

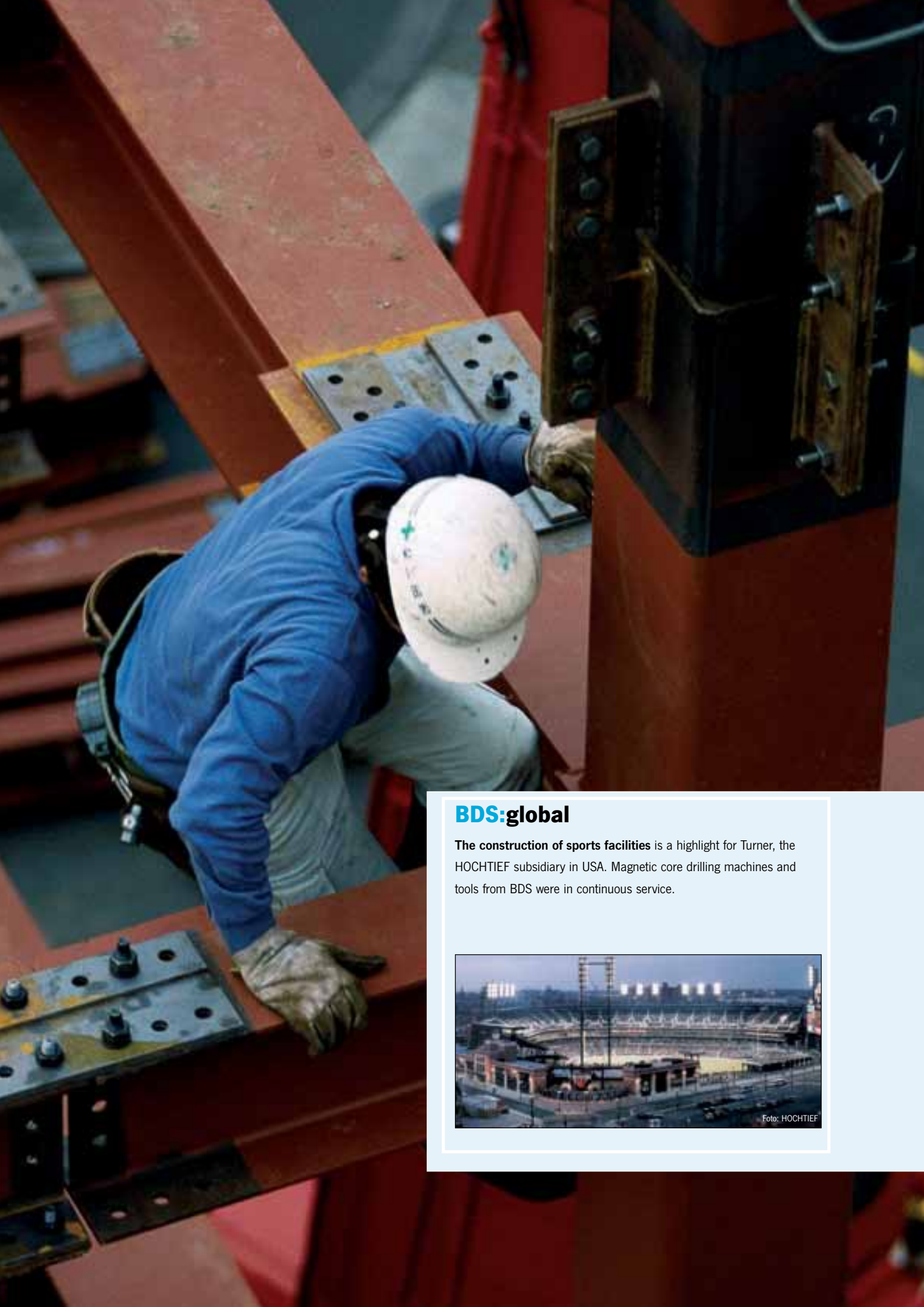
BDS:portal

Magnetic Core Drilling Technology · Chamfering Technology
Innovative technique, competent information

NEW

MAB Magnetic Core
Drilling Machines
Core Drills and
Accessories





BDS:global

The construction of sports facilities is a highlight for Turner, the HOCHTIEF subsidiary in USA. Magnetic core drilling machines and tools from BDS were in continuous service.



Foto: HOCHTIEF

BDS Maschinen develops and produces a wide programme of magnetic-core drilling machines, core drills and accessories at the company location in Mönchengladbach.

Since its foundation in 1989, the company has established itself world-wide as a successful specialist in the core drilling metalworking market. Its position in the premium segment is again and again proved by the high innovation power and the high quality of BDS products.

The specialization in the international market is pushed forward by BDS machines with high priority.

Many new products in the range of magnetic-core drilling machines and core drilling tools are introduced by the publication of the new BDS catalogue, they have been developed and tuned to international market and industry requirements.

The catalogue is intended to inform you about the variety of new functions and options of BDS products – for better working results world-wide.



1.1

1.2

1.3

2.1

my:BDS

Always well informed with BDS. Professional information and back-ground knowledge concerning Magnetic Core Drilling Technology.



>> bds-maschinen.de



BDS:power

MAB 825/845 – the next generation. Ideally suited for reaming, countersinking, thread cutting and twist drilling.

>> more on page 28



BDS:design

Keyless go! The BDS quick-change drill chuck – high functionality, consequent product design!

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BDS:edition

The BDS Starter Kit – the basic equipment for each magnetic core drilling machine by BDS.

With a clear price advantage!

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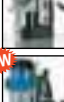







BDS
STARTER KIT
PRICE
ADVANTAGE
NEW








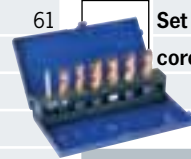






Where do I find... ?

The entire program at a glance.

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1.1



1.2



1.3



2.1

BDS:profi


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For site installation, workshop and production.


BDS magnetic core drilling technology – competent, innovative and leading!


1.1 Magnetic Core Drilling Machines Rail Drilling Machines


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BDS sets new standards...

Product innovations and creative progresses



The universal machine.

MAB 825/845 – With the magnetic core drilling machine of the 2nd generation, BDS creates new benchmarks concerning performance, working safety and design.

[>> more on page 28](#)



For tight situations.

The new compact BDS magnetic core drilling machine **MAB 150**. Developed for applications under difficult space conditions. If necessary, the advancing lever can be replugged step by step, it can be used on the left or on the right side of the machine. Also available with advancing ratchet mechanism

[>> more on page 16](#)



Full power - with compressed air.

AirMAB – the new powerful magnetic core drilling machine with pneumatic drive. For all special applications expecting high core drilling capacity without current supply.

[>> more on page 34](#)



The best solution for each industry.

Magnetic core drilling machines by BDS

Drilling applications in the most diverse areas such as steel building construction, bridge building construction, crane construction, railway building and mining industry, mechanical construction and specialized workshops stand for different requirements.

Today, BDS offers solutions for any assembly work on the construction site or in the workshop. The summary shows the major applications of the MAB and MABasic series, user-oriented and well-designed to the smallest detail.

Drilling with BDS magnetic core drilling machines yields optimal drilling results in much shorter time, accompanied by considerable reduction of costs.

- ▶ Substantially lower expenditure of force during drilling
- ▶ Noticeably reduced power consumption – saving energy
- ▶ Faster drilling – less time needed for the same drilling results
- ▶ No pilot-drilling and retooling of the machine: Thus, the machining time is reduced by 30 - 40%.



Foto: Stadt Gelsenkirchen

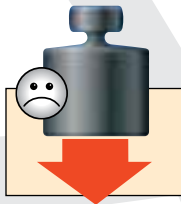


The true German power!

BDS magnetic core drilling technology made in Germany is successful all over the world. In Dubai just as on many building sites in Europe, Asia and America.



BBDS magnetic core drilling machines:



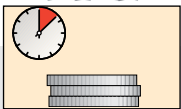
Working economically with magnetic core drilling machines by BDS.



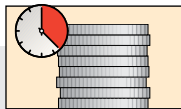
Low expenditure of force during drilling.



Much shorter machining time.



Saving time and money.



BDS machine in action at Times Square:
The HOCHTIEF subsidiary Turner has realized a 49 storey office building at the New York Times Square. The Times Square tower is expensively protected against vibrations, because it is surrounded by several subway tunnels.

Foto: HOCHTIEF

Rugged construction, sophisticated functionality.

Magnetic core drilling machines by BDS

BDS Core Drilling Machines are designed for continuous operation. Powerful, reliable motors are the guarantee for best drilling results under extreme circumstances.

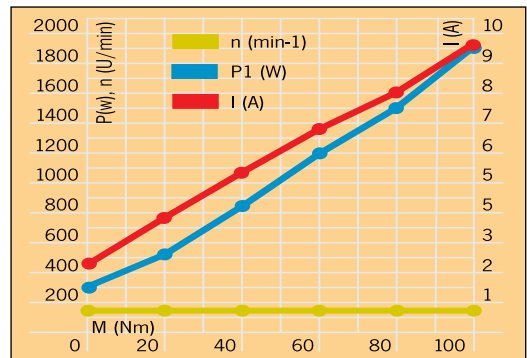
working conditions. BDS permanently develops new products and innovative solutions for the user.

The BDS concept: Innovative, convenient and cost-saving drilling solutions.

The compact design allows easy handling, high functionality and precision. All control elements are ergonomically located, i.e. they can be easily and quickly actuated with one hand, even under difficult



Quick tool change saves time and cost: Realized by the BDS Keyless quick-change drill system.



High work safety: Straightforward, ergonomic one-hand control with large, unmistakable control elements and emergency-off function.

High power at low speed: The full wave control electronics infinitely controls the motor output.

Power: Electronic torque control: Avoids damage to the tools and reduces costs due to intelligent technology for increased work safety.

Noticeable development of power and high reserve capacity: Strong and rugged motors with specially geared-down gear stages for the high power requirements of the magnetic core drilling technology.

Active safety.

Magnet indicator and concealed cable routing.

The maximum magnetic adhesion guarantees maximum safety for man, machine and tools.

BDS Magnetic Core Drilling Machines have a great reputation for the high magnetic adhesion of the MAB and MABasic series.

Like tyres and car, magnet and motor of the BDS Magnetic Core Drilling Machines form a unified whole which allows the full transfer of machine power into performance during work.

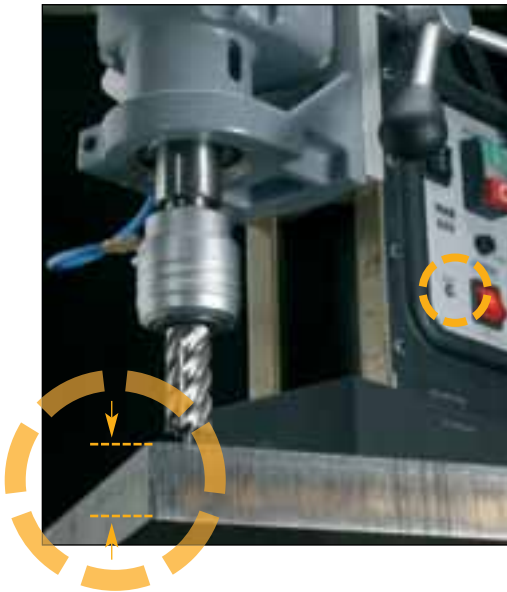
By means of permanent optimisation in accordance with the latest state of the art, the BDS Magnetic Core Drilling Technology also sets the standards concerning work safety.



LED green... the magnetic adhesion corresponds to the minimum requirements. Machining can take place.



LED red... the magnetic adhesion is not sufficient. Drilling should not take place since the material thickness is too small or the magnetic adhesion is reduced due to a coat of lacquer, scale or zinc.



BDS:profi

The advantages of integrated cable routing!

The new generation of the magnetic core drilling machines MAB has been developed in view of increased working safety. This includes the complete cable routing within the casing.

- ▶ no threading and getting caught
- ▶ no tearing or snapping off



MAB series	Width x length x height (mm)	Page
MAB 100	80 x 160 x 41,5 mm	14
MAB 150	80 x 160 x 41,5 mm	16
MAB 425	84 x 168 x 41,5 mm	18
MAB 455	84 x 168 x 41,5 mm	20
MAB 485	84 x 168 x 41,5 mm	22
MAB 500	100 x 200 x 51 mm	26
MAB 825/845	110 x 220 x 54 mm	28
MAB 1000	120 x 240 x 54 mm	32
AutoMAB 1500	90 x 180 x 48 mm	34
AutoMAB 2000	90 x 195 x 51 mm	36
AirMAB	80 x 210 x 90 mm	38

MAB series	Width x length x height (mm)	Page
MABasic 200	80 x 160 x 41,5 mm	40
MABasic 600	110 x 220 x 54 mm	40
MABasic 850	110 x 220 x 54 mm	41

Magnetic core drilling machines by BDS:

All features in comparison.



Type	MAB 100	MAB 150	MAB 425	MAB 455	MAB 485	MAB 500	MAB 825/845	MAB 1000
Tool holder	Direct arbor 19 mm Weldon	Direct arbor 19 mm Weldon	Direct arbor 19 mm Weldon	KEYLESS MK2 19 mm Weldon	KEYLESS MK2 19 mm Weldon	KEYLESS MK3 19 mm Weldon	KEYLESS MK3 32 mm Weldon	Direct arbor 32 mm Weldon
Morse taper MT				MK 2	MK 2	MK 3	MK 3	
Core drill short ø	ø 12 – 30 mm	ø 12 – 30 mm	ø 12 – 35 mm	ø 12 – 40 mm	ø 12 – 40 mm	ø 12 – 50 mm	ø 12 – 100 mm	ø 61 – 130 mm
Core drill long ø				ø 12 – 40 mm	ø 12 – 40 mm	ø 12 – 50 mm	ø 12 – 100 mm	ø 61 – 130 mm
Twist drill			ø 16 mm	ø 18 mm	ø 18 mm	ø 23 mm	ø 31,75 mm	
Thread cutting					M 16		M 30	
Counter- sinking					ø 40 mm	ø 50 mm	ø 50 mm	
Reaming					ø 18 mm	ø 23 mm	ø 31,75 mm	
Speed range 1	450	400	430	250	50 – 250	90 – 280	40 – 110	40 – 110
Speed range 2			760	450	100 – 450	180 – 580	65 – 175	65 – 175
Speed range 3							140 – 370	140 – 370
Speed range 4							220 – 600	220 – 600
Full wave con- trol electronics					✓	✓	✓	✓
CW/CCW operation					✓		✓	
Overheating protection					✓	✓	✓	✓
Safety friction clutch							✓	✓
Torque control						✓	✓	✓
Magnet size	80 x 160 x 41,5	80 x 160 x 41,5	84 x 168 x 41,5	84 x 168 x 41,5	84 x 168 x 41,5	100 x 200 x 51	110 x 220 x 54	120 x 240 x 54
Magnet indicator			✓	✓	✓	✓	✓	✓
Stroke	80 mm	39 mm	160 mm	160 mm	160 mm	150 mm	255 mm	85 mm
Weight	9,9 kg	11 kg	13 kg	13 kg	13 kg	19,5 kg	25 kg	36 kg



AirMAB	AutoMAB 1500	AutoMAB 2000	MABasic 200	MABasic 600	MABasic 850	RailMAB 900	RailMAB 960
Keyless 19 mm Weldon	Direct arbor 19 mm Weldon	Keyless 19 mm Weldon	Direct arbor 19 mm Weldon	–	–	ZIA MK2/ 19 mm Weldon	Direct arbor 19 mm Weldon
MK 2				MK 3	MK 3	MK 2	
∅ 12 – 35 mm	∅ 18 – 35 mm	∅ 14 – 40 mm	∅ 12 – 32 mm	∅ 12 – 50 mm		∅ 18 – 35 mm	∅ 18 – 35 mm
				∅ 12 – 50 mm			
∅ 23 mm				∅ 31,75 mm	∅ 31,75 mm		
						∅ 40 mm	
315	360	250	450	280	110	50 – 250	150 – 225
		450		580	175	100 – 450	
					245		
					385		
						✓	
						✓	
80 x 210 x 90	90 x 195 x 48	90 x 180 x 51	80 x 180 x 41,5	110 x 220 x 54	110 x 220 x 54		
	✓	✓	✓	✓	✓		
150 mm	77 mm	75 mm	150 mm	255 mm	255 mm	150 mm	40 mm
17,5 kg	17 kg	21 kg	12 kg	23 kg	25 kg	16 kg	21,5

Drilling of rails ✓

Diameter up to 130 mm ✓

Core drilling with compressed air ✓

Drilling without loss of power ✓

Allows thread cutting ✓

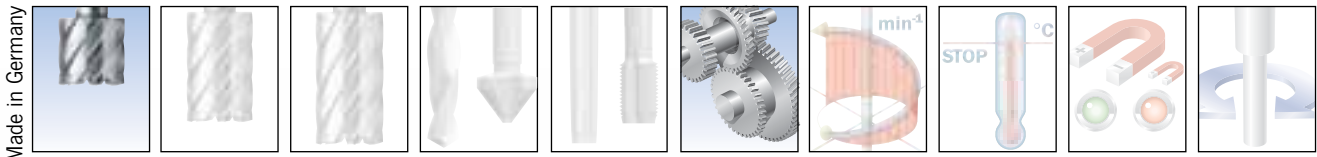
Saves motor and gear ✓

Saves the tool and saves costs ✓

Easy to handle and particularly mobile ✓

MAB 100

Compact, easy to handle and powerful.



Made in Germany

Core drill short,
30 mm
ø 12 – 30 mm

Speed range 1
450 min⁻¹

Magnetic core drilling machine MAB

100. The very compact casing and the low weight make the MAB 100 particularly suitable for all mobile applications and for work in cramped surroundings.

Power and Service Life

850 W motor and single-gear transmission for the high power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Safe, reliable function

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.



Optimum protection

Integrated cutting oil reservoir.
Complete cabling in the housing.

High safety

Confusion-free, correct ergonomic arrangement of switches for power and magnetic force.





MAB 100 Specification

Power:	800 Watt
Tool holder:	Direct arbor
Voltage:	230 V AC, 50-60 Hz
Stroke:	80 mm
Magnet size:	80 x 160 x 41,5 mm
Permanent internal lubrication:	•
Weight:	9,9 kg
Order No.	
MAB 100/ 230 Volt:	
MAB 100/ 110 Volt:	

MAB 100 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Ejector pin ZAK 075
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 4
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

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- Service** >> Page 46



BDS:profi

Working safely under high voltage!

Magnetic core drilling machines from BDS are in service on many unusual building sites. BDS technicians have accompanied the C-Team of Biberach/Riss for revision activities on pylons. Such assembling operations in vertiginous height and often at tough weather conditions demand a lot from man and technology. "We need machines that we can fully rely on. MAB 100 is one of them; it is light, very handy, and exactly as efficient as we need it."



BDS:edition

The new BDS STARTER KIT is the optimal basic equipment for all BDS magnetic core drilling machines.

