



SIMPLY BETTER DRILLING

Magnetic Core Drilling Machines, Tools, Accessories and Service.
Core Drills / Annular Cutters / Broach Cutters.
Edge Processing Machines, Tools, Accessories and Service.

EN 2014





Headline: BDS Core drilling production Made in Germany

BDS Maschinen has been developing and producing magnetic core drilling machines and associated core drilling products at its premises in Mönchengladbach for over 25 years. A willingness to invest in the latest technology has led to a significant increase in our production capacity. We continue to meet the high quality requirements that our clients place on our products worldwide by using chained production plants and the latest CNC-controlled grinding centre's, developed especially for BDS.

"We focus our main attention on the most important functional requirements of a product and develop simple and practical solutions for the benefit of our customers."

Simply better drilling – in line with this motto, we would like to present a new economical magnetic core drilling machine range as well as our recently developed cordless magnetic core drilling machine. Let us surprise you!



NEW – ProfiBASIC series: With this new machine concept, BDS Maschinen is looking to fill a gap for professional users who cannot compromise on the quality or performance of their magnetic core drilling machines, but who are able to forgo comfort and fittings for the benefit of good savings on price. **See page 28 and following for more details.**

NEW – AkkuMAB 3000: Cordless core drilling. This machine offers all the benefits of BDS professional magnetic core drilling technology. The cordless AkkuMAB 3000 offers the greatest possible freedom from an electrical supply thanks to our new high-performance industrial battery. **Read more about it on page 34.**

NEW – Swivel Base Models: a good idea comes to life!

The swivel base allows the core drill to be positioned with absolute accuracy when used with activated magnets. This is a useful relief for the user, particularly when working overhead or horizontally. BDS now has four machines to offer with a swivel base. An overview of all our machines and a comparison of their characteristics can be found on **pages 10 and 11.**

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Far ahead in the professional league

The four BDS magnetic core drilling machine performance categories.

BDS Maschinen brings structure to the fore. 20 different magnetic core drilling machines for very varied tasks, different requirements and the individual demands of the user. All of the same BDS quality Made in Germany.



The magnetic core drilling machines of the ProfiPLUS category are primarily intended for users in plant and mechanical engineering. These machines can be used during assembly or in the workshop and during production. All the magnetic core drilling machines of this category have in common a high degree of flexibility for drilling, reaming, countersinking and thread cutting. The MAB 1300 model in this category is currently the strongest magnetic core drilling machine on the market. **More on page 12.**



The best introduction to magnetic core drilling technology by BDS Maschinen. Professional users, especially from the steel, plant construction and locksmith industries, prefer to work with BDS machines from this category. They are robust, well-engineered magnetic core drilling machines, adapted for a variety of uses, whether during assembly or in the workshop. There is an extensive range of accessories available for machines in the ProfiSTART category. **More on page 22.**

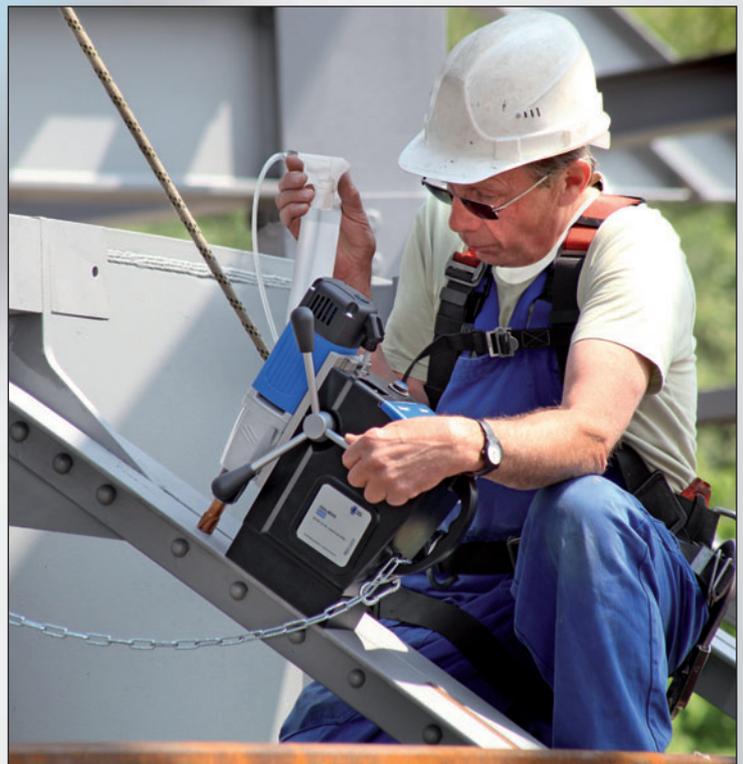


ProfiBASIC

High performance - low price. The ProfiBASIC performance category follows a new machine concept with three graded magnetic core drilling machines. They 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. **More on page 28.**

ProfiSPEZIAL

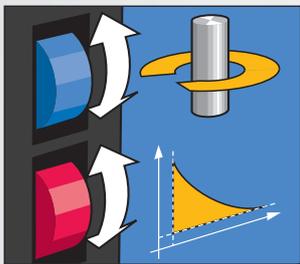
Special tasks require special magnetic core drilling machines. As a pioneering developer, BDS has sought solutions for the tasks of the customers time and again. BDS has always sought the best solution for the special tasks of the customers to save their time and effort. BDS offers many machines under the profiSPEZIAL category like, machines to work under constrained working condition, pneumatic driven machine, automatic feed machine, cordless machine, railway track drilling machine, etc. **More on page 32.**



Convincing solutions for engineers

BDS magnetic core drilling machines are characterised by a variety of innovative technical details and special features.

High power for a low rotation speed!



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

This machine presents the advantages 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. BDS Maschinen actively participates in work safety.



No more running dry or overheating.

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 cooling agent. This significantly improves tool life and work results.



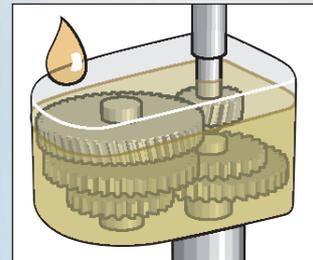
Change drills without tools.



Easy to position.

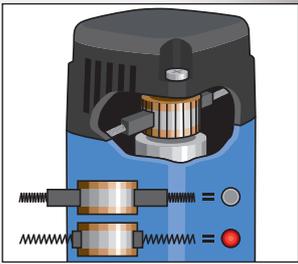


To a long service life!

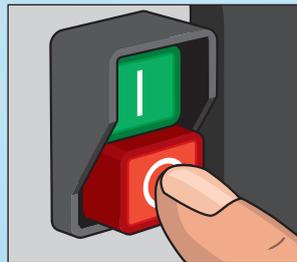


One of the most important and differentiating features of a BDS magnetic core drilling machine is its gearbox. The BDS machines have multi-stage oil gearbox. An oil gearbox helps in providing lubrication to all the gears uniformly, therefore making the BDS machines more robust and reliable for longer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

Timely wear warning!



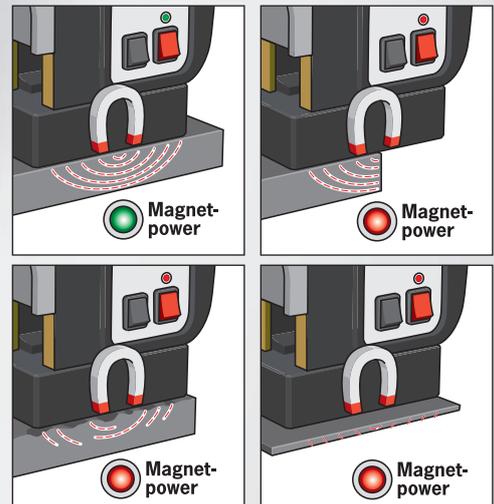
The machines of the Profi-PLUS class are provided with an indicator to visualise & control the wear of the carbon brushes. By replacing the worn carbon brushes in time, you will protect the motor of your machine from damage.



Impossible to activate accidentally!

The large switches for motor and magnet power are properly separated and are safe to handle, i.e., confusion is impossible and accidents are prevented. Thanks to the special design of the switches, therefore preventing the unintended actuation of the motor switch.

Work in the green area!



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 device on BDS magnetic core drilling machines. 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.

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.

Possibilities to enthuse all practitioners!

BDS magnetic core drilling machines offer the user even more flexible and varied fields of application.



Core drilling from \varnothing 12 mm to \varnothing 150 mm.

BDS Maschinen produces a wide range of tools with different drill series. More on pages 46 to 49.



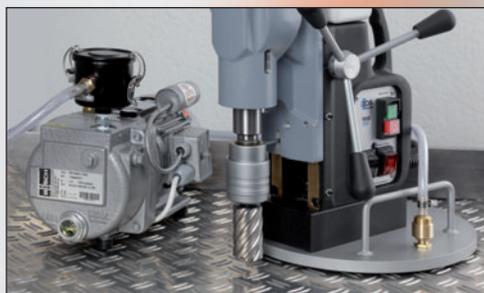
Magnetic core drilling with large calibres.

Up to 130 mm in diameter and up to 110 mm cutting depth - a comparison of all BDS machines can be found on pages 10-11 and 46-49, along with the complete BDS core drilling range.



Drilling with a twist drill of up to \varnothing 42 mm.

A flexible choice of tools. Almost all BDS magnetic core drilling machines also work with twist drills. Try it upside down! See the performance comparison on pages 10-11.



Processing channelled and gusset plates.

Use the vacuum clamping device ZAV 300 with a high-performance pump for these materials. Product information can be found on page 77.



Processing nonferrous metals.

The ZAV 400 vacuum clamping device with high-performance pump and the magnetic core drilling machines of the ProfiPLUS category are best suited for these tasks. See page 77.



Rail drilling with BDS core drilling machines.

One of the specialists in the BDS machines range. The RailMAB is specially used for track and signal construction. The following products are adapted for this use: BDS core drills of the carbide RAIL series and the environmentally friendly biodegradable BDS 5000. See pages 38, 62, 80.



The correct adapter for every profile.

Retooling made easy. Various profile adapters are available for our rail core drilling machines. Please contact us for more information.

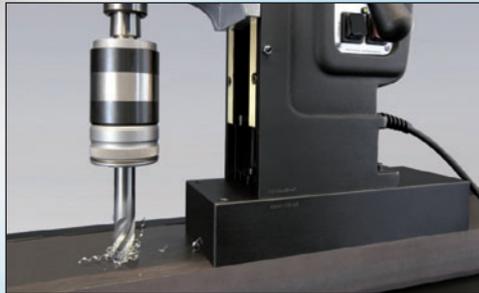


Processing pipes up to \varnothing 500 mm.

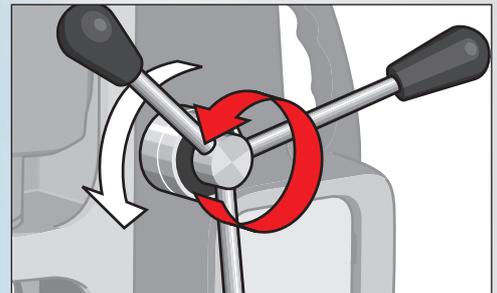
Expanding application possibilities for magnetic core drilling machines thanks to clamping devices for pipes from \varnothing 80 to 500 mm. These appliances can be fixed easily and safely with tension chains. See page 76.



Countersinking from \varnothing 80 mm – reaming to \varnothing 50 mm. BDS magnetic core drilling machines with MT tool holder are adapted for the universal use of reamers and countersinks. An overview can be found on pages 10 and 11.



Thread cutting from M5 to M39/42. Quick-change drill chuck and inserts, also with safety friction clutch for magnetic core drilling machines with CW/CCW. Pages 70 - 71.



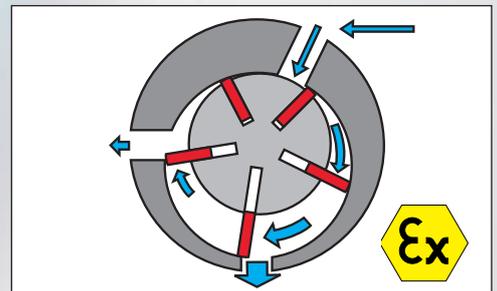
MAB 1300 – drilling with servo-assistance. PowerASSIST is a power-assisted feed when drilling - a particularly welcome aid for core drilling with large diameters.



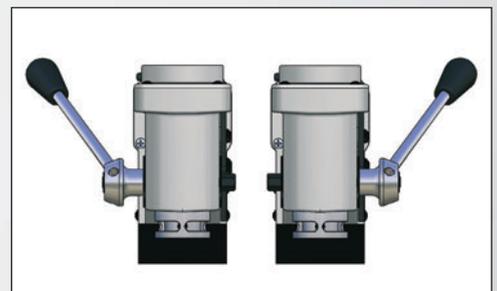
Tight drilling situations – no exceptions. Tight spatial conditions, impossible for the parts to disassemble. Here, the MAB 150 shows the true greatness of the ProfiSPEZIAL category. More on page 33.



Core drilling with battery power. Drilling with the power of our industry lithium ion batteries 6.0 Ah. The cordless AkkuMAB 3000 works independently from the mains network. See page 34.



AirMAB 5000 – magnetic core drilling with pneumatic drive. The high performance vane motor performs at 830 Watt and is approved according to Ex class - Ex II 2G T4 IIC D110° C. See page 37.



Moving the feed handles. The feed cross-joint on all BDS magnetic core drilling machines can be changed from left to right use in just a few movements. According to the circumstances.

Compare for yourselves

All the technical details of the BDS magnetic core drilling machines at a glance.



	Page	MAB 485 13	MAB 485 Swivel Base 14-15	MAB 525 16	MAB 525 Swivel Base 17	MAB 825 18	MAB 845 Swivel Base 19	MAB 1300 20-21	MAB 100 23	MAB 455 Swivel Base 24-25
Motor output	Watt	1,150	1,150	1,600	1,600	1,800	1,800	2,300	1,050	1,150
Voltage 230 V AC, 50 – 60 Hz		✓	✓	✓	✓	✓	✓	✓	✓	✓
Voltage 110/125 V, 50 – 60 Hz		✓	✓	✓	✓	✓	✓	upon request	✓	✓
Voltage 36 V · 6 Ah										
Petrol engine Honda GXH 50	kW									
Air consumption	l/min									
Stroke	mm	160	160	160	160	255	255	310 85	70	160
Swivel Base – adjustment feature			✓		✓		✓			✓
Magnet size	L x W x H mm	84 x 168 x 41.5	84 x 168 x 41.5	90 x 180 x 48	90 x 180 x 48	110 x 220 x 54	110 x 220 x 54	120 x 360 x 67	80 x 60 x 41.5	84 x 168 x 41.5
Weight	kg	13	13	16	16	25	25	51	9.9	13
Direct arbor 19 mm Weldon 3/4"								✓	✓	
Industrial arbor 19 mm Weldon 3/4"										
Industrial arbor 32mm Weldon 1 1/4"						✓	✓			
KEYLESS*) 19 mm Weldon 3/4"		✓	✓	✓	✓	✓	✓			✓
Morse taper MT 2		✓	✓							✓
Morse taper MT 3				✓	✓	✓	✓			
Morse taper MT 4								✓		
Speed range 1	min ⁻¹	50 – 250	50 – 250	70 – 280	70 – 280	40 – 110	40 – 110	30 – 80	460	250
Speed range 2	min ⁻¹	100 – 450	100 – 450	180 – 580	180 – 580	65 – 175	65 – 175	50 – 120		450
Speed range 3	min ⁻¹					40 – 360	140 – 360	130 – 350		
Speed range 4	min ⁻¹					220 – 600	220 – 600	210 – 550		
Permanent internal lubrication		✓	✓	✓	✓	✓	✓	✓	✓	✓
Friction clutch						✓	✓	✓		
Torque control				✓	✓	✓	✓	✓		
Full wave control electronics		✓	✓	✓	✓	✓	✓	✓		
Magnet indicator		✓	✓	✓	✓	✓	✓	✓		✓
Overheating protection		✓	✓	✓	✓	✓	✓	✓		
CW/CCW rotation		✓	✓	✓	✓	✓	✓	✓		
Core drill short 30 mm	ø mm	12 – 40	12 – 40	12 – 50	12 – 50	12 – 100	12 – 100	12 – 130	12 – 30	12 – 40
Core drill short 30 mm HKK-R	ø mm									
Core drill long 55 mm	ø mm	12 – 40	12 – 40	12 – 50	12 – 50	12 – 100	12 – 100	12 – 120		12 – 40
Core drill overlong 75 mm	ø mm			18 – 50	18 – 50	18 – 60	18 – 60	18 – 120		
Core drill extra-long 110 mm	ø mm					20 – 60	20 – 60	20 – 120		
Twist drilling	≤ ø mm	18	18	20	20	31.75	31.75	45		18
Reaming	≤ ø mm	18	18	20	20	31.75	31.75	50		
Countersinking	≤ ø mm	40	40	50	50	50	50	80		
Thread cutting	≤ M	16	16	20	20	30	30	42		

 Prof**BASIC**

 Prof**SPEZIAL**

MAB 455	MAB 855	MABasic 200	MABasic 400	MABasic 450	MAB 150	AutoMAB 1500 36	AkkuMAB 3000 34-35	AirMAB 5000 37	RailMAB 925	RailMAB 960
26	27	29	30	31	33				40	41
1,150	1,700	900	1,050	1,150	1,080	1,080		830	1,600	
✓	✓	✓	✓	✓	✓	✓			✓	
✓	✓	✓	✓	✓	✓	✓			✓	
										1.5
								1,000		
160	255	160	160	160	39	77	150	160	125	40
84x168x41.5	110x220x54	84x168x41.5	84x168x41.5	84x168x41.5	80x160x36.5	90x180x48	84x168x41.5	90x190x60		
13	25	12	12	13	11	17	16	17.5	17	21.5
		✓	✓		✓	✓	✓			✓
	✓			✓						
	✓							✓	✓	
✓				✓				✓		
✓									✓	
	✓								✓	
250	110	450	430	250	400	360	400	≥ 290 / ≤ 575	70 – 280	≥ 150 / ≤ 225
450	175		760	450						180 – 580
	245									
	385									
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
	✓								✓	
									✓	
✓	✓									
12 – 40	12 – 75	12 – 32	12 – 35	12 – 40	12 – 35	18 – 35	12 – 30	12 – 35		
									17 – 36	17 – 36
12 – 40	12 – 75	12 – 32	12 – 35	12 – 40			12 – 30	12 – 35		
	20 – 75									
18	31.75	13	16	18			13	23		



Magnetic core drilling machines with all performance characteristics for plant construction and engineering: With full wave control electronics, CW/CCW operation, multi-stage gear reductions, torque control, KEYLESS quick-change drill chuck system, and many more.

MACHINE	PAGE
MAB 485	13
MAB 485 Swivel Base	14
MAB 525	16
MAB 525 Swivel Base	17
MAB 825	18
MAB 845 Swivel Base	19
MAB 1300	20 - 21

MAB 485

The best entrance into the ProfiPLUS class – indispensable in the workshop and when being away on a job.

The advantages of the MAB 485

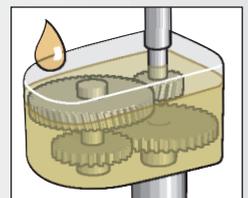
- > Continuous electronic control of motor output and speed
- > Drilling with core and twist drills, countersinking, reaming, thread cutting
- > Two-stage gear unit, non-destructive with oil bath gear box



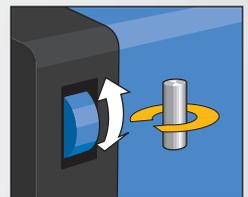
SPECIFICATION

	Motor output:	1150 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	13 kg
	Direct arbor:	–
	Industrial arbor:	–
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 2
	Speed range 1:	50 – 250 min ⁻¹
	Speed range 2:	100 – 450 min ⁻¹
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

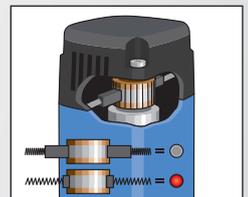
	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 40 mm
	Core drill long 55 mm:	12 – 40 mm
	Core drill overlong 75 mm:	–
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 18 mm
	Reaming:	≤ ø 18 mm
	Countersinking:	≤ ø 40 mm
	Thread cutting:	≤ M16



Two-stage oil bath gearbox



Full wave control electronics



Carbon brush wear control

ORDER NO.

MAB 485 230 Volt

MAB 485 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

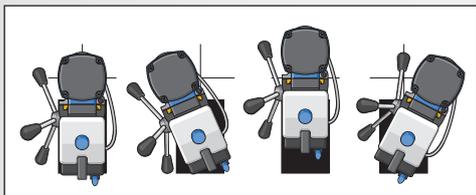
SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Hard protective case
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Safety chain
1 Tapping adapter ZGA 010 + ZGA 012 + ZGA 016	1 Drill drift MT 2
1 Ejector pin ZAK 075 + 100	1 Gear rim drill chuck 1 – 13 mm
	1 Taper drift MT 2/B16
	1 Operating manual

MAB 485 Swivel Base

The best introduction to the ProfiPLUS category - with the swivel base adjusting feature.

