

**THE FULL RANGE**

**FOR ALL REQUIREMENTS**

**BDSMASCHINEN**  
MADE IN GERMANY

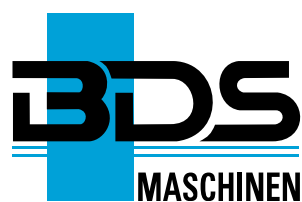





























# **MAGNETIC CORE DRILLING MACHINES**

Annular Cutters & Accessories 2020/2021

**BDS**  
MASCHINEN

# CORE DRILLING MACHINES FOR PROFESSIONALS.



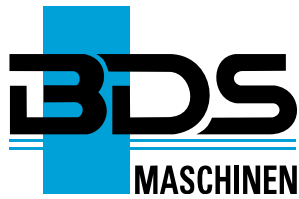
Machine	MAB 485	MAB 525	MAB 825	MAB 1300	
	MAB 485 Swivel Base 	MAB 525 Swivel Base 	MAB 845 Swivel Base 		
 Motor output	Watt	1,150	1,600	1,800	2,300
 Voltage, V AC	Volt	230 - 110/125	230 - 110/125	230 - 110/125	230 - 110/125
 Core drill cutting depth max.	mm	55	75	110	110
 Core drill max. Ø HSS/carbide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

# KEY SPECIFICATIONS AT A GLANCE:



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

# SPECIAL MACHINES FOR SPECIAL TASKS.



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



# BDS HAS IT:



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

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



**TOP PERFORMANCE  
IN A NEW DESIGN**

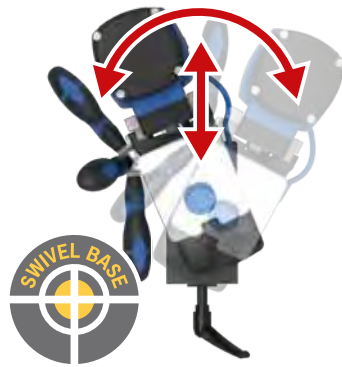


# MAB 485 / 485 SB

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

## THE BESTSELLER AMONG PROFESSIONALS

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



Overheating protection

Magnet indicator

Permanent internal lubrication

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



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

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

Core drill	Twist drill	Reamer	Countersink	Tapping
HSS Ø 40 mm	Ø 18 mm	Ø 18 mm	Ø 40 mm	M16
TCT Ø 50 mm				
Cutting depth: 30 - 55 mm				



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Arbors and adapters

Accessories and consumables

Drills

About BDS

# MAB 525 / 525 SB

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

## THE STRONG COMPACT MACHINES

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

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



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

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

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

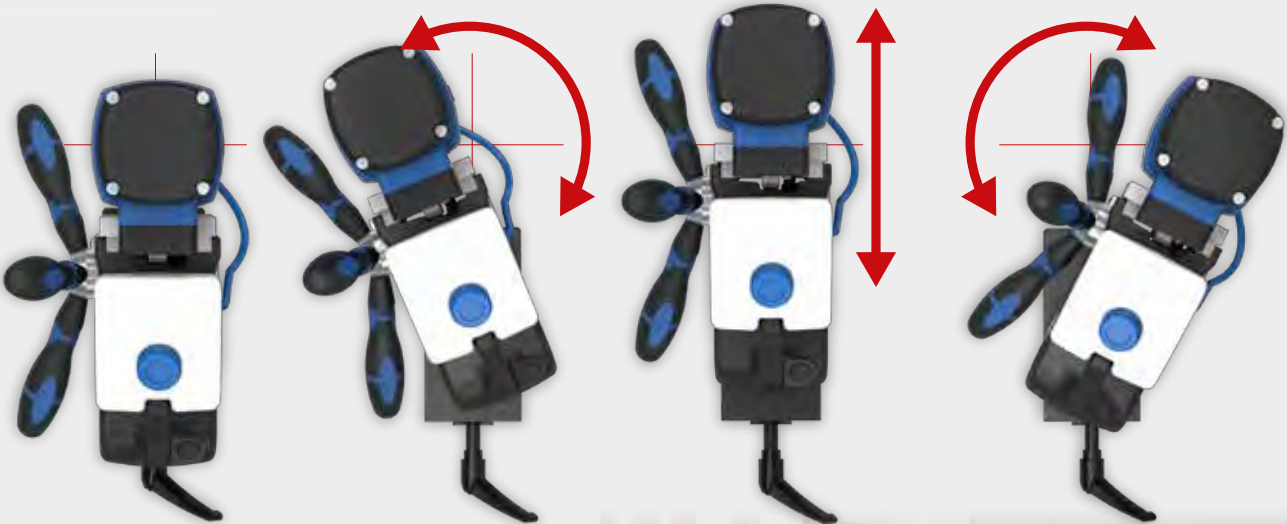




Anyone who has ever worked with Swivel Base equipped machines from BDS will never wish to be drill without it again. Swivel Base allows precise, accurate centering of the hole to be drilled without having to move the complete weight of the machine at the same time. Ideal for overhead and horizontal drilling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



## FOR QUICKER AND SAFER WORK



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

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



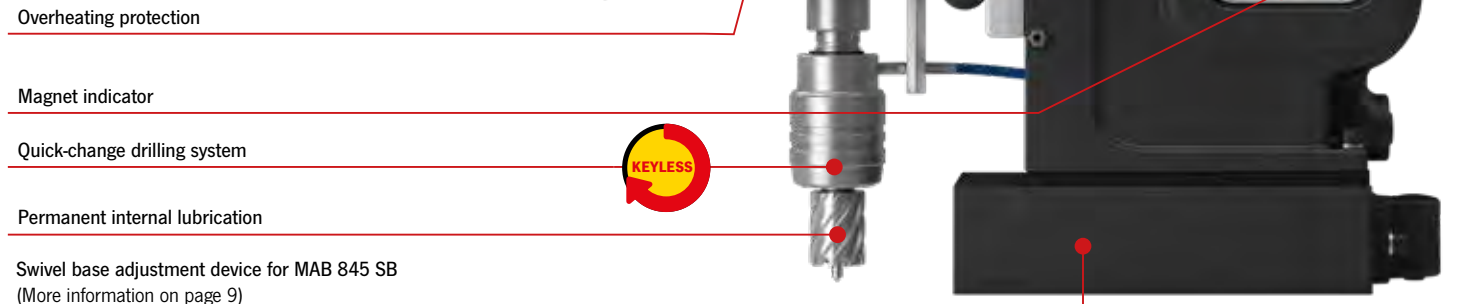
- 1.** Put the machine in roughly the right position.
- 2.** Switch on the magnet.
- 3.** Unlock adjustment device and effortlessly adjust machine precisely.
- 4.** Lock the adjustment device with the hand lever again, once the center of the hole is achieved.

# MAB 825 / MAB 845 SB

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

**WELCOME  
TO THE  
TOP CLASS**

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



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

Overheating protection

Magnet indicator

Quick-change drilling system

Permanent internal lubrication

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



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

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

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





# BDS Special Purpose Drilling Machines

## WHAT IS NEEDED

## IS SPECIALLY BUILT

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

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



### MAB 525 with prism clamping system for machining pipes

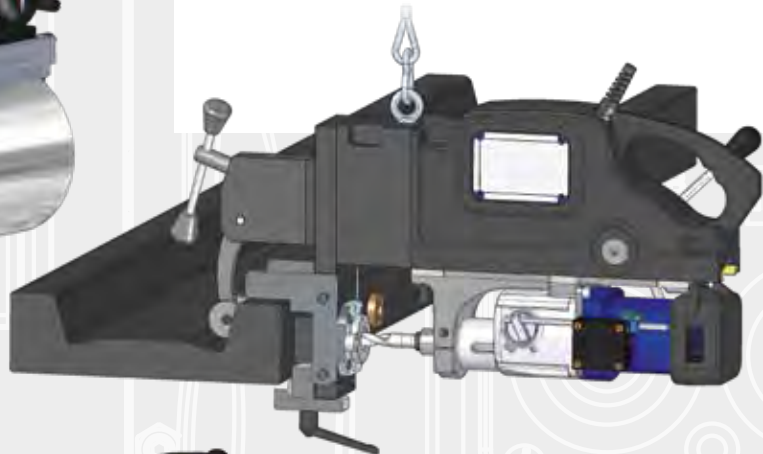
The prism plates adjustable at the sides can be adapted to the pipe diameter and thus stabilise the core drilling unit against lateral twisting.

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



### MAB 825 PS

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



### MAB 825 W90

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



# MAB 1300

Superior performance with exceptional power delivery.

