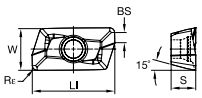
WIDIA VICTORY

Inserts for VSM11 Series



● first choice
○ alternate choice

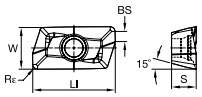
P							○	●	●		○	●				
M							●	○	●	●	●	●				
K			●	●			○	○								
N		●			●	●										
S							●		○	●	●	●				
H																

catalogue number	cutting edges	LI	BS	S	W	Rε	hm	WDN10U	WK15CM	WK15PM	WN10HM	WN25PM	WP25PM	WP35CM	WP40PM	WS30PM	NEW! WS40PM	WU35PM
XDCW110404PDFRPCD	1	13,43	2,10	4,00	6,90	0,40	0,02	5415420	-	-	-	-	-	-	-	-	-	-
XDCW110408PDFRPCD	1	13,44	1,70	4,00	6,90	0,80	0,02	5415421	-	-	-	-	-	-	-	-	-	-
XDCT110402PDFRALP	2	13,42	2,29	4,00	6,90	0,20	–	-	-	-	6407444	6407445	-	-	-	-	-	-
XDCT110404PDFRALP	2	13,43	2,09	4,00	6,90	0,40	0,02	-	-	-	5933940	5417054	-	-	-	-	-	-
XDCT110408PDFRALP	2	13,44	1,69	4,00	6,90	0,80	0,02	-	-	-	5936171	5417053	-	-	-	-	-	-
XDCT110412PDFRALP	2	13,44	1,29	4,00	6,90	1,20	0,02	-	-	-	6055634	6055635	-	-	-	-	-	-
XDCT110416PDFRALP	2	13,44	0,88	4,00	6,89	1,60	0,02	-	-	-	6055598	6055599	-	-	-	-	-	-
XDCT110420PDFRALP	2	13,44	0,49	4,00	6,89	2,00	–	-	-	-	6407446	6407447	-	-	-	-	-	-
XDCT110424PDFRALP	2	13,44	0,16	4,00	6,88	2,40	0,02	-	-	-	6055600	6055631	-	-	-	-	-	-
XDCT110432PDFRALP	2	12,86	–	4,00	6,89	3,20	0,02	-	-	-	6055632	6055633	-	-	-	-	-	-
XDCT110404PDERML	2	13,43	2,09	4,00	6,90	0,40	0,04	-	-	6242456	-	-	5536671	5536670	5642230	-	6180174	-
XDCT110408PDERML	2	13,44	1,69	4,00	6,90	0,80	0,04	-	5415549	6242457	-	-	5415548	5415547	5545065	5517826	6180173	5415546
XDCT110412PDERML	2	13,44	1,29	4,00	6,90	1,20	–	-	-	-	-	-	6408003	-	-	-	6408002	-
XDCT110416PDERML	2	13,44	0,88	4,00	6,89	1,60	0,04	-	-	-	-	-	5964861	-	5964810	-	6408004	-
XDCT110420PDERML	2	13,44	0,49	4,00	6,89	2,00	–	-	-	-	-	-	-	-	-	-	6408005	-
XDCT110424PDERML	2	13,44	0,16	4,00	6,88	2,40	–	-	-	-	-	-	-	-	-	-	6408006	-

(continued)

(Inserts for VSM11 Series — continued)

WIDIA VICTORY



● first choice
○ alternate choice

Inserts for VSM11 Series

	WDN10U	WK15CM	WK15PM	WN10HM	WN25PM	WP25PM	WP35CM	WP40PM	WS30PM	WS40PM NEW!	WU35PM
P						○	●	●		○	●
M						●	○	●	●	●	●
K		●	●			○	○				
N	●			●	●						
S						●		○	●		●
H											

