

DRILLING AND DEBURRING COMBINED WINS TIME

HEULE PRECISION TOOLS | RENÉ KEHL

**Drilling and
chamfering at
the same time**



**Drilling and then
chamfering both
sides**



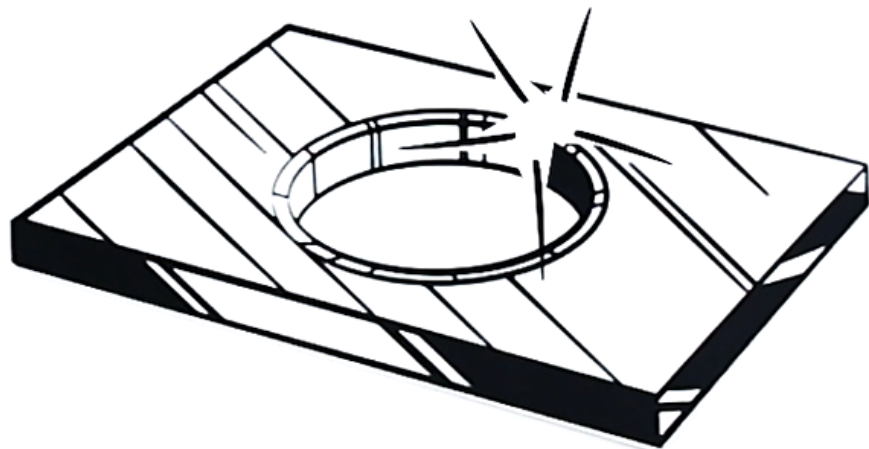
**Drilling,
countersinking,
turn workpiece,
countersinking**



What if...

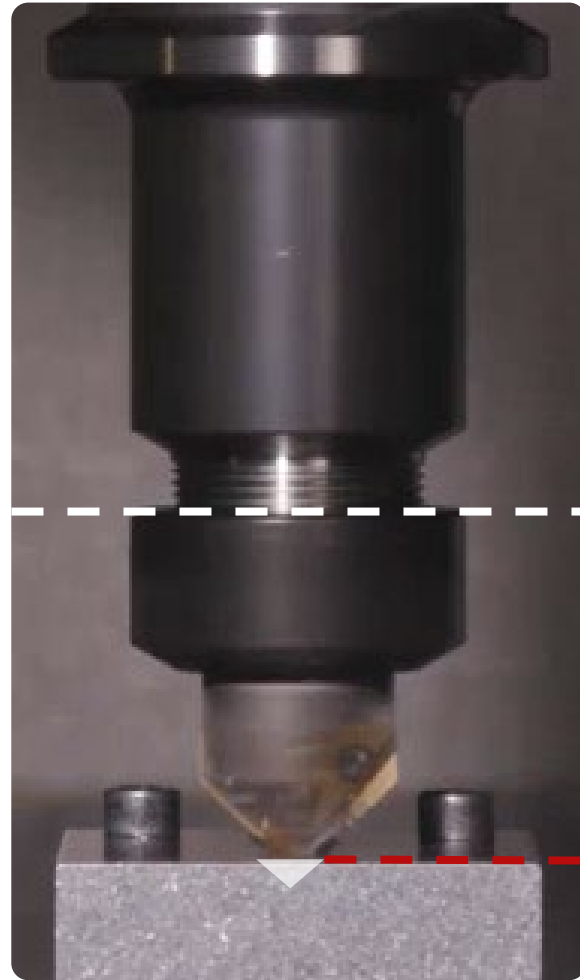


Drilling and Chamfering in
ONE OPERATION ?