## THE STRONGEST OF THE STRONG!

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

Full wave control electronics

Overheating protection

Torque control

Clockwise/anticlockwise rotation

Magnet indicator

Permanent internal lubrication

Drilling of diameters up to 130 mm





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

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

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

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



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

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Arbors and adapters

Accessories and consumables

Drills

About BDS



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



# ProfiSTART

**WITH OPTIMISED  
ERGONOMICS  
AND PERFORMANCE**



# MAB 100 K

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

## THE LIGHTWEIGHT HEAVY PERFORMER

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



Quick-change drilling system

Magnet indicator

Permanent internal lubrication

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

### Included in delivery

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

### Core drill

- Max. Ø 32 mm
- Cutting depth:  
30 - 55 mm



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

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Arbors  
and adapters

Accessories and  
consumables

Drills

About BDS

# MAB 455 / 455 SB

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

## PERFECT FOR THE WORKSHOP AND ON THE ASSEMBLY LINE

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



Magnet indicator

Quick-change drilling system



Permanent internal lubrication



### MAB 455/455 SB

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

### Included in delivery

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

Core drill	Twist drill
------------	-------------

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





# MAB 465

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

## GREAT POWER FOR A SMALL PRICE

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

Internal cable feed

Overheating protection

Magnet indicator

Permanent internal lubrication

Full wave control electronics

Variable speed control

Clockwise/  
anticlockwise rotation



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

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

Core drill	Twist drill	Countersink	Tapping
HSS Ø 40 mm	Ø 16 mm	Ø 40 mm	M16
TCT Ø 50 mm			
Cutting depth: 30-55 mm			



ProfiSTART

ProfiBASIC

ProfiSPEZIAL

Arbors  
and adapters

Accessories and  
consumables

Drills

About BDS

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



# MABasic 200

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

## THE SMALL MACHINE

## WITH A LARGE

## IMPACT!

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



Switches are arranged on the back for safe and easy operation

Permanent internal lubrication



Coolant tank mounted on the side

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

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

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



ProfiBASIC

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Arbors and adapters

Accessories and consumables

Drills

About BDS



# MABasic 400

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

## THE FAST RUNNER

## IDEAL FOR

## TWIST DRILLS

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



Switches are arranged on the back for safe and easy operation

Two-speed gearbox with high speed for twist drills

Permanent internal lubrication



Coolant tank mounted on the side



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

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

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



# MABasic 450

Flexible handling thanks to MT 2 tool changing system.

## WITH MT 2 CHANGING SYSTEM

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



Switches are arranged on the back for safe and easy operation

MT 2 Spindle taper

MT 2 Industrial arbor

Permanent internal lubrication



Coolant tank mounted on the side



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

### Included in delivery

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

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



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About BDS

# MABasic 850

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

**WITH 1800 W**  
**SUITABLE FOR**  
**EXTREME TASKS**

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

4-speed gearbox

MT 3 Spindle taper

Permanent internal lubrication



Switches are arranged on the back for safe and easy operation

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

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

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





# ALWAYS THERE FOR YOU BEFORE AND AFTER A PURCHASE

## WORRY TAKEN OUT OF EVERYTHING THANKS TO BDS PREMIUM SERVICE

### Machine check-up

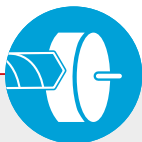
This will help you keep your magnetic core drilling machines in top form! BDS will check your machine, check all the functions and recommend the solution that represents the best value for money if repairs need to be carried out. The scope of a BDS machine check-up comprises the following:

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



### Grinding service

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



### Individual consultancy

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

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

Email: [export@bds-maschinen.de](mailto:export@bds-maschinen.de)



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



# MAB 825 KTS

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

## VERSATILE

## DRILLING & MILLING

## WITH CROSS TABLE



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

Permanent internal lubrication

Magnet indicator



With cross table  
X 110 mm Y 120 mm

With cross table  
X 110 mm Y 120 mm

### MAB 825 KTS

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

### Included in delivery

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

### Core drill    Twist drill    Reamer    Countersink    Tapping

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



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

Full wave control electronics

Overheating protection

Clockwise/anti-clockwise rotation

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# AutoMAB 350

# AutoMAB 450

Magnetic core drilling machines with fully automatic feed and return.

Integrated coolant tank

## ECONOMICAL

## FULLY AUTOMATIC

## DRILLING SOLUTION



Overload protection

LED switch

Magnet indicator

Permanent internal lubrication

### AutoMAB 350

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

### Included in delivery

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

### Core drill

#### Automatic feed

- Max. Ø 35
- Cutting depth
- 30-55 mm

#### Manual feed

- Max. Ø 35
- Cutting depth
- 30-55 mm





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

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

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

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

Core drill
<b>Automatic feed</b>
Max. Ø 45
Cutting depth
30-55 mm
<b>Manual feed</b>
Max. Ø 45
Cutting depth
30-55 mm



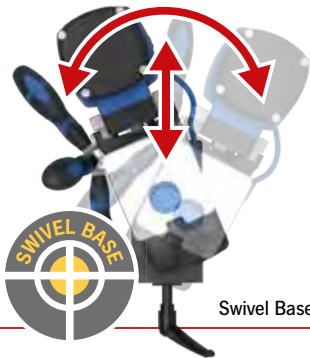
# MAB 825 V / MAB 845 V

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

## THE HEAVY-DUTY AUTOMATIC MAGNETIC DRILL



Torque control



Magnet indicator

Permanent internal lubrication

Swivel Base adjustment device (More information on page 9)

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

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

### MAB 825 V/MAB 845 V

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

### Included in delivery

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

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





# MAB 1300 V

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

**THE STRONGEST  
OF THE STRONG**



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

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

### Included in delivery

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

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



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# MAB 155

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

## THE SMALL MACHINE

## WITH HUGE POWER

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



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

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

Core drill
Max. Ø 35 mm
Cutting depth:
30 mm



# AirMAB 5000

Drilling with pneumatic drive and permanent magnet.

## POWERFUL DRILLING WITH COMPRESSED AIR

MT 2 Morse taper

Quick-change drilling system

KEYLESS

Permanent internal lubrication

Powerful permanent magnet

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



Powerful 830 W multi-disc motor

AirMAB 5000 BDS MASCHINEN

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

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

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



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# RailMAB 915

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

## THE SPECIALIST FOR RAILS



Suitable adapter for every rail profile

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

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

### Included in delivery

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

### Core drill

Max. Ø 50 mm  
Cutting depth:  
30-55 mm



### Twist drill

Ø 20 mm



### Order no.

### Rail adapter for RailMAB 915

ZAS 049S	Rail adapter S 49
ZAS 054S	Rail adapter S 54
ZAS 050U	Rail adapter UIC 50
ZAS 054U	Rail adapter UIC 54



# RailMAB 965

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

## LIGHTWEIGHT

## RAIL DRILL MACHINE

Integrated Petrol Tank

Petrol engine 1500 Watts (2 HP)

Connection for high-pressure coolant tank

Quick-change clamping system

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

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

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

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

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

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# Drill stands and clamping devices

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

## EXPAND THE POSSIBILITIES OFFERED

## BY YOUR MACHINES



Magnetic drill stand

### Magnetic drill stand for manual drilling machines

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

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

The powerful magnet therefore allows safe work on a horizontal plane or overhead work (a safety lashing strap must also be used for these applications). The slide has a working stroke of 180 mm.

#### Magnetic drill stand

##### Order no.

MBS 300

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



Industrial drill stand

### Industrial drill stand for manual drilling machines

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

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

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

#### Industrial drill stand

##### ORDER NO.

ZBS 100.2

ZST 300 Prism vice

Screw for T slots

ZSM 100 Hexagon nut

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

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



MobilCLAMP – mobile work with magnetic core drilling machines

### MobilCLAMP for magnetic core drilling machines



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

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

#### MobilCLAMP

##### ORDER NO.

ZMC 200



# Adapters, drill chucks and accessories

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



1. Connect adapter to drill chuck.



2. Insert drill chuck into the direct arbor.



3. Ready for use for twist drills.

**Direct arbor**  
**19 mm Weldon (3/4")**



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



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



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



1. Connect taper drift to drill chuck.



2. Insert drill chuck in MT arbor.



3. Ready for use for twist drills.

**Spindle taper**  
**MT 2 or MT 3**



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



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



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



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



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



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

## Safety lashing strap

ORDER NO.
40 0016 1

## Pump bottle

ORDER NO.
ZKP 100



Arbors  
and adapters

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# Carry case

For magnetic core drilling machines.

## EXTREMELY ROBUST

## YET LIGHTWEIGHT

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



### Hard-top case

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

**Application:** Carry case for BDS magnetic core drilling machines.

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



### Carry case

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



### Carry case on wheels

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

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

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

### Carry case on wheels

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

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

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



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



# Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS category.