catalogue number	cutting edges	LI	BS	S	W	Rε	hm	WDN10U	WK15CM	WK15PM	WN10HM	WN25PM	WP25PM	WP35CM	WP40PM	WS30PM	WS40PM	WU35PM
XDCT110432PDERML	2	12,86	–	4,00	6,89	3,20	–	-	-	-	-	-	-	-	-	-	6408007	-
XDPT110404PDSRMM	2	13,49	2,06	4,13	6,94	0,39	0,06	-	5415428	6242458	-	-	5642237	5415450	5642231	-	6180149	-
XDPT110408PDSRMM	2	13,50	1,66	4,13	6,94	0,78	0,06	-	5415315	6242459	-	-	5415319	5415318	5545063	5519921	6180148	5415317
XDPT110412PDSRMM	2	13,44	1,29	4,00	6,90	1,20	0,06	-	5415310	-	-	-	5415314	5415313	5642232	-	6180150	5415312
XDPT110416PDSRMM	2	13,51	0,85	4,13	6,95	1,60	0,06	-	5415250	-	-	-	5415254	5415253	5642233	-	6180172	-
XDPT110420PDSRMM	2	13,51	0,45	4,13	6,95	2,00	0,06	-	-	-	-	-	5980399	5980400	5980398	-	6408095	-
XDPT110424PDSRMM	2	13,37	–	4,01	6,94	2,40	0,06	-	-	-	-	-	5901355	-	5901354	-	6408096	-
XDPT110431PDSRMM	2	12,94	–	4,01	6,94	3,10	0,06	-	5415422	-	-	-	5415426	5415425	5642234	5517827	6279204	-
XDPT110408PDSRMH	2	13,44	1,68	4,00	6,90	0,79	0,13	-	5415255	-	-	-	-	5415257	5545064	-	6408098	5415256
XDPT110412PDSRMH	2	13,44	1,29	4,00	6,90	1,20	0,13	-	5415360	-	-	-	-	5415362	5642235	-	6408099	-
XDPT110416PDSRMH	2	13,44	0,90	4,00	6,90	1,59	0,13	-	5415364	-	-	-	-	5415366	5642236	-	6408100	-

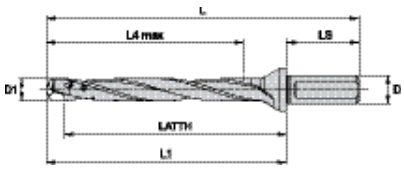
NOTE: XDCT11: High-precision periphery ground inserts.
XDPT11: Precision-pressed and sintered-to-size inserts.

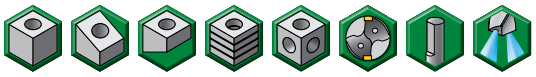
Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	XDCT-ML	WP40PM	**XDPT-MM**	**WP40PM**	XDPT-MH	WP40PM
P3–P4	XDCT-ML	WP40PM	**XDPT-MM**	**WP40PM**	XDPT-MH	WP40PM
P5–P6	XDPT-MM	WP25PM	**XDPT-MM**	**WP35CM**	XDPT-MH	WP40PM
M1–M2	XDCT-ML	WS40PM	**XDPT-MM**	**WS40PM**	XDPT-MH	WS40PM
M3	XDCT-ML	WS40PM	**XDPT-MM**	**WS40PM**	XDPT-MH	WS40PM
K1–K2	XDCT-ML	WK15CM	**XDPT-MM**	**WK15CM**	XDPT-MH	WK15CM
K3	XDCT-ML	WP35CM	**XDPT-MM**	**WP35CM**	XDPT-MH	WP35CM
N1–N2	XDCT-ALP	WN10HM	**XDCT-ALP**	**WN25PM**	XDCT-ALP	WN25PM
N3	XDCW-PCD	WDN10U	**XDCW-PCD**	**WDN10U**	XDCW-PCD	WDN10U
S1–S2	XDCT-ML	WP25PM	**XDPT-MM**	**WS40PM**	XDPT-MH	WS40PM
S3	XDCT-ML	WS40PM	**XDPT-MM**	**WS40PM**	XDPT-MH	WS40PM
S4	XDCT-ML	WS40PM	**XDPT-MM**	**WS40PM**	XDPT-MH	WS40PM
H1	XDCT-ML	WP25PM	**XDPT-MM**	**WP25PM**	–	–

