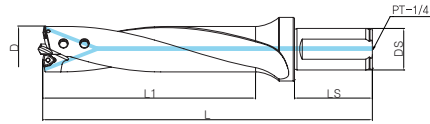


TURBO DRILL

VLT 5×D

DRILLING

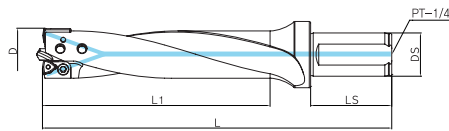


- Shank ISO9766, Parallel with clamping flat

▶ STANDARD TYPE

Code No.	치수 Dimension(mm)					센터드릴 Pilot Drill	인서트 Insert	부품 Component	
	D	L1	L	Ds	Ls			Screw	Driver
VLT-25050D S32	25	150	240	32	60	PLD-V0630 TiN	WCMT030204	TSB-22045	TXL-6
VLT-26050D S32	26								
VLT-27050D S32	27								
VLT-28050D S32	28								
VLT-29050D S32	29								
VLT-30050D S32	30	175	265			PLD-V0835 TiN	WCMT050308	TSB-30070	TXL-8
VLT-31050D S32	31								
VLT-32050D S32	32								
VLT-33050D S32	33								
VLT-34050D S32	34								
VLT-35050D S32	35	200	290						
VLT-36050D S32	36								
VLT-37050D S32	37								
VLT-38050D S32	38								
VLT-39050D S32	39								
VLT-40050D S32	40								

※ ø25~ø40 : 일반형 Standard Type



- Shank ISO9766, Parallel with clamping flat

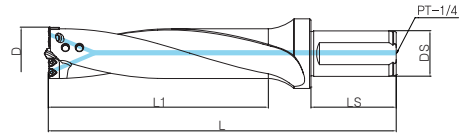
▶ SINGLE INSERT CARTRIDGE TYPE

Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge				
	D	L1	L			Screw	Driver	Inner	Outer			
VLT-414550D S40	41	225	330	PLD-V1035 TiN-H	WCMT 06T308	TSB- 35078	TXL-15	VLC- 410450N	VLC-000410T			
	42								VLC-000420T			
	43								VLC-000430T			
	44								VLC-000440T			
	45								VLC-000450T			
VLT-465050D S40	46	250	355					PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	VLC- 460500N	VLC-000460T
	47											VLC-000470T
	48											VLC-000480T
	49											VLC-000490T
	50											VLC-000500T
VLT-515550D S40	51	275	380	VLC- 510550N	VLC-000510T							
	52					VLC-000520T						
	53					VLC-000530T						
	54					VLC-000540T						
	55					VLC-000550T						
VLT-565950D S40	56	300	405	VLC- 560590N	VLC-000560T							
	57					VLC-000570T						
	58					VLC-000580T						
	59					VLC-000590T						

※ ø41~ø59 : 1mm단위 개별 카트리지 사용으로 직경을 조절합니다.

※ ø41~ø59 : Adjustable 5mm unit when you replace individual outer cartridge(1mm)



- Shank ISO9766, Parallel with clamping flat

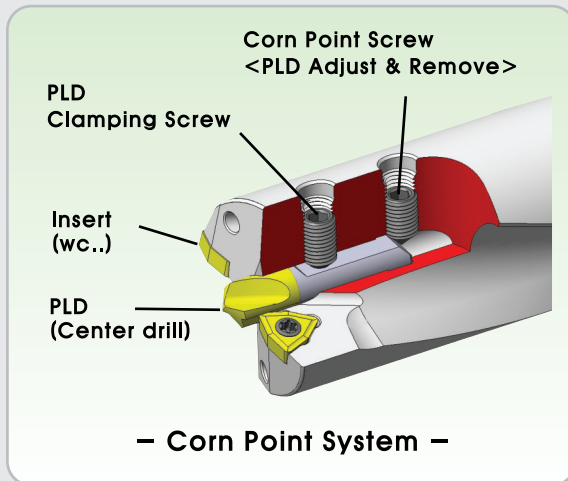
▶ DUAL INSERT CARTRIDGE TYPE

Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge	
	D	L1	L			Screw	Driver	Inner	Outer
VLT-606550D S40	60~65	325	430	PLD-V1238 TiN-H	WCMT 050308	TSB- 30070	TXL-8	VMC-060065N	VLC-060065T
VLT-657050D S40	65~70	350	455					VMC-065070N	VLC-065070T
VLT-707550D S40	70~75	375	480					VMC-070075N	VLC-070075T
VLT-758050D S40	75~80	400	505	PLD-V1645 TiN-H	WCMT 06T308	TSB- 35090	TXL-15	VMC-075080N	VLC-075080T

- ※ $\phi 60 \sim \phi 80$: 외측 카트리지를 커팅하여 직경을 조절합니다.
- ※ $\phi 60 \sim \phi 80$: Cut the outer cartridge and setting.(adjust 5mm)

- VLT 드릴 가공 동영상을 보시려면, 오른쪽 QR코드를 스캔하세요.
- Please scan the QR code if you want to see VLT drill testing sample video.

