

MTS

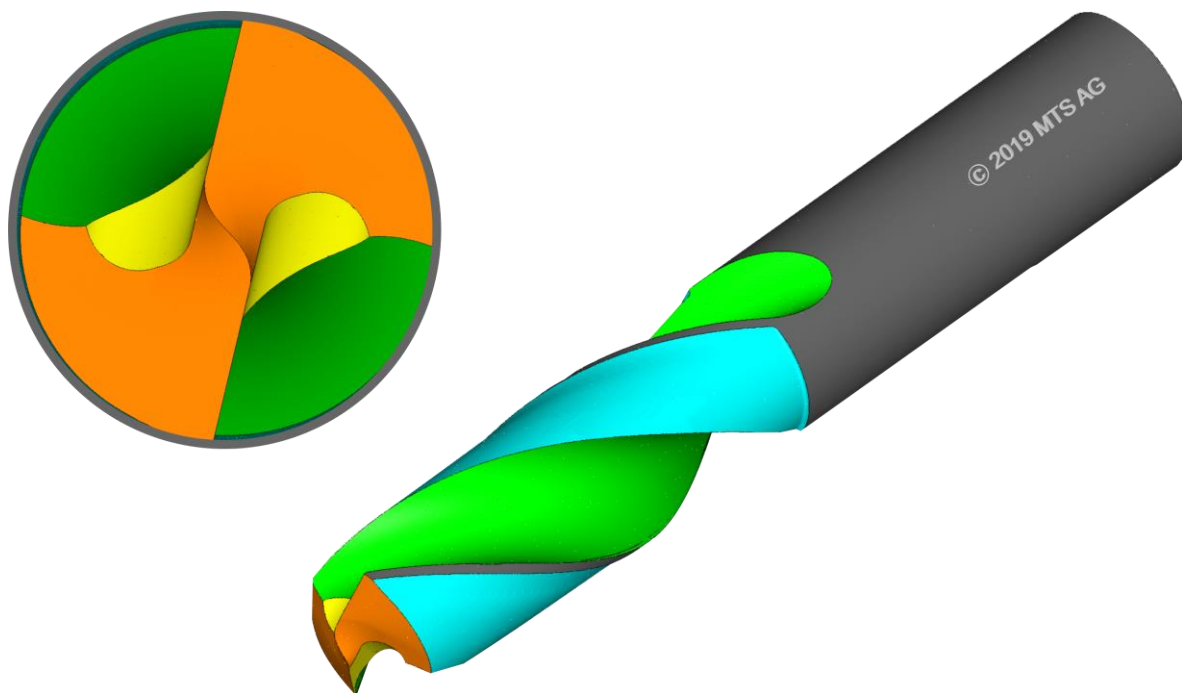
Product of the VOLLMER Group

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

Software-Modul

Spezifikation „Drills/BMENU“

Stand: 30.01.25



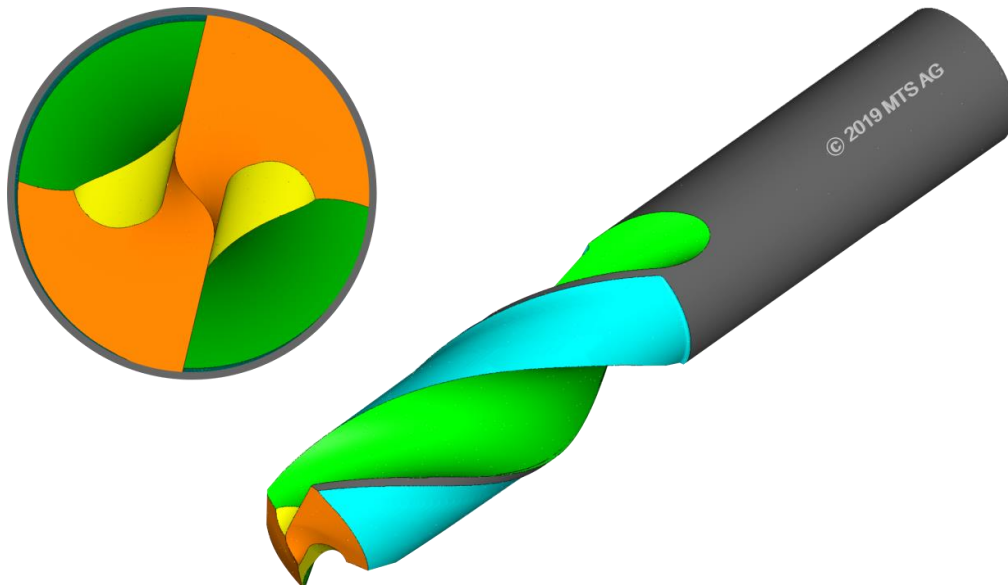
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6.1 Drills

