



Welcome to VKD
You will get our latest information

DEEP DRILLING INSERTS

CEMENTED CARBIDE



Zhuzhou Weikeduo Cemented Carbide Co., LTD.

ADDRESS: Building B, Smart Cube, No. 460, Jinshan Road, Hetang
Zhuzhou City, Hunan Province, China

Phone: +86 137 8633 2019 +86 186 7080 5093

Wechat&WhatsApp: +86 137 8633 2019 +86 177 0056 1536

Email: cathy@weikeduocarbide.com

admin@weikeduocarbide.com





Production Capacity

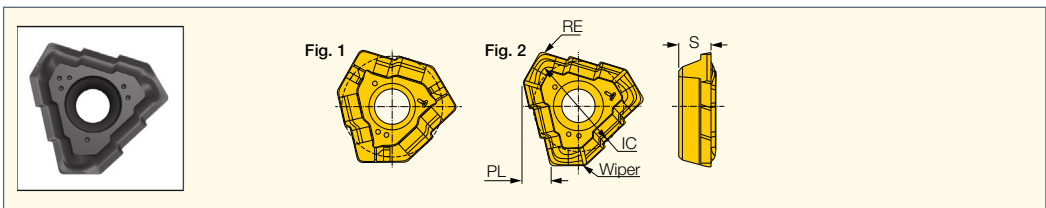
Weikeduo possesses high-precision mold production lines, automated and efficient inclinable ball mills and spray drying granulation system, fully automated TPA pressing and forming equipment, imported pressure sintering furnaces, as well as a constant temperature and humidity-controlled production environment. These highly specialized and automated production facilities fully ensure the stability of product quality and the efficiency of production.



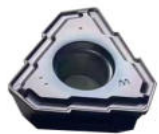


Deep Hole Drilling Inserts TOGT- DT

Deep Drilling Inserts with 3 Chip Splitting Cutting Edges, a Positive Rake Chipbreaker and a Wiper.



Designation	Dimensions					VKD304/VKD301
	IC	RE	PL	S	Fig.	
TOGT 070304-DT	7.69	0.40	1.95	2.30	1	●
TOGT 080305-DT	8.55	0.50	2.20	2.80	1	●
TOGT 090305-DT	8.32	0.50	3.00	3.00	2	●
TOGT 100305-DT	9.23	0.50	3.20	3.30	2	●
TOGT 110405-DT	10.40	0.50	3.40	3.80	2	●
TOGT 120405-DT	11.59	0.50	3.60	4.30	2	●
TOGT 130408-DT	12.85	0.80	4.57	4.76	2	●



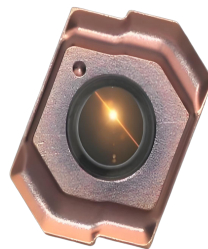
TOGT –DT - VKD304



TOGT –DT - VKD301

Problem	Cause	Solution	
		Grade	Cutting Conditions / Other
1. Chipping, Fracture	- excessive vibration or impact - torn away built-up edge	use a tough grade	- reduce the feed rate - eliminate the vibration
2. Flaking	excessive vibration or impact	use a tough grade	- reduce the feed rate - eliminate the vibration
3. Flank Wear	- cutting speed too high - inadequate tool toughness	- use a grade with high wear resistance - use a coated grade	- reduce the cutting speed - reduce the feed rate - use coolant properly
4. Crater Wear	- cutting speed too high - feed rate too high - inadequate tool toughness	- use a grade with high wear resistance - use a coated grade	- reduce the cutting speed - reduce the feed rate - use coolant properly
5. Initial Chipping	- inappropriate guide bush or pilot hole - misalignment	use a tough grade	- adjust or change the guide bushing or pilot hole - reduce the feed rate - correct the misalignment

Deep Hole Drilling Inserts LOGT- DT



LOGT060204–DT



LOGT060204–DT

Deep Hole Drilling Inserts ZSGT- DT

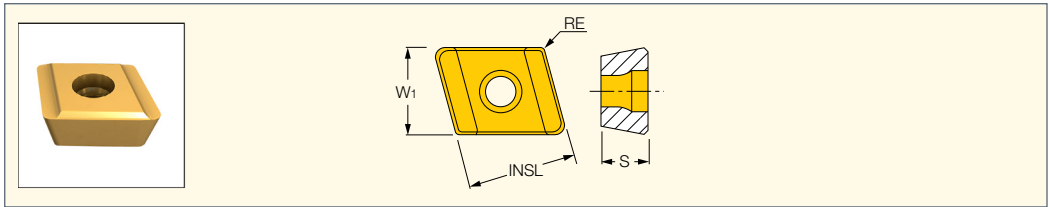


ZSGT060204–DT



Deep Hole Drilling Inserts NPHT- G

Peripheral Precision Inserts for Drilling Heads.

