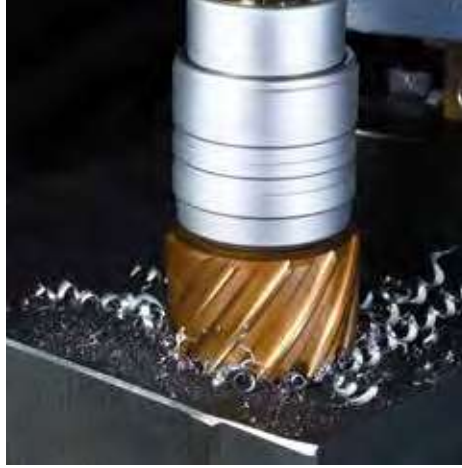


The range of BDS fully ground core drills.



HSS-Co 8 series

- ▶ High degree of heat resistance
- ▶ Better wear protection
- ▶ High cobalt content of 8%
- ▶ Suitable for higher loads in fine-grained steels and rustproof materials
- ▶ With 19 mm or 32 mm Weldon shank
- ▶ Can be resharpened

HSS-VarioPLUS series

- ▶ High-strength fully ground core drill
- ▶ Carbide coating in a range of 2.5 μ
- ▶ Longer service lives
- ▶ More uniform discharge of chips, particularly during prolonged drilling – a key point for safety during work

HSS-Standard series

- ▶ Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- ▶ Core drilling diameters of 12 mm to 130 mm
- ▶ Can be resharpened

HSS-Co 8 series
Core drills made from special steel with high cobalt content, for increased heat resistance and wear protection.

HSS-Co 8 series	
KBK-CO	KBL-CO
Cutting depth: 30 mm	55 mm
Drilling diameter: 12 – 130 mm	12 – 100 mm

HSS-VarioPLUS series
Fully ground core drills made from high-performance high-speed steel, with carbide coating, high degree of protection against wear, excellent discharge of chips.

HSS-VarioPLUS series	
KBK-VP	KBL-VP
Cutting depth: 30 mm	55 mm
Drilling diameter: 12 – 60 mm	12 – 60 mm

HSS-Standard series
Fully ground core drill made from high-performance high-speed steel

HSS-Standard series			
KBK	KBL	KEL	KBK-Z
Cutting depth: 30 mm	55 mm	110 mm	30 mm
Drilling diameter: 12 – 60 mm	12 – 60 mm	20 – 50 mm	1/2" - 2 1/16"

Professional quality for professional tasks.



BDS core drills are produced on modern CNC-controlled grinding centres. This guarantees uniform cutting, quality and cutting performance of all BDS drilling tools across the entire range.

Huge vertical range of products

BDS core drills are produced in five cutting depths of 30, 35, 55, 75 and 110 mm and with more than 94 different drilling diameters.

Arbors

BDS core drilling tools are offered with different arbors.

They fit the KEYLESS quick-change drilling system and the MT 2, MT 3 and MT 4 industrial arbors also available in the range of accessories with automatic or manual internal lubrication.



Arbors:

- ① 19 mm Weldon shank (3/4")
- ② 32 mm Weldon shank (1 1/4")
- ③ 18 mm Quick-In shank
- ④ Carbide TCT annular cutters optionally available as Universal shank (Nitto+Weldon)

Carbide series and Carbide-PLUS series

- ▶ Carbide-tipped core drills
- ▶ Cutting depths of 30 mm, 55 mm, 75 mm and 110 mm
- ▶ Diameters of 12 mm to 150 mm
- ▶ Carbide-PLUS also with wear-resistant hard coating up to 2.5 μ

Carbide series

Carbide-tipped core drills. For machining stainless steel and non-ferrous metals, we recommend our BDS 6000 high-performance cooling lubricant concentrate.



Carbide series

HKK	HKL	HKX-L	HKE-L
30 mm	55 mm	75 mm	110 mm
12 – 150 mm	12 – 100 mm	18 – 120 mm	20 – 120 mm

Carbide-PLUS series

Carbide-tipped core drills with carbide coating.



Carbide-PLUS series

HKK-P
30 mm
12 – 60 mm

Carbide-RAIL series

Carbide-tipped core drills for rail core drilling machines.