**Drilling and
chamfering at
the same time**





Tool position

- Part tolerance -



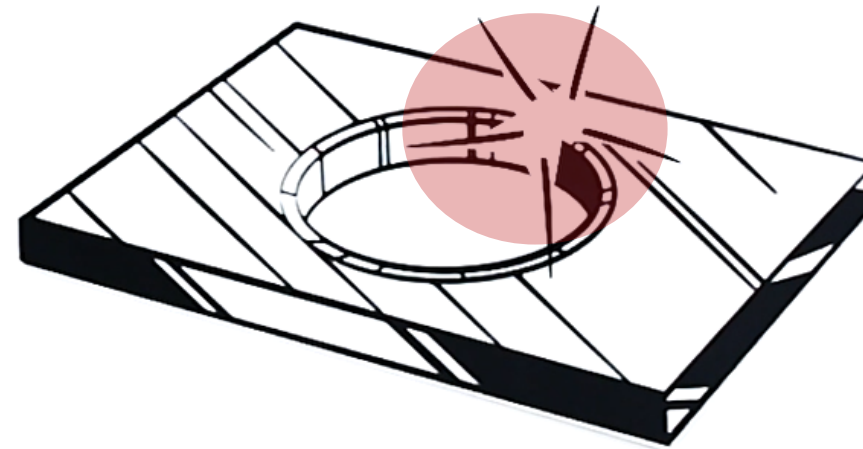
○ Countersink-Ø



○ Countersink-Ø

What if...

your drill can also do this?

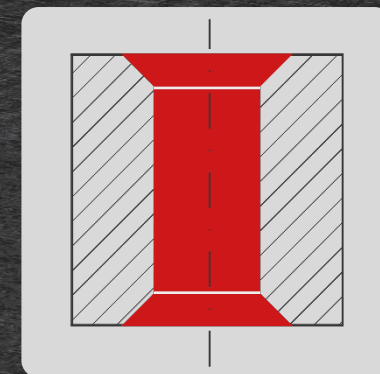
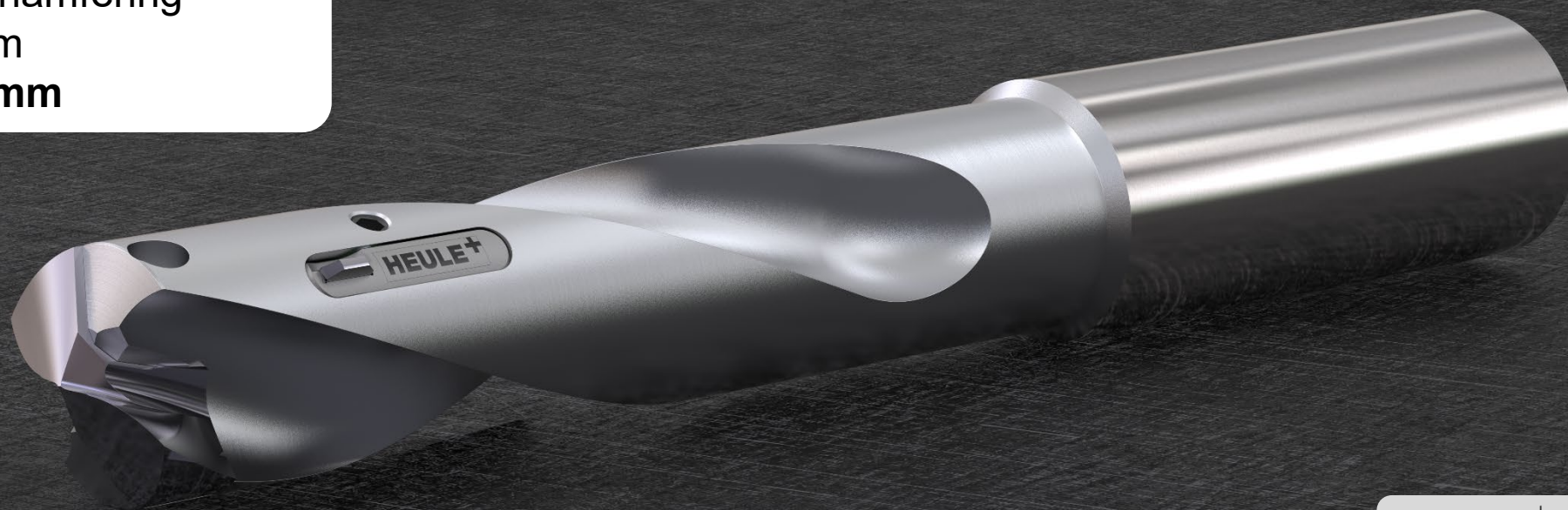


