





Original BDS core drill from own production

Product quality is not a coincidence

BDS produces core drills at their facility in Mönchengladbach, with all the benefits for users worldwide:

- ▶ High manufacturing precision and competence
- ▶ Use of steels from well-known manufacturers
- ▶ Short-term availability and fast delivery

BDS magnetic core drilling machines and core drilling tools must be considered as a functional unit. Thus, the development of in-house core drill production was expedited right from the beginning in parallel to the production of the machines. This is why the core drills of BDS today are on top worldwide.

The correct tool for any application

The particularly comprehensive range of BDS core drilling tools is justified by the diversity of the applications and materials handled.

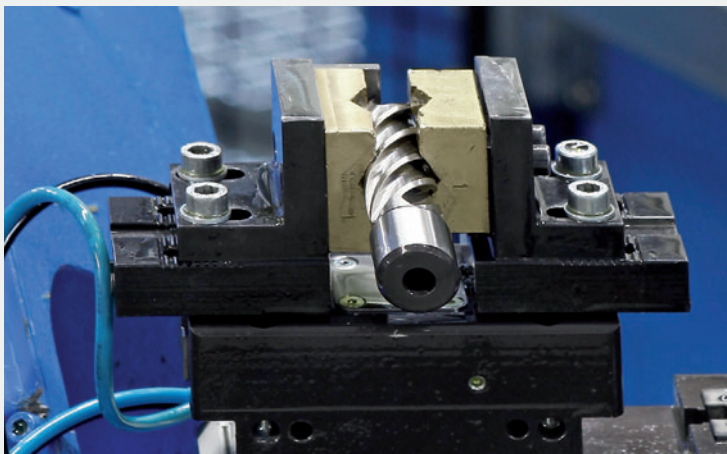
Starting with the HSS core drills of the standard range, the most comprehensive range of tools with short, long and extra-long core drills, there are those with hard coatings, the large group of carbide drills and, as the most recent development, HSS-Co 8 core drills with 8% of cobalt content.

Significant features of the BDS core drill tools are machining of full cuts and the high precision in geometry and concentricity associated with it, as well as optimised removal of shavings, high level of stability using qualitatively high-class types of steel. The VarioPLUS core drills with hard coatings ensure a high degree of wear resistance and long service life as a result of the good surface quality and hardness.

Know-how and technology – the recipe for quality

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

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



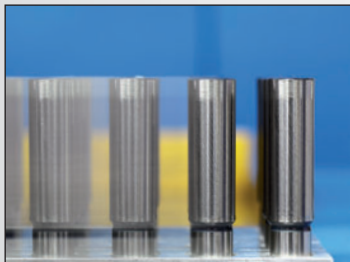
The BDS Core Drill Series

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



HSS-VarioPLUS series

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



HSS-Co 8 series

The objective of this most recent product development at BDS was to produce a range of core drills optimised for power with greater heat resistance and better protection against wear. The desired results were achieved by an enhanced proportion of cobalt in special steel. Combined with speed-controlled BDS magnetic core drilling machines, these core drills are adapted for high loads in fine-grained steels and rust-proof materials. The core drills can be reground whilst retaining their positive product characteristics.



HSS-Standard series

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

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

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



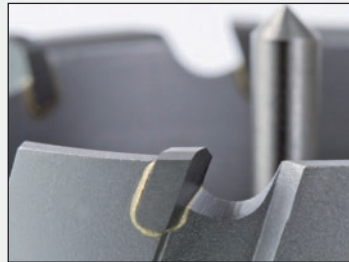
Classification of BDS drill series and appropriate BDS cooling lubricants with materials.

Cutting oil BDS 5000
 Lubrication spray BDS 5200
 Cutting paste BDS 5500
 Cooling lubricant concentrate BDS 6000

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

Recommended cutting speed

Core drill series	Material	m/min
HSS-Co 8	Fine-grain steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
	Inox	10 – 15
	Casting (depending on type)	15 – 20
HSS-VarioPLUS	Fine-grain steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
HSS-Standard	Aluminium	20 – 30
	Steel	25
	Casting	10 – 20
Carbide	Steel/Fine-grain steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1000 N/m ²	20
	Stainless, Inox	20
Carbide PLUS	Steel/Fine-grain steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1000 N/m ²	20
	Stainless, Inox	20
Carbide RAIL	Railway rails	15 – 20



Carbide series

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

BDS provides for the rising demand by expanding its range. Carbide core drills are manufactured as standard with cutting depths of 30 mm, 55 mm, 75 mm and 110 mm, with diameters of 14 mm to 150 mm.