- ▶ 1 Standard core drill box with 5 core drills with
 - 2 KBK each – ø 14 and 18 mm
 - 1 KBK – ø 22 mm
- ▶ 1l High-performance cutting oil BDS 5000
- ▶ 1 BDS Power-Worker

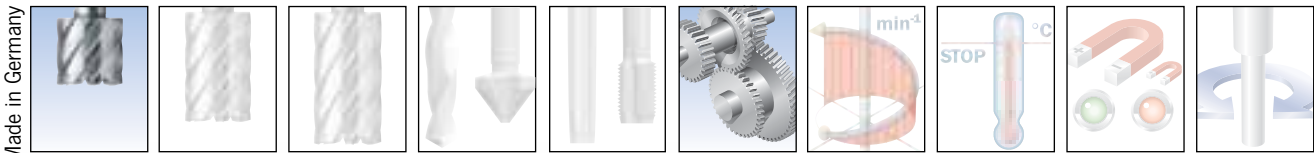
Order No.

ZST 100



MAB 150

With angular gear – drilling under cramped conditions



Made in Germany

Core drill short,
30 mm
ø 12 – 35 mm

Speed range 1
400 min⁻¹

The new MAB 150 is the ideal magnetic core drilling machine for work under cramped conditions.

The MAB 150 is optionally available in two versions, with replugable advancing mechanism or with advancing ratchet mechanism.



MAB 150 optional advancing ratchet mechanism – facilitates the work in cramped surroundings.



Variable conversion

The advancing lever can be changed from the right to the left side of the machine.

Dynamic

- 1080 W motor
- ▶ High power development
- ▶ One-stage gear
- ▶ Safe, reliable function

Easy to handle

With the ergonomic carry handle the MAB 150 is well balanced.



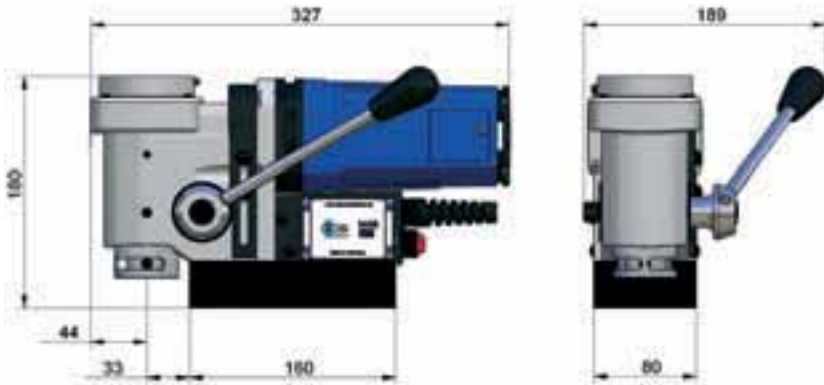
Active safety

The switches for Power and Magnetic Adhesion are arranged so that they cannot be mixed up.



Tool holder

Direct arbor for BDS core drills 19 mm Weldon shank (3/4") 30 mm cutting depth



MAB 150 – Specification

Power:	1080 Watt
Tool holder:	Direct arbor 19 mm Weldon (3/4")
Voltage:	230 V AC, 50-60 Hz
Stroke:	39 mm
Magnet size:	80 x 160 x 36,5 mm
Permanent internal lubrication:	•
Weight:	11 kg

Order No.

- MAB 150/ 230 Volt:
- MAB 150/ 110 Volt:
- MAB 150 with ratchet mechanism / 230 Volt:
- MAB 150 with ratchet mechanism/ 110 Volt:



MAB 150 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Ejector pin ZAK 075
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 4
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

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BDS:design

VarioPLUS: The next generation!

- ▶ Improved chip removal
- ▶ Longer service life
- ▶ More working safety >> Page 62

The pluggable advancing lever can be inserted on both sides of the machine without any problems.



Order No./Content

KBK-VP 001

- 2 VarioPLUS core drills each
- ø 14, 18, 22 mm
- 1 Ejector pin ZAK 075
- Robust metal box




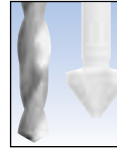

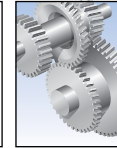
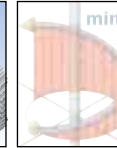
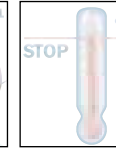

KBK-VP 002

- 1 VarioPLUS core drill each
- ø 13, 14, 17, 18, 21, 22 mm
- 1 Ejector pin ZAK 075
- Robust metal box

MAB 425

The BDS Classic – with high speed for sintered carbide core drills and twist drills.

Made in Germany

								
Core drill short, 30 mm ø 12 – 35 mm			Twist drill up to ø 16 mm	Speed range 1 430 min ⁻¹ Speed range 2: 760 min ⁻¹			Magnet indicator	

More power development

1050 W motor and two-stage gear for more power in the magnetic core drilling technology.

- ▶ High power development
- ▶ High speed of 760 m⁻¹ – ideal for twist drills and sintered carbide core drills
- ▶ Safe, reliable function



Straightforward change

Quick installation of drill chuck, optimized by the adapter ZAP 100.

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.



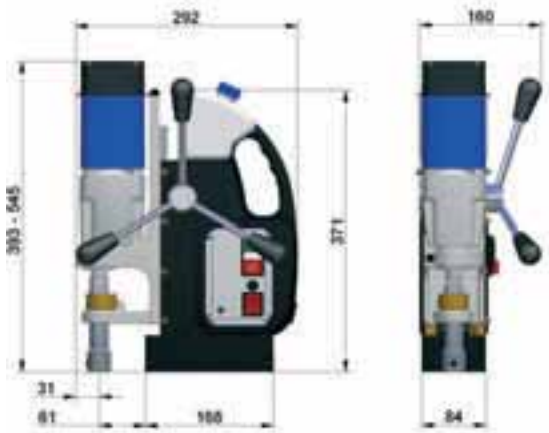
Optimal protection

Integrated cutting oil reservoir
Complete cable routing within the machine



High safety

Visual inspection of magnetic adhesion and unmistakable arrangement of switches for power and magnetic adhesion.



MAB 425 Specification:

Power:	1050 Watt
Tool holder:	Direct arbor 19 mm Weldon (3/4")
Voltage:	230 V AC, 50-60 Hz
Stroke:	160 mm
Magnet size:	84 x 168 x 41,5 mm
Permanent internal lubrication:	•
Weight:	13 kg
Order No.	

MAB 425/ 230 Volt:

MAB 425/ 110 Volt:

MAB 425 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Ejector pin ZAK 075
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 4
- 1 Operating manual
- 1 Warranty certificate

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BDS:advice

For vertical drilling or overhead work we recommend using high-performance grease spray. For increased working safety!

High performance lubrication spray BDS 5200



BDS:advice

Due to its special high-speed gear, machines of the MAB 425 series are particularly suitable for the use of BDS sintered carbide core drills of the HKK series.

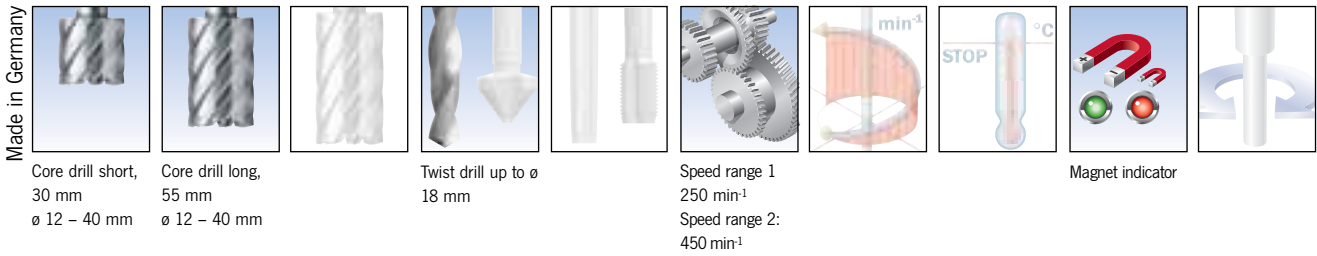
>> more on page 64 foll.



Order No.	Content
ZHS 400	1 x 400 ml
ZHS 406	6 x 400 ml
ZHS 412	12 x 400 ml

MAB 455

The powerful assembly machine. KEYLESS as standard.



More power generation

1150 W motor and two-gear transmission for more power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Two-stage oil bath gear
- ▶ Safe, reliable function

Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm (3/4")

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.

CE

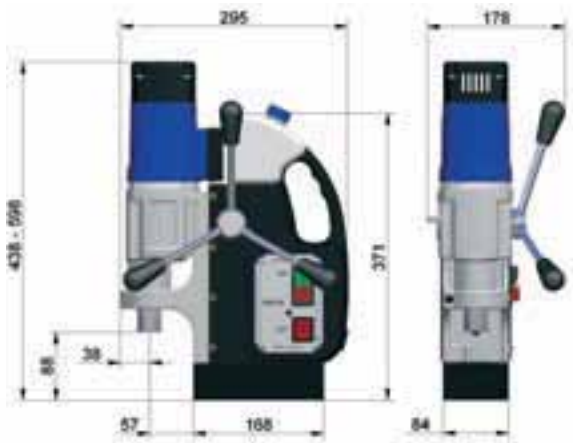
Optimum protection

Integrated cutting oil reservoir.
Complete cabling in the housing.

High safety

Visual inspection of magnetic adhesion and unmistakable arrangement of switches for power and magnetic adhesion.





MAB 455 Specification

Power:	1150 Watt
Morse taper:	MK 2
Voltage:	230 V AC, 50-60 Hz
Stroke:	160 mm
Magnet size:	84 x 168 x 41,5 mm
Permanent internal lubrication:	•
Weight:	13 kg

Order No.

MAB 455/ 230 Volt:

MAB 455/110 Volt:

MAB 455 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system
- KEYLESS Weldon 19 mm (3/4")
- 1 Ejector pin ZAK 075
- 1 Ejector pin ZAK 100
- 1 Steel carry case
- 1 Safety chain
- 1 Drill drift MT 2
- 1 Operating manual
- 1 Warranty certificate

Quicklinks




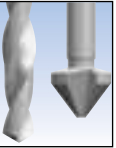
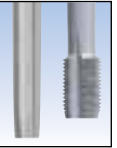
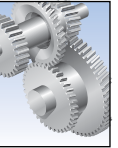

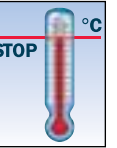



Core drills	>> Page 48
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MAB 485

The versatile workshop and assembly machine.

Made in Germany

											
Core drill short, 30 mm ø 12 - 40 mm	Core drill long, 55 mm ø 12 - 40 mm	Twist drill up to ø 18 mm Countersinking up to 40 mm	Reaming up to 18 mm Thread cutting M8 - M16	Speed range 1: 50 - 250 min ⁻¹ Speed range 2: 100 - 450 min ⁻¹	Full wave control electronics	Overheating pro- tection	Magnet indicator	CW/CCW opera- tion			

More power generation

1150 W motor and two-gear transmission for more power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Two-stage oil bath gear
- ▶ Safe, reliable function

Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm (3/4")

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.



Infinitely variable

The full wave control electronics varies the speed also infinitely.

Optimum protection

Integrated cutting oil reservoir. Complete cabling in the housing.

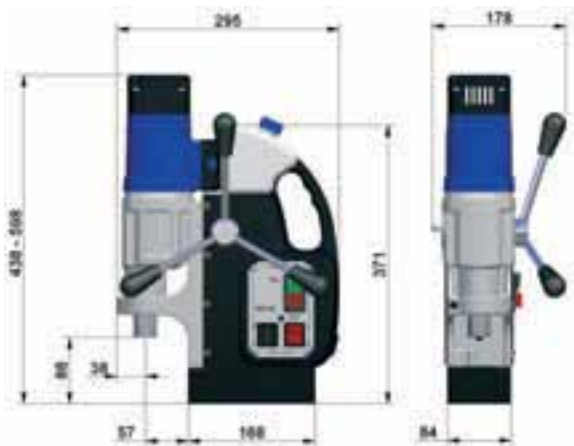
High safety

Visual inspection of magnetic adhesion and unmistakable arrangement of switches for power and magnetic adhesion.

CW/CCW operation

Tapping up to M16





MAB 485 Specification:

Power:	1150 Watt
Morse taper:	MK 2
Voltage:	230 V AC, 50-60 Hz
Stroke:	160 mm
Magnet size:	84 x 168 x 41,5 mm
Permanent internal lubrication:	•
Weight:	13 kg

Order No.

MAB 485/ 230 Volt:

MAB 485/ 110 Volt:

MAB 485 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system
KEYLESS Weldon 19 mm (3/4")
- 1 Ejector pin ZAK 075 + ZAK 100
- 1 Steel carry case
- 1 Safety chain
- 1 Drill drift MT 2
- 1 Gear rim drill chuck
- 1 Morse taper MT 2/B16
- 1 Adapter for tap M10/M12/M16
- 1 Operating manual
- 1 Warranty certificate

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BDS:design

Shape follows function!

The new generation of MAB core drilling machines can also be recognized by details, e.g. by the new design of the coolant reservoir. The reservoir is now fully integrated in the machine pillar.



Damages are prevented because there are no protruding corners and edges.

The BDS Design is a step towards more working safety.

MAB 485 – flexible applications.

The small all-round machine for all types of materials and applications. Various clamping devices allow for use with stainless steel and nonferrous metals.

For applications which cannot be mastered with magnetic force alone, BDS has developed clamping devices, which can be used on

- ▶ channelled plates
- ▶ nonferrous metals
- ▶ tubes

With our vacuum clamping devices, a circular oil lubrication of the vacuum pump guarantees permanent safety.

If maintained at regular intervals, lubricants or small dirt particles cannot cause any damage.

Tube clamping devices with tension chains guarantee best adhesion. Swivelling V-blocks ensure a positive joining with the tube.

Special sizes for larger tube diameters can be delivered on request.



Vacuum plate for channelled plates: ZAV 300



Vacuum plate for smooth surfaces: ZAV 400



BDS:profi

**Steel structure at top level:
Production of bridge components**

Bridge components of several tons weight are produced and pre-assembled in modular segments. Magnetic core drilling machines by BDS are in service nearly in each of these building phases, with high economic power and flexibility, based on the versatility of applications.



Tube clamping device



Drilling with core drills



Countersinking



Reaming



Thread cutting



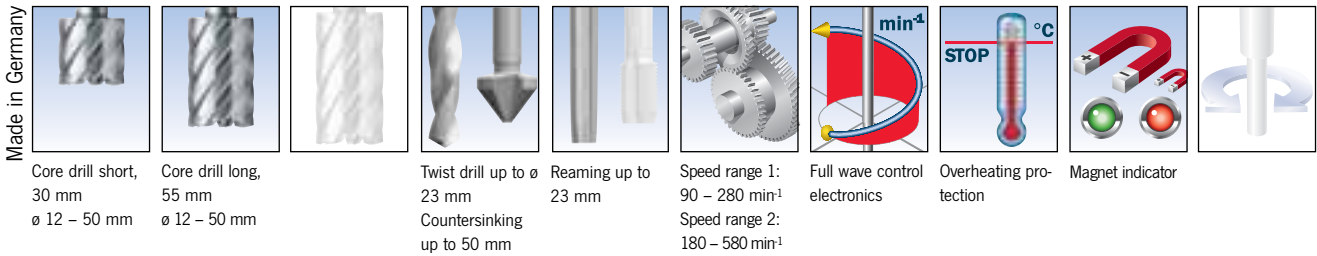
Thread cutting adapter with safety friction clutch



Drilling with twist drills

MAB 500

Rugged construction, with double pillar guide.



Made in Germany

Core drill short,
30 mm
ø 12 – 50 mm

Core drill long,
55 mm
ø 12 – 50 mm

Twist drill up to ø
23 mm
Countersinking
up to 50 mm

Reaming up to
23 mm

Speed range 1:
90 – 280 min⁻¹
Speed range 2:
180 – 580 min⁻¹

Full wave control
electronics

Overheating pro-
tection

Magnet indicator

Power and Service Life

1600 W motor and two-stage gear for the high power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Safe, reliable function

Infinitely variable

Torque control
Full wave control
electronics

Quick drill change

KEYLESS quick-change drill
chuck system for Weldon shank
19 mm (3/4")

Correct oil dosage

Automatic internal lubrication right to
the tip of the core drill.

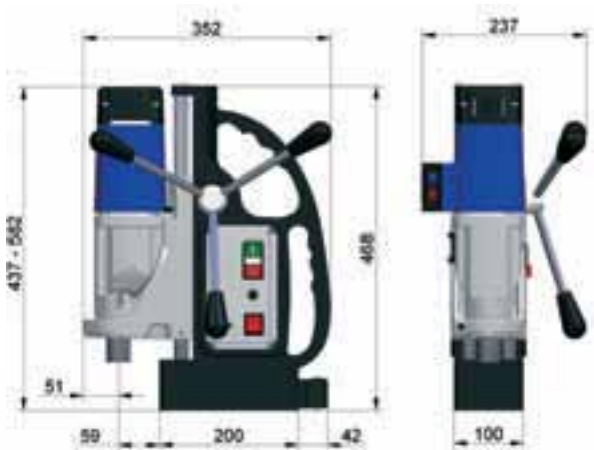


dual pillar guide

Safety for tough permanent
use in production

High safety

Confusion-free and correct
ergonomic arrangement of
switches for power and mag-
netic force.



MAB 500 Specification

Power:	1600 Watt
Morse taper:	MK 3
Voltage:	230 V AC, 50-60 Hz
Stroke:	150 mm
Magnet size:	100 x 200 x 51 mm
Permanent internal lubrication:	•
Weight:	19,5 kg

Order No.

MAB 500/ 230 Volt:

MAB 500/ 110 Volt:

MAB 500 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system
KEYLESS Weldon 19 mm (3/4")
- 1 Ejector pin ZAK 075
- 1 Ejector pin ZAK 100
- 1 Steel carry case
- 1 Safety chain
- 1 Drill drift MT 3
- 1 Operating manual
- 1 Warranty certificate

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BDS:global

**Construction of the Borussia
Mönchengladbach football stadium
– an easy job and a 'home game'
for BDS Maschinen!**

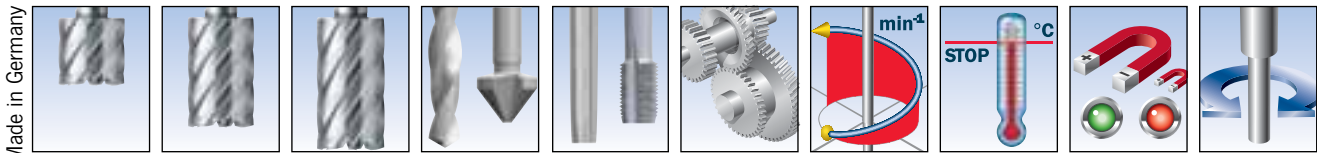
27,500 tons of steel, 7,500 joints for the roof of the stand.
Magnetic core drilling machines of the MAB 500 series and core drilling tools of BDS Maschinen have been applied



for the construction and the assembly of the supporting framework.