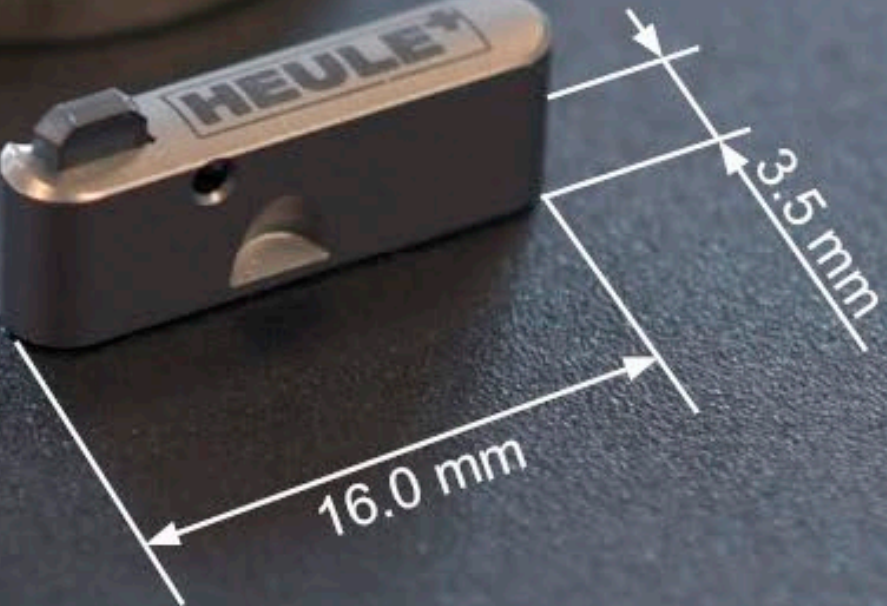
Your drill. Our chamfering module.
Your time-saving.