## DRILLING, COUNTERSINKING AND CUTTING QUICK AND SAFE

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

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

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

### Quick-change drill chucks

#### Sizes MT 2, MT 3 and MT 4

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



### Version 1: Quick-change inserts with safety friction clutch

#### Thread from M6 to M42 –

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

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

### Version 2:

#### Standard quick-change inserts

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



# Which machine, which thread?

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

## PRECISION WITH BDS SYSTEM ACCESSORIES

### Thread cutting systems

#### GSW quick-change drill chucks:

In MT 2, MT 3 and MT 4 versions.

To accommodate GSE or GSS quick-change inserts

GSW 222 size 2 MT 2

GSW 331 size 1 MT 3

GSW 332 size 2 MT 3

GSW 333 size 3 MT 3

GSW 442 size 2 MT 4

GSW 443 size 3 MT 4

GSW 444 size 4 MT 4



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



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

#### ORDER NO.

GSW 222 quick-change drill chuck

GSW 331 quick-change drill chuck

GSW 332 quick-change drill chuck

GSW 333 quick-change drill chuck

GSW 442 quick-change drill chuck

GSW 443 quick-change drill chuck

GSW 444 quick-change drill chuck

GSE 103 - GSE 114 per unit

GSE 205 - GSE 222 per unit

GSE 314 - GSE 330 per unit

GSS 205 - GSS 222 per unit

GSS 312 - GSS 330 per unit

GSS 420 - GSS 442 per unit

### Machine screw tap adapters – making an affordable start

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



#### Machine screw tap adapter with Weldon shank

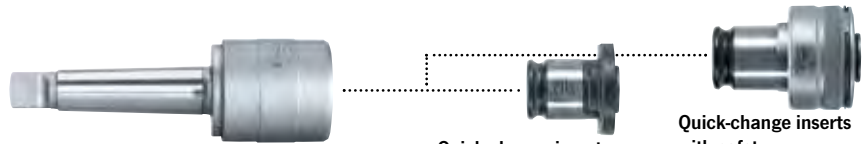
ORDER NO.	THREAD	SHANK Ø	SQUARE
ZGA 010	M10 DIN 376	7	5.5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14.5
ZGA 024	M24 DIN 376	18	14.5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18

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

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



## THREAD CUTTING SYSTEMS



### Quick-change drill chucks GSW

### Quick-change inserts Standard GSE

### Quick-change inserts with safety friction clutch GSS

MAB 1300	MAB 825 MAB 845	MAB 485 MAB 485 SB	MAB 525 MAB 525 SB	Order No. Quick-change drill chuck	Thread	Order No.	ø x square	Order No.	ø x square	
				GSW 222 Size 2 MT 2	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210-DIN 371	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0	
				GSW 331 Size 1 MT 3	M4	GSE 104	4.5 / 3.4			
					M5/M6					GSE 105
					M8	GSE 108	8 / 6.2			
					M10					GSE 110
					M12	GSE 112	9 / 7.0			
					M14					GSE 114
				GSW 332 Size 2 MT 3	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210.1	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9	GSS 216	12 / 9	
					M18					GSE 218
					M20	GSE 220	16 / 12	GSS 220	16 / 12	
					*not suitable for MAB 525					M22/M24*
					GSW 333 Size 3 MT 3	M12			GSS 312	9 / 7.0
				M14		GSE 314				
				M16			GSE 316	12 / 9	GSS 316	12 / 9
				M18		GSE 318				
				M20			GSE 320	16 / 12	GSS 320	16 / 12
						M22/M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
						GSE 327				
							GSE 330	22 / 18	GSS 330	22 / 18
				GSW 442 Size 2 MT 4	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210-DIN 371	10 / 8.0	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9	GSS 216	12 / 9	
					M18					GSE 218
					M20	GSE 220	16 / 12	GSS 220	16 / 12	
					M22/24					GSE 222
					GSW 443 Size 3 MT 4	M12			GSS 312	9 / 7.0
				M14		GSE 314				
				M16			GSE 316	12 / 9	GSS 316	12 / 9
				M18		GSE 318				
				M20			GSE 320	16 / 12	GSS 320	16 / 12
				M22/24		GSE 322				
				M27			GSE 327	20 / 16	GSS 327	20 / 16
				M30		GSE 330				
				GSW 444 Size 4 MT 4	M20			GSS 420	16 / 12	
					M22/24					GSS 422
					M27	GSS 427	20 / 16			
					M30			GSS 430	22 / 18	
					M33	GSS 433	25 / 20			
					M36			GSS 436	28 / 22	
					M39/42	GSS 442	32 / 24			

Arbors  
and adapters

Accessories and  
consumables

Drills

About BDS

# Arbors for BDS core drills

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

## ACCOMMODATING OF EVERY DRILL

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



**KEYLESS quick-change drilling system**

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

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



**Reducing bush DIN 2185**

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

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



**Industrial arbor with manual internal lubrication**

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

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



**Extension sleeve DIN 2178**

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

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



**Industrial arbor with automatic internal lubrication**

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

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



# Adapters with Weldon shank

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

## WE ARE OPEN TO ALL SYSTEMS

32 mm (1 1/4")



**Adapter**  
**ORDER NO.**  
 ZAP 200  
 From 32 mm (1 1/4") Weldon shank  
 To 19 mm (3/4") Weldon shaft

19 mm (3/4")



**Adapter**  
**ORDER NO.**  
 ZAF 002  
 For fine core drills with M18 x 6 P1.5 female thread incl. 1 ZAK 125 ejector pin

19 mm (3/4")



**Adapter**  
**ORDER NO.**  
 ZAF 003  
 For fine core drills with QUICK-IN shank incl. 1 ZAK 115 ejector pin

19 mm (3/4")



**Extension**  
**ORDER NO.**  
 ZAP 300  
 80 mm, 19 mm Weldon shank (3/4"), incl. 1 ZAK 080 ejector pin

Adapters for Nitto One-Touch



**Adapter**  
**ORDER NO.**  
 ZAF 005  
 With Nitto One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Adapters for Fine QUICK-IN



**Adapter**  
**ORDER NO.**  
 ZAF 004  
 With Quick-In One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Arbors and adapters

Accessories and consumables

Drills

About BDS

# PowerCLEANER

The ideal multi-function tool



USE OF BDS

GENUINE ACCESSORIES ADVISED

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

## PowerCLEANER

PowerCLEANER

ORDER NO.

POW 200



Removal of drilling chips with sharp edges



Cleaning of working surface

## PowerCLEANER starter kit

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

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

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

BDS PowerCLEANER starter kit

ORDER NO.

ZST 200

Contents:

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



PRICE ADVANTAGE

# PowerWORKER

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

## TIDIER WORK AREA

### PowerWORKER

PowerWORKER

ORDER NO.

POW 100



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

## PowerWORKER starter kit

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



BDS PowerWORKER starter kit

ORDER NO.

ZST 100

#### Contents:

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



**PRICE ADVANTAGE!**

Accessories and  
consumables

Drills

About BDS





### High-performance cutting oil **BDS 5000**

### Cooling lubricant concentrate **BDS 6000**



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

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



For high standards based on synthetic raw materials

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



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

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



# Cutting oil, lubrication spray, cutting paste and cooling lubricant

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

**BEST RESULTS**

**KIND ON**

**THE ENVIRONMENT**

## High-performance lubrication spray **BDS 5200**



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

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

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

## High-performance cutting paste **BDS 5500**

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



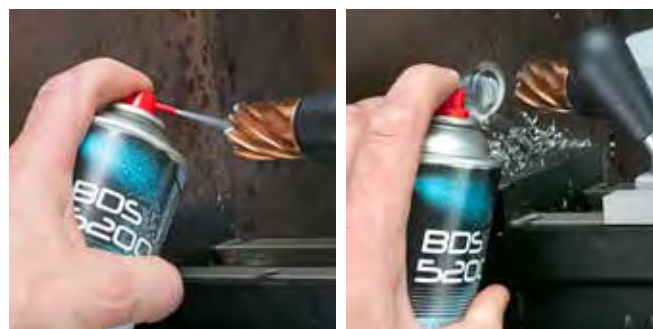
**BDS 5500:** Ideal for material types that are hard to machine. Suitable for use overhead and work in awkward positions.

