

# ALZMETALL

we drive productivity

## CLASSIC DRILLING MACHINES

### CATALOG No. 71 valid from 01.01.2024



## ABOUT ALZMETALL



ALZMETALL Germany



ALZMETALL Machine Tools (Taicang, China)

**ALZMETALL** is a company with international reputation and worldwide activities. We have been the leader in the technology of drilling, milling and casting for more than seven decades. Our products have proven themselves a thousandfold in the general machine construction sector, in the aerospace industry, the automotive industry, in tooling and mold making as well as in the broad scene of medium-sized manufacturing companies.

We rely on the experience of more than 230,000 machines delivered. We focus on Precision, Performance and Quality of all of our products.

With our proper in-house ALZMETALL foundry, we process grey-cast iron and spheroidal greycast iron, not only for our own machines but also for machine tool builders in Germany and abroad.

In our open company culture, that drives innovation and results, we will always use cutting-edge technology as an added economic value for our customers.

With the development of the GS series we created and developed highly dynamic and extremely rigid machining centers according to our motto „**We drive productivity**“.

Since 2016 you will also find ALZMETALL as a sales and service company in China.

ALZMETALL Machine Tools (Taicang) Co., Ltd.  
Dong Ting Building, Room 1612,  
No 319, Middle Zheng He Road,  
215400 Taicang, Jiangsu Province

## MACHINING CENTERS

ALZMETALL develops and manufactures CNC machining centres for 3-and 5-axis applications with torque-drive technology enabling 5-axis simultaneous machining.



## DRILLING MACHINES

ALZMETALL is the market leader for drilling machines. This leading position has grown continuously since 1947, when the company began developing, producing and distributing industrial drilling machines in mass production, two years after it was founded. Particularly impressive is the large number of drilling machines that have been manufactured. Totalling over 210.000, they convince worldwide with their performance capabilities and leading technology.



*Flexible production cell with pallet changer stations. In our production we are using machining centres from ALZMETALL.*



## WHAT MAKES ALZMETALL DRILLING MACHINES STAND OUT?



### Advantage for our customers

- ★ Extensive know-how in the field of casting technologies, derived from our own foundry, enables the unique column diameter design of our drilling machines (photo).
  - » Minimum opening bounce on the impact of drilling forces
  - » Verticality of the tool axis remains within approved DIN values
- ★ The unique mechanical connection of the drilling machine-head and the column guarantees the right angularity to the drilling table to the highest quality.
- ★ Continuous innovation and design transfer as a manufacturer of machining centers and special drilling and milling machines guarantees the most advanced drilling machines worldwide.

## The standard in drilling includes:

- ★ **Stepless Spindle Speed Setting**
- ★ **Digital Spindle Speed Display**
- ★ **24 months Warranty**
- ★ **Exclusive Design**
- ★ **Spindle protection – electrically secured**



ALZMETALL applies the new European Directive for machinery 2006/42 / EC in force, since the beginning of 2009.



All photos with options

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### TRAINING OPTIONS

### NEW IN THE RANGE

#### ALZSTAR

The **START-UP-Range** for reduced budgets

#### AX

**TOP-QUALITY** drilling with complete options

#### AB

**TRENDSETTERS** for high performance drilling. Unmatched and highly precise

#### ALZFLOW AB-FLOW

**ALZFLOW, AB-FLOW,** flowdrilling, chipless drilling

#### RADIAL

**RADIAL** for large and heavy parts

#### RFT

**2-6 PRESETTED DRILLING STATIONS**

Accessories

Special equipment

<b>Training with ALZMETALL - Machines</b> Examples of options	Automatic drill depth control, combination table, precision depth adjuster and fixed stop, belt technology, coolant device A, tapping, training contents	Page 6/7
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(Sliding) cross tables, vices, drill chucks, adapters, ejectors, reducers		Page 36/37
for all drilling machines: foot switches, machine tables, special lacquer etc./configuration help		Page 38

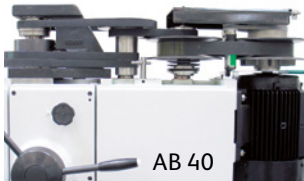
## OPTIONS



### Tapping device

The tapping device upgrades these machines to a versatile and thus more economical application.

The attachment enables the rotation direction of the drilling spindle to be altered from clockwise to anticlockwise – at any drilling depth setting – and changes back to clockwise rotation automatically at the spindle starting position. The thread depth can be controlled either by using the depth stop or the pedal switch (shown).



### Belt technology

Stepless RPM speed setting through mechanical variators is a standard in ALZMETALL drilling machines. This photo is showing the AB 40/SV, n=70-4000 mechanical variator in combination with a two-step belt gear box (powerful low Rpm speeds and high speeds. Upto 4000 rpm)



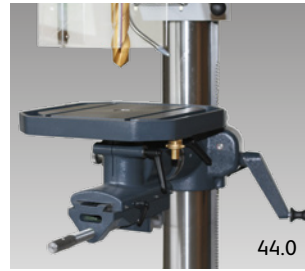
### Coolant supply-system A

The coolant supply-system A is integrated in the base of the drill press and fitted with coolant pump and motor overload protection switch, valves and fittings. (Not for HST versions)



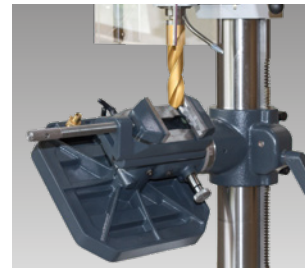
### Coolant supply-system B

The coolant supply-system attachment type B consists of a separate plastic container with capacity of 33 liters, supplied completely with motor overload protection switch and valves and fittings.



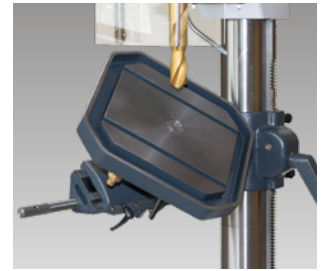
### Combined drilling table

The combined drilling table is particularly suitable for machining components, that need to be drilled at various angles.



### Micro drilling depth setting and fixed stop

The micro drilling depth setting provides quick and accurate drilling depth adjustments and/or drilling depth corrections.



### LED lamp

We recommend this device for safe and more pleasant work.



### Automated drill depth program

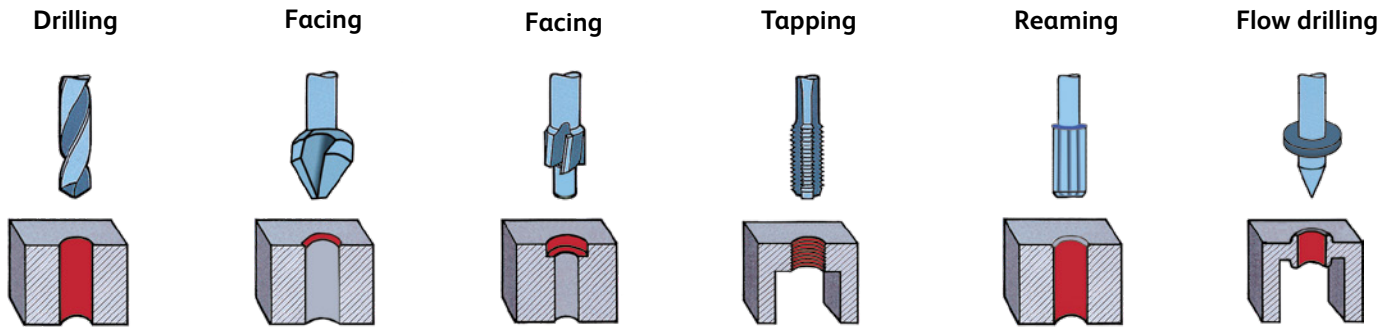
Easy and quick to enter

1. Digital depth read-out
2. Spindle start position/workpiece zero
3. Chip breaking interval
4. Final depth, total depth
5. Dwell time (Free cutting)
6. Zero point setting button
7. Function setting
8. Potentiometer/wheel
9. Digital speed display

Any prices are not applying to retrofit orders (accessories, options, spare/wear parts) or any assembly/modification works.

## TRAINING WITH ALZMETALL-MACHINES – INVESTMENTS IN YOUR FUTURE

### TRAINING CONTENTS



### Apprenticeships

- Industrial mechanics
- Foundry mechanics
- Machining mechanics
- Mechatronics

### Work techniques

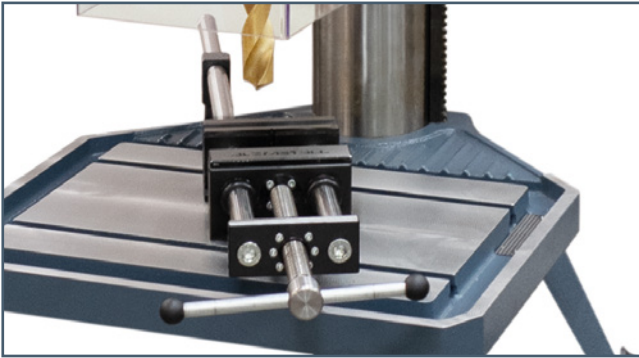
- Preparing a workpiece (marking out/centrepunching)
- Clamping a workpiece
- Setting a drilling machine (cutting parameters, clamp)
- Inspect personal protection
- Inspect machine protection
- Work sequence – machining method
- Test – measure – control

### Work safety

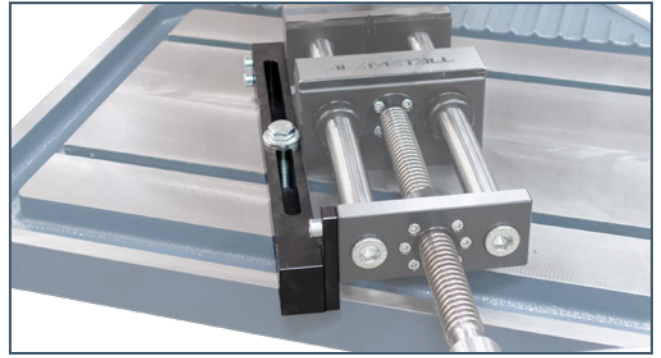
- Competent safety advices
- Specific safety systems (example: ROOM-EMERGENCY-OFF system)
- Spindle protection
- EMERGENCY-OFF switches
- Safety-checked auxiliary devices (drill chucks, vices)
- High quality manuals and documentations



