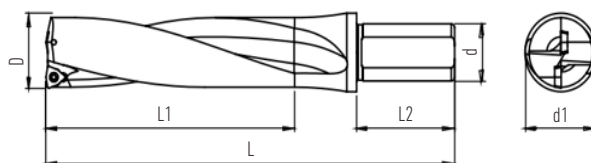


Drill V3100 with inserts



DRILLING DEPTH 4xD / internal coolant supply 



Cylindrical shank with flat

| Order code | Dimensions (mm) | | | | | | Insert | Screw | Key |
|-------------------|-----------------|----|----|-----|-----|----|----------------------|--------------|-----|
| | D | d | d1 | L | L1 | L2 | | | |
| V3100.15.5.V25.D4 | 15,5 | 25 | 34 | 142 | 62 | 56 | WPMT 033208 (1,2 Nm) | TMSV-M2,5x6 | T08 |
| V3100.16.V25.D4 | 16 | 25 | 34 | 142 | 64 | 56 | | | |
| V3100.17.V25.D4 | 17 | 25 | 34 | 146 | 68 | 56 | | | |
| V3100.17,5.V25.D4 | 17,5 | 25 | 34 | 150 | 72 | 56 | | | |
| V3100.18.V25.D4 | 18 | 25 | 34 | 150 | 72 | 56 | | | |
| V3100.19.V25.D4 | 19 | 25 | 34 | 154 | 76 | 56 | | | |
| V3100.19,5.V25.D4 | 19,5 | 25 | 34 | 159 | 80 | 56 | | | |
| V3100.20.V25.D4 | 20 | 25 | 34 | 159 | 80 | 56 | WPMT 043208 (1,2 Nm) | TMSV-M2,5x7 | T08 |
| V3100.21.V25.D4 | 21 | 25 | 34 | 164 | 84 | 56 | | | |
| V3100.22.V25.D4 | 22 | 25 | 34 | 169 | 88 | 56 | | | |
| V3100.23.V25.D4 | 23 | 25 | 34 | 174 | 92 | 56 | | | |
| V3100.23,5.V25.D4 | 23,5 | 25 | 34 | 174 | 94 | 56 | | | |
| V3100.24.V25.D4 | 24 | 25 | 34 | 177 | 96 | 56 | | | |
| V3100.25.V25.D4 | 25 | 25 | 34 | 181 | 100 | 56 | | | |
| V3100.25,5.V25.D4 | 25,5 | 25 | 34 | 181 | 102 | 56 | WPMT 053308 (1,9 Nm) | TMSV-M3x8 | T10 |
| V3100.26.V25.D4 | 26 | 25 | 34 | 186 | 104 | 56 | | | |
| V3100.27.V25.D4 | 27 | 25 | 34 | 191 | 108 | 56 | | | |
| V3100.27,5.V25.D4 | 27,5 | 25 | 34 | 191 | 110 | 56 | | | |
| V3100.28.V25.D4 | 28 | 25 | 34 | 196 | 112 | 56 | | | |
| V3100.29.V25.D4 | 29 | 25 | 34 | 201 | 116 | 56 | | | |
| V3100.30.V32.D4 | 30 | 32 | 44 | 210 | 120 | 60 | | | |
| V3100.31.V32.D4 | 31 | 32 | 44 | 215 | 124 | 60 | | | |
| V3100.31,5.V32.D4 | 31,5 | 32 | 44 | 220 | 126 | 60 | | | |
| V3100.32.V32.D4 | 32 | 32 | 44 | 220 | 128 | 60 | | | |
| V3100.33.V32.D4 | 33 | 32 | 44 | 225 | 132 | 60 | | | |
| V3100.33,5.V32.D4 | 33,5 | 32 | 44 | 225 | 134 | 60 | WPMT 063308 (2,9 Nm) | TMSV-M3,5x10 | T15 |
| V3100.34.V32.D4 | 34 | 32 | 44 | 230 | 136 | 60 | | | |
| V3100.35.V32.D4 | 35 | 32 | 44 | 235 | 140 | 60 | | | |
| V3100.36.V32.D4 | 36 | 32 | 44 | 238 | 144 | 60 | | | |
| V3100.37.V32.D4 | 37 | 32 | 44 | 241 | 148 | 60 | | | |
| V3100.38.V32.D4 | 38 | 32 | 44 | 244 | 152 | 60 | | | |
| V3100.38,5.V32.D4 | 38,5 | 32 | 44 | 247 | 164 | 60 | | | |
| V3100.39.V32.D4 | 39 | 32 | 44 | 247 | 172 | 60 | | | |
| V3100.40.V32.D4 | 40 | 32 | 44 | 250 | 173 | 60 | | | |
| V3100.41.V32.D4 | 41 | 32 | 44 | 253 | 173 | 60 | | | |
| V3100.41,5.V32.D4 | 41,5 | 32 | 44 | 256 | 180 | 60 | WPMT 083412 (4,3 Nm) | TMSV-M4x11 | T15 |
| V3100.42.V32.D4 | 42 | 32 | 44 | 256 | 168 | 60 | | | |
| V3100.43.V32.D4 | 43 | 32 | 44 | 259 | 172 | 60 | | | |
| V3100.44.V32.D4 | 44 | 32 | 44 | 262 | 176 | 60 | | | |
| V3100.45.V40.D4 | 45 | 40 | 54 | 265 | 180 | 70 | | | |
| V3100.46.V40.D4 | 46 | 40 | 54 | 268 | 184 | 70 | | | |
| V3100.47.V40.D4 | 47 | 40 | 54 | 271 | 188 | 70 | | | |
| V3100.48.V40.D4 | 48 | 40 | 54 | 274 | 192 | 70 | | | |
| V3100.49.V40.D4 | 49 | 40 | 54 | 277 | 196 | 70 | | | |
| V3100.50.V40.D4 | 50 | 40 | 54 | 280 | 200 | 70 | | | |