Carbide-RAIL series

HKK-R
30 mm
17 – 36 mm

Quick-In series

HSS-Co 8-F/carbide

Core drills made from HSS tool steel or carbide-tipped. Suitable for Quick-In arbor systems.



Quick-In series

KBK-CO 8 F	HKK-F
35 mm	35 mm
12 – 60 mm	12 – 60 mm

HSS-CO 8 CORE DRILL SERIES



The drills from this series have outstanding heat resistance and wear protection. In combination with speed-controlled BDS magnetic core drilling machines, they are suitable for machining fine-grained steels and rustproof materials. BDS recommends the BDS 5000 cutting oil for machining stainless steel.

HSS-Co 8 Short core drill

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



HSS-Co 8 Short core drill

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



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 SERIES

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

EJECTOR PIN FOR KBK-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBK-CO, Ø 61 – 130 mm

ORDER NO.

ZAK 090

HSS-Co 8 core drill series

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

HSS-Co 8 Long core drill

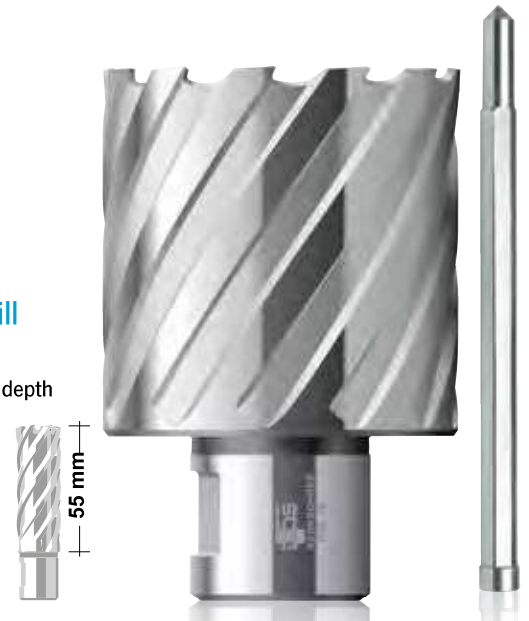
- > 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



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		

HSS-Co 8 Long core drill

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



HSS-Co 8 SERIES			
Ø mm	ORDER NO.	Ø mm	ORDER NO.
61	KBL-CO 061	81	KBL-CO 081
62	KBL-CO 062	82	KBL-CO 082
63	KBL-CO 063	83	KBL-CO 083
64	KBL-CO 064	84	KBL-CO 084
65	KBL-CO 065	85	KBL-CO 085
66	KBL-CO 066	86	KBL-CO 086
67	KBL-CO 067	87	KBL-CO 087
68	KBL-CO 068	88	KBL-CO 088
69	KBL-CO 069	89	KBL-CO 089
70	KBL-CO 070	90	KBL-CO 090
71	KBL-CO 071	91	KBL-CO 091
72	KBL-CO 072	92	KBL-CO 092
73	KBL-CO 073	93	KBL-CO 093
74	KBL-CO 074	94	KBL-CO 094
75	KBL-CO 075	95	KBL-CO 095
76	KBL-CO 076	96	KBL-CO 096
77	KBL-CO 077	97	KBL-CO 097
78	KBL-CO 078	98	KBL-CO 098
79	KBL-CO 079	99	KBL-CO 099
80	KBL-CO 080	100	KBL-CO 100

EJECTOR PIN FOR KBL-CO, Ø 12 – 60 mm

ORDER NO.

ZAK 100

Ejector pin FOR KBL-CO, Ø 61 – 100 mm

ORDER NO.

ZAK 120

Optimum drilling and lubrication with BDS products.