## NEW IN THE RANGE – DRILLING MACHINE VICE ALZ 120/220



Basic version



with clamping bar for fixation

### Technical characteristics

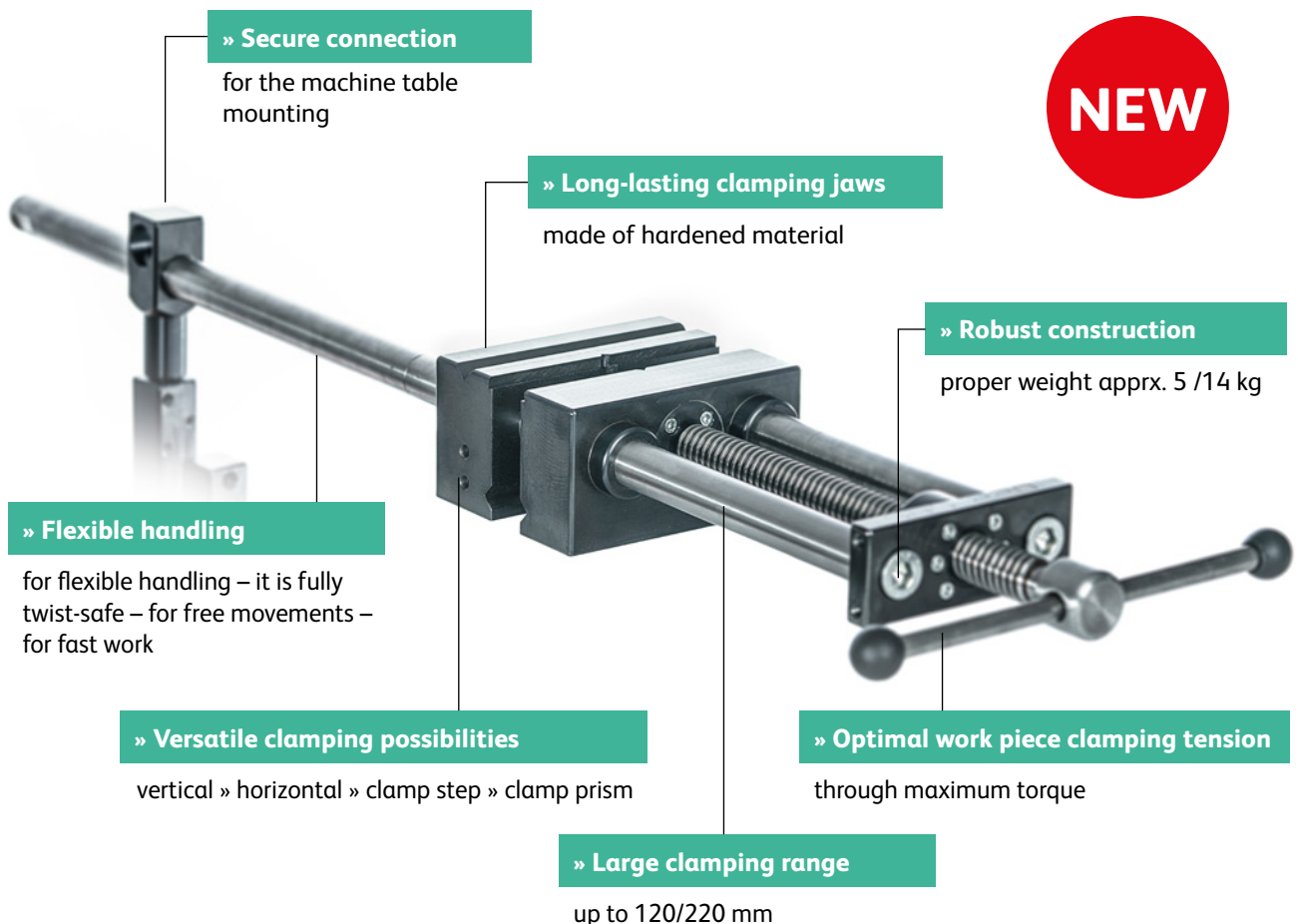
- Robust construction
- Simple installation
- Secure mounting
- Guide rod and clamp holder included
- Flexible handling – fully twist-safe – free moving - fast work piece positioning
- Wide clamping range
- Optimal work piece clamping
- Versatile clamping possibilities – vertical – horizontal – clamp step – clamp prism
- Long-lasting clamping jaws
- Option: clamping bar for fixation to the table

### Technical details

- Clamping width up to 120/220 mm
- Jaw width 100/150 mm
- Hardened jaws
- Approximate weight 5/14 kg



The ALZ 220 is suitable for all machines with a column diameter **starting** 115 mm.  
The ALZ 120 is suitable for all machines starting ALZTRONIC i14





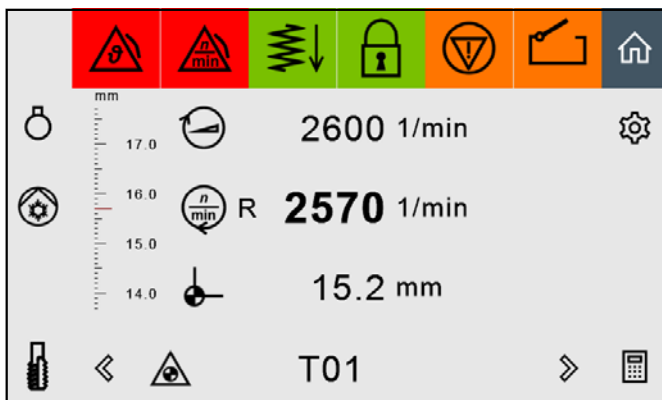
## iTRONIC DRILLING MACHINES WITH TFT - LCD-DISPLAY WITH TOUCH FUNCTION

A separate iTRONIC - catalog 70i is available!

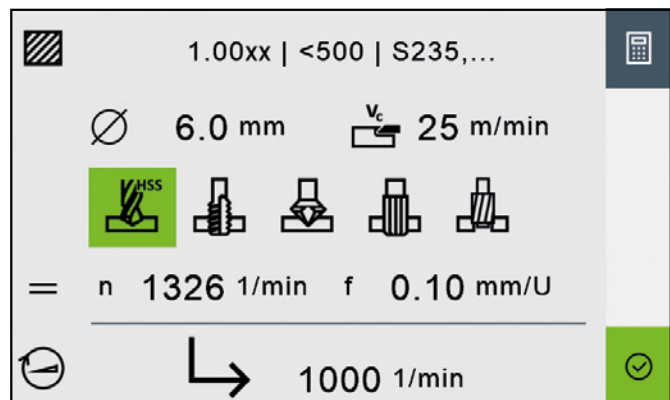


### Added value with new iTRONIC Drilling Machines, STANDARDS INCLUDED

- Multi-Touch Display 5" or 7" with scratch-resistant glass
- Clear digits and good readability
- Simple and uniform menu navigation with pictograms
- Manual setting of the RPM value – nominal value
- RPM read out – actual value
- Drill depth read out with zero-setting (drill start)
- Virtual depth scale with synchron zero-setting
- Status indicators and warnings (safety)
- Main switch, lockable
- Right and left turn under protective control
- Control tension 24 V
- Service informations
- Language switch: DE/EN/FR/ES/IT/NL/RU
- Spindle brake function – only with ALZTRONIC (safety)
- Automatic RPM control with AB 40 iTRONIC and AB-FLOW 40 iTRONIC
- Adjustable Display-Timeout



Main screen



Technology calculator [option]

### Added value with options

- Technology calculator in the display – The technology calculator is guiding operators through their machining task. Calculation of RPM speeds and advance speeds.
  - + Input of the tool diameter, cutting speed  $V_c = \text{m/min}$   
**PLUS**  
Selection of the machining process  
Drill – Tap – Countersink – Counterbore – Ream  
**OR**
  - + Input of the tool diameter, selection of a material from a list  
**PLUS**
  - + Selection of the machining process  
Drill – Tap – Countersink – Counterbore – Ream
- The resulting RPM speed may be visualized in the main screen as a nominal value
- Maximum depth gauging control of the actual drill or counterbore depth
- Automatic drill depth control with programming functions (AB machines)
- LED light with switch functions
- Coolant device with switch functions
- Energy savings with automatic switch functions for light and coolant device [ALZSTAR, AX, AB iTRONIC]
- Foot switch and comfortable cross-lever switch for tapping devices (cross-lever switch only with AB machines)
- Automatic spindle stop
- Parts counter and Spindle total runtime

## BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 18 mm

Photo with options



	Bench drilling machine <b>ALZSTAR 18-T/S</b>
<b>Drilling capacity steel E 335 (St 60)</b>	18 mm
<b>Tapping performance steel E 335 (St 60)</b>	M 12
<b>Tapping performance cast iron EN-GJL-200 (GG 20)</b>	M 14
Short spindle	MT 2
Z-travel of spindle	80 mm
Distance spindle to column	190 mm
Column diameter	65 mm
Table clamping area (width x depth)	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm
Distance spindle/table min./max.	75/357 mm
Table height adjustment	Crank
Base plate, clamping area (width x depth)	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm
Distance spindle / base plate min. / max.	437/437 mm
Feed	manual
Height of the machine without options approx.	840 mm
Net weight approx.	110 kg
<b>Drive System</b>	infinitely variable
<b>Motor:</b> n = 750 / 1500 rpm	<b>0,37 / 0,55 kW</b>
Spindle Rpm range	225-4300 rpm
<b>Price of the machine without options</b>	<b>3.182,00 €</b>

### Standard Equipment

**Main switch** with Overload Protection Switch lockable  
**Reverse switch** for tapping  
**Infinitely variable speed drive**, mechanical variator  
**Protection class IP 54**  
**Cable** w/o plug, 2 m

**Motor Isolation Class „F“ (155°)**  
**Self-Locking Mushroom Button** for Emergency-Off  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.

### OPTIONS

<b>09.</b>	<b>Table/Bench</b> , W x D x H 700 x 600 x 840 mm, Net weight approx. 48 kg, weight net. approx. 16 kg	<b>1.038,00 €</b>
<b>12</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>410,00 €</b>
<b>08</b>	<b>Packaging</b> , disposable L x W x H ca. 800 x 600 x 1050 mm, packing weight approx. 10 kg	<b>35,00 €</b>
<b>08.1</b>	<b>Packaging for the Table/Bench 09</b>	<b>49,00 €</b>

## BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 23 mm

Photo with options



	Bench drilling machine ALZSTAR 23-T/S
Drilling capacity steel E 335 (St 60)	23 mm
Tapping performance steel E 335 (St 60)	M 14
Tapping performance cast iron EN-GJL-200 (GG 20)	M 16
Short spindle	MT 2
Z-travel of spindle	100 mm
Distance spindle to column	250 mm
Column diameter	90 mm
Table clamping area (width x depth)	370 x 300 mm
T-Slots, number x width x distance	2 x 14 x 160 mm
Distance Spindle-Machine table (intermediate) min.max.	125 / 455 mm
Table height adjustment	Manual with crank
Base plate, clamping area (width x depth)	320 x 250 mm
T-Slots, number x width x distance	2 x 14 x 160 mm
Distance spindle / base plate min. /max.	625/625 mm
Feed	manual
Height of the machine without options approx.	1095 mm
Net weight approx.	155 kg
<b>Drive System</b>	infinitely variable
<b>Motor:</b> n = 750 / 1500 rpm	<b>0,6 / 0,95 kW</b>
Spindle Rpm range	225-4300 rpm
<b>Price of the machine without options</b>	<b>5.699,00 €</b>

### Standard Equipment

**Main switch** lockable  
**Self-Locking Mushroom Button** for Emergency-Off  
**Reverse switch** for tapping  
**Overload Protection Switch**  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Motor Isolation Class „F“ (155°)**  
**Protection class IP 54**  
**Cable** w/o plug, 2 m  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.

