SIMPLY BETTER DRILLING

The latest programme of BDS Maschinen GmbH.
Magnetic core drilling machines, Annular cutters and Accessories.

Product Overview 2017
BDS magnetic core drilling machines

Four performance categories in the range.

**ProfiPLUS**
Heavy duty magnetic drilling + tapping + countersink + reaming machine. Equipped with oil bath gearbox, full wave control electronics, KEYLESS drill chuck, reversible motor, variable speed & torque controls, intelligent sensors & indicators, etc. With a range of 7 different models to suit your requirements.

**ProfiSTART**
Heavy duty magnetic drilling machine. Equipped with intelligent sensors and indicators. With a range of 4 different models to suit your requirements.

**ProfiBASIC**
High performance - low price. The economic magnetic drilling machines. Now equipped with attached cooling tank and bigger stronger carry case. With a range of 4 different models to suit your requirements.

**ProfiSPEZIAL**
Special purpose drilling machines. Consisting of rail drilling machines, compact magnetic drilling machine, Automatic magnetic drilling machine, Cordless magnetic drilling machine, Pneumatic magnetic drilling machine, etc.

Change drills without tools.

Easy to position.
Magnetic core drilling machines from BDS are convincing because of their performance, their features and their safety.

**Timely wear warning!**

The machines of the Profi-PLUS class are provided with an indicator to visualise & control the wear of the carbon brushes. By replacing the worn carbon brushes in time, you will protect the motor of your machine from damage.

**Covered for more safety!**

BDS Magnetic Core Drilling Machines are safe to handle. Due to internal cabling, cables are protected against being torn-off.

**Easy to adjust with precision!**

The Swivel Base is an adjustment mechanism on the BDS magnetic core drilling machines to position the machine even under the magnetic condition. To use it: Bring the machine roughly into position, activate the magnet, disable the Swivel Base locking mechanism and now adjust the machine exactly. A relief, especially for overhead or horizontal work.

**High power for a low rotation speed!**

Full wave control electronics enable the motor performance to constantly adapt to the load when drilling.

This feature enables the machine to deliver of high power with a low rotation speed and a steady operating sequence.

If the peak load is too high, the electronic torque shutdown will activate and prevent the tool from breaking.

**For a long service life!**

One of the most important and differentiating feature of a BDS magnetic core drilling machine is its gearbox. The BDS machines have multi-stage oil gearbox. An oil gearbox helps in providing lubrication to all the gears uniformly, therefore making the BDS machines more robust and reliable for longer service time.

**Magnet adhesion indicator!**

Thanks to the tool’s automatic internal lubrication, the cutting oil is always applied where it is needed. This principle ensures an exact amount and even distribution over the entire cutting area.

The drill doesn’t run dry or overheat, and there’s no unnecessary use of coolant. This significantly improves tool life and work results.

**No more running dry or overheating.**

The load configuration and the reserves of the electromagnet are exactly adapted for the performance of the respective magnetic core drilling machine. The user is informed by an indicator if the magnet is completely clamped or not on the material. LED green: The magnetic adhesion meets the minimum requirements.

LED red: The magnetic adhesion is not sufficient, because it is reduced due to low material thickness or a coat of lacquer, forge scale or zinc.
BDS Magnetic Core Drilling Machines

Magnetic core drilling machines of the ProfiPLUS series are characterized by the universal range of applications in machinery and plant engineering. As an all-rounder, this series offers the following features:

- Full wave control electronics
- Forward and Reverse operation (CW / CCW)
- Multi-stage gear oil bath gearbox
- Reversible motor
- Torque control
- KEYLESS quick-change drill chuck system, and many more.

All the magnetic core drilling machines of this category have in common a high degree of flexibility when drilling, reaming, countersinking and thread cutting.
MAB 485

Motor output: 1150 Watt
Voltage: 230 V AC, 50-60 Hz
Stroke: 160 mm
Magnet size: 84 x 168 x 41,5 mm
Weight: 13 kg

Quick change drill chuck system: KEYLESS, 19 mm (3/4”)
Morse taper: MT 2
Speed range 1: 50 – 250 min⁻¹
Speed range 2: 100 – 450 min⁻¹
Permanent internal lubrication: ●
Full wave control electronics: ●
Magnet indicator: ●
Overheating protection: ●
CW/CCW rotation: ●
Carbon brush wear control: ●

Core drill: ø 40 mm
L 30 mm
L 55 mm
Twist drilling: ø 18 mm
Countersinking: ø 40 mm
Reaming: ø 18 mm
Thread cutting: M16

MAB 485 230 V
MAB 485 110/125 V

MAB 485 SB

Motor output: 1150 Watt
Voltage: 230 V AC, 50-60 Hz
Stroke: 160 mm
Magnet size: 84 x 168 x 41,5 mm
Weight: 13 kg

Quick change drill chuck system: KEYLESS, 19 mm (3/4”)
Morse taper: MT 2
Speed range 1: 50 – 250 min⁻¹
Speed range 2: 100 – 450 min⁻¹
Permanent internal lubrication: ●
Full wave control electronics: ●
Magnet indicator: ●
Overheating protection: ●
CW/CCW rotation: ●
Carbon brush wear control: ●

Core drill: ø 40 mm
L 30 mm
L 55 mm
Twist drilling: ø 18 mm
Countersinking: ø 40 mm
Reaming: ø 18 mm
Thread cutting: M16

MAB 485 SB 230 V
MAB 485 SB 110/125 V

Clamping devices

Processing channelled and gusset plates.
Use the vacuum clamping device ZAV 300 with a high-performance pump for these materials.

Vacuum clamping device
ZAV 300 – suitable for channelled or gusset plates, non-ferrous metals and stainless steel.

Vacuum clamping device
ZAV 400 – suitable for smooth surfaces, non-ferrous metals and stainless steel.

Tube clamping device
ZRO 250 – for tube ø 80 – 250 mm, for MAB 455, MAB 485, MAB 525, MABasic 450
ZRO 500 – for tube ø 150 bis 500 mm, for MAB 825, MAB 845, MABasic 850

Scope of delivery MAB 485 and MAB 485 SB:
1 Magnetic core drilling machine · 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4”) · 1 Tapping adapter ZAG 010, ZAG 012, ZAG 016 · 1 Ejector ZAK 075/100 · 1 Hard protective case · 1 Safety chain · 1 Drill drift MT 2 · 1 Gear rim drill chuck 13 mm · 1 Taper drift MT 2/186 · 1 Operating manual
**MAB 525**

- **Core drill:** Ø: 50 mm
- **Twist drilling:** Ø: 20 mm
- **Countersinking:** Ø: 50 mm
- **L:** 30 mm
- **L:** 55 mm
- **L:** 75 mm

- **Motor output:** 1600 Watt
- **Voltage:** 230 V AC, 50-60 Hz
- **Stroke:** 160 mm
- **Magnet size:** 90 x 180 x 48 mm
- **Weight:** 16 kg

**Scope of delivery MAB 525 and MAB 525 SB:**
- 1 Magnetic core drilling machine
- 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4”)
- 1 Tapping adapter ZGA 010, ZGA 012, ZGA 016
- 1 Ejector ZAK 075, ZAK 090
- 1 Hard protective case
- 1 Safety chain
- 1 Taper drill MT 3/B16
- 1 Gear rim drill chuck 1 - 13 mm
- 1 Drill drift MT 3
- 1 Operating manual

**MAB 525 SB 230 V**

- **Twist drilling:** Ø: 20 mm
- **Reaming:** Ø: 20 mm
- **Thread cutting:** Ø: M20

**MAB 825**

- **Core drill:** Ø: 100 mm
- **Twist drilling:** Ø: 31.75 mm
- **Countersinking:** Ø: 50 mm
- **Thread cutting:** Ø: M30
- **L:** 30 / 55 mm
- **L:** 60 mm
- **L:** 75 / 110 mm

- **Motor output:** 1800 Watt
- **Voltage:** 230 V AC, 50-60 Hz
- **Stroke:** 255 mm
- **Magnet size:** 110 x 220 x 54 mm
- **Weight:** 25 kg