TDMX — TOP DRILL™ Modular X

Modular Drill System • TDMX





▼ TOP DRILL™ Modular X • 3 x D/ 5 x D/ 8 x D • Side Lock Shank • Metric

3 x D		5 x D		8 x D		D1			clamping	
order #	catalogue #	order #	catalogue #	order #	catalogue #	SSC	min	max	screw	wrench
6572091	TDMX160R3SL20M	6572125	TDMX160R5SL20M	6572155	TDMX160R8SL20M	A	16,000	16,999	193.537	12148086600
6572092	TDMX170R3SL20M	6572126	TDMX170R5SL20M	6572156	TDMX170R8SL20M	B	17,000	17,999	193.537	12148086600
6572093	TDMX180R3SL25M	6572127	TDMX180R5SL25M	6572157	TDMX180R8SL25M	C	18,000	18,999	193.537	12148086600
6572094	TDMX190R3SL25M	6572128	TDMX190R5SL25M	6572158	TDMX190R8SL25M	D	19,000	19,999	193.537	12148086600
6572096	TDMX200R3SL25M	6572129	TDMX200R5SL25M	6572159	TDMX200R8SL25M	E	20,000	20,999	193.523	170.0240
6572097	TDMX210R3SL25M	6572130	TDMX210R5SL25M	6572160	TDMX210R8SL25M	F	21,000	21,999	193.523	170.0240
6572098	TDMX220R3SL25M	6572141	TDMX220R5SL25M	6572171	TDMX220R8SL25M	G	22,000	22,999	193.523	170.0240
6572099	TDMX230R3SL25M	6572142	TDMX230R5SL25M	6572172	TDMX230R8SL25M	H	23,000	23,999	193.523	170.0240
6572100	TDMX240R3SL32M	6572143	TDMX240R5SL32M	6572173	TDMX240R8SL32M	I	24,000	24,999	193.524	12148082400
6572101	TDMX250R3SL32M	6572144	TDMX250R5SL32M	6572174	TDMX250R8SL32M	J	25,000	25,999	193.524	12148082400
6572102	TDMX260R3SL32M	6572145	TDMX260R5SL32M	6572175	TDMX260R8SL32M	K	26,000	26,999	193.524	12148082400
6572104	TDMX270R3SL32M	6572146	TDMX270R5SL32M	6572176	TDMX270R8SL32M	L	27,000	27,999	193.524	12148082400
6572105	TDMX280R3SL32M	6572147	TDMX280R5SL32M	6572177	TDMX280R8SL32M	M	28,000	28,999	193.525	TT15
6572106	TDMX290R3SL32M	6572148	TDMX290R5SL32M	6572178	TDMX290R8SL32M	N	29,000	29,999	193.525	TT15
6572107	TDMX300R3SL32M	6572149	TDMX300R5SL32M	6572179	TDMX300R8SL32M	O	30,000	30,999	193.525	TT15
6572108	TDMX310R3SL32M	6572150	TDMX310R5SL32M	6572180	TDMX310R8SL32M	P	31,000	31,999	193.525	TT15
6572109	TDMX320R3SL40M	6572151	TDMX320R5SL40M	6572181	TDMX320R8SL40M	Q	32,000	33,999	193.525	TT15
6572110	TDMX340R3SL40M	6572152	TDMX340R5SL40M	6572182	TDMX340R8SL40M	R	34,000	35,999	193.525	TT15
6572121	TDMX360R3SL40M	6572153	TDMX360R5SL40M	6572183	TDMX360R8SL40M	S	36,000	37,999	193.585	TT15
6572122	TDMX380R3SL40M	6572154	TDMX380R5SL40M	6572184	TDMX380R8SL40M	T	38,000	40,000	193.585	TT15

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.

