

THE FULL RANGE

FOR ALL REQUIREMENTS

BDSMASCHINEN
MADE IN GERMANY



MAGNETIC CORE DRILLING MACHINES

Annular Cutters & Accessories 2020/2021

BDS
MASCHINEN

CORE DRILLING MACHINES FOR PROFESSIONALS.



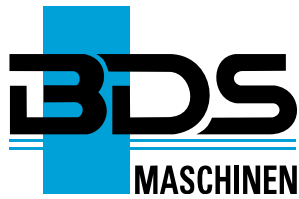
| Machine | MAB 485 | MAB 525 | MAB 825 | MAB 1300 | |
|----------------------------------|---------------------|---------------------|---------------------|---|-------------------------------------|
| | MAB 485 Swivel Base | MAB 525 Swivel Base | MAB 845 Swivel Base | | |
| Motor output | Watt | 1,150 | 1,600 | 1,800 | 2,300 |
| Voltage, V AC | Volt | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 |
| Core drill cutting depth max. | mm | 55 | 75 | 110 | 110 |
| Core drill max. Ø HSS/carbide | mm | 40/50 | 50/60 | 100 | 130 |
| Twist drill | ≤ Ø mm | 18 | 20 | 31.75 | 45 |
| Reaming | ≤ Ø mm | 18 | 20 | 31.75 | 50 |
| Countersinking | ≤ Ø mm | 40 | 50 | 50 | 80 |
| Thread cutting | ≤ Ø mm | 16 | 20 | 30 | 42 |
| Stroke | mm | 160 | 160 | 255 | 85/310 |
| Magnet dimensions | mm | 84 x 168 x 48 | 84 x 168 x 48 | 110 x 220 x 54 | 120 x 360 x 67 |
| Weight | kg | 13 | 16 | 25 | 51 |
| Spindle taper | | MT 2 | MT 3 | MT 3 | MT 4 |
| Weldon arbor | | | | Industrial arbor 32 mm Weldon 1 1/4" | Direct arbor 32 mm Weldon 1 1/4" |
| KEYLESS 19 mm Weldon 3/4" | | ✓ | ✓ | ✓ | |
| Speed gears | | 2 | 2 | 4 | 4 |
| Speed range | rpm | 50 - 450 | 70 - 580 | 40 - 600 | 30 - 550 |
| Permanent internal lubrication | | ✓ | ✓ | ✓ | ✓ |
| Safety clutch | | | | ✓ | ✓ |
| Torque control | | | ✓ | ✓ | ✓ |
| Full wave control electronics | | ✓ | ✓ | ✓ | ✓ |
| Magnet indicator | | ✓ | ✓ | ✓ | ✓ |
| Overheating protection | | ✓ | ✓ | ✓ | ✓ |
| Clockwise/anticlockwise rotation | | ✓ | ✓ | ✓ | ✓ |
| Carbon brush wear indicator | | ✓ | ✓ | ✓ | ✓ |
| Catalogue page | | 7 | 8 | 10 | 12 |

KEY SPECIFICATIONS AT A GLANCE:



| ProfiSTART | | | ProfiBASIC | | | |
|-----------------|--------------------------------|-----------------------------------|-----------------------------------|-----------------------------------|---------------------------------------|---|
| MAB 100 K | MAB 455 MAB 455 Swivel Base | MAB 465 | MABasic 200 | MABasic 400 | MABasic 450 | MABasic 850 |
| 1,050 | 1,150 | 1,150 | 1,050 | 1,050 | 1,150 | 1,800 |
| 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 |
| 55 | 55 | 55 | 55 | 55 | 55 | 110 |
| 32 | 40/50 | 40/50 | 32 | 35 | 40/50 | 75 |
| | 18 | 16 | 13 | 16 | 18 | 31.75 |
| | | 40 | | | | |
| | | 16 | | | | |
| 70 | 160 | 160 | 160 | 160 | 160 | 255 |
| 80 x 160 x 41.5 | 84 x 168 x 48 | 84 x 168 x 48 | 84 x 168 x 48 | 84 x 168 x 48 | 84 x 168 x 48 | 110 x 220 x 56 |
| 9.9 | 13 | 13 | 12 | 12 | 13 | 24 |
| | MT 2 | | | | MT 2 | MT 3 |
| | | Direct arbor 19 mm Weldon 3/4" | Direct arbor 19 mm Weldon 3/4" | Direct arbor 19 mm Weldon 3/4" | Industrial arbor 19 mm Weldon 3/4" | Industrial arbor 19 mm 3/4" + 32 mm 1 1/4" |
| ✓ | ✓ | | | | | |
| 1 | 2 | 2 | 1 | 2 | 2 | 4 |
| 460 | 250 - 450 | 50 - 450 | 460 | 430 - 760 | 250 - 450 | 110 - 385 |
| ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |
| | | | | | | |
| | | ✓ | | | | |
| ✓ | ✓ | ✓ | | | | |
| | | ✓ | | | | |
| | | ✓ | | | | |
| 15 | 16 | 17 | 19 | 20 | 21 | 22 |

SPECIAL MACHINES FOR SPECIAL TASKS.



| Machine | | MAB 825 KTS | AutoMAB 350 | AutoMAB 450 | MAB 825 V MAB 845 V |
|--|--------|---|--|--|---|
| Motor output | Watt | 1,800 | 1,050 | 1,150 | 1,800 |
| Voltage, V AC | Volt | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 | 230 - 110/125 |
| Core drill cutting depth max. | mm | 55 | 55 | 55 | 110 |
| Core drill max. Ø HSS/carbide | mm | 80 | 35 | 45 | 100 |
| Twist drill | ≤ Ø mm | 31.75 | | | 31.75 |
| Reaming | ≤ Ø mm | 31.75 | | | 31.75 |
| Countersinking | ≤ Ø mm | 50 | | | 50 |
| Thread cutting | ≤ Ø mm | 30 | | | 30 |
| Stroke | mm | 255 | 150 | 150 | 255 |
| Magnet dimensions | mm | 220 x 220 x 54 | 84 x 168 x 48 | 84 x 168 x 48 | 110 x 220 x 54 |
| Weight | kg | 57.5 | 15 | 16 | 34 |
| Spindle taper | | MT 3 | | MT 2 | MT 3 |
| Weldon arbor | | Industrial arbor 19 mm ³ / ₄ " + 32 mm 1 ¹ / ₄ " | Direct arbor 19 mm Weldon ³ / ₄ " | Industrial arbor 19 mm Weldon ³ / ₄ " | Industrial arbor 19 mm ³ / ₄ " + 32 mm 1 ¹ / ₄ " |
| KEYLESS 19 mm Weldon ³ / ₄ " | | | | | |
| Speed gears | | 4 | 1 | 2 | 4 |
| Speed range | rpm | 40 – 600 | 460 | 250 – 450 | 40 – 600 |
| Permanent internal lubrication | | ✓ | ✓ | ✓ | ✓ |
| Safety clutch | | ✓ | | | ✓ |
| Torque control | | ✓ | | | ✓ |
| Full wave control electronics | | ✓ | | | ✓ |
| Magnet indicator | | ✓ | ✓ | ✓ | ✓ |
| Overheating protection | | ✓ | | | ✓ |
| Clockwise/anticlockwise rotation | | ✓ | | | ✓ |
| Carbon brush wear indicator | | ✓ | | | ✓ |
| Catalogue page | | 25 | 26 | 27 | 28 |

BDS HAS IT:



| MAB 1300 V | MAB 155 | AirMAB 5000 | RailMAB 915 | RailMAB 965 |
|---|-----------------------------------|---------------|---------------------------------------|-----------------------------------|
| 2,300 | 1,050 | 830 | 1,600 | 1,500 |
| 230 - 110/125 | 230 - 110/125 | | 230 - 110/125 | Petrol (Benzin) driven |
| 110 | 30 | 55 | 55 | 30 |
| 130 | 35 | 35 | 36 | 36 |
| 45 | | 23 | | |
| 50 | | | | |
| 80 | | | | |
| 42 | | | | |
| 310 | 39 | 160 | 160 | 40 |
| 120 x 360 x 67 | 80 x 160 x 36.5 | 90 x 160 x 60 | | |
| 51 | 11 | 17.5 | 17 | 21.5 |
| MT 4 | | MT 2 | MT 3 | |
| Industrial arbor 19 mm 3/4" + 32 mm 1 1/4" | Direct arbor 19 mm Weldon 3/4" | | Industrial arbor 19 mm Weldon 3/4" | Direct arbor 19 mm Weldon 3/4" |
| | | ✓ | | |
| 4 | 1 | 1 | 2 | 1 |
| 30 - 550 | 320 | 290 - 575 | 70 - 580 | 110 - 280 |
| ✓ | | ✓ | ✓ | ✓ |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| ✓ | | | ✓ | |
| 29 | 30 | 31 | 32 | 33 |

The heavy-duty magnetic drilling machines with all features as well as reversible motor. Ideal for professional users in structural engineering & heavy engineering companies.



**TOP PERFORMANCE
IN A NEW DESIGN**



MAB 485 / 485 SB

The compact all-rounder. Wide range of possible applications and excellent performance make the MAB 485 / MAB 485 SB one of the most popular machines among metal-working professionals.

THE BESTSELLER AMONG PROFESSIONALS

For greater comfort and precision, there is the MAB 485 SB with a Swivel Base adjustment fixture. This makes centering of the hole to be drilled easier and quicker.



Overheating protection

Magnet indicator

Permanent internal lubrication

Swivel base adjustment device for MAB 485 SB
(More information on page 9)



ProfiPLUS

ProfiSTART

ProfiBASIC

ProfiSPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

MAB 485/485 SB

| | |
|----------------------------------|-----------------------|
| Motor output | 1,150 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 13 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Spindle taper | MT 2 |
| Gear 1 range | 50 – 250 rpm |
| Gear 2 range | 100 – 450 rpm |
| Permanent internal lubrication | ✓ |
| Full wave control electronics | ✓ |
| Magnet indicator | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Carbon brush wear indicator | ✓ |
| MAB 485 230 V | MAB 485 110/125 V |
| MAB 485SB 230 V | MAB 485SB 110/125 V |

Included in delivery

- 1 Magnetic core drilling machine 485/485 SB
- 1 KEYLESS quick-change drilling system 19 mm Weldon (3/4")
- 1 Tapping adapter ZGA 010, ZGA 012, ZGA 016
- 1 Ejector pin ZAK 075 +100
- 1 Hard-top case
- 1 Safety lashing strap
- 1 Ejector drift MT 2
- 1 Gear rim drill chuck 1 - 13 mm
- 1 Taper drift MT 2/B16
- 1 Operating instructions

Core drill Twist drill Reamer Countersink Tapping

| | | | | |
|------------------------------|---------|---------|---------|-----|
| HSS Ø 40 mm | Ø 18 mm | Ø 18 mm | Ø 40 mm | M16 |
| TCT Ø 50 mm | | | | |
| Cutting depth: 30 - 55 mm | | | | |



MAB 525 / 525 SB

The compact heavy-duty machine with more motor power and less weight.

THE STRONG COMPACT MACHINES

Magnetic core drilling machine with two-speed oil bath gearbox. Ideal for the service and maintenance department thanks to just 16 kg. weight. With MT 3 Morse taper system and drilling capacity up to Ø 50 mm. Torsion-resistant design through single-piece gearbox housing with slide.

- Overheating protection
- Torque control
- Full wave control electronics
- Clockwise/anticlockwise rotation
- Quick-change drilling system
- Permanent internal lubrication
- Magnet indicator



| MAB 525/525 SB | |
|----------------------------------|-----------------------|
| Motor output | 1,600 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 16 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Spindle taper | MT 3 |
| Gear 1 range | 70 – 280 rpm |
| Gear 2 range | 180 – 580 rpm |
| Permanent internal lubrication | ✓ |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Magnet indicator | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Carbon brush wear indicator | ✓ |
| MAB 525 230 V | MAB 525 110/125 V |
| MAB 525SB 230 V | MAB 525SB 110/125 V |

| Included in delivery | | | | |
|--|--|--|--|--|
| 1 Magnetic core drilling machine | | | | |
| 1 KEYLESS quick-change drilling system 19 mm Weldon (3/4") | | | | |
| 1 Tapping adapter ZGA 010, ZGA 012, ZGA 016 | | | | |
| 1 Ejector pin ZAK 075, ZAK 100 | | | | |
| 1 Hard-top case | | | | |
| 1 Safety lashing strap | | | | |
| 1 Taper drift MT 3/B16 | | | | |
| 1 Gear rim drill chuck 1 - 13 mm | | | | |
| 1 Ejector drift MT 3 | | | | |
| 1 Operating instructions | | | | |

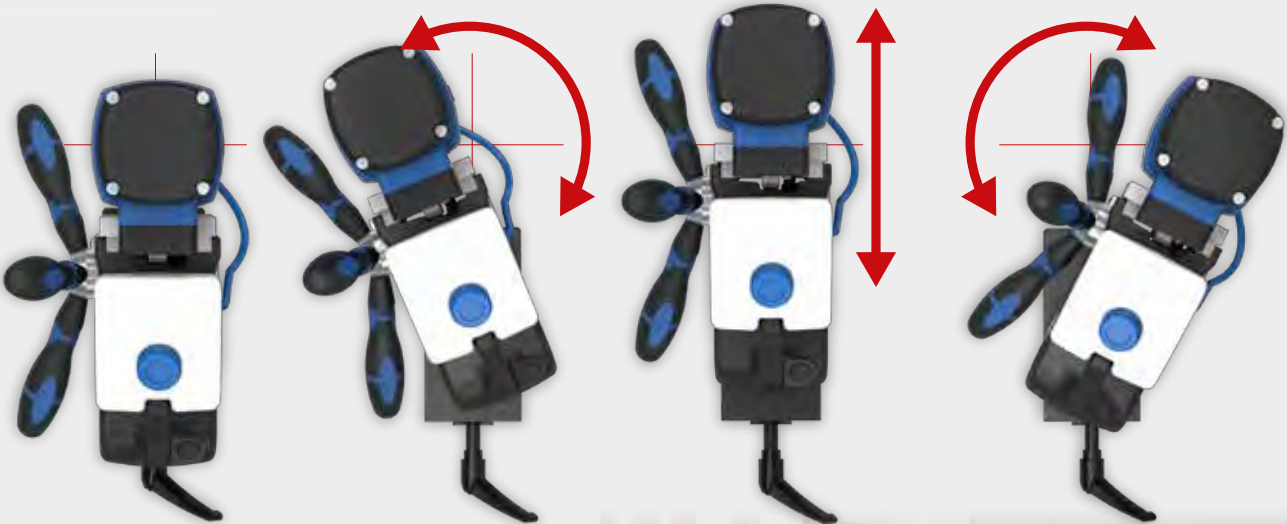
| Core drill | Twist drill | Reamer | Countersink | Tapping |
|-------------------------------|-------------|---------|-------------|---------|
| HSS Ø 50 mm | Ø 20 mm | Ø 20 mm | Ø 50 mm | M20 |
| TCT Ø 60 mm | | | | |
| Cutting depth: 30-55-75 mm | | | | |



Anyone who has ever worked with Swivel Base equipped machines from BDS will never wish to be drill without it again. Swivel Base allows precise, accurate centering of the hole to be drilled without having to move the complete weight of the machine at the same time. Ideal for overhead and horizontal drilling situations.



FOR QUICKER AND SAFER WORK



The Swivel Base technology of BDS allows easy and precise movement of the drilling machine on the magnet. The machine can be swivelled by 20° to the left and right and be moved 15 mm forward and backward.

Precise centring is thus significantly easier. Swivel Base ensures greater comfort and safety particularly when working on a vertical surface or overhead.



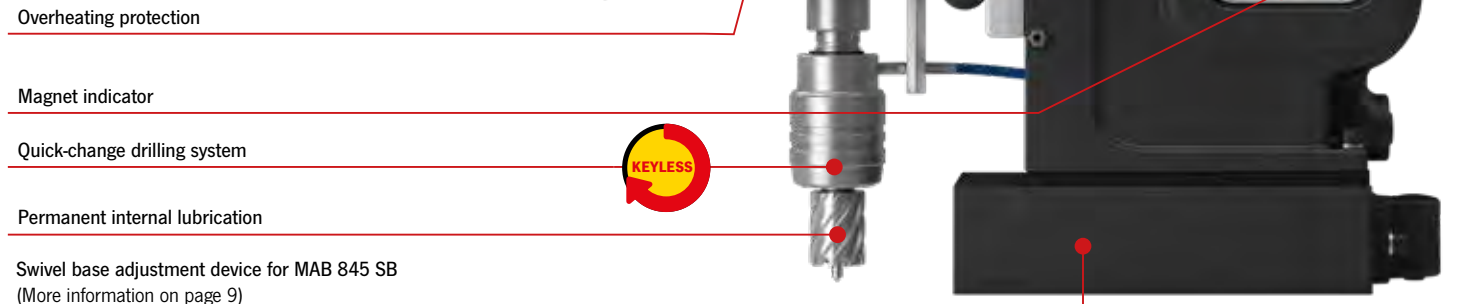
- 1.** Put the machine in roughly the right position.
- 2.** Switch on the magnet.
- 3.** Unlock adjustment device and effortlessly adjust machine precisely.
- 4.** Lock the adjustment device with the hand lever again, once the center of the hole is achieved.

MAB 825 / MAB 845 SB

The classic among the large BDS magnetic core drilling machines. For core drilling up to Ø 100 mm and 110 mm cutting depth.

**WELCOME
TO THE
TOP CLASS**

Entry to the top class with strong output and a high degree of flexibility. Suitable for twist drilling, reaming, countersink and tapping.



Carbon brush wear indicator
Internal cable feed
Full wave control electronics
Clockwise/anti-clockwise rotation

Overheating protection

Magnet indicator

Quick-change drilling system



Permanent internal lubrication

Swivel base adjustment device for MAB 845 SB
(More information on page 9)

| MAB 825/MAB 845 SB | |
|----------------------------------|-----------------------------|
| Motor output | 1,800 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 255 mm |
| Magnet dimensions | 110 x 220 x 54 mm |
| Weight | 25 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Industrial arbor | MT 3, 32 mm (1 1/4") |
| Spindle taper | MT 3 |
| Gear 1 range: 40 – 110 rpm | Gear 2 range: 65 – 175 rpm |
| Gear 3 range: 140 – 360 rpm | Gear 4 range: 220 – 600 rpm |
| Safety clutch | ✓ |
| Permanent internal lubrication | ✓ |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Magnet indicator | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Carbon brush wear indicator | ✓ |
| MAB 825 230 V | MAB 825 110/125 V |
| MAB 845 SB 230 V | MAB 845 SB 110/125 V |

| Included in delivery | |
|--|--|
| 1 Magnetic core drilling machine | |
| 1 KEYLESS quick-change drilling system 19 mm Weldon (3/4") | |
| 1 Industrial arbor ZIA 332-KN, 32 mm Weldon (1 1/4") | |
| 1 Ejector pin ZAK 075, 090, 100, 120 | |
| 1 Carry case on wheels | |
| 1 Safety lashing strap | |
| 1 Offset screwdriver size 6 | |
| 1 Ejector drift MT 3 | |
| 1 Operating instructions | |

| Core drill | Twist drill | Reamer | Countersink | Tapping |
|-----------------------------------|-------------|------------|-------------|---------|
| Max. Ø 100 mm | Ø 31.75 mm | Ø 31.75 mm | Ø 50 mm | M30 |
| Cutting depth: 30-55-75-110 mm | | | | |



BDS Special Purpose Drilling Machines

WHAT IS NEEDED

IS SPECIALLY BUILT

BDS already has the correct machine in its range for the vast majority of applications. However, every now and then tasks crop up that cannot be completed optimally with existing technology. In such special cases, we develop customised special machines in small series or even as single pieces for our customers. We will be happy to quantities your individual solution for you. Here you can see three examples out of hundreds of solutions already delivered.

