

## Rugged bench and Upright drills with powerful OPTIMUM Brushless drive, electronic speed control

### Facts that impress in terms of quality, performance and price

- ▶ Powerful brushless drive with particularly smooth action and high performance with almost constant torque over the entire speed range
- ▶ Best possible force transmission thanks to aluminium pulleys in combination with GATES quality toothed belts
- ▶ Smooth action thanks to polished multi-tooth carrier
- ▶ Guaranteed concentricity guaranteed to be less than 0.015 mm measured in the drilling spindle sleeve
- ▶ Separate emergency stop button
- ▶ Digital speed display integrated in housing
- ▶ Premium OPTIMUM quick clamping chuck as standard
- ▶ Generously dimensioned, height adjustable protective screen with safety switch for greatest possible user protection
- ▶ Single-piece, pressure cast aluminium spindle sleeve lever (B 24HV with Softgrip handles)
- ▶ Drilling depth stop
- ▶ V-belt cover with safety switch
- ▶ V-belt tensioning device

- ▶ Right-handed/left-handed rotation
- ▶ Machine lamp integrated in drilling head
- ▶ Precision workmanship; rugged drilling table with diagonal T-slots, 360° rotation and all-around cooling water channel
- ▶ Thick walled cast column for high force absorption and stability
- ▶ Solid baseplate, large dimensions und pronounced ribbing on rear

### As of B 28HV

- ▶ Spindle sleeve lever made of steel
- ▶ Coolant system
- ▶ Chip filter in line with Machinery Directive
- ▶ Easy tool changes through integrated push-out tool

### B 34HV

- ▶ Spindle sleeve stroke 160 mm
- ▶ Thread tapping function
- ▶ Digital depth sensor



### B 34HV - Operating modes

#### "auto" operating mode

- › Motor runs automatically after lever movement
- › Stops again in original position
- › Start and stop pushbuttons do not need to be actuated for repetitive drilling tasks

#### "Thread tapping" operating mode

- › The motor is activated by moving the handle down
- › The direction of rotation is changed by the limit switch on the adjustable drilling depth stop