Tangible relief for operators when performing drilling works overhead or in horizontal situations. A good idea comes to life: BDS now offers four machines with a moveable magnetic adjustment feature in two performance categories.



A larger swivel range



Release the adjustment feature

How the swivel base works: place the machine roughly in position, activate the magnet, release the adjustment feature and adjust it effortlessly. The swivel base enables the drill to be placed in exactly the right position without needing to hold the whole weight of the machine at the same time. This relief is an additional factor in work safety even when the machine is secured with a chain.



The advantages of the MAB 485 Swivel Base

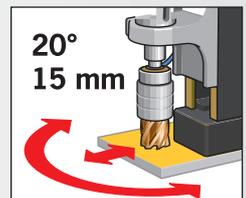
- > Continuous electronic control of motor output and speed
- > Drilling with core and twist drills, countersinking, reaming, thread cutting
- > Two-stage gear unit, non-destructive with oil bath gearbox
- > With Swivel Base, the adjustment feature for an easy positioning of the drill



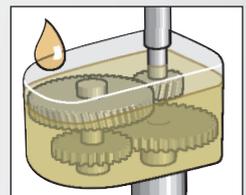
SPECIFICATION

	Motor output:	1150 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	✓
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	13 kg
	Direct arbor:	-
	Industrial arbor:	-
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 2
	Speed range 1:	50 – 250 min ⁻¹
	Speed range 2:	180 – 450 min ⁻¹
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

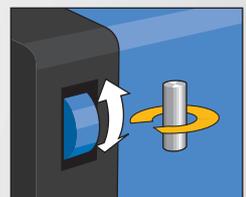
	Friction clutch:	-
	Torque control:	-
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 40 mm
	Core drill long 55 mm:	12 – 40 mm
	Core drill overlong 75 mm:	-
	Core drill extra-long 110 mm:	-
	Twist drilling:	≤ ø 18 mm
	Reaming:	≤ ø 18 mm
	Countersinking:	≤ ø 40 mm
	Thread cutting:	≤ M16



Swivel Base adjustment feature



Two-stage oil bath gearbox



Full wave control electronics

ORDER NO.

MAB 485 SB 230 Volt

MAB 485 SB 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Hard protective case
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Safety chain
1 Tapping adapter ZGA 010 + ZGA 012 + ZGA 016	1 Drill drift MT 2
1 Ejector pin ZAK 075 + 100	1 Gear rim drill chuck 1 – 13 mm
	1 Taper drift MT 2/B16
	1 Operating manual

MAB 525

Robust and lightweight! With two-stage oil bath gearbox, thread cutting up to M 20.

The advantages of the MAB 525

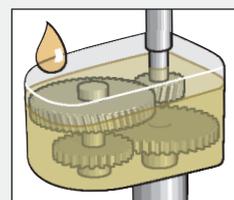
- > Best choice for service work: Total weight only 16 kg
- > With MT 3 tool holder and a drilling performance of up to \varnothing 50 mm
- > Torsion-resistant design, monoblock gearbox and slide



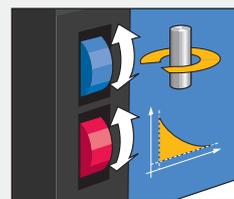
SPECIFICATION

	Motor output:	1600 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	-
	Magnet size:	90 x 180 x 48 mm
	Weight:	16 kg
	Direct arbor:	-
	Industrial arbor:	-
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 3
	Speed range 1:	70 – 280 min ⁻¹
	Speed range 2:	180 – 580 min ⁻¹
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

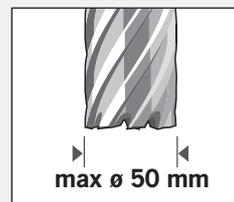
	Friction clutch:	-
	Torque control:	✓
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 50 mm
	Core drill long 55 mm:	12 – 50 mm
	Core drill overlong 75 mm:	18 – 50 mm
	Core drill extra-long 110 mm:	-
	Twist drilling:	≤ \varnothing 20 mm
	Reaming:	≤ \varnothing 20 mm
	Countersinking:	≤ \varnothing 50 mm
	Thread cutting:	≤ M20



Two-stage oil bath gearbox



Full wave control electronics with torque control



Core drilling up to \varnothing 50 mm

ORDER NO.

MAB 525 230 Volt

MAB 525 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Ejector pin ZAK 075 + 090
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Safety chain
1 Tapping adapter ZGA 010 + ZGA 012 + ZGA 016	1 Drill drift MT 3
1 Hard protective case	1 Taper drift MT 3/B16
	1 Gear rim drill chuck 1 – 13 mm
	1 Operating manual

MAB 525 Swivel Base

Indispensable during assembly and in the workshop. Versatile, robustly built. Easier to position thanks to the swivel base.

The advantages of the MAB 525 Swivel Base

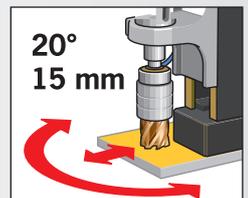
- > Best choice for service work: Total weight only 16 kg
- > With MT 3 tool holder and a drilling performance of up to \varnothing 50 mm
- > Torsion-resistant design, monoblock gearbox and slide
- > With Swivel Base, the adjustment feature for an easy positioning of the drill



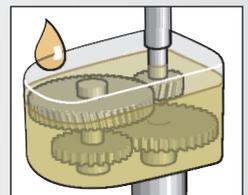
SPECIFICATION

	Motor output:	1600 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	✓
	Magnet size:	90 x 180 x 48 mm
	Weight:	16 kg
	Direct arbor:	-
	Industrial arbor:	-
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 3
	Speed range 1:	70 – 280 min ⁻¹
	Speed range 2:	180 – 580 min ⁻¹
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

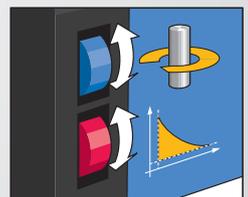
	Friction clutch:	-
	Torque control:	✓
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 50 mm
	Core drill long 55 mm:	12 – 50 mm
	Core drill overlong 75 mm:	18 – 50 mm
	Core drill extra-long 110 mm:	-
	Twist drilling:	≤ \varnothing 20 mm
	Reaming:	≤ \varnothing 20 mm
	Countersinking:	≤ \varnothing 50 mm
	Thread cutting:	≤ M20



Swivel Base adjustment feature



Two-stage oil bath gearbox



Full wave control electronics with torque control

ORDER NO.

MAB 525 SB 230 Volt

MAB 525 SB 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

Swivel base adjustment feature: Page 14

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Ejector pin ZAK 075 + 090
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Safety chain
1 Tapping adapter ZGA 010 + ZGA 012 + ZGA 016	1 Drill drift MT 3
1 Hard protective case	1 Taper drift MT 3/B16
	1 Gear rim drill chuck 1 – 13 mm
	1 Operating manual

MAB 825

Full performance and flexibility for structural steel engineering, plant construction and engineering.

The advantages of the MAB 825

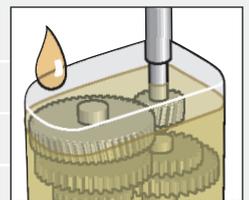
- > The classic of the large-size series – with MT 3
- > For core drills with a cutting depth of 30 mm, 55 mm, 75 mm and 110 mm.
- > Suitable for twist drills, reamer chucks, countersinks and thread cutting systems



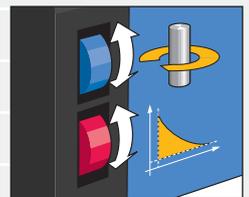
SPECIFICATION

	Motor output:	1800 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	255 mm
	Swivel Base, adjustment feature: –	
	Magnet size:	110 x 220 x 54 mm
	Weight:	25 kg
	Direct arbor:	–
	Industrial arbor:	MT 3, 32 mm Weldon (1 1/4")
	Quick change drill chuck system: KEYLESS, 19 mm Weldon (3/4")	
	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
	Permanent internal lubrication:	✓

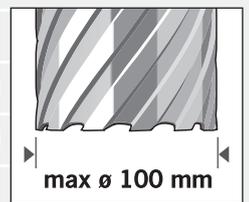
	Friction clutch:	✓
	Torque control:	✓
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 100 mm
	Core drill long 55 mm:	12 – 100 mm
	Core drill overlong 75 mm:	18 – 60 mm
	Core drill extra-long 110 mm:	20 – 60 mm
	Twist drilling:	≤ ø 31.75 mm
	Reaming:	≤ ø 31.75 mm
	Countersinking:	≤ ø 50 mm
	Thread cutting:	≤ M30



Four-stage oil bath gearbox



Full wave control electronics with torque control



Core drilling up to ø 100 mm

ORDER NO.

MAB 825 230 Volt

MAB 825 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Ejector pin ZAK 100 + 120
1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4")	1 Carry case on wheels
1 Industrial arbor MT 3 / 32 mm Weldon (1 1/4")	1 Safety chain
1 Ejector pin ZAK 075 + 090	1 Offset screwdriver SW 6
	1 Drill drift MT 3
	1 Operating manual

MAB 845 Swivel Base

Full performance and flexibility for structural steel engineering, plant construction and engineering.

The advantages of the MAB 845 Swivel Base

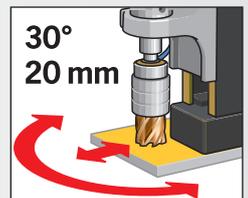
- > With Swivel Base, the adjustment feature for an easy positioning of the drill
- > For core drills with a cutting depth of 30 mm, 55 mm, 75 mm and 110 mm
- > Suitable for twist drills, reamer chucks, countersinks and thread cutting systems



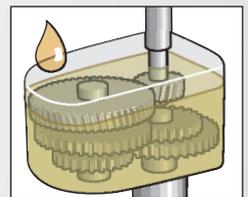
SPECIFICATION

	Motor output:	1800 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	255 mm
	Swivel Base, adjustment feature:	✓
	Magnet size:	110 x 220 x 54 mm
	Weight:	25 kg
	Direct arbor:	-
	Industrial arbor:	MT 3, 32 mm Weldon (1 1/4")
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon (3/4")
	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
	Permanent internal lubrication:	✓

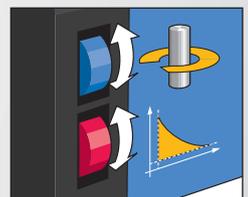
	Friction clutch:	✓
	Torque control:	✓
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 100 mm
	Core drill long 55 mm:	12 – 100 mm
	Core drill overlong 75 mm:	18 – 60 mm
	Core drill extra-long 110 mm:	20 – 60 mm
	Twist drilling:	≤ ø 31.75 mm
	Reaming:	≤ ø 31.75 mm
	Countersinking:	≤ ø 50 mm
	Thread cutting:	≤ M30



Swivel base adjustment feature



Four-stage oil bath gearbox



Full wave control electronics with torque control

ORDER NO.

MAB 845 SB 230 Volt

MAB 845 SB 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Ejector pin ZAK 100 + 120
1 Quick change drill chuck system KEYLESS, 19 mm Weldon (3/4")	1 Carry case on wheels
1 Industrial arbor MT 3 / 32 mm Weldon (1 1/4")	1 Safety chain
1 Ejector pin ZAK 075 + 090	1 Offset screwdriver SW 6
	1 Drill drift MT 3
	1 Operating manual

MAB 1300 – The Worlds' Most Powerful Magnetic Core Drilling Machine

Outstanding performance with exceptional power delivery. The MAB 1300 is currently the strongest magnetic core drilling machine.

You just need to look at the machine to get the idea! 2,300 Watt motor performance, four speed gears, Morse Taper 4, Single phase and fully equipped to fulfil every requirement. The MAB 1300 reaches the maximum limit of magnetic drilling technology.

MAB 1300 – sheer power

This magnetic core drilling machine meets all the expectations that arise in heavy engineering & fabrication, ship building, production engineering, etc.

Core drilling upto \varnothing 130 mm (30 mm cutting depth), the whole spectrum of BDS core drills can be used with this machine: twist drilling, reaming, countersinking and thread cutting to M42.

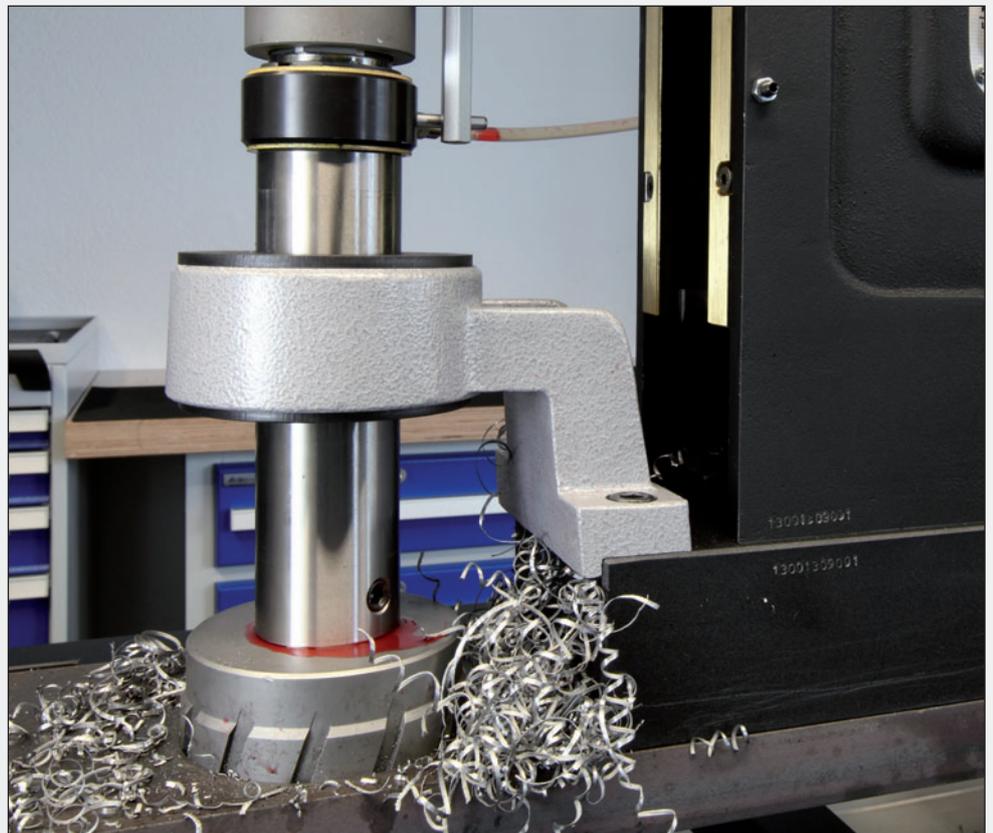
As a standard, the MAB 1300 has a direct arbor with 32 mm Weldon shank ($1 \frac{1}{4}$ "") and a Morse Taper MT 4.

If the steady is removed, which can be done in just a few moments, the machine's stroke can be extended to a remarkable 310 mm.

The machine is fully equipped with all the safety measures of current magnetic core drilling technology: protection from machine overheating, protection from tool damage, alerts when the carbon brushes are worn and a warning when the magnet holding force is too low.

The MAB 1300 drilling system is delivered as standard in a stable carry case on wheels made out of impact resistant plastic. It is thus very portable and easy to handle despite its weighty 51 kg.

The MAB 1300 even though being such a powerful machine, it uses Single Phase power supply, thus helping to reduce the power consumption.



The MAB 1300 in its element: drilling, countersinking, reaming, thread cutting.



The robust carry case on wheels for the MAB 1300.

Maximum stroke without steady:
310 mm high.



Visit our homepage to experience live the MAB 1300 demo video.
http://www.kernbohrer.de/downloads/downloads.html#tab_4

The advantages of the MAB 1300

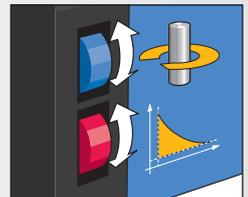
- > Drilling to \varnothing 130 mm with a cutting depth of 110 mm
- > MT 4 Motor, output of 2,300 Watt and all features of the ProfiPLUS class
- > With Power-Assist – servo-assisted drilling



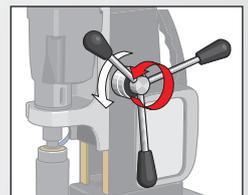
SPECIFICATION

	Motor output:	2300 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke without steady:	310 mm
	Stroke with steady:	85 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	120 x 360 x 65 mm
	Weight:	51 kg
	Direct arbor:	32 mm Weldon (1 1/4")
	Quick change drill chuck system:	–
	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
	Permanent internal lubrication:	✓

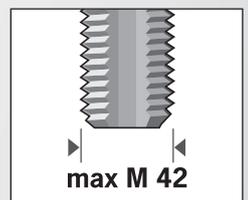
	Friction clutch:	✓
	Torque control:	✓
	Full wave control electronics:	✓
	Magnet indicator:	✓
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓
	Core drill short 30 mm:	12 – 130 mm
	Core drill long 55 mm:	12 – 120 mm
	Core drill overlong 75 mm:	18 – 120 mm
	Core drill extra-long 110 mm:	20 – 120 mm
	Twist drilling:	≤ \varnothing 45 mm
	Reaming:	≤ \varnothing 50 mm
	Countersinking:	≤ \varnothing 80 mm
	Thread cutting:	≤ M42



Full wave control electronics with torque control



Drilling with servo assist



Thread cutting upto M42

ORDER NO.

MAB 1300 230 Volt

MAB 1300 110/125 Volt

Technical drawing: Page 42-43

Thread cutting systems: Page 70-71

SCOPE OF DELIVERY

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



Profistart

The best entry into a successful technology, where the professional user can expect well-engineered, robust machines built for continuous service. Satisfy yourself as to the BDS quality 'Made in Germany'.

MACHINE

PAGE

MAB 100	23
MAB 455 Swivel Base	24
MAB 455	26
MAB 855	27

MAB 100

Compact, handy, powerful – really successful when low weight is in demand.

The advantages of the MAB 100

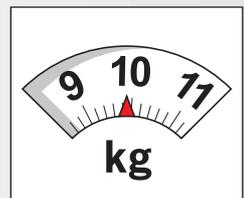
- > With only 9.9 kg the light-weight in the BDS range of products
- > Straightforward handling – small design height of 300/370 mm
- > High work safety due to internal cabling



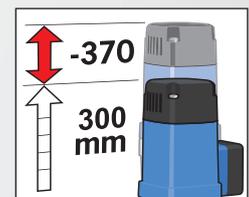
SPECIFICATION

	Motor output:	1,050 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	70 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	80 x 160 x 41.5 mm
	Weight:	9.9 kg
	Direct arbor:	✓
	Industrial arbor:	–
	Quick change drill chuck system:	–
	Morse taper:	–
	Speed range 1:	460 min ⁻¹
	Speed range 2:	–
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

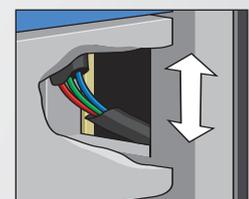
	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Carbon brush wear control:	–
	Core drill short 30 mm:	12 – 30 mm
	Core drill long 55 mm:	12 – 30 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	–
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



The light-weight



Compact design, stroke 70 mm



Protected internal cabling

ORDER NO.

MAB 100 230 Volt

MAB 100 110/125 Volt

SCOPE OF DELIVERY

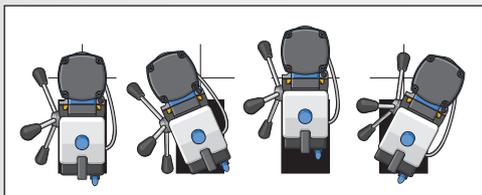
- | | |
|----------------------------------|---------------------------|
| 1 Magnetic core drilling machine | 1 Offset screwdriver SW 4 |
| 1 Ejector pin ZAK 075 + 100 | 1 Operating manual |
| 1 Hard protective case | |
| 1 Safety chain | |

Technical drawing: Page 42-43

MAB 455 Swivel Base

A particularly high performance in steel construction, during assembly and in the workshop. Easily positioned thanks to the Swivel Base adjustment feature.

