



## CATALOG No. 64

### DRILLING MACHINES

## ABOUT ALZMETALL



ALZMETALL Germany



ALZMETALL Machine Tools (Taicang)  
Co. Ltd. China

ALZMETALL is a renowned company with an international reputation and global activities. For seven decades, we have been the leader in the technology for drilling, milling and casting. Our products have proven themselves many times in the general machine construction sector, the automotive industry and in the broad scene of medium-sized production companies.

The strengths of ALZMETALL are based upon the high quality of their products, delivery reliability, quick reaction times and prompt implementation of even the most unusual of customer wishes. Our main goals are satisfied and well-being customers. We strive to guarantee an extensive and lasting competitive advantage for our customers following our vision "we drive productivity".

## MACHINING CENTERS

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

ALZMETALL offers its support through extensive advices relating to the machines and their use, the tools and tool technology. Where others stop ALZMETALL goes that little bit further, addressing all technical and individual problem solutions.

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

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



## 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 200.000, they convince with their performance capabilities and leading technology.



*Flexible production cell with pallet changer station.  
In our production we are using machining centres from  
ALZMETALL, GROB, HELLER and STARRAG-HECKERT.*

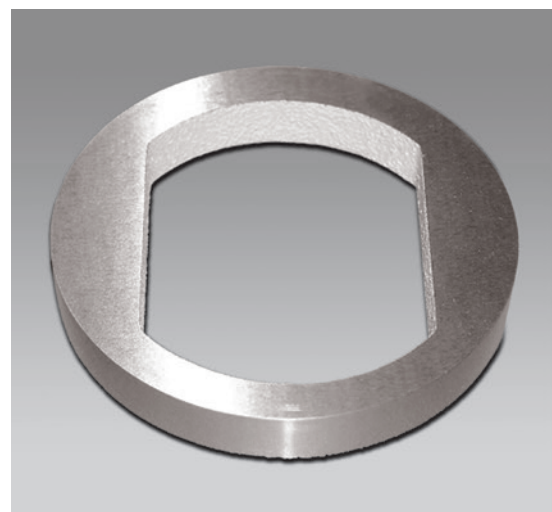


*Assembly line for drilling machines*

## 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
  - » Tilting of the tool shaft remains far below 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.



### EDUCATIONAL OPTIONS

#### ALZTRONIC

Fast precise **TABLE DRILLING MACHINES** 230 V for schools, trainees, laboratories, institutes and manufacture at a top entry-price.

#### 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

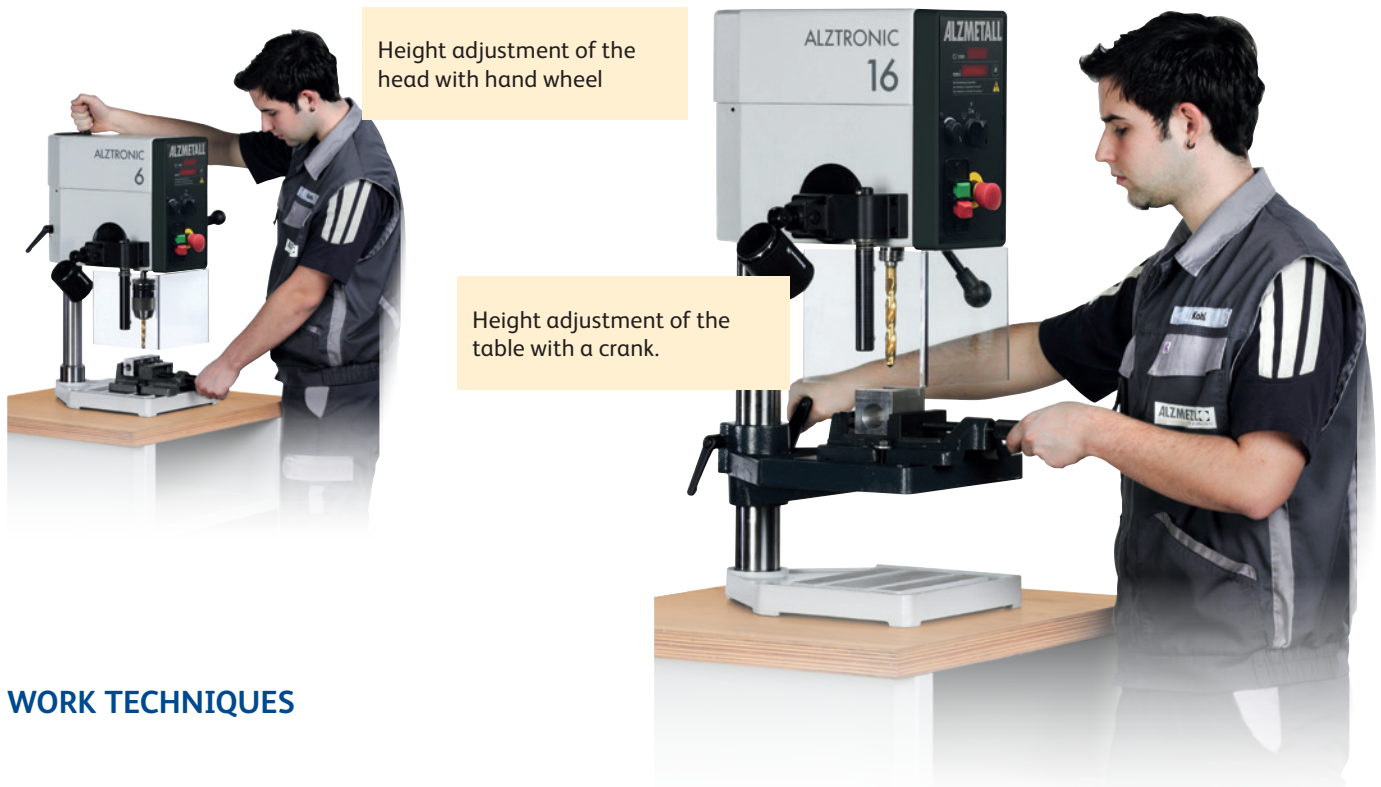
Special equipment

All photos with options

# Table of Contents

<b>Education with ALZMETALL - Machines</b> <b>Examples of options</b>	Automatic drill depth control, combination table, precision depth adjuster and fixed stop, belt technology, coolant device A, tapping, training contents	Page 6/7
<b>Bench Drilling Machines</b> ALZTRONIC 6/9/12/14/16	Drilling capacity 6/9/12/14/16 mm B 16 / Morse Taper 2	Page 8/9
<b>Bench and Column Drilling Machines</b> ALZSTAR 18/23/30/40	Drilling capacity 18/23/30/40 mm Morse Taper 2 / 3 / 4	Page 10/13
<b>Bench and Column Drilling Machines</b> AX 2/3/4	Drilling capacity 23/40/55 mm Morse Taper 2/3/4	Page 14/19
<b>Column and Semi-Box Column Drilling Machines</b> AB 26/34/40/50	Drilling capacity 30/40/50/60 mm Morse Taper 3/4	Page 20/25
<b>Column and Semi-Box Column Drilling Machines</b> ALZFLOW 30/AB-FLOW 40	Flowdrilling capacity 12/20 mm Morse Taper 3/4	Page 26/27
<b>Rapid Radial Drilling Machines</b> ALZSPRINT 30	Drilling capacity 30 mm Morse Taper 4	Page 28/29
<b>Radial Drilling Machines</b> AB 30/R-1000; AB 30/R-1400	Drilling capacity 45/50 mm Morse Taper 4	Page 30
<b>Multi-Head Drills</b> RFT 20/1 RFT 2 / RFT 3	Drilling capacity 23 – 55 mm Morse Taper 2, 3, 4	Page 31/33
(Sliding) cross tables, vices, drill chucks, adapters, ejectors, reducers		Page 34/35
for all drilling machines: foot switches, machine tables, special lacquer etc.		Page 36

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

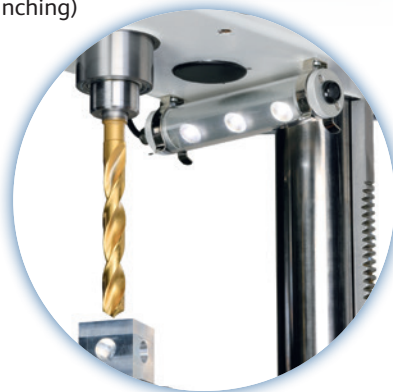


Height adjustment of the head with hand wheel

Height adjustment of the table with a crank.