MAB 825/845

Developed for steel engineering, plant construction and mechanical engineering.



Made in Germany

- Core drill short, 30 mm
ø 12 - 100 mm
- Core drill long, 55 mm
ø 12 - 100 mm
- Core drill extra long, 110 mm
ø 20 - 50 mm
- Twist drill up to 31,75 mm
Countersinking up to 50 mm
- Reaming up to 31,75 mm
Thread cutting M30
- Speed range 1: 40 - 110 min⁻¹
Speed range 2: 65 - 175 min⁻¹
Speed range 3: 140 - 360 min⁻¹
Speed range 4: 220 - 600 min⁻¹
- Full wave control electronics
- Overheating protection
- Magnet indicator
- CW/CCW operation

Pure power generation

1800 W motor and four-stage gear for high power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Four-stage oil bath gear

Infinitely variable

- Torque control
- Full wave control electronics

Selectable

...with easy gear selection.

Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm (3/4")

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.

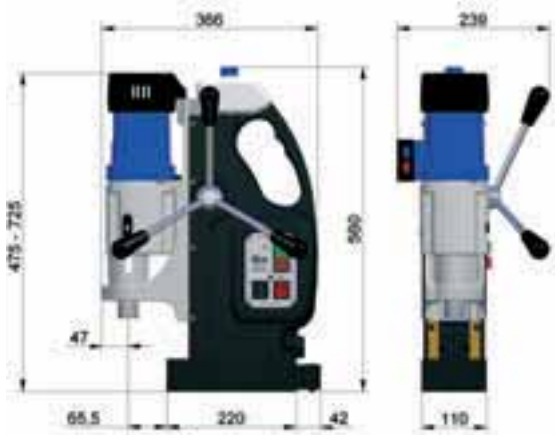


Optimum protection

Integrated cutting oil reservoir.
Complete cabling in the housing.

Active safety

Unmistakable arrangement of switches Power and Magnetic adhesion.
Visual indication of the magnetic adhesion.



MAB 825/ 845 Specification

Power:	1800 Watt
Morse taper:	MK 3
Voltage:	230 V AC, 50-60 Hz
Stroke:	255 mm
Magnet size:	110 x 220 x 54 mm
Permanent internal lubrication:	•
Weight:	25 kg

Order No.

MAB 825/ 230 Volt:

MAB 825/ 110 Volt:

MAB 845 Additional equipment:

Magnetic core drilling machine with rotating mechanism. Adjustable by 30° to both sides and longitudinal displacement by 20 mm

Order No.

MAB 845/ 230 Volt:

MAB 845/ 110 Volt:

MAB 825/845 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system
KEYLESS
- 1 Industrial arbor MT 3/
32 mm Weldon shank
- 1 Ejector pin ZAK 075
- 1 Ejector pin ZAK 090
- 1 Ejector pin ZAK 100
- 1 Ejector pin ZAK 120
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 6
- 1 Drill drift MT 3
- 1 Operating manual
- 1 Warranty certificate

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BDS:global

BDS magnetic core drilling machines are the first choice of many international shipbuilders. That comes down to the especially high drilling performance, the rugged construction and the extensive service. Performance counts!



MAB 825/845

The mainstay.

The MT3 tool holder allows the use of core drills, reamers, taps, countersinks and solid drills. Due to the extensive range of accessories, such as the vacuum clamping plate for non-magnetic surfaces or the tube clamping device, this machine is suitable for every kind of work.

The magnetic core drilling machine MAB 825 can be made even more flexible with the optional tube clamping device ZRO 500.

This clamping device guarantees best adhesion due to the tension chains and swivelling V-blocks. These V-blocks ensure a positive joining with the tube. The perfect machine for pipeline engineering.

Best application possibilities for repair work and special purpose mechanical engineering. Strong, powerful and flexible.

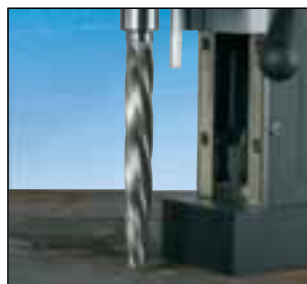
The machines of the MAB 845 series are provided with a rotating mechanism. The foot, which can be rotated by 30° to both sides, can be moved forward or backward by 20 mm. That means utmost flexibility for the positioning of the machine in use: Attach the machine, secure it by means of the magnet and then position it precisely. This allows drilling work directly next to walls of the material.



Drilling with core drills



Countersinking



Reaming



Thread cutting



Drilling with twist drills



MAB 845: The foot, which can be rotated by 30° to both sides, can be moved forward or backward by 20 mm.





BDS:profi

Core bores with large diameter



Vacuum clamping devices for non-ferrous metal with smooth surface, the optional accessory for MAB magnetic core drilling machines.

>> see Page 72



Vacuum clamping devices for non-ferrous metal with rough surface, the optional accessory for MAB magnetic core drilling machines.

>> see Page 72

Feed:

- Slow starting phase, 1-2 mm
- Feed 50%

Drilling:

- Lift the drill when running
- Remove chips, clean the borehole
- Fill the borehole with coolant
- Lower the drill when running
- Repeat several times, depending on the drilling depth

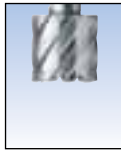
Lubrication:

- High-performance cutting oil BDS 5000
- Lubricate continuously
- Additionally lubricate from the outside >> Page 80

MAB 1000

The bundle of core drilling power.

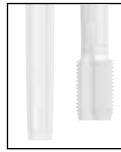
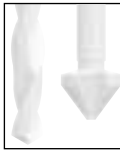
Made in Germany



Core drill short,
30 mm
ø 61 – 130 mm



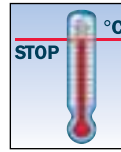
Core drill long,
55 mm
ø 61 – 100 mm



Speed range 1:
40 – 110 min⁻¹
Speed range 2:
65 – 175 min⁻¹
Speed range 3:
140 – 370 min⁻¹
Speed range 4:
220 – 600 min⁻¹



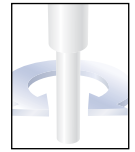
Full wave control
electronics



Overheating pro-
tection



Magnet indicator



Pure power generation

1800 W motor and four-stage gear for high power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Four-stage oil bath gear

Infinitely variable

Torque control
Full wave control electronics



Correct oil dosage

Automatic internal lubrication
right to the tip of the core drill.

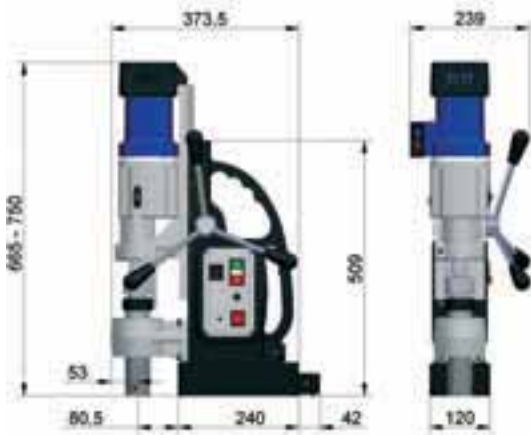


High safety

confusion-free arrangement
of switches for power
and magnetic force.

High safety

Optical control of
correct magnetic force



MAB 1000 Specification

Power:	1800 Watt
Tool holder:	Direct arbor
Voltage:	230 V AC, 50-60 Hz
Stroke:	85 mm
Magnet size:	120 x 240 x 54 mm
Permanent internal lubrication:	•
Weight:	36 kg

Order No.

MAB 1000/ 230 Volt:

MAB 1000 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 6
- 1 Drill drift MT 3
- 1 Operating manual
- 1 Warranty certificate

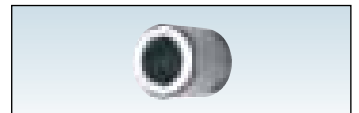
Quicklinks

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BDS:profi

Bushing

32 mm Weldon shank to
19 mm Weldon shank



Order No.

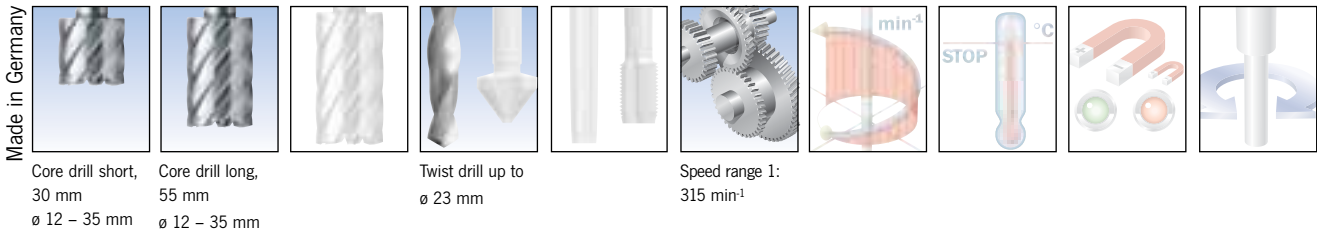
ZAP 200



Positioning and drilling with ease. Working without exertion. Each working position can be realized. The powerful magnet secures the machine and creates stable conditions during drilling.

AirMAB 5000

The magnetic core drilling machine with pneumatic drive.



For harsh conditions

Magnetic core drilling machine for the use under harder conditions:

Dirt, dust, humidity.

Heavy-duty rotating piston air motor, industrial version

- ▶ Output 800 W
- ▶ Torque 18 Nm
- ▶ completely made of stainless steel

Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm

($\frac{3}{4}$ "

- ▶ Kernbohrer bis \varnothing 35 mm
- ▶ Spiralbohrer bis \varnothing 23 mm
- ▶ Automatic internal lubrication right to the tip of the core drill.

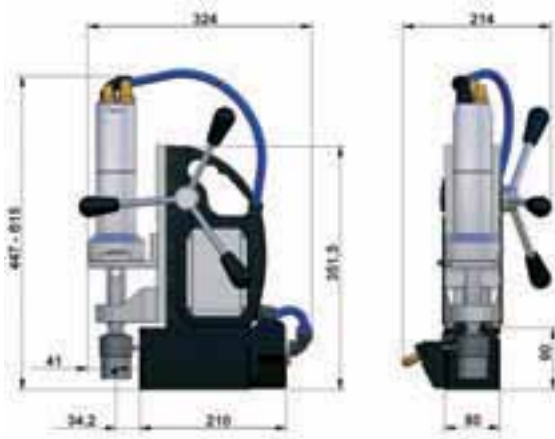


CE

High working safety

Permanent magnet operated by compressed air with centrally arranged compressed air connections.





AirMAB 5000 Specification

Power:	800 Watt
Nominal torque:	18 Nm
Morse taper:	MK 2
Stroke:	150 mm
Luftverbrauch:	0,85 m ³ /min.
Magnet size:	80 x 210 x 90 mm
Permanent internal lubrication:	•
Weight:	17,5 kg
Order No.	
MAB 5000	

AirMAB 5000 Scope of delivery

- 1 Magnetic Core Drilling Machine
- 1 Quick change drill chuck system
KEYLESS, 19 mm Weldon (3/4")
- 1 Ejector pin ZAK 075
- 1 Ejector pin ZAK 100
- 1 Carry case
- 1 Safety chain
- 1 Drill drift MK 2
- 1 Operating manual
- 1 Warranty certificate



Quicklinks

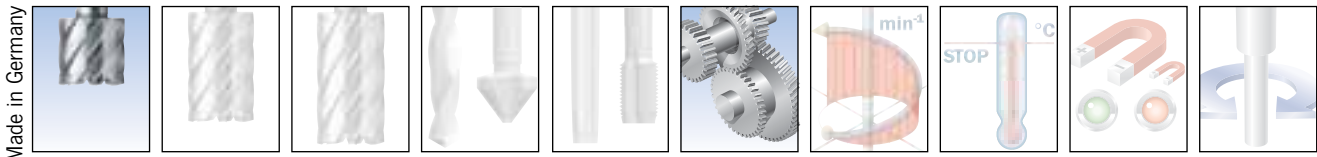
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Foto: Stadt Gelsenkirchen

AutoMAB 1500

Magnetic core drilling machine with automatic feed.



Made in Germany

Core drill short,
30 mm
ø 18 - 35 mm

Speed range 1:
360 min⁻¹

More time, more flexibility. Drilling - not longer manually but automatically. The new AutoMAB 1500 is a real enhancement, it allows room for parallel work and relieves the operator in the case of large drilling volume. Several machines can be operated simultaneously. Productivity is increased many times.



Damage impossible

Cabling inside

More power

generation

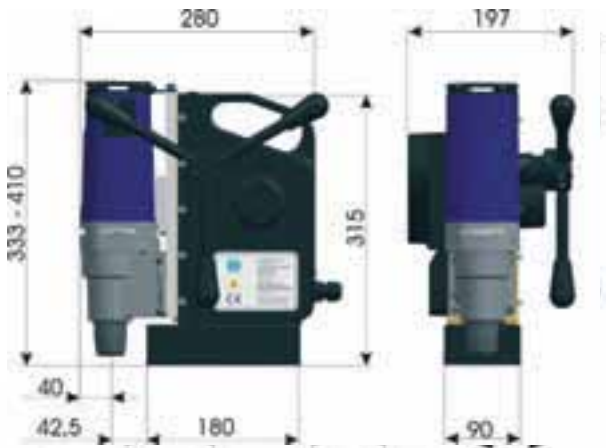
1080 W motor

Automatic drill feed, manual return

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.





AutoMAB 1500 Specification:

Power:	1080 Watt
Tool holder:	Direct arbor
Voltage:	230 V AC, 50-60 Hz
Stroke:	77 mm
Magnet size:	90 x 180 x 48 mm
Weight:	17 kg

Order No.

MAB 1500 / 230 Volt:

MAB 1500 / 110 Volt:

AutoMAB 1500 Scope of

delivery:

- 1 Magnetic core drilling machine
- 1 Steel carry case
- 1 Safety chain
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

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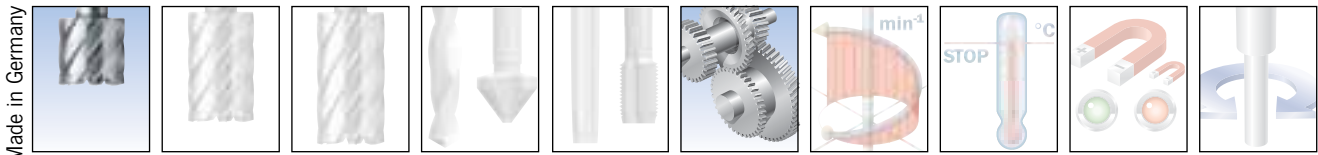
Accessories >> Page 68

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AutoMAB 2000

Magnetic core drilling machine with automatic feed.



Made in Germany

Core drill short,
30 mm
ø 14 – 40 mm

Speed range 1:
250 min⁻¹
Speed range 2:
450 min⁻¹

No more drilling by hand – but automatically.

The AutoMAB 2000 was developed for professional applications. A high drilling performance combined with continuous operation is just right for this type of machine. Especially when drilling a great number of holes, the time and cost saving advantages of this machine becomes obvious. The machine operator carries out control functions, consequently, more free time is provided for parallel tasks or the simultaneous use of further machines.



Development of sheer power

1200 W motor and two-stage gear for increased performance requirements of the magnetic core drilling technology.

Fully automatic

2-stage drill feed, automatic return

High safety

confusion-free arrangement of switches for power and magnetic force.

Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm (3/4")

Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.





AutoMAB 2000 Specification

Power:	1200 Watt
Tool holder:	KEYLESS
Voltage:	230 V AC, 50-60 Hz
Stroke:	75 mm
Magnet size:	90 x 195 x 51 mm
Weight:	21 kg
Order No.	
MAB 2000/ 230 Volt:	

AutoMAB 2000 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system
KEYLESS Weldon 19 mm (3/4")
- 1 Steel carry case
- 1 Safety chain
- 1 Operating manual
- 1 Warranty certificate

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BDS:profi

Series drilling – working with several machines at the same time!

The fully automatic AutoMAB 2000 allows inexpensive and effective making of drilled holes in series, e.g.



Feed is activated by pushing the handles. Upon the end of the drilling procedure, the motor returns to the zero position.

The feed rate is controlled electronically, the cutting pressure is proportionally adapted.



for façade and roof elements. The work can be carried out directly on-site. Transportation and the use of machines in the workshop is not required.

MABasic: The low-cost series.

MABasic 200, MABasic 600, MABasic 850

MABasic 200 – small, handy, economic. The machines of the MABasic series renounce features for the benefit of attractive conditions.

They are the gateway to the world of BDS Technology.



MABasic 600 – More motor output, increased magnetic adhesion and core drilling up to a diameter of 50 mm with a boring depth of 30 and 55 mm.



MABasic 200 Specification:

Tool holder:	Direct arbor
	19 mm Weldon shank
Core drill short 30 mm:	ø 12 – 32 mm
Power consumption:	900 Watt
Voltage:	230 V AC, 50-60 Hz
Working stroke:	150 mm
Speed:	450 min-1
Weight:	12 kg

Order No.

MABasic 200/ 230 Volt

MABasic 200/ 110 Volt

MABasic 600 Specification:

Tool holder:	Morse taper MT 3
Core drill short 30 mm:	ø 12 – 50 mm
Core drill long 55 mm:	ø 12 – 50 mm
Twist drill:	ø 31.75 mm
Power consumption:	1600 Watt
Voltage:	230 V AC, 50-60 Hz
Working stroke:	255 mm
Speed range 1:	280 min-1
Speed range 2:	580 min-1
Weight:	23 kg

Order No.

MABasic 600/ 230 Volt

MABasic 600/ 110 Volt





MABasic 850 – Leading in the low-cost class.

The characteristic feature is the four-stage gear and a motor output of 1,700 W in a really sensational price-performance ratio.



MABasic 850 Specification:

Tool holder:	Morse taper MT 3
Twist drill:	ø 31.75 mm
Power consumption:	1700 Watt
Voltage:	230 V AC, 50-60 Hz
Working stroke:	255 mm
Speed range 1:	110 min-1
Speed range 2:	175 min-1
Speed range 3:	245 min-1
Speed range 4:	385 min-1
Weight:	25 kg

Order No.