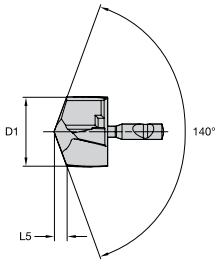
▼ Dimensions

	mm Ø				SHORT ~3 x D				LONG ~5 x D				EXTRA LONG ~8 x D			
SSC	D1 min	D1 max	LS	D	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max	LATTH	L	L1	L4 max
A	16,000	16,999	50	20	68,8	131	81	51	102,8	165	115	85	153,8	216	166	136
B	17,000	17,999	50	20	73,8	136	86	54	109,8	172	122	90	163,8	226	176	144
C	18,000	18,999	56	25	76,7	146	90	57	114,7	184	128	95	171,7	241	185	152
D	19,000	19,999	56	25	81,7	151	95	60	121,7	191	135	100	181,7	251	195	160
E	20,000	20,999	56	25	84,6	155	99	63	126,6	197	141	105	189,6	260	204	168
F	21,000	21,999	56	25	89,6	160	104	66	133,6	204	148	110	199,6	270	214	176
G	22,000	22,999	56	25	92,5	164	108	69	138,5	210	154	115	207,5	279	223	184
H	23,000	23,999	56	25	97,5	169	113	72	145,5	217	161	120	217,5	289	233	192
I	24,000	24,999	60	32	100,4	177	117	75	150,4	227	167	125	225,4	302	242	200
J	25,000	25,999	60	32	105,4	182	122	78	157,4	234	174	130	235,4	312	252	208
K	26,000	26,999	60	32	108,3	186	126	81	162,3	240	180	135	243,3	321	261	216
L	27,000	27,999	60	32	113,3	191	131	84	169,3	247	187	140	253,3	331	271	224
M	28,000	28,999	60	32	116,2	195	135	87	174,2	253	193	145	261,2	340	280	232
N	29,000	29,999	60	32	121,2	200	140	90	181,2	260	200	150	271,2	350	290	240
O	30,000	30,999	60	32	124,1	204	144	93	186,1	266	206	155	279,1	359	299	248
P	31,000	31,999	60	32	129,1	209	149	96	193,1	273	213	160	289,1	369	309	256
Q	32,000	33,999	70	40	136,0	228	158	102	204,0	296	226	170	306,0	398	328	272
R	34,000	35,999	70	40	145,0	237	167	108	217,0	309	239	180	325,0	417	347	288
S	36,000	37,999	70	40	151,8	246	176	114	227,8	322	252	190	341,8	436	366	304
T	38,000	40,000	70	40	160,8	255	185	120	240,8	335	265	200	360,8	455	385	320

▼ TOP DRILL™ Modular X • PK(M)



