



Hello,

In this issue, we have once again put together three topics for you that show what VÖLKEŁ stands for: established expertise, technical know-how, and practical solutions for everyday work.

We begin with a collaboration that is a great fit not only professionally, but also regionally. **VÖLKEŁ and FLOTT**, two long-established companies from Remscheid, are combining their expertise and rethinking the process from drilling to the finished thread in an even more practical way. We also show **what really matters when cutting external threads with a die**. And finally, we take a look at a question that comes up time and again in practice: **which twist drill is actually the right one?**

VÖLKEŁ x FLOTT: Precision From Remscheid



When two traditional companies from the toolmaking capital of Remscheid work together, the result is a solution with real practical value. VÖLKEL and FLOTT combine their strengths in metalworking to create a coordinated interaction between machine, drill, and threading tool.

Selected FLOTT machines already come with a matching VÖLKEL precision package, including GRÜNRING machine taps from M4 to M8 as well as matching LÖHER core hole drills. The result is a well-designed solution that makes work noticeably easier for users.

👉 [Learn more](#)

Cutting Clean External Threads With a Die



At first glance, cutting external threads may seem simple, but in practice, the right preparation is what matters most. The key factors are the correct workpiece diameter, a clean chamfer, a straight start, and sufficient lubrication. These are exactly the points where mistakes often occur.

Choosing the right tool is also important. Round dies are the classic solution for cutting new external threads, while hex dies can be useful for reworking or repair. For demanding materials such as stainless steel, HSSE versions are often the better choice. This is how precise and durable results are achieved.

👉 [Learn more](#)

Choosing the Right Drill

N



W



H



Choosing the right drill does not depend on the material alone. Shape, grind, helix angle, point angle, and the drill material itself also play an important role. According to DIN 1836, twist drills are generally divided into types N, H, and W. Type N is suitable for standard-hard materials such as structural steels, cast iron, or non-ferrous metals. Type H is designed for hard and brittle materials such as stainless steel, brass, or Plexiglas. Type W is mainly used for soft materials such as aluminum, copper, or PVC.

The drill material itself also makes a difference. HSS is the classic all-rounder for many standard applications. HSSE contains additional alloying elements, often cobalt, and is especially suitable for difficult-to-machine materials. The same applies to the point angle: hard materials generally require larger angles, while softer materials require smaller ones. Only when these factors match will you achieve a clean drilling result.

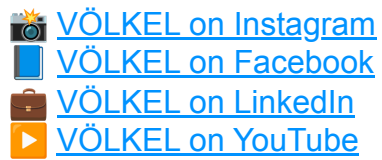
Not sure which drill is the right choice for your application? Then get in touch with us now.

👉 [Request now](#)

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

We hope this newsletter has once again given you some interesting insights.

If you would like to discover more about VÖLKEL, you can regularly find applications, updates, and further impressions on our social media channels:



See you next time,
Your VÖLKELE Team

Imprint

VÖLKELE GmbH
Morsbachtalstr. 20, 42855 Remscheid, Germany

Executive Board: Daniel Völkel, Peter Völkel, Sarah Joa-Völkel
Headquarter: Remscheid
Registered at Wuppertal, HRB 11462

Tel. +49 2191 490112
Fax +49 2191 490125
E-Mail info@voelkel.com
www.voelkel.com



© 2026 VÖLKELE GmbH