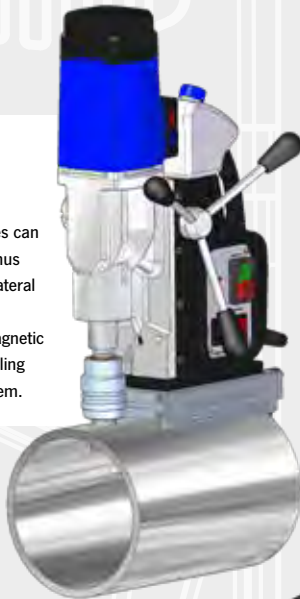
Do you have specific tasks that cannot be completed optimally with existing tools? Do not hesitate to ask us. We will be happy to provide you with advice with no obligation. You need it? We will build it!



MAB 525 with prism clamping system for machining pipes

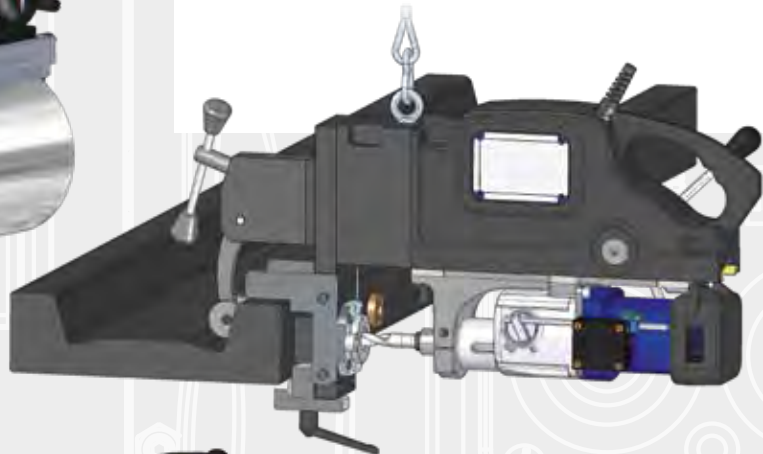
The prism plates adjustable at the sides can be adapted to the pipe diameter and thus stabilise the core drilling unit against lateral twisting.

The magnetic retaining force of the magnetic core drilling machine now fixes the drilling unit to the pipe with the clamping system.



MAB 825 PS

Specially retooled MAB 825 magnetic core drilling machine with rail clamping system for precise fitted bores in special profiles with a drilling template.



MAB 825 W90

Small angular drilling machines can do lots of things. But in this particular case, the challenge was considerable. With a 90° clamping angle, BDS has solved the problem.



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ProfiSTART

ProfiBASIC

ProfiSPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

MAB 1300

Superior performance with exceptional power delivery.

THE STRONGEST OF THE STRONG!

Pure power! 2,300 W motor power, four speeds and a full package of features leave nothing to be desired. The MAB 1300 goes to the limit of magnetic core drill technology.

Full wave control electronics

Overheating protection

Torque control

Clockwise/anticlockwise rotation

Magnet indicator

Permanent internal lubrication

Drilling of diameters up to 130 mm





The MAB 1300 magnetic core drilling machine is currently the strongest magnetic core drilling machine available with a reversible motor. The appearance of these drills alone shows what they are about: Pure power! 2,300 W powerful motor, four-speed gear-box and a full package of features leave nothing to be desired. This magnetic core drilling machine meets all the requirements made by heavy-duty structure engineering, shipbuilding, and mechanical engineering. Core drilling capacity up to 130 mm diameter (30 mm cutting depth) is possible. The full range of the BDS core drills can thus be utilized to its full extent. As standard, the MAB 1300 has a direct arbor with a 32 mm Weldon shank. Without the solid steady, which can be removed very easily, the stroke of the drill increases to an impressive 310 mm. The MAB 1300 magnetic core drilling machine is also fully equipped with all the safety features of modern magnetic core drill technology. The premium feature of the MAB 1300 is the Power-Assist, servo-assisted drilling for effortless drilling, especially for larger diameters.

| MAB 1300 | |
|----------------------------------|-----------------------------|
| Motor output | 2,300 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke/without steady | 85/310 mm |
| Magnet dimensions | 120 x 360 x 65 mm |
| Weight | 51 kg |
| Spindle taper | MT 4 |
| Gear 1 range: 30 – 80 rpm | Gear 2 range: 50 – 120 rpm |
| Gear 3 range: 130 – 350 rpm | Gear 4 range: 210 – 550 rpm |
| Safety clutch | ✓ |
| Permanent internal lubrication | ✓ |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Magnet indicator | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Carbon brush wear indicator | ✓ |
| Power-Assist servo drilling | ✓ |
| MAB 1300 230 V | |
| MAB 1300 110/125 V | |

| Included in delivery | |
|--|--|
| 1 Magnetic core drilling machine | |
| 1 Carry case on wheels | |
| 1 Safety lashing strap | |
| 1 Offset screwdriver size 4, 6, 8 | |
| 1 Ejector pin ZAK 075, 090, 100, 120 | |
| 1 Ejector drift MT 4 | |
| 1 Bushing ZAP 200 from Weldon 32 mm to 19 mm | |
| 1 Operating instructions | |

| Core drill | Twist drill | Reamer | Countersink | Tapping |
|-----------------------------------|-------------|---------|-------------|---------|
| Max. Ø 130 mm | Ø 45 mm | Ø 50 mm | Ø 80 mm | M42 |
| Cutting depth: 30-55-75-110 mm | | | | |



Note:

When using core drills with a cutting depth of 110 mm, the steady must be removed. In addition, you require a MT 4 ZIA 419-KN or ZIA 432-KN industrial arbor.

ProfiPLUS

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ProfiBASIC

ProfiSPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

Getting started with BDS premium technology technology:
Sturdy, fully developed machines for professional users.
Reliable and tested continuous operation in tough conditions.



ProfiSTART

**WITH OPTIMISED
ERGONOMICS
AND PERFORMANCE**



MAB 100 K

Compact, handy, powerful.
The right magnetic core drilling machine,
when low weight is the priority.

THE LIGHTWEIGHT HEAVY PERFORMER

At just 9.9 kg, the MAB 100 K is the lightweight of the BDS range. Easy to handle and with a low overall height. The internal wiring ensures a high degree of safety during work. Equipped with KEYLESS quick-change drilling system.



Quick-change drilling system

Magnet indicator

Permanent internal lubrication



| MAB 100 K | |
|--------------------------------|-----------------------|
| Motor output | 1,050 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 70 mm |
| Magnet dimensions | 80 x 160 x 41.5 mm |
| Weight | 9.9 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Gear range | 460 rpm |
| Permanent internal lubrication | ✓ |
| MAB 100 230 V | |
| MAB 100 110/125 V | |

| Included in delivery |
|----------------------------------|
| 1 Magnetic core drilling machine |
| 1 Ejector pin ZAK 075 +100 |
| 1 Hard-top case |
| 1 Safety lashing strap |
| 1 Operating instructions |

| Core drill |
|------------------------------|
| Max. Ø 32 mm |
| Cutting depth: 30 - 55 mm |



(Twist drilling up to 13 mm diameter possible only with Twist Drills with Weldon Shaft. See page 68)

ProfiSTART

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ProfiSPEZIAL

Arbors
and adapters

Accessories and
consumables

Drills

About BDS

MAB 455 / 455 SB

Weather its for a workshop or in the field – the first choice for metal working!

PERFECT FOR THE WORKSHOP AND ON THE ASSEMBLY LINE

Available with the Swivel Base adjustment device for easy centring even when drilling overhead or on a vertical surface. More information about Swivel Base can be found on page 9.



Magnet indicator

Quick-change drilling system



Permanent internal lubrication



| MAB 455/455 SB | |
|--------------------------------|-----------------------|
| Motor output | 1,150 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 13 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Spindle taper | MT 2 |
| Gear 1 range | 250 rpm |
| Gear 2 range | 450 rpm |
| Permanent internal lubrication | ✓ |
| Magnet indicator | ✓ |
| MAB 455 230 V | MAB 455 110/125 V |
| MAB 455SB 230 V | MAB 455SB 110/125 V |

| Included in delivery | |
|--|--|
| 1 Magnetic core drilling machine | |
| 1 KEYLESS quick-change drilling system 19 mm Weldon (3/4") | |
| 1 Ejector pin ZAK 075, 100 | |
| 1 Hard-top case | |
| 1 Safety lashing strap | |
| 1 Ejector drift MT 2 | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|----------------|-------------|
| HSS Ø 40 mm | Ø 18 mm |
| TCT Ø 50 mm | |
| Cutting depth: | |
| 30-55 mm | |



MAB 465

The compact drilling unit from the ProfiSTART series with electronic control and clockwise/anticlockwise rotation. For core drilling and thread cutting.

GREAT POWER FOR A SMALL PRICE

A compact yet powerful model with an output of 1,150 W reversible motor ideal for drilling and tapping. Versatility for use in workshop and on the go with a transport weight of just 13 kg.

Internal cable feed

Overheating protection

Magnet indicator

Permanent internal lubrication

Full wave control electronics

Variable speed control

Clockwise/
anticlockwise rotation



MAB 465

| | |
|----------------------------------|----------------------------------|
| Motor output | 1,150 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 13 kg |
| Direct arbor | 19 mm Weldon ($\frac{3}{4}$ ") |
| Gear 1 range | 50 – 250 rpm |
| Gear 2 range | 100 – 450 rpm |
| Permanent internal lubrication | ✓ |
| Full wave control electronics | ✓ |
| Magnet indicator | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| MAB 465 230 V | |
| MAB 465 110/125 V | |

Included in delivery

- 1 Magnetic core drilling machine
- 1 Hexagonal offset screwdriver size 4
- 1 Ejector pin ZAK 075, 100
- 1 Hard-top case
- 1 Operating instructions
- 1 Safety lashing strap

Core drill Twist drill Countersink Tapping

| | | | |
|----------------------------|---------|---------|-----|
| HSS Ø 40 mm | Ø 16 mm | Ø 40 mm | M16 |
| TCT Ø 50 mm | | | |
| Cutting depth: 30-55 mm | | | |



ProfiSTART

ProfiBASIC

ProfiSPEZIAL

Arbors
and adapters

Accessories and
consumables

Drills

About BDS

The machine series for professional users who do not wish to compromise on quality or performance but can dispense with convenience and certain features.
Genuine BDS quality at an attractive price!



MABasic 200

No one needs to compromise on the BDS "Made in Germany" quality of workmanship. BDS delivers top performance even in the lower price bracket.

THE SMALL MACHINE

WITH A LARGE

IMPACT!

Who says that only big machines can do big things? The MABasic 200 proves the opposite. It will ensure that you are well equipped for professional use on site and in the workshop.



Switches are arranged on the back for safe and easy operation

Permanent internal lubrication



Coolant tank mounted on the side

| MABasic 200 | |
|--------------------------------|----------------------|
| Motor output | 1050 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 12 kg |
| Direct arbor | 19 mm Weldon (3/4") |
| Gear 1 range | 450 rpm |
| Permanent internal lubrication | ✓ |
| MABasic 200 230 V | |
| MABasic 200 110/125 V | |

| Included in delivery | |
|----------------------------------|--|
| 1 Magnetic core drilling machine | |
| 1 Ejector pin ZAK 075 | |
| 1 Plastic carry case | |
| 1 Safety lashing strap | |
| 1 Allen key size 4 | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|----------------------------|-------------|
| Max. Ø 32 mm | Ø 13 mm |
| Cutting depth: 30-55 mm | |



ProfiBASIC

ProfiSPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

MABasic 400

Sturdy and reliable 1,050 W motor with high speed.

THE FAST RUNNER

IDEAL FOR

TWIST DRILLS

The motor safety switch and magnet switch are positioned in the middle of the back of the machine on an anti-glare display. The MABasic 400 can thus be operated safely even during overhead work or when working on a vertical surface.



Switches are arranged on the back for safe and easy operation

Two-speed gearbox with high speed for twist drills

Permanent internal lubrication



Coolant tank mounted on the side



| MABasic 400 | |
|--------------------------------|----------------------|
| Motor output | 1050 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 12 kg |
| Direct arbor | 19 mm Weldon (3/4") |
| Gear 1 range | 430 rpm |
| Gear 2 range | 760 rpm |
| Permanent internal lubrication | ✓ |
| MABasic 400 230 V | |
| MABasic 400 110/125 V | |

| Included in delivery | |
|----------------------------------|--|
| 1 Magnetic core drilling machine | |
| 1 Ejector pin ZAK 075 | |
| 1 Plastic carry case | |
| 1 Safety lashing strap | |
| 1 Allen key size 4 | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|----------------------------|-------------|
| Max. Ø 35 mm | Ø 16 mm |
| Cutting depth: 30-55 mm | |



MABasic 450

Flexible handling thanks to MT 2 tool changing system.

WITH MT 2 CHANGING SYSTEM

With an ample motor power of 1,150 W with a weight of just 13 kg, this is a portable and reliable workhorse in the workshop and on the assembly line. Drilling of diameters up to 40 mm / 50 mm with a cutting depth of 55 mm is possible.



Switches are arranged on the back for safe and easy operation

MT 2 Spindle taper

MT 2 Industrial arbor

Permanent internal lubrication



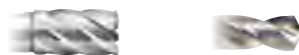
Coolant tank mounted on the side



| MABasic 450 | |
|---|---------------------------|
| Motor output | 1,150 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 84 x 168 x 48 mm |
| Weight | 13 kg |
| Industrial arbor | MT 2 ,19 mm Weldon (3/4") |
| Spindle taper | MT 2 |
| Gear 1 range | 250 rpm |
| Gear 2 range | 450 rpm |
| Permanent internal lubrication with integrated tank | ✓ |
| MABasic 450 230 V | |
| MABasic 450 110/125 V | |

| Included in delivery | |
|--|--|
| 1 Magnetic core drilling machine | |
| 1 Industrial arbor ZIA 219-KN, 19 mm Weldon (3/4") | |
| 1 Ejector pin ZAK 075 | |
| 1 Ejector drift MT 2 | |
| 1 Plastic carry case | |
| 1 Safety lashing strap | |
| 1 Allen key size 5 | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|-------------------------|-------------|
| HSS Ø 40 mm | Ø 18 mm |
| TCT Ø 50 mm | |
| Cutting depth: 30-55 mm | |



ProfiBASIC

ProfiSPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

MABasic 850

Full power for demanding tasks. This machine will offer you an extremely powerful and reliable drilling solution with the BDS quality.

WITH 1800 W
SUITABLE FOR
EXTREME TASKS

Ample performance with a 1,800 Watt motor. Thanks to the 255 mm stroke, larger parts can also be machined with this magnetic core drilling machine. The MABasic 850 is designed for core drills with a diameter of up to 75 mm and length up to 110 mm. This is an ideal machine drilling twist drill bits up to 31.75 mm diameter with MT3 Shank.

4-speed gearbox

MT 3 Spindle taper

Permanent internal lubrication



Switches are arranged on the back for safe and easy operation

| MABasic 850 | |
|--------------------------------|-----------------------------|
| Motor output | 1,800 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 255 mm |
| Magnet dimensions | 110 x 220 x 54 mm |
| Weight | 24 kg |
| Industrial arbor | MT 3, 19 mm Weldon (3/4") |
| Industrial arbor | MT 3, 32 mm Weldon (1 1/4") |
| Spindle taper | MT 3 |
| Gear 1 range: 110 rpm | Gear 2 range: 175 rpm |
| Gear 3 range: 425 rpm | Gear 4 range: 385 rpm |
| Permanent internal lubrication | ✓ |
| MABasic 850 230 V | |
| MABasic 850 110/125 V | |

| Included in delivery | |
|--|--|
| 1 Magnetic core drilling machine | |
| 1 Industrial arbor ZIA 319-KN, 19 mm Weldon (3/4") | |
| 1 Industrial arbor ZIA 332-KN, 32 mm Weldon (1 1/4") | |
| 1 Ejector pin ZAK 075 + 90 + 100 + 120 | |
| 1 Ejector drift MT 3 | |
| 1 Plastic carry case | |
| 1 Safety lashing strap | |
| 1 Allen key sizes 5 + 6 | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|-----------------|-------------|
| Max. Ø 75 mm | Ø 31.75 mm |
| Cutting depth: | |
| 30-55-75-110 mm | |



ALWAYS THERE FOR YOU BEFORE AND AFTER A PURCHASE

WORRY TAKEN OUT OF EVERYTHING THANKS TO BDS PREMIUM SERVICE

Machine check-up

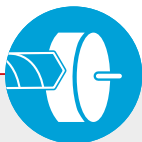
This will help you keep your magnetic core drilling machines in top form! BDS will check your machine, check all the functions and recommend the solution that represents the best value for money if repairs need to be carried out. The scope of a BDS machine check-up comprises the following:

- ▶ Dismantling and cleaning
- ▶ Check of connectors, switches and wires
- ▶ Replacement of wear parts such as spindles, steadies, guide rails and carbon brushes
- ▶ Anchors, coils, PCBs and magnets are checked and, if necessary, replaced following the issue of a quotation



Grinding service

Sharpening BDS core drills will reduce your tool costs. BDS core drills from the HSS-Co 8 and HSS-Standard series are designed so that multiple regrinding is possible without loss of quality. Use our professional regrinding service with ORIGINAL BDS grinding geometry. Do you want to sharpen yourself? Instructions are enclosed with every drill package and are available for downloading in the downloads section of our website.



Individual consultancy

Do you have any questions about magnetic core drilling technology? Do you want to know which machine is the right one for your requirements? We will be pleased to provide you with specific advice! Contact our head office in Mönchengladbach. You will be put in touch with the relevant expert or be given a call back. We look forward to your call or email.

Telephone: +49 (0)2161-3546-0

Email: export@bds-maschinen.de



ProfiBASIC

ProfiSPEZIAL

Arbors
and adapters

Accessories and
consumables

Drills

About BDS

Special tasks require special machines.
BDS can deliver machines for every task.
As a single product in a special version if necessary!



MAB 825 KTS

Full performance and flexibility for steel, plant and machinery construction.

VERSATILE

DRILLING & MILLING

WITH CROSS TABLE



- ▶ The stable cross table allows offset drilling and hole patterns
- ▶ The optional collet chuck available facilitates light-duty milling tasks such as elongated holes or slots

Permanent internal lubrication

Magnet indicator



With cross table
X 110 mm Y 120 mm



With cross table
X 110 mm Y 120 mm

MAB 825 KTS

| | |
|----------------------------------|-----------------------------|
| Motor output | 1,800 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 255 mm |
| Magnet dimensions | 220 x 220 x 54 mm |
| Weight | 57.5 kg |
| Industrial arbor | MT 3, 19 mm (3/4") |
| Industrial arbor | MT 3, 32 mm (1 1/4") |
| Spindle taper | MT 3 |
| Gear 1 range: 40 – 110 rpm | Gear 2 range: 65 – 175 rpm |
| Gear 3 range: 140 – 360 rpm | Gear 4 range: 220 – 600 rpm |
| Permanent internal lubrication | ✓ |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Safety clutch | ✓ |
| Carbon brush wear indicator | ✓ |
| Magnet indicator | ✓ |
| MAB 825 KTS 230 V | |
| MAB 825 KTS 110/125 V | |

Included in delivery

- 1 Magnetic core drilling machine MAB 825 KTS
- 1 Ejector pin ZAK 075 + 090 + 100 + 120
- 1 Ejector drift MT 3
- 1 Industrial arbor ZIA 319-KN, 19 mm Weldon (3/4")
- 1 Industrial arbor ZIA 332-KN, 32 mm Weldon (1 1/4")
- 1 Allen key size 5 + size 6
- 1 Carry case on wheels
- 1 Safety lashing strap
- 1 Operating instructions

Core drill Twist drill Reamer Countersink Tapping

| | | | | |
|-------------------------|------------|------------|---------|-----|
| Max. Ø 80 mm | Ø 31.75 mm | Ø 31.75 mm | Ø 50 mm | M30 |
| Cutting depth: 30-55 mm | | | | |



Collet chuck set
ZSF 316, MT 3, including
15 collets Ø 3 – 16 mm

Full wave control electronics

Overheating protection

Clockwise/anti-clockwise rotation

ProfisPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

AutoMAB 350 AutoMAB 450

Magnetic core drilling machines with fully automatic feed and return.