### OPTIONS

09.1	<b>Table/Bench</b> , L x W x H 750 x 700 x 840 mm (Net weight approx. 66 kg), package weight net. approx. 16 kg	<b>1.218,00 €</b>
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>410,00 €</b>
25.	<b>Coolant Attachment B</b> , separate container (33 l), with overload-protected pump, check valve and accessories	<b>532,00 €</b>
08.	<b>Packaging</b> , disposable L x W x H 1100 x 800 x 1400 mm, weight net. approx. 45 kg	<b>61,00 €</b>
08.1	<b>Packaging table 09.1</b>	<b>49,00 €</b>

## COLUMN DRILLING MACHINES

Drilling capacity 23/30 mm

Photo with options



	Column Drilling Machine <b>ALZSTAR 23/S</b>	Column Drilling Machine <b>ALZSTAR 30/S</b>
<b>Drilling capacity steel E 335 (St 60)</b>	23 mm	30 mm
<b>Tapping performance steel E 335 (St 60)</b>	M 14	M 16
<b>Tapping performance Cast iron EN-GJL-200 (GG 20)</b>	M 16	M 20
<b>Short spindle</b>	MT 2	MT 3
<b>Z-travel of spindle</b>	100 mm	140 mm
<b>Distance spindle to column</b>	250 mm	293 mm
<b>Column diameter</b>	90 mm	115 mm
<b>Table clamping area (width x depth)</b>	370 x 300 mm	514 x 360 mm
<b>T-Slots, number x width x distance</b>	2 x 14 x 160 mm	2 x 14 x 224 mm
<b>Distance spindle/table min./max.</b>	140/670 mm	132/724 mm
<b>Feed</b>	manual	manual
<b>Height of the machine without options approx.</b>	1770 mm	1790 mm
<b>Net weight approx.</b>	175 kg	260 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor: n = 750 / 1500 rpm</b>	<b>0,6 / 0,95 kW</b>	<b>1,0 / 1,6 kW</b>
<b>Spindle Rpm range</b>	225-4300 rpm	225-4300 rpm
<b>Price of the machine without options</b>	<b>5.917,00 €</b>	<b>6.855,00 €</b>
<b>Motor: n = 750 / 1500 rpm</b>	-	<b>1,0/1,6 kW</b>
<b>Spindle Rpm range</b>	-	100-1800 rpm
<b>Price of the machine without options</b>	-	<b>7.123,00 €</b>

### Standard Equipment

**Main switch** lockable  
**Self-Locking Mushroom Button** for Emergency-Off  
**Reverse switch** for tapping  
**Overload Protection Switch**  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Motor Isolation Class „F“ (155°)**  
**Protection class IP 54**  
**Cable w/o plug**, 2 m  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.

### OPTIONS

<b>12.</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>410,00 €</b>
<b>25.</b>	<b>Coolant Attachment B</b> , separate container (33 l), with overload-protected pump, check valve and accessories	<b>532,00 €</b>
<b>03.</b>	<b>Anchoring set</b>	<b>234,00 €</b>
<b>08.</b>	<b>Packaging</b> disposable, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg	<b>126,00 €</b>

## COLUMN DRILLING MACHINES

Drilling capacity 40 mm

Photo with options



	Column Drilling Machine ALZSTAR 40/S	Column Drilling Machine ALZSTAR 40/SV
Drilling capacity steel E 335 (St 60)	40 mm	40 mm
Tapping performance steel E 335 (St 60)	M 24	M 24
Tapping performance Cast iron EN-GJL-200 (GG 20)	M 30	M 30
Short spindle	MT 3	MT3
Z-travel of spindle	120 mm	120 mm
Distance spindle to column	293 mm	293 mm
Column diameter	115 mm	115 mm
Table clamping area (width x depth)	514 x 360 mm	514 x 360 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	117/701 mm	117/701 mm
Feed	manual	0,10 + 0,20 mm/Rot.
Height of the machine without options approx.	1840 mm	1840 mm
Net weight approx.	270 kg	285 kg
Drive System	infinitely variable	infinitely variable
Motor: n = 1500 / 3000 rpm	1,45 / 1,9 kW	1,45 / 1,9 kW
Spindle Rpm range	160-2250 rpm	160-2250 rpm
Price of the machine without options	7.524,00 €	8.479,00 €

## Standard Equipment

**Main switch** lockable  
**Self-Locking Mushroom Button** for Emergency-Off  
**Reverse switch** for tapping  
**Overload Protection Switch**  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Feed overload clutch** (ALZSTAR 40/SV)

**Motor Isolation Class „F“** (155°)  
**Protection class IP 54**  
**Cable w/o plug**, 2 m  
**Spindle protection** electrically secured  
**Lacquer**: DD-structured signal white RAL 9003, PANTONE 7545c, black.  
**Machine oil** (ALZSTAR 40/SV)

## OPTIONS

12.	LED machine light, adjustable angle, 230 V, IP 65	410,00 €
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, check valve and accessories	532,00 €
47.1.2	Short spindle MT4	386,00 €
03.	Anchoring set	234,00 €
08.	Disposable packaging, L x B x H 1200 x 800 x 2100 mm. net weight approx. 75 kg	126,00 €

## BENCH AND COLUMN DRILLING MACHINES

Drilling capacity 23 mm

Photo with options



	Bench drilling machine <b>AX 2-T/S</b>	Column drilling machine <b>AX 2/S</b>
<b>Drilling capacity steel E 335 (St 60)</b>	23 mm	23 mm
Tapping performance steel E 335 (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 14	M 14
Tapping performance Cast iron EN-GJL-200 (GG 20) <i>(Option 20.0 or 20.1 required)</i>	M 16	M 16
Short spindle	MT 2	MT 2
Z-travel of spindle	100 mm	100 mm
Distance spindle to column	250 mm	250 mm
Column diameter	90 mm	90 mm
Table clamping area (width x depth)	370 x 300 mm	370 x 300 mm
T-Slots, number x width x distance	2 x 14 x 160 mm	2 x 14 x 160 mm
Distance spindle/table min./max.	125/455 mm	140/670 mm
Table height adjustment	Crank	Crank
Base plate, clamping area (width x depth)	320 x 250 mm	-
T-Slots, number x width x distance	2 x 14 x 160 mm	-
Distance spindle / base plate min. /max.	625/625 mm	-
Feed	manual	manual
Height of the machine without options approx.	1095 mm	1770 mm
Net weight approx.	160 kg	180 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor:</b> n = 750 / 1500 rpm	<b>0,6 / 0,95 kW</b>	<b>0,6 / 0,95 kW</b>
Spindle Rpm range	125-2400 rpm	125-2400 rpm
<b>Price of the machine without options</b>	<b>6.265,00 €</b>	<b>6.433,00 €</b>
<b>Motor:</b> n = 750 / 1500 rpm	<b>0,6 / 0,95 kW</b>	<b>0,6 / 0,95 kW</b>
Spindle Rpm range	225-4300 rpm	225-4300 rpm
<b>Price of the machine without options</b>	<b>6.265,00 €</b>	<b>6.433,00 €</b>

Drilling heads (height adjustable) for Multi-Head Systems RFT page 33

## Standard Equipment

**Main switch** lockable  
**Motor** heat-protected  
**Self-Locking Mushroom Button** for Emergency-Off  
**Right rotation** through protective control  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Motor Isolation Class „F“ (155°)**

**Connection terminal** in the electrics cabinet. Without cable.  
 (All versions with tapping option.)  
**Cable** w/o plug, 2 m. (All versions without tapping option.)  
**Protection class IP 54**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured signal white RAL 9003,  
 PANTONE 7545c, black.

## OPTIONS

09.1	Table/Bench, W x D x H 750 x 700 x 840 mm (weight approx. 66 kg)	1.218,00 €
10.	Spindle Reverse Switch for counter-clockwise rotation with 0-Position	35,00 €
12.	LED machine light, adjustable angle, 230 V, IP 65	410,00 €
20.0	Tapping Attachment, w/o foot switch, max. 12 tapped holes per minute (tapping capacity depending on Rpm speed), reduces stroke by 15 mm, auto-reverse at end stop	994,00 €
20.1	Tapping Attachment, with reverse foot switch, max. 12 tapped holes per minute (tapping capacity depending on Rpm speed), reduces stroke by 15 mm, auto-reverse at end stop	1.190,00 €
24.	Coolant Attachment A*, consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, check valve and accessories (only for AX 2/S)	1.092,00 €
25.	Coolant Attachment B, consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
37.1	Digital Depth Read-Out, O-fixation (drill start), 5 position LED-Display, characters 13 mm high	606,00 €
50.6	Precision Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm (spindle stroke reduced by 20 mm)	332,00 €
03.	Anchoring set for AX 2/S	234,00 €
08.	Wooden Packing, disposable L x W x H 1100 x 800 x 1400 mm for AX 2-T/S. Net weight approx. 45 kg L x W x H 1200 x 800 x 2100 mm for AX 2/S. Net weight approx. 75 kg	61,00 € 126,00 €
08.1	Packaging for the Table/Bench 09.1	49,00 €

\*) = Net weight increases with 80 kg

Special Accessories page 36/37

Special equipment page 38

## COLUMN DRILLING MACHINES

Drilling capacity 40 mm

Photo with options



	Column Drilling Machine <b>AX 3/S</b>	Column Drilling Machine <b>AX 3/SV</b>
<b>Drilling capacity steel E 335 (St 60)</b>	40 mm	40 mm
Tapping performance steel E 335 (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 24	M 24
Tapping performance Cast iron EN-GJL-200 (GG 20) <i>(Option 20.0 or 20.1 required)</i>	M 30	M 30
Short spindle	MT 3	MT 3
Z-travel of spindle	120 mm	120 mm
Distance spindle to column	293 mm	293 mm
Column diameter	115 mm	115 mm
Table clamping area (width x depth)	514 x 360 mm	514 x 360 mm
Distance spindle/table min./max.	117/701 mm	117/701 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Feed	manual	0,1 + 0,2 mm/Rot.
Height of the machine without options approx.	1840 mm	1840 mm
Net weight approx.	260 kg	270 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor: n = 750 / 1500 rpm</b>	<b>1,0 / 1,6 kW</b>	<b>1,0 / 1,6 kW</b>
Spindle Rpm range	80-1125 rpm	80-1125 rpm
<b>Price of the machine without options</b>	<b>7.992,00 €</b>	<b>9.345,00 €</b>
<b>Motor: n = 1500 / 3000 rpm</b>	<b>1,45 / 1,9 kW</b>	<b>1,45 / 1,9 kW</b>
Spindle Rpm range	160-2250 rpm	160-2250 rpm
<b>Price of the machine without options</b>	<b>7.992,00 €</b>	<b>9.345,00 €</b>

Drilling heads (height adjustable) for Multi-Head-Systems RFT, page 34



## Standard Equipment

<b>Main switch (lockable) with Overload Protection Switch</b> <b>Motor</b> heat-protected <b>Self-Locking Mushroom Button</b> for Emergency-Off <b>Right rotation</b> through protective control <b>Infinitely variable speed drive</b> , mechanical variator <b>Digital RPM Read-out</b> <b>Feed overload clutch</b> (AX 3/SV) <b>Motor Isolation Class „F“ (155°)</b>	<b>Connection terminal</b> in the electrics cabinet. Without cable. (All versions with tapping option.) <b>Cable</b> w/o plug, 2 m. (All versions without tapping option.) <b>Protection class IP 54</b> <b>Spindle protection</b> electrically secured <b>Lacquer:</b> DD-structured signal white RAL 9003, PANTONE 7545c, black. <b>Machine oil</b> (AX 3/SV)
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## OPTIONS

10.	<b>Spindle Reverse Switch for counter-clockwise rotation</b> with 0-Position	35,00 €
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) (If Motor 1500/3000 is chosen, the 1st gear should be used for tapping), auto-reverse at end stop	994,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) (If Motor 1500/3000 is chosen, the 1st gear should be used for tapping), auto-reverse at end stop	1.190,00 €
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, check valve and accessories	992,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
37.1	<b>Digital Depth Read-Out</b> 0-fixation (drill start), 5 position LED-Display, characters 13 mm high	712,00 €
42.	<b>Column extension</b> + 200 mm (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)	644,00 €
47.1.2	<b>Short spindle MT4</b>	386,00 €
50.6	<b>Precision Depth Adjuster and fixed stop</b> Precision adjustment to 0,1 mm	332,00 €
03.	<b>Anchoring set</b>	234,00 €
08.	<b>Wooden packing, disposable</b> L x W x H 1200 x 800 x 2100 mm, Net weight approx. 75 kg	126,00 €