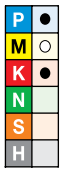
● first choice
○ alternate choice



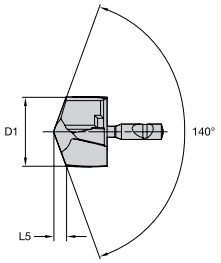
order #	catalogue #	D1	L5	SSC
		grade WP40PD TiAlN		
6568446	TDMX16000PKM	16,00	3,21	A
6568447	TDMX16200PKM	16,20	3,25	A
6568448	TDMX16281PKM	16,28	3,26	A
6568449	TDMX16500PKM	16,50	3,30	A
6568450	TDMX16667PKM	16,67	3,33	A
6568461	TDMX17000PKM	17,00	3,39	B
6568462	TDMX17064PKM	17,06	3,41	B
6568464	TDMX17463PKM	17,46	3,48	B
6568465	TDMX17500PKM	17,50	3,49	B
6568467	TDMX17600PKM	17,60	3,50	B
6568471	TDMX17800PKM	17,80	3,54	B
6568472	TDMX17859PKM	17,86	3,55	B
6568473	TDMX18000PKM	18,00	3,58	C
6568474	TDMX18255PKM	18,26	3,64	C
6568475	TDMX18500PKM	18,50	3,68	C
6568476	TDMX18651PKM	18,65	3,71	C
6568477	TDMX18800PKM	18,80	3,74	C
6568478	TDMX19000PKM	19,00	3,78	D
6568479	TDMX19050PKM	19,05	3,78	D
6568480	TDMX19200PKM	19,20	3,81	D
6568481	TDMX19270PKM	19,27	3,82	D
6568482	TDMX19450PKM	19,45	3,86	D
6568483	TDMX19500PKM	19,50	3,87	D
6568484	TDMX19700PKM	19,70	3,90	D
6568485	TDMX19840PKM	19,84	3,93	D
6568813	TDMX20000PKM	20,00	3,97	E
6568814	TDMX20100PKM	20,10	3,99	E
6568815	TDMX20200PKM	20,20	4,01	E
6568816	TDMX20239PKM	20,24	4,02	E
6568817	TDMX20300PKM	20,30	4,03	E
6568818	TDMX20400PKM	20,40	4,05	E
6568819	TDMX20500PKM	20,50	4,06	E
6568820	TDMX20600PKM	20,60	4,08	E
6568841	TDMX20650PKM	20,65	4,09	E
6568842	TDMX20700PKM	20,70	4,10	E
6568843	TDMX20800PKM	20,80	4,12	E
6568844	TDMX20900PKM	20,90	4,14	E
6568845	TDMX21000PKM	21,00	4,16	F
6568846	TDMX21430PKM	21,43	4,23	F
6568847	TDMX21500PKM	21,50	4,25	F
6568848	TDMX22000PKM	22,00	4,35	G
6568849	TDMX22225PKM	22,23	4,39	G
6568850	TDMX22450PKM	22,45	4,44	G
6568851	TDMX22500PKM	22,50	4,44	G
6568852	TDMX23000PKM	23,00	4,54	H
6568853	TDMX23500PKM	23,50	4,63	H
6568854	TDMX23813PKM	23,81	4,68	H
6568856	TDMX24000PKM	24,00	4,73	I
6568857	TDMX24500PKM	24,50	4,82	I
6568858	TDMX24605PKM	24,61	4,84	I
6568859	TDMX25000PKM	25,00	4,91	J
6568860	TDMX25400PKM	25,40	4,99	J
6568861	TDMX25500PKM	25,50	5,01	J
6568862	TDMX25670PKM	25,67	5,04	J
6568863	TDMX25700PKM	25,70	5,04	J
6568864	TDMX25760PKM	25,76	5,05	J

(continued)

(TOP DRILL Modular X • PK(M) — continued)



● first choice
○ alternate choice



		grade WP40PD TiAlN		
order #	catalogue #	D1	L5	SSC
6568865	TDMX25796PKM	25,80	5,06	J
6568866	TDMX26000PKM	26,00	5,11	K
6568867	TDMX26192PKM	26,19	5,15	K
6568868	TDMX26400PKM	26,40	5,18	K
6568869	TDMX26500PKM	26,50	5,20	K
6568870	TDMX26589PKM	26,59	5,22	K
6568871	TDMX27000PKM	27,00	5,29	L
6568872	TDMX27500PKM	27,50	5,38	L
6568873	TDMX27780PKM	27,78	5,43	L
6568874	TDMX28000PKM	28,00	5,49	M
6568875	TDMX28176PKM	28,18	5,52	M
6568876	TDMX28500PKM	28,50	5,58	M
6568877	TDMX28575PKM	28,58	5,59	M
6568878	TDMX29000PKM	29,00	5,67	N
6568879	TDMX29367PKM	29,37	5,74	N
6568880	TDMX29500PKM	29,50	5,76	N
6568891	TDMX29764PKM	29,76	5,81	N
6568892	TDMX30000PKM	30,00	5,87	O
6568893	TDMX30163PKM	30,16	5,90	O
6568896	TDMX30500PKM	30,50	5,96	O
6568897	TDMX30955PKM	30,96	6,04	O
6568898	TDMX31000PKM	31,00	6,05	P
6568899	TDMX31500PKM	31,50	6,14	P
6568900	TDMX31750PKM	31,75	6,18	P
6568901	TDMX32000PKM	32,00	6,25	Q
6568902	TDMX32500PKM	32,50	6,34	Q
6568903	TDMX33000PKM	33,00	6,43	Q
6568904	TDMX33338PKM	33,34	6,49	Q
6568905	TDMX34000PKM	34,00	6,61	R
6568906	TDMX34130PKM	34,13	6,64	R
6568907	TDMX34925PKM	34,93	6,78	R
6568908	TDMX35000PKM	35,00	6,79	R
6568909	TDMX35500PKM	35,50	6,89	R
6568910	TDMX36000PKM	36,00	7,00	S
6568911	TDMX36500PKM	36,50	7,09	S
6568912	TDMX37000PKM	37,00	7,18	S
6568913	TDMX37500PKM	37,50	7,27	S
6568914	TDMX38000PKM	38,00	7,36	T
6568915	TDMX38100PKM	38,10	7,38	T
6568916	TDMX38500PKM	38,50	7,46	T
6568917	TDMX39000PKM	39,00	7,55	T
6568918	TDMX39289PKM	39,29	7,60	T
6568919	TDMX39500PKM	39,50	7,64	T
6568920	TDMX40000PKM	40,00	7,73	T

