5 Series – 1,000 possibilities

You keep a clear view.

The tools of BDS machines are optimized for use with MAB magnetic core drilling machines. What job you face, you will find the correct solution for your requirement:

- **Constructional steelwork**
- **Construction of pressure vessels**
- **Pipeline construction**
- **Mechanical engineering**





The core drill series

Standard Series

Fully ground HSS core drills

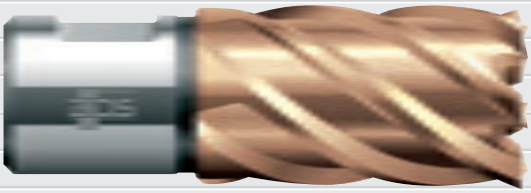
Tool holder:	Weldon 19 mm (3/4")
	Weldon 32 mm (1 1/4")



VarioPLUS Series

Fully ground HSS core drills with VarioPLUS hard coating

Tool holder:	Weldon 19 mm (3/4")



NEW

HKK Series

Sintered carbide core drills

Tool holder:	Weldon 19 mm (3/4")
	Nitto One-Touch
	FEIN Quick-In



HKK-PLUS Series

Sintered carbide core drills with hard coating

Tool holder:	Weldon 19 mm (3/4")
	Nitto One-Touch



NEW

HKK-Rail Series

Sintered carbide core drills for railway rails

Tool holder:	Weldon 19 mm (3/4")



NEW



Application focuses, cutting speed, lubrication

Core drill series	Material						
Lubrication/	Aluminium/non-	Steel	Fine-grain steel	Fine-grain steel	Stainless steel	Casting	Railway rails
Cooling lubricant	ferrous metals	< 500 N/m²	< 700 N/m²	< 1000 N/m²	Inox		
							
Standard	25–30 m/min	25 m/min				10–20 m/min	
Lubricant Oil		•					
Grease spray		•					
Grease paste							
Spezialschmierstoff	•						
							
VarioPLUS			10–15m/min	10–15m/min	10–15m/min		
Lubricant Oil			•	•	•		
Grease spray			•	•	•		
Grease paste				•	•		
Special lubricant				•	•		
							
HKK		35 m/min	25 m/min	20 m/min VCE	20 m/min VCE		
Cooling lubricant/		•	•	•	•		
Drilling emulsion		•	•	•	•		
							
HKK-PLUS		35 m/min	25 m/min	20 m/min	20 m/min		
Cooling lubricant/		•	•	•	•		
Drilling emulsion		•	•	•	•		
							
HKK-Rail							15–20 m/min
Cooling lubricant/							
Drilling emulsion							

VCE = Full wave control electronics

Cutting speed:

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

Speed:

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

The BDS core drill guide

Extensive programme range, cutting depth and drill diameter

Extensive programme range:

BDS core drills are available in 4 cutting depths of 30, 50, 55, and 110 mm and more than 94 different drill diameters from 12 mm to 140 mm.

Advantage:

High flexibility due to a maximum user-friendly assortment depth.

The Drive:

BDS core drill tools are available with various tool holders:

- Weldon shank holder 19 mm (3/4") and
- Weldon shank holder 32 mm (1 1/4")

Sintered carbide core drills:

- FEIN Quick-In holder
- Combi shank with: Weldon 19 mm (3/4"), Nitto One-Touch and Alfra Rota-Quick

Advantage:

Compatibility with major worldwide industrial standards.

Standard Series	
Designation:	**KBK**
Cutting depth:	30 mm
Drilling ø:	12 – 130 mm



Designation:	**KBL**
Cutting depth:	55 mm
Drilling ø:	12 – 100 mm



Designation:	**KEL**
Cutting depth:	110 mm
Drilling ø:	20 – 50 mm



Vario Series	
Designation:	**KBK-VP**
Cutting depth:	30 mm
Drilling ø:	12 – 60 mm

NEW



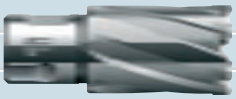
Designation:	**KBL-VP**
Cutting depth:	55 mm
Drilling ø:	12 – 60 mm

NEW



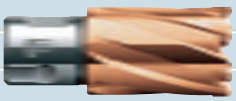
HKK Series	
Designation:	**HKK**
Cutting depth:	30 mm
Drilling ø:	14 – 150 mm

