Flowdrill Flow drilling

Description:

The polygon contour of the carbide flow drill generates frictional heat which plasticises all types of metal materials. This allows closed apertures to be created in a variety of thicknesses of materials, without chips, in just a few seconds.

Advantage:

- Large savings of time and costs compared to conventional processes (such as drawn-on nuts).
- Generates no chips or swarf; supersedes rivet nuts, weld nuts and press nuts.
- Solid basis for threads with high pull-out forces.
 - For all popular material thicknesses and thread sizes (threads to DIN 13).

Flow drilling sets

Supplied with:

08 2710/2715 - ■ 1 Special chuck MT2 with cooling ring.

- 1 hook spanner and 1 open-ended spanner.
- 4 ER25 collets in sizes suitable for M4 M12.
- 1 flow drill in the selected thread size.
- 1 Flowtap fluteless tap in the selected thread size.
- 1 bottle special parting agent for flow drilling, with brass brush (FDKS100; 100 q).
- 1 bottle special thread forming oil, with bristle brush (FTMZ100; 100 ml).
- 1 system case with brief user guide (comprehensive user manual available as PDF download).

Other versions and sets for special applications (such as for thin sheet metal) available on request.

Note:

for thread M **₹ 08 2710** For suitable fluteless taps see items No. 139115 ff.

	M4	M5	M6	M8	M10	M12
Starter set standard	XXX	XXX	XXX	XXX	XXX	XXX
Starter set flat	XXX	XXX	XXX	XXX	XXX	XXX
Starter Set Hat	XXX	XXX	ХХХ	λλλ	XXX	٨٨

for thread M		M5-M8	M6-M10	M5-M12
ਭ 08 2721	Flow drilling set - standard including fluteless taps	XXX	XXX	XXX
9 08 2726	Flow drilling set - flat including fluteless taps	XXX	XXX	XXX
Content:		Size M5; M6; M8	Size M6; M8; M10	Size M5; M6; M8; M10: M12

Flow drill / accessories

08 2730/2735 - Carbide flow drills for production of tapping holes preliminary to thread forming.

mm	XXX XXX 3.7	XXX XXX 4.5	XXX XXX 5.4	XXX XXX 7.3	XXX	XXX
mm						
mm	3.7	4.5	ЕЛ	7.7		
		1.5	2.4	7.3	9.2	10.9
mm	6	6	6	8	10	12
mm	2.6	2.7	2.9	3.3	3.7	4
mm	4.2	4.6	5	5.9	6.6	7.2
kW	0.7	0.8	1	1.3	1.5	1.7
rpm	2600	2500	2400	2200	2000	1800
	mm mm kW	mm 2.6 mm 4.2 kW 0.7	mm 2.6 2.7 mm 4.2 4.6 kW 0.7 0.8	mm 2.6 2.7 2.9 mm 4.2 4.6 5 kW 0.7 0.8 1	mm 2.6 2.7 2.9 3.3 mm 4.2 4.6 5 5.9 kW 0.7 0.8 1 1.3	mm 2.6 2.7 2.9 3.3 3.7 mm 4.2 4.6 5 5.9 6.6 kW 0.7 0.8 1 1.3 1.5

Contents in I or kg		1
9 08 2741	Parting agent	XXX
₹ 08 2742	Thread forming oil	XXX

Flow drills for aluminium

Special flow drill for production of tapping holes in aluminium preliminary to thread forming. Coated aluminium profiles can be drilled without separating agent, without the risk of scratching or scorching the paint. The geometry and an extremely smooth surface coating prevent vibration and noise, and material pick-up.

Other versions and sets for special applications (such as for thin sheet metal) available on request. Use fluteless taps without oil grooves. See items No. 139115 ff for suitable fluteless taps.





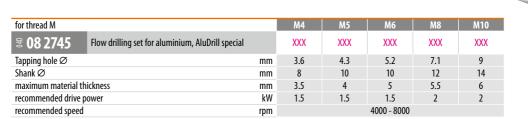
08 2721 / 2726_M5-M12



Flat – no collar



08 2735





08 2735