### 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



LED lamp

### 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



Spindle protection electrically secured



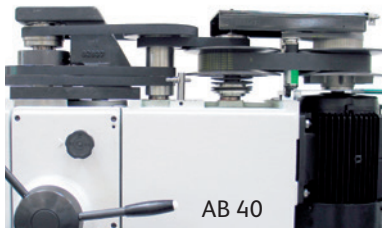
Spindle protection turned aside

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



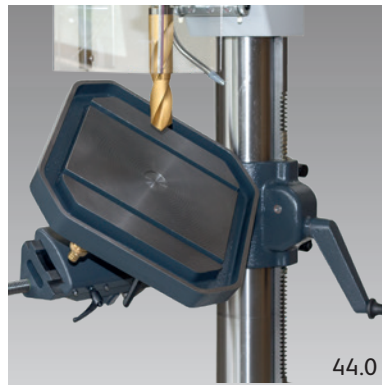
#### Automated drill depth program [ option ]

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



#### 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 speed. Upto 4000 rpm)



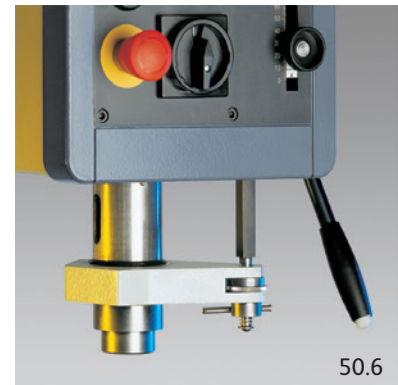
#### Combined drilling table [ option ]

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



#### Coolant supply-system A [ option ]

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)



#### Micro drilling depth setting and fixed stop [ option ]

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

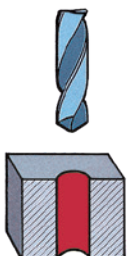


#### Tapping device [ option ]

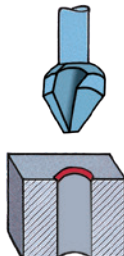
The tapping device upgrades these machines to a versatile and thus more economical application. The attachment enables the rotation direction of the drilling spindle to be altered from clockwise to anticlockwise – at any drilling depth setting – and changes back to clockwise rotation automatically at the spindle starting position. The thread depth can be controlled either by using the depth stop or the pedal switch (shown).

## TRAINING CONTENTS

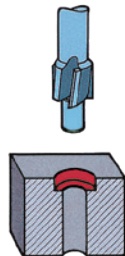
### Drilling



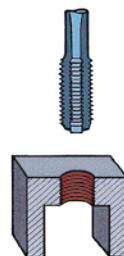
### Facing



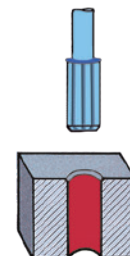
### Facing



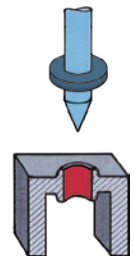
### Tapping



### Reaming



### Flow drilling



## BENCH DRILLING MACHINES WITH DRILL HEAD HEIGHT ADJUSTMENT

Drilling capacity 6/9/12 mm

Photo with options



	Bench drilling machine <b>ALZTRONIC 6</b>	Bench drilling machine <b>ALZTRONIC 9</b>	Bench drilling machine <b>ALZTRONIC 12</b>
<b>Drilling capacity steel E 335 (St 60)</b>	6 mm	9 mm	12 mm
<b>Tapping performance steel E 335 (St 60)</b>	M 6	M 8	M 10
<b>Drill chuck adapter (DIN 238)*</b>	B 16	B 16	B 16
<b>Z-travel of spindle</b>	40 mm	40 mm	40 mm
<b>Distance spindle to column</b>	200 mm	200 mm	200 mm
<b>Column diameter</b>	50 mm	50 mm	50 mm
<b>Machine table (intermediate)</b>	without	without	without
<b>Base plate, clamping area (width x depth)</b>	300 x 240 mm	300 x 240 mm	300 x 240 mm
<b>T-Slots, number x width x distance</b>	2 x 12 x 80 mm	2 x 12 x 80 mm	2 x 12 x 80 mm
<b>Distance spindle / base plate min. /max.</b>	110/250 mm	110/250 mm	110/250 mm
<b>Feed</b>	manual	manual	manual
<b>Drill head adjustment (trapezoid vice)</b>	wheel	wheel	wheel
<b>Height of the machine without options approx.</b>	670 mm	670 mm	670 mm
<b>Net weight approx.</b>	64 kg	64 kg	64 kg
<b>Drive System</b>	infinitely variable	infinitely variable	infinitely variable
<b>Motor</b>	<b>0,54 kW</b>	<b>0,54 kW</b>	<b>0,54 kW</b>
<b>Spindle Rpm range</b>	700 - 10000 rpm	390 - 6500 rpm	250 - 5000 rpm
<b>Price of the machine without options</b>	<b>EUR 2.445,-</b>	<b>EUR 1.350,-</b>	<b>EUR 1.878,-</b>

### Standard Equipment:

AC motor 230 Volt, 50 Hz or 60 Hz  
**Digital RPM** Read-out (LED)  
**Infinitely variable** speed drive  
**Reverse switch** for tapping  
**Spindle protection** electrically secured  
**ON/OFF switch**

**EMERGENCY-OFF switch**  
**Plug**, fully assembled, cable length 3 m  
**Lacquer**: DD-structured grey RAL 7035, anthracite RAL 7016, black  
**Stable carton, width x depth x height**: approx. 800 x 600 x 1050 mm,  
 weight net. approx. 10 kg

### Options:

<b>09.</b>	<b>Table/Bench</b> , w x d x h 700 x 600 x 840 mm, Net weight approx. 48 kg / Package weight approx. 16 kg	<b>EUR 414,-</b>
<b>12.1</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>EUR 317,-</b>
<b>37.1</b>	<b>Digital drilling depth read-out</b> , 0-fixation (drill start), 4 position LED-display, characters 13 mm high	<b>EUR 229,-</b>
<b>800481</b>	<b>Quick action drill chucks SPIRO SK 10</b> , with B 16 inner bore*, clamping 0-10 mm, suitable for up to 10.000 rpm and right – left rotation.	<b>EUR 142,-</b>
<b>800483</b>	<b>Quick action drill chucks SPIRO SK 13S</b> , with B 16 inner bore*, clamping 1-13 mm, suitable for up to 8.000 rpm and right – left rotation.	<b>EUR 156,-</b>



## BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 14/16 mm

Photo with options



	Bench drilling machine <b>ALZTRONIC 14</b>	Bench drilling machine <b>ALZTRONIC 16</b>
<b>Drilling capacity steel E 335 (St 60)</b>	14 mm	16 mm
<b>Tapping performance steel E 335 (St 60)</b>	M 10	M 12
Short spindle	MT 2	MT 2
Z-travel of spindle	80 mm	80 mm
Distance spindle to column	190 mm	190 mm
Column diameter	65 mm	65 mm
Machine table (intermediate), clamping area (width x depth)	300 x 240 mm	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm	2 x 12 x 80 mm
Distance spindle / table min. /max.	75/357 mm	75/357 mm
Base plate, clamping area (width x depth)	300 x 240 mm	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm	2 x 12 x 80 mm
Distance spindle / base plate min. /max.	437/437 mm	437/437 mm
Feed	manual	manual
Machine table (intermediate) Height adjustment	Crank	Crank
Height of the machine without options approx.	825 mm	825 mm
Net weight approx.	83 kg	83 kg
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor</b>	<b>0,54 kW</b>	<b>0,54 kW</b>
Spindle Rpm range	230 - 4.000 rpm	100 - 2.000 rpm
<b>Price of the machine without options</b>	<b>EUR 2.085,-</b>	<b>EUR 2.369,-</b>

### Standard Equipment:

**AC motor** 230 Volt, 50 Hz or 60 Hz

**Digital RPM Read-out (LED)**

**Infinitely variable** speed drive

**Reverse switch** for tapping

**Spindle protection** electrically secured

**ON/OFF switches**

**EMERGENCY-OFF switch**

**Plug**, fully assembled, cable length 3 m

**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, black

**Stable carton, width x depth x height:** approx. 800 x 600 x 1050 mm, weight net. approx. 10 kg

### Options:

<b>09.</b>	<b>Table/Bench</b> , w x d x h 700 x 600 x 840 mm, Net weight approx. 48 kg / Package weight approx. 16 kg	<b>EUR 414,-</b>
<b>12.1</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>EUR 317,-</b>
<b>37.1</b>	<b>Digital drilling depth read-out</b> , 0-fixation (drill start), 4 position LED-display, characters 13 mm high	<b>EUR 229,-</b>

Quick action drill chucks and tapers see Page 8 and Page 35.

## 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
Tapping performance steel E 335 (St 60)	M 12
Tapping performance cast iron EN-GJL-200 (GG 20)	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	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>EUR 2.450,-</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)  
**Self-Locking Mushroom Button** for Emergency-Off  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, 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>EUR 414,-</b>
<b>12</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>EUR 317,-</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>EUR 28,-</b>

## BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 23 mm

*Photo with options*



	Bench drilling machine <b>ALZSTAR 23-T/S</b>
<b>Drilling capacity steel E 335 (St 60)</b>	23 mm
Tapping performance <b>steel E 335 (St 60)</b>	M 14
Tapping performance <b>cast iron EN-GJL-200 (GG 20)</b>	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	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>EUR 4.386,-</b>

### Standard Equipment:

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

**Protection class IP 54**  
**Plug** (fully assembled, Cable length 2 m)  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
 anthracite RAL 7016, black

### Options:

<b>09.1</b>	<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>EUR 737,-</b>
<b>12.</b>	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>EUR 317,-</b>
<b>25.</b>	<b>Coolant Attachment B</b> , separate container (33 l), with overload-protected pump and accessories	<b>EUR 412,-</b>
<b>08.</b>	<b>Packaging</b> , disposable L x W x H 1100 x 800 x 1400 mm, weight net. approx. 45 kg	<b>EUR 35,-</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</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>EUR 4.553,-</b>	<b>EUR 5.274,-</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>EUR 5.482,-</b>

### Standard Equipment:

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

Protection class IP 54  
 Plug (fully assembled, cable length 2m)  
 Spindle protection electrically secured  
 Lacquer: DD-structured grey RAL 7035,  
 anthracite RAL 7016, black

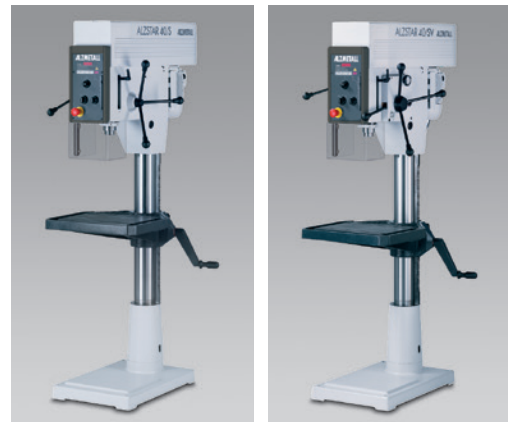
### Options:

12.	LED machine light, adjustable angle, 230 V, IP 65	EUR 317,-
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump and accessories	EUR 412,-
03.	Anchoring set	EUR 182,-
08.	Packaging disposable, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg	EUR 99,-

## COLUMN DRILLING MACHINES

Drilling capacity 40 mm

Photo with options



	Column Drilling Machine <b>ALZSTAR 40/S</b>	Column Drilling Machine <b>ALZSTAR 40/SV</b>
<b>Drilling capacity steel E 335 (St 60)</b>	40 mm	40 mm
Tapping performance <b>steel E 335 (St 60)</b>	M 24	M 24
Tapping performance <b>Cast iron EN-GJL-200 (GG 20)</b>	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	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
<b>Drive System</b>	infinitely variable	infinitely variable
<b>Motor:</b> n = 1500 / 3000 rpm	<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>EUR 5.789,-</b>	<b>EUR 6.523,-</b>

### Standard Equipment:

**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)

**Protection class IP 54**  
**Plug** (fully assembled, cable length 2 m)  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
 anthracite RAL 7016, black  
**Machine oil** (ALZSTAR 40/SV)

### Options:

12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	<b>EUR 317,-</b>
25.	<b>Coolant Attachment B</b> , separate container (33 l), with overload-protected pump and accessories	<b>EUR 412,-</b>
47.1.2 4	<b>Short spindle MT4</b>	<b>EUR 299,-</b>
03.	<b>Anchoring set</b>	<b>EUR 182,-</b>
08.	<b>Disposable packaging</b> , L x B x H 1200 x 800 x 2100 mm. net weight approx. 75 kg	<b>EUR 99,-</b>

## 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	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>EUR 4.821,-</b>	<b>EUR 4.950,-</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>EUR 4.821,-</b>	<b>EUR 4.950,-</b>

Drilling heads (height adjustable) for Multi-Head Systems RFT page 32

### Standard Equipment:

**Main switch** lockable with overload protection switch  
**Self-Locking Mushroom Button** for Emergency-Off  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Protection class IP 54**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, black

## OPTIONS

09.1	Table/Bench, W x D x H 750 x 700 x 840 mm (weight approx. 66 kg)	EUR	737,-
10.	Spindle Reverse Switch for counter-clockwise rotation with 0-Position (not with pos. 20.0 + 20.1)	EUR	28,-
12.	LED machine light, adjustable angle, 230 V, IP 65	EUR	317,-
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	EUR	765,-
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	EUR	914,-
24.	Coolant Attachment A*, consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump and accessories (only for AX 2/S)	EUR	839,-
25.	Coolant Attachment B, consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
37.1	Digital Depth Read-Out, O-fixation (drill start), 5 position LED-Display, characters 13 mm high	EUR	467,-
50.6	Precision Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm (spindle stroke reduced by 20 mm)	EUR	428,-
03.	Anchoring set for AX 2/S	EUR	182,-
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	EUR EUR	35,- 99,-

\*) = Net weight increases with 80 kg

Special equipment Page 36

Special Accessories Page 34/35

## 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	515 x 360 mm	515 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:</b> n = 750 / 1500 rpm	<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>EUR 6.149,-</b>	<b>EUR 7.190,-</b>
<b>Motor:</b> n = 1500 / 3000 rpm	<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>EUR 6.149,-</b>	<b>EUR 7.190,-</b>

