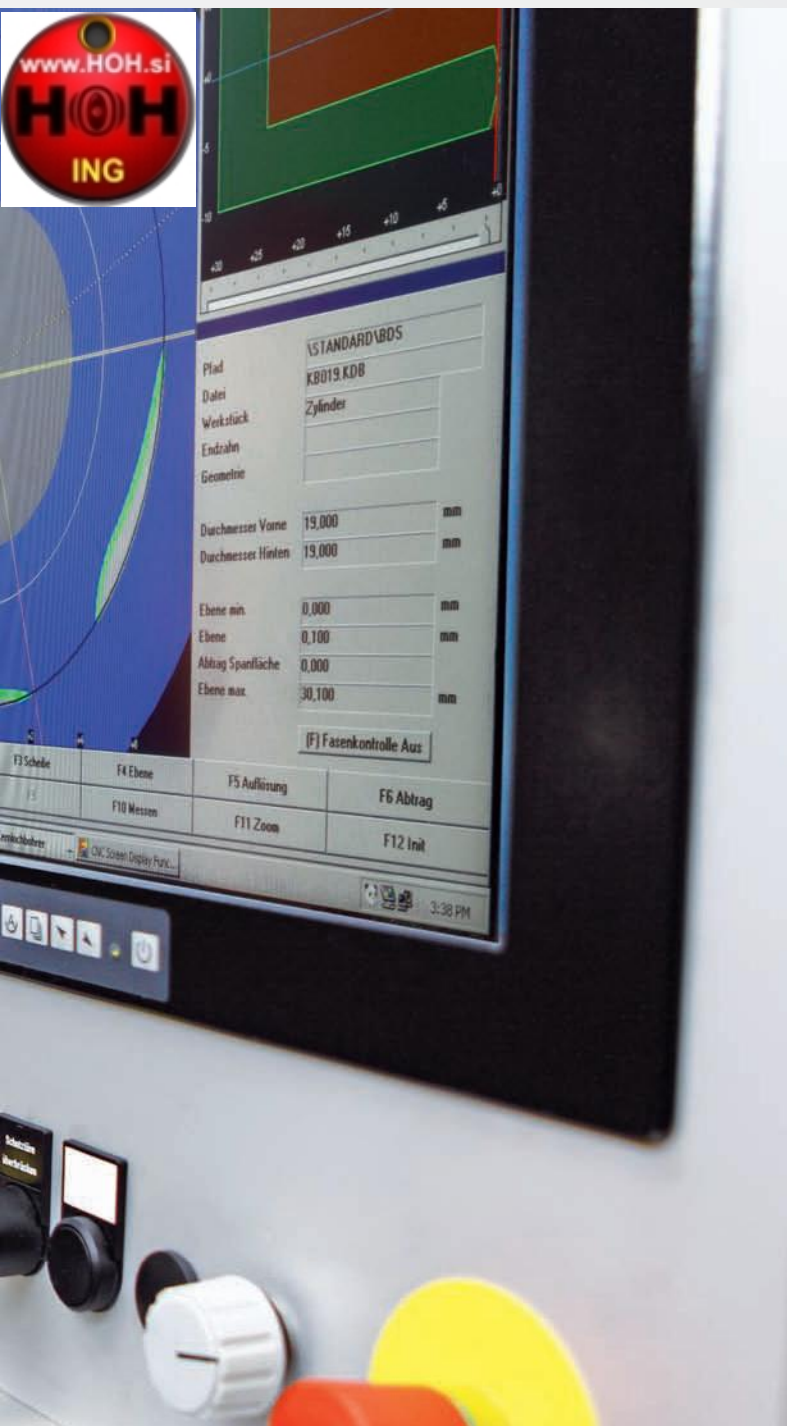
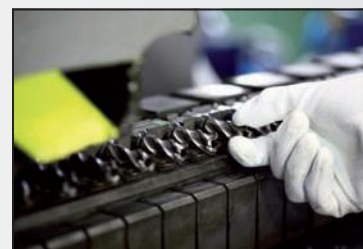
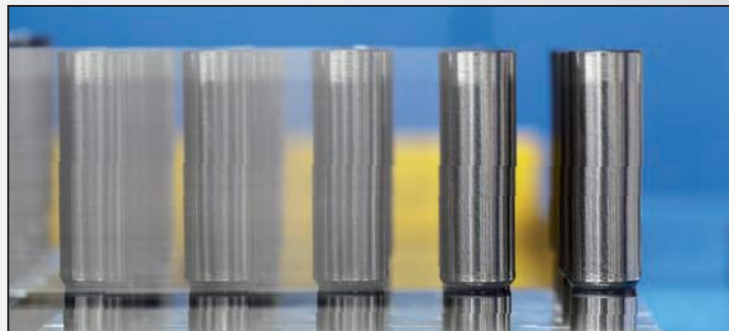