Integrated coolant tank

ECONOMICAL FULLY AUTOMATIC DRILLING SOLUTION



Overload protection

LED switch

Magnet indicator

Permanent internal lubrication

AutoMAB 350

| | |
|--------------------------------------|-----------------------|
| Motor output | 1,050 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 168 x 84 x 48 mm |
| Weight | 15 kg |
| Direct arbor | 19 mm Weldon (3/4") |
| Gear 1 range | 460 rpm |
| Permanent internal lubrication | ✓ |
| LED power indicator | ✓ |
| Magnet indicator with safety cut-out | ✓ |
| Feed | Automatic feed/return |
| AutoMAB 350 230 V | |
| AutoMAB 350 110/125 V | |

Included in delivery

- 1 Magnetic core drilling machine AutoMAB 350
- 1 Ejector pin ZAK 075 + 100
- 1 Allen key size 4
- 1 Hard-top case
- 1 Safety lashing strap
- 1 Operating instructions

Core drill

Automatic feed

- Max. Ø 35
- Cutting depth 30-55 mm

Manual feed

- Max. Ø 35
- Cutting depth 30-55 mm





Features and function of control are identical for both AutoMAB units!

- ▶ The control reliably monitors the drilling process, while the power consumption is displayed by means of an LED
- ▶ A safety cut-out protects the drilling motor from overload
- ▶ The high degree of uniformity in the drilling process protects the tool and machine and significantly reduces the risk of the core drill breaking
- ▶ Safety control cut-out: If the magnet loses its adhesion, the drilling and feed motors automatically cut out
- ▶ The automatic feed is activated by one of the three handles

| AutoMAB 450 | |
|--------------------------------------|-----------------------|
| Motor output | 1,150 W |
| Voltage | 230 V, 50 – 60 Hz |
| Stroke | 160 mm |
| Magnet dimensions | 168 x 84 x 48 mm |
| Weight | 16 kg |
| Spindle taper | MT 2 |
| Industrial arbor | MT 2, 19 mm (3/4") |
| Gear 1 range | 250 rpm |
| Gear 2 range | 450 rpm |
| Permanent internal lubrication | ✓ |
| LED power indicator | ✓ |
| Magnet indicator with safety cut-out | ✓ |
| Feed | Automatic feed/return |
| AutoMAB 450 230 V | |
| AutoMAB 450 110/125 V | |

| Included in delivery |
|--|
| 1 Magnetic core drilling machine AutoMAB 450 |
| 1 Ejector pin ZAK 075 + 100 |
| 1 Ejector drift MT 2 |
| 1 Industrial arbor ZIA 219-KN, 19 mm Weldon (3/4") |
| 1 Allen key size 5 |
| 1 Carry case |
| 1 Safety lashing strap |
| 1 Operating instructions |

| Core drill |
|-----------------------|
| Automatic feed |
| Max. Ø 45 |
| Cutting depth |
| 30-55 mm |
| Manual feed |
| Max. Ø 45 |
| Cutting depth |
| 30-55 mm |



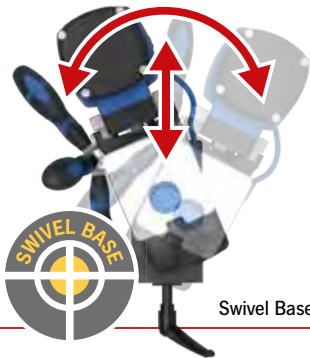
MAB 825 V / MAB 845 V

Full performance and flexibility for steel, plant and machinery construction. With controllable automatic feed.

THE HEAVY-DUTY AUTOMATIC MAGNETIC DRILL



Torque control



Magnet indicator

Permanent internal lubrication

Swivel Base adjustment device (More information on page 9)

- ▶ The automatic feed is activated and deactivated at the hub and can be switched on in any position
- ▶ The variable feed speed ensures optimum use of the respective tool
- ▶ The feed is automatically disabled when the top or bottom end position is reached

- ▶ Further machining is possible at any time by means of manual reversing
- ▶ Safety control cut-out: If the magnet loses its adhesion, the drilling and feed motors automatically cut out
- ▶ The machine can also be used with manual feed

MAB 825 V/MAB 845 V

| | |
|----------------------------------|-----------------------------|
| Motor output | 1,800 W |
| Voltage | 230 V AC 50 – 60 Hz |
| Stroke | 255 mm |
| Magnet dimensions | 110 x 220 x 54 mm |
| Weight | 34 kg |
| Spindle taper | MT 3 |
| Gear 1 range: 40 – 100 rpm | Gear 2 range: 65 – 175 rpm |
| Gear 3 range: 140 – 360 rpm | Gear 4 range: 220 – 600 rpm |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Safety clutch | ✓ |
| Permanent internal lubrication | ✓ |
| Carbon brush wear indicator | ✓ |
| Magnet indicator | ✓ |
| Feed | Automatic variable speed |
| MAB 825 V 230 V | MAB 825 V 110/125 V |
| MAB 845 V 230 V | MAB 845 V 110/125 V |

Included in delivery

- 1 Core drilling machine MAB 825 V/MAB 845 V
- 1 Ejector drift MT 3
- 1 Industrial arbor ZIA 319-KN, 19 mm Weldon (3/4")
- 1 Industrial arbor ZIA 332-KN, 32 mm Weldon (1 1/4")
- 1 Ejector pin ZAK 075 + 090 + 100 + 120
- 1 Allen key size 6 + size 8
- 1 Carry case on wheels
- 1 Safety lashing strap
- 1 Operating instructions

| Core drill | Twist drill | Reamer | Countersink | Tapping |
|----------------------------------|-------------|---------|-------------|------------|
| Automatic feed | | | | |
| Max. Ø 60 | Ø 26 | Ø 31.75 | | |
| Cutting depth 30-55 mm | | | | |
| Manual feed | | | | |
| Max. Ø 100 | Ø 31.75 | Ø 31.75 | Ø 50 | Ø max. M30 |
| Cutting depth 30-55-75-110 mm | | | | |



MAB 1300 V

Superior performance thanks to sophisticated display of power. The MAB 1300 V is currently the most powerful magnetic core drilling machine with controllable automatic feed.

**THE STRONGEST
OF THE STRONG**



► Features and equipment of MAB 1300 V are identical to MAB 825 V/MAB 845 V (see left-hand side)

| MAB 1300 V | |
|----------------------------------|-----------------------------|
| Motor output | 2,300 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 310 mm |
| Magnet dimensions | 120 x 360 x 65 mm |
| Weight | 51 kg |
| Spindle taper | MT 4 |
| Gear 1 range: 30 – 80 rpm | Gear 2 range: 50 – 120 rpm |
| Gear 3 range: 130 – 350 rpm | Gear 4 range: 210 – 550 rpm |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Overheating protection | ✓ |
| Clockwise/anticlockwise rotation | ✓ |
| Safety clutch | ✓ |
| Permanent internal lubrication | ✓ |
| Carbon brush wear indicator | ✓ |
| Magnet indicator | ✓ |
| Feed | Automatic variable speed |
| MAB 1300 V 230 V | |
| MAB 1300 V 110/125 V | |

Included in delivery

- 1 Magnetic core drilling machine MAB 1300 V – without steady
- 1 Ejector drift MT 4
- 1 Industrial arbor ZIA 419-KN, 19 mm Weldon (3/4")
- 1 Industrial arbor ZIA 432-KN, 32 mm Weldon (1 1/4")
- 1 Ejector pin ZAK 075 + 090 + 100 + 120
- 1 Allen key size 6 + size 8
- 1 Carry case on wheels
- 1 Safety lashing strap
- 1 Operating instructions

| Core drill | Twist drill | Reamer | Countersink | Thread |
|----------------|-----------------|--------|-------------|------------|
| Automatic feed | | | | |
| Max. Ø 60 | Ø 32 | Ø 50 | | |
| Cutting depth | 30-55 mm | | | |
| Manual feed | | | | |
| Max. Ø 130 | Ø 45 | Ø 50 | Ø 80 | Ø max. M42 |
| Cutting depth | 30-55-75-110 mm | | | |



ProfisPEZIAL

Arbors
and adapters

Accessories and
consumables

Drills

About BDS

MAB 155

Horizontal magnetic core drilling machine with an angular gearbox.
Ideal for drilling in extremely confined spaces.

THE SMALL MACHINE

WITH HUGE POWER

- ▶ Handy and compact machine for drilling in confined spaces
- ▶ New powerful motor
- ▶ With ratchet for optimum handling



| MAB 155 | |
|-------------------|--------------------------------|
| Motor output | 1,050 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 39 mm |
| Magnet dimensions | 80 x 160 x 36.5 mm |
| Weight | 11 kg |
| Direct arbor | 19 mm Weldon ($\frac{3}{4}$ " |
| Gear 1 range | 320 rpm |
| MAB 155 230 V | |
| MAB 155 110/125 V | |

Included in delivery

- 1 Magnetic core drilling machine MAB 155
- 1 Ejector pin ZAK 075
- 1 Offset screwdriver size 4
- 1 Hard-top case
- 1 Safety lashing strap
- 1 Quick release ratchet
- 1 Operating instructions

Core drill

Max. Ø 35 mm
Cutting depth:
30 mm



AirMAB 5000

Drilling with pneumatic drive and permanent magnet.

POWERFUL DRILLING WITH COMPRESSED AIR

MT 2 Morse taper

Quick-change drilling system

KEYLESS

Permanent internal lubrication

Powerful permanent magnet

- ▶ High-performance Atlas Copco pneumatic motor
- ▶ With MT 2 Morse taper
- ▶ Motor approved according to Ex class Ex II 2G T4 IIC D110°C



Powerful 830 W multi-disc motor

AirMAB 5000 BDS MASCHINEN

| AirMAB 5000 | |
|--------------------------------|------------------------------|
| Motor output | 830 W |
| Rated torque | 27 Nm |
| Air consumption | 1000 l/min |
| Stroke | 160 mm |
| Magnet dimensions | 90 x 160 x 60 mm |
| Weight | 17.5 kg |
| Quick-change drilling system | KEYLESS, 19 mm (3/4") |
| Spindle taper | MT 2 |
| Gear 1 range | Min. 290 rpm Max. 575 rpm |
| Permanent internal lubrication | ✓ |
| AirMAB 5000 | |

| Included in delivery | |
|---|--|
| 1 Magnetic core drilling machine AirMAB 5000 | |
| 1 Ejector pin ZAK 075 + 100 | |
| 1 Ejector drift MT 2 | |
| 1 KEYLESS quick-change drilling system, 19 mm Weldon (3/4") | |
| 1 Hard-top case | |
| 1 Safety lashing strap | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|------------------------------|-------------|
| Max. Ø 35 mm | Ø 23 mm |
| Cutting depth: 30 - 55 mm | |



ProfisPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

RailMAB 915

Developed for rail core drilling in signalling equipment and track construction.

THE SPECIALIST

FOR RAILS




Suitable adapter for every rail profile

- ▶ Powerful 1,600 W electric motor
- ▶ 2-speed oil bath gearbox
- ▶ Full wave control electronics
- ▶ Powerful quick-change clamping system

| RailMAB 915 | |
|--------------------------------|----------------------|
| Motor output | 1,600 W |
| Voltage | 230 V AC, 50 – 60 Hz |
| Stroke | 160 mm |
| Weight | 17 kg |
| Industrial arbor | Weldon 19 mm (3/4") |
| Spindle taper | MT 3 |
| Gear 1 range | 70 – 280 rpm |
| Gear 2 range | 180 – 580 rpm |
| Torque control | ✓ |
| Full wave control electronics | ✓ |
| Overheating protection | ✓ |
| Permanent internal lubrication | ✓ |
| Cooling | Drilling emulsion |
| Carbon brush wear indicator | ✓ |
| RailMAB 915 230 V | |
| RailMAB 915 110/125 V | |

| Included in delivery | |
|--|--|
| 1 Rail core drilling machine RailMAB 915 | |
| 1 Ejector pin ZAK 075 + 100 | |
| 1 Ejector drift MT 3 | |
| 1 Industrial arbor ZIA 319-KN, 19 mm Weldon (3/4") | |
| 1 High-pressure tank, 5 litres | |
| 1 Quick release ratchet | |
| 1 Rail adapter of your choice (no special version) | |
| 1 Offset screwdriver size 6 | |
| 1 Carry case | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|----------------------------|---|
| Max. Ø 50 mm | Ø 20 mm |
| Cutting depth: 30-55 mm |  |

| Order no. | Rail adapter for RailMAB 915 |
|-----------|------------------------------|
| ZAS 049S | Rail adapter S 49 |
| ZAS 054S | Rail adapter S 54 |
| ZAS 050U | Rail adapter UIC 50 |
| ZAS 054U | Rail adapter UIC 54 |

RailMAB 965

Rail core drilling machine with petrol engine for working independently of power supply.

LIGHTWEIGHT

RAIL DRILL MACHINE

Integrated Petrol Tank

Petrol engine 1500 Watts (2 HP)

Connection for high-pressure coolant tank

Quick-change clamping system

- ▶ Independent of power supply
- ▶ Powerful 1.5 kW petrol engine
- ▶ Compact design
- ▶ Powerful quick-change clamping system

| RailMAB 965 | |
|--------------------------------|------------------------------|
| Motor output | 1500 Watts (2 HP) |
| Cubic capacity | 49.4 ccm |
| Torque | 3.04 Nm |
| Stroke | 40 mm |
| Weight | 21.5 kg |
| Direct arbor | 19 mm Weldon (3/4") |
| Gear 1 range | Min. 110 rpm Max. 280 rpm |
| Permanent internal lubrication | ✓ |
| Cooling | Drilling emulsion |
| RailMAB 965 | |

| Included in delivery | |
|--|--|
| 1 Rail core drilling machine RailMAB 965 | |
| 1 Ejector pin ZAK 075 | |
| 1 High-pressure tank, 5 litres | |
| 1 Rail adapter of your choice (no special version) | |
| 1 Offset screwdriver sizes 4 + 5 + 6 | |
| 1 Carry case | |
| 1 Operating instructions | |

| Core drill | Twist drill |
|-------------------------|---|
| Max. Ø 36 mm | Ø 20 mm |
| Cutting depth: 30 mm |  |

| Order no. | Rail adapter for RailMAB 965 |
|-----------|------------------------------|
| ZAS 250U | Rail adapter UIC 50 |
| ZAS 254U | Rail adapter UIC 54 |
| ZAS 260U | Rail adapter UIC 60 |
| ZAS 249S | Rail adapter S 49 |
| ZAS 254S | Rail adapter S54 |

ProfisPEZIAL

Arbors and adapters

Accessories and consumables

Drills

About BDS

Drill stands and clamping devices

Magnetic drill stand for conventional twist drilling machines and MobilCLAMP for magnetic drilling machines.

EXPAND THE POSSIBILITIES OFFERED

BY YOUR MACHINES



Magnetic drill stand

Magnetic drill stand for manual drilling machines

With this practical magnetic drill stand, you can turn your manual drilling machine into a magnetic drilling machine.

The magnetic drill stand is suitable for commercially available manual drilling machines with 43 mm collar diameter.

The powerful magnet therefore allows safe work on a horizontal plane or overhead work (a safety lashing strap must also be used for these applications).

The slide has a working stroke of 180 mm.

Magnetic drill stand

Order no.

MBS 300

For commercially available manual drilling machines with 43 mm collar diameter,
Stroke 180 mm



Industrial drill stand

Industrial drill stand for manual drilling machines

Industrial drill stand for commercially available manual drilling machines with a 43 mm collar diameter.

Safe and stable thanks to cast base plate and slide with a working stroke of 180 mm.

Optional with drilling machine vice, 100 mm jaw width. Screws for T slots are also available for retention.

Industrial drill stand

ORDER NO.

ZBS 100.2

ZST 300 Prism vice

Screw for T slots

ZSM 100 Hexagon nut

Jaw width: 100 mm,
Clamping range: 100 mm.

Vice and screws are not included in the scope of delivery.



MobilCLAMP – mobile work with magnetic core drilling machines

MobilCLAMP for magnetic core drilling machines



The MobilCLAMP mobile clamping device has allowed the scope of application of a magnetic core drilling machine to be extended to the assembly line and workshop. To this end, the magnetic core drilling machine is placed on the supporting surface and switched

on. Components can be securely clamped in the prism vice, and without having to expend a lot of effort you immediately have a flexible bench drilling machine.

MobilCLAMP

ORDER NO.

ZMC 200



Adapters, drill chucks and accessories

For 19 mm direct arbor and morse taper MT 2 or MT 3.



1. Connect adapter to drill chuck.



2. Insert drill chuck into the direct arbor.



3. Ready for use for twist drills.

Direct arbor
19 mm Weldon (3/4")



| Adapter for drill chucks |
|---|
| ORDER NO. |
| ZAP 100 |
| Weldon shank 19 mm (3/4") to 1/2" x 20 NF |



| Gear rim drill chuck | | | |
|----------------------|-----------------|---------------|--|
| ORDER NO. | INTERNAL THREAD | CLAMPING SIZE | |
| ZBI 113 | 1/2" x 20 NF | 1 - 13 mm | |
| ZBI 116 | 1/2" x 20 NF | 2.5 - 16 mm | |



| Quick-action drill chuck | | | |
|--------------------------|-----------------|---------------|--|
| ORDER NO. | INTERNAL THREAD | CLAMPING SIZE | |
| ZSI 113 | 1/2" x 20 NF | 1 - 13 mm | |
| ZSI 116 | 1/2" x 20 NF | 3 - 16 mm | |



1. Connect taper drift to drill chuck.



2. Insert drill chuck in MT arbor.



3. Ready for use for twist drills.

Spindle taper
MT 2 or MT 3



| Adapter for drill chucks |
|----------------------------|
| ORDER NO. |
| ZKD 216 DIN 238 - MT 2/B16 |
| ZKD 316 DIN 238 - MT 3/B16 |



| Gear rim drill chuck | | | |
|----------------------|-----------------|---------------|--|
| ORDER NO. | INTERNAL THREAD | CLAMPING SIZE | |
| ZBK 113 | DIN 238-B16 | 1 - 13 mm | |
| ZBK 116 | DIN 238-B16 | 2.5 - 16 mm | |



| Quick-action drill chuck | | | |
|--------------------------|-----------------|---------------|--|
| ORDER NO. | INTERNAL THREAD | CLAMPING SIZE | |
| ZSB 113 | DIN 238-B16 | 1 - 13 mm | |
| ZSB 116 | DIN 238-B16 | 3 - 16 mm | |



| Ejector drift DIN 228 | | |
|-----------------------|------|--------------|
| ORDER NO. | SIZE | DIN STANDARD |
| ZAS 002 | MT 2 | DIN 228 |
| ZAS 003 | MT 3 | DIN 228 |



| Key for gear rim drill chuck | |
|------------------------------|--|
| ORDER NO. | |
| ZEZ 113 | |
| ZEZ 116 | |



| Chip protection | |
|-----------------|-------------------|
| ORDER NO. | MACHINE |
| ZSS 050 | MAB 100 - MAB 525 |
| ZSS 500 | MAB 825 - MAB 855 |

Safety lashing strap

| |
|------------------|
| ORDER NO. |
| 40 0016 1 |

Pump bottle

| |
|------------------|
| ORDER NO. |
| ZKP 100 |



Arbors
and adapters

Accessories and
consumables

Drills

About BDS

Carry case

For magnetic core drilling machines.

EXTREMELY ROBUST

YET LIGHTWEIGHT

- ▶ Portable – low weight coupled with high stability.
- ▶ Firmly locked – secure, large mechanical locks.
- ▶ Rolling instead of carrying – ABS wheels and telescopic handle.



Hard-top case

| ORDER NO. | SUITABLE FOR |
|-----------|--|
| ZHK 100 | MAB 100K - MAB 155 |
| ZHK 350 | AutoMAB 350, AutoMAB 450 |
| ZHK 400 | MAB 455, MAB 465, MAB 485, MAB 525 incl. SB series |
| ZHK 800 | MABasic 850 |

Application: Carry case for BDS magnetic core drilling machines.

Design: Sturdy hard shell case with handle and secure locks. With foam insert. No content.