Recommended cutting speed

Core drill series	Material	m/min
HSS-Co 8	Fine-grained steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
	Stainless steel	10 – 15
	Cast iron (depending on type)	15 – 20
HSS-VarioPLUS	Fine-grained steel	
	< 700 N/m ²	10 – 15
	< 1000 N/m ²	10 – 15
HSS-Standard	Aluminium	20 – 30
	Steel	25
	Cast iron	10 – 20
Carbide	Steel/fine-grained steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1,000 N/m ²	20
	Rustproof, stainless steel	20
Carbide-PLUS	Steel/fine-grained steel	
	< 500 N/m ²	35
	< 700 N/m ²	25
	< 1,000 N/m ²	20
	Rustproof, stainless steel	20
Carbide-RAIL	Railway rails	15 – 20

Cutting speed:

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

Table of speeds

Diame-ter	Vc 15 m/ min	Vc 20 m/ min	Vc 25 m/ min	Vc 30 m/ min	Vc 35 m/ min
\emptyset	rpm	rpm	rpm	rpm	rpm
14	340	460	570	690	800
18	260	360	450	540	620
22	220	300	370	440	510
26	180	250	310	370	430
30	160	220	270	320	380
35	140	190	230	280	320
40	120	160	200	240	280
45	110	150	180	220	250
50	100	130	160	200	230
55	90	120	150	180	210
60	80	110	140	160	190
65	75	100	130	150	180
70	70	90	120	140	160
75	65	85	110	130	150
80	60	80	100	120	140
85	55	75	95	110	130
90	55	70	90	110	120
95	50	65	85	100	120
100	50	65	80	100	110
110	45	60	80	90	100
120	40	60	70	80	100
130	40	50	60	80	90

Speed:

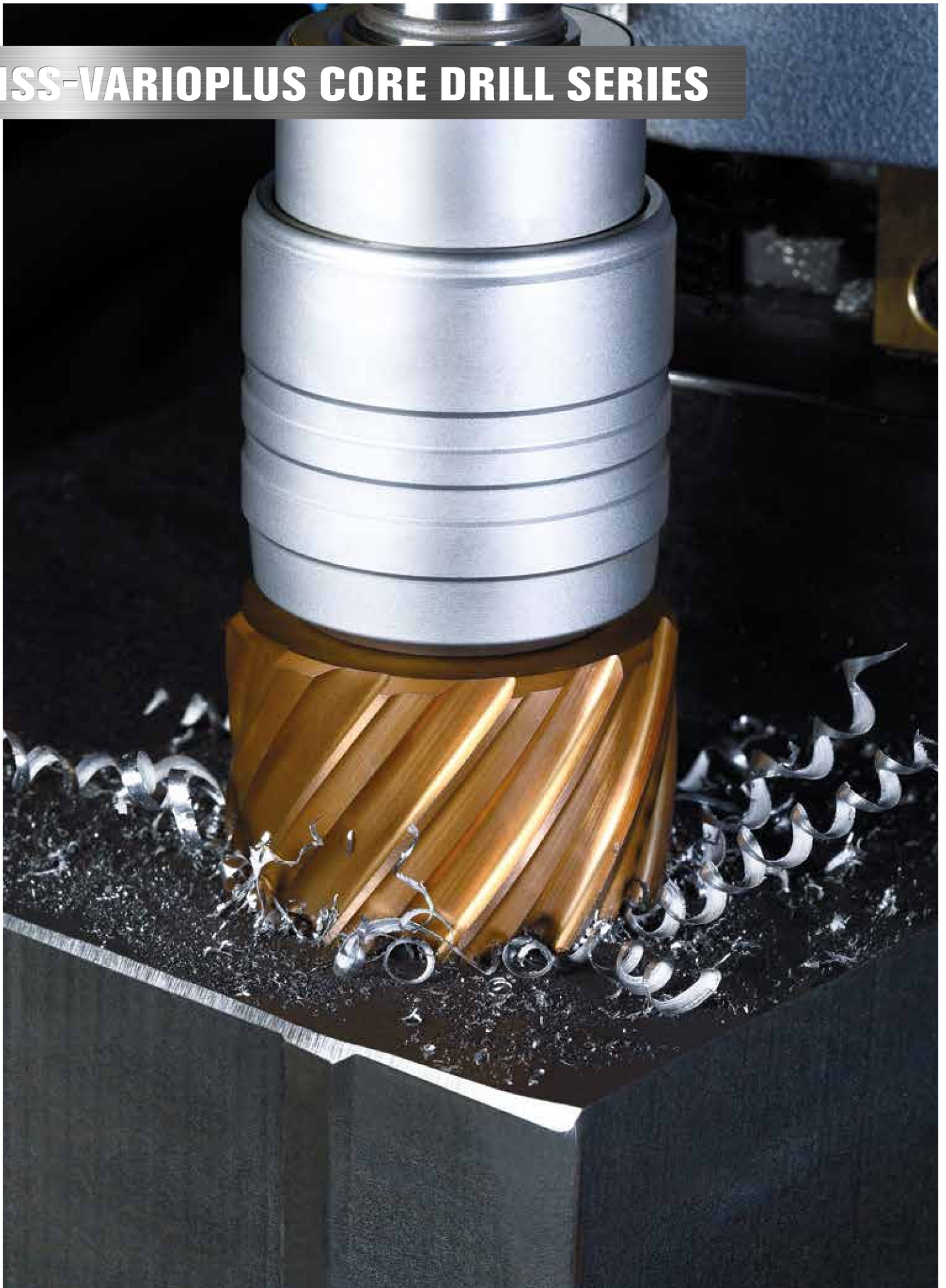
$$n = \frac{v \times 1,000}{d \times \pi} = \text{rpm}$$

