

MTS

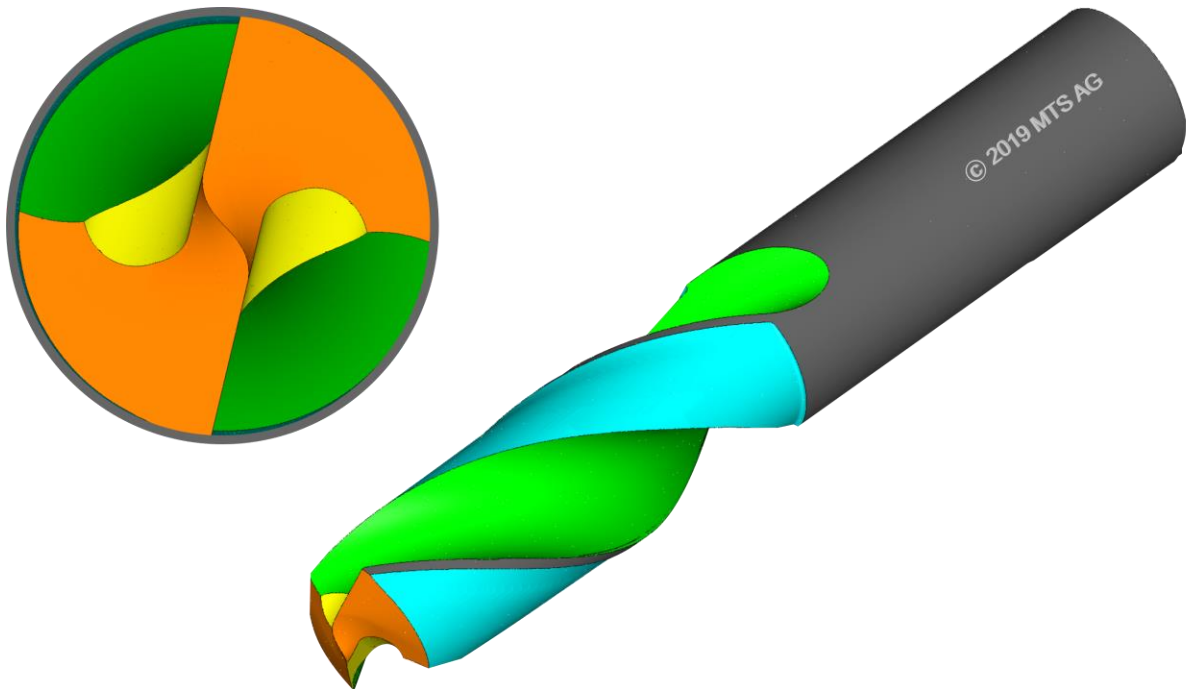
Product of the VOLLMER Group

tool-kit PROFESSIONAL by MTS – Product of the VOLLMER Group

Software-Modul

Spezifikation „Drills/BMENU“

Stand: 15.01.25



MTS – Product of the VOLLMER Group
Innovationszentrum Freiburg (FRIZ)
Georges-Köhler-Allee 302
79110 Freiburg im Breisgau
Tel.: +49 7351 571 8141 / +49 160 5426017
info@mtsag.net
www.mtsag.net