\*) = net weight increases with 80 kg

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Special equipment page 38

## COLUMN DRILLING MACHINE

Drilling capacity 55 mm

Photo with options



	Column Drilling Machine <b>AX 4/SV</b>	<b>AX 4/SV</b> with 3 kW motor
<b>Drilling capacity steel E 335 (St 60)</b>	55 mm	55 mm
Tapping performance <b>steel E 335 (St 60)</b> <i>(Option 20.0 or 20.1 required)</i>	M 30	M 42
Tapping performance <b>Cast iron EN-GJL-200 (GG 20)</b> <i>(Option 20.0 or 20.1 required)</i>	M 36	M 56
Short spindle	MT 4	MT 4
Z-travel of spindle	140 mm	140 mm
Distance spindle to column	300 mm	300 mm
Column diameter	145 mm	145 mm
Table clamping area (width x depth)	615 x 430 mm	615 x 430 mm
Distance spindle/table min./max.	150/735 mm	150/735 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Feed	0,1 + 0,3 mm/Rot.	0,1 + 0,3 mm/Rot.
Height of the machine without options approx.	1850 mm	1850 mm
Net weight approx.	380 kg	380 kg
<b>Drive System</b>	infinitely variable	infinitely variable with 2-step gear box
<b>Motor:</b> n = 750/1500 rpm	<b>1,8 / 2,9 kW</b>	-
Spindle Rpm range	70-1200 rpm	-
<b>Price of the machine without options</b>	<b>13.095,00 €</b>	-
<b>Motor:</b> n = 1500 rpm	-	<b>3,0 kW</b>
Spindle Rpm range	-	70-2400 rpm
<b>Price of the machine without options</b>	-	<b>14.311,00 €</b>

Drilling heads for Multi-Head-Systems RFT, page 32/34/35

## Standard Equipment

**Main switch** with Overload Protection Switch, lockable  
**Motor** heat-protected  
**Self-Locking Mushroom Button** for Emergency-Off  
**Right rotation** through protective control  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Protection class IP 54**  
**Motor Isolation Class „F“ (155°)**

**Feed overload protection clutch**  
**Connection terminal** in the electrics cabinet. Without cable.  
 (All versions with tapping option.)  
**Cable w/o plug**, 2 m. (All versions without tapping option.)  
**Spindle protection** electrically secured  
**Lacquer**: DD-structured signal white RAL 9003,  
 PANTONE 7545c, black.  
**Machine oil**

## OPTIONS

10.	<b>Spindle Reverse Switch for counter-clockwise rotation</b> with 0-Position	35,00 €
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	994,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	1.190,00 €
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump check valve and accessories	992,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
37.1	<b>Digital Depth Read-Out 0-fixation</b> (drill start), 5 position LED-Display, characters 13 mm high	712,00 €
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)	644,00 €
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	332,00 €
03.	<b>Anchoring set</b>	234,00 €
08.	<b>Wooden packing, disposable</b> L x W x H 1200 x 800 x 2100 mm, Net weight approx. 75 kg	126,00 €

\*) = net weight increases with 60 kg

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## COLUMN AND SEMI-BOX COLUMN DRILLING MACHINES

Drilling capacity 30/40 mm

Photos with options



	Column Drilling Machine <b>AB 26/SV</b>	Column Drilling Machine <b>AB 34/SV</b>	Semi-Box Column Drilling Machine <b>AB 34/HST</b>
<b>Drilling performance steel E 335* (St 60)</b>	26 mm	34 mm	34 mm
<b>Drilling performance Cast iron EN-GJL-200* (GG 20)</b>	30 mm	40 mm	40 mm
<b>Drilling capacity steel E 335* (St 60)</b>	30 mm	40 mm	40 mm
Tapping performance <b>steel E 335* (St 60)</b> <i>(Option 20.0 or 20.1 required)</i>	M 20	M 24	M 24
Tapping performance <b>Cast iron EN-GJL-200 (GG 20)</b> <i>(Option 20.0 or 20.1 required)</i>	M 24	M 30	M 30
Short spindle	MT 3	MT 4	MT 4
Distance spindle to column	293 mm	300 mm	330 mm
Table clamping area (width x depth)	514 x 360 mm	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	90/675 mm	147/688 mm	266/928 mm
Column diameter / Box Column width	115 mm	145 mm	290 mm
Z-travel of spindle	160 mm	160 mm	160 mm
Feed(s)	0,1-0,2-0,3-0,4 mm/Rot.	0,1-0,2-0,3-0,4 mm/Rot.	0,1-0,2-0,3-0,4 mm/Rot.
Height of the machine without options approx.	1865 mm	1865 mm	2110 mm
Net weight approx.	380 kg	470 kg	760 kg
<b>Drive System</b>	infinitely variable	infinitely variable	infinitely variable
<b>Motor:</b> n = 750/1500 rpm	<b>1,0 / 1,6 kW</b>	<b>1,4 / 2,2 kW</b>	<b>1,4 / 2,2 kW</b>
Spindle Rpm range	120-2200 rpm	100-1800 rpm	100-1800 rpm
<b>Price of the machine without options</b>	<b>11.569,00 €</b>	<b>13.142,00 €</b>	<b>19.484,00 €</b>
<b>Motor:</b> n = 750/1500 rpm	<b>1,0 / 1,6 kW</b>	<b>1,4 / 2,2 kW</b>	
Spindle Rpm range	120-2200 rpm	100-1800 rpm	
<b>Price of the machine with options 37.3</b>	<b>13.758,00 €</b>	<b>15.331,00 €</b>	

\* Drilling performance and capacity only with motor 750/1500 rpm

The "Autodigit" version includes the basic machine with option 37.3.  
Drilling heads for Multi-Head-Systems RFT, page 32/34/35.

## Standard Equipment

<b>Electro-magnetic feed clutch</b> with overload protection and Electrical Cross Handle Switches <b>Main switch</b> lockable <b>Motor</b> heat-protected <b>Self-Locking Mushroom Button</b> for Emergency-Off <b>Right rotation</b> through protective control <b>Infinitely variable speed drive</b> , mechanical variator <b>Digital RPM Read-out</b> <b>Protection class IP 54</b>	<b>Motor Isolation Class „F” (155°)</b> <b>Connection terminal</b> in the electrics cabinet. Without cable. (All versions with tapping option.) <b>Cable w/o plug</b> , 2 m. (All versions without tapping option.) <b>Spindle protection</b> electrically secured <b>Lacquer</b> : DD-structured signal white RAL 9003, PANTONE 7545c, black. <b>Machine oil</b>
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## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation</b> with 0-position	35,00 €
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	994,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	1.190,00 €
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm, and 2 slots, overload protected pump, check valve and accessories (for AB 26/SV and AB 34/SV only)	992,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
37.1	<b>Digital Depth Read-Out 0-fixation</b> (drill start), 5 position LED-Display, characters 13 mm high	712,00 €
37.3	<b>Automatic Drill Depth Control (Autodigit)</b> : Simple Drill Depth programming, interval drilling and free cutting possibility. Settings by means of Digi-Pot, Digital Read-Out, includes Position 37.1	2.189,00 €
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (for AB 26/SV and AB 34/SV only)	644,00 €
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	332,00 €
03.	<b>Anchoring set</b>	234,00 €
07	<b>Wooden packing, disposable for AB 34/HST</b> L x W x H 2400 x 1000 x 1600 mm, Package weight approx. 135 kg	250,00 €
08.	<b>Wooden packing, disposable for AB 26/SV + AB 34/SV</b> L x W x H 1200 x 800 x 2100 mm, Package weight approx. 75 kg	126,00 €

\*) = net weight increases with 80 kg at AB 26/SV  
net weight increases with 60 kg at AB 34/SV


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## COLUMN AND SEMI-BOX COLUMN DRILLING MACHINES

Drilling capacity 50 mm

Photos with options



	Column Drilling Machine <b>AB 40/SV</b>	Semi-Box Column Drilling Machine <b>AB 40/HST</b>
<b>Drilling performance steel E 335* (St 60)</b>	40 mm	40 mm
<b>Drilling performance Cast iron EN-GJL-200* (GG 20)</b>	46 mm	46 mm
<b>Drilling capacity steel E 335* (St 60)</b>	50 mm	50 mm
Tapping performance <b>steel E 335* (St 60)</b> <i>(Option 20.0 or 20.1 required)</i>	M 30	M 30
Tapping performance <b>Cast iron EN-GJL-200* (GG 20)</b> <i>(Option 20.0 or 20.1 required)</i>	M 36	M 36
Short spindle	MT 4	MT 4
Distance spindle to column	300 mm	330 mm
Table clamping area (width x depth)	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	147/688 mm	266/928 mm
Column diameter / Box Column width	145 mm	290 mm
Z-travel of spindle	160 mm	160 mm
Feed(s)	0,1-0,2-0,3-0,4 mm/Rot.	0,1-0,2-0,3-0,4 mm/Rot.
Height of the machine without options approx.	1885 mm	2110 mm
Net weight approx.	470 kg	760 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor:</b> n = 750/1500 rpm	<b>1,8 / 2,9 kW</b>	<b>1,8 / 2,9 kW</b>
Spindle Rpm range	100-1600 rpm	100-1600 rpm
<b>Price of the machine without options</b>	<b>16.302,00 €</b>	<b>21.313,00 €</b>
<b>Motor:</b> n = 750/1500 rpm (with gear)	<b>1,8 / 2,9 kW</b>	<b>1,8 / 2,9 kW</b>
Spindle Rpm range	70-4000 rpm	70-4000 rpm
<b>Price of the machine without options</b>	<b>17.455,00 €</b>	<b>22.466,00 €</b>
	<b>AB 40/SV Autodigit</b>	
<b>Motor:</b> n = 750/1500 rpm	<b>1,8 / 2,9 kW</b>	
Spindle Rpm range	100-1600 rpm	
<b>Price of the machine with options 37.3</b>	<b>18.491,00 €</b>	

\* Performance data are for motor n=750/1500 rpm (with gear).  
The "Autodigit" version includes the basic machine with option 37.3.  
Drilling heads for Multi-Head-Systems RFT, page 32/34/35.