Assignment of BDS drill series and the appropriate BDS cooling lubricants to the material.

	Cutting oil BDS 5000	Lubrication spray BDS 5200	Cutting paste BDS 5500	Paste ZHS 570	BDS 6000 cooling lubricant concentrate
Aluminium, non-ferrous metals					
HSS-Standard	•	•			
Steel < 500 N/m²					
HSS-Standard	•	•			
Carbide					•
Carbide-PLUS					•
Fine-grained steel < 700 N/m²					
HSS-Co 8	•	•	•	•	
HSS-VarioPLUS	•	•	•	•	
Carbide					•
Carbide-PLUS					•
Fine-grained steel < 1,000 N/m²					
HSS-Co 8	•	•	•	•	
HSS-VarioPLUS	•	•	•	•	
Carbide					•
Carbide-PLUS					•
Rustproof steels, stainless steel					
HSS-Co 8	•	•	•	•	
Carbide					•
Carbide-PLUS					•
Cast iron					
HSS-Co 8					•
HSS-Standard					•
Railway rails					
Carbide-RAIL					•



HSS-VARIOPLUS CORE DRILL SERIES



Fully ground core drills made from high-performance high-speed steel with carbide coating. High economic efficiency due to longer service life, greater safety during work thanks to excellent discharge of chips, particularly for long core drills. BDS recommends the BDS 5000 high-performance cutting oil.

HSS-VarioPLUS short core drill

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



HSS-VarioPLUS long core drill

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



HSS-VarioPLUS SERIES

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

HSS-VarioPLUS SERIES

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

EJECTOR PIN FOR KBK-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 075

EJECTOR PIN FOR KBL-VP, Ø 12 – 60 mm

ORDER NO.

ZAK 100

HSS-STANDARD CORE DRILL SERIES



The basic core drill range for professional use. Fully ground core drill made from high-performance high-speed steel on CNC-controlled grinding centres, with good discharge of chips. Drilling with minimal effort. For working on a horizontal plane, BDS recommends the BDS 5200 high-performance lubrication spray.

HSS-Standard short core drill

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



HSS-Standard long core drill

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



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

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

EJECTOR PIN FOR KBK, Ø 12 – 60 mm	
ORDER NO.	
ZAK 075	

EJECTOR PIN FOR KBL, Ø 12 – 60 mm	
ORDER NO.	
ZAK 100	

HSS-Standard

Fully groundcore drills
made from high-performance
high-speed steel.

