



Quality Tools and Machines

PUNCHING
DRILLING
CUTTING
DEBURRING



**revised
Edition**

21
Part B



NATURALLY ALSO ON THE INTERNET – www.alfra.de



Made in Germany



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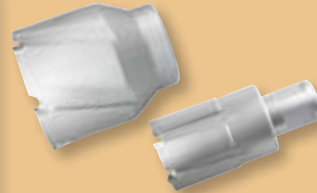
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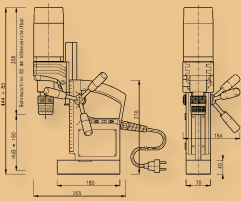
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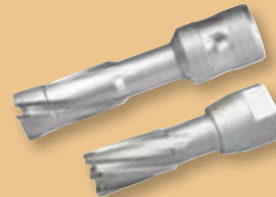
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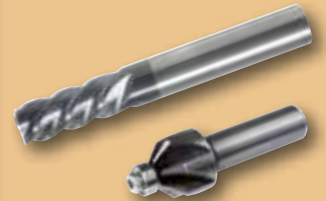
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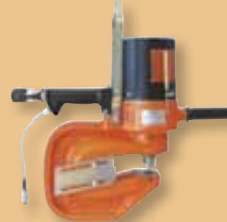
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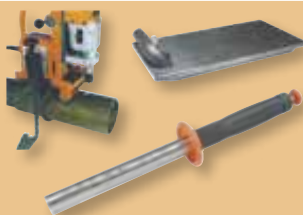
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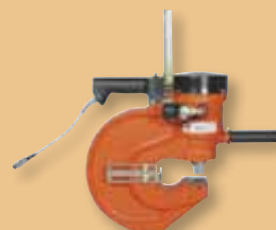
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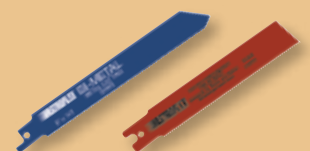
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METAL CORE DRILLING HAS GOT A NAME


ALFRA RÖTABEST®





GOOD REASONS TO DECIDE ON **ALFRA RÖTABEST®**


**MANUFACTURER'S COMPETENCE
30 YEARS OF EXPERIENCE**


 **Powerful Motors with high torques and a range from 1.100 to 2.500W, ergonomic design, perfect technology.**


 **Oilbath Gear Box**


 **Improved magnetic adhesion due to 3 instead of 2 coils.**


 **Soft-Touch Grip**
Low-vibration – with optimum secure grip (even with oil-coated gloves).


 **Pressed-in brass rings for an improved protection of the magnet coils.**


 **Continuously adjustable motor on the slide for a maximum stroke enlargement, when using twist drills, drill chucks and tapping attachments.**

 **Rota-Quick® – quick change arbor – problem-free change of cutter. The decisive advantage compared with other quick change arbors: every usual cutter with Weldon-shank fits.**

 **Durable keyboard with flat cable. Panel slopingly arranged, directly in sight of the user. To feel for the ON/OFF-switch has come to an end. Easy reachability of keyboard, even in narrow U-beams and H-beams.**

 **Newly designed gear-housing with integrated motor support. With built-in height adjustment by means of clamping jaws – there is no better fixing device.**

 **Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.**

 **The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable between Model 32 – 40 – 60 – 100 and between 40 RL-E – 60 RL-E – 100 RL-E**





ALFRA METAL CORE DRILLING MACHINES – RQ Series Overview

Made in Germany by ALFRA



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Type	Rotabest® 32 RQ	Rotabest® 40 RQ	Rotabest® 40 RL-E	Rotabest® 60
Prod.-No	18600	18610	18611	18625
Input	1.100 Watt	1.200 Watt	1.200 Watt	1.800 Watt
Speed rpm	450	250/450	100-250 180-450	110/175/ 245/385
Full Wave Electronics/ Thermal protection	–	–	■	–
Oil-bath gear box NEW	–	■	■	■
Motor Overload Protection/ Over-Voltage Switch-Off	–	–	■	–
Right-/Left Rotation	–	–	■	–
Friction Clutch	–	–	–	■
Max. Ø of Cutter	32 mm	40 mm	40 mm	60 mm
Max. Cutting Depth	50 mm	50 mm	50 mm	50 mm
Tapping	M 12	M 20	M 20	M 30
Countersinking	■	■	■	■
Twist Drills Ø max.	13 mm	13 mm	16 mm	32 mm
Arbor	19 mm Weldon Rota-Quick® quick change arbor	19 mm Weldon Rota-Quick® quick change arbor	MT 2	MT 3
Magnetic Adhesion	11.000 N rigid	16.000 N rigid	16.000 N rigid	20.000 N 30° swiveling
Min. Material Thickness	6 mm	6 mm	6 mm	10 mm
Size of Magnet Foot	70 x 180 mm	80 x 230 mm	80 x 230 mm	80 x 230 mm
Stroke	160 mm NEW	170 mm	170 mm	190 mm
Motor adjustable in height	85 mm	100 mm	100 mm	60 mm
Weight	10,5 kg	16 kg	16 kg	22 kg

ALFRA METAL CORE DRILLING MACHINES – RQ Series Overview

Made in Germany by ALFRA



			
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Rotabest® 60 RL-E	Rotabest® 100	Rotabest® 100 RL-E	Rotabest® V32
18626	18630/18635*	18632	18710
1.800 Watt	1.800 Watt/2.500 Watt*	1.800 Watt	900 Watt
50-110/75-175 105-245/165-385	110/175/245/385	50-110/75-175/ 105-245/165-385	450
■	■	■	–
■ 	■ 	■ 	–
■	■	■	–
■	–	■	–
■	–	■	–
60 mm	100 mm	100 mm	32 mm
50 mm	50 mm	50 mm	25 mm
M 30	M 30	M 30	–
■	■	■	■
32 mm	32 mm	32 mm	–
MT 3	MT 3	MT 3	19 mm Weldon
20.000 N 30° swiveling	20.000 N 30° swiveling	20.000 N 30° swiveling	16.000 N rigid
10 mm	10 mm	10 mm	6 mm
80 x 230 mm	80 x 230 mm	80 x 230 mm	95 x 200 mm
190 mm	245 mm	245 mm	45 mm
60 mm	116 mm	116 mm	–
22 kg	28 kg/29 kg*	28 kg	12,5 kg