**Scope of delivery:**
- 1 Magnetic core drilling machine
- 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4”)
- 1 Tapping adapter ZGA 010, ZGA 012, ZGA 016
- 1 Ejector ZAK 075, ZAK 090
- 1 Hard protective case
- 1 Safety chain
- 1 Taper drill MT 3/B16
- 1 Gear rim drill chuck 1 - 13 mm
- 1 Drill drift MT 3
- 1 Operating manual

**MAB 525 SB 230 V**

- **Twist drilling:** Ø: 31.75 mm
- **Reaming:** Ø: 31.75 mm

**MAB 825 230 V**

- **Twist drilling:** Ø: 31.75 mm
- **Reaming:** Ø: 31.75 mm

**MAB 825 110/125 V**

- **Twist drilling:** Ø: 31.75 mm
- **Reaming:** Ø: 31.75 mm
MAGNETIC CORE DRILLING MACHINES

MAB 845 SB

- Core drill: ø: 100 mm
  L: 30 / 55 mm
  ø: 60 mm
  L: 75 / 110 mm
- Twist drilling: ø: 31.75 mm
  Reaming: ø: 31.75 mm
- Countersinking: ø: 50 mm
- Thread cutting: ø: M30
- Direct arbor: 32 mm Weldon (1/4")
- Morse taper: MT 3
- Speed range 1: 40 – 110 min⁻¹
  Speed range 2: 65 – 175 min⁻¹
  Speed range 3: 140 – 360 min⁻¹
  Speed range 4: 220 – 600 min⁻¹
- Friction clutch:
- Permanent internal lubrication:
- Torque control:
- Full wave control electronics:
- Magnet indicator:
- Overheating protection:
- CW/CCW rotation:
- Carbon brush wear control:
- Swivel Base, adjustment feature:
- Motor output: 1800 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 255 mm
- Magnet size: 110 x 220 x 54 mm
- Weight: 25 kg

MAB 1300

- Core drill: ø: 130 / 100 mm
  L: 30 / 55 mm
  ø: 120 mm
  L: 75 / 110 mm
- Twist drilling: ø: 45 mm
  Reaming: ø: 50 mm
- Countersinking: ø: 80 mm
- Thread cutting: ø: M42
- Direct arbor: 32 mm Weldon (11/4")
- Morse taper: MT 4
- Speed range 1: 30 – 80 min⁻¹
  Speed range 2: 50 – 120 min⁻¹
  Speed range 3: 130 – 350 min⁻¹
  Speed range 4: 210 – 550 min⁻¹
- Friction clutch:
- Permanent internal lubrication:
- Torque control:
- Full wave control electronics:
- Magnet indicator:
- Overheating protection:
- CW/CCW rotation:
- Carbon brush wear control:
- Motor output: 2300 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke with/without steady: 85 / 310 mm
- Magnet size: 120 x 360 x 65 mm
- Weight: 51 kg

Magnetic core drilling with large calibres.
Up to 130 mm in diameter and up to 110 mm cutting depth.

Retooling made easy.

Scope of delivery MAB 825, MAB 845 and MAB 845 SB:
1 Magnetic core drilling machine · 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (1/4") · 1 Industrial arbor MT3, 32 mm Weldon (11/4") · 1 Ejector ZAK 075, 090, 100, 120 · 1 Carry case on wheels · 1 Safety chain · 1 Offset screwdriver SW 6 · 1 Drill drift MT 3 · 1 Operating manual

Scope of delivery MAB 1300:
1 Magnetic core drilling machine · 1 Carry case on wheels · 1 Safety chain · 1 Offset screwdriver SW 4, 6, 8 · 1 Ejector ZAK 075, 090, 100, 120 · 1 Drill drift MT 4 · 1 Bushing ZAP 200 from Weldon 32 mm to 19 mm · 1 Operating manual

Core drill:
ø: 100 mm
L: 30 / 55 mm
ø: 60 mm
L: 75 / 110 mm

Twist drilling:
ø: 31.75 mm
Reaming:
ø: 31.75 mm

Countersinking:
ø: 50 mm

Thread cutting:
ø: M30

MAB 845 SB 230 V
MAB 845 SB 230 V

Core drill:
ø: 130 / 100 mm
L: 30 / 55 mm
ø: 120 mm
L: 75 / 110 mm

Twist drilling:
ø: 45 mm
Reaming:
ø: 50 mm

Countersinking:
ø: 80 mm

Thread cutting:
ø: M42

MAB 1300 230 V
MAB 1300 110/125 V

Magnet indicator:

Overheating protection:

CW/CCW rotation:

Carbon brush wear control:

Drilling with a twist drill of up to ø 45 mm.
A flexible choice of tools. Maximum stroke without steady: 310 mm

L 4678 RZ_Export_Broschüre_20_Seiten_EN_Muster niedere Tabelle 18.08.15 14:24 Seite 7
The best entry into a successful technology: The professional user can expect well-engineered, robust machines built for continuous service.

Satisfy yourself as to the BDS quality ‘Made in Germany’.

Heavy duty oil bath gearbox machines equipped with intelligent sensors and indicators.

BDS Magnetic Core Drilling Machines

Core drill:
- ø: 30 mm
- L: 30 mm
- L: 55 mm

Motor output: 1050 Watt
Voltage: 230 V AC, 50-60 Hz
Stroke: 70 mm
Magnet size: 80 x 160 x 41,5 mm
Weight: 9,9 kg

Direct arbor: KEYLESS, 19 mm (3/4"
Speed range 1: 460 min⁻¹
Permanent internal lubrication: •

Scope of delivery MAB 100:
- 1 Magnetic core drilling machine
- 1 Ejector
- 2M OTS +100
- 1 Hard protective case
- 1 Safety chain
- 1 Offset screwdriver
- SW 4
- 1 Operating manual
The best entry into a successful technology: The professional user can expect well-engineered, robust machines built for continuous service. Satisfy yourself as to the BDS quality ‘Made in Germany’.

Heavy duty oil bath gearbox machines equipped with intelligent sensors and indicators.

**MAGNETIC CORE DRILLING MACHINES**

**MAB 455**

- Quick change drill chuck system: KEYLESS, 19 mm (3/4”)
- Motor output: 1150 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 13 kg

**Scope of delivery MAB 455:**
- 1 Magnetic core drilling machine
- 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4”)
- 1 Ejector ZAK 075 + 100
- 1 Hard protective case
- 1 Safety chain
- 1 Drill drift MT 2
- 1 Operating manual

**MAB 455 SB**

- Quick change drill chuck system: KEYLESS, 19 mm (3/4”)
- Motor output: 1150 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 13 kg

**Scope of delivery MAB 455 SB:**
- 1 Magnetic core drilling machine
- 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4”)
- 1 Ejector ZAK 075 + 100
- 1 Hard protective case
- 1 Safety chain
- 1 Drill drift MT 2
- 1 Operating manual

**MAB 455 230 V**

**MAB 455 110/125 V**

**MAB 465**

- Quick change drill chuck system: KEYLESS, 19 mm (3/4”)
- Motor output: 1150 Watt
- Voltage: 230 VAC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 13 kg

**Scope of delivery MAB 465:**
- Machine MAB 465, Hexagonal offset screwdrive, size SW 4, ZAK 075 ejector pin, ZAK 100 ejector pin, Safety chain
- Transport case (not illustrated)
- Operating instructions

**MAB 465 230 V**

**MAB 465 110/125 V**
High performance - low price. With this new machine concept, BDS Maschinen fill a gap for professional users who cannot compromise on the quality or performance of their machines, but who are able to forgo comfort and fittings for the benefit of good prices.

New: Integrated reservoir for cutting oil and lubricant for all machines of the ProfiBASIC series.

