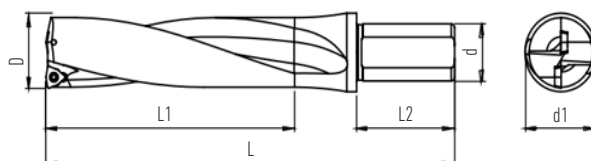


Drill V3100 with inserts



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	T10
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	●	●	●	●	

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	●	●	●	●	

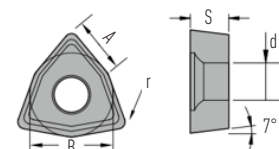
Order code	P	M	K	S	H
WPMT063308-M PKU35	●	●	●	○	○
WPMT063308-M PKS38	●	●	●	●	●
WPMT063308-M PKT38	●	●	●	●	●
WPMT063308-M PKS48	●	●	●	●	
WPMT063308-S PKU35	●	●	●	○	○
WPMT063308-S PKS38	●	●	●	●	●
WPMT063308-S PKT38	●	●	●	●	●
WPMT063308-S PKS48	●	●	●	●	

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	●	●	●	●	

● = 1.choice ○ = 2.choice

Dimensions (mm)

Insert	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



Blade shape



Blade shape