Carry case

| ORDER NO. | SUITABLE FOR |
|-----------|-----------------------|
| ZPK 200 | MABasic 200, 400, 450 |



Carry case on wheels

| ORDER NO. | SUITABLE FOR |
|-----------|------------------|
| ZHK 825 | MAB 825, MAB 845 |

Application: Carry case on wheels for BDS magnetic core drilling machines.

Design: Sturdy transport case on wheels with handle and secure locks. No content.

Carry case on wheels

| ORDER NO. | SUITABLE FOR |
|-----------|-------------------------------------|
| ZHK 1300 | MAB 1300 |
| ZHK 1500 | MAB 825 V/845 V/1300 V, MAB 825 KTS |

Application: Carry case on wheels for BDS magnetic core drilling machines

Design: Sturdy transport case on wheels with handle and secure locks. No content.



BDS carry case for MAB 825/845. Machine not included in delivery!

Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS category.

DRILLING, COUNTERSINKING AND CUTTING QUICK AND SAFE

Quick-change drill chucks and inserts for threads from M6 to M42

Magnetic core drilling machines of the ProfiPLUS category are ideal for thread cutting.

The basic requirements for this are: Clockwise/anticlockwise rotation, solid shaft control electronics and high motor output.

Quick-change drill chucks

Sizes MT 2, MT 3 and MT 4

The large stroke range of the BDS magnet core drilling machines combined with the quick-change drill chuck allows quick and efficient working without having to realign and centre after changing tools. The quick-change drill chuck is designed for universal use when using quick-change inserts with and without a safety friction clutch.



Version 1: Quick-change inserts with safety friction clutch

Thread from M6 to M42 –

BDS inserts with a safety friction clutch allow precise cutting of through-hole and blind-hole threads.

The safety friction clutch prevents the machine screw tap hitting the floor of the drill hole and shearing.

Version 2: Standard quick-change inserts

Threads from M6 to M30 – BDS inserts for machine screw taps are suitable for accommodating machine screw taps for through-hole threads.



Which machine, which thread?

Assignment of possible thread diameter to size of quick-change base holders and inserts.

PRECISION WITH BDS SYSTEM ACCESSORIES

Thread cutting systems

GSW quick-change drill chucks:

In MT 2, MT 3 and MT 4 versions.

To accommodate GSE or GSS quick-change inserts

GSW 222 size 2 MT 2

GSW 331 size 1 MT 3

GSW 332 size 2 MT 3

GSW 333 size 3 MT 3

GSW 442 size 2 MT 4

GSW 443 size 3 MT 4

GSW 444 size 4 MT 4



GSE standard quick-change insert
Sizes 1, 2, 3



GSS quick-change insert with safety friction clutch
sizes 2, 3, 4

ORDER NO.

GSW 222 quick-change drill chuck

GSW 331 quick-change drill chuck

GSW 332 quick-change drill chuck

GSW 333 quick-change drill chuck

GSW 442 quick-change drill chuck

GSW 443 quick-change drill chuck

GSW 444 quick-change drill chuck

GSE 103 - GSE 114 per unit

GSE 205 - GSE 222 per unit

GSE 314 - GSE 330 per unit

GSS 205 - GSS 222 per unit

GSS 312 - GSS 330 per unit

GSS 420 - GSS 442 per unit

Machine screw tap adapters – making an affordable start

The machine screw tap is accommodated directly in the 19 mm or 32 mm Weldon system with an adapter. Only suitable for through-hole threads!



Machine screw tap adapter with Weldon shank

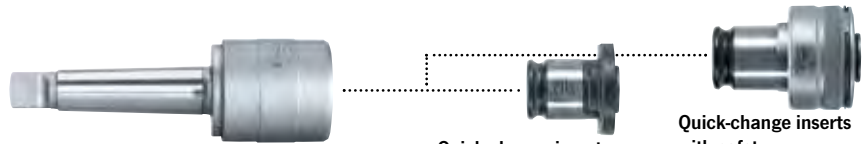
| ORDER NO. | THREAD | SHANK Ø | SQUARE |
|-----------|-------------|---------|--------|
| ZGA 010 | M10 DIN 376 | 7 | 5.5 |
| ZGA 012 | M12 DIN 376 | 9 | 7 |
| ZGA 014 | M14 DIN 376 | 11 | 9 |
| ZGA 016 | M16 DIN 376 | 12 | 9 |
| ZGA 018 | M18 DIN 376 | 14 | 11 |
| ZGA 020 | M20 DIN 376 | 16 | 12 |
| 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 |

Up to ZGA 020 with 19 mm Weldon shank (¾")

From ZGA 022 with 32 mm Weldon shank (1 ½")



THREAD CUTTING SYSTEMS



Quick-change drill chucks GSW

Quick-change inserts Standard GSE

Quick-change inserts with safety friction clutch GSS

| MAB 1300 | MAB 825 MAB 845 | MAB 485 MAB 485 SB | MAB 525 MAB 525 SB | Order No. Quick-change drill chuck | Thread | Order No. | ø x square | Order No. | ø x square | |
|----------|--------------------|-----------------------|-----------------------|------------------------------------|---------------------------|-----------------|-----------------|-----------|------------|----------|
| | | | | GSW 222 Size 2 MT 2 | M5/M6 | GSE 205 | 6 / 4.9 | GSS 205 | 6 / 4.9 | |
| | | | | | M6 | | | | | GSS 206 |
| | | | | | M8 | GSE 208 | 8 / 6.2 | GSS 208 | 8 / 6.2 | |
| | | | | | M8 | | | | | GSS 205 |
| | | | | | M10 | GSE 210-DIN 371 | 10 / 8 | GSS 210 | 7 / 5.5 | |
| | | | | | M10 | | | | | GSE 210 |
| | | | | | M12 | GSE 212 | 9 / 7.0 | GSS 212 | 9 / 7.0 | |
| | | | | | M14 | | | | | GSE 214 |
| | | | | | M16 | GSE 216 | 12 / 9.0 | GSS 216 | 12 / 9.0 | |
| | | | | | | | | | | |
| | | | | GSW 331 Size 1 MT 3 | M4 | GSE 104 | 4.5 / 3.4 | | | |
| | | | | | M5/M6 | | | | | GSE 105 |
| | | | | | M8 | GSE 108 | 8 / 6.2 | | | |
| | | | | | M10 | | | | | GSE 110 |
| | | | | | M12 | GSE 112 | 9 / 7.0 | | | |
| | | | | | M14 | | | | | GSE 114 |
| | | | | | | | | | | |
| | | | | GSW 332 Size 2 MT 3 | M5/M6 | GSE 205 | 6 / 4.9 | GSS 205 | 6 / 4.9 | |
| | | | | | M6 | | | | | GSS 206 |
| | | | | | M8 | GSE 208 | 8 / 6.2 | GSS 208 | 8 / 6.2 | |
| | | | | | M8 | | | | | GSS 205 |
| | | | | | M10 | GSE 210.1 | 10 / 8 | GSS 210 | 7 / 5.5 | |
| | | | | | M10 | | | | | GSE 210 |
| | | | | | M12 | GSE 212 | 9 / 7.0 | GSS 212 | 9 / 7.0 | |
| | | | | | M14 | | | | | GSE 214 |
| | | | | | M16 | GSE 216 | 12 / 9 | GSS 216 | 12 / 9 | |
| | | | | | M18 | | | | | GSE 218 |
| | | | | | M20 | GSE 220 | 16 / 12 | GSS 220 | 16 / 12 | |
| | | | | | *not suitable for MAB 525 | | | | | M22/M24* |
| | | | | | | | | | | |
| | | | | | GSW 333 Size 3 MT 3 | M12 | | | GSS 312 | 9 / 7.0 |
| | | | | M14 | | GSE 314 | | | | |
| | | | | M16 | | | GSE 316 | 12 / 9 | GSS 316 | 12 / 9 |
| | | | | M18 | | GSE 318 | | | | |
| | | | | M20 | | | GSE 320 | 16 / 12 | GSS 320 | 16 / 12 |
| | | | | | | M22/M24 | | | | |
| | | | | | | | GSE 327 | 20 / 16 | GSS 327 | 20 / 16 |
| | | | | | | GSE 330 | | | | |
| | | | | | | | | | | |
| | | | | GSW 442 Size 2 MT 4 | | M5/M6 | GSE 205 | 6 / 4.9 | GSS 205 | 6 / 4.9 |
| | | | | | M6 | GSS 206 | | | | |
| | | | | | M8 | | GSE 208 | 8 / 6.2 | GSS 208 | 8 / 6.2 |
| | | | | | M8 | GSS 205 | | | | |
| | | | | | M10 | | GSE 210-DIN 371 | 10 / 8.0 | GSS 210 | 7 / 5.5 |
| | | | | | M10 | GSE 210 | | | | |
| | | | | | M12 | | GSE 212 | 9 / 7.0 | GSS 212 | 9 / 7.0 |
| | | | | | M14 | GSE 214 | | | | |
| | | | | | M16 | | GSE 216 | 12 / 9 | GSS 216 | 12 / 9 |
| | | | | | M18 | GSE 218 | | | | |
| | | | | | M20 | | GSE 220 | 16 / 12 | GSS 220 | 16 / 12 |
| | | | | | M22/24 | GSE 222 | | | | |
| | | | | | | | | | | |
| | | | | | GSW 443 Size 3 MT 4 | M12 | | | GSS 312 | 9 / 7.0 |
| | | | | M14 | | GSE 314 | | | | |
| | | | | M16 | | | GSE 316 | 12 / 9 | GSS 316 | 12 / 9 |
| | | | | M18 | | GSE 318 | | | | |
| | | | | M20 | | | GSE 320 | 16 / 12 | GSS 320 | 16 / 12 |
| | | | | M22/24 | | GSE 322 | | | | |
| | | | | M27 | | | GSE 327 | 20 / 16 | GSS 327 | 20 / 16 |
| | | | | M30 | | GSE 330 | | | | |
| | | | | | | | | | | |
| | | | | GSW 444 Size 4 MT 4 | M20 | | | GSS 420 | 16 / 12 | |
| | | | | | M22/24 | | | | | GSS 422 |
| | | | | | M27 | GSS 427 | 20 / 16 | | | |
| | | | | | M30 | | | GSS 430 | 22 / 18 | |
| | | | | | M33 | GSS 433 | 25 / 20 | | | |
| | | | | | M36 | | | GSS 436 | 28 / 22 | |
| | | | | | M39/42 | GSS 442 | 32 / 24 | | | |
| | | | | | | | | | | |

Arbors
and adapters

Accessories and
consumables

Drills

About BDS

Arbors for BDS core drills

Three systems are available – they allow a friction-type, convenient and secure connection between the core drill and the magnetic core drilling machine.

ACCOMMODATING OF EVERY DRILL

Arbors for BDS core drills with 19 mm ($\frac{3}{4}$ ") Weldon shank



KEYLESS quick-change drilling system

| ORDER NO. | SPINDLE ARBOR |
|-----------|---------------|
| ZSS 200 | MT 2 |
| ZSS 300 | MT 3 |

With automatic internal lubrication for core drills with 19 mm ($\frac{3}{4}$ ") Weldon shank. With tube and quick-lock coupling. Quick tool change without wrench.



Reducing bush DIN 2185

| ORDER NO. | EXTERNAL | INTERNAL |
|-----------|----------|----------|
| ZRH 210 | MT 2 | MT 1 |
| ZRH 320 | MT 3 | MT 2 |
| ZRH 430 | MT 4 | MT 3 |

Arbors for BDS core drills with 19 mm ($\frac{3}{4}$ ") and 32 mm ($1\frac{1}{4}$ ") Weldon shank



Industrial arbor with manual internal lubrication

| ORDER NO. | SPINDLE ARBOR |
|-----------|---------------|
| ZIA 219-M | MT 2 |
| ZIA 319-M | MT 3 |
| ZIA 419-M | MT 4 |

For core drills with 32 mm ($1\frac{1}{4}$ ") Weldon shank



Extension sleeve DIN 2178

| ORDER NO. | EXTERNAL | INTERNAL |
|-----------|----------|----------|
| ZVH 220 | MT 2 | MT 2 |
| ZVH 230 | MT 2 | MT 3 |
| ZVH 320 | MT 3 | MT 2 |
| ZVH 330 | MT 3 | MT 3 |

Arbors for BDS core drills with 19 mm ($\frac{3}{4}$ ") and 32 mm ($1\frac{1}{4}$ ") Weldon shank



Industrial arbor with automatic internal lubrication

| ORDER NO. | SPINDLE ARBOR |
|------------|---------------|
| ZIA 219-KN | MT 2 |
| ZIA 319-KN | MT 3 |
| ZIA 419-KN | MT 4 |

For core drills with 32 mm ($1\frac{1}{4}$ ") Weldon shank. With tube and quick-lock coupling.

Adapters with Weldon shank

With the relevant adapters, BDS core drills with a Weldon shank are compatible with commercially available machines and arbor systems.

WE ARE OPEN TO ALL SYSTEMS

32 mm (1 1/4")



19 mm (3/4")



19 mm (3/4")



19 mm (3/4")



Adapters for Nitto One-Touch



Adapters for Fine QUICK-IN



Adapter

ORDER NO.

ZAP 200

From 32 mm (1 1/4") Weldon shank
To 19 mm (3/4") Weldon shaft

Adapter

ORDER NO.

ZAF 002

For fine core drills with M18 x 6 P1.5 female thread incl. 1 ZAK 125 ejector pin

Adapter

ORDER NO.

ZAF 003

For fine core drills with QUICK-IN shank incl. 1 ZAK 115 ejector pin

Extension

ORDER NO.

ZAP 300

80 mm, 19 mm Weldon shank (3/4"), incl. 1 ZAK 080 ejector pin

Adapter

ORDER NO.

ZAF 005

With Nitto One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Adapter

ORDER NO.

ZAF 004

With Quick-In One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Arbors and adapters

Accessories and consumables

Drills

About BDS

PowerCLEANER

The ideal multi-function tool



USE OF BDS

GENUINE ACCESSORIES ADVISED

PowerCLEANER

PowerCLEANER

ORDER NO.

POW 200

With special hook for removing drilling chips and lockable cleaning brush for cleaning the working surface.



Removal of drilling chips with sharp edges



Cleaning of working surface

PowerCLEANER starter kit

Save money with the BDS starter kit at the bargain price!

Start with the right basic equipment for every magnetic core drilling machine. In a pack at a particularly good price.

- ▶ 5 short core drills in the most common diameters: 14 mm, 18 mm and 22 mm.
- ▶ 1 litre of BDS 5000 high-performance cutting oil.
- ▶ And a BDS PowerWORKER or BDS PowerCLEANER.

BDS PowerCLEANER starter kit

ORDER NO.

ZST 200

Contents:

- 1 standard core drill box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 l BDS 5000 high-performance cutting oil
- 1 BDS PowerCLEANER POW200



BDS ÖkoLogisch

PRICE ADVANTAGE

PowerWORKER

Cleans up all magnetic drilling chips.
The indispensable helpmate for every workshop.

TIDIER WORK AREA

PowerWORKER

PowerWORKER

ORDER NO.

POW 100



The PowerWORKER cleans up all magnetic drilling chips. With this practical tool and its strong magnetic force, chips are easily collected and then quickly and easily disposed of in the scrap container. Magnetisation, collection, stripping – done.

PowerWORKER starter kit

Save money with the BDS starter kit
at the bargain price!



BDS PowerWORKER starter kit

ORDER NO.

ZST 100

Contents:

- 1 standard core drill box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 l BDS 5000 high-performance cutting oil
- 1 BDS PowerWORKER POW100



PRICE ADVANTAGE!

Accessories and
consumables

Drills

About BDS



High-performance cutting oil **BDS 5000**

Cooling lubricant concentrate **BDS 6000**



Purely vegetable oil that does not come under the category of hazardous goods in terms of customs & transport regulations.
The raw materials used are not listed in the Catalogue of Substances Hazardous to Water.
BDS 5000 is not subject to any labelling requirements.

- ▶ Biological raw material with additives
- ▶ Water hazard level 1
- ▶ Biodegradable, optimum basic adjustment of viscosity for use of BDS core drills, problem-free use for subsequent tin plating



For high standards based on synthetic raw materials

- ▶ Can be mixed with water, biologically stable and mild in odour
- ▶ Extends the service life of the core drill
- ▶ Toxicologically harmless, Water Hazard Class 1



| Cutting Oil (For HSS Core Drills) | | |
|-----------------------------------|----------------------|-------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 005 | BDS 5000 cutting oil | 5-litre can |
| ZHS 006 | BDS 5000 cutting oil | 1-litre can |

| Cooling Lubricant (For TCT Core Drills) | | |
|---|--|-------------|
| ORDER NO. | NAME | CONTENT |
| ZHB 001 | BDS 6000 cooling lubricant concentrate | 1-litre can |

Cutting oil, lubrication spray, cutting paste and cooling lubricant

High-performance products that can be used effectively and in an ecologically sound manner.

BEST RESULTS

KIND ON

THE ENVIRONMENT

High-performance lubrication spray **BDS 5200**



For working in awkward positions (overhead and on a horizontal plane), also suitable for high-alloy materials. Foam-like spray with very high adhesive strength.

Advantages: Precise dosing of lubrication spray and therefore optimum lubrication directly on the cutting edges. No dripping or splashing, thus ensuring maximum safety when working on ladders and scaffolds.

- ▶ White adhesive lubricant containing PTFE with corrosion protection
- ▶ Free from PCB, PCT, CFCs and chlorine
- ▶ Active substance: Mineral-based lithium grease with additives and solvents
- ▶ Compressed gas: Propane/butane, subject to labelling requirements

High-performance cutting paste **BDS 5500**

High-Tech metal-free cutting paste **BDS 7500**



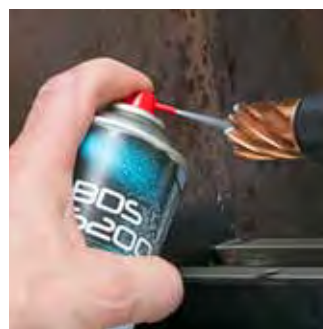
BDS 5500: Ideal for material types that are hard to machine. Suitable for use overhead and work in awkward positions.

BDS 7500: Base oil: Medicinal white oil. Extremely high heat resistance up to 1,400°C. For manual lubrication of high-alloy steel, Hardox steel and stainless and heat-resistant steel. For extremely high standards.

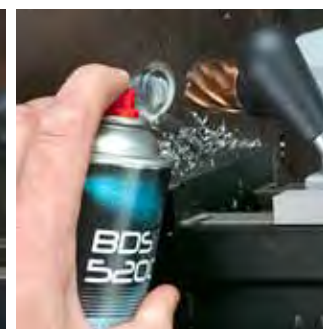
BDS high-performance lubricants and cleaning spray are tailored precisely to the respective intended purpose. The highly efficient composition allows sparing and environmentally friendly use.

The following are particularly recommended: BDS high-performance cutting oil or high-performance cooling lubricant concentrate. These products are fully biologically degradable and toxicologically harmless. However, also highly effective in the required lubrication and cooling performance. The BDS 6000 concentrate can also be mixed with water in a ratio of 1:10 and is therefore extremely efficient.

Caution: Please do not use liquid lubricants for overhead work or work on vertical surface. There is a risk that oil will get into the motor, thus causing a short-circuit. Please use BDS high-performance lubrication spray BDS 5200 or the BDS 5500/7500 cutting paste.



Step 1: Prior to drilling, spray high-performance lubrication spray directly into the drill.



Step 2: During drilling, spray high-performance lubrication spray onto the tip of the drill and into the borehole.

| Lubricants and adjuvants | | |
|--------------------------|------------------------|-----------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 550 | BDS 5500 cutting paste | 1000 g can |
| ZHS 570 | BDS 7500 cutting paste | 85 g tube |
| ZHS 572 | BDS 7500 cutting paste | 12 x 85 g tubes |

| Lubricants and adjuvants | | |
|--------------------------|----------------------------|-----------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 400 | BDS 5200 lubrication spray | 1 x 400 ml tin |
| ZHS 406 | BDS 5200 lubrication spray | 6 x 400 ml tin |
| ZHS 412 | BDS 5200 lubrication spray | 12 x 400 ml tin |



Clamping device for pipes with a diameter of 80 mm to 500 mm

The BDS pipe clamping devices are as standard suitable for pipes with a diameter of 80 mm to 250 mm and 150 mm to 500 mm. Flexible and quick clamping is possible in every drilling situation. Tension chains fix the clamping device to the pipe with swivelling prisms. Adjustment of the drilling position to the pipe is easy and safe. These devices significantly expand the range of possible applications of the ProfiPLUS magnetic core drilling machines.