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

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

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

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



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

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

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

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



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

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



ZRO 250



ZRO 500

### Pipe clamping device

#### ORDER NO.

ZRO 250

ZRO 500

ZRO 250: for MAB 455, 485, 525

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

ZRO 500: for MAB 825, 845, MABasic 850

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



# Clamping devices

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

## FOR MACHINING PIPES

## AND DRILLING NON-FERROUS METALS

## AND STAINLESS STEEL

### Vacuum clamping devices for non-ferrous metals

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



Vacuum plate for smooth surfaces

**ORDER NO.**

ZAV 400

**Application:** For smooth surfaces.

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



Vacuum plate for smooth corrugated sheet metal/gussets

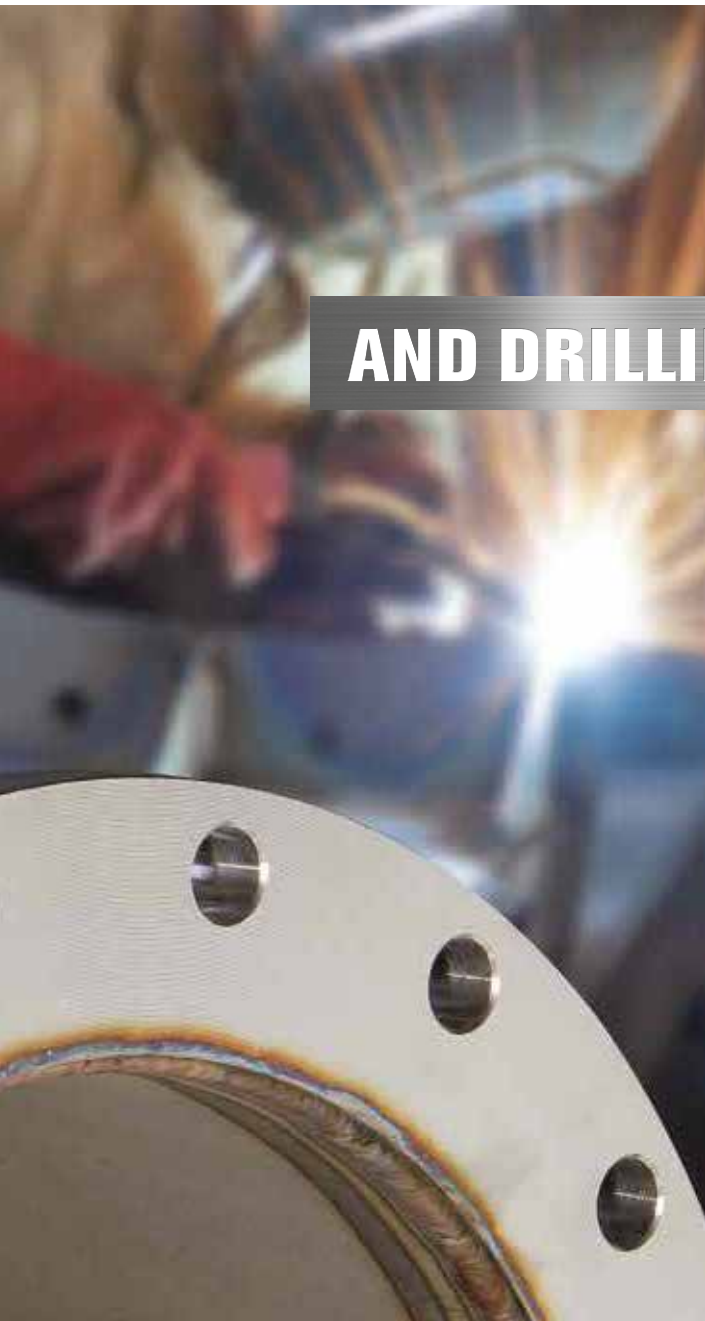
**ORDER NO.**

ZAV 300

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

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

Delivery without machines



ZAV 400  
Vacuum clamping  
device for smooth  
surfaces

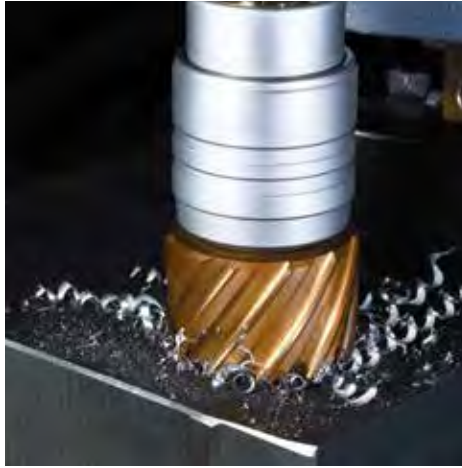


ZAV 300  
Vacuum clamping  
device for corrugated  
sheet metal and  
gussets





# The range of BDS fully ground core drills.



## HSS-Co 8 series

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

## HSS-VarioPLUS series

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

## HSS-Standard series

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

### HSS-Co 8 series

Core drills made from special steel with high cobalt content, for increased heat resistance and wear protection.



### HSS-Co 8 series

	KBK-CO	KBL-CO
Cutting depth:	30 mm	55 mm
Drilling diameter:	12 – 130 mm	12 – 100 mm

### HSS-VarioPLUS series

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



### HSS-VarioPLUS series

	KBK-VP	KBL-VP
Cutting depth:	30 mm	55 mm
Drilling diameter:	12 – 60 mm	12 – 60 mm

### HSS-Standard series

Fully ground core drill made from high-performance high-speed steel



### HSS-Standard series

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

# Professional quality for professional tasks.



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

## Huge vertical range of products

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

## Arbors

BDS core drilling tools are offered with different arbors.

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



### Arbors:

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

## Carbide series and Carbide-PLUS series

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

### Carbide series

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



### Carbide-PLUS series

Carbide-tipped core drills with carbide coating.



### Carbide-RAIL series

Carbide-tipped core drills for rail core drilling machines.



### Quick-In series

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



### Carbide series

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

### Carbide-PLUS series

HKK-P
30 mm
12 – 60 mm

### Carbide-RAIL series

HKK-R
30 mm
17 – 36 mm

### Quick-In series

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



# HSS-CO 8 CORE DRILL SERIES





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

## HSS-Co 8 Short core drill

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



## HSS-Co 8 Short core drill

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



### HSS-Co 8 SERIES

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

### HSS-Co 8 SERIES

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

EJECTOR PIN FOR KBK-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBK-CO, Ø 61 – 130 mm

ORDER NO.

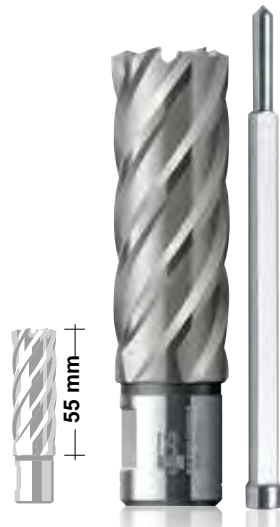
ZAK 090

# HSS-Co 8 core drill series

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

## HSS-Co 8 Long core drill

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



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

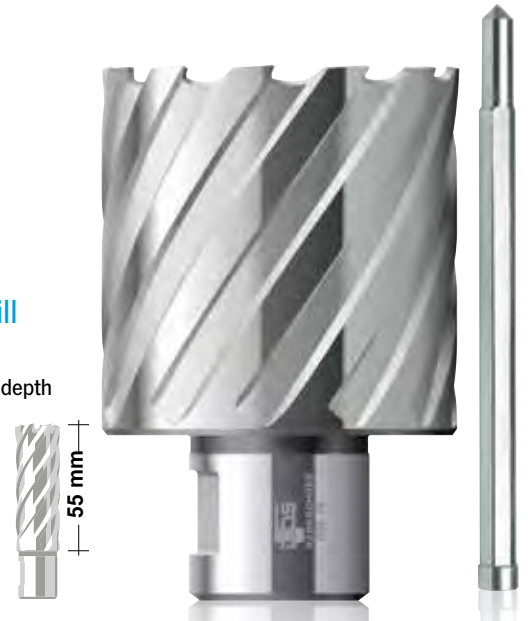
EJECTOR PIN FOR KBL-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 100

## HSS-Co 8 Long core drill

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



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

Ejector pin FOR KBL-CO, Ø 61 – 100 mm

ORDER NO.