MABasic 850/ 230 Volt

MABasic 850/110 Volt

MABasic: Scope of delivery

- 1 Steel carry case
- 1 Safety chain
- 1 Drill drift
- (MABasic 600/850)
- 1 Hexagon socket screw key
- (MABasic 200)
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

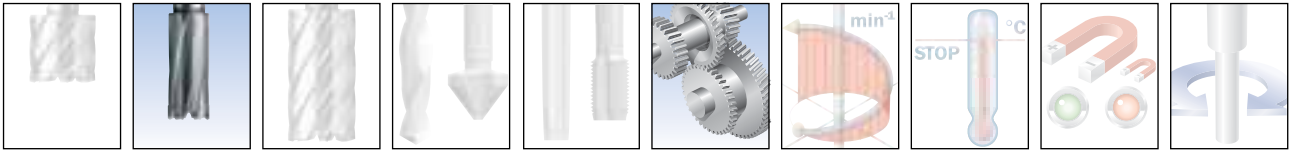
- Core drills** >> Page 48
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RailMAB 900

The rail core drilling machine.

Made in Germany

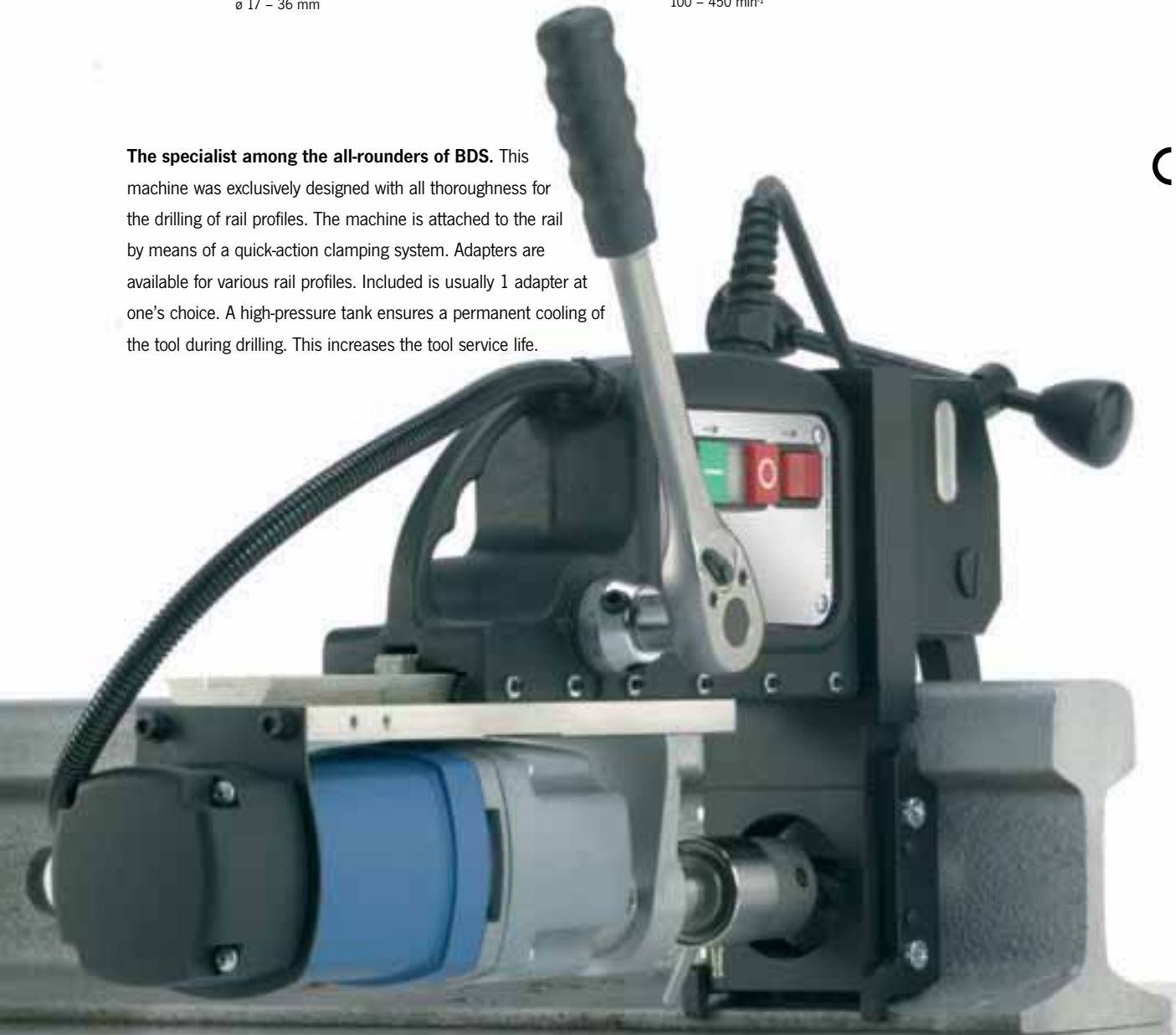


Core drills for rail drilling machine, long, 50 mm
ø 17 – 36 mm

Speed range 1:
50 – 250 min⁻¹
Speed range 2:
100 – 450 min⁻¹

The specialist among the all-rounders of BDS. This machine was exclusively designed with all thoroughness for the drilling of rail profiles. The machine is attached to the rail by means of a quick-action clamping system. Adapters are available for various rail profiles. Included is usually 1 adapter at one's choice. A high-pressure tank ensures a permanent cooling of the tool during drilling. This increases the tool service life.

CE



S 49/54



UIC 50/54/60



RailMAB 900 Specification:

Tool holder:	Morse taper MT 2
Core drill tool holder:	MT 2 for 19 mm Weldon shank
Core drill short 30 mm:	ø 18 – 35 mm
Power consumption:	1150 Watt
Voltage:	230 V AC, 50-60 Hz
Working stroke:	125 mm
Full wave control electronics:	•
Overheating protection:	•
Permanent internal lubrication:	•
Weight:	16 kg

Order No.

MAB 900/ 230 Volt:

MAB 900/ 110 Volt:

Railadaptors Order No.

Adaptor for UIC 50	ZAS 050U
Adaptor for UIC 54	ZAS 054U
Adaptor for UIC 60	ZAS 060U
Adaptor for S 49	ZAS 049S
Adaptor for S 54	ZAS 054S

RailMAB 900 Scope of delivery

- 1 Rail drilling machine
- 1 Quick-action clamping device
- 1 High-pressure tank, 5 litres
- 1 Reversing ratchet
- 1 Rail adapter of your choice (no special version)
- 1 Industrial arbor
MT 2/19 mm Weldon shank
- 1 Drill drift MT 2
- 1 Hexagon socket screw key SW 5
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

- Accessories** >> Page 68
- Service** >> Page 46

BDS:profi

Core drills HKL-R, Cutting depth 50 mm, weldon shank 19 mm (3/4")



Order No.	ø - mm
HKL-R 017	17
HKL-R 018	18
HKL-R 019	19
HKL-R 020	20
HKL-R 021	21
HKL-R 022	22
HKL-R 023	23
HKL-R 024	24
HKL-R 025	25
HKL-R 026	26
HKL-R 026	27
HKL-R 028	28
HKL-R 029	29
HKL-R 030	30
HKL-R 031	31
HKL-R 032	32
HKL-R 033	33
HKL-R 034	34
HKL-R 035	35
HKL-R 036	36

Ejector pin for core drills HKL-R ø 17 – 36 mm



ZAK 120



The quick-action clamping device exerts a pressure of 1.2 tons onto the rail foot, thus creating the required stability during drilling.

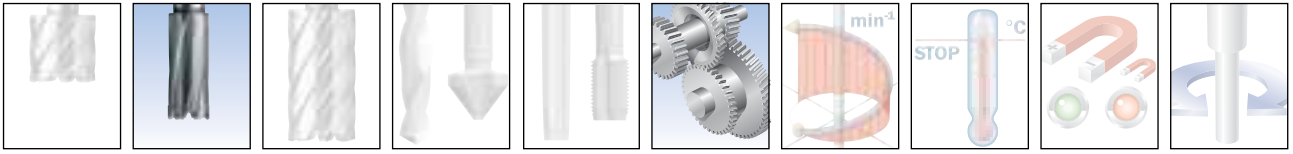


The ratchet feed in action.

RailMAB 960

The rail core drilling machine with petrol engine.

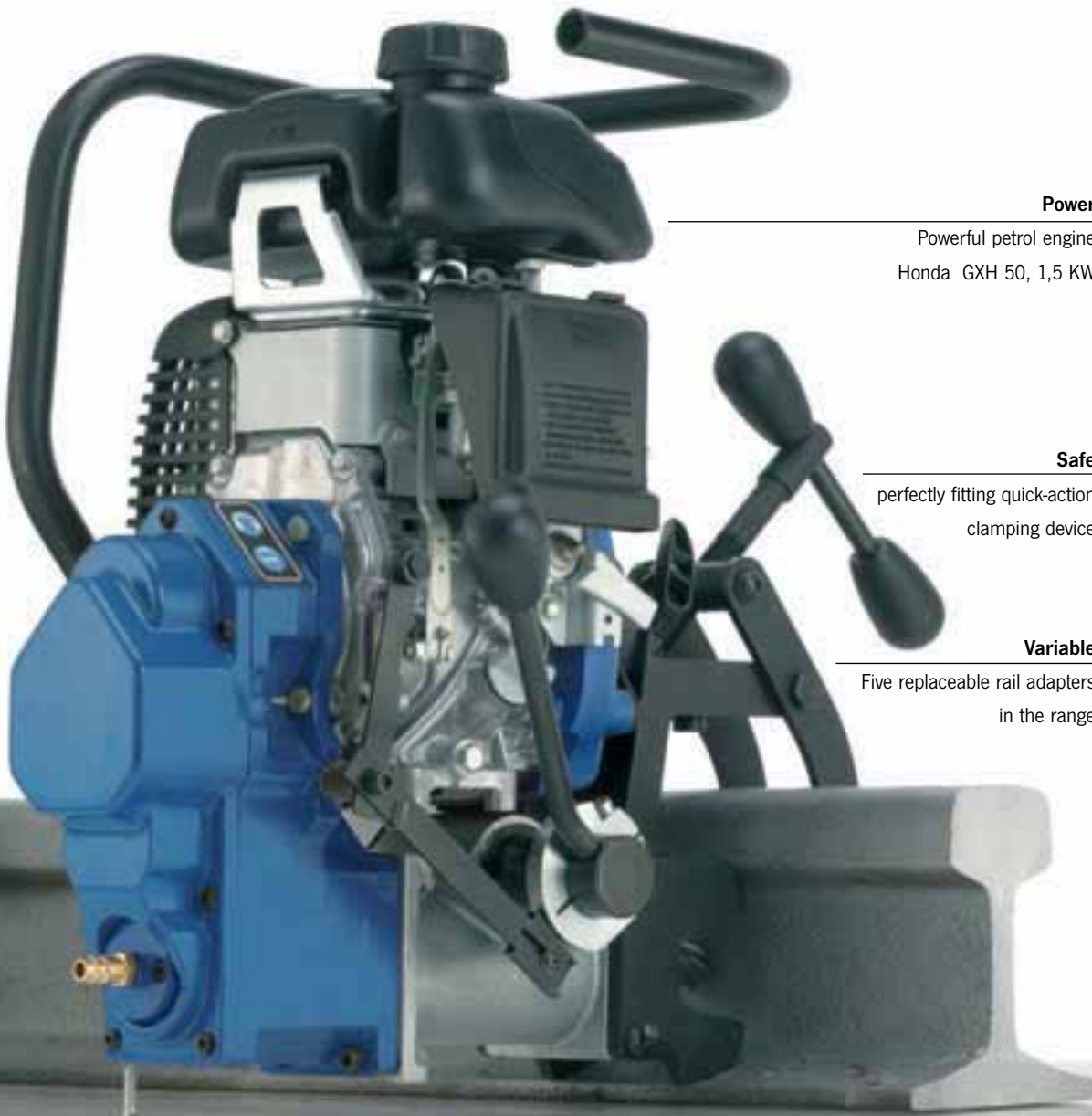
Made in Germany



Core drills for rail drilling machine, long, 50 mm
ø 17 - 36 mm

min. 150 min⁻¹
max. 225 min⁻¹

CE



Power

Powerful petrol engine
Honda GXH 50, 1,5 KW

Safe

perfectly fitting quick-action
clamping device

Variable

Five replaceable rail adapters
in the range





RailMAB 960 Specification

Motor:	Honda GXH 50
Cubic capacity:	49,4 ccm
Tank capacity:	0,5 l
Output:	1,5 KW
Torque:	3,04 Nm
Stroke:	40 mm
Tool holder:	Direct arbor 19 mm Weldon (3/4")
Cooling:	Bohremulsion
Permanent internal lubrication:	•
Weight:	21,5 kg

Order No.

MAB 960:

Railadaptors Order No.

Adaptor for UIC 50	ZAS 250U
Adaptor for UIC 54	ZAS 254U
Adaptor for UIC 60	ZAS 260U
Adaptor for S 49	ZAS 249S
Adaptor for S 54	ZAS 254S

Custom-made design upon request



RailMAB 960 Scope of delivery

- 1 Rail drilling machine
- 1 Quick-action clamping device
- 1 High-pressure tank, 5 litres
- 1 Rail adapter of your choice (no special version)
- 1 Hexagon socket screw key SW 4+5
- 1 Operating manual
- 1 Warranty certificate

Quicklinks

- Accessories** >> Page 68
- Service** >> Page 46

BDS:profi

Core drills HKL-R, Cutting depth 50 mm, weldon shank 19 mm (3/4")



Order No.	ø - mm
HKL-R 017	17
HKL-R 018	18
HKL-R 019	19
HKL-R 020	20
HKL-R 021	21
HKL-R 022	22
HKL-R 023	23
HKL-R 024	24
HKL-R 025	25
HKL-R 026	26
HKL-R 026	27
HKL-R 028	28
HKL-R 029	29
HKL-R 030	30
HKL-R 031	31
HKL-R 032	32
HKL-R 033	33
HKL-R 034	34
HKL-R 035	35
HKL-R 036	36

Ejector pin for core drills HKL-R
ø 17 – 36 mm



ZAK 120

The BDS Premium Service

This is how your core drilling machines and core drills are kept in top-quality!



BDS checks your machine, verifies all functions and recommends the most economical solution, if repair work is to be carried out.

- ▶ Inspection of connectors, switches and wiring.
 - ▶ Armature, coil, printed-circuit boards and magnet will be checked and replaced, if required, after an estimate has been made.
- Service and assistance are also provided by specialized workshops all over the world, which are approved and recommended by us.

Regrinding of BDS core drills reduces your tool cost.

BDS core drills are designed so that they can be reground several times without losing the cutting depth of e.g. 30 mm or 55 mm.

The BDS regrinding service corresponds with the BDS quality standard:

The tools are retouched with diamond and CBN grinding wheels on up-to-date wet grinding machines.

Benefit from the cost advantage!



The scope of a BDS Service Package includes:

- ▶ Dismantling and cleaning
- ▶ Replacement of wearing parts, such as spindle, steady, guideway elements and carbon brushes.



Finishing a drill at a lock gate



Reverse drilling

The BDS regrinding service offers very short delivery times.

Anytime upon request, we will place regrinding instructions for the regrinding of your core drills at your disposal.

Not all of the core drilling jobs can be done with standard machines or accessories, since the requirements of industry and trade are strongly varying. Individually adapted special versions must be made to meet special requirements.

This is our specialty.

Our technicians and engineers have considerable experience in the area of metal drilling technology.

For us it is a challenge to supply professional solutions for your applications.

- ▶ In-house CAD construction
- ▶ Sample construction
- ▶ Construction of prototypes
- ▶ Manufacturing of special accessories
- ▶ Test drilling and consultancy

Special versions can be realised by us quickly.



Special versions and technical support. Do you need a special magnetic core drilling machine for a special job? Just contact us!

BDS:profi

MAB 1000 special model with tool for finishing drills.

The machine was successfully used for finishing the drills of an excavator tool.



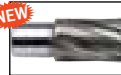










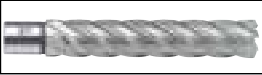



Special clamping system for pipe machining with laser measuring system

Core drilling tools

Competence and innovation

1.2 Core Drilling Tools

Standard Series	Page	VarioPLUS Series	Page	Sintered Carbide Series	Page
Cutting depth 30 mm		Cutting depth 30 mm		Cutting depth 30 mm	
					
KBK ø 12 – 60 mm	56	KBK VP ø 12 – 60 mm	62	HKK ø 14 – 150 mm	64
		Cutting depth 55 mm		Cutting depth 35 mm	
KBK ø 61 – 130 mm	57				
		KBL VP ø 12 – 60 mm	63	HKK-F ø 14 – 60 mm	65
KBK-Z ø 1/2" – 2 1/16"	61	Set of VarioPLUS core drills	62	Cutting depth 30 mm	
Cutting depth 55 mm					
		Ejector Pins for Core Drilling Tools		HKK-PLUS ø 14 – 60 mm	66
KBL ø 12 – 60 mm	58			Cutting depth 50 mm	
		Ejector pins			
KBL ø 61 – 100 mm	59	30 mm	56, 62, 66	HKL-Rail ø 17 – 36 mm	67
Cutting depth 110 mm		35 mm	58, 65		
		50 mm	67		
KEL ø 20 – 50 mm	60	55 mm	58, 63		
		110 mm	60		
Set of Standard core drills	56				

The next generation.

VarioPLUS – hard coated core drills by BDS

The advantages of the new VarioPLUS hard coating:

- ▶ Considerably increased chip removal even with long core drills!
- ▶ Increased wear resistance, that means longer working life!
- ▶ High efficiency and more working safety.

>> more on page 50





VarioPLUS: The next generation!

BDS core drills with new high-tech hard coating.

The new core drill generation by BDS is a milestone in core drilling technology. By the development of the hard coating VarioPLUS, it has been possible to optimize the positive features of the BDS core drills clearly.

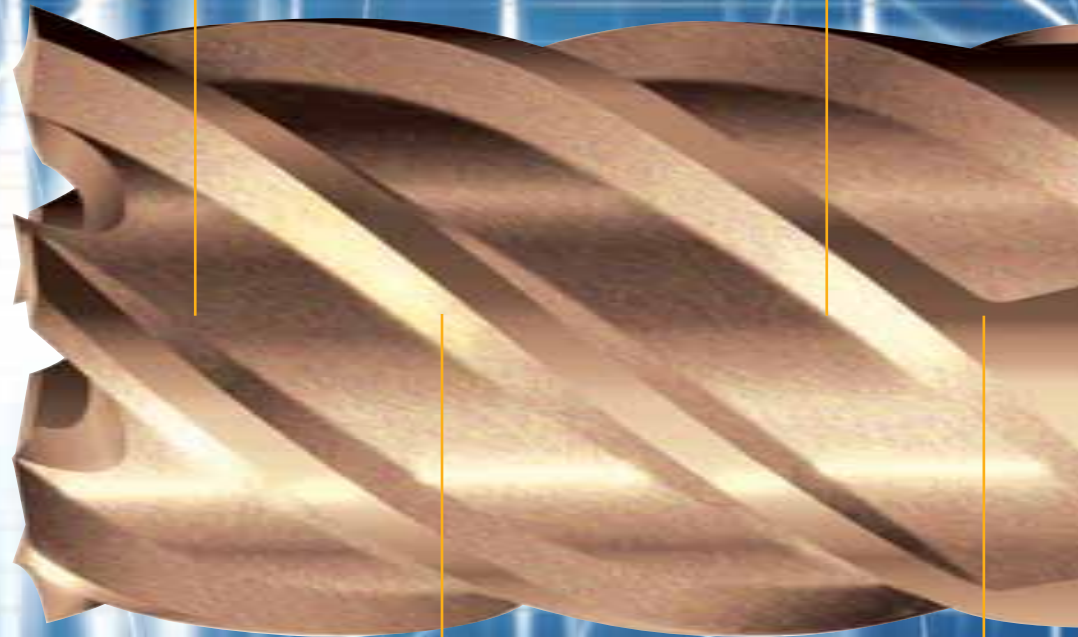
The high surface quality and the hardness of VarioPLUS, with coating thicknesses in the range of 2.5 μ , have achieved definite-

ly longer tool lives in extensive test runs. The chip flow, particularly during work with long core drills, could also be improved considerably.