NEW



HKK-PLUS Series	
Designation :	**HKK-P**
Cutting depth:	30 mm
Drilling ø:	14 – 60 mm

NEW



HKK-Rail Series	
Designation :	**HKL-Rail**
Cutting depth:	50 mm
Drilling ø:	17 – 36 mm

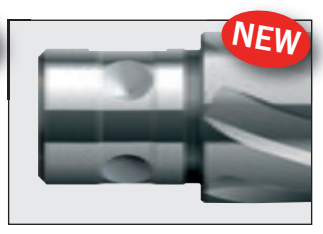
NEW





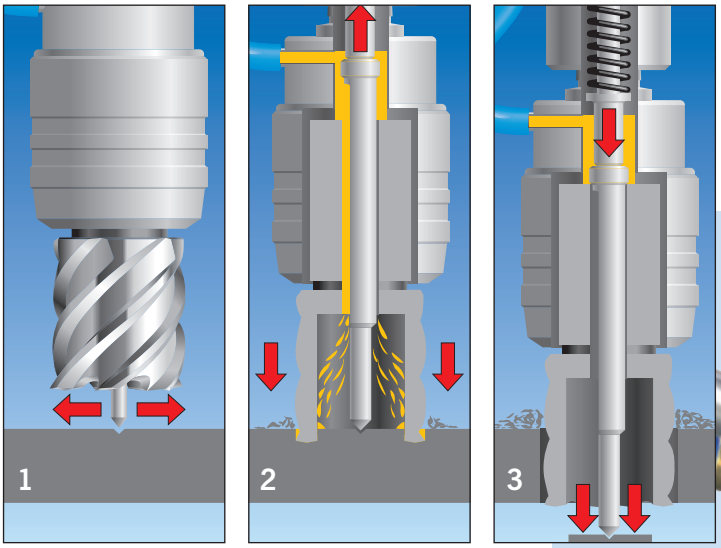
NEW

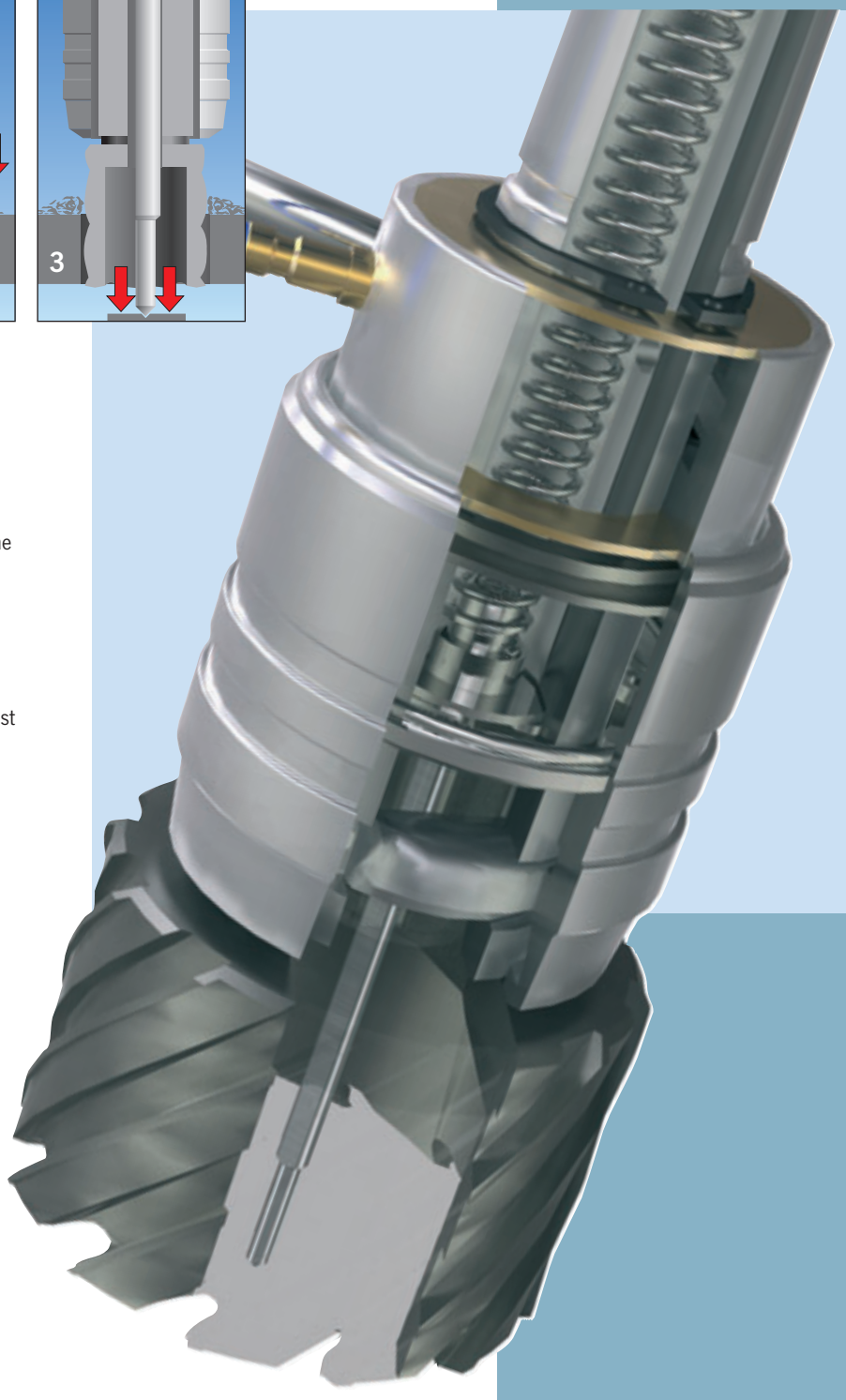
Combi shank with Weldon 19 mm (3/4"), Nitto One-Touch and Alfra Rota-Quick