ZRO 250



ZRO 500

Pipe clamping device

ORDER NO.

ZRO 250

ZRO 500

ZRO 250: for MAB 455, 485, 525

For pipe \varnothing : 80 – 250 mm, chain length: 900 mm

ZRO 500: for MAB 825, 845, MABasic 850

For pipe \varnothing : 150 – 500 mm, chain length: 1650 mm

Clamping devices

Can be used for magnetic core drilling machines from the ProfiPLUS, ProfiSTART and ProfiBASIC categories.

FOR MACHINING PIPES

AND DRILLING NON-FERROUS METALS

AND STAINLESS STEEL

Vacuum clamping devices for non-ferrous metals

Magnetic core drilling machines from the ProfiPLUS can also be used fully to machine non-ferrous metals and stainless steel. To this end, BDS offers clamping devices that build up a vacuum with a pump lubricated by means of oil circulation, thus creating a secure connection between the magnetic core drilling machine and the workpiece.



Vacuum plate for smooth surfaces

ORDER NO.

ZAV 400

Application: For smooth surfaces.

Design: High-performance vacuum pump with oil circulation lubrication. Clamping plate with two suction surfaces and an internal drilling area.
Dimensions: 440 x 260 mm,
Elongated hole: 50 x 120 mm



Vacuum plate for smooth corrugated sheet metal/gussets

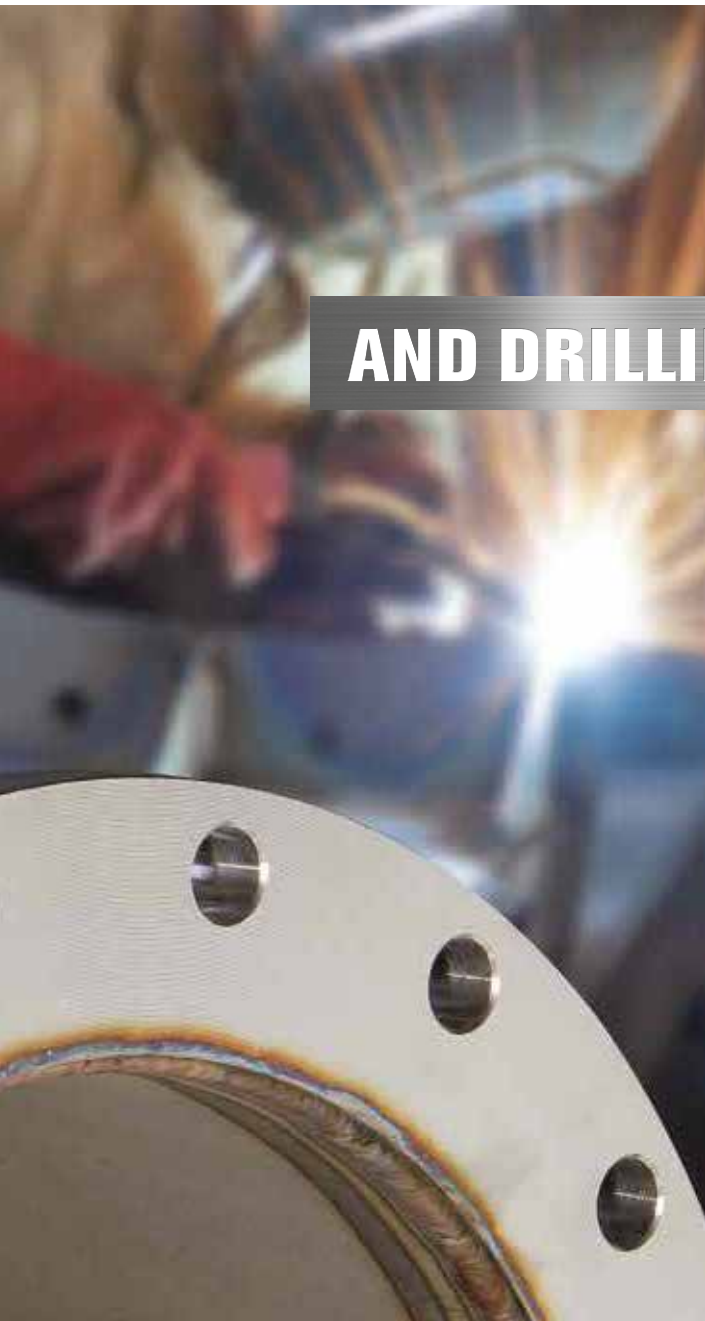
ORDER NO.

ZAV 300

Application: Suitable for corrugated sheet metal, gussets and smooth surfaces.

Design: High-performance vacuum pump with oil circulation lubrication. Clamping plate \varnothing 300 mm.

Delivery without machines



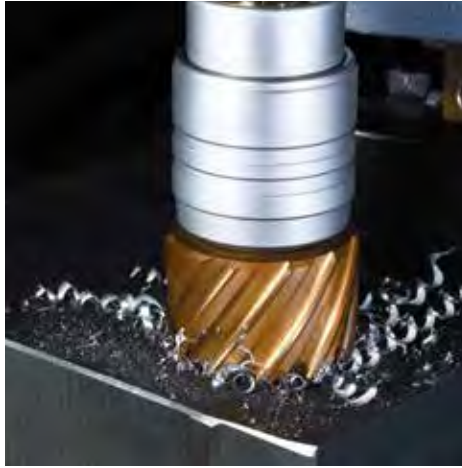
ZAV 400
Vacuum clamping
device for smooth
surfaces



ZAV 300
Vacuum clamping
device for corrugated
sheet metal and
gussets



The range of BDS fully ground core drills.



HSS-Co 8 series

- ▶ High degree of heat resistance
- ▶ Better wear protection
- ▶ High cobalt content of 8%
- ▶ Suitable for higher loads in fine-grained steels and rustproof materials
- ▶ With 19 mm or 32 mm Weldon shank
- ▶ Can be resharpened

HSS-VarioPLUS series

- ▶ High-strength fully ground core drill
- ▶ Carbide coating in a range of 2.5 μ
- ▶ Longer service lives
- ▶ More uniform discharge of chips, particularly during prolonged drilling – a key point for safety during work

HSS-Standard series

- ▶ Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- ▶ Core drilling diameters of 12 mm to 130 mm
- ▶ Can be resharpened

HSS-Co 8 series
Core drills made from special steel with high cobalt content, for increased heat resistance and wear protection.

| HSS-Co 8 series | |
|--------------------------------|-------------|
| KBK-CO | KBL-CO |
| Cutting depth: 30 mm | 55 mm |
| Drilling diameter: 12 – 130 mm | 12 – 100 mm |

HSS-VarioPLUS series
Fully ground core drills made from high-performance high-speed steel, with carbide coating, high degree of protection against wear, excellent discharge of chips.

| HSS-VarioPLUS series | |
|-------------------------------|------------|
| KBK-VP | KBL-VP |
| Cutting depth: 30 mm | 55 mm |
| Drilling diameter: 12 – 60 mm | 12 – 60 mm |

HSS-Standard series
Fully ground core drill made from high-performance high-speed steel

| HSS-Standard series | | | |
|-------------------------------|------------|------------|----------------|
| KBK | KBL | KEL | KBK-Z |
| Cutting depth: 30 mm | 55 mm | 110 mm | 30 mm |
| Drilling diameter: 12 – 60 mm | 12 – 60 mm | 20 – 50 mm | 1/2" - 2 1/16" |

Professional quality for professional tasks.



BDS core drills are produced on modern CNC-controlled grinding centres. This guarantees uniform cutting, quality and cutting performance of all BDS drilling tools across the entire range.

Huge vertical range of products

BDS core drills are produced in five cutting depths of 30, 35, 55, 75 and 110 mm and with more than 94 different drilling diameters.

Arbors

BDS core drilling tools are offered with different arbors.

They fit the KEYLESS quick-change drilling system and the MT 2, MT 3 and MT 4 industrial arbors also available in the range of accessories with automatic or manual internal lubrication.



Arbors:

- ① 19 mm Weldon shank (3/4")
- ② 32 mm Weldon shank (1 1/4")
- ③ 18 mm Quick-In shank
- ④ Carbide TCT annular cutters optionally available as Universal shank (Nitto+Weldon)

Carbide series and Carbide-PLUS series

- ▶ Carbide-tipped core drills
- ▶ Cutting depths of 30 mm, 55 mm, 75 mm and 110 mm
- ▶ Diameters of 12 mm to 150 mm
- ▶ Carbide-PLUS also with wear-resistant hard coating up to 2.5 μ

Carbide series

Carbide-tipped core drills. For machining stainless steel and non-ferrous metals, we recommend our BDS 6000 high-performance cooling lubricant concentrate.



Carbide-PLUS series

Carbide-tipped core drills with carbide coating.



Carbide-RAIL series

Carbide-tipped core drills for rail core drilling machines.



Quick-In series

HSS-Co 8-F/carbide
Core drills made from HSS tool steel or carbide-tipped. Suitable for Quick-In arbor systems.



Carbide series

| HKK | HKL | HKX-L | HKE-L |
|-------------|-------------|-------------|-------------|
| 30 mm | 55 mm | 75 mm | 110 mm |
| 12 – 150 mm | 12 – 100 mm | 18 – 120 mm | 20 – 120 mm |

Carbide-PLUS series

| HKK-P |
|------------|
| 30 mm |
| 12 – 60 mm |

Carbide-RAIL series

| HKK-R |
|------------|
| 30 mm |
| 17 – 36 mm |

Quick-In series

| KBK-CO 8 F | HKK-F |
|------------|------------|
| 35 mm | 35 mm |
| 12 – 60 mm | 12 – 60 mm |

HSS-CO 8 CORE DRILL SERIES



The drills from this series have outstanding heat resistance and wear protection. In combination with speed-controlled BDS magnetic core drilling machines, they are suitable for machining fine-grained steels and rustproof materials. BDS recommends the BDS 5000 cutting oil for machining stainless steel.

HSS-Co 8 Short core drill

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-Co 8 Short core drill

- > 30 mm cutting depth
- > 32 mm Weldon shank (1 1/4")



HSS-Co 8 SERIES

| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
|------|------------|------|------------|
| 12 | KBK-CO 012 | 36 | KBK-CO 036 |
| 13 | KBK-CO 013 | 37 | KBK-CO 037 |
| 14 | KBK-CO 014 | 38 | KBK-CO 038 |
| 15 | KBK-CO 015 | 39 | KBK-CO 039 |
| 16 | KBK-CO 016 | 40 | KBK-CO 040 |
| 17 | KBK-CO 017 | 41 | KBK-CO 041 |
| 17.5 | KBK-CO 175 | 42 | KBK-CO 042 |
| 18 | KBK-CO 018 | 43 | KBK-CO 043 |
| 19 | KBK-CO 019 | 44 | KBK-CO 044 |
| 19.5 | KBK-CO 195 | 45 | KBK-CO 045 |
| 20 | KBK-CO 020 | 46 | KBK-CO 046 |
| 21 | KBK-CO 021 | 47 | KBK-CO 047 |
| 22 | KBK-CO 022 | 48 | KBK-CO 048 |
| 23 | KBK-CO 023 | 49 | KBK-CO 049 |
| 24 | KBK-CO 024 | 50 | KBK-CO 050 |
| 25 | KBK-CO 025 | 51 | KBK-CO 051 |
| 26 | KBK-CO 026 | 52 | KBK-CO 052 |
| 27 | KBK-CO 027 | 53 | KBK-CO 053 |
| 28 | KBK-CO 028 | 54 | KBK-CO 054 |
| 29 | KBK-CO 029 | 55 | KBK-CO 055 |
| 30 | KBK-CO 030 | 56 | KBK-CO 056 |
| 31 | KBK-CO 031 | 57 | KBK-CO 057 |
| 32 | KBK-CO 032 | 58 | KBK-CO 058 |
| 33 | KBK-CO 033 | 59 | KBK-CO 059 |
| 34 | KBK-CO 034 | 60 | KBK-CO 060 |
| 35 | KBK-CO 035 | | |

HSS-Co 8 SERIES

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

EJECTOR PIN FOR KBK-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBK-CO, Ø 61 – 130 mm

ORDER NO.

ZAK 090

HSS-Co 8 core drill series

Fully ground core drills
made from high-performance high-speed steel.

HSS-Co 8 Long core drill

- > 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



| HSS-Co 8 SERIES | | | |
|-----------------|------------|------|------------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBL-CO 012 | 36 | KBL-CO 036 |
| 13 | KBL-CO 013 | 37 | KBL-CO 037 |
| 14 | KBL-CO 014 | 38 | KBL-CO 038 |
| 15 | KBL-CO 015 | 39 | KBL-CO 039 |
| 16 | KBL-CO 016 | 40 | KBL-CO 040 |
| 17 | KBL-CO 017 | 41 | KBL-CO 041 |
| 17.5 | KBL-CO 175 | 42 | KBL-CO 042 |
| 18 | KBL-CO 018 | 43 | KBL-CO 043 |
| 19 | KBL-CO 019 | 44 | KBL-CO 044 |
| 19.5 | KBL-CO 195 | 45 | KBL-CO 045 |
| 20 | KBL-CO 020 | 46 | KBL-CO 046 |
| 21 | KBL-CO 021 | 47 | KBL-CO 047 |
| 22 | KBL-CO 022 | 48 | KBL-CO 048 |
| 23 | KBL-CO 023 | 49 | KBL-CO 049 |
| 24 | KBL-CO 024 | 50 | KBL-CO 050 |
| 25 | KBL-CO 025 | 51 | KBL-CO 051 |
| 26 | KBL-CO 026 | 52 | KBL-CO 052 |
| 27 | KBL-CO 027 | 53 | KBL-CO 053 |
| 28 | KBL-CO 028 | 54 | KBL-CO 054 |
| 29 | KBL-CO 029 | 55 | KBL-CO 055 |
| 30 | KBL-CO 030 | 56 | KBL-CO 056 |
| 31 | KBL-CO 031 | 57 | KBL-CO 057 |
| 32 | KBL-CO 032 | 58 | KBL-CO 058 |
| 33 | KBL-CO 033 | 59 | KBL-CO 059 |
| 34 | KBL-CO 034 | 60 | KBL-CO 060 |
| 35 | KBL-CO 035 | | |

HSS-Co 8 Long core drill

- > 55 mm cutting depth
- > 32 mm Weldon shank (1 1/4")



| HSS-Co 8 SERIES | | | |
|-----------------|------------|------|------------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 61 | KBL-CO 061 | 81 | KBL-CO 081 |
| 62 | KBL-CO 062 | 82 | KBL-CO 082 |
| 63 | KBL-CO 063 | 83 | KBL-CO 083 |
| 64 | KBL-CO 064 | 84 | KBL-CO 084 |
| 65 | KBL-CO 065 | 85 | KBL-CO 085 |
| 66 | KBL-CO 066 | 86 | KBL-CO 086 |
| 67 | KBL-CO 067 | 87 | KBL-CO 087 |
| 68 | KBL-CO 068 | 88 | KBL-CO 088 |
| 69 | KBL-CO 069 | 89 | KBL-CO 089 |
| 70 | KBL-CO 070 | 90 | KBL-CO 090 |
| 71 | KBL-CO 071 | 91 | KBL-CO 091 |
| 72 | KBL-CO 072 | 92 | KBL-CO 092 |
| 73 | KBL-CO 073 | 93 | KBL-CO 093 |
| 74 | KBL-CO 074 | 94 | KBL-CO 094 |
| 75 | KBL-CO 075 | 95 | KBL-CO 095 |
| 76 | KBL-CO 076 | 96 | KBL-CO 096 |
| 77 | KBL-CO 077 | 97 | KBL-CO 097 |
| 78 | KBL-CO 078 | 98 | KBL-CO 098 |
| 79 | KBL-CO 079 | 99 | KBL-CO 099 |
| 80 | KBL-CO 080 | 100 | KBL-CO 100 |

EJECTOR PIN FOR KBL-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 100

Ejector pin FOR KBL-CO, Ø 61 – 100 mm

ORDER NO.

ZAK 120

Optimum drilling and lubrication with BDS products.

Recommended cutting speed

| Core drill series | Material | m/min |
|----------------------|-------------------------------|---------|
| HSS-Co 8 | Fine-grained steel | |
| | < 700 N/m ² | 10 – 15 |
| | < 1000 N/m ² | 10 – 15 |
| | Stainless steel | 10 – 15 |
| | Cast iron (depending on type) | 15 – 20 |
| HSS-VarioPLUS | Fine-grained steel | |
| | < 700 N/m ² | 10 – 15 |
| | < 1000 N/m ² | 10 – 15 |
| HSS-Standard | Aluminium | 20 – 30 |
| | Steel | 25 |
| | Cast iron | 10 – 20 |
| Carbide | Steel/fine-grained steel | |
| | < 500 N/m ² | 35 |
| | < 700 N/m ² | 25 |
| | < 1,000 N/m ² | 20 |
| | Rustproof, stainless steel | 20 |
| Carbide-PLUS | Steel/fine-grained steel | |
| | < 500 N/m ² | 35 |
| | < 700 N/m ² | 25 |
| | < 1,000 N/m ² | 20 |
| | Rustproof, stainless steel | 20 |
| Carbide-RAIL | Railway rails | 15 – 20 |

Cutting speed:

$$V_c = \frac{d \times \pi \times n}{1,000} = \text{m/min.}$$

Table of speeds

| Diame-ter | Vc 15 m/ min | Vc 20 m/ min | Vc 25 m/ min | Vc 30 m/ min | Vc 35 m/ min |
|-----------|--------------|--------------|--------------|--------------|--------------|
| Ø | rpm | rpm | rpm | rpm | rpm |
| 14 | 340 | 460 | 570 | 690 | 800 |
| 18 | 260 | 360 | 450 | 540 | 620 |
| 22 | 220 | 300 | 370 | 440 | 510 |
| 26 | 180 | 250 | 310 | 370 | 430 |
| 30 | 160 | 220 | 270 | 320 | 380 |
| 35 | 140 | 190 | 230 | 280 | 320 |
| 40 | 120 | 160 | 200 | 240 | 280 |
| 45 | 110 | 150 | 180 | 220 | 250 |
| 50 | 100 | 130 | 160 | 200 | 230 |
| 55 | 90 | 120 | 150 | 180 | 210 |
| 60 | 80 | 110 | 140 | 160 | 190 |
| 65 | 75 | 100 | 130 | 150 | 180 |
| 70 | 70 | 90 | 120 | 140 | 160 |
| 75 | 65 | 85 | 110 | 130 | 150 |
| 80 | 60 | 80 | 100 | 120 | 140 |
| 85 | 55 | 75 | 95 | 110 | 130 |
| 90 | 55 | 70 | 90 | 110 | 120 |
| 95 | 50 | 65 | 85 | 100 | 120 |
| 100 | 50 | 65 | 80 | 100 | 110 |
| 110 | 45 | 60 | 80 | 90 | 100 |
| 120 | 40 | 60 | 70 | 80 | 100 |
| 130 | 40 | 50 | 60 | 80 | 90 |

Speed:

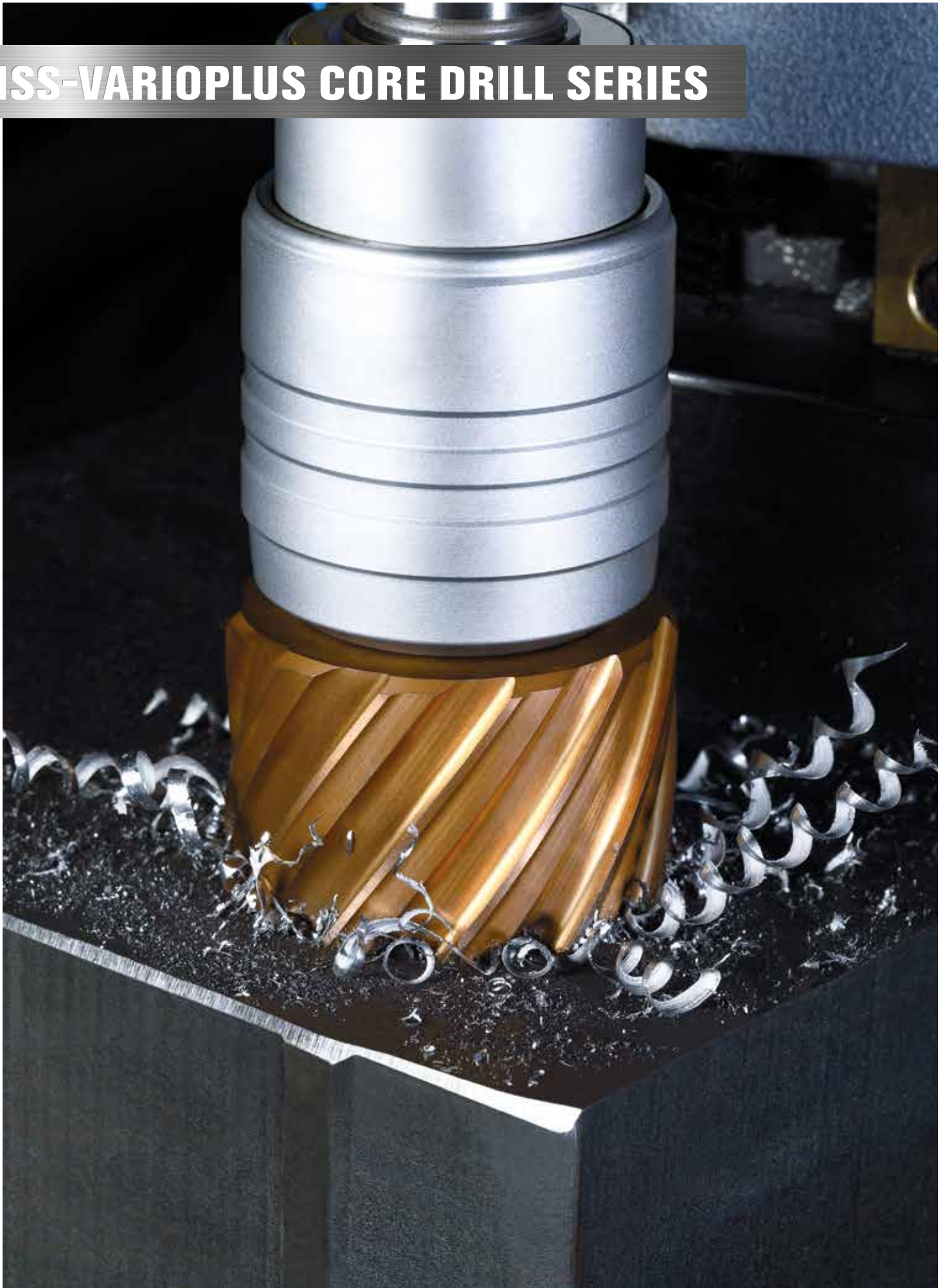
$$n = \frac{v \times 1,000}{d \times \pi} = \text{rpm}$$

Assignment of BDS drill series and the appropriate BDS cooling lubricants to the material.

| | Cutting oil BDS 5000 | Lubrication spray BDS 5200 | Cutting paste BDS 5500 | Paste ZHS 570 | BDS 6000 cooling lubricant concentrate |
|--|-------------------------|-------------------------------|---------------------------|------------------|---|
| Aluminium, non-ferrous metals | | | | | |
| HSS-Standard | • | • | | | |
| Steel < 500 N/m² | | | | | |
| HSS-Standard | • | • | | | |
| Carbide | | | | | • |
| Carbide-PLUS | | | | | • |
| Fine-grained steel < 700 N/m² | | | | | |
| HSS-Co 8 | • | • | • | • | |
| HSS-VarioPLUS | • | • | • | • | |
| Carbide | | | | | • |
| Carbide-PLUS | | | | | • |
| Fine-grained steel < 1,000 N/m² | | | | | |
| HSS-Co 8 | • | • | • | • | |
| HSS-VarioPLUS | • | • | • | • | |
| Carbide | | | | | • |
| Carbide-PLUS | | | | | • |
| Rustproof steels, stainless steel | | | | | |
| HSS-Co 8 | • | • | • | • | |
| Carbide | | | | | • |
| Carbide-PLUS | | | | | • |
| Cast iron | | | | | |
| HSS-Co 8 | | | | | • |
| HSS-Standard | | | | | • |
| Railway rails | | | | | |
| Carbide-RAIL | | | | | • |



HSS-VARIOPLUS CORE DRILL SERIES



Fully ground core drills made from high-performance high-speed steel with carbide coating. High economic efficiency due to longer service life, greater safety during work thanks to excellent discharge of chips, particularly for long core drills. BDS recommends the BDS 5000 high-performance cutting oil.

HSS-VarioPLUS short core drill

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-VarioPLUS long core drill

- > 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-VarioPLUS SERIES

| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
|------|------------|------|------------|
| 12 | KBK-VP 012 | 36 | KBK-VP 036 |
| 13 | KBK-VP 013 | 37 | KBK-VP 037 |
| 14 | KBK-VP 014 | 38 | KBK-VP 038 |
| 15 | KBK-VP 015 | 39 | KBK-VP 039 |
| 16 | KBK-VP 016 | 40 | KBK-VP 040 |
| 17 | KBK-VP 017 | 41 | KBK-VP 041 |
| 17.5 | KBK-VP 175 | 42 | KBK-VP 042 |
| 18 | KBK-VP 018 | 43 | KBK-VP 043 |
| 19 | KBK-VP 019 | 44 | KBK-VP 044 |
| 19.5 | KBK-VP 195 | 45 | KBK-VP 045 |
| 20 | KBK-VP 020 | 46 | KBK-VP 046 |
| 21 | KBK-VP 021 | 47 | KBK-VP 047 |
| 22 | KBK-VP 022 | 48 | KBK-VP 048 |
| 23 | KBK-VP 023 | 49 | KBK-VP 049 |
| 24 | KBK-VP 024 | 50 | KBK-VP 050 |
| 25 | KBK-VP 025 | 51 | KBK-VP 051 |
| 26 | KBK-VP 026 | 52 | KBK-VP 052 |
| 27 | KBK-VP 027 | 53 | KBK-VP 053 |
| 28 | KBK-VP 028 | 54 | KBK-VP 054 |
| 29 | KBK-VP 029 | 55 | KBK-VP 055 |
| 30 | KBK-VP 030 | 56 | KBK-VP 056 |
| 31 | KBK-VP 031 | 57 | KBK-VP 057 |
| 32 | KBK-VP 032 | 58 | KBK-VP 058 |
| 33 | KBK-VP 033 | 59 | KBK-VP 059 |
| 34 | KBK-VP 034 | 60 | KBK-VP 060 |
| 35 | KBK-VP 035 | | |

HSS-VarioPLUS SERIES

| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
|------|------------|------|------------|
| 12 | KBL-VP 012 | 36 | KBL-VP 036 |
| 13 | KBL-VP 013 | 37 | KBL-VP 037 |
| 14 | KBL-VP 014 | 38 | KBL-VP 038 |
| 15 | KBL-VP 015 | 39 | KBL-VP 039 |
| 16 | KBL-VP 016 | 40 | KBL-VP 040 |
| 17 | KBL-VP 017 | 41 | KBL-VP 041 |
| 17.5 | KBL-VP 175 | 42 | KBL-VP 042 |
| 18 | KBL-VP 018 | 43 | KBL-VP 043 |
| 19 | KBL-VP 019 | 44 | KBL-VP 044 |
| 19.5 | KBL-VP 195 | 45 | KBL-VP 045 |
| 20 | KBL-VP 020 | 46 | KBL-VP 046 |
| 21 | KBL-VP 021 | 47 | KBL-VP 047 |
| 22 | KBL-VP 022 | 48 | KBL-VP 048 |
| 23 | KBL-VP 023 | 49 | KBL-VP 049 |
| 24 | KBL-VP 024 | 50 | KBL-VP 050 |
| 25 | KBL-VP 025 | 51 | KBL-VP 051 |
| 26 | KBL-VP 026 | 52 | KBL-VP 052 |
| 27 | KBL-VP 027 | 53 | KBL-VP 053 |
| 28 | KBL-VP 028 | 54 | KBL-VP 054 |
| 29 | KBL-VP 029 | 55 | KBL-VP 055 |
| 30 | KBL-VP 030 | 56 | KBL-VP 056 |
| 31 | KBL-VP 031 | 57 | KBL-VP 057 |
| 32 | KBL-VP 032 | 58 | KBL-VP 058 |
| 33 | KBL-VP 033 | 59 | KBL-VP 059 |
| 34 | KBL-VP 034 | 60 | KBL-VP 060 |
| 35 | KBL-VP 035 | | |

EJECTOR PIN FOR KBK-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 100

HSS-STANDARD CORE DRILL SERIES



The basic core drill range for professional use. Fully ground core drill made from high-performance high-speed steel on CNC-controlled grinding centres, with good discharge of chips. Drilling with minimal effort. For working on a horizontal plane, BDS recommends the BDS 5200 high-performance lubrication spray.

HSS-Standard short core drill

- > 30 mm cutting depth
- > 19 mm Weldon shank ($\frac{3}{4}$ "



HSS-Standard long core drill

- > 55 mm cutting depth
- > 19 mm Weldon shank ($\frac{3}{4}$ "



| HSS-STANDARD SERIES | | | |
|---------------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBK 012 | 36 | KBK 036 |
| 13 | KBK 013 | 37 | KBK 037 |
| 14 | KBK 014 | 38 | KBK 038 |
| 15 | KBK 015 | 39 | KBK 039 |
| 16 | KBK 016 | 40 | KBK 040 |
| 17 | KBK 017 | 41 | KBK 041 |
| 17.5 | KBK 175 | 42 | KBK 042 |
| 18 | KBK 018 | 43 | KBK 043 |
| 19 | KBK 019 | 44 | KBK 044 |
| 19.5 | KBK 195 | 45 | KBK 045 |
| 20 | KBK 020 | 46 | KBK 046 |
| 21 | KBK 021 | 47 | KBK 047 |
| 22 | KBK 022 | 48 | KBK 048 |
| 23 | KBK 023 | 49 | KBK 049 |
| 24 | KBK 024 | 50 | KBK 050 |
| 25 | KBK 025 | 51 | KBK 051 |
| 26 | KBK 026 | 52 | KBK 052 |
| 27 | KBK 027 | 53 | KBK 053 |
| 28 | KBK 028 | 54 | KBK 054 |
| 29 | KBK 029 | 55 | KBK 055 |
| 30 | KBK 030 | 56 | KBK 056 |
| 31 | KBK 031 | 57 | KBK 057 |
| 32 | KBK 032 | 58 | KBK 058 |
| 33 | KBK 033 | 59 | KBK 059 |
| 34 | KBK 034 | 60 | KBK 060 |
| 35 | KBK 035 | | |

| HSS-STANDARD SERIES | | | |
|---------------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBL 012 | 36 | KBL 036 |
| 13 | KBL 013 | 37 | KBL 037 |
| 14 | KBL 014 | 38 | KBL 038 |
| 15 | KBL 015 | 39 | KBL 039 |
| 16 | KBL 016 | 40 | KBL 040 |
| 17 | KBL 017 | 41 | KBL 041 |
| 17.5 | KBL 175 | 42 | KBL 042 |
| 18 | KBL 018 | 43 | KBL 043 |
| 19 | KBL 019 | 44 | KBL 044 |
| 19.5 | KBL 195 | 45 | KBL 045 |
| 20 | KBL 020 | 46 | KBL 046 |
| 21 | KBL 021 | 47 | KBL 047 |
| 22 | KBL 022 | 48 | KBL 048 |
| 23 | KBL 023 | 49 | KBL 049 |
| 24 | KBL 024 | 50 | KBL 050 |
| 25 | KBL 025 | 51 | KBL 051 |
| 26 | KBL 026 | 52 | KBL 052 |
| 27 | KBL 027 | 53 | KBL 053 |
| 28 | KBL 028 | 54 | KBL 054 |
| 29 | KBL 029 | 55 | KBL 055 |
| 30 | KBL 030 | 56 | KBL 056 |
| 31 | KBL 031 | 57 | KBL 057 |
| 32 | KBL 032 | 58 | KBL 058 |
| 33 | KBL 033 | 59 | KBL 059 |
| 34 | KBL 034 | 60 | KBL 060 |
| 35 | KBL 035 | | |

| EJECTOR PIN FOR KBK, Ø 12 – 60 mm | |
|-----------------------------------|--|
| ORDER NO. | |
| ZAK 075 | |

| EJECTOR PIN FOR KBL, Ø 12 – 60 mm | |
|-----------------------------------|--|
| ORDER NO. | |
| ZAK 100 | |

HSS-Standard

Fully groundcore drills
made from high-performance
high-speed steel.

HSS-Standard core drill Extra-long

- > 110 mm cutting depth
- > 19 mm Weldon shank (3/4")



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

HSS-Standard, Inches

Fully ground core drills
made from high-performance high-speed steel.

HSS-Standard core drill Short, Inches

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



| HSS-STANDARD SERIES, IMPERIAL | | |
|-------------------------------|--------|---------------|
| Ø Inches | Ø mm | ORDER NO. |
| 1/2" | 12.700 | KBK-Z 1/2 |
| 9/16" | 14.288 | KBK-Z 9/16 |
| 5/8" | 15.875 | KBK-Z 5/8 |
| 11/16" | 17.463 | KBK-Z 11/16 |
| 3/4" | 19.050 | KBK-Z 3/4 |
| 13/16" | 20.638 | KBK-Z 13/16 |
| 7/8" | 22.225 | KBK-Z 7/8 |
| 15/16" | 23.813 | KBK-Z 15/16 |
| 1" | 25.400 | KBK-Z 1 |
| 1 1/16" | 26.988 | KBK-Z 1 1/16 |
| 1 1/8" | 28.575 | KBK-Z 1 1/8 |
| 1 3/16" | 30.136 | KBK-Z 1 3/16 |
| 1 1/4" | 31.750 | KBK-Z 1 1/4 |
| 1 5/16" | 33.338 | KBK-Z 1 5/16 |
| 1 3/8" | 34.925 | KBK-Z 1 3/8 |
| 1 7/16" | 36.513 | KBK-Z 1 7/16 |
| 1 1/2" | 38.100 | KBK-Z 1 1/2 |
| 1 9/16" | 39.688 | KBK-Z 1 9/16 |
| 1 5/8" | 41.276 | KBK-Z 1 5/8 |
| 1 11/16" | 42.863 | KBK-Z 1 11/16 |
| 1 3/4" | 44.450 | KBK-Z 1 3/4 |
| 1 13/16" | 46.038 | KBK-Z 1 13/16 |
| 1 7/8" | 47.625 | KBK-Z 1 7/8 |
| 1 15/16" | 49.213 | KBK-Z 1 15/16 |
| 2" | 50.800 | KBK-Z 2 |
| 2 1/16" | 52.388 | KBK-Z 2 1/16 |

| EJECTOR PIN FOR KEL, Ø 20 – 50 mm | |
|-----------------------------------|------------------|
| ORDER NO. | VERSION |
| ZAK 275 | Two-part version |

| EJECTOR PIN FOR KBK-Z, Ø 1/2" – 2 1/16" | |
|---|--|
| ORDER NO. | |
| ZAK 075 | |

Quality features that make the difference.



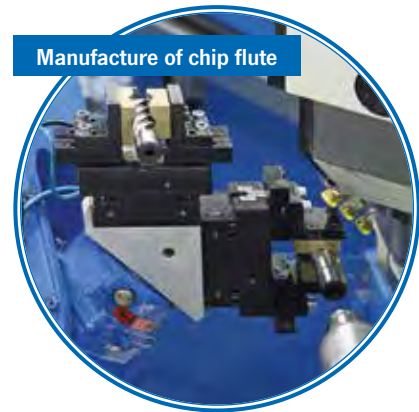
Grinding the end teeth

Modern CNC-controlled grinding centres ensure consistent quality.



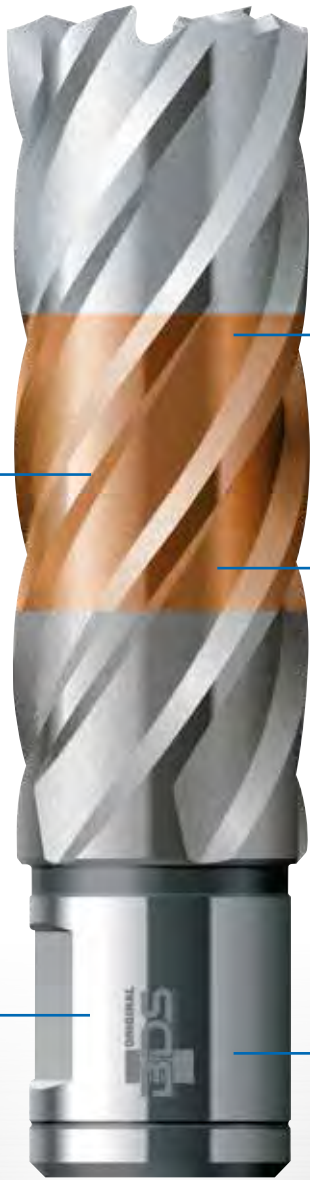
Perfect cylindrical grinding

Maximum concentricity and a high degree of dimensional stability are guaranteed by the latest generation of cylindrical grinding machines.



Manufacture of chip flute

Optimised work processes and quick loading operations with loading robots speed up the work process.



VarioPLUS coating

The VarioPLUS developed for BDS provides an additional protective layer on the tools. A hard coating provides a high degree of heat resistance and increased hardness of the coating.

The best raw materials



Böhrler high-performance tool steel ensures continuous quality of the highest standard.

From the first to the last cut!

HSS-Co 8%, HSS-VarioPLUS and HSS-BDS fully ground core drills



Unprocessed round bar



Mechanically processed



Hardened



Ground to external dimension



Ground with flute and end tooth



Coated VarioPLUS core drills



CARBIDE CORE DRILL SERIES



BDS carbide-tipped core drills. Series with cutting depths of 30 mm, 35 mm, 55 mm, 75 mm and 110 mm and almost stepless graduations of the diameter from Ø 12 mm to Ø 150 mm. BDS recommends the BDS 6000 high-performance cooling lubricant concentrate for machining stainless steel and non-ferrous metals.

Carbide (TCT) Core Drills Short

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



Carbide (TCT) Core Drills Short

- > 30 mm cutting depth
- > 32 mm Weldon shank (1 1/4")



CARBIDE SERIES

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

CARBIDE SERIES

| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
|------|-----------|------|-----------|
| 61 | HKK 061 | 86 | HKK 086 |
| 62 | HKK 062 | 87 | HKK 087 |
| 63 | HKK 063 | 88 | HKK 088 |
| 64 | HKK 064 | 89 | HKK 089 |
| 65 | HKK 065 | 90 | HKK 090 |
| 66 | HKK 066 | 91 | HKK 091 |
| 67 | HKK 067 | 92 | HKK 092 |
| 68 | HKK 068 | 93 | HKK 093 |
| 69 | HKK 069 | 94 | HKK 094 |
| 70 | HKK 070 | 95 | HKK 095 |
| 71 | HKK 071 | 96 | HKK 096 |
| 72 | HKK 072 | 97 | HKK 097 |
| 73 | HKK 073 | 98 | HKK 098 |
| 74 | HKK 074 | 99 | HKK 099 |
| 75 | HKK 075 | 100 | HKK 100 |
| 76 | HKK 076 | 105 | HKK 105 |
| 77 | HKK 077 | 110 | HKK 110 |
| 78 | HKK 078 | 115 | HKK 115 |
| 79 | HKK 079 | 120 | HKK 120 |
| 80 | HKK 080 | 125 | HKK 125 |
| 81 | HKK 081 | 130 | HKK 130 |
| 82 | HKK 082 | 135 | HKK 135 |
| 83 | HKK 083 | 140 | HKK 140 |
| 84 | HKK 084 | 145 | HKK 145 |
| 85 | HKK 085 | 150 | HKK 150 |

EJECTOR PIN FOR HKK, Ø 14 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK, Ø 61 – 150 mm

ORDER NO.