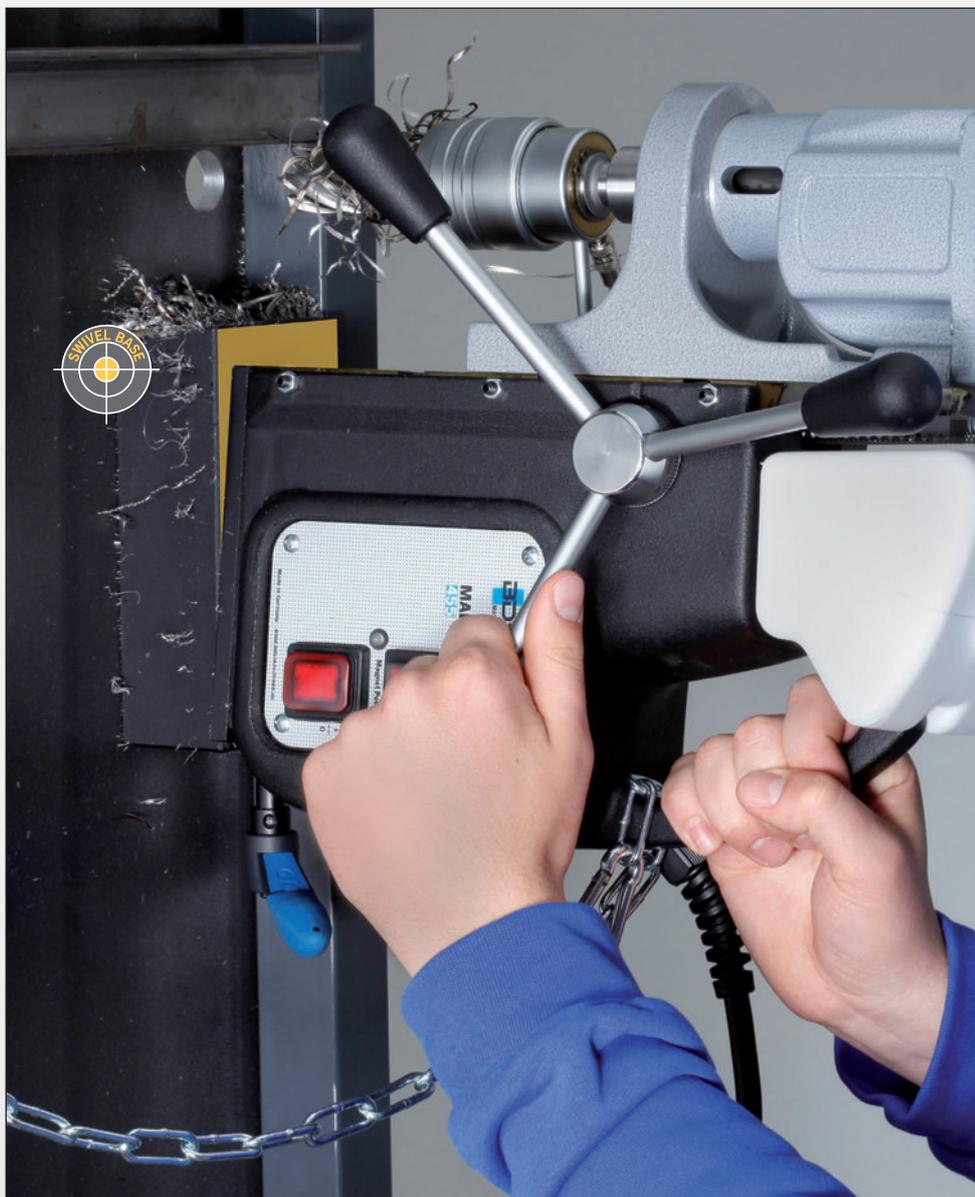
Tangible relief for operators when performing drilling works overhead or in horizontal situations. A good idea comes to life: BDS now offers four machines in two performance categories that include Swivel Base.



Release the adjustment feature

How the swivel base works: place the machine roughly in position, activate the magnet, release the adjustment feature and adjust it effortlessly.

The swivel base enables the drill to be placed in exactly the right position without needing to hold the whole weight of the machine at the same time. This relief is an additional factor in work safety even when the machine is secured with a chain.



The advantages of the MAB 455 Swivel Base

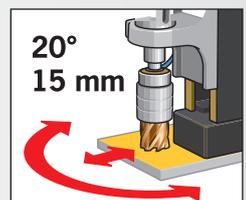
- > With Swivel Base adjustment feature for easier positioning
- > Two-speed machine with oil-bath gearbox
- > Quick tool change from core drills to twist drills and vice versa
- > MT 2 tool holder, integrated cabling



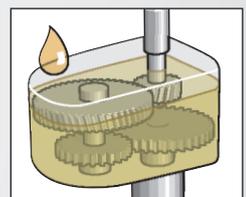
SPECIFICATION

	Motor output:	1150 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base adjustment feature:	✓
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	13 kg
	Direct arbor:	-
	Industrial arbor:	-
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 2
	Speed range 1:	250 min ⁻¹
	Speed range 2:	450 min ⁻¹
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

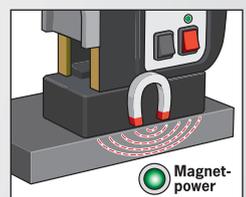
	Friction clutch:	-
	Torque control:	-
	Full wave control electronics:	-
	Magnet indicator:	✓
	Overheating protection:	-
	CW/CCW rotation:	-
	Carbon brush wear control:	-
	Core drill short 30 mm:	12 – 40 mm
	Core drill long 55 mm:	12 – 40 mm
	Core drill extra-long 110 mm:	-
	Twist drilling:	≤ ø 18 mm
	Reaming:	-
	Countersinking:	-
	Thread cutting:	-



Swivel Base adjustment feature



Two-stage oil-bath gearbox



Magnet indicator

ORDER NO.

MAB 455 SB 230 Volt
MAB 455 SB 110/125 Volt

Technical drawing: Page 42-43

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Safety chain
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Drill drift MT 2
1 Ejector pin ZAK 075 + 100	1 Operating manual
1 Hard protective case	

MAB 455

Immensely powerful in steel industry, for assembly jobs and in the workshop.

The advantages of the MAB 455

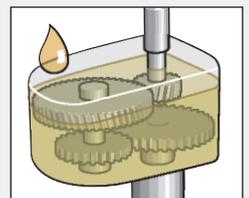
- > Two-speed machine with oil-bath gearbox
- > Quick tool change from core drills to twist drills and vice versa
- > MT 2 tool holder, integrated cabling



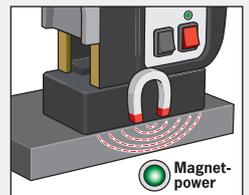
SPECIFICATION

	Motor output:	1150 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	13 kg
	Direct arbor:	–
	Industrial arbor:	–
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 2
	Speed range 1:	250 min ⁻¹
	Speed range 2:	450 min ⁻¹
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

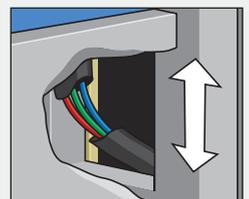
	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	✓
	Overheating protection:	–
	CW/CCW rotation:	–
	Carbon brush wear control:	–
	Core drill short 30 mm:	12 – 40 mm
	Core drill long 55 mm:	12 – 40 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 18 mm
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Two-stage oil-bath gearbox



Magnet indicator



Protected internal cabling

ORDER NO.

MAB 455 230 Volt

MAB 455 110/125 Volt

Technical drawing: Page 42-43

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Safety chain
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Drill drift MT 2
1 Ejector pin ZAK 075 + 100	1 Operating manual
1 Hard protective case	

MAB 855

Performance and price will be of interest to you.

The advantages of the MAB 855

- > Core drilling performance up to \varnothing 75 mm
- > Robust, four-stage gear



SPECIFICATION

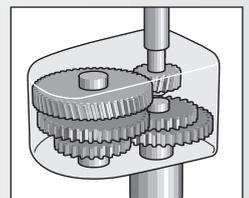
	Motor output:	1700 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	255 mm
	Swivel Base, adjustment feature:	-
	Magnet size:	110 x 220 x 54 mm
	Weight:	25 kg
	Direct arbor:	-
	Industrial arbor:	MT 3, 19 mm Weldon ($\frac{3}{4}$ " MT 3, 32 mm Weldon ($1\frac{1}{4}$ "
	Quick change drill chuck system:	-
	Morse taper:	MT 3
	Speed range 1:	110 min ⁻¹
	Speed range 2:	175 min ⁻¹
	Speed range 3:	245 min ⁻¹
	Speed range 4:	385 min ⁻¹

ORDER NO.

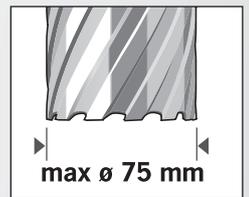
MAB 855 230 Volt
MAB 855 110/125 Volt

Technical drawing: Page 42-43

	Permanent internal lubrication:	✓
	Friction clutch:	✓
	Torque control:	-
	Full wave control electronics:	-
	Magnet indicator:	✓
	Overheating protection:	-
	CW/CCW rotation:	-
	Carbon brush wear control:	-
	Core drill short 30 mm:	12 – 75 mm
	Core drill long 55 mm:	12 – 75 mm
	Core drill extra-long 110 mm:	20 – 60 mm
	Twist drilling:	≤ \varnothing 31.75 mm
	Reaming:	-
	Countersinking:	-
	Thread cutting:	-



Four-stage gearbox



Core drilling up to \varnothing 75 mm



Twist drilling up to \varnothing 31.75 mm

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Industrial arbor ZIA 319-KN
1 Carry case on wheels	1 Industrial arbor ZIA 322-KN
1 Safety chain	1 Ejector pin each ZAK 075, ZAK 090, ZAK 100, ZAK 120
1 Offset screwdriver	1 Operating manual
1 Drill drift MT 3	



High performance - low price. BDS Maschinen is looking to fill a gap with this new machine concept for professional users who cannot compromise on quality or performance, but who are able to forgo comfort and fittings for the benefit of good prices.

MACHINE	PAGE
MABasic 200	29
MABasic 400	30
MABasic 450	31

MABasic 200

The introduction into the world of BDS Maschinen.

The advantages of the MABasic 200

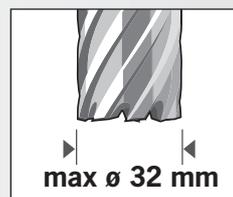
- > 900 Watt motor
- > 1-stage gear unit
- > Core drilling from 12 mm to 32 mm – cutting depth 30 mm and 55 mm



SPECIFICATION

	Motor output:	900 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	12 kg
	Direct arbor:	19 mm Weldon 3/4"
	Industrial arbor:	–
	Quick change drill chuck system:	–
	Morse taper:	–
	Speed range 1:	450 min ⁻¹
	Speed range 2:	–
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Core drill short 30 mm:	12 – 32 mm
	Core drill long 55 mm:	12 – 32 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 13 mm
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Core drills ø 12 – 32 mm



Twist drills up to ø 13 mm



The practical carry case

ORDER NO.

MABasic 200 / 230 Volt
MABasic 200 / 110 Volt

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Hexagon Offset screwdriver SW 4
1 Ejector pin ZAK 075	1 Operating manual
1 Cutting oil pump bottle ZKP 100	
1 Plastic carry case	
1 Safety lashing strap	

Technical drawing: Page 42-43

MABasic 400

The high-speed machine - also suited for twist drills.

The advantages of the MABasic 400

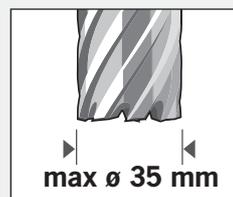
- > 1050 Watt motor
- > 2-stage gear unit with high rotation speed, ideal for working with twist drills
- > Core drilling from 12 mm to 35 mm – cutting depth 30 mm and 55 mm



SPECIFICATION

	Motor output:	1050 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	12 kg
	Direct arbor:	19 mm Weldon $\frac{3}{4}$ "
	Industrial arbor:	–
	Quick change drill chuck system:	–
	Morse taper:	–
	Speed range 1:	430 min ⁻¹
	Speed range 2:	760 min ⁻¹
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Core drill short 30 mm:	12 – 35 mm
	Core drill long 55 mm:	12 – 35 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 16 mm
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Core drills ø 12 – 35 mm



Twist drills up to ø 16 mm



The practical carry case

ORDER NO.

MABasic 400 / 230 Volt
MABasic 400 / 110 Volt

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Hexagon Offset screwdriver SW 4
1 Ejector pin ZAK 075	1 Operating manual
1 Cutting oil pump bottle ZKP 100	
1 Plastic carry case	
1 Safety lashing strap	

Technical drawing: Page 42-43

MABasic 450

Fast and flexible tool change thanks to the MT 2 morse taper.

The advantages of the MABasic 450

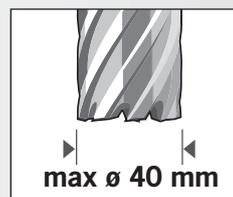
- > 1150 Watt motor
- > 2-stage gear
- > Core drilling from 12 mm to 40 mm – cutting depth 30 mm and 55 mm
- > With MT 2 industrial arbor



SPECIFICATION

	Motor output:	1150 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	160 mm
	Swivel Base, adjustment feature:	-
	Magnet size:	84 x 168 x 41.5 mm
	Weight:	13 kg
	Direct arbor:	-
	Industrial arbor:	MT 2, 19 mm Weldon $\frac{3}{4}$ "
	Quick change drill chuck system:	-
	Morse taper:	✓
	Speed range 1:	250 min ⁻¹
	Speed range 2:	450 min ⁻¹
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

	Friction clutch:	-
	Torque control:	-
	Full wave control electronics:	-
	Magnet indicator:	-
	Overheating protection:	-
	CW/CCW rotation:	-
	Core drill short 30 mm:	12 – 40 mm
	Core drill long 55 mm:	12 – 40 mm
	Core drill extra-long 110 mm:	-
	Twist drilling:	≤ ø 18 mm
	Reaming:	-
	Countersinking:	-
	Thread cutting:	-



Core drills ø 12 – 40 mm



Twist drills up to ø 18 mm



The practical carry case

ORDER NO.

MABasic 450 / 230 Volt
MABasic 450 / 110 Volt

Technical drawing: Page 42-43

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Safety lashing strap
1 Industrial arbor ZIA 219 KN 19 mm Weldon $\frac{3}{4}$ "	1 Hexagon Offset screwdriver SW 4
1 Ejector pin ZAK 075	1 Operating manual
1 Cutting oil pump bottle ZKP 100	
1 Plastic carry case	



ProfisPEZIAL

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 petrol drive.

Have you got specific requirements? BDS also delivers special out-of-series solutions.

MACHINE	PAGE
MAB 150	33
AkkuMAB 3000	34-35
AutoMAB 1500	35
AirMAB 5000	36
RailMAB 925	40
RailMAB 960	41

MAB 150

Horizontal magnetic core drilling machine with angular gear, ideally suited for most confined drilling situations.

The advantages of the MAB 150

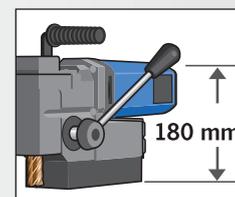
- > Only 11 kg – especially light-weight and handy
- > Feed handle changeable from the left to the right side of the machine
- > Core drills up to \varnothing 35 mm



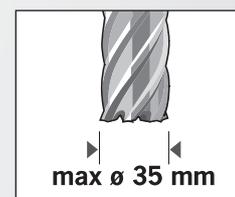
SPECIFICATION

	Motor output:	1080 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	39 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	80 x 160 x 36.5 mm
	Weight:	11 kg
	Direct arbor:	19 mm Weldon ($\frac{3}{4}$ "
	Industrial arbor:	–
	Quick change drill chuck system:	–
	Morse taper:	–
	Speed range 1:	400 min ⁻¹
	Speed range 2:	–
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

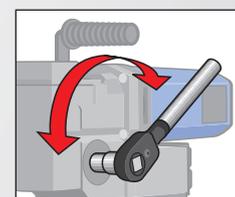
	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Carbon brush wear control:	–
	Core drill short 30 mm:	12 – 35 mm
	Core drill long 55 mm:	–
	Core drill extra-long 110 mm:	–
	Twist drilling:	–
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Low design height



Core drilling up to \varnothing 35 mm



Optionally with ratchet

ORDER NO.

- MAB 150 230 Volt
- MAB 150 110/125 Volt
- MAB 150 with lever drill 230 Volt
- MAB 150 with lever drill 110/125 Volt

Technical drawing: Page 42-43

SCOPE OF DELIVERY

- 1 Magnetic core drilling machine
- 1 Ejector pin ZAK 075
- 1 Hard protective case
- 1 Safety chain
- 1 Cutting oil pump bottle ZKP 100
- 1 Offset screwdriver SW 4
- 1 Operating manual

AkkuMAB 3000 – Cordless core drilling

The magnetic core drilling machine with more flexibility and mobility.

Great freedom: make up to 40 holes / ø 20 mm / 10 mm steel.

The new cordless AkkuMAB 3000 offers all the advantages of a professional magnetic core drilling technology as well as the greatest possible autonomy from stationary power sources.

6.0 Ampere power in its tank.

With its battery capacity suited to industrial uses, the AkkuMAB 3000 is beyond compare. 6.0 A allow the performance peaks called upon by the BDS motor. The size and weight of the battery are optimally designed for the magnetic core drilling system and are fully integrated in the body of the machine.

The battery can be changed quickly and easily. With the help of associated quick-charge station, the battery is fully charged in 180 minutes. This handy, compact machine is very well balanced and easy to manipulate even for horizontal drilling works or overhead usage.

For the mobile AkkuMAB 3000, BDS Maschinen is drawing fully on tried and tested electro-magnetic technology.

Controlled magnetic force.

The strong BDS electromagnet allows the user to position and control the AkkuMAB 3000 safely. The high magnet holding force guarantees a high degree of work safety. In particular, the user will note positive relief when drilling horizontally or overhead. The operator can therefore concentrate fully on the drilling procedure. This is a great advantage which traditional drilling machines cannot offer with a range of other features. The electronic controls and the safety motor shut-down mechanism ensure that the magnet is supplied with sufficient voltage. This is essential for the high work safety of the AkkuMAB 3000.



Protected from accidental activation.



The battery compartment is accessed from above.



Simple removal of battery.



The AkkuMAB 3000 is free from stationary power sources.

The advantages of the AkkuMAB 3000

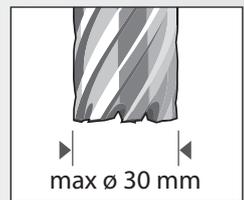
- > Uninterrupted power supply to the magnet
- > With powerful 6.0 Ah industrial power battery
- > Up to 40 core drillings / ø 20 mm / 10 mm steel



SPECIFICATION

	Voltage:	Li-Ionen Akku 36 V – 6.0 A
	Stroke:	150 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	168 x 84 x 41.5 mm
	Weight:	16 kg
	Direct arbor:	19 mm Weldon ³ / ₄ "
	Industrial arbor:	–
	Quick change drill chuck system:	–
	Morse taper:	–
	Speed range 1:	400 min ⁻¹
	Speed range 2:	–
	Speed range 3:	–
	Speed range 4:	–
	Permanent internal lubrication:	✓

	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Carbon brush wear control:	–
	Core drill short 30 mm:	12 – 30 mm
	Core drill long 55 mm:	12 – 30 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 13 mm
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Core drilling up to ø 35 mm



The complete system with carry case



Industrial lithium ion battery 6 A

ORDER NO.

AkkuMAB 3000

Technical drawing: Page 42-43

SCOPE OF DELIVERY

- | | |
|---|----------------------------------|
| 1 Battery magnetic core drilling machine incl. battery and charging station | 1 Offset screwdriver SW 4 |
| 1 Ejector pin ZAK 075 + 100 | 1 Screwdriver with T-handle SW 6 |
| 1 Hard protective case | 1 Operating manual |
| 1 Safety lashing strap | |

AutoMAB 1500

Magnetic core drilling machine
with automatic drill feed.

The advantages of the AutoMAB 1500

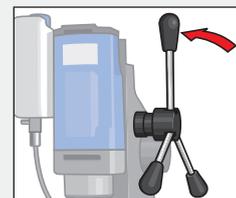
- > Automatic drill feed with limit stop and manual return
- > More productivity by room for parallel work
- > Handy, economic version for mobile applications



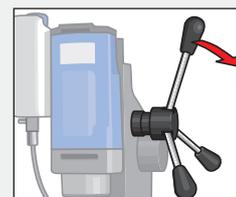
SPECIFICATION

	Motor output:	1080 Watt
	Voltage:	230 V AC, 50-60 Hz
	Stroke:	77 mm
	Swivel Base, adjustment feature:	-
	Magnet size:	90 x 180 x 48 mm
	Weight:	17 kg
	Direct arbor:	✓
	Industrial arbor:	-
	Quick change drill chuck system:	-
	Morse taper:	-
	Speed range 1:	360 min ⁻¹
	Speed range 2:	-
	Speed range 3:	-
	Speed range 4:	-
	Permanent internal lubrication:	✓

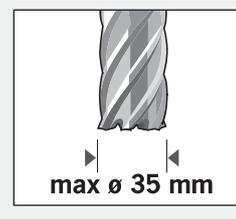
	Friction clutch:	-
	Torque control:	-
	Full wave control electronics:	-
	Magnet indicator:	-
	Overheating protection:	-
	CW/CCW rotation:	-
	Carbon brush wear control:	-
	Core drill short 30 mm:	18 – 35 mm
	Core drill long 55 mm:	-
	Core drill extra-long 110 mm:	-
	Twist drilling:	-
	Reaming:	-
	Countersinking:	-
	Thread cutting:	-



Automatic feed



Manual return



Core drilling up to ø 35 mm

ORDER NO.