NEW

FEIN Quick-In drive





The functions of the BDS ejector pin

1. Centring:
The ejector pin is exactly positioned to the centre punch mark. Switch the magnet on and the machine and tool are in the drilling position.

2. Oiling:
By means of the automatic internal lubrication, cutting oil is supplied via the ejector pin to the bit in just the right quantity.

3. Ejecting:
In the final stage, the ejector pin, pre-stressed by means of a spring, pushes the core out of the drill hole.

Standard Series – tools on a high level.

Fully ground core drills, short version, metric.

Standard core drill KBK
Cutting depth 30 mm Weldon shank 19 mm (3/4")



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

Ejector pin for core drills short version ø 12-60 mm



Order No.
ZAK 075

Set of standard core drills



Order No.	Content
KBK 001	2 x KBK 014
	2 x KBK 018
	2 x KBK 020
	1 x ZAK 075

Order No.	Content
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



Standard core drill KBK
Cutting depth 30 mm Weldon shank 32 mm (1 1/4")





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

Ejector pin for core drills short version ø 61-130 mm



Order No.
ZAK 090



BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- **Increased tool life** due to HSS special steel.
- **Particularly wide product range** with perfect surface finish
- Improved chip flow by **full-grinding technology**

Standard Series – with BDS producer competence

Fully ground core drills, long version, metric.

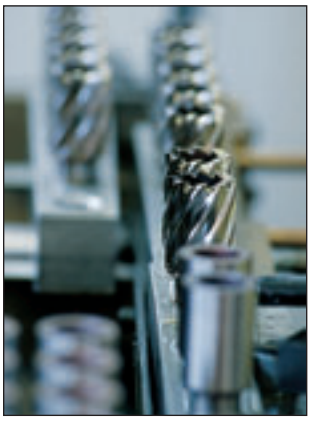
Standard core drill KBL
Cutting depth 55 mm Weldon shank 19 mm (3/4")



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









Ejector pin for core drills long version ø 12 – 60 mm



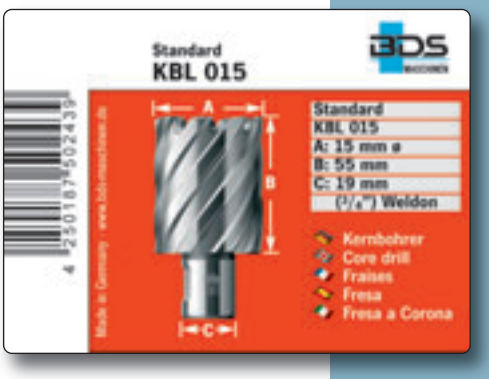
Order No.
ZAK 100

Standard Series

Fully ground core drills, long version, metric.