VarioPLUS core drills of BDS represent an important step forward towards higher economy and working security, in every respect.

15 years of producer's competence and experience stand for optimum drilling results.

High-performance grade steel ensures uniform core drill quality



Fully ground

Optimal chip removal

The advantages of the new VarioPLUS hard coating:

- ▶ Considerably increased chip removal even with long core drills!
- ▶ Increased wear resistance, that means longer working life!
- ▶ High efficiency and more working safety.



1.2



Weldon shank



With a layer thickness in the range of 2,5 μ , the hard coated VarioPLUS tools from BDS have high surface finish and hardness. This results in a considerably increased tool life!

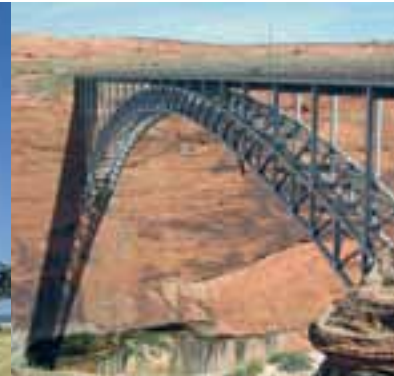
5 Series – 1,000 possibilities

You keep a clear view.

The tools of BDS machines are optimized for use with MAB magnetic core drilling machines.

What job you face, you will find the correct solution for your requirement:

- ▶ Constructional steelwork
- ▶ Construction of pressure vessels
- ▶ Pipeline construction
- ▶ Mechanical engineering








The core drill series

Standard Series			
Fully ground HSS core drills			
Tool holder:	Weldon 19 mm (3/4")		
	Weldon 32 mm (1 1/4")		
VarioPLUS Series			
Fully ground HSS core drills with VarioPLUS hard coating			
Tool holder:	Weldon 19 mm (3/4")		
			
HKK Series			
Sintered carbide core drills			
Tool holder:	Weldon 19 mm (3/4")		
	Nitto One-Touch		
	FEIN Quick-In		
HKK-PLUS Series			
Sintered carbide core drills with hard coating			
Tool holder:	Weldon 19 mm (3/4")		
	Nitto One-Touch		
HKK-Rail Series			
Sintered carbide core drills for railway rails			
Tool holder:	Weldon 19 mm (3/4")		
			



Application focuses, cutting speed, lubrication

Core drill series	Material						
	Aluminium/non-ferrous metals	Steel < 500 N/m ²	Fine-grain steel < 700 N/m ²	Fine-grain steel < 1000 N/m ²	Stainless steel Inox	Casting	Railway rails
							
Standard	25–30 m/min	25 m/min				10–20 m/min	
Lubricant Oil		•					
Grease spray		•					
Grease paste							
Spezialschmierstoff	•						
							
VarioPLUS			10–15m/min	10–15m/min	10–15m/min		
Lubricant Oil			•	•	•		
Grease spray			•	•	•		
Grease paste				•	•		
Special lubricant				•	•		
							
HKK		35 m/min	25 m/min	20 m/min VCE	20 m/min VCE		
Cooling lubricant/Drilling emulsion		•	•	•	•		
							
HKK-PLUS		35 m/min	25 m/min	20 m/min	20 m/min		
Cooling lubricant/Drilling emulsion		•	•	•	•		
							
HKK-Rail							15–20 m/min
Cooling lubricant/Drilling emulsion							

VCE = Full wave control electronics

Cutting speed:

$$V_c = \frac{d \times \pi \times n}{1000} = \text{m/min.}$$

Speed:

$$n = \frac{v \times 1000}{d \times \pi} = \text{min}^{-1}$$

The BDS core drill guide

Extensive programme range, cutting depth and drill diameter

Extensive programme range:

BDS core drills are available in 4 cutting depths of 30, 50, 55, and 110 mm and more than 94 different drill diameters from 12 mm to 140 mm.

Advantage:

High flexibility due to a maximum user-friendly assortment depth.

The Drive:

BDS core drill tools are available with various tool holders:

- ▶ Weldon shank holder
19 mm ($\frac{3}{4}$ ") and
- ▶ Weldon shank holder
32 mm ($1\frac{1}{4}$ ")

Sintered carbide core drills:

- ▶ FEIN Quick-In holder
- ▶ Combi shank with:
Weldon 19 mm ($\frac{3}{4}$ "),
Nitto One-Touch and
Alfra Rota-Quick

Advantage:

Compatibility with major worldwide industrial standards.

Standard Series

Designation: KBK
Cutting depth: 30 mm
Drilling ø: 12 – 130 mm



Designation: KBL
Cutting depth: 55 mm
Drilling ø: 12 – 100 mm



Designation: KEL
Cutting depth: 110 mm
Drilling ø: 20 – 50 mm



Vario Series

Designation: KBK-VP
Cutting depth: 30 mm
Drilling ø: 12 – 60 mm



NEW

Designation: KBL-VP
Cutting depth: 55 mm
Drilling ø: 12 – 60 mm



NEW

HKK Series

Designation: HKK
Cutting depth: 30 mm
Drilling ø: 14 – 150 mm



NEW

HKK-PLUS Series

Designation : HKK-P
Cutting depth: 30 mm
Drilling ø: 14 – 60 mm



NEW

HKK-Rail Series

Designation : HKL-Rail
Cutting depth: 50 mm
Drilling ø: 17 – 36 mm



NEW



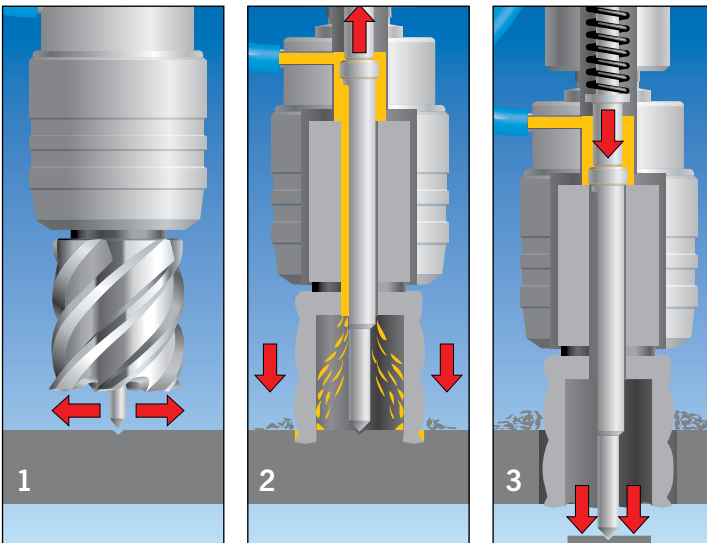
NEW



NEW

Combi shank with Weldon 19 mm ($\frac{3}{4}$ "), Nitto One-Touch and Alfra Rota-Quick

FEIN Quick-In drive



The functions of the BDS ejector pin

1. Centring:

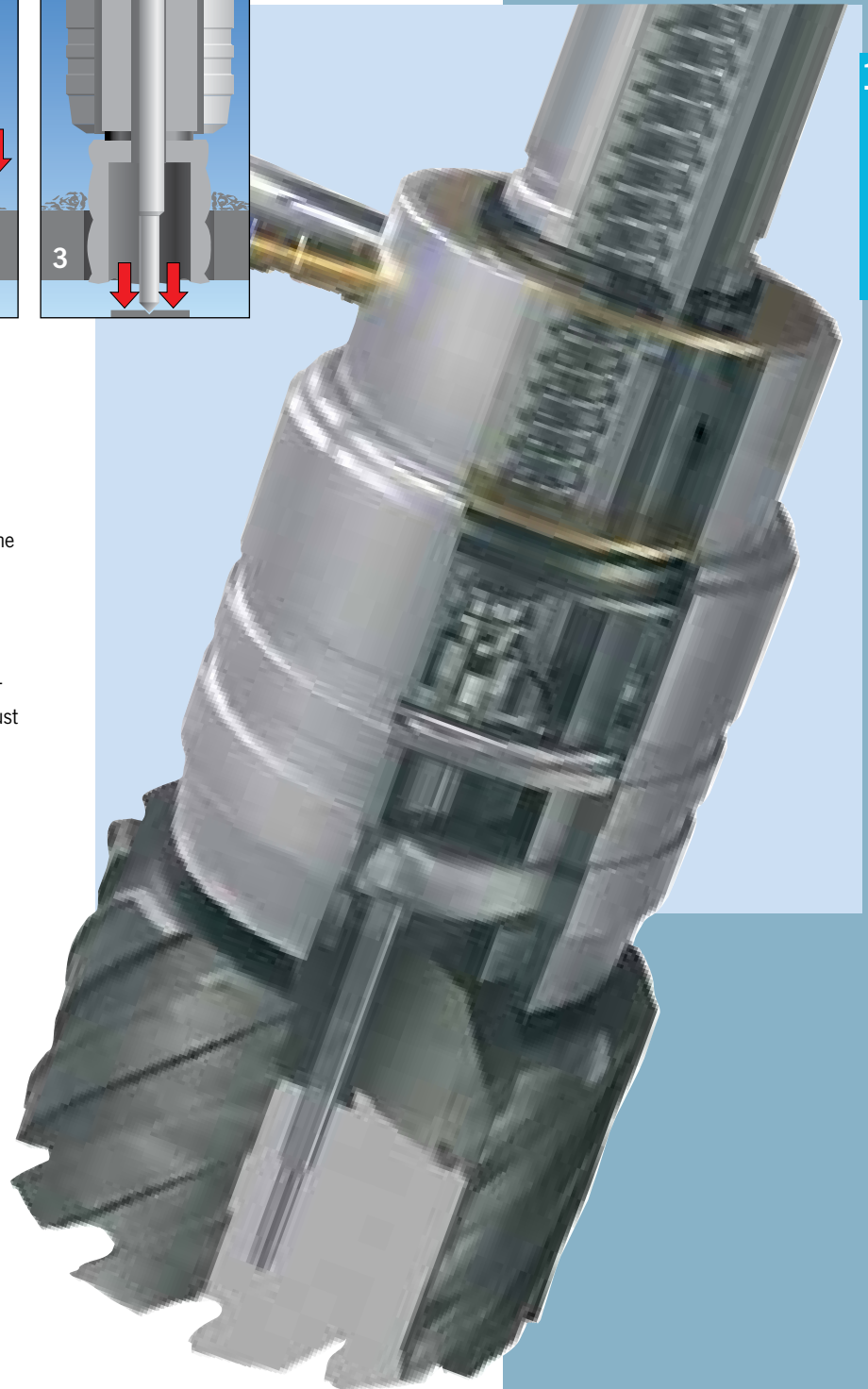
The ejector pin is exactly positioned to the centre punch mark. Switch the magnet on and the machine and tool are in the drilling position.

2. Oiling:

By means of the automatic internal lubrication, cutting oil is supplied via the ejector pin to the bit in just the right quantity.

3. Ejecting:

In the final stage, the ejector pin, pre-stressed by means of a spring, pushes the core out of the drill hole.



Standard Series – tools on a high level.

Fully ground core drills, short version, metric.

Standard core drill KBK

Cutting depth 30 mm Weldon shank 19 mm (3/4")



Order No.	ø mm	Order No.	ø mm
KBK 012	12	KBK 036	36
KBK 013	13	KBK 037	37
KBK 014	14	KBK 038	38
KBK 015	15	KBK 039	39
KBK 016	16	KBK 040	40
KBK 017	17	KBK 041	41
KBK 175	17,5	KBK 042	42
KBK 018	18	KBK 043	43
KBK 019	19	KBK 044	44
KBK 195	19,5	KBK 045	45
KBK 020	20	KBK 046	46
KBK 021	21	KBK 047	47
KBK 022	22	KBK 048	48
KBK 023	23	KBK 049	49
KBK 024	24	KBK 050	50
KBK 025	25	KBK 051	51
KBK 026	26	KBK 052	52
KBK 027	27	KBK 053	53
KBK 028	28	KBK 054	54
KBK 029	29	KBK 055	55
KBK 030	30	KBK 056	56
KBK 031	31	KBK 057	57
KBK 032	32	KBK 058	58
KBK 033	33	KBK 059	59
KBK 034	34	KBK 060	60
KBK 035	35		

Ejector pin for core drills short version ø 12-60 mm



Order No.
ZAK 075

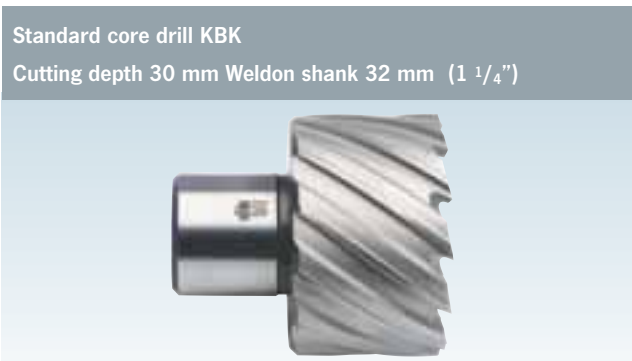
Set of standard core drills



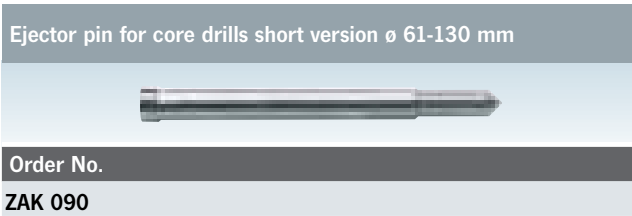
Order No.	Content
KBK 001	2 x KBK 014
	2 x KBK 018
	2 x KBK 020
	1 x ZAK 075

Order No.	Content
KBK 002	1 x KBK 013
	1 x KBK 014
	1 x KBK 017
	1 x KBK 018
	1 x KBK 021
	1 x KBK 022
	1 x ZAK 075





Order No.	ø - mm	Order No.	ø - mm
KBK 061	61	KBK 084	84
KBK 062	62	KBK 085	85
KBK 063	63	KBK 086	86
KBK 064	64	KBK 087	87
KBK 065	65	KBK 088	88
KBK 066	66	KBK 089	89
KBK 067	67	KBK 090	90
KBK 068	68	KBK 091	91
KBK 069	69	KBK 092	92
KBK 070	70	KBK 093	93
KBK 071	71	KBK 094	94
KBK 072	72	KBK 095	95
KBK 073	73	KBK 096	96
KBK 074	74	KBK 097	97
KBK 075	75	KBK 098	98
KBK 076	76	KBK 099	99
KBK 077	77	KBK 100	100
KBK 078	78	KBK 105	105
KBK 079	79	KBK 110	110
KBK 080	80	KBK 115	115
KBK 081	81	KBK 120	120
KBK 082	82	KBK 125	125
KBK 083	83	KBK 130	130



BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- ▶ Increased tool life due to HSS special steel.
- ▶ Particularly wide product range with perfect surface finish
- ▶ Improved chip flow by full-grinding technology

Standard Series – with BDS producer competence

Fully ground core drills, long version, metric.

Standard core drill KBL

Cutting depth 55 mm Weldon shank 19 mm (3/4")



Order No.	ø mm	Order No.	ø mm
KBL 012	12	KBL 036	36
KBL 013	13	KBL 037	37
KBL 014	14	KBL 038	38
KBL 015	15	KBL 039	39
KBL 016	16	KBL 040	40
KBL 017	17	KBL 041	41
KBL 175	17,5	KBL 042	42
KBL 018	18	KBL 043	43
KBL 019	19	KBL 044	44
KBL 195	19,5	KBL 045	45
KBL 020	20	KBL 046	46
KBL 021	21	KBL 047	47
KBL 022	22	KBL 048	48
KBL 023	23	KBL 049	49
KBL 024	24	KBL 050	50
KBL 025	25	KBL 051	51
KBL 026	26	KBL 052	52
KBL 027	27	KBL 053	53
KBL 028	28	KBL 054	54
KBL 029	29	KBL 055	55
KBL 030	30	KBL 056	56
KBL 031	31	KBL 057	57
KBL 032	32	KBL 058	58
KBL 033	33	KBL 059	59
KBL 034	34	KBL 060	60
KBL 035	35		



Ejector pin for core drills long version ø 12 – 60 mm



Order No.

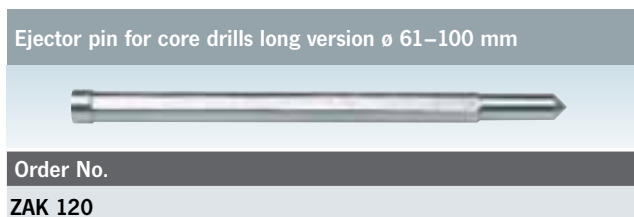
ZAK 100

Standard Series

Fully ground core drills, long version, metric.



Order No.	ø - mm	Order No.	ø - mm
KBL 061	61	KBL 081	81
KBL 062	62	KBL 082	82
KBL 063	63	KBL 083	83
KBL 064	64	KBL 084	84
KBL 065	65	KBL 085	85
KBL 066	66	KBL 086	86
KBL 067	67	KBL 087	87
KBL 068	68	KBL 088	88
KBL 069	69	KBL 089	89
KBL 070	70	KBL 090	90
KBL 071	71	KBL 091	91
KBL 072	72	KBL 092	92
KBL 073	73	KBL 093	93
KBL 074	74	KBL 094	94
KBL 075	75	KBL 095	95
KBL 076	76	KBL 096	96
KBL 077	77	KBL 097	97
KBL 078	78	KBL 098	98
KBL 079	79	KBL 099	99
KBL 080	80	KBL 100	100



BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- ▶ Increased tool life due to HSS special steel.
- ▶ Particularly wide product range with perfect surface finish
- ▶ Improved chip flow by full-grinding technology

Standard Series – proven in practice

Fully ground core drills, extra long version, metric.