ZAK 120

# Optimum drilling and lubrication with BDS products.

## Recommended cutting speed

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

**Cutting speed:**  

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

## Table of speeds

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

**Speed:**  

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

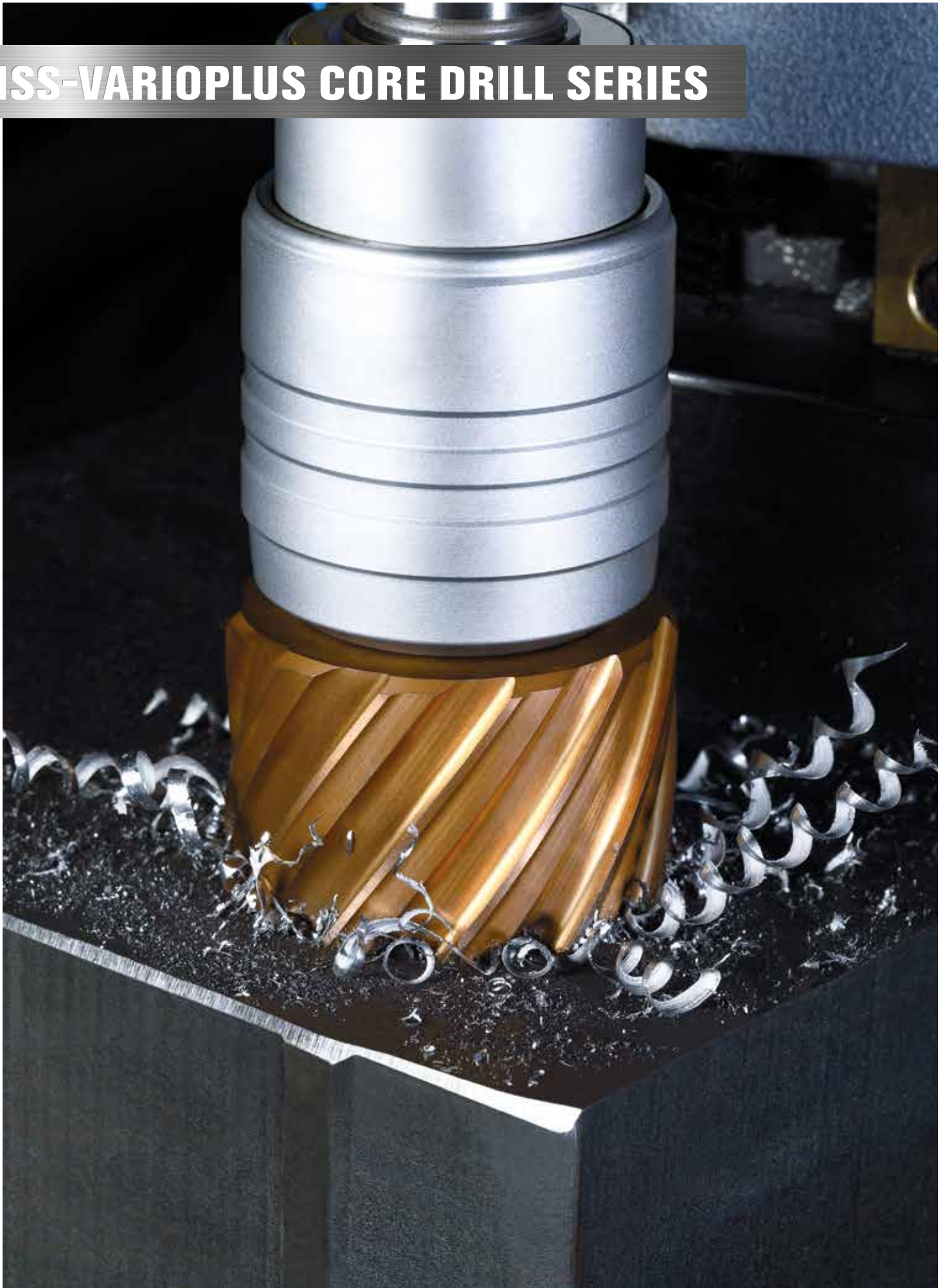
## Assignment of BDS drill series and the appropriate BDS cooling lubricants to the material.

	Cutting oil BDS 5000	Lubrication spray BDS 5200	Cutting paste BDS 5500	Paste ZHS 570	BDS 6000 cooling lubricant concentrate
<b>Aluminium, non-ferrous metals</b>					
HSS-Standard	•	•			
<b>Steel &lt; 500 N/m<sup>2</sup></b>					
HSS-Standard	•	•			
Carbide					•
Carbide-PLUS					•
<b>Fine-grained steel &lt; 700 N/m<sup>2</sup></b>					
HSS-Co 8	•	•	•	•	
HSS-VarioPLUS	•	•	•	•	
Carbide					•
Carbide-PLUS					•
<b>Fine-grained steel &lt; 1,000 N/m<sup>2</sup></b>					
HSS-Co 8	•	•	•	•	
HSS-VarioPLUS	•	•	•	•	
Carbide					•
Carbide-PLUS					•
<b>Rustproof steels, stainless steel</b>					
HSS-Co 8	•	•	•	•	
Carbide					•
Carbide-PLUS					•
<b>Cast iron</b>					
HSS-Co 8					•
HSS-Standard					•
<b>Railway rails</b>					
Carbide-RAIL					•





# HSS-VARIOPLUS CORE DRILL SERIES



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

### HSS-VarioPLUS short core drill

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



### HSS-VarioPLUS long core drill

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



#### HSS-VarioPLUS SERIES

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

#### HSS-VarioPLUS SERIES

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

EJECTOR PIN FOR KBK-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 100



# HSS-STANDARD CORE DRILL SERIES





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

### HSS-Standard short core drill

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



### HSS-Standard long core drill

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



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

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

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

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

# HSS-Standard

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

## HSS-Standard core drill Extra-long

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



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

# HSS-Standard, Inches

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

## HSS-Standard core drill Short, Inches

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



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

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

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

# Quality features that make the difference.



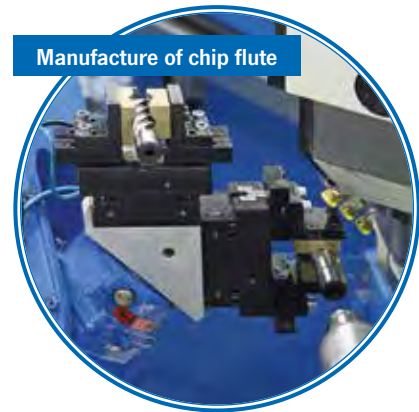
Grinding the end teeth

Modern CNC-controlled grinding centres ensure consistent quality.



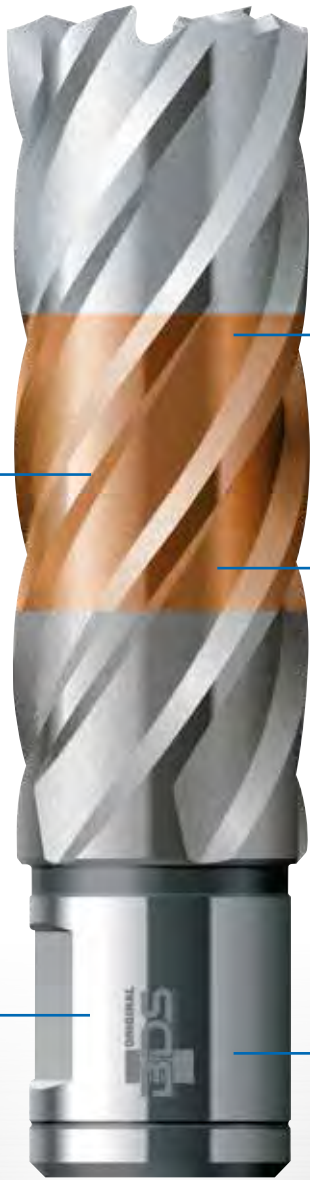
Perfect cylindrical grinding

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



Manufacture of chip flute

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



VarioPLUS coating

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

The best raw materials



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

## From the first to the last cut!

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



Unprocessed round bar



Mechanically processed



Hardened



Ground to external dimension



Ground with flute and end tooth



Coated VarioPLUS core drills





# CARBIDE CORE DRILL SERIES



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

### Carbide (TCT) Core Drills Short

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



### Carbide (TCT) Core Drills Short

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



#### CARBIDE SERIES

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

#### CARBIDE SERIES

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

EJECTOR PIN FOR HKK, Ø 14 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK, Ø 61 – 150 mm

ORDER NO.

