



Diameter
ø30.0~70.0 mm

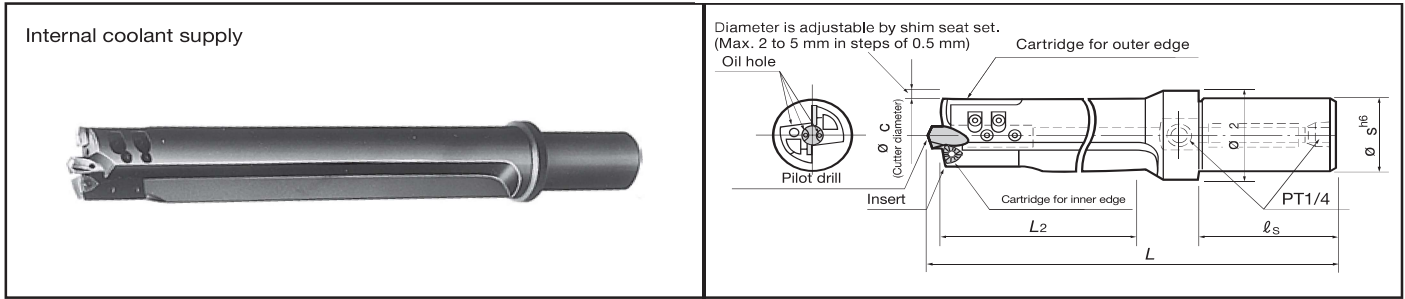
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5
L/D

For Deep Hole Rough Drilling of Steels and Cast Irons
Indexable insert drills with oil hole



L/D ≤ 5

Drill dia. øD _C (Tool dia. adjusting range)	Cat. No.	Stock	Dimensions (mm)					Applicable inserts	Pilot drill (Attached)	
			øD _S	øD ₂	L	L ₂	l _s			
30 ~ 32	TDP30-32	○	32	40.0	248	150	60	WPMT040208-D3	DP08 (ø8)	
32 ~ 34	TDP32-34	○			258	160				
34 ~ 37	TDP34-37	○			278	170				
37 ~ 40	TDP37-40	○	40	50.0	295	185	70	WPMT050308-D3	DP10 (ø10)	
40 ~ 45	TDP40-45	○			310	200				
45 ~ 50	TDP45-50	○			347	225				
50 ~ 55	TDP50-55	○			60.0	372			250	
55 ~ 60	TDP55-60	○	50	53.5	395	275	120	WPMT06T308-D3 WPMT080412-D3	DP12 (ø12)	
60 ~ 65	TDP60-65	○			58.5	470				300
65 ~ 70	TDP65-70	○			63.5	495				325

Notes • Diameter is adjustable by shim seat set.
• Drills are supplied with a pilot drill, or inserts.

Note: L/D = Hole depth / Drill diameter

Inserts

Cat. No.	Stock	Dimensions (mm)				
		T313W	øD	s	r _e	ød ₁
WPMT040208-D3	●	6.35	2.38	0.8	2.86	3.75
WPMT050308-D3	●	7.938	3.18	0.8	3.4	4.5
WPMT06T308-D3	●	9.525	3.97	0.8	3.9	5.1
WPMT080412-D3	●	12.70	4.76	1.2	4.4	6.0

Note: Shape of WPMT040208-D3 type insert differs a little from the figure above.

Pilot drills

Cat. No.	Stock	Dimensions (mm)	
		øD _C	L
DP08	●	8	42
DP10	●	10	48
DP12	●	12	55

Note : DP08 type drill does not have oil hole shown above.

Package Quantity = 1pcs.

Replacement parts

Drill Cat. No.	Cartridge		Clamping screw			Oil hole plug screw	Wrenches				Shim seat set
	For outer edge	For inner edge	For insert	For cartridge	For pilot drill		For insert	For cartridge	For pilot drill	Oil hole plug screw	
TDP30-32	CW04A	CW04B	CSTB-2.5S	BHM4-8	SSHM5-10	PT1/4GN	T-8D	P-2.5	P-2.5	P-6	SW04
TDP32-34											
TDP34-37											
TDP37-40	CW05A	CW05B	CSTB-3S	BHM4-10	SSHM6-12		T-9D	P-3	P-3		
TDP40-45											
TDP45-50	CW06A	CW06B	CSTB-3.5D	BHM5-14	SSHM6-20		T-9D	P-4	P-3		
TDP50-55											
TDP55-60	CW08A	CW08B	CSTB - 3.5D CSTB - 4M	CHHM5-14 (CM5×0.8×14)	SSHM6-20	T-15D	P-4	P-3	P-6	SW06	
TDP60-65											
TDP65-70											

Standard cutting conditions

Work materials	Cutting speed: V _c (m/min)	Feed: f (mm/rev)
Carbon steels	60-65-70	0.07-0.12-0.17
Alloy steels		
Cast irons	70-80-100	0.1-0.15-0.2

Note: For drills with diameter less than 37 mm, reduce the feed to less than 0.13 mm/rev (0.15 mm/rev for cast irons).

- No. of revolutions (min⁻¹) = Cutting speed × 1000 ÷ 3.14 ÷ Tool diameter
- Table feed (mm/min) = No. of revolutions × Feed per revolution

Cautionary points in use

- When drilling steel, a water soluble cutting fluid should be used.
- Fluid pressure of 1 MPa or higher and fluid quantity of 10 l/min or more are essential.
- For tool-rotating applications, use a commercially available rotary coolant supply holder. (However, TDP60-65 and TDP65-70 must be used only for work rotating applications because their shank diameters are as large as ø50 mm.)
- Drilling into stacked plates tends to damage the tool and is not recommended.
- Not suitable for low carbon steels (SS400) and stainless steels (SUS304).

- : Stocked items.
- : Stocked in Japan