

SIMPLY BETTER DRILLING

INTERNATIONAL CATALOGUE



EN
GK-EN-V2

***MAGNETIC DRILLING MACHINES
ANNULAR CUTTERS
BEVELLING MACHINES***

BDS
MASCHINEN

QUALITY, MADE IN GERMANY.



BDS MACHINES: YOUR INNOVATIVE PARTNER FOR CORE DRILLING IN METAL.

BDS Machines was founded in 1990 and can look back on 35 years of experience in the development and manufacture of high-quality machining technology. As an innovative manufacturer of magnetic core drilling machines, annular cutters and edge processing machines, we have established ourselves as experts in the field of core drilling for metal. Our products are known for their outstanding quality and user-friendliness. We utilise the latest technologies to develop solutions that meet the highest industry standards. We have won the prestigious German Design Awards for our innovative machines, which has recognised our reliability. This emphasises our commitment to excellent product design and innovative strength. At BDS, we endeavour to offer our customers not only high-quality products, but also a comprehensive service that is individually tailored to their needs.

Our dedicated team is always on hand with expert advice and support to ensure you get the best solutions for your projects. Put your trust in BDS – together we can shape the future of core drilling.



EXCLUSIVE PRODUCTS FOR THE HIGHEST DEMANDS. FOR THOSE WHO MAKE NO COMPROMISES.



**MAGNETIC
DRILLING MACHINES**



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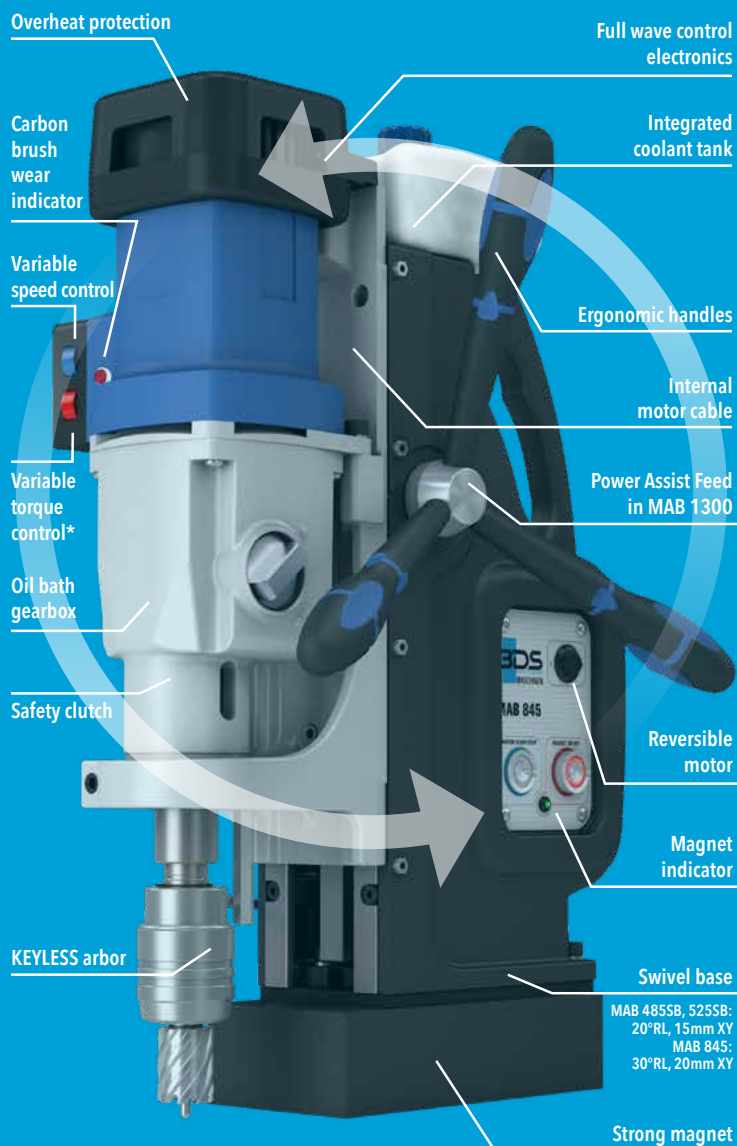
ACCESSORIES



BEVELLING MACHINES

ProfiPLUS **HIGH- PERFORMANCE ALL-ROUND MACHINES.**

**CORE DRILLING,
THREAD CUTTING,
REAMING &
COUNTERSINKING.**



The ProfiPLUS series is aimed at users who not only need power, but also precise control and enhanced operating comfort in demanding applications. ProfiPLUS impresses with powerful motors, optimized control and safety systems that ensure efficient and safe working – even under the toughest conditions. ProfiPLUS - Made in Germany magnetic drilling and tapping machines.



MAB 485



MAB 485 SB



	Core drill max. Ø HSS/TCT	40/50 mm (2")
	Core drill cutting depth max.	55 mm (2-3/8")
	Thread cutting Ø max.	M16 (5/8")
	Twist drill Ø max.	18 mm (7/8")
	Reaming Ø max.	18 mm (7/8")
	Countersinking Ø max.	40 mm (2-1/16")
	Swivel Base	(✓ MAB 485 SB)
	Motor output ⚡ Voltage, V AC	1150 W (10.5 A) / 230; 110/125 V AC
	Stroke	160 mm (6-1/4")
	Weight	13 Kg. (29 lbs.)
	Spindle taper	MT 2
	KEYLESS arbor (19mm Weldon 3/4")	✓
	Speed gears	2
	Speed range (min ⁻¹)	50-250; 100-450
	Variable torque control	
	Variable speed control	✓
	Safety clutch	
	Clockwise/anticlockwise rotation	✓
	Full wave control electronics	✓
	Magnet indicator	✓
	Overheat protection	✓
	Carbon brush wear indicator	✓

Scope of delivery MAB 485 / MAB 485 SB

Carry case	ZHK 400
Ejector pin	ZAK 075, 100
Arbor	ZSS 200
Tapping adapter	ZGA 010, 012, 016
Gear rim drill chuck	ZBK 113
Taper drift/Adapter	ZKD 216
Ejector drift	ZAS 002
Safety lashing strap	4000161
Allen key	8010301 (3 mm)
Operating instructions	✓


MAB 525
MAB 525 SB


50/60 mm (2-3/8")

75 mm (3")

M20 (3/4")

20 mm (1")

20 mm (1")

50 mm (2-1/2")

(✓ MAB 525 SB)

1600 W (14.50 A) / 230; 110/125 V AC

160 mm (6-1/4")

16 Kg. (35 lbs.)

MT 3



2

70-280; 180-580



Scope of delivery MAB 525 / MAB 525 SB

ZHK 400

ZAK 075, 100

ZSS 300

ZGA 010, 012, 016

ZBK 113

ZKD 316

ZAS 003

4000161

8010301 (3 mm)


MAB 825
MAB 845


100 mm (4")

60 mm (2-3/8")

55 mm (2-3/8")

110 mm (4")

M30 (1-1/8")

31.75 mm (1-1/4")

31.75 mm (1-1/4")

50 mm (2-1/2")

(✓ MAB 845)

1800 W (16 A) / 230; 110/125 V AC

255 mm (10")

25 Kg. (55 lbs.)

MT 3



4

40-110; 65-175; 140-360; 220-600



Scope of delivery MAB 825 / 845

ZHK 825

ZAK 075, 090, 100, 120

ZSS 300 + ZIA 332-KN

ZAS 003

4000161

911058 (6 mm) + for MAB 845:
8010381 (8 mm)

MAB 1300

130 mm (6")

80 mm (3")

55 mm (2-3/8")

110 mm (4")

M42 (1-5/8")

45 mm (1-3/4")

50 mm (2-1/2")

80 mm (3")

2300 W (20 A) / 230; 110/125 V AC

85/310 mm (3.35" / 12" without retainer)

51 Kg. (112 lbs.)

MT 4



4

30-180; 50-120; 130-350; 210-550



Scope of delivery MAB 1300 V

ZHK 1300

ZAK 075, 090, 100, 120

ZAP 200

ZAS 004

4000161

911058 (6 mm), 8010251 (4 mm),
8010381 (8 mm)

MAB 2300

200 mm (8")

130 mm (6")

55 mm (2-3/8")

110 mm (4")

50 mm (2")

55 mm (2-3/8")

60 mm (2-3/8")

90 mm (3-9/16")

2800 Watts / 230; 110/125 V AC

310 mm (12")

52 kg (115 lbs.)

MT 4



3

25-50; 50-100; 100-200



Scope of delivery MAB 2300

ZHK 1500

ZAK 075, 090, 100, 120

ZIA 419-KN, ZIA 432-KN

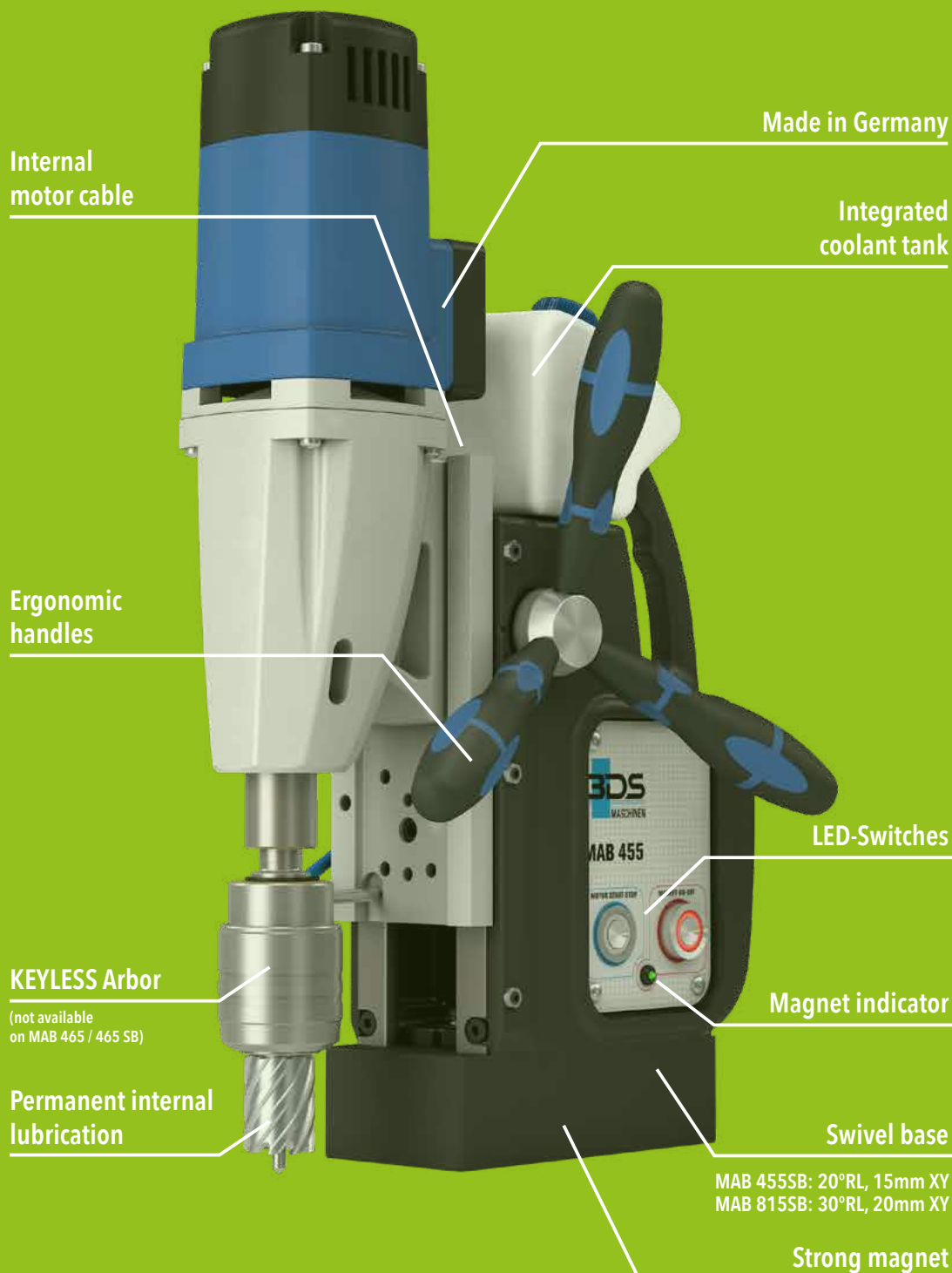
ZAS 004

4000161

911058 (6 mm), 8010251 (4 mm),
8010381 (8 mm)


MAXIMUM POWER, ZERO COMPROMISES.

**RELIABLE, POWERFUL, HEAVY-DUTY
DRILLING MACHINES FOR DAILY USE.**



The ProfiSTART series from BDS offers robust and sophisticated Magnetic Drilling Machines for professional operation. These machines are characterized by optimized ergonomics and operation and have been reliably tested in tough continuous operation. They are the ideal introduction to BDS top technology.

	Core drill max. Ø HSS/TCT
	Core drill cutting depth max.
	Twist drill Ø max.
	Swivel Base
	Motor output
	Voltage, V AC
	Stroke
	Weight
	Spindle taper
	KEYLESS arbor (19mm Weldon 3/4")
	Speed gears
	Speed range (min ⁻¹)
	Safety clutch
	Full wave control electronics
	Magnet indicator
	Overheat protection
	Internal motor cable

Carry case
Ejector pin
Arbor
Ejector drift
Allen key
Safety lashing strap
Operating instructions

MAB 455SB: 20°RL, 15mm XY
MAB 815SB: 30°RL, 20mm XY



MAB 100 K



32/35 mm (1-3/8")

55 mm (2-3/8")

13 mm (1/2")

MAB 455



MAB 455 SB



40/50 mm (2")

55 mm (2-3/8")

18 mm (7/8")

✓ (MAB 455 SB)

MAB 815



MAB 815 SB



100 mm (6")

110 mm (3")

31.75 mm (1-1/4")

✓ (MAB 815 SB)

900 W (7.5 A)

230; 110/125 V AC

70 mm (2 3/4")

9.9 Kg (22 lbs.)

✓

1

460

✓

✓

1150 W (10.5 A)

230; 110/125 V AC

160 mm (6-1/4")

13 Kg. (29 lbs.)

MT 2

✓

2

250 & 450

✓

✓

1800 W (16 A)

230; 110/125 V AC

255 mm (10")

24 Kg. (53 lbs.)

MT 3

✓

4

110, 175, 360, 600

✓

✓

Scope of delivery MAB 100 K

ZHK 100

ZAK 075, 100

4000161

✓

Scope of delivery MAB 455 / MAB 455 SB

ZHK 400

ZAK 075, 100

ZSS 200

ZAS 002

4000161

✓

Scope of delivery MAB 815

ZHK 825

ZAK 075, 090, 100, 120, 225, 275

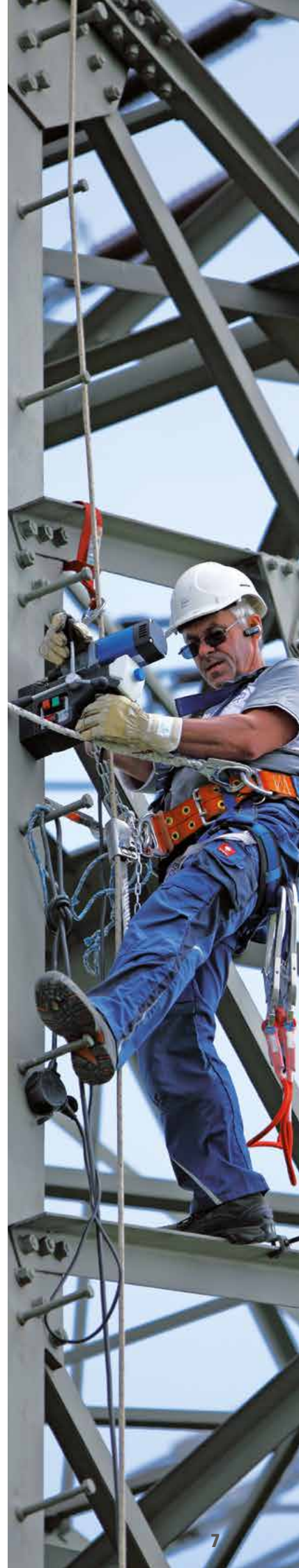
ZSS 300 + ZIA 332-KN

ZAS 003

911058 (6 mm)

4000161

✓





TOP QUALITY AT A LOW PRICE.

**THAT'S HOW AFFORDABLE MADE IN
GERMANY IS. PRECISION DRILLING,
MAXIMUM PERFORMANCE.**



The ProfiBASIC series from BDS Machines is aimed at professional users who do not want to compromise on quality and performance, but can do without additional comfort and extended equipment. These machines offer the proven BDS quality at particularly attractive prices. ProfiBASIC – Economical magnetic drilling machines.

