

BDS CORE DRILLS 2016 PROGRAMME

Simply Better Drilling

PROFESSIONAL DRILLING TECHNOLOGY

PREMIUM QUALITY

NO COMPROMISE



Overview

HSS-Co 8

HSS-VarioPLUS

HSS-Standard

Carbide

Core Drill Sets

Holders/
Adapters

Twist drills/
Taps

Accessories/
Coolants

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...

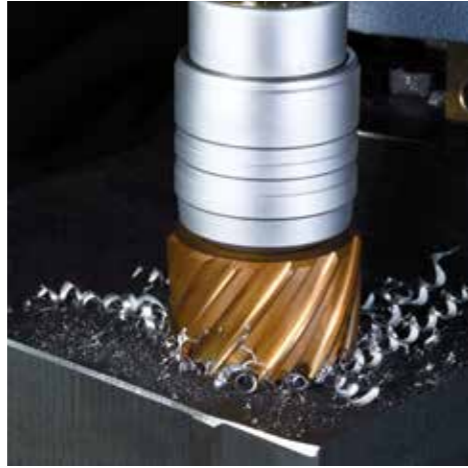


CORE DRILLS PRODUCTION AT THE HIGHEST LEVEL



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

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

HSS-Co 8

HSS-VarioPLUS

HSS-Standard

Carbide

Core Drill Sets

Holders/
Adapters

Twist drills/
Taps

Accessories/
Coolants

Core Drill Series HSS-Co 8

Fully ground core drills made of high-speed steel.

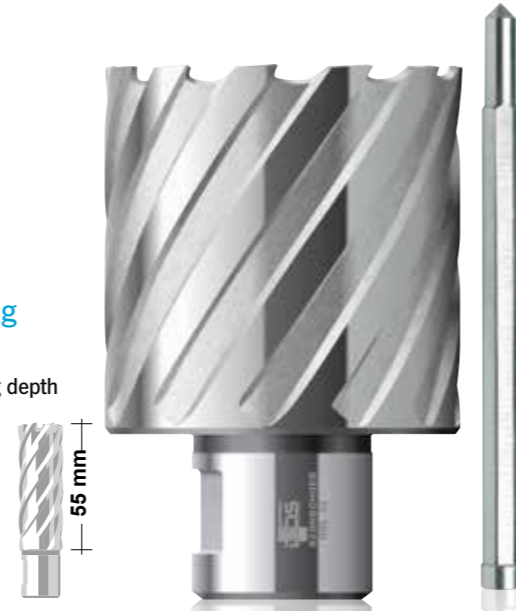
HSS-Co 8 Core drill long

- > 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

Cutting speed:

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

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	100	130	150	180
70	70	90	120	140	160
75	65	85	110	130	150
80	60	80	100	120	140
85	55	75	95	110	130
90	55	70	90	110	120
95	50	65	85	100	120
100	50	65	80	100	110
110	45	60	80	90	100
120	40	60	70	80	100
130	40	50	60	80	90

Speed:

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

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

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 KBK-Z, Ø 1/2" – 2 1/16"	
ORDER NO.	VERSION
ZAK 075	Two-part version

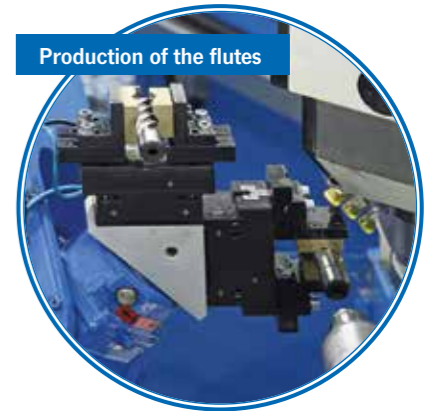
Distinct quality that makes all the difference.



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



Böhrler 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

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.