* Drilling tolerance + - 0,2 mm

Drills V3100 with inserts



DRILLING DEPTH 2xD/3xD/4xD/5xD

Recommended cutting conditions

| ISO | Material | HB | Vc (m/min) | Feed fz (mm/t) | | | | |
|-----|--------------------------------------|--------------|------------|----------------|-------------|-------------|-------------|-------------|
| | | | | WPMT03 | WPMT04 | WPMT05 | WPMT06 | WPMT08 |
| | | | | D15,5 - D21,5 | D22 - D25,5 | D26 - D30 | D31 - D39 | D40 - D50 |
| P | Nelegovaná ocel, žíhaná | < 180 HB | 110 - 220 | 0,06 - 0,09 | 0,06 - 0,11 | 0,07 - 0,13 | 0,08 - 0,18 | 0,10 - 0,25 |
| | Nízkolegovaná ocel, žíhaná | 180 - 280 HB | 90 - 140 | 0,06 - 0,09 | 0,06 - 0,11 | 0,07 - 0,13 | 0,08 - 0,18 | 0,10 - 0,25 |
| | Vysoce legovaná a nástr., žíhaná | 280 - 350 HB | 70 - 120 | 0,05 - 0,07 | 0,05 - 0,09 | 0,06 - 0,11 | 0,07 - 0,14 | 0,08 - 0,17 |
| M | Nerezové oceli | < 200 HB | 60 - 140 | 0,05 - 0,09 | 0,05 - 0,10 | 0,06 - 0,13 | 0,07 - 0,15 | 0,08 - 0,18 |
| K | Šedá litina < 1000 N/mm ² | < 350 Mpa | 100 - 160 | 0,07 - 0,11 | 0,07 - 0,13 | 0,08 - 0,15 | 0,09 - 0,18 | 0,11 - 0,22 |
| | Tvárná litina | < 450 Mpa | 90 - 120 | 0,06 - 0,10 | 0,06 - 0,12 | 0,07 - 0,14 | 0,08 - 0,16 | 0,10 - 0,20 |
| S | Vysoce legované oceli | - | 25 - 50 | 0,03 - 0,05 | 0,03 - 0,06 | 0,04 - 0,08 | 0,05 - 0,10 | 0,06 - 0,12 |
| H | Superslitiny | - | 25 - 50 | 0,03 - 0,05 | 0,03 - 0,06 | 0,04 - 0,08 | 0,05 - 0,10 | 0,06 - 0,12 |