HSS-Standard core drill Extra-long

- > 110 mm cutting depth
- > 19 mm Weldon shank (3/4")



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

EJECTOR PIN FOR KEL, Ø 20 – 50 mm	
ORDER NO.	VERSION
ZAK 275	Two-part version

HSS-Standard, Inches

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

HSS-Standard core drill Short, Inches

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



HSS-STANDARD SERIES, IMPERIAL		
Ø Inches	Ø mm	ORDER NO.
1/2"	12.700	KBK-Z 1/2
9/16"	14.288	KBK-Z 9/16
5/8"	15.875	KBK-Z 5/8
11/16"	17.463	KBK-Z 11/16
3/4"	19.050	KBK-Z 3/4
13/16"	20.638	KBK-Z 13/16
7/8"	22.225	KBK-Z 7/8
15/16"	23.813	KBK-Z 15/16
1"	25.400	KBK-Z 1
1 1/16"	26.988	KBK-Z 1 1/16
1 1/8"	28.575	KBK-Z 1 1/8
1 3/16"	30.136	KBK-Z 1 3/16
1 1/4"	31.750	KBK-Z 1 1/4
1 5/16"	33.338	KBK-Z 1 5/16
1 3/8"	34.925	KBK-Z 1 3/8
1 7/16"	36.513	KBK-Z 1 7/16
1 1/2"	38.100	KBK-Z 1 1/2
1 9/16"	39.688	KBK-Z 1 9/16
1 5/8"	41.276	KBK-Z 1 5/8
1 11/16"	42.863	KBK-Z 1 11/16
1 3/4"	44.450	KBK-Z 1 3/4
1 13/16"	46.038	KBK-Z 1 13/16
1 7/8"	47.625	KBK-Z 1 7/8
1 15/16"	49.213	KBK-Z 1 15/16
2"	50.800	KBK-Z 2
2 1/16"	52.388	KBK-Z 2 1/16

EJECTOR PIN FOR KBK-Z, Ø 1/2" – 2 1/16"	
ORDER NO.	
ZAK 075	

Quality features that make the difference.



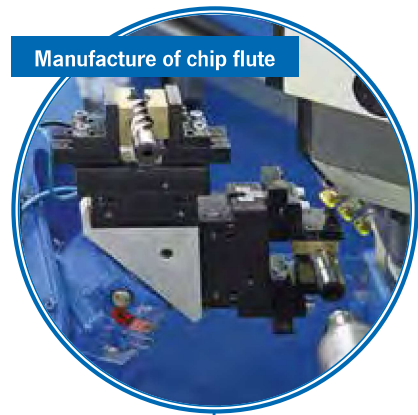
Grinding the end teeth

Modern CNC-controlled grinding centres ensure consistent quality.



Perfect cylindrical grinding

Maximum concentricity and a high degree of dimensional stability are guaranteed by the latest generation of cylindrical grinding machines.



Manufacture of chip flute

Optimised work processes and quick loading operations with loading robots speed up the work process.



VarioPLUS coating

The VarioPLUS developed for BDS provides an additional protective layer on the tools. A hard coating provides a high degree of heat resistance and increased hardness of the coating.

The best raw materials



STEEL FOR THE BEST IN THE WORLD

Böhrler high-performance tool steel ensures continuous quality of the highest standard.

From the first to the last cut!

HSS-Co 8%, HSS-VarioPLUS and HSS-BDS fully ground core drills



Unprocessed round bar



Mechanically processed



Hardened



Ground to external dimension



Ground with flute and end tooth



Coated VarioPLUS core drills



CARBIDE CORE DRILL SERIES



BDS carbide-tipped core drills. Series with cutting depths of 30 mm, 35 mm, 55 mm, 75 mm and 110 mm and almost stepless graduations of the diameter from Ø 12 mm to Ø 150 mm. BDS recommends the BDS 6000 high-performance cooling lubricant concentrate for machining stainless steel and non-ferrous metals.

Carbide (TCT) Core Drills Short

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



Carbide (TCT) Core Drills Short

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



CARBIDE SERIES

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

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.

