



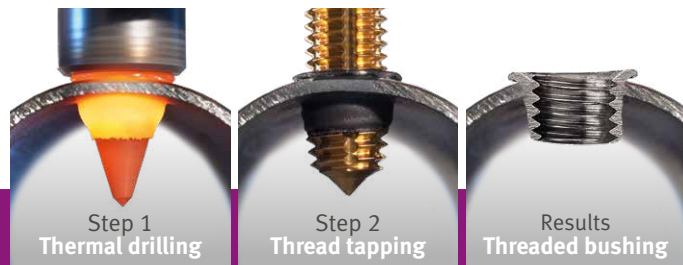
The solution for loose rivet nuts

Secure threaded connections
for thin wall thicknesses

THERMADRILL®

Verbindungstechnik – Made in Germany

The Thermadrill® method



MADE IN
GERMANY



In thermal drilling, the friction heat from the existing material is used to create an anti-twist protected bushing without material removal in which a thread is then tapped.

- For aluminium, brass, copper, steel, stainless steel as of 1.0 mm wall thickness
- For use with milling cutters, CNC systems and post drills

www.thermadrill.de

✓ **Cost savings**

✓ **Time savings**

✓ **Maximum safety**

1 Thermal drill



SHAPE

For bushes
with collar



CUT

For bushes
without collars



- Suitable for aluminium, non-ferrous metal, steel and stainless steel
- Made of solid carbide with a special polygon grind

Size	Type	Max. material thickness [mm]	Art. no.	Max. material thickness [mm]	Art. no.
M4	short	1.5	3060104	2.0	3060164
	long	2.5	3060124	4.0	3060144
M5	short	2.0	3060105	3.0	3060165
	long	3.0	3060125	4.5	3060145
M6	short	2.0	3060106	3.0	3060166
	long	3.5	3060126	5.0	3060146
M8	short	2.5	3060108	4.0	3060168
	long	4.0	3060128	6.0	3060148
M10	short	2.5	3060110	4.0	3060170
	long	4.5	3060130	6.5	3060150
M12	short	2.5	3060112	4.0	3060172
	long	4.5	3060132	6.5	3060152

Other thread sizes available (also in metric fine and pipe threads)

2 Thread tapper



with TiN
coating
and lubricant grooves
tolerance 6HX
Form C

- Legacy tool fittings can be used

Size	Art. no.
M4 x 0.7	3060184
M5 x 0.8	3060185
M6 x 1.0	3060186
M8 x 1.25	3060188
M10 x 1.25	3060190
M12 x 1.25	3060192

3 Basic equipment



Contains everything you need to get started with the THERMADRILL right away

Shank	Art. no.
MK 2	3060005

Contents:

- THERMADRILL Paste 100 g
- Thread tapping oil 100 ml
- Open-end wrench
- Hook wrench
- Tool holder with cooling ring MK 3
- Case
- Reduction sleeve MK 3 - MK 2
- Spring collets (Ø 6/8/10/12 mm)

Tool set = Thermal drill + thread tapper

Type SHAPE

Size	Type	Max. material thickness [mm]	Art. no.
M4	short	1.5	3060024
	long	2.5	3060034
M5	short	2.0	3060025
	long	3.0	3060035
M6	short	2.0	3060026
	long	3.5	3060036
M8	short	2.5	3060028
	long	4.0	3060038
M10	short	2.5	3060030
	long	4.5	3060040
M12	short	2.5	3060032
	long	4.5	3060042

Type CUT

Max. material thickness [mm]	Art. no.
2.0	3060044
4.0	3060054
3.0	3060045
4.5	3060055
3.0	3060046
5.0	3060056
4.0	3060048
6.0	3060058
4.0	3060050
6.5	3060060
4.0	3060052
6.5	3060062

Other thread sizes available (also in metric fine and pipe threads)

THERMADRILL Paste

Container	Art. no.
For friction drilling including brush	
1 kg	3060090



Protects the thermal drill against excessive wear.

Thread tapping oil

Container	Art. no.
Including brush	
1 litre	3060092



High-performance oil, specially suited for thread tapping in aluminium, copper, brass, steel, stainless steel,

Overview Metallkraft® Magnetic core drilling machines



MB 351



MB 502 E



MB 502



MB 754



RB 127



MB 351 F



MB 1204



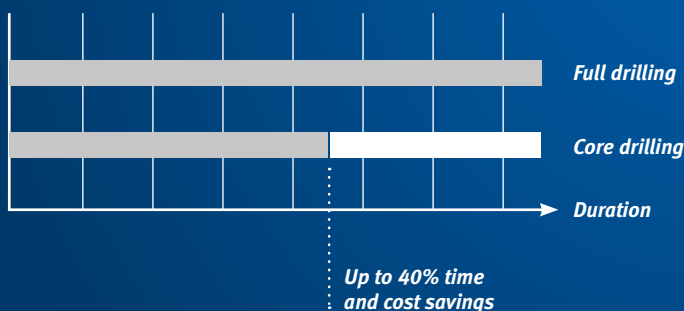
MB 202 G

Magnetic drilling

Modell	MB 351	MB 502 E	MB 502	MB 754	MB 1204	RB 127	MB 351 F	MB 202 G
	Feed manual	Feed manual	Feed manual	Feed manual	Feed manual	Feed manual	Feed manual	Feed manual
Technical specifications								
Keyhole sawing max. Ø	-	-	-	-	-	127 mm	-	-
Max. drill Ø / Core drilling	35 mm	50 mm	50 mm	75 mm	120 mm	-	35 mm	35 mm
Max. drilling depth / Core drilling	50 mm	50 mm	75 mm	50 mm	75 mm	-	30 mm	50 mm
Max. drill bit Ø/Full drilling ¹	-	-	-	32 mm	32 mm	-	-	13 mm
Max. drilling depth/Full drilling ¹	-	-	-	150 mm	150 mm	-	-	110 mm
Max. drill bit Ø/Full drilling ²	13 mm	13 mm	16 mm	16 mm	16 mm	-	-	-
Max. drilling depth/Full drilling ²	140 mm	140 mm	110 mm	110 mm	110 mm	-	-	-
Spindle holder	M 27	Fixed	M 27	MK 3	MK 3	5/8"-16	Fixed	Fixed
Weldon shaft holder	19 mm	19 mm	19 mm	19 mm	19 mm	-	19 mm	19 mm
Speed under load in rpm	330	180/270	230/300	90/120/180/230	120/220/250/450	-	390	330
Motor output	1 100 Watts	1 100 Watts	2 000 Watts	2 000 Watts	2 000 Watts	1 100 Watts	1 100 Watts	1 100 Watts
Electrical connection	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz	230 V/50 Hz
Magnetic foot dimensions	165 x 80 mm	180 x 90 mm	200 x 100 mm	200 x 100 mm	210 x 120 mm	-	165 x 80 mm	180 x 80 mm
Magnetic holding force	15 000 N	17 000 N	32 000 N	32 000 N	32 000 N	-	15 000 N	15 000 N

1) with directly mounted full drill 2) with mounted drill chuck adapter and drill chuck

More economical and faster drilling:



Full drilling:

- Pre-drilling usually necessary
- Time-consuming tool changes for large drill Ø
- Large machining area
- High energy expenditure
- Poorer drill hole quality (burr)



Core drilling:

- No centring or preliminary drilling necessary
- The smaller machining area means you are much faster while needing less energy
- Drilling to max. 120 mm Ø, also overlapping
- Highest quality (burr, surface)
- Significantly more economical than full drilling
- Rapid tool change via "Lock & Load" system apart from MB 754/1204

Magnetic drilling machines

MB – High-quality magnetic core drilling machines for versatile use.
Drilling large diameters economically and rapidly.