*Cutting condition are recommended for drill body 2xD/3xD

For 4xD reduce condition by 10%

For 5xD reduce condition by 15%

| Order code | P | M | K | S | H |
|--------------------|---|---|---|---|---|
| WPMT033208-M PKU35 | ● | ● | ● | ○ | ○ |
| WPMT033208-M PKS38 | ● | ● | ● | ● | ● |
| WPMT033208-M PKT38 | ● | ● | ● | ● | ● |
| WPMT033208-M PKS48 | ● | ● | ● | ● | |
| WPMT033208-S PKU35 | ● | ● | ● | ○ | ○ |
| WPMT033208-S PKS38 | ● | ● | ● | ● | ● |
| WPMT033208-S PKS48 | ● | ● | ● | ● | |

| Order code | P | M | K | S | H |
|--------------------|---|---|---|---|---|
| WPMT043208-M PKU35 | ● | ● | ● | ○ | ○ |
| WPMT043208-M PKS38 | ● | ● | ● | ● | ● |
| WPMT043208-M PKT38 | ● | ● | ● | ● | ● |
| WPMT043208-M PKS48 | ● | ● | ● | ● | |
| WPMT043208-S PKU35 | ● | ● | ● | ○ | ○ |
| WPMT043208-S PKS38 | ● | ● | ● | ● | ● |
| WPMT043208-S PKT38 | ● | ● | ● | ● | ● |
| WPMT043208-S PKS48 | ● | ● | ● | ● | |

| Order code | P | M | K | S | H |
|--------------------|---|---|---|---|---|
| WPMT053308-M PKU35 | ● | ● | ● | ○ | ○ |
| WPMT053308-M PKS38 | ● | ● | ● | ● | ● |
| WPMT053308-M PKT38 | ● | ● | ● | ● | ● |
| WPMT053308-M PKS48 | ● | ● | ● | ● | |
| WPMT053308-S PKU35 | ● | ● | ● | ○ | ○ |
| WPMT053308-S PKS38 | ● | ● | ● | ● | ● |
| WPMT053308-S PKT38 | ● | ● | ● | ● | ● |
| WPMT053308-S PKS48 | ● | ● | ● | ● | |

| Order code | P | M | K | S | H |
|--------------------|---|---|---|---|---|
| WPMT063308-M PKU35 | ● | ● | ● | ○ | ○ |
| WPMT063308-M PKS38 | ● | ● | ● | ● | ● |
| WPMT063308-M PKT38 | ● | ● | ● | ● | ● |
| WPMT063308-M PKS48 | ● | ● | ● | ● | |
| WPMT063308-S PKU35 | ● | ● | ● | ○ | ○ |
| WPMT063308-S PKS38 | ● | ● | ● | ● | ● |
| WPMT063308-S PKT38 | ● | ● | ● | ● | ● |
| WPMT063308-S PKS48 | ● | ● | ● | ● | |

| Order code | P | M | K | S | H |
|--------------------|---|---|---|---|---|
| WPMT083412-M PKU35 | ● | ● | ● | ○ | ○ |
| WPMT083412-M PKS38 | ● | ● | ● | ● | ● |
| WPMT083412-M PKT38 | ● | ● | ● | ● | ● |
| WPMT083412-M PKS48 | ● | ● | ● | ● | |
| WPMT083412-S PKU35 | ● | ● | ● | ○ | ○ |
| WPMT083412-S PKS38 | ● | ● | ● | ● | ● |
| WPMT083412-S PTS38 | ● | ● | ● | ● | ● |
| WPMT083412-S PKS48 | ● | ● | ● | ● | |

| Insert | Dimensions (mm) | | | | |
|-------------|-----------------|------|------|-----|-----|
| | A | B | S | r | d1 |
| WPMT 033208 | 3,8 | 5,56 | 2,38 | 0,8 | 2,8 |
| WPMT 043208 | 4,3 | 6,35 | 2,38 | 0,8 | 3 |
| WPMT 053308 | 5,4 | 7,94 | 3,18 | 0,8 | 3,4 |
| WPMT 063308 | 6,5 | 9,53 | 3,97 | 0,8 | 4 |
| WPMT 083412 | 8,7 | 12,7 | 4,76 | 1,2 | 4,3 |