	Core drill max. Ø HSS/TCT
	Core drill cutting depth max.
	Twist drill Ø max.
	Motor output
	Voltage, V AC
	Stroke
	Weight
	Spindle taper
	Speed gears
	Speed range (min ⁻¹)

Carry case

Ejector pin

Arbor

Ejector drift

Allen key

Safety lashing strap

Operating instructions



MABasic 200



32/35 mm (1-3/8")

55 mm (2-3/8")

13 mm (1/2")

1050 W (8.2 A)

230; 110/125 VAC

160 mm (6-1/3")

12 Kg. (27 lbs.)

Direct arbor 19 mm Weldon 3/4"

1

460

Scope of delivery MABasic 200

ZPK 200

ZAK 075, 100

8010251 (4 mm)

4000161



MABasic 400



35/40 mm (1-5/8")

55 mm (2-3/8")

16 mm (5/8")

1100 W (9.5 A)

230; 110/125 VAC

160 mm (6-1/3")

12 Kg. (27 lbs.)

Direct arbor 19 mm Weldon 3/4"

2

430 & 760

Scope of delivery MABasic 400

ZPK 200

ZAK 075, 100

8010251 (4 mm)

4000161



MABasic 450



40/50 mm (2")

55 mm (2-3/8")

18 mm (7/8")

1150 W (10.5 A)

230; 110/125 VAC

160 mm (6-1/3")

13 Kg. (29 lbs.)

Morse Taper MT2

2

250 & 450

Scope of delivery MABasic 450

ZPK 200

ZAK 075, 100

ZIA 219-KN

ZAS 002

8010311 (5 mm)

4000161



MABasic 850



75/80 mm (3")

110 mm (4")

31.75 mm (1-1/4")

1800 W (16 A)

230; 110/125 VAC

255 mm (10")

24 Kg. (53 lbs.)

Morse Taper MT3

4

110, 175, 245 & 385

Scope of delivery MABasic 850

ZHK 800

ZAK 075, 090, 100, 120

ZIA 319-KN, ZIA 332-KN

ZAS 003

8010311 (5 mm), 911058 (6 mm)

4000161



LIGHTWEIGHT. SMALL.

VERSATILE.

COMPACT, LOW PROFILE MACHINE FOR DRILLING IN CONFINED SPACES.



1050 watts motor power

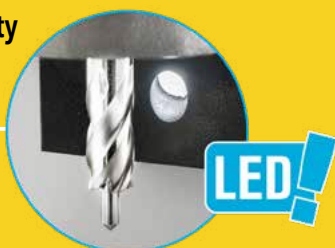
Weighs only 11 kg

Carrying handle

Side interchangeable
ratchet

Strong magnet

LED spotlight for
greater visibility
and precise
drilling



LED!

Compact
height
180 mm

Horizontal Magnetic
Drilling Machine with
angular gearbox.
Ideal for the tightest
drilling situations.
New! Integrated LED
spotlight for greater
safety and precise
drilling.



BDSMASCHINEN
DESIGNED IN GERMANY

MAB 155PRO

Horizontal with angular gearbox,
compact height – 180 mm



	Core drill max. Ø HSS/TCT	35 mm (1-3/8")
	Core drill cutting depth max.	30 mm (1-3/16") / 40 mm*
	Twist drill Ø max.	13 mm (1/2") With SPS Weldon shank twist drills
	Height	180 mm
	Motor output	1050 Watt (8.2 Amp)
	Voltage, V AC	230; 110/125 V AC
	Stroke	39 mm (1-1/2")
	Weight	11 Kg. (24 lbs.)
	Spindle taper	Direct arbor
	Speed gears	1
	Speed range (min ⁻¹)	320
	LED spotlight	✓
	Internal motor cable	✓

Scope of delivery MAB 155PRO

Carry case	ZHK 155
Ejector pin	ZAK 075
Allen key	8010311 (5 mm)
Safety lashing strap	4000161
Operating instructions	✓

*For drilling up to a cutting depth of 40 mm,
please order our special model with item
number MAB 155PSP



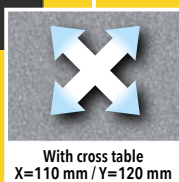
PORTABLE MILLING MACHINE.

WORLD'S FIRST PORTABLE MILLING, DRILLING, AND TAPPING MACHINE FEATURING A MAGNETIC CROSS-TABLE BASE.



 **reddot winner 2021**
innovative product

The integrated cross table allows exact positioning and sensitive movements in the X and Y directions, which facilitates precise drilling and milling work.



The portable milling machine with a magnetic cross table base delivers precision, stability, and versatility, making it ideal for accurate on-site metalworking and industrial maintenance tasks.



BDSMASCHINEN
MADE IN GERMANY

MAB 825 KTS

Drilling, milling, thread cutting, with cross table



	Core drill max. Ø HSS/TCT	80 mm (3")
	Core drill cutting depth max.	55 mm (2-3/8")
	Thread cutting Ø max.	M30 (1-1/8")
	Twist drill Ø max.	31.75 mm (1-1/4")
	Reaming Ø max.	31.75 mm (1-1/4")
	Countersinking Ø max.	50 mm (2-1/2")
	Cross table	X=110 mm, Y=120 mm
	Motor output	1800 Watts (16 Amp)
	Voltage, V AC	230; 110/125 V AC
	Stroke	255 mm (10")
	Weight	57.5 Kg. (127 lbs.)
	Spindle taper	MT 3
	Speed gears	4
	Speed range (min ⁻¹)	40-110; 65-175; 140-360; 220-600
	Permanent internal lubrication	✓
	Safety clutch	✓
	Clockwise/anticlockwise rotation	✓
	Variable torque control	✓
	Variable speed control	✓
	Full wave control electronics	✓
	Magnet indicator	✓
	Overheat protection	✓
	Carbon brush wear indicator	✓

Scope of delivery MAB 825 KTS

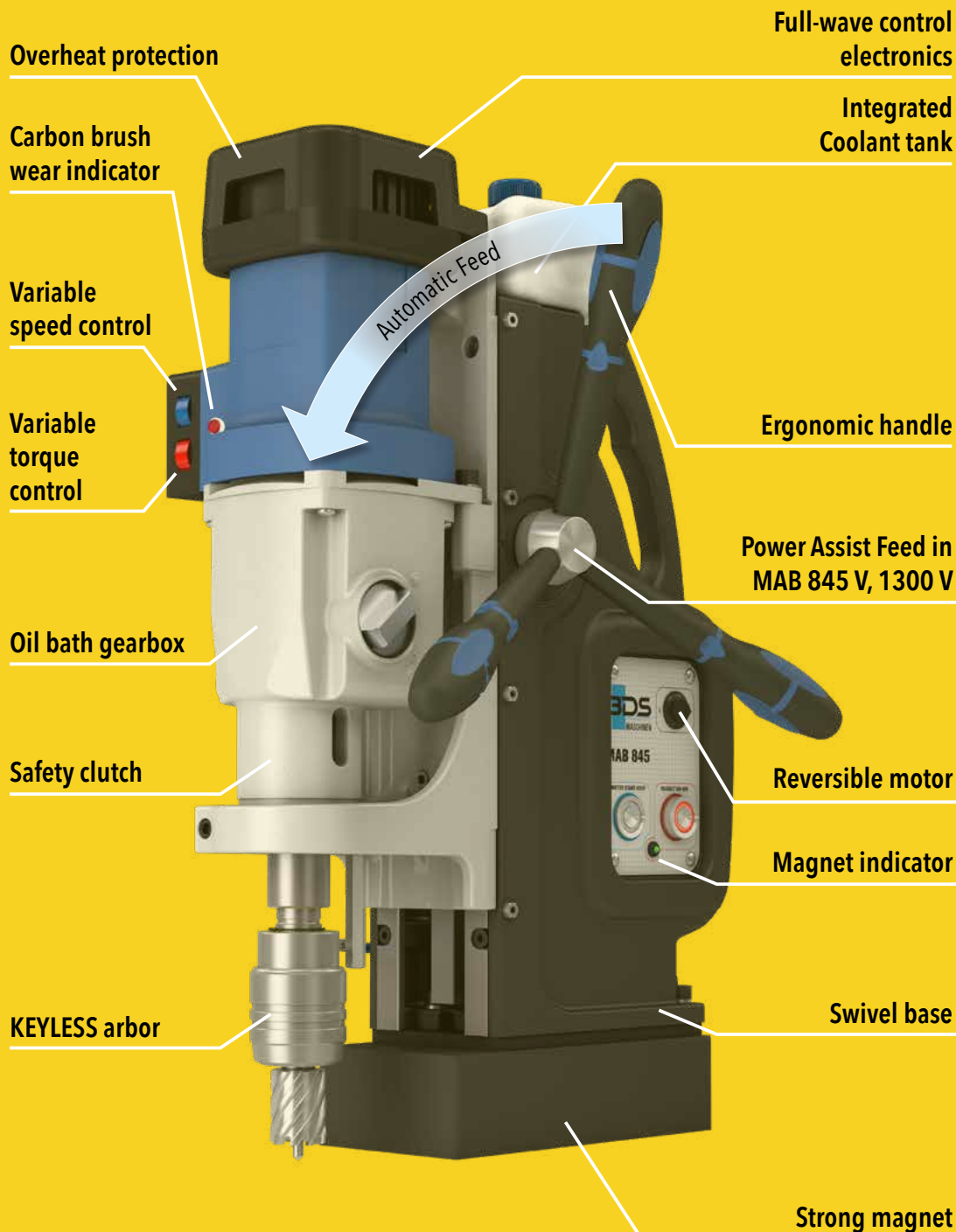
Carry case	ZHK 1500
Ejector pin	ZAK 075, 090, 100, 120
Arbor	ZIA 319-KN, ZIA 332-KN
Ejector drift	ZAS 003
Allen key	8010311 (5 mm), 911058 (6 mm)
Safety lashing strap	4000161
Operating instructions	✓

NOTE: Please order ZSF 316 separately for milling operation

ZSF 316 Collet chuck MT 3,
incl. 15 collets Ø 3 - 16 mm



FULLY AUTOMATIC HANDS-FREE DRILLING. MAXIMUM ACCURACY. SAVE TIME, EFFORT, AND COSTS.



Automatic magnetic drilling machines increase efficiency and productivity as they carry out the drilling process automatically, thus reducing the amount of manual work required. High performance is achieved thanks to the precise and even feed rate, which minimizes drilling errors. This also leads to longer tool life, as the load on the drill is optimally distributed.

	Core drill max. Ø HSS/TCT
	Core drill cutting depth max.
	Thread cutting Ø max.
	Twist drill Ø max.
	Reaming Ø max.
	Countersinking Ø max.
	Swivel Base
	Motor output ⚡ Voltage, V AC
	Power Assist Feed
	Stroke
	Weight
	Spindle taper
	Speed gears
	Speed range (min ⁻¹)
	Oil-bath gearbox
	Safety clutch
	Clockwise/anticlockwise rotation
	Torque control
	Rotational speed control
	Full wave control electronics
	Magnet indicator
	Overheat protection
	Carbon brush wear indicator

Carry case

Ejector pin

Arbor

Ejector drift

Allen key

Safety lashing strap

Operating instructions



BDSMASCHINEN
MADE IN GERMANY



AutoMAB 350

Fully automatic feed



AutoMAB 450

Fully automatic feed



MAB 825 V / 845 V

Adjustable
automatic feed



MAB 1300 V

Adjustable
automatic feed



35 mm (1-3/8")

55 mm (2-3/8")

13 mm (1/2")

45 mm (1-3/4")

55 mm (2-3/8")

13 mm (1/2")

100 mm (4")

60 mm (2-3/8")

55 mm (2-3/8")

110 mm (4")

M30 (1-1/8")

31.75 mm (1-1/4")

31.75 mm (1-1/4")

50 mm (2-1/2")

✓ (MAB 845V)

130 mm (6")

80 mm (3")

55 mm (2-3/8")

110 mm (4")

M42 (1-5/8")

≤ Ø 45 mm (1-3/4")

≤ Ø 50 mm (2-1/2")

≤ Ø 80 mm (3")

1050 Watt (8.2 Amp) / 230; 110/125 V AC

1050 Watts (8.2 Amp) / 230; 110/125 V AC

1800 Watts (16 Amp) / 230; 110/125 V AC

2300 Watts (20 Amp) / 230; 110/125 V AC

150 mm (5-7/8")

160 mm (6-1/4")

255 mm (10")

85/310 mm (3.35" / 12" without retainer)

15 Kg. (33 lbs.)

16 Kg. (35 lbs.)

25 Kg. (55 lbs.)

51 Kg. (112 lbs.)

Direct arbor

MT 2

MT 3

MT 4

1

2

4

4

460

250 & 450

40-110; 56-175; 140-360; 220-600

30-180; 50-120; 130-350; 210-550

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

✓

Scope of delivery AutoMAB 350

ZHK 350

ZAK 075, 100

Scope of delivery AutoMAB 450

ZHK 350

ZAK 075, 100

ZIA 219-KN

ZAS 002

8010251 (4 mm)

4000161

✓

8010311 (5 mm)

4000161

✓

Scope of delivery MAB 825V / 845V

ZHK 1500

ZAK 075, 090, 100, 120

ZIA 319-KN, ZIA 332-KN

ZAS 003

8010311 (5 mm), 911058 (6 mm),
8010381 (8 mm)

4000161

✓

Scope of delivery MAB 1300 V

ZHK 1500

ZAK 075, 090, 100, 120

ZIA 419-KN, ZIA 432-KN

ZAS 004

911058 (6 mm), 8010381 (8 mm)

4000161

✓

PIPE DRILLING, FLEXIBLE AND SAFE.

THE RIGHT SOLUTION FOR EVERY PIPE.



The BDS PipeMAB magnetic core drilling machines, for drilling tubes, pipes and plates. The patented magnetic pipe clamping system automatically adapts to the pipe diameter. The extended support surfaces ensure optimal stability and safety. Resulting in fast, precise, and safe operation with the BDS PipeMAB series.

	Core drill max. Ø HSS/TCT
	Core drill cutting depth max.
	Thread cutting Ø max.
	Twist drill Ø max.
	Reaming Ø max.
	Countersinking Ø max.
	Permanent magnet for pipes & plates
	Motor output
	Voltage, VAC
	Stroke
	Weight
	Spindle taper
	Speed gears
	Speed range (min ⁻¹)
	Oil-bath gearbox & Internal motor cable
	Safety clutch
	Clockwise/anticlockwise rotation
	Torque control
	Rotational speed control
	Full wave control electronics
	Magnet indicator
	Overheat protection
	Carbon brush wear indicator

Carry case
Ejector pin
Arbor
Tapping adapter
Gear rim drill chuck
Taper drift
Ejector drift
Allen key
Safety lashing strap
Operating instructions



PipeMAB 200

Pipe drilling machine



35 mm (1-3/8")

55 mm (2-3/8")

13 mm (1/2")



1050 Watts (8.2 Amp)

230; 110/125 V AC

160 mm (6-1/3")

16 Kg. (35 lbs.)

Direct Arbor

1

450



PipeMAB 525

Pipe drilling and
tapping machine



60 mm (2-3/8")

75 mm (3")

M20 (3/4")

20 mm (1")

20 mm (1")

50 mm (2-1/2")



1600 Watts (14.50 Amp)

230; 110/125 V AC

160 mm (6-1/4")

16 Kg. (35 lbs.)

MT 3

2

70-280; 180-580



PipeMAB 825

Pipe drilling and
tapping machine



100 mm (4")

60 mm (2-3/8")

55 mm (2-3/8")

110mm (4")

M30 (1-1/8")

31.75 mm (1-1/4")

31.75 mm (1-1/4")

50 mm (2-1/2")



1800 Watts (16 Amp)

230; 110/125 V AC

255 mm (10")

25 Kg. (55 lbs.)

MT 3

4

40-110; 65-175; 140-360; 220-600



AirMAB 5000PRO

Pipe drilling with pneumatic
Atlas Copco motor



35 mm (1-3/8")

55 mm (2-3/8")

23 mm (29/32")



830 Watt (4 Amp)

Compressed air

160 mm (6-1/4")

15 Kg. (33 lbs.)

MT 2 - KEYLESS arbor (19mm Weldon 3/4)

min. 290 - max. 575

Scope of delivery PipeMAB 200

ZHK 800

ZAK 075, 100

8010251 (4 mm)

4000161



Scope of delivery PipeMAB 525

ZHK 800

ZAK 075, 100

ZIAL 319-KN

ZGA 010, 012, 016

ZBK 113

ZKD 316

ZAS 003

8010301 (3 mm)

4000161



Scope of delivery PipeMAB 825

ZHK 1500

ZAK 075, 090, 100, 120

ZIAL 319-KN

ZAS 003

911058 (6 mm)

4000161



Scope of delivery AirMAB 5000PRO

ZHK 800

ZAK 075, 100

ZSS 200

ZAS 002

4000161



RAIL DRILLING:

FLEXIBLE WITH PETROL OR ELECTRIC MOTOR.



	eRailMAB 450 Battery-Powered Rail core drilling machine	RailMAB 915 Rail core drilling machine with electric motor	RailMAB 965 Rail core drilling machine with petrol motor
Core drill max. Ø HSS/TCT	36 mm (2-1/16")	36 mm (2-1/16")	36 mm (2-1/16")
Core drill cutting depth max.	55 mm (2-3/8")	55 mm (2-3/8")	55 mm (2-3/8")
Thread cutting Ø max.	M16 (5/8")		
Twist drill Ø max.	18 mm (7/8")	20 mm (1")	20 mm (1")
Motor output	1100 Watts	1600 Watts (14.50 Amp)	1500 Watts (2 HP)
Voltage, V AC	18 Volt / 10.4 Ah	230; 110/125 V AC	3.04 Nm torque. 49.4 ccm displacement.
Stroke	135 mm (5 5/16")	160 mm (6-1/4")	40 mm (1 9/16")
Weight	13 Kg. (25.4 lbs.) without battery	16 Kg. (35 lbs.)	21.5 Kg. (47 lbs.)
Spindle taper	Direct arbor	MT 3	Direct arbor 19mm Weldon 3/4"
Speed gears	1	2	1
Speed range (min ⁻¹)	134, 189, 246, 298, 355	70 – 580	min. 110 – max. 280
Quick clamping device	✓	✓	✓
Oil-bath gearbox		✓	
Safety clutch		✓	
Torque control		✓	
Rotational speed control	✓	✓	
Overheat protection		✓	
Carbon brush wear indicator		✓	
	Scope of delivery eRailMAB 450	Scope of delivery RailMAB 915	Scope of delivery RailMAB 965
Carry case	ZHK 825	ZHK 825	Metal case
Ejector pin	ZAK 075	ZAK 075, 100	ZAK 075
Arbor		ZIA 319-KN	
Ejector drift	AKKU-18V10.4	ZAS 003	
Allen key		8010251 (4 mm), 8010311 (5 mm), 911058 (6 mm)	8010251 (4 mm), 8010311 (5 mm), 911058 (6 mm)
Rail adapter	1 included, depending on your choice	1 included, depending on your choice	1 included, depending on your choice
High-pressure coolant tank	✓	✓	✓
Operating instructions	✓	✓	✓



Order no.	RailMAB 915 eRailMAB 450	Order no.	RailMAB 965
ZAS 049S	Rail adapter S 49	ZAS 250U	Rail adapter UIC 50
ZAS 054S	Rail adapter S 54	ZAS 254U	Rail adapter UIC 54
ZAS 050U	Rail adapter UIC 50	ZAS 260U	Rail adapter UIC 60
ZAS 054U	Rail adapter UIC 54	ZAS 249S	Rail adapter S 49
		ZAS 254S	Rail adapter S54

CORDLESS, BRUSHLESS, LIMITLESS.

