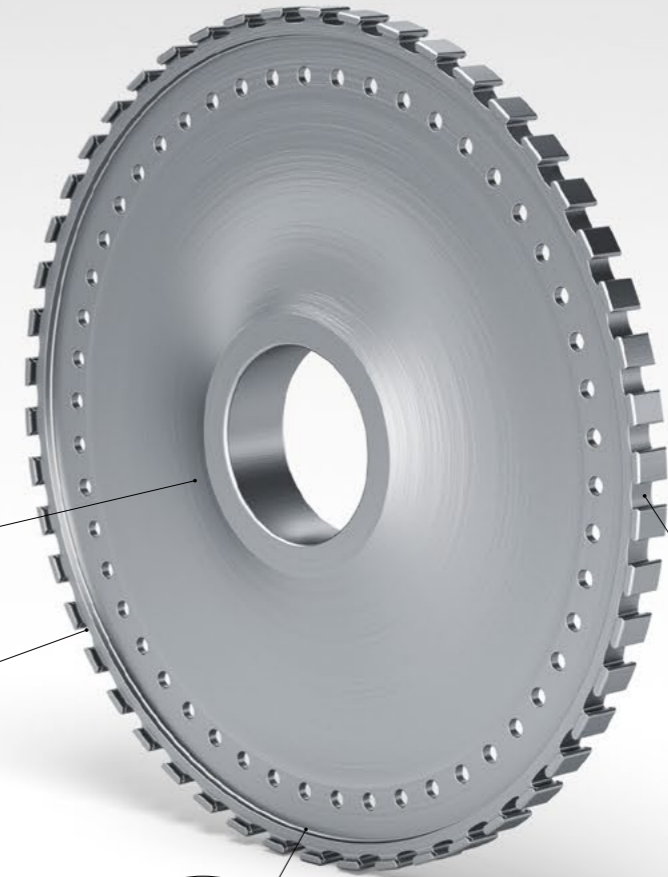


TURBINE DISC

Nickel-based alloy

Turbine discs are engine components manufactured from titanium 64 or heat-resistant high-temperature alloys such as Inconel 718 and Udimet 720. These complex workpieces with chambers and grooves are rarely easily accessible. For this reason, our aerospace specialists develop individual machining solutions

according to the shape of the component. Our focus is on ensuring that implementation of these solutions is cost-effective and reliable – which is where our cutting tools and processes can prove their worth. This enables you to carry out extremely cost-effective production, even under unfavourable conditions.



YOUR APPLICATION

HSC roughing disc contours

OUR SOLUTION

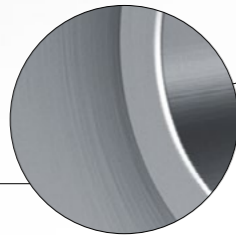
Walter Turn with claw clamping and ceramic indexable insert



- Ceramic substrate for machining nickel-based alloys
- Indexable insert geometry with stable design, adapted for nickel-based alloys

BENEFITS FOR YOU

Long tool life and high cutting speed when machining nickel-based alloys.



YOUR APPLICATION

HSC milling of turbine blade grooves

OUR SOLUTION

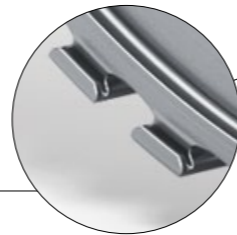
Carbide body end mill with ceramic cutting head



- High stability and long tool life
- Ceramic head fused onto carbide shank
- Edge geometry designed for nickel-based alloy
- Also suitable for plunge milling

BENEFITS FOR YOU

High stability and a metal removal rate five times higher than for conventional carbide solutions thanks to high cutting speed using "High Speed Cutting" (HSC) parameters.



YOUR APPLICATION

Contour turning of the disc profile

OUR SOLUTION

Walter Cut Capto™



- Tiger-tec® PVD coating
- Versatility thanks to diverse geometries
- Special solutions for modules and inserts

BENEFITS FOR YOU

Flexible grooving system for grooving and parting off, recessing and longitudinal turning – with indexable inserts that guarantee maximum wear and temperature resistance.



YOUR APPLICATION

Roughing and finish milling of blade root profiles

OUR SOLUTION

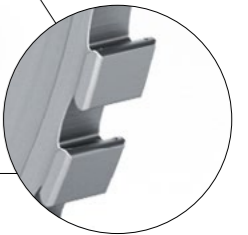
Walter Prototyp profile groove milling cutter



- Milling to closely match the required profile
- TiAlN coating

BENEFITS FOR YOU

High accuracy and custom design to match customer specifications so that the tool reproduces the profile required in each case.



DOOR C FRAME AREA

Titanium

Door frame areas refer to areas in the aircraft fuselage that surround cargo doors and passenger doors. These components are important for safety, and must compensate for the structural weaknesses created as a result of openings in the aircraft fuselage. For this reason, these frames not only need to be precisely manufactured, but also must not warp, even under heavy load. They are therefore mainly made of

titanium. In order to prevent crack propagation, the titanium is beta-annealed, which significantly increases tool wear. The frames are also designed in lengths of up to 4 m and incorporate reinforcement bars, all requiring high machining volumes without causing the component to warp. The primary focus is therefore on process reliability.

YOUR APPLICATION

Dynamic milling of titanium structures (High Performance Cutting)

OUR SOLUTION

Ti40 high-performance milling cutter



- Solid carbide tool for full slotting, dynamic milling, semi-finishing and finishing operations
- All-rounder with five cutting edges
- Microgeometry with cylindrical stabilising land
- New PVD coating technology

BENEFITS FOR YOU

Higher productivity for roughing, semi-finishing, finishing and dynamic high-feed milling. 50% longer tool life compared to the previous aluminium chromium nitride solution.