SNAP Module

Module Line

Drilling and Chamfering
combined from
bore-Ø 18.0 mm





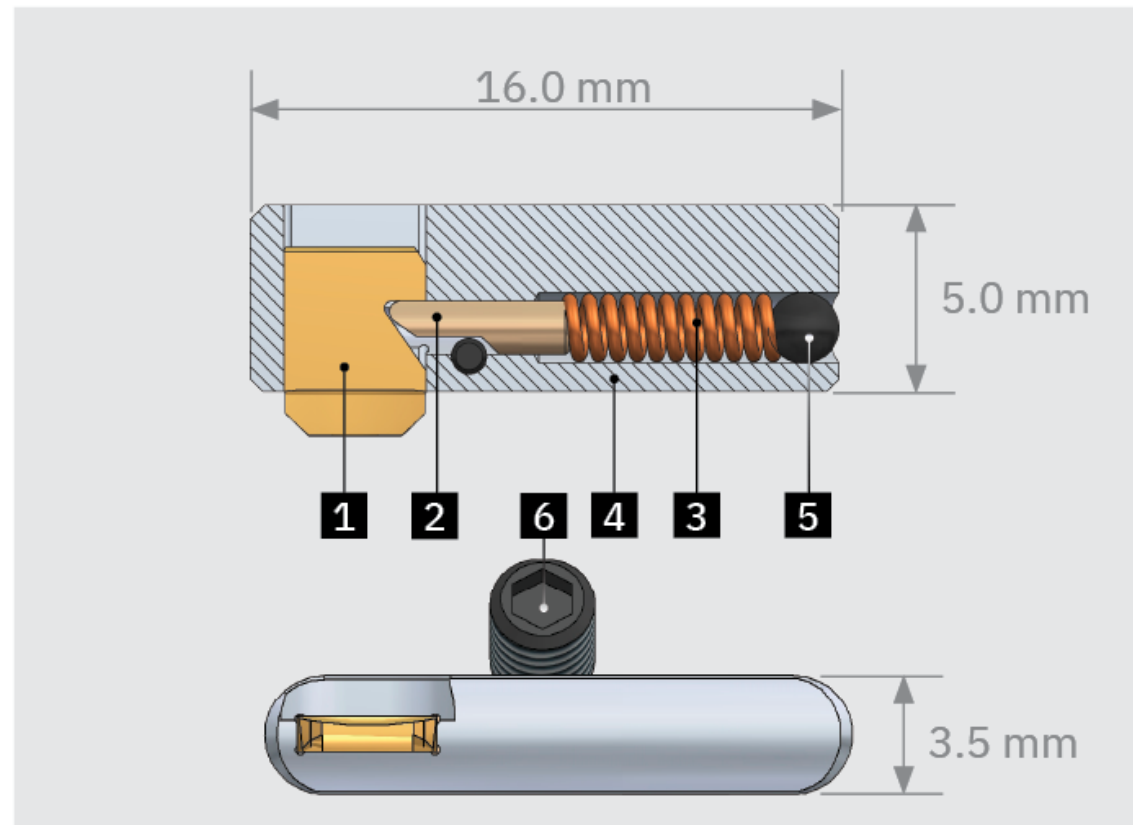


Position behind the drill tip:
approx. 25 mm

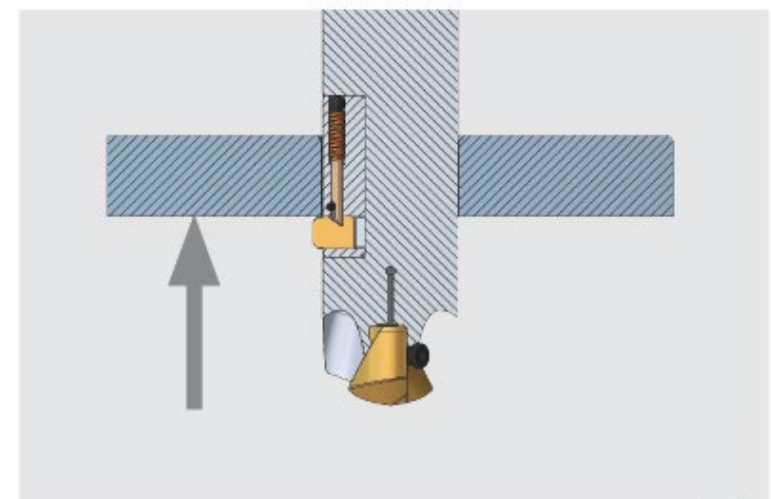
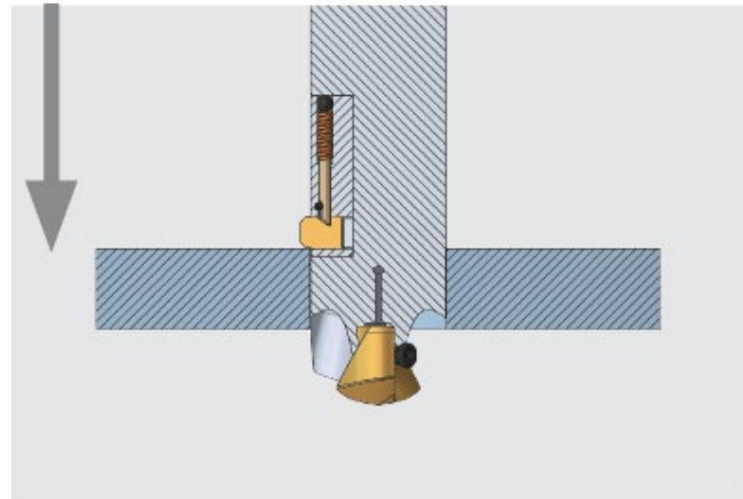
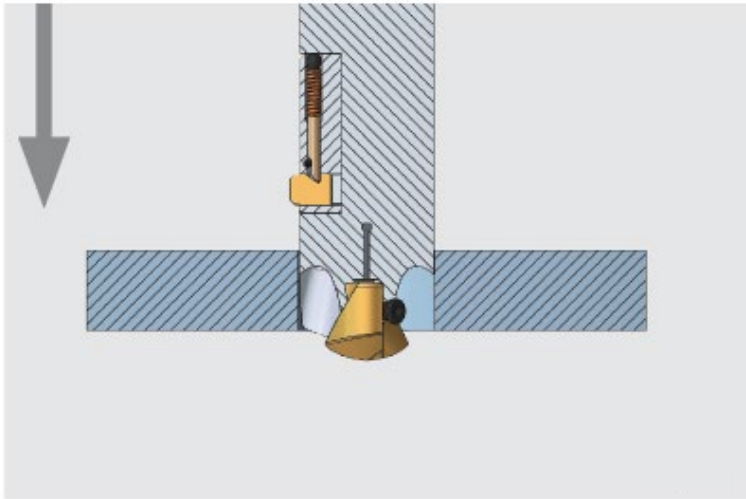
1 or 2 modules per drill body