Carbide PLUS series

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

Cutting speed:

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

Speed:

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

The Range of BDS Core Drills

All series, cutting depths and drill diameters available.

BDS core drills – professional quality for professional applications

BDS core drills are manufactured on up-to-date CNC-controlled grinding centres. This is the guarantee for consistent grinding, quality and cutting performance of all BDS drilling tools in the entire product spectrum.

Key applications

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

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

Extensive programme range

BDS core drilling tools are produced in five cutting depths of 35, 35, 55, 75 and 110 mm and with more than 94 different drill diameters from 12 mm to 150 mm.

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

TOOL HOLDERS

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



Tool holders:

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

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



Carbide Series			
HKK	HKL	HKX-L	HKE-L
30 mm	55 mm	75 mm	110 mm
14 – 150 mm	14 – 100 mm	18 – 120 mm	20 – 120 mm



Carbide PLUS Series
HKK-P
30 mm
14 – 60 mm

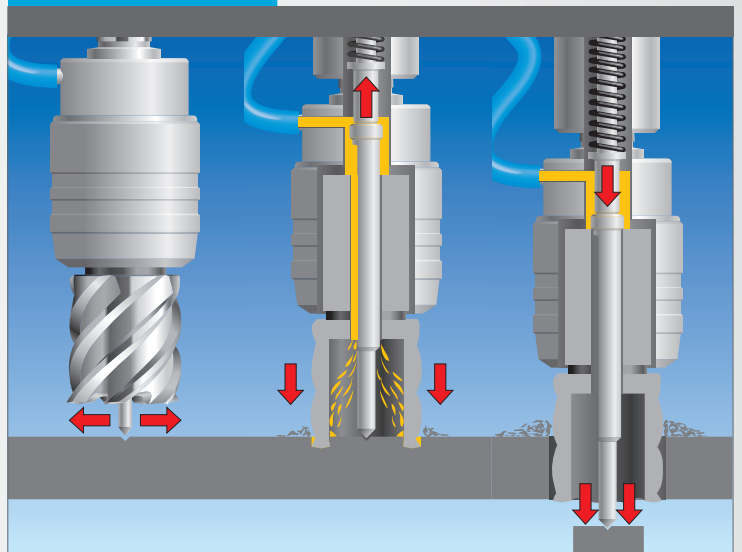


Carbide RAIL series
HKK-R
30 mm
17 – 36 mm



Quick-In series	
KBK-CO 8 F	HKK-F
35 mm	35 mm
12 – 60 mm	12 – 60 mm

EJECTOR PIN



Function of the ejector pin

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



Core Drill Series HSS-Co 8

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

CORE DRILLS

PAGE

HSS-Co 8 Core drills short

51

HSS-Co 8 Core drills long

51

HSS-Co 8

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

HSS-Co 8 Core drills short

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



