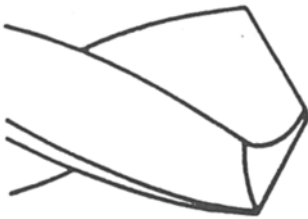




# ACE

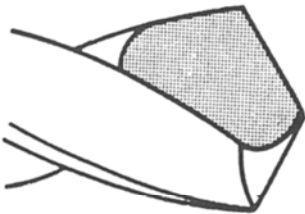
technical reference

## WEB THINNING OF TWIST DRILLS



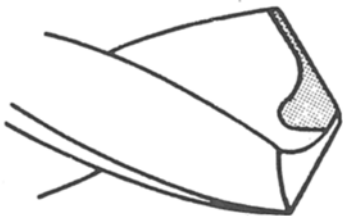
### CONVENTIONAL POINT

Drill webs need no thinning as received from the manufacturer.



### CONVENTIONAL TYPE WEB THINNING

Stock is removed in such a way as to follow the flute contour.



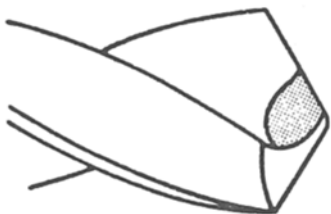
### FLATTED LIP TYPE WEB THINNING

The web is thinned by flattening the face of the flute. This type of thinning also eliminates drill "hogging-in".



### SPLIT POINT TYPE WEB THINNING

This thinning is accomplished by two secondary back-off grinds adjacent to the chisel and almost to center.



### GASH TYPE WEB THINNING

This thinning is accomplished by grinding two half-round gashes near the center of the drill, thus reducing the web.