

BDS CORE DRILLS 2016 PROGRAMME

Simply Better Drilling

PROFESSIONAL DRILLING TECHNOLOGY

PREMIUM QUALITY

NO COMPROMISE



Simply Better Drilling.

„One who uses BDS Machines & Core Drills knows it immediately that he is using a world-class product. We work hard every day for you to make sure that your professional work becomes easier, better and safer. You can be sure, if you use BDS products, you have made a correct decision both, technically and financially!“

Yours, Martin Dürr
Director BDS Maschinen GmbH



BDS core-drilling technology is used in a wide range of areas:

- ▶ Structural steelwork engineering
- ▶ Pre Engineered Buildings
- ▶ Overhead line construction
- ▶ Building construction
- ▶ Tank construction
- ▶ Plant construction
- ▶ Tool construction
- ▶ Pipeline construction
- ▶ Mechanical engineering
- ▶ Railway construction
- ▶ Mining
- ▶ Vehicle construction
- ▶ Shipbuilding
- ▶ Aircraft construction
- ▶ Workshop
- ▶ Assembly jobs
- ▶ Service and others...

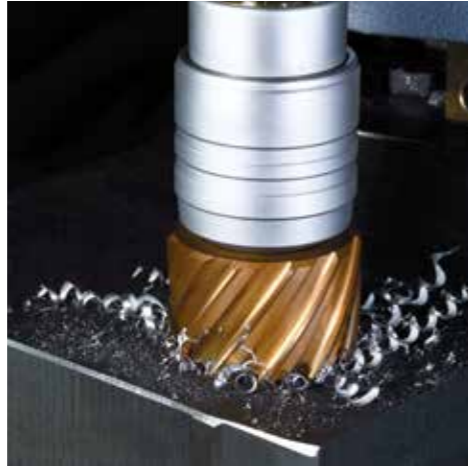


CORE DRILLS PRODUCTION AT THE HIGHEST LEVEL



BDS High-Tech: Core Drills grinding centre at the Mönchengladbach, Germany production facility.

The range of fully ground core drills.



HSS-Co 8 Series

- ▶ High thermal resistance
- ▶ Better wear protection
- ▶ High proportion of cobalt at 8 %
- ▶ Suitable for higher levels of stress in fine-grained steel and stainless material
- ▶ With 19 mm or 32 mm Weldon shank
- ▶ Regrindable

HSS-VarioPLUS Series

- ▶ High-strength fully ground core drills
- ▶ Hard coating in the range of 2.5 μ
- ▶ Longer life
- ▶ More uniform removal of chips, particularly with long drills – an important aspect for occupational safety

HSS-Standard Series

- ▶ Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- ▶ Core drill diameters from 12 mm to 130 mm
- ▶ Regrindable

Professional quality for professional tasks.



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

Extensive programme range

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

Tool holders

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

Carbide Series and Carbide-PLUS Series (TCT)

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



- Tool holders:**
- ① 19 mm Weldon shank (3/4")
 - ② 32 mm Weldon shank (1 1/4")
 - ③ 18 mm Quick-In shank

HSS-Co8 Series

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



HSS-Co 8 Series

| | |
|---------------|---------------|
| KBK-CO | KBL-CO |
| 30 mm | 55 mm |
| 12 – 130 mm | 12 – 100 mm |

HSS-VarioPLUS Series

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



HSS-VarioPLUS Series

| | |
|---------------|---------------|
| KBK-VP | KBL-VP |
| 30 mm | 55 mm |
| 12 – 60 mm | 12 – 60 mm |

HSS-Standard Series

Fully ground core drills made of high-speed steel.



HSS-Standard Series

| | | | |
|------------|------------|------------|----------------|
| KBK | KBL | KEL | KBK-Z |
| 30 mm | 55 mm | 110 mm | 30 mm |
| 12 – 60 mm | 12 – 60 mm | 20 – 50 mm | 1/2" – 2 1/16" |

Carbide Series

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



Carbide Series

| | | | |
|-------------|-------------|--------------|--------------|
| HKK | HKL | HXX-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

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



Carbide-PLUS Series

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

Carbide-RAIL Series

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



Carbide-RAIL Series

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

Quick-In Series

HSS-Co 8-F/Carbide Core drills made of HSS tool steel or carbide tipped. Suitable for Quick-in tool holder systems.