**BDS Economic Magnetic Core Drilling Machines**

**MABasic 200**

- Core drill:
  - Ø: 32 mm
  - L: 30 mm
  - L: 55 mm

- Twist drilling:
  - Ø: 13 mm

- Motor output: 900 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 12 kg

- Direct arbor: 19 mm Weldon (3/4")
- Speed range 1: 450 min⁻¹
- Permanent internal lubrication with integrated reservoir:

**Options**

- MABasic 200 230 V
- MABasic 200 110/125 V
MABasic 400

- Motor output: 1050 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 12 kg

Direct arbor: 19 mm Weldon (3/4”)

- Speed range 1: 430 min⁻¹
- Speed range 2: 760 min⁻¹
- Permanent internal lubrication with integrated reservoir:

Core drill: Ø: 35 mm
L: 30 mm
L: 55 mm

Twist drilling: Ø: 16 mm

MABasic 400 230 V
MABasic 400 110/125 V

MABasic 450

- Motor output: 1150 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 160 mm
- Magnet size: 84 x 168 x 41,5 mm
- Weight: 13 kg

Industrial arbor: MT 2, 19 mm Weldon (3/4”)

- Speed range 1: 250 min⁻¹
- Speed range 2: 450 min⁻¹
- Permanent internal lubrication with integrated reservoir:

Core drill: Ø: 40 mm
L: 30 mm
L: 55 mm

Twist drilling: Ø: 18 mm

MABasic 450 230 V
MABasic 450 110/125 V

MABasic 850

- Motor output: 1700 Watt
- Voltage: 230 V AC, 50-60 Hz
- Stroke: 255 mm
- Magnet size: 110 x 220 x 54 mm
- Weight: 24 kg

Industrial arbor: MT 3, 19 mm Weldon (3/4”)

- Speed range 1: 110 min⁻¹
- Speed range 2: 175 min⁻¹
- Speed range 3: 245 min⁻¹
- Speed range 4: 385 min⁻¹
- Permanent internal lubrication with integrated reservoir:

Core drill: Ø: 75 mm
L: 30 mm
L: 55 mm
L: 75 mm
L: 110 mm

Twist drilling: Ø: 31.75 mm

MABasic 850 230 V
MABasic 850 110/125 V

Scope of delivery: 1 Magnetic core drilling machine · 1 Ejector pin ZAK 075 · 1 Plastic carry case · 1 Safety lashing strap · 1 Operating manual. Additional scope of delivery MABasic 200: 1 Hexagon offset screwdriver SW 4. Additional scope of delivery MABasic 450: 1 Hexagon offset screwdriver SW 5 · 1 Industrial arbor ZIA 219 KN · 1 Drill drift MT 2 · Additional scope of delivery MABasic 850: 1 Hexagon offset screwdriver SW 5 and SW 6 · 1 Industrial arbor ZIA 332 KN · 1 Drill drift MT 3
Special magnetic core drilling machines assist with specific tasks:

- Use in very tight drilling situations
- Drill with compressed air
- Drill rail profiles with electricity or gas drive

Do you have specific requirements? BDS also delivers special out-of-series solutions.
MAB 155

Core drill:
- ø: 35 mm
- L: 30 mm

Motor output: 1050 Watt
Voltage: 230 V AC, 50-60 Hz
Stroke: 19 mm Weldon (3/4")
Weight: 11 kg

Speed range 1: 40–110 min-1
Speed range 2: 65–175 min-1

Scope of delivery MAB 155:
1 Magnetic core drilling machine
1 Ejector ZAK 075 + 090 + 100 + 120
1 Carry case
1 Safety chain
1 Operating manual

AutoMAB 350

Core drill:
- ø: 35 mm
- L: 30 mm
- ø: 45 mm
- L: 55 mm

Motor output: 1050 Watt
Voltage: 230 V AC, 50-60 Hz
Stroke: 150 mm
Weight: 15 kg

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

Scope of delivery AutoMAB 350:
1 Magnetic core drilling machine
1 Ejector ZAK 075 + 100
1 Hard protective case
1 Safety chain
1 Operating manual

AutoMAB 450

Core drill:
- ø: 45 mm
- L: 55 mm

Motor output: 1150 Watt
Voltage: 230 V AC, 50 – 60 Hz
Stroke: 150 mm
Weight: 16 kg

Speed range 1: 250 min-1
Speed range 2: 575 min-1

Scope of delivery AutoMAB 450:
AutoMAB 450 core drilling machine,
Screwdriver Size SW5 Weldon MK2/19 mm industrial holder ZIA 219 KN,
Industrial arbor: MT 2, 19 mm Weldon (3/4")
Motor approved according to EX
Permanent internal lubrication: •
Feed Automatic feed & reverse
LED Load indicators: •
Magnet with safety switch off: •

Scope of delivery AutoMAB 450:
AutoMAB 450 110/120 V

Scope of delivery AutoMAB 350:
1 Magnetic core drilling machine
1 Ejector ZK 075 100
1 Magnetic core drilling machine
1 Ejector ZK 075 100
1 Carry case
1 Safety chain
1 Operating manual

Scope of delivery AutoMAB 450:
AutoMAB 450 230 V
AutoMAB 450 110/120 V
### MAB 1300 V

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor output</td>
<td>2300 Watt</td>
</tr>
<tr>
<td>Voltage</td>
<td>230 V AC, 50-60 Hz</td>
</tr>
<tr>
<td>Stroke</td>
<td>310 mm</td>
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<tr>
<td>Magnet size</td>
<td>120 x 360 x 65 mm</td>
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<tr>
<td>Weight</td>
<td>51 kg</td>
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<tr>
<td>Direct arbor</td>
<td>32 mm Weldon (1/4&quot;&quot;)</td>
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<td>Morse taper</td>
<td>MK 4</td>
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<tr>
<td>Speed range 1 (min⁻¹)</td>
<td>30 – 80</td>
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<tr>
<td>Speed range 2 (min⁻¹)</td>
<td>50 – 120</td>
</tr>
<tr>
<td>Speed range 3 (min⁻¹)</td>
<td>130 – 350</td>
</tr>
<tr>
<td>Speed range 4 (min⁻¹)</td>
<td>210 – 550</td>
</tr>
<tr>
<td>Friction clutch</td>
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<tr>
<td>Permanent internal lubrication</td>
<td></td>
</tr>
<tr>
<td>Torque control</td>
<td></td>
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<tr>
<td>Full wave control electronics</td>
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<tr>
<td>Magnet indicator</td>
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</tr>
<tr>
<td>Overheating protection</td>
<td></td>
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<tr>
<td>CW/CCW rotation</td>
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<tr>
<td>Carbon brush wear control</td>
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<tr>
<td>Feed</td>
<td>Automatic Variable Feed</td>
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### MAB 825 KTS

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<tr>
<th>Feature</th>
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<tbody>
<tr>
<td>Motor output</td>
<td>1800 Watt</td>
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<tr>
<td>Voltage</td>
<td>230 V AC, 50-60 Hz</td>
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<td>Stroke</td>
<td>255 mm</td>
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<td>Magnet size</td>
<td>220 x 220 x 54 mm</td>
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<td>Weight</td>
<td>57.5 kg</td>
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<tr>
<td>Industrial arbor</td>
<td>MK 3, 19 mm (1/4&quot;&quot;)</td>
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<tr>
<td>Industrial arbor</td>
<td>MK 3, 32 mm (1/4&quot;&quot;)</td>
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<tr>
<td>Morse taper</td>
<td>MK 3</td>
</tr>
<tr>
<td>Speed range 1 (min⁻¹)</td>
<td>40 – 110</td>
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<td>Speed range 2 (min⁻¹)</td>
<td>65 – 175</td>
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<td>Speed range 3 (min⁻¹)</td>
<td>140 – 360</td>
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<td>Speed range 4 (min⁻¹)</td>
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<td>Full wave control electronics</td>
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<td>CW/CCW rotation</td>
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<td>Friction clutch</td>
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<td>Carbon brush wear control</td>
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<td>Magnet indicator</td>
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<td>Permanent internal lubrication</td>
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### AirMAB 5000

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<th>Specification</th>
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<tr>
<td>Motor output</td>
<td>830 Watt</td>
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<td>Nominal torque</td>
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<td>Air consumption</td>
<td>1.000 l/min</td>
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<td>Stroke</td>
<td>160 mm</td>
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<td>Magnet size</td>
<td>90 x 160 x 60 mm</td>
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<tr>
<td>Weight</td>
<td>17.5 kg</td>
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<td>Quick change drill chuck system</td>
<td>KEYLESS, 19 mm (3/8&quot;)</td>
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<tr>
<td>Morse taper</td>
<td>MK 2</td>
</tr>
<tr>
<td>Speed range 1 (min⁻¹)</td>
<td>290 min⁻¹ max 575 min⁻¹</td>
</tr>
<tr>
<td>Permanent internal lubrication</td>
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</tr>
</tbody>
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**MAB 1300 V 230 V**