* High-Performance Version

















Type	Piccolo 32/50 WD	Piccolo 32/50 WD	Mini 38/50 WD	Mini 38/50 WD
Prod.-No	18500	18501	18556	18557
Input	1.100 Watt	1.100 Watt	1.100 Watt	1.100 Watt
Speed rpm	450	450	450	450
Full Wave Electronics/ Thermal protection	-	-	-	-
Oil-bath gear box NEW	-	-	-	-
Motor Overload Protection/ Over-Voltage Switch-Off	-	-	-	-
Right-/Left Rotation	-	-	-	-
Friction Clutch	-	-	-	-
Max. Ø of Cutter	32 mm	32 mm	38 mm	38 mm
Max. Cutting Depth	50 mm	50 mm	50 mm	50 mm
Tapping	M 12	M 12	M 12	M 12
Countersinking	■	■	■	■
Twist Drills Ø max.	13 mm	13 mm	13 mm	13 mm
Arbor	19 mm Weldon	19 mm Weldon	19 mm Weldon	19 mm Weldon
Magnetic Adhesion	8.000 N rigid	8.000 N rigid	12.000 N rigid	12.000 N rigid
Min. Material Thickness	6 mm	6 mm	6 mm	6 mm
Size of Magnet Foot	70 x 160 mm	70 x 160 mm	95 x 200 mm	95 x 200 mm
Stroke	129 mm	129 mm	141 mm	141 mm
Motor adjustable in height	86 mm	86 mm	98 mm	98 mm
Weight	10,6 kg	10,6 kg	15,5 kg	15,5 kg



ALFRA METAL CORE DRILLING MACHINES – Eco Series Overview

Made in Germany by ALFRA



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Mini 40/2 (HS*) WD	Mini 40/2 (HS*) WD	Junior 75/4	Junior 75/4
18510; (18512*) NEW	18511 (18513*) NEW	18520	18521
1.200 Watt	1.200 Watt	1.800 Watt	1.800 Watt
250/450; (450/700 rpm*)	250/450; (450/700 rpm*)	110/175/245/385	110/175/245/385
-	-	-	-
			
-	-	-	-
-	-	-	-
-	-		
40 mm	40 mm	75 mm	75 mm
50 mm	50 mm	50 mm	50 mm
M 12	M 12	M 30	M 30
			
13 mm	13 mm	32 mm	32 mm
19 mm Weldon	19 mm Weldon	MT 3	MT 3
12.000 N rigid	12.000 N rigid	18.000 N 330° swiveling	18.000 N 330° swiveling
6 mm	6 mm	10 mm	10 mm
95 x 200 mm	95 x 200 mm	95 x 200 mm	95 x 200 mm
141 mm	141 mm	235 mm	235 mm
120 mm	120 mm	130 mm	130 mm
15 kg	15 kg	25 kg	25 kg

* HS (HIGH SPEED)

B



Metal Core Drilling with

ALFRA ROTABEST[®]

32RQ



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 32 RQ

Made in Germany by ALFRA



Technical data:

Core Drill:	Ø 12,0 - 32,0 mm
Cutting Depth:	50.0 mm
Twist drill:	Ø 1.0 - 13.0 mm
Countersinking:	Ø 10.0 - 40.0 mm
Tapping:	with auto reversible Tapping Attachment: M3 - M12
Input:	1,100 W
1-speed gearbox:	450 rpm
Tool holder:	19.0 mm Rota-Quick® quick change arbor internal, automatically
Coolant Supply:	internal, automatically
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	11000 N
Magnet foot:	70 x 180 mm (rigid)
Height Adjustable:	85 mm
Stroke:	160 mm
Weight:	10.5 kg

Scope of Supply:

- Metal Core Drilling Machine 32 RQ
- Transport Case
- Coolant Unit
- Drilling Spray
- Drill chuck Ø 1 - 13 mm
- Chip remover
- Safety belt
- HSS-Co Cutter Ø 18 mm
- Ejector Pin



Prod.-No.

ALFRA Rotabest@Complete Set® 32 RQ	230 Volt	18600
ALFRA Rotabest@Complete Set® 32 RQ	110 Volt	18600.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



Rota-Quick® quick change arbor – easy cutter change. The decisive advantage over other quick-change systems: It takes all standard cutters with Weldon shanks.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



The jackscrews for the slide guidance are no longer on the front side, but on the back side of the panel. No danger of injuries. Fixing device to fix the slide on each height. For comfortable tool-change, ideal for the machine-transport.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills and drill chucks.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.



B



Metal Core Drilling with

ALFRA ROTABEST[®]

40RQ



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 40 RQ

Made in Germany by ALFRA



Technical data:

Core Drill:	Ø 12.0 - 40.0 mm
Cutting Depth:	50.0 mm
Twist drill:	Ø 1.0 - 13.0 mm
Countersinking:	Ø 10.0 - 40.0 mm
Tapping:	with Tapping Attachment: M3 - M20
Input:	1,200 W
2-speed gearbox:	250/450 rpm
Tool holder:	19.0 mm Rota-Quick® quick change arbor
Coolant Supply:	internal, automatically
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	16000 N
Magnet foot:	80 x 230 mm (rigid)
Height Adjustable:	100 mm
Stoke:	170 mm
Weight:	16.0 kg

Scope of Supply:

- Metal Core Drilling Machine 40 RQ
- Transport Case
- Coolant Unit
- Drilling Spray
- Drill chuck Ø 1 - 13 mm
- Chip remover
- Safety belt
- HSS-Co Cutter Ø 22 mm
- Ejector Pin



Prod.-No.

ALFRA Rotabest® Complete Set 40 RQ	230 Volt	18610
ALFRA Rotabest® Complete Set 40 RQ	110 Volt	18610.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



Rota-Quick® quick change arbor – easy cutter change. The decisive advantage over other quick-change systems: It takes all standard cutters with Weldon shanks.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



The jackscrews for the slide guidance are no longer on the front side, but on the back side of the panel. No danger of injuries. Fixing device to fix the slide on each height. For comfortable tool-change, ideal for the machine-transport.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B

ALFRA

Metal Core Drilling with

ALFRA ROTABEST[®]

40RL-E



- The characteristic feature of this series is the right-/left rotation (e. g., for threading without tapping attachment).
- Used with threading quick-change chuck with threaded inserts.
- Diverse applications: Drilling with twist or core drills, threading, countersinking and rubbing.
- With control electronics for optimal speeds.
- Robust – precise – versatile.

METAL CORE DRILLING MACHINE – ALFRA Rotabest® 40 RL-E

Made in Germany by ALFRA

Technical data:

Core Drill:	Ø 12.0 - 40.0 mm
Cutting Depth:	50.0 mm
Twist Drill:	Ø 1.0 up to 16.0 mm with MT 2 quick-clamp drill chuck up to Ø 20.0 mm with MT 2 DIN 345 direct insertion with Tap Collets: M3 - M14 with Tapping Attachment: M3 - M20 Ø 40.0 mm
Tapping:	
Countersinking:	
Motor:	
Input:	1,200 W
2-speed gear:	right/left
1. speed	100 - 250 rpm
2. speed	180 - 450 rpm
Arbor:	MT 2
Coolant Supply:	via Tool Holder
Full Wave Electronics:	serial
Thermal protection:	serial
Torque Cutoff:	serial
Height Adjustable:	100 mm
Stoke:	170 mm
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	16000 N
Magnet foot:	80 x 230 mm (rigid)
Weight:	16.0 kg

Scope of Supply:

- Metal Core Drilling Machine 40 RL-E
- Transport Case
- Coolant Unit
- Drilling Spray
- Quick-clamp drill chuck 1 to 16 mm, MT 2
- Chip remover
- Safety belt
- operation manual



Prod.-No.