Quick-In Series

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

Cutting depth:

Drill diameter:

CORE DRILL SERIES HSS-CO 8



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

HSS-Co 8 Core drill short

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



| HSS-CO 8 SERIES | | | |
|-----------------|------------|------|------------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBK-CO 012 | 36 | KBK-CO 036 |
| 13 | KBK-CO 013 | 37 | KBK-CO 037 |
| 14 | KBK-CO 014 | 38 | KBK-CO 038 |
| 15 | KBK-CO 015 | 39 | KBK-CO 039 |
| 16 | KBK-CO 016 | 40 | KBK-CO 040 |
| 17 | KBK-CO 017 | 41 | KBK-CO 041 |
| 17,5 | KBK-CO 175 | 42 | KBK-CO 042 |
| 18 | KBK-CO 018 | 43 | KBK-CO 043 |
| 19 | KBK-CO 019 | 44 | KBK-CO 044 |
| 19,5 | KBK-CO 195 | 45 | KBK-CO 045 |
| 20 | KBK-CO 020 | 46 | KBK-CO 046 |
| 21 | KBK-CO 021 | 47 | KBK-CO 047 |
| 22 | KBK-CO 022 | 48 | KBK-CO 048 |
| 23 | KBK-CO 023 | 49 | KBK-CO 049 |
| 24 | KBK-CO 024 | 50 | KBK-CO 050 |
| 25 | KBK-CO 025 | 51 | KBK-CO 051 |
| 26 | KBK-CO 026 | 52 | KBK-CO 052 |
| 27 | KBK-CO 027 | 53 | KBK-CO 053 |
| 28 | KBK-CO 028 | 54 | KBK-CO 054 |
| 29 | KBK-CO 029 | 55 | KBK-CO 055 |
| 30 | KBK-CO 030 | 56 | KBK-CO 056 |
| 31 | KBK-CO 031 | 57 | KBK-CO 057 |
| 32 | KBK-CO 032 | 58 | KBK-CO 058 |
| 33 | KBK-CO 033 | 59 | KBK-CO 059 |
| 34 | KBK-CO 034 | 60 | KBK-CO 060 |
| 35 | KBK-CO 035 | | |

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

HSS-Co 8 Core drill short

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



| 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 |

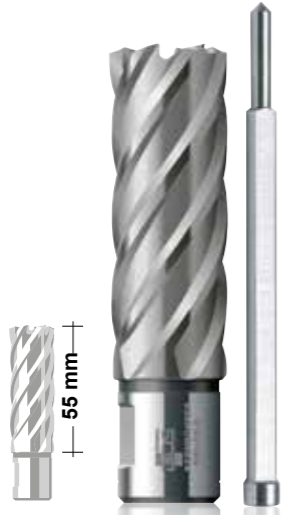
| EJECTOR PIN FOR KBK-CO, Ø 61 – 130 mm | |
|---------------------------------------|--|
| ORDER NO. | |
| ZAK 090 | |

Core Drill Series HSS-Co 8

Fully ground core drills made of high-speed steel.