**MAB 1300 V 110/125 V**

**MAB 825 KTS 230 V**

**MAB 825 KTS 110/125 V**

**Collet chuck**

**ZSF 316, MK 3, 2 – 16 mm**

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**AirMAB 5000**

**Scope of delivery**

**MAB 1300 V**

- Magnetic core drilling machine - 1 Ejector ZAK 075 + 090 + 100 + 120 - 1 Carry case - 1 Safety chain - 1 Drill chuck MK 3 - 1 Quick change drill chuck system MK 3 19 mm Weldon (1/4") - 1 Industrial arbor MK 3 32 mm Weldon (1/4") - 1 Torsion screwdriver SW 6 + SW 8 - 1 Operating manual

**Scope of delivery**

**MAB 825 KTS**

- Magnetic core drilling machine - 1 Ejector ZAK 075 + 090 + 100 + 120 - 1 Carry case - 1 Safety chain - 1 Drill chuck MK 3 - 1 Quick change drill chuck system MK 3 19 mm Weldon (1/4") - 1 Industrial arbor MK 3 32 mm Weldon (1/4") - 1 Torsion screwdriver SW 5 + SW 6 - 1 Operating manual

**Scope of delivery**

**AirMAB 5000**

- Magnetic core drilling machine - 1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/8") - 1 Ejector ZAK 075 + 100 - 1 Hard protective case - 1 Safety chain - 1 Drill chuck MK 2 - 1 Operating manual
BDS rail core drilling machines

**RailMAB 925**

- **Motor output:** 1,5 KW
- **Motor:** Honda GXH 50
- **Cubic capacity:** 49,4 ccm
- **Torque:** 3,04 Nm
- **Stroke:** 40 mm
- **Weight:** 21,5 kg

**Core drill: Carbide RAIL**
- ø: 36 mm
- L: 30 mm
- L: 55 mm

---

**RailMAB 925 with electric motor and**

**RailMAB 960 with HONDA petrol engine** –

Both systems are easily fixed to the rails with a rapid clamping system. The multitude of optionally available drill adapters greatly increases the flexibility and the ease of use of the two core drilling machines. The track construction machine range is topped off with the BDS special drills of the carbide RAIL series, which have a cutting depth of 30 mm and a diameter of 16 mm to 36 mm. The drill on both machines is lubricated and cooled through an external attachable high-pressure storage tank. Use the cooling lubricant concentrate BDS 6000 to cool and lubricate the machine.

---

**Scope of delivery RailMAB 925:**
- 1 Rail core drilling machine
- 1 High-pressure tank, 5 litres
- 1 Reversing ratchet
- 1 Rail adapter of your choice (no special version)
- 1 Offset screwdriver SW 4 + 5 + 6
- 1 Ejector ZAK 075
- 1 Carry case

**Scope of delivery RailMAB 960:**
- 1 Rail core drilling machine
- 1 High-pressure tank, 5 litres
- 1 Rail adapter of your choice (no special version)
- 1 Offset screwdriver SW 4 + 5 + 6
- 1 Ejector ZAK 075
- 1 Carry case

---

**RailMAB 965**

- **Motor output:** 1600 Watt
- **Voltage:** 230 V AC, 50-60 Hz
- **Stroke:** 160 mm
- **Weight:** 17 kg

**Quick change drill chuck system: KEYLESS, 19 mm (3/4”)**
- **Morse taper:** MT 3
- **Speed range 1:** 70 – 280 min⁻¹
- **Speed range 2:** 180 – 580 min⁻¹
- **Permanent internal lubrication:** ●
- **Cooling:** With drilling emulsion
- **Torque control:** ●
- **Full wave control electronics:** ●
- **Overheating protection:** ●
- **Carbon brush wear control:** ●

**Core drill: Carbide RAIL**
- ø: 36 mm
- L: 30 mm

---

**Scope of delivery RailMAB 965:**
- 1 Rail core drilling machine
- 1 High-pressure tank, 5 litres
- 1 Rail adapter of your choice (no special version)
- 1 Offset screwdriver SW 6 · 1 Ejector ZAK 075+100 · 1 Drill drill MT 3 · 1 Carry case · 1 Operating manual
## Compare for yourselves

<table>
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<tr>
<th></th>
<th>MAB 485</th>
<th>MAB 525</th>
<th>MAB 825</th>
<th>MAB 845</th>
<th>MAB 1300</th>
<th>MAB 100 K</th>
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<th>MAB 825 KTS</th>
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**MAGNETIC CORE DRILLING MACHINES**

NEW
MAB Magnetic core drilling machines.

Technical drawings
Original BDS accessories makes work easier.
BDS PowerWORKER, PowerCLEANER and the StarterKITS.

PowerCLEANER

ORDER NO.
POW 200

PowerCLEANER – An ideal two in one tool for removing the metal chips from the core drills with the special hook and then cleaning the chips from workplace with the special brush.

The PowerCLEANER and PowerWORKER StarterKITS:
High-quality necessary equipment at an attractive price!

Start with the right basic equipment for each magnetic core drilling machine. In one package at a very favourable price.

► 5 core drills, short, of the most common diameters: 14, 18 and 22 mm.
► 1 liter of High-performance cutting oil BDS 5000
► and one BDS PowerWORKER or one BDS PowerCLEANER.

BDS StarterKIT PowerCLEANER

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 liter of High-performance cutting oil BDS 5000
1 BDS PowerCLEANER
Original BDS accessories for magnetic core drilling machines

The practical, universally usable BDS PowerWORKER and PowerCLEANER tools are indispensable in the workshop. Keep an eye out for the KITS at special prices!

**BDS StarterKIT PowerWORKER**

**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 liter of High-performance cutting oil BDS 5000
1 BDS PowerWORKER

The BDS PowerWORKER cleans up all magnetic drilling chips. With the help of this practical tool and its powerful magnetic force, chips are collected with ease and then placed quickly and easily in the scrap container. Magnetise, collect together, strip off and finished.

**PowerWORKER**

**ORDER NO.**
POW 100

Magnetise, collect together...

Demagnetise and finished!
Quick-change drill chuck and inserts for threads from M 6 to M 42

Magnetic core drilling machines of the ProfiPLUS class are ideally suited for thread cutting. Basic requirements are: CW/CCW operation, full wave control electronics and high motor performance.

Quick-change drill chuck size MK 2, MK 3 and MK 4

The large stroke range of the BDS magnetic core drilling machines, in conjunction with the quick-change chuck, facilitates fast and efficient working without having to repeat the aligning and centring when changing the tool. The quick-change drill chuck can be universally used for the quick-change inserts with and without safety friction clutch.
Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS class.

Option 1:
Quick-change inserts with safety friction clutch

Threads from M 6 to M 42 – BDS inserts with safety friction clutch allow for precise threading of through-hole threads and blind-hole threads.

The safety friction clutch prevents tap fracture by contacting the bottom of the borehole.

Option 2:
Standard quick-change inserts

Threads from M 6 to M 30 – BDS inserts are suited for taking up of taps for through-hole threads.
Which Machine? Which thread?
Assignment of machines of the ProfiPLUS class and the possible thread diameter to the size of the basic quick-change drill chucks and inserts.

GSW Quick-change drill chucks:
In the versions MK 2, MK 3, MK 4. For taking up quick-change inserts GSE or GSS.
- GSW 222 Size 2 MK 2
- GSW 331 Size 1 MK 3
- GSW 332 Size 2 MK 3
- GSW 333 Size 3 MK 3
- GSW 442 Size 2 MK 4
- GSW 443 Size 3 MK 4
- GSW 444 Size 4 MK 4

GSS
GSS Quick-change insert
with safety friction clutch
Size 2, 3, 4

GSE
Standard quick-change insert
Size 1, 2, 3

Tap adapters – getting started economically
By means of the adapter, the taps are taken up directly into the 19 mm or 32 mm Weldon system. Suitable for through-hole threads only!