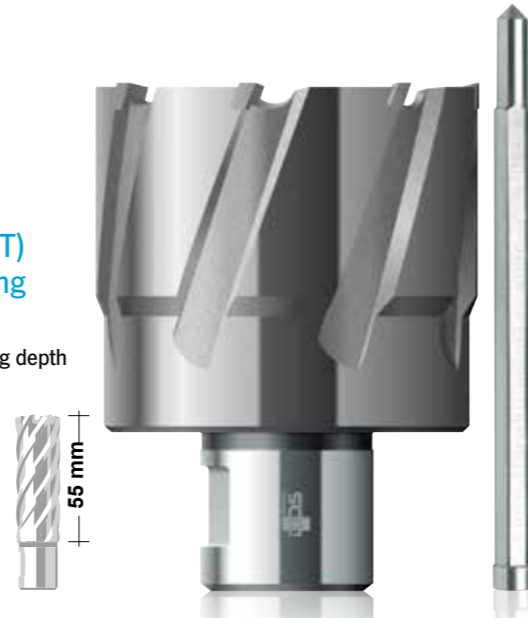
Carbide (TCT) Core drill long

- > 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")



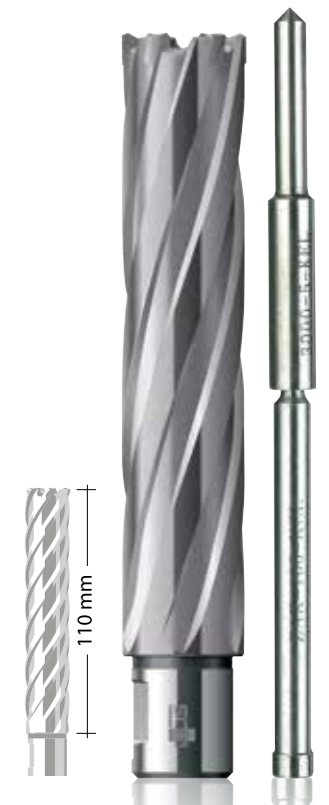
Carbide (TCT) Core drill overlong

- > 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

HSS-VarioPLUS Core drill short

Carbide Core drill short



CORE DRILL-BOX

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

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

CORE DRILL-BOX

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

HSS-Standard Core drill long

HSS-VarioPLUS Core drill long

Carbide-PLUS Core drill short



CORE DRILL-BOX

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

CORE DRILL-BOX

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

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

HSS-Standard Core drill short

HSS-VarioPLUS 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

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

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 (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
(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 (3/4")	ZSE 040
50	Weldon shank 19 mm (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

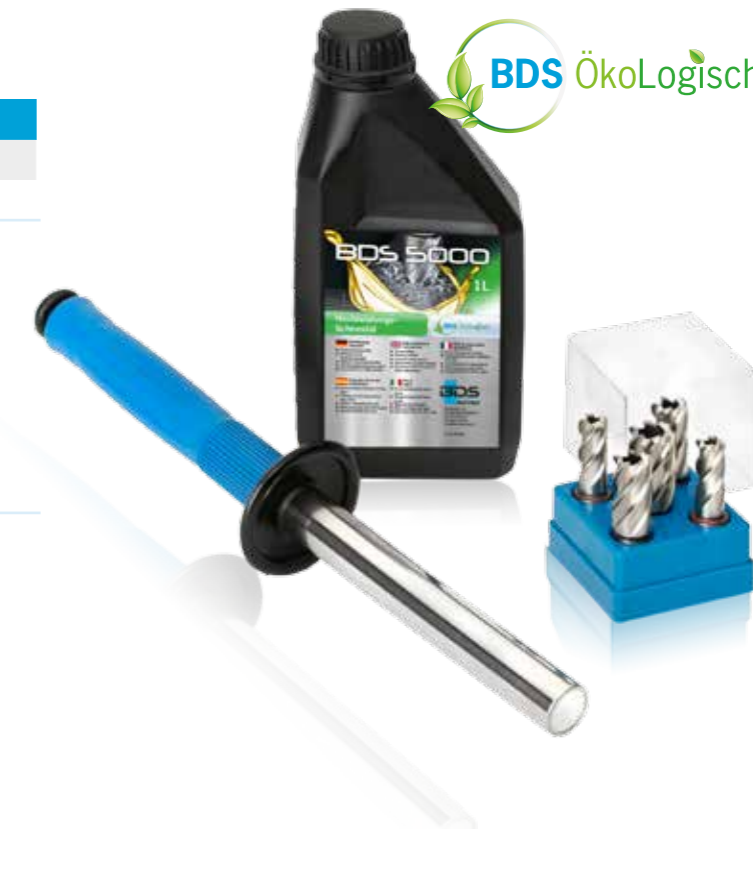
BDS StarterKIT PowerWORKER

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