## Standard Equipment

**Electro-magnetic feed clutch**  
with Overload Protection and Electrical Cross Handle Switches  
**Control and Light Transformer 24 Volts**  
**Main switch** lockable  
**Motor** heat-protected  
**Self-Locking Mushroom Button** for Emergency-Off  
**Right rotation** through protective control  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Rpm setting by potentiometer** (w/o lever)  
**Protection class IP 54**  
**Motor Isolation Class „F“ (155°)**  
**Cable** w/o plug, 2 m  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured signal white RAL 9003,  
PANTONE 7545c, black.  
**Machine oil**

## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation</b> with 0-position	229,00 €
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	586,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	781,00 €
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump check valve and accessories (for AB 40/SV only)	992,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, Check valve and accessories	532,00 €
37.1	<b>Digital Depth Read-Out</b> , 0-fixation (drill start), 5 position LED-Display, characters 13 mm high	712,00 €
37.3	<b>Automatic Drill Depth Control (Autodigit) with:</b> Drill Depth programming, interval drilling and free cutting possibility. Settings by means of Digi-Pot, Digital Read-Out, includes Position 37.1	2.189,00 €
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (for AB 40/SV only)	644,00 €
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	332,00 €
51.1	<b>Special feeds</b> 0,05 - 0,10 - 0,15 - 0,20 mm/Rot.	513,00 €
03.	<b>Anchoring set</b>	234,00 €
07	<b>Wooden packing, disposable for AB 40/HST</b> L x W x H 2400 x 1000 x 1600 mm, net weight approx. 135 kg	250,00 €
08.	<b>Wooden packing, disposable for AB 40/SV</b> L x W x H 1200 x 800 x 2100 mm, net weight approx. 75 kg	126,00 €

\*) = net weight increases with 60 kgs (AB 40/SV)

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Special equipment page 38

## COLUMN AND SEMI-BOX COLUMN DRILLING MACHINES

Drilling capacity 60 mm

Photos with options



	Column Drilling Machine <b>AB 50/SV</b>	Semi-Box Column Drilling Machine <b>AB 50/HST</b>
<b>Drilling performance steel E 335* (St 60)</b>	50 mm	50 mm
<b>Drilling performance Cast iron EN-GJL-200* (GG 20)</b>	60 mm	60 mm
<b>Drilling capacity steel E 335* (St 60)</b>	60 mm	60 mm
Tapping performance <b>steel E 335* (St 60)</b> <i>(Option 20.0 or 20.1 required)</i>	M 42	M 42
Tapping performance <b>Cast iron EN-GJL-200* (GG 20)</b> <i>(Option 20.0 or 20.1 required)</i>	M 60	M 60
Short spindle	MT 4	MT 4
Distance spindle to column	350 mm	330 mm
Table clamping area (width x depth)	720 x 510 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max	159/884 mm	257/919 mm
Column diameter / Box Column Width	200 mm	290 mm
Z-travel of spindle	200 mm	200 mm
Feeds mm/Rev.	0,15-0,2-0,3-0,36	0,15-0,2-0,3-0,36
Machine height without options approx.	1950 mm	2135 mm
Net weight approx.	605 kg	850 kg
<b>Drive System</b>	infinitely variable with gear box	
<b>Motor:</b> n = 1500/3000 rpm	<b>3,6 / 4,3 kW</b>	<b>3,6 / 4,3 kW</b>
Spindle Rpm range	60-1530 rpm	60-1530 rpm
<b>Price of the machine without options</b>	<b>19.896,00 €</b>	<b>24.974,00 €</b>
<b>Motor:</b> n = 1500/3000 rpm	<b>3,6 / 4,3 kW</b>	<b>3,6 / 4,3 kW</b>
Spindle Rpm range	50-1280 rpm	50-1280 rpm
<b>Price of the machine without options</b>	<b>19.896,00 €</b>	<b>24.974,00 €</b>

\* **Please note:** Performance data relating to rpm range n = 50-1280 rpm only.



## Standard Equipment

**Electro-magnetic feed clutch** with Overload Feed Protection and Electrical Cross Handle Switches  
**Main switch** lockable  
**Overload Protection Switch**  
**Protective control** for clockwise rotation  
**Self-Locking Mushroom Button** for Emergency-Off  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Protection class IP 54**

**Motor Isolation Class „F“ (155')**  
**Connection terminal** in the electrics cabinet. Without cable.  
**Machined Base Plate**, with T-slots (AB 50/SV only), clamping area 380 x 450 mm (width x depth)  
**Spindle protection** electrically secured  
**Lacquer**: DD-structured signal white RAL 9003, PANTONE 7545c, black.  
**Machine oil**

## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation</b> with 0-position	35,00 €
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	1.098,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	1.291,00 €
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 450 x 460 mm and 2 slots, overload protected pump, check valve and accessories (for AB 50/SV only)	992,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (for AB 50/SV only)	772,00 €
50.6	<b>Precision Depth Adjuster and fixed stop</b> . Precision adjustment to 0,1 mm	332,00 €
03.	<b>Anchoring set</b>	234,00 €
07	<b>Wooden packing, disposable AB 50/HST</b> L x W x H 2400 x 1000 x 1600 mm, net weight approx. 135 kg	250,00 €
08.	<b>Wooden packing, disposable AB 50/SV</b> L x W x H 2200 x 800 x 1600 mm, net weight approx. 105 kg	218,00 €

\*) = net weight increases with 115 kgs (AB 50/SV)

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## COLUMN DRILLING MACHINE FOR BOTH FLOW DRILLING AND STANDARD DRILLING

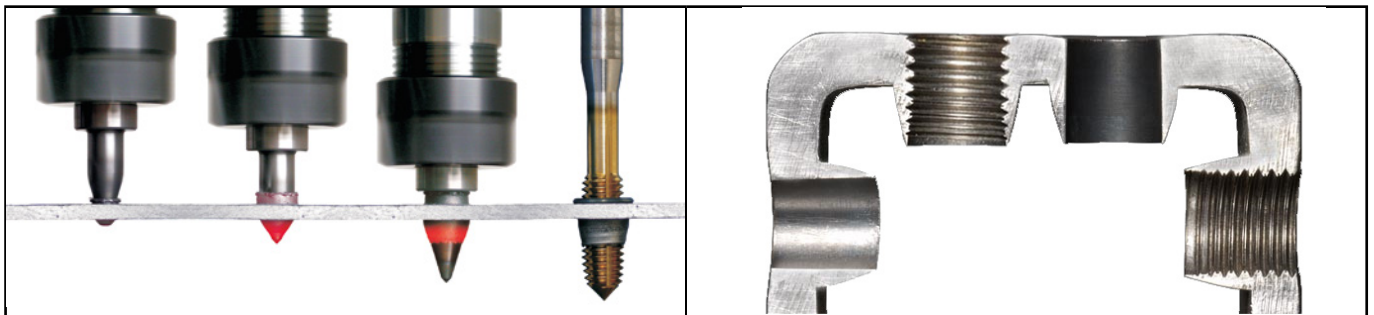
Flow Drilling capacity 12 mm

Photos with options



	Column Drilling Machine <b>ALZFLOW 30/S</b>
Flow Drilling capacity steel DC 01A (St 12.03) (sheet metal thickness 2,5 mm)	12 mm
Tapping performance steel DC 01A (St 12.03) (Option 20.0 or 20.1 required)	M 12 mm
Drilling capacity steel E 335 (St 60)	30 mm
Tapping performance steel E 335 (St 60) (Option 20.0 or 20.1 required)	M 16
Tapping performance Cast iron EN-GJL-200 (GG 20) (Option 20.0 or 20.1 required)	M 20
Short spindle	MT 3
Z-travel of spindle	140 mm
Distance spindle to column	293 mm
Column diameter	115 mm
Table clamping area (width x depth)	514 x 360 mm
T-Slots, number x width x distance	2 x 14 x 224 mm
Distance spindle/table min./max.	132/724 mm
Feed	Manual
Height of the machine without options approx.	1790 mm
Net weight approx.	260 kg
<b>Drive System</b>	infinitely variable
<b>Motor:</b> n = 750/1500 rpm	<b>1,0/1,6 kW</b>
Spindle Rpm range	225-4300 rpm
<b>Price of the machine without options</b>	<b>7.328,00 €</b>

### Chipless Flow Drilling and Cold roll threading



Process sequence

Examples

## Standard Equipment

**Main switch** lockable  
**Self-Locking Mushroom Button** for Emergency-Off switch  
**Reverse switch** for tapping  
**Motor** heat-protected  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Protection class IP 54**  
**Motor Isolation Class „F“ (155°)**  
**Connection terminal** in the electrics cabinet. Without cable.  
 (All versions with tapping option.)

**Cable w/o plug**, 2 m. (All versions without tapping option.)  
**Spindle protection** electrically secured  
**Lacquer**: DD-structured signal white RAL 9003,  
 PANTONE 7545c, black.  
**Plug** (fully assembled, cable length 2m)  
**Spindle protection** electrically secured  
**Lacquer**: DD-structured signal white RAL 9003,  
 PANTONE 7545c, black.

## OPTIONS

12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	410,00 €
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed), auto-reverse at end stop	1.428,00 €
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute, auto-reverse at end stop	1.622,00 €
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
50.6	<b>Precision depth adjustment and fixed stop</b> , precision adjustment to 0,1 mm	332,00 €
03.	<b>Anchoring set</b>	234,00 €
08.	<b>Packing, disposable</b> , L x W x H 1200 x 800 x 2100 mm, net weight approx. 75 kg	126,00 €

Special Accessories page 36/37  
 Special equipment page 38

## COLUMN DRILLING MACHINE FOR BOTH FLOW DRILLING AND STANDARD DRILLING

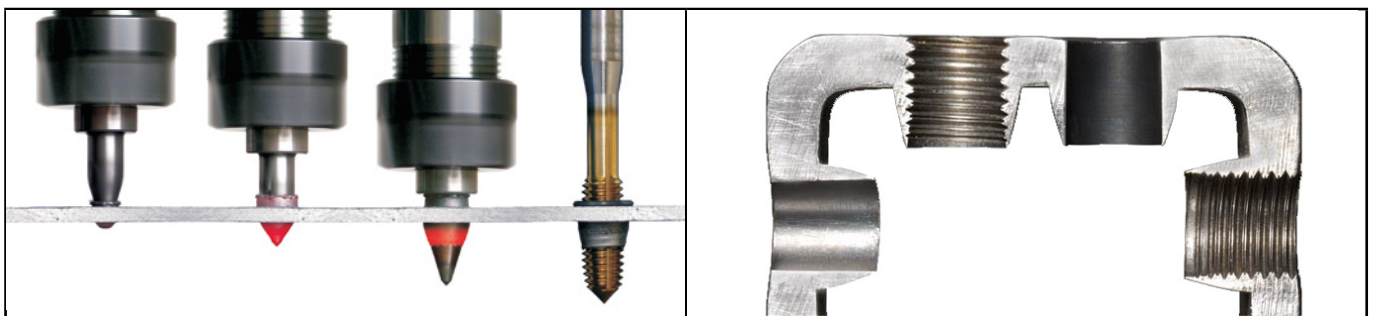
Flow Drilling capacity 20 mm

Photos with options



	Column Drilling Machine <b>AB-FLOW 40/SV</b>	Semi Box Column Drilling Machine <b>AB-FLOW 40/HST</b>
Flow Drilling capacity steel DC 01A (St 12.03) (sheet metal thickness 2,5 mm)	20 mm	20 mm
Tapping performance steel DC 01A (St 12.03) <i>(Option 20.2 or 20.3 required)</i>	M 20 mm	M 20 mm
Drilling capacity steel E 335 (St 60)	40 mm	40 mm
Tapping performance steel E 335 (St 60) <i>(Option 20.2 or 20.3 required)</i>	M 30	M 30
Tapping performance Cast iron EN-GJL-200 (GG 20) <i>(Option 20.2 or 20.3 required)</i>	M 36	M 36
Short spindle	MT 4	MT 4
Z-travel of spindle	160 mm	160 mm
Distance spindle to column	300 mm	330 mm
Column diameter/ box column width	145 mm	290 mm
Table clamping area (width x depth)	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	147/688 mm	266/928 mm
Feed	0,1-0,2-0,3-0,4 mm/Rot.	0,1-0,2-0,3-0,4 mm/Rot.
Height of the machine without options approx.	1885 mm	2110 mm
Net weight approx.	470 kg	760 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor:</b> n = 1500 rpm	<b>4,0 kW</b> (with gear)	<b>4,0 kW</b> (with gear)
Spindle Rpm range	140-4000 rpm	140-4000 rpm
<b>Price of the machine without options</b>	<b>17.548,00 €</b>	<b>22.967,00 €</b>