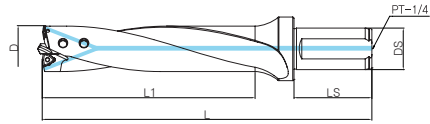


- ▶ **VLT A TYPE** $\phi 25\text{mm} \sim \phi 40\text{mm}$ (Standard Type)
- ▶ **VLT B TYPE** $\phi 41\text{mm} \sim \phi 59\text{mm}$ (Single Insert Cartridge Type)
- ▶ **VLT C TYPE** $\phi 60\text{mm} \sim \phi 80\text{mm}$ (Dual Insert Cartridge Type)

TURBO DRILL

VLT 6.5xD

DRILLING

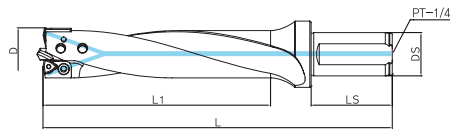


- Shank ISO9766, Parallel with clamping flat

▶ STANDARD TYPE

Code No.	치수 Dimension(mm)					센터드릴 Pilot Drill	인서트 Insert	부품 Component	
	D	L1	L	Ds	Ls			Screw	Driver
VLT-250650D S32	25	185	275	32	60	PLD-V0630 TiN	WCMT030204	TSB-22045	TXL-6
VLT-260650D S32	26								
VLT-270650D S32	27								
VLT-280650D S32	28								
VLT-290650D S32	29								
VLT-300650D S32	30	218	308			PLD-V0835 TiN	WCMT050308	TSB-30070	TXL-8
VLT-310650D S32	31								
VLT-320650D S32	32								
VLT-330650D S32	33								
VLT-340650D S32	34								
VLT-350650D S32	35	250	340	PLD-V0835 TiN	WCMT050308	TSB-30070			
VLT-360650D S32	36								
VLT-370650D S32	37								
VLT-380650D S32	38								
VLT-390650D S32	39								
VLT-400650D S32	40								

※ ø25~ø40 : 일반형 Standard Type



- Shank ISO9766, Parallel with clamping flat

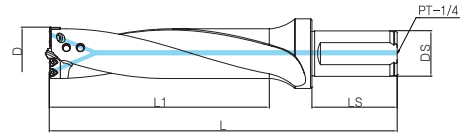
▶ SINGLE INSERT CARTRIDGE TYPE

Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge				
	D	L1	L			Screw	Driver	Inner	Outer			
VLT-4145650D S40	41	283	388	PLD-V1035 TiN-H	WCMT 06T308	TSB- 35078	TXL-15	VLC- 410450N	VLC-000410T			
	42								VLC-000420T			
	43								VLC-000430T			
	44								VLC-000440T			
	45								VLC-000450T			
VLT-4650650D S40	46	315	420					PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	VLC- 460500N	VLC-000460T
	47											VLC-000470T
	48											VLC-000480T
	49											VLC-000490T
	50											VLC-000500T
VLT-5155650D S40	51	348	453	PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	VLC- 510550N	VLC-000510T				
	52							VLC-000520T				
	53							VLC-000530T				
	54							VLC-000540T				
	55							VLC-000550T				
VLT-5659650D S40	56	380	485	PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	VLC- 560590N	VLC-000560T				
	57							VLC-000570T				
	58							VLC-000580T				
	59							VLC-000590T				

※ ø41~ø59 : 1mm단위 개별 카트리지 사용으로 직경을 조절합니다.

※ ø41~ø59 : Adjustable 5mm unit when you replace individual outer cartridge(1mm)



● Shank ISO9766, Parallel with clamping flat

▶ DUAL INSERT CARTRIDGE TYPE

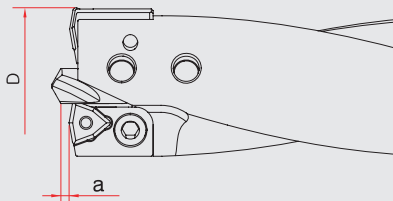
Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge	
	D	L1	L			Screw	Driver	Inner	Outer
VLT-6065650D S40	60~65	423	528	PLD-V1238 TiN-H	WCMT 050308	TSB- 30070	TXL-8	VMC-060065N	VLC-060065T
VLT-6570650D S40	65~70	455	560					VMC-065070N	VLC-065070T
VLT-7075650D S40	70~75	488	593					VMC-070075N	VLC-070075T
VLT-7580650D S40	75~80	520	625	PLD-V1645 TiN-H	WCMT 06T308	TSB- 35090	TXL-15	VMC-075080N	VLC-075080T