MAB 1500 230 Volt

MAB 1500 110/125 Volt

SCOPE OF DELIVERY

1 Magnetic core drilling machine

1 Carry case

1 Safety chain

1 Offset screwdriver SW 4

1 Operating manual

AirMAB 5000

The magnetic core drilling machine with pneumatic drive and new permanent magnet.

The advantages of the AirMAB 5000

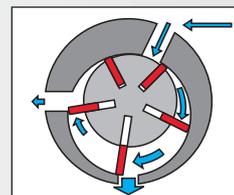
- > High-performance vane motor
- > Motor approved according to Ex class – Ex II 2G T4 IIC D110° C 
- > With powerful permanent magnet



SPECIFICATION

	Motor output:	830 Watt
	Nominal torque:	27 Nm
	Air consumption:	1000 l/min
	Stroke:	160 mm
	Swivel Base, adjustment feature:	–
	Magnet size:	90 x 190 x 60 mm
	Weight:	17.5 kg
	Direct arbor:	–
	Industrial arbor:	–
	Quick change drill chuck system:	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 2
	Speed range 1:	min 290 min ⁻¹ , max 575 min ⁻¹
	Speed range 2:	–
	Speed range 3:	–
	Speed range 4:	–

	Permanent internal lubrication:	✓
	Friction clutch:	–
	Torque control:	–
	Full wave control electronics:	–
	Magnet indicator:	–
	Overheating protection:	–
	CW/CCW rotation:	–
	Carbon brush wear control:	–
	Core drill short 30 mm:	12 – 35 mm
	Core drill long 55 mm:	12 – 35 mm
	Core drill extra-long 110 mm:	–
	Twist drilling:	≤ ø 23 mm
	Reaming:	–
	Countersinking:	–
	Thread cutting:	–



Vane motor



Shift lever to activate and deactivate the strong permanent magnet

ORDER NO.

AirMAB 5000

SCOPE OF DELIVERY

1 Magnetic core drilling machine	1 Hard protective case
1 Quick change drill chuck system KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "	1 Safety chain
1 Ejector pin ZAK 075 + 100	1 Drill drift MT 2
	1 Operating manual

Technical drawing: Page 42-43

BDS Rail core drilling machines

Developed for rail core drilling for the signalling and track construction fields.

In the rail processing sector, BDS offers two new and completely redeveloped machines:

The RailMAB 925 with 1,600 Watt motor and 2-stage oil bath gearbox and the RailMAB 960 core drilling machine with petrol engine.

The rail specialists.

The RailMAB 925 and RailMAB 960 are special core drilling machines used in track construction and signalling, for example to drill grounding screws, contact systems and insulated joints.

RailMAB 960 is an electricity-independent rail core drilling machine equipped with a robust HONDA motor. Its performance reaches 1.5 kW at a torque of 3.04 Nm.

Both systems are easily fixed to the rails with a rapid clamping system. In order to ensure the necessary drilling stability, this carries a pressure of 1.2 t on the rail base.

The multitude of optionally available drill adapters greatly increases the flexibility and the ease of use of the two core drilling machines. These adapters automatically determine the height and distance of the core drilling.

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.



RailMAB 925 - The rapid clamping system reliably fixes the machine to the rail.

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.



For high demands based on synthetic raw materials.

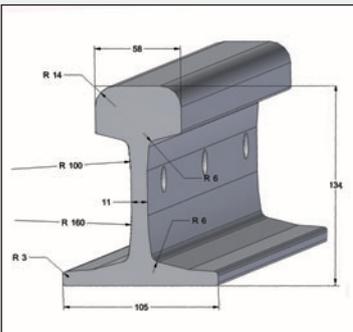
- ▶ Miscible with water, biostable and mild smelling
- ▶ Improves the core drill service life
- ▶ Toxicologically harmless, water hazard class 1



Rail MAB 600 with petrol engine. Performance 1.5 kW, torque 3.04 Nm.

CARBIDE RAIL SERIES

ø mm ORDER NO.	ø mm ORDER NO.
17 HKK-R 017	34 HKK-R 034
18 HKK-R 018	35 HKK-R 035
19 HKK-R 019	36 HKK-R 036
20 HKK-R 020	
21 HKK-R 021	Ejector pin
22 HKK-R 022	ZAK 075
23 HKK-R 023	
24 HKK-R 024	
25 HKK-R 025	
26 HKK-R 026	
27 HKK-R 027	
28 HKK-R 028	
29 HKK-R 029	
30 HKK-R 030	
31 HKK-R 031	
32 HKK-R 032	
33 HKK-R 033	



Rail profile



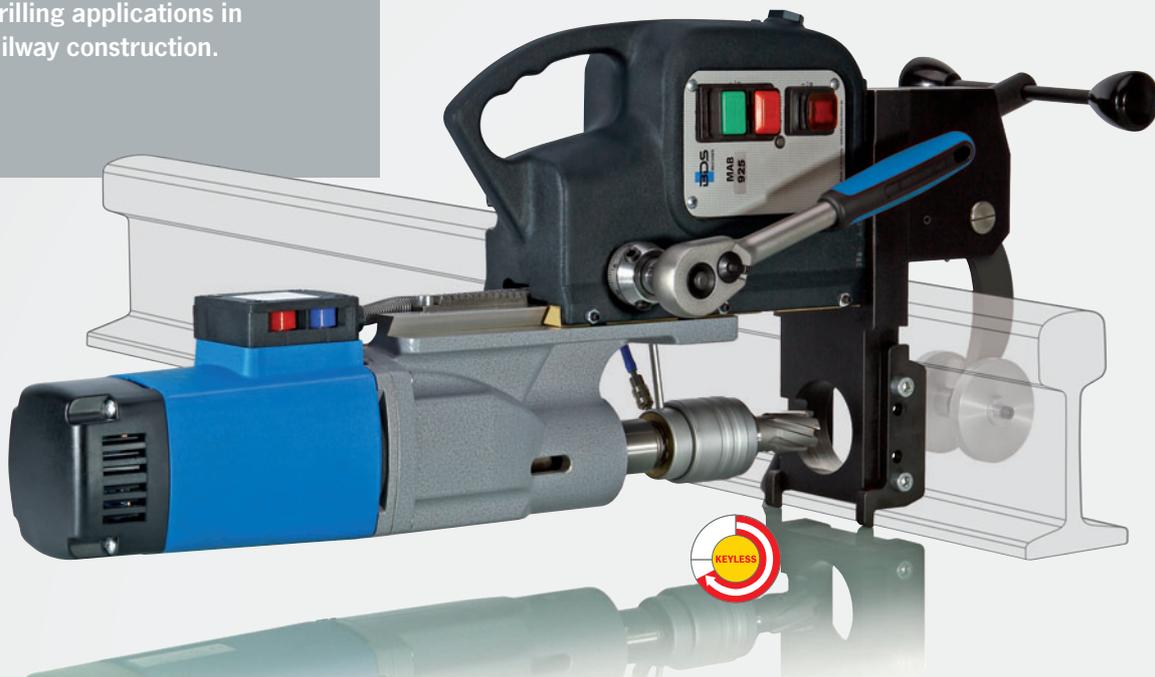
An appropriate adapter for every rail profile.

RailMAB 925

Developed for all rail core drilling applications in signalling technology and railway construction.

The advantages of the RailMAB 925

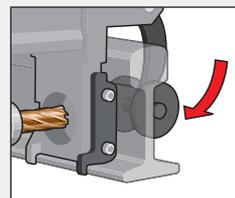
- > Very handy and compact design with 17 kg only
- > With powerful 1,600 Watt motor
- > Low-wear oil bath gear
- > Internal cabling



SPECIFICATION

	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 Weldon ($\frac{3}{4}$ "
	Morse taper:	MT 3
	Speed range 1:	70 – 280 min ⁻¹
	Speed range 2:	180 – 580 min ⁻¹
	Permanent internal lubrication:	✓
	Core drill HKK-R:	ø 17 – 36 mm
	Cooling:	with drilling emulsion
	Torque control:	✓
	Full wave control electronics:	✓

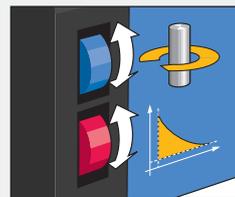
	Overheating protection:	✓
	CW/CCW rotation:	✓
	Carbon brush wear control:	✓



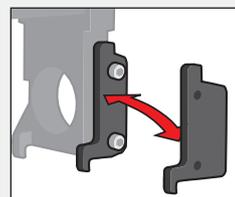
Quick-action clamping system

RAIL ADAPTERS

ADAPTER FOR	ORDER NO.
UIC 50	ZAS 050U
UIC 54	ZAS 054U
UIC 60	ZAS 060U
S 49	ZAS 049S
S 54	ZAS 054S
Custom-made design upon request	



Full wave control electronics with torque control



Rail adapter

ORDER NO.

RailMAB 925 230 Volt
RailMAB 925 110/125 Volt

Technical drawing: Page 42-43

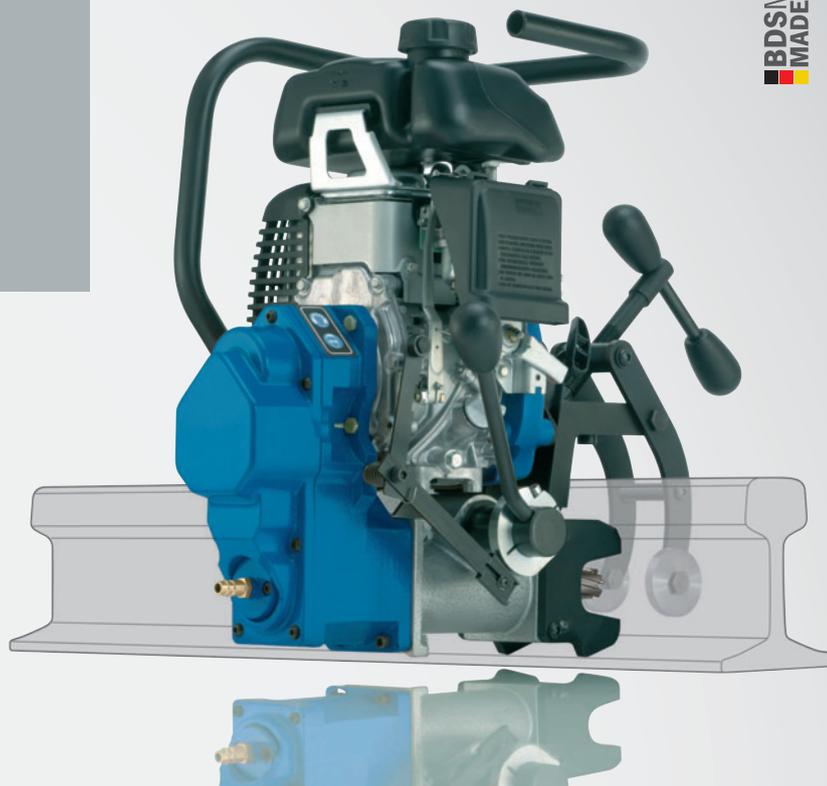
Rail core drills series carbide RAIL: pages 39 and 62.

SCOPE OF DELIVERY

1 Rail core drilling machine	1 Quick change drill chuck system
1 High-pressure tank, 5 litres	KEYLESS, 19 mm Weldon ($\frac{3}{4}$ "
1 Reversing ratchet	1 Drill drift MT 3
1 Rail adapter of your choice (no special version)	1 Carry case
	1 Operating manual

RailMAB 960

Rail core drilling machine with petrol engine.



The advantages of the RailMAB 960

- > Independent of electric power supply at the railway
- > Reliable Honda motor with an output of 1.5 kW
- > With quick-action clamping system

SPECIFICATION

	Motor:	Honda GXH 50
	Cubic capacity:	49.4 ccm
	Output:	1500 Watt
	Torque:	3.04 Nm
	Stroke:	40 mm
	Weight:	21.5 kg
	Direct arbor:	19 mm Weldon (3/4")
	Speed range 1:	min. 150 min ⁻¹ , max. 225 min ⁻¹
	Permanent internal lubrication:	✓
	Core drill HKK-R:	ø 17 – 36 mm
	Cooling:	with drilling emulsion

RAIL ADAPTERS

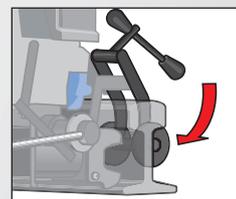
ADAPTER FOR	ORDER NO.
UIC 50	ZAS 250U
UIC 54	ZAS 254U
UIC 60	ZAS 260U
S 49	ZAS 249S
S 54	ZAS 254S
Custom-made design upon request	



Petrol engine 49.4 ccm, 1.5 kw



Core drilling up to ø 35 mm



Quick-action clamping system

ORDER NO.

RailMAB 960

SCOPE OF DELIVERY

- | | |
|---|-------------------------------|
| 1 Rail core drilling machine | 1 Offset screwdriver SW 4 + 5 |
| 1 High-pressure tank, 5 litres | 1 Operating manual |
| 1 Rail adapter of your choice
(no special version) | |

Technical drawing: Page 42-43

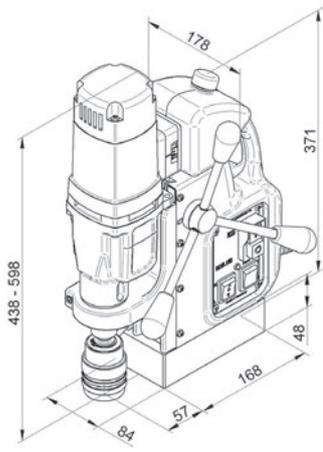
Rail adapter images: Page 39

Technical drawings

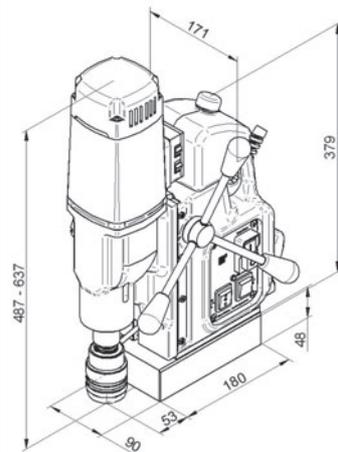
Magnetic core drilling machines.