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<th>SHANK Ø</th>
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<td>M12 DIN 376</td>
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<td>ZGA 014</td>
<td>M14 DIN 376</td>
<td>11</td>
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<td>M16 DIN 376</td>
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<td>ZGA 018</td>
<td>M18 DIN 376</td>
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<td>ZGA 020</td>
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<td>ZGA 022</td>
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<tr>
<td>ZGA 030</td>
<td>M30 DIN 376</td>
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<td>18</td>
</tr>
</tbody>
</table>

up to ZGA 020 with 19 mm Weldon shank (¾")
from ZGA 022 with 32 mm Weldon shank (1 ¼")
### Quick-change drill chucks GSW

<table>
<thead>
<tr>
<th>GSW 222</th>
<th>Size</th>
<th>2</th>
<th>MK 2</th>
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</thead>
<tbody>
<tr>
<td>M5/M6</td>
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<td>205</td>
<td>6 / 4.9</td>
</tr>
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<td>206</td>
<td>4.5 / 3.4</td>
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</tr>
<tr>
<td>M10</td>
<td>GSE</td>
<td>210-DIN 371</td>
<td>10 / 8</td>
</tr>
<tr>
<td>M10</td>
<td>GSS</td>
<td>210</td>
<td>7 / 5.5</td>
</tr>
<tr>
<td>M12</td>
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<td>212</td>
<td>9 / 7.0</td>
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*not suitable for MAB 525|

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<td>8 / 6.2</td>
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<td>10 / 8.0</td>
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</tr>
<tr>
<td>M16</td>
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<tr>
<td>M18</td>
<td>GSE</td>
<td>218</td>
<td>14 / 11</td>
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<tr>
<td>M20</td>
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<table>
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<tbody>
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<table>
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### Quick-change inserts

#### Standard GSE

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</tr>
<tr>
<td>M6</td>
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<td>8 / 6.2</td>
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<tr>
<td>M10</td>
<td>10 / 8</td>
</tr>
<tr>
<td>M12</td>
<td>9 / 7.0</td>
</tr>
<tr>
<td>M14</td>
<td>11 / 9</td>
</tr>
<tr>
<td>M16</td>
<td>12 / 9</td>
</tr>
<tr>
<td>M18</td>
<td>14 / 11</td>
</tr>
<tr>
<td>M20</td>
<td>16 / 12</td>
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</table>

#### With safety friction clutch GSS

<table>
<thead>
<tr>
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<tbody>
<tr>
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<td>6 / 4.9</td>
</tr>
<tr>
<td>M6</td>
<td>4.5 / 3.4</td>
</tr>
<tr>
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<td>8 / 6.2</td>
</tr>
<tr>
<td>M10</td>
<td>7 / 5.5</td>
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<td>9 / 7.0</td>
</tr>
<tr>
<td>M14</td>
<td>11 / 9.0</td>
</tr>
<tr>
<td>M16</td>
<td>12 / 9.0</td>
</tr>
<tr>
<td>M18</td>
<td>14 / 11</td>
</tr>
<tr>
<td>M20</td>
<td>16 / 12</td>
</tr>
<tr>
<td>M22</td>
<td>18 / 14.5</td>
</tr>
<tr>
<td>M24</td>
<td>18 / 14.5</td>
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</tbody>
</table>

---

### Thread cutting systems

**Tap adapters – getting started economically**

- By means of the adapter, the taps are taken up directly into the 19 mm or 32 mm Weldon system.
- Suitable for through-hole threads only!

### Overview

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>TAP ADAPTER WITH WELDON SHANK</th>
</tr>
</thead>
<tbody>
<tr>
<td>GSW 222</td>
<td>Quick-change drill chuck</td>
</tr>
<tr>
<td>GSW 331</td>
<td>Quick-change drill chuck</td>
</tr>
<tr>
<td>GSW 332</td>
<td>Quick-change drill chuck</td>
</tr>
<tr>
<td>GSW 333</td>
<td>Quick-change drill chuck</td>
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<td>GSW 442</td>
<td>Quick-change drill chuck</td>
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<td>GSW 443</td>
<td>Quick-change drill chuck</td>
</tr>
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<td>GSW 444</td>
<td>Quick-change drill chuck</td>
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</table>

### Thread shank Ø square

<table>
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<th>Order No.</th>
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<tbody>
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<td>5.5</td>
<td>ZGA 010 M10 DIN 376 7 5.5</td>
</tr>
<tr>
<td>7</td>
<td>ZGA 012 M12 DIN 376 9 7</td>
</tr>
<tr>
<td>9</td>
<td>ZGA 014 M14 DIN 376 11 9</td>
</tr>
<tr>
<td>9.5</td>
<td>ZGA 016 M16 DIN 376 12 9.5</td>
</tr>
<tr>
<td>11.5</td>
<td>ZGA 018 M18 DIN 376 1</td>
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<td>14.5</td>
<td>ZGA 020 M20 DIN 376 16 12</td>
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<tr>
<td>16.5</td>
<td>ZGA 022 M22 DIN 376 18 14.5</td>
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<td>19.0</td>
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<td>20.0</td>
<td>ZGA 027 M27 DIN 376 20 16</td>
</tr>
<tr>
<td>22.0</td>
<td>ZGA 030 M30 DIN 376 22 18</td>
</tr>
</tbody>
</table>

- up to ZGA 020 with 19 mm Weldon shank (3/4")
- from ZGA 022 with 32 mm Weldon shank (1 1/4")
Carry cases and adapters

Carry cases for magnetic core drilling machines and EKF edge processing machines. Adapters for drill chuck and gear rim drill chuck.

Carry cases for magnetic core drilling machines

The new carry cases developed by BDS for magnetic core drilling machines have many benefits.

- Portable – low weight with high level of stability at the same time.
- Closed firmly – secure and large mechanical locks.
- Sealed – the contents are protected completely against dust and spray water.
- Roll along instead of carry – ABS wheels and telescopic grip.

BDS Maschinen develops products from the ergonomic points of view.

The new carry case provided with wheels for magnetic core drilling machines of the MAB 1300 series has large, robust ABS wheels and a telescopic grip, which facilitate transporting the heavy machine to a large extent and make it safe.

The MAB 1300 is fitted safely and securely in robust plastic bowls that absorb the heavy weight of the machine ideally.

CARRY CASE

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>SUITABLE FOR</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZPK 001</td>
<td>EKF 300, EKF 450, EKF 452</td>
</tr>
</tbody>
</table>

Application: Carry case for EKF 300, EKF 450 and EKF 452.
Design: Plastic case with handle and foam padding, no contents.

HARD PROTECTIVE CASE

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>SUITABLE FOR</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZHK 100</td>
<td>MAB 100, MAB 150</td>
</tr>
<tr>
<td>ZHK 400</td>
<td>MAB 455, MAB 485, MAB 525</td>
</tr>
</tbody>
</table>

Application: Carry case for BDS magnetic core drilling machines. Design: Robust hard cover case with handle and stable clasps. With foam padding, no contents.

CARRY CASE ON WHEELS

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>SUITABLE FOR</th>
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</thead>
<tbody>
<tr>
<td>ZHK 1300</td>
<td>MAB 1300</td>
</tr>
</tbody>
</table>

Application: Carry case on wheels for BDS magnetic core drilling machines. Design: Robust carry case on wheels with handle and stable clasps. No contents.

CARRY CASE

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>SUITABLE FOR</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZPK 001</td>
<td>EKF 300, EKF 450, EKF 452</td>
</tr>
</tbody>
</table>

Application: Carry case for EKF 300, EKF 450 and EKF 452.
Design: Plastic case with handle and foam padding, no contents.

CARRY CASE ON WHEELS

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>SUITABLE FOR</th>
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</thead>
<tbody>
<tr>
<td>ZHK 825</td>
<td>MAB 825, MAB 845</td>
</tr>
</tbody>
</table>

Application: Carry case on wheels for BDS magnetic core drilling machines. Design: Robust carry case on wheels with handle and stable clasps. No contents.

