

VÖLKEL

THREADING SOLUTIONS

Hello,

in this issue, it's all about speed, technology and the right tool for applications where every detail matters.

We look back at **Team VÖLKEL's first DHLM outing** with the Mercedes 500 SEC on the Nürburgring Nordschleife. We also show you how to recognize **left-hand threads**, where they are used and which details make the difference when cutting them properly. Finally, we introduce the **LÖHER L29**, a special drill for clean, crack-free holes in Plexiglas and other plastics.

Through the Green Hell in the Mercedes 500 SEC



Three hours at the Nürburgring, around 90 corners per lap, changeable Eifel weather and a packed 24-hour race weekend: for Team VÖLKEL, the first major outing with the Mercedes-Benz 500 SEC was a real test right from the start.

On 14 and 15 May, the team headed to the Nordschleife for the second round of the German Historic Endurance Championship. Jörg Sand and Markus Horn started with number 500 in a setting that could hardly have been bigger: the ADAC RAVENOL 24h Nürburgring, a full paddock and around 350,000 visitors.

Despite technical challenges, the SEC showed that the basic package is right. Especially in the rain, the team gained valuable experience, built confidence in the car and was able to make up several positions. In the end, the result was 11 completed laps, 109th place overall and the class win in class 32.

It was not a perfect race. But that was not the point. The first DHLM race with the 500 SEC showed where the car stands, where further development is needed and how much potential there is in this project.

👉 [Learn more](#)

Left-Hand Threads: How to Recognize Them and Cut Them Correctly



Left-hand threads are much less common in practice than standard right-hand threads. That is exactly why they often cause uncertainty in workshops, maintenance and assembly. The principle itself is simple: a left-hand thread is tightened counterclockwise and loosened clockwise.

The key is to identify the thread direction in time. Indicators include the “LH” marking, the flank direction or the application itself. Left-hand threads are often used where a standard right-hand thread could loosen itself due to rotation, for

example on rotating components, certain clamping and adjustment elements or gas cylinder fittings.

When cutting, clean preparation, the right tool and the correct direction of rotation are essential: left-hand threads are always cut counterclockwise.

If you would like to dive deeper into the topic, you will find more details on identifying, using and correctly cutting left-hand threads in the full blog article.

👉 [Learn more](#)

LÖHER L29: The Specialist for Plexiglas and Plastics



Drilling plastics cleanly is more demanding than it may seem at first. Especially with brittle materials such as acrylic glass or Plexiglas, it is not just about drilling a hole. What matters is that the hole is accurate, clean and as crack-free as possible.

That is exactly what the LÖHER L29 according to DIN 338 type HK was developed for. The drill combines the helix angle of a type H drill, from 12° to 15°, with particularly wide flutes. This allows a larger chip volume to be accommodated, which is an important factor for clean results when drilling plastics.

The special 80° point geometry and Form B web thinning with corrected main cutting edge make the profile-ground HK drill especially suitable for brittle plastics such as acrylic glass and Plexiglas. This drill type is also a suitable choice for hard rubber, Bakelite, Pertinax, hard paper and rigid PVC.

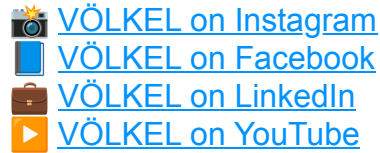
Our recommendation for drilling acrylic glass: from a material thickness of 5 mm, cooling should be carried out with an acrylic-compatible coolant lubricant. For deep holes, it may be advantageous to work only with drilling oil. Thin sheets should also be clamped together with a firm, flat backing material to prevent the lower hole edge from breaking out.

 [Request now](#)

You can also find more information about cobit and LÖHER on [LinkedIn](#).

We hope you enjoyed this mix of racing, thread technology and special tools.

As usual, you can find more insights, applications and news about VÖLKEL on our social media channels:



See you next time,
Your VÖLKEL Team

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