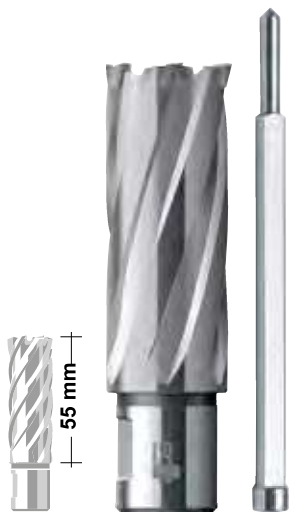
ZAK 090

Carbide (TCT)

Tungsten Carbide Tip Core Drills

Carbide (TCT) Core Drills Long

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



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

Carbide (TCT) Core Drills Long

- > 55 mm cutting depth
- > 32 mm Weldon shank (1 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 (TCT) Core Drills Overlong

- > 75 mm cutting depth
- > up to Ø 60 mm:
19 mm Weldon shank (3/4")
- > from Ø 61 mm
32 mm Weldon shank (1 1/4")



Carbide (TCT) Core Drills Overlong

- > 110 mm cutting depth
- > up to Ø 60 mm:
19 mm Weldon shank (3/4")
- > from Ø 61 mm
32 mm Weldon shank (1 1/4")



CARBIDE SERIES			
Ø mm	ORDER NO.	Ø mm	ORDER NO.
18	HKX-L 018	44	HKX-L 044
19	HKX-L 019	45	HKX-L 045
20	HKX-L 020	46	HKX-L 046
21	HKX-L 021	47	HKX-L 047
22	HKX-L 022	48	HKX-L 048
23	HKX-L 023	49	HKX-L 049
24	HKX-L 024	50	HKX-L 050
25	HKX-L 025	51	HKX-L 051
26	HKX-L 026	52	HKX-L 052
27	HKX-L 027	53	HKX-L 053
28	HKX-L 028	54	HKX-L 054
29	HKX-L 029	55	HKX-L 055
30	HKX-L 030	56	HKX-L 056
31	HKX-L 031	57	HKX-L 057
32	HKX-L 032	58	HKX-L 058
33	HKX-L 033	59	HKX-L 059
34	HKX-L 034	60	HKX-L 060
35	HKX-L 035	65	HKX-L 065
36	HKX-L 036	70	HKX-L 070
37	HKX-L 037	75	HKX-L 075
38	HKX-L 038	80	HKX-L 080
39	HKX-L 039	90	HKX-L 090
40	HKX-L 040	100	HKX-L 100
41	HKX-L 041	110	HKX-L 110
42	HKX-L 042	120	HKX-L 120
43	HKX-L 043		

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

EJECTOR PIN FOR HKX-L, Ø 18 – 120 mm

ORDER NO. VERSION

- ZAK 225 Two-part for core drill cutting depth of 75 mm, Ø 18 – 60
 ZAK 245 Two-part for core drill cutting depth of 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 Short core drill

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



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

Carbide-RAIL

Carbide-tipped core drills for railway track drilling.

Carbide-RAIL core drill

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



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



EJECTOR PIN FOR HKK-P, Ø 14 – 60 mm
ORDER NO.
 ZAK 075

EJECTOR PIN FOR HKK-R, Ø 17 – 36 mm
ORDER NO.
 ZAK 075

Quick-In HSS-Co 8-F

Core drills made from tool steel with high cobalt content, for increased heat resistance and wear protection. For Quick-In arbor system.

HSS-Co 8-F short core drill

- > 35 mm cutting depth
- > 18 mm shank for Quick-In arbor system



Quick-In carbide-F

Carbide-tipped core drills. For Quick-In arbor system.

Short carbide-F core drill

- > 35 mm cutting depth
- > 18 mm shank for Quick-In arbor 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		

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

EJECTOR PIN FOR HSS-Co 8-F, Ø 12 – 60 mm
ORDER NO.
 ZAK 096

EJECTOR PIN FOR HKK-F, Ø 12 – 60 mm
ORDER NO.
 ZAK 096

Core drill box

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

Core drill sets 5 core drills

- > 30 mm and 55 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-Standard short core drill



CORE DRILL BOX

ORDER NO.	CONTENTS
KBK box, standard	2 x KBK 014 2 x KBK 018 1 x KBK 022

HSS-VarioPLUS short core drill



CORE DRILL BOX

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

HSS-Co short core drill



CORE DRILL BOX

ORDER NO.	CONTENTS
KBK-CO box	2 x 014 2 x 018 1 x 022

HSS-Standard long core drill



CORE DRILL BOX

ORDER NO.	CONTENTS
KBK box standard	2 x KBL 014 2 x KBL 018 1 x KBL 022

HSS-VarioPLUS long core drill



CORE DRILL BOX

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

Short carbide core drill



CORE DRILL BOX

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

Core drill case

Six BDS core drills in the most common sizes in a sturdy plastic case.