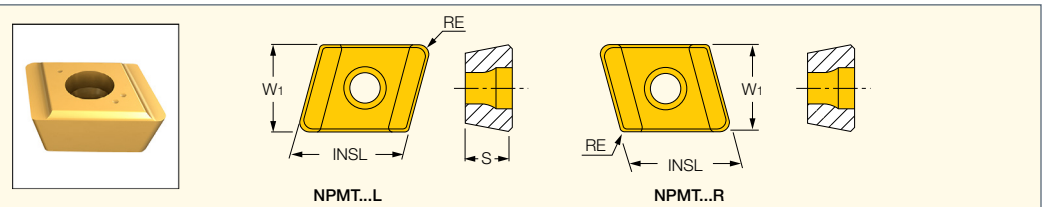


Dimensions				
Designation	W1	INSL	S	RE
NPHT 060308R-G-P	6.00	8.00	3.00	0.80
NPHT 070408R-G-P	7.50	10.00	4.00	0.80
NPHT 090408R-G-P	9.00	10.00	4.00	0.80
NPHT 110408R-G-P	11.00	10.00	4.00	0.80

Customized production is available upon request.

Deep Hole Drilling Inserts NPMT- G

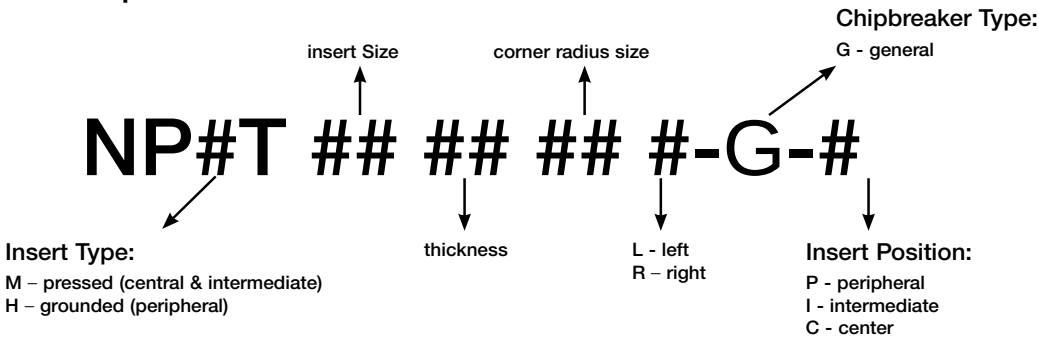
Internal and Central Inserts for Drilling Heads



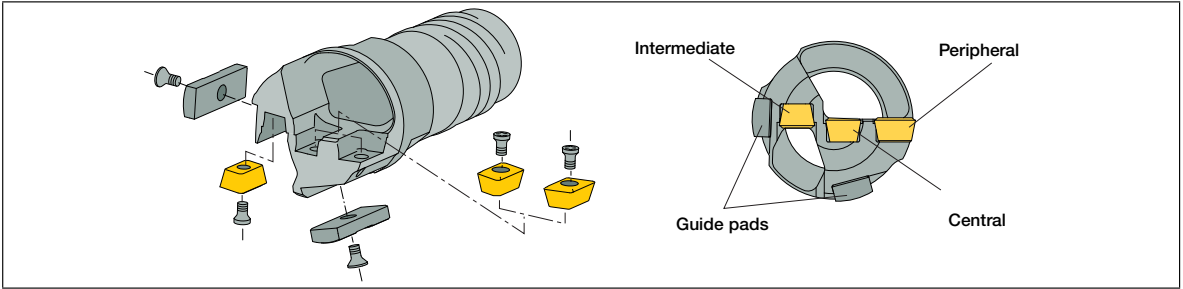
Dimensions				
Designation	W1	INSL	S	RE
NPMT 050304R-G-I	5.50	8.00	3.00	0.40
NPMT 060404R-G-I	6.50	10.00	4.00	0.40
NPMT 080404R-G-I	8.00	10.00	4.00	0.40
NPMT 090404R-G-I	9.50	10.00	4.00	0.40
NPMT 060408L-G-C	6.50	10.00	4.00	0.80
NPMT 080408L-G-C	8.00	10.00	4.00	0.80
NPMT 090408L-G-C	9.50	10.00	4.00	0.80
NPMT 120408L-G-C	12.50	10.00	4.00	0.80