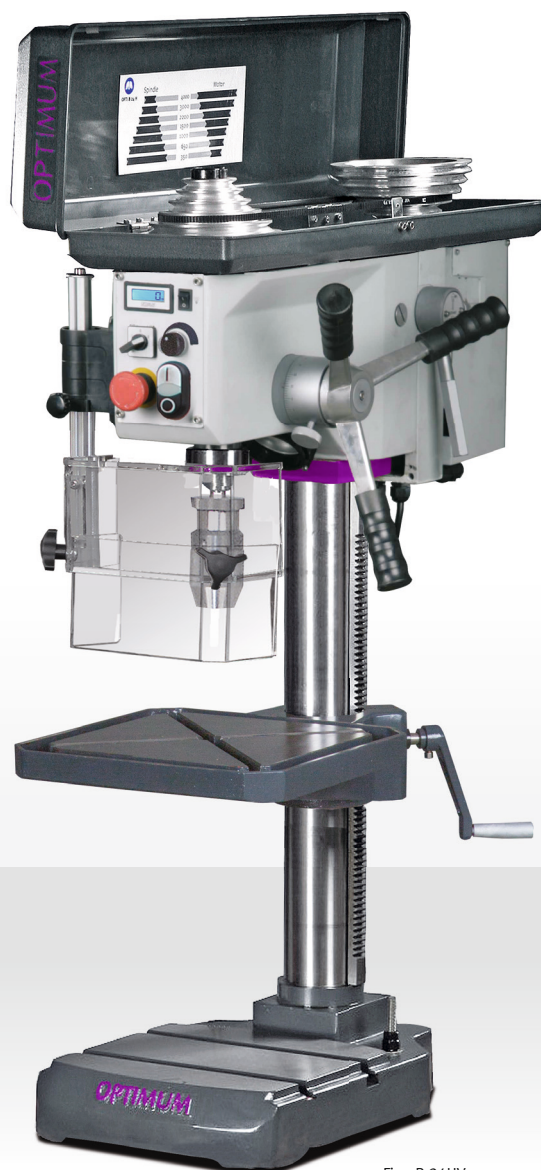


Fig.: B 24HV



## Technical data and accessories

Model	B 24HV	B 28HV	B 34HV
Article no.	3020245	3020285	3020335
<b>Technical specifications</b>			
Electrical connection	230 V / 1 Ph ~50 Hz	230 V / 1 Ph ~50 Hz	230 V / 1 Ph ~50 Hz
Motor output	1.5 kW	1.5 kW	2.2 kW
Coolant pump motor	-	40 W	40 W
<b>Drilling performance</b>			
Drilling performance in steel (S235JR)	Ø 24 mm	Ø 28 mm	Ø 34 mm
Continuous drilling performance in steel (S235JR)	Ø 20 mm	Ø 24 mm	Ø 26 mm
Thread tapping steel (S235JR)	-	-	M 16 x 2 mm
<b>Spindle</b>			
Spindle sleeve stroke	85 mm	105 mm	160 mm
Spindle seat	MT 2	MT 3	MT 4
Throat	165 mm	200 mm	285 mm
<b>Speeds</b>			
Spindle speeds	100 - 5 950 rpm	35 - 5 600 rpm	40 - 5 000 rpm
Number of speeds	4 speeds Electronic speed control	12 speeds Electronic speed control	9 speeds Electronic speed control
<b>Drilling table</b>			
Drilling table workspace L x W	280 x 300 mm	340 x 360 mm	420 x 400 mm
T-slot size	14 mm, diagonal	14 mm, diagonal	14 mm, diagonal
Rotating drilling table	360°	360°	360°
Clearance spindle - drilling table	max. 515 mm	max. 860 mm	max. 790 mm
<b>Machine base</b>			
Machine base work area L x W	280 x 260 mm	320 x 320 mm	390 x 390 mm
T-slot size / spacing / count	14 mm / 120 mm / 2	14 mm / 120 mm / 2	14 mm / 150 mm / 2
Rotating drilling table	360°	360°	360°
Distance spindle - machine base	max. 590 mm	max. 1 285 mm	max. 1 275 mm
<b>Dimensions</b>			
Column diameter	Ø 80 mm	Ø 92 mm	Ø 115 mm
Length x width x height	665 x 434 x 998 mm	701 x 474 x 1 755 mm	918 x 595 x 1 930 mm
Weight	96 kg	166 kg	275 kg

Accessories	Article no.
Assortment of clamping tools size 12	3352017
Hold-down device 14 mm/M12	3352031
Twist drill bits HSS-CO 5%, 25 parts	3201010
<b>NEW</b> Twist drill bits HSS-CO 5%, 51 parts	3201020
<b>NEW</b> Twist drill bits HSS-CO 5%, 41 parts	3201021
Quick clamping drill chuck 1 - 8 mm; B16	3050608
Quick clamping drill chuck 1 - 10 mm; B16	3050610
Quick clamping drill chuck 1 - 13 mm; B16	3050623
Quick clamping drill chuck 1 - 16 mm; B16	3050626

> More „Accessories for drills“ from page 60

Machine vices	Article no.
<b>BMS 100</b>	3000010
<b>BMS 120</b>	3000012
<b>BSI 100</b>	3000210
<b>BSI 140</b>	3000214
<b>BSI-Q 100</b>	3000230
<b>BSI-Q 140</b>	3000234

> Information on the vises on page 67

Accessories B 24HV	Article no.
Direct quick release chuck 1 - 16 mm	3050571
Direct quick release chuck 1 - 13 mm	3050572
Collet chuck set MT 2/ ER 25	3352052
Morse taper MT 2/B16	3050659
Twist drill bit HSS / MT 2, 9 parts	3051002
Thread tapping chuck MT 2	3050702
Universal coolant unit	3352002

Accessories B 28HV	Article no.
Direct quick release chuck 1 - 16 mm	3050573
Collet chuck set MT 3/ ER 32	3352093
Reduction sleeve MT 3 - MT 2	3050663
Reduction sleeve MT 3 - MT 2	3350313
Morse taper MT 3/B16	3050660
Twist drill bit HSS / MT 3, 9 parts	3051003
Thread tapping chuck MT 3	3050705

Accessories B 34HV	Article no.
Direct quick release chuck 1 - 16 mm	3050574
Collet chuck set MT 4/ ER 32	3352094
Reduction sleeve MT 4 - MT 3	3050664
Reduction sleeve MT 4 - MT 3	3350314
Morse taper MT 4/B16	3050661
Thread tapping chuck MT 4	3050709

\* Important information on the transport packaging flat rate and surcharge and „Operation of machines with frequency converters“ on page 249  
\*\*The machines comply with DIN EN 55011: class C2.