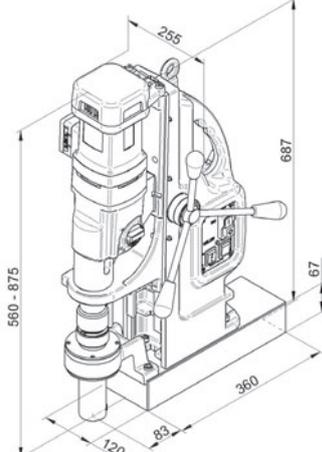
MAB 485



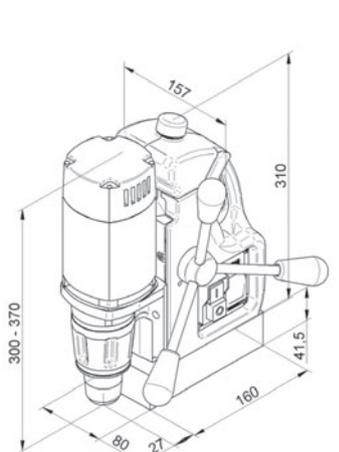
MAB 525 Swivel Base



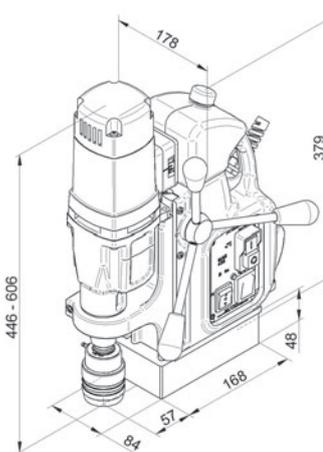
MAB 1300



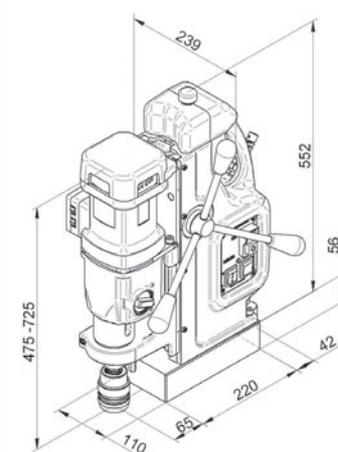
MAB 100



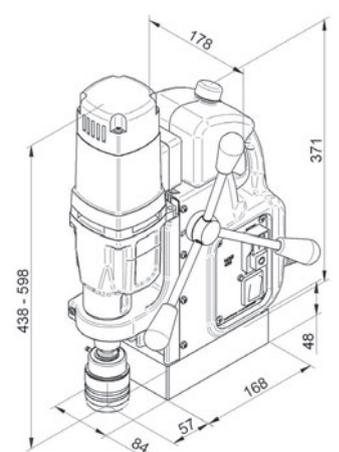
MAB 485 Swivel Base



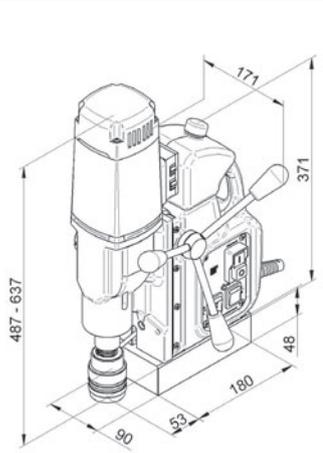
MAB 825



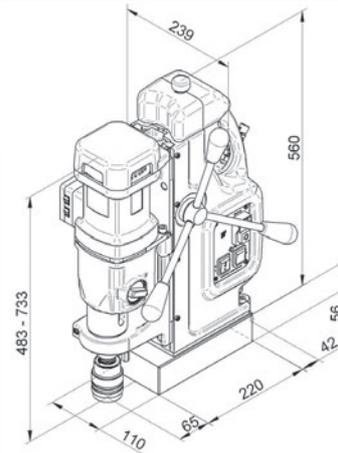
MAB 455



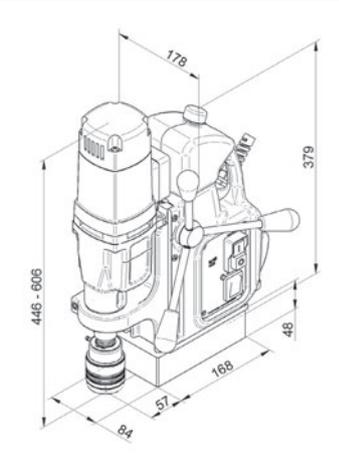
MAB 525



MAB 845 Swivel Base

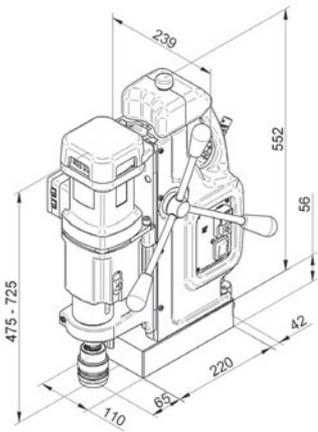


MAB 455 Swivel Base

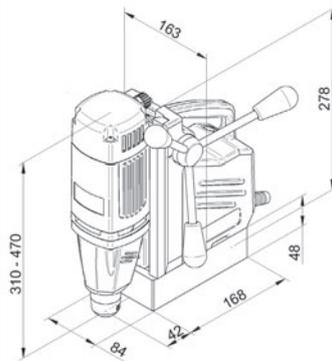




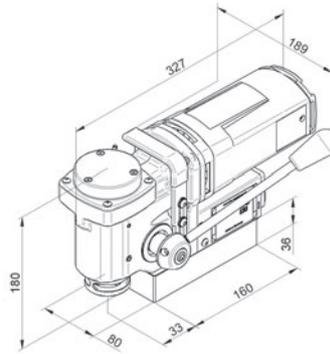
MAB 855



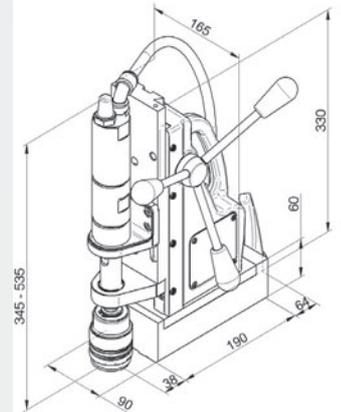
MABasic 200



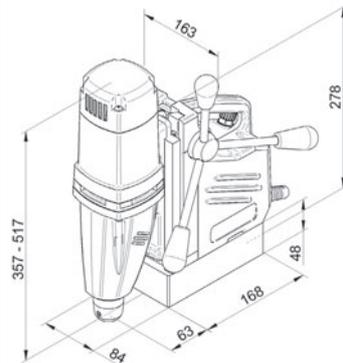
MAB 150



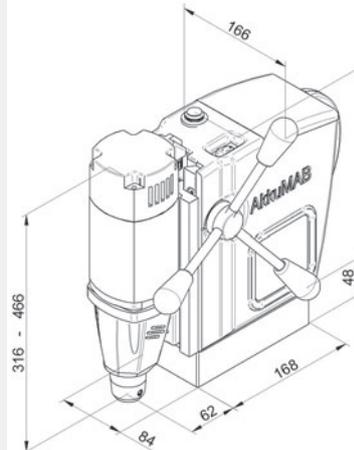
AirMAB 5000



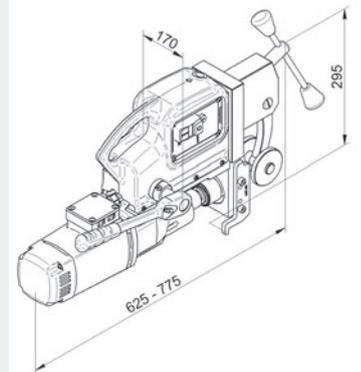
MABasic 400



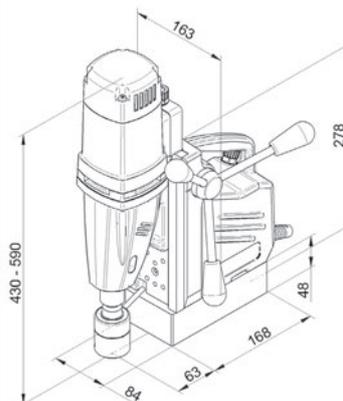
AkkuMAB 3000



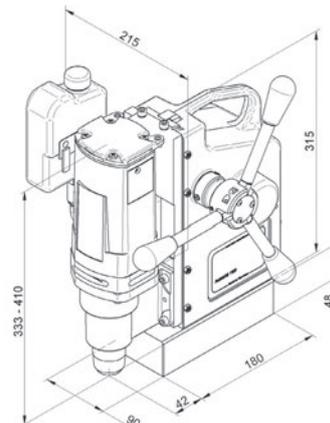
RailMAB 925



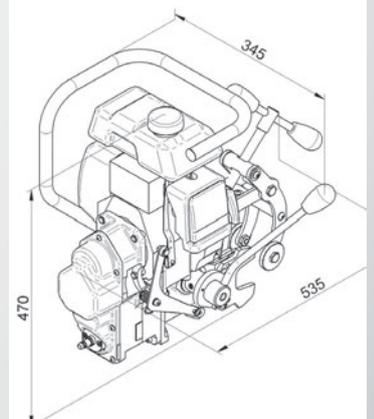
MABasic 450

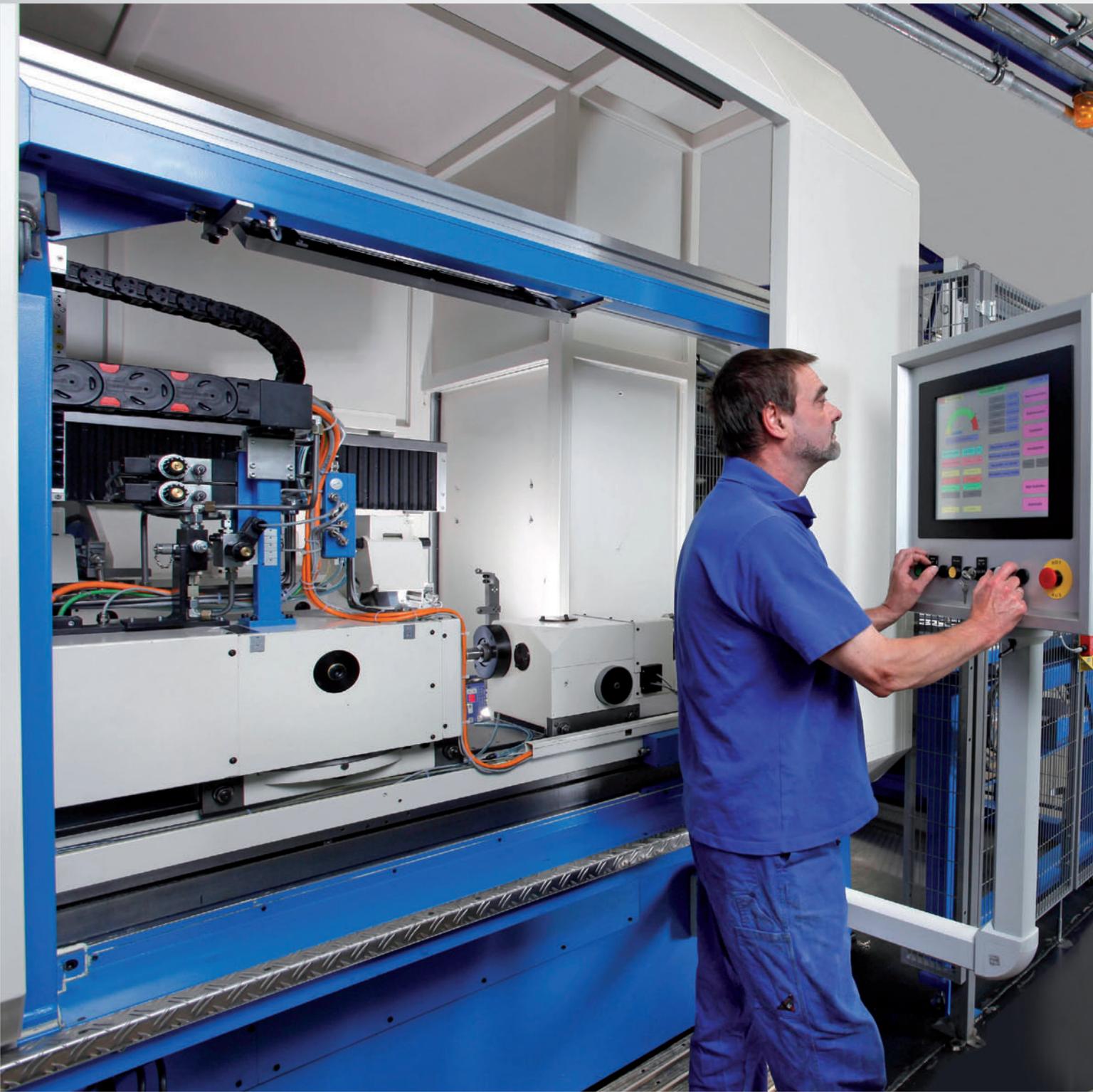


AutoMAB 1500



RailMAB 960







Original BDS core drill from own production

Product quality is not a coincidence

BDS produces core drills at their facility in Mönchengladbach, with all the benefits for users worldwide:

- ▶ High manufacturing precision and competence
- ▶ Use of steels from well-known manufacturers
- ▶ Short-term availability and fast delivery

BDS magnetic core drilling machines and core drilling tools must be considered as a functional unit. Thus, the development of in-house core drill production was expedited right from the beginning in parallel to the production of the machines. This is why the core drills of BDS today are on top worldwide.

The correct tool for any application

The particularly comprehensive range of BDS core drilling tools is justified by the diversity of the applications and materials handled.

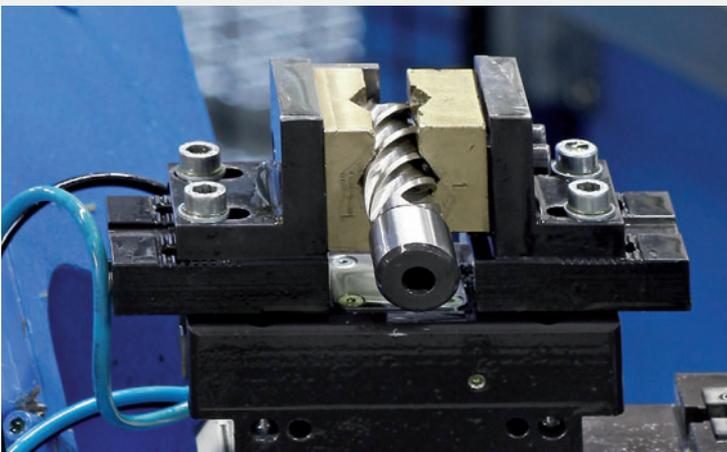
Starting with the HSS core drills of the standard range, the most comprehensive range of tools with short, long and extra-long core drills, there are those with hard coatings, the large group of carbide drills and, as the most recent development, HSS-Co 8 core drills with 8% of cobalt content.

Significant features of the BDS core drill tools are machining of full cuts and the high precision in geometry and concentricity associated with it, as well as optimised removal of shavings, high level of stability using qualitatively high-class types of steel. The VarioPLUS core drills with hard coatings ensure a high degree of wear resistance and long service life as a result of the good surface quality and hardness.

Know-how and technology – the recipe for quality

BDS produces high-performance tools on the most modern high-power grinding stations, which are partially based on in-house construction and program ideas and concepts and have been developed and built particularly for BDS.

The large production capacity set up at the corporate premises forms the basis of the high availability of the BDS core drill tools that are exported worldwide from Germany at present. The experience of our employees having put in many years of service contributes towards ensuring a significant part of the success.



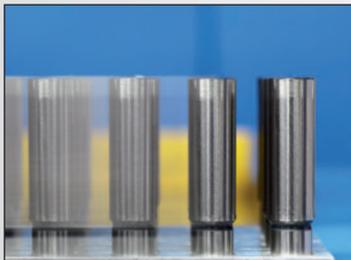
The BDS Core Drill Series

Fully ground core drills having different surface coatings, material designs and machining.



HSS-VarioPLUS series

High-strength fully ground core drills that are machined under the effect of plasma with a hard coating in the range of 2.5 μ . As a result, these tools have considerably longer life and more uniform removal of chips, particularly with long drills. An important aspect for occupational



HSS-Co 8 series

The objective of this most recent product development at BDS was to produce a range of core drills optimised for power with greater heat resistance and better protection against wear. The desired results were achieved by an enhanced proportion of cobalt in special steel. Combined with speed-controlled BDS magnetic core drilling machines, these core drills are adapted for high loads in fine-grained steels and rust-proof materials. The core drills can be reground whilst retaining their positive product characteristics.



HSS-Standard series

The BDS base range. This is where the professional user has the greatest depth of product range at his disposal.

- ▶ Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- ▶ Core drill diameters from 12 mm to 130 mm
- ▶ With Weldon arbor 19 mm or 32 mm

The BDS HSS-Standard range of core drills has long service life and high heat resistance by the use of high-performance steel. Drilling without excessive use of force characterises the tools of this all-round range.



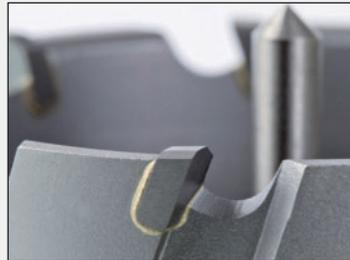
Classification of BDS drill series and appropriate BDS cooling lubricants with materials.

Cutting oil BDS 5000
 Lubrication spray BDS 5200
 Cutting paste BDS 5500
 Cooling lubricant concentrate BDS 6000

	Cutting oil BDS 5000	Lubrication spray BDS 5200	Cutting paste BDS 5500	Cooling lubricant concentrate BDS 6000
Aluminium, non-ferrous metals				
HSS-Standard	•	•		
Steel < 500 N/m²				
HSS-Standard	•	•		
Carbide				•
Carbide PLUS				•
Fine-grain steel < 700 N/m²				
HSS-Co 8	•	•	•	
HSS-VarioPLUS	•	•	•	
Carbide				•
Carbide PLUS				•
Fine-grain steel < 1000 N/m²				
HSS-Co 8	•	•	•	
HSS-VarioPLUS	•	•	•	
Carbide				•
Carbide PLUS				•
Stainless steel, Inox				
HSS-Co 8	•	•	•	
Carbide				•
Carbide PLUS				•
Casting				
HSS-Co 8				•
HSS-Standard				•
Railway rails				
Carbide RAIL				•

Recommended cutting speed

Core drill series	Material	m/min
HSS-Co 8	Fine-grain steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
	Inox	10 – 15
	Casting (depending on type)	15 – 20
HSS-VarioPLUS	Fine-grain steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
HSS-Standard	Aluminium	20 – 30
	Steel	25
	Casting	10 – 20
Carbide	Steel/Fine-grain steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1000 N/m ²	20
	Stainless, Inox	20
Carbide PLUS	Steel/Fine-grain steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1000 N/m ²	20
	Stainless, Inox	20
Carbide RAIL	Railway rails	15 – 20



Carbide series

Hard-tipped core drills have become a successful range of tools worldwide.

BDS provides for the rising demand by expanding its range. Carbide core drills are manufactured as standard with cutting depths of 30 mm, 55 mm, 75 mm and 110 mm, with diameters of 14 mm to 150 mm.



Carbide PLUS series

Core drills of the Carbide PLUS range are coated with hard, wear-resistant material under the effect of plasma in another work step. Tools of this range are used preferably for machining stainless steel and in combination with the BDS 5000 drill emulsion.

Cutting speed:

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

Speed:

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

The Range of BDS Core Drills

All series, cutting depths and drill diameters available.

BDS core drills – professional quality for professional applications

BDS core drills are manufactured on up-to-date CNC-controlled grinding centres.

This is the guarantee for consistent grinding, quality and cutting performance of all BDS drilling tools in the entire product spectrum.

Key applications

BDS drilling tools are optimally adapted to all BDS magnetic core drilling machines and third-party products. There are economically attractive application possibilities in almost all areas of the metalworking industry with particular emphasis on:

- ▶ Structural steelwork engineering
- ▶ Overhead line construction
- ▶ Building construction
- ▶ Tank construction
- ▶ Plant construction
- ▶ Tool construction
- ▶ Pipeline construction
- ▶ Mechanical engineering
- ▶ Railway construction
- ▶ Mining
- ▶ Vehicle construction
- ▶ Shipbuilding
- ▶ Aircraft construction
- ▶ Workshop
- ▶ Production
- ▶ Assembly jobs
- ▶ Repair
- ▶ Upkeeping
- ▶ Service
- ▶ Maintenance

Extensive programme range

BDS core drilling tools are produced in five cutting depths of 35, 35, 55, 75 and 110 mm and with more than 94 different drill diameters from 12 mm to 150 mm.



	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 – 60 mm	12 – 60 mm	12 – 60 mm	12 – 60 mm	12 – 130 mm	12 – 100 mm	20 – 50 mm	1/2" – 2 1/16"

TOOL HOLDERS

19 mm Weldon shank 32 mm Weldon shank Quick-In shank



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 also available in the range of accessories.

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



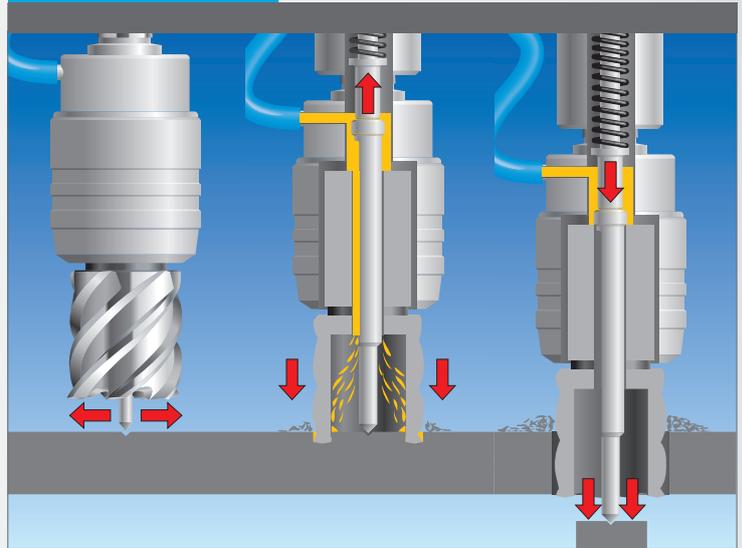
Carbide Series			
HKK	HKL	HKX-L	HKE-L
30 mm	55 mm	75 mm	110 mm
14 – 150 mm	14 – 100 mm	18 – 120 mm	20 – 120 mm

Carbide PLUS Series
HKK-P
30 mm
14 – 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

EJECTOR PIN



Function of the ejector pin

- ▶ Centring: The ejector pin is exactly positioned to the centre punch mark. Switch the magnet on and the machine and tool are in the drilling position.
- ▶ Oiling: By means of the automatic internal lubrication, cutting oil is supplied via the ejector pin to the bit in just the right quantity.
- ▶ Ejecting: In the final stage, the ejector pin, pre-stressed by means of a spring, pushes the core out of the drill hole.



Core Drill Series HSS-Co 8

The drills of this series are characterized by high thermal resistance and wear protection. In combination with speed-controlled BDS magnetic core drilling machines, they are suited for the processing of fine-grain steel and stainless materials. For the processing of stainless steel, BDS recommends the cutting oil BDS 5000.

CORE DRILLS

PAGE

HSS-Co 8 Core drills short
HSS-Co 8 Core drills long

51
51

HSS-Co 8

Core drills made of special steel with a percentage of cobalt for greater heat resistance and wear protection.

HSS-Co 8 Core drills short

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



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 Core drills long

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



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		

EJECTOR PIN FOR KBK-CO, Ø 12 - 60 mm

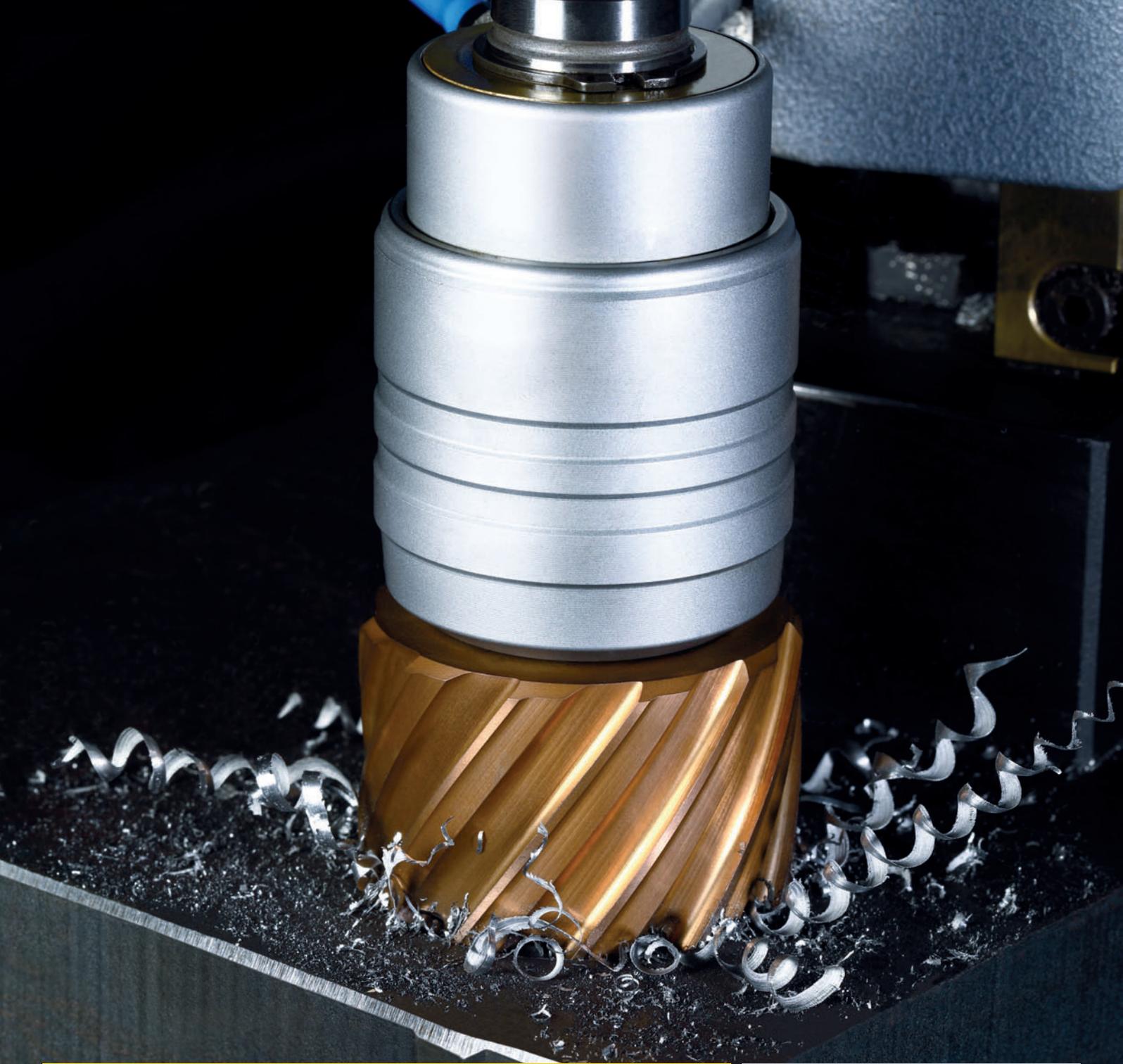
ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-CO, Ø 12 - 60 mm

ORDER NO.

ZAK 100



Core Drill Series HSS-VarioPLUS

Fully ground core drills made of high-speed steel with carbide coating. Highly economic due to increased service life, more work safety due to good chip flow, especially in the case of long core drills. BDS recommends the high-performance cutting oil BDS 5000.