### Chipless Flow Drilling and Cold roll threading



Process sequence

Examples

## Standard Equipment

<p><b>Electro-Magnetic automatic feed switch at cross handle</b> with overload protection <b>Control and Light Transformer 24 V</b> Main switch lockable Motor heat-protected <b>Self-Locking Mushroom Button</b> for Emergency-Off <b>Protective control</b> for clockwise rotation <b>Infinitely variable speed drive</b>, mechanical variator <b>Digital RPM Read-out</b></p>	<p><b>Cable w/o plug</b>, 2 m <b>Rpm setting by potentiometer</b> (w/o lever) <b>Protection class IP 54</b> <b>Motor Protection Class „F“ (155°)</b> <b>Spindle protection</b> electrically secured <b>Lacquer</b>: DD-structured signal white RAL 9003, PANTONE 7545c, black. <b>Machine Oil</b></p>
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## OPTIONS

12.	LED machine light, adjustable angle, 230 V, IP 65	410,00 €
20.2	Tapping Attachment w/o foot switch, max. 6 tapped holes per minute, with soft reverse automate	2.240,00 €
20.3	Tapping Attachment (as 20.2) but with foot switch	2.437,00 €
24.	Coolant Attachment A*, consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, check valve and accessories (for AB-FLOW 40/SV only)	992,00 €
25.	Coolant Attachment B, consisting of: separate container (33 l), with overload protected pump, check valve and accessories	532,00 €
37.3	Automatic Drill Depth Control with: Drill Depth programming, interval drilling and free cutting possibility. Settings by means of Digi+Pot, Digital Read-Out (Autodigit)	2.189,00 €
50.6	Precision Depth Adjuster and fixed Stop precision adjustment to 0,1 mm	332,00 €
51.1	Special feeds 0,05 - 0,10 - 0,15 - 0,20 mm/Rev.	513,00 €
03.	Anchoring set	234,00 €
07.	Packaging, disposable / AB-FLOW 40/HST , L x W x H 2400 x 1000 x 1600 mm, weight approx. 135 kg	250,00 €
08.	Packaging, disposable / AB-FLOW 40/SV, L x W x H 1200 x 800 x 2100 mm, weight approx. 75 kg	126,00 €

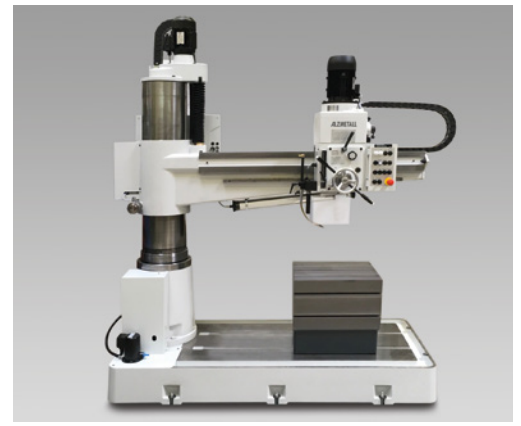
Special Accessories page 36/37

Special equipment page 38

**RADIAL DRILLING MACHINES  
AB 30/R-1000 AND AB 30/R-1400**

Drilling capacity 45/50 mm

Photos with options



	Radial Drilling Machine	
	AB 30/R-1000 AB 30/R-1400 with 1,5 kW Motor	AB 30/R-1000 AB 30/R-1400 with 3,0 kW Motor
<b>Drilling performance steel E 335 (St 60)</b>	32 mm	40 mm
<b>Drilling performance Cast iron EN-GJL-200 (GG 20)</b>	45 mm	50 mm
<b>Drilling capacity steel E 335 (ST 60)</b>	45 mm	50 mm
Tapping performance steel E 335 (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 30	M 30
Tapping performance Cast iron EN-GJL-200(GG 20) <i>(Option 20.0 or 20.1 required)</i>	M 42	M 42
Short spindle	MT 4	
Diameter of Column with AB 30/R-1000 / with AB 30/R-1400	220 mm / 300 mm	
Travel of radial arm AB 30/R-1000 / AB 30/R-1400	730 mm / 1100 mm	
Drilling radius min. max. AB 30/R-1000 / AB 30/R-1400	240/970 mm / 220/1320 mm	
Base plate, clamping area (b x t) AB 30/R-1000 / AB 30/R-1400	960 x 520 mm / 1365 x 640 mm	
Height of the base plate AB 30/R-1000 / AB 30/R-1400	190 mm / 230 mm	
T-Slots, number x width x distance	2 x 18 x 250 mm	
Distance Spindle - Base plate min./max. AB 30/R-1000 / AB 30/R-1400	510/1220 mm / 565/1305 mm	
Height of the machine without options approx. AB 30/R-1000 / AB 30/R-1400	2428 mm / 2564 mm	
Travel Motor	0,75 kW	
4 feeds	0,15-0,2-0,3-0,36 mm/Rot.	
Z-travel of spindle (Alt. Pos. 54)	160 mm	
Net weight approx. with AB 30/R-1000	1250 kg	
Net weight approx. with AB 30/R-1400	1650 kg	
<b>Drive System</b>	Gear box	
<b>Motor:</b> n = 1500 rpm	<b>1,5 kW</b>	<b>3,0 kW •</b>
Spindle Rpm range	40-56-80-112-160-224-315-450-630-900-1250-1800 rpm or 28-40-56-80-112-160-224-315-450-630-900-1250 rpm or 56-80-112-160-224-315-450-630-900-1250-1800-2500 rpm	only 56-2500 rpm
<b>Grundpreis der Maschine mit Ausladung ca. 1000 mm</b>	<b>AB 30/R-1000</b>	<b>51.155,00 €</b>
<b>Grundpreis der Maschine mit Ausladung ca. 1400 mm</b>	<b>AB 30/R-1400</b>	<b>64.806,00 €</b>
		<b>51.908,00 €</b>
		<b>65.398,00 €</b>

• in connection with 3,0 kW motor, Pos. 42.6 is recommended

## Standard Equipment

**Electromagnetic Feed Clutch** with overload protection and cross handle switches

**Contact Control for Clockwise Spindle Rotation** incl. motor protection circuit breaker for spindle motor and feed motor

**Control Transformer** (VDE 0113)

**Main switch** lockable

**Motor Isolation Class „F“ (155°)**

**Connection terminal box provided (w/o cable)**

**Base plate with T-slots**

**Self-Locking Mushroom Button** for EMERGENCY OFF

**Spindle protection electrically secured**

**Protection class IP 54**

**Lacquer DD-structured** signal white RAL 9003, black.

**Machine oil**

## OPTIONS

1.11	<b>Anchor and levelling elements</b> (6 elements)	826,00 €
12.2	<b>Protected tube light</b> with LED technics	493,00 €
20.0	<b>Tapping auto-reverse w/o foot switch</b> , max. 6 tapped holes per minute, incl. smooth-start clutch in gear box	1.626,00 €
24.	<b>Coolant Attachment A</b> , integrated in standard base plate with overload-protected pump and accessories	990,00 €
28.	<b>Electrically controlled free-cutting system</b> when depth is reached cutter remains for a controllable time in position. Incl. time-limit relay and feed brake.	3.935,00 €
42.6 •	<b>Outboard support</b> (an extra built-in switch will cut circuit to elevating motor when outboard support is locked)	3.125,00 €
47.2.1	<b>Long spindle MT 4</b> with key bore DIN 1807	388,00 €
50.6	<b>Precision depth adjuster and fixed stop</b> precision adjustment to 0,1 mm	411,00 €
53.2	<b>Portable boxed clamping table</b> , length 560 mm, width 480 mm, height 500 mm, clamping area at top 560 x 480 mm, with 3 T-slots 14 mm, at distance 150 mm, clamping area at side 560 x 330 mm, with 2 T-slots 14 mm, at distance 150 mm, weight 200 kg	3.450,00 €
54.	<b>Spindle travel 200 mm</b>	1.460,00 €
58	<b>Central clamping system</b> for sliding drill unit = mechanic, for column and arm = pneumatic/hydraulic	6.562,00 €
58.1	<b>Central clamping system</b> for sliding drill unit and arm = mechanic, for column = pneumatic	3.623,00 €
01.	<b>Special Lacquer: DD-brillant</b>	1.183,00 €
02.	<b>Special Lacquer: DD-structured</b>	556,00 €
05.	<b>Special voltages</b>	upon request

**Packing:** on wooden bars at no costs, Net weight approx. 100 kg

**MULTI-HEAD-DRILLS  
WITH FIXED HEIGHT OF TABLE RFT 20/1**

Photo with options



	Casted table RFT 20/1-1	Casted table RFT 20/1-2
Height of Table	780 mm	780 mm
Width/Depth of table with coolant channel	915 x 935 mm	915 x 1035 mm
Clamping Area at Table (width x depth)	765 x 495 mm	765 x 670 mm
Clamping Slots (number x width x distance)	3 x 14 x 112 mm	3 x 14 x 112 mm
Approximate weight w/o head	520 kg	550 kg
<b>Price of the table</b>	<b>4.526,00 €</b>	<b>5.421,00 €</b>

Assembly of heads for table	RFT 20/1-1		
<b>Drill Head</b> , height adjustable 700 mm	<b>AX 4/SV</b>	<b>AB 34/SV</b>	<b>AB 40/SV</b>
Spindle	MT 4 short	MT 4 short	MT 4 short
Distance spindle to column *	322,5 mm	322,5 mm	322,5 mm
Distance Spindle Nose to Table max.	1034 mm	998 mm	998 mm
Distance Spindle Nose to Table min.	340 mm	304 mm	304 mm
Z-travel of spindle	140 mm	160 mm	160 mm
Weight	280 kg	285 kg	315 kg
<b>Motor</b>	<b>750/1500 rpm</b>	<b>750/1500 rpm</b>	<b>750/1500 rpm</b>
kW	1,8/2,9	1,4/2,2	1,8/2,9
Spindle Rpm range, mechanical variator	70-1200 rpm	100-1800 rpm	100-1600 rpm
<b>Price per Drill Head</b>	<b>12.843,00 €</b>	<b>12.889,00 €</b>	<b>16.050,00 €</b>

Assembly of heads for table	RFT 20/1-2		
<b>Drill head</b> , height adjustable 490 mm <b>* with larger distance spindle to column</b>	<b>AX 4/SV</b>	<b>AB 34/SV</b>	<b>AB 40/SV</b>
Spindle	MT 4 short	MT 4 short	MT 4 short
Distance spindle to column *	477,5 mm	477,5 mm	477,5 mm
Distance Spindle Nose to Table max.	949 mm	913 mm	913 mm
Distance Spindle Nose to Table min.	459 mm	423 mm	423 mm
Z-travel of spindle	140 mm	160 mm	160 mm
Weight	280 kg	285 kg	315 kg
<b>Motor</b>	<b>750/1500 rpm</b>	<b>750/1500 rpm</b>	<b>750/1500 rpm</b>
kW	1,8/2,9	1,4/2,2	1,8/2,9
Spindle Rpm range, mechanical variator	70-1200 rpm	100-1800 rpm	100-1600 rpm
<b>Price per Drill Head</b>	<b>14.334,00 €</b>	<b>14.379,00 €</b>	<b>17.541,00 €</b>

**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.

Standard Equipment of the drill heads and options: Please see the relevant drilling machines page.

\* Attention: Drilling capacities are different due to larger distance spindle to column.