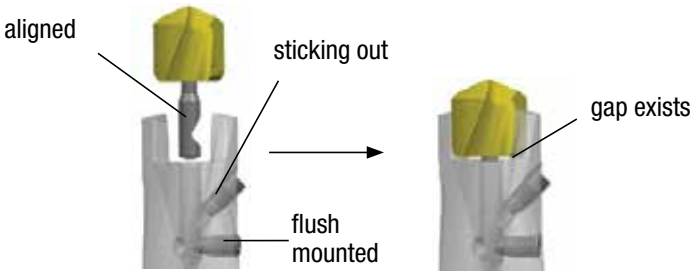
NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.

Metric tolerance	
D1	tolerance k8
8–10	0,000/+0,022
>10–17	0,000/+0,027
>17–18	0,000/+0,027
>18–21	0,000/+0,033

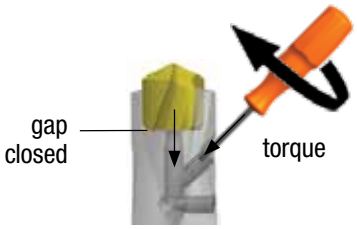
Assembling and Disassembling Instructions

▼ Assembly

1 Insert positioning



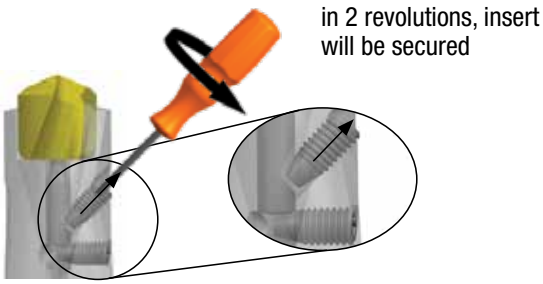
2 Insert clamping



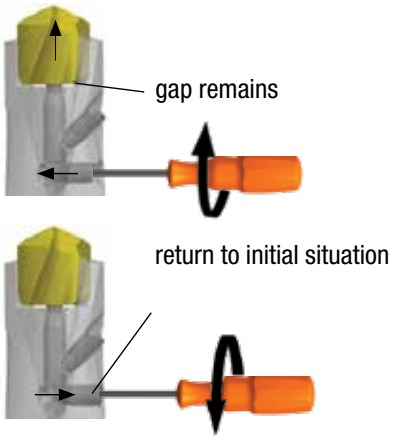
Drill diameter	Torque
ø 16–19,999mm	1,5 Nm
ø 20–23,999mm	2,1 Nm
ø 24–27,999mm	3,0 Nm
ø 28–40,000mm	4,5 Nm

▼ Disassembly

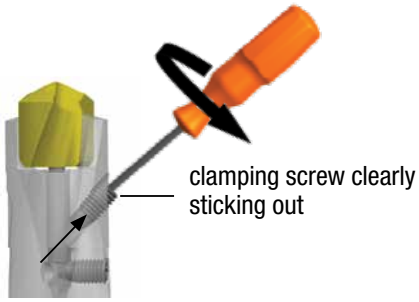
1 Clamping screw loosening



2 Insert pushing out



3 Further clamping screw loosening



4 Insert removal