HSS-CO 8 SERIES

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

HSS-Co 8 Core drills long

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



HSS-CO 8 SERIES

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

EJECTOR PIN FOR KBK-CO, Ø 12 - 60 mm

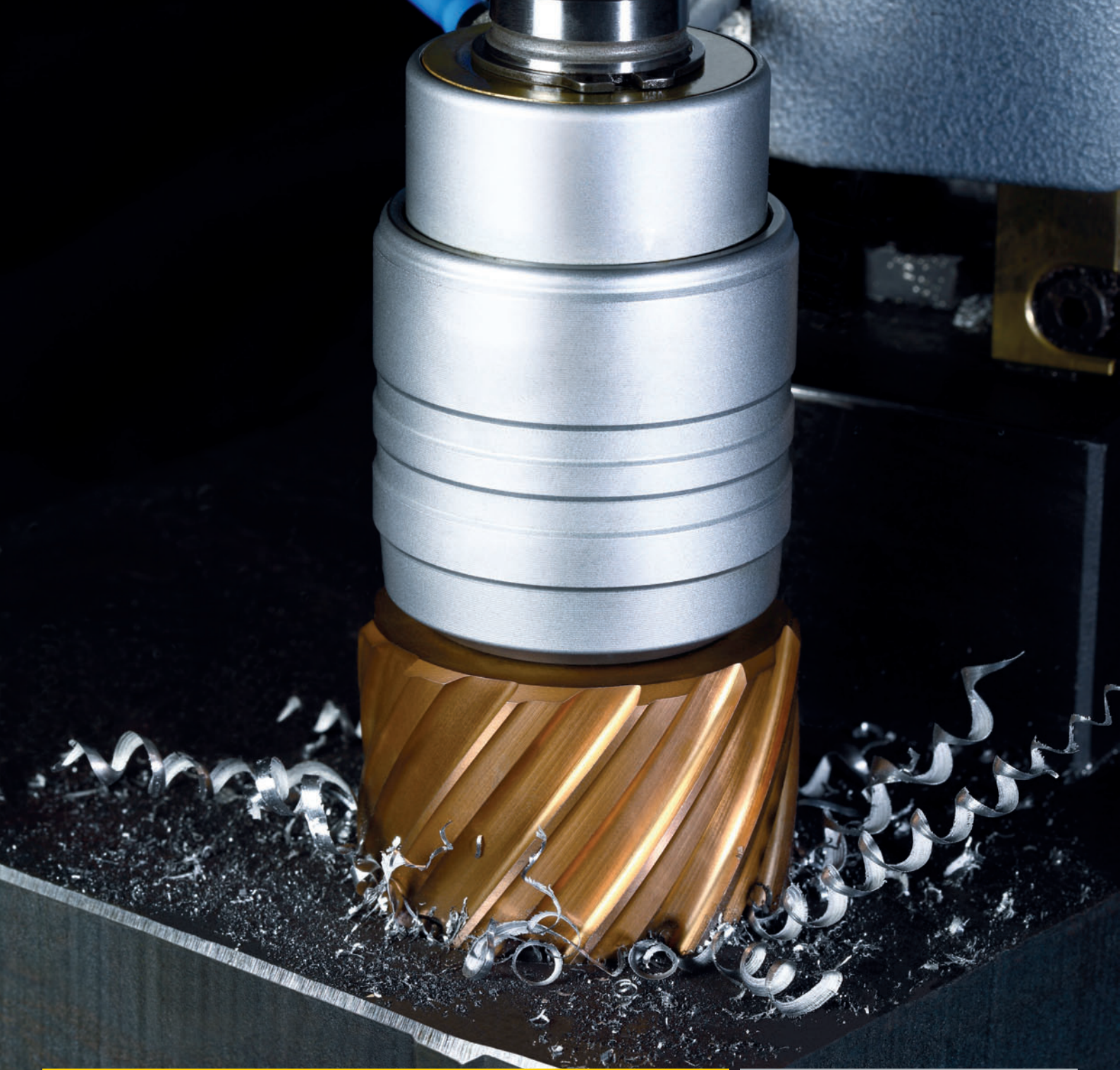
ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-CO, Ø 12 - 60 mm

ORDER NO.

ZAK 100



Core Drill Series HSS-VarioPLUS

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

CORE DRILLS

PAGE

HSS-VarioPLUS Core drills short

53

HSS-VarioPLUS Core drills long

53

HSS-VarioPLUS

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

HSS-VarioPLUS Core drills short

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



HSS-VarioPLUS SERIE

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

HSS-VarioPLUS Core drills long

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



HSS-VarioPLUS SERIE

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

EJECTOR PIN FOR KBK-VP, Ø 12 - 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-VP, Ø 12 - 60 mm

ORDER NO.

ZAK 100



Core Drill Series HSS-Standard

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

CORE DRILLS

PAGE

HSS-Standard Core drills short	55
HSS-Standard Core drills long	56
HSS-Standard Core drills extra long	57
HSS-Standard Core drills short, inch	57

HSS-Standard

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills short

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



HSS-STANDARD SERIES

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

HSS-Standard Core drills short

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



HSS-STANDARD SERIES

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

EJECTOR PIN FOR KBK, Ø 12 - 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBK, Ø 61 - 130 mm

ORDER NO.