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

### Standard Equipment:

<b>Main switch (lockable) with Overload Protection Switch</b>	<b>Protection class IP 54</b>
<b>Self-Locking Mushroom Button</b> for Emergency-Off	<b>Spindle protection</b> electrically secured
<b>Infinitely variable speed drive</b> , mechanical variator	<b>Lacquer:</b> DD-structured grey RAL 7035, anthracite RAL 7016, black
<b>Digital RPM Read-out</b>	<b>Machine oil</b> (AX 3/SV)
<b>Feed overload clutch</b> (AX 3/SV)	



## OPTIONS

10.	<b>Spindle Reverse Switch for counter-clockwise rotation with 0-Position</b> (not with pos. 20.0 + 20.1)	EUR	28,-
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	EUR	317,-
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)	EUR	765,-
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)	EUR	914,-
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump and accessories	EUR	763,-
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
37.1	<b>Digital Depth Read-Out</b> 0-fixation (drill start), 5 position LED-Display, characters 13 mm high	EUR	549,-
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)	EUR	496,-
47.1.2	<b>Short spindle MT4</b>	EUR	299,-
50.6	<b>Precision Depth Adjuster and fixed stop</b> Precision adjustment to 0,1 mm	EUR	258,-
03.	<b>Anchoring set</b>	EUR	182,-
08.	<b>Wooden packing, disposable</b> L x W x H 1200 x 800 x 2100 mm, Net weight approx. 75 kg	EUR	99,-

\*) = net weight increases with 80 kg

Special Equipment Page 36

Special Accessories Page 34-35

## COLUMN DRILLING MACHINE

Drilling capacity 55 mm

Photos with options



	Column Drilling Machine <b>AX 4/SV</b>	With 3 kW motor
<b>Drilling capacity steel E 335 (St 60)</b>	55 mm	55 mm
Tapping performance steel E 335 (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 30	M 42
Tapping performance Cast iron EN-GJL-200 (GG 20) <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	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>EUR 10.072,-</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>EUR 11.009,-</b>

Drilling heads for Multi-Head-Systems RFT, page 31/33

### Standard Equipment:

**Main switch** with Overload Protection Switch, lockable  
**Self-Locking Mushroom Button** for Emergency-Off  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**  
**Protection class IP 54**

**Feed overload protection clutch**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
 anthracite RAL 7016, black  
**Machine oil**

## OPTIONS

10.	<b>Spindle Reverse Switch for counter-clockwise rotation with 0-Position</b> (not with pos. 20.0 + 20.1)	EUR	28,-
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	EUR	317,-
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	765,-
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	914,-
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump and accessories	EUR	763,-
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
37.1	<b>Digital Depth Read-Out 0-fixation</b> (drill start), 5 position LED-Display, characters 13 mm high	EUR	549,-
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)	EUR	496,-
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	EUR	258,-
03.	<b>Anchoring set</b>	EUR	182,-
08.	<b>Wooden packing, disposable</b> L x W x H 1200 x 800 x 2100 mm, Net weight approx. 75 kg	EUR	99,-

\*) = net weight increases with 60 kg

Special Equipment Page 36


Special Accessories Page 34-35

## 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
<b>Tapping performance steel E 335* (St 60)</b> <i>(Option 20.0 or 20.1 required)</i>	M 20	M 24	M 24
<b>Tapping performance 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	515 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	138/688 mm	266/928 mm
Column diameter / Box Column Dimensions	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>EUR 8.900,-</b>	<b>EUR 10.109,-</b>	<b>EUR 14.985,-</b>
<b>Motor:</b> n = 500/1500 rpm	<b>0,5 / 1,5 kW</b>	<b>0,6 / 1,8 kW</b>	<b>0,6 / 1,8 kW</b>
Spindle Rpm range	80-2200 rpm	70-1800 rpm	70-1800 rpm
<b>Attention: reduced drilling and tapping performance at n = 500 rpm</b>			
<b>Price of the machine without options</b>	<b>EUR 9.127,-</b>	<b>EUR 10.939,-</b>	<b>EUR 15.815,-</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 without options incl. Option 37.3</b>	<b>EUR 10.580,-</b>	<b>EUR 11.789,-</b>	

### Standard Equipment:

**Electro-magnetic feed clutch** with overload protection and Electrical Cross Handle Switches  
**Main switch** lockable  
**Overload Protection Switch**  
**Self-Locking Mushroom Button** for Emergency-Off switch  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Protection class IP 54**  
**Motor Protection Class „F“ (15°)**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, black  
**Machine oil**

**Autodigit: Automatic Drill Depth Control** with Drill Depth programming, interval drilling and free cutting possibility. Settings by means of Digi-Pot, Digital Read-Out, includes Position 37.1

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

## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation with 0-position</b> (not with pos. 20.0 + 20.1)	EUR	28,-
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	EUR	317,-
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	765,-
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	914,-
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm, and 2 slots, overload protected pump and accessories (for AB 26/SV and AB 34/SV only)	EUR	763,-
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
37.1	<b>Digital Depth Read-Out</b> 0-fixation (drill start), 5 position LED-Display, characters 13 mm high	EUR	549,-
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	EUR	1.680,-
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)	EUR	496,-
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	EUR	258,-
03.	<b>Anchoring set</b>	EUR	182,-
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	EUR	194,-
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	EUR	99,-


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

## 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	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 Dimensions	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>EUR 12.540,-</b>	<b>EUR 16.392,-</b>
<b>Motor:</b> n = 750/1500 rpm	<b>1,8 / 2,9 kW</b>	<b>1,8 / 2,9 kW</b>
Spindle Rpm range	200-3200 rpm	200-3200 rpm
<b>Price of the machine without options</b>	<b>EUR 12.540,-</b>	<b>EUR 16.392,-</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>EUR 13.428,-</b>	<b>EUR 17.280,-</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 without options inkl. Option 37.3</b>	<b>EUR 14.220,-</b>	

### Standard Equipment:

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

**Electrical Rpm settings** (without lever)  
**Protection class IP 54**  
**Motor Protection Class „F“ (155°)**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
anthracite RAL 7016, black  
**Machine oil**

**Autodigit: Automatic Drill Depth Control** with Drill Depth programming, interval drilling and free cutting possibility.  
Settings by means of Digi-Pot, Digital Read-Out, includes Position 37.1

\* Performance data for motor n=750/1500 rpm (with gear)

## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation</b> with 0-position (not with pos. 20.0 + 20.1)	EUR	178,-
12.	<b>LED machine light</b> , adjustable angle, 230 V, IP 65	EUR	317,-
20.0	<b>Tapping Attachment w/o foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	452,-
20.1	<b>Tapping Attachment with reverse foot switch</b> , max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	601,-
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump and accessories (for AB 40/SV only)	EUR	763,-
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
37.1	<b>Digital Depth Read-Out</b> , 0-fixation (drill start), 5 position LED-Display, characters 13 mm high	EUR	549,-
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	EUR	1.680,-
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (for AB 40/SV only)	EUR	496,-
50.6	<b>Precision Depth Adjuster and fixed stop</b> , Precision adjustment to 0,1 mm	EUR	258,-
50.1	<b>Special feeds</b> 0,05 - 0,10 - 0,15 - 0,20 mm/Rot.	EUR	396,-
03.	<b>Anchoring set</b>	EUR	182,-
07	<b>Wooden packing, disposable for AB 40/HST</b> L x W x H 2400 x 1000 x 1500 mm, net weight approx. 135 kg	EUR	194,-
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	EUR	99,-