BMENU



6.1 Basic Modul Drills

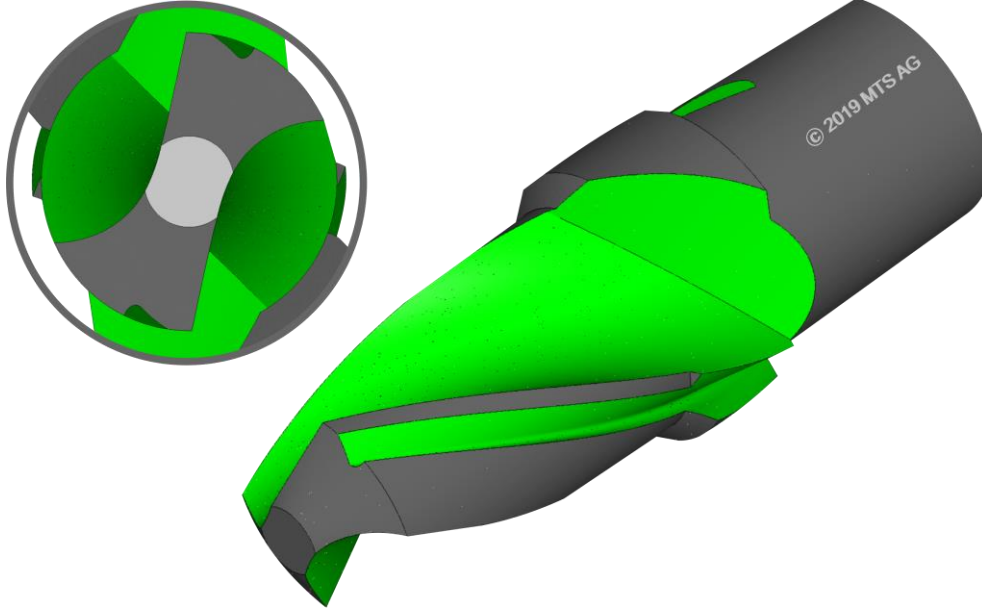
- **Work Piece**
2 or 3 teeth
1 – 5 Steps
- **Cutting Edge Combination:**
right helix/right cut
left helix/left cut
- **Produktion / Regrinding**
Production by different infeed (several steps)
Regrinding with calculation of removal length, periphery and rake.
Regrinding, finishing with different wheels
- **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
- **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

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6.2 Drills Subland Drills

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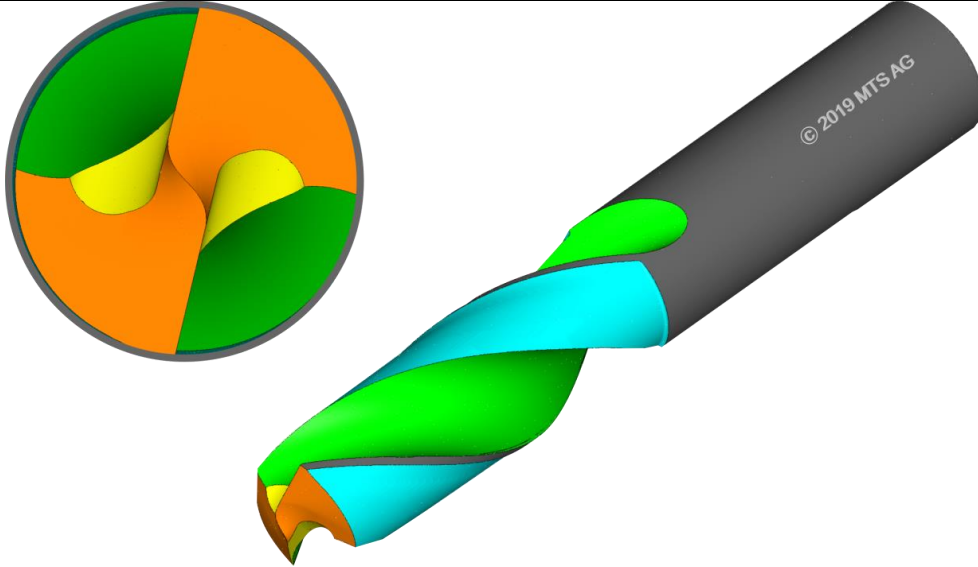