THE NEW **eMAB 450**

**CORDLESS MAGNETIC DRILLING MACHINE.
HEAVY-DUTY PERFORMANCE MEETS
CORDLESS FREEDOM - ENGINEERED FOR
TRUE PROFESSIONALS.**

Magnet indicator

Variable speed control

Reversible motor

Brushless motor

Smart Control Panel

Adjustable
lifting handle

Ergonomic
handle

Lithium-Ion
Battery
18 V / 10.4 Ah

Permanent
magnet (non-electric)

Height-Adjustable
motor

Compatible with pipes $\geq \varnothing 80$ mm

- ▶ Cordless and Mobile - No power supply needed, versatile in use
- ▶ Durable Motor - Brushless motor reduces wear
- ▶ High Magnetic Force - Permanent magnet ensure secure hold
- ▶ Low Maintenance - Fewer wear parts, reduced service effort
- ▶ Reversible - Motor with clockwise and counterclockwise rotation

The new cordless magnetic core drilling machine with a 18 V / 10.4 Ah battery offers precise, cordless drilling for professional use. A brushless motor ensures high efficiency and low maintenance. The integrated permanent magnet provides strong adhesion and reliable performance - ideal for demanding applications on construction sites or in assembly work. It also features a reversible motor with clockwise and counterclockwise rotation for added versatility.



eMAB 450

Battery-Powered
Magnetic Drill
with Brushless Motor
and Permanent Magnet



	Core drill max. $\varnothing$ HSS/TCT	36/40 mm (2-1/16")
	Core drill cutting depth max.	55 mm (2-3/8")
	Thread cutting $\varnothing$ max.	M16 (5/8")
	Twist drill $\varnothing$ max.	18 mm (7/8")
	Battery	Li-Ion 18 V / 10.4 Ah / 187 Wh
	Motor output	1100 Watts
	Voltage, V AC	18 Volt / 10.4 Ah
	Stroke	135 mm (5 5/16")
	Weight	13 Kg. (25.4 lbs.) without battery
	Spindle taper	Direct arbor
	Speed gears	1
	Speed range (min ⁻¹)	134, 189, 246, 298, 355
	Brushless motor	✓
	Permanent magnet	✓
	Variable speed control	✓
	Magnet indicator	✓

Scope of delivery eMAB 450

Carry case	ZHK 400
Battery (20V Li-Ion)	AKKU-18V10.4
Battery charger	DOCK-18
Ejector pin	ZAK 075, ZAK 090
Safety lashing strap	4000161
Operating instructions	✓

HIGH-PERFORMANCE BRUSHLESS FULL-COPPER MOTOR

Efficient, long-lasting brushless motor designed for minimal wear. Full copper windings ensure optimal conductivity and heat dissipation. Delivers powerful torque, quiet operation, and high reliability with low energy consumption.



***YOU NEED IT?
WE'LL BUILD IT!***

***CUSTOMIZED SPECIAL PURPOSE MACHINES,
MADE IN GERMANY BY EXPERTS.***

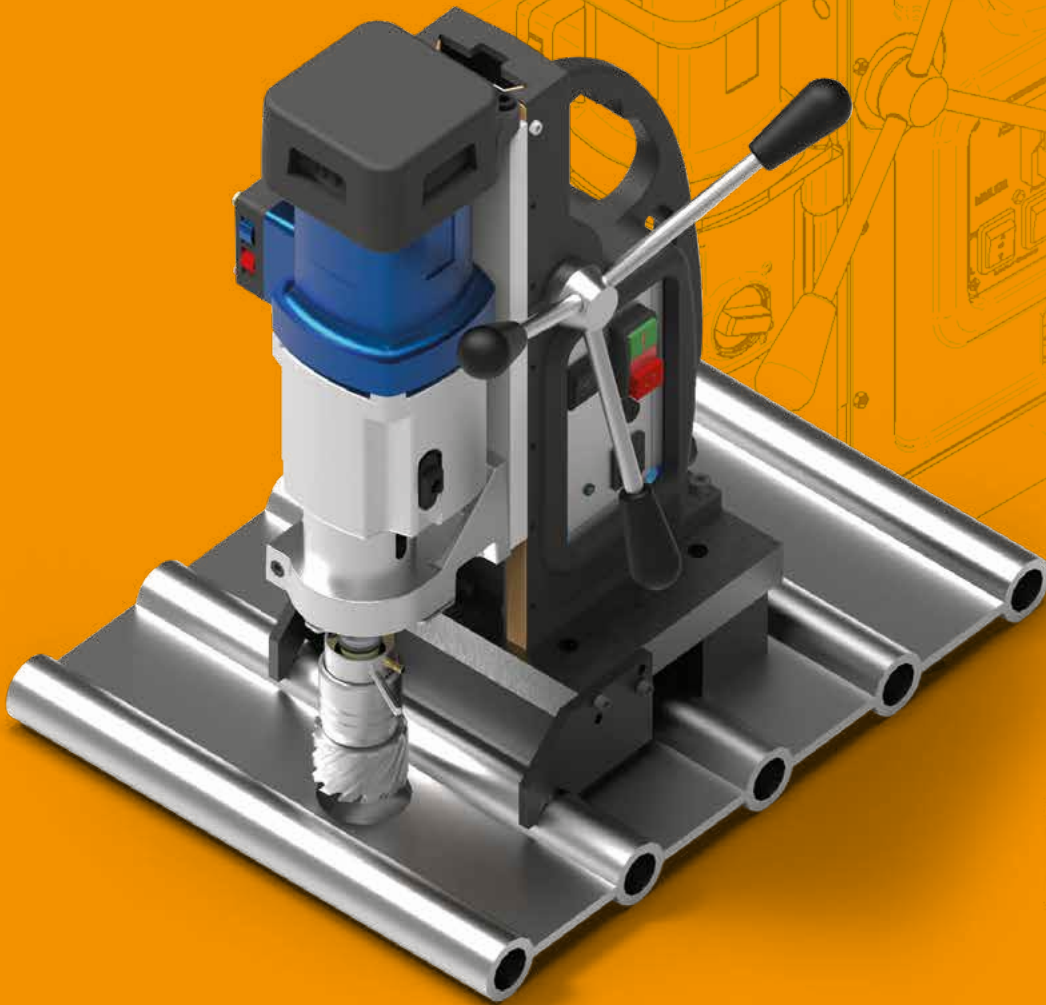
**SPECIAL MACHINES FOR
SPECIAL REQUIREMENTS.**

**YOU DEFINE THE CHAL-
LENGE WE CREATE THE
SOLUTION.
MADE IN GERMANY.**

Do you have special applications
that standard machines can't
handle effectively?

Don't hesitate to contact us –
we're happy to provide expert,
no-obligation advice.

You need it? We'll build it!



CUSTOMISED DRILLING SOLUTION: PRECISION WITHOUT LIMITS.

EVERY MACHINE IS UNIQUE.

Our designers, project managers, and specialists in metal processing and assembly regularly face complex challenges. To meet these demands, our project managers work closely with customers to define timelines and budgets for each custom machine. Reference workpieces are provided in advance to ensure solutions are precisely tailored to real-world requirements. From there, our design engineers and technical product designers collaborate to create detailed CAD models, which are then handed over to our production team for implementation.



Two inline magnetic drilling machines specially designed for drilling with a single feed mechanism.



Special magnetic drilling machine with drilling angle adjustment. Angle adjustment according to customer requirements.



Special magnetic drilling machine with stroke extension and reversed motor.



Special magnetic drilling machine with extended stroke of up to 1000 mm.



CUSTOMIZED AND ADAPTED TO CUSTOMER REQUIREMENTS.

From planning to production, employees from a wide range of disciplines collaborate closely, continuously developing innovative and efficient new models. Our engineers design and build customized production machines specifically tailored to each unique workpiece, taking into account differing materials, sizes, and operational requirements. Every project is handled with precision, from the initial idea through development, design, and final realization, ensuring that BDS Machines delivers complete solutions from a single source. Throughout the process, our focus remains on creating machines that are not only technically advanced but also reliable, safe, and easy to operate. In the end, what truly matters is that each machine performs its function flawlessly, meeting and often exceeding customer expectations.

YOUR SPECIAL SOLUTION IN JUST 4 STEPS:

1. Send us your inquiry or request a callback.
2. Our expert will contact you shortly for a detailed consultation.
3. After thoroughly reviewing your special requirements, we will provide an offer for your approval.
4. Delivery of your custom solution within the agreed timeframe, guaranteed with professional "Made in Germany" quality.

+49-2161-35460

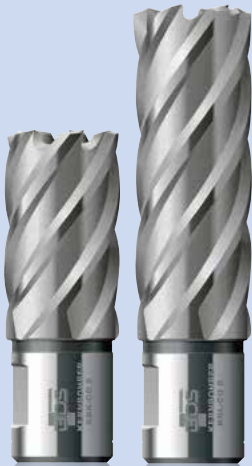
@ export@bds-maschinen.de



Series HSS-Co 8

Annular Cutters made from special steel with a high cobalt content.

- High heat resistance
- Better wear protection
- High cobalt content of 8%
- Suitable for higher loads in fine-grained steels and stainless materials
- Available with 19 mm or 32 mm Weldon shank
- Regrindable



KBK-CO

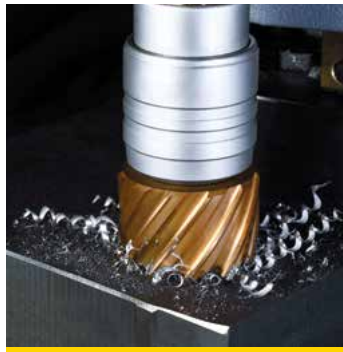
KBL-CO

Cutting depth
30 mm

Cutting depth
55 mm

Drilling diameter
12 – 130 mm

Drilling diameter
12 – 100 mm



Series HSS-VarioPLUS

High Speed Steel Annular Cutters with premium carbide coating.

- High-strength solid ground core drills
- Hardness-resistant layer in the range of 2.5 μ – for longer service life.
- More even chip evacuation, especially with long drills - an important point for work safety
- Regrindable



KBK-VP

KBL-VP

Cutting depth
30 mm

Cutting depth
55 mm

Drilling diameter
12 – 60 mm

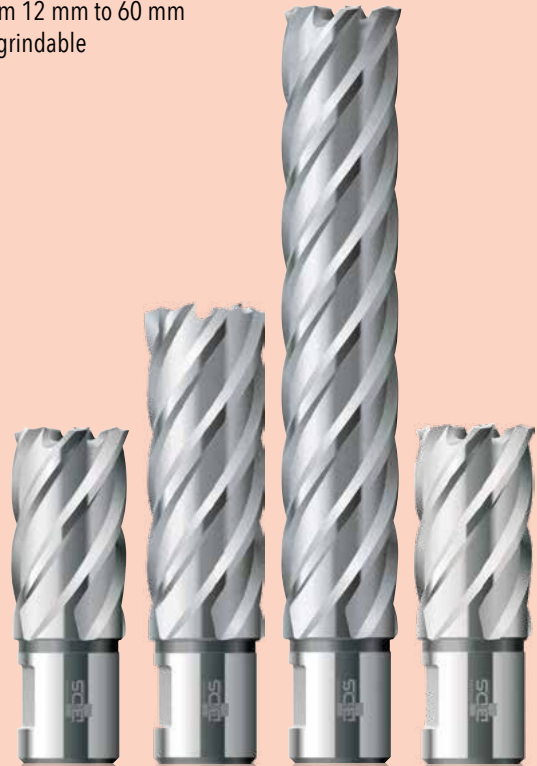
Drilling diameter
12 – 60 mm



Series HSS-Standard

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

- Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- Core drill diameter from 12 mm to 60 mm
- Regrindable



KBK

KBL

KEL

KBK-Z

Cutting depth
30 mm

Cutting depth
55 mm

Cutting depth
110 mm

Cutting depth
30 mm

Drilling diameter
12 – 60 mm

Drilling diameter
12 – 60 mm

Drilling diameter
20 – 50 mm

Drilling diameter
 $\frac{1}{2}$ " – $2\frac{1}{16}$ "

TOOL HOLDERS / SHANK TYPE

BDS core drilling tools are available with various tool holders to suit different machines and applications. All BDS annular cutters come standard with the WELDON shank system. Cutters up to 60 mm in diameter feature a 19 mm Weldon shank, while cutters from 61 mm upwards use a 32 mm Weldon shank. BDS also offers annular cutters with, Nitto shank, Universal shank (a combination of Weldon and Nitto), 18 mm Quick-In shank. This versatility ensures compatibility with a wide range of magnetic drilling machines.



19 mm
Weldon shank ($\frac{3}{4}$ ")



32 mm
Weldon shank ($1\frac{1}{4}$ ")



18 mm
Quick-In shank



Carbide Annular Cutters option-
ally available as universal shank
(Nitto + Weldon)



BDS FULLY-GROUND ANNULAR CUTTERS.

**THEY MAKE THE DIFFERENCE: MAXIMUM
CUTTING PERFORMANCE FOR MORE HOLES!**

Series Carbide

Annular Cutters with tungsten carbide tips. Tungsten carbide tips are ultra-hard, wear-resistant inserts used to enhance the durability and cutting performance of tools. Ideal for drilling tough materials, they provide longer tool life, increased precision, and improved efficiency in demanding industrial applications.

- Cutting depths of 30 mm, 55 mm, 75 mm and 110 mm
- Diameter from 12 mm to 150 mm



HKK	HKL	HXX-L	HKE-L
Cutting depth 30 mm	Cutting depth 55 mm	Cutting depth 75 mm	Cutting depth 110 mm
Drilling diameter 12 – 150 mm	Drilling diameter 12 – 100 mm	Drilling diameter 18 – 120 mm	Drilling diameter 20 – 120 mm

Series Carbide-PLUS

Carbide PLUS additionally with wear-resistant hard coating up to 2.5 μ .



HKK-P

Cutting depth
30 mm
Drilling diameter
12 – 60 mm

Series Carbide-RAIL

Annular Cutter with tungsten carbide tips for drilling rail-way tracks and hard material.



HKK-R

Cutting depth
30 mm
Drilling diameter
12 – 50 mm

Series Quick-In HSS-Co 8-F / Carbide

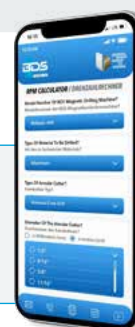
Annular Cutters made of HSS tool steel or with tungsten carbide tip. Suitable for Quick-In holding systems. Annular Cutter with 18 mm shank for Quick-In mounting system.