MTS

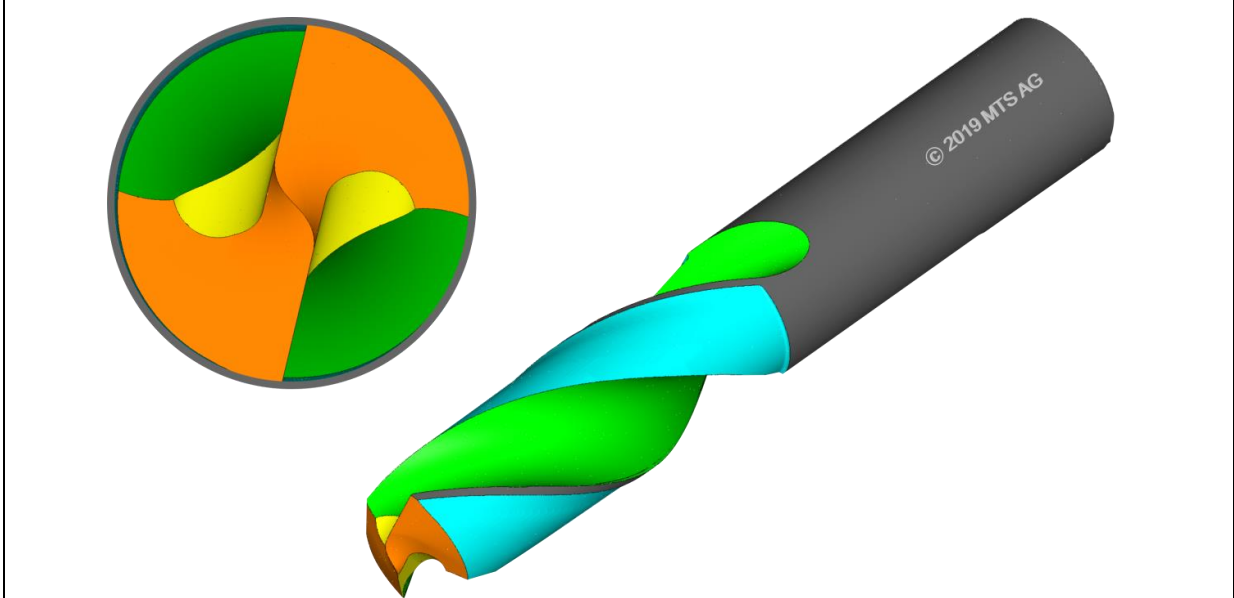
Product of the VOLLMER Group

MTS

Product of the VOLLMER Group

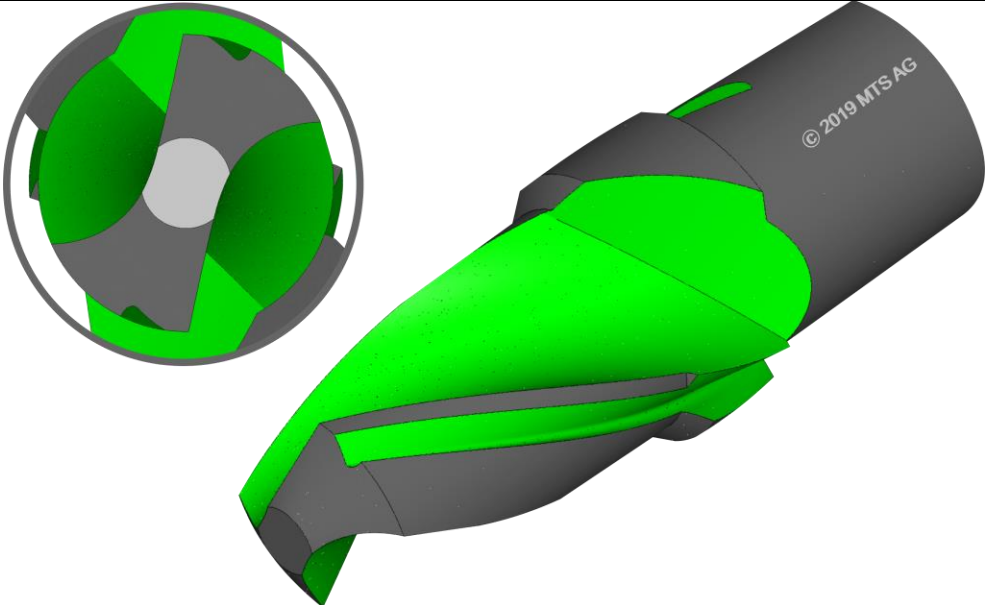
6.1 Drills

BMENU



MTS

Product of the VOLLMER Group

<p>6.1 Basic Modul Drills</p>	
<ul style="list-style-type: none"> • Work Piece 2 or 3 teeth 1 – 5 Steps • Cutting Edge Combination: right helix/right cut left helix/left cut • Produktion / Regrinding Production by different infeed (several steps) Regrinding with calculation of removal length, periphery and rake. Regrinding, finishing with different wheels • Preparation: Separation Profile roughing Profile finishing • Point Standard Split point 2-facet point 4-facet point 6-facet point Delta – point M – point Kevlar – point Centring point Milling end face 	<ul style="list-style-type: none"> • 2nd Chamfer Optional: 2nd chamfer • 1st Web Thinning Correction of main cutting edge Correction of chisel edge S-web thinning (incl. Sumitomo like) Free constructed notchings / corrections • 2nd Web Thinning Correction of main cutting edge Correction of chisel edge • Main Fluting Meas. definition: Point-/ normal cut Grind. direction: Forward / backward Optional spark out grinding Separated fluting per step • Periphery Radial grinding / Round grinding Transverse/longitudinal positioning Linear relief: 1./2. relief angle • Steps Standard step (axial/radial relief angle) Step aperture angle: 45 - 200° Linear relief step (aperture angle $\geq 170^\circ$) • Chip Breaker 1 or 2 chip breakers per tooth • Production from standard- to step drill Special measurement and calculation Program
<p>mtsag.net</p>	
<p>6.2 Drills Subland Drills</p>	<p>BMENU</p>
	

