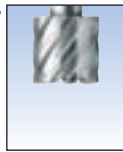


# MAB 825/845

Developed for steel engineering, plant construction and mechanical engineering.

Made in Germany



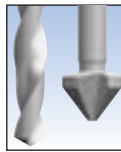
Core drill short,  
30 mm  
ø 12 - 100 mm



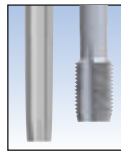
Core drill long,  
55 mm  
ø 12 - 100 mm



Core drill extra  
long, 110 mm  
ø 20 - 50 mm



Twist drill up to  
31,75 mm  
Countersinking  
up to 50 mm



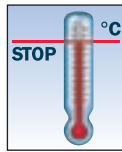
Reaming up to  
31,75 mm  
Thread cutting  
M30



Speed range 1:  
40 - 110 min<sup>-1</sup>  
Speed range 2:  
65 - 175 min<sup>-1</sup>  
Speed range 3:  
140 - 360 min<sup>-1</sup>  
Speed range 4:  
220 - 600 min<sup>-1</sup>



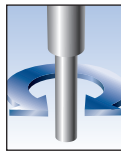
Full wave control  
electronics



Overheating pro-  
tection



Magnet indicator



CW/CCW opera-  
tion

## Pure power generation

1800 W motor and four-stage gear for high power requirements of magnetic core drilling.

- ▶ High power output
- ▶ Four-stage oil bath gear

## Infinitely variable

Torque control  
Full wave control electronics

## Selectable

...with easy gear selection.

## Quick drill change

KEYLESS quick-change drill chuck system for Weldon shank 19 mm ( $\frac{3}{4}$ "

## Correct oil dosage

Automatic internal lubrication right to the tip of the core drill.

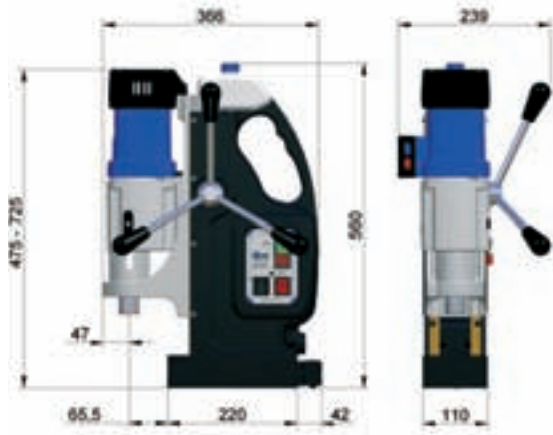


## Optimum protection

Integrated cutting oil reservoir.  
Complete cabling in the housing.

## Active safety

Unmistakable arrangement of switches Power and Magnetic adhesion.  
Visual indication of the magnetic adhesion.



#### MAB 825/ 845 Specification

Power:	1800 Watt
Morse taper:	MK 3
Voltage:	230 V AC, 50-60 Hz
Stroke:	255 mm
Magnet size:	110 x 220 x 54 mm
Permanent internal lubrication:	•
Weight:	25 kg

#### Order No.

**MAB 825/ 230 Volt:**

**MAB 825/ 110 Volt:**

#### MAB 845 Additional equipment:

Magnetic core drilling machine with rotating mechanism. Adjustable by 30° to both sides and longitudinal displacement by 20 mm

#### Order No.

**MAB 845/ 230 Volt:**

**MAB 845/ 110 Volt:**

#### MAB 825/845 Scope of delivery

- 1 Magnetic core drilling machine
- 1 Quick-change drill chuck system KEYLESS
- 1 Industrial arbor MT 3/  
32 mm Weldon shank
- 1 Ejector pin ZAK 075
- 1 Ejector pin ZAK 090
- 1 Ejector pin ZAK 100
- 1 Ejector pin ZAK 120
- 1 Steel carry case
- 1 Safety chain
- 1 Hexagon socket screw key SW 6
- 1 Drill drift MT 3
- 1 Operating manual
- 1 Warranty certificate



#### Quicklinks

Core drills	>> Page 48
Accessories	>> Page 68
Service	>> Page 46

## BDS:global

BDS magnetic core drilling machines are the first choice of many international shipbuilders. That comes down to the especially high drilling performance, the rugged construction and the extensive service. Performance counts!



# MAB 825/845

## The mainstay.

The MT3 tool holder allows the use of core drills, reamers, taps, countersinks and solid drills. Due to the extensive range of accessories, such as the vacuum clamping plate for non-magnetic surfaces or the tube clamping device, this machine is suitable for every kind of work.

The magnetic core drilling machine MAB 825 can be made even more flexible with the optional tube clamping device ZRO 500.

This clamping device guarantees best adhesion due to the tension chains and swivelling V-blocks. These V-blocks ensure a positive joining with the tube.

The perfect machine for pipeline engineering.

**Best application possibilities for repair work and special purpose mechanical engineering. Strong, powerful and flexible.**

The machines of the MAB 845 series are provided with a rotating mechanism. The foot, which can be rotated by 30° to both sides, can be moved forward or backward by 20 mm. That means utmost flexibility for the positioning of the machine in use: Attach the machine, secure it by means of the magnet and then position it precisely. This allows drilling work directly next to walls of the material.



Drilling with core drills



Countersinking



Reaming



Thread cutting



Drilling with twist drills



MAB 845: The foot, which can be rotated by 30° to both sides, can be moved forward or backward by 20 mm.





## BDS:profi

Core bores with large diameter



Vacuum clamping devices for non-ferrous metal with smooth surface, the optional accessory for MAB magnetic core drilling machines.

>> see Page 72



Vacuum clamping devices for non-ferrous metal with rough surface, the optional accessory for MAB magnetic core drilling machines.

>> see Page 72

### Feed:

- Slow starting phase, 1-2 mm
- Feed 50%

### Drilling:

- Lift the drill when running
- Remove chips, clean the borehole
- Fill the borehole with coolant
- Lower the drill when running
- Repeat several times, depending on the drilling depth

### Lubrication:

- High-performance cutting oil BDS 5000
- Lubricate continuously
- Additionally lubricate from the outside >> Page 80