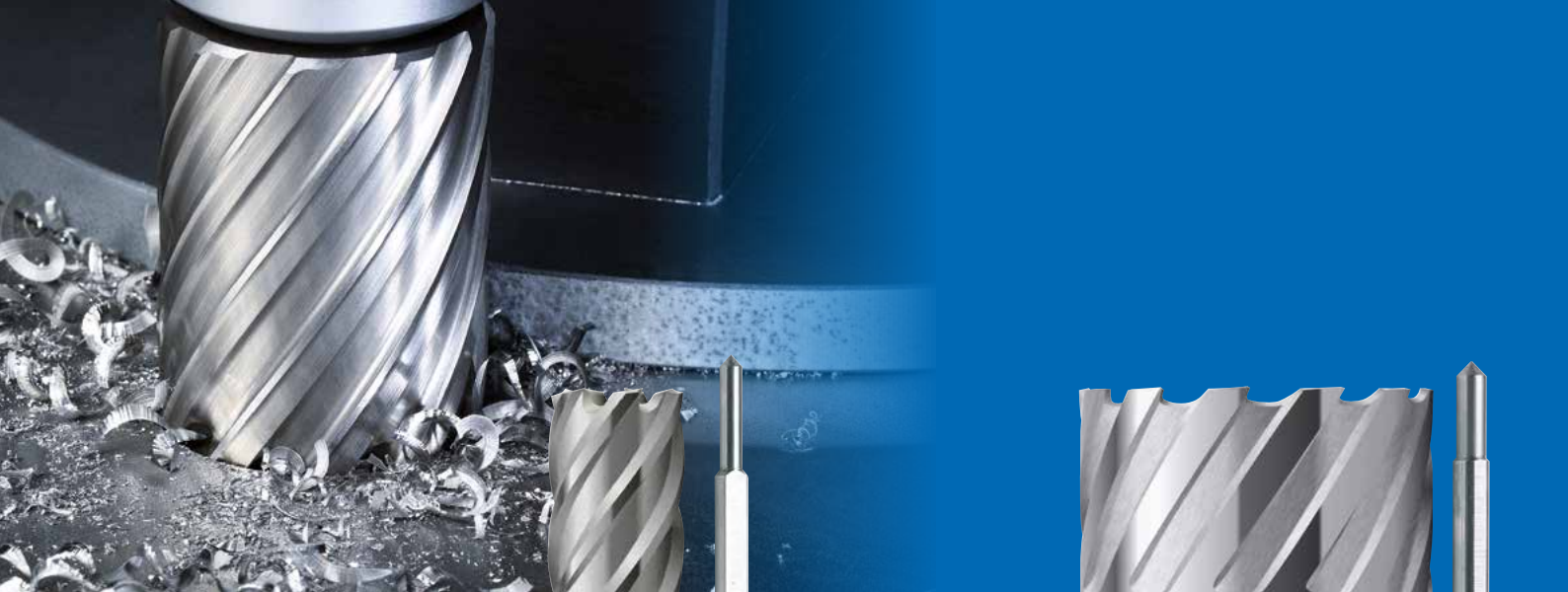


KBK-CO 8 F	HKK-F
Cutting depth 35 mm	Cutting depth 35 mm
Drilling diameter 12 – 60 mm	Drilling diameter 12 – 60 mm

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.





HSS-CO 8 ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.
12	KBK-CO 012
13	KBK-CO 013
14	KBK-CO 014
15	KBK-CO 015
16	KBK-CO 016
17	KBK-CO 017
17.5	KBK-CO 17,5
18	KBK-CO 018
19	KBK-CO 019
19.5	KBK-CO 19,5
20	KBK-CO 020
21	KBK-CO 021
22	KBK-CO 022
23	KBK-CO 023
24	KBK-CO 024
25	KBK-CO 025
26	KBK-CO 026
27	KBK-CO 027
28	KBK-CO 028
29	KBK-CO 029
30	KBK-CO 030
31	KBK-CO 031
32	KBK-CO 032
33	KBK-CO 033
34	KBK-CO 034
35	KBK-CO 035

HSS-CO 8 ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 32 mm Weldon shank (1 ¼")



Ø mm	Order no.
61	KBK-CO 061
62	KBK-CO 062
63	KBK-CO 063
64	KBK-CO 064
65	KBK-CO 065
66	KBK-CO 066
67	KBK-CO 067
68	KBK-CO 068
69	KBK-CO 069
70	KBK-CO 070
71	KBK-CO 071
72	KBK-CO 072
73	KBK-CO 073
74	KBK-CO 074
75	KBK-CO 075
76	KBK-CO 076
77	KBK-CO 077
78	KBK-CO 078
79	KBK-CO 079
80	KBK-CO 080
81	KBK-CO 081
82	KBK-CO 082
83	KBK-CO 083

Ø mm	Order no.
84	KBK-CO 084
85	KBK-CO 085
86	KBK-CO 086
87	KBK-CO 087
88	KBK-CO 088
89	KBK-CO 089
90	KBK-CO 090
91	KBK-CO 091
92	KBK-CO 092
93	KBK-CO 093
94	KBK-CO 094
95	KBK-CO 095
96	KBK-CO 096
97	KBK-CO 097
98	KBK-CO 098
99	KBK-CO 099
100	KBK-CO 100
105	KBK-CO 105
110	KBK-CO 110
115	KBK-CO 115
120	KBK-CO 120
125	KBK-CO 125
130	KBK-CO 130

Ejector pin for KBK-CO Ø 12 - 60 mm

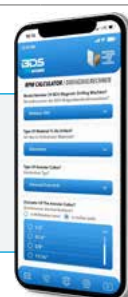
ZAK 075

Ejector pin for KBK-CO Ø 61- 130 mm

ZAK 090

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



ANNULAR CUTTERS SERIES HSS-CO 8

FULLY-GROUND CORE DRILL MADE FROM HIGH-PERFORMANCE HIGH-SPEED STEEL.

The annular cutters in this series are characterized by high heat resistance and excellent wear protection. They are ideal for use with speed-controlled BDS magnetic drilling machines and are especially suitable for processing fine-grain steels and stainless materials.



Videos & documents

HSS-CO 8 ANNULAR CUTTER LONG

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



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 17,5	42	KBL-CO 042
18	KBL-CO 018	43	KBL-CO 043
19	KBL-CO 019	44	KBL-CO 044
19.5	KBL-CO 19,5	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 ANNULAR CUTTER LONG

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



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

ZAK 100

Ejector pin for KBL-CO Ø 61 - 100 mm

ZAK 120

Recommended lubricants

Order no.	Article (suitable for all HSS-CO 8 Annular Cutters)
ZHS 005	BDS 5000 Cutting oil (5 liters)
ZHS 006	BDS 5000 Cutting oil (1 liter)
ZHS 571	BDS 7500 Cutting paste, 120 g Brush-Top can



Order no.	Article (suitable for all HSS-CO 8 Annular Cutters)
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



ANNULAR CUTTERS SERIES HSS-VarioPLUS



Videos & documents

Fully-ground core drill made of high-performance HSS with a hard material coating. Offers high economic efficiency thanks to extended service life and increased work safety, supported by excellent chip evacuation – especially with long annular cutters. For optimal performance, BDS recommends using BDS 5000 high-performance cutting oil.

HSS-VarioPLUS ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



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 17,5	42	KBK-VP 042
18	KBK-VP 018	43	KBK-VP 043
19	KBK-VP 019	44	KBK-VP 044
19.5	KBK-VP 19,5	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

ZAK 075

HSS-VarioPLUS ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



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 17,5	42	KBL-VP 042
18	KBL-VP 018	43	KBL-VP 043
19	KBL-VP 019	44	KBL-VP 044
19.5	KBL-VP 19,5	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

ZAK 100

Recommended lubricants

Order no.	Article (suitable for all HSS-VarioPLUS)
ZHS 005	BDS 5000 Cutting oil (5 liters)
ZHS 006	BDS 5000 Cutting oil (1 liter)
ZHS 571	BDS 7500 Cutting paste, 120 g Brush-Top can



Order no.	Article (suitable for all HSS-VarioPLUS)
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



ANNULAR CUTTERS SERIES QUICK-IN HSS & TCT

High-performance annular cutters manufactured from HSS Co 8% and tungsten carbide tipped designs with Quick-IN shank system. Featuring 35 mm cutting depth and an 18 mm shank diameter, they offer excellent wear resistance, fast tool changes, and reliable drilling performance in demanding industrial metalworking applications.



Videos & documents



Videos & documents

QUICK-IN HSS-Co 8-F ANNULAR CUTTER SHORT

- ▶ 35 mm Cutting depth
- ▶ 18 mm shank for Quick-In Chuck system



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

QUICK-IN CARBIDE-F ANNULAR CUTTER SHORT

- ▶ 35 mm Cutting depth
- ▶ 18 mm shank for Quick-In Chuck system



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

Ejector pin for HSS-Co 8-F, Ø 12 - 60 mm

ZAK 075

Ejector pin for HKK-F, Ø 12 - 60 mm

ZAK 075

Order no. Article (suitable for all HSS Quick-In)

ZHS 005 BDS 5000 Cutting oil (5 liters)

ZHS 006 BDS 5000 Cutting oil (1 liter)

ZHS 571 BDS 7500 Cutting paste, 120 g Brush-Top can



Order no. Article (suitable for all TCT Quick-In)

ZHB 001 BDS 6000 Lubricant concentrate

ZHS 400 BDS 5200 Lub. spray 1 x 400 ml Can

ZHS 571 BDS 7500 Cutting paste, 120 g Brush-Top can



ANNULAR CUTTERS SERIES HSS-STANDARD

The standard Annular Cutter range for professional use. These fully-ground annular cutters are made from high-speed steel and manufactured on CNC-controlled grinding centers. They ensure good chip evacuation and effortless drilling. For horizontal applications, BDS recommends the BDS 5200 high-performance grease spray.

HSS-STANDARD ANNULAR CUTTER SHORT

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



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

HSS-STANDARD ANNULAR CUTTER LONG

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



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 17,5	42	KBL 042
18	KBL 018	43	KBL 043
19	KBL 019	44	KBL 044
19.5	KBL 19,5	45	KBL 045
20	KBL 020	46	KBL 046
21	KBL 021	47	KBL 047
22	KBL 022	48	KBL 048
23	KBL 023	49	KBL 049
24	KBL 024	50	KBL 050
25	KBL 025	51	KBL 051
26	KBL 026	52	KBL 052
27	KBL 027	53	KBL 053
28	KBL 028	54	KBL 054
29	KBL 029	55	KBL 055
30	KBL 030	56	KBL 056
31	KBL 031	57	KBL 057
32	KBL 032	58	KBL 058
33	KBL 033	59	KBL 059
34	KBL 034	60	KBL 060
35	KBL 035		

Ejector pin for KBK, Ø 12 - 60 mm

ZAK 075

Ejector pin for KBL, Ø 12 - 60 mm

ZAK 100

Recommended lubricants

Order no. Article (suitable for all HSS Annular Cutters)

ZHS 005 BDS 5000 Cutting oil (5 liters)

ZHS 006 BDS 5000 Cutting oil (1 liter)

ZHS 571 BDS 7500 Cutting paste, 120 g Brush-Top can



Order no. Article (suitable for all HSS Annular Cutters)

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





Videos & documents

HSS-STANDARD ANNULAR CUTTER EXTRA LONG

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



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 ANNULAR CUTTERS AVAILABLE IN INCH DIAMETERS

High-Quality Annular Cutter – Inch Sizes, 1 3/16" (30 mm) Cutting Depth. Designed for precise and efficient metal drilling, this robust annular cutter is made from high-performance steel, ensuring long tool life and clean cuts. Its compact length provides excellent control, even in confined spaces, making it ideal for professional use in both industry and trade.

HSS STANDARD ANNULAR CUTTER, SHORT, INCH

- ▶ 30 mm (≈ 1 3/16")
- ▶ 19 mm (3/4") Weldon shank



Ø Zoll	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

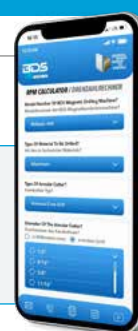
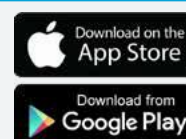
ZAK 275 2-part construction

Ejector pin for KBK-Z, Ø 1/2" – 2 1/16"

ZAK 075

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



SERIES CARBIDE TUNGSTEN CARBIDE TIPPED (TCT) ANNULAR CUTTERS

CARBIDE ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



CARBIDE ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 32 mm Weldon shank (1¼")



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

ZAK 075

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

ZAK 090

Recommended lubricants

Order no. Article (suitable for all TCT Annular Cutters)

ZHB 001 BDS 6000 Lubricant concentrate

ZHS 550 BDS 5500 Cutting paste, 1000 g

ZHS 571 BDS 7500 Cutting paste, 120 g Brush-Top can



Order no. Article (suitable for all TCT Annular Cutters)

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



Tungsten Carbide Tipped (TCT) Annular Cutters – High Performance for Tough Materials
Carbide annular cutters deliver exceptional cutting performance, enabling fast and efficient drilling through hard materials such as steel, stainless steel, and cast iron. Their extreme hardness and wear resistance ensure long-lasting sharpness, significantly extending tool life.



Videos & documents

CARBIDE ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



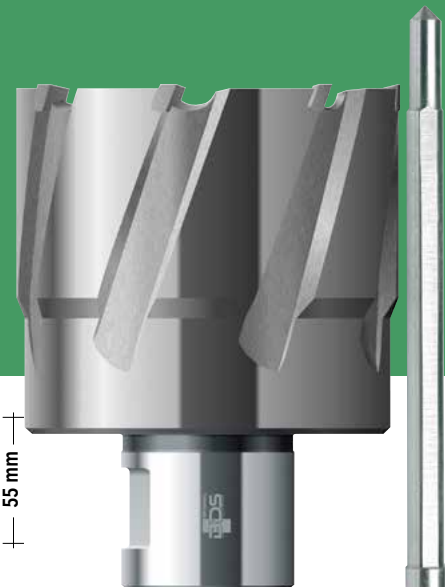
Ø mm	Order no.	Ø mm	Order no.
12	HKL 012	37	HKL 037
13	HKL 013	38	HKL 038
14	HKL 014	39	HKL 039
15	HKL 015	40	HKL 040
16	HKL 016	41	HKL 041
17	HKL 017	42	HKL 042
18	HKL 018	43	HKL 043
19	HKL 019	44	HKL 044
20	HKL 020	45	HKL 045
21	HKL 021	46	HKL 046
22	HKL 022	47	HKL 047
23	HKL 023	48	HKL 048
24	HKL 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		

Ejector pin for HKL, Ø 14 – 60 mm

ZAK 100

CARBIDE ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 32 mm Weldon shank (1¼")



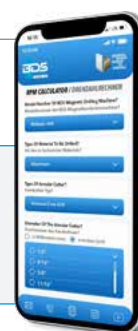
Ø mm	Order no.	Ø mm	Order no.
61	HKL 061	81	HKL 081
62	HKL 062	82	HKL 082
63	HKL 063	83	HKL 083
64	HKL 064	84	HKL 084
65	HKL 065	85	HKL 085
66	HKL 066	86	HKL 086
67	HKL 067	87	HKL 087
68	HKL 068	88	HKL 088
69	HKL 069	89	HKL 089
70	HKL 070	90	HKL 090
71	HKL 071	91	HKL 091
72	HKL 072	92	HKL 092
73	HKL 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 61 – 100 mm

ZAK 120

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



ANNULAR CUTTERS SERIES CARBIDE TUNGSTEN CARBIDE TIPPED (TCT)



Videos & documents

CARBIDE ANNULAR CUTTER LONG PLUS

- ▶ 75 mm Cutting depth
- ▶ up to Ø 60 mm: 19 mm Weldon shank (¾")
- ▶ from Ø 61 mm: 32 mm Weldon shank (1¼")



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 ANNULAR CUTTER EXTRA LONG

- ▶ 110 mm Cutting depth
- ▶ up to Ø 60 mm: 19 mm Weldon shank (¾")
- ▶ from Ø 61 mm: 32 mm Weldon shank (1¼")



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

Ejector pin for HKX-L, Ø 18 - 120 mm

ZAK 225 2-piece for Annular Cutter Cutting depth 75 mm Ø 19 - 60

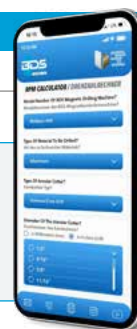
ZAK 245 2-piece for Annular Cutter Cutting depth 75 mm Ø 61 - 120

Ejector pin for HKE-L, Ø 20 - 120 mm

ZAK 275 2-part design

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.





Videos & documents



Videos & documents

CarbidePLUS ANNULAR CUTTER

TCT Annular Cutters with Premium Carbide Coating – High durability and precision for hard metals.

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



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

ZAK 075

CarbideRAIL ANNULAR CUTTER

Special TCT Annular Cutters for Railway Track Drilling. Made with a higher grade of carbide for enhanced durability and performance in tough rail steel.

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	HKK-R 012	28	HKK-R 028
13	HKK-R 013	29	HKK-R 029
14	HKK-R 014	30	HKK-R 030
15	HKK-R 015	31	HKK-R 031
17	HKK-R 017	32	HKK-R 032
18	HKK-R 018	33	HKK-R 033
19	HKK-R 019	34	HKK-R 034
20	HKK-R 020	35	HKK-R 035
21	HKK-R 021	36	HKK-R 036
22	HKK-R 022	37	HKK-R 037
23	HKK-R 023	38	HKK-R 038
24	HKK-R 024	39	HKK-R 039
25	HKK-R 025	40	HKK-R 040
26	HKK-R 026	50	HKK-R 050
27	HKK-R 027		

Ejector pin for HKK-R, Ø 12 – 50 mm

ZAK 075

Recommended lubricants

Order no. Article (suitable for all CarbidePLUS & Rail)

ZHB 001 BDS 6000 Lubricant concentrate

ZHS 550 BDS 5500 Cutting paste, 1000 g

ZHS 571 BDS 7500 Cutting paste, 120 g Brush-Top can



Order no. Article (suitable for all CarbidePLUS & Rail)

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



BDS ANNULAR CUTTER BOXES & CASSETTES

SIMPLY WELL SORTED!