Standard core drill KEL

Cutting depth 110 mm Weldon shank 19 mm (3/4")



Order No.	ø - mm	Order No.	ø - mm
KEL 020	20	KEL 036	36
KEL 021	21	KEL 037	37
KEL 022	22	KEL 038	38
KEL 023	23	KEL 039	39
KEL 024	24	KEL 040	40
KEL 025	25	KEL 041	41
KEL 026	26	KEL 042	42
KEL 027	27	KEL 043	43
KEL 028	28	KEL 044	44
KEL 029	29	KEL 045	45
KEL 030	30	KEL 046	46
KEL 031	31	KEL 047	47
KEL 032	32	KEL 048	48
KEL 033	33	KEL 049	49
KEL 034	34	KEL 050	50
KEL 035	35		



The function of the two-piece ejector pin:

The lower part of the pin is removed in order to fully utilize the full cutting depth of 110 mm of a KEL core drill!

Ejector pin for KEL with 6.35 mm bore diameter



For KEL with bore diameter 6.35 mm (old version)

Order No.	Drilling range
ZAK 175	ø 20 - 50 mm

Ejector pin for KEL mit 8 mm bore diameter



For KEL with bore diameter 8 mm (new version)

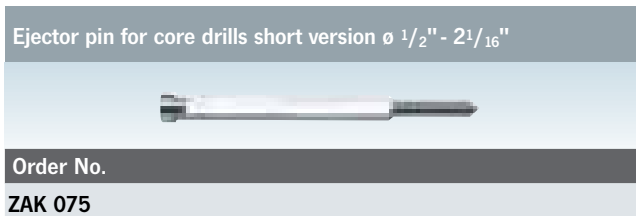
Order No.	Version	Drilling range
ZAK 275	two-part	ø 20 - 50 mm

Standard Series

Fully ground core drills, short version, inch



Order No.	ø inch	ø mm
KBK 1/2	1/2"	12,700
KBK 9/16	9/16"	14,288
KBK 5/8	5/8"	15,875
KBK 11/16	11/16"	17,463
KBK 3/4	3/4"	19,050
KBK 13/16	13/16"	20,638
KBK 7/8	7/8"	22,225
KBK 15/16	15/16"	23,813
KBK 1	1"	25,400
KBK 1 1/16	1 1/16"	26,988
KBK 1 1/8	1 1/8"	28,575
KBK 1 3/16	1 3/16"	30,136
KBK 1 1/4	1 1/4"	31,750
KBK 1 5/16	1 5/16"	33,338
KBK 1 3/8	1 3/8"	34,925
KBK 1 7/16	1 7/16"	36,513
KBK 1 1/2	1 1/2"	38,100
KBK 1 9/16	1 9/16"	39,688
KBK 1 5/8	1 5/8"	41,276
KBK 1 11/16	1 11/16"	42,863
KBK 1 3/4	1 3/4"	44,450
KBK 1 13/16	1 13/16"	46,038
KBK 1 7/8	1 7/8"	47,625
KBK 1 15/16	1 15/16"	49,213
KBK 2	2"	50,800
KBK 2 1/16	2 1/16"	52,388



BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- ▶ Increased tool life due to HSS special steel.
- ▶ Particularly wide product range with perfect surface finish
- ▶ Improved chip flow by full-grinding technology



Serie Vario Plus

BDS Fully ground core drills, short version, metric.

Vario core drill KBK-VP

Cutting depth 30 mm Weldon shank 19 mm (3/4")



Order No.	ø mm	Order No.	ø mm
KBK 012-VP	12	KBK 036-VP	36
KBK 013-VP	13	KBK 037-VP	37
KBK 014-VP	14	KBK 038-VP	38
KBK 015-VP	15	KBK 039-VP	39
KBK 016-VP	16	KBK 040-VP	40
KBK 017-VP	17	KBK 041-VP	41
KBK 175-VP	17,5	KBK 042-VP	42
KBK 018-VP	18	KBK 043-VP	43
KBK 019-VP	19	KBK 044-VP	44
KBK 195-VP	19,5	KBK 045-VP	45
KBK 020-VP	20	KBK 046-VP	46
KBK 021-VP	21	KBK 047-VP	47
KBK 022-VP	22	KBK 048-VP	48
KBK 023-VP	23	KBK 049-VP	49
KBK 024-VP	24	KBK 050-VP	50
KBK 025-VP	25	KBK 051-VP	51
KBK 026-VP	26	KBK 052-VP	52
KBK 027-VP	27	KBK 053-VP	53
KBK 028-VP	28	KBK 054-VP	54
KBK 029-VP	29	KBK 055-VP	55
KBK 030-VP	30	KBK 056-VP	56
KBK 031-VP	31	KBK 057-VP	57
KBK 032-VP	32	KBK 058-VP	58
KBK 033-VP	33	KBK 059-VP	59
KBK 034-VP	34	KBK 060-VP	60
KBK 035-VP	35		

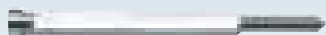
Set of Vario Plus core drills



Order No.	Content
KBK 001-VP	2 x KBK-VP 014
	2 x KBK-VP 018
	2 x KBK-VP 022
	1 x ZAK 075

Order No.	Content
KBK 002-VP	1 x KBK-VP 013
	1 x KBK-VP 014
	1 x KBK-VP 017
	1 x KBK-VP 018
	1 x KBK-VP 021
	1 x KBK-VP 022
	1 x ZAK 075

Ejector pin for core drill short, up to ø 60 mm



Order No.

ZAK 075

NEW



Serie Vario Plus

BDS Fully ground core drills, long version, metric.



Order No.	ø - mm	Order No.	ø - mm
KBL 012-VP	12	KBL 036-VP	36
KBL 013-VP	13	KBL 037-VP	37
KBL 014-VP	14	KBL 038-VP	38
KBL 015-VP	15	KBL 039-VP	39
KBL 016-VP	16	KBL 040-VP	40
KBL 017-VP	17	KBL 041-VP	41
KBL 175-VP	17,5	KBL 042-VP	42
KBL 018-VP	18	KBL 043-VP	43
KBL 019-VP	19	KBL 044-VP	44
KBL 195-VP	19,5	KBL 045-VP	45
KBL 020-VP	20	KBL 046-VP	46
KBL 021-VP	21	KBL 047-VP	47
KBL 022-VP	22	KBL 048-VP	48
KBL 023-VP	23	KBL 049-VP	49
KBL 024-VP	24	KBL 050-VP	50
KBL 025-VP	25	KBL 051-VP	51
KBL 026-VP	26	KBL 052-VP	52
KBL 027-VP	27	KBL 053-VP	53
KBL 028-VP	28	KBL 054-VP	54
KBL 029-VP	29	KBL 055-VP	55
KBL 030-VP	30	KBL 056-VP	56
KBL 031-VP	31	KBL 057-VP	57
KBL 032-VP	32	KBL 058-VP	58
KBL 033-VP	33	KBL 059-VP	59
KBL 034-VP	34	KBL 060-VP	60
KBL 035-VP	35		



1.2



BDS:profi

VarioPLUS series
Hard covered core drills
of the next generation.

- ▶ Longer service life
- ▶ Improved chip flow

Conclusion: More efficiency and more working safety.

Ejector pin for core drill long, up to ø 60 mm

Order No.
ZAK 100

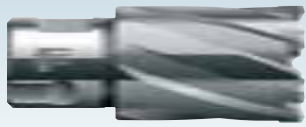
NEW

HKK Series

Sintered Carbide, short version, metric

Core drills HKK
Cutting depth 30 mm One-Touch and Weldon shank 19 mm (3/4")

One-Touch
Rota-Quick



WELDON
19 mm
3/4"

Order No.	ø - mm	Order No.	ø - mm
HKK 014	14	HKK 054	54
HKK 015	15	HKK 055	55
HKK 016	16	HKK 056	56
HKK 017	17	HKK 057	57
HKK 018	18	HKK 058	58
HKK 019	19	HKK 059	59
HKK 020	20	HKK 060	60
HKK 021	21	HKK 061	61
HKK 022	22	HKK 062	62
HKK 023	23	HKK 063	63
HKK 024	24	HKK 064	64
HKK 025	25	HKK 065	65
HKK 026	26	HKK 066	66
HKK 027	27	HKK 067	67
HKK 028	28	HKK 068	68
HKK 029	29	HKK 069	69
HKK 030	30	HKK 070	70
HKK 031	31	HKK 071	71
HKK 032	32	HKK 072	72
HKK 033	33	HKK 073	73
HKK 034	34	HKK 074	74
HKK 035	35	HKK 075	75
HKK 036	36	HKK 076	76
HKK 037	37	HKK 077	77
HKK 038	38	HKK 078	78
HKK 039	39	HKK 079	79
HKK 040	40	HKK 080	80
HKK 041	41	HKK 081	81
HKK 042	42	HKK 082	82
HKK 043	43	HKK 083	83
HKK 044	44	HKK 084	84
HKK 045	45	HKK 085	85
HKK 046	46	HKK 086	86
HKK 047	47	HKK 087	87
HKK 048	48	HKK 088	88
HKK 049	49	HKK 089	89
HKK 050	50	HKK 090	90
HKK 051	51	HKK 091	91
HKK 052	52	HKK 092	82
HKK 053	53	HKK 093	93




Order No.	ø - mm	Order No.	ø - mm
HKK 094	94	HKK 115	115
HKK 095	95	HKK 120	120
HKK 096	96	HKK 125	125
HKK 097	97	HKK 130	130
HKK 098	98	HKK 135	135
HKK 099	99	HKK 140	140
HKK 100	100	HKK 145	145
HKK 105	105	HKK 150	150
HKK 110	110		

Ejector pin for core drills HKK ø 14 – 17 mm



Order No.
ZAK 096

Ejector pin for core drills HKK ø 18 – 150 mm



Order No.
ZAK 090



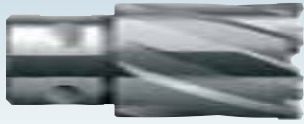
NEW

HKK-F Series

Sintered Carbide, short version, metric

HKK core drill for FEIN Quick-In holder system
Cutting depth 30 mm Weldon shank 18 mm

Quick-In



Order No.	ø - mm	Order No.	ø - mm
HKK-F 014	14	HKK-F 031	31
HKK-F 015	15	HKK-F 032	32
HKK-F 016	16	HKK-F 033	33
HKK-F 017	17	HKK-F 034	34
HKK-F 018	18	HKK-F 035	35
HKK-F 019	19	HKK-F 036	36
HKK-F 020	20	HKK-F 037	37
HKK-F 021	21	HKK-F 038	38
HKK-F 022	22	HKK-F 039	39
HKK-F 023	23	HKK-F 040	40
HKK-F 024	24	HKK-F 041	41
HKK-F 025	25	HKK-F 042	42
HKK-F 026	26	HKK-F 043	43
HKK-F 027	27	HKK-F 044	44
HKK-F 028	28	HKK-F 045	45
HKK-F 029	29	HKK-F 046	46
HKK-F 030	30	HKK-F 047	47



Order No.	ø - mm
HKK-F 048	48
HKK-F 049	49
HKK-F 050	50
HKK-F 051	51
HKK-F 052	52
HKK-F 053	53
HKK-F 054	54
HKK-F 055	55
HKK-F 056	56
HKK-F 057	57
HKK-F 058	58
HKK-F 059	59
HKK-F 060	60

1.2

Ejector pin for core drills HKK-F ø 14 – 60 mm



Order No.
ZAK 096



Quick-In

BDS:profi

Soluble cutting oil
BDS 6000



Order No. ø - mm
ZHB 001 1 Liter container

BDS 6000 High-performance cooling lubricant concentrate for high demands

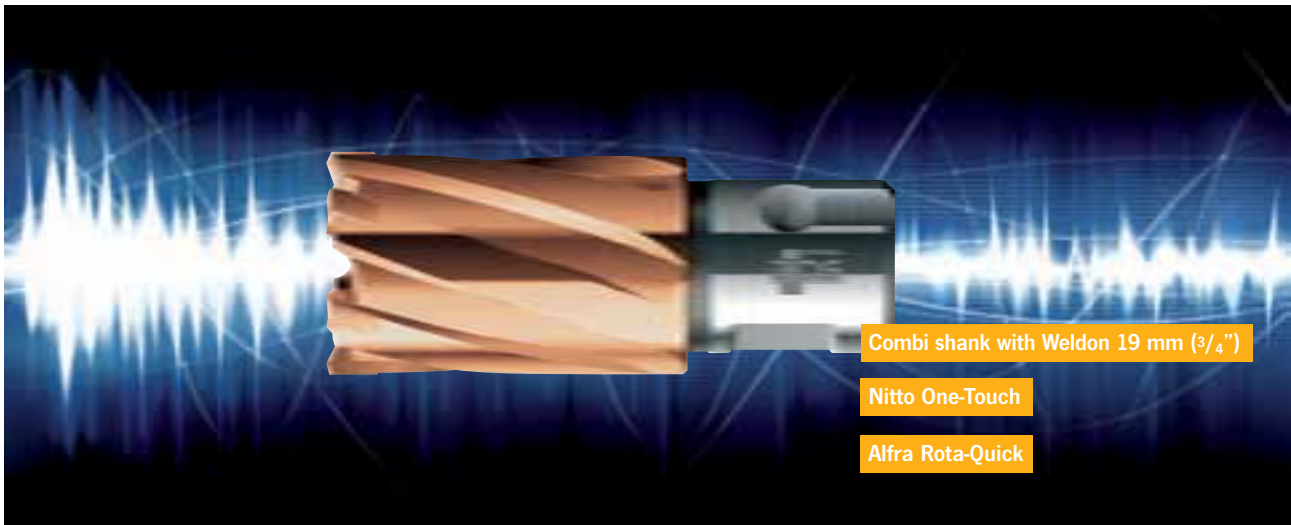
based on synthetic raw materials.

- ▶ Soluble in water
- ▶ Compatible in toxicological viewpoint
- ▶ Water hazard class 1

NEW

HKK-PLUS Series

Sintered carbide core drill with hard coating, short version, metric



Combi shank with Weldon 19 mm (3/4")

Nitto One-Touch

Alfra Rota-Quick

Core drill with hard coating HKK-P, cutting depth 30 mm, Weldon shank 19 mm (3/4"), Nitto One-Touch-, Alfra Rota-Quick

One-Touch
Rota-Quick

WELDON
19 mm
3/4"



Order No.	ø - mm
HKK-P 014	14
HKK-P 015	15
HKK-P 016	16
HKK-P 017	17
HKK-P 018	18
HKK-P 019	19
HKK-P 020	20
HKK-P 021	21
HKK-P 022	22
HKK-P 023	23
HKK-P 024	24
HKK-P 025	25
HKK-P 026	26
HKK-P 027	27
HKK-P 028	28
HKK-P 029	29
HKK-P 030	30
HKK-P 031	31
HKK-P 032	32
HKK-P 033	33
HKK-P 034	34

Order No.	ø - mm
HKK-P 035	35
HKK-P 036	36
HKK-P 037	37
HKK-P 038	38
HKK-P 039	39
HKK-P 040	40
HKK-P 041	41
HKK-P 042	42
HKK-P 043	43
HKK-P 044	44
HKK-P 045	45
HKK-P 046	46
HKK-P 047	47
HKK-P 048	48
HKK-P 049	49
HKK-P 050	50
HKK-P 051	51
HKK-P 052	52
HKK-P 053	53
HKK-P 054	54
HKK-P 055	55



Order No.	ø - mm
HKK-P 056	56
HKK-P 057	57
HKK-P 058	58
HKK-P 059	59
HKK-P 060	60

Ejector pin for core drills HKK-P ø 14 – 17 mm



Order No.
ZAK 096

Ejector pin for core drills HKK-P ø 18 – 60 mm



Order No.
ZAK 090

NEW



HKL-Rail Series

Sintered Carbide, long version, metric



1.2

Cor drills HKL-R

Cutting depth 50 mm Weldon shank 19 mm (3/4")



Order No.	ø - mm
HKL-R 017	17
HKL-R 018	18
HKL-R 019	19
HKL-R 020	20
HKL-R 021	21
HKL-R 022	22
HKL-R 023	23
HKL-R 024	24
HKL-R 025	25
HKL-R 026	26
HKL-R 027	27

Order No.	ø - mm
HKL-R 028	28
HKL-R 029	29
HKL-R 030	30
HKL-R 031	31
HKL-R 032	32
HKL-R 033	33
HKL-R 034	34
HKL-R 035	35
HKL-R 036	36



BDS:advice

Carbide series: Core drills for professional working results.

- ▶ Long service life
- ▶ Extensive programme range
- ▶ **Plus special assortment for rail core drilling machines**

New: Rail core drilling machine with petrol engine. RailMAB 960

>> Page 44



Ejector pin for core drills HKL-R ø 17 – 36 mm



Order No.