CORE DRILLS

PAGE

HSS-VarioPLUS Core drills short

53

HSS-VarioPLUS Core drills long

53

HSS-VarioPLUS

Fully ground core drills made of high-speed steel, with carbide coating, high wear protection, very good chip flow.

HSS-VarioPLUS Core drills short

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



HSS-VarioPLUS SERIE

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 Core drills long

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



HSS-VarioPLUS SERIE

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



Core Drill Series HSS-Standard

The basic core drill assortment for professional applications. Fully ground core drills made of high-speed steel on CNC-controlled grinding centres, with good chip flow, drilling with little effort. For horizontal work, BDS recommends the high-performance lubrication spray BDS 5200.

CORE DRILLS

PAGE

HSS-Standard Core drills short	55
HSS-Standard Core drills long	56
HSS-Standard Core drills extra long	57
HSS-Standard Core drills short, inch	57

HSS-Standard

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills short

- > 30 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 Core drills short

- > 30 mm cutting depth
- > 32 mm Weldon shank (1 $\frac{1}{4}$ "



HSS-STANDARD SERIES

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

EJECTOR PIN FOR KBK, Ø 12 - 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBK, Ø 61 - 130 mm

ORDER NO.

ZAK 090

HSS-Standard

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills long

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



HSS-STANDARD SERIES

Ø mm	ORDER NO.
12	KBL 012
13	KBL 013
14	KBL 014
15	KBL 015
16	KBL 016
17	KBL 017
17.5	KBL 175
18	KBL 018
19	KBL 019
19.5	KBL 195
20	KBL 020
21	KBL 021
22	KBL 022
23	KBL 023
24	KBL 024
25	KBL 025
26	KBL 026
27	KBL 027
28	KBL 028
29	KBL 029
30	KBL 030
31	KBL 031
32	KBL 032
33	KBL 033
34	KBL 034
35	KBL 035

Ø mm	ORDER NO.
36	KBL 036
37	KBL 037
38	KBL 038
39	KBL 039
40	KBL 040
41	KBL 041
42	KBL 042
43	KBL 043
44	KBL 044
45	KBL 045
46	KBL 046
47	KBL 047
48	KBL 048
49	KBL 049
50	KBL 050
51	KBL 051
52	KBL 052
53	KBL 053
54	KBL 054
55	KBL 055
56	KBL 056
57	KBL 057
58	KBL 058
59	KBL 059
60	KBL 060

Standard Core drills long

- > 55 mm cutting depth
- > 32 mm Weldon shank ($1 \frac{1}{4}$ "



HSS-STANDARD SERIES

Ø mm	ORDER NO.
61	KBL 061
62	KBL 062
63	KBL 063
64	KBL 064
65	KBL 065
66	KBL 066
67	KBL 067
68	KBL 068
69	KBL 069
70	KBL 070
71	KBL 071
72	KBL 072
73	KBL 073
74	KBL 074
75	KBL 075
76	KBL 076
77	KBL 077
78	KBL 078
79	KBL 079
80	KBL 080

Ø mm	ORDER NO.
81	KBL 081
82	KBL 082
83	KBL 083
84	KBL 084
85	KBL 085
86	KBL 086
87	KBL 087
88	KBL 088
89	KBL 089
90	KBL 090
91	KBL 091
92	KBL 092
93	KBL 093
94	KBL 094
95	KBL 095
96	KBL 096
97	KBL 097
98	KBL 098
99	KBL 099
100	KBL 100

EJECTOR PIN FOR KBL, Ø 12 - 60 mm

ORDER NO.

ZAK 100

EJECTOR PIN FOR KBL, Ø 61 - 100 mm

ORDER NO.

ZAK 120

HSS-Standard, inch

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills extra long

- > 110 mm cutting depth
- > 19 mm Weldon shank ($\frac{3}{4}$ "



HSS-Standard Core drills short, inch

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



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 SERIES INCH

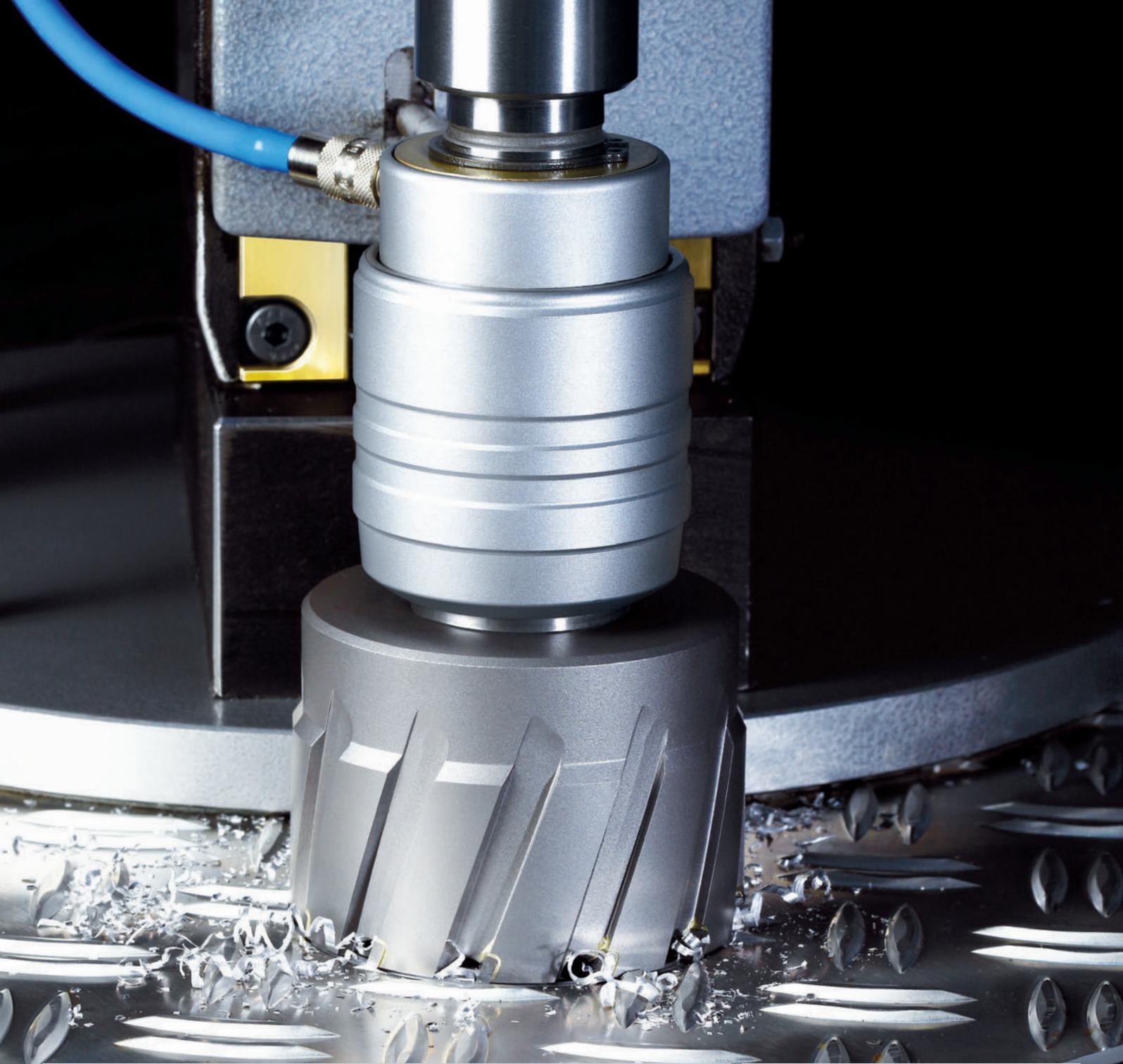
Ø inch	Ø mm	ORDER NO.
$\frac{1}{2}$ "	12.700	KBK-Z $\frac{1}{2}$
$\frac{9}{16}$ "	14.288	KBK-Z $\frac{9}{16}$
$\frac{5}{8}$ "	15.875	KBK-Z $\frac{5}{8}$
$\frac{11}{16}$ "	17.463	KBK-Z $\frac{11}{16}$
$\frac{3}{4}$ "	19.050	KBK-Z $\frac{3}{4}$
$\frac{13}{16}$ "	20.638	KBK-Z $\frac{13}{16}$
$\frac{7}{8}$ "	22.225	KBK-Z $\frac{7}{8}$
$\frac{15}{16}$ "	23.813	KBK-Z $\frac{15}{16}$
1"	25.400	KBK-Z 1
$1 \frac{1}{16}$ "	26.988	KBK-Z $1 \frac{1}{16}$
$1 \frac{1}{8}$ "	28.575	KBK-Z $1 \frac{1}{8}$
$1 \frac{3}{16}$ "	30.136	KBK-Z $1 \frac{3}{16}$
$1 \frac{1}{4}$ "	31.750	KBK-Z $1 \frac{1}{4}$
$1 \frac{5}{16}$ "	33.338	KBK-Z $1 \frac{5}{16}$
$1 \frac{3}{8}$ "	34.925	KBK-Z $1 \frac{3}{8}$
$1 \frac{7}{16}$ "	36.513	KBK-Z $1 \frac{7}{16}$
$1 \frac{1}{2}$ "	38.100	KBK-Z $1 \frac{1}{2}$
$1 \frac{9}{16}$ "	39.688	KBK-Z $1 \frac{9}{16}$
$1 \frac{5}{8}$ "	41.276	KBK-Z $1 \frac{5}{8}$
$1 \frac{11}{16}$ "	42.863	KBK-Z $1 \frac{11}{16}$
$1 \frac{3}{4}$ "	44.450	KBK-Z $1 \frac{3}{4}$
$1 \frac{13}{16}$ "	46.038	KBK-Z $1 \frac{13}{16}$
$1 \frac{7}{8}$ "	47.625	KBK-Z $1 \frac{7}{8}$
$1 \frac{15}{16}$ "	49.213	KBK-Z $1 \frac{15}{16}$
2"	50.800	KBK-Z 2
$2 \frac{1}{16}$ "	52.388	KBK-Z $2 \frac{1}{16}$

EJECTOR PIN FOR KEL, ø 20 – 50 mm

ORDER NO.	VERSION
ZAK 275	Two-part version

EJECTOR PIN FOR KBK-Z, ø $\frac{1}{2}$ " – $2 \frac{1}{16}$ "

ORDER NO.
ZAK 075



Core Drill Series Carbide

Carbide-tipped BDS core drills. Series with cutting depths of 30 mm, 35 mm, 55 mm, 75 mm and 110 mm and almost gapless range of diameters from 14 mm to 150 mm.

For the processing of stainless steel and non-ferrous metals, BDS recommends the high-performance cooling lubricant concentrate BDS 6000.

CORE DRILLS	PAGE
Carbide core drills short	59
Carbide core drills long	60
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Carbide core drills F (Quick-in holder)	63

Carbide

Carbide-tipped core drills.

Carbide core drills short

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



CARBIDE SERIES

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

Carbide core drills short

- > 30 mm cutting depth
- > 32 mm Weldon shank ($1\frac{1}{4}$ "



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.

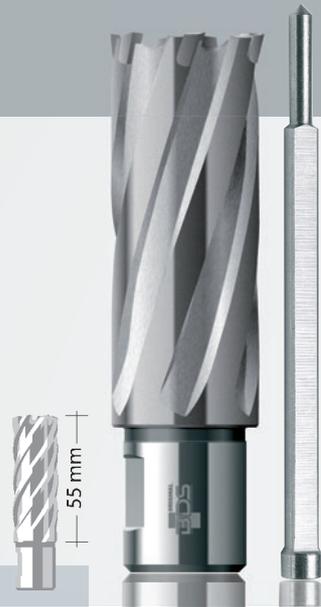
ZAK 090

Carbide

Carbide-tipped core drills.

Carbide core drills long

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



CARBIDE SERIES

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

Carbide core drills lang

- > 55 mm Cutting depth
- > 32 mm Weldon shank ($1 \frac{1}{4}$ "



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 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 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 core drills extra long

- > 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.
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 | 2-part for core drill cutting depth 75 mm ø 18 - 60 |
| ZAK 245 | 2-part for core drill cutting depth 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 core drills short

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



CARBIDE SERIES-PLUS

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		

EJECTOR PIN FOR HKK-P Ø 14 - 60 mm

ORDER NO.

ZAK 075

Carbide RAIL

Carbide-tipped core drills for rail core drilling machines.

Carbide RAIL core drills

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



CARBIDE SERIES-RAIL

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-R, Ø 17 - 36 mm

ORDER NO.

ZAK 075

Quick-In HSS-Co 8-F

Core drills made from special steel with a high percentage of cobalt for higher heat resistance and protection from wear. For Quick-in tool holder system.

HSS-Co 8-F core drills short

- > 35 mm cutting depth
- > 18 mm shank for Quick-in tool holder 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		

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

ORDER NO.

ZAK 096

Quick-In Carbide-F

Carbide-tipped core drills for Quick-in tool holder system.

Carbide-F core drills short

- > 35 mm cutting depth
- > 18 mm shank for Quick-in tool holder system



CARBIDE SERIES-F

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 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.

Set of core drills

- > 30 mm und 55 mm cutting depth
- > 19 mm Weldon shank ($\frac{3}{4}$ "



HSS-Standard core drills short



CORE DRILLS BOX

ORDER NO.	CONTENTS
KBK Box Standard	2 x KBK 014
	2 x KBK 018
	1 x KBK 022

HSS-VarioPLUS core drills short



CORE DRILLS BOX

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

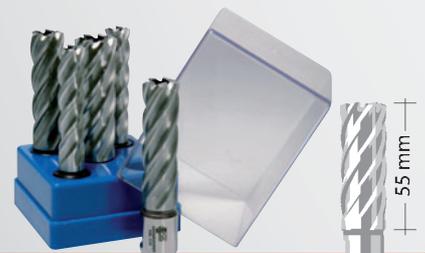
Carbide core drills short



CORE DRILLS BOX

ORDER NO.	CONTENTS
HKK Box	2 x HKK 014
	2 x HKK 018
	1 x HKK 022

HSS-Standard core drills long



CORE DRILLS BOX

ORDER NO.	CONTENTS
KBL Box Standard	2 x KBL 014
	2 x KBL 018
	1 x KBL 022

HSS-VarioPLUS core drills long



CORE DRILLS BOX

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

Carbide PLUS core drills short



CORE DRILLS BOX

ORDER NO.	CONTENTS
HKK-P Box	2 x HKK-P 014
	2 x HKK-P 018
	1 x HKK-P 022

Core Drill Cassette

Six BDS core drills of the most common sizes in a solid metal cassette.



Set of core drills

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

HSS-Co 8 core drills short



CORE DRILL CASSETTE

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

HSS-Standard core drills short



CORE DRILL CASSETTE

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

HSS-VarioPLUS core drills short



CORE DRILL CASSETTE

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

Using Proper Accessories

The BDS PowerWORKER and the StarterKIT.

Accessories for magnetic core drill machines from BDS makes work easier

The functional, universally applicable BDS PowerWORKER tool, which is offered in the BDS Starter-KIT together with one litre of high-performance cutting oil and the KBK core drill box with 5 core drills, is indispensable in the workshop and is offered as a money-saving package.

PowerWORKER

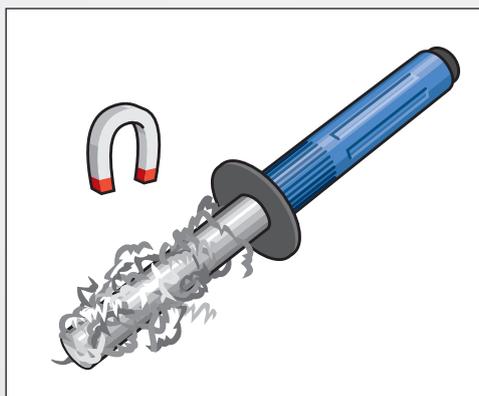
The BDS PowerWORKER cleans up with all magnetic drilling chips.

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.

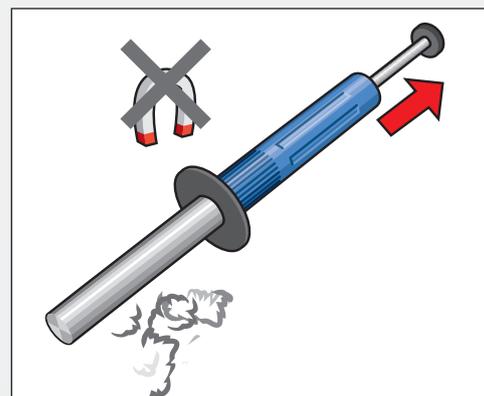
POWERWORKER

ORDER NO.

POW 100



Iron chips are collected together easily with the powerful permanent magnet of the PowerWORKER.



The chips can then be disposed of in a contact-less manner by demagnetisation.



The StarterKIT, professional choice for your drilling application

Begin with the proper base equipment for each magnetic core drilling machine. As a consolidated package at a particularly attractive price.

- ▶ Five short core drills of the most common diameters: 14, 18 and 22 mm
- ▶ 1 litre of High-performance cutting oil BDS 5000
- ▶ and the BDS PowerWORKER

BDS StarterKIT

ORDER NO.

ZST 100

Contents:

- 1 Standard core drill box with
- 2 KBK – \varnothing 14 mm
- 2 KBK – \varnothing 18 mm
- 1 KBK – \varnothing 22 mm
- 1 | High-performance cutting oil BDS 5000
- 1 BDS PowerWORKER

COMBI TOOL SET

ORDER NO. STANDARD/SIZE

ZGK 001

BDS Combi Tool Set, 8 pcs.

Neat, solid steel box equipped with twist drills, taps and countersinks for making threaded holes from M8 to M16

- | | |
|--------------------|----------------------------------|
| 1 Twist drill | DIN 338, \varnothing 6.8 mm |
| 1 Twist drill | DIN 338, \varnothing 8.5 mm |
| 1 Twist drill | DIN 338, \varnothing 10.2 mm |
| 1 Machine tap each | |
| | DIN 371, M8 |
| | DIN 376, M10, M12, M16 |
| 1 Countersink | DIN 335 |
| | Form C 90° \varnothing 20.5 mm |



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.



Drilling, countersinking and thread cutting with a magnetic core drilling machine from BDS. Quickly, easily and with high precision.

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.

THREAD CUTTING SYSTEMS

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



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

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

OVERVIEW

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 each	
GSE 205 – GSE 222 each	
GSE 314 – GSE 330 each	
GSS 205 – GSS 222 each	
GSS 312 – GSS 330 each	
GSS 420 – GSS 442 each	
GSE 100 Set of quick-change inserts size 1, M3 – M14	
GSE 200 Set of quick-change inserts size 2, M5 – M24	
GSE 300 Set of quick-change inserts size 3, M14 – M30	

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!



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

from ZGA 022 with 32 mm Weldon shank ($1\frac{1}{4}$ "

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 525	MAB 485	Order No.	Quick-change drill chuck	Thread	Order No.	ø x square	Order No.	ø x square
				GSW 222	Size 2 MK 2	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8/M10	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8.0	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9.0	GSS 214	11 / 9.0
						M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0
				GSW 331	Size 1 MK 3	M3	GSE 103	3.5 / 2.7		
						M4	GSE 104	4.5 / 3.4		
						M5/M6	GSE 105	6 / 4.9		
						M8	GSE 108	8 / 6.2		
						M10	GSE 110	10 / 8.0		
						M12	GSE 112	9 / 7.0		
						M14	GSE 114	11 / 9.0		
				GSW 332	Size 2 MK 3	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9	GSS 214	11 / 9
						M16	GSE 216	12 / 9	GSS 216	12 / 9
						M18	GSE 218	14 / 11	GSS 218	14 / 11
						M20	GSE 220	16 / 12	GSS 220	16 / 12
					not suitable for MAB 525	M22/M24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
				GSW 333	Size 3 MK 3	M12			GSS 312	9 / 7.0
						M14	GSE 314	11 / 9	GSS 314	11 / 9
						M16	GSE 316	12 / 9	GSS 316	12 / 9
						M18	GSE 318	14 / 11	GSS 318	14 / 11
						M20	GSE 320	16 / 12	GSS 320	16 / 12
						M22/M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
						M27	GSE 327	20 / 16	GSS 327	20 / 16
						M30	GSE 330	22 / 18	GSS 330	22 / 18
				GSW 442	Size 2 MK 4	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8.0	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9	GSS 214	11 / 9
						M16	GSE 216	12 / 9	GSS 216	12 / 9
						M18	GSE 218	14 / 11	GSS 218	14 / 11
						M20	GSE 220	16 / 12	GSS 220	16 / 12
						M22/24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
				GSW 433	Size 3 MK 4	M12			GSS 312	9 / 7.0
						M14	GSE 314	11 / 9	GSS 314	11 / 9
						M16	GSE 316	12 / 9	GSS 316	12 / 9
						M18	GSE 318	14 / 11	GSS 318	14 / 11
						M20	GSE 320	16 / 12	GSS 320	16 / 12
						M22/24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
						M27	GSE 327	20 / 16	GSS 327	20 / 16
						M30	GSE 330	22 / 18	GSS 330	22 / 18
				GSW 444	Size 4 MK 4	M20			GSS 420	16 / 12
						M22/24			GSS 422	18 / 14.5
						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

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.