- ▶ For core drills with 19 mm Weldon shaft
- ▶ Stable drilling guidance thanks to long and particularly deep mounted spindle sleeve holder
- ▶ Device is earthed and double isolated,

- hence ideal for building sites
- ▶ High magnetic holding force
- ▶ High-quality mechanical design
- ▶ The coolant is routed through the drill
- ▶ Conversion from core to full drilling in just a

- few actions
- ▶ Safe and reliable function
- ▶ Quick-release chuck for convenient core drill changing
(for MB 351, 502 and 502 E)

MB 351



- Single speed
- Quick-release chuck
- 1 100 Watt motor

MB 502 E



- Two speeds
- Quick-release chuck
- 1 100 Watt motor

MB 502



- Two speeds
- 2 000 Watt motor
- Quick-release chuck

Model		MB 351	MB 502 E	MB 502	MB 754	MB 1204
Art. no.		3860351	3860500	3860502	3860754	3861204
Technical specifications		Feed manual	Feed manual	Feed manual	Feed manual	Feed manual
Max. drill Ø / Core drilling	mm	35	50	75	120	
Max. drilling depth / Core drilling	mm	50		75	50	75
Max. drill Ø / Full drilling ¹	mm	-	-	-	32	
Max. drilling depth / Full drilling ¹	mm	-	-	-	150	
Max. drill Ø / Full drilling ²	mm	13	13		16	
Max. drilling depth / Full drilling ²	mm	140	140		110	
Spindle holder		M 24	Fixed	M 24	MK 3	
Weldon shaft holder	mm			19		
Speeds	rpm	330	180/270	230/300	90/120/180/230	35-120 70-220 80-250 140-450
Motor output	W	1 100			2 000	
Electrical connection	V/Hz			230 / 50		
Magnetic foot dimensions	mm	165 x 80	180 x 90	200 x 100		210 x 120
Magnetic holding force	N	15 000	17 000	32 000		
Max. dimension	mm	450 x 330 x 260	330 x 125 x 476	330 x 125 x 476		
Weight	kg	12.6	15	22.9	24.8	28.3

1) with directly mounted full drill 2) with mounted drill chuck adapter and drill chuck

Scope of supply

MB 351, MB 502,

MB 754, MB 1204:

- › 1 coolant tank and coolant line
- › 1 Protection device
- › Operating tool
- › Plastic carrying case
- › 1 Chain
- › MB 754, 1204 also with clearing cotter
- › MB 754, 1204 additionally with core drill chuck MK 3/19 mm & core drill chuck MK 3/32 mm



- Fastening element**
Specially for the MB 754 magnetic drilling machine
- ▶ For fastening the machine on pipes with a diameter of 32 – 203 mm
 - ▶ Easy to install
 - ▶ Stable and reliable

Art no. 3867504
€205.00 plus VAT

MB 754



- Four speeds
 - 2 000 Watt motor
 - Max. magnetic holding force of 32 000 N
- Spindle holder MK 3
- Clockwise/Anti-clockwise rotation

MB 1204



- Four variable speed ranges
 - 2 000 Watt motor
 - Max. magnetic holding force of 32 000 N
- Spindle holder MK 3
- Clockwise/Anti-clockwise rotation



Various speeds adjustable
with the following models
MB 502, MB 502 E,
MB 754 and 1204



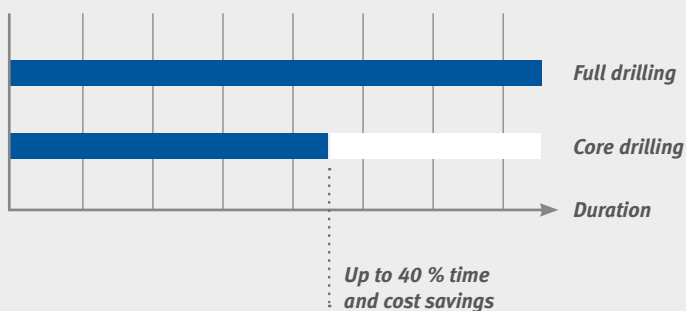
Quick-release chuck
(for MB 351 and MB 502)



Conversion from core to full drilling
with just a few actions

Core drilling benefits

More economical and faster drilling:



Full drilling:

- Pre-drilling usually necessary
- Time-consuming tool changes for large drill Ø
- Large machining area
- High energy expenditure
- Poorer drill hole quality (burr)



Core drilling:

- No centring or preliminary drilling necessary
- The smaller machining area means you are much faster while needing less energy
- Drilling to max. 120 mm Ø, also overlapping
- Highest quality (burr, surface)
- Significantly more economical than full drilling
- Rapid tool change via "Lock & Load" system apart from MB 754/1204

Magnetic drilling machines

MB – High-quality magnetic core drilling machines for versatile use.

RB – Pipe drilling machine with keyhole saw and low installation height.

- ▶ For core drills with 19 mm Weldon shaft (apart from RB 127)
- ▶ Stable drilling guidance thanks to long and particularly deep mounted spindle sleeve holder
- ▶ Device is earthed and double isolated, hence ideal for building sites

- ▶ High magnetic holding force (apart from RB 127)
- ▶ High-quality mechanical design
- ▶ The coolant is routed through the drill (apart from RB 127 and MB 351 F)
- ▶ Conversion from core to full drilling in just a few actions

Special features MB 202 G

- ▶ Integrated, automatic coolant supply
- ▶ Tapping drill direction of rotation can be changed without changing the direction or stopping of the motor
- ▶ 3 functions: Thread tapping, core drilling and full drilling

MB 202 G



- Integrated automatic coolant supply
- Tapping drill direction of rotation can be changed (without changing the direction or stopping of the motor)
- 3 functions: Thread tapping, core drilling and full drilling

RB 127



With integrated spirit level



- 1 Speed
- 1 100 Watt motor
- Integrated spirit level

Model	MB 202 G	RB 127	MB 351 F
Art. no.	3862000	3860127	3860350
	Feed manual	Feed manual	Feed manual
Technical specifications			
Keyhole sawing max. Ø	-	127 mm	-
Max. drill Ø / Core drilling	35 mm	-	35 mm
Max. drilling depth / Core drilling	50 mm	-	30 mm
Max. drill Ø / Full drilling ¹	13 mm	-	-
Max. drilling depth / Full drilling ¹	110 mm	-	-
Spindle holder	Fixed	5/8"-16	Fixed
Weldon shaft holder	19 mm	-	19 mm
Speed under load in rpm	330	-	390
Motor output	1 100 Watts	1 100 Watts	1 100 Watts
Electrical connection	230 V / 50 Hz	230 V / 50 Hz	230 V / 50 Hz
Magnetic foot dimensions	180 x 80 mm	-	165 x 80 mm
Magnetic holding force	15 000 N	-	15 000 N
Max. dimension in mm	280 x 205 x 395	319 x 270 x 302	285 x 101 x 200
Weight	13.7 kg	14.5 kg	10 kg

1) with mounted drill chuck adapter and drill chuck

Scope of delivery MB 202 G:

- › 1 coolant tank and coolant line
- › 1 Protection device
- › Operating tool
- › Plastic carrying case
- › Adapter, universal chuck for M5 to M22 taps and quick release system for core drill bits and taps

Scope of delivery RB 127, MB 351 F:

- › 1 Protection device
- › Operating tool
- › Plastic carrying case
- › Holder for pipes 32 - 203 mm (RB 127)
- › Integrated spirit level (RB 127)



RB 127

Holder for pipes 32 - 203 mm

Special features pipe drill RB 127

- ▶ Integrated spirit level
- ▶ Cutting holes up to 127 mm possible
- ▶ Horizontal and vertical working position possible
- ▶ Holder for pipes with simple quick-release system and chain
- ▶ Low installation height

Special features MB 351 F

- ▶ Balanced carrying comfort
- ▶ Operating lever can be used on both sides
- ▶ LED light for dark work areas
- ▶ Practical and lightweight
- ▶ Optimum use in cramped conditions

MB 351 F



With freely adjustable lever



LED light for 'dark work areas'

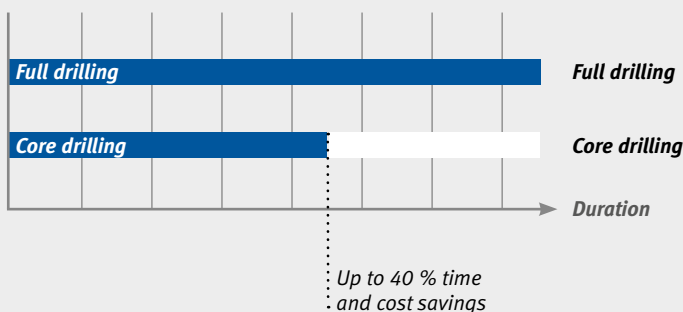


Flat version

- 1 Speed
- With quick-release chuck
- 1 100 Watt motor
- LED light for dark work areas
- Operating lever can be used on both sides

Core drilling benefits

More economical and faster drilling:



Full drilling:

- Pre-drilling usually necessary
- Time-consuming tool changes for large drill Ø
- Large machining area
- High energy expenditure
- Poorer drill hole quality (burr)