ALFRA Rotabest® Complete Set 40 RL-E	230 Volt	18611
ALFRA Rotabest® Complete Set 40 RL-E	110 Volt	18611.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams. Plus: motor control for right-/left rotation.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



Especially well-suited to problem-solving and fast threading.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B



Metal Core Drilling with

ALFRA ROTABEST[®]

60



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 60

Made in Germany by ALFRA

Technical data:

Core Drill:	Ø 12.0 - 60.0 mm
Cutting depth:	50.0/110.0 mm
Twist drill:	Ø 1.0 - 16.0 mm with drill chuck up to Ø 32.0 with Morse Taper Ø 10.0 - 55.0 mm
Countersinking:	
Tapping:	up to M30 with Tapping Attachment
Input:	1,800 W
4-speed gearbox:	110/175/245/385 rpm
Arbor:	MT3
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnetic adhesion:	20000 N
Magnet Foot:	80 x 230 mm, 30° adjustable right/left 10 mm back/forwards
Height Adjustable:	60 mm
Stroke:	190 mm
Weight:	22.0 kg

Scope of Supply:

- Metal Core Drilling Machine 60
- Transport Case
- Coolant Unit
- Chip remover
- Safety belt
- Drilling Spray



Prod.-No.

ALFRA Rotabest® Complete Set 60	230 Volt	18625
ALFRA Rotabest® Complete Set 60	110 Volt	18625.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



Adjustable Magnet Foot for better positioning. 10 mm back/forwards. 30° right/left.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B



Metal Core Drilling with

ALFRA ROTABEST[®]

60RL-E



- This machine has the same features as model 40 RL-E for drilling – threading (M3 to M30) – countersinking up to Ø 55 mm or rubbing
- Even more powerful and robust with the greatest magnetic adhesion for your safety.
- The magnet foot can be rotated 30° right and left and can be adjusted 10 mm forwards and backwards.
- This means the greatest possible flexibility for positioning:
 - setting the machine
 - securing with magnet
 - and then precise positioning.
- Motor height adjustable for greatest possible stroke, especially for use with MT twist drills, tap collets and extra-long cutters.



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 60 RL-E

Made in Germany by ALFRA



Technical data:

Core Drill:	Ø 12.0 - 60.0 mm
Cutter, extra long 110 mm:	Ø 20,0 - 50,0 mm
Cutting depth:	50.0/110.0 mm
Twist drill:	Ø 1.0 - 16.0 mm with drill chuck up to Ø 32 mm with Morse Taper DIN 345
Tapping:	with Tap Collets: up to M30 with Tapping Attachment: up to M30
Countersinking:	Ø 55.0 mm
Motor:	
Input:	1,800 W
4-speed gearbox:	right/left
	1. speed 50 - 110 rpm
	2. speed 75 - 175 rpm
	3. speed 105 - 245 rpm
	4. speed 165 - 385 rpm
Tool holder:	MT 3
Coolant Supply:	via Tool Holder
Full Wave Electronics:	serial
Thermal protection:	serial
Torque Cutoff:	serial
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnetic adhesion:	20000 N
Magnet Foot:	80 x 230 mm, 30° adjustable right/ left, 10 mm back/forwards
Height Adjustable:	60 mm
Stroke:	190 mm
Weight:	22.0 kg

Scope of Supply:

- Metal Core Drilling Machine 60 RL-E
- Transport Case
- Coolant Unit
- Drilling Spray
- Quick-clamp drill chuck 1 to 16 mm, MT 3
- Chip remover
- Safety belt
- operation manual



Prod.-No.

ALFRA Rotabest® Complete Set 60 RL-E	230 Volt	18626
ALFRA Rotabest® Complete Set 60 RL-E	110 Volt	18626.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams. Plus: motor control for right-/left rotation.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



Especially well-suited to smooth and fast threading.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B



Metal Core Drilling with

ALFRA ROTABEST[®]

100



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 100

Made in Germany by ALFRA



Technical Data 100:

Core Drill:	Ø 12.0 - 100.0 mm
Cutting Depth:	50.0 mm/110 mm
Twist drill:	Ø 1.0 - 16.0 mm with drill chuck up to Ø 32.0 mm with Morse Taper Ø 10.0 - 55.0 mm
Countersinking:	
Tapping:	up to M30 with Tapping Attachment
Input:	1.800/2.500* W
4-speed gearbox:	110/175/245/385 rpm
Tool holder:	MT 3
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnetic adhesion:	20000 N
Magnet Foot:	80 x 230 mm, 30° adjustable right/left 10 mm back/forwards
Height Adjustable:	116 mm
Stroke:	245 mm
Weight:	28.0 kg / 29.0 kg*



Scope of Supply:

- Metal Core Drilling Machine 100
- Transport Case
- Coolant Unit
- Chip remover
- Safety belt
- Drilling Spray

Prod.-No.

ALFRA Rotabest® Complete Set 100	1800 W	230 Volt	18630
ALFRA Rotabest® Complete Set 100	1800 W	110 Volt	18630.110
In high-performance version with 2,500 Watts (29kg):			
*ALFRA Rotabest® Complete Set 100	2500 W	230 Volt	18635
*ALFRA Rotabest® Complete Set 100	2500 W	110 Volt	18635.110



NEW



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance.



Left-handed? Reversible handles for right- and left-handed operation. Allen key misplaced? Tool pouch for the Allen key for the motor height adjustment fixing screws. Ruler to check drilling depth.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



Adjustable Magnet Foot for better positioning. 10 mm back/forwards. 30° right/left.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B



Metal Core Drilling with

ALFRA ROTABEST[®]

100 RL-E



METAL CORE DRILLING MACHINE – ALFRA Rotabest® 100 RL-E

Made in Germany by ALFRA



Technical Data 100 RL-E:

Core Drill:	Ø 12.0 - 100.0 mm
Cutting Depth:	50.0 mm/110 mm
Twist drill:	Ø 1.0 - 16.0 mm with drill chuck up to Ø 32.0 mm with Morse Taper Ø 10.0 - 55.0 mm
Countersinking:	with Tap Collets: up to M30
Tapping:	with Tapping Attachment: up to M30
Input:	1,800 W
4-speed gearbox:	right/left 1. speed 50 - 110 rpm 2. speed 75 - 175 rpm 3. speed 105 - 245 rpm 4. speed 165 - 385 rpm
Tool holder:	MT 3
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnetic adhesion:	20000 N
Magnet Foot:	80 x 230 mm, 30° adjustable right/left 10 mm back/forwards
Stroke:	245 mm
Weight:	28.0 kg

Scope of Supply:

- Metal Core Drilling Machine 100 RL-E
- Transport Case
- Coolant Unit
- Chip remover
- Safety belt
- Drilling Spray
- Quick-clamp drill chuck



Prod.-No.