HARD PROTECTIVE CASE

ORD. NO. SUITABLE FOR

ZHK 100 MAB 100, MAB 150

ZHK 400 MAB 455, MAB 485, MAB 525

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

ORD. NO. SUITABLE FOR

ZPK 001 EKF 300, EKF 450, EKF 452

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

ORD. NO. SUITABLE FOR

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.



CARRY CASE ON WHEELS

ORD. NO. SUITABLE FOR

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.



The robust carry case on wheels.

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



1. Connect adapter to drill chuck.



2. Place drill chuck in direct arbor.



3. Ready for use with twist drill.

For magnetic core drilling machines with direct arbor
19 mm Weldon ($\frac{3}{4}$ ")

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



ADAPTER FOR DRILL CHUCKS

ORDER NO.

ZAP 100
Weldon shank 19 mm ($\frac{3}{4}$ ") to $\frac{1}{2}$ " x 20 NF



GEAR RIM DRILL CHUCK

ORD. NO. INTERNAL THREAD CLAMP SIZE

ZBI 113	$\frac{1}{2}$ " x 20 NF	1 - 13 mm
ZBI 116	$\frac{1}{2}$ " x 20 NF	2.5 - 16 mm



QUICK-ACTION DRILL CHUCK

ORD. NO. INTERNAL THREAD CLAMP SIZE

ZSI 113	$\frac{1}{2}$ " x 20 NF	1 - 13 mm
ZSI 116	$\frac{1}{2}$ " x 20 NF	3 - 16 mm



1. Connect taper drift to drill chuck.



2. Place drill chuck in MT arbor.



3. Ready for use with twist drill.

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

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



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

ORD. NO. INTERNAL THREAD CLAMP SIZE

ZBK 113	DIN 238-B16	1 - 13 mm
ZBK 116	DIN 238-B16	2.5 - 16 mm



QUICK-ACTION DRILL CHUCK

ORD. NO. INTERNAL THREAD CLAMP SIZE

ZSB 113	DIN 238-B16	1 - 13 mm
ZSB 116	DIN 238-B16	3 - 16 mm



KEY FOR GEAR RIM DRILL CHUCK

ORDER NO.

ZEZ 113
ZEZ 116



CHIP PROTECTION

ORD. NO. MACHINE

ZSS 050	MAB 100 – MAB 525
ZSS 500	MAB 825 – MAB 855



DRILL DRIFT DIN 228

ORD. NO. SIZE DIN STANDARD

ZAS 002	MK 2	DIN 228
ZAS 003	MK 3	DIN 228

SAFETY CHAIN

ORDER NO.

ZSK 001

PUMP BOTTLE

ORDER NO.

ZKP 100



Tool holders and adapters

For BDS core drills with Weldon shanks - suitable for adaptation to external systems.

Tool holders for BDS core drills with Weldon arbor. Three systems are available; they allow for a friction-locked, comfortable and secure connection between the core drill and the magnetic core drilling machine.

Tool holder for BDS core drills with Weldon shanks 19 mm ($\frac{3}{4}$ "

Tool holder for BDS core drills with Weldon shanks 19 mm ($\frac{3}{4}$ " and 32 mm ($1\frac{1}{4}$ "

Tool holder for BDS core drills with 19 mm Weldon shanks ($\frac{3}{4}$ " and 32 mm ($1\frac{1}{4}$ "



KEYLESS QUICK-CHANGE DRILL CHUCK SYSTEM

ORDER NO. SPINDLE HOLDER

ZSS 200 MK 2

ZSS 300 MK 3

With automatic internal lubrication for core drills with Weldon shank 19 mm ($\frac{3}{4}$ "

With hose and quick acting coupling. Quick tool change without any chuck key.

INDUSTRIAL ARBOR WITH MANUAL INTERNAL LUBRICATION

ORDER NO. SPINDLE HOLDER

ZIA 219-M MK 2

ZIA 319-M MK 3

ZIA 419-M MK 4

For core drills with 19 mm Weldon shank ($\frac{3}{4}$ "

ZIA 332-M MK 3

ZIA 432-M MK 4

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

INDUSTRIAL ARBOR WITH AUTOMATIC INTERNAL LUBRICATION

ORDER NO. SPINDLE HOLDER

ZIA 219-KN MK 2

ZIA 319-KN MK 3

ZIA 419-KN MK 4

For core drills with 19 mm Weldon shank ($\frac{3}{4}$ "

ZIA 332-KN MK 3

ZIA 432-KN MK 4

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

With hose and quick acting coupling.



REDUCING BUSH DIN 2185

ORDER NO. OUTSIDE INSIDE

ZRH 210 MK 2 MK 1

EXTENSION BUSH DIN 2178

ORDER NO. OUTSIDE INSIDE

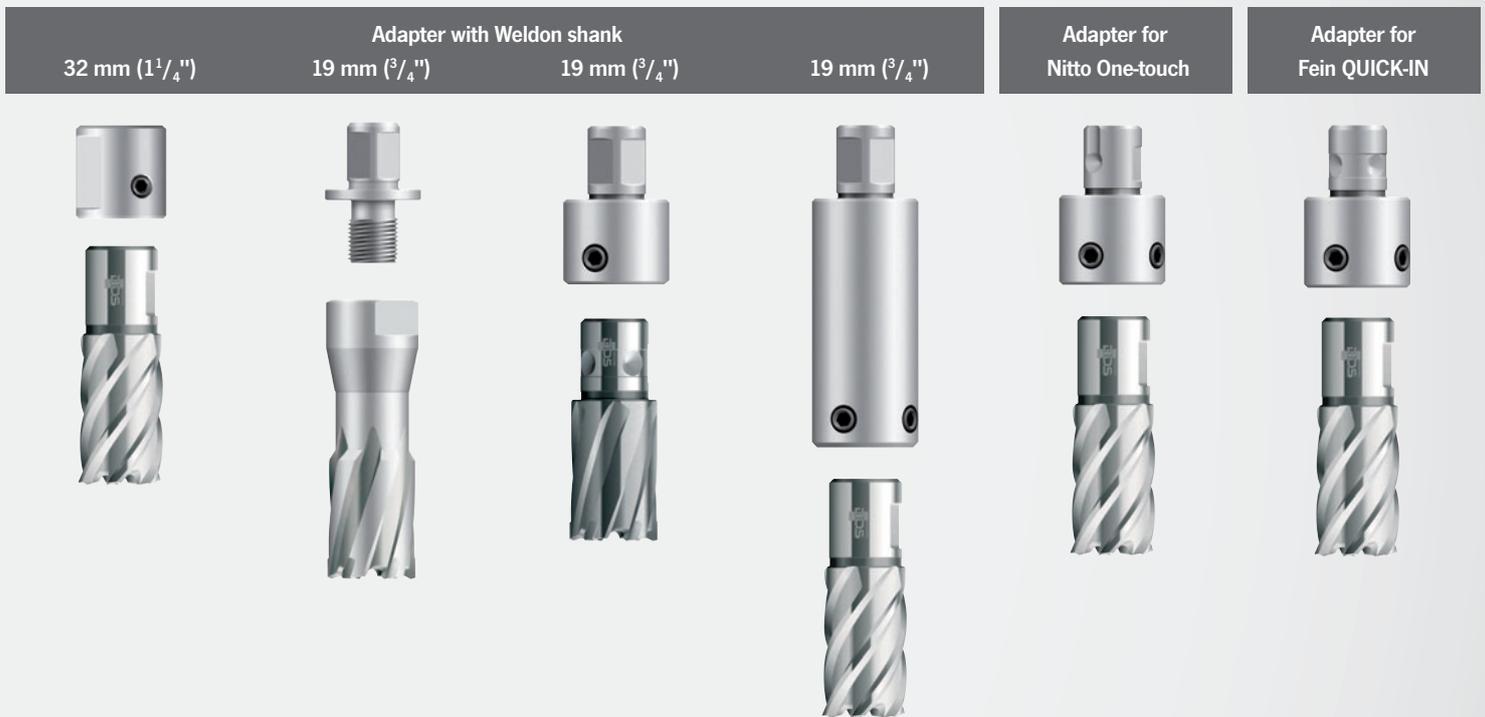
ZVH 220 MK 2 MK 2

ZVH 230 MK 2 MK 3

ZVH 320 MK 3 MK 2

ZVH 330 MK 3 MK 3

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



ADAPTER ORDER NO.	ADAPTER ORDER NO.	ADAPTER ORDER NO.	EXTENSION ORDER NO.	ADAPTER ORDER NO.	ADAPTER ORDER NO.
ZAP 200 from 32 mm Weldon shank (1 1/4") to 19 mm Weldon shank (3/4")	ZAF 002 For fine core drills with internal thread M18 x 6 P1.5 incl. 1 ejector pin ZAK125	ZAF 003 For fine core drills with QUICK-IN shank incl. 1 ejector pin ZAK 115	ZAP 300 80 mm, 19 mm Weldon shanks (3/4"), ncl. 1 ejector pin ZAK 080	ZAF 005 With Nitto one-touch holder for core drills with Weldon shanks 19 mm (3/4") each incl. 1 ejector pin ZAK 107 and 125	ZAF 004 With Quick-in holder for core drills with Wel- don shanks 19 mm (3/4") each incl. 1 ejector pin ZAK 107 and 125



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.



ZRO 250



ZRO 500

TUBE CLAMPING DEVICE

ORDER NO.

ZRO 250

ZRO 500

ZRO 250: for MAB 455, 485, 525

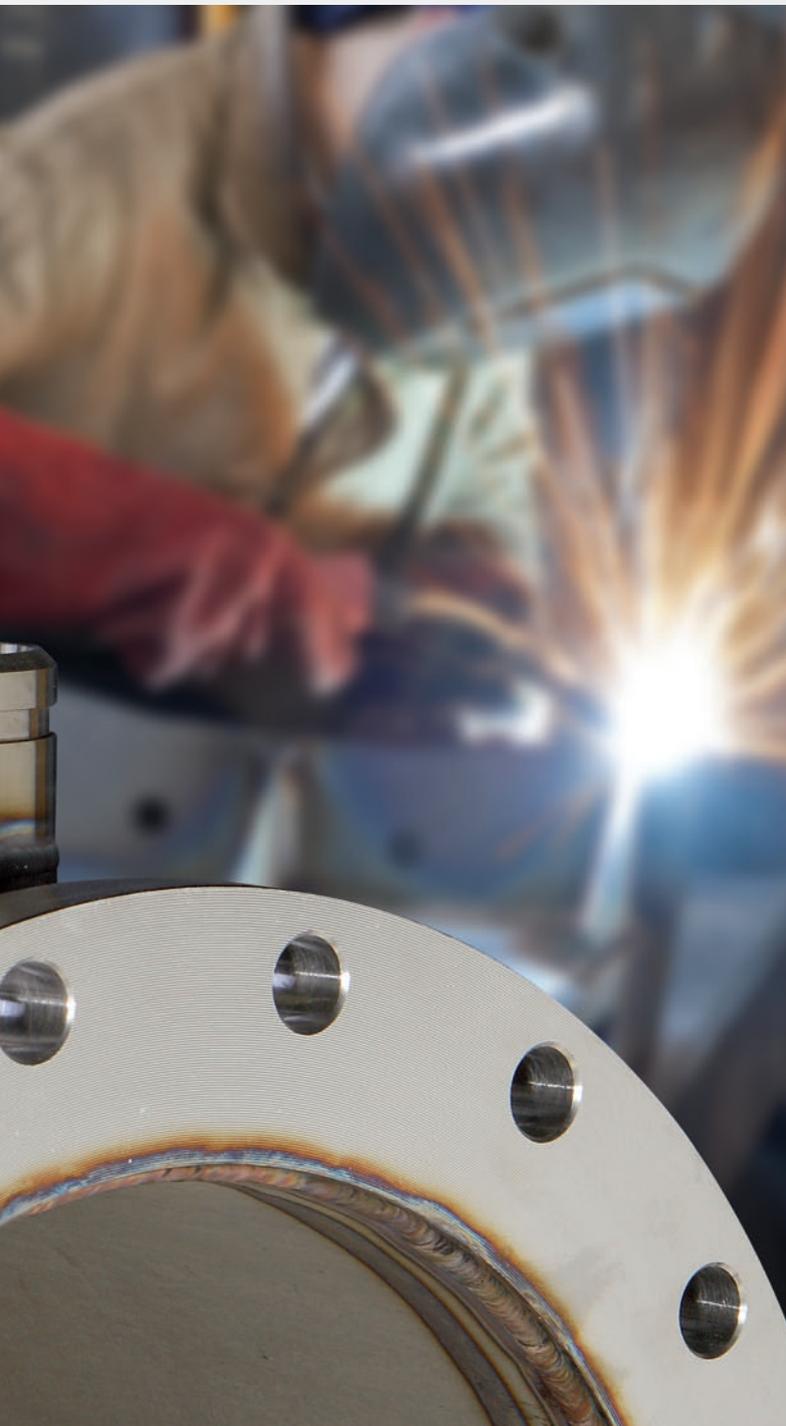
For tube \varnothing : 80 – 250 mm

Chain length: 900 mm

ZRO 500: for MAB 825, 845, 855

For tube \varnothing : 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.

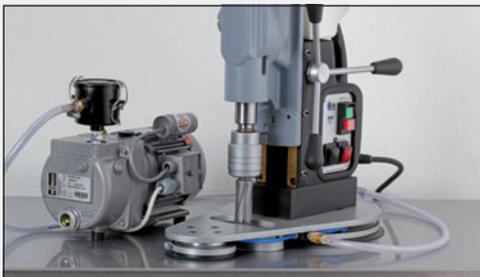
ZAV 400

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 260 mm, long hole: 50 x 120 mm

ZAV 400
Vacuum clamping device
for smooth surfaces



ZAV 300
Vacuum clamping device
for channelled and
gusset plates



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 \varnothing 300 mm.

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.



Magnetic pillar



Industrial pillar



MobilCLAMP – mobile working with magnetic core drilling machines

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.



MAGNETIC PILLARS

ORDER NO.

MBS 300

For commercially available hand drills with a collar diameter of 43 mm, stroke 180 mm.



INDUSTRIAL PILLAR

ORDER NO.

ZBS 100

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



PRISM VICE

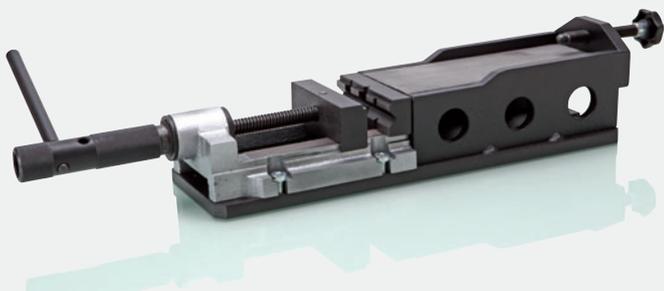
ORDER NO.

ZST 300 Prism vice

ZTN 100 Screw for T slots

ZSM 100 Hexagon nut

Jaw width: 100 mm, clamping range: 100 mm



CLAMPING DEVICE MobilCLAMP

ORDER NO.

JAW WIDTH

ZMC 180

100 cm, 80 mm clamping width

ZMC 300

Base frame for clamping device

Mechanical clamping device for magnetic core drilling machines.



MAGNETIC CLAMPING DEVICE MagnetCLAMP

ORDER NO.

CLAMPING RANGE

ZMS 500/230V

100 – 800 mm

ZMS 500/120V

100 – 800 mm

Magnetic clamping device, the versatile mounting aid.



The best working results – for the nature! High-performance lubricants and cleaning spray are aligned perfectly to the respective application. These are environment-friendly products.

Particularly recommended in outdoor application: BDS high-performance cutting oil or high-performance cooling lubricant concentrate are bio-degradable without leaving any residues and toxicologically harmless.

However, at the same time, they are highly effective for the desired lubricating and cooling performance. In addition, the BDS 6000 concentrate can be mixed with water in the ratio 1:10 and is thus, high-yield.

High-performance cutting oil **BDS 5000**



Pure vegetable oil that is not a hazardous good in the context of transport regulations. The base materials used are not listed in the catalogue of substances hazardous to water. BDS 5000 is not subject to labelling.

- ▶ Organic basic 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

High-performance lubrication spray **BDS 5200**



Suitable for working under special conditions (overhead and horizontal) and also for high-alloy materials. Foam-like spray with very high adhesive force.

Advantages: Exact dosage of the grease 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



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.

Cooling lubricant concentrate **BDS 6000**



For high demands based on synthetic raw materials.

- ▶ Miscible with water, biostable and mild smelling
- ▶ Improves the core drill service life
- ▶ Toxicologically harmless, water hazard class 1

Spray cleanser **BDS 1000**



Optimal for repair and installation. The spray cleanser BDS 1000 cleans and degreases all metals. In contrast to conventional thinners, BDS 1000 evaporates without leaving any residues behind.

Operating materials

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



LUBRICANTS AND AUXILIARY MATERIAL

ORD. NO.	NAME	CONTENTS
ZHB 001	BDS 6000 Cooling lubricant concentrate	1-litre can
ZHS 005	BDS 5000 Cutting oil	5-litre can
ZHS 006	BDS 5000 Cutting oil	1-litre can
ZHS 400	BDS 5200 Lubrication spray	1 x 400 ml can
ZHS 406	BDS 5200 Lubrication spray	6 x 400 ml can
ZHS 412	BDS 5200 Lubrication spray	12 x 400 ml can
ZHS 550	BDS 5500 Cutting paste	1000 g can
ZSR 100	BDS 1000 Spray cleanser	500 ml can

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.



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 borehole.





Bevelling made easy

BDS offers a range of professional machines for easy and perfect processing of milling edges: For the preparation of welding seams with the fully automatic AutoCUT 500 or the manually guided SKF 25. The machines of the EKF series are ideally suited for deburring and making visible edges and chamfers, also on internal and external radii.

MACHINE	PAGE
SKF 25	84 – 85
AutoCUT 500	86 – 87
EKF 300.3	88 – 89
EKF 450.3	88 – 89
EKF 452.3	88 – 89

SKF 25 – good preparation is everything

Good work preparation, good results. This universal bevel edge milling machine with integrated tube enables perfect weld preparation.

SKF 25 - This new hand-guided BDS machine is ideally suited for easy and quick preparation of welded seams. On account of its low weight of 22 Kg, it is easy to handle and can be guided exactly and easily with smooth-running rollers. The end result is uniformly milled edges for perfect welded seams.

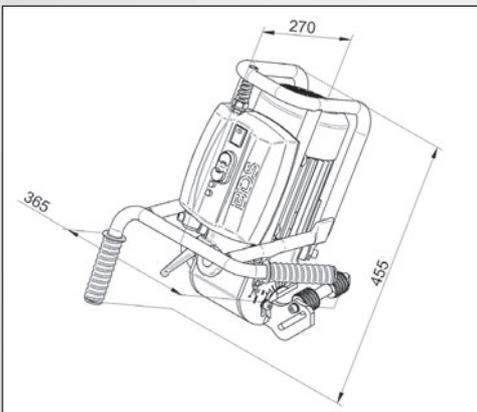
The SKF 25 of BDS is suitable for machining

- ▶ normal steel
- ▶ stainless steel
- ▶ aluminium
- ▶ non-ferrous metals

The chamfer angle can be adjusted continuously from 15° to 60° with a maximum chamfer width of 15 mm.



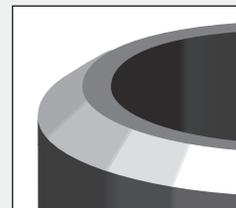
Large guide rollers and a continuous angle adjustment from 15 to 60° render the system practical.



Technical drawing



Edge processing of pipes in a vertical position.



Milling edge

The advantages of the SKF 25

- > Wide chamfers – up to 15 mm
- > Continuous angle adjustment – from 15 to 60°
- > Handy – with ergonomic handle arrangement
- > Easily guided – with guide rollers



SPECIFICATION

	Motor output:	1.1 kW
	Voltage:	220-240 V AC, 50-60 Hz
	Feed:	manual
	Speed range 1:	2850 min ⁻¹
	Chamfer width:	15 mm
	Angle adjustment:	15 – 60° continuously
	Safety:	automatic overload cutout / restart lockout
	Weight:	22 kg
	Tools:	Arbor milling cutter, double-row, with 10 sintered carbide reversible disks

ACCESSORIES

ORDER NO.

Arbor milling cutter

ZFR 250 1 pc.

Carbide reversible disks are not included in delivery. Please clearly order them as an extra.

Carbide reversible disks

SHM 800 1 pc.

SHM 400-E 1 pc.

1 set = 10 carbide reversible disks



Arbor milling cutter ZFR 250



Carbide reversible disk



Angle adjustment 15 - 60°

ORDER NO.