Customized production is available upon request.

Insert Description:



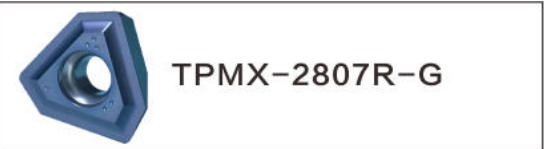
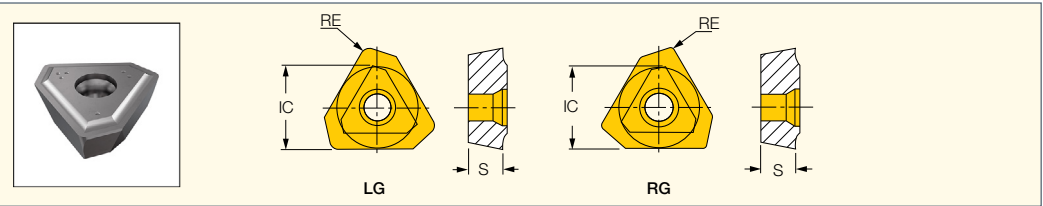
Spare Parts List





Deep Hole Drilling Inserts TPMX

Inserts for Drilling / Counterboring / Trepanning Tools



TPMX-2807R-G



TPMX-2405R-G



TPMX-2204R-G



TPMX-1704R-G



TPMX-1403R-G



TPMX-0902R-G



TPMX-2807R-B



TPMX-2405R-B



TPMX-2204R-B



TPMX-1704R-B



TPMX-1403R-B

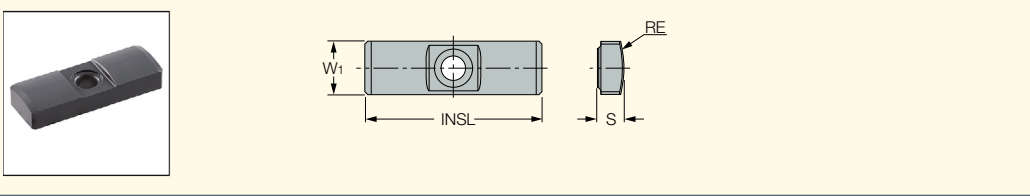


TPMX-0902R-B

G			B		
	versatile			good chip control for heat-resistant alloy	

Deep Hole Drilling GPS Guide Key

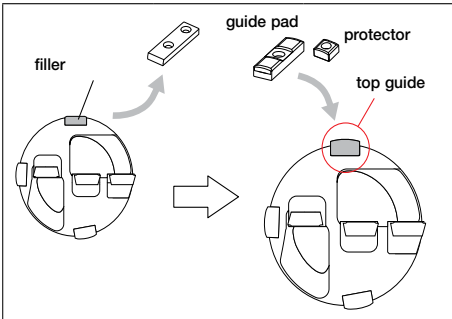
Deep Drilling Solid Carbide Guide Pads for ISCAR