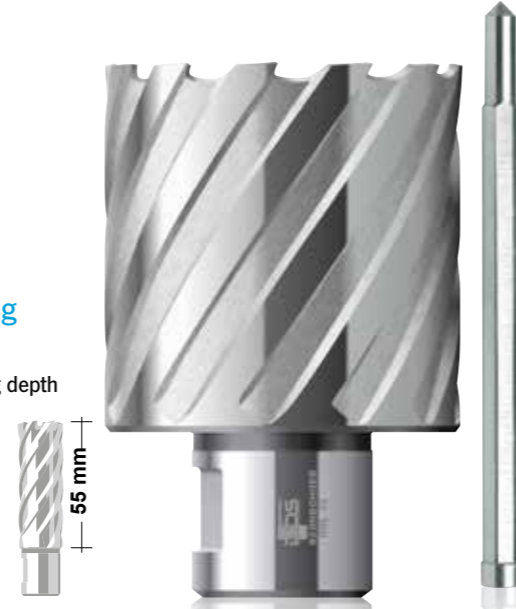
HSS-Co 8 Core drill long

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



HSS-Co 8 Core drill long

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



| HSS-CO 8 SERIES | | | |
|-----------------|------------|------|------------|
| Ø mm | ORDER NO. | Ø mm | ORDER NO. |
| 12 | KBL-CO 012 | 36 | KBL-CO 036 |
| 13 | KBL-CO 013 | 37 | KBL-CO 037 |
| 14 | KBL-CO 014 | 38 | KBL-CO 038 |
| 15 | KBL-CO 015 | 39 | KBL-CO 039 |
| 16 | KBL-CO 016 | 40 | KBL-CO 040 |
| 17 | KBL-CO 017 | 41 | KBL-CO 041 |
| 17,5 | KBL-CO 175 | 42 | KBL-CO 042 |
| 18 | KBL-CO 018 | 43 | KBL-CO 043 |
| 19 | KBL-CO 019 | 44 | KBL-CO 044 |
| 19,5 | KBL-CO 195 | 45 | KBL-CO 045 |
| 20 | KBL-CO 020 | 46 | KBL-CO 046 |
| 21 | KBL-CO 021 | 47 | KBL-CO 047 |
| 22 | KBL-CO 022 | 48 | KBL-CO 048 |
| 23 | KBL-CO 023 | 49 | KBL-CO 049 |
| 24 | KBL-CO 024 | 50 | KBL-CO 050 |
| 25 | KBL-CO 025 | 51 | KBL-CO 051 |
| 26 | KBL-CO 026 | 52 | KBL-CO 052 |
| 27 | KBL-CO 027 | 53 | KBL-CO 053 |
| 28 | KBL-CO 028 | 54 | KBL-CO 054 |
| 29 | KBL-CO 029 | 55 | KBL-CO 055 |
| 30 | KBL-CO 030 | 56 | KBL-CO 056 |
| 31 | KBL-CO 031 | 57 | KBL-CO 057 |
| 32 | KBL-CO 032 | 58 | KBL-CO 058 |
| 33 | KBL-CO 033 | 59 | KBL-CO 059 |
| 34 | KBL-CO 034 | 60 | KBL-CO 060 |
| 35 | KBL-CO 035 | | |

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

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

| EJECTOR PIN FOR KBL-CO, Ø 61 - 100 mm | |
|---------------------------------------|--|
| ORDER NO. | |
| ZAK 120 | |

The optimal way to drill and lubricate the BDS core drills.

Recommended cutting speed

| Core drill series | Material | m/min |
|----------------------|---------------------------------|---------|
| HSS-Co 8 | Fine-grain steel | |
| | < 700 N/m² | 10 – 15 |
| | < 1000 N/m² | 10 – 15 |
| | Inox | 10 – 15 |
| | Casting (depending on the type) | 15 – 20 |
| HSS-VarioPLUS | Fine-grain steel | |
| | < 700 N/m² | 10 – 15 |
| | < 1000 N/m² | 10 – 15 |
| HSS-Standard | Aluminium | 20 – 30 |
| | Steel | 25 |
| | Casting | 10 – 20 |
| Carbide | Steel/Fine-grain steel | |
| | < 500 N/m² | 35 |
| | < 700 N/m² | 25 |
| | < 1000 N/m² | 20 |
| | Stainless steel, Inox | 20 |
| Carbide-PLUS | Steel/Fine-grain steel | |
| | < 500 N/m² | 35 |
| | < 700 N/m² | 25 |
| | < 1000 N/m² | 20 |
| | Stainless steel, Inox | 20 |
| Carbide-RAIL | Railway rails | 15 – 20 |

Speed table

| Dia-meter | Vc 15 m/min | Vc 20 m/min | Vc 25 m/min | Vc 30 m/min | Vc 35 m/min |
|-----------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Ø | min ⁻¹ | min ⁻¹ | min ⁻¹ | min ⁻¹ | min ⁻¹ |
| 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 | 10 | 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 |

Cutting speed:

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

Speed:

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

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

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



CORE DRILL SERIES HSS-VARIOPLUS



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

HSS-VarioPLUS Core drill short

- > 30 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 | | |

EJECTOR PIN FOR KBK-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 075

HSS-VarioPLUS Core drill long

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



| 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 KBL-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 100

HSS-VarioPLUS

HSS-Standard

Carbide

Core Drill Sets

Holders/
Adapters

Twist drills/
Taps

Accessories/
Coolants

CORE DRILL SERIES HSS-STANDARD

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

HSS-Standard Core drill short

- > 30 mm Cutting depth
- > 19 mm Weldon shank (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 | | |

EJECTOR PIN FOR KBK, Ø 12 – 60 mm

ORDER NO.