Core drill sets
6 core drills
plus 1 ejector pin

- > High-performance high-speed steel
- > 30 mm cutting depth
- > 19 mm Weldon shank (3/4")



HSS-Co 8 short core drill



HSS-Standard short core drill



HSS-VarioPLUS short core drill



CORE DRILL CASE	
ORDER NO.	CONTENTS
KBK-CO 001	2 x KBK-CO 014 2 x KBK-CO 018 2 x KBK-CO 022 1 x ZAK 075
KBK-CO 002	1 x KBK-CO 013 1 x KBK-CO 014 1 x KBK-CO 017 1 x KBK-CO 018 1 x KBK-CO 021 1 x KBK-CO 022 1 x ZAK 075

CORE DRILL CASE	
ORDER NO.	CONTENTS
KBK 001	2 x KBK 014 2 x KBK 018 2 x KBK 022 1 x ZAK 075
KBK 002	1 x KBK 013 1 x KBK 014 1 x KBK 017 1 x KBK 018 1 x KBK 021 1 x KBK 022 1 x ZAK 075

CORE DRILL CASE	
ORDER NO.	CONTENTS
KBK-VP 001	2 x KBK-VP 014 2 x KBK-VP 018 2 x KBK-VP 022 1 x ZAK 075
KBK-VP 002	1 x KBK-VP 013 1 x KBK-VP 014 1 x KBK-VP 017 1 x KBK-VP 018 1 x KBK-VP 021 1 x KBK-VP 022 1 x ZAK 075

Twist drills, countersinks and machine screw taps

HSS twist drills with 19 mm ($\frac{3}{4}$ ")
Weldon shank
Twist length 35 mm



Ø	Twist length	Order No.
6.00	35 mm	SPS 060
6.80	35 mm	SPS 068
8.00	35 mm	SPS 080
8.50	35 mm	SPS 085
10.00	35 mm	SPS 100
10.20	35 mm	SPS 102
12.00	35 mm	SPS 120
13.00	35 mm	SPS 130
14.00	35 mm	SPS 140

HSS machine screw taps with 19 mm ($\frac{3}{4}$ ") Weldon shank
DIN 376 form B



Ø	Total length	DIN	Order No.
M8	90 mm	DIN 371 form B	GWB 008
M10	100 mm	DIN 376 form B	GWB 010
M12	110 mm	DIN 376 form B	GWB 012
M16	110 mm	DIN 376 form B	GWB 016
M18	125 mm	DIN 376 form B	GWB 018
M20	140 mm	DIN 376 form B	GWB 020

3-fluted countersink 90°,
3 cutting edges



Ø	Shank	Order No.
20.5	Straight shank	ZSE 205
40	Weldon shank 19 mm ($\frac{3}{4}$ ")	ZSE 040
50	Weldon shank 19 mm ($\frac{3}{4}$ ")	ZSE 050
40	MT 3	ZSE 340
50	MT 3	ZSE 350

Combi tool set and starter kit

COMBINATION TOOL SET

ORDER NO. STANDARD/SIZE

ZGK 001

BDS combi tool set, 8-piece

Clear, sturdy steel box, equipped with twist drills, screw taps and countersinks to manufacture tapped holes from M8 to M16.

1 twist drill	DIN 338, Ø 6.8 mm
1 twist drill	DIN 338, Ø 8.5 mm
1 twist drill	DIN 338, Ø 10.2 mm
1 each of machine screw tap	DIN 371, M8
	DIN 376, M10, M12, M16
1 countersink	DIN 335
	form C 90°, Ø 20.5 mm



BDS TOOL SET STARTER KIT

ORDER NO.

ZST 400

Contents:

- 1 ZGK 001 combination tool set
- 1 tin of BDS ZHS 400 lubrication spray
- 1 BDS PowerWORKER POW100

PRICE ADVANTAGE!