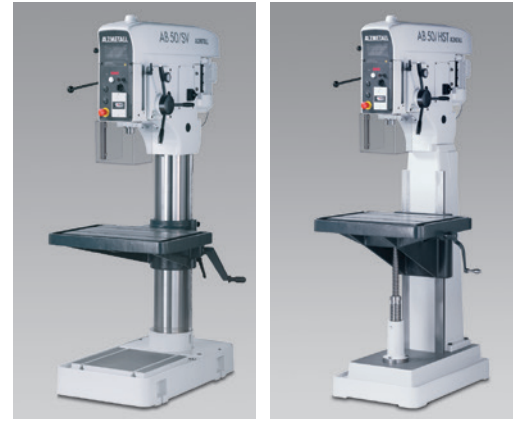
\*) = net weight increases with 60 kgs (AB 40/SV)

Special Equipments Page 36  
Special Accessories Page 34-35

## 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>
Drilling performance steel E 335* (St 60)	50 mm	50 mm
Drilling performance Cast iron EN-GJL-200* (GG 20)	60 mm	60 mm
Drilling capacity steel E 335* (St 60)	60 mm	60 mm
Tapping performance steel E 335* (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 42	M 42
Tapping performance Cast iron EN-GJL-200* (GG 20) <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	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	138/874 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>EUR 15.303,-</b>	<b>EUR 19.210,-</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>EUR 15.303,-</b>	<b>EUR 19.210,-</b>

### Standard Equipment:

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

**Protection class IP 54**  
**Machined Base Plate**, with T-slots (AB 50/SV only),  
clamping area 380 x 450 mm  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
anthracite RAL 7016, black  
**Machine oil**

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



## OPTIONS

10.	<b>Spindle Reverse switch for counter-clockwise rotation</b> with 0-position (not with pos. 20.0 + 20.1)	EUR	28,-
12.	<b>LED machine light,</b> adjustable angle, 230 V, IP 65	EUR	317,-
20.0	<b>Tapping Attachment w/o foot switch,</b> max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	843,-
20.1	<b>Tapping Attachment with reverse foot switch,</b> max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR	994,-
24.	<b>Coolant Attachment A*</b> , consisting of: Coolant Base plate with machined surface 450 x 460 mm and 2 slots, overload protected pump and accessories (for AB 50/SV only)	EUR	763,-
25.	<b>Coolant Attachment B</b> , consisting of: separate container (33 l), with overload protected pump and accessories	EUR	412,-
42.	<b>Column extension + 200 mm</b> (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (for AB 50/SV only)	EUR	595,-
50.6	<b>Precision Depth Adjuster and fixed stop.</b> Precision adjustment to 0,1 mm	EUR	258,-
03.	<b>Anchoring set</b>	EUR	182,-
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	EUR	194,-
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	EUR	171,-

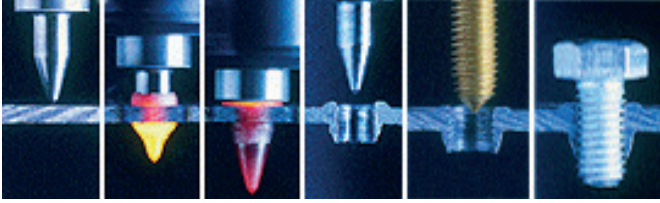
\*) = net weight increases with 115 kgs (AB 50/SV)

Special Equipments Page 36  
Special Accessories Page 34-35

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

Flow Drilling capacity 12 mm  
Photos with options

Chipless flow drilling and cold roll threading



	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	515 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
Motor: 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>EUR 5.639,-</b>

### Standard Equipment:

**Self-Locking Mushroom Button** for Emergency-Off switch  
**Reverse switch** for tapping  
(not available with option 20.0 or 20.1)  
**Overload Protection Switch**  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Protection class IP 54**  
**Connector** (fully assembled, cable length 2m)  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035,  
anthracite RAL 7016, black

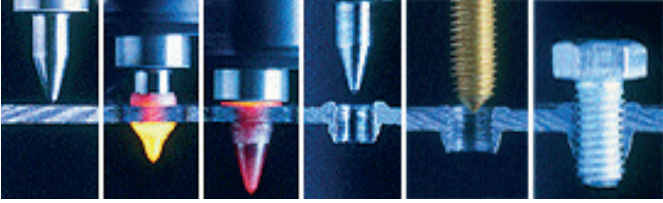
### Options

12. LED machine light, adjustable angle, 230 V, IP 65	EUR 317,-
20.0 Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed)	EUR 1.098,-
20.1 Tapping Attachment with reverse foot switch, max. 6 tapped holes per minute	EUR 1.246,-
25. Coolant Attachment B, consisting of: separate container (33 l), with overload protected pump and accessories	EUR 412,-
03. Anchoring set	EUR 182,-
08. Packing, disposable, L x W x H 1200 x 800 x 2100 mm, net weight approx. 75 kg	EUR 99,-

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

Flow Drilling capacity 20 mm  
Photos with options

Chipless flow drilling and cold roll threading



	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) (Option 20.0 or 20.1 required)	M 20 mm	M 20 mm
Drilling capacity steel E 335 (St 60)	40 mm	40 mm
Tapping performance steel E 335 (St 60) (Option 20.0 or 20.1 required)	M 30	M 30
Tapping performance Cast iron EN-GJL-200 (GG 20) (Option 20.0 or 20.1 required)	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 dimensions	145 mm	290 x 325 mm
Table clamping area	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	267/947 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
Motor: 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>EUR 13.498,-</b>	<b>EUR 17.665,-</b>

### Standard Equipment:

**Electro-Magnetic automatic feed switch at cross handle** with overload protection  
**Control and Light Transformer 24 V**  
**Main switch lockable**  
**Self-Locking Mushroom Button** for Emergency-Off  
**Infinitely variable speed drive**, mechanical variator  
**Digital RPM Read-out**

**Electrical rpm settings** (without lever)  
**Protection class IP 54**  
**Motor Protection Class „F“ (155°)**  
**Spindle protection** electrically secured  
**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, black  
**Machine Oil**

### Options

<b>12.</b> LED machine light, adjustable angle, 230 V, IP 65	EUR 317,-
<b>20.2</b> Tapping Attachment w/o foot switch, max. 6 tapped holes per minute, with soft reverse	EUR 1.720,-
<b>20.3</b> Tapping Attachment (as 20.2) but with foot switch	EUR 1.870,-
<b>25.</b> Coolant Attachment B, consisting of: separate container (33 l), with overload protected pump and accessories	EUR 412,-
<b>37.3</b> Automatic Drill Depth Control with: Drill Depth programming, interval drilling and free cutting possibility. Settings by means of Digi+Pot, Digital Read-Out	EUR 1.680,-
<b>50.6</b> Precision Depth Adjuster and fixed Stop precision adjustment to 0,1 mm	EUR 258,-
<b>51.1</b> Special feeds 0,05 - 0,10 - 0,15 - 0,20 mm/Rev.	EUR 396,-
<b>03.</b> Anchoring set	EUR 182,-
<b>07.</b> Packaging, disposable / AB-FLOW 40/HST, L x W x H 2400 x 1000 x 1500 mm, weight approx. 135 kg	EUR 194,-
<b>08.</b> Packaging, disposable / AB-FLOW 40/SV, L x W x H 1200 x 800 x 2100 mm, weight approx. 75 kg	EUR 99,-