Designation	Dimensions			
	W1	INSL	S	RE
GPS-04-16-045-DC	4.0	16.00	1.80	4.50
GPS-04-16-050-DC	4.0	16.00	1.80	5.00
GPS-04-16-055-DC	4.0	16.00	2.00	5.50
GPS-05-18-060-DC	5.0	18.00	2.50	6.00
GPS-05-18-075-DC	5.0	18.00	2.50	7.50
GPS-06-20-075-DC	6.0	20.00	3.00	7.50
GPS-06-20-075	6.0	20.00	3.00	7.50
GPS-06-20-085-DC	6.0	20.00	3.00	8.50
GPS-06-20-085	6.0	20.00	3.00	8.50
GPS-06-20-100-DC	6.0	20.00	3.00	10.00
GPS-06-20-100	6.0	20.00	3.00	10.00
GPS-06-20-120-DC	6.0	20.00	3.00	12.00
GPS-06-20-120	6.0	20.00	3.00	12.00
GPS-07-20-120-DC	7.0	20.00	3.50	12.00
GPS-07-20-120	7.0	20.00	3.50	12.00
GPS-08-25-155-DC	8.0	25.00	4.50	15.50
GPS-08-25-155	8.0	25.00	4.50	15.50
GPS-10-30-200-DC	10.0	30.00	4.50	20.00
GPS-10-30-200	10.0	30.00	4.50	20.00
GPS-10-35-200-DC	10.0	35.00	6.00	20.00
GPS-10-35-200	10.0	35.00	6.00	20.00
GPS-12-35-250-DC	12.0	35.00	5.50	25.00
GPS-12-35-250	12.0	35.00	5.50	25.00

Please replace the filler with the top guide pad when:

- High hole accuracy is required.
- L/D (hole length-to-diameter) ratio is greater than 50:1.
- Drilling a workpiece which has a tail stock hole.
- The DOC required is greater than the range of the peripheral insert for counterboring. *See chart below.



*Maximum DOC of peripheral insert.

Deep Hole Drilling GPS Guide Key

Deep Drilling Solid Carbide Guide Pads for CoroDrill®



				
Type	INSL	W1	S	Range(mm)
800-06A	18	6	3	φ25-31
800-07A	20	7	3.5	φ31.01-39.6
800-08A	25	8	4.5	φ39.61-47
800-10A	30	10	4.5	φ47.01-54.99
800-12A	35	12	5.5	φ55.00-65.00
800-14D	35	14	7	φ63.5-74.99
800-16D	35	14	7	φ75.0-84.99
800-18D	35	14	7	φ85.0-99.99
800-20D	50	20	8.5	φ100-109.99
800-24D	50	20	8.5	φ120-129.99

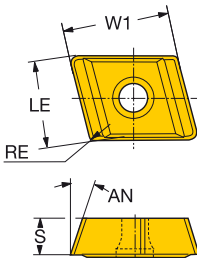
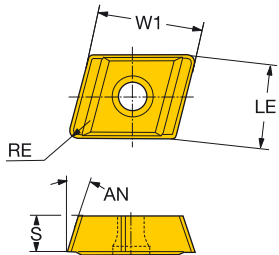
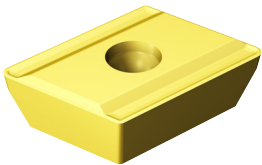
Support pad	Shim set (8 pcs)	S
800-06A	5549 127-85	0.02
	5549 127-86	0.03
800-07A	5549 127-88	0.02
	5549 127-89	0.03
800-08A	5549 127-91	0.02
	5549 127-92	0.03
800-10A	5549 127-94	0.02
	5549 127-95	0.03
800-12A	5549 127-97	0.02
	5549 127-98	0.03

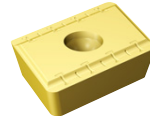
Note: Do not add more than 0.05 mm thickness of shims



Support pads for CoroDrill® 800 solid drill heads

CoroDrill®800 insert for drilling



		Ordering code			Ordering code
	05	800-05 03 08M-C-G		05	800-05 03 08M-I-G
	06	800-06 T3 08M-C-G		06	800-06 T3 08M-I-G
	08	800-08 T3 08M-C-G		08	800-08 T3 08M-I-G
	10	800-10 T3 08M-C-G		12	800-12 T3 08M-I-G
	12	800-12 T3 08M-C-G		05	800-05 03 08M-I-L
	05	800-05 03 08M-C-L		06	800-06 T3 08M-I-L
	06	800-06 T3 08M-C-L		08	800-08 T3 08M-I-L
	08	800-08 T3 08M-C-L		12	800-12 T3 08M-I-L
	10	800-10 T3 08M-C-L			
	12	800-12 T3 08M-C-L			

Customized production is available upon request.