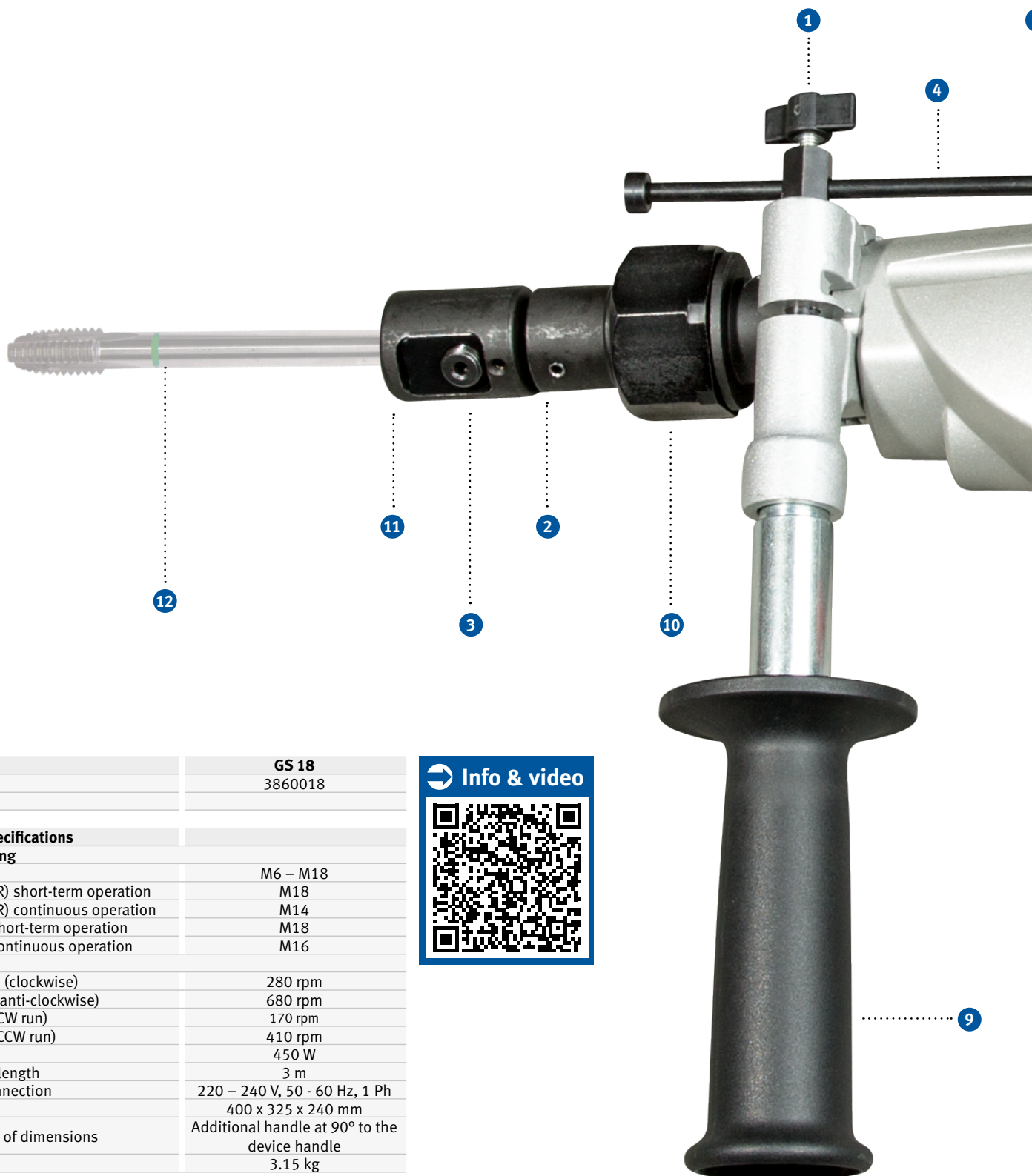
Core drilling:

- No centring or preliminary drilling necessary
- The smaller machining area means you are much faster while needing less energy
- Drilling to max. 120 mm Ø, also overlapping
- Highest quality (burr, surface)
- Significantly more economical than full drilling
- Rapid tool change via "Lock & Load" system apart from MB 754/1204

Electrical thread tap

GS 18 – Electric thread tap with reversing gear for time-saving, precise tapping of threads in drilled holes

- ▶ Reversing gear allows for very fast processing: pressure on the spindle starts slow clockwise action of the tool. Pulling back automatically enables quick reverse at 680 rpm
- ▶ Easy thread tapping in a single step thanks to high torque, low speed and excellent concentricity precision
- ▶ Additional handle allows for optimum and convenient tool guidance
- ▶ Compensates for cutting tool angular offset in the borehole thanks to an articulated coupling between the chuck adapter and threaded chuck
- ▶ For drilling blind holes



Model	GS 18
Art. no.	3860018
Technical specifications	
Thread tapping	
screw tap	M6 – M18
Steel (S235JR) short-term operation	M18
Steel (S235JR) continuous operation	M14
Aluminium short-term operation	M18
Aluminium continuous operation	M16
Speeds	
Idle forwards (clockwise)	280 rpm
Idle reverse (anti-clockwise)	680 rpm
Under load (CW run)	170 rpm
Under load (CCW run)	410 rpm
Rating	450 W
Power cable length	3 m
Electrical connection	220 – 240 V, 50 - 60 Hz, 1 Ph
Dimensions	400 x 325 x 240 mm
Explanations of dimensions	Additional handle at 90° to the device handle
Weight	3.15 kg



- › Reversing gear for fast and easy thread tapping
- › Precision thanks to high torque, low speed and excellent concentricity precision
- › Universal chuck with slip clutch for longer tool service life
- › Compensates for cutting tool angular offset thanks to articulated coupling

Scope of delivery GS 18:

- › Universal chuck M6 – M18 with slip clutch
- › Additional handle
- › 4 mm Allen key
- › Depth stop
- › Transport case



Transport case

- 1 Tightening screw
- 2 Rotating head
- 3 Tightening screw
- 4 Depth stop
- 5 Housing
- 6 Motor
- 7 Handle
- 8 On switch
- 9 Side handle
- 10 Safety slip clutch
- 11 Universal chuck
- 12 Thread taper (not included in scope of delivery)



Reversing gear for short processing duration: pressure on the spindle starts slow clockwise action, reversing automatically enables fast action



Depth stop and universal chuck for standard thread tap from M6 to M18 included in scope of delivery



Compensates for cutting tool angular offset in the borehole thanks to an articulated coupling between the chuck adapter and threaded chuck

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

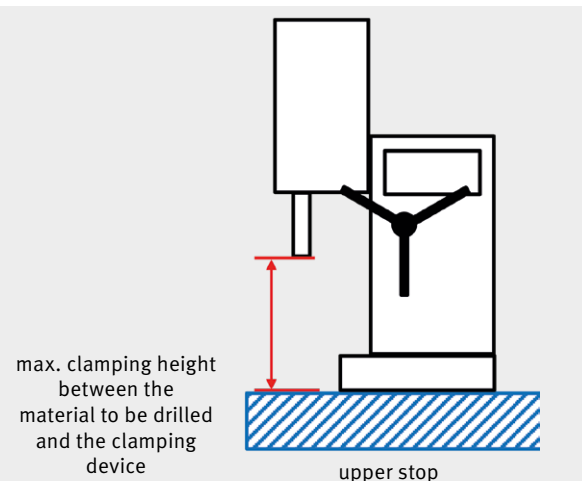
Roller conveyors

Metal-cutting band saws

Magnetic drilling machine adapters

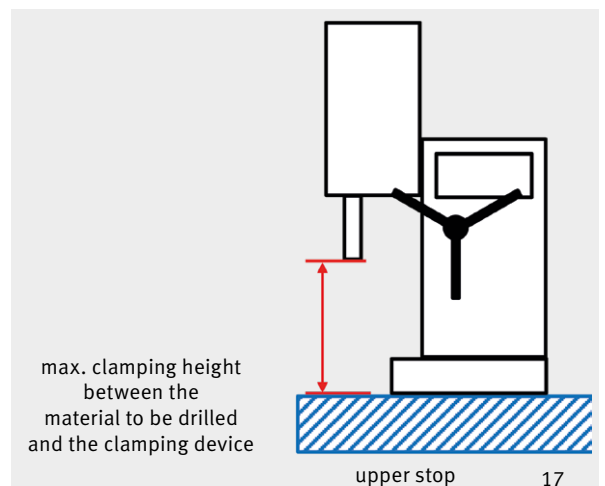
Model		MB 202 G	MB 351	MB 502
Art. no.		3862000	3860351	3860502
Accessories used		Core drill adapter (19 mm) (included with delivery)  Chuck adapter (included in scope of delivery)  Thread tapping adapter (included in scope of delivery) 	Quick-release chuck for core drill bit M 24 (Art. no.: 3877351)  Chuck 1.5 - 13 mm (Art.-No. 3876002)  Chuck adapter 1/2" x 15 OT (Art. no.: 3876001) 	Quick-release chuck for core drill bit M 24 (Art.-Nr. 3877502)  Chuck 1 - 16 mm (Art. no.: 3876005)  Chuck adapter 5/8" x 15 OT (Art. no. 3876004) 
Without adapter	Upper stop – lower stop = stroke length	205 mm – 58 mm = 147 mm	191 mm – 85 mm = 106 mm	245 mm – 120 mm = 125 mm
max. clamping height between the material to be drilled and ...	...core drill adapter (19 mm)	145 mm	–	–
	...core drill adapter (32 mm)	–	–	–
	...quick release core drill adapter (19 mm)	–	63 mm	82 mm
	...Chuck adapter (jaws retracted/extended)	120 mm / 110 mm	–	–
	...Chuck adapter 13 mm (jaws retracted/extended)	–	120 mm / 107 mm	–
	...Chuck adapter 16 mm (jaws retracted/extended)	–	–	121 mm / 105 mm
	...Thread tapping adapter	149 mm	–	–

Please note that the drilling depths can vary depending on the adapters and drill bits used!