## RAPID RADIAL DRILLING MACHINE

Drilling performance 30 mm

*Photos with options*



Rapid Radial Drilling Machine <b>ALZSPRINT 30</b>	
<b>Drilling performance steel E 335* (St 60)</b>	30 mm
<b>Drilling performance Cast iron EN-GJL-200* (GG 20)</b>	32 mm
*) Performance data based on $\varnothing$ 30 mm, n=210 rpm, $f_n=0,15$ mm/Rot.	
<b>Tapping performance steel E 335 (St 60)</b>	M 24
Short spindle	MT 4
Z-travel of spindle	140 mm
Column height adjustment (electrical)	400 mm
Arm travel (radius)	900 mm
Table clamping area	
in front: w x d x h	1200 x 600 x 905 mm
T-slots: number x weight x distance	4 x 18 x 125 mm
3 feeds	0,075-0,15-0,30 mm/Rot.
Net weight approx.	2300 kg
<b>Drive System</b>	Stepped gear drive
<b>Motor:</b> n = 1500/3000 rpm	<b>1,0/1,6 kW</b>
18 spindle Rpm speeds	60/100/130/150/210/240/305/ 390/490/565/635/800/1030/ 1150/1300/1490/2100/3050 rpm
<b>Price of the machine without options</b>	<b>EUR 34.709,-</b>

### Standard Equipment:

**Self-Locking Mushroom Button** for Emergency-Off  
**Protection class IP 54**  
**Electro-magnetic feed clutch (button)**  
**Tapping device** with double return speed  
**Control transformer** (VDE 0113)  
**Spindle protection** electrically secured

**Main switch** lockable  
**Central clamp** (hydraulics) for both angle and radius  
**Machine light**  
**Lacquer:** DD-structured grey RAL 7035,  
 anthracite RAL 7016, black  
**Machine oil**

## ALZSPRINT 30 extension

## Description

## 3.15 Positioning Assistance

(Price: as per options below)



## Functions:

- 2-D Probing of workpiece edges
- Programming of coordinates as X-Y-values or as radius and angular values with drill/tap hole pattern cycle functions
- Programming in absolute or incremental values
- Alignment function / Axis orientation
- Zero setting and Zero off-set
- Languages: German, English, French, Spanish
- Two individual hydraulic clamping circuits for radius movement and for angular movement

## Included equipment:

- Digital position readout X/Y/Z (Heidenhain)
- Softkeys
- USB-Interface (Type A)
- Monochrome flat screen for value display
- Bracket for position readout apparatus
- Electronical probe KT 130 with holder and anti-rotation sensor
- Rotation angle measurement system for the column
- Linear length measurement system for the radial arm
- Rotary encoder for depth sensing the quill/spindle movement
- Hydraulic system extension for two separate clamping circuits
- Assembling, mounting and system calibration

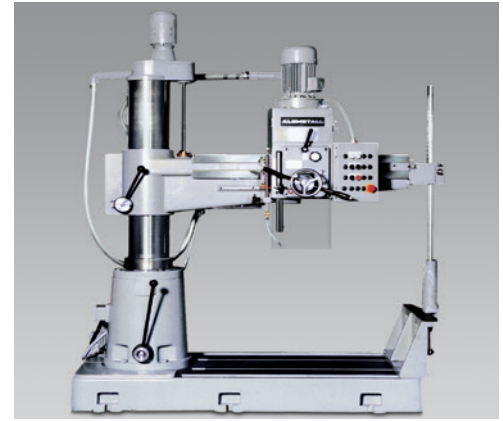
## OPTIONS

1.10	<b>Levelling elements for the basic machine</b> Consisting of: Base plates, lock-levelling nuts, O-rings, anchors, composite cement cartridges. (1 set = 5 elements)	EUR	520,-
1.40	<b>Levelling elements for floor plate (2.10)</b> (1 set = 6 elements)	EUR	623,-
2.10	<b>Floor plate</b> , with surrounding coolant channel. Clamping surface 1000 x 1400 mm. Height 100 mm with 4 T-slots 18 mm (Option no. 1.40 necessary!)	EUR	4.602,-
2.20	<b>T-slot plate</b> , Vertical clamping plate with horizontal T-slots. For mounting into the vertical T-slots integrated in the machine base. At either side of the machine. Clamping surface 750 x 350 mm. Depth 185 mm with 3 T-slots 18 mm, distance 125 mm	EUR	2.249,-
2.30	<b>Angular table</b> with surrounding coolant channel. For mounting into the vertical T-slots integrated in the machine base. At either side of the machine. Clamping surface 800 x 600 mm, with 4 T-slots 18 mm at a distance of 150 mm.	EUR	3.454,-
2.40	<b>Tilting table</b> swivelling by $\pm 90^\circ$ , clamping surface 600 x 400 mm. With 3 T-slots, with 18 mm, at a distance of 125 mm. Swivel adjustable by worm and wheel mechanism with crank. Maximum table load 150 kg. For mounting into the vertical T-slots integrated in the machine base. At either side of the machine.	EUR	4.046,-
	<b>Cubic work table</b> with 2 clamping surfaces:		
2.70	upper side 1000 x 755 mm, vertical side 1000 x 500 mm	EUR	4.080,-
	<b>Cubic work table tilting from 0 to 90°:</b>		
2.80	Clamping surface upper side 550 x 550 mm, Clamping surface vertical 550 x 410 mm	EUR	3.371,-
2.90	Clamping surface upper side 750 x 600 mm, Clamping surface vertical 750 x 410 mm	EUR	4.277,-
3.15	<b>Digital position assistant function</b> (Details as per the above description)	EUR	14.072,-
10.10	<b>Coolant system A</b> , for machines without a floor plate consisting of: coolant tank, with a content of 25 l, coolant pump, with complete fittings	EUR	387,-
10.40	<b>Separate coolant re-circulation</b> for floor plates (under-floor size integration approx. 300 x 200 x 200 mm). Needed: coolant system A, Pos. 10.10	EUR	1.065,-
	<b>Packing:</b> wooden structure, weight approx. 70 kg	EUR	392,-

## 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	AB 30/R-1000 AB 30/R-1400
		with 1,5 kW Motor	with 3,0 kW Motor
Drilling performance steel E 335 (St 60)		32 mm	40 mm
Drilling performance Cast iron EN-GJL-200* (GG 20)		45 mm	50 mm
Drilling capacity steel E 335 (ST 60)		45 mm	50 mm
Tapping performance steel E 335 (St 60) (Option 20.0 or 20.1 required)		M 30	M 30
Tapping performance Cast iron EN-GJL-200(GG 20) (Option 20.0 or 20.1 required)		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 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	
Drive System		Gear box	
Motor: n = 1500 rpm		1,5 kW	3,0 kW •
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
Price of the machine. Distance spindle to column approx. 1000 mm	AB 30/R-1000	EUR 39.343,-	EUR 39.922,-
Price of the machine. Distance spindle to column approx. 1400 mm	AB 30/R-1400	EUR 49.840,-	EUR 50.297,-

• 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

Base plate with T-slots

Self-Locking Mushroom Button for EMERGENCY OFF

Spindle protection electrically secured

Protection class IP 54

Lacquer DD-structured grey RAL 7035 and anthracite RAL 7016, black

Machine oil

### OPTIONS

1.11	Anchor and levelling elements (6 elements)	EUR	637,-
12.2	Protected tube light incl. lamp	EUR	339,-
20.0	Tapping Attachment w/o foot switch, max. 6 tapped holes per minute, incl. smooth-start clutch in gear box	EUR	1.249,-
22.	Light transformer, for special voltages (not necessary with 230 or 400 V with usable O-conductor and light voltage 230 V) (only with Pos. 12.2)	EUR	324,-
24.	Coolant Attachment A, integrated in standard base plate with overload-protected pump and accessories	EUR	761,-
28.	Electrically controlled free-cutting system when depth is reached cutter remains for a controllable time in position. Incl. time-limit relay and feed brake.	EUR	3.018,-
42.6 •	Outboard support (an extra build-in switch will cut circuit to elevating motor when outboard support is locked)	EUR	2.398,-
47.2.1	Long spindle MT 4 with key bore DIN 1807	EUR	300,-
50.6	Precision depth adjuster and fixed stop precision adjustment to 0,1 mm	EUR	318,-
53.2	Portable boxed clamping table, length 560 mm, width 480 mm, H 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	EUR	2.646,-
54.	Spindle travel 200 mm	EUR	1.122,-
58	Central clamping system for sliding drill unit = mechanic, for column and arm = pneumatic/hydraulic	EUR	5.031,-
58.1	Central clamping system for sliding drill unit and arm = mechanic, for column = pneumatic	EUR	2.778,-
01.	Special Lacquer: DD-brillant	EUR	908,-
02.	Special Lacquer: DD-structured	EUR	429,-
05.	Special voltages		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