ALFRA Rotabest® Complete Set 100 RL-E	230 Volt	18632
ALFRA Rotabest® Complete Set 100 RL-E	110 Volt	18632.110



Trouble with ordinary dovetail or pillar guides? Solid brass guide rails guarantee an optimum slide guidance. Guarantee an optimum slide guidance.



Left-handed? Reversible handles for right- and left-handed operation. Allen key misplaced? Tool pouch for the Allen key for the motor height adjustment fixing screws. Ruler to check drilling depth.



NEW – durable foil keypad with flat cable, control panel slanted in direct view of operator. An end to groping for the on/off switch. Keypad easily accessible even in narrow U-beams and H-beams.



Improved magnetic adhesion due to 3 instead of 2 coils.

Pressed in brass rings for an improved protection of the magnet coils.



Adjustable Magnet Foot for better positioning. 10 mm back/forwards. 30° right/left.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills, drill chucks or when tapping.



The heart of our Magnetic Drilling Machines: Robust electronic switch units, interchangeable with all types of the new Generation. Easy to approach for a quick service.

B



Metal Core Drilling with

ALFRA ROTABEST[®]

V32

NEW



ANGULAR METAL CORE DRILLING MACHINE – ALFRA Rotabest® V32

100% Made in Germany by ALFRA



- Horizontal metal core drilling machine for the tightest conditions. Perfect for use where regular metal core drilling machines cannot go due to their height.
- Application areas:
Steel construction (in between girder flanges), vehicle construction (truck frames), bridge construction, tower construction, tunnel construction, tersely everywhere, where it's poky ...
- The total height is just 227 mm and can even be reduced to 185 mm by removing the handle.
- The spur gear unit is designed for robust use and is fed using a ratchet leveler.
Reversible for right- and left-handed operation.
- Another advantage: the design of the angled gear unit ensures permanent lubrication and prevents dry running.
- Used with the proven motors and magnet foot components from the Rotabest® series.

Technical data:

Core Drill:	Ø 12.0 - 32.0 mm
Cutting Depth:	25 mm
Countersinking:	Ø 10.0 - 32.0 mm
Input:	900 W
1-speed gearbox:	450 rpm
Tool Holder:	19 mm Weldon
Cooling:	internal, automatically through the spindle the spindle
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet Foot:	95 x 200 mm (rigid)
Magnet adhesion:	16000 N
Height:	227/185 mm
Power cord:	3.0 m
Weight:	12.5 kg



Scope of Supply:

- 1 Angular Metal Core Drilling Machine V 32
- 1 Coolant unit with hose and nipple
- 1 transport case
- 1 Allen key for Weldon arbor
- 1 safety belt
- 1 HSS Co Cutter Ø 18 mm, cutting depth 25 mm
- 1 Ejector pin 6.35 x 70 mm (specifically for Rotabest® V32)
- 1 operation manual



Suitable for the tightest spaces, wherever it is tight.



Fed using ratchet leveler, reversible for right- and left-handed operation



Spur gear unit for robust application



Good view from operator position to drill



Robust rack guides



*Easy to use:
Magnet on – Motor on/off*

Prod.-No.

ALFRA Rotabest® Complete Set V32	230 Volt	18710
ALFRA Rotabest® Complete Set V32	110 Volt	18710.110



METAL CORE DRILLING MACHINE – ALFRA Rotabest®
Made in Germany by ALFRA

Piccolo 32/50 Weldon



Technical data:

Core Drill:	Ø 12.0 - 32.0 mm
Cutting Depth:	50.0 mm
Twist Drills:	Ø 1.0 - 13.0 mm DIN 338
Countersinking:	Ø 10.0 - 40.0 mm
Threading:	with tapping attachment: M3 - M12
Input:	1,100 W
1-speed gearbox:	450 rpm
Tool Holder:	19 mm Weldon shank
Coolant Supply:	internal, automatically
Height Adjustable:	86 mm
Stroke:	129 mm
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	8,000 N
Magnet Foot:	70 x 160 mm
Magnet Foot Assembly:	rigid
Weight:	10.6 kg

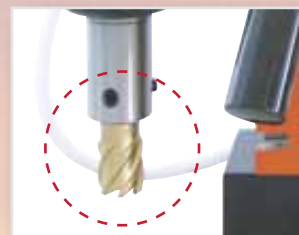
Scope of Supply:

- Metal Core Drilling Machine Piccolo 32/50 Weldon
- Plastic transport case
- Safety belt
- Coolant Unit
- operation manual



Prod.-No.

ALFRA Rotabest® Complete Set Piccolo 32/50 WD	230 Volt	18500
ALFRA Rotabest® Complete Set Piccolo 32/50 WD	110 Volt	18500.110
ALFRA Rotabest® Complete Set Piccolo 32/50 WD	230 Volt	18501
ALFRA Rotabest® Complete Set Piccolo 32/50 WD	110 Volt	18501.110



Weldon held directly in the motor spindle. No tool holder necessary. Ensures the highest concentricity.



Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills and drill chucks. Solid brass guide rails guarantee an optimum slide guidance.

METAL CORE DRILLING MACHINE – ALFRA Rotabest®
Made in Germany by ALFRA



Mini 38/50 Weldon



Prod.-No. 18557



Prod.-No. 18556

Technical data:

Core Drill:	Ø 12.0 - 38.0 mm
Cutting Depth:	50.0 mm
Twist Drill:	Ø 1.0 - 13.0 mm DIN 338
Countersinking:	Ø 10.0 - 40.0 mm
Threading:	with tapping attachment: M3 - M12
Input:	1,100 W
1-speed gearbox:	450 rpm
Tool Holder:	19 mm Weldon shank
Coolant Supply:	internal, automatically
Height Adjustable:	98 mm
Stroke:	141 mm
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	12,000 N
Magnet Foot:	95 x 200 mm
Magnet Foot Assembly:	rigid
Weight:	15.5 kg

Scope of Supply:

- Metal Core Drilling Machine Mini 38/50 Weldon
- Plastic transport case
- Safety belt
- Coolant Unit
- operation manual



Prod.-No.

			Prod.-No.
ALFRA Rotabest® Complete Set Mini 38/50 WD	230 Volt	18556	
ALFRA Rotabest® Complete Set Mini 38/50 WD	110 Volt	18556.110	
ALFRA Rotabest® Complete Set Mini 38/50 WD	230 Volt	18557	
ALFRA Rotabest® Complete Set Mini 38/50 WD	110 Volt	18557.110	

Weldon held directly in the motor spindle. No tool holder necessary. Ensures the highest concentricity.

Motor adjustable in height on the slide for maximum stroke enlargement when using twist drills and drill chucks. Solid brass guide rails guarantee an optimum slide guidance.