Five BDS Annular Cutters in the most commonly used sizes in a compact box.

- ▶ Available in 30 mm and 55 mm cutting depth
- ▶ 19 mm Weldon shank ($\frac{3}{4}$ ")



Videos & Dokumente



HSS STANDARD ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK 014
BOX1	2 x KBK 018
	1 x KBK 022

HSS STANDARD ANNULAR CUTTER LONG



Order no. Content

KBL	2 x KBL 014
BOX1	2 x KBL 018
	1 x KBL 022

HSS VarioPLUS ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK-VP 014
BOX1-V	2 x KBK-VP 018
	1 x KBK-VP 022

HSS VarioPLUS ANNULAR CUTTER LONG



Order no. Content

KBL	2 x KBL-VP 014
BOX1-V	2 x KBL-VP 018
	1 x KBL-VP 022

HSS COBALT 8% ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK-CO 014
BOX1-CO	2 x KBK-CO 018
	1 x KBK-CO 022

CARBIDE (TCT) ANNULAR CUTTER SHORT



Order no. Content

HKK	2 x HKK 014
BOX	2 x HKK 018
	1 x HKK 022

BDS ANNULAR CUTTER CASSETTES

6 ANNULAR CUTTERS PLUS EJECTOR PIN

Six BDS Annular Cutters in the most commonly used sizes in a sturdy cassette.

- ▶ High Speed Steel
- ▶ 30 mm cutting depth
- ▶ 19 mm Weldon shank ($\frac{3}{4}$ ")
- ▶ Suitable ejector pin
- ▶ Premium quality cassette

HSS STANDARD ANNULAR CUTTER



Order no. Content

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 ANNULAR CUTTER



Order no. Content

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

HSS COBALT 8% ANNULAR CUTTER



Order no. Content

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



TOOLS WITH WELDON SHANK

**TWIST DRILLS, COUNTERSINKS AND MACHINE TAPS -
PERFECTLY MATCHED FOR YOUR MAGNETIC CORE DRILLING MACHINE.**



HSS Twist drill with
19 mm (¾")
Weldon shank,
Spiral length 35 mm



Ø	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

Taper and deburring
countersink 90°,
three cutting edges



Ø	Shaft	Order no.
20.5	Cylinder shaft	ZSE 205
40	Weldon shank 19 mm (¾")	ZSE 040
50	Weldon shank 19 mm (¾")	ZSE 050
40	MT 3	ZSE 340
50	MT 3	ZSE 350

HSS machine tap with 19 mm (¾")
Weldon shank

DIN 376 Form B up to GWB 020 with
19 mm Weldon shank (¾") from
GWB 022 with 32 mm Weldon shank (1½")



Ø	Length	Order no.
M8	90 mm	GWB 008
M10	100 mm	GWB 010
M12	110 mm	GWB 012
M16	110 mm	GWB 016
M18	125 mm	GWB 018
M20	140 mm	GWB 020
M22	115 mm	GWB 022
M24	120 mm	GWB 024
M27	130 mm	GWB 027
M30	135 mm	GWB 030
M33	135 mm	GWB 033
M36	155 mm	GWB 036
M42	175 mm	GWB 042

No additional adapters are
required when using twist drills,
taps, or countersinks with
Weldon shank tools.



OPTIMAL DRILLING AND LUBRICATION WITH BDS PRODUCTS

RECOMMENDED CUTTING SPEED

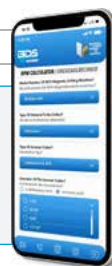
Annular Cutter Series	Material	m/min
HSS-Co 8	Fine-grain steel	
	< 700 N/m2	10 - 15
	< 1000 N/m2	10 - 15
	Stainless steel	10 - 15
HSS-VarioPLUS	Cast (depending on type)	15 - 20
	Fine-grain steel	
	< 700 N/m2	10 - 15
	< 1000 N/m2	10 - 15
HSS-Standard	Aluminium	20 - 30
	Steel	25
	Cast	10 - 20
Carbide	Steel/fine-grain steel	
	< 500 N/m2	35
	< 700 N/m2	25
	< 1000 N/m2	20
	Rostfrei, Inox	20
Carbide-PLUS	Steel/fine-grain steel	
	< 500 N/m2	35
	< 700 N/m2	25
	< 1000 N/m2	20
	Stainless, Inox	20
Carbide-RAIL	Railroad tracks	15 - 20

CUTTING SPEED TABLE BASED ON ANNULAR CUTTER DIAMETER AND MATERIAL TYPE

Diameter	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

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



RECOMMENDATION TABLE OF BDS ANNULAR CUTTER SERIES WITH SUITABLE BDS COOLING LUBRICANTS BY MATERIAL TYPE

	Cutting oil BDS 5000	Lubrication spray BDS 5200	Cutting paste BDS 5500	Cutting paste ZHS 571	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, INOX					
HSS-Co 8	✓	✓	✓	✓	
Carbide					✓
Carbide-PLUS					✓
CAST					
HSS-Co 8					✓
HSS-Standard					✓
RAILROAD TRACKS					
Carbide-RAIL					✓



BDS high-performance lubricants are precisely formulated for their specific applications. Their highly efficient compositions enable economical and environmentally friendly use.

For outdoor applications, we especially recommend BDS high-performance cutting oil or cooling lubricant concentrate. These products are biodegradable and toxicologically safe, while delivering excellent lubrication and cooling performance.

The BDS 6000 concentrate can be diluted with water at a ratio of 1:10, making it extremely economical. Made in Germany.



Videos & Dokumente

HIGH-PERFORMANCE CUTTING OIL BDS 5000



- ▶ Pure vegetable oil – biodegradable
- ▶ Classified as not dangerous goods under ADR regulations
- ▶ Raw materials are not listed as substances hazardous to water
- ▶ Not subject to labeling requirements
- ▶ Composed of biological raw materials with additional additives
- ▶ Water hazard classification: Level 1
- ▶ Optimized viscosity for use with BDS Annular Cutters
- ▶ Ensures problem-free performance in subsequent galvanizing processes

Order no.

ZHS 005	BDS 5000 Cutting oil, 5 liter Can
ZHS 006	BDS 5000 Cutting oil, 1 liter Can

COOLING LUBRICANT CONCENTRATE BDS 6000



- ▶ Ideal for carbide (TCT) annular cutters
- ▶ Formulated from high-quality synthetic raw materials to meet high-performance demands
- ▶ Miscible with water, biostable and mild in odor
- ▶ Enhances the service life of core drills
- ▶ Toxicologically harmless
- ▶ Water hazard classification: Class 1

Order no.

ZHB 001	BDS 6000 Cooling lubricant concentrate, 1 liter Can
---------	--

HIGH-PERFORMANCE LUBRICATION-SPRAY BDS 5200



- ▶ Designed for work in constrained positions (overhead and horizontal applications)
- ▶ Suitable for use on high-alloy materials
- ▶ Produces a foamy spray with very high adhesive strength
- ▶ Allows precise dosage of the lubricant
- ▶ Provides optimum lubrication directly on drill cutting edges
- ▶ No dripping or splashing during use
- ▶ Ensures maximum work safety on ladders and work platforms
- ▶ PTFE-containing, white adhesive lubricant with integrated corrosion protection

Order no.

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

BDSMASCHINEN
MADE IN GERMANY

HIGH-PERFORMANCE CUTTING PASTE BDS 5500

- ▶ Ideal for taps, HSS core drills and carbide core drills
- ▶ Ideally suited for difficult-to-machine materials
- ▶ Suitable for overhead use and working in constrained positions



Order no.

ZHS 550	BDS 5500 Cutting paste, 1000 g Can
---------	--

PREMIUM CUTTING PASTE BDS 7500

- ▶ High-performance anti-seize assembly paste in a practical brush-top container
- ▶ Base oil: Medical white oil
- ▶ Provides excellent heat resistance up to 1400°C
- ▶ Suitable for manual lubrication of high-alloy steel, Hardox, stainless steel, and heat-resistant steel
- ▶ Designed to meet the highest performance requirements

NEW



Order no.

ZHS 571	BDS 7500 Cutting paste, 120 g brush-top container
---------	--

TRANSPORT CASE FOR MAGNETIC DRILLING MACHINES

- ▶ **Portable:** Low weight combined with high structural stability
- ▶ **Secure Closure:** Large, robust mechanical locks ensure safe transport
- ▶ **Easy Mobility:** ABS castors and telescopic handle allow rolling instead of carrying

HARD-SHELL CASE



Order no.	Suitable for
ZHK 100	MAB 100K - MAB 155PRO
ZHK 350	AutoMAB 350, AutoMAB 450
ZHK 400	MAB 455, MAB 465, MAB 485, MAB 525 inkl. SB Series
ZHK 800	MABasic 850
Application:	Transport case for BDS Magnetic Drilling Machines.
Execution:	Robust hard-shell case with carrying handle and sturdy fasteners. With foam insert. Without contents.

CARRY CASE

Order no.	Suitable for
ZPK 200	MABasic 200, 400, 450



TRANSPORT CASE WITH WHEELS



Order no.	Suitable for
ZHK 825	MAB 825, MAB 845
Application:	Transport case with wheels for BDS Magnetic Drilling Machines.
Execution:	Robust transport case with wheels, carrying handle and sturdy latches. Without contents.

TRANSPORT CASE WITH WHEELS



Order no.	Suitable for
ZHK 1300	MAB 1300
ZHK 1500	MAB 825V/845V/ 1300V/MAB 825KTS
Application:	Transport case with wheels for BDS Magnetic Drilling Machines.
Execution:	Robust transport case with wheels, carrying handle and sturdy latches. Without contents.



EXPAND THE POSSIBILITIES OF YOUR DRILLING MACHINES: DRILL STANDS AND CLAMPING DEVICES

MOBILCLAMP FOR MAGNETIC DRILLING MACHINES

The MobilCLAMP mobile clamping device significantly expands the application range of a Magnetic Drilling Machine, both on assembly sites and in workshops. By placing the Magnetic Drilling Machine onto the MobilCLAMP's support surface and switching it on, the machine is instantly ready for flexible use. Components can be securely fixed in the integrated prismatic vice, allowing you to use the Magnetic Drilling Machine like a versatile bench drill in no time.

- Place magnetic drilling machine over MobilCLAMP
- Magnet adheres to the surface of the MobilCLAMP
- Installing the prismatic vice on the MobilCLAMP
- Clamping small parts on a prismatic vice
- Begin drilling!

Order no.

ZMC 200

ZST 300 Prism vice



Videos & documents



Example photo
with magnetic drill

INDUSTRIAL DRILL STAND FOR HAND DRILLS

Robust drill stand designed for use with commercially available hand drills featuring a 43 mm clamping neck diameter. The solid cast base plate and precision-guided slide ensure safe and stable operation, offering a working stroke of 180 mm. An optional drilling vice with a 100 mm jaw width is available for securely holding workpieces. Additionally, T-slot screws are offered for reliable clamping and fastening.



Videos & documents

Order no.

ZBS 100.2 Industrial drill stand

ZST 300 Prism vice

ZTN 110 Screws for T-slot nut M10

Jaw width: 100 mm, clamping range: 100 mm

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

MAGNETIC DRILL STAND FOR HAND DRILLS

This practical magnetic drill stand transforms your standard hand drill into a versatile magnetic drilling machine. Designed for commercially available hand drills with a 43 mm clamping neck diameter, it offers enhanced flexibility for various drilling tasks. The powerful magnet ensures secure positioning, making it suitable for horizontal and overhead drilling applications. For these operations, the use of an additional safety strap is mandatory. The precision carriage provides a working stroke of 180 mm for smooth and controlled drilling.



Videos & documents

Order no.

MBS 300.2

For commercially available hand drills with 43 mm clamping neck diameter, Stroke 180 mm

CLAMPING DEVICES FOR PIPES FROM 80 - 500 MM Ø



BDS pipe clamping devices are designed for standard use on pipes with diameters ranging from 80 to 500 mm. They enable flexible and rapid clamping in virtually any drilling situation. The clamping chains securely attach the device to the pipe, while pivoting prisms ensure a stable and precise fit.

Adjusting the drilling position on the pipe is both simple and safe, enhancing ease of use. These clamping devices significantly expand the application range of BDS Magnetic Drilling Machines, making them ideal for pipe drilling tasks in the workshop or on-site.



PIPE CLAMPING DEVICE ZRO 250



Videos & documents

Order no.

ZRO 250 For MAB 455, 485, 525,
for pipe Ø 80 - 250 mm, chain length: 900 mm



PIPE CLAMPING DEVICE ZRO 500



Videos & documents

Order no.

ZRO 500 For MAB 825, 845, MABasic 850,
for pipe Ø 150 - 500 mm, chain length: 1.650 mm



PIPE CLAMPING DEVICE ZRO 1300



Videos & documents

Order no.

ZRO 1300 For MAB 1300, for pipe Ø 150 - 500 mm,
chain length: 1.650 mm

VACUUM CLAMPING DEVICES FOR NON-FERROUS METALS

VACUUM CLAMPING DEVICE FOR NON-FERROUS METALS - ZAV 200

The cordless vacuum clamping plate from BDS Maschinen is an advanced solution for drilling non-ferrous and non-magnetic materials using magnetic drilling machines. Operation is remarkably simple: place the vacuum clamping plate on the workpiece, activate the integrated battery-powered vacuum pump, and apply brief pressure to the plate. Once the clamping plate is securely fixed, the magnetic drilling machine can be positioned, and drilling can begin. Thanks to the cordless vacuum pump, users benefit from maximum flexibility – without the hassle of cables, bulky external equipment, or reliance on stationary power sources. The ZAV 200 comes as a complete package, including the vacuum clamping plate, a powerful battery vacuum pump, a charging cable, and a manual vacuum pump – all at an attractive price-performance ratio.



BATTERY VACUUM PLATE

NEW

Ideal for use with a magnetic drilling machine on non-magnetic materials.



Videos & documents



Order no.

ZAV 200

Application: Suitable for checker plates, cross plates and smooth surfaces.

Execution: Mobile vacuum plate with battery-powered vacuum pump and manual vacuum pump. Clamping plate Ø 300 mm.
Scope of delivery: Vacuum plate, battery-powered vacuum pump, hand vacuum pump and USB charging cable.

VACUUM PLATE FOR SMOOTH CORRUGATED/CROSS PLATES



Videos & documents



Order no.

ZAV 300

Application: Suitable for checker plates, cross plates and smooth surfaces.

Execution: High-performance vacuum pump* with recirculating oil lubrication. Clamping plate Ø 300 mm.

*NOTE for ZAV 300PRO / ZAV 400PRO: The high-performance vacuum pump supplied differs from the illustration. The new high-performance vacuum pump has a new, smaller, next-generation design.

VACUUM PLATE FOR SMOOTH SURFACES



Videos & documents



Order no.

ZAV 400

Application: For smooth surfaces.

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

CLEAN WORK WITH INNOVATIVE TOOLS

PowerCLEANER

Equipped with a chip hook for efficient removal of drilling chips and a lockable cleaning brush to keep the work surface clean and clear.

Order no.

POW 200



Videos & documents



STARTERKIT PowerCLEANER

Start with the right basic equipment for every Magnetic Drilling Machine. In a package at a particularly advantageous price.

Order no.

ZST 200

Contents:

1 standard core drill box with
2 KBK - Ø 14 mm
2 KBK - Ø 18 mm
1 KBK - Ø 22 mm

1 l high-performance cutting oil BDS 5000
1 BDS PowerCLEANER POW200



Videos & documents



THE EFFICIENT SOLUTION FOR SAFE CHIP DISPOSAL

PowerWORKER

Magnetic rod that effortlessly cleans up all magnetic drilling chips – the indispensable helper for every workshop.

Order no.

POW 100



Videos & documents



STARTERKIT PowerWORKER

Save money with the BDS starter kits at a special price!

Order no.

ZST 100

Contents:

1 standard core drill box with
2 KBK – Ø 14 mm
2 KBK – Ø 18 mm
1 KBK – Ø 22 mm

1 l high-performance cutting oil BDS 5000
1 BDS PowerWORKER POW100



Videos & documents





For direct mounting 19 mm Weldon

ADAPTER FOR DRILL CHUCK



Order no.

ZAP 100 Weldon shank
19 mm (3/4")
to 1/2" x 20 NF

GEAR RIM DRILL CHUCK



Order no.

ZBI 113 Internal thread
1/2" x 20 NF
Clamping size
1 - 13 mm

ZBI 116 Internal thread
1/2" x 20 NF
Clamping size
2.5 - 16 mm

QUICK-ACTION DRILL CHUCK



Order no.