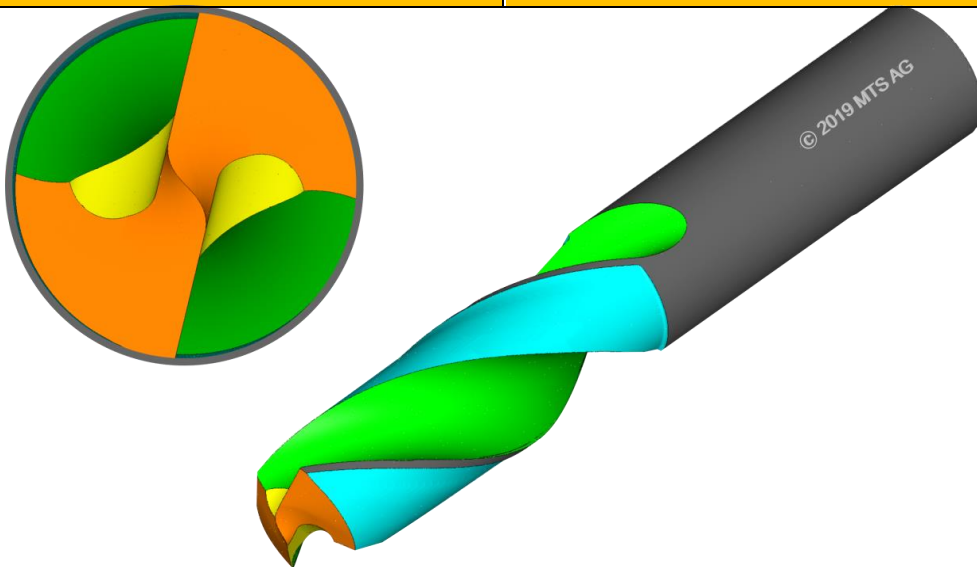
6.2 Subland Drills
Extension to 6.1:

- **Specification according to Standard-/Stepping Drills**
- **Secondary Fluting**
Defined rotation against main fluting
Stufe

mtsag.net

6.3 Drills S-Point

BMENU



MTS

Product of the VOLLMER Group

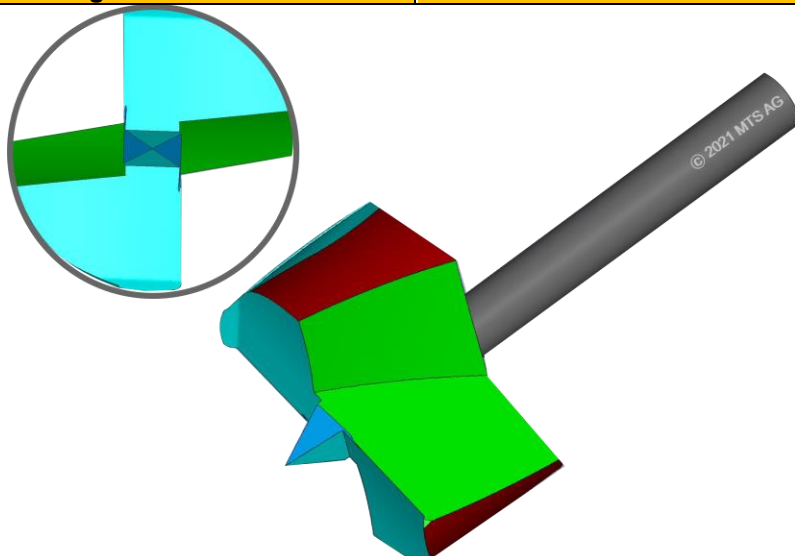
6.3 S-Point Extension to 6.1:

- **S-Point:**
2- and 3-Teeth

mtsag.net

6.4 Drills Woodworking Tools

BMENU



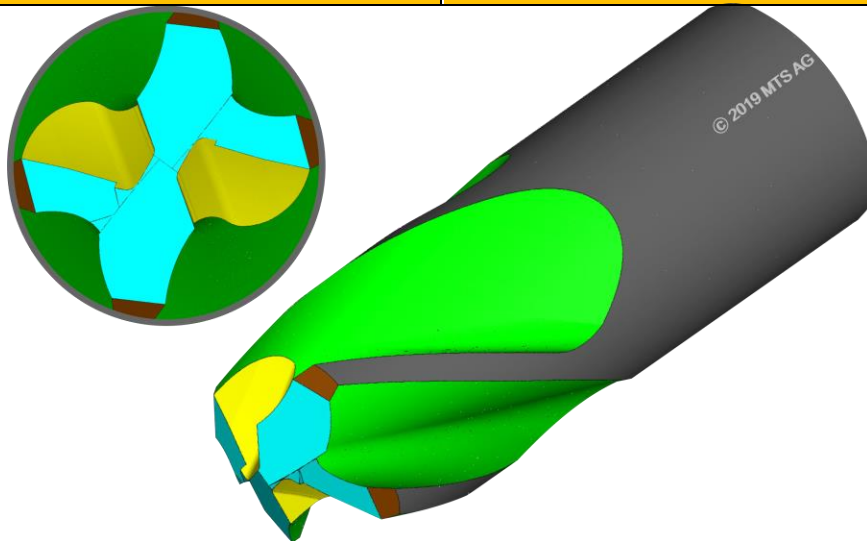
6.4 Woodworking Tools
Extension to 6.1:

- Drills for woodworking:
At the moment available:
- Pin-drill
- Forstner-drill

mtsag.net

6.5 Drills MTS-GIGA-4FL

BMENU



MTS

Product of the VOLLMER Group

6.5 MTS-GIGA-4FL Extension to 6.1:

- Special point with 4 teeth / flutes:
There are 4 main cutting edges, each including a 4-facet-points and a 4-facet-chamfer, splitted into two groups. The main group is constructed by a typical 4-facet-point while the secondary group is done by shortened teeth. (like a end mill tool with 2-to-center-geometry).
- The two-stepped Giga-Drill is like a typical subland-drill-geometry.