

VÖLKEĻ

THREADING SOLUTIONS ■ ■ ■

VÖLKEĻ Summer Party, over 50,000 threads in a practical test and a drill with two fully functional tips: in this issue, team spirit, application practice and tool technology come together.

We look back on a summer party with many familiar faces, good conversations and a true VÖLKEĻ feeling. Then we show you how more than 50,000 threads can be achieved in thread forming instead of the expected 30,000. And finally, we introduce the L80 Double LÖHER, which offers greater efficiency in sheet metal processing thanks to two usable drill tips.

VÖLKEĻ Summer Party: A Day for the Team, Families and Friends



Some days show particularly well what a company is all about. Our 2026 summer party was one of those days.

At the VÖLKELE summer party, employees, families and friends came together on the company premises. With games, good food, cold drinks, a bouncy castle, an ice cream van and many conversations, it became a day that clearly showed something that is often taken for granted in everyday working life: VÖLKELE is shaped by the people who work here.

Between the ice cream van, games and many conversations, it also became clear what 111 years of VÖLKELE mean: experience, team spirit and people who carry the company forward.

Of course, a few technical highlights were also part of the day: the VÖLKELE Dakar G-Class and the Mercedes SEC 500 quickly became popular meeting points for photos, questions and conversations.

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Praxistest Gewindeformen: Wie aus 30.000 plötzlich über 50.000 Gewinde wurden



30,000 threads were planned. More than 50,000 were achieved. That is exactly why it is worth taking a closer look at the details.

The practical case shows that long tool life is no coincidence, but the result of precise coordination. In thread forming, the tool alone is not the only decisive factor. What matters is the interaction between material, core hole diameter, tool geometry, coating, lubrication, cutting speed and machine environment.

The material machined was ADC12 die-cast aluminium. An M6 thread former with lubrication grooves and TiCN coating was used. Thanks to the correct coordination of all process parameters, the tool life was increased significantly beyond the original expectation.

This is exactly where theory and practice differ. If the core hole is too small, forming forces increase. If it is too large, thread quality suffers. If the right lubrication is missing, friction, temperature and wear increase. But when all factors are properly aligned, thread forming becomes particularly process-reliable and economical.

This practical case is also relevant for specialist retailers: if customers have questions about tool life, process reliability or tool selection, our application engineering team can review the existing setup and point out targeted optimization opportunities.

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The article uses a real practical case to show what really matters in thread forming and why technical know-how in the application often makes the decisive difference.

👉 [Learn more](#)

Drill Twice, Work Longer: The L80 Double LÖHER



In sheet metal processing, precision, time savings and cost-effectiveness matter. That is exactly what the L80 Double LÖHER was developed for.

This special drill has two fully functional drill tips in one tool body. When one side becomes dull, you simply turn the drill around and continue working right away. This saves time, reduces interruptions and ensures significantly more efficient use of the tool.

The L80 Double LÖHER shows its strengths especially when working with sheet metal and blind rivet holes:

The short flute provides high stability and reduces the risk of catching when breaking through the material. The extremely small chisel edge enables clean spot drilling without wandering. At the same time, the optimized cutting edge design reduces axial pressure and makes daily work noticeably easier.

The tool is also economically convincing: two cutting tips mean twice the usable life, reduced tool demand and lower storage costs. In short: a special drill that is particularly worthwhile wherever many precise holes are required in sheet metal or for blind rivets.

The L80 Double LÖHER is available directly from stock in sizes from 1.5 mm to 10 mm. Particularly popular are the precise rivet hole diameters 2.5 mm, 3.1 mm, 4.1 mm, 4.9 mm, 5.1 mm, 6.1 mm and 6.5 mm.

👉 [Request Now](#)

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



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Are you a specialist retailer and want to process your orders with VÖLKEL quickly and efficiently? Register now!

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That was our current selection from team, technology and application practice.

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Until next time
Your VÖLKEL 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



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