ZSI 113 Internal thread
1/2" x 20 NF
Clamping size
1 - 13 mm

ZSI 116 Internal thread
1/2" x 20 NF
Clamping size
3 - 16 mm

1. Connect the adapter to the drill chuck.



2. Insert the drill chuck into the direct mount.



3. Ready for use with Twist drills.



For Spindle taper MT 2 or MT 3

ADAPTER FOR DRILL CHUCK



Order no.

ZKD 216 DIN 238 -
MT 2/B16

ZKD 316 DIN 238 -
MT 3/B16

GEAR RIM DRILL CHUCK



Order no.

ZBK 113 DIN 238-B16
Clamping size
1 - 13 mm

ZBK 116 DIN 238-B16
Clamping size
2.5 - 16 mm

QUICK-ACTION DRILL CHUCK



Order no.

ZSB 113 DIN 238-B16
Clamping size
1 - 13 mm

ZSB 116 DIN 238-B16
Clamping size
3 - 16 mm

1. Connect the tapered mandrel to the drill chuck.



2. Insert the drill chuck into the MT holder.



3. Ready for use with twist drills.



DRILL DRIFT



Order no.

ZAS 002 Size MT 2
DIN 228

ZAS 003 Size MT 3
DIN 228

KEY FOR GEAR RIM DRILL CHUCK



Order no.

ZEZ 113

ZEZ 116

CHIP GUARD



Order no.

ZSS 050 Suitable for
machines
MAB 100 -
MAB 525

ZSS 500 Suitable for
machines
MAB 825 -
MAB 855

SAFETY LASHING STRAP



Order no.

40 0016 1

MORSE TAPER TOOL HOLDER FOR ANNULAR CUTTERS



Videos & Dokumente

KEYLESS QUICK-CHANGE DRILLING SYSTEM

Tool holder for BDS Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ")

Order no.	Spindle taper
ZSS 200	MT 2
ZSS 300	MT 3

With automatic internal lubrication for annular cutters featuring a 19 mm ($\frac{3}{4}$ ") Weldon shank. Includes hose and quick-release coupling for easy connection. Enables quick tool changes without the need for a clamping wrench.



EXTENSION SLEEVE DIN 2178

Order no.	Outside	Inside	Length
ZVH 220	MT 2	MT 2	91 mm
ZVH 230	MT 2	MT 3	116 mm
ZVH 320	MT 3	MT 2	96 mm
ZVH 330	MT 3	MT 3	116 mm

REDUCING SLEEVE DIN 2185

Order no.	Outside	Inside
ZRH 210	MT 2	MT 1
ZRH 320	MT 3	MT 2
ZRH 430	MT 4	MT 3

INDUSTRIAL HOLDER WITH AUTOMATIC INTERNAL LUBRICATION

Tool holder for BDS Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ") and 32 mm ($1\frac{1}{4}$ ")

Order no.	Spindle taper
For Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ")	
ZIA 219-KN	MT 2
ZIA 319-KN	MT 3
ZIA 419-KN	MT 4
For Annular Cutters with Weldon shank 32 mm ($1\frac{1}{4}$ "). With hose and quick-release coupling.	
ZIA 332-KN	MT 3
ZIA 432-KN	MT 4



INDUSTRIAL HOLDER WITH MANUAL INTERNAL LUBRICATION

Tool holder for BDS Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ") and 32 mm ($1\frac{1}{4}$ ")

Order no.	Spindle taper
For Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ")	
ZIA 219-M	MT 2
ZIA 319-M	MT 3
ZIA 419-M	MT 4
For Annular Cutters with Weldon shank 32 mm ($1\frac{1}{4}$ ")	
ZIA 332-M	MT 3
ZIA 432-M	MT 4



Videos & Dokumente

ADAPTER WITH WELDON SHANK

32 MM WELDON TO 19 MM WELDON

From 32 mm Weldon shank ($1\frac{1}{4}$ ") to 19 mm Weldon shank ($\frac{3}{4}$ ")

Order no.
ZAP 200



WELDON ADAPTER FOR QUICK-IN

For Fein Annular Cutters with QUICK-IN shank incl. 1 ejector pin ZAK 115

Order no.
ZAF 003



ADAPTER FOR NITTO ONE-TOUCH

With Nitto one-touch holder for Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ") incl. 1 ejector pin each ZAK 107 and 125

Order no.
ZAF 005



WELDON ADAPTER FOR KB WITH INTERNAL THREAD

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

Order no.
ZAF 002



EXTENSION

80 mm, 19 mm Weldon shank ($\frac{3}{4}$ "), incl. 1 ejector pin ZAK 080

Order no.
ZAP 300



ADAPTER FOR FEIN QUICK-IN

With quick-in holder for Annular Cutters with Weldon shank 19 mm ($\frac{3}{4}$ ") incl. 1 ejector pin each ZAK 107 and 125

Order no.
ZAF 004





QUICK-CHANGE CHUCKS AND INSERTS FOR THREADS FROM M6 TO M42

Magnetic Drilling Machines in the ProfiPLUS class are ideal for thread cutting. They require clockwise/anti-clockwise operation, full-shaft control electronics, and high motor power.

Quick-Change Chuck Sizes MT 2, MT 3, and MT 4

The large stroke range of BDS Magnetic Drilling Machines, combined with the quick-change chuck, allows for fast and cost-effective operation without the need to realign or re-center when switching tools. The quick-change chuck is universally compatible with quick-change inserts, both with and without a safety slip clutch, ensuring versatile and efficient tool changes.



Order no.

GSW 222 Quick-change chuck

GSW 331 Quick-change chuck

GSW 332 Quick-change chuck

GSW 333 Quick-change chuck

GSW 442 Quick-change chuck

GSW 443 Quick-change chuck

GSW 444 Quick-change chuck

GSE 103 - GSE 114 per piece

GSE 205 - GSE 222 per piece

GSE 314 - GSE 330 per piece

GSS 205 - GSS 222 per piece

GSS 312 - GSS 330 per piece

GSS 420 - GSS 442 per piece

GSW quick-change chuck:
In the versions
MT 2, MT 3, MT 4.
For mounting
quick-change inserts
GSE or GSS

GSW 222 Size 2 MT 2

GSW 331 Size 1 MT 3

GSW 332 Size 2 MT 3

GSW 333 Size 3 MT 3

GSW 442 Size 2 MT 4

GSW 443 Size 3 MT 4

GSW 444 Size 4 MT 4



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

GSS quick-change insert with safety slip clutch size 2, 3, 4



VERSION 1: QUICK-CHANGE INSERTS WITH SAFETY SLIP CLUTCH

Ideal for blind-hole and through-hole threads from M6 to M42.

BDS inserts with safety slip clutch enable precise cutting of through-hole and blind-hole threads. The safety slip clutch prevents the tap from hitting the bottom of the hole and breaking off.



VERSION 2: STANDARD QUICK-CHANGE INSERTS

Ideal for through-hole threads from M6 to M30

BDS inserts for taps are suitable for holding taps for through-hole threads.



TAP ADAPTER WITH WELDON SHANK - AN INEXPENSIVE WAY TO GET STARTED.

The tap is inserted directly into the 19 or 32 mm Weldon system using an adapter. Only suitable for through-hole threads!



Order no.	Thread	Shank Ø (mm)	Square
ZGA 010	M10 DIN 376	7	5.5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14.5
ZGA 024	M24 DIN 376	18	14.5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18
ZGA 033	M33 DIN 376	25	20
ZGA 036	M36 DIN 376	28	22
ZGA 042	M42 DIN 376	32	24



up to ZGA 020 with 19 mm Weldon shank (3/4")

from ZGA 022 with 32 mm Weldon shank (1 1/2")



Scan the QR code or use the web link for our automated configuration for thread cutting systems:

<https://www.bds-machines.com/find-tapping-accessories/>

WHICH MACHINE, WHICH THREAD?

Assignment of tapping adapter sizes to the respective magnetic drilling machine models for correct application.



GSW quick-change chuck



Quick-change inserts
Standard GSE



Quick-change inserts with safety
slip clutch GSS



MAB1300	MAB 825/845	MAB 525	MAB 485	Order no.	Quick-change chuck	Thread	Order no.	Ø x square	Order no.	Ø x square
			✓	GSW 222	Size 2 MT 2	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
			✓			M6			GSS 206	4.5 / 3.4
			✓			M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
			✓			M8			GSS 205	6 / 4.9
			✓			M10	GSE 210.1	10 / 8		
			✓			M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
			✓			M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
			✓			M14	GSE 214	11 / 9.0	GSS 214	11 / 9.0
			✓			M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0
	✓	✓		GSW 331	Size 1 MT 3	M4	GSE 104	4.5 / 3.4		
	✓	✓				M5 / M6	GSE 105	6 / 4.9		
	✓	✓				M8	GSE 108	8 / 6.2		
	✓	✓				M10	GSE 110	10 / 8.0		
	✓	✓				M12	GSE 112	9 / 7.0		
	✓	✓				M14	GSE 114	11 / 9.0		
	✓	✓		GSW 332	Size 2 MT 3	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
	✓	✓				M6			GSS 206	4.5 / 3.4
	✓	✓				M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
	✓	✓				M8			GSS 205	6 / 4.9
	✓	✓				M10	GSE 210.1	10 / 8		
	✓	✓				M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
	✓	✓				M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
	✓	✓				M14	GSE 214	11 / 9	GSS 214	11 / 9
	✓	✓				M16	GSE 216	12 / 9	GSS 216	12 / 9
	✓	✓				M18	GSE 218	14 / 11	GSS 218	14 / 11
	✓	✓				M20	GSE 220	16 / 12	GSS 220	16 / 12
	✓	✓				M22 / 24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
	✓	✓		GSW 333	Size 3 MT 3	M12			GSS 312	9 / 7.0
	✓	✓				M14	GSE 314	11 / 9	GSS 314	11 / 9
	✓	✓				M16	GSE 316	12 / 9	GSS 316	12 / 9
	✓	✓				M18	GSE 318	14 / 11	GSS 318	14 / 11
	✓	✓				M20	GSE 320	16 / 12	GSS 320	16 / 12
	✓	✓				M22 / M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
	✓	✓				M27	GSE 327	20 / 16	GSS 327	20 / 16
	✓	✓				M30	GSE 330	22 / 18	GSS 330	22 / 18
✓				GSW 442	Size 2 MT 4	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
✓						M6			GSS 206	4.5 / 3.4
✓						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
✓						M8			GSS 205	6 / 4.9
✓						M10	GSE 210.1	10 / 8.0		
✓						M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
✓						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
✓						M14	GSE 214	11 / 9	GSS 214	11 / 9
✓						M16	GSE 216	12 / 9	GSS 216	12 / 9
✓						M18	GSE 218	14 / 11	GSS 218	14 / 11
✓						M20	GSE 220	16 / 12	GSS 220	16 / 12
✓						M22 / M24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
✓				GSW 443	Size 3 MT4	M12			GSS 312	9 / 7.0
✓						M14	GSE 314	11 / 9	GSS 314	11 / 9
✓						M16	GSE 316	12 / 9	GSS 316	12 / 9
✓						M18	GSE 318	14 / 11	GSS 318	14 / 11
✓						M20	GSE 320	16 / 12	GSS 320	16 / 12
✓						M22 / 24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
✓						M27	GSE 327	20 / 16	GSS 327	20 / 16
✓						M30	GSE 330	22 / 18	GSS 330	22 / 18
✓				GSW 444	Size 4 MT4	M20			GSS 420	16 / 12
✓						M22 / 24			GSS 422	18 / 14.5
✓						M27			GSS 427	20 / 16
✓						M30			GSS 430	22 / 18
✓						M33			GSS 433	25 / 20
✓						M36			GSS 436	28 / 22
✓						M39 / 42			GSS 442	32 / 24

PREMIUM QUALITY BEVELLING MACHINES



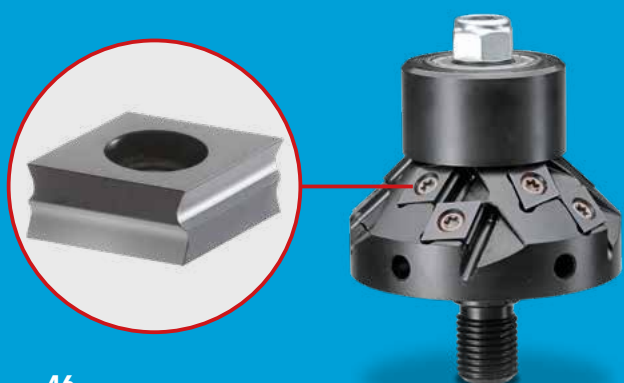
The BDS EKF series is a comprehensive, well-coordinated line of milling machines designed to meet the diverse needs of users across various industries. With the latest innovations and a carefully structured program, every user will find the right machine for their specific application.

The EKF range is available in two performance classes, each engineered to deliver precise and efficient results in minimal time. Whether you're machining steel, stainless steel, non-ferrous metals, brass, or plastic, EKF machines offer reliable performance and exceptional versatility.

All EKF machines are suitable for internal and external contour machining as well as drilling operations. The latest milling cutter technology from BDS ensures not only top-tier results but also user-friendly operation.

A new tangential plate arrangement on the milling heads minimizes impact and vibration, even at lower speeds. Combined with electronic speed control and full-shaft control electronics, the powerful motor allows for smooth processing of a wide range of materials.

Additionally, the new four-edge indexable inserts enhance cutting efficiency and durability—further improving performance and tool life.



EKF 452.3

Single speed



	Chamfer width up to	Radius 2.5 mm (0.098")
	Chamfer angle	-
	Insert (quantity)	SHM 202 (3x)
	Milling head	ZFR 452.3
	Motor output	1500 W (13.6 A)
	Voltage VAC	230; 110/125 V AC
	Speed	6000/min ⁻¹
	Variable speed control	
	Full wave control electronics	
	Weight, approx.	4.6 Kg. (10 lbs.)

Scope of delivery EKF 452

Carbide insert (quantity)	SHM 202 (3x)
Milling head	ZFR 452.3
Hook wrench DIN 1810B (34/36)	ZAC 001
Torx screwdriver	0.00002 (T09)
Spanner DIN 894 (22mm)	ZAC 002
Carry case	ZPK 001
Operating instructions	✓

Accessories EKF 452

Carbide insert standard (per piece)	SHM 202 r=2.5 mm SHM 201 r=1.5 mm SHM 200 Standard
Carbide insert with VarioPLUS coating, Carbide insert for stainless steel machining (per piece)	
Milling head	ZFR 452.3
Clamping screw for the insert (per piece)	7012021



HM Insert SHM 202
Milling head ZFR 452.3

COMPACT, UNIVERSAL, HANDY.

Designed for professional use, delivering consistent, high-quality results across industrial, workshop, and on-site assembly applications. Engineered for ease of guidance and simple, intuitive handling, they ensure efficient and reliable performance—even in demanding environments.

BDSMASCHINEN
MADE IN GERMANY



EKF 300.3 Single speed	EKF 450.3 Single speed	EKF 630 With electronic speed control	EKF 645 With electronic speed control
			
1.5 - 5 mm (1/4")	1.5 - 6 mm (1/4")	15 mm (9/16")	15 mm (9/16")
30°	45°	30°	45°
SHM 200 (3x)	SHM 200 (3x)	SHM 900 (10x)	SHM 900 (10x)
ZFR 300.3	ZFR 450.3	ZFR 630	ZFR 645
1500 W (13.6 A)	1500 W (13.6 A)	2300 W (20 A)	2300 W (20 A)
230; 110/125 V AC	230; 110/125 V AC	230; 110/125 V AC	230; 110/125 V AC
6000/min ⁻¹	6000/min ⁻¹	1600-3000/min ⁻¹	1600-3000/min ⁻¹
			electronic, stepless
4.6 Kg. (10 lbs.)	4.6 Kg. (10 lbs.)	10.2 Kg. (22.5 lbs.)	10.2 Kg. (22.5 lbs.)
Scope of delivery EKF 300	Scope of delivery EKF 450	Scope of delivery EKF 630	Scope of delivery EKF 645
SHM 200 (3x)	SHM 200 (3x)	SHM 900 (10x)	SHM 900 (10x)
ZFR 300.3	ZFR 450.3	ZFR 630	ZFR 645
ZAC 001	ZAC 001	8010411	8010421
0.00002 (T09)	0.00002 (T09)	ZTX 15	ZTX 15
ZAC 002	ZAC 002	ZAC 002	ZAC 002
ZPK 001	ZPK 001	ZHK 400	ZHK 400
✓	✓	✓	✓
Accessories EKF 300	Accessories EKF 450	Accessories EKF 630	Accessories EKF 645
SHM 200	SHM 200	SHM 900	SHM 900
SHM 200-E	SHM 200-E	SHM 900-E	SHM 900-E
ZFR 300.3	ZFR 450.3	ZFR 630	ZFR 645
7012021	7012021	7012131	7012131



ZFR 300.3 / ZFRS 450.3



HM Insert SHM 200-E



ZFR 630 / ZFR 645



HM Insert SHM 900

AirKF 700

PNEUMATIC EDGE BEVELING MACHINE



CHAMFERING FROM C2 TO C7

The cutter holder height can be adjusted from C2 to C7 by rotating the base plate.