ZAK 090

HSS-Standard

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills long

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



HSS-STANDARD SERIES

Ø mm	ORDER NO.
12	KBL 012
13	KBL 013
14	KBL 014
15	KBL 015
16	KBL 016
17	KBL 017
17.5	KBL 175
18	KBL 018
19	KBL 019
19.5	KBL 195
20	KBL 020
21	KBL 021
22	KBL 022
23	KBL 023
24	KBL 024
25	KBL 025
26	KBL 026
27	KBL 027
28	KBL 028
29	KBL 029
30	KBL 030
31	KBL 031
32	KBL 032
33	KBL 033
34	KBL 034
35	KBL 035

Ø mm	ORDER NO.
36	KBL 036
37	KBL 037
38	KBL 038
39	KBL 039
40	KBL 040
41	KBL 041
42	KBL 042
43	KBL 043
44	KBL 044
45	KBL 045
46	KBL 046
47	KBL 047
48	KBL 048
49	KBL 049
50	KBL 050
51	KBL 051
52	KBL 052
53	KBL 053
54	KBL 054
55	KBL 055
56	KBL 056
57	KBL 057
58	KBL 058
59	KBL 059
60	KBL 060

Standard Core drills long

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



HSS-STANDARD SERIES

Ø mm	ORDER NO.
61	KBL 061
62	KBL 062
63	KBL 063
64	KBL 064
65	KBL 065
66	KBL 066
67	KBL 067
68	KBL 068
69	KBL 069
70	KBL 070
71	KBL 071
72	KBL 072
73	KBL 073
74	KBL 074
75	KBL 075
76	KBL 076
77	KBL 077
78	KBL 078
79	KBL 079
80	KBL 080

Ø mm	ORDER NO.
81	KBL 081
82	KBL 082
83	KBL 083
84	KBL 084
85	KBL 085
86	KBL 086
87	KBL 087
88	KBL 088
89	KBL 089
90	KBL 090
91	KBL 091
92	KBL 092
93	KBL 093
94	KBL 094
95	KBL 095
96	KBL 096
97	KBL 097
98	KBL 098
99	KBL 099
100	KBL 100

EJECTOR PIN FOR KBL, Ø 12 - 60 mm

ORDER NO.

ZAK 100

EJECTOR PIN FOR KBL, Ø 61 - 100 mm

ORDER NO.

ZAK 120

HSS-Standard, inch

Fully ground core drills made of high-speed steel.

HSS-Standard Core drills extra long

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



HSS-Standard Core drills short, inch

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



HSS-STANDARD SERIES

Ø mm	ORDER NO.	Ø mm	ORDER NO.
20	KEL 020	36	KEL 036
21	KEL 021	37	KEL 037
22	KEL 022	38	KEL 038
23	KEL 023	39	KEL 039
24	KEL 024	40	KEL 040
25	KEL 025	41	KEL 041
26	KEL 026	42	KEL 042
27	KEL 027	43	KEL 043
28	KEL 028	44	KEL 044
29	KEL 029	45	KEL 045
30	KEL 030	46	KEL 046
31	KEL 031	47	KEL 047
32	KEL 032	48	KEL 048
33	KEL 033	49	KEL 049
34	KEL 034	50	KEL 050
35	KEL 035		