※ ø60~ø80 : 외측 카트리지를 커팅하여 직경을 조절합니다.
 ※ ø60~ø80 : Cut the outer cartridge and setting.(adjust 5mm)

User Guide

▶ 파일럿드릴(PLD) 셋팅높이 Pilot drill(PLD) setting



Drill dia. (ø)	a		
	non-alloy steels	alloy steels	non-ferrous metal
25-30	1.2	1	1.5
31-40	1.5	1.3	1.8
41-50	1.8	1.5	2.2
51-59	2.2	1.8	2.5
60-75	2.5	2	2.8
75-80	3	2.5	3.5

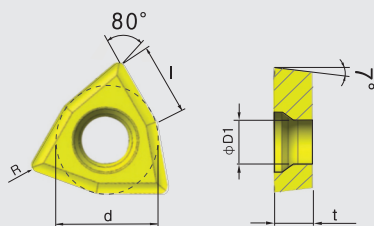
▶ 업그레이드 파일럿드릴(PLD) Upgrade PLD-V type



- 기존 PLD 적용 드릴 : TSD, TMD, VMD(MXD)
- Existing PLD-application drill : TSD, VMD(MXD)

- 업그레이드 PLD적용 드릴(호환성이 좋아짐) : TSD, TMD, VLT, VMD(MXD)
- Upgrade PLD-application drill : TSD, VMD(MXD) and VLT

▶ VLT용 인서트 The insert for VLT-DRILL



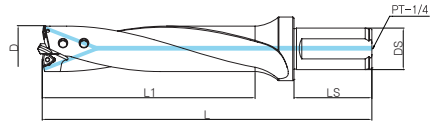
Code No.	치수 Dimension(mm)				
	R	d	D1	t	l
WCMT030204	0.4	5.56	2.5	2.38	3.8
WCMT040204	0.4	6.35	2.8	2.38	4.3
WCMT050308	0.8	7.94	3.4	3.18	5.4
WCMT06T308	0.8	9.525	4.4	3.97	6.5
WCMT080408	0.8	12.7	5.5	4.76	8.7

- 위 규격과 다른 인서트를 사용하면 인서트 스크류가 인서트보다 튀어나오거나, 가공경이 작아질 수 있습니다.
- The standard table above is for the reference of inserts for VLT-DRILL, we also sell different designs of the insert screws separately.

TURBO DRILL

VLT 8×D

DRILLING

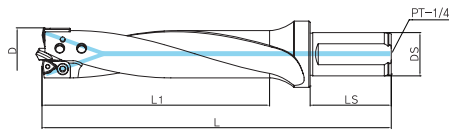


- Shank ISO9766, Parallel with clamping flat

▶ STANDARD TYPE

Code No.	치수 Dimension(mm)					센터드릴 Pilot Drill	인서트 Insert	부품 Component	
	D	L1	L	Ds	Ls			Screw	Driver
VLT-25080D S32	25	220	310	32	60	PLD-V0630 TiN	WCMT030204	TSB-22045	TXL-6
VLT-26080D S32	26								
VLT-27080D S32	27								
VLT-28080D S32	28								
VLT-29080D S32	29								
VLT-30080D S32	30								
VLT-31080D S32	31	260	350	32	60	PLD-V0835 TiN	WCMT040204	TSB-25055	TXL-8
VLT-32080D S32	32								
VLT-33080D S32	33								
VLT-34080D S32	34								
VLT-35080D S32	35								
VLT-36080D S32	36								
VLT-37080D S32	37	300	390	32	60	PLD-V0835 TiN	WCMT050308	TSB-30070	TXL-8
VLT-38080D S32	38								
VLT-39080D S32	39								
VLT-40080D S32	40								

※ ø25~ø40 : 일반형 Standard Type



- Shank ISO9766, Parallel with clamping flat

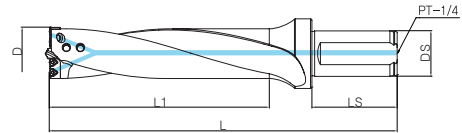
▶ SINGLE INSERT CARTRIDGE TYPE

Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge	
	D	L1	L			Screw	Driver	Inner	Outer
VLT-414580D S40	41	340	445	PLD-V1035 TiN-H	WCMT 06T308	TSB- 35078	TXL-15	VLC- 410450N	VLC-000410T
	42								VLC-000420T
	43								VLC-000430T
	44								VLC-000440T
	45								VLC-000450T
VLT-465080D S40	46	380	485	PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	TXL-15	VLC- 460500N	VLC-000460T
	47								VLC-000470T
	48								VLC-000480T
	49								VLC-000490T
	50								VLC-000500T
VLT-515580D S40	51	420	525	PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	TXL-15	VLC- 510550N	VLC-000510T
	52								VLC-000520T
	53								VLC-000530T
	54								VLC-000540T
	55								VLC-000550T
VLT-565980D S40	56	460	565	PLD-V1238 TiN-H	WCMT 080408	TSB- 40110	TXL-15	VLC- 560590N	VLC-000560T
	57								VLC-000570T
	58								VLC-000580T
	59								VLC-000590T

※ ø41~ø59 : 1mm단위 개별 카트리지 사용으로 직경을 조절합니다.