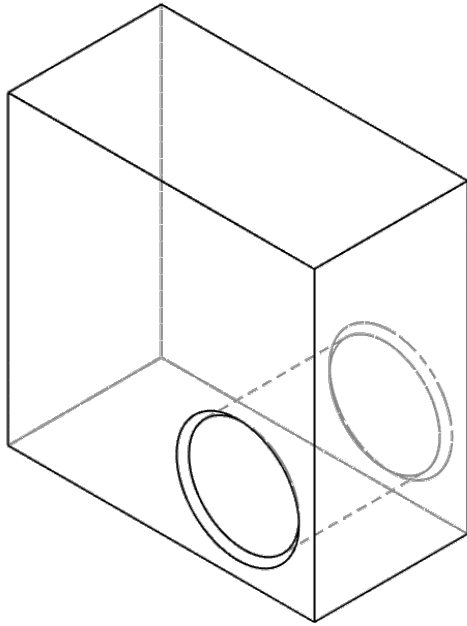
Drill body from bore-Ø 18.0 mm

Chamfer size from 0.5 to 1.0 mm



- 1** Blade
- 2** Control bolt
- 3** Pressure spring
- 4** Tool body
- 5** Locking bolt
- 6** Fixing screw

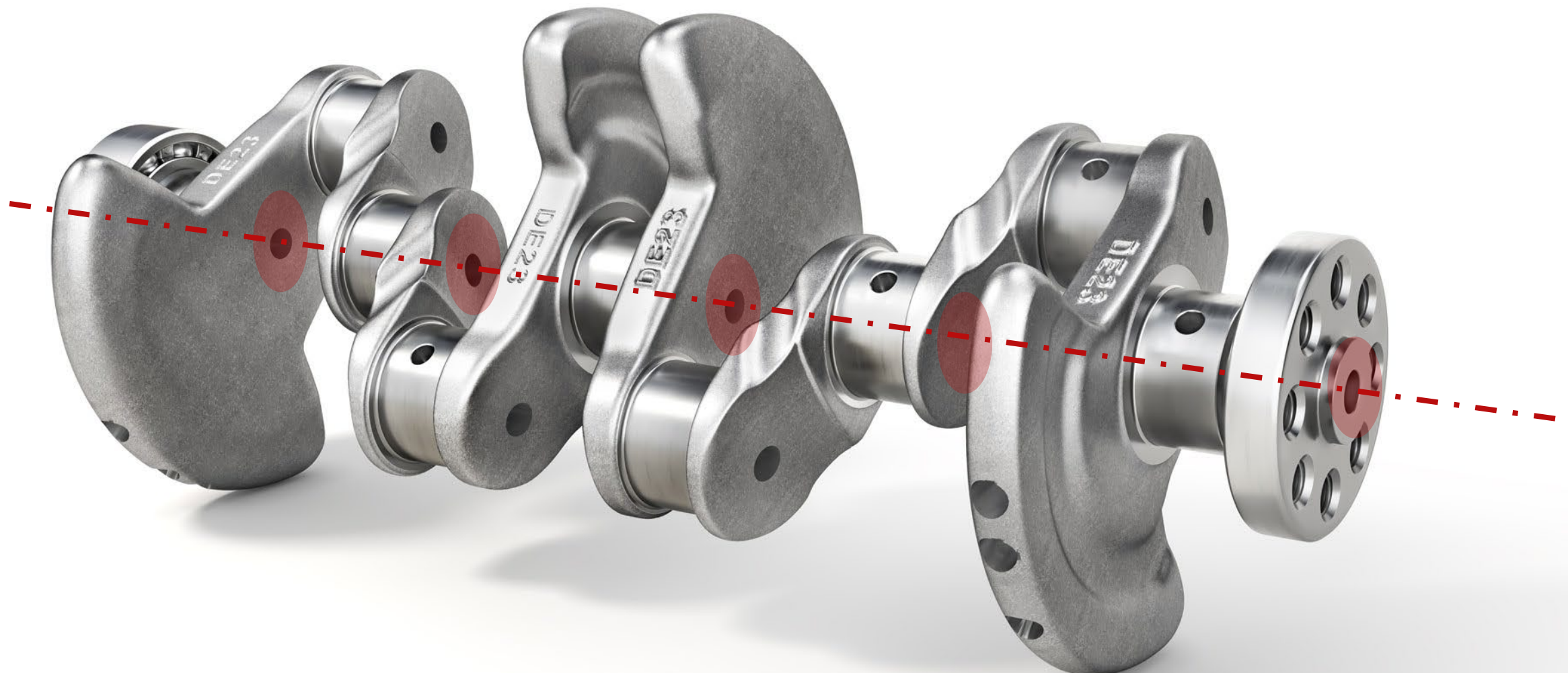




Bore-Ø: 18 mm
 Workpiece height: 15 mm

	Combi-Tool	Drilling + chamfering both sides	Drilling + countersinking + turn workpiece + countersinking
Drilling	4.03	4.03	4.03
Machining	5.96	6.78	5.08
Tool change	-	3.20	3.20
Turn workpiece	-	-	10.00
Total time	10.03	14.22	22.32