YOUR APPLICATION

Finishing pocket bases and walls (High Performance Cutting)

OUR SOLUTION

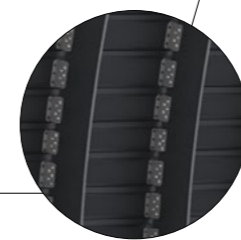
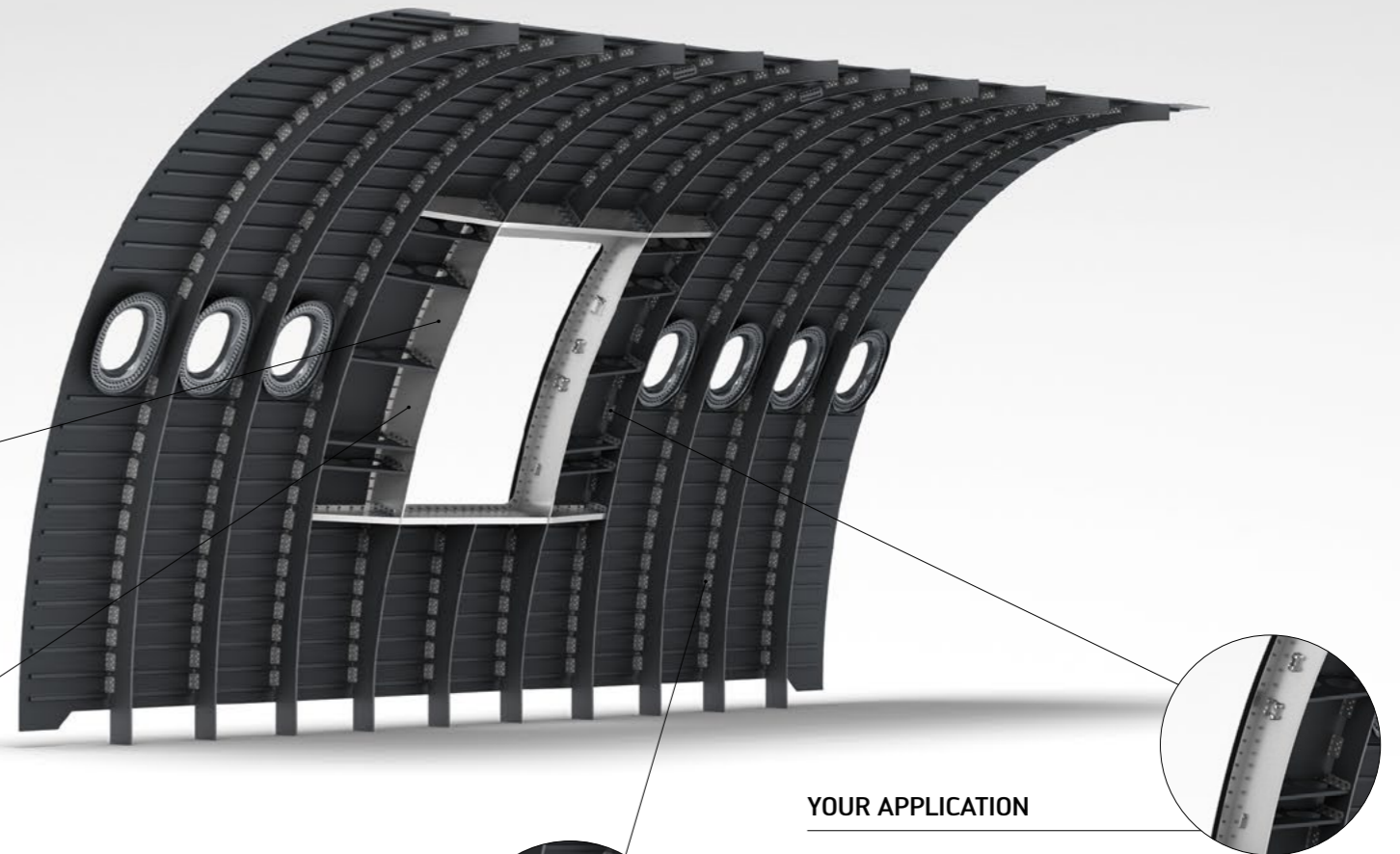
Ti45 high-performance milling cutter



- New PVD coating technology
- Long reach for machining deep pockets
- Finishing with close pitch options

BENEFITS FOR YOU

Short machining times when finishing with the highest possible tool life thanks to new PVD coating. 50% longer tool life compared to the previous aluminium chromium nitride solution.



YOUR APPLICATION

Drilling CFRP rivet holes (carbon fibre reinforced plastic)

OUR SOLUTION

Walter Titex AF1D twist drill



- Self-centring AF1D geometry
- Diamond coating for long tool life
- Specially designed for carbon fibre composite materials
- Usable in CNC systems and drill feed units

BENEFITS FOR YOU

Perfect for drilling in unidirectional and multidirectional carbon fibre composite materials. Even with drill feed units, the geometry provides excellent roundness and dimensional accuracy.

YOUR APPLICATION

Drilling stacks

OUR SOLUTION

Walter Titex AFT4A solid carbide drill



- Designed for Automatic Drilling Units (ADU's) and CNC systems
- Stable design with large coolant-through channels
- Smooth, heat-resistant aluminium chromium nitride coating

BENEFITS FOR YOU

Specially developed for use with Automatic Drilling Units. Polished flutes and the heat-resistant aluminium chromium nitride (ACN) coating ensure optimal chip evacuation.

Watch the application video:
Scan this QR code or go directly to
<https://goo.gl/C9ov2x>