HSS-STANDARD SERIES INCH

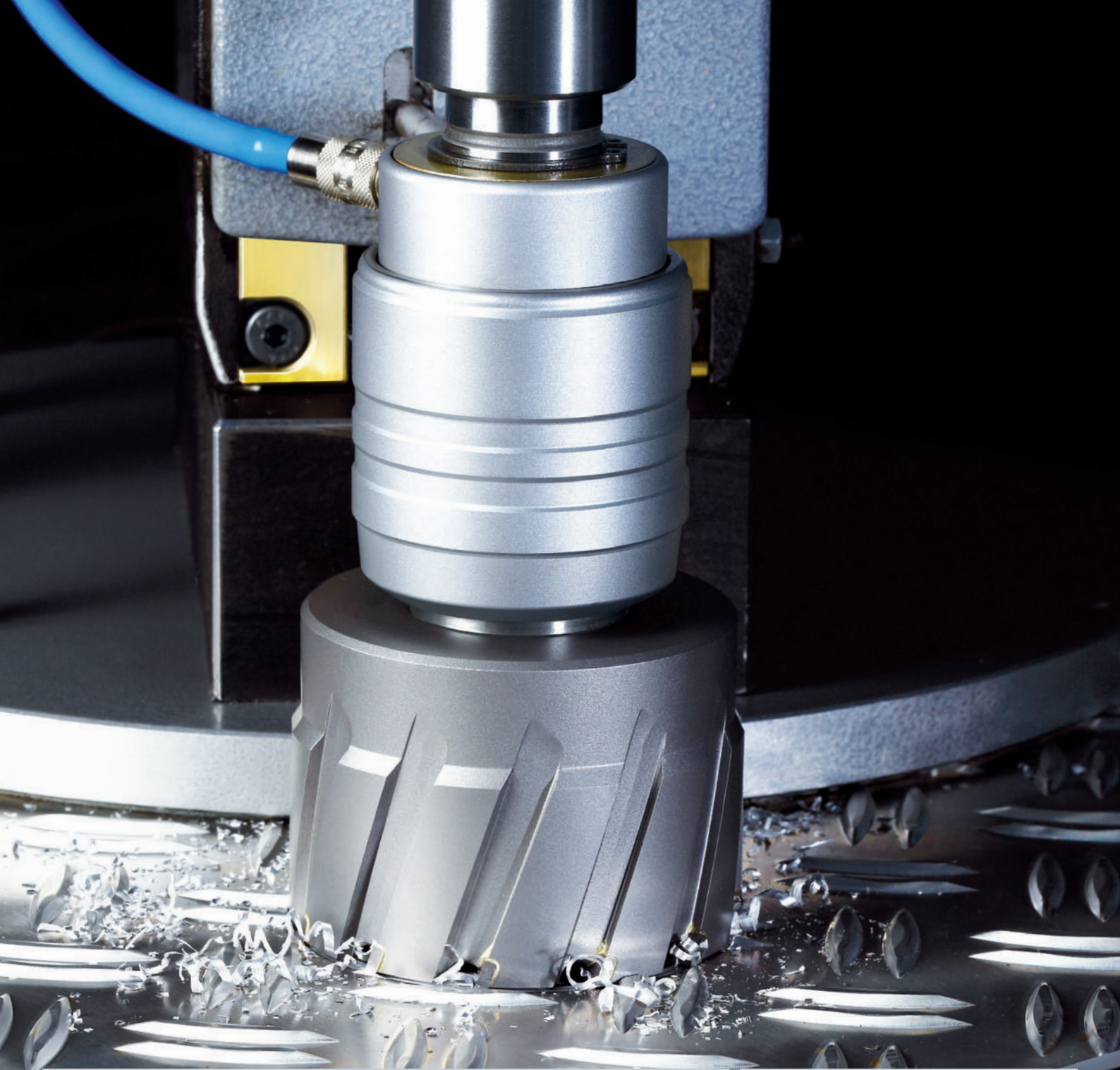
Ø inch	Ø mm	ORDER NO.
$\frac{1}{2}$ "	12.700	KBK-Z $\frac{1}{2}$
$\frac{9}{16}$ "	14.288	KBK-Z $\frac{9}{16}$
$\frac{5}{8}$ "	15.875	KBK-Z $\frac{5}{8}$
$\frac{11}{16}$ "	17.463	KBK-Z $\frac{11}{16}$
$\frac{3}{4}$ "	19.050	KBK-Z $\frac{3}{4}$
$\frac{13}{16}$ "	20.638	KBK-Z $\frac{13}{16}$
$\frac{7}{8}$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

EJECTOR PIN FOR KEL, ø 20 – 50 mm

ORDER NO.	VERSION
ZAK 275	Two-part version

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

ORDER NO.
ZAK 075



Core Drill Series Carbide

Carbide-tipped BDS core drills. Series with cutting depths of 30 mm, 35 mm, 55 mm, 75 mm and 110 mm and almost gapless range of diameters from 14 mm to 150 mm.

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

CORE DRILLS

PAGE

Carbide core drills short	59
Carbide core drills long	60
Carbide core drills overlong	61
Carbide core drills extra long	61
Carbide PLUS Core drills short	62
Carbide RAIL Core drills	62
HSS-Co 8 F Core drills (Quick-in holder)	63
Carbide core drills F (Quick-in holder)	63

Carbide

Carbide-tipped core drills.