Core Drills Made in Germany



Know-how and technology – the recipe for quality

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

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

The BDS Core Drill Series

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



VarioPLUS SERIES

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



HSS-Co 8 SERIES

The objective of this most recent product development at BDS was to produce a range of core drills optimised for power with greater heat resistance and better protection against wear. The desired results were achieved by an enhanced proportion of cobalt in special steel. These core drills are suitable for higher levels of stress in fine-grained steel and stainless material in conjunction with speed-controlled BDS magnetic core drilling machines. The core drills can be ground again subsequently so that they retain their favourable product characteristics. HSS-Co 8 core drills can be identified by the black ring, the signature mark on the shaft!





STANDARD SERIES

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

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

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



CARBIDE PLUS SERIES

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



CARBIDE SERIES

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

BDS is contributing to this growing demand by expanding the range with cutting depths of 30 mm, 55 mm and 110 mm length and almost continuous gradation from $\varnothing$ 14 mm to $\varnothing$ 150 mm.

The Range of BDS Core Drills

All series, cutting depths and drill diameters available

BDS core drills – professional quality for professional applications

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

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

Key applications

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

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

Extensive programme range

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

							
HSS-Co 8 Series		VarioPLUS Series		Standard Series			
KBK-CO	KBL-CO	KBK-VP	KBL-VP	KBK	KBL	KEL	KBK-Z
Cutting depth:	30 mm	55 mm	30 mm	55 mm	110 mm	30 mm	
Drill diameter:	12 – 60 mm	12 – 60 mm	12 – 60 mm	12 – 130 mm	12 – 100 mm	20 – 50 mm	1/2" – 2 1/16"

Tool holders

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



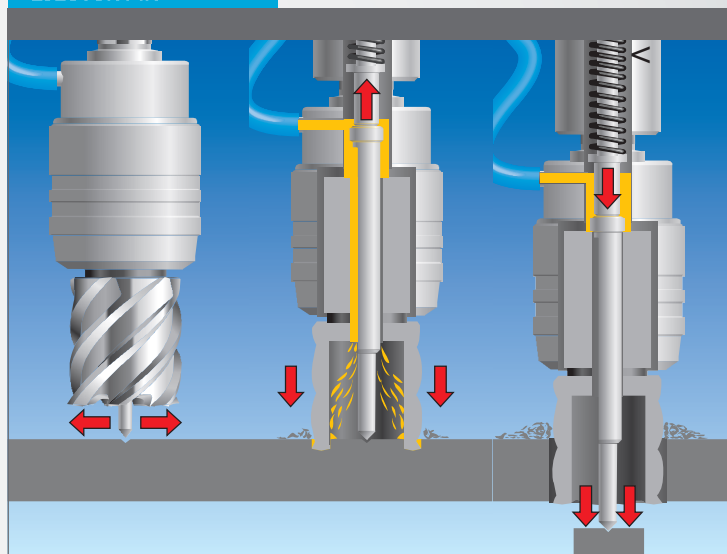
Tool holders:

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

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



EJECTOR PIN



Function of the ejector pin

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

Carbide Series

HKK	HKL	HKE-L
30 mm	55 mm	110 mm
14 – 150 mm	14 – 100 mm	20 – 120 mm

Carbide PLUS Series

HKK-P
30 mm
14 – 60 mm

Carbide RAIL Series

HKK-R
30 mm
17 – 36 mm

Carbide F Series

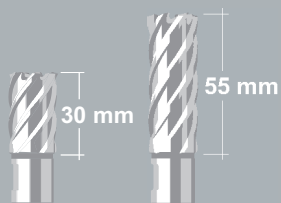
HKK-F
35 mm
14 – 60 mm



Core drills Series HSS-Co 8

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

CORE DRILLS	PAGE
HSS-Co 8 Core drills short	45
HSS-Co 8 Core drills long	45



HSS-Co 8

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

HSS-Co 8 Core drills short

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



HSS-Co 8 SERIES

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

HSS-Co 8 Core drills long

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



HSS-Co 8 SERIES

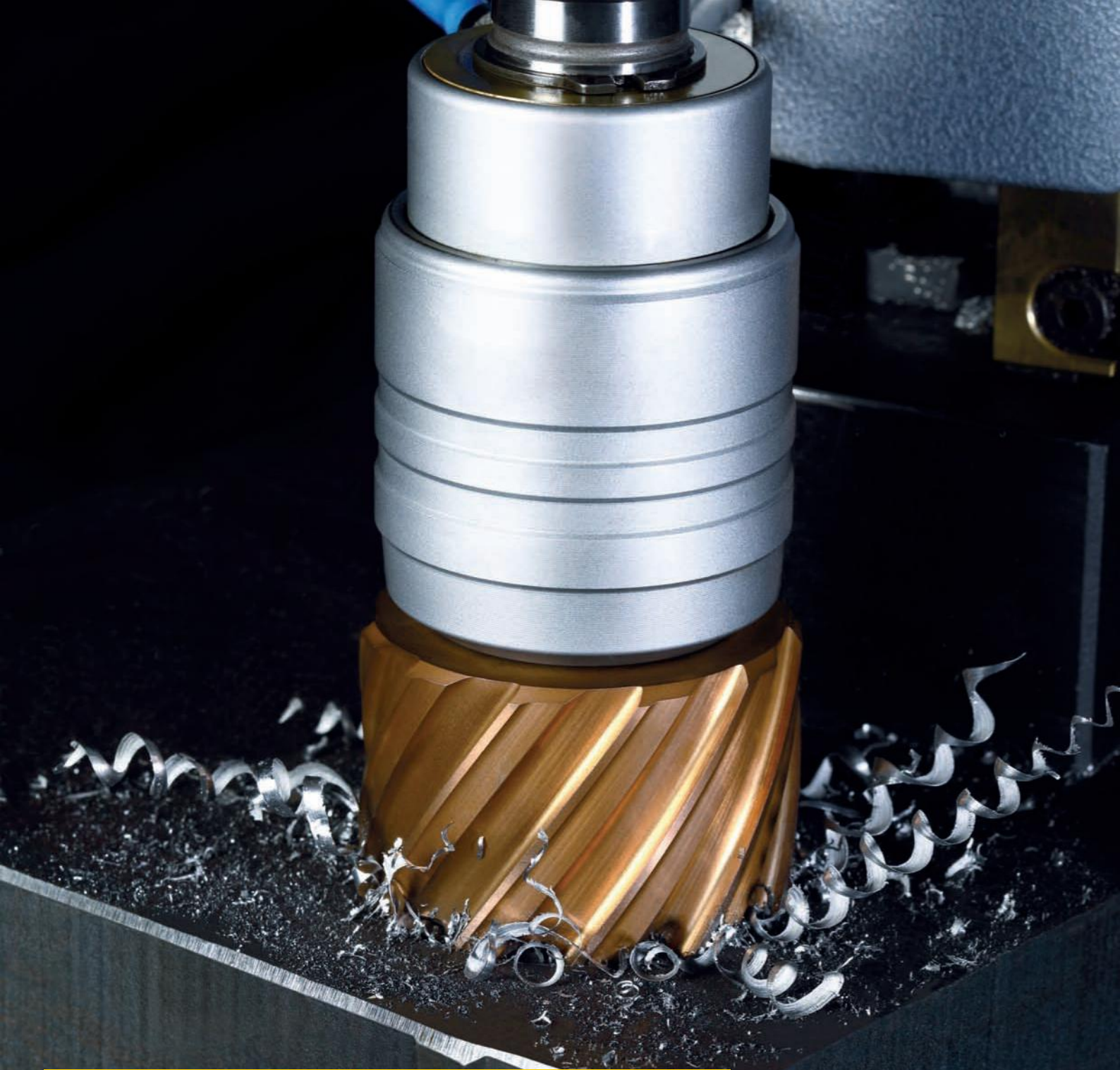
Ø mm	ORDER NO.	€	Ø mm	ORDER NO.
12	KBL-CO 012		36	KBL-CO 036
13	KBL-CO 013		37	KBL-CO 037
14	KBL-CO 014		38	KBL-CO 038
15	KBL-CO 015		39	KBL-CO 039
16	KBL-CO 016		40	KBL-CO 040
17	KBL-CO 017		41	KBL-CO 041
17.5	KBL-CO 175		42	KBL-CO 042
18	KBL-CO 018		43	KBL-CO 043
19	KBL-CO 019		44	KBL-CO 044
19.5	KBL-CO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