BDS hard cover cases and carry cases on wheels are robust, watertight and shockproof.
Carry cases and adapters

Carry cases for magnetic core drilling machines and EKF edge processing machines.

Adapters for drill chuck and gear rim drill chuck.

The new carry cases developed by BDS for magnetic core drilling machines have many benefits.

- Portable – low weight with high level of stability at the same time.
- Closed firmly – secure and large mechanical locks.
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The new carry case provided with wheels for magnetic core drilling machines of the MAB 1300 series has large, robust ABS wheels and a telescopic grip, which facilitate transporting the heavy machine to a large extent and make it safe.

The MAB 1300 is fitted safely and securely in robust plastic bowls that absorb the heavy weight of the machine ideally.

BDS hard cover cases and carry cases on wheels are robust, watertight and shockproof.

### ADAPTER FOR DRILL CHUCKS

| ORDER NO. | ZAP 100 | Weldon shank 19 mm (3/4”) to 1/2” x 20 NF |

### GEAR RIM DRILL CHUCK

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>INTERNAL THREAD</th>
<th>CLAMP SIZE</th>
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<tbody>
<tr>
<td>ZBI 113</td>
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<td>1 - 13 mm</td>
</tr>
<tr>
<td>ZBI 116</td>
<td>1/2” x 20 NF</td>
<td>2.5 - 16 mm</td>
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### QUICK-ACTION DRILL CHUCK

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>INTERNAL THREAD</th>
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<tbody>
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<td>1/2” x 20 NF</td>
<td>1 - 13 mm</td>
</tr>
<tr>
<td>ZSI 116</td>
<td>1/2” x 20 NF</td>
<td>3 - 16 mm</td>
</tr>
</tbody>
</table>

For magnetic core drilling machines with direct arbor 19 mm Weldon (3/4”)

- ProfiSTART MAB 100
- ProfiBASIC MABasic 200
- ProfiBASIC MABasic 400
- ProfiSPEZIAL AutoMAB 1500
- AkkuMAB 3000

### TAPER DRIFT FOR DRILL CHUCK

| ORDER NO. | ZKD 216 | DIN 238 - MK 2/B16 |
| ZKD 316   | DIN 238 - MK 3/B16 |

### GEAR RIM DRILL CHUCK

<table>
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</tr>
<tr>
<td>ZBK 116</td>
<td>DIN 238-B16</td>
<td>2.5 - 16 mm</td>
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### QUICK-ACTION DRILL CHUCK

<table>
<thead>
<tr>
<th>ORD. NO.</th>
<th>INTERNAL THREAD</th>
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</tr>
<tr>
<td>ZSB 116</td>
<td>DIN 238-B16</td>
<td>3 - 16 mm</td>
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</table>

For magnetic core drilling machines with Morse taper MK 2 or MK 3.

- ProfiPLUS MAB 485 / 485SB
- MAB 485
- MAB 525 / 525 SB
- MAB 825 / 845 SB
- MAB 1300
- ProfiSTART MAB 455 / 455SB
- MAB 855
- ProfiBASIC MABasic 450
- ProfiSPEZIAL AirMAB 5000

### KEY FOR GEAR RIM DRILL CHUCK

| ORDER NO. | ZEZ 113 |
| ZEZ 116   |

### DRILL DRIFT DIN 228

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<td>DIN 228</td>
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### CHIP PROTECTION

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<td>ZSS 500</td>
<td>MAB 825 – MAB 855</td>
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### SAFETY CHAIN

| ORDER NO. | ZSK 001 |

### PUMP BOTTLE

| ORDER NO. | ZKP 100 |

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

Application:

- Carry case for BDS magnetic core drilling machines.
- Design: Robust hard cover case with handle and stable clasps. With foam padding, no contents.

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

ZHK 1300 MAB 1300

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

Application:

- Carry case for BDS magnetic core drilling machines.
- Design: Robust hard cover case with handle and stable clasps. With foam padding, no contents.

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

ZHK 825 MAB 825, MAB 845

Application:

- Carry case on wheels for BDS magnetic core drilling machines.
- Design: Robust carry case on wheels with handle and stable clasps. No contents.

Application:

- Carry case for BDS magnetic core drilling machines.
- Design: Robust hard cover case with handle and stable clasps. With foam padding, no contents.
Tool holders and Adapters

For BDS core drills with Weldon shank – suitable for third-party systems with adaption. Tool holders for BDS core drills with Weldon holder. There are now a total of three systems to choose from, which enable a stable, comfortable and safe connection between the core drill and the magnetic core drilling machine.

**Tool holder for BDS core drills with 19 mm (3/4") Weldon shank**

**Tool holder for BDS core drills with 19 mm (3/4") and 32 mm (1 1/4") Weldon shank**

**Tool holder for BDS core drills with 19 mm (3/4") and 32 mm (1 1/4") Weldon shank**

**QUICK CHANGE DRILL CHUCK SYSTEM KEYLESS**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>SPINDLE HOLDER</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZSS 200</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZSS 300</td>
<td>MK 3</td>
</tr>
</tbody>
</table>

With automatic internal lubrication for core drills with 19 mm (3/4") Weldon shank. With hose and quick acting coupling. Quick tool change without a chuck key.

**INDUSTRIAL ARBOR WITH MANUAL INTERNAL LUBRICATION**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>SPINDLE HOLDER</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZIA 219-M</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZIA 319-M</td>
<td>MK 3</td>
</tr>
<tr>
<td>ZIA 419-M</td>
<td>MK 4</td>
</tr>
</tbody>
</table>

For BDS core drills with 19 mm (3/4") Weldon shank

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>SPINDLE HOLDER</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZIA 332-M</td>
<td>MK 3</td>
</tr>
<tr>
<td>ZIA 432-M</td>
<td>MK 4</td>
</tr>
</tbody>
</table>

For BDS core drills with 32 mm (1 1/4") Weldon shank

**INDUSTRIAL ARBOR WITH AUTOMATIC INTERNAL LUBRICATION**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>SPINDLE HOLDER</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZIA 219-KN</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZIA 319-KN</td>
<td>MK 3</td>
</tr>
<tr>
<td>ZIA 419-KN</td>
<td>MK 4</td>
</tr>
</tbody>
</table>

For BDS core drills with 19 mm (3/4") Weldon shank

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>SPINDLE HOLDER</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZIA 332-KN</td>
<td>MK 3</td>
</tr>
<tr>
<td>ZIA 432-KN</td>
<td>MK 4</td>
</tr>
</tbody>
</table>

For BDS core drills with 32 mm (1 1/4") Weldon shank

With hose and quick acting coupling.

**REDUCING BUSH DIN 2185**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>OUTSIDE</th>
<th>INSIDE</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZRH 210</td>
<td>MK 2</td>
<td>MK 1</td>
</tr>
<tr>
<td>ZRH 320</td>
<td>MK 3</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZRH 430</td>
<td>MK 4</td>
<td>MK 3</td>
</tr>
</tbody>
</table>

**EXTENSION BUSH DIN 2178**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>OUTSIDE</th>
<th>INSIDE</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZVH 220</td>
<td>MK 2</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZVH 320</td>
<td>MK 3</td>
<td>MK 2</td>
</tr>
<tr>
<td>ZVH 330</td>
<td>MK 3</td>
<td>MK 3</td>
</tr>
</tbody>
</table>
Adapters with Weldon shank

Adapters for BDS core drills. With the appropriate adapters, BDS core drills with Weldon shanks are compatible with all standard machines and tool holder systems on the market.