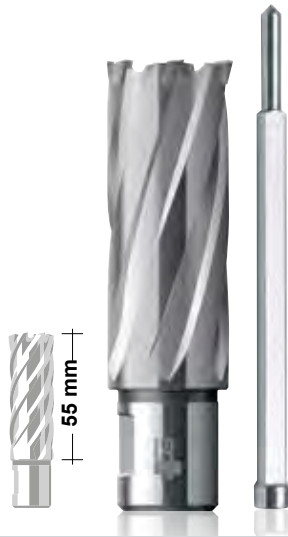
ZAK 090

Carbide (TCT)

Tungsten Carbide Tip Core Drills

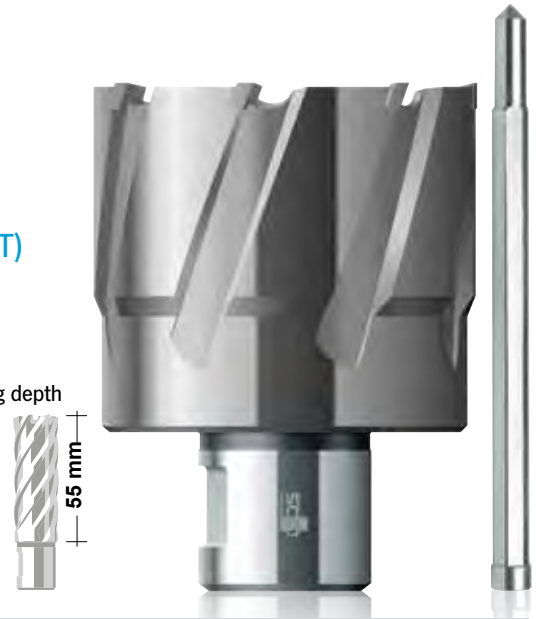
Carbide (TCT) Core Drills Long

- > 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



Carbide (TCT) Core Drills Long

- > 55 mm cutting depth
- > 32 mm Weldon shank (1 1/4")



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

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

EJECTOR PIN FOR HKL, Ø 14 – 60 mm

ORDER NO.

ZAK 100

EJECTOR PIN FOR HKL, Ø 61 – 100 mm

ORDER NO.

ZAK 120

Carbide (TCT) Core Drills Overlong

- > 75 mm cutting depth
- > up to Ø 60 mm:
19 mm Weldon shank (¾")
- > from Ø 61 mm
32 mm Weldon shank (1 ¼")



Carbide (TCT) Core Drills Overlong

- > 110 mm cutting depth
- > up to Ø 60 mm:
19 mm Weldon shank (¾")
- > from Ø 61 mm
32 mm Weldon shank (1 ¼")



| CARBIDE SERIES | | | |
|----------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 18 | HKX-L 018 | 44 | HKX-L 044 |
| 19 | HKX-L 019 | 45 | HKX-L 045 |
| 20 | HKX-L 020 | 46 | HKX-L 046 |
| 21 | HKX-L 021 | 47 | HKX-L 047 |
| 22 | HKX-L 022 | 48 | HKX-L 048 |
| 23 | HKX-L 023 | 49 | HKX-L 049 |
| 24 | HKX-L 024 | 50 | HKX-L 050 |
| 25 | HKX-L 025 | 51 | HKX-L 051 |
| 26 | HKX-L 026 | 52 | HKX-L 052 |
| 27 | HKX-L 027 | 53 | HKX-L 053 |
| 28 | HKX-L 028 | 54 | HKX-L 054 |
| 29 | HKX-L 029 | 55 | HKX-L 055 |
| 30 | HKX-L 030 | 56 | HKX-L 056 |
| 31 | HKX-L 031 | 57 | HKX-L 057 |
| 32 | HKX-L 032 | 58 | HKX-L 058 |
| 33 | HKX-L 033 | 59 | HKX-L 059 |
| 34 | HKX-L 034 | 60 | HKX-L 060 |
| 35 | HKX-L 035 | 65 | HKX-L 065 |
| 36 | HKX-L 036 | 70 | HKX-L 070 |
| 37 | HKX-L 037 | 75 | HKX-L 075 |
| 38 | HKX-L 038 | 80 | HKX-L 080 |
| 39 | HKX-L 039 | 90 | HKX-L 090 |
| 40 | HKXL 040 | 100 | HKX-L 100 |
| 41 | HKX-L 041 | 110 | HKX-L 110 |
| 42 | HKX-L 042 | 120 | HKX-L 120 |
| 43 | HKX-L 043 | | |

| CARBIDE SERIES | | | |
|----------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 20 | HKE-L 020 | 45 | HKE-L 045 |
| 21 | HKE-L 021 | 46 | HKE-L 046 |
| 22 | HKE-L 022 | 47 | HKE-L 047 |
| 23 | HKE-L 023 | 48 | HKE-L 048 |
| 24 | HKE-L 024 | 49 | HKE-L 049 |
| 25 | HKE-L 025 | 50 | HKE-L 050 |
| 26 | HKE-L 026 | 51 | HKE-L 051 |
| 27 | HKE-L 027 | 52 | HKE-L 052 |
| 28 | HKE-L 028 | 53 | HKE-L 053 |
| 29 | HKE-L 029 | 54 | HKE-L 054 |
| 30 | HKE-L 030 | 55 | HKE-L 055 |
| 31 | HKE-L 031 | 56 | HKE-L 056 |
| 32 | HKE-L 032 | 57 | HKE-L 057 |
| 33 | HKE-L 033 | 58 | HKE-L 058 |
| 34 | HKE-L 034 | 59 | HKE-L 059 |
| 35 | HKE-L 035 | 60 | HKE-L 060 |
| 36 | HKE-L 036 | 65 | HKE-L 065 |
| 37 | HKE-L 037 | 70 | HKE-L 070 |
| 38 | HKE-L 038 | 75 | HKE-L 075 |
| 39 | HKE-L 039 | 80 | HKE-L 080 |
| 40 | HKE-L 040 | 90 | HKE-L 090 |
| 41 | HKE-L 041 | 100 | HKE-L 100 |
| 42 | HKE-L 042 | 110 | HKE-L 110 |
| 43 | HKE-L 043 | 120 | HKE-L 120 |
| 44 | HKE-L 044 | | |

EJECTOR PIN FOR HKX-L, Ø 18 – 120 mm

ORDER NO. VERSION

- ZAK 225 Two-part for core drill cutting depth of 75 mm, Ø 18 – 60
 ZAK 245 Two-part for core drill cutting depth of 75 mm, Ø 61 – 120

EJECTOR PIN FOR HKE-L, Ø 20 – 120 mm

ORDER NO. VERSION

- ZAK 275 Two-part version

Carbide-PLUS

Carbide-tipped core drills with carbide coating.

Carbide-PLUS Short core drill

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



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

Carbide-RAIL

Carbide-tipped core drills for railway track drilling.

Carbide-RAIL core drill

- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



| CARBIDE-RAIL SERIES | | | |
|---------------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 17 | HKK-R 017 | 27 | HKK-R 027 |
| 18 | HKK-R 018 | 28 | HKK-R 028 |
| 19 | HKK-R 019 | 29 | HKK-R 029 |
| 20 | HKK-R 020 | 30 | HKK-R 030 |
| 21 | HKK-R 021 | 31 | HKK-R 031 |
| 22 | HKK-R 022 | 32 | HKK-R 032 |
| 23 | HKK-R 023 | 33 | HKK-R 033 |
| 24 | HKK-R 024 | 34 | HKK-R 034 |
| 25 | HKK-R 025 | 35 | HKK-R 035 |
| 26 | HKK-R 026 | 36 | HKK-R 036 |



EJECTOR PIN FOR HKK-P, Ø 14 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK-R, Ø 17 – 36 mm

ORDER NO.

ZAK 075

Quick-In HSS-Co 8-F

Core drills made from tool steel with high cobalt content, for increased heat resistance and wear protection. For Quick-In arbor system.

HSS-Co 8-F short core drill

- > 35 mm cutting depth
- > 18 mm shank for Quick-In arbor system



| HSS-Co 8-F SERIES | | | |
|-------------------|-----------|------|-----------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBK-F 012 | 37 | KBK-F 037 |
| 13 | KBK-F 013 | 38 | KBK-F 038 |
| 14 | KBK-F 014 | 39 | KBK-F 039 |
| 15 | KBK-F 015 | 40 | KBK-F 040 |
| 16 | KBK-F 016 | 41 | KBK-F 041 |
| 17 | KBK-F 017 | 42 | KBK-F 042 |
| 18 | KBK-F 018 | 43 | KBK-F 043 |
| 19 | KBK-F 019 | 44 | KBK-F 044 |
| 20 | KBK-F 020 | 45 | KBK-F 045 |
| 21 | KBK-F 021 | 46 | KBK-F 046 |
| 22 | KBK-F 022 | 47 | KBK-F 047 |
| 23 | KBK-F 023 | 48 | KBK-F 048 |
| 24 | KBK-F 024 | 49 | KBK-F 049 |
| 25 | KBK-F 025 | 50 | KBK-F 050 |
| 26 | KBK-F 026 | 51 | KBK-F 051 |
| 27 | KBK-F 027 | 52 | KBK-F 052 |
| 28 | KBK-F 028 | 53 | KBK-F 053 |
| 29 | KBK-F 029 | 54 | KBK-F 054 |
| 30 | KBK-F 030 | 55 | KBK-F 055 |
| 31 | KBK-F 031 | 56 | KBK-F 056 |
| 32 | KBK-F 032 | 57 | KBK-F 057 |
| 33 | KBK-F 033 | 58 | KBK-F 058 |
| 34 | KBK-F 034 | 59 | KBK-F 059 |
| 35 | KBK-F 035 | 60 | KBK-F 060 |
| 36 | KBK-F 036 | | |

Quick-In carbide-F

Carbide-tipped core drills. For Quick-In arbor system.

Short carbide-F core drill

- > 35 mm cutting depth
- > 18 mm shank for Quick-In arbor system



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

EJECTOR PIN FOR HSS-Co 8-F, Ø 12 – 60 mm

ORDER NO.

ZAK 096

EJECTOR PIN FOR HKK-F, Ø 12 – 60 mm

ORDER NO.

ZAK 096

Core drill box

Five BDS core drills of the most common sizes in a compact plastic box.

Core drill sets 5 core drills

- > 30 mm and 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-Standard short core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|-------------------|---|
| KBK box, standard | 2 x KBK 014 2 x KBK 018 1 x KBK 022 |

HSS-VarioPLUS short core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|------------|--|
| KBK-VP box | 2 x KBK-VP 014 2 x KBK-VP 018 1 x KBK-VP 022 |

HSS-Co short core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|------------|-------------------------------|
| KBK-CO box | 2 x 014 2 x 018 1 x 022 |

HSS-Standard long core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|------------------|---|
| KBK box standard | 2 x KBL 014 2 x KBL 018 1 x KBL 022 |

HSS-VarioPLUS long core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|------------|--|
| KBL-VP box | 2 x KBL-VP 014 2 x KBL-VP 018 1 x KBL-VP 022 |

Short carbide core drill



CORE DRILL BOX

| ORDER NO. | CONTENTS |
|-----------|---|
| HKK box | 2 x HKK 014 2 x HKK 018 1 x HKK 022 |

Core drill case

Six BDS core drills in the most common sizes in a sturdy plastic case.

Core drill sets
6 core drills
plus 1 ejector pin

- > High-performance high-speed steel
- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-Co 8 short core drill



HSS-Standard short core drill



HSS-VarioPLUS short core drill



| CORE DRILL CASE | |
|-----------------|---|
| ORDER NO. | CONTENTS |
| KBK-CO 001 | 2 x KBK-CO 014 2 x KBK-CO 018 2 x KBK-CO 022 1 x ZAK 075 |
| KBK-CO 002 | 1 x KBK-CO 013 1 x KBK-CO 014 1 x KBK-CO 017 1 x KBK-CO 018 1 x KBK-CO 021 1 x KBK-CO 022 1 x ZAK 075 |

| CORE DRILL CASE | |
|-----------------|---|
| ORDER NO. | CONTENTS |
| KBK 001 | 2 x KBK 014 2 x KBK 018 2 x KBK 022 1 x ZAK 075 |
| 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 |

| CORE DRILL CASE | |
|-----------------|---|
| ORDER NO. | CONTENTS |
| KBK-VP 001 | 2 x KBK-VP 014 2 x KBK-VP 018 2 x KBK-VP 022 1 x ZAK 075 |
| KBK-VP 002 | 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 |

Twist drills, countersinks and machine screw taps

HSS twist drills with 19 mm ($\frac{3}{4}$ ")
Weldon shank
Twist length 35 mm



| Ø | Twist length | Order No. |
|-------|--------------|-----------|
| 6.00 | 35 mm | SPS 060 |
| 6.80 | 35 mm | SPS 068 |
| 8.00 | 35 mm | SPS 080 |
| 8.50 | 35 mm | SPS 085 |
| 10.00 | 35 mm | SPS 100 |
| 10.20 | 35 mm | SPS 102 |
| 12.00 | 35 mm | SPS 120 |
| 13.00 | 35 mm | SPS 130 |
| 14.00 | 35 mm | SPS 140 |

HSS machine screw taps with 19 mm ($\frac{3}{4}$ ") Weldon shank
DIN 376 form B



| Ø | Total length | DIN | Order No. |
|-----|--------------|----------------|-----------|
| M8 | 90 mm | DIN 371 form B | GWB 008 |
| M10 | 100 mm | DIN 376 form B | GWB 010 |
| M12 | 110 mm | DIN 376 form B | GWB 012 |
| M16 | 110 mm | DIN 376 form B | GWB 016 |
| M18 | 125 mm | DIN 376 form B | GWB 018 |
| M20 | 140 mm | DIN 376 form B | GWB 020 |

3-fluted countersink 90°,
3 cutting edges



| Ø | Shank | Order No. |
|------|--|-----------|
| 20.5 | Straight shank | ZSE 205 |
| 40 | Weldon shank 19 mm ($\frac{3}{4}$ ") | ZSE 040 |
| 50 | Weldon shank 19 mm ($\frac{3}{4}$ ") | ZSE 050 |
| 40 | MT 3 | ZSE 340 |
| 50 | MT 3 | ZSE 350 |

Combi tool set and starter kit

COMBINATION TOOL SET

ORDER NO. STANDARD/SIZE

ZGK 001

BDS combi tool set, 8-piece

Clear, sturdy steel box, equipped with twist drills, screw taps and countersinks to manufacture tapped holes from M8 to M16.

| | |
|-----------------------------|------------------------|
| 1 twist drill | DIN 338, Ø 6.8 mm |
| 1 twist drill | DIN 338, Ø 8.5 mm |
| 1 twist drill | DIN 338, Ø 10.2 mm |
| 1 each of machine screw tap | DIN 371, M8 |
| | DIN 376, M10, M12, M16 |
| 1 countersink | DIN 335 |
| | form C 90°, Ø 20.5 mm |



BDS TOOL SET STARTER KIT

ORDER NO.

ZST 400

Contents:

- 1 ZGK 001 combination tool set
- 1 tin of BDS ZHS 400 lubrication spray
- 1 BDS PowerWORKER POW100

PRICE ADVANTAGE!

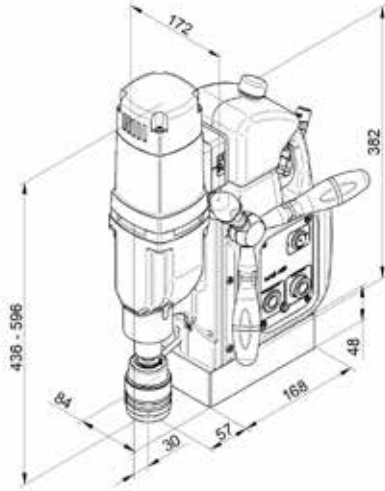


Technical drawings

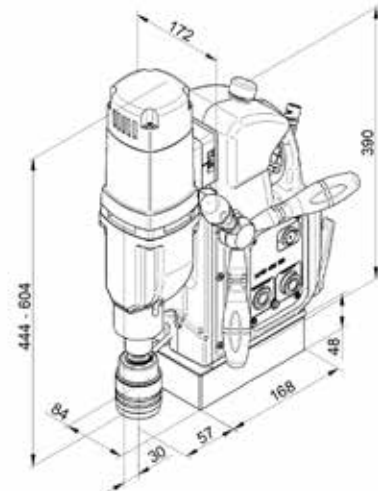
The dimensions of the BDS magnetic core drilling machines.



