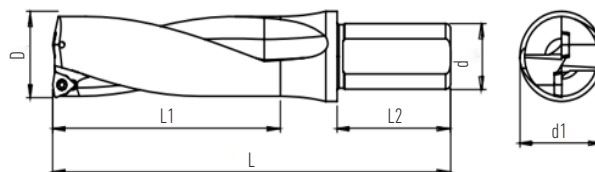


Drill V3100 with inserts



DRILLING DEPTH 3xD / internal coolant supply 



Cylindrical shank with flat

Order code	Dimensions (mm)						Insert	Screw	Key			
	D	d	d1	L	L1	L2						
V3100.15,5.V25.D3	15,5	25	34	126	46,5	56	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08			
V3100.16.V25.D3	16	25	34	126	48	56						
V3100.16,5.V25.D3	16,5	25	34	129	49,5	56						
V3100.17.V25.D3	17	25	34	129	51	56						
V3100.17,5.V25.D3	17,5	25	34	132	52,5	56						
V3100.18.V25.D3	18	25	34	132	54	56						
V3100.18,5.V25.D3	18,5	25	34	135	55,5	56						
V3100.19.V25.D3	19	25	34	135	57	56						
V3100.19,5.V25.D3	19,5	25	34	139	58,8	56						
V3100.20.V25.D3	20	25	34	139	60	56						
V3100.20,5.V25.D3	20,5	25	34	143	61,5	56	WPMT 043208 (1,2 Nm)	TMSV-M2,5x7	T08			
V3100.21.V25.D3	21	25	34	143	63	56						
V3100.21,5.V25.D3	21,5	25	34	147	64,5	56						
V3100.22.V25.D3	22	25	34	147	66	56						
V3100.22,5.V25.D3	22,5	25	34	151	67,5	56						
V3100.23.V25.D3	23	25	34	151	69	56						
V3100.23,5.V25.D3	23,5	25	34	153	70,5	56						
V3100.24.V25.D3	24	25	34	153	72	56				WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10
V3100.24,5.V25.D3	24,5	25	34	156	73,5	56						
V3100.25.V25.D3	25	25	34	156	75	56						
V3100.25,5.V25.D3	25,5	25	34	160	76,5	56						
V3100.26.V25.D3	26	25	34	160	78	56						
V3100.26,5.V25.D3	26,5	25	34	164	79,5	56						
V3100.27.V25.D3	27	25	34	164	81	56						
V3100.27,5.V25.D3	27,5	25	34	168	82,5	56						
V3100.28.V25.D3	28	25	34	168	84	56						
V3100.28,5.V25.D3	28,5	25	34	172	85,5	56						
V3100.29.V25.D3	29	25	34	172	87	56						
V3100.29,5.V25.D3	29,5	25	34	172	88,5	56						

* Drilling tolerance + - 0,2 mm

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.30.V32.D3	30	32	44	180	90	60	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.30,5.V32.D3	30,5	32	44	184	91,5	60			
V3100.31.V32.D3	31	32	44	184	93	60			
V3100.31,5.V32.D3	31,5	32	44	188	94,5	60			
V3100.32.V32.D3	32	32	44	188	96	60			
V3100.32,5.V32.D3	32,5	32	44	192	97,5	60			
V3100.33.V32.D3	33	32	44	192	99	60			
V3100.33,5.V32.D3	33,5	32	44	192	100,5	60			
V3100.34.V32.D3	34	32	44	192	102	60			
V3100.34,5.V32.D3	34,5	32	44	200	103,5	60			
V3100.35.V32.D3	35	32	44	200	105	60	WPMT 083412 (4,3 Nm)	TMSV-M4x11	T15
V3100.35,5.V32.D3	35,5	32	44	204	106,5	60			
V3100.36.V32.D3	36	32	44	204	108	60			
V3100.36,5.V32.D3	36,5	32	44	208	109,5	60			
V3100.37.V32.D3	37	32	44	208	111	60			
V3100.37,5.V32.D3	37,5	32	44	212	112,5	60			
V3100.38.V32.D3	38	32	44	212	114	60			
V3100.38,5.V32.D3	38,5	32	44	216	115,5	60			
V3100.39.V32.D3	39	32	44	216	117	60			
V3100.39,5.V32.D3	39,5	32	44	220	118,5	60			
V3100.40.V32.D3	40	32	44	220	120	60			
V3100.41.V32.D3	41	32	44	223	123	60			
V3100.42.V32.D3	42	32	44	226	126	60			
V3100.43.V32.D3	43	32	44	229	129	60			
V3100.44.V32.D3	44	32	44	232	132	60			
V3100.45.V40.D3	45	40	54	245	135	70			
V3100.46.V40.D3	46	40	54	248	138	70			
V3100.47.V40.D3	47	40	54	251	141	70			
V3100.48.V40.D3	48	40	54	254	144	70			
V3100.49.V40.D3	49	40	54	257	147	70			
V3100.50.V40.D3	50	40	54	260	150	70			

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