ZAK 120







Accessories for Magnetic Core Drilling Machines







Competence and Innovation

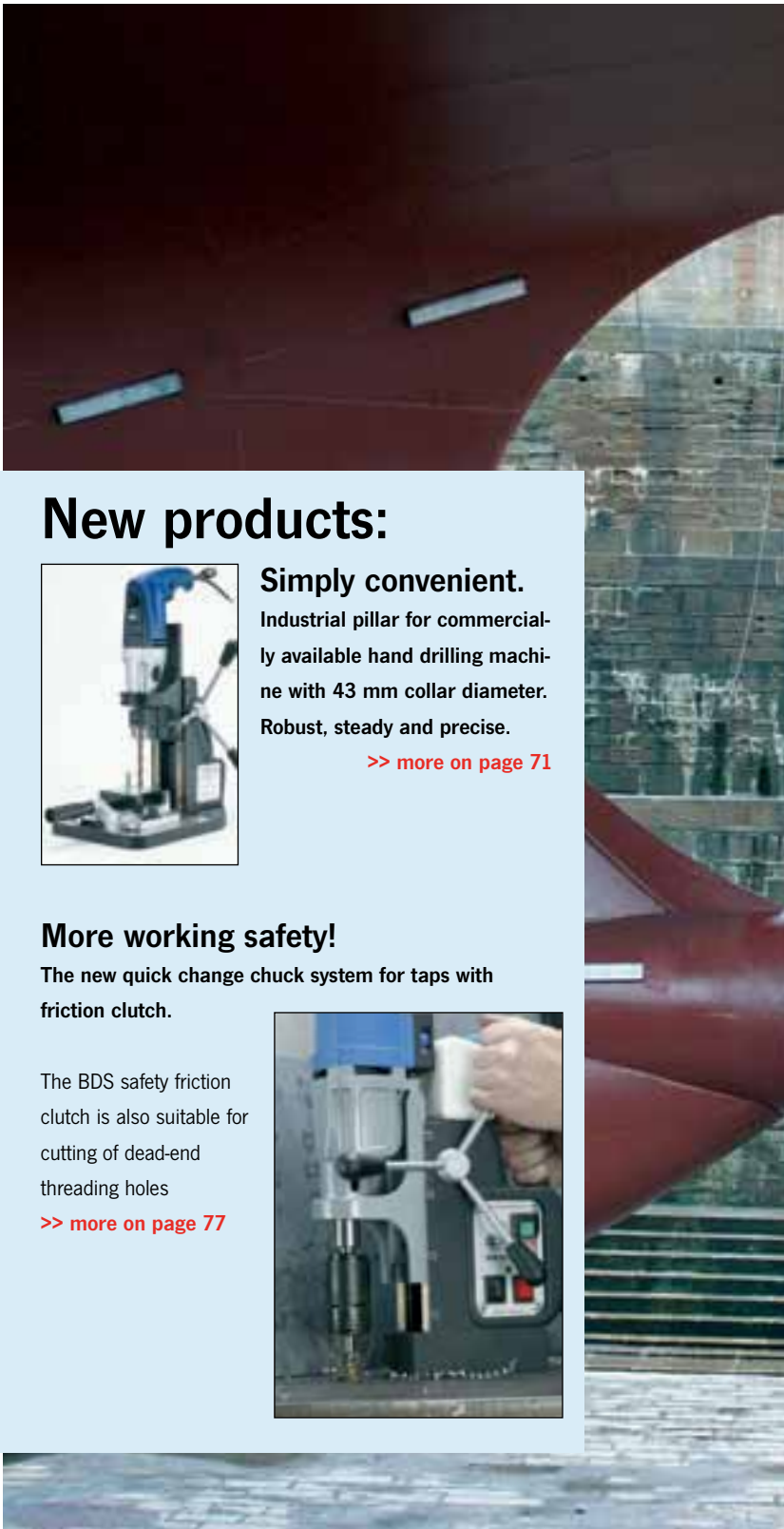
1.3 Accessories for Magnetic Core Drilling Machines

Clamping devices	Page	Lubricants	Page
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	Mobil Clamp	70		High performance cutting oil	80
	Industrial pillar	71		High performance lubrication spray	80
	Vacuum clamping device	72		Cutting paste	80
	Tube clamping device	73		Cleaning spray	80
Changeable drill chuck systems				Soluble cutting oil	80

Quick change drill chuck system KEYLESS		Thread cutting			
	Quick change drill chuck system KEYLESS	74		Quick-change tapping chuck	
	Industrial arbors	75		Quick change inserts	
	Cutting oil reservoir	75		Tap adapter	76

Drill chucks and adapters		General accessories			
	Gear rim drill chuck	78		Power Worker	81
	Reducing bushes, Extension bushes	78		Chip protection for core drilling machines	79
	Adapter	79		Steel carry case	79




New products:



Simply convenient.
Industrial pillar for commercial-ly available hand drilling machine with 43 mm collar diameter. Robust, steady and precise.
[>> more on page 71](#)

More working safety!
The new quick change chuck system for taps with friction clutch.
The BDS safety friction clutch is also suitable for cutting of dead-end threading holes
[>> more on page 77](#)





1.3

Clamping Devices

Accessories for Magnetic Core Drilling Machines

A true progress in core drilling technology: The new clamping system MOBIL CLAMP can be used to convert the core drilling machine into a bench drill.

Consequently, the user options can be substantially extended. Parts, which so far could only be drilled in the workshop, can now also be machined directly on site. Above all, it is possible to drill, countersink, ream or tap small parts, since these can be mounted without any problems into the quick clamping device.

With the mounting of the core drilling machine onto the surface of the vice and the subsequent activating of the magnet, you will have a flexible, stationary drilling

machine in next no time. The magnetic core drilling machine becomes a multi-talent: whether large or small applications, flat or high, with the twist drill or the reamer, everything is possible. A stable support, designed for the Mobil Clamp clamping device, ensures the correct working height and a comfortable and reliable working.

Mobil Clamp clamping device



Order No.	Jaw width	Quick-action clamping jaw	V-block clamping jaw
ZMC 180	100 mm	80 mm clamping width	•
Clamping device			
ZMC 300			
Base for clamping device			



Powerful grip.
Jaws with step and prism for clamping of flat and round material.



Fine-adjustment
in longitudinal movement by an adjusting screw accurately set to the machining point.

Industrial drilling pillar

for commercial hand drills with 43 mm chuck journal diameter

Industrial drilling pillar for commercial hand drills



Order No.
ZBS 100

Prism vice for industrial pillar:
Jaw width 100 mm
Clamping range 100 mm



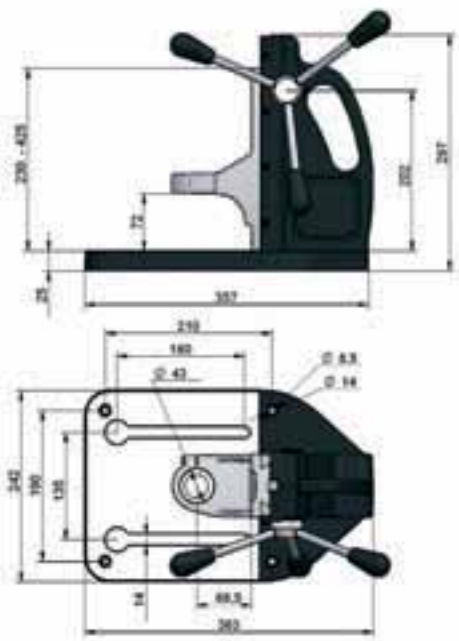
Order No.
ZST 100

Screws for T-Slots

Order No.
ZTN 100

Hexagon nut with collar

Order No.
ZSM 100



Industrial drilling pillars for commercial hand drills with 43mm chuck journal diameter.

Optimum stability by cast base plate combined with a pillar top of the MAB series.

Versatile usability by a drill vice with 100 mm jaw width. (special accessories).

Screws for slots are available for additional security under higher loads (special accessories).

Working stroke 230 – 425 mm.

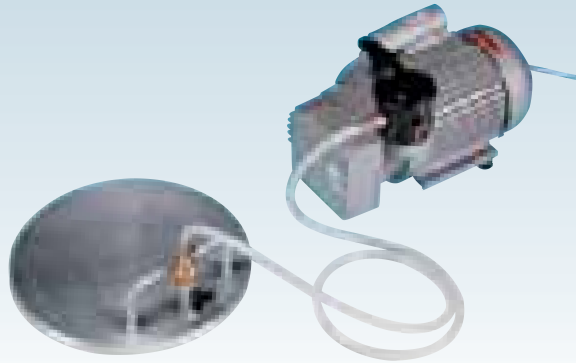


The hand drilling machine is not part of the delivery.

Vacuum plates

Accessories for Magnetic Core Drilling Machines

Vacuum plate for channelled plates



Application:

Specially suitable for channelled plates.

Version:

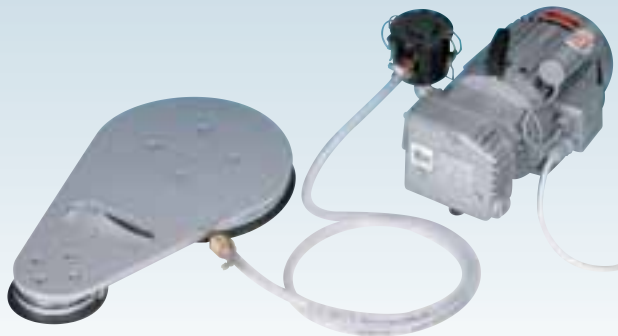
High-performance vacuum pump, with circular oil lubrication. Clamping plate \varnothing 300 mm.

Order No.

ZAV 300



Vacuum plate for smooth surfaces



Application:

For smooth surfaces.

Version:

High-performance vacuum pump, with circular oil lubrication. Clamping plates with two suction surfaces and internal drilling area.

Order No.

ZAV 400



Pipe Clamping Devices

Accessories for Magnetic Core Drilling Machines

Pipe clamping device



Application:

For MAB 425, 455, 485, MABasic 200

For pipe \varnothing : 80 - 250 mm

Version:

Chain length: 900 mm

Order No.

ZRO 250

Pipe clamping device



Application:

For MAB 500, 825, 845, MABasic 850

For pipe \varnothing : 150 - 500 mm

Version:

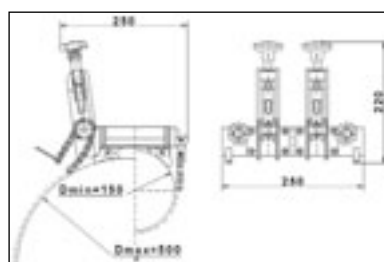
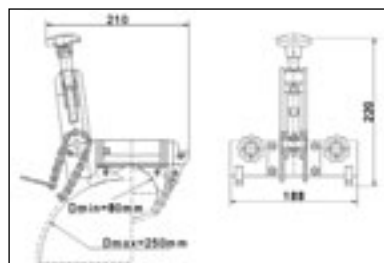
Chain length: 1650 mm

Order No.

ZRO 500



1.3



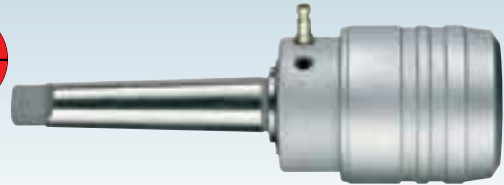
Automatic internal lubrication.

Time is money: The Keyless quick change drill chuck system allows the convenient change of BDS core drills with 19 mm Weldon shank without a key.

Special adapters for older BDS core drills are not required. The automatic internal lubrication system by BDS supplies the correct amount of cutting oil to the core bit.



KEYLESS quick change drill chuck system, with automatic internal lubrication, 19 mm Weldon shank



Application:

KEYLESS quick change drill chuck system with automatic internal lubrication for BDS core drills. Quick tool change without chuck key. For BDS core drills with 19 mm Weldon shank.

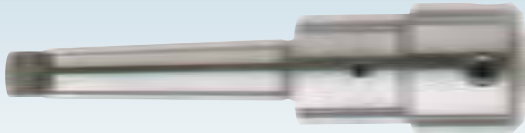
Version:

With hose and quick acting coupling.

Order No.	Spindle holder	Core drill tool holder
ZSS 200	MK 2	19 mm Weldon shank
ZSS 300	MK 3	19 mm Weldon shank

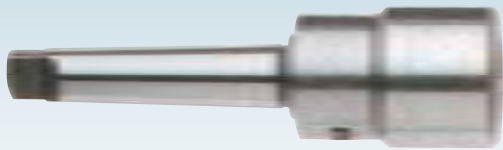


Industrial holder, with automatic internal lubrication,
19 mm / 32 mm Weldon shank



Order No.	Spindle holder	Core drill tool holder
ZIA 219 - M	MK 2	19 mm Weldon shank
ZIA 319 - M	MK 3	19 mm Weldon shank
ZIA 332 - M	MK 3	32 mm Weldon shank

Industrial holder, with manual internal lubrication,
19 mm / 32mm Weldon shank



Order No.	Spindle holder	Core drill tool holder
ZIA 219 - KN	MK 2	19 mm Weldon shank
ZIA 319 - KN	MK 3	19 mm Weldon shank
ZIA 332 - KN	MK 3	32 mm Weldon shank

Cutting oil reservoir



Application:

Cutting oil reservoir for the automatic internal lubrication of BDS core drills in connection with the appropriate changeable drill chuck system.

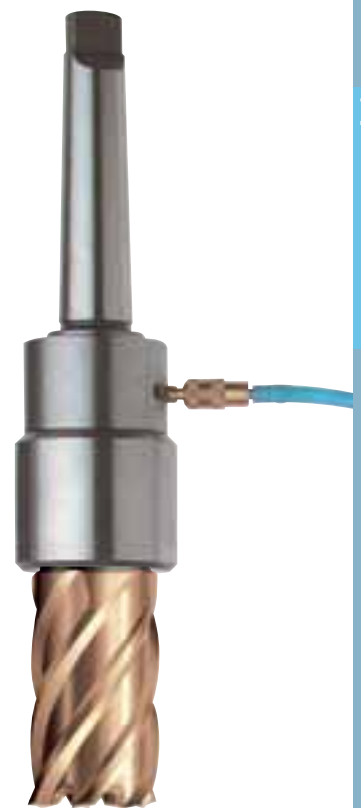
Version:

Reservoir with flow tap and magnetic holder.

Order No.

ZKK 100

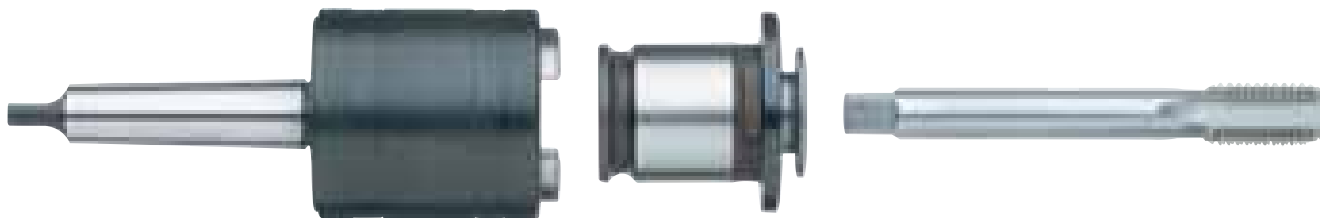
1.3



Quick change chuck system for taps

Basic holder and inserts

This quick change system allows the quick insertion and change of the taps.



Tapping quick-change chuck size 1, 2, 3 for taps M3, M5, M14



Application: Quick change chuck system for magnetic core drilling machines type: MAB 825 - 845
Version: Basic holder without quick change insert

Order No.	Holder	Thread
GSW 331	MK 3	M 3 – M 14
GSW 332	MK 3	M 5 – M 24
GSW 333	MK 3	M 14 – M 30

Quick change insert for taking up of taps for the tapping quick change chuck size 1, 2, 3



Application: Quick change chuck system for magnetic core drilling machines type: MAB 825 - 845
Version: Basic holder without quick change insert

Order No.	Size	Thread	Shank ø	Square
GSE 103	1	M3	3,5	2,7
GSE 104	1	M4	4,5	3,4
GSE 105	1	M5 / M6	6	4,9
GSE 108	1	M8	8	6,3
GSE 110	1	M10	10	8
GSE 112	1	M12	9	7,1
GSE 114	1	M14	11	9

Set of quick change inserts for tapping quick-change chucks size 1, 2, 3



Application: Quick change chuck system for magnetic core drilling machines type: MAB 825 - 845
Version: without basic holder

Order No.	Content
GSE 100	M3 - M14
GSE 200	M5 - M24
GSE 300	M14 - M30

Order No.	Size	Thread	Shank ø	Square
GSE 205	2	M5 / M6	6	4,9
GSE 208	2	M8	8	6,3
GSE 210	2	M10	10	8
GSE 212	2	M12	9	7,1
GSE 214	2	M14	11	9
GSE 216	2	M16	12	9
GSE 218	2	M18	14	11
GSE 220	2	M20	16	12
GSE 222	2	M22	18	14,5

Order No.	Size	Thread	Shank ø	Square
GSE 314	3	M14	11	9
GSE 316	3	M16	12	9
GSE 318	3	M18	14	11
GSE 320	3	M20	16	12
GSE 322	3	M22 / M24	18	14,5
GSE 327	3	M27	20	16
GSE 330	3	M30	22	18

...with friction clutch

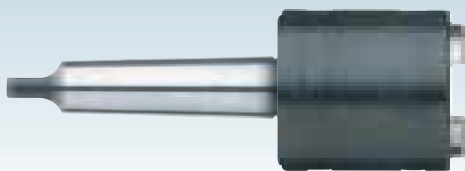
Basic holder and inserts with friction clutch



The safety coupling permits threadcutting of blind holes.

Inserts can also be used in combination with the quick-change threading chucks, size 2 GSW 332 in BDS magnetic core drill units MAB 828 and MAB 845 (old design MAB 800/840).

Tapping quick-change chuck size 2
for taps M8 – M16



Application: Quick change chuck system for magnetic core drilling machines type: MAB 485
Version: Tap holder without quick change insert

Order No.	Holder
GSW 222	MK 2

Quick change insert for the holding of taps for the tapping quick change chuck size 2



Application: Quick change chuck system for magnetic core drilling machines type: MAB 485
Version: Tap holder without quick change insert

Order No.	Size	Thread	Shank ø	Square
GSS 205	2	M5 / M6	6	4,9
GSS 208	2	M8	8	6,3
GSS 210	2	M10	10	8
GSS 212	2	M12	9	7,1
GSS 214	2	M14	11	9
GSS 216	2	M16	12	9

Tapping – quickly & economically priced!



Tap adapter with Weldon shank



Order No.	Thread	Shank ø	Square
ZGA 010	M10 DIN 376	7	5,5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14,5
ZGA 024	M24 DIN 376	18	14,5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18

Chucks, adapters and general accessories

Gear rim drill chuck



Order No.	Taper bore	Chuck size
ZBK 113	DIN 238-B 16	1 - 13 mm
ZBK 116	DIN 238-B 16	2,5 - 16 mm
ZBI 113	1/2" x 20 NF	1 - 13 mm
ZBI 116	1/2" x 20 NF	2,5 - 16 mm

Spare key for drill chuck

ZEZ 113
ZEZ 116

Quick-action drill chuck



Order No.	Taper bore	Chuck size
ZSB 113	DIN 238-B 16	1 - 13 mm
ZSB 116	DIN 238-B 16	3 - 16 mm
ZSI 113	1/2" x 20 NF	1 - 13 mm
ZSI 116	1/2" x 20 NF	3 - 16 mm

Taper drift for drill chuck with Taper bore DIN 238



Order No.	DIN Norm
ZKD 216	DIN 238 - MK2/B16
ZKD 316	DIN 238 - MK3/B16

Bushing 32 mm Weldon shank to 19 mm Weldon shank



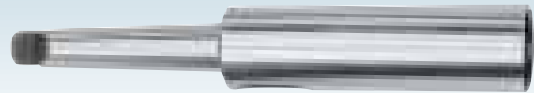
Order No.
ZAP 200

Reducing bush DIN 2185



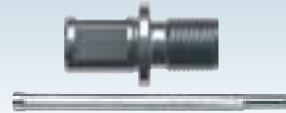
Order No.	Outside/inside
ZRH 210	MK 2:1
ZRH 320	MK 3:2

Extension bush DIN 2178



Order No.	Outside/inside
ZVH 220	MK 2:2
ZVH 230	MK 2:3
ZVH 320	MK 3:2
ZVH 330	MK 3:3

Adapter with Weldon shank 19 mm (3/4") for Fein core drills with thread M18 x 6 P1,5 incl. 1 Ejector pin ZAK 125



Order No.	Machine	Core drill
ZAF 002	Weldon 19 mm (3/4")	M18 x 6 P1,5

Adapter with Weldon shank 19 mm (3/4") for Fein core drills with Quick-In shank incl. 1 Ejector pin ZAK 115



Order No.	Machine	Core drill
ZAF 003	Weldon 19 mm (3/4")	Quick-IN

Adapter with Quick-In shank for core drills with Weldon shank 19 mm (3/4") incl. 1 ejector pin ZAK 107 and ZAK 125 each



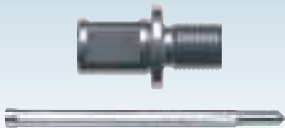
Order No.	Machine	Core drill
ZAF 004	Quick-IN	Weldon 19 mm (3/4")

Adapter with NITTO "One-Touch" shank for core drills with Weldon shank 19 mm (3/4") incl. 1 Ejector pin ZAK 107



Order No.	Machine	Core drill
ZAF 005	NITO "One-Touch"	Weldon 19 mm (3/4")

Adapter with Weldon shank 19 mm (3/4") for core drills with thread M16 x 1,5 incl. 1 Ejector pin ZAK 125



Order No.	Machine	Core drill
ZAF 006	Weldon 19 mm (3/4")	M16 x 1,5

Drill chuck adapter



Order No.	Machine	Core drill
ZAP 100	Weldon 19 mm (3/4")	1/2" x 20 NF

Weldon shank extension 80 mm, Weldon 19 mm (3/4") x Weldon 19 mm (3/4"), incl. ejector pin ZAK 080



Order No.	Machine	Core drill
ZAP 300	Weldon 19 mm (3/4")	Weldon 19 mm (3/4")

Drift key DIN 228



Order No.	Machine	Core drill
ZAS 002	MK 2	DIN 228
ZAS 003	MK 3	DIN 228

Chip protection for Magnetic Core Drilling Machines

Application: Chip protection for BDS Magnetic Core Drilling Machines, detachable



Order No.	For Series
ZSS 050	MAB 100 – MAB 480
ZSS 500	MAB 500 – MAB 850

Safety chain for Magnetic Core Drilling Machines



Order No.
ZSK 001

Steel carry case for Magnetic Core Drilling Machines



Application: Steel carry case for magnetic core drilling machines by BDS

Execution: Robust metal box with carrying handle and solid closures. With *foam insert, without contents.