M2131 RAMPING MILLING CUTTER

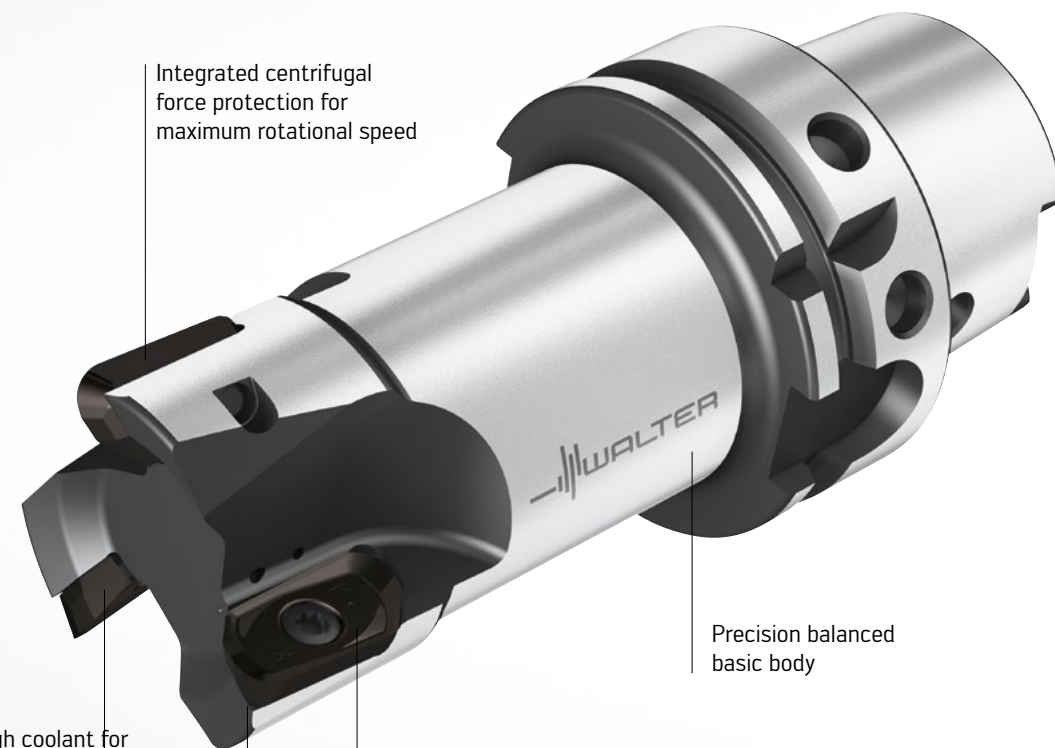
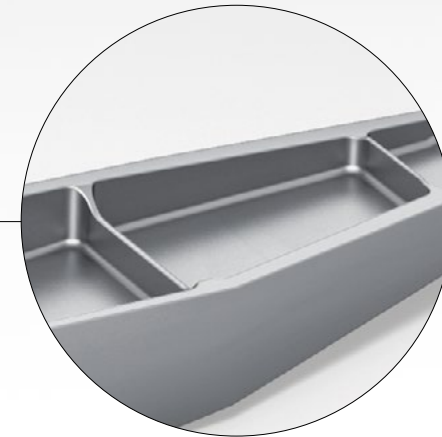
Aluminium

YOUR APPLICATION

Rough milling and semi-finishing of pockets generating high chip volumes

OUR SOLUTION

Walter M2131 ramping milling cutter



Integrated centrifugal force protection for maximum rotational speed

Precision balanced basic body

Through coolant for MQL and emulsion

New WNN15 milling grade with extremely long tool life

V-shaped cutting edge for ramping

BENEFITS FOR YOU

High level of concentricity and process reliability even at maximum speeds thanks to centrifugal force protection. Maximum machining volumes and tool life thanks to minimum formation of workpiece material build up on the cutting edge.

Watch product animation: Scan this QR code or go directly to <https://goo.gl/W1tzqY>



M3255 PORCUPINE MILLING CUTTER

Titanium

YOUR APPLICATION

Roughing (slot, corner, profile and pocket milling) of titanium alloys

OUR SOLUTION

Walter BLAXX M3255 porcupine milling cutter

Four cutting edges on the leading insert

Two cutting edges on the face insert

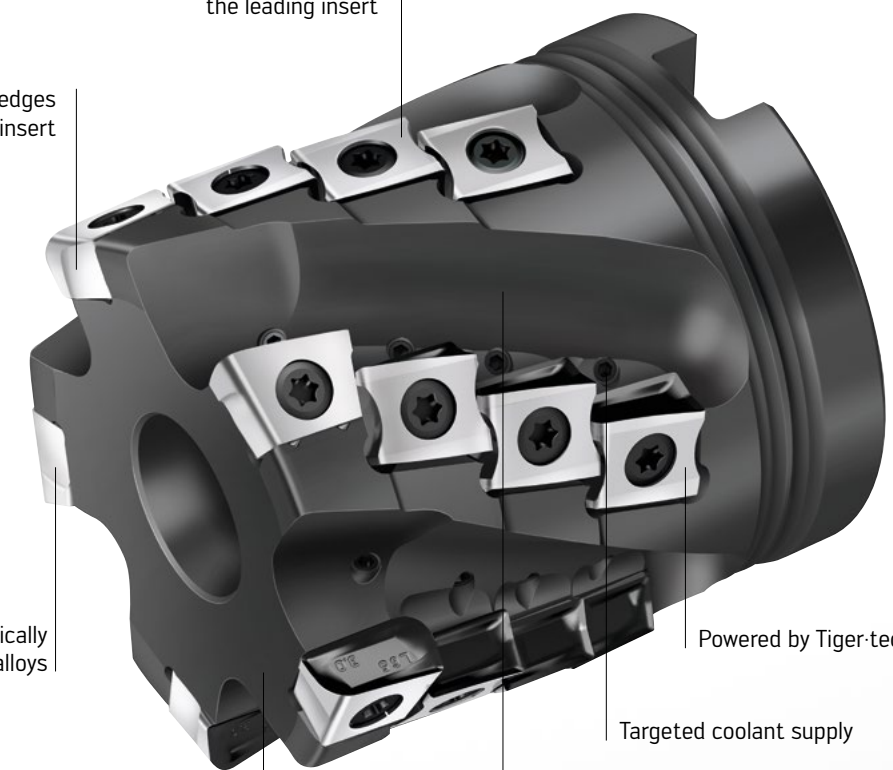
WSM45X grade specifically developed for titanium alloys

Powered by Tiger-tec® Silver

Targeted coolant supply

Porcupine milling cutter with maximum number of teeth

Ideal chip clearance



BENEFITS FOR YOU

High level of process reliability thanks to excellent chip removal, optimum chip space and stable design. Positive cutting characteristics thanks to soft-cutting geometry – and short machining times thanks to the maximum number of teeth and the highest possible metal removal rate. High cost efficiency thanks to four or two cutting edges per indexable insert.