METAL CORE DRILLING MACHINE – ALFRA Rotabest®
Made in Germany by ALFRA

Mini 40/2 Weldon

Mini 40/2 HS Weldon



Technical data:

Core Drill:	Ø 12.0 - 40.0 mm
Cutting Depth:	50.0 mm
Twist drill:	Ø 1.0 - 13.0 mm
Countersinking:	Ø 10.0 - 40.0 mm
Tapping:	up to M20 with Tapping Attachment
Input:	1,200 W
2-speed gearbox:	250/450 rpm; 450/700 rpm (Type HS)
Arbor:	19 mm Weldon Direct Arbor
Coolant Supply:	internal, automatically
Height Adjustable:	120 mm
Stroke:	141 mm
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	12,000 N
Magnet Foot:	95 x 200 mm
Magnet Foot Assembly:	rigid
Weight:	15.0 kg

Scope of Supply:

- Metal Core Drilling Machine Rotabest® mini 40/2
- Plastic transport case
- Quick-clamp drill chuck
- HSS-Co Cutter Ø 22 mm
- Ejector Pin
- Coolant Spray BIO 2000
- Coolant unit



Prod. No.

ALFRA Rotabest® Complete Set	Mini 40/2 WD	230 Volt	18510
ALFRA Rotabest® Complete Set	Mini 40/2 WD	110 Volt	18510.110
ALFRA Rotabest® Complete Set	Mini 40/2 WD	230 Volt	18511
ALFRA Rotabest® Complete Set	Mini 40/2 WD	110 Volt	18511.110

Type HS (HIGH SPEED) Weldon is qualified for the use of TCT Cutters.

			Prod. No.
ALFRA Rotabest® Complete Set	Mini 40/2 HS WD	230 Volt	18512
ALFRA Rotabest® Complete Set	Mini 40/2 HS WD	110 Volt	18512.110
ALFRA Rotabest® Complete Set	Mini 40/2 HS WD	230 Volt	18513
ALFRA Rotabest® Complete Set	Mini 40/2 HS WD	110 Volt	18513.110



Weldon held directly in the motor spindle. No tool holder necessary. Ensures the highest concentricity.

METAL CORE DRILLING MACHINE – ALFRA Rotabest®

Made in Germany by ALFRA



Junior 75/4



Prod.-No. 18521



Prod.-No. 18520

Technical data:

Core Drill:	Ø 12.0 - 75.0 mm
Cutting Depth:	50.0 mm
Twist Drill:	Ø 32.0 mm
Tap	with tapping attachment: up to M30
Countersinking:	Ø 10.0 - 55.0 mm
Input:	1,800 W
4-speed gearbox:	110/175/245/385 rpm.
Tool Holder:	MT 3 spindle for tool holder AMK-3
Coolant Supply:	via Tool Holder
Height Adjustable:	130 mm
Stroke:	235 mm
Voltage:	230 Volt or 110 Volt (50-60 Hz)
Magnet adhesion:	18,000 N
Magnet Foot:	95 x 200 mm, movable 10 mm back and forth, 330° to both sides
Weight:	25.0 kg

Scope of Supply:

- Metal Core Drilling Machine Rotabest® Junior 75/4
- Transport case
- Safety belt
- Coolant Unit
- operation manual



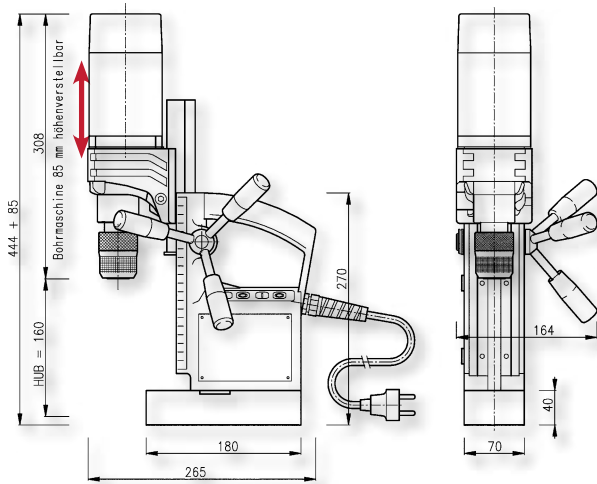
Prod.-No.

		Prod.-No.
ALFRA Rotabest® Complete Set Junior 75/4	230 Volt	18520
ALFRA Rotabest® Complete Set Junior 75/4	110 Volt	18520.110
ALFRA Rotabest® Complete Set Junior 75/4	230 Volt	18521
ALFRA Rotabest® Complete Set Junior 75/4	110 Volt	18521.110