EJECTOR PIN FOR KBK-CO, Ø 12 - 60 mm
ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-CO, Ø 12 - 60 mm
ORDER NO.

ZAK 100



Core drills Series VarioPLUS

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

CORE DRILLS

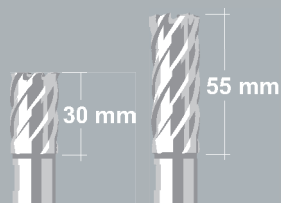
PAGE

VarioPLUS Core drills short

47

VarioPLUS Core drills long

47



VarioPLUS

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

VarioPLUS Core drills short

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



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		

VarioPLUS Core drills long

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



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



Core drills Series Standard

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

CORE DRILLS	PAGE
Standard Core drills short	49
Standard Core drills long	50
Standard Core drills extra-long	51
Standard Core drills short, inch	51



Standard

Fully ground core drills made of high-speed steel



Standard Core drills short

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

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



Standard Core drills short

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

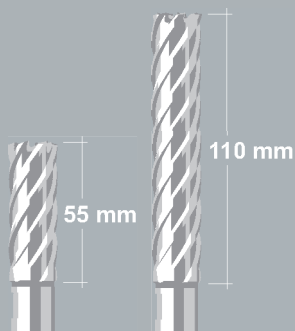
STANDARD SERIES

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

EJECTOR PIN FOR KBK, Ø 61 - 130 mm

ORDER NO.

ZAK 090



Standard

Fully ground core drills made of high-speed steel

Standard long

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



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

Standard long

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



STANDARD SERIES

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

EJECTOR PIN FOR KBL, Ø 61 - 100 mm

ORDER NO.