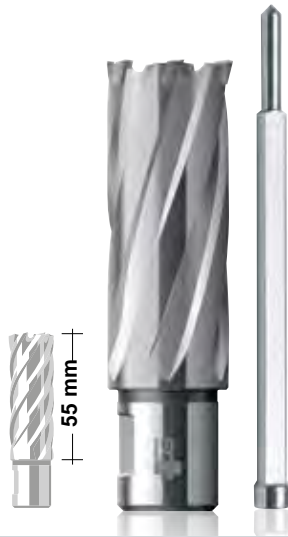
ZAK 090

# Carbide (TCT)

## Tungsten Carbide Tip Core Drills

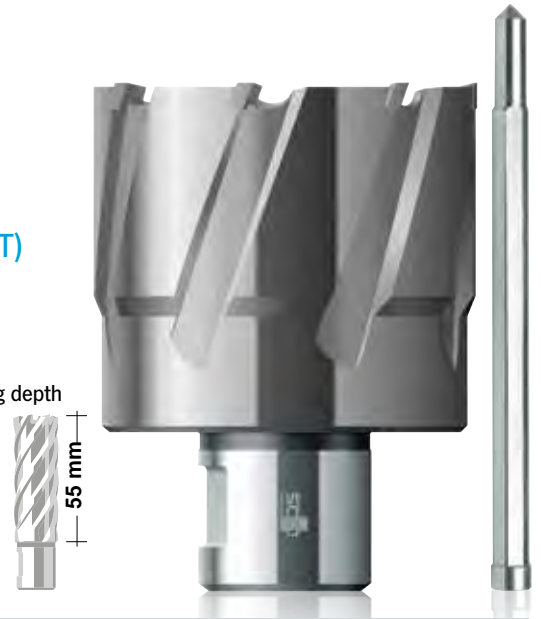
### Carbide (TCT) Core Drills Long

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



### Carbide (TCT) Core Drills Long

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



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

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

EJECTOR PIN FOR HKL, Ø 14 – 60 mm  
**ORDER NO.**  
 ZAK 100

EJECTOR PIN FOR HKL, Ø 61 – 100 mm  
**ORDER NO.**  
 ZAK 120



## Carbide (TCT) Core Drills Overlong

- > 75 mm cutting depth
- > up to Ø 60 mm:  
19 mm Weldon shank (3/4")
- > from Ø 61 mm  
32 mm Weldon shank (1 1/4")



## Carbide (TCT) Core Drills Overlong

- > 110 mm cutting depth
- > up to Ø 60 mm:  
19 mm Weldon shank (3/4")
- > from Ø 61 mm  
32 mm Weldon shank (1 1/4")



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

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

### EJECTOR PIN FOR HKX-L, Ø 18 – 120 mm

#### ORDER NO. VERSION

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

### EJECTOR PIN FOR HKE-L, Ø 20 – 120 mm

#### ORDER NO. VERSION

- ZAK 275 Two-part version

# Carbide-PLUS

Carbide-tipped core drills with carbide coating.

## Carbide-PLUS Short core drill

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



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

# Carbide-RAIL

Carbide-tipped core drills for railway track drilling.

## Carbide-RAIL core drill

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



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



EJECTOR PIN FOR HKK-P, Ø 14 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK-R, Ø 17 – 36 mm

ORDER NO.

ZAK 075

# Quick-In HSS-Co 8-F

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

## HSS-Co 8-F short core drill

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



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

# Quick-In carbide-F

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

## Short carbide-F core drill

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



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

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

ORDER NO.

ZAK 096

EJECTOR PIN FOR HKK-F, Ø 12 – 60 mm

ORDER NO.

ZAK 096



# Core drill box

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

## Core drill sets 5 core drills

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



### HSS-Standard short core drill



#### CORE DRILL BOX

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

### HSS-VarioPLUS short core drill



#### CORE DRILL BOX

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

### HSS-Co short core drill



#### CORE DRILL BOX

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

### HSS-Standard long core drill



#### CORE DRILL BOX

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

### HSS-VarioPLUS long core drill



#### CORE DRILL BOX

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

### Short carbide core drill



#### CORE DRILL BOX

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

# Core drill case

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

Core drill sets  
6 core drills  
plus 1 ejector pin

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



## HSS-Co 8 short core drill



## HSS-Standard short core drill



## HSS-VarioPLUS short core drill



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

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

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

# Twist drills, countersinks and machine screw taps

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



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

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



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

3-fluted countersink 90°,  
3 cutting edges



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



# Combi tool set and starter kit

## COMBINATION TOOL SET

ORDER NO. STANDARD/SIZE

ZGK 001

### BDS combi tool set, 8-piece

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

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



## BDS TOOL SET STARTER KIT

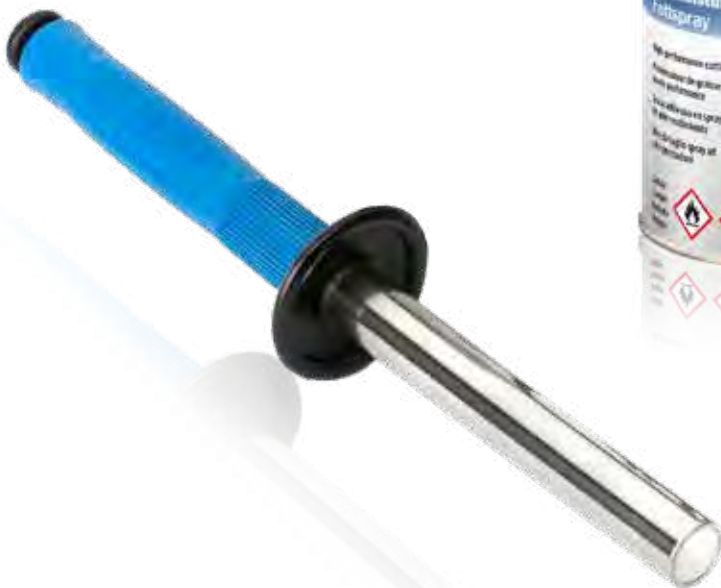
ORDER NO.

ZST 400

### Contents:

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

**PRICE ADVANTAGE!**

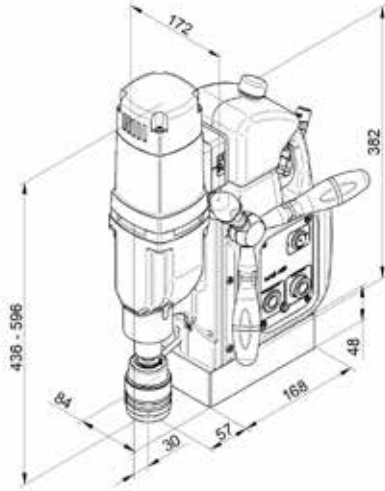


# Technical drawings

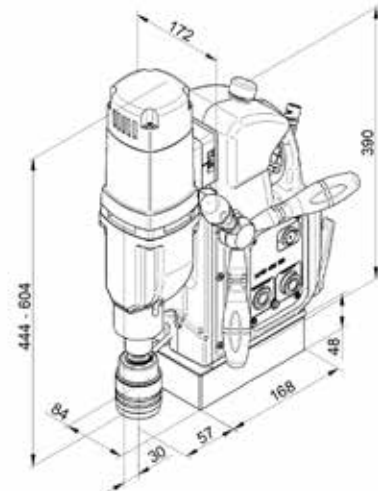
The dimensions of the BDS magnetic core drilling machines.