Model		MB 502 E	MB 754	MB 1204
Art. no.		3860500	3860754	3861204
Accessories used				
		Chuck 1.5 - 13 mm (Art.-No. 3876002)	Chuck 1 - 16 mm (Art. no.: 3876005)	Chuck 1 - 16 mm (Art. no.: 3876005)
				
		Chuck adapter (Art.-No. 3876020)	Chuck adapter MK 3 (Art. no.: 3876007)	Chuck adapter MK 3 (Art. no.: 3876007)
				
			Thread tapping chuck 19 mm (Art. 3876017) 31 mm (Art. no. 3876018)	
				
			Quick change inserts M5 - M25 (Art. no. 3876009-16)	
				
	Without adapter			
	Upper stop – lower stop = stroke length	110 mm (variable drilling head adjustment)	210 mm – 55 mm = 155 mm	219 mm – 19 mm = 200 mm
max. clamping height between the material to be drilled and ...	...core drill adapter (19 mm)	–	90 mm	158 mm
	...core drill adapter (32 mm)	–	–	153 mm
	...quick release core drill adapter (19 mm)	225 mm	–	–
	...Chuck adapter (jaws retracted/extended)	–	–	–
	...Chuck adapter 13 mm (jaws retracted/extended)	160 mm / 147 mm	–	–
	...Chuck adapter 16 mm (jaws retracted/extended)	–	108 mm / 92 mm	116 mm / 102 mm
	...Thread tapping adapter	–	–	–

Please note that the drilling depths can vary depending on the adapters and drill bits used!



Magnetic drilling machines

Accessories for Metallkraft magnetic drilling machines

Accessories MB 351

Chuck adapter	
	Art. no.
Thread: 1/4" x 15 OT Shaft length: 27 mm Shank Ø 35 mm Chuck: M 24	3876001

Chuck · Including chuck key	
	Art. no.
1.5 - 13 mm	3876002

Quick-release chuck for core drill bit · Compatible with all core drill bit models in the Metallkraft main catalogue	
	Art. no.
M 24, short shank	3877351

Accessories MB 502

Chuck adapter	
	Art. no.
Thread: 5/8" x 15 OT Shaft length: 61 mm Shank Ø 35 mm Chuck: M 24	3876004

Chuck · Including chuck key	
	Art. no.
1 - 16 mm	3876005

Quick-release chuck for core drill bit · Compatible with all core drill bit models in the Metallkraft main catalogue	
	Art. no.
M 24, long shank	3877502

Accessories MB 754

Chuck adapter	
	Art. no.
MK 3	3876007

Chuck · Including chuck key	
	Art. no.
1 - 16 mm	3876005

Thread tapping chuck		
		
Morse cone	Chuck Ø	Art. no.
MK 3	19 mm	3876017
MK 3	31 mm	3876018

Accessories MB 502 E

Chuck adapter	
	Art. no.
Weldon 19 mm to 1/2" x 20 OT	3876020

Chuck · Including chuck key	
	Art. no.
1.5 - 13 mm	3876002

Quick change inserts		
		
Thread DIN376	Shank Ø	Art. no.
M5	19 mm	3876009
M6	19 mm	3876010
M8	31 mm	3876011
M10	31 mm	3876012
M12	31 mm	3876013
M16	31 mm	3876014
M20	31 mm	3876015
M25	31 mm	3876016



Core-drill set 6-part
in a practical plastic case
(Ø 12, 14, 16, 18, 20, 22 mm
Length: 25 mm)

Art no. 3873008

Now with 18 mm **BLUE-LINE** drill bit!

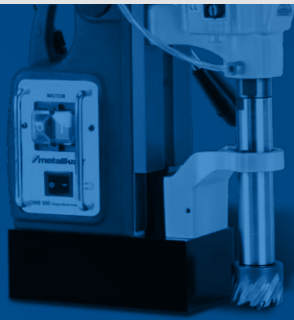


Test a core drill bit with universal chuck in our premium quality line **BLUE-LINE** with patented **Durablue coating** for extreme surface hardness and smoothness.
For maximum service life also in dry drilling.

Chipmag swarf remover

For removing magnetic metal chips
For cleaning, e.g. the core drill inside surfaces
and collecting magnetic small parts
Art no. 3850010,





Product info

Core bit qualities



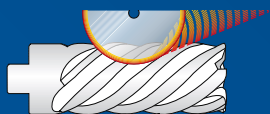
Made of high-alloyed HSS-XE special steel. For extreme hardness at the tip of the tooth (up to 68 HRC). And thus for a long service life.



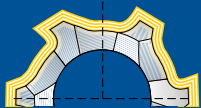
Made of ASP powder steel for drilling of difficult materials like railway tracks, stainless steels and exotic alloys. Deployable wherever maximum service life is needed.



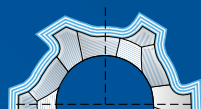
Only a few manufacturers are capable of producing hardened HSS core drills. For Karnasch this is "standard". Only this helps us produce extremely hard tooth tips (68 HRC) but with a flexible core drill.



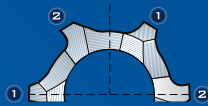
HSS-XE/ASP core drill bits ground from solid material. This finish increases the cutting ability while reducing friction at the same time. For a longer service life.



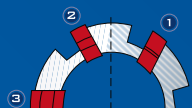
Gold-Tech surface treatment.
The special treatment for a longer service life.



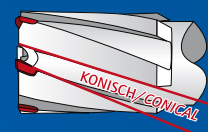
Our premium HSS-XE/ASP core drills + solid drills feature the unique and patented Durablue coating. Extreme surface hardness and smoothness guarantee an amazing service life even under less than optimum conditions like "overhead work", dry drilling, etc.



With HSS-XE/ASP core drills we are not happy with just one cutting edge geometry. Five geometries have been optimally adapted to the various diameters and cutting depths. You can always look forward to the perfect geometry.



Karnasch carbide core drills (Hard-Line) are manufactured with an elaborate pre-/intermediate-/post-cutting geometry. This results in: low-vibration, quiet and easy cutting with longest service lives.



Karnasch carbide core drills (Hard-Line) are made with a conical helix for a clean chip flow and highest cutting ability even with difficult materials.
(heavy duty cutting)



Karnasch carbide core drills (Hard-Line) are exclusively equipped with Sandvik carbide teeth.
Our opinion is: Only the best carbide is good enough for Karnasch core drills.



SILVER-LINE



GOLD-LINE



BLUE-LINE



BLUE-LINE PRO



HARD-LINE

SILVER-LINE	GOLD-LINE	BLUE-LINE	BLUE-LINE PRO	HARD-LINE
✓	✓	✓		
			✓	
✓	✓	✓	✓	
	✓	✓	✓	
	✓			
		✓	✓	
✓	✓	✓	✓	
				✓
				✓
				✓

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

Core bits

Variant	Ø	Applications
 Ø 12 - 150 mm 40, 55, 80, 110 mm Cutting depths HARD-LINE Carbide-tipped core drills The best performing core drill in our product range excellent for all steels up to 1400 N strength, and for all stainless steels.		 Steel  stainless steel  Grey cast iron  Alu  Copper, brass, Tin < 1 400 N > 900 N > 10% Si

Variant	Ø	Applications
 Ø 12 - 36 mm 30, 55 mm Cutting depths BLUE-LINE PRO Powder steel core drills with DURABLU coating. For the most difficult cutting tasks. Good for all steels up to 1 400 N strength, and for all stainless steels.		 Steel  stainless steel  Grey cast iron  Alu  Copper, brass, Tin < 1 400 N > 900 N > 10% Si

Variant	Ø	Applications
 Ø 12 - 60 mm 30, 55, 80, 110 mm Cutting depths BLUE-LINE Core drills made of HSS-XE special steel with DURABLU coating. The most popular coated core drill for all steels up to 1 100 N strength, and for all stainless steels.		 Steel  stainless steel  Grey cast iron  Alu  Copper, brass, Tin < 1 400 N > 900 N > 10% Si

Variant	Ø	Applications
 Ø 12 - 60 mm 30, 55, 80, 110 mm Cutting depths GOLD-LINE Core drills made of HSS-XE special steel with GOLD TECH treatment. The most popular non-coated core drill for all steels up to 900 N strength. Also suitable for stainless steel.		 Steel  stainless steel < 1 400 N > 900 N > 10% Si

Variant	Ø	Applications
 Ø 12 - 60 mm 25, 50 mm Cutting depths SILVER-LINE Core drills made of HSS-XE special steel with 7 different cutting geometries. For all steels up to 750 N strength.		 Steel < 750 N  Alu  Copper, brass, Tin > 10% Si

Feed mm/rev.