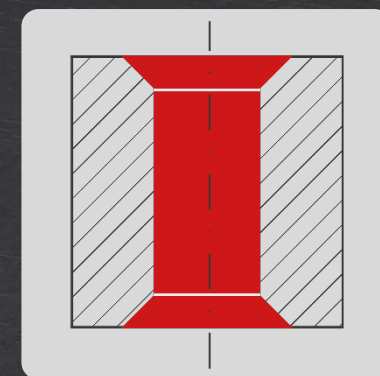
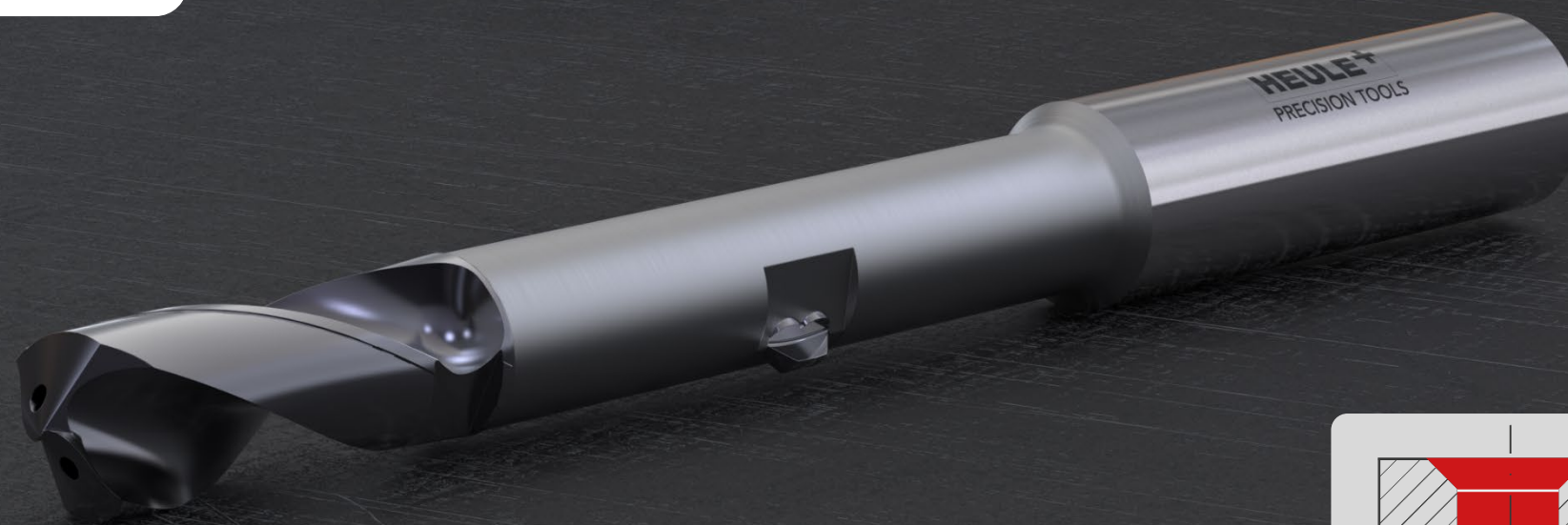
Parameter 2 Modules	drilling vc 80m/min, f0.25mm/rev. chamfering vc 50m/min, f0.25mm/rev.
Material	38MnVS6



But what if the bore is smaller?...