CHAMFERING RANGE

Diameter	Depth	Thickness	Radius
C2 ≥ 32 mm	C2 ≥ 32 mm	C2 ≥ 8 mm	≥ R17
C3 ≥ 34 mm	C2 ≥ 32 mm	C2 ≥ 9 mm	
C4 ≥ 36 mm	C2 ≥ 32 mm	C2 ≥ 10 mm	
C5 ≥ 38 mm	C2 ≥ 32 mm	C2 ≥ 11 mm	
C6 ≥ 40 mm	C2 ≥ 32 mm	C2 ≥ 12 mm	
C7 ≥ 42 mm	C2 ≥ 32 mm	C2 ≥ 13 mm	

Air jets blow chips away from the workpiece, preventing them from adhering to the cutting inserts.

The airflow cools the carbide inserts directly, reducing temperature buildup by approximately 50% and significantly extending insert life. The continuous air stream also prevents chips from adhering to the workpiece.

AirKF 700



	Chamfer width	C2 - C7 (5/64"-9/32")
	Speed	10000/min ⁻¹
	Motor output	900 W (1.2 HP)
	Weight	3.95 kg (8.7 lbs)
	Air consumption	16 l/sec
	Air inlet size	1/4" BSP

Scope of delivery AirKF 700

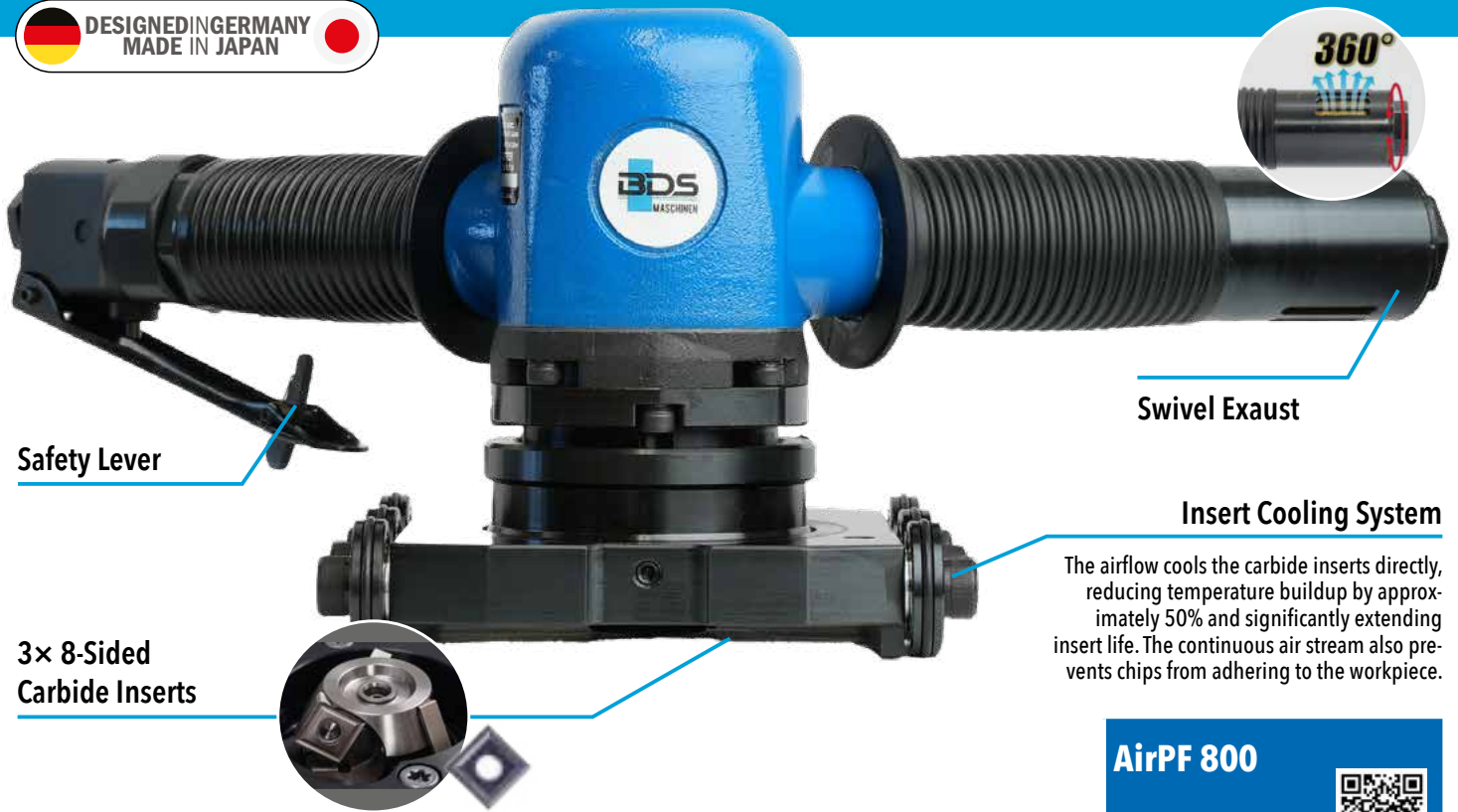
Carbide insert (quantity)	SHM 70 (3x)
Milling head	ZFR 700
Adjustment Tools	✓
Allen Key	3 mm
T-Wrench	4 mm
Guide Roller	✓
Operating instructions	✓

Zubehör AirKF 700

Carbide insert	SHM 70
Milling head	ZFR 700
Clamping screw for the insert (per piece)	7012700

AirPF 800

PNEUMATIC WELD SEAM MILLING MACHINE



ADVANTAGES

- ▶ Three carbide cutting heads rotate at high speed to efficiently remove weld seams.
- ▶ Produces a smooth, uniform surface with simple operation.
- ▶ Significantly less effort and vibration compared to grinding with an angle grinder.
- ▶ Virtually dust-free operation – generates chips instead of hazardous grinding dust.
- ▶ Fast, clean, and efficient weld seam removal.



AirPF 800



	Bead width	10 mm (3/8")
	Bead height	6 mm (1/4")
	Speed	10000/min ⁻¹
	Weight	4.5 kg (9.9 lbs)
	Air consumption	14,6 l/sec
	Air inlet size	1/4" BSP

Scope of delivery AirPF 800

Carbide insert (quantity)	SHM 80 (3x)
Milling head	ZFR 800
Adjustment Tools	✓
Allen Key	3 mm
T-Wrench	4 mm
Guide Roller	✓
Operating instructions	✓

Zubehör AirPF 800

Carbide insert	SHM 80
Milling head	ZFR 800
Clamping screw for the insert (per piece)	7012700

SHOW A CLEAR EDGE.

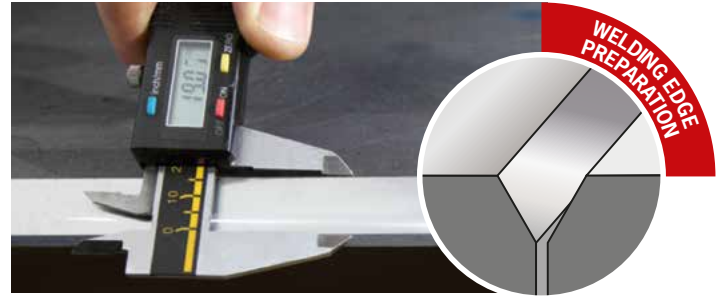
WITH BEVELLING MACHINES FROM BDS.

Deburring. Weld Preparation. Weld Seam Chamfering. Edge Rounding. BDS beveling machines deliver precision without compromise. Designed for a wide range of applications, they mill edges with

consistently high quality, ensuring clean, accurate results for professional metalworking tasks. Whether you're preparing weld seams or rounding sharp edges, trust BDS for advanced technology, reliable performance, and exceptional finish – every time.



- ▶ Clean, consistent milling edge
- ▶ Easy handling
- ▶ Precise adjustment of the chamfer width



- ▶ Uniform opening angle
- ▶ Easy handling with low material thickness
- ▶ Weld seam preparation on almost all contours



- ▶ To protect against injuries
- ▶ Visual enhancement of components



- ▶ Indispensable in the field of corrosion protection
- ▶ No cracking of the paint layer after drying
- ▶ Better adhesion of paint and powder
- ▶ Rounded edges are essential for components with frequent hand contact



Simple solution, great benefits:
The guide plate is firmly fixed to the edge of the workpiece and ensures a smooth motion when beveling.

EKF GUIDE PLATE

The guide plate ensures safe and precise positioning of EKF milling machines. It reliably prevents tilting and slipping, providing greater stability and control during operation. An essential accessory for improved safety and accuracy – a must-have for every professional user.

Order no.

ZFP 100



Videos & Dokumente

WELDING EDGES PERFECTLY PREPARED.

SKF 25

The BDS Beveling Machine is purpose-built for continuous industrial use, delivering powerful, robust, and highly precise performance. It ensures clean and accurate preparation of welding edges on sheet metal and workpieces of various sizes and materials.

Whether in series production, maintenance operations, or mobile use on construction sites, this machine guarantees outstanding reliability and results.

- ▶ Chamfer width up to 15 mm
- ▶ Stepless angle adjustment from 15° - 60°
- ▶ With ergonomic handle arrangement
- ▶ Easy to guide roller guide
- ▶ Processing of mild steel, aluminum, non-ferrous metal



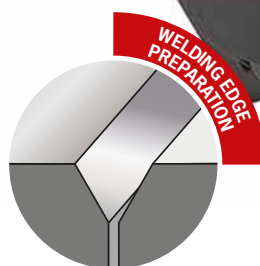
Continuous angle adjustment from 15° to 60°.



Edge processing of pipes in vertical position.



With ergonomic handle arrangement. Easy to guide rollers.



	Chamfer width up to	15 mm (3/4")
	Chamfer angle	15° - 60° stepless
	Insert (quantity)	SHM 800 (10x)
	Milling head	ZFR 250
	Motor output	1100 W (10 A)
	Voltage VAC	230; 110/125 V AC
	Speed	2850/min ⁻¹
	Weight, approx.	22 Kg. (48.5 Lbs.)

SKF 25

Weld edge milling machine



Scope of delivery SKF 25

Carbide insert (quantity)	SHM 800 (10x)
Milling head	ZFR 250
Allen key	4 mm, 6 mm und 8 mm
Spanner	12 mm
Torx screwdriver (TX 15)	ZTX 15
Carry case	PP container
Operating instructions	✓

Accessories SKF 25

Carbide insert standard (per piece)	SHM 800
Milling head	ZFR 250
Clamping screw for the insert (per piece)	7012141



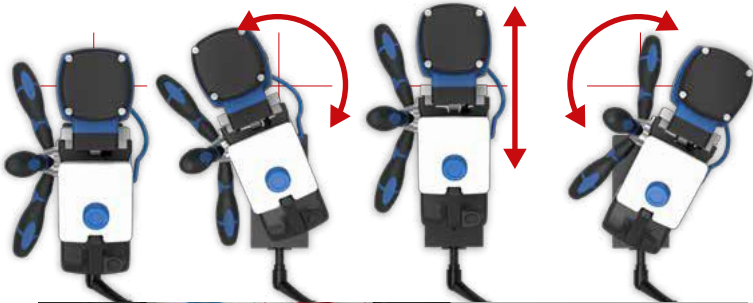
Accessorie:
Milling head ZFR 250



Accessorie: HM-Insert

SWIVEL BASE: FOR FAST, SAFE, PRECISE DRILLING.

Anyone who has used the BDS Swivel-Base will never want to drill without it again. It enables precise, pinpoint centering under magnetic hold – without lifting the machine’s full weight.



The BDS Swivel-Base allows effortless and precise movement of the drill even with the magnet engaged. Swivel the machine 20° left or right and move it 15 mm forward or backward for exact centering. This enhances comfort and safety, particularly during horizontal or overhead drilling. For optimal results, use our BDS 5200 cutting spray and BDS 7500 cutting paste.



1. Roughly position the machine.
2. Switch on the magnet.
3. Unlock the adjustment device using the lever, then precisely adjust the machine with ease.
4. Lock the adjustment device again using the hand lever.

STRONG HOLD WITH PipeMAB! FOR PIPES, TUBES, CURVED SURFACES & PLATES.



HIGH MAGNETIC HOLDING FORCE UP TO MAX. 1020 kg

Magnetic drilling machine with patented permanent magnets, specially designed for secure clamping on pipes, tubes, curved surfaces, and flat plates. The patented magnets are activated with a quick turn of the clamping lever, ensuring rapid and easy setup. The extended support surfaces provide optimal hold and maximum safety. As the magnets rotate, the drilling unit is automatically guided into the central drilling position.

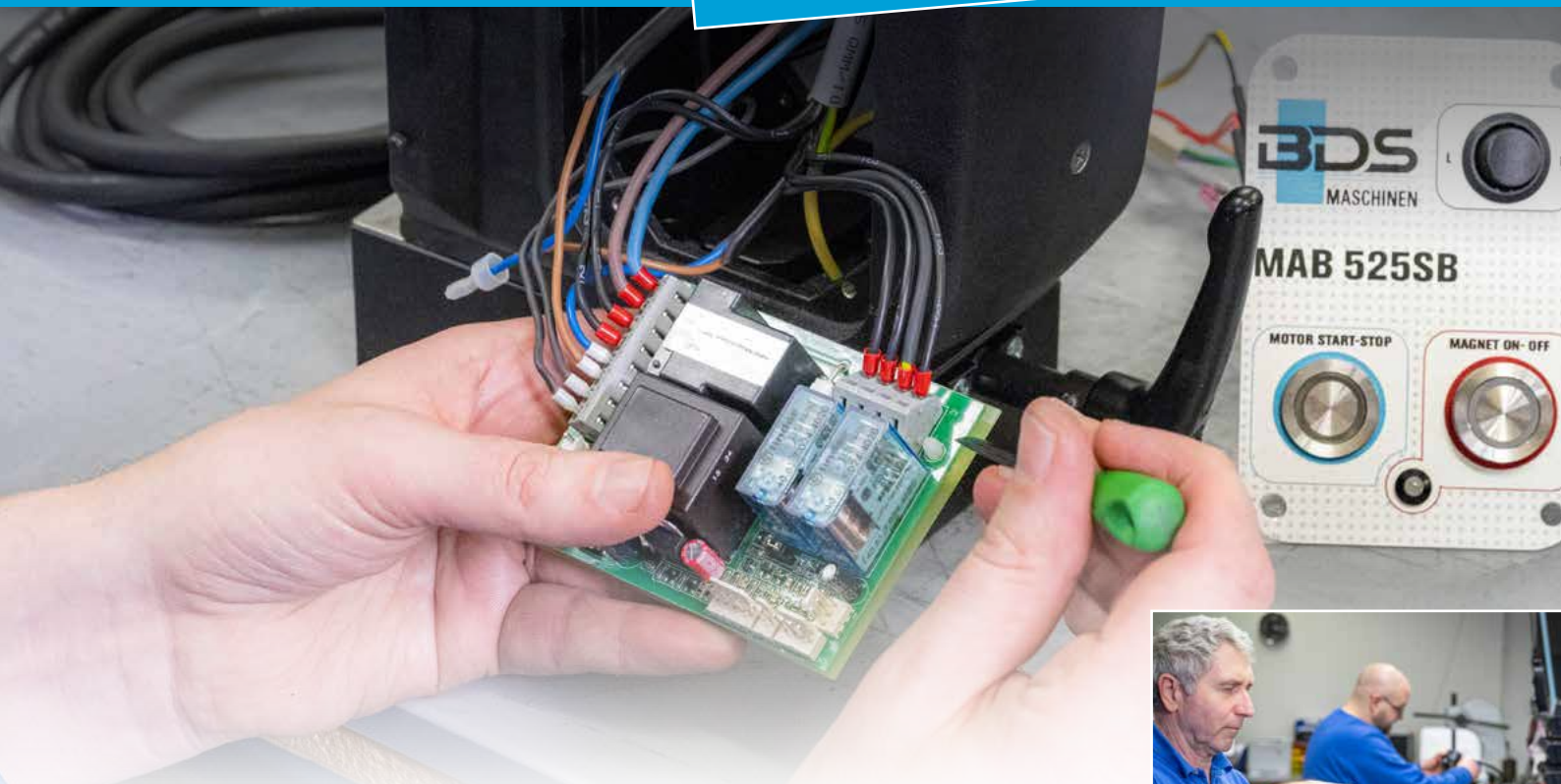
Material thickness and magnetic holding force			
Material thickness	3 mm	10 mm	20 mm
Maximum magnetic holding force	410 kg	890 kg	1020 kg



REPAIRS YOU CAN RELY ON.

Please note our new address for deliveries and collections:

Hehner Strasse 76 A,
41069 Mönchengladbach



REPAIR SERVICE FROM BDS

BDS machines stand for the highest quality and durability. But even the best machines are exposed to stresses and strains in tough everyday working conditions. Whether due to natural wear and tear, improper handling or external influences – should a defect occur, the BDS repair service is the best choice. Our experienced technicians know the machines inside and out and use only original spare parts. This ensures your machine remains efficient and reliable – for long service life and maximum safety.



TECHNICAL SUPPORT

We stand by the quality of our machines and are committed to providing reliable after-sales support. Our technical service team is available to assist you with troubleshooting, maintenance, and repairs for any machine purchased from us.



