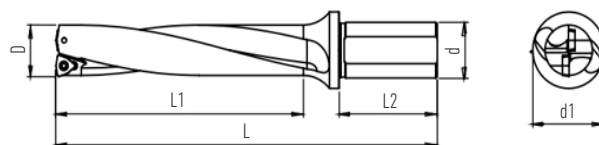


# Drill V3100 with inserts



DRILLING DEPTH 5xD / internal coolant supply 



## Cylindrical shank with flat

Order code	Dimensions (mm)						Insert	Screw	Key
	D	d	d1	L	L1	L2			
V3100.16.V25.D5	16	25	34	153	80	56	WPMT 033208 (1,2 Nm)	TMSV-M2,5x6	T08
V3100.17.V25.D5	17	25	34	158	85	56			
V3100.18.V25.D5	18	25	34	163	90	56			
V3100.19.V25.D5	19	25	34	168	95	56			
V3100.20.V25.D5	20	25	34	174	100	56	WPMT 043208 (1,2 Nm)	TMSV-M2,5x7	T08
V3100.21.V25.D5	21	25	34	180	105	56			
V3100.22.V25.D5	22	25	34	186	110	56			
V3100.23.V25.D5	23	25	34	192	115	56			
V3100.24.V25.D5	24	25	34	196	120	56	WPMT 053308 (1,9 Nm)	TMSV-M3x8	T10
V3100.25.V25.D5	25	25	34	200	125	56			
V3100.26.V25.D5	26	25	34	206	130	56			
V3100.27.V25.D5	27	25	34	212	135	56			
V3100.28.V25.D5	28	25	34	218	140	56			
V3100.29.V25.D5	29	25	34	224	145	56	WPMT 063308 (2,9 Nm)	TMSV-M3,5x10	T15
V3100.30.V32.D5	30	32	44	233	150	60			

\* 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 <sup>2</sup>	< 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
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
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

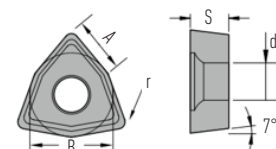
○ = 2.choice

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
WPMT063308-M PKU35	●	●	●	○	○
WPMT063308-M PKS38	●	●	●	●	●
WPMT063308-M PKT38	●	●	●	●	●
WPMT063308-M PKS48	●	●	●	●	
WPMT063308-S PKU35	●	●	●	○	○
WPMT063308-S PKS38	●	●	●	●	●
WPMT063308-S PKT38	●	●	●	●	●
WPMT063308-S PKS48	●	●	●	●	

#### 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



sharp geometry

#### Blade shape



low cutting force