ZAK 075

HSS-Standard Core drill long

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



| 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 KBL, Ø 12 - 60 mm

ORDER NO.

ZAK 100

HSS-Standard

Carbide

Core Drill Sets

Holders/
Adapters

Twist drills/
Taps

Accessories/
Coolants

HSS-Standard

Fully ground core drills made of high-speed steel.



HSS-Standard
Core drill extra long

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

HSS-Standard, Inches

Fully ground core drills made of high-speed steel.

HSS-Standard
Core drill short, Inches

- > 30 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 SERIES INCHES | | |
|----------------------------|--------|---------------|
| 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. | VERSION |
| ZAK 075 | |

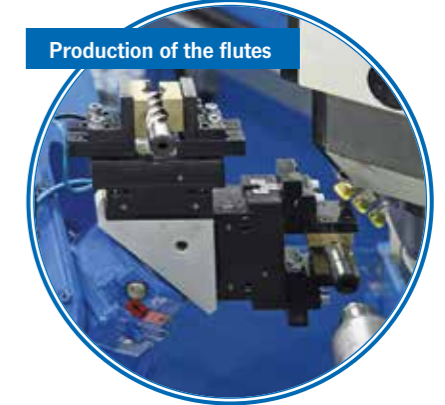
Distinct quality that makes all the difference.



Grinding end teeth
Modern CNC grinding centres ensure consistent quality.



Perfect cylindrical grinding
Highest concentricity and high dimensional stability are guaranteed by the latest generation of cylindrical grinding machines.



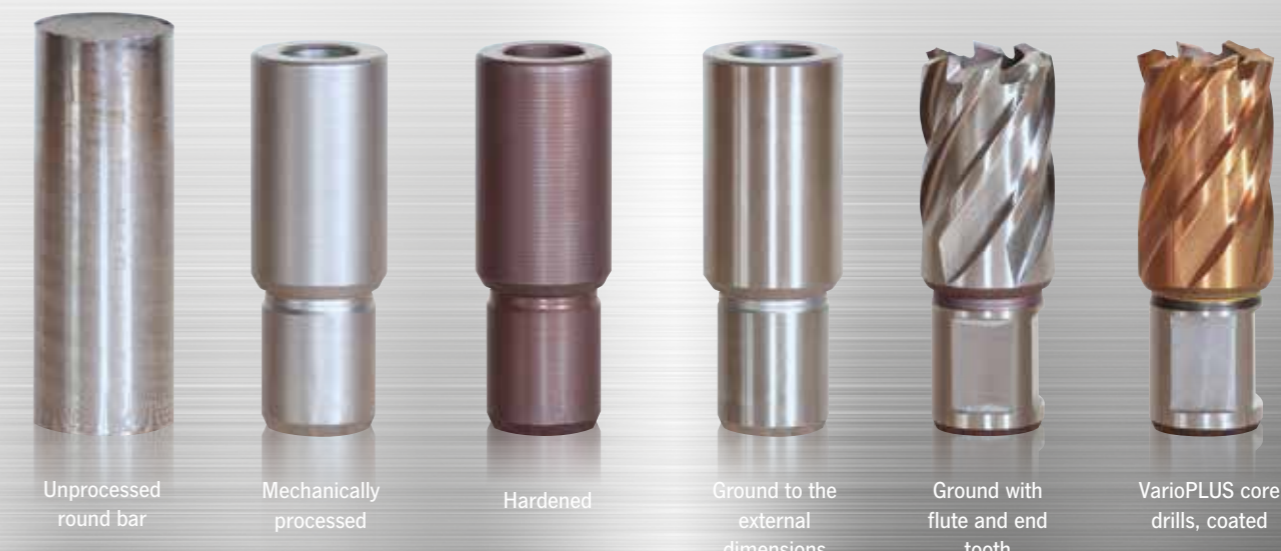
Production of the flutes
Optimised workflows and fast loading procedures using modern loading robots accelerate the work process.