Carbide core drills short

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

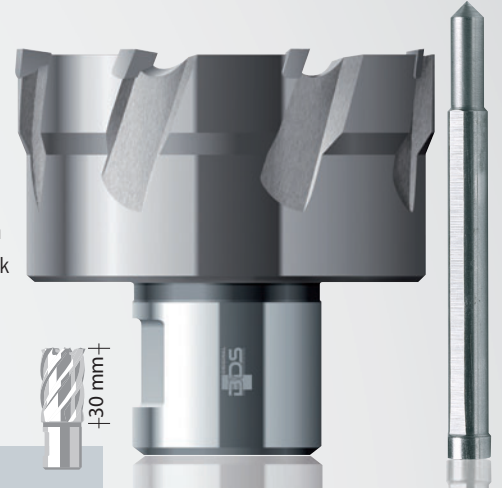


CARBIDE SERIES

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

Carbide core drills short

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



CARBIDE SERIES

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

EJECTOR PIN FOR HKK, Ø 14 - 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR HKK, Ø 61 - 150 mm

ORDER NO.

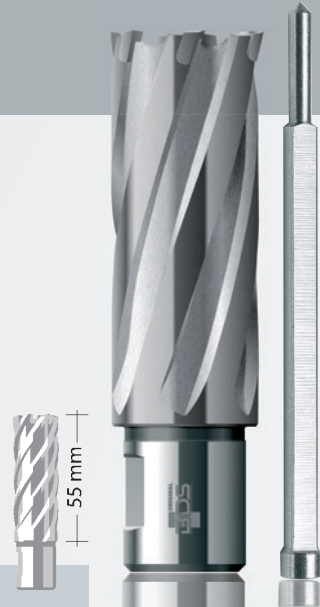
ZAK 090

Carbide

Carbide-tipped core drills.

Carbide core drills long

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

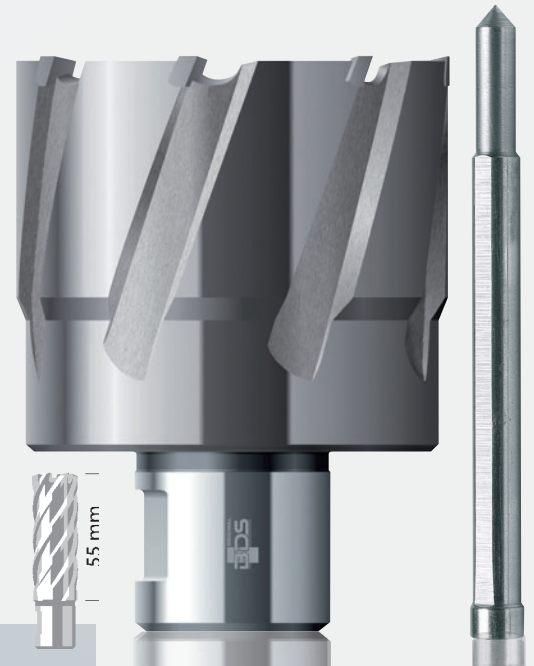


CARBIDE SERIES

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

Carbide core drills lang

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



CARBIDE SERIES

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

EJECTOR PIN FOR HKL Ø 14 - 60 mm

ORDER NO.

ZAK 100

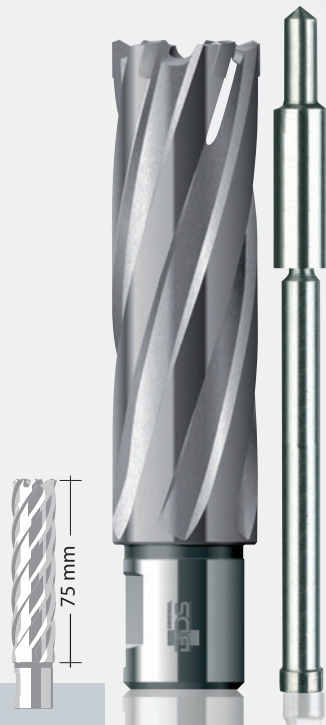
EJECTOR PIN FOR HKL Ø 61 - 100 mm

ORDER NO.