<table>
<thead>
<tr>
<th>ADAPTER</th>
<th>ORDER NO.</th>
<th>ADAPTER ORDER NO.</th>
<th>ADAPTER ORDER NO.</th>
<th>EXTENSION ORDER NO.</th>
<th>ADAPTER ORDER NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZAP 200</td>
<td>32 mm (1 (\frac{1}{4})&quot;&quot;)</td>
<td>ZAF 002</td>
<td>For Fein core drills with internal thread M18 x 6 P1.5 incl. 1 ejector pin</td>
<td>ZAK 115</td>
<td>ZAF 004</td>
</tr>
<tr>
<td>From 32 mm Weldon shank (1 (\frac{1}{4})&quot;) to 19 mm Weldon shank ((\frac{3}{4})&quot;&quot;)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>With Quick-in holder for core drills with 19 mm ((\frac{3}{4})&quot;&quot;) Weldon shank each incl. 1 ejector pin</td>
</tr>
<tr>
<td>ZAP 300</td>
<td>19 mm ((\frac{3}{4})&quot;&quot;)</td>
<td>ZAF 003</td>
<td>For Fein core drills with QUICK-IN-shank incl. 1 ejector pin</td>
<td>ZAK 080</td>
<td>ZAF 005</td>
</tr>
<tr>
<td>80 mm, 19 mm Weldon shank ((\frac{3}{4})&quot;&quot;) incl. 1 ejector pin</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>With Nitto one-touch holder for core drills with 19 mm ((\frac{3}{4})&quot;&quot;) Weldon shank each incl. 1 ejector pin</td>
</tr>
<tr>
<td>ZAK 080</td>
<td>19 mm ((\frac{3}{4})&quot;&quot;)</td>
<td></td>
<td></td>
<td>ZAK 107 und 125</td>
<td>ZAK 107 und 125</td>
</tr>
</tbody>
</table>
Clamping devices for tubes from 80 mm to 500 mm diameter

The BDS clamping devices are suitable for tubes with a diameter from 80 to 250 mm and 150 to 500 mm. Flexible and quick clamping is possible in any drilling situation. The clamping device with swivelling V-blocks is fixed on the tube by means of tension chains. The drilling position on the tube can be adjusted easily and safely. The range of application of the magnetic core drilling machines of the ProfiPLUS series is significantly increased by these devices.

<table>
<thead>
<tr>
<th>TUBE CLAMPING DEVICE</th>
</tr>
</thead>
<tbody>
<tr>
<td>ORDER NO.</td>
</tr>
<tr>
<td>ZRO 250</td>
</tr>
<tr>
<td>ZRO 500</td>
</tr>
</tbody>
</table>

**ZRO 250**: for MAB 455, 485, 525
For tube ø: 80 – 250 mm
Chain length: 900 mm

**ZRO 500**: for MAB 825, 845, 855
For tube ø: 150 – 500 mm
Chain length: 1,650 mm
Clamping devices

For magnetic core drilling machines of the ProfiPLUS and ProfiSTART class. For tube processing and drilling of non-ferrous metals and stainless steel.

Vacuum clamping device for non-ferrous metals

Magnetic core drilling machines from the ProfiPLUS class can in their entirety also be used for the processing of non-ferrous metals and stainless steel. For that purpose, BDS offers clamping devices, which are provided with a pump with circular oil lubrication to build up a vacuum to ensure a safe connection between the magnetic core drilling machine and the workpiece.

Furthermore, BDS offers customized devices, which exactly meet your requirements and instructions. Just contact us!

VACUUM PLATE FOR SMOOTH SURFACES

ORDER NO.

ZAV 400

Application: For smooth surfaces.

Design: High-performance vacuum pump with circular oil lubrication. Clamping plate with two suction areas and internal drilling area.

Size: 440 x 250 mm, long hole: 50 x 120 mm

VACUUM PLATE FOR CHANNELLED AND GUSSET PLATES

ORDER NO.

ZAV 300

Application: Suitable for channelled and gusset plates.

Design: High-performance vacuum pump with circular oil lubrication. Clamping plate ø 300 mm.
Pillars and clamping devices

MobilCLAMP for BDS magnetic core drilling machines

Using the portable clamping mechanism, MobilCLAMP, you can supplement the application options of a magnetic core drilling machine onsite and in the workshop. The magnetic core drilling machine is placed on the desired surface for this purpose and switched on. Components can be clamped securely in the quick-action clamping vice and you have a flexible table-top drilling machine in no time.

Optionally available: stable frame for MobilCLAMP clamping device.

Magnetic pillars for hand drills

Using this practical magnetic drilling stand, you can convert your manual drilling machine into a magnetic drilling machine. The magnetic drilling stand is suitable for commercially available manual drilling machines with 43 mm collar diameter.

Thus, the powerful magnet facilitates working horizontally and doing overhead work safely. (For these applications, a safety chain must be used additionally.) The carriage has a working stroke of 180 mm.

Industrial pillar for twist drilling machines

Industrial drilling stand for commercially available manual drilling machines with 43 mm collar diameter.
Safe, secure and stable by a cast base plate and carriage with a working stroke of 180 mm.

Optionally with a drilling machine vice, 100 mm jaw width. Screws for T-grooves are also available for securing.

MobilCLAMP for BDS magnetic core drilling machines

Using the portable clamping mechanism, MobilCLAMP, you can supplement the application options of a magnetic core drilling machine onsite and in the workshop. The magnetic core drilling machine is placed on the desired surface for this purpose and switched on. Components can be clamped securely in the quick-action clamping vice and you have a flexible table-top drilling machine in no time.
Optionally available: stable frame for MobilCLAMP clamping device.
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Industrial drilling stand for commercially available manual drilling machines with a collar diameter of 43 mm. Safe, secure and stable by a cast base plate and carriage with a working stroke of 180 mm. Optionally with a drilling machine vice, 100 mm jaw width. Screws for T-grooves are also available for securing.

MobilCLAMP – mobile working with magnetic core drilling machines

Magnetic pillar Industrial pillar

Pillars and clamping devices

Magnetic pillars for your own twist drilling machine, MobilCLAMP and drill stands. Build your own magnetic drilling machine! BDS provides new options for the subject of clamping mechanisms for working with commercially available manual drilling machines and for magnetic core drilling machines.

<table>
<thead>
<tr>
<th>MAGNETIC PILLARS</th>
<th>ORDER NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>MBS 300</td>
<td></td>
</tr>
</tbody>
</table>

For commercially available hand drills with a collar diameter of 43 mm, stroke 160 mm.

<table>
<thead>
<tr>
<th>INDUSTRIAL PILLAR</th>
<th>ORDER NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZBS 100</td>
<td></td>
</tr>
</tbody>
</table>

For commercially available hand drills with a collar diameter of 43 mm, stroke 180 mm. Vice and screws are not included in the delivery.

<table>
<thead>
<tr>
<th>PRISM VICE</th>
<th>ORDER NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZST 300</td>
<td>Prism vice</td>
</tr>
<tr>
<td>ZTN 100</td>
<td>Screw for T slots</td>
</tr>
<tr>
<td>ZSM 100</td>
<td>Hexagon nut</td>
</tr>
</tbody>
</table>

Jaw width: 100 mm, clamping range: 100 mm

<table>
<thead>
<tr>
<th>CLAMPING DEVICE MobilCLAMP</th>
<th>ORDER NO.</th>
<th>JAW WIDTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZMC 180</td>
<td>100 cm, 80 mm clamping width</td>
<td></td>
</tr>
<tr>
<td>ZMC 300</td>
<td>Base frame for clamping device</td>
<td></td>
</tr>
</tbody>
</table>

Mechanical clamping device for magnetic core drilling machines.

<table>
<thead>
<tr>
<th>MAGNETIC CLAMPING DEVICE MagnetCLAMP</th>
<th>ORDER NO.</th>
<th>CLAMPING RANGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZMS 500/230V</td>
<td>100 – 800 mm</td>
<td></td>
</tr>
<tr>
<td>ZMS 500/120V</td>
<td>100 – 800 mm</td>
<td></td>
</tr>
</tbody>
</table>

Magnetic clamping device, the versatile mounting aid.
High-performance cutting oil **BDS 5000**
Recomended for High Speed Steel Core Drills. Pure vegetable oil that is not a hazardous good in the context of import-export regulations. The base materials used are not described in the catalogue of water endangering substances. BDS 5000 do not have to be specifically labelled.