※ ø41~ø59 : Adjustable 5mm unit when you replace individual outer cartridge(1mm)



● Shank ISO9766, Parallel with clamping flat

▶ DUAL INSERT CARTRIDGE TYPE

Shank	Ds	Ls
S40	40	70

Code No.	치수 Dimension(mm)			센터드릴 Pilot Drill	인서트 Insert	부품 Component		카트리지 Cartridge	
	D	L1	L			Screw	Driver	Inner	Outer
VLT-606580D S40	60~65	520	625	PLD-V1238 TiN-H	WCMT 050308	TSB- 30070	TXL-8	VMC-060065N	VLC-060065T
VLT-657080D S40	65~70	560	665					VMC-065070N	VLC-065070T
VLT-707580D S40	70~75	600	705					VMC-070075N	VLC-070075T
VLT-758080D S40	75~80	640	745	PLD-V1645 TiN-H	WCMT 06T308	TSB- 35090	TXL-15	VMC-075080N	VLC-075080T

※ $\phi 60 \sim \phi 80$: 외측 카트리지를 커팅하여 직경을 조절합니다.
 ※ $\phi 60 \sim \phi 80$: Cut the outer cartridge and setting.(adjust 5mm)

Corn Point System

Anti-Vibration! Anti-Loose!

■ 콘포인트 시스템 특징

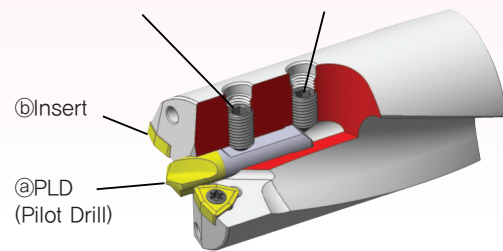
- (1) PLD높이를 빠르고 쉽게 조절할 수 있다
- (2) PLD를 빼 내야 할 경우, 콘포인트볼트를 이용해 쉽게 제거할 수 있다.
- (3) 가공시 진동발생이 발생해도 볼트가 풀리지 않아 PLD가 뒤로 밀리는 현상이 없다.

■ Corn Point System Characteristic

- (1) It is fast and easy to adjust height, when you insert the PLD on the drill.
- (2) The PLD is broken while you use, you can remove of the corn-point-screw.
- (3) The corn-point-screw treat prevent of unloose when vibration occur, the PLD is not into the drill.

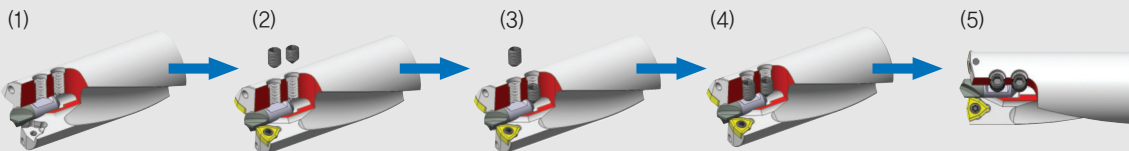
@PLD Clamping Screw ©Corn Point Screw

ⓑInsert
 @PLD
 (Pilot Drill)



[Corn Point System]

■ 조립순서(VLT,FXD) How to use (VLT, FXD)



- (1) 먼저 @PLD를 삽입한다.
- (2) 인서트 (또는 카트리지)를 클램핑한다.
- (3) 콘포인트볼트로 PLD높이를 알맞게 맞춘다.
- (4) PLD 클램핑볼트로 강하게 조여준다.
- (5) 콘포인트 볼트로 다시한번 강하게 조여 유격을 없앤다.

- (1) First, The @PLD insert to Hole.
- (2) Locking the ⓑInsert, (Cartridge+Insert)
- (3) The @PLD hight control as the ©corn-point-screw
- (4) @PLD-Clamping-screw tightly.
- (5) Clamping of ©Corn-point-screw tightly again.

(※Important!)

[Corn Point System]

Prevention from screw loose.



- The corn-point-screw treat prevent of unloose when vibration occur, the PLD is not in to the drill (It can be reused several times)