ZAK 120

Carbide core drills overlong

- > 75 mm cutting depth
- > up to ø 60 mm:
19 mm Weldon shank (¾")
- > from ø 61 mm:
32 mm Weldon shank (1 ¼")



CARBIDE SERIES

Ø mm	ORDER NO.	Ø mm	ORDER NO.
18	HKX-L 018	44	HKX-L 044
19	HKX-L 019	45	HKX-L 045
20	HKX-L 020	46	HKX-L 046
21	HKX-L 021	47	HKX-L 047
22	HKX-L 022	48	HKX-L 048
23	HKX-L 023	49	HKX-L 049
24	HKX-L 024	50	HKX-L 050
25	HKX-L 025	51	HKX-L 051
26	HKX-L 026	52	HKX-L 052
27	HKX-L 027	53	HKX-L 053
28	HKX-L 028	54	HKX-L 054
29	HKX-L 029	55	HKX-L 055
30	HKX-L 030	56	HKX-L 056
31	HKX-L 031	57	HKX-L 057
32	HKX-L 032	58	HKX-L 058
33	HKX-L 033	59	HKX-L 059
34	HKX-L 034	60	HKX-L 060
35	HKX-L 035	65	HKX-L 065
36	HKX-L 036	70	HKX-L 070
37	HKX-L 037	75	HKX-L 075
38	HKX-L 038	80	HKX-L 080
39	HKX-L 039	90	HKX-L 090
40	HKXL 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 core drills extra long

- > 110 mm cutting depth
- > up to ø 60 mm:
19 mm Weldon shank (¾")
- > from ø 61 mm:
32 mm Weldon shank (1 ¼")



CARBIDE SERIES

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

EJECTOR PIN FOR HKX-L Ø 18 - 120 mm

ORDER NO. VERSION

ZAK 225	2-part for core drill cutting depth 75 mm ø 18 - 60
ZAK 245	2-part for core drill cutting depth 75 mm ø 61 - 120

EJECTOR PIN FOR HKE-L Ø 20 - 120 mm

ORDER NO. VERSION

ZAK 275	Two-part version
---------	------------------

Carbide PLUS

Carbide-tipped core drills with carbide coating.

Carbide PLUS core drills short

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



CARBIDE SERIES-PLUS

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

EJECTOR PIN FOR HKK-P Ø 14 - 60 mm

ORDER NO.

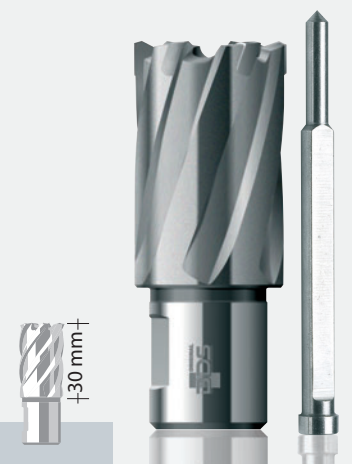
ZAK 075

Carbide RAIL

Carbide-tipped core drills for rail core drilling machines.

Carbide RAIL core drills

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



CARBIDE SERIES-RAIL

Ø mm	ORDER NO.	Ø mm	ORDER NO.
17	HKK-R 017	27	HKK-R 027
18	HKK-R 018	28	HKK-R 028
19	HKK-R 019	29	HKK-R 029
20	HKK-R 020	30	HKK-R 030
21	HKK-R 021	31	HKK-R 031
22	HKK-R 022	32	HKK-R 032
23	HKK-R 023	33	HKK-R 033
24	HKK-R 024	34	HKK-R 034
25	HKK-R 025	35	HKK-R 035
26	HKK-R 026	36	HKK-R 036



EJECTOR PIN FOR HKK-R, Ø 17 - 36 mm

ORDER NO.

ZAK 075

Quick-In HSS-Co 8-F

Core drills made from special steel with a high percentage of cobalt for higher heat resistance and protection from wear. For Quick-in tool holder system.

HSS-Co 8-F core drills short

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



HSS-Co 8-F SERIES

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

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

ORDER NO.

ZAK 096

Quick-In Carbide-F

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

Carbide-F core drills short

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



CARBIDE SERIES-F

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

EJECTOR PIN FOR HKK-F, Ø 12 - 60 mm

ORDER NO.

ZAK 096