Watch product animation: Scan this QR code or go directly to <https://goo.gl/nemqxl>

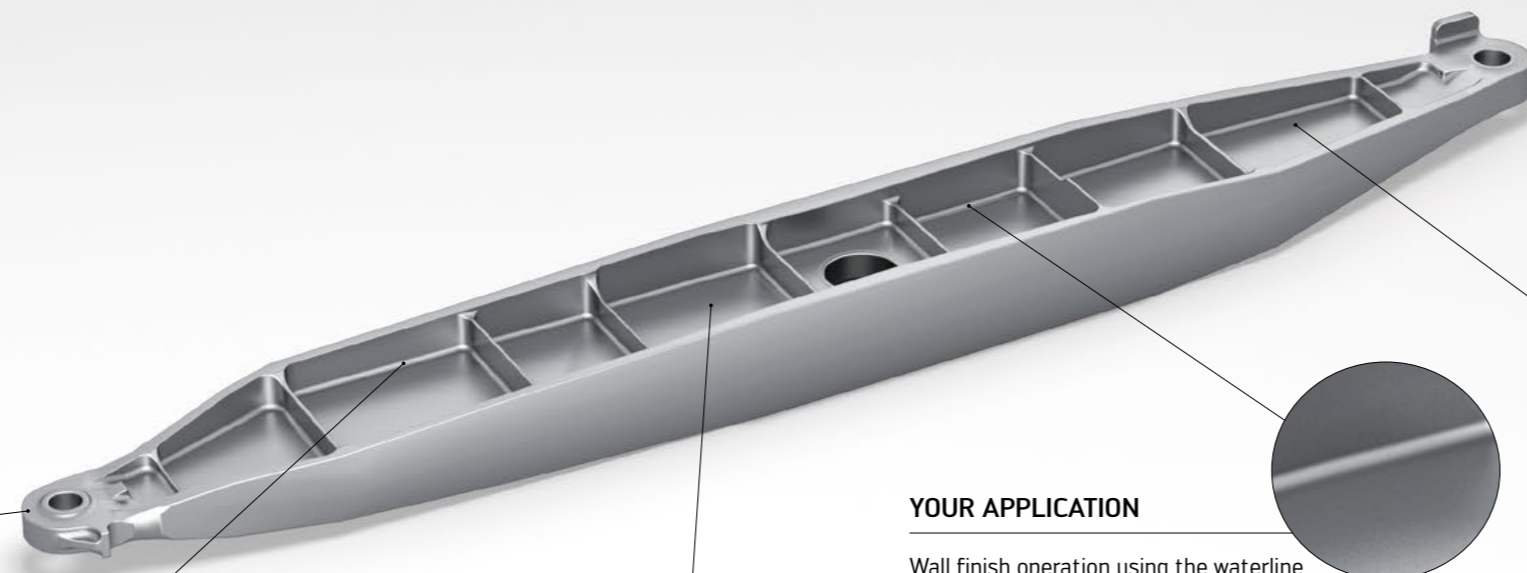


LANDING GEAR MOUNTS

Titanium alloy

Landing gear mounts are complex structural components that are situated horizontally in the wing structure above the landing gear. These elements connect the wing and the landing gear and act as a shock absorber in conjunction with the main cylinder of the landing gear. These are solid forged components with numerous 3-axis and 5-axis pockets, and mainly consist of titanium alloys. Machining titanium

produces high temperatures at the tool cutting edge. Uncontrolled heat transfer creates tension in the component that can subsequently cause it to warp, even after weeks have passed. Optimum cooling when machining, controlled chip removal and high-quality tools and fixturing are therefore crucial for ensuring process reliability.



YOUR APPLICATION

High-feed milling of mating faces

OUR SOLUTION

Walter M4002 high-feed milling cutter



- Face milling cutter with a 15° approach angle
- Four-edged Universal system inserts in three sizes
- Wave-form finish along the flank face facilitates the choice of geometry

BENEFITS FOR YOU

Cost-efficient high-feed milling thanks to Universal system inserts with four cutting edges and the highest possible metal removal rate. Up to 100 percent longer tool life thanks to the new WSM45X cutting tool material for titanium.

YOUR APPLICATION

High-feed milling of pocket structures

OUR SOLUTION

ConeFit Flash



- Four cutting edges
- Internal coolant supply
- Special microgeometry for high-feed milling
- Ideal for long tool projections

BENEFITS FOR YOU

Cost-efficient high-feed milling with changeable head system: ConeFit with maximum number of teeth for the highest possible metal removal rate.

YOUR APPLICATION

Wall finish operation using the waterline process

OUR SOLUTION

Ti50 high-performance milling cutter 1.5 x D



- Optimised ConeFit wall finishing tool with high concentricity
- For semi-finishing and finishing operations with a large radius at the rear for step-free transitions on the walls
- Minimal deflection up to a length of 7 x D
- New PVD coating technology

BENEFITS FOR YOU

Optimised finishing tool for cost-effective machining strategies (waterline) for semi-finishing and finishing with just one tool. 50% longer tool life compared to the previous aluminium chromium nitride (ACN) solution.

YOUR APPLICATION

Finishing pocket base

OUR SOLUTION

Ti50 high-performance milling cutter 0.55 x D



- Flexible ConeFit changeable head system
- Can be used for finishing the base of pockets up to 7 x D
- New design for ideal transitions when carrying out base face finish machining
- New PVD coating technology

BENEFITS FOR YOU

Cost-effective base face finishing with maximum tool life thanks to new PVD coating technology. 50% longer tool life compared to the previous aluminium chromium nitride (ACN) solution.