VarioPLUS coating
The VarioPLUS coating developed for BDS provides an additional layer of protection for the tools. A hard material coating ensures high heat resistance and greater hardness in the coated area.

The best raw materials
BÖHLER
THE BEST STEEL IN THE WORLD
Böhler high performance tool steel guarantees consistent quality at the highest level.

From the first to the last step!
HSS-Co 8% - HSS-VarioPLUS and HSS BDS fully ground core drills



BDS MASCHINEN
MADE IN GERMANY

HSS-Standard
Carbide
Core Drill Sets
Holders/ Adapters
Twist drills/ Taps
Accessories/ Coolants

CARBIDE CORE DRILL SERIES



Carbide-tipped (TCT) BDS core drills. Series with cutting depths of 30 mm, 35 mm, 55 mm, 75 mm and 110 mm and almost gapless range of diameters from 12 mm to 150 mm. For the processing of stainless steel and non-ferrous metals, BDS recommends using the high-performance cooling lubricant concentrate BDS 6000.

Carbide (TCT) Core drill short

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



| 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 | | |

EJECTOR PIN FOR HKK, Ø 14 - 60 mm

ORDER NO.

ZAK 075

Carbide (TCT) Core drill short

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



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

EJECTOR PIN FOR HKK, Ø 61 - 150 mm

ORDER NO.

ZAK 090

Carbide (TCT)

Carbide-tipped core drills.

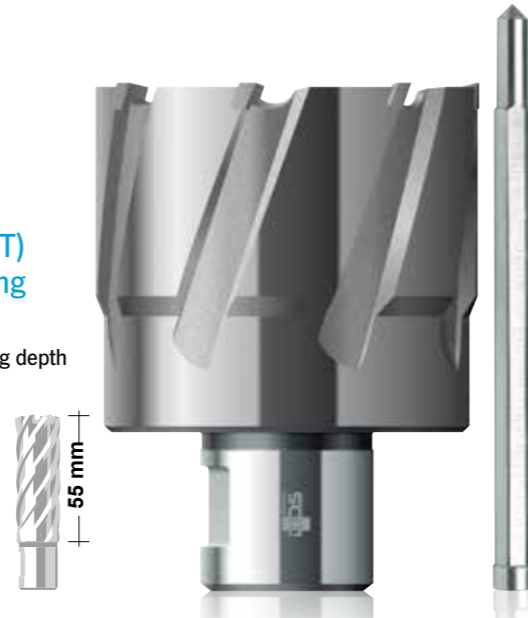
Carbide (TCT) Core drill long

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



Carbide (TCT) Core drill long

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



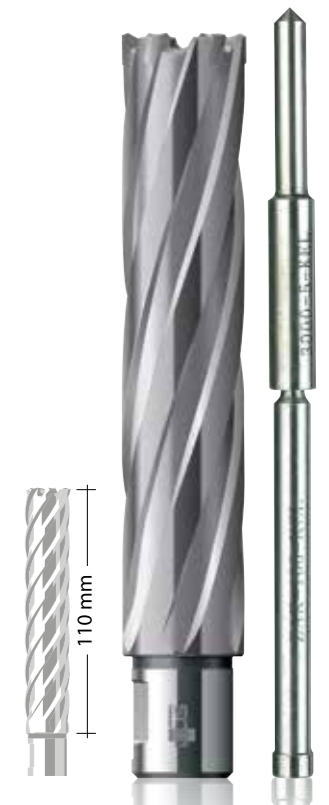
Carbide (TCT) Core drill overlong

- > 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 drill extralong

- > 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. |
| 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 |

| 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 | HKX-L 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 HKL Ø 14 - 60 mm | |
|----------------------------------|---------|
| ORDER NO. | VERSION |
| ZAK 100 | |