**Packing:** on wooden bars at no costs, Net weight approx. 70 kg.



## MULTI-HEAD-DRILLS RFT 2 WITH FIXED HEIGHT OF TABLE

Photo with options



	Casted Table RFT 2/2	Casted Table RFT 2/3	Special Equipment
Tool Cabinet	see Pos. 09.1	see Pos. 09.1	<b>09.1 Built-in Tool Cabinet with door</b>
Height of Table	930 mm	930 mm	4 drawers (w x d x h): 3 pieces 500 x 430 x 100 mm 1 piece 500 x 430 x 150 mm door can be locked
Width of Table	900 mm	1350 mm	
Clamping Area at Table (width x depth)	750 x 330 mm	1200 x 330 mm	
Clamping Slots (number x width x distance)	2 x 12 x 224 mm	2 x 12 x 224 mm	
Approximate Weight w/o Heads	200 kg	300 kg	
Number of Drill Heads	2	3	
<b>Price of the table</b>	<b>6.822,00 €</b>	<b>7.648,00 €</b>	<b>1.110,00 €</b>
<b>Assembly of heads for</b>	<b>RFT 2/2 - 2/3</b>		
<b>Drill head</b> , height adjustable 500 mm	<b>AX 2/S</b>		
Short spindle	MT 2		
Distance spindle to column	235 mm		
Distance Spindle Nose to Table max.	660 mm		
Distance Spindle Nose to Table min.	160 mm		
Z-travel of spindle	100 mm		
Weight	75 kg		
<b>Motor</b>	<b>750/1500 rpm</b>	<b>750/1500 rpm</b>	
kW	0,6/0,95 kW	0,6/0,95 kW	
Spindle Rpm range, mechanical variator	125-2400 rpm	225-4300 rpm	
<b>Price per Drill Head</b>	<b>6.182,00 €</b>	<b>6.182,00 €</b>	

**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.

Standard Equipment of the drill heads and options: Please see the relevant drilling machines page.

### OPTIONS

35.	<b>Coolant attachment system B</b> , with 48 l container, overload protected pump with backflow valve and complete accessories for two drill heads, with central ON/OFF switch at the electrics cabinet.	<b>1.641,00 €</b>
35.1	- for 3 Drill heads	<b>1.781,00 €</b>
01.	<b>Special Lacquer:</b> DD-brillant, table only	<b>1.451,00 €</b>
02.	<b>Special Lacquer:</b> DD-structured, table only	<b>700,00 €</b>
03.	<b>Anchoring set</b> (set of 4 pieces) up to RFT 3/3	<b>234,00 €</b>

**Packing** on wooden bars only, no costs. Net weight approx. 40-150 kg (as per type).

**MULTI-HEAD-DRILLS RFT 3  
WITH FIXED HEIGHT OF TABLE**

Photo with options



	Casted table RFT 3/2	Casted table RFT 3/3	Casted table RFT 3/4	Casted table RFT 3/5	Casted table RFT 3/6
Height of Table (mm)	780	780	780	780	780
Width of Table (incl. channel) (mm)	1150	1650	2150	2650	3150
Clamping Area at Table (width x depth) (mm)	1000 x 350	1500 x 350	2000 x 350	2500 x 350	3000 x 350
Clamping Slots (number x width x distance) (mm)	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224
Approximate Weight w/o Heads	350 kg	520 kg	680 kg	840 kg	990 kg
Number of Drill Heads	1 or 2	max. 3	max. 4	max. 5	max. 6
<b>Price of the table</b>	<b>7.853,00 €</b>	<b>10.310,00 €</b>	<b>10.816,00 €</b>	<b>13.972,00 €</b>	<b>16.897,00 €</b>

Assembly of heads for	RFT 3/2 - RFT 3/3 - RFT 3/4 - RFT 3/5 - RFT 3/6		
<b>Drill head, height adjustable 500 mm</b>	<b>AX 3/S</b>	<b>AX 3/SV</b>	<b>AX 4/SV</b>
Option 700 mm	(Pos. 42.6)	(Pos. 42.6)	(Pos. 42.6)
Short spindle	MT 3	MT 3	MT 4
Distance spindle to column	293 mm	293 mm	300 mm
Distance Spindle Nose to Table max.	764 [964] mm	764 [964] mm	804 [1004] mm
Distance Spindle Nose to Table min.	264 mm	264 mm	304 mm
Z-travel of spindle	120 mm	120 mm	140 mm
Distance spindle to spindle (fix)	500 mm	500 mm	500 mm
Weight	150 kg	160 kg	265 kg
<b>Motor n=1500 rpm</b>	-	-	<b>3 kW</b>
Spindle Rpm range, mechanical variator	-	-	70-2400 rpm
<b>Price per Drill Head</b>	-	-	<b>14.062,00 €</b>
<b>Motor n=750/1500 rpm</b>	<b>1,0 / 1,6 kW</b>	<b>1,0 / 1,6 kW</b>	<b>1,8 / 2,9 kW</b>
Spindle Rpm range	80-1125 rpm	80-1125 rpm	70-1200 rpm
<b>Motor n=1500/3000 rpm</b>	<b>1,45 / 1,9 kW</b>	<b>1,45 / 1,9 kW</b>	-
Spindle Rpm range, mechanical variator	160-2250 rpm	160-2250 rpm	-
<b>Price per Drill Head</b>	<b>7.742,00 €</b>	<b>9.097,00 €</b>	<b>12.843,00 €</b>

**Lacquer:** DD-structured signal white RAL 9003, PANTONE 7545c, black.  
Standard equipment of the drill heads and options: Please see the relevant drilling machines page.



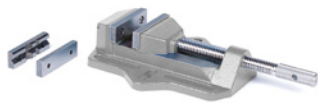
Assembly of heads for	RFT 3/2 - RFT 3/3 - RFT 3/4 - RFT 3/5 - RFT 3/6		
<b>Drill head</b> , height adjustable 500 mm	<b>AB 26/S</b>	<b>AB 34/SV</b>	<b>AB 40/SV</b>
Option 700 mm	(Pos. 42.6)	(Pos. 42.6)	(Pos. 42.6)
Short spindle	MT 3	MT 4	MT 4
Distance spindle to column	293 mm	300 mm	300 mm
Distance Spindle Nose to Table max.	738 [938] mm	768 [968] mm	768 [968] mm
Distance Spindle Nose to Table min.	238 mm	268 mm	268 mm
Z-travel of spindle	160 mm	160 mm	160 mm
Distance spindle to spindle (fix)	500 mm	500 mm	500 mm
Weight	250 kg	270 kg	290 kg
<b>Motor n = 750/1500 rpm</b>	<b>1,0 / 1,6 kW</b>	<b>1,4 / 2,2 kW</b>	<b>1,8 / 2,9 kW</b>
Spindle Rpm range, mechanical variator	120-2200 rpm	100-1800 rpm	100-1600 rpm
<b>Price per Drill Head</b>	<b>11.325,00 €</b>	<b>12.889,00 €</b>	<b>16.050,00 €</b>
<b>Motor n = 750/1500 rpm</b>	-	-	<b>1,8 / 2,9 kW with gear box</b>
Spindle Rpm range, mechanical variator	-	-	70-4000 rpm
<b>Price per Drill Head</b>	-	-	<b>17.206,00 €</b>

## OPTIONS

17.1	<b>Pedal Bar as Emergency OFF switch</b> only for RFT 3/2 to RFT 3/6	1.058,00 €
35.	<b>Coolant attachment system B</b> , with 48 l container, overload protected pump with backflow valve and complete accessories, with central ON/OFF switch at the electrics cabinet. - for 2 Drill heads	1.641,00 €
35.1	- for 3 Drill heads	1.781,00 €
35.2	- for 4 Drill heads	1.937,00 €
35.3	- for 5 Drill heads	2.115,00 €
35.4	- for 6 Drill heads	2.290,00 €
42.6	<b>Drill Heads 700 mm adjustable (RFT 3)</b>	519,00 €
01.	<b>Special Lacquer: DD-brillant</b> , table only	1.451,00 €
02.	<b>Special Lacquer: DD-structured</b> , table only	700,00 €
03.	<b>Anchoring set</b> (set of 4 pieces) up to RFT 3/3	234,00 €
03.	<b>Anchoring set</b> (set of 6 pieces) RFT 3/4 and 3/5	354,00 €
03.	<b>Anchoring set</b> (set of 8 pieces) RFT 3/6	476,00 €

Packing on wooden bars only, no costs. Net weight approx. 40-150 kg (as per type).


## Accessories

 <p>Two-axis production table with copying device</p>	810776 *)	<b>Two-axis Production Table (sliding)</b> 760 x 425 mm, clamping area 600 x 325 mm, Height 170 mm, Travel 400 mm in X, 200 mm in Y, with adjustable end limiters, with 2 T-Slots 14 mm at distance 160 mm, max. admissible load approx. 150 kgs, max. admissible drill force 15000 N, weight approx. 140 kg	<b>7.294,00 €</b>
	816600 *)	<b>Two-axis Production Table (sliding)</b> 880 x 425 mm, clamping area 820 x 410 mm Travel 400 mm in X, 200 mm in Y, (only for AB 50 or larger). Weight approx. 190 kg	<b>7.744,00 €</b>
	37721	<b>Two-axis production table (810776) with copying device</b>	<b>9.091,00 €</b>
	37804	<b>Two-axis production table (816600) with copying device</b>	<b>9.540,00 €</b>
	37648	<b>Templates for positioning device</b> size 1 160 x 220 mm	<b>125,00 €</b>
	37630	size 2 290 x 220 mm	<b>170,00 €</b>
	37622	size 3 420 x 220 mm	<b>209,00 €</b>
	101.5	<b>Customised Hole Patterns</b> with hardened inserts A5 x 12, DIN 179, per hole	<b>58,00 €</b>
 <p>Compound table</p>	*)	<b>Compound Table</b> with drum grips for X and Y, with mm scale for X, Positioning accuracy 0.1 mm	
	810854 *)	<b>Size 200</b> cross traverse 160 mm, longitudinal traverse 240 mm Clamping area with coolant groove 430 x 240 mm, 3 T-slots Weight approx. 46 kg	<b>2.441,00 €</b>
	810856 *)	<b>Size 300</b> cross traverse 160 mm, longitudinal traverse 350 mm Clamping area with coolant groove 600 x 240 mm, 3 T-slots Weight approx. 56 kg	<b>2.731,00 €</b>
	810858 *)	<b>Size 400</b> cross traverse 240 mm, longitudinal traverse 470 mm Clamping area with coolant groove 800 x 240 mm, 3 T-slots Weight approx. 86 kg	<b>3.043,00 €</b>
	810860 *)	<b>Size 500</b> cross traverse 300 mm, longitudinal traverse 470 mm Clamping area with coolant groove 800 x 320 mm, 4 T-slots Weight approx. 122 kg	<b>3.944,00 €</b>
	836682 *)	<b>Set of Mounting Bars</b>	<b>247,00 €</b>
	102.5	<b>Numerical Position Display</b> for Compound Table, sizes 400 and 500 with support hook for mounting to drilling machine, display in steps of 0,005 or 0.010 mm (switchable), incl. Preset and Memofix, covered incremental scales.	<b>7.478,00 €</b>
 <p>Vices 125/155</p>	10637	<b>Machine Vice, size 125</b> height 85 mm, width of jaws 125 mm, clamping width 155 mm, weight 14 kgs	<b>536,00 €</b>
	10660	<b>including prism jaws</b> (1 longitudinal and 2 cross prisms)	<b>620,00 €</b>
	42143	<b>Machine Vice, size 155</b> height 112 mm, width of jaws 155 mm, clamping width 230 mm, weight 29 kgs	<b>722,00 €</b>
	42168	<b>including prism jaws</b> (1 longitudinal and 2 cross prisms)	<b>753,00 €</b>
		<b>Packing Two-axis production table, B x T x H, 1200 x 800 x 450</b>	<b>49,00 €</b>
		<b>Packing Compound table 200, B x T x H, 800 x 600 x 400</b>	<b>49,00 €</b>
		<b>Packing Compound table 300-500, B x T x H, 1200 x 800 x 400</b>	<b>49,00 €</b>

\*) Mounting possibilities to different machines to be checked! Subject to change without notice (see page 36, matrix).


