

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 g).
- 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).

Note: Other versions and sets for special applications (such as for thin sheet metal) available on request. **For suitable fluteless taps see items No. 139115 ff.**



08 2710

for thread M		M4	M5	M6	M8	M10	M12
04D 08 2710	Starter set standard	XXX	XXX	XXX	XXX	XXX	XXX
04D 08 2715	Starter set flat	XXX	XXX	XXX	XXX	XXX	XXX

for thread M		M5-M8	M6-M10	M5-M12
04D 08 2721	Flow drilling set - standard including fluteless taps	XXX	XXX	XXX
04D 08 2726	Flow drilling set - flat including fluteless taps	XXX	XXX	XXX

Content:
1 each flowdrill and fluteless tap



08 2721 / 2726_M5-M12

Flow drill / accessories

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

for thread M		M4	M5	M6	M8	M10	M12
04D 08 2730	Flow drill - standard (with collar)	XXX	XXX	XXX	XXX	XXX	XXX
04D 08 2735	Flow drill - flat (no collar)	XXX	XXX	XXX	XXX	XXX	XXX
Tapping hole Ø	mm	3.7	4.5	5.4	7.3	9.2	10.9
Shank Ø	mm	6	6	6	8	10	12
maximum material thickness (08 2730)	mm	2.6	2.7	2.9	3.3	3.7	4
maximum material thickness (08 2735)	mm	4.2	4.6	5	5.9	6.6	7.2
recommended drive power	kW	0.7	0.8	1	1.3	1.5	1.7
recommended speed	rpm	2600	2500	2400	2200	2000	1800

Contents in l or kg		1
04D 08 2741	Parting agent	XXX
04D 08 2742	Thread forming oil	XXX



08 2730



08 2730



08 2735



08 2735

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.

Note: 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.**

for thread M		M4	M5	M6	M8	M10
04D 08 2745	Flow drilling set for aluminium, AluDrill special	XXX	XXX	XXX	XXX	XXX
Tapping hole Ø	mm	3.6	4.3	5.2	7.1	9
Shank Ø	mm	8	10	10	12	14
maximum material thickness	mm	3.5	4	5	5.5	6
recommended drive power	kW	1.5	1.5	1.5	2	2
recommended speed	rpm	4000 - 8000				



08 2745