Standard core drill KBL
Cutting depth 55 mm Weldon shank 32 mm (1¼")





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

Ejector pin for core drills long version ø 61–100 mm



Order No.
ZAK 120



BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- **Increased tool life** due to HSS special steel.
- **Particularly wide product range** with perfect surface finish
- Improved chip flow by **full-grinding technology**

Standard Series – proven in practice

Fully ground core drills, extra long version, metric.

Standard core drill KEL
Cutting depth 110 mm Weldon shank 19 mm (3/4")



Order No.	ø - mm
KEL 020	20
KEL 021	21
KEL 022	22
KEL 023	23
KEL 024	24
KEL 025	25
KEL 026	26
KEL 027	27
KEL 028	28
KEL 029	29
KEL 030	30
KEL 031	31
KEL 032	32
KEL 033	33
KEL 034	34
KEL 035	35

Order No.	ø - mm
KEL 036	36
KEL 037	37
KEL 038	38
KEL 039	39
KEL 040	40
KEL 041	41
KEL 042	42
KEL 043	43
KEL 044	44
KEL 045	45
KEL 046	46
KEL 047	47
KEL 048	48
KEL 049	49
KEL 050	50

Ejector pin for KEL with 6.35 mm bore diameter



For KEL with bore diameter 6.35 mm (old version)

Order No.	Drilling range
ZAK 175	ø 20 - 50 mm

Ejector pin for KEL mit 8 mm bore diameter



For KEL with bore diameter 8 mm (new version)

Order No.	Version	Drilling range
ZAK 275	two-part	ø 20 - 50 mm





The function of the two-piece ejector pin:
The lower part of the pin is removed in order to fully utilize the full cutting depth of 110 mm of a KEL core drill!

Standard Series

Fully ground core drills, short version, inch

Standard core drill KBK-Z
Cutting depth 30 mm Weldon shank 19 mm (3/4")

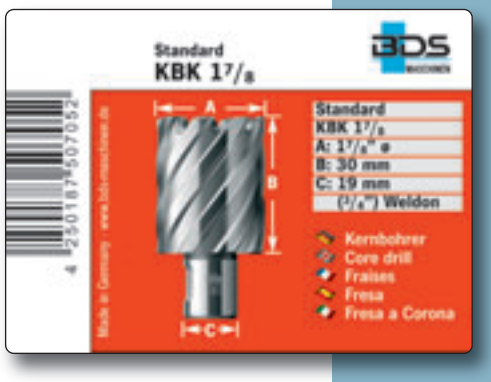


Order No.	ø inch	ø mm
KBK 1/2	1/2"	12,700
KBK 9/16	9/16"	14,288
KBK 5/8	5/8"	15,875
KBK 11/16	11/16"	17,463
KBK 3/4	3/4"	19,050
KBK 13/16	13/16"	20,638
KBK 7/8	7/8"	22,225
KBK 15/16	15/16"	23,813
KBK 1	1"	25,400
KBK 1 1/16	1 1/16"	26,988
KBK 1 1/8	1 1/8"	28,575
KBK 1 3/16	1 3/16"	30,136
KBK 1 1/4	1 1/4"	31,750
KBK 1 5/16	1 5/16"	33,338
KBK 1 3/8	1 3/8"	34,925
KBK 1 7/16	1 7/16"	36,513
KBK 1 1/2	1 1/2"	38,100
KBK 1 9/16	1 9/16"	39,688
KBK 1 5/8	1 5/8"	41,276
KBK 1 11/16	1 11/16"	42,863
KBK 1 3/4	1 3/4"	44,450
KBK 1 13/16	1 13/16"	46,038
KBK 1 7/8	1 7/8"	47,625
KBK 1 15/16	1 15/16"	49,213
KBK 2	2"	50,800
KBK 2 1/16	2 1/16"	52,388

Ejector pin for core drills short version ø 1/2" - 2 1/16"



Order No.
ZAK 075





BDS:profi

Series Standard: These BDS core drilling tools already represent the highest level.