Prices are not valid for retrofitting orders and retrofitting works.

## Machine vice

	<b>137067</b>	<b>Machine Vice Type BON with prism jaws size 1</b> height 60 mm, width of jaws 80 mm, clamping width 70 mm, weight 7,5 kg	<b>198,00 €</b>
	<b>137075</b>	<b>size 2</b> height 72 mm, width of jaws 100 mm, clamping width 110 mm, weight 9,5 kg	<b>351,00 €</b>
	<b>137083</b>	<b>size 3</b> height 80 mm, width of jaws 125 mm, clamping width 130 mm, weight 13,5 kg	<b>526,00 €</b>
	<b>137091</b>	<b>size 4</b> height 95 mm, width of jaws 160 mm, clamping width 220 mm, weight 25 kg	<b>887,00 €</b>


Vice BON

## Quick action drill chucks SUPRA


	<b>138107</b>	Type 136 clamping width 1-13 mm B 16	<b>108,00 €</b>
	<b>140251</b>	Type 136 clamping width 3-16 mm B 16	<b>127,00 €</b>
	<b>150466</b>	Type 136 clamping width 3-16 mm B 18	<b>127,00 €</b>
	<b>189290</b>	Type 136 clamping width 0-10 mm B 16	<b>125,00 €</b>

Permitted for spindle Rpm range up to max. 5000 rpm.  
Not suitable for CCW rotation.


## Tapers KD, DIN 238 for quick action drill chucks SUPRA

	<b>138115</b>	Type 236 MT 2 B 16	<b>15,00 €</b>
	<b>139048</b>	Type 236 MT 3 B 16	<b>15,00 €</b>
	<b>150474</b>	Type 236 MT 3 B 18	<b>15,00 €</b>
	<b>160820</b>	Type 236 MT 4 B 16	<b>19,00 €</b>
	<b>320283</b>	Type 236 MT 4 B 18	<b>19,00 €</b>

## Reduction inserts RH, DIN 2185

	<b>161075</b>	Type 261 N MT 2/1	<b>20,00 €</b>
	<b>190256</b>	Type 261 N MT 3/1	<b>20,00 €</b>
	<b>150482</b>	Type 261 N MT 3/2	<b>20,00 €</b>
	<b>160838</b>	Type 261 N MT 4/1	<b>30,00 €</b>
	<b>160846</b>	Type 261 N MT 4/2	<b>30,00 €</b>
	<b>160853</b>	Type 261 N MT 4/3	<b>30,00 €</b>

## Expeller for taper DIN 228

	<b>81950</b>	MT 2	<b>13,00 €</b>
	<b>150490</b>	MT 3	<b>19,00 €</b>
	<b>161018</b>	MT 4	<b>32,00 €</b>

## Semi-automatic expeller for morse taper DIN 228

	<b>17277</b>	MT 1 - 3	<b>113,00 €</b>
	<b>18952</b>	MT 3 - 6	<b>130,00 €</b>

## Special equipment

Pos.	Description	AX 2-T/S	AX 2/S	AX 3/S, AX 3/SV	AX 4/SV	AB 26/SV	AB 34/SV-HST AB 40/SV-HST	AB 50/SV, AB 50/HST
17.	Foot Emergency-OFF Switch	223,-	223,-	223,-	223,-	223,-	223,-	223,-
21.	Control Transformer, for special voltages only	437,-	437,-	437,-	437,-	437,-	437,- #	437,-
22.	Light Transformer for special voltages only	437,-	437,-	437,-	437,-	437,-	437,- #	437,-
41.	° Machined Base Plate with clamp surface and 2 T-slots	-	631,-	631,-	631,-	631,-	631,-	-
44.0	° Combination Sq. Table (440 x 440 mm), for drilling under angles with an opposite-side sliding vice with clamping width 130 mm, including prism jaws, clamp surface 350 x 350 mm, Net weight increases by approx. 80 kg	-	-	2.386,-	2.386,-	2.386,-	2.386,-	2.386,-
48.2	Flange quill with double return spring for weight compensation. AX 3 up to 25 kg, AX 4 up to 40 kg, AB 50 up to 50 kg	-	-	898,-	898,-	-	-	1.092,-
48.5.1	Flange quill with stronger return spring for weight compensation up to 10 kg	-	-	-	-	1.023,-	1.023,-	-
01.	Special Painting DD-Brillant, (small parts DD-structured)	1.204,-	1.204,-	1.204,-	1.204,-	1.204,-	1.204,-	1.204,-
02.	Special Painting DD-structured	799,-	799,-	799,-	799,-	799,-	799,-	799,-
05.	Special Voltages	<b>upon request</b>						

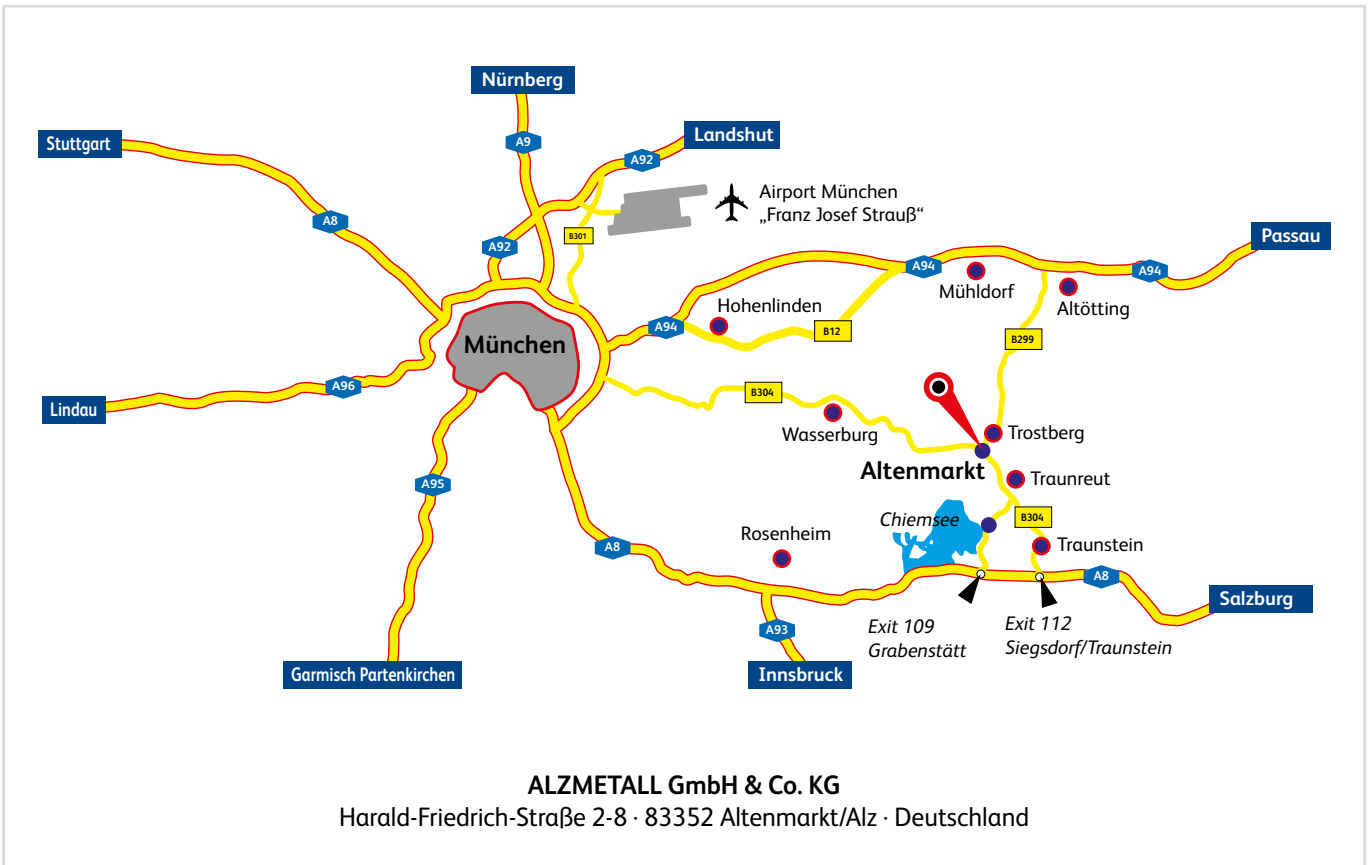
*Special equipments upon request. Prices are not valid for retrofitting orders and retrofitting works.  
° only for round column types; # with AB 40 standard*

### Decision matrix for mounting compound tables and two-axis production table; Versions see page 36

Size	Nr.	ALZTRONIC	ALZSTAR 18 T/S	ALZSTAR 23 T/S	ALZSTAR 23/S	ALZSTAR 30/S	ALZSTAR 40/S(V)	
200	810854	-	-	••	••	•	•	
300	810856	-	-	-	-	•	•	
400	810858	-	-	-	-	•	•	
500	810860	-	-	-	-	-	-	
Größe	Nr.	AX 2-T/S	AX 2/S	AX 3/S(V)	ALZFLOW 30	AB 26/SV		
200	810854	••	••	•	•	•		
300	810856	-	-	•	•	•		
400	810858	-	-	•	•	•		
500	810860	-	-	-	-	-		
Größe	Nr.	AX 4/SV	AB 34/SV	AB 34/HST	AB (FLOW) 40/SV	AB (FLOW) 40/HST	AB 50/SV	AB 50/HST
200	810854	-	-	-	-	-	-	-
300	810856	-	-	-	-	-	-	-
400	810858	•	•	-	•	-	•	-
500	810860	-	-	•	-	•	•	•
Production table	810776	•	•	•	•	•	•	•
Production table	816600	-	-	•	-	•	•	•

- = mounting not possible, • = mounting possible, •• = possible only with mounting bars. Surcharge for two mounting bars, see Page 34, Pos. 101.7 Attention: For models with combi table 44.0, this matrix is not valid!

## Where to find us



## Short notice of our delivery terms

- All prices are in EURO.
- Former price lists are no more valid.
- All prices are in Euro, FCA Altenmarkt/Alz , and do not include insurance, packing or any taxes and duties
- Lacquer: DD-structured signal white RAL 9003, PANTONE 7545c, black.
- CE Norms are applied.
- Standardly equipped for 400 V, 50 Hz networks, (with ALZTRONIC for 230 V, 50 Hz).
- Every machine is delivered with : Operator's Manual , Conformity Declaration, grease and lubrication table, anchor plan
- Machines may be constructed and equipped according to customer's internal specifications. These are only upon request and do need special offers and pricings.
- For transport safety reasons ALZMETALL does not deliver machines that contain oil. Oil only in separate bins.
- Only our general conditions for the supply of machinery for national and international transactions are valid.
- Any prices are not applying to retrofit orders (accessories, options, spare/wear parts) or any assembly/modification works.

### Machining centres



GS 600

### CNC Rapid Radial Drilling Machines



Donau Werkzeugmaschinen GmbH  
83352 Altenmarkt, [www.donau-wzm.de](http://www.donau-wzm.de)

### Machining centres



GS 600 / GS 800 / GS 1000 / GS 1200 / GS 1400

### Foundry and processing technology



ALZMETALL is operating their proper foundry at 11.000 tons per year and is a sub-contractor for many industries. Activities consist of casting, machining, lacquering.

Your dealer



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