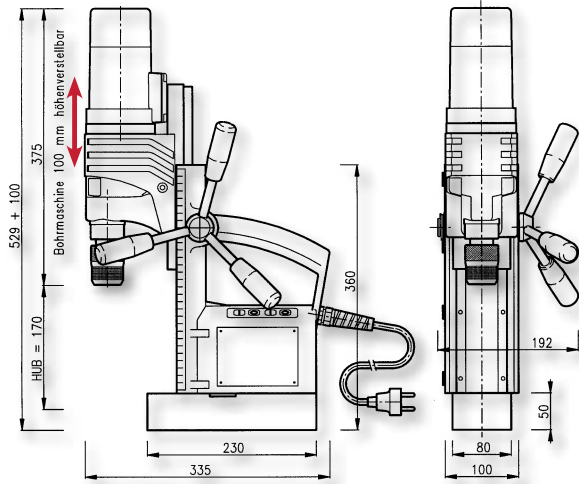




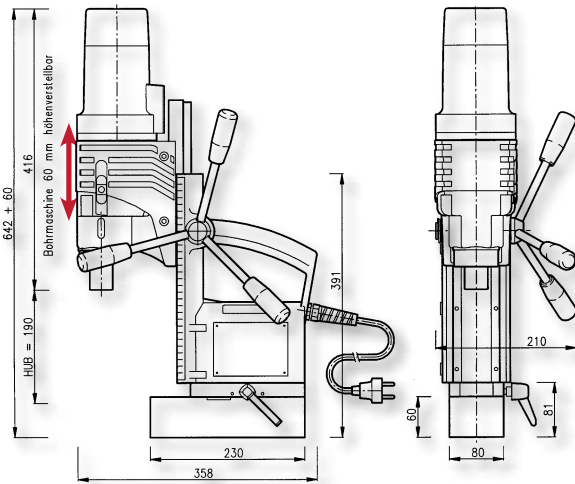
32 RQ



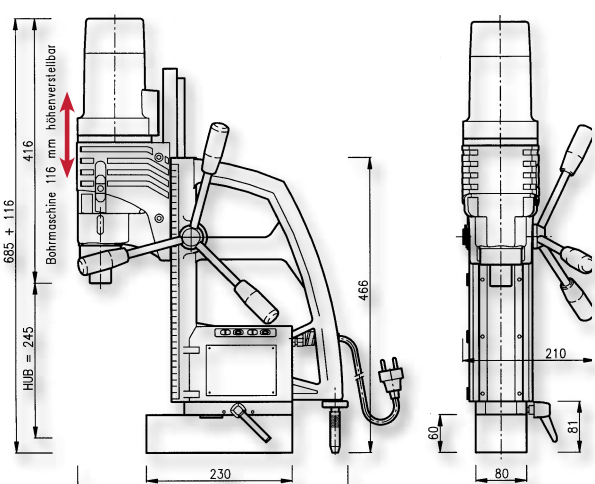
40 RQ + 40 RL-E



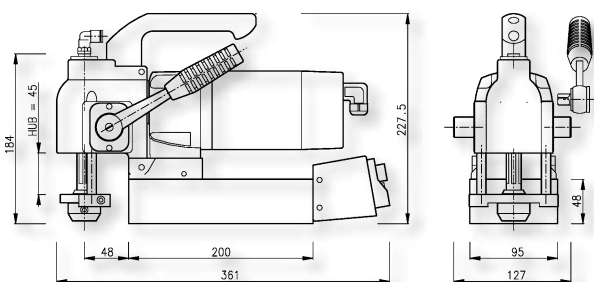
60 + 60 RL-E



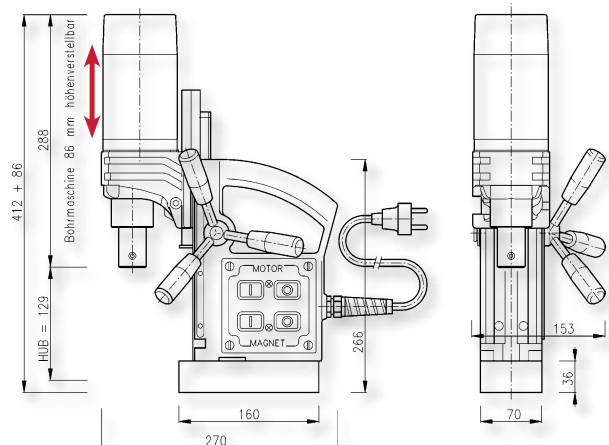
100 + 100 RL-E



V 32



Piccolo 32/50 WD



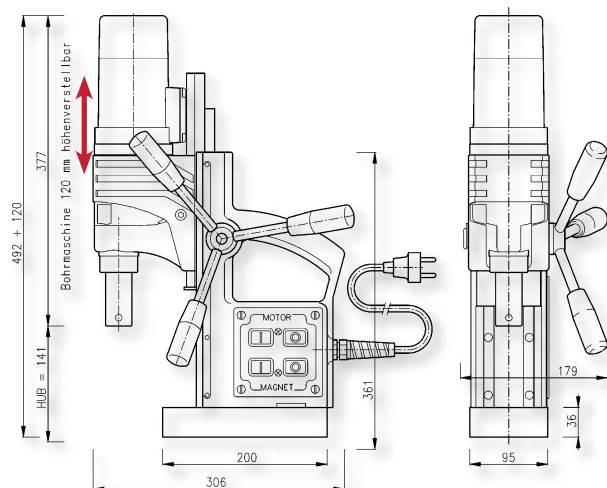


B

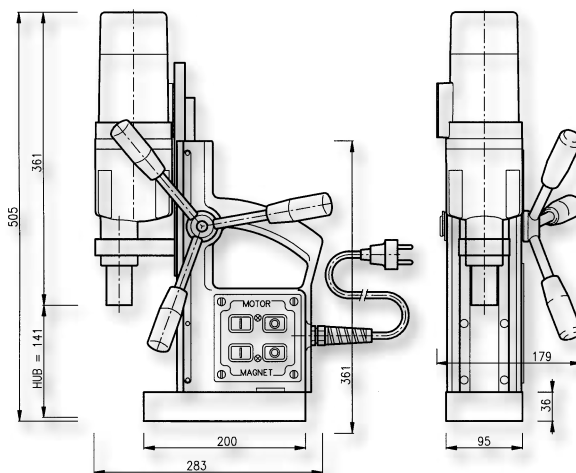
MACHINE DIMENSIONS – ALFRA Rotabest®



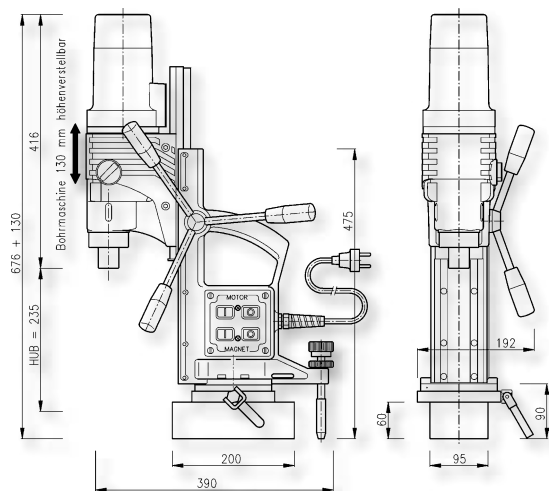
Mini 38/50 WD








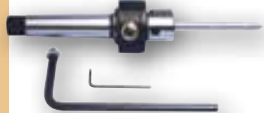


Mini 40/2 WD

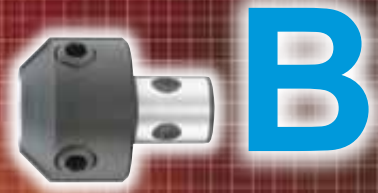


Junior 75/4





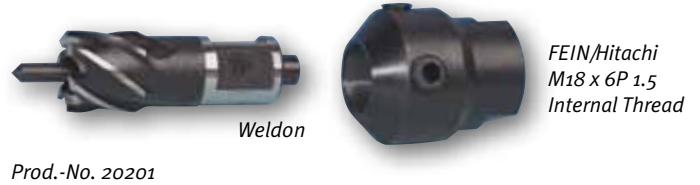
Description	Prod.-No.	32 RQ	40 RQ	60	100	
		Piccolo 32/50WD	40 RL-E Mini 38/50WD	60 RL-E Junior 75/4	100 RL-E	
Drill chuck with Weldon shank for twist drills Ø 1 - 13 mm	18107	■	■			 Prod.-No. 18107
Quick-clamp drill chuck with Morse taper 2 for twist drills Ø 1 - 16 mm	18008		40 RL-E ■	■	■	 Prod.-No. 18008/18009
Quick-clamp drill Chuck with Morse Taper 3 for twist drills Ø 1 - 16 mm	18009			■	■	
Tool Holder AMK-2 – Morse Taper 2 for core drills with Weldon shank Ø 12 - 60 mm with automatic internal cooling – suitable for all machines with drill spindle MT 2	18003		40 RL-E ■			 Prod.-No. 18003/18025
Tool Holder AMK-2 Morse Taper 2 without internal film cooling	18001		40 RL-E ■			 Prod.-No. 18001/18002
Tool Holder AMK-3 – Morse Taper 3 for core drills with Weldon shank Ø 12 - 60 mm with automatic internal cooling – suitable for all machines with drill spindle MT 3	18025			■	■	
Tool Holder AMK-3 Morse Taper 3 without internal film cooling	18002			■	■	
Tool Holder AMK-3 – elongated design with Weldon shank Ø 12 - 50 mm, Cutting Depth 110 mm with automatic internal cooling – suitable for all machines with drill spindle MT 3	18025L			■	■	 Prod.-No. 18025L
Tool Holder AL3 - Morse Taper 3 for cutters strong construction Ø 51 - 100 mm, with keyway with automatic internal cooling	20230			■	■	 Prod.-No. 20230
Quick Change Tool Holder Rota-Quick® Morse Taper 2 with automatic internal cooling suitable for all machines with MT 2 arbor Application area: max. Ø 40 mm core drills	18650		40 RL-E ■	■ With Reducing Sleeve MT 3/2	■ With Reducing Sleeve MT 3/2	
Quick Change Tool Holder Rota-Quick® Morse taper 3 with automatic internal cooling – suitable for all machines with drill spindle MT 3 Application area: max. Ø 40 mm core drills	18651			■	■	 Prod.-No. 18650 + 18651