Watch the application video: Scan this QR code or go directly to <https://goo.gl/MTxsSB>



Tools on this page are available as:

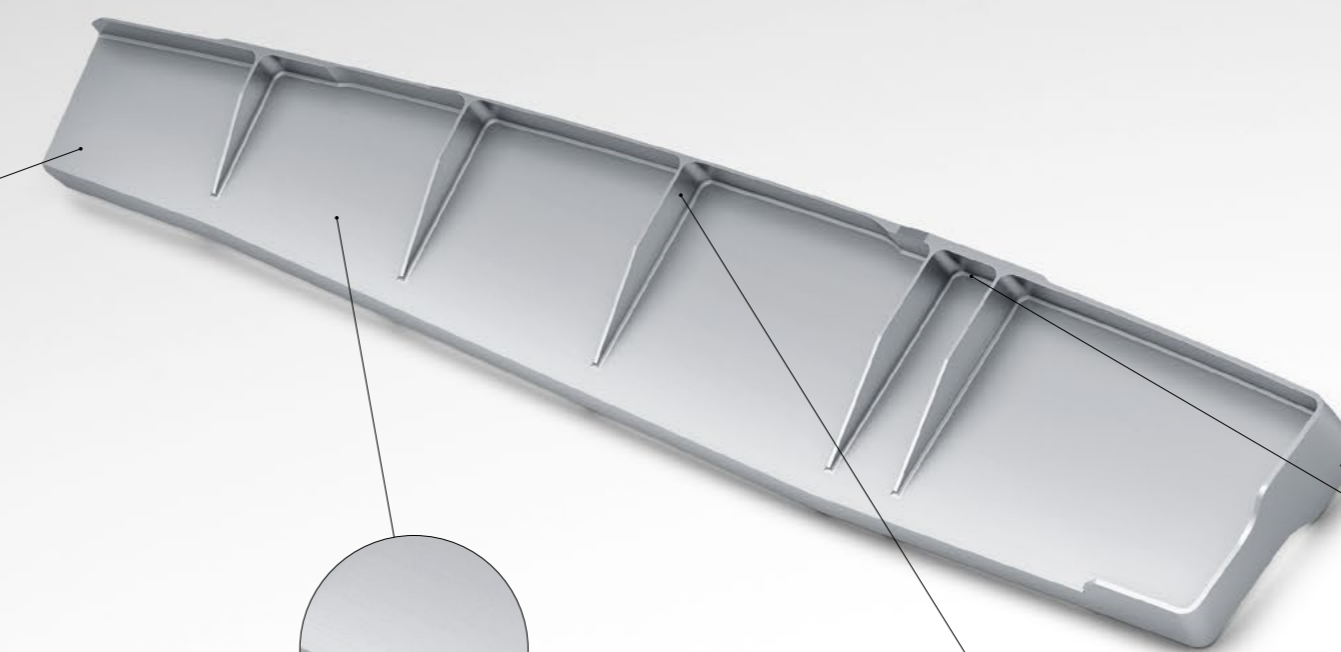
Walter Xpress

WING RIB

Aluminium

The wing ribs are structural components within the wing. Together with the longerons, they form the frame for the wing skin. Wing ribs are predominantly manufactured from aluminium wrought alloys. These are light, have a high load-bearing capacity and are extremely robust. This applies in particular for new generations such as the 2050 aluminium-lithium alloy. In order to enable this alloy to be machined

successfully, the machine, tool, processes and milling strategies must be designed to perfectly suit the material. Walter high-performance solutions for HPC and HSM aluminium machining meet the highest requirements for quality and process reliability, whether working with indexable insert tools, carbide tools or PCD tools.



YOUR APPLICATION

HPC pocket and base finishing

OUR SOLUTION

Walter Prototyp HPC Al30 close pitch cutter



- Microgeometry of the centre cutting edge ensures low axial cutting forces
- Vibration-free thanks to the microgeometry of the secondary cutting edge
- Coolant thro' for MQL
- Constant helix angle

BENEFITS FOR YOU

Extremely short machining times for unstable structural components.

YOUR APPLICATION

HPC rough milling of pocket structures

OUR SOLUTION

Walter Prototyp MB 265 Supreme



- WJ30UU grade (uncoated),
- WJ30CA grade (CrN-coated)
- Thro' coolant for emulsion or MQL
- Al-RAPAX G30 geometry for maximum metal removal rate
- Centre cutting edge for reliable roughing

BENEFITS FOR YOU

Extremely high machining volumes on high-end machines.

YOUR APPLICATION

HPC rough/finishing milling of pocket structures

OUR SOLUTION

Walter Prototyp MB 266 Supreme



- WJ30UU grade (uncoated)
- Thro' coolant for emulsion/MQL
- Al 30 geometry for finishing and maximum metal removal rate
- Centre cutting edge for reliable roughing

BENEFITS FOR YOU

Combination tool for rough and finish machining with maximum process reliability.

YOUR APPLICATION

Wall finishing machining

OUR SOLUTION

Walter Prototyp HPC Al38



- Four cutting edges - differential pitch for wall finishing operations
- Transition radius on the circumference
- Optimised cutting edge micro-geometry
- Internal coolant supply - also suitable for MQL

BENEFITS FOR YOU

Vibration-free finishing operations and step-free waterline milling.

Watch the application video: Scan this QR code or go directly to <https://goo.gl/WuvMab>



Tools on this page are available as:

Walter Xpress

LANDING GEAR – MAIN CYLINDER

High-alloy steels (300M, 4340)

The landing gear main cylinder cushions impacts during landing and enables the landing gear to be extended and retracted. The number and size of this central element may vary depending on the size of the aircraft. However, all landing gear main cylinders must always meet the highest safety standards. For this reason, only a small number of materials are suitable for producing these components, mainly titanium alloys and high-alloy steels such as 300M.

However, the material is not the only demanding aspect of these components, as their complexity is also constantly increasing. An ever-expanding number of add-on parts are being integrated into the forged blank for new models. For this reason, an optimal machining strategy is required alongside the tool technology. The most important types of machining operations include contour milling, turning and drilling.

YOUR APPLICATION

Roughing and semi-finishing of transitional radii.