	Feed for HSS-XE/ASP Core drill: Silver-Line, Gold-Line, Blue-Line, Blue-Line Pro	Feed guide values for HM core drills: Hard-Line
 Steel < 500 N	0.15	0.10
 Steel < 750 N	0.18	0.10
 Steel < 900 N	0.16	0.10-0.12
 Steel < 1 200 N	0.16	0.10-0.15
 Steel < 1 400 N	0.17	0.16
 stainless steel	0.10	0.13
 Aluminium	0.25	0.24
 Grey cast iron	0.16	0.08-0.13
 Bronze	0.18	0.12
 Copper	0.21	0.12

Grey cast iron cutting cooling: dry/compressed air
Cutting oil is recommended for all other materials!

Instructions for use:

- Centre punching for core drills. For core drills with a diameter of 12-15 mm it is absolutely necessary to create a strong centre mark. Make sure that the tip of the ejector pin is positioned exactly in the middle of the centre mark. Highly recommendable also for all other diameters.
- Speeds for core drills. For HSS core bits 12 - 15 mm, a minimum speed of 450 rpm must be adhered to. For HM core bits, a minimum of approx. 600 rpm would be optimal. If this is not possible, you will need to work at half the recommended feed speed.
- Feed. Always initially drill slowly and carefully to a depth of 1 mm. You can then continue at the normal feed speed. Please take this advice to heart. It will significantly extend the drill's service life.
- Drilling. It may be necessary to repeatedly ventilate the drill depending on the chip flow. This applies in particular to cutting depths as of approx. 25 mm. If you feel more pronounced resistance or vibrations, please immediately proceed as follows:
 - Exit the borehole while drill is turning.
 - Clean the swarf off the drill and hole (e.g., with a blow-gun)
 - Fill the hole with cooling and lubricating emulsion.
 - Insert the drill into the hole again while it is rotating. Do not change the position of the machine or the workpiece during the entire process.
 - This procedure may need to be repeated depending on the chip flow and drilling depth.
- Cooling. Use only high-performance cutting oils. As of approx. 35mm Ø only use Morse taper seats with automatic internal cooling.

Speeds

Speeds for HSS-XE/ASP core drills
Silver-Line, Gold-Line, Blue-Line, Blue-Line Pro



Ø	mm Inches	12-18 7/16" - 11/16"	19-25 3/4" - 1"	26-32 1 1/16" - 1 1/4"	33-39 1 5/16" - 1 9/16"	40-46 1 5/8" - 1 13/16"	47-53 1 7/8" - 2 1/16"	54-60 2 1/8" - 2 3/8"	61-70 2 13/32" - 2 3/4"	71-80 2 51/64" - 3 5/32"	81-90 3 3/16" - 3 9/16"	91-100 3 19/32" - 3 15/16"	101-112 3 31/32" - 4 13/32"	113-124 4 15/32" - 4 7/8"	125-136 4 15/16" - 5 11/32"	137-150 5 13/32" - 5 29/32"
	Steel ◀ 500 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	Steel ◀ 750 N	530	340	245	195	160	135	115	163	87	77	68	62	55	50	45
		350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
	Steel ◀ 900 N	340	250	185	145	120	100	88	78	67	58	52	47	41	38	34
		265	190	150	125	105	90	80	68	59	53	48	42	39	35	31
	Steel ◀ 1 200 N	265	165	125	95	79	67	58	52	44	39	34	31	27	25	22
		175	130	100	80	70	60	53	45	40	35	32	28	26	23	21
	Steel ◀ 1 400 N	185	117	85	67	55	47	41	36	30	26	23	21	18	16	16
		125	90	70	57	48	42	37	31	27	24	22	19	17		14
	stainless steel	320	200	145	115	90	80	70	62	53	46	41	37	32	29	27
		210	150	120	95	85	72	63	54	47	42	38	33	30	28	25
	Aluminium	980	620	455	360	295	250	220	193	165	145	129	116	104	94	85
		655	470	370	305	255	225	195	170	150	130	117	105	95	86	78
	Grey cast iron	480	300	200	175	143	122	106	93	80	70	62	56	50	45	41
		320	230	180	147	125	108	95	81	71	63	57	51	46	42	38
	Bronze	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	Copper	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
		700	510	400	330	280	240	210	180	160	140	130	115	105	95	85

Rotational speed guide values for HM core bits
Hard-Line



Ø	mm Inches	12-18 7/16" - 11/16"	19-25 3/4" - 1"	26-32 1 1/16" - 1 1/4"	33-39 1 5/16" - 1 9/16"	40-46 1 5/8" - 1 13/16"	47-53 1 7/8" - 2 1/16"	54-60 2 1/8" - 2 3/8"	61-70 2 13/32" - 2 3/4"	71-80 2 51/64" - 3 5/32"	81-90 3 3/16" - 3 9/16"	91-100 3 19/32" - 3 15/16"	101-112 3 31/32" - 4 13/32"	113-124 4 15/32" - 4 7/8"	125-136 4 15/16" - 5 11/32"	137-150 5 13/32" - 5 29/32"
	Steel ◀ 500 N	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
		700	510	400	330	280	240	210	180	160	140	130	115	105	95	85
	Steel ◀ 750 N	980	620	450	360	295	250	220	193	165	145	129	115	104	94	85
		655	470	370	300	260	225	195	170	150	130	120	105	95	87	78
	Steel ◀ 900 N	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
	Steel ◀ 1 200 N	795	500	370	290	240	200	175	155	135	117	104	94	84	76	69
		530	380	300	245	265	180	160	135	120	105	95	85	77	70	63
	Steel ◀ 1 400 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
		440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
	stainless steel	530	340	245	195	160	135	115	103	87	77	68	62	55	56	45
		350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
	Aluminium	2390	1510	1100	870	715	610	530	470	405	355	315	283	253	229	209
		1 590	1150	895	735	625	540	480	410	360	320	285	255	230	210	190
	Grey cast iron	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
	Bronze	1325	840	615	490	400	340	295	260	225	195	174	157	140	127	116
		885	635	500	410	345	300	265	230	200	175	160	145	130	117	105
	Copper	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
		620	450	340	285	240	210	185	160	140	125	110	100	90	81	75

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

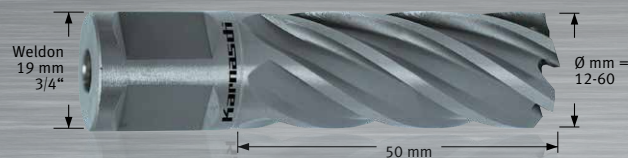
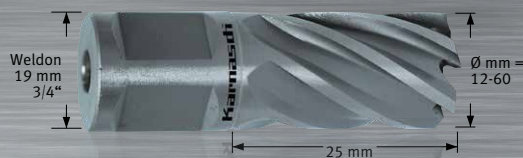
Circular saws

Roller conveyors

Metal-cutting band saws

Core bits

SILVER-
LINE



Ø mm	38720.1255		Ø mm	38720.1255	
12	38720.1255 12		37	38720.1255 37	
13	38720.1255 13		38	38720.1255 38	
14	38720.1255 14		39	38720.1255 39	
15	38720.1255 15		40	38720.1255 40	
16	38720.1255 16		41	38720.1255 41	
17	38720.1255 17		42	38720.1255 42	
18	38720.1255 18		43	38720.1255 43	
19	38720.1255 19		44	38720.1255 44	
20	38720.1255 20		45	38720.1255 45	
21	38720.1255 21		46	38720.1255 46	
22	38720.1255 22		47	38720.1255 47	
23	38720.1255 23		48	38720.1255 48	
24	38720.1255 24		49	38720.1255 49	
25	38720.1255 25		50	38720.1255 50	
26	38720.1255 26		51	38720.1255 51	
27	38720.1255 27		52	38720.1255 52	
28	38720.1255 28		53	38720.1255 53	
29	38720.1255 29		54	38720.1255 54	
30	38720.1255 30		55	38720.1255 55	
31	38720.1255 31		56	38720.1255 56	
32	38720.1255 32		57	38720.1255 57	
33	38720.1255 33		58	38720.1255 58	
34	38720.1255 34		59	38720.1255 59	
35	38720.1255 35		60	38720.1255 60	
36	38720.1255 36				

Ejector pin



38720.1261

Ø mm	38720.1265		Ø mm	38720.1265	
12	38720.1265 12		37	38720.1265 37	
13	38720.1265 13		38	38720.1265 38	
14	38720.1265 14		39	38720.1265 39	
15	38720.1265 15		40	38720.1265 40	
16	38720.1265 16		41	38720.1265 41	
17	38720.1265 17		42	38720.1265 42	
18	38720.1265 18		43	38720.1265 43	
19	38720.1265 19		44	38720.1265 44	
20	38720.1265 20		45	38720.1265 45	
21	38720.1265 21		46	38720.1265 46	
22	38720.1265 22		47	38720.1265 47	
23	38720.1265 23		48	38720.1265 48	
24	38720.1265 24		49	38720.1265 49	
25	38720.1265 25		50	38720.1265 50	
26	38720.1265 26		51	38720.1265 51	
27	38720.1265 27		52	38720.1265 52	
28	38720.1265 28		53	38720.1265 53	
29	38720.1265 29		54	38720.1265 54	
30	38720.1265 30		55	38720.1265 55	
31	38720.1265 31		56	38720.1265 56	
32	38720.1265 32		57	38720.1265 57	
33	38720.1265 33		58	38720.1265 58	
34	38720.1265 34		59	38720.1265 59	
35	38720.1265 35		60	38720.1265 60	
36	38720.1265 36				

