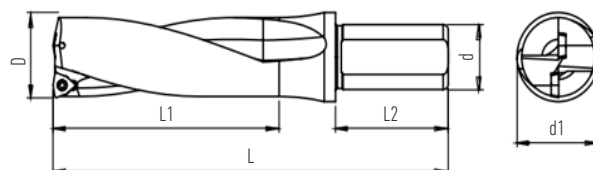


Drill V3100 with inserts



DRILLING DEPTH 2xD / internal coolant supply 



Cylindrical shank with flat

Order code	Dimensions (mm)							Insert	Screw	Key
	D	d	d1	L	L1	L2				
V3100.16.V25.D2	16	25	34	110	32	54	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08	
V3100.16,5.V25.D2	16,5	25	34	112	33	56				
V3100.17.V25.D2	17	25	34	112	34	56				
V3100.17,5.V25.D2	17,5	25	34	114	35	56				
V3100.18.V25.D2	18	25	34	114	36	56				
V3100.18,5.V25.D2	18,5	25	34	116	37	56				
V3100.19.V25.D2	19	25	34	116	38	56				
V3100.19,5.V25.D2	19,5	25	34	119	39	56				
V3100.20.V25.D2	20	25	34	119	40	56				
V3100.20,5.V25.D2	20,5	25	34	122	41	56				
V3100.21.V25.D2	21	25	34	122	42	56				
V3100.21,5.V25.D2	21,5	25	34	125	43	56				
V3100.22.V25.D2	22	25	34	125	44	56				
V3100.22,5.V25.D2	22,5	25	34	128	45	56				
V3100.23.V25.D2	23	25	34	128	46	56				
V3100.23,5.V25.D2	23,5	25	34	129	47	56				
V3100.24.V25.D2	24	25	34	129	48	56				
V3100.24,5.V25.D2	24,5	25	34	131	49	56				
V3100.25.V25.D2	25	25	34	131	50	56				
V3100.25,5.V25.D2	25,5	25	34	134	51	56				
V3100.26.V25.D2	26	25	34	134	52	56				
V3100.26,5.V25.D2	26,5	25	34	137	53	56				
V3100.27.V25.D2	27	25	34	137	54	56				
V3100.27,5.V25.D2	27,5	25	34	140	55	56				
V3100.28.V25.D2	28	25	34	140	56	56				
V3100.28,5.V25.D2	28,5	25	34	140	57	56				
V3100.29.V25.D2	29	25	34	143	58	56				
V3100.29,5.V25.D2	29,5	25	34	143	59	56				
V3100.30.V32.D2	30	32	44	150	60	60				
V3100.31.V32.D2	31	32	44	153	62	60				
V3100.32.V32.D2	32	32	44	156	64	60				
V3100.33.V32.D2	33	32	44	159	66	60				
V3100.34.V32.D2	34	32	44	162	68	60				
V3100.35.V32.D2	35	32	44	165	70	60				
V3100.36.V32.D2	36	32	44	168	72	60				
V3100.37.V32.D2	37	32	44	171	74	60				
V3100.38.V32.D2	38	32	44	174	76	60				
V3100.39.V32.D2	39	32	44	177	78	60				
V3100.40.V32.D2	40	32	44	180	80	60				
V3100.41.V32.D2	41	32	44	183	82	60				
V3100.42.V32.D2	42	32	44	186	84	60				
V3100.43.V32.D2	43	32	44	189	86	60				
V3100.44.V32.D2	44	32	44	192	88	60				
V3100.45.V40.D2	45	40	54	195	90	70				
V3100.46.V40.D2	46	40	54	198	92	70				
V3100.47.V40.D2	47	40	54	201	94	70				
V3100.48.V40.D2	48	40	54	204	96	70				
V3100.49.V40.D2	49	40	54	207	98	70				
V3100.50.V40.D2	50	40	54	210	100	70				
V3100.20,5.V25.D2	20,5	25	34	122	41	56				
V3100.21,5.V25.D2	21,5	25	34	125	43	56				
V3100.22,5.V25.D2	22,5	25	34	128	45	56				
V3100.23,5.V25.D2	23,5	25	34	129	47	56				
V3100.24,5.V25.D2	24,5	25	34	131	49	56				
V3100.25,5.V25.D2	25,5	25	34	134	51	56				
V3100.26,5.V25.D2	26,5	25	34	137	53	56				
V3100.27,5.V25.D2	27,5	25	34	140	55	56				
V3100.28,5.V25.D2	28,5	25	34	140	57	56				
V3100.29,5.V25.D2	29,5	25	34	143	59	56				
V3100.30.V32.D2	30	32	44	150	60	60				
V3100.31.V32.D2	31	32	44	153	62	60				
V3100.32.V32.D2	32	32	44	156	64	60				
V3100.33.V32.D2	33	32	44	159	66	60				
V3100.34.V32.D2	34	32	44	162	68	60				
V3100.35.V32.D2	35	32	44	165	70	60				
V3100.36.V32.D2	36	32	44	168	72	60				
V3100.37.V32.D2	37	32	44	171	74	60				
V3100.38.V32.D2	38	32	44	174	76	60				
V3100.39.V32.D2	39	32	44	177	78	60				
V3100.40.V32.D2	40	32	44	180	80	60				
V3100.41.V32.D2	41	32	44	183	82	60				
V3100.42.V32.D2	42	32	44	186	84	60				
V3100.43.V32.D2	43	32	44	189	86	60				
V3100.44.V32.D2	44	32	44	192	88	60				
V3100.45.V40.D2	45	40	54	195	90	70				
V3100.46.V40.D2	46	40	54	198	92	70				
V3100.47.V40.D2	47	40	54	201	94	70				
V3100.48.V40.D2	48	40	54	204	96	70				
V3100.49.V40.D2	49	40	54	207	98	70				
V3100.50.V40.D2	50	40	54	210	100	70				

Order code	Dimensions (mm)							Insert	Screw	Key
	D	d	d1	L	L1	L2				
V3100.28,5.V25.D2	28,5	25	34	140	57	56	WPMT 053308	TMSV-M3x8	T10	
V3100.29.V25.D2	29	25	34	143	58	56				
V3100.29,5.V25.D2	29,5	25	34	143	59	56				
V3100.30.V32.D2	30	32	44	150	60	60	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15	
V3100.31.V32.D2	31	32	44	153	62	60				
V3100.32.V32.D2	32	32	44	156	64	60				
V3100.33.V32.D2	33	32	44	159	66	60				
V3100.34.V32.D2	34	32	44	162	68	60				
V3100.35.V32.D2	35	32	44	165	70	60				
V3100.36.V32.D2	36	32	44	168	72	60				
V3100.37.V32.D2	37	32	44	171	74	60				
V3100.38.V32.D2	38	32	44	174	76	60				
V3100.39.V32.D2	39	32	44	177	78	60				
V3100.40.V32.D2	40	32	44	180	80	60				
V3100.41.V32.D2	41	32	44	183	82	60				
V3100.42.V32.D2	42	32	44	186	84	60				
V3100.43.V32.D2	43	32	44	189	86	60				
V3100.44.V32.D2	44	32	44	192	88	60				
V3100.45.V40.D2	45	40	54	195	90	70	WPMT 083412 (4,3 Nm)	TMSV-M4x11		
V3100.46.V40.D2	46	40	54	198	92	70				
V3100.47.V40.D2	47	40	54	201	94	70				
V3100.48.V40.D2	48	40	54	204	96	70				
V3100.49.V40.D2	49	40	54	207	98	70				
V3100.50.V40.D2	50	40	54	210	100	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