OUR SOLUTION

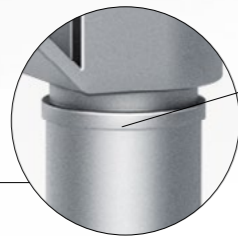
F2339 ball nose mill



- Available with and without peripheral cutting edges
- Integrated fail-safe device for easy and secure tool handling
- Soft-cutting, circumference-sintered indexable inserts
- Modern Tiger-tec® Silver cutting tool material grades for optimum tool life and excellent cutting data

BENEFITS FOR YOU

High stability, process reliability and long tool life. Maximum cost-effectiveness thanks to soft-cutting indexable inserts with low power consumption.



YOUR APPLICATION

5-axis contour milling

OUR SOLUTION

F2334R round insert cutter



- Round inserts with location flats ensure high-stability insert clamping
- Designed for maximum feed rates and cutting efficiency
- Powered by Tiger-tec® Silver

BENEFITS FOR YOU

High process reliability and cost reduction. Ideal for roughing steels and difficult-to-cut materials such as titanium alloys.



YOUR APPLICATION

Drilling connection holes

OUR SOLUTION

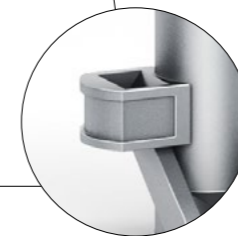
Walter Xtra-tec® B4013 point drill



- Drill with exchangeable carbide insert
- Internal coolant supply ensures cooling directly on the drill insert
- High positive geometry

BENEFITS FOR YOU

High productivity thanks to rapid drilling cycles and process reliability due to zero vibration as a result of insert positive locking.



YOUR APPLICATION

Profiling of the mating face

OUR SOLUTION

Walter Xtra-tec® F4030 high-performance milling cutter



- Surface milling, plunge milling and copy milling cutter with double sided Trigon indexable insert
- Long tools and stable indexable insert with Tiger-tec® Silver cutting tool material
- Six usable cutting edges per indexable insert
- Feed per tooth rates of up to f_z 3.5 mm are possible

BENEFITS FOR YOU

High productivity, process reliability and long tool life thanks to high machining volume with low cutting depths and high feed per tooth rates. Lower process costs and reduced vibrations.

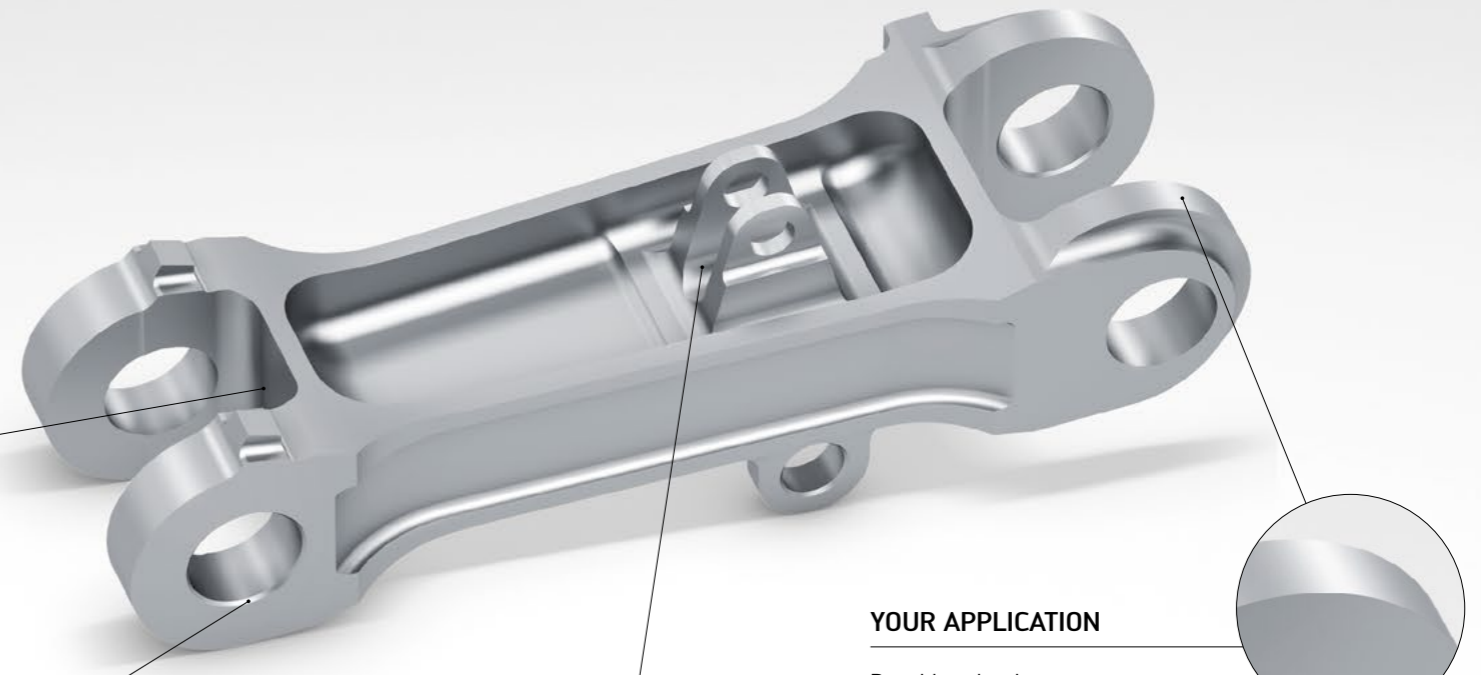


STRUT

Titanium

One of the major components of any aircraft is the landing gear. It absorbs the enormous forces on take-off and especially during landing. Besides the engine, the components used here are subject to the strictest demands in terms of reliability and functionality under extreme conditions. The strut provides the landing gear with support against the longitudinal movement of the wheel. It is positioned in the middle

of the landing gear and enables it to be retracted into the aircraft fuselage. There are particular challenges when machining this component as a result of the material: Struts are predominantly manufactured from titanium materials that are difficult to machine such as Ti5553 or Ti10-2-3. Walter milling cutters enable you to accomplish this task reliably and cost-effectively while still ensuring ideal quality.