- **Increased tool life** due to HSS special steel.
- **Particularly wide product range** with perfect surface finish
- Improved chip flow by **full-grinding technology**

NEW

Serie Vario Plus

BDS Fully ground core drills, short version, metric.

Vario core drill KBK-VP
Cutting depth 30 mm Weldon shank 19 mm (3/4")



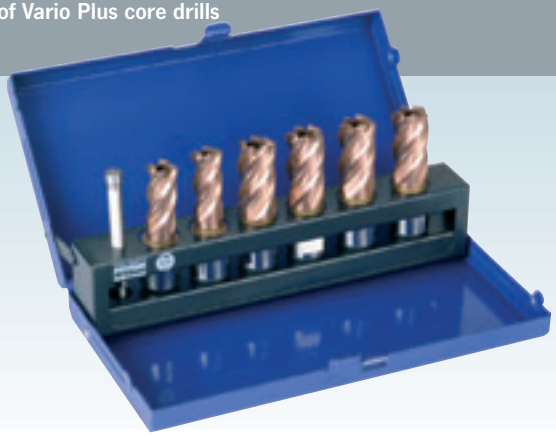
Order No.	ø mm	Order No.	ø mm
KBK 012-VP	12	KBK 036-VP	36
KBK 013-VP	13	KBK 037-VP	37
KBK 014-VP	14	KBK 038-VP	38
KBK 015-VP	15	KBK 039-VP	39
KBK 016-VP	16	KBK 040-VP	40
KBK 017-VP	17	KBK 041-VP	41
KBK 175-VP	17,5	KBK 042-VP	42
KBK 018-VP	18	KBK 043-VP	43
KBK 019-VP	19	KBK 044-VP	44
KBK 195-VP	19,5	KBK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

Ejector pin for core drill short, up to ø 60 mm



Order No.
ZAK 075

Set of Vario Plus core drills



Order No.	Content
KBK 001-VP	2 x KBK-VP 014
	2 x KBK-VP 018
	2 x KBK-VP 022
	1 x ZAK 075

Order No.	Content
KBK 002-VP	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

NEW

Serie Vario Plus

BDS Fully ground core drills, long version, metric.

Vario core drill KBL-VP
Cutting depth 55 mm Weldon shank 19 mm (3/4")



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

Ejector pin for core drill long, up to ø 60 mm



Order No.
ZAK 100





BDS:profi

VarioPLUS series
Hard covered core drills of the next generation.

- Longer service life
- Improved chip flow

Conclusion: More efficiency and more working safety.

NEW

HKK Series

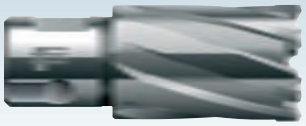
Sintered Carbide, short version, metric

Core drills HKK

Cutting depth 30 mm One-Touch and Weldon shank 19 mm (3/4")

One-Touch Rota-Quick

WELDON 19 mm 3/4"



Order No.	ø - mm
HKK 014	14
HKK 015	15
HKK 016	16
HKK 017	17
HKK 018	18
HKK 019	19
HKK 020	20
HKK 021	21
HKK 022	22
HKK 023	23
HKK 024	24
HKK 025	25
HKK 026	26
HKK 027	27
HKK 028	28
HKK 029	29
HKK 030	30
HKK 031	31
HKK 032	32
HKK 033	33
HKK 034	34
HKK 035	35
HKK 036	36
HKK 037	37
HKK 038	38
HKK 039	39
HKK 040	40
HKK 041	41
HKK 042	42
HKK 043	43
HKK 044	44
HKK 045	45
HKK 046	46
HKK 047	47
HKK 048	48
HKK 049	49
HKK 050	50
HKK 051	51
HKK 052	52
HKK 053	53

Order No.	ø - mm
HKK 054	54
HKK 055	55
HKK 056	56
HKK 057	57
HKK 058	58
HKK 059	59
HKK 060	60
HKK 061	61
HKK 062	62
HKK 063	63
HKK 064	64
HKK 065	65
HKK 066	66
HKK 067	67
HKK 068	68
HKK 069	69
HKK 070	70
HKK 071	71
HKK 072	72
HKK 073	73
HKK 074	74
HKK 075	75
HKK 076	76
HKK 077	77
HKK 078	78
HKK 079	79
HKK 080	80
HKK 081	81
HKK 082	82
HKK 083	83
HKK 084	84
HKK 085	85
HKK 086	86
HKK 087	87
HKK 088	88
HKK 089	89
HKK 090	90
HKK 091	91
HKK 092	82
HKK 093	93