Ejector pin



38720.1271

SILVER-LINE SET 25



Contents

Ø mm
14, 16, 18,
20, 22, 26

38720.1474

+ 2 ejector pins

SILVER-LINE SET 50



Contents

Ø mm
14, 16, 18,
20, 22, 26

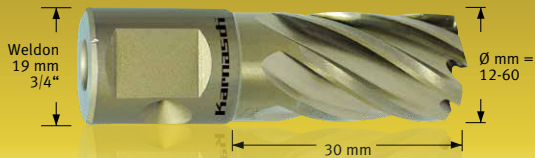
38720.1475

+ 2 ejector pins

Suitable
for core drilling
machines

Metallkraft, Alfa-Rotabest + Alfa Rota-Quick, BDS + BDS Keyless, Bektap,
Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron, Magnetor,
Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

**GOLD-
LINE**



Ø mm	38720.1260U	Ø mm	38720.1260U
12	38720.1260U 12	37	38720.1260U 37
13	38720.1260U 13	38	38720.1260U 38
14	38720.1260U 14	39	38720.1260U 39
15	38720.1260U 15	40	38720.1260U 40
16	38720.1260U 16	41	38720.1260U 41
17	38720.1260U 17	42	38720.1260U 42
18	38720.1260U 18	43	38720.1260U 43
19	38720.1260U 19	44	38720.1260U 44
20	38720.1260U 20	45	38720.1260U 45
21	38720.1260U 21	46	38720.1260U 46
22	38720.1260U 22	47	38720.1260U 47
23	38720.1260U 23	48	38720.1260U 48
24	38720.1260U 24	49	38720.1260U 49
25	38720.1260U 25	50	38720.1260U 50
26	38720.1260U 26	51	38720.1260U 51
27	38720.1260U 27	52	38720.1260U 52
28	38720.1260U 28	53	38720.1260U 53
29	38720.1260U 29	54	38720.1260U 54
30	38720.1260U 30	55	38720.1260U 55
31	38720.1260U 31	56	38720.1260U 56
32	38720.1260U 32	57	38720.1260U 57
33	38720.1260U 33	58	38720.1260U 58
34	38720.1260U 34	59	38720.1260U 59
35	38720.1260U 35	60	38720.1260U 60
36	38720.1260U 36		

Ejector pin



38720.1261

Ejector pin



38720.1271

GOLD-LINE SET 30



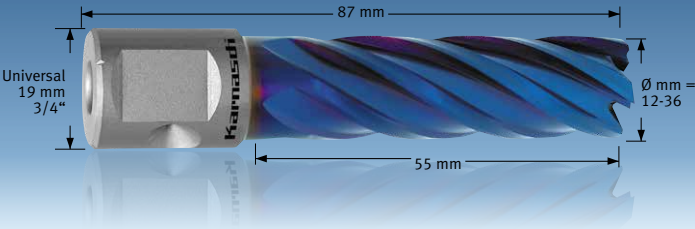
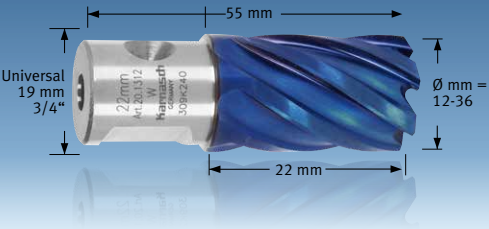
Contents	Ø mm	
	14, 16, 18, 20, 22, 26	38720.1322
+ 2 ejector pins		

GOLD-LINE SET 55



Contents	Ø mm	
	14, 16, 18, 20, 22, 26	38720.1332
+ 2 ejector pins		

Core bits



Ø mm	38720.1312		Ø mm	38720.1312	
12	38720.1312 12		37	38720.1312 37	
13	38720.1312 13		38	38720.1312 38	
14	38720.1312 14		39	38720.1312 39	
15	38720.1312 15		40	38720.1312 40	
16	38720.1312 16		41	38720.1312 41	
17	38720.1312 17		42	38720.1312 42	
18	38720.1312 18		43	38720.1312 43	
19	38720.1312 19		44	38720.1312 44	
20	38720.1312 20		45	38720.1312 45	
21	38720.1312 21		46	38720.1312 46	
22	38720.1312 22		47	38720.1312 47	
23	38720.1312 23		48	38720.1312 48	
24	38720.1312 24		49	38720.1312 49	
25	38720.1312 25		50	38720.1312 50	
26	38720.1312 26		51	38720.1312 51	
27	38720.1312 27		52	38720.1312 52	
28	38720.1312 28		53	38720.1312 53	
29	38720.1312 29		54	38720.1312 54	
30	38720.1312 30		55	38720.1312 55	
31	38720.1312 31		56	38720.1312 56	
32	38720.1312 32		57	38720.1312 57	
33	38720.1312 33		58	38720.1312 58	
34	38720.1312 34		59	38720.1312 59	
35	38720.1312 35		60	38720.1312 60	
36	38720.1312 36				

Ø mm	38720.1313		Ø mm	38720.1313	
12	38720.1313 12		37	38720.1313 37	
13	38720.1313 13		38	38720.1313 38	
14	38720.1313 14		39	38720.1313 39	
15	38720.1313 15		40	38720.1313 40	
16	38720.1313 16		41	38720.1313 41	
17	38720.1313 17		42	38720.1313 42	
18	38720.1313 18		43	38720.1313 43	
19	38720.1313 19		44	38720.1313 44	
20	38720.1313 20		45	38720.1313 45	
21	38720.1313 21		46	38720.1313 46	
22	38720.1313 22		47	38720.1313 47	
23	38720.1313 23		48	38720.1313 48	
24	38720.1313 24		49	38720.1313 49	
25	38720.1313 25		50	38720.1313 50	
26	38720.1313 26		51	38720.1313 51	
27	38720.1313 27		52	38720.1313 52	
28	38720.1313 28		53	38720.1313 53	
29	38720.1313 29		54	38720.1313 54	
30	38720.1313 30		55	38720.1313 55	
31	38720.1313 31		56	38720.1313 56	
32	38720.1313 32		57	38720.1313 57	
33	38720.1313 33		58	38720.1313 58	
34	38720.1313 34		59	38720.1313 59	
35	38720.1313 35		60	38720.1313 60	
36	38720.1313 36				

Ejector pin



38720.1261

Ejector pin



38720.1271

BLUE-LINE SET 30



Contents	Ø mm	
14, 16, 18, 20, 22, 26	38720.1325	
+ 2 ejector pins		

BLUE-LINE SET 55

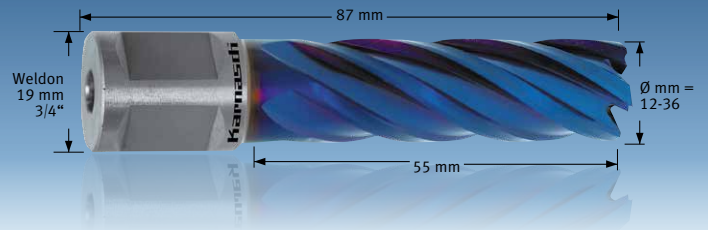
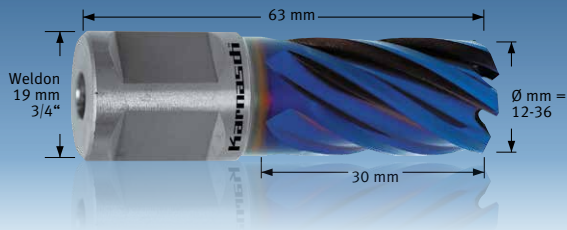


Contents	Ø mm	
14, 16, 18, 20, 22, 26	38720.1328	
+ 2 ejector pins		

Suitable
for core drilling
machines

Metallkraft, Alfa-Rotabest + Alfa Rota-Quick, BDS + BDS Keyless,
Bektop, Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron,
Magnetor, Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

**BLUE-
LINE
PRO**



Ø mm	38720.1284		Ø mm	38720.1284	
12	38720.1284 12		25	38720.1284 25	
13	38720.1284 13		26	38720.1284 26	
14	38720.1284 14		27	38720.1284 27	
15	38720.1284 15		28	38720.1284 28	
16	38720.1284 16		29	38720.1284 29	
17	38720.1284 17		30	38720.1284 30	
18	38720.1284 18		31	38720.1284 31	
19	38720.1284 19		32	38720.1284 32	
20	38720.1284 20		33	38720.1284 33	
21	38720.1284 21		34	38720.1284 34	
22	38720.1284 22		35	38720.1284 35	
23	38720.1284 23		36	38720.1284 36	
24	38720.1284 24				