| EJECTOR PIN FOR HKL Ø 61 - 100 mm | |
|-----------------------------------|---------|
| ORDER NO. | VERSION |
| ZAK 120 | |

| EJECTOR PIN FOR HKX-L Ø 18 - 120 mm | |
|-------------------------------------|---|
| ORDER NO. | VERSION |
| ZAK 225 | Two-part for core drills Cutting depth 75 mm Ø 18-60 |
| ZAK 245 | Two-part for core drills Cutting depth 75 mm Ø 61-120 |

| EJECTOR PIN FOR HKE-L Ø 20 - 120 mm | |
|-------------------------------------|------------------|
| ORDER NO. | VERSION |
| ZAK 275 | Two-part Version |

Carbide-PLUS

Carbide-tipped core drills with carbide coating.

Carbide-PLUS Core drill short

- > 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 | | |

EJECTOR PIN FOR HKK-P Ø 14 - 60 mm

ORDER NO.
ZAK 075

Carbide-RAIL

Carbide-tipped core drills for rail core drilling machines.

Carbide-RAIL Core 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-R, Ø 17 - 36 mm

ORDER NO.
ZAK 075

Quick-In HSS-Co 8-F

Core drills made of tool steel with a percentage of cobalt for greater heat resistance and wear protection. For Quick-in tool holder systems.

HSS-Co 8-F Core drill short

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



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

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

ORDER NO.
ZAK 096

Quick-In Carbide-F

Carbide-tipped core drills. For Quick-in tool holder systems.

Carbide-F Core drill short

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



| QUICK-IN 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 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 set, 5 pieces, 5 core drills

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



HSS-Standard Core drill short



| CORE DRILL-BOX | |
|----------------|---|
| ORDER NO. | CONTENTS |
| KBK Box 1 | 2 x KBK 014 2 x KBK 018 1 x KBK 022 |

HSS-VarioPLUS Core drill short



| CORE DRILL-BOX | |
|----------------|--|
| ORDER NO. | CONTENTS |
| KBK Box 1-V | 2 x KBK-VP 014 2 x KBK-VP 018 1 x KBK-VP 022 |

Carbide Core drill short



| CORE DRILL-BOX | |
|----------------|---|
| ORDER NO. | CONTENTS |
| HKK Box | 2 x HKK 014 2 x HKK 018 1 x HKK 022 |

HSS-Standard Core drill long



| CORE DRILL-BOX | |
|----------------|---|
| ORDER NO. | CONTENTS |
| KBL Box 1 | 2 x KBL 014 2 x KBL 018 1 x KBL 022 |

HSS-VarioPLUS Core drill long



| CORE DRILL-BOX | |
|----------------|--|
| ORDER NO. | CONTENTS |
| KBL Box | 2 x KBL-VP 014 2 x KBL-VP 018 1 x KBL-VP 022 |

Carbide-PLUS Core drill short



| CORE DRILL-BOX | |
|----------------|---|
| ORDER NO. | CONTENTS |
| HKK Box | 2 x HKK-P 014 2 x HKK-P 018 1 x HKK-P 022 |

Core Drill Cassette

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

Core drill set, 7 pieces, 6 core drills and one ejector pin

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



HSS-Co 8 Core drill short



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

HSS-Standard Core drill short



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

HSS-VarioPLUS Core drill short



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

Tool holders and Adapters

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

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



QUICK CHANGE DRILL CHUCK SYSTEM KEYLESS

| ORDER NO. | SPINDLE HOLDER |
|-----------|----------------|
| ZSS 200 | MK 2 |
| ZSS 300 | MK 3 |

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

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



INDUSTRIAL ARBOR WITH MANUAL INTERNAL LUBRICATION

| ORDER NO. | SPINDLE HOLDER |
|-----------|----------------|
| ZIA 219-M | MK 2 |
| ZIA 319-M | MK 3 |
| ZIA 419-M | MK 4 |

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

| | |
|-----------|------|
| ZIA 332-M | MK 3 |
| ZIA 432-M | MK 4 |

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

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



INDUSTRIAL ARBOR WITH AUTOMATIC INTERNAL LUBRICATION

| ORDER NO. | SPINDLE HOLDER |
|------------|----------------|
| ZIA 219-KN | MK 2 |
| ZIA 319-KN | MK 3 |
| ZIA 419-KN | MK 4 |

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

| | |
|------------|------|
| ZIA 332-KN | MK 3 |
| ZIA 432-KN | MK 4 |

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

With hose and quick acting coupling.