Order No.	ø - mm
HKK 094	94
HKK 095	95
HKK 096	96
HKK 097	97
HKK 098	98
HKK 099	99
HKK 100	100
HKK 105	105
HKK 110	110

Order No.	ø - mm
HKK 115	115
HKK 120	120
HKK 125	125
HKK 130	130
HKK 135	135
HKK 140	140
HKK 145	145
HKK 150	150

Ejector pin for core drills HKK ø 14 – 17 mm



Order No.
ZAK 096

Ejector pin for core drills HKK ø 18 – 150 mm



Order No.
ZAK 090

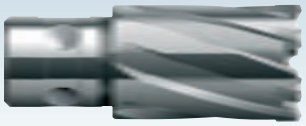


HKK-F Series

Sintered Carbide, short version, metric

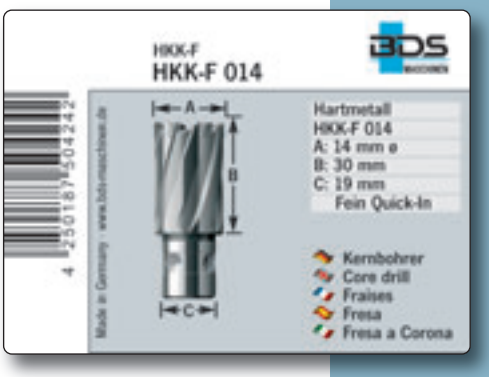
HKK core drill for FEIN Quick-In holder system
Cutting depth 30 mm Weldon shank 18 mm

Quick-In



Order No.	ø - mm
HKK-F 014	14
HKK-F 015	15
HKK-F 016	16
HKK-F 017	17
HKK-F 018	18
HKK-F 019	19
HKK-F 020	20
HKK-F 021	21
HKK-F 022	22
HKK-F 023	23
HKK-F 024	24
HKK-F 025	25
HKK-F 026	26
HKK-F 027	27
HKK-F 028	28
HKK-F 029	29
HKK-F 030	30

Order No.	ø - mm
HKK-F 031	31
HKK-F 032	32
HKK-F 033	33
HKK-F 034	34
HKK-F 035	35
HKK-F 036	36
HKK-F 037	37
HKK-F 038	38
HKK-F 039	39
HKK-F 040	40
HKK-F 041	41
HKK-F 042	42
HKK-F 043	43
HKK-F 044	44
HKK-F 045	45
HKK-F 046	46
HKK-F 047	47



Order No.	ø - mm
HKK-F 048	48
HKK-F 049	49
HKK-F 050	50
HKK-F 051	51
HKK-F 052	52
HKK-F 053	53
HKK-F 054	54
HKK-F 055	55
HKK-F 056	56
HKK-F 057	57
HKK-F 058	58
HKK-F 059	59
HKK-F 060	60

