



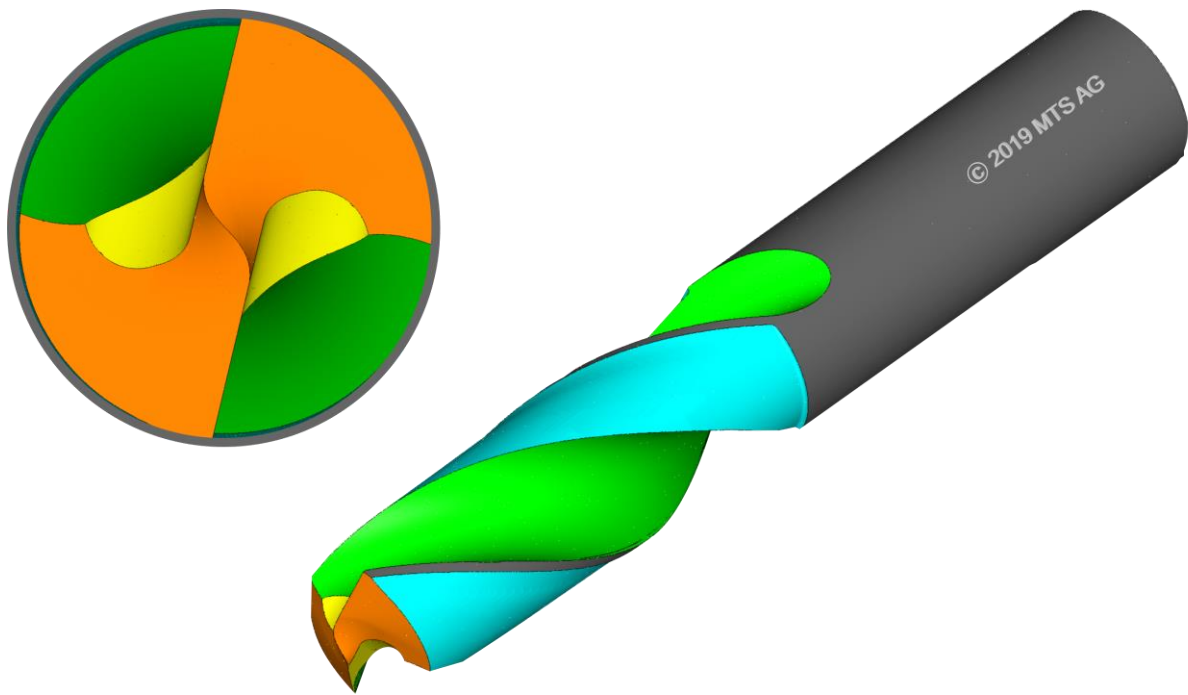
MTS AG  
Mathematisch-Technische-Software

*tool-kit* PROFESSIONAL by MTS AG

# Software-Modul

## Spezifikation „Drills/BMENU“

Stand: 23.03.21



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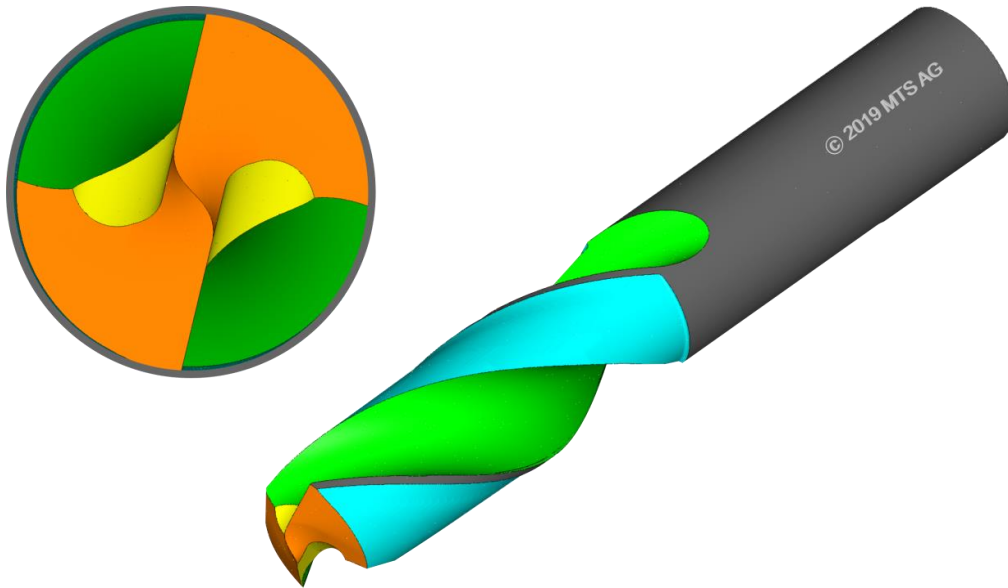