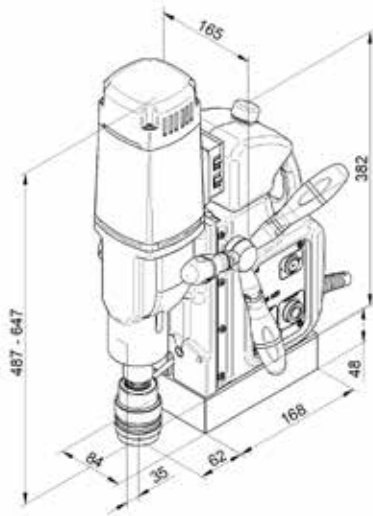
MAB 485



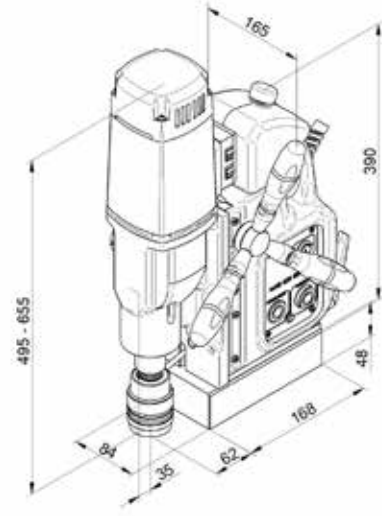
MAB 485 Swivel Base



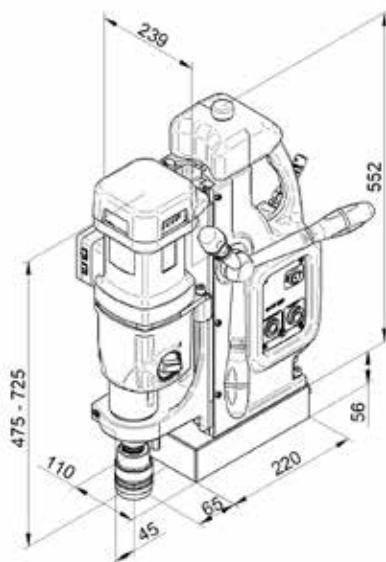
MAB 525



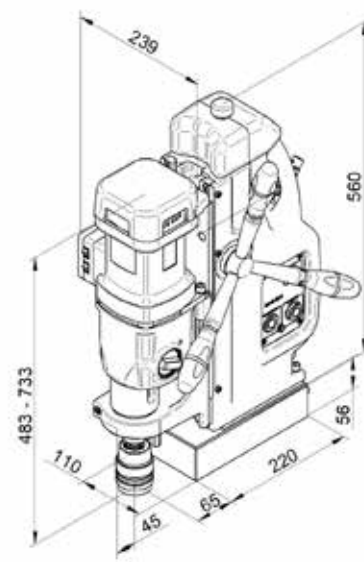
MAB 525 Swivel Base



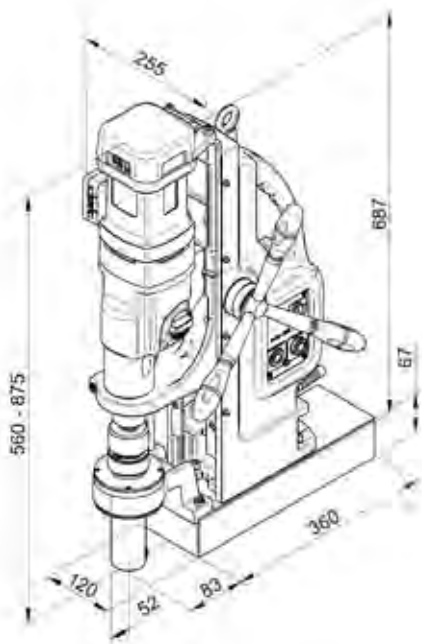
MAB 825



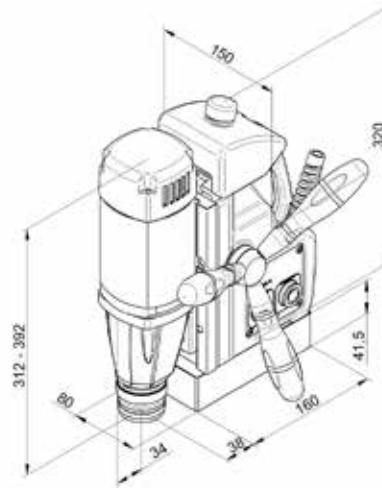
MAB 845 Swivel Base



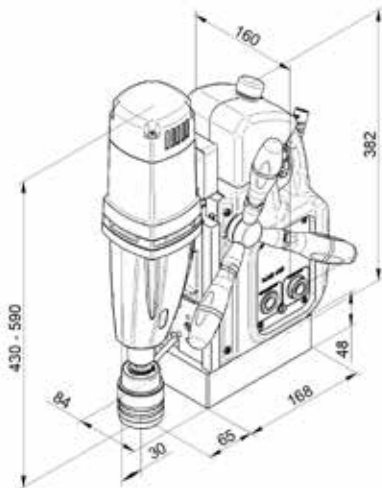
MAB 1300



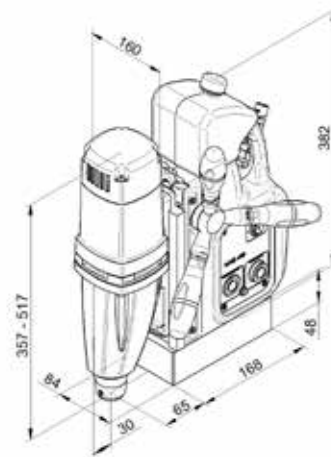
MAB 100K



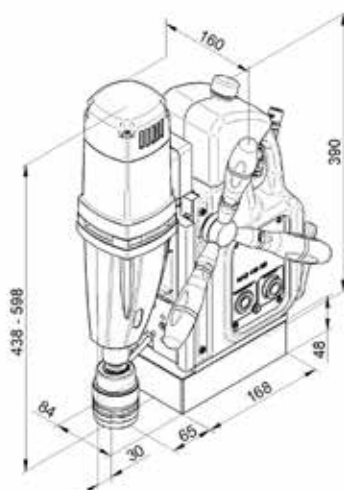
MAB 455



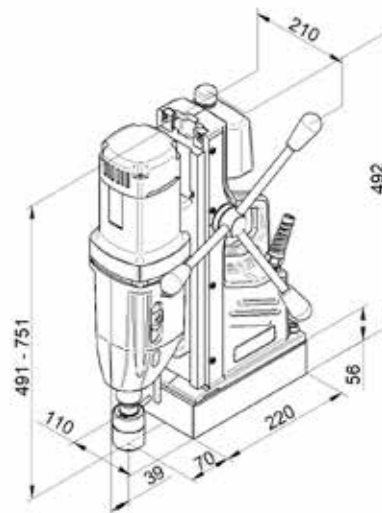
MAB 465



MAB 455 Swivel Base



MABasic 850



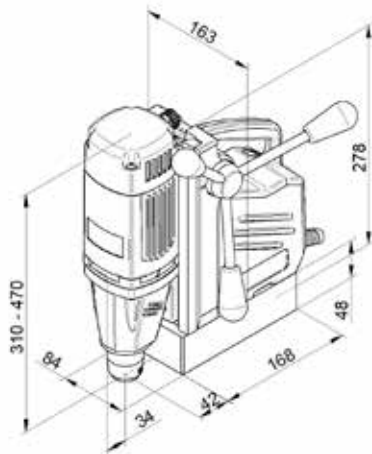


# Technical drawings

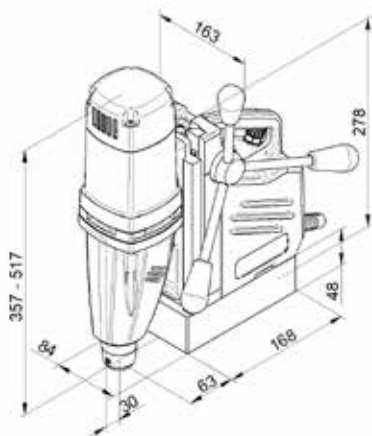
The dimensions of the MAB magnetic core drilling machine.