ZAK 120



Standard, inch

Fully ground core drills made of high-speed steel



Standard short, inch

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

Standard extra-long

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



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		

STANDARD SERIES INCH

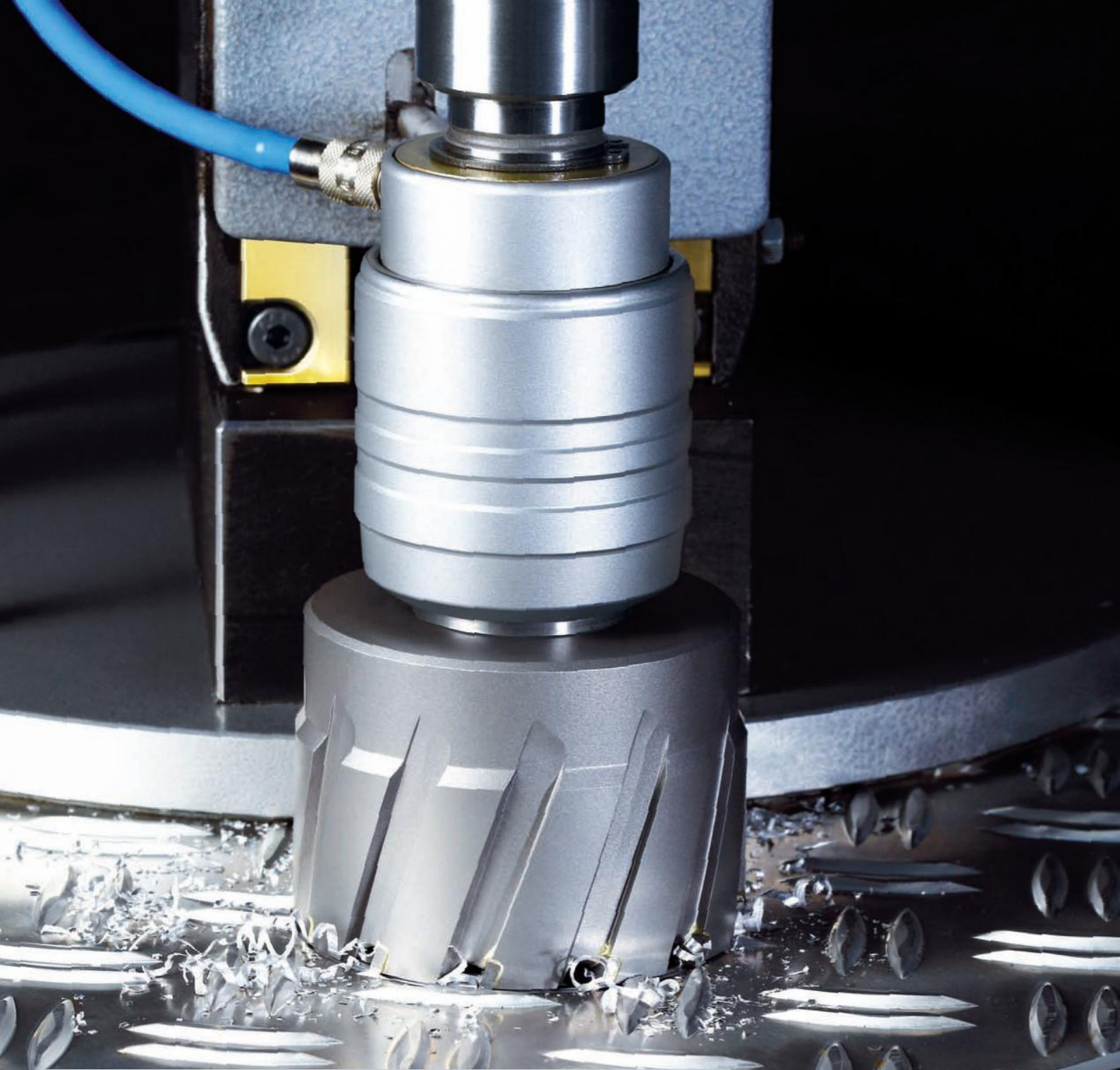
Ø inch	Ø mm	ORDER NO.
$\frac{1}{2}$ "	12.700	KBK-Z $\frac{1}{2}$
$\frac{9}{16}$ "	14.288	KBK-Z $\frac{9}{16}$
$\frac{5}{8}$ "	15.875	KBK-Z $\frac{5}{8}$
$\frac{11}{16}$ "	17.463	KBK-Z $\frac{11}{16}$
$\frac{3}{4}$ "	19.050	KBK-Z $\frac{3}{4}$
$\frac{13}{16}$ "	20.638	KBK-Z $\frac{13}{16}$
$\frac{7}{8}$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

EJECTOR PIN FOR KEL, Ø 20 – 50 mm

ORDER NO.	VERSION
ZAK 275	Two-part version

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

ORDER NO.
ZAK 075



Core drills Series Carbide

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

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

CORE DRILLS

PAGE

Carbide core drills short	53
Carbide core drills long	54
Carbide core drills extra-long	55
Carbide core drills PLUS short	55
Carbide core drills RAIL	56
Carbide core drills F	57
(Quick-In holder)	



Carbide

Carbide-tipped core drills

Carbide short

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



CARBIDE SERIES

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

Carbide short

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



CARBIDE SERIES

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

EJECTOR PIN FOR HKK, Ø 14 - 60 mm

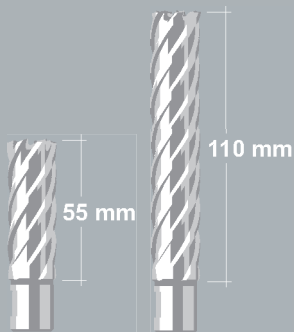
ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK, Ø 61 - 150 mm

ORDER NO.