Ejector pin for core drills HKK-F ø 14 – 60 mm



Order No.
ZAK 096

Quick-In



BDS:profi

Soluble cutting oil
BDS 6000



Order No.	ø - mm
ZHB 001	1 Liter container

BDS 6000 High-performance cooling lubricant concentrate for high demands

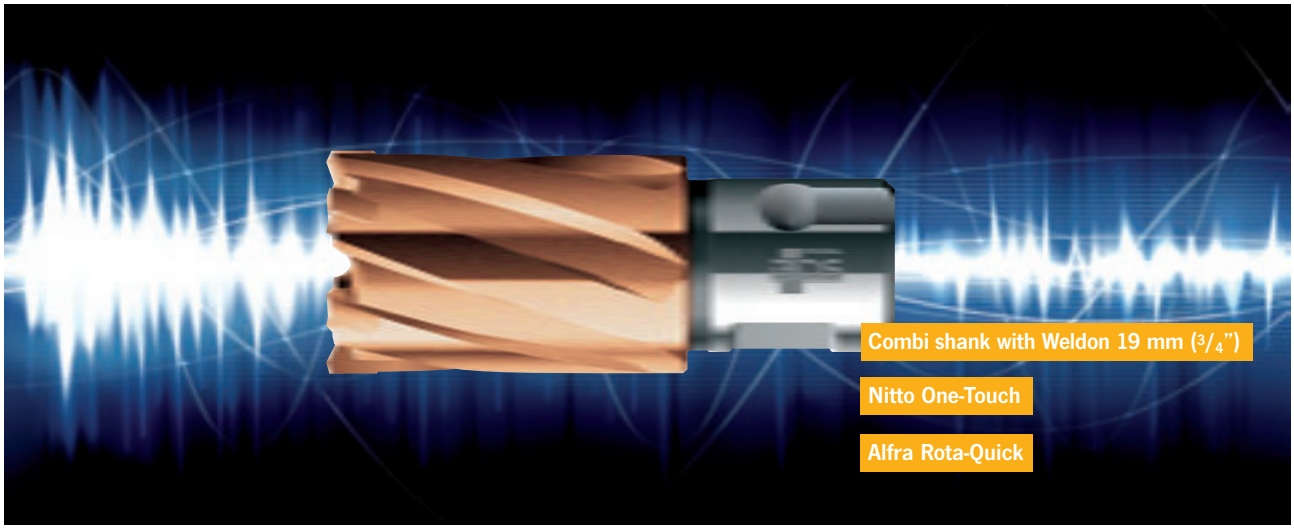
based on synthetic raw materials.

- **Soluble in water**
- Compatible in toxicological viewpoint
- Water hazard class 1

NEW

HKK-PLUS Series

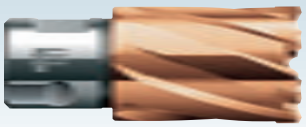
Sintered carbide core drill with hard coating, short version, metric



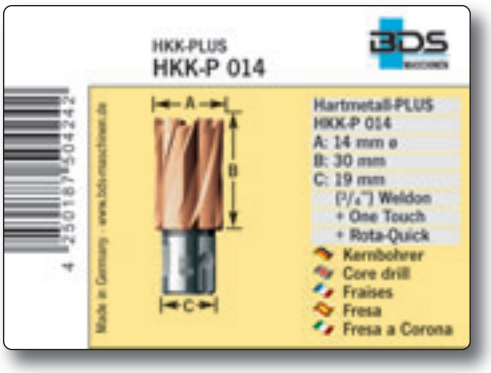
Core drill with hard coating HKK-P, cutting depth 30 mm, Weldon shank 19 mm (3/4"), Nitto One-Touch-, Alfra Rota-Quick

One-Touch Rota-Quick

WELDON 19 mm 3/4"



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



Order No.	ø - mm
HKK-P 056	56
HKK-P 057	57
HKK-P 058	58
HKK-P 059	59
HKK-P 060	60

Ejector pin for core drills HKK-P ø 14 – 17 mm



Order No.
ZAK 096

Ejector pin for core drills HKK-P ø 18 – 60 mm



Order No.
ZAK 090

HKL-Rail Series

Sintered Carbide, long version, metric





Cor drills HKL-R
Cutting depth 50 mm Weldon shank 19 mm (3/4")



Order No.	ø - mm
HKL-R 017	17
HKL-R 018	18
HKL-R 019	19
HKL-R 020	20
HKL-R 021	21
HKL-R 022	22
HKL-R 023	23
HKL-R 024	24
HKL-R 025	25
HKL-R 026	26
HKL-R 027	27

Order No.	ø - mm
HKL-R 028	28
HKL-R 029	29
HKL-R 030	30
HKL-R 031	31
HKL-R 032	32
HKL-R 033	33
HKL-R 034	34
HKL-R 035	35
HKL-R 036	36

Ejector pin for core drills HKL-R ø 17 – 36 mm



Order No.
ZAK 120



BDS:advice

Carbide series: Core drills for professional working results.

- Long service life
- Extensive programme range
- **Plus special assortment for rail core drilling machines**

New: Rail core drilling machine with petrol engine. RailMAB 960

>> Page 44