Ø mm	38720.1317		Ø mm	38720.1317	
12	38720.1317 12		25	38720.1317 25	
13	38720.1317 13		26	38720.1317 26	
14	38720.1317 14		27	38720.1317 27	
15	38720.1317 15		28	38720.1317 28	
16	38720.1317 16		29	38720.1317 29	
17	38720.1317 17		30	38720.1317 30	
18	38720.1317 18		31	38720.1317 31	
19	38720.1317 19		32	38720.1317 32	
20	38720.1317 20		33	38720.1317 33	
21	38720.1317 21		34	38720.1317 34	
22	38720.1317 22		35	38720.1317 35	
23	38720.1317 23		36	38720.1317 36	
24	38720.1317 24				

Ejector pin



38720.1261

Ejector pin



38720.1271

BLUE-LINE PRO SET 30



Contents	Ø mm	
	14, 16, 18, 20, 22, 26	38720.1331
+ 2 ejector pins		

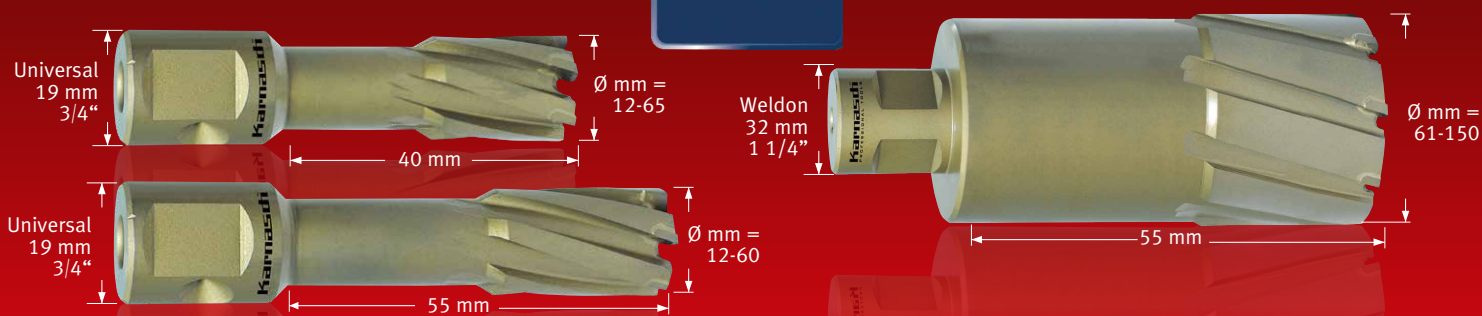
BLUE-LINE PRO SET 55



Contents	Ø mm	
	14, 16, 18, 20, 22, 26	38720.1334
+ 2 ejector pins		

Core bits

**HARD-
LINE**



Ø mm	38720.1315	Ø mm	38720.1315	Ø mm	38720.1315
12	38720.1315 12	38	38720.1315 38	64	38720.1315 64
13	38720.1315 13	39	38720.1315 39	65	38720.1315 65
14	38720.1315 14	40	38720.1315 40	66*	38720.1315 66
15	38720.1315 15	41	38720.1315 41	67*	38720.1315 67
16	38720.1315 16	42	38720.1315 42	68*	38720.1315 68
17	38720.1315 17	43	38720.1315 43	69*	38720.1315 69
18	38720.1315 18	44	38720.1315 44	70*	38720.1315 70
19	38720.1315 19	45	38720.1315 45	71*	38720.1315 71
20	38720.1315 20	46	38720.1315 46	72*	38720.1315 72
21	38720.1315 21	47	38720.1315 47	73*	38720.1315 73
22	38720.1315 22	48	38720.1315 48	74*	38720.1315 74
23	38720.1315 23	49	38720.1315 49	75*	38720.1315 75
24	38720.1315 24	50	38720.1315 50	76*	38720.1315 76
25	38720.1315 25	51	38720.1315 51	77*	38720.1315 77
26	38720.1315 26	52	38720.1315 52	78*	38720.1315 78
27	38720.1315 27	53	38720.1315 53	79*	38720.1315 79
28	38720.1315 28	54	38720.1315 54	80*	38720.1315 80
29	38720.1315 29	55	38720.1315 55	85*	38720.1315 85
30	38720.1315 30	56	38720.1315 56	90*	38720.1315 90
31	38720.1315 31	57	38720.1315 57	95*	38720.1315 95
32	38720.1315 32	58	38720.1315 58	100*	38720.1315 100
33	38720.1315 33	59	38720.1315 59	105*	38720.1315 105
34	38720.1315 34	60	38720.1315 60	110*	38720.1315 110
35	38720.1315 35	61	38720.1315 61	115*	38720.1315 115
36	38720.1315 36	62	38720.1315 62	120*	38720.1315 120
37	38720.1315 37	63	38720.1315 63		

* as of Ø 66 mm the Weldon 32 mm seat is required

Ø mm	38720.1316	Ø mm	38720.1316	Ø mm	38720.1316
12	38720.1316 12	41	38720.1316 41	74	38720.1316 74
13	38720.1316 13	42	38720.1316 42	75	38720.1316 75
14	38720.1316 14	43	38720.1316 43	76	38720.1316 76
15	38720.1316 15	44	38720.1316 44	77	38720.1316 77
16	38720.1316 16	45	38720.1316 45	78	38720.1316 78
17	38720.1316 17	46	38720.1316 46	79	38720.1316 79
17.5	38720.1316 17,5	47	38720.1316 47	80	38720.1316 80
18	38720.1316 18	48	38720.1316 48	82	38720.1316 82
19	38720.1316 19	49	38720.1316 49	83	38720.1316 83
20	38720.1316 20	50	38720.1316 50	84	38720.1316 84
21	38720.1316 21	51	38720.1316 51	85	38720.1316 85
21.5	38720.1316 21,5	52	38720.1316 52	88	38720.1316 88
22	38720.1316 22	53	38720.1316 53	90	38720.1316 90
23	38720.1316 23	54	38720.1316 54	92	38720.1316 92
23.5	38720.1316 23,5	55	38720.1316 55	95	38720.1316 95
24	38720.1316 24	56	38720.1316 56	100	38720.1316 100
25	38720.1316 25	57	38720.1316 57	103	38720.1316 103
25.5	38720.1316 25,5	58	38720.1316 58	104	38720.1316 104
26	38720.1316 26	59	38720.1316 59	105	38720.1316 105
27	38720.1316 27	60	38720.1316 60	106	38720.1316 106
28	38720.1316 28	61	38720.1316 61	108	38720.1316 108
29	38720.1316 29	62	38720.1316 62	110	38720.1316 110
30	38720.1316 30	63	38720.1316 63	115	38720.1316 115
31	38720.1316 31	64	38720.1316 64	120	38720.1316 120
32	38720.1316 32	65	38720.1316 65	125	38720.1316 125
33	38720.1316 33	66	38720.1316 66	130	38720.1316 130
34	38720.1316 34	67	38720.1316 67	135	38720.1316 135
35	38720.1316 35	68	38720.1316 68	140	38720.1316 140
36	38720.1316 36	69	38720.1316 69	145	38720.1316 145
37	38720.1316 37	70	38720.1316 70	150	38720.1316 150
38	38720.1316 38	71	38720.1316 71		
39	38720.1316 39	72	38720.1316 72		
40	38720.1316 40	73	38720.1316 73		

Ejector pin

Ø 12-17 mm	38720.1149
Ø 18-65 mm	38720.1151
Ø 66-120 mm	38720.1273

Ejector pin

Ø 12-17 mm	38720.1271
Ø 18-60 mm	38720.1273
Ø 61-150 mm	38720.1272

HARD-LINE SET 40

Contents	Ø mm 14, 16, 18, 20, 22, 26	38720.1336
+ 2 ejector pins		

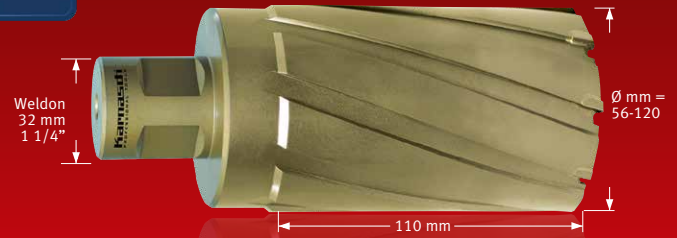
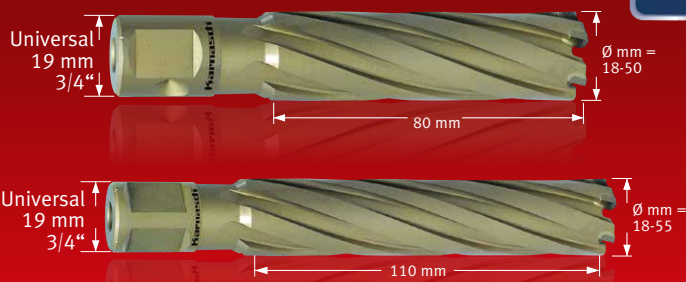
HARD-LINE SET 55

Contents	Ø mm 14, 16, 18, 20, 22, 26	38720.1339
+ 2 ejector pins		

**Suitable
for core drilling
machines**

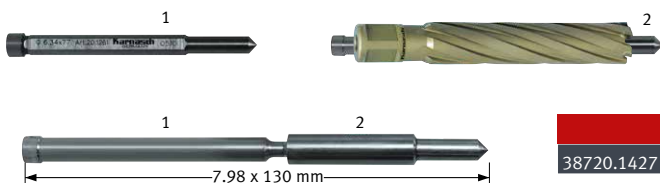
Metallkraft, Alfa-Rotabest + Alfa Rota-Quick, BDS + BDS Keyless, Bektap, Bux, Euroboor, Evolution, Hougen, Jancy, Magbroach, Magtron, Magnetor, Promag, Rotabroach, Ruko + Ruko Easy Lock, Universal...