REDUCING BUSH DIN 2185

| ORDER NO. | OUTSIDE | INSIDE |
|-----------|---------|--------|
| ZRH 210 | MK 2 | MK 1 |
| ZRH 320 | MK 3 | MK 2 |
| ZRH 430 | MK 4 | MK 3 |



EXTENSION BUSH DIN 2178

| ORDER NO. | OUTSIDE | INSIDE |
|-----------|---------|--------|
| ZVH 220 | MK 2 | MK 2 |
| ZVH 230 | MK 2 | MK 3 |
| ZVH 320 | MK 3 | MK 2 |
| ZVH 330 | MK 3 | MK 3 |

Adapters with Weldon shank

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

32 mm (1 1/4")



ADAPTER

ORDER NO.

ZAP 200

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

19 mm (3/4")



ADAPTER

ORDER NO.

ZAF 002

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

19 mm (3/4")



ADAPTER

ORDER NO.

ZAF 003

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

19 mm (3/4")



EXTENSION

ORDER NO.

ZAP 300

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

Adapter for Nitto One-touch



ADAPTER

ORDER NO.

ZAF 005

With Nitto one-touch holder for core drills with 19 mm (3/4") Weldon shank each incl. 1 ejector pin ZAK 107 und 125

Adapter for Fein QUICK-IN



ADAPTER

ORDER NO.

ZAF 004

With Quick-in holder for core drills with 19 mm (3/4") Weldon shank each incl. 1 ejector pin ZAK 107 und 125

Twist drills, Countersinks and Taps

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



| Ø | Working 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 tap 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 |

Taper and deburring countersinker
90° three 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 | MK3 | ZSE 340 |
| 50 | MK3 | ZSE 350 |

Combi Tool Set and StarterKIT

COMBI TOOL SET

ORDER NO. STANDARD/SIZE

ZGK 001

BDS Combi Tool Set , 8-pcs.

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

| | |
|----------------------|------------------------|
| 1 St. Twist drill | DIN 338, Ø 6,8 mm |
| 1 St. Twist drill | DIN 338, Ø 8,5 mm |
| 1 St. Twist drill | DIN 338, Ø 10,2 mm |
| je 1 St. machine tap | DIN 371, M8 |
| | DIN 376, M10, M12, M16 |
| 1 St. Countersinks | DIN 335 |
| | Form C 90° Ø 20,5 mm |



BDS StarterKIT TOOL SET

ORDER NO.

ZST 400

Contents:

- 1 Combi Tool Set ZGK 001
- 1 liter BDS lubrication spray ZHS 400
- 1 BDS PowerWORKER



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

PowerCLEANER

PowerCLEANER

ORDER NO.

POW 200

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



Remove sharp-edged metal chips



Clean the work surface

Original BDS accessories for magnetic core drilling machines

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

PowerWORKER

PowerWORKER

ORDER NO.

POW 100



Magnetise, collect together...



Demagnetise and finished!

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

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

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

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

BDS StarterKIT PowerCLEANER

ORDER NO.

ZST 200

Contents:

- 1 Standard-Core Drill Box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 litre of High-performance cutting oil BDS 5000
- 1 BDS PowerCLEANER