ACCESSORIES – Adaptors

- You use FEIN Magnet Drilling Machines?
- You do not want to do without ALFRA Rotabest® Cutters?
- No Problem – we have the suitable adaptors

Prod.-No. 20201
 Adaptor with internal thread M18 x 6P 1.5
 Adaptor for the use of Rotabest® HSS-Co-Eco and HSS-Co RQX cutters from Ø 12 to 32.0 mm and Rotabest TCT cutters from Ø 14.0 to 32.0 mm on: FEIN Core Drilling Machines Type KBM 542



Prod.-No. 20202
 Adaptor with external thread (inc. ejector pin)
 Adaptor for use of Fein cutters with internal thread M18 x 6P 1.5 on Metal Core Drilling Machines with Weldon shank.



Prod.-No. 20203
 Ejector pin to fit Prod.-No. 20202 – separate

Prod.-No. 20204
 Adaptor
 Adaptor for the use of all cutters with Weldon shank on Fein Quick IN quick change system.

This adaptor is unnecessary when using our HSS Eco cutters in series Prod. No. 1909... and 2009...

Prod.-No. 1950500
 Ejector pin for HSS cutter, Cutting depth 25 mm
Prod.-No. 1975500
 Ejector pin for HSS cutter, Cutting depth 50 mm



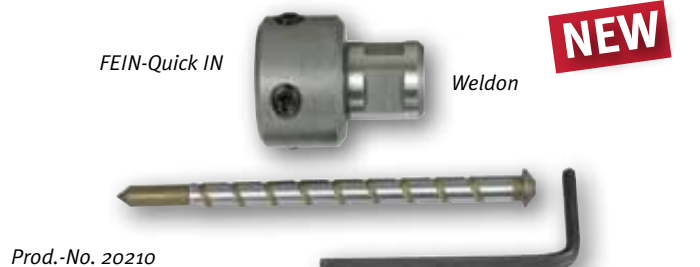
Prod.-No. 20206
 Extension Adaptor
 with Weldon shank and ejector pin.

For the use of cutters 25 – 35 – 50 mm cutting depth in cases when the surface of the material to be drilled is lower than the support surface of the machine. The first ejector pin releases the second ejector pin, the coolant flows through the hole to the cutter.

Total length of Adaptor: 80 mm
 Diameter: 30 mm
 Ejector pin: 6.35 x 77 mm, Prod.-No. 1926500



Prod.-No. 20210
 Adaptor cpl. with ejector pin+ Allen key
 Adaptor for the use of cutters with FEIN Quick IN shank on Metal Core Drilling Machines with Weldon tool holder.



Prod.-No. 1936501
 Replacement ejector pin (for adaptor only) 6.35 x 125 mm

Prod.-No. o6oWD
 Adaptor for TCT Hole Saws, type MBS
 on Metal Core Drilling Machines with Weldon tool holder (incl. ejector pin Prod. No. 1950500)





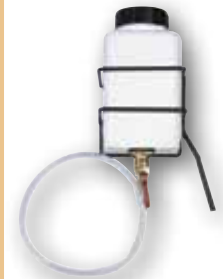
ACCESSORIES – Countersinking/Coolant

For all types

Description	Prod.-No.	32 RQ	40 RQ	60	100
		Piccolo 32/50WD	40 RL-E Mini 38/50WD	60 RL-E Junior 75/4	100 RL-E
HSS Countersink and Deburrer with Weldon shank Ø 25 mm	18533	■	■	■ With Tool Holder 18003/18025 18650+18651	■ With Tool Holder 18003/18025 18650+18651
HSS Countersink and Deburrer with Weldon shank Ø 30 mm	18536	■	■	■ With Tool Holder 18003/18025 18650+18651	■ With Tool Holder 18003/18025 18650+18651
HSS Countersink and Deburrer with Weldon shank Ø 40 mm	18534	■	■	■ With Tool Holder 18003/18025 18650+18651	■ With Tool Holder 18003/18025 18650+18651
HSS Countersink and Deburrer with Weldon shank Ø 55 mm	18537			■	■
Coolant unit, complete (see illustration)	18104	■	■	■	■
Coolant unit with hose and nipple 0.5 litre for Rotabest® V32	18103				
ALFRA Bio 2000 Cutting and Drilling Spray Sprayer 405 ml	21010	■	■	■	■
High-performance wax pin Ideal for vertical and overhead core drillings as paste sticks to the cutter.	09011	■	■	■	■



Prod.-No. 18533



Prod.-No. 18104



Prod.-No. 18103



Prod.-No. 21010 + 09011



ACCESSORIES – Tapping

For all types

Description	Shank	Prod.-No.
Tapping Attachment M3 - M12 Scope of supply: with Rota-Quick®- shank and MT2, interchangeable, plastic case, manual book	MT2 + RotaQuick®	18652
Tapping Attachment M10 - M20 Scope of supply: with Rota-Quick®- shank and MT2, interchangeable, plastic case, manual book	MT2 + RotaQuick®	18653

40 RQ	60	75/4	100
■	■ with reducing sleeve MT 3/2	■ with reducing sleeve MT 3/2	■ with reducing sleeve MT 3/2
■	■ with reducing sleeve MT 3/2	■ with reducing sleeve MT 3/2	■ with reducing sleeve MT 3/2



Prod.-No. 18652 + 18653

Tap Collets with Quick Change Inserts for Rotabest® RL-E, models with right/left rotation.