YOUR APPLICATION

Roughing, high-feed milling and plunge milling of mating faces

OUR SOLUTION

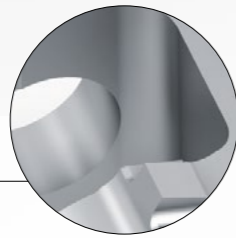
Walter M4002 high-feed milling cutter



- Four cutting edges per indexable insert
- System insert suitable for universal use
- Highly positive geometries with low power requirements
- Powered by Tiger-tec® Silver with CVD-coated WSM45X grade

BENEFITS FOR YOU

High productivity and tool life, high cost savings thanks to four useable cutting edges and reduced procurement and inventory costs. Soft and stable cutting action.

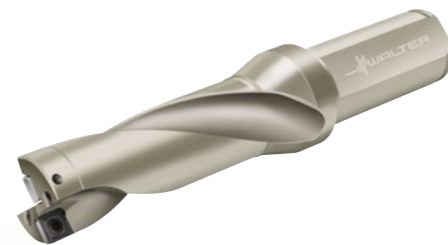


YOUR APPLICATION

Drilling connection bores

OUR SOLUTION

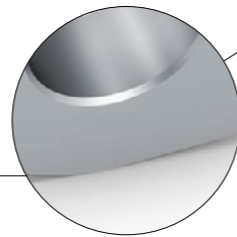
Walter Xtra-tec® B4213 insert drill



- Low hole tolerance due to the optimum balance of forces
- Maximum cost efficiency thanks to indexable inserts with four real cutting edges
- Excellent component surface quality thanks to the wiper edge insert
- Maximum process reliability due to positive locking

BENEFITS FOR YOU

Two indexable inserts with four cutting edges each enable maximum productivity and low tolerances.



YOUR APPLICATION

Roughing of pocket bases and radius transitions

OUR SOLUTION

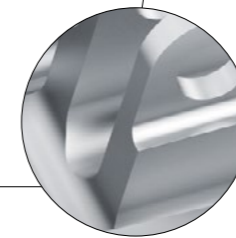
F2139 profile milling cutter



- Extremely accurate indexable inserts that are ground on all surfaces
- Special grade for ISO S machining
- Symmetrical body for HSC machining
- Available with optional solid carbide shank for vibration damping when working with long projection lengths

BENEFITS FOR YOU

No line formation or cut spacing. Can be optimised to suit the specific machining situation. Maximum tool life and ideal surface quality on the workpiece.



YOUR APPLICATION

Roughing titanium structures

OUR SOLUTION

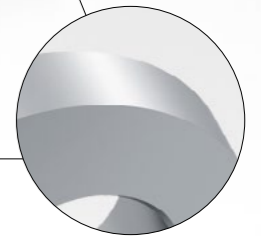
Walter BLAXX M3255 porcupine milling cutter



- Process-reliable, stable design
- Precise coolant supply at every cutting edge
- Maximum number of teeth for maximum metal removal rate
- Four or two cutting edges per indexable insert
- Soft-cutting geometry
- Powered by Tiger-tec® Silver with CVD-coated WSM45X grade

BENEFITS FOR YOU

Soft cutting action, high productivity and process reliability. Extremely cost-effective thanks to long tool life, high metal removal rate and short machining times.

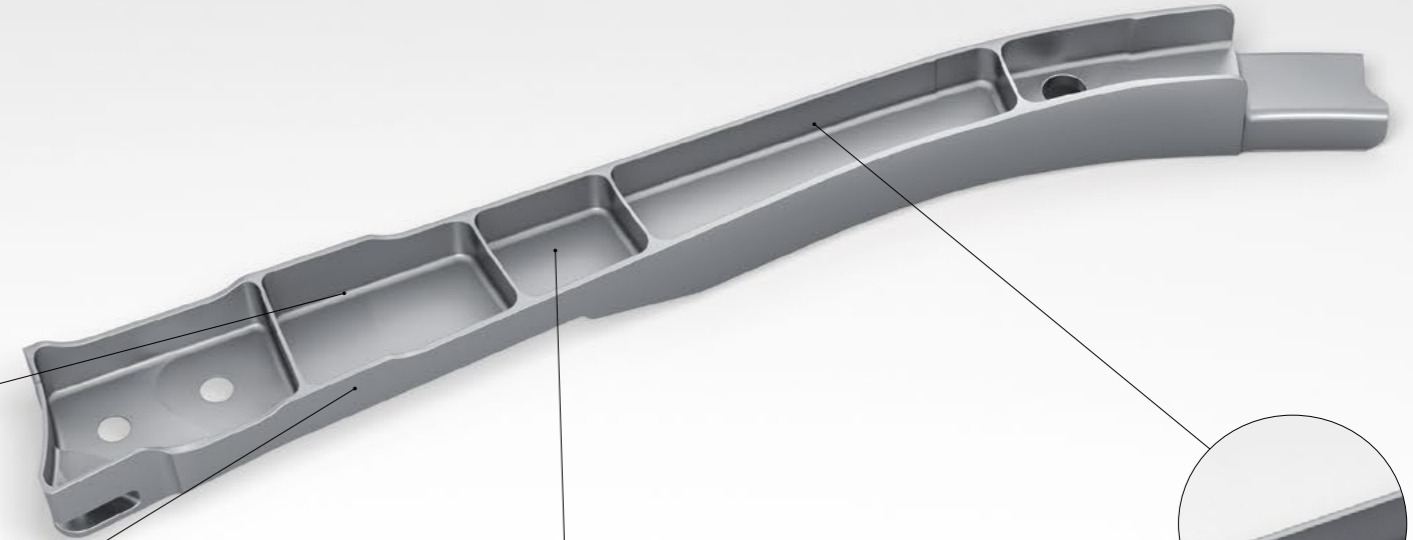


FLAP TRACK

Titanium alloy

The landing flaps situated at the rear edge of the wings provide the necessary lift when landing the aircraft. A variety of materials are used when manufacturing them: The flap track usually consists of 15-5 PH stainless steel, Carpenter C465 or TiAl6V4, but may also consist of titanium/aluminium or

CFRP/titanium combinations on newer aircraft. The machining of this component – which mainly involves pocket and contour milling – is generally carried out on CNC machining centres or multi-spindle portal milling machines. Walter tools offer optimal tool life and dimensional accuracy for these operations.