BDS ÖkoLogisch

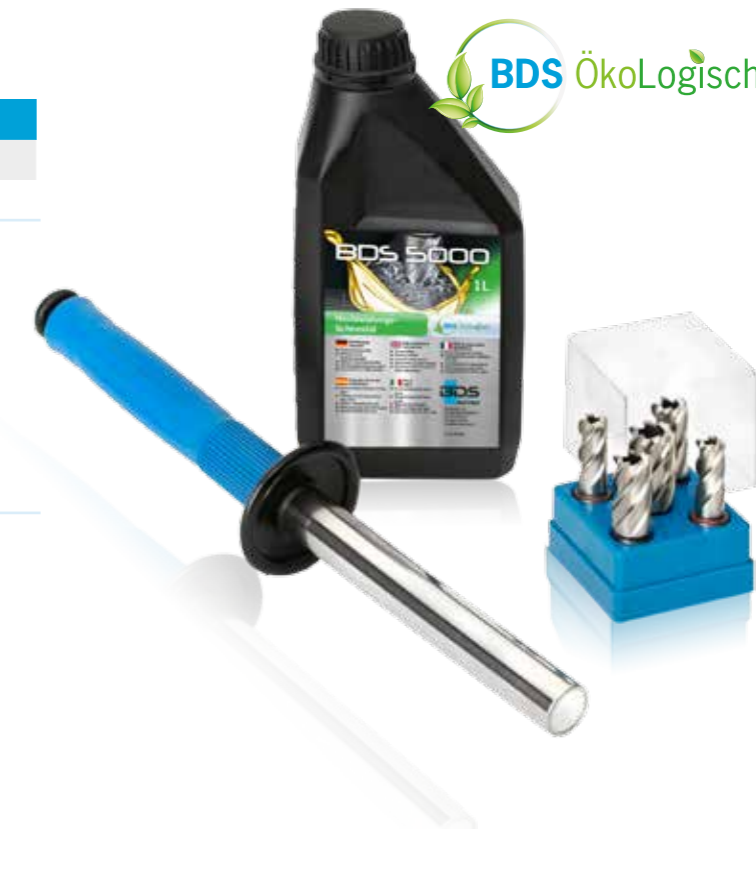
BDS StarterKIT PowerWORKER

ORDER NO.

ZST 100

Contents:

- 1 Standard-Core Drill Box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 litre of High-performance cutting oil BDS 5000
- 1 BDS PowerWORKER



BDS ÖkoLogisch

Cutting oil, lubrication spray, lubrication paste and cooling lubricant

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

The best working result - for the nature!!

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

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

High-performance lubrication spray **BDS 5200**



Suitable for working under special conditions (overhead and vertical surface) and also for high-alloy materials. Foam-like spray with very high adhesive force. Advantages: Exact dosage of the lubrication spray and thus, optimal lubrication directly on the drill cutters. No drop formation and spraying around, and thus, maximum occupational safety on ladders and work platforms.

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

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



High-performance cutting oil **BDS 5000**

Cooling lubricant **BDS 6000**

High-performance-Cutting paste **BDS 5500**



Recommended for High Speed Steel Core Drills. Pure vegetable oil that is not a hazardous good in the context of import-export regulations. The base materials used are not described in the catalogue of water endangering substances. BDS 5000 do not have to be specifically labelled.

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



Recommended for carbide (TCT) Core Drills. For high demands based on synthetic raw materials.

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



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



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

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



| CUTTING OIL | | |
|-------------|----------------------|-------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 005 | BDS 5000 cutting oil | 5 Liter Can |
| ZHS 006 | BDS 5000 cutting oil | 1 Liter Can |

| COOLING LUBRICANT | | |
|-------------------|----------------------------|-------------|
| ORDER NO. | NAME | CONTENT |
| ZHB 001 | BDS 6000 Cooling lubricant | 1 Liter Can |

| CUTTING PASTE | | |
|---------------|------------------------|------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 550 | BDS 5500 Cutting paste | 1000 g Can |

| LUBRICATION SPRAY | | |
|-------------------|----------------------------|-----------------|
| ORDER NO. | NAME | CONTENT |
| ZHS 400 | BDS 5200 lubrication spray | 1 x 400 ml Can |
| ZHS 406 | BDS 5200 lubrication spray | 6 x 400 ml Can |
| ZHS 412 | BDS 5200 lubrication spray | 12 x 400 ml Can |

DO YOU HAVE ANY QUESTIONS? WE HAVE THE ANSWERS!

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



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BDSMASCHINEN
MADE IN GERMANY

BDS
MASCHINEN

BDS Maschinen GmbH
Martinstraße 108
D-41063 Mönchengladbach
Telefon +49(0)21 61/35 46-0
Fax +49(0)21 61/35 46-15
www.bds-maschinen.de
info@bds-maschinen.de