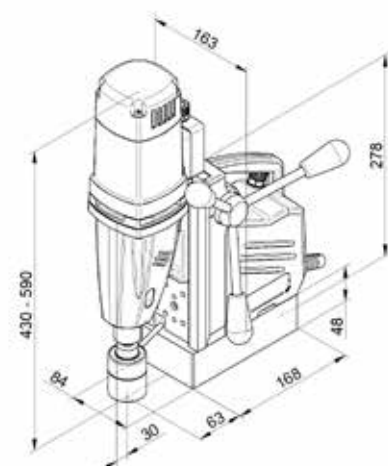
MABasic 200



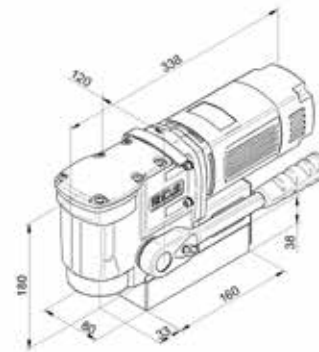
MABasic 400



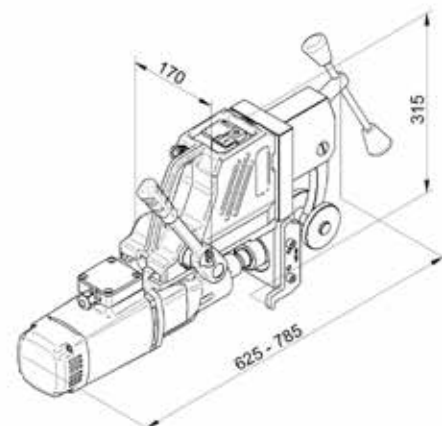
MABasic 450



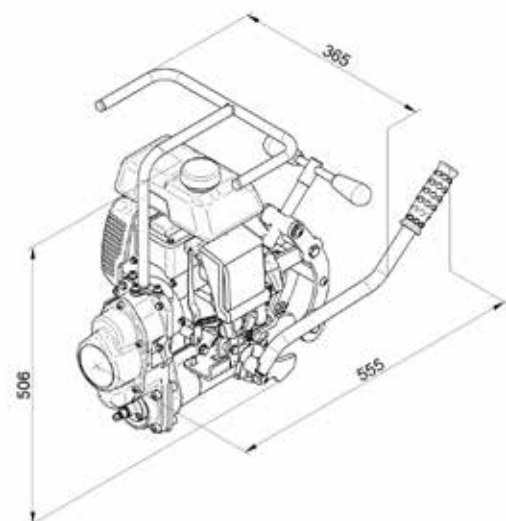
MAB 155



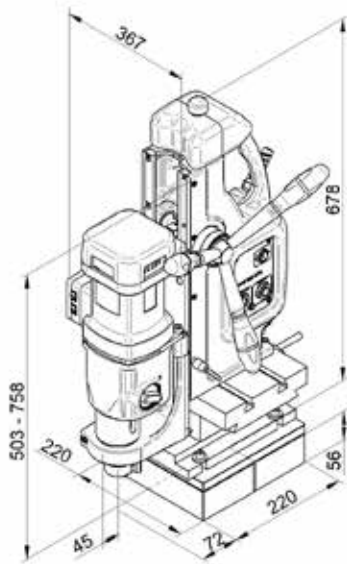
RailMAB 915



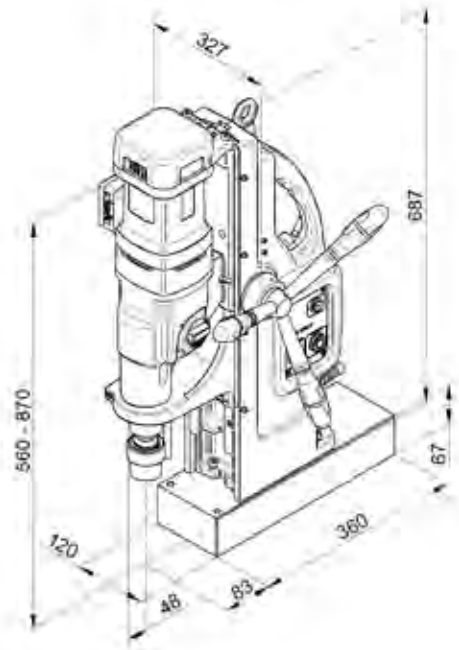
RailMAB 965



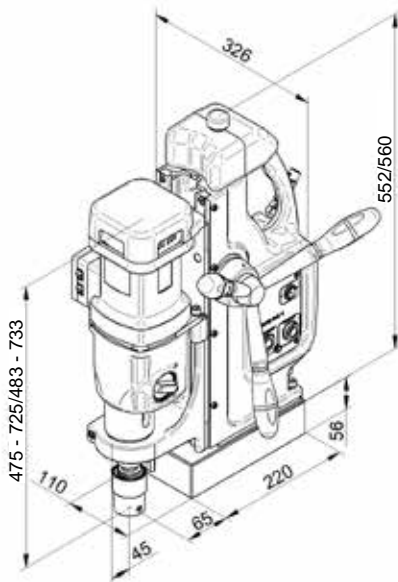
### MAB 825 KTS



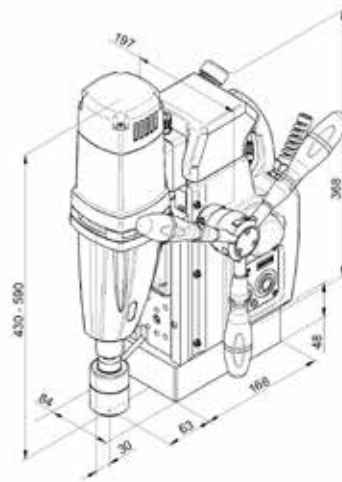
### MAB 1300 V



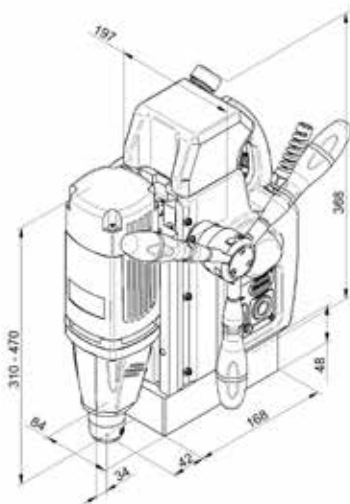
### MAB 825 V / 845 V



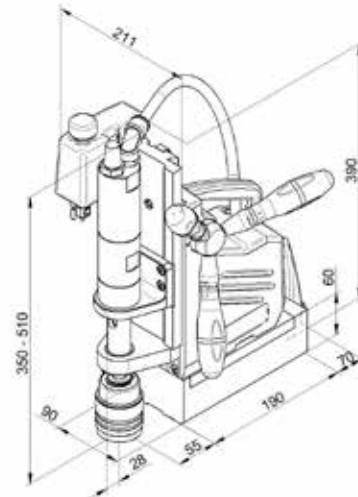
### AutoMAB 450



### AutoMAB 350



### AirMAB 5000



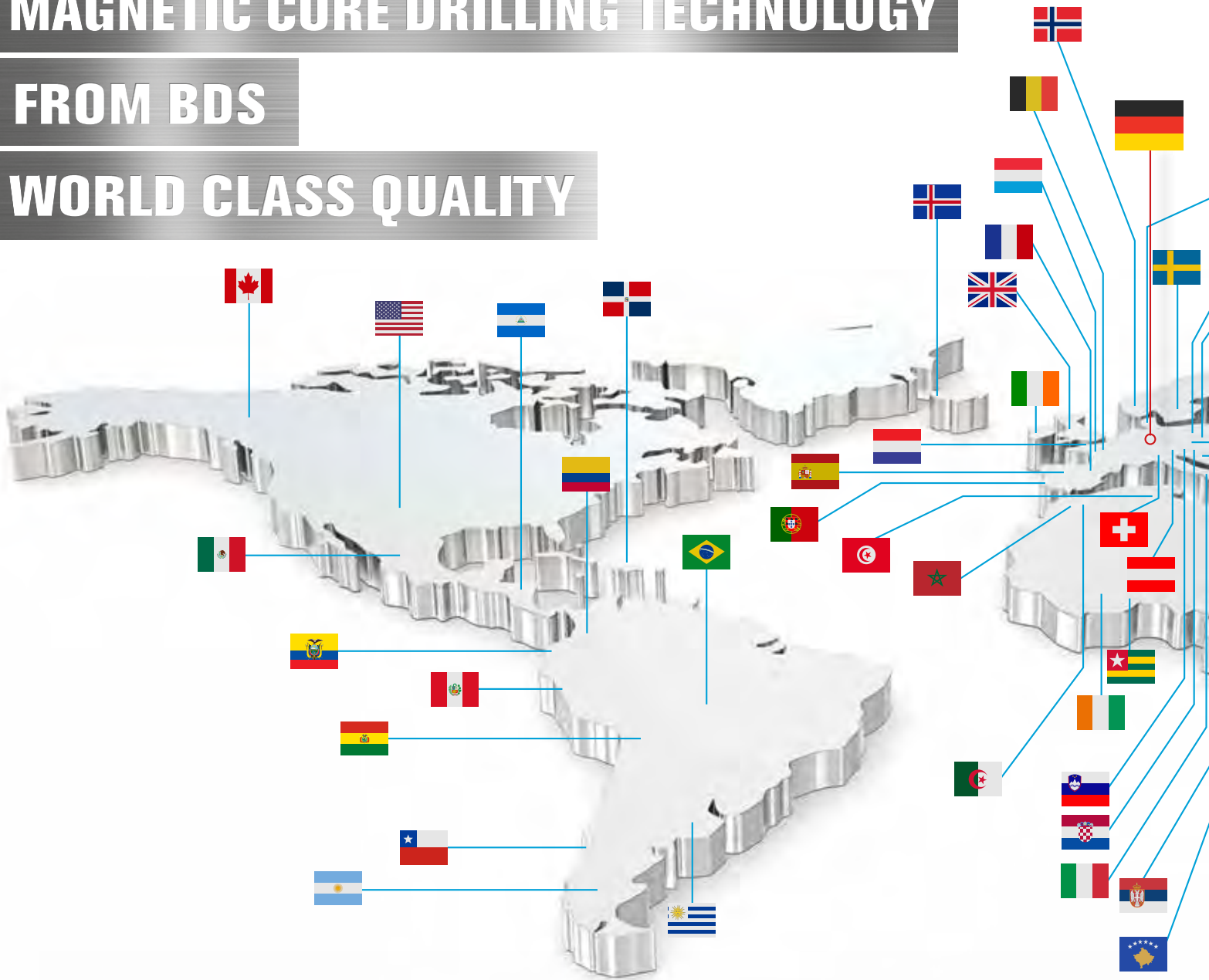
# Popular with and trusted by metal professionals throughout the world.

Quality gets around. Even around the world.

## MAGNETIC CORE DRILLING TECHNOLOGY

### FROM BDS

### WORLD CLASS QUALITY



BDS company headquarters and manufacturing in Mönchengladbach



CNC-controlled core drill manufacturing



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



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

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

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



Sharpening BDS core drills



Machine assembly hall in the Mönchnegladbach, Germany plant

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