► Organic basis material with additives
► Water hazard class 1
► Bio-degradable, optimal base adjustment of the viscosity for the use of BDS core drills, and easy use for subsequent galvanising

Cooling lubricant **BDS 6000**
Recomended for Carbide (TCT) Core Drills. For high demands based on synthetic raw materials.

► Soluble with water, biostable and mild smelling
► Improves the core drill service life
► Toxicologically harmless, water hazard class 1

---

**CUTTING OIL**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>NAME</th>
<th>CONTENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZHS 005</td>
<td>BDS 5000 cutting oil</td>
<td>5 Liter Can</td>
</tr>
<tr>
<td>ZHS 006</td>
<td>BDS 5000 cutting oil</td>
<td>1 Liter Can</td>
</tr>
</tbody>
</table>

**COOLING LUBRICANT**

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>NAME</th>
<th>CONTENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZHB 001</td>
<td>BDS 6000 Cooling lubricant</td>
<td>1 Liter Can</td>
</tr>
</tbody>
</table>
Cutting oil, lubrication spray, lubrication paste and cooling lubricant

High-performance, which can be applied effectively and is environmentally friendly.

The best working result - for the nature!!

High-performance lubricants and cleaning spray by BDS are aligned perfectly to the respective application. The highly efficient composition allows economical and environmentally friendly use.

Particularly recommended in outdoor application: BDS high-performance cutting oil or high-performance soluble cooling lubricant. These products are bio-degradable without leaving any residues and toxicologically harmless. However, at the same time, they are highly effective in the desired lubricating and cooling performance. In addition, the BDS 6000 soluble can be mixed with water in the ratio 1:10 and is thus, high-yield.

High-performance lubrication spray BDS 5200

Suitable for working under special conditions (overhead and vertical surface) and also for high-alloy materials.

Foam-like spray with very high adhesive force.

Advantages: Exact dosage of the lubrication spray and thus, optimal lubrication directly on the drill cutters. No drop formation and spraying around, and thus, maximum occupational safety on ladders and work platforms.

► White adhesive lubricant containing PTFE with corrosion protection
► Free from PCB, PCT, FCKW and chlorine
► Active ingredient: Lithium base grease on mineral basis with additives and solvent
► Propellant: Propane/Butane, to be specified

Caution: Do not use liquid lubricants when working overhead or on vertical surfaces. In such a case, oil might get into the motor causing short-circuit. Please, use BDS High-performance lubrication spray BDS 5200.

High-performance Cutting paste BDS 5500

Optimally suitable for material types that are difficult to machine such as high-alloy steels, Hardox, stainless and heat-resistant steels. Suitable for use overhead and for work in constrained spaces. Ideal for tapping or thread cutting tools.

CUTTING PASTE

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>NAME</th>
<th>CONTENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZHS 550</td>
<td>BDS 5500 Cutting paste</td>
<td>1000 g Can</td>
</tr>
</tbody>
</table>

LUBRICATION SPRAY

<table>
<thead>
<tr>
<th>ORDER NO.</th>
<th>NAME</th>
<th>CONTENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZHS 400</td>
<td>BDS 5200 lubrication spray</td>
<td>1 x 400 ml Can</td>
</tr>
<tr>
<td>ZHS 406</td>
<td>BDS 5200 lubrication spray</td>
<td>6 x 400 ml Can</td>
</tr>
<tr>
<td>ZHS 412</td>
<td>BDS 5200 lubrication spray</td>
<td>12 x 400 ml Can</td>
</tr>
</tbody>
</table>

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

Step 2: During drilling, spray the high-performance lubrication spray onto the tip of the drill and into the cut hole.
Fully Ground High Speed Steel (HSS) Core Drills

<table>
<thead>
<tr>
<th>HSS-Co 8 Series</th>
<th>HSS-VarioPLUS Series</th>
<th>HSS-Standard Series</th>
</tr>
</thead>
<tbody>
<tr>
<td>► High thermal resistance</td>
<td>► High-strength fully ground core drills</td>
<td>► Tools with three different cutting depths:</td>
</tr>
<tr>
<td>► Better wear protection</td>
<td>► Hard coating in the range of 2.5 μ</td>
<td>30 mm, 55 mm and 110 mm</td>
</tr>
<tr>
<td>► High proportion of cobalt at 8 %</td>
<td>► Longer life</td>
<td>► Core drill diameters from 12 mm to 130 mm</td>
</tr>
<tr>
<td>► Suitable for higher levels of stress in fine-grained steel and stainless material</td>
<td>► More uniform removal of chips, particularly with long drills – an important aspect for occupational safety</td>
<td>► Regrindable</td>
</tr>
<tr>
<td>► With 19 mm or 32 mm Weldon shank</td>
<td>► High thermal resistance</td>
<td></td>
</tr>
<tr>
<td>► Regrindable</td>
<td>► Better wear protection</td>
<td>► Core drill diameters from 12 mm to 130 mm</td>
</tr>
</tbody>
</table>

| | HSS-Co 8 Series | HSS-VarioPLUS Series | HSS-Standard Series |
| | KBK-CO | KBL-CO | KBK-VP | KBL-VP | KBK | KBL | KEL | KBK-Z |
| Cutting depth: | 30 mm | 55 mm | 30 mm | 55 mm | 30 mm | 55 mm | 110 mm | 30 mm |
| Drill diameter: | 12 – 130 mm | 12 – 100 mm | 12 – 60 mm | 12 – 60 mm | 12 – 60 mm | 12 – 60 mm | 20 – 50 mm | 1/2” – 2 1/16” |
Professional Quality Tungsten Carbide Tip (TCT) Core Drills

BDS core drills are manufactured on state of the art CNC-controlled grinding centres. This guarantees consistent grinding, quality and cutting performance for all BDS drilling tools in the entire product spectrum.

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

Tool holders
BDS core drilling tools are available with various tool holders. They fit in the KEYLESS quick change drill chuck system as well as in the industrial arbors MK 2, MK 3 and MK 4 with automatic or manual internal lubrication, which are available in our range of accessories.

Carbide Series and Carbide-PLUS Series (TCT)
► Carbide-tipped (TCT) core drills
► Cutting depths of 30 mm, 55 mm, 75 mm and 110 mm
► Diameters from 12 mm to 150 mm
► Carbide PLUS with additional wear resistant carbide coating of up to 2.5 μ

Carbide Series
Carbide-tipped (TCT) core drills. For the processing of stainless steel and non-ferrous metals, we recommend using the high-performance water soluble cooling lubricant BDS 6000.

Carbide-PLUS Series
Carbide-tipped (TCT) core drills with carbide coating.

Carbide-RAIL Series
Carbide-tipped (TCT) core drills for rail core drilling machines.

Quick-In Series
HSS-Co 8-F/Carbide
Core drills made of HSS tool steel or carbide tipped. Suitable for Quick-in tool holder systems.
Our call centre is at your disposal.

You can contact our call centre in Mönchengladbach from Mondays to Thursdays between 8 am and 5 pm and Fridays from 8 am to 4 pm German time. +49 (0)2161-3546-0

BDS contact details.

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Fax: +43(0)5238 /52977
E-mail: bds-maschinen@aon.at

Call up demo videos.

You can always find new and interesting videos of our machines on our website. They make application possibilities clearer and connections more obvious. See for yourself what is possible with BDS magnetic core drilling technology and edge processing machines.
The BDS network – always available

See our performance for yourself.

Customers and users can always contact BDS Maschinen: with personalised advice from competent experts, a fast parts replacement service and detailed product information on magnetic core drilling technology and edge processing. Take us at our word.

Personalised advice

BDS experts in our sales department are available all over Germany to present our products and demonstrate them on-site. Questions about magnetic core drilling technology or edge processing? For personalised expert advice, contact our centre in Mönchengladbach. You will be put through to the relevant administrator or we will call you back. We look forward to your call! Telephone: +49 (0)2161-3546 -0

Newsletter

You can automatically receive constant information from BDS Maschinen on new products and interesting reports and practical solutions by registering on our homepage.

Express-Service

We can express deliver your order upon request. Talk directly to our administrators. Telephone: +49 (0)2161-3546 -0

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WE HAVE THE ANSWERS!

Contact us in person, on the web or via the app, from wherever you want.