VEX

Drilling and Chamfering
combined from
bore-Ø 5.0 mm to 11.5 mm



Battery housing



Parameter	drilling 200m/min, f0.25mm/rev. chamfering 100m/min, f0.20mm/rev.
Material	Aluminium

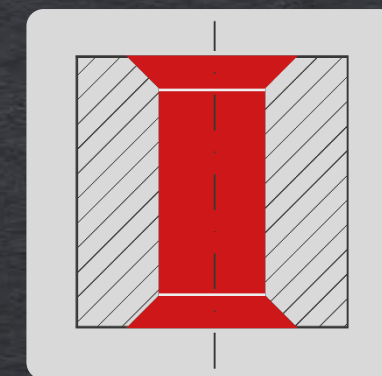
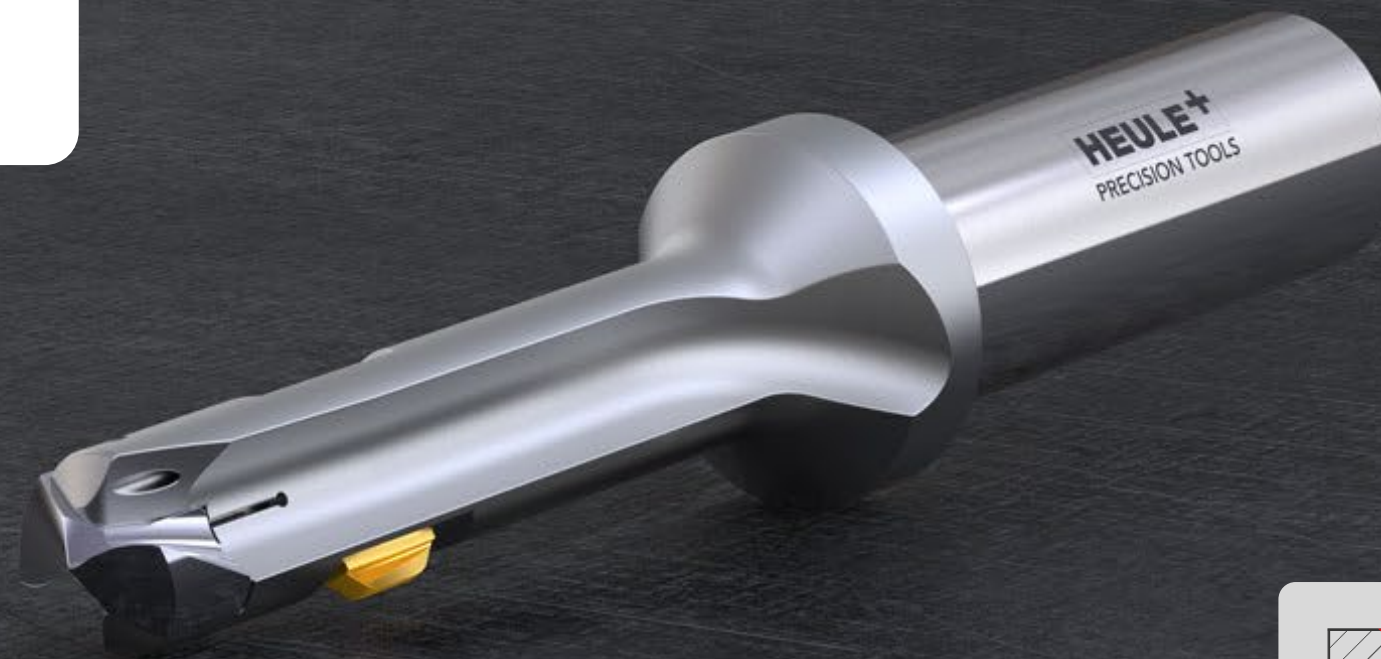
Flow meter

Bore	Ø6.0 mm
Chamfer	Backside 0.25 mm x 45°
Material	300-Serie, stainless steel
Parameter	drilling 40m/min, f0.10mm/rev. chamfering 20m/min, f0.10mm/rev.



VEX-P

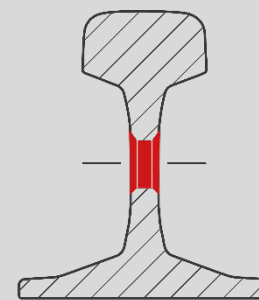
Drilling and Chamfering
combined from
bore-Ø 11.0 to 17.0 mm



DCT | Drill Combi Tool

Drilling and Chamfering
combined from
bore-Ø 16.5 mm to 36.0 mm

HEULE⁺
PRECISION TOOLS
GH-QS-0049 78012



HEULE as development partner





**Drilling and
chamfering at
the same time**



**Drilling and then
chamfering both
sides**



**Drilling,
countersinking,
turn workpiece,
countersinking**



A large, circular metal ring with a brushed metal finish is positioned in the center of the image. The ring is slightly offset, creating a white circular space in the middle. The background is a textured, grey surface.

**THANK YOU FOR
YOUR ATTENTION**

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