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6.1 Drills

BMENU



6.1 Basic Modul Drills

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

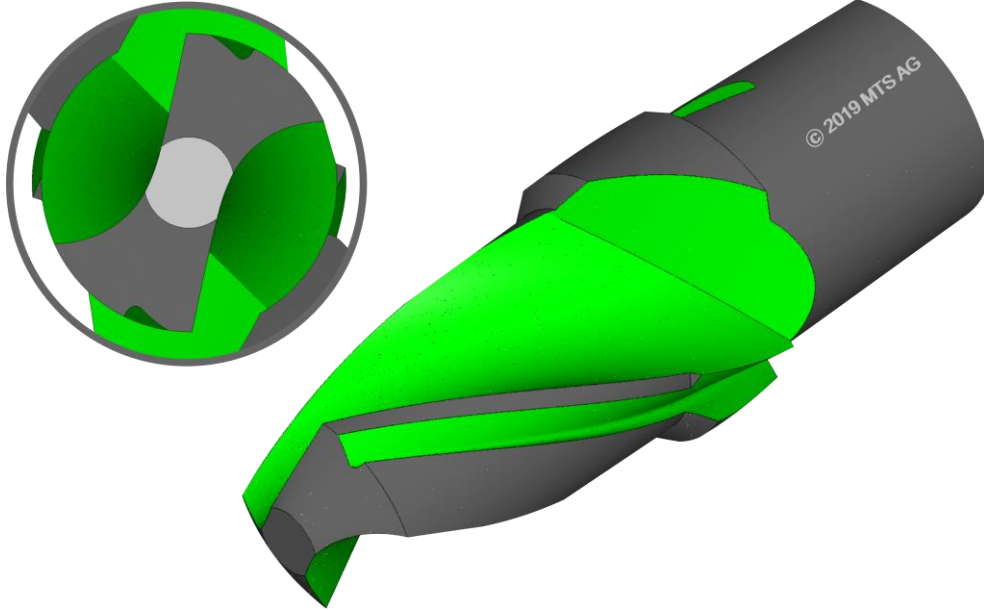


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6.2 Drills Subland Drills

2BMENU



6.2 Subland Drills  
Extension to 6.1:

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

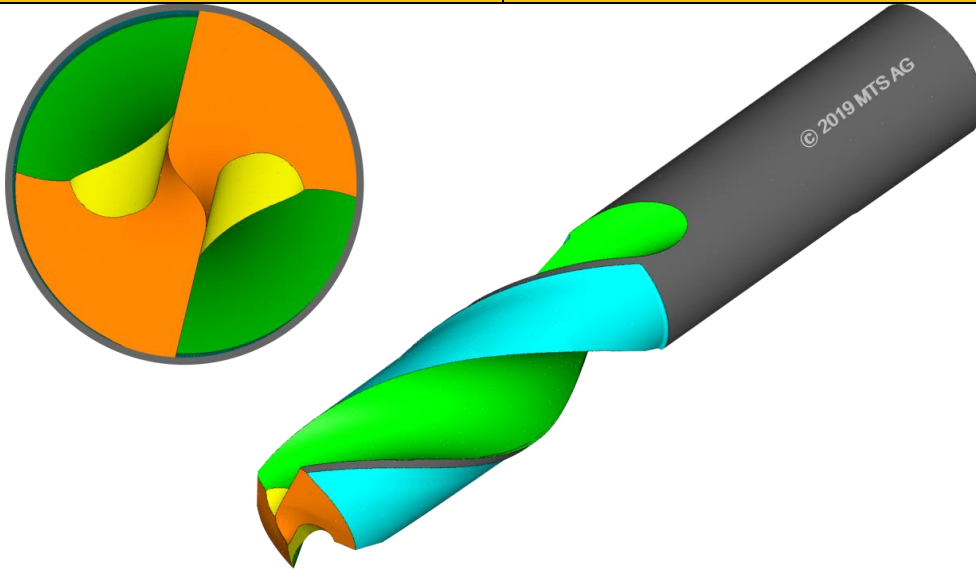


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**6.Drills S-Point**