Photos 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>EUR 3.470,-</b>	<b>EUR 4.157,-</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 or 200-3200 rpm
<b>Price per Drill Head</b>	<b>EUR 9.881,-</b>	<b>EUR 9.916,-</b>	<b>EUR 12.347,-</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 or 200-3200 rpm
<b>Price per Drill Head</b>	<b>EUR 11.026,-</b>	<b>EUR 11.061,-</b>	<b>EUR 13.492,-</b>

**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, 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

Photos with options



	Table RFT 2/2	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	1 or 2	1, 2 or 3	
<b>Price of the table</b>	<b>EUR 3.481,-</b>	<b>EUR 5.334,-</b>	<b>EUR 821,-</b>
<b>Assembly of heads for</b>	<b>RFT 2/2 - 2/3</b>		Distance spindle-to-spindle is adjustable
<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>EUR 4.757,-</b>	<b>EUR 4.757,-</b>	

Lacquer: DD-structured grey RAL 7035, anthracite RAL 7016, black

### OPTIONS

17.1	<b>Pedal Bar as Emergency OFF switch</b> only for RFT 3/2 to RFT 3/6	EUR	814,-
35.	<b>Coolant attachment system B</b> , with 48 l container, overload protected pump and complete accessories - for 2 Drill heads	EUR	1.259,-
35.1	- for 3 Drill heads	EUR	1.368,-
35.2	- for 4 Drill heads	EUR	1.486,-
35.3	- for 5 Drill heads	EUR	1.622,-
35.4	- for 6 Drill heads	EUR	1.757,-
36.	<b>Control Transformer</b> for special voltages, not necessary with 230 V or 400 V, with 0-conductor	EUR	343,-
37.	<b>Light Transformer</b> for special voltages, not necessary with 230 V or 400 V, with 0-conductor and light voltage 230 V - if delivered with 1-2 Drill Heads	EUR	369,-
37.1	- if delivered with 3-6 Drill Heads	EUR	546,-
42.6	<b>Drill Heads 700 mm adjustable (RFT 3)</b>	EUR	226,-
01.	<b>Special Lacquer: DD-brillant</b> , table only	EUR	1.115,-
02.	<b>Special Lacquer: DD-structured</b> , table only	EUR	540,-
03.	<b>Anchoring set</b> (set of 4 pieces) up to RFT 3/3	EUR	182,-
03.	<b>Anchoring set</b> (set of 6 pieces) RFT 3/4 and 3/5	EUR	275,-
03.	<b>Anchoring set</b> (set of 8 pieces) RFT 3/6	EUR	368,-
	<b>Packing</b> on wooden bars only, no costs. Net weight approx. 40-150 kg		



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

Photos 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	780	780	780	780	780
Width of Table	1150	1650	2150	2650	3150
Clamping Area at Table (width x depth)	1000 x 350	1500 x 350	2000 x 350	2500 x 350	3000 x 350
Clamping Slots (number x width x distance)	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>EUR 6.020,-</b>	<b>EUR 7.902,-</b>	<b>EUR 8.290,-</b>	<b>EUR 10.708,-</b>	<b>EUR 12.948,-</b>




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>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 mm	764 mm	804 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	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>EUR 10.818,-</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>EUR 5.958,-</b>	<b>EUR 6.999,-</b>	<b>EUR 9.881,-</b>

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	500 mm	500 mm	500 mm
Weight	250 kg	270 kg	290 kg
<b>Motor n = 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 200-3200 rpm
<b>Price per Drill Head</b>	<b>EUR 8.712,-</b>	<b>EUR 9.916,-</b>	<b>EUR 12.347,-</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>EUR 13.235,-</b>

**Lacquer:** DD-structured grey RAL 7035, anthracite RAL 7016, black; [ Option ]

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

## ACCESSORIES

 Two-axis production table with copying device	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 (starting from AB 34/SV), weight approx. 140 kg	EUR	4.218,-
	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	EUR	4.618,-
	37721	<b>Positioning Device / Copying Device</b> for Two-axis Production Table, 760 x 425 mm	EUR	1.400,-
	37804	<b>Positioning Device / Copying Device</b> for Two-axis Production Table, 880 x 425 mm	EUR	1.400,-
	37648	<b>Templates for positioning device size 1</b> 160 x 220 mm	EUR	98,-
	37630	size 2 290 x 220 mm	EUR	134,-
	37622	size 3 420 x 220 mm	EUR	163,-
	101.5	<b>Customised Hole Patterns</b> with hardened inserts A5 x 12, DIN 179, per hole	EUR	46,-
	101.7 *)	<b>Set of Mounting Bars</b>	EUR	193,-
 Compound table	*)	<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	EUR	1.873,-
	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	EUR	2.096,-
	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	EUR	2.334,-
	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	EUR	3.024,-
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.	EUR	5.732,-	
 Vices 125/155	10637	<b>Machine Vice, size 125</b> height 85 mm, width of jaws 125 mm, clamping width 155 mm, weight 14 kgs	EUR	415,-
	10660	<b>including prism jaws</b> (1 longitudinal and 2 cross prisms)	EUR	478,-
	42143	<b>Machine Vice, size 155</b> height 112 mm, width of jaws 155 mm, clamping width 230 mm, weight 29 kgs	EUR	555,-
	42168	<b>including prism jaws</b> (1 longitudinal and 2 cross prisms)	EUR	580,-

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

**Machine vice**

Vice BON

<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	EUR	<b>156,-</b>
<b>137075</b>	<b>size 2</b> height 72 mm, width of jaws 100 mm, clamping width 110 mm, weight 9,5 kg	EUR	<b>272,-</b>
<b>137083</b>	<b>size 3</b> height 80 mm, width of jaws 125 mm, clamping width 130 mm, weight 13,5 kg	EUR	<b>406,-</b>
<b>137091</b>	<b>size 4</b> height 95 mm, width of jaws 160 mm, clamping width 220 mm, weight 25 kg	EUR	<b>683,-</b>

**Quick action drill chucks SUPRA**

<b>138107</b>	Type 136 clamping width 1-13 mm B 16	EUR	<b>87,-</b>
<b>140251</b>	Type 136 clamping width 3-16 mm B 16	EUR	<b>100,-</b>
<b>150466</b>	Type 136 clamping width 3-16 mm B 18	EUR	<b>100,-</b>
<b>189290</b>	Type 136 clamping width 0-10 mm B 16	EUR	<b>98,-</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	EUR	<b>11,-</b>
<b>139048</b>	Type 236	MT 3 B 16	EUR	<b>11,-</b>
<b>150474</b>	Type 236	MT 3 B 18	EUR	<b>11,-</b>
<b>160820</b>	Type 236	MT 4 B 16	EUR	<b>15,-</b>
<b>320283</b>	Type 236	MT 4 B 18	EUR	<b>15,-</b>