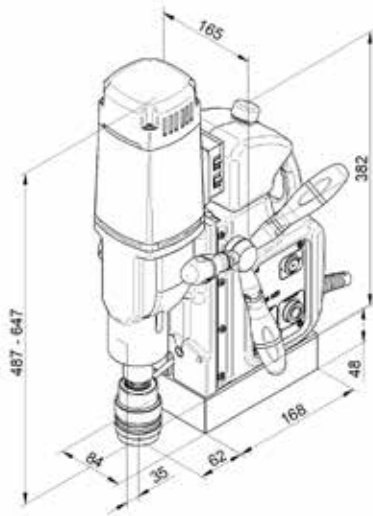
MAB 485



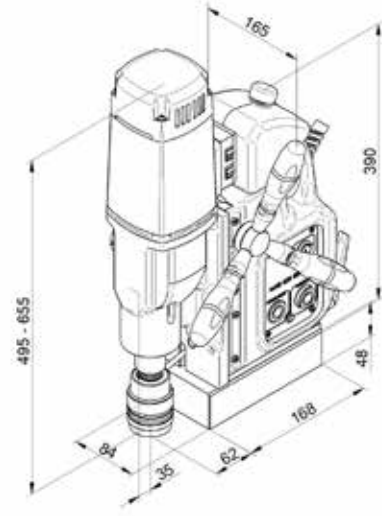
MAB 485 Swivel Base



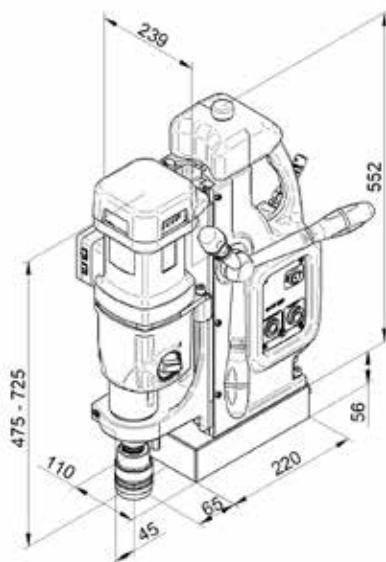
MAB 525



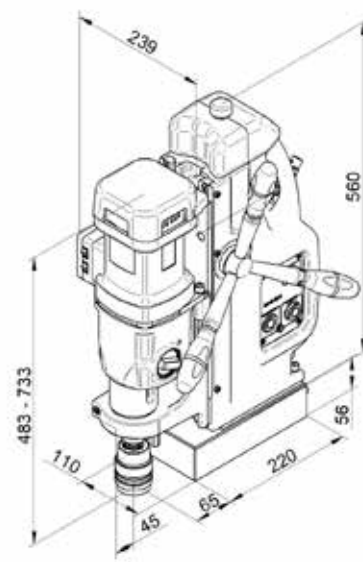
MAB 525 Swivel Base



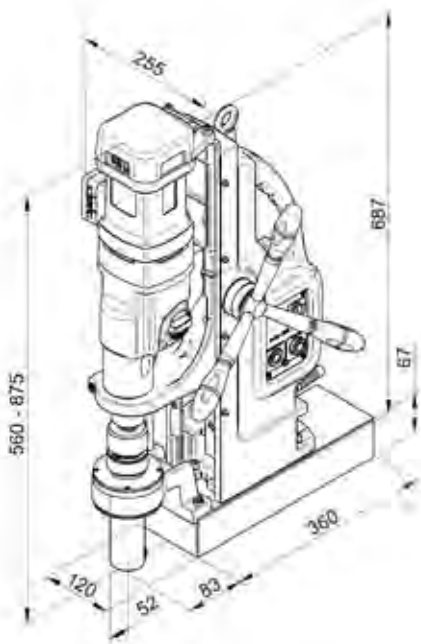
MAB 825



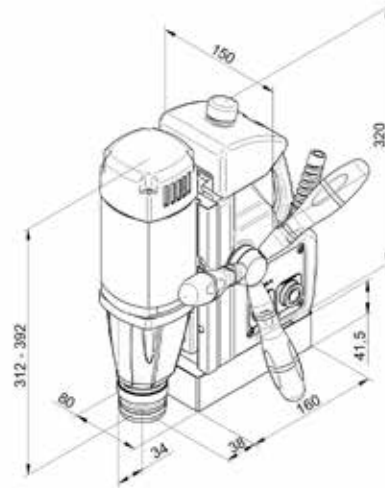
MAB 845 Swivel Base



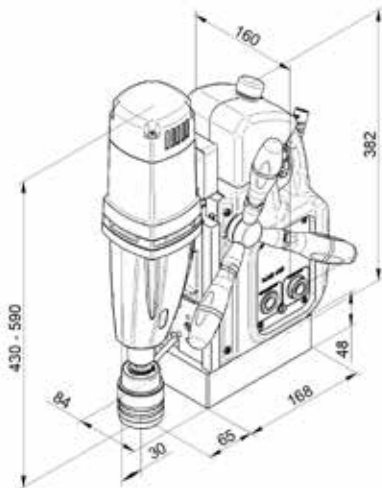
MAB 1300



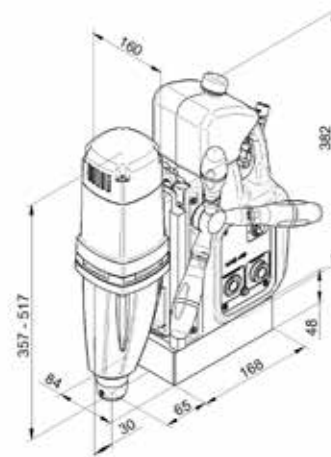
MAB 100K



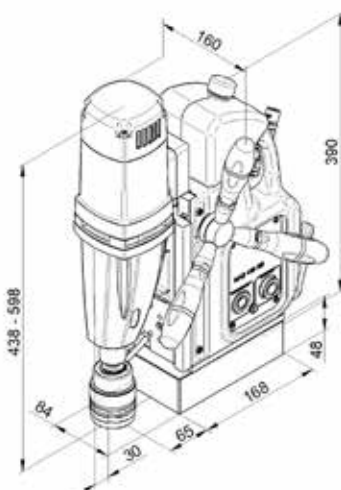
MAB 455



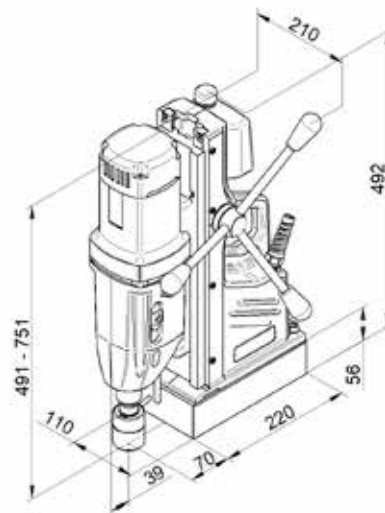
MAB 465



MAB 455 Swivel Base



MABasic 850

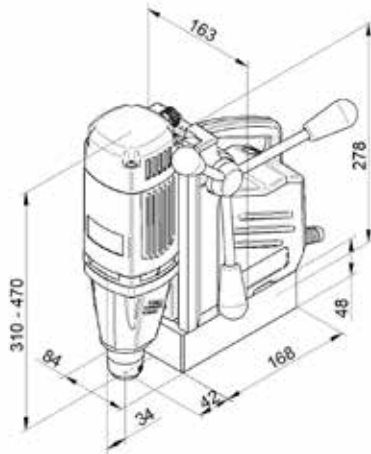


Technical drawings

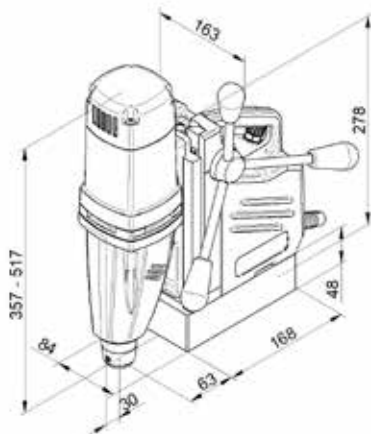
The dimensions of the MAB magnetic core drilling machine.



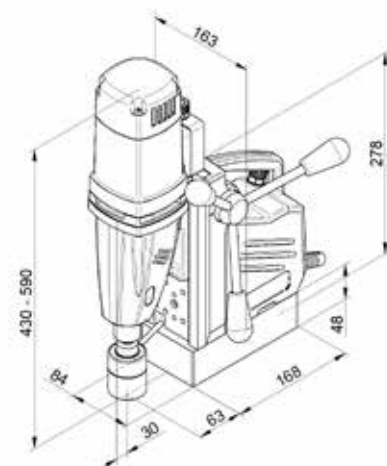
MABasic 200



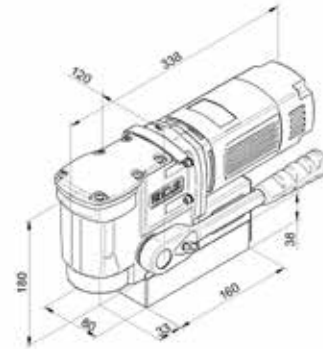
MABasic 400



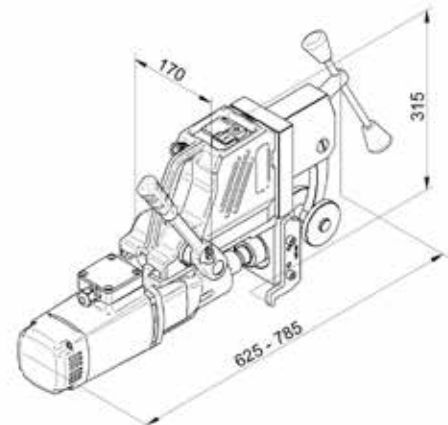
MABasic 450



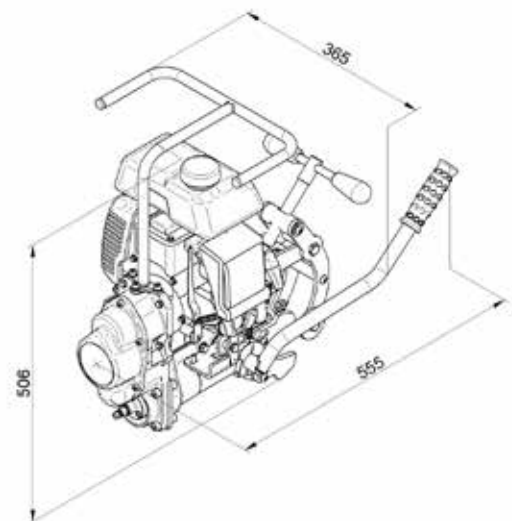
MAB 155



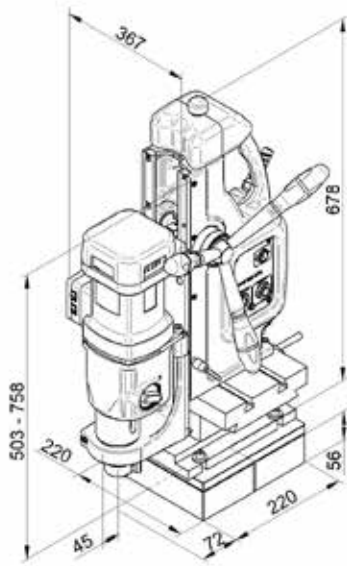
RailMAB 915



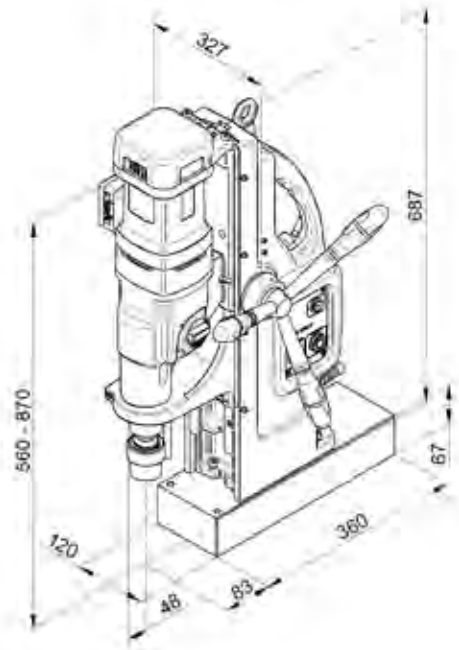
RailMAB 965



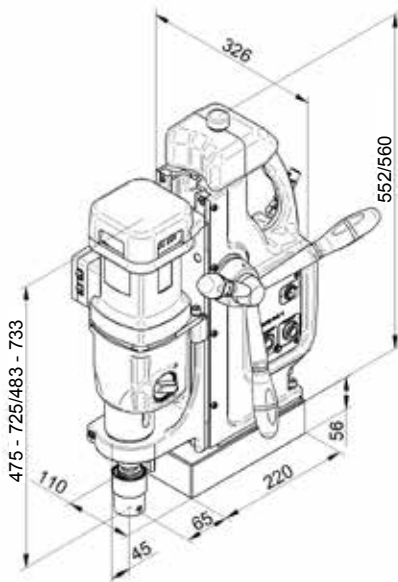
MAB 825 KTS



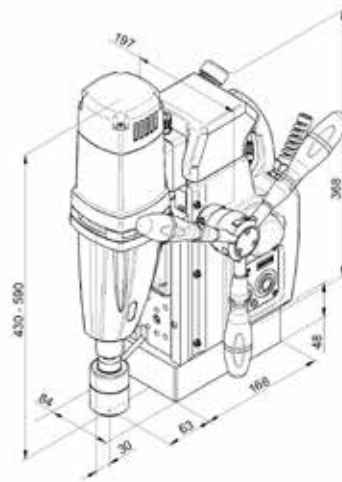
MAB 1300 V



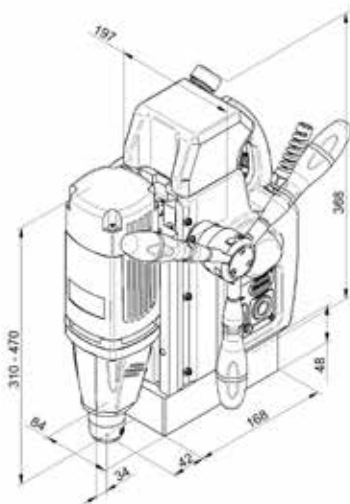
MAB 825 V / 845 V



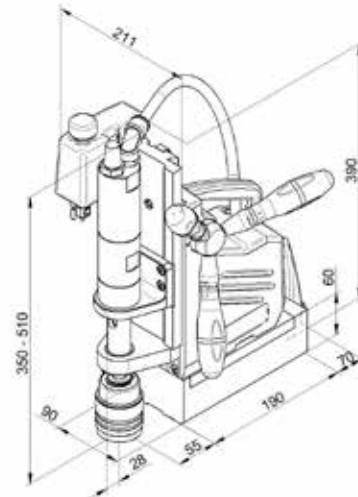
AutoMAB 450



AutoMAB 350



AirMAB 5000



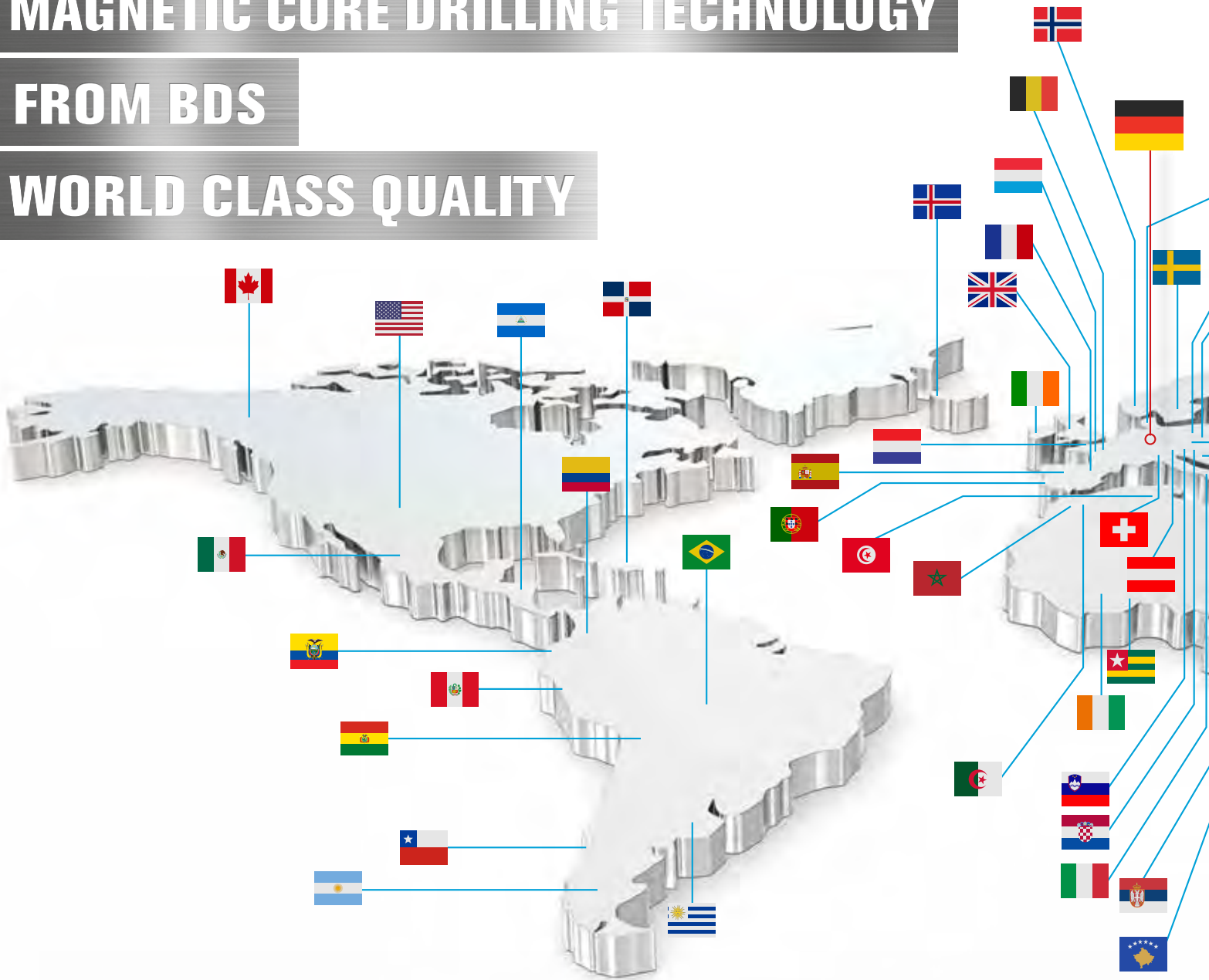
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MAGNETIC CORE DRILLING TECHNOLOGY

FROM BDS

WORLD CLASS QUALITY



BDS company headquarters and manufacturing in Mönchengladbach



CNC-controlled core drill manufacturing

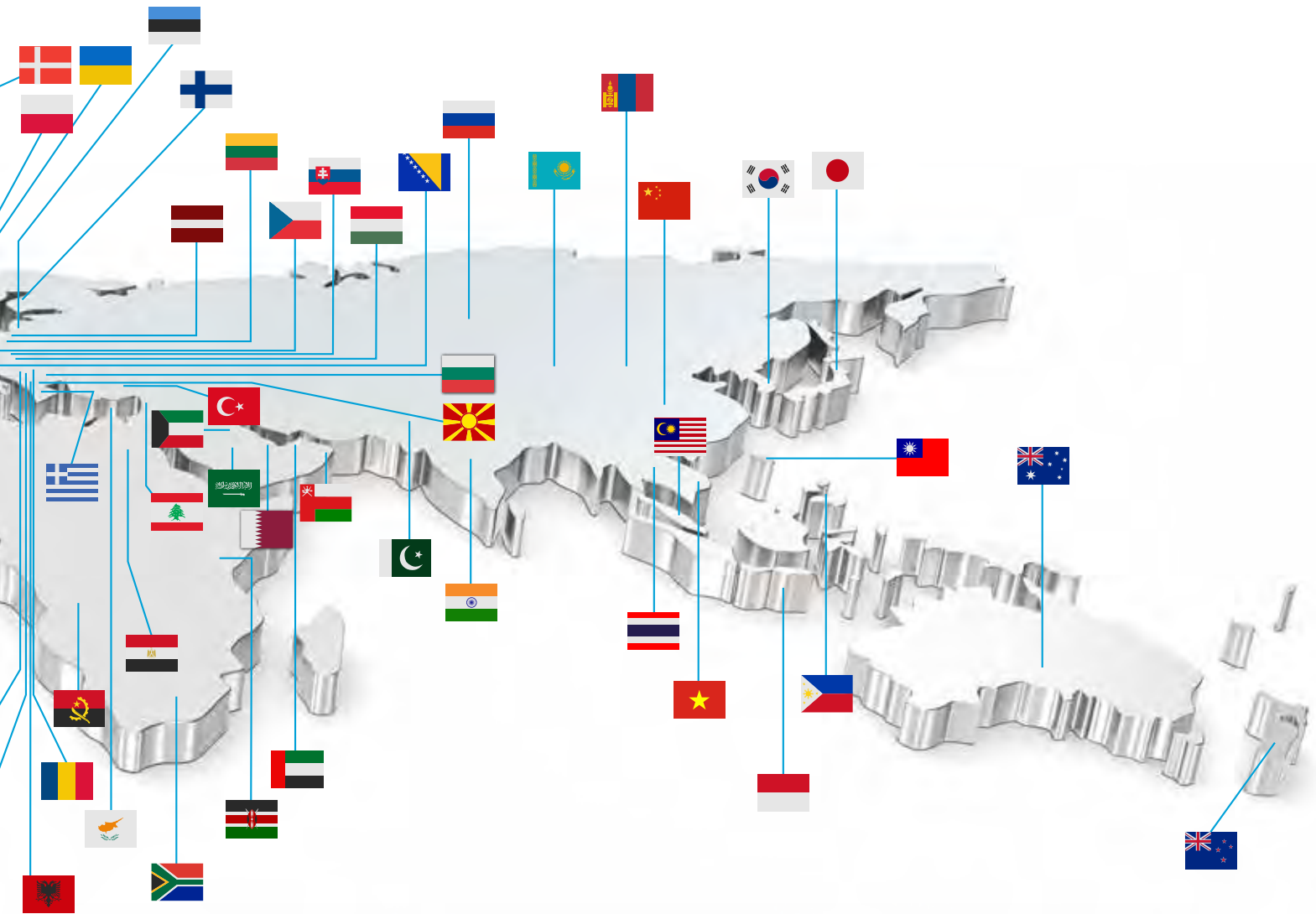
Our claim: Precision from design to manufacturing, best possible material, first-class service.



A good reputation doesn't just happen – it has to be worked at. This is what BDS has done: Since the company was founded in 1989, we have been producing magnetic core drill machines, core drills made from high-quality steel grades, beveling machines for preparing edges and chamfering and deburring machines for the metalworking

industry. And we have done this to such a high standard of quality that there is now worldwide demand for BDS products and they are used across the world.

BDS is the reliable partner to industry, trade and specialist retailers. All over the world.



Sharpening BDS core drills



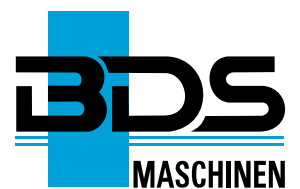
Machine assembly hall in the Mönchnegladbach, Germany plant

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