

To our customers :

INFORMATION ABOUT FLOWDRILL®

FLOWDRILL® frictional drilling and correct choice of tooling.

Flowdrill® introduce the possibility of a sturdy bushing by using the Flowdrill® drilling method. Flowdrill® is used for adequate threading, bushings for tubular connections, seats for hinges and bearings, etc. where the original material thickness is too small to serve Your demand. Flowdrill® works in tubes, sheet metal, bended profiles, RHS, piping and in a variety of materials as iron, steel, stainless, copper and aluminium. It is possible to apply Flowdrill® in diameters from Ø2 until Ø45 mm or more, from approx. M2 until almost 2" BSP, in material thicknesses from 1mm exceeding 10mm, depending on the actual diameter of the Flowdrill®.

Flowdrill®, as used in drilling machines, drilling heads and CNC, consist of a toolholder w. cooler disc, clamping collets, Flowdrill®, lubricant and possible cold forming threading tap. We offer You suitable advice concerning tools, methods, necessary machine capacities etc. Flowdrill® workshop manual with all specifications needed, as well as a shortform user guide, comes along with Your Flowdrill® start-kit.

As example a Flowdrill® Ø7,4Short (for M8) withstands as much as **10.000 holes** in ordinary mild steel (whilst approx 1/3 in stainless) in optimized production, as do the cold roll-forming threading taps. Cycle time pr. Flowdrill®-hole is usually less than by ordinary drilling. Also the roll-forming of threads is very efficient, as it is also a chipless tapping method, giving considerable advantages such as; Improved thread strength, increased cycle speed, less risk of breakage, no chipremoval, less cleaning a.m.o.

All considered; Flowdrill® is the obvious solution to choose in workpieces where You usually insert bearnuts, welded nuts, welded tubular connections, welded enhancements, etc., which all, apart from mounting costs, also bear a purchase price or production costs, that often alone will exceed the total costs of a similar hole made with Flowdrill® in production.

Choice of tooling (help us helping You):

Item: Consider and determin:

- Hole :**
- Metric / BSP / NPT / UNC / UNF / or straight cylindrical bushing.
 - with / without top collar on workpiece (- /FLAT applies best on flat surface)
 - **! NOTE! :** Choosing FLAT-type involves cutters on the Flowdrill® rim, whereas ordinary Flowdrill® (SHORT or LONG) is recommendable.

- Material:**
- wall thickness
 - geometri (outer/inner measurements of tubes and profile)
 - type (steel, stainless, copper etc. ?)

- Machinery :**
- Adequate drilling machine must be available. Machine specs chosen from diagram in manual / brochure. Manual feed (by hand), pneumatic feed (airguided) or CNC progressive feed is to be desired. Mecanical feed is applicable in specific circumstances only and most often will decrease tool lifetime.

FURTHER QUESTIONS : Call +45 7020 9320.

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Yours sincerely
Allan Andersen
Indutek/Danish Tool Systems



Flowdrill®
Start-kit

Complete Flowdrill®-system

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Start kit:

Flowdrill® toolholder, 3 collets, toolcase, manual amo..



Wear parts:

Flowdrill® and thread tap



Lubricants:

Flowdrill® Paste, Akafill tapp. oil

Original Flowdrill®-tooling:

Flowdrill® StartKit		Prices	
		€/Pcs.	€ (Euro)
Example: M4 Short. Matr. thickn. 1-2 mm			
50FDMC2	Flowdrill® holder m. cooler disc MK2	325,74	
ER25-xx	Collets (3pcs i.e. Ø6, 8 and 10)	62,33	
90FDCA	Flowdrill® Toolcase.	45,58	OFFER
SUMME incl.:	Spanners, UK Manual, quick guide	433,65	349,00
200370	Flowdrill® 3,7 SHORT	55,23	
4004000	M4 Thread tap with TiN / oil grooves	30,29	85,52
Total price	EXW.	€ (EURO)	434,52

(Machine capacity: Best: 1kW / 2400 RPM, (min. 0,7kW / btw. 2200-2800 RPM))

The 3 pcs. of collets in the Flowdrill® StartKit can be supplied in different sizes of Your free choice. The StartKit is completed by Flowdrill®, lubricants and thread tap according to the job in demand.

FDMC2 toolholder is recommended to a maximum of Ø14,4mm Flowdrill®. If You foresee tasks involving larger sizes we recommend the FDMC3 toolholder which also holds smaller Flowdrill®.

Hereafter the implementation of a new holesize only involves an adequate Flowdrill®, perhaps a collet and a thread tap if in demand, as long as the requested toolholder is applicable.

In this complete StartKit the primary wear parts is the Flowdrill® and thread tap (€ 85,52) To supplement the M4 with for example M6 You will need only:

200540	Flowdrill® 5,4 SHORT	61,80	Total € :
4006000	M6 Thread tap w. TiAIN and oilgrooves	31,37	93,17

and You are ready for Flowdrilling a new size.

Best regards

Indutek/Danish Tool Systems

This special offer for the Flowdrill® StartKit, FDMC2 StartKit, is valid at least 1 month from 20. januar 2010.

All calculations and specifications are to be considered strictly indicative, presenting no grounds whatsoever for liability claims of any kind. All prices listed less VAT, freight, etc. Prices may change without further notice.