Order No.	For Series
ZMK 100	MAB 100*
ZMK 150	MAB 150
ZMK 200	MAB 425, MAB 485*
ZMK 500	MAB 500, MAB 825, MAB 845*
ZMK 900	MAB 900
ZMK 1000	MAB 1000
ZMK 2000	AutoMAB
ZMK 205	MABasic 200
ZMK 805	MABasic 600, MABasic 850

BDS supplies

General Accessories

High-performance cutting oil BDS 5000: Pure vegetable oil, which is not considered a hazardous material according to the federal transportation regulations. The ingredients used are not contained in the catalogue of water polluting materials. BDS 5000 does not fall under the federal marking regulations.

- ▶ Biological base material with additives.
- ▶ Water hazard class 1.
- ▶ Biological decomposition, optimum basic adjustment of viscosity for the use of BDS core drills, straightforward usage for subsequent galvanizing.

Caution: Never use liquid lubricants for overhead or horizontal work. In such a case, oil might get into the motor causing short-circuit.

Please use BDS High-performance lubrication spray ZHS 400.

High-performance cutting paste BDS 5500: Ideal for heavily machinable materials such as high-alloy steel, Hardox, rust-resistant and heat-resistant steel. Suitable for overhead use and work in constrained positions.

High-performance lubrication spray BDS 5200: for work in constrained positions (overhead and horizontal), also suitable for high-alloy materials. Foamy paste with very high adhesive power.

Advantages: Exact amount of the lubrication spray, i.e. optimum lubrication directly at the cutting edges of the drill. No dripping and splashing, i.e. maximum working safety on ladders and platforms.

- ▶ PTFE-containing, white adhesive lubricant with protection against corrosion. Free from PCB, PCT, FCKW and Chlorine.
- ▶ **Active ingredient:** Lithium base grease on mineral basis with additives and solvent.
- ▶ **Propellant:** Propane/Butane, to be specified.

High-performance cutting oil BDS 5000



Order No.	Content
ZHS 005	5 l canister
ZHS 006	1 l can

High-performance cutting paste BDS 5500



Order No.	Content
ZHS 550	1000 g

High-performance lubrication spray BDS 5200



Order No.	Content
ZHS 400	1 x 400 ml
ZHS 406	6 x 400 ml
ZHS 412	12 x 400 ml

Cleaning spray BDS 1000



Order No.	Content
ZSR 100	500 ml can

Cleaning spray BDS 1000:

Optimal for repair and assembly work. The Spray cleaner ZSR 100 cleans and degreases all metals.

Unlike usual dilutions, the Spray cleaner ZSR 100 evaporates absolutely free from residues. The special valve also allows overhead work.

Soluble cutting oil BDS 6000:

For high demands based on synthetic raw materials.

- ▶ Soluble in water
- ▶ Compatible in toxicological viewpoint
- ▶ Water hazard class 1

Soluble cutting oil BDS 6000



Order No.	Content
ZHB 005	5 l canister

Power Worker

Indispensable in the workshop.

Power Worker: Sharp-edged drilling chips are its speciality.

The BDS Power Worker is there when there is a risk of injury - always and everywhere. Easily and safely it removes the drilling chips with magnetic power.

- ▶ Collecting
- ▶ Pushing off
- ▶ Done

It is obvious that the power of the Power Worker can also be used to remove metals from unapproachable positions,

and the key under the lathe comes to the surface again.

Power Worker
Order No.
POW 100



1.3



Hot, razor-sharp drilling chips are collected by the strong magnet and wiped off over the scrap metal container by actuating the mechanics without any risk of injury and wiped off over the scrap metal container by actuating the mechanics without any risk of injury.

The BDS Power Worker also very useful when picking up screws or other metal parts.

Deburring and Chamfering Machines

Competence and Innovation

2.1 Deburring and Chamfering Technology

Deburring and chamfering Page



EKF

Deburring and chamfering
machine

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Bevel edge milling



SKF

Bevel edge milling machine

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Accessories

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EKF 300, 450, 452

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Sintered carbide reversible disks

Milling cutters

Fixture

SKF 20

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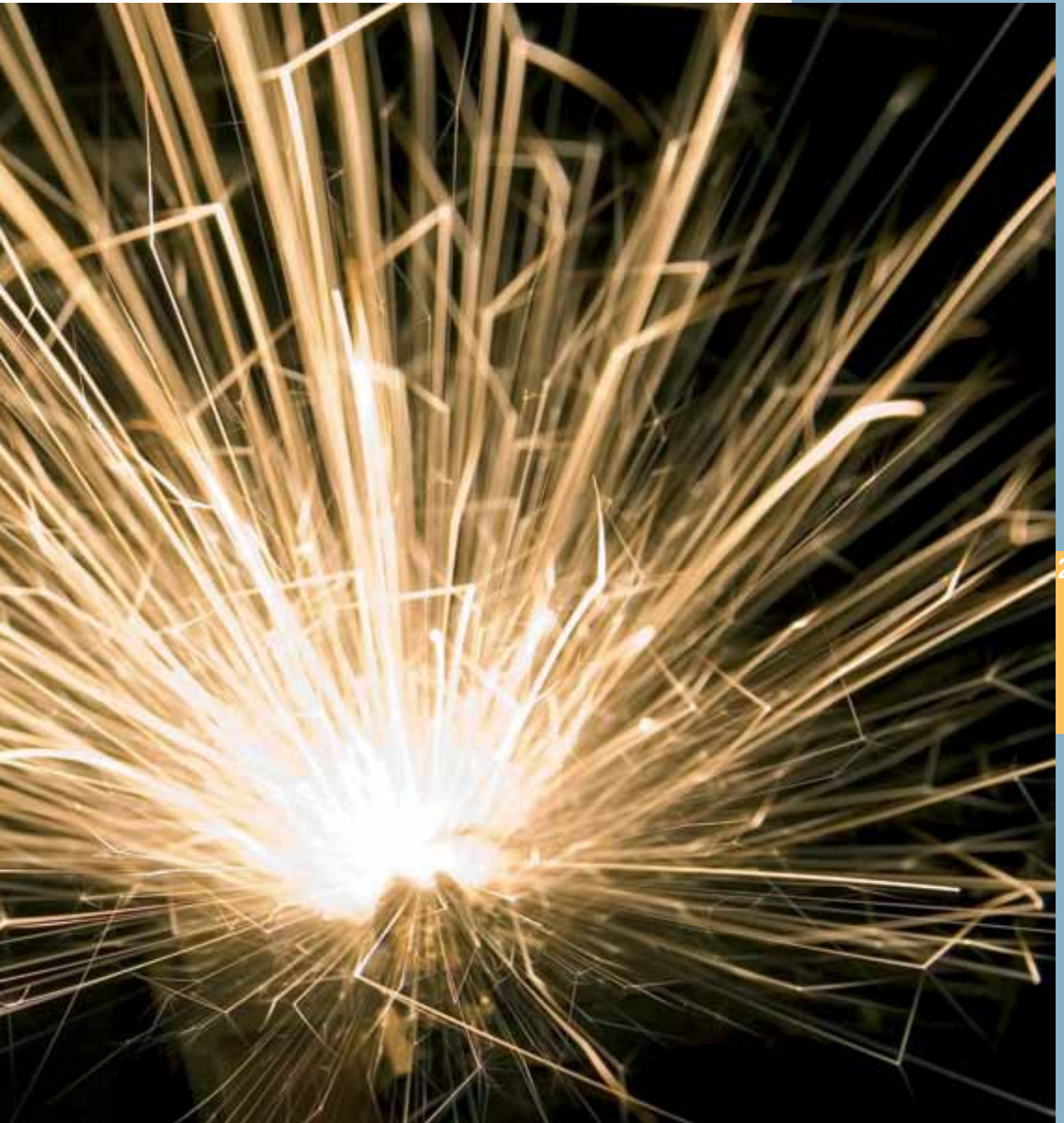
Reversible insert

Disk milling cutter

Milling spindle

Pipe insert





2.1

EKF 300, EKF 450, EKF 452

Deburring and chamfering machine by BDS. For quick and precise edge machining.

Made in Germany



Milling cutter 45° Chamfer 0 – 6 mm	optionally: Milling cutter 30° Chamfer 0 – 5 mm	optionally: Milling cutter radius 2.5 mm	Overheating pro- tection
--	---	--	-----------------------------

Boiler and process plant construction:

- ▶ Preparation of welding seams on heat exchangers (bores)
- ▶ Preparation of welding seams 30° up to 7 mm

Mechanical engineering:

- ▶ Deburring of machine parts
- ▶ Chamfering of edges as protection against peeling of the varnish after painting
- ▶ Making of visible edges

Sheet metal working:

- ▶ Deburring of cut edges

Mould making:

- ▶ Deburring of contours, radius, bore holes

Powerful
1500 W motor output



Handy

Compact design,
usable for all radii and
edges

High-precision

continuous adjustment of chamfer
widths by using a scale

Effective and flexible

Milling tools 30°, 45° and
radius 2.5 mm with 3 HM reversible
disks each



Milling tool



Fine adjustment



EKF Deburring and chamfering machine Specification:

Motor power:	1500 W
Soft start:	✓
Chamfer angle:	45° opt. 30° opt R 2,5
Land width:	45° 0-6 mm 30° 0-5 mm
Weight:	4,6 kg

Order No.

EKF 300.3/230 V

EKF 450.3/230 V

EKF 452.3/230 V, R = 2,5 mm

also available in 110 V version

Accessories

Sintered carbide reversible discs

SHM 200

SHM 200-E

SHM 202

Milling Cutters

ZFR 300.3

ZFR 450.3

ZFR 452.3

Fixture for stationary deburring of small parts

ZKF 100



Ideal for straight edges,
inner and outer radii.

EKF Scope of delivery

- 1 Deburring and chamfering machine
- 1 Milling cutter of your choice
- 3 sintered carbide reversible disks
- 1 Spanner SW 22
- 1 Steel carry case
- 1 Sickle spanner
- 1 Torx screw driver T 9
- 1 Operating manual
- 1 Warranty certificate

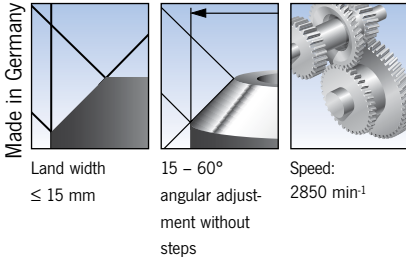
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The optimum fixture for stationary deburring of small parts (Order No. ZKF 100)

SKF 20

Good work planning – good results. Bevel edge milling machine by BDS.



The robust structure of the machine has been designed for continuous operation – that means saving time and costs.

The system works with 2 disk milling cutters, which are provided with 6 sintered carbide reversible disks each.

The BDS SKF 20 is suitable for the machining of

- ▶ standard steel
- ▶ stainless steel
- ▶ aluminium
- ▶ nonferrous heavy metal

Powerful

1.1 kw motor output, overload protection



Rugged and handy

Straightforward handling, single-operator control



Effective

2 disk milling cutters with 12 HM reversible disks

Continuous

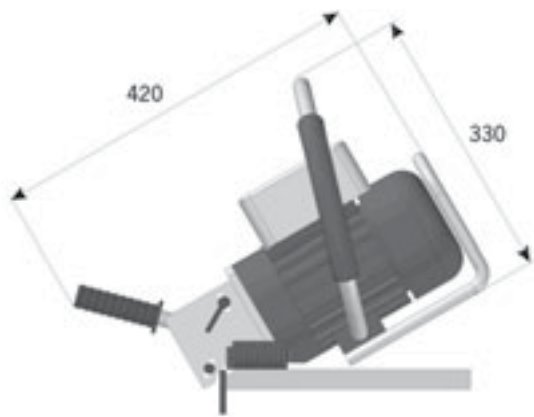
milling angle adjustment from 15° to 60°

Working safely

soft running guide rollers

Cool

Compressed air connection for tool cooling



SKF 20 Specification

Motor voltage:	220 - 240 V AC, 50 - 60 Hz
Output:	1,1 kW
Speed:	2850 min ⁻¹
Feed:	by manpower
Land width:	15 mm
Angular adjustment:	15 – 60° without steps
Safety:	automatic electric safety clutch/secured start
Dimensions: L x W x H:	420 x 330 x 300 mm
Weight:	22 kg
Tools:	2 disk milling cutters ø63mm provided with 12 sintered carbide reversible inserts

Order No.

SKF 020/ 230 Volt:

SKF 020/ 110 Volt:

Accessories

SHM 500 Reversible Insert

SFR 063 Disk milling cutter

SFS Milling spindle

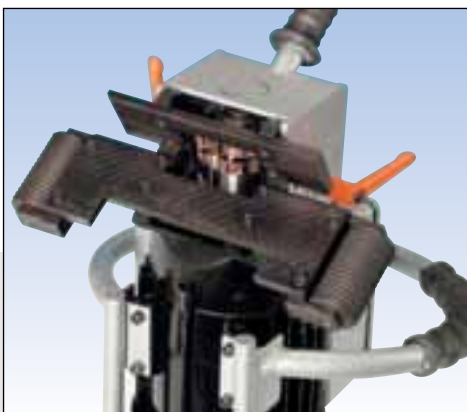
SRE Pipe insert



Scope of delivery

- 1 Bevel edge milling machine
- 1 Steel carry case
- 12 sintered carbide reversible inserts SHM 500
- 1 Sickle spanner
- 1 Hexagon socket screw key
- 1 Take-off for disk milling cutter
- 1 Operating manual
- 1 Warranty certificate

2.1



Precise roller guidance, low frictional resistance



Single-operator control, straightforward handling



The BDS network

Magnetic core drilling technology – innovative and competent.



Success by specialization

With innovation and quality, BDS Maschinen GmbH have firmly established in its niche. The specialist for core drilling in metal, active world-wide, advanced to one of the leading suppliers in this segment.



Consequent support of specialized dealers

Apart from quality and logistics, the communication with trade partners and users is a major feature for BDS that belongs to good service.

- Training of up-to-date know-how for new products and applications.
- Product training of traders.
- Theory and practice, locally on-site.
- Transfer of know-how and practical information on the subject of metal core drilling.
- Support with in-house exhibitions



Sales partners world-wide!

BDS products are in the meantime available in more than 60 countries throughout the world. Strong sales partners world-wide offer competent and individual consultation and services.



BDS - right at home on trade fairs!

Hanover, Stuttgart, Munich, Cologne, Milano, Paris, Shanghai and Seoul are firm dates in our annual fair calendar. As an innovative enterprise, BDS considers product development a duty for setting accents in the industry. Always one step ahead, is our claim. In world-wide competition, transfer is the duty to stand in the market also in future. However, it is also a stimulus and the joy of developing something new – no matter whether in products or in service.



Expert training on-site

BDS Maschinen passes expertise know-how for various subjects, for instance:

- magnetic core drilling machines in practical usage
- effective use of core drills
- useful accessories extending the options of application
- BDS service check-up

Please contact us – we are ready to spare a personal training session for you



BDS Homepage

The direct approach to competent information. The new edition of the BDS Homepage is one of the central sources for users and expert trade on national and international level.

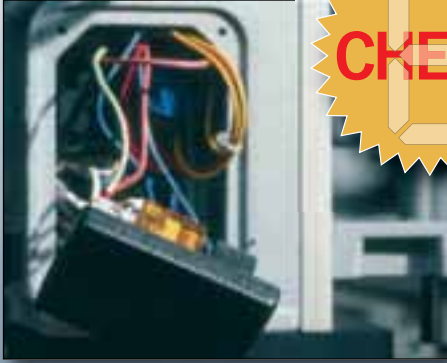
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With BDS always one step ahead.
For us everything is arranged around optimum service.



**E-Check – for MAB magne-
tic core drilling machines.**

E-CHECK is the approved test seal for electric equipment. It documents their proper condition and enables the recognition of hazards before a damage can occur.



BDS Maintenance Service.

We test and maintain your MAB magnetic core drilling machine and put it to the acid test. Our service offer includes a detailed inspection, replacement of defective parts, and basic cleaning. A regular maintenance of your MAB magnetic core drilling machines is characterized by a definitely longer machine service cycle.



BDS Shop-Center

BDS machines and core drills presented correctly. We actively support the trade dealers with the proper material for successful product presentation.



BDS Newsletter 2008

We inform our customers in regular intervals about up-to-date subjects of our company. In the BDS Newsletter, we report on new products, provide background information, present dealer activities and user solutions on the subject of magnetic drilling technique. Order your Newsletter online >> bds-maschinen.de



Positive press echo!

In the customer magazine of Messrs. Böhler Stahl, Edition 6/08 a detailed report is given on BDS machines – but not only there! A positive press echo is given regularly to BDS innovations in the most varying trade papers.



VarioPLUS: New hard coating!

By the development of the hard material coating VarioPLUS a successful approach has been made to optimize the positive features of BDS core drills. VarioPLUS obtains by a higher surface finish and hardness and by coating thicknesses in the range of 2.5 µm definitely longer tool lives.

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