**3BMENU**



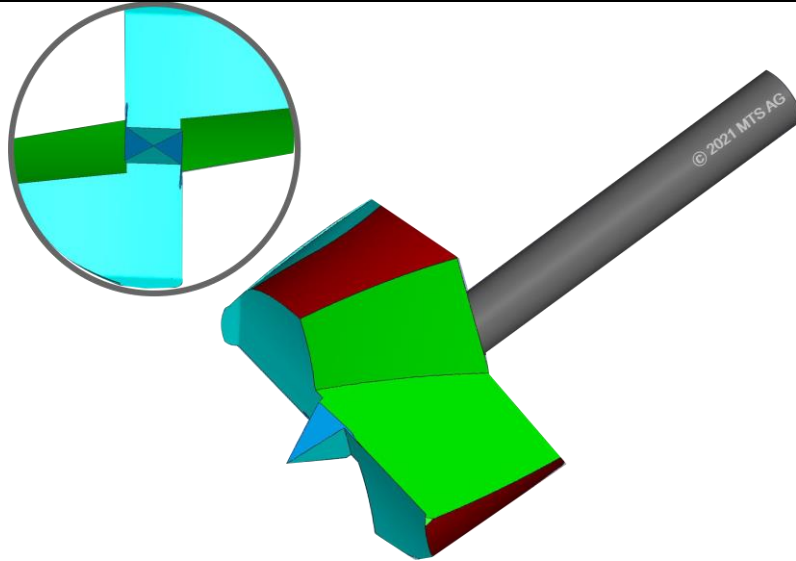
**6.3 S-Point  
Extension to 6.1:**

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



**6. Drills Woodworking Tools**

**4BMENU**



**6.4 Woodworking Tools  
Extension to 6.1:**

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

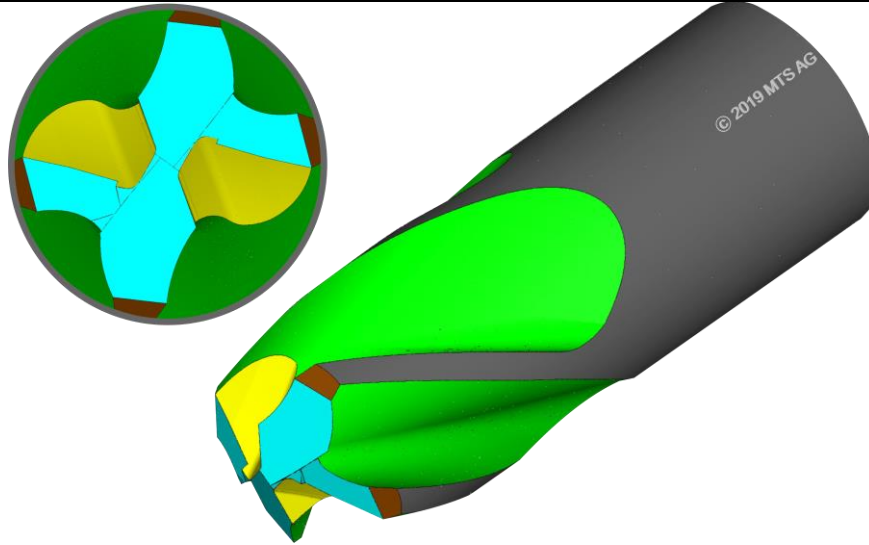


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6.Drills MTS-GIGA-4FL

5BMENU



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.