SKF 25 / 230 Volt

SKF 25 / 110 Volt

SCOPE OF DELIVERY

1 Bevel edge milling machine

1 Carry case

1 Arbor milling cutter ZFR 250 with
10 carbide reversible disks

SHM 800

1 Offset screwdriver SW 8

1 Operating manual

1 Screwdriver TX 15

AutoCUT 500

Automatic edge processing for weld preparation – simple and secure handling with guide rails on both sides.

AutoCUT 500 – This BDS machine is perfectly suited for straightforward and quick weld preparation. The system is characterised by easy handling and evenly milled sides for a perfect weld.

Bevel edge milling with automated and continually adjustable speed rate: fast, flexible and variable milling angle adjustment.

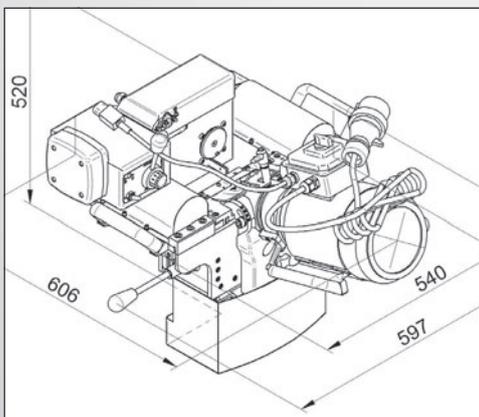
The guide rails make handling the AutoCUT 500 especially simple and secure. The milling angle can be continuously adjusted from 15 to 60°.

Advantages of the BDS AutoCUT 500

- ▶ Easy, safe handling
- ▶ No restrictions of the working length
- ▶ Work without carriage, i.e., independent of floor conditions
- ▶ Cutting up to a plate thickness of 40 mm
- ▶ Face milling head with carbide reversible plates



The AutoCUT 500 with automatic forward and return



Technical drawing



AutoCUT 500 guide rails



Chamfer width 30 mm max.



Visit our homepage to experience
live the AutoCUT demo video.
[http://www.kernbohrer.de/downloads
/downloads.html#tab_4](http://www.kernbohrer.de/downloads/downloads.html#tab_4)

The advantages of AutoCUT 500

- > Fully automatic – forward and return motion via guide rollers
- > Powerful – Milling up to a plate thickness of 40 mm, unlimited working length
- > Guided on the plate, independent of floor conditions



SPECIFICATION

	Motor output:	1.1 kW
	Voltage:	380 V
	Weight:	50 kg
	Feed:	Automatic, continuously adjustable up to a maximum of 500 mm/min
	Speed range 1:	2750 min ⁻¹
	Chamfer width:	max. 30 mm
	Angle adjustment:	15 – 60° continuously
	Milling cutter:	Arbor milling cutter with 6 sintered carbide reversible disks

ACCESSORIES

ORDER NO.

Arbor milling cutter
ZFR 500 1 pc.

Carbide reversible disks are not included in
delivery. Please clearly order them as an extra.

Carbide reversible disks
SHM 400 1 pc.
SHM 400-E 1 pc.

1 set = 6 carbide reversible disks SHM 400



Arbor milling cutter ZFR 500



Carbide reversible disk SHM 400

ORDER NO.

AutoCUT 500 / 380 Volt

SCOPE OF DELIVERY

1 AutoCUT 500	1 Jaw spanner M 19
1 Arbor milling cutter with 6 carbide reversible disks SHM 400	1 Screwdriver with T-handle SW 5
1 Operating manual	1 Offset screwdriver SW 6, SW 8, SW 10 each
1 Guide rail on both left and right side	1 Screwdriver TX 15

EKF 300.3 – EKF 450.3 – EKF 452.3

Deburring and chamfering machines for quick and precise edge processing 20°, 45° or R 2.5 mm.

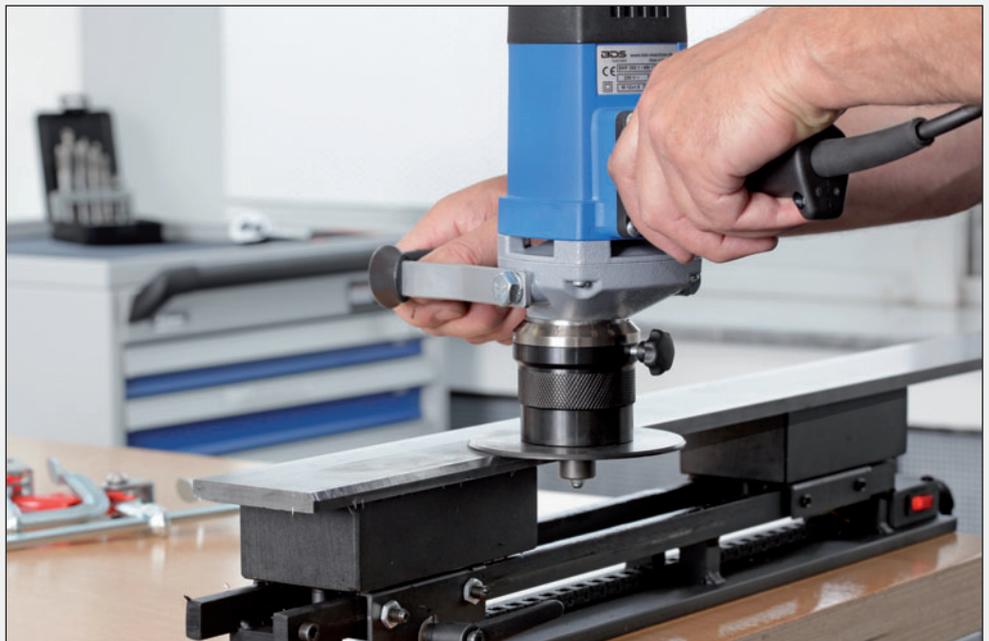
Deburring and chamfering with machines from the EKF series. The BDS deburring and chamfering machine can be universally used for industry and craft: In mould making, boiler construction, plant construction, mechanical engineering and for sheet metal working.

The EKF machine is ideally suited for deburring and chamfering of parts made of steel, stainless steel, non-ferrous metals, brass and plastic. Due to its handy, compact design, the machine can be used on straight edges, internal and external radii and for drill holes from \varnothing 22 mm. The fine adjustment allows slight chamfers for deburring up to the preparation of welding seams.

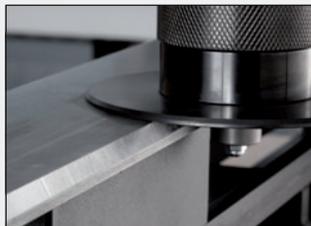
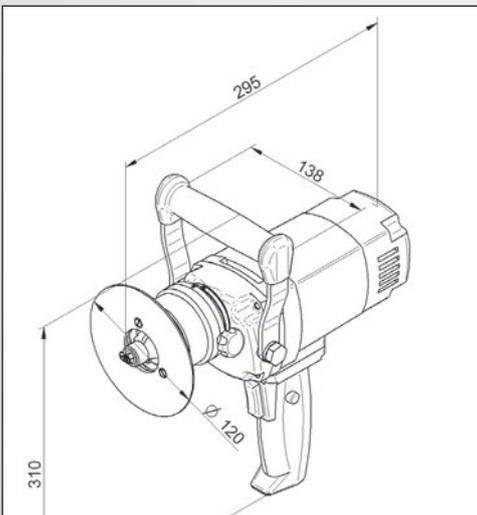


Three milling cutters with a chamfering angle of 45°, optionally 30° or a radius of 2.5 mm are available.

The reversible disks can be used in 3 ways. Due to the small guiding roller, insertion into drill holes from \varnothing 22 mm is possible without any problems.



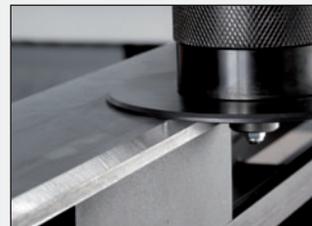
Edge processing with the EKF - the workpiece is securely fixed with the MagnetCLAMP magnetic clamping device. See page 79.



Cutting angle
30°



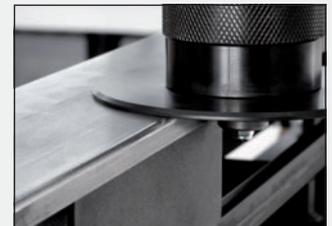
EKF 300.3 with milling cutter ZFR



Cutting angle
45°



EKF 450.3 with milling cutter ZFR 450.3



Radius
R 2.5 mm



EKF 452.3 with milling cutter ZFR 452.3



Visit our homepage to experience live the EKF demo video.
http://www.kernbohrer.de/downloads/downloads.html#tab_4

The advantages of the EKF

- > Straightforward – easy handling, low weight
- > Variable – 3 milling cutters optionally 45°, 30°, or R 2.5 mm
- > Powerful – 1.5 kW motor



SPECIFICATION

	Motor output:	1500 Watt
	Voltage:	220 - 240 V AC, 50-60 Hz
	Speed range 1:	6000 min ⁻¹
	Feed:	manual
	Milling cutter optional:	Fase 45° – width continuously 0 - 6 mm Fase 30° – width continuously 0 - 5 mm Radius R 2.5 mm
	Carbide reversible disks:	3 per milling cutter
	Weight:	4.6 kg

ACCESSORIES

ORDER NO.

Milling cutter

ZFR 300.3 – 30°

ZFR 450.3 – 45°

ZFR 452.3 – R 2.5

Carbide reversible disks are not included in delivery. Please clearly order them as an extra.

Carbide reversible disks

SHM 200 1 pc.

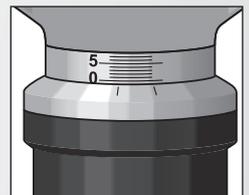
SHM 200-E 1 pc.

SHM 202 1 pc.

1 set = 3 carbide reversible disks SHM



Changeable carbide reversible



Fine adjustment

ORDER NO.

EKF 300.3 / 230 Volt

EKF 300.3 / 110 Volt

EKF 450.3 / 230 Volt

EKF 450.3 / 110 Volt

EKF 452.3 / 230 Volt

EKF 452.3 / 110 Volt

SCOPE OF DELIVERY

1 Deburring and chamfering machine

1 Milling cutter

3 Carbide reversible disks

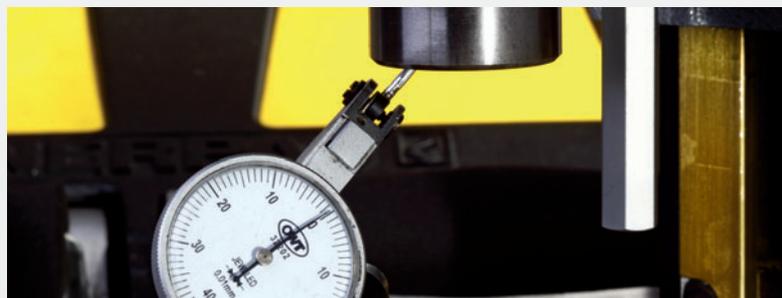
1 Jaw spanner SW 22

1 Carry case

1 Sickle spanner

1 Torx screwdriver T9

1 Operating manual



BDS Premium Service

Special versions, machine check-up, E-check, regrinding, training courses, advice.

Machine Check-up

This is how you keep your magnetic core drilling machines in top shape! BDS checks your machine thoroughly, tests all functions and recommends the most cost-effective solution if repair work needs to be done. The scope of a BDS service package includes:

- ▶ Disassembly and repair
- ▶ Check of connector, switches and wiring
- ▶ Replacement of wearing parts such as spindle, steady, guideway elements and carbon brushes
- ▶ Armature, coil, printed-circuit boards and magnet will be checked and replaced, if required, after an estimate has been made

BGV-A3 CHECK

ORDER NO.

BGV 300

BGV-A3 Check for stationary and mobile electric tools

Grinding service

Regrinding of BDS core drilling tools lowers your tool costs. BDS core drills of the HSS-Co 8 and HSS-Standard series are designed so that they can be re-ground several times without losing quality. The tools are reworked on up-to-date grinding machines. Benefit from our professional regrinding service with ORIGINAL BDS grinding geometry. Do you want to regrind yourself? Instructions are enclosed with drill package and available in the download area on our website.

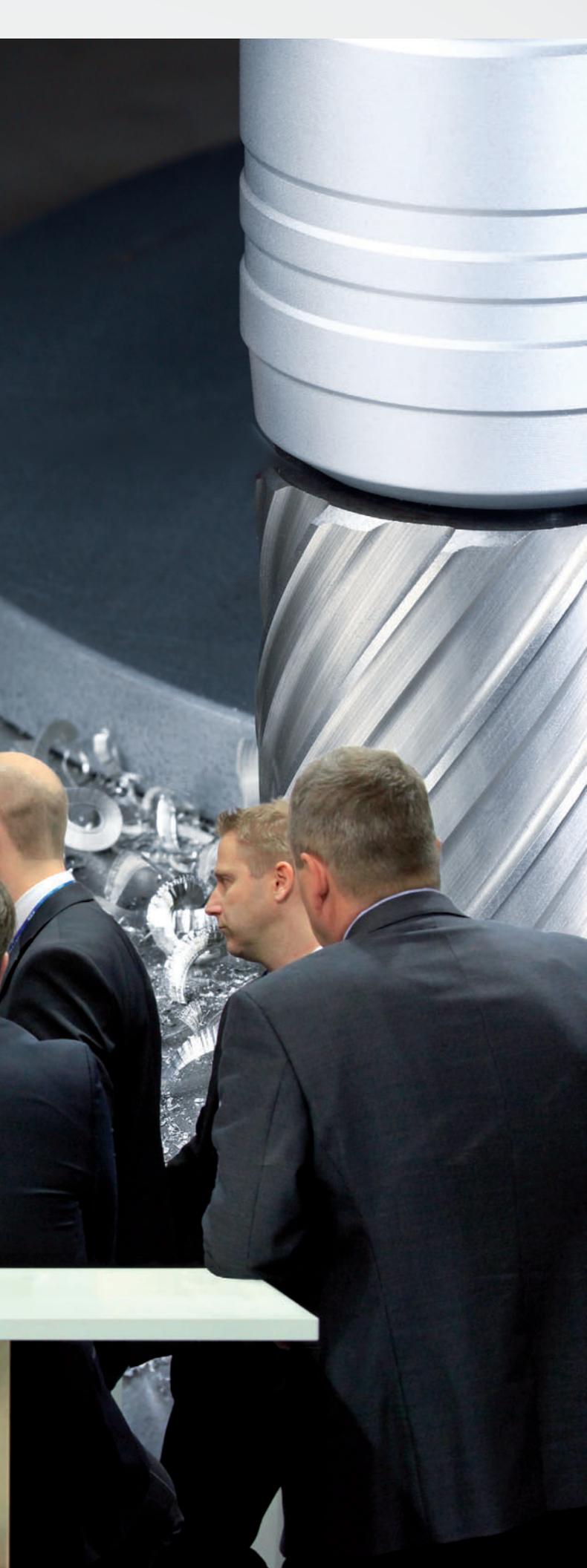
Special versions

Not all core bores can be made with standard machines or standard accessories. The requirements in industry and commerce are quite diverse. Individually adapted special versions must be made to meet special requirements. This is our specialty. Our technicians and engineers have considerable experience in the area of metal drilling technology. For us it is a challenge to supply professional solutions for your applications.

- ▶ In-house CAD construction
- ▶ Short-term realization of special versions
- ▶ Manufacturing of special accessories
- ▶ Expert advice







Answering Your Questions

Compare in detail, try and test in peace. Take advantage of the opportunity.

The new BDS Information and Training Centre

In 2013, we inaugurated our new Information and Training Centre in Mönchengladbach. The full range of BDS magnetic core drilling technology can be experienced and realised here. All our machines are ready for demonstration with interesting accessories and the whole assortment of our core drill series. We are happy to arrange to inform you on-site about the universal possibilities of our machines, about the differences between products and about our concept of quality Made in Germany. Simply better drilling.

Current trade fair dates

We present and demonstrate our novelties and products at several international trade fair venues. You are cordially invited to visit BDS at any of these trade fairs.

Please talk to us and we would be pleased to inform you about the current schedules and venues. The trade fair dates are also updated on our company website homepage.

Simply better drilling

BDS magnetic core drilling machines are technically fully developed tools for professional use. All components, machines, accessories, working materials and our core drilling tools are precisely associated with each other, thus ensuring perfect work results.

Our products are the result of our philosophy: focusing on the most important functional requirements of a product and developing simple and practical solutions for the benefit of our customers.

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

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Spare parts and repair

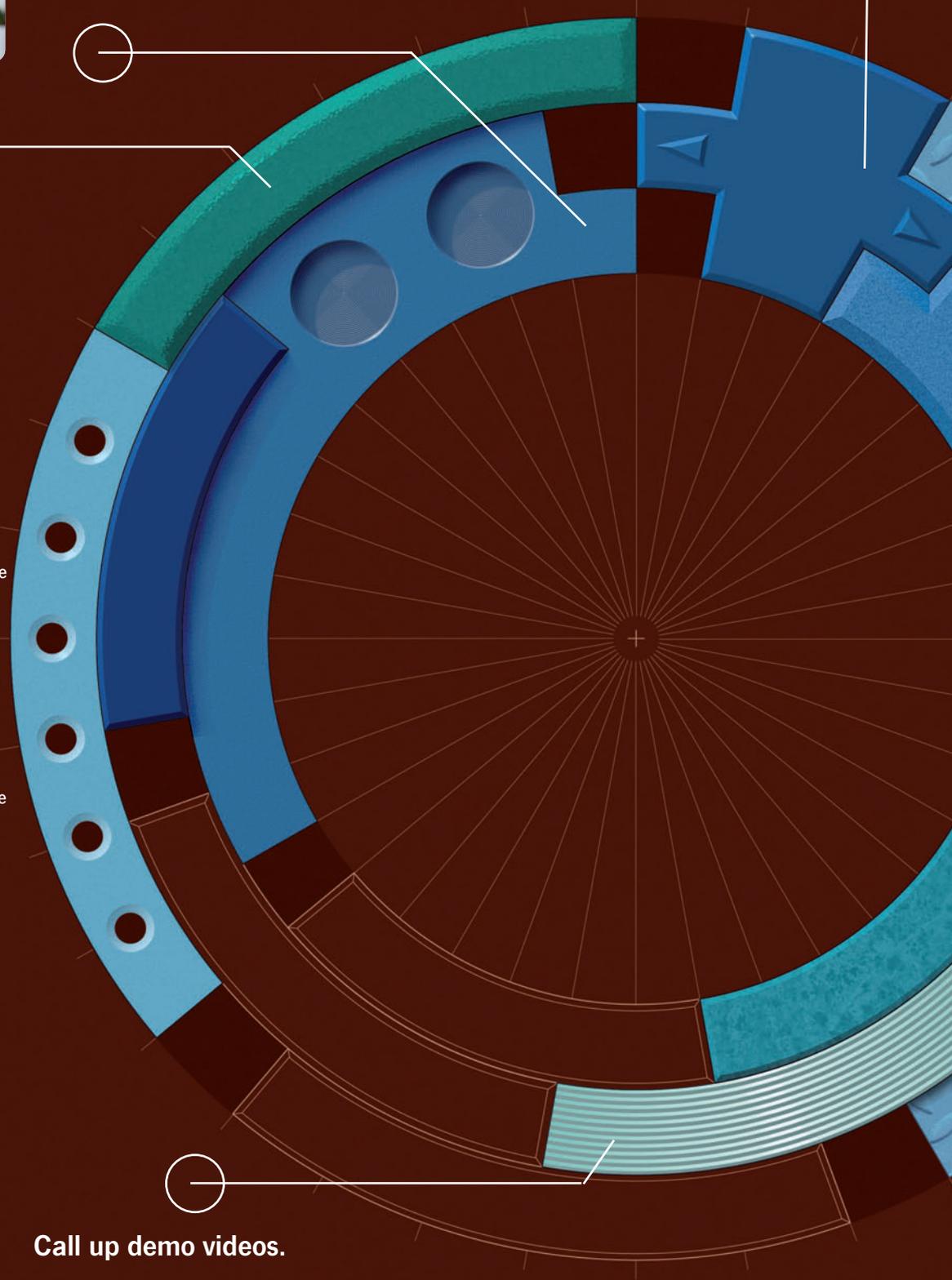
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Call up demo videos.



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.

BDS on the Internet: bds-maschinen.de

Always find the latest information on the whole delivery process. Download area with videos, instruction manuals and further product information. Click and enter.

BDS on Apple App Store and Google Play



The brand new BDS Apps for Apple (iPhone, iPad), Android smart phones, Windows smart phones and Blackberry now available on Apple App Store, Google Play, Windows Store and Blackberry World for free. The App comes with interesting features like Calculate cutting speed for ProfiPLUS machines, Compare machines and core drills, Find machine, Digital catalogue and much more.
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BDS Maschinen in specialised trade.



You can also find magnetic core drilling machines, accessories and core drills by BDS Maschinen in all good specialised tool stores. Our committed on-site sales partners are happy to advise you and work closely with BDS Maschinen experts to offer you the right tool for your job.

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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