+49-2161-35460

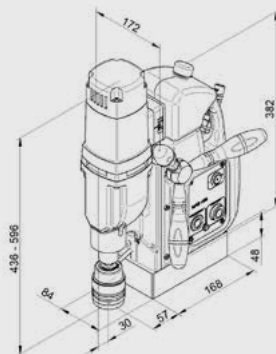


support@bds-machines.com

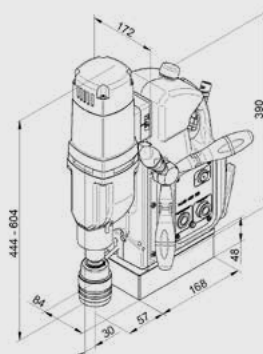
TECHNICAL DRAWINGS

The dimensions of the Magnetic Drilling Machines.

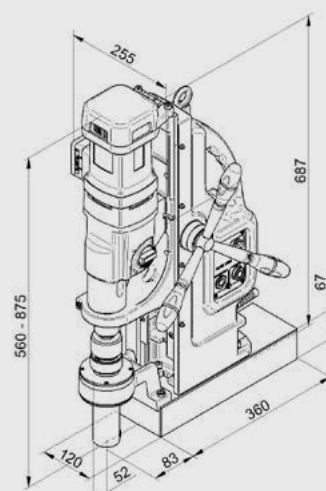
MAB 485



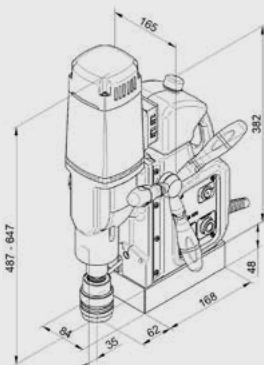
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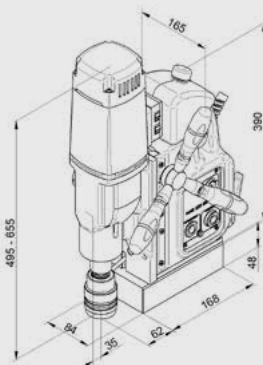
MAB 1300



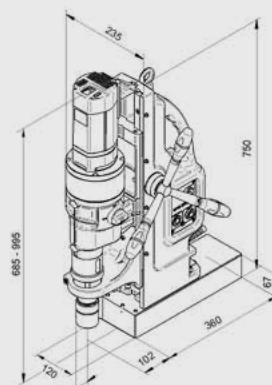
MAB 525



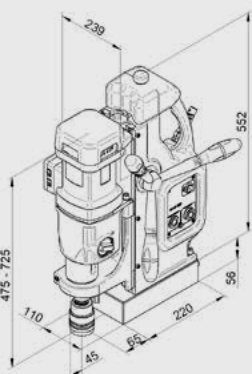
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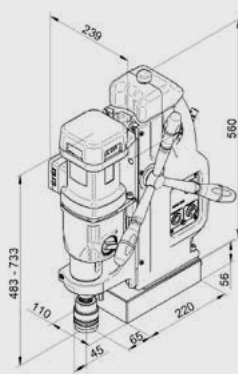
MAB 2300



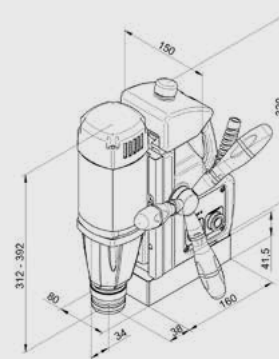
MAB 825



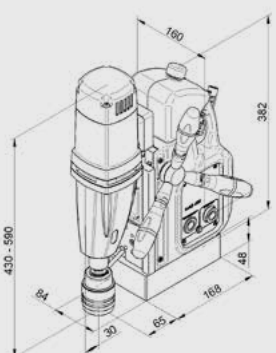
MAB 845SB



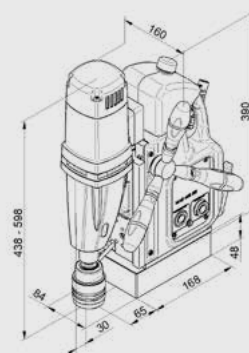
MAB 100K



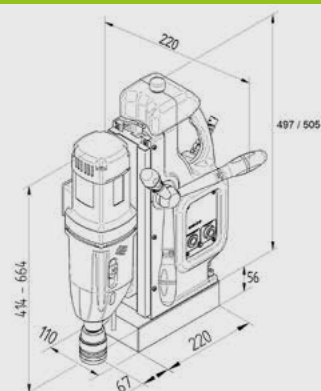
MAB 455



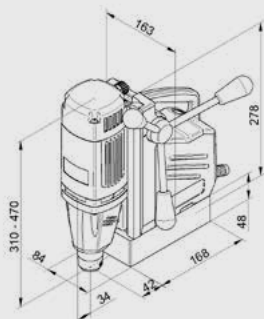
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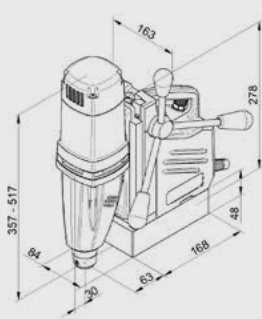
MAB 815 / 815SB



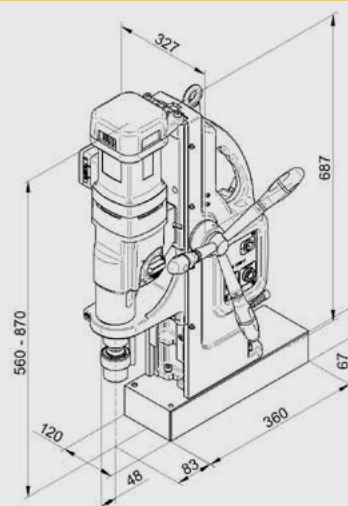
MABasic 200



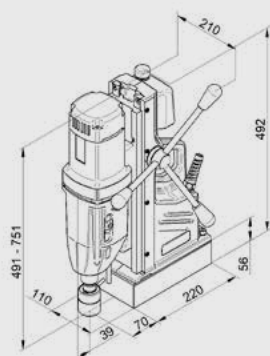
MABasic 400



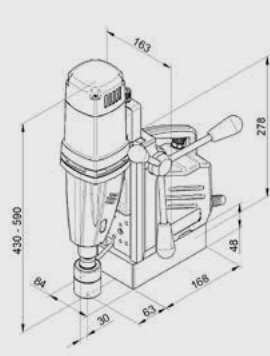
MAB 1300 V



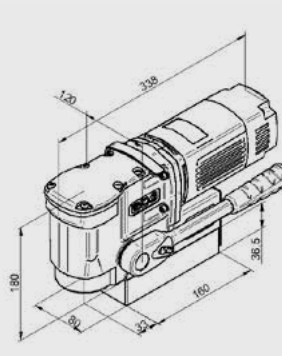
MABasic 850



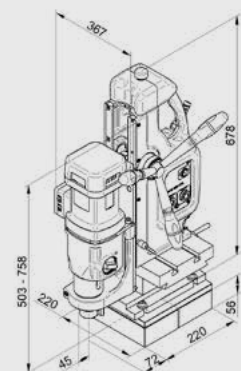
MABasic 450



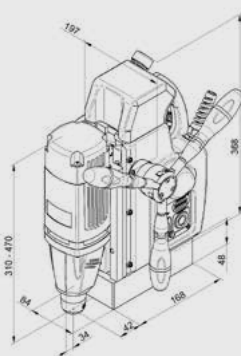
MAB 155PRO



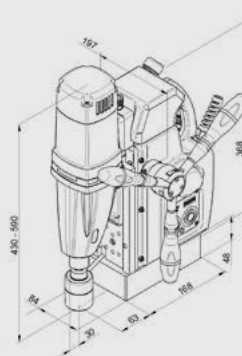
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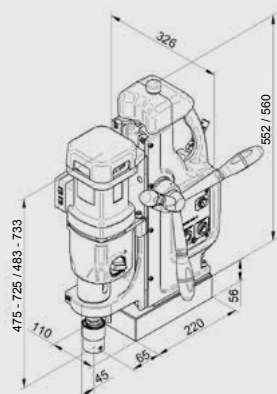
AutoMAB 350



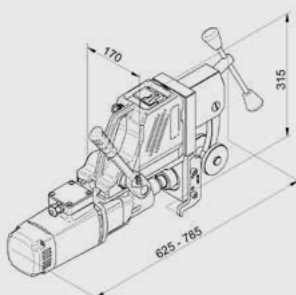
AutoMAB 450



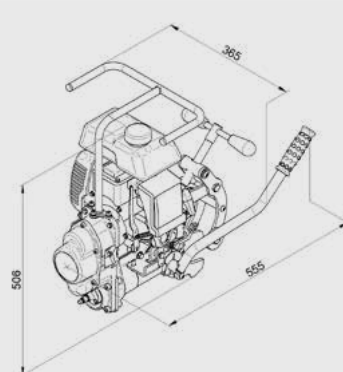
MAB 825 V / 845 V



RailMAB 915

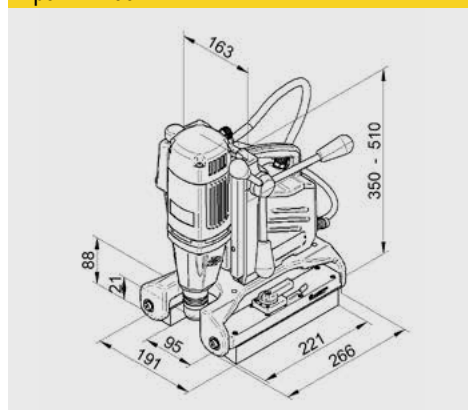


RailMAB 965

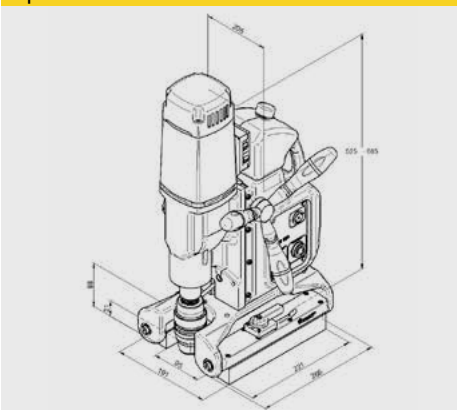


The dimensions of the Magnetic Drilling Machines.

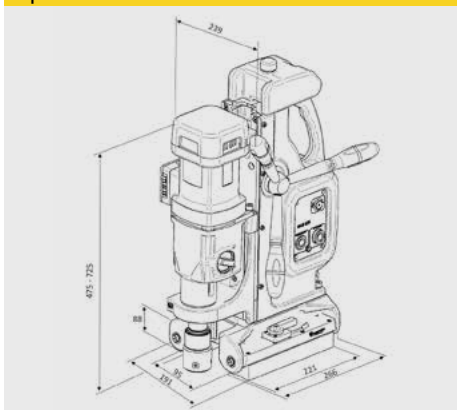
PipeMAB 200



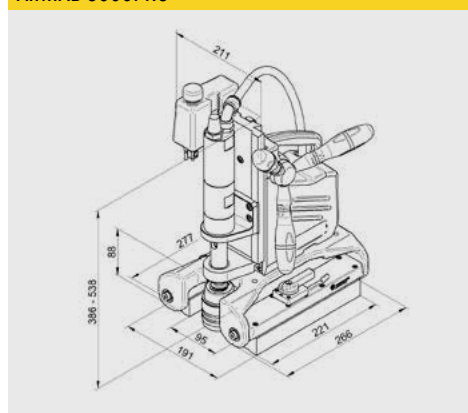
PipeMAB 525



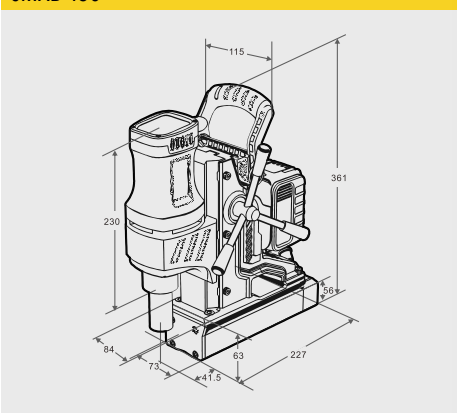
PipeMAB 825



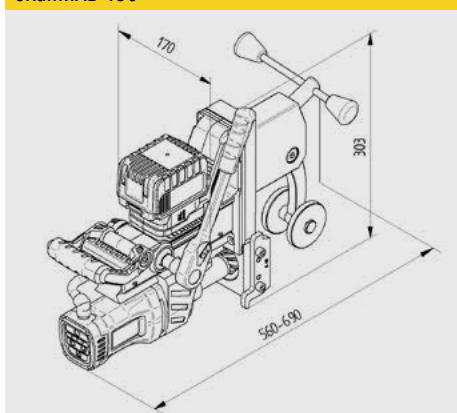
AirMAB 5000PRO



eMAB 450

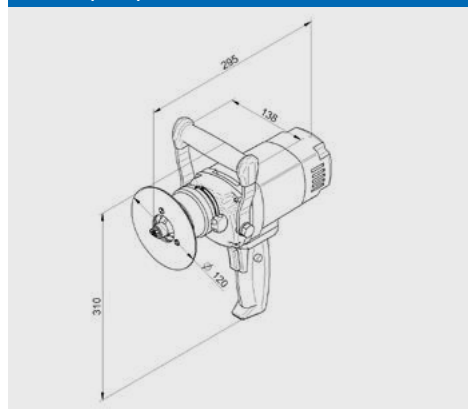


eRailMAB 450

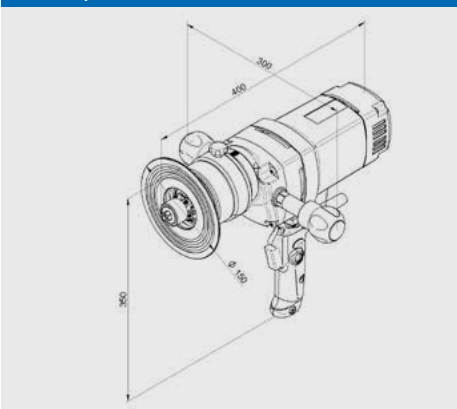


The dimensions of the edge processing machines.

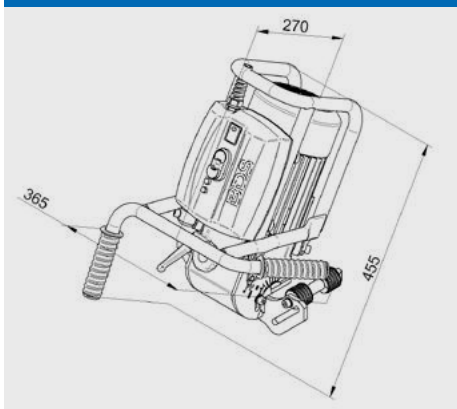
EKF 300, 450, 452



EKF 630, 645



SKF 025



AirKF 700



AirPF 800



DIGITAL DOCUMENTATION AVAILABLE ANYTIME

We provide all important documents in digital format on our website, including technical drawings, operating instructions, current spare parts lists, and technical data sheets.

This ensures you have access to all relevant information quickly, conveniently, and paper-free, anytime and anywhere.

<https://www.bds-machines.com/download>



INVESTMENT IN THE FUTURE: OUR NEW HIGH-TECH PRODUCTION HALL.

Our new, state-of-the-art production hall combines the latest technology with proven expertise. Equipped with state-of-the-art machinery and automated processes, it guarantees efficient and precise production of our "Made in Germany" products. Our experienced skilled workers are at the heart of produc-

tion and ensure the highest quality through their expertise and care. With this investment, we are focusing on sustainability, innovation and precision – for products that our customers around the world can rely on. "Made in Germany" thus becomes a promise and a reality.

Assembly line for magnetic drilling machines



Assembly line for bevelling machines



Packaging of machines



Modern warehouse with high capacity



Fast delivery products - ready for immediate shipment



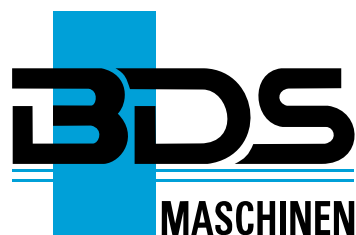
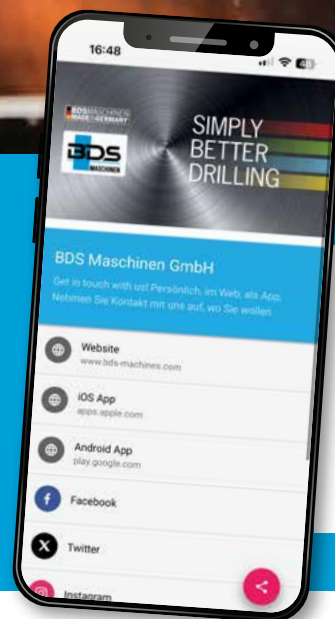
Worldwide shipping of products "Made in Germany"





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BDS Maschinen GmbH
Martinstrasse 108
D-41063 Mönchengladbach
Germany
Phone +49(0)2161 3546-18
www.bds-machines.com
export@bds-maschinen.de