YOUR APPLICATION

HPC residual material machining in the corners and semi-finishing

OUR SOLUTION

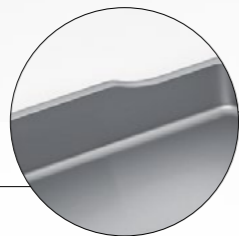
Ti40 high-performance milling cutter



- Solid carbide tool for full slotting, dynamic milling, semi-finishing and finishing operations
- All-rounder with five cutting edges
- Micro-geometry with cylindrical stabilising land
- New PVD coating technology

BENEFITS FOR YOU

Higher productivity for roughing, semi-finishing, finishing and dynamic high-feed milling. 50% longer tool life compared to the previous ACN coating (aluminium chromium nitride) solution.



YOUR APPLICATION

Roughing of pocket structures

OUR SOLUTION

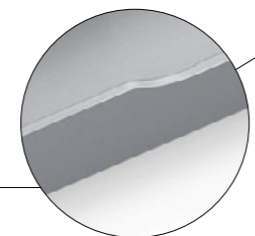
Walter BLAXX M3255 porcupine milling cutter Monoblock HSK100A



- Full effective porcupine milling cutter
- Targeted coolant supply
- Reinforced core thanks to tangential indexable inserts interlocked axially in the body
- Four cutting edges on the circumference and two on the face insert

BENEFITS FOR YOU

Unique solution for optimum stability and tool life when roughing titanium alloys. High level of process reliability thanks to excellent chip removal and optimum chip space. Positive cutting characteristics thanks to soft-cutting geometry.



YOUR APPLICATION

Finishing the pocket base

OUR SOLUTION

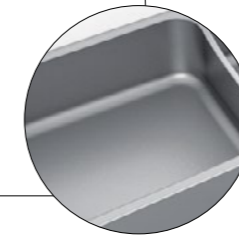
Ti50 high-performance milling cutter 0.55 x D



- Flexible ConeFit changeable head system
- Can be used for finishing the base of pockets up to 7 x D
- New design for ideal transitions when carrying out pocket base finish machining

BENEFITS FOR YOU

Cost-effective base finishing with maximum tool life thanks to new coating. 50% longer tool life compared to the previous aluminium chromium nitride (ACN) solution.



YOUR APPLICATION

Wall finish operation using the waterline process

OUR SOLUTION

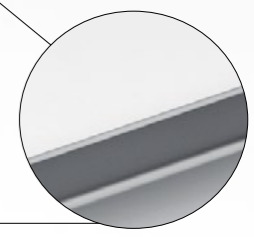
Ti50 high-performance milling cutter 1.5 x D



- Optimised ConeFit wall finishing tool with high concentricity
- For semi-finishing and finishing operations with a large radius at the rear for step-free transitions on the walls
- Minimal deflection up to a length of 7 x D

BENEFITS FOR YOU

Optimised finishing tool for cost-effective machining strategies (waterline) for semi-finishing and finishing with just one tool. 50% longer tool life compared to the previous aluminium chromium nitride (ACN) solution.



Watch the application video:
Scan this QR code or go directly to
<https://goo.gl/NY85ei>

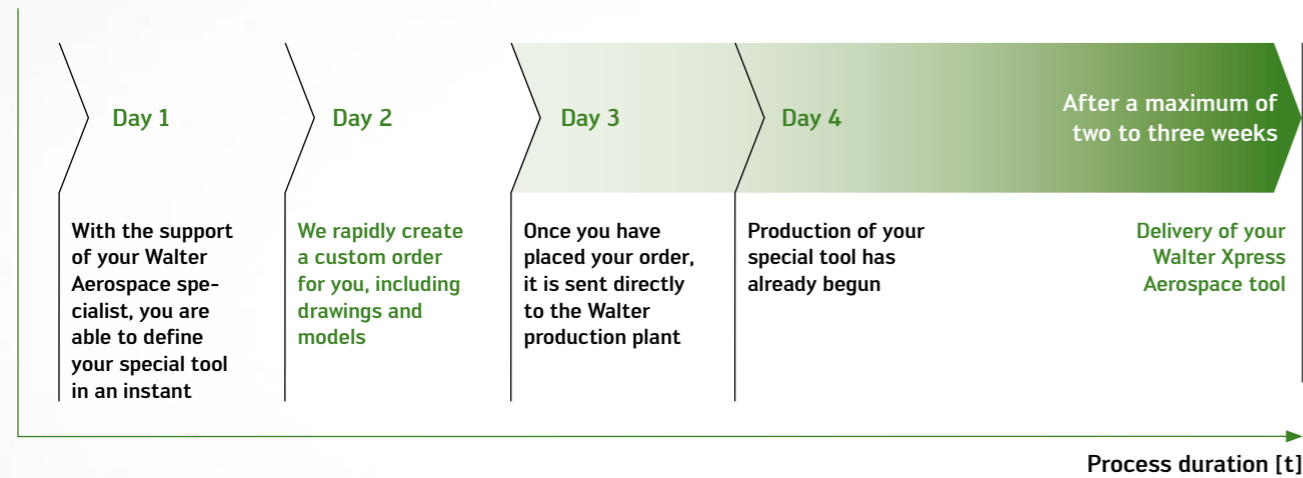


WALTER XPRESS AEROSPACE

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Challenging machining operations require customised processes. For this reason, Walter Xpress is now available in a version specially tailored to the aerospace industry. Walter Xpress Aerospace enables you to define your own personalised solid carbide milling cutter in an instant. A Walter Aerospace specialist is available at your request to provide you with on-site

assistance at your production facility. Your order is sent directly to the Walter production plant. Blanks that have been specially designed for the requirements of the aerospace industry provide the basis of your special tool. This enables us to ensure that your Walter Xpress Aerospace tool is available in the shortest possible time.



MAXIMUM DELIVERY TIME THREE WEEKS: Walter Xpress Aerospace aims for supersonic speed

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Walter Xpress

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