ZAK 090



Carbide

Carbide-tipped core drills

Carbide long

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



CARBIDE SERIES

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

Carbide long

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



CARBIDE SERIES

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

EJECTOR PIN FOR HKL Ø 14 - 60 mm

ORDER NO.

ZAK 100

EJECTOR PIN FOR HKL Ø 61 - 100 mm

ORDER NO.

ZAK 120



Carbide PLUS

Carbide-tipped core drills with carbide coating

Carbide PLUS short

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



Carbide extra-long

- > 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.
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		

CARBIDE 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 HKE-L Ø 20 – 120 mm

ORDER NO.	VERSION
ZAK 275	Two-part version

EJECTOR PIN FOR HKK-P Ø 14 - 60 mm

ORDER NO.
ZAK 100



Carbide RAIL

Carbide-tipped core drills
for rail core drilling machines



Carbide RAIL – core drills

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

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



Carbide F

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



Carbide-F short

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

CARBIDE F SERIES

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

EJECTOR PIN FOR HKK-F, Ø 14 - 60 mm
ORDER NO.

ZAK 096

Technical Information

Recommended lubricants and torque values

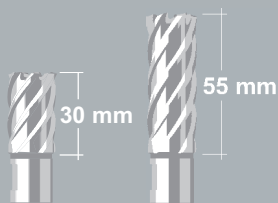


CORE DRILLS SERIES		MATERIAL						
Lubricant/ cooling lubricant		Aluminium Non-ferrous metals	Steel < 500 N/m ²	Fine-grain steel < 700 N/m ²	Fine-grain steel < 1,000 N/m ²	Stainless steel Inox	Casting	Railway rails
	HSS-Co 8			10 – 15 m/min	10 – 15 m/min	10 – 15 m/min	15 – 20 m/min*	
	BDS 5000			✓	✓	✓		
	BDS 5200			✓	✓	✓		
	BDS 5500			✓	✓	✓		
	BDS 6000						✓	
	VarioPLUS			10 – 15 m/min	10 – 15 m/min			
	BDS 5000			✓	✓			
	BDS 5200			✓	✓			
	BDS 5500			✓	✓			
	Standard	25 – 30 m/min	25 m/min				10 – 20 m/min	
	BDS 5000	✓	✓					
	BDS 5200		✓					
	BDS 5500							
	BDS 6000						✓	
	Carbide		35 m/min	25 m/min	20 m/min	20 m/min		
	BDS 6000		✓	✓	✓	✓		
	Carbide PLUS		35 m/min	25 m/min	20 m/min	20 m/min		
	BDS 6000		✓	✓	✓	✓		
	Carbide RAIL							15 – 20 m/min
	BDS 6000							✓

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

Speed: $n = \frac{v \times 1,000}{d \times \pi} = \text{min}^{-1}$

*depending on the variety



Core Drill Box

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

Set of core drills

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



CORE DRILL BOX, HSS STANDARD SHORT

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



CORE DRILL BOX, HSS STANDARD LONG

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



CORE DRILL BOX, HSS VarioPLUS SHORT

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



CORE DRILL BOX, HSS VarioPLUS LONG

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



CORE DRILL BOX, CARBIDE SHORT

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



CORE DRILL BOX, CARBIDE PLUS SHORT

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



Core Drill Cassette

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

Set of core drills

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



CORE DRILL CASSETTE, HSS-Co 8

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 CASSETTE, HSS STANDARD

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 CASSETTE, HSS VarioPLUS

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