6.2 Subland Drills Extension to 6.1:

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

6.3 Drills S-Point

BMENU

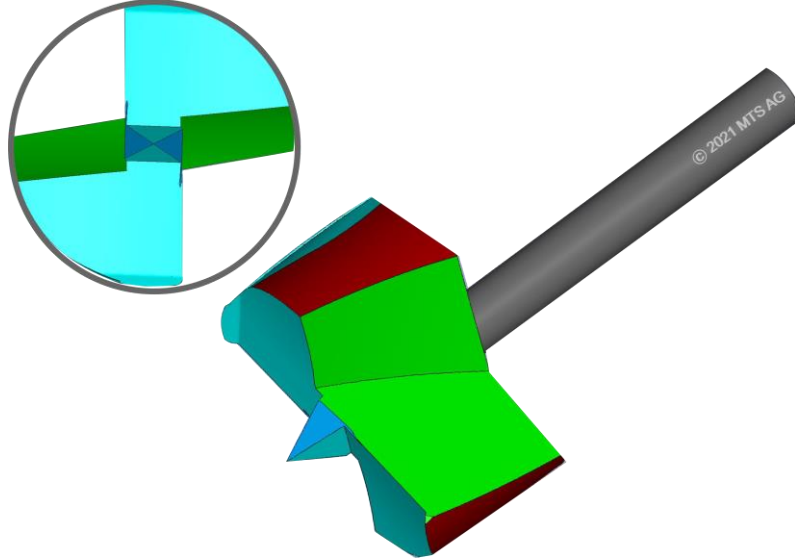


6.3 S-Point Extension to 6.1:

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

6.4 Drills Woodworking Tools

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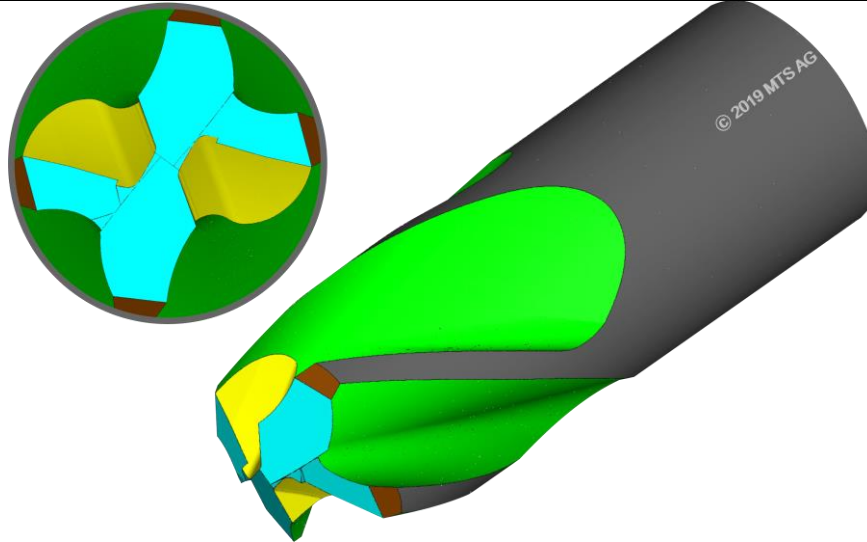


6.4 Woodworking Tools Extension to 6.1:

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

6.5 Drills MTS-GIGA-4FL

BMENU



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.