HARD- LINE



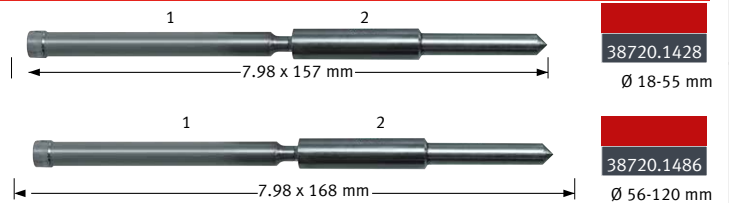
Ø mm	38720.1650	Ø mm	38720.1650	Ø mm	38720.1650	Ø mm	38720.1660	Ø mm	38720.1660	Ø mm	38720.1660
18	38720.1650 18	43	38720.1650 43	68	38720.1650 68	18	38720.1660 18	43	38720.1660 43	68	38720.1660 68
19	38720.1650 19	44	38720.1650 44	69	38720.1650 69	19	38720.1660 19	44	38720.1660 44	69	38720.1660 69
20	38720.1650 20	45	38720.1650 45	70	38720.1650 70	20	38720.1660 20	45	38720.1660 45	70	38720.1660 70
21	38720.1650 21	46	38720.1650 46	72	38720.1650 72	21	38720.1660 21	46	38720.1660 46	72	38720.1660 72
22	38720.1650 22	47	38720.1650 47	73	38720.1650 73	22	38720.1660 22	47	38720.1660 47	73	38720.1660 73
23	38720.1650 23	48	38720.1650 48	74	38720.1650 74	23	38720.1660 23	48	38720.1660 48	74	38720.1660 74
24	38720.1650 24	49	38720.1650 49	75	38720.1650 75	24	38720.1660 24	49	38720.1660 49	75	38720.1660 75
25	38720.1650 25	50	38720.1650 50	76	38720.1650 76	25	38720.1660 25	50	38720.1660 50	76	38720.1660 76
26	38720.1650 26	51	38720.1650 51	78	38720.1650 78	26	38720.1660 26	51	38720.1660 51	78	38720.1660 78
27	38720.1650 27	52	38720.1650 52	80	38720.1650 80	27	38720.1660 27	52	38720.1660 52	80	38720.1660 80
28	38720.1650 28	53	38720.1650 53	82	38720.1650 82	28	38720.1660 28	53	38720.1660 53	82	38720.1660 82
29	38720.1650 29	54	38720.1650 54	85	38720.1650 85	29	38720.1660 29	54	38720.1660 54	85	38720.1660 85
30	38720.1650 30	55	38720.1650 55	90	38720.1650 90	30	38720.1660 30	55	38720.1660 55	90	38720.1660 90
31	38720.1650 31	56	38720.1650 56	95	38720.1650 95	31	38720.1660 31	56	38720.1660 56	95	38720.1660 95
32	38720.1650 32	57	38720.1650 57	100	38720.1650 100	32	38720.1660 32	57	38720.1660 57	100	38720.1660 100
33	38720.1650 33	58	38720.1650 58	103	38720.1650 103	33	38720.1660 33	58	38720.1660 58	103	38720.1660 103
34	38720.1650 34	59	38720.1650 59	104	38720.1650 104	34	38720.1660 34	59	38720.1660 59	104	38720.1660 104
35	38720.1650 35	60	38720.1650 60	105	38720.1650 105	35	38720.1660 35	60	38720.1660 60	105	38720.1660 105
36	38720.1650 36	61	38720.1650 61	106	38720.1650 106	36	38720.1660 36	61	38720.1660 61	106	38720.1660 106
37	38720.1650 37	62	38720.1650 62	108	38720.1650 108	37	38720.1660 37	62	38720.1660 62	108	38720.1660 108
38	38720.1650 38	63	38720.1650 63	110	38720.1650 110	38	38720.1660 38	63	38720.1660 63	110	38720.1660 110
39	38720.1650 39	64	38720.1650 64	115	38720.1650 115	39	38720.1660 39	64	38720.1660 64	115	38720.1660 115
40	38720.1650 40	65	38720.1650 65	120	38720.1650 120	40	38720.1660 40	65	38720.1660 65	120	38720.1660 120
41	38720.1650 41	66	38720.1650 66			41	38720.1660 41	66	38720.1660 66		
42	38720.1650 42	67	38720.1650 67			42	38720.1660 42	67	38720.1660 67		

Ejector pin, 2-piece



APPLICATION
Insert part 1 into the core drill shank.
Push part 2 onto part 1. Drill to a cutting depth of approx. 50 mm. Then remove part 2 and continue drilling.

Ejector pin, 2-piece



APPLICATION
Insert part 1 into the core drill shank.
Push part 2 onto part 1. Drill to a cutting depth of approx. 50 mm. Then remove part 2 and continue drilling.

Ejector pin, 1-piece



This one-piece ejector pin can be used in combination with adapter seat Art no. 38720.1291. Drilling depths up to 110 mm in a single work step without changing. Robust and simple.

Ejector pin



This one-piece ejector pin can be used in combination with adapter seat Art no. 38720.1291. Drilling depths up to 110 mm in a single work step without changing. Robust and simple.

Seat holders core bits/lubricants

Seat holder

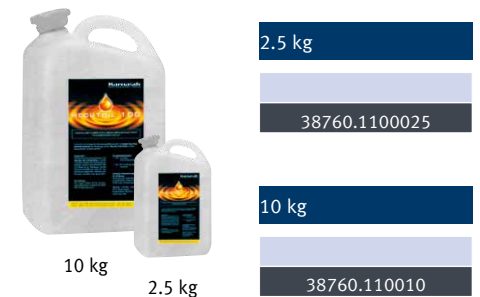


Quick-Change seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

Seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").

Lubricants + cutting oil

Heavy-duty cutting oil "MECUTOIL 100". For mixing with water 5% oil = for normal construction steels as well as all NF metals, 10 % oil = for steels of higher strength, incl. stainless steels. For difficult machining problems up to 50 % oil can be admixed with water. Ideal oil for any machining work. For filling, e.g., into Karnasch cooling pressure cylinders



Heavy-duty cutting spray "MECUTSPRAY". Propellant-free thanks to manual pump mechanism. Content 500 ml. The ideal spray for machining work on all steel grades and non-ferrous metals. Bio-degradable as per CC-L-33-T82.



Universal cutting paste. Paste clings on the tool. Ideal for work under difficult conditions, e.g., overhead work. For machining work with various steel grades and non-ferrous metals. Free from chlorine.



Special cutting wax: Especially for non-ferrous metals like aluminium, copper, brass. Wax sticks to the tool, making it ideal for, e.g., overhead work. Free from chlorine.



MORSE-KONUS 2 Morse taper 2

Core drill change within seconds without any tools



MORSE-KONUS 3 Morse taper 3

Core drill change within seconds without any tools



Quick-Change seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4") core bits.

Seat holder **with** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 32 mm (1 1/4").

MORSE-KONUS 2 Morse taper 2

Core drill change within seconds without any tools



MORSE-KONUS 3 Morse taper 3

Core drill change within seconds without any tools



MORSE-KONUS 3 Morse taper 3

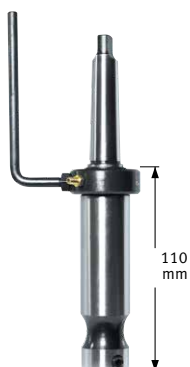


MORSE-KONUS 4 Morse taper 4



MORSE-KONUS 3 Morse taper 3

Extra long seat holder with automatic coolant supply especially for all extra long core drills such as the following series: Gold-Line 80+110, Blue-Line 80+110, Hard-Line 80+110 with universal shank 19 mm (3/4"). With this seat holder you don't need to change the two-piece ejector pins. You can drill as deep as 110 mm in a single work step.



Seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 19 mm (3/4").



Seat holder **without** automatic internal cooling. Suitable for all core drills with Weldon shank/universal shank 32 mm (1 1/4").