**Reduction inserts RH, DIN 2185**

<b>161075</b>	Type 261 N	MT 2/1	EUR	<b>16,-</b>
<b>190256</b>	Type 261 N	MT 3/1	EUR	<b>16,-</b>
<b>150482</b>	Type 261 N	MT 3/2	EUR	<b>16,-</b>
<b>160838</b>	Type 261 N	MT 4/1	EUR	<b>23,-</b>
<b>160846</b>	Type 261 N	MT 4/2	EUR	<b>23,-</b>
<b>160853</b>	Type 261 N	MT 4/3	EUR	<b>23,-</b>

**Expeller for taper DIN 228**

<b>81950</b>	MT 2	EUR	<b>9,-</b>
<b>150490</b>	MT 3	EUR	<b>15,-</b>
<b>161018</b>	MT 4		<b>25,-</b>

**Semi-automatic expeller for morse taper DIN 228**

<b>17277</b>	MT 1 - 3	EUR	<b>89,-</b>
<b>18952</b>	MT 3 - 6	EUR	<b>103,-</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	EUR	174,-	174,-	174,-	174,-	174,-	174,-	174,-
21.	Control Transformer, for special voltages only	EUR	338,-	338,-	338,-	338,-	338,-	338,-#	338,-
22.	Light Transformer for special voltages only	EUR	338,-	338,-	338,-	338,-	338,-	338,- #	338,-
41.	° Machined Base Plate with clamp surface 320 x 320 mm and 2 T-slots (AB50/SV = 450x460 mm)	EUR	-	486,-	486,-	486,-	486,-	486,-	-
44.0	° Combination Sq. Table (400 x 400 mm), for drilling under angles with at opposite side sliding mounted vice with clamping width 125 mm, including prism jaws, clamp surface 350 x 350 mm, Net weight increases by approx. 80 kg	EUR	-	-	1.831,-	1.831,-	1.831,-	1.831,-	1.831,-
48.2	Flange Quill incl. Double Return Spring to compensate up to 40 kg max. (at AB 50 up to 50 kg)	EUR	-	-	691,-	691,-	691,-	691,-	839,-
48.5	Double Return Spring to compensate up to 10 kg max.	EUR	-	-	-	-	97,-	97,-	-
01.	Special Painting DD-Brillant, (small parts DD-structured)	EUR	925,-	925,-	925,-	925,-	925,-	925,-	925,-
02.	Special Painting DD-structured	EUR	615,-	615,-	615,-	615,-	615,-	615,-	615,-
05.	Special Voltages	<b>upon request</b>							
<i>Special equipments upon request</i> ° only for round column types; # with AB 40 standard									

### Decision matrix for mounting compound tables and two-axis production table;

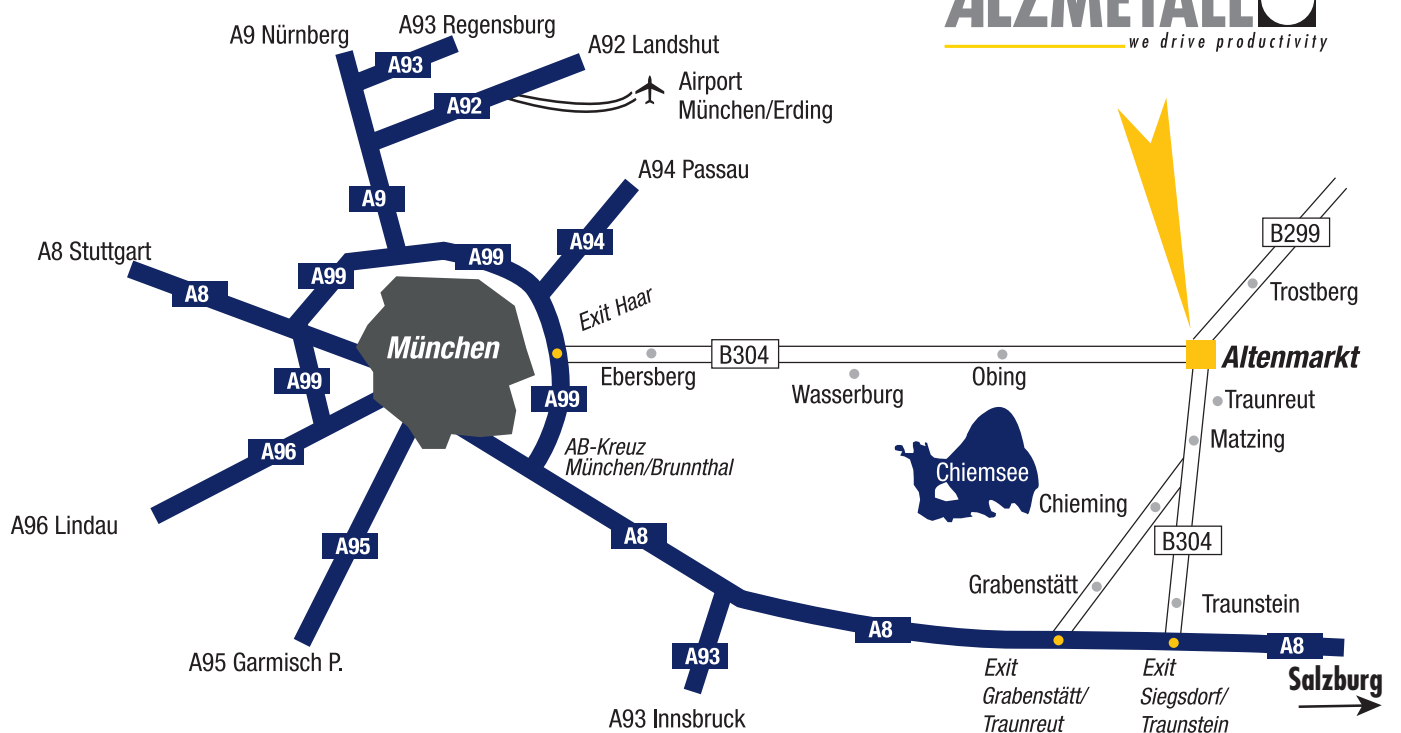
Versions see Page 34

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	-	-	-	-	-	-	
Size	Nr.	AX 2-T/S	AX 2/S	AX 3/S(V)	AX 4/SV	ALZFLOW 30	AB FLOW 40	
200	810854	••	••	•	-	•	-	
300	810856	-	-	•	-	•	-	
400	810858	-	-	•	•	•	•	
500	810860	-	-	-	-	-	-	
Size	Nr.	AB 26/SV	AB 34/SV	AB 34/HST	AB 40/SV	AB 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 € 193,-, 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

- Former price lists are no more valid
- All prices are in Euro, EXW , and do not include insurance, packing or any taxes and duties
- Lacquer: DD-structured grey RAL 7035, anthracite RAL 7016, black
- CE Norms are applied
- Standardly equipped for 400 V, 50 Hz networks, (with ALZTRONIC for 230 V, 50/60 Hz)
- Every machine is delivered with : Operator's Manual , Conformity Declaration, grease and lubrication table, anchor plan
- 2-3 further documentations / manuals free of charge, upon request
- 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 in separate bins.
- Prices are not valid for retrofit purposes, or for options that are delivered later
- Exchange of parts at original prices only possible if delivered back in original packing and if not damaged or showing wear
- Only our general conditions for the supply of machinery for national and international transactions are valid.

### Machining centres



GS 600

### CNC Rapid Radial Drilling Machines



Donau Werkzeugmaschinen GmbH, 83352 Altenmarkt  
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, laquering.

Your dealer



## ALZMETALL

### Werkzeugmaschinenfabrik und Gießerei Friedrich GmbH & Co. KG

Po. Box 1169 · 83350 Altenmarkt/Alz · Germany  
Harald-Friedrich-Straße 2-8  
83352 Altenmarkt/Alz · Germany  
Tel. +49 86 21/88-0 · Fax +49 86 21/88-213  
E-Mail: info@alzmetall.com · www.alzmetall.com