Tapping Set Size 1 in wooden case consisting of: Quick Change Tapping Adaptor Size 1 MT 2 1pc. each of Tap Collet Size 1 M3 – M4 – M5 – M6 – M8 – M10 – M12 – M14	18660
Tapping Set Size 2 in wooden case consisting of: Quick Change Tapping Adaptor Size 2 MT 3 1pc. each of Tap Collet Size 2 M6 – M8 – M10 – M12 – M14 – M16 – M18 – M20 – M22	18680
Quick Change Tapping Adaptor Size 1 MT 2, separate	18661
Quick Change Tapping Adaptor Size 2 MT 3, separate	18681



Prod.-No. 18680



Prod.-No. 18682 (M6)

Prod.-No. 18681

Tap Collets with clutch

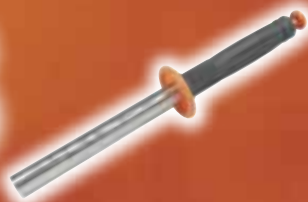
	Shank-Ø	Square	Tap	
Size 1 M3	3,5	2,7	DIN 371	18662
Size 1 M4	4,5	3,4	DIN 371	18663
Size 1 M5	6,0	4,9	DIN 371	18664
Size 1 M6	6,0	4,9	DIN 371	18678
Size 1 M8	8,0	6,2	DIN 371	18665
Size 1 M10	10,0	8,0	DIN 371	18666
Size 1 M12	9,0	7,0	DIN 376	18667
Size 1 M14	11,0	9,0	DIN 376	18668
Size 2 M6	6,0	4,9	DIN 371	18682
Size 2 M8	8,0	6,2	DIN 371	18683
Size 2 M10	10,0	8,0	DIN 371	18684
Size 2 M12	9,0	7,0	DIN 376	18685
Size 2 M14	11,0	9,0	DIN 376	18686
Size 2 M16	12,0	9,0	DIN 376	18687
Size 2 M18	14,0	11,0	DIN 376	18688
Size 2 M20	16,0	12,0	DIN 376	18689
Size 2 M22	18,0	14,5	DIN 376	18690



Prod.-No. 18681 – Assembly Note



B



ALFRA – Magnetic Chip Remover

In a stainless steel round rod, you can move a magnet back and forth. The strong magnet picks up metal chips – pull a knob and the chips fall off. For more cleanliness in the work place.

Prod.-No.

ALFRA Magnetic Chip Remover, Length 400 mm

18654



Prod.-No. 18654





ACCESSORIES – Mechanical Clamping Devices for Pipes

For all types



Description

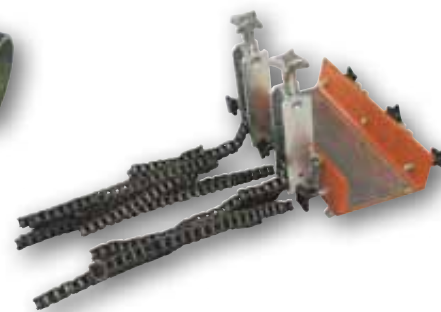
"When all hell is let loose" on site - or in the workshop!
 Our mechanical attachment for clamping pipes with tension chains enables the use of Magnetic Core Drilling Machines on pipes from Ø 80 mm. The adjustment is carried out by means of clamping jaws. For pipes of various Ø.
 Base plate for magnet foot **100 x 205 mm**

Prod.-No.

Attachment for Clamping Pipes with 1 tension chain Ø 80 - 300 mm Weight 7.5 kg	18019
Attachment for Clamping Pipes with 2 tension chains Ø 80 - 900 mm Weight 12 kg	18020
Attachment for Clamping Pipes with tension belt Ø 80 - 900 mm Weight 6.5 kg	18021



Prod.-No. 18019



Prod.-No. 18020

Tension range with double tension belt up to 2000 mm pipe Ø on request Prod.-No. 18022



Prod.-No. 18021

ACCESSORIES – Vacubest Vacuum Attachment

For all types

Description

Vacuum Attachment Vacubest

Prod.-No.

18150

Use on **non-magnetic** surfaces such as aluminium, copper, brass, stainless steel, plastics, structured materials (e.g. bulb or checker plate)

Vacuum capacity: 1.5 m³/h - 25 l/min.
 Max vacuum: 200 mbar (abs)
 Overpressure: 300 mbar
 Dimension of vacuum plate: 400 x 200 mm

Scope of Supply:

Pump (230 V, 50Hz), vacuum plate, vacuum hose 3m

TIP:

Please explain operation range (problems).
 We are pleased to advice.



Vacuum plate



Pump

METAL CORE CUTTERS HAVE GOT A NAME

ALFRA RÖTABEST®

- ▶ HSS-BASIC
- ▶ HSS-CO-Eco
- ▶ HSS-CO RQX COATED
- ▶ ASP-30 RAIL



ALFRA RÖTABEST MAGNETIC CORE DRILLING MACHINES + ALFRA RÖTABEST CUTTERS BELONG TOGETHER. PERFECTLY TUNED WITH EACH OTHER.

**MANUFACTURER'S COMPETENCE
30 YEARS OF EXPERIENCE**

Advantages of ALFRA ROTABEST® Cutters

Design Specially designed cutting geometry

- Advantages**
- Immediate centering
 - No running off center
 - Good concentricity
 - Suitable for NC and CNC machines

Design Optimum regular chip break

- Advantages**
- Smooth cutting
 - Excellent cutting capacity
 - Good chip production at each tooth
 - Regular chip flow

Design Minimum cross section of chip removing surface

- Advantages**
- Easy cutting
 - Low torque
 - Minimum demand for energy

Design High tooth hardness due to optimum raw material and special heat treatment

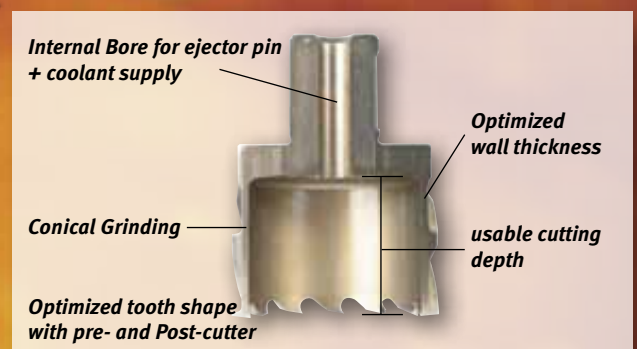
- Advantages**
- Long tool life
 - Also suitable for material difficult to cut

Design High toughness of cutter, specially graduated hardness

- Advantages**
- Low risk of tool break, especially under rough working conditions

Industrial scale manufacturing by state-of-the-art CNC technology

- Best reproducibility
- Constant quality



B



ALFRA ROTABEST® – HSS BASIC Cutters

With Weldon shank 19.0 mm

- With Weldon shank 19.0 mm, 2 clamping surfaces, 1 Countersinking for RotaQuick®
- Internal bore: 6.35 mm
- Steel quality: Special high-capacity speed steel
- Ground section: high performance toothing with pre- and post cutter

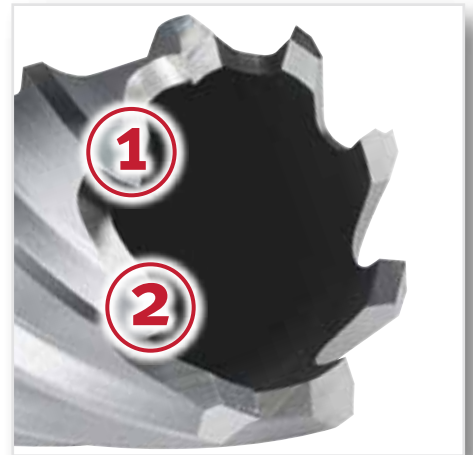
suitable for:

ALFRA-Rotabest® (Weldon), ALFRA-RotaQuick® quick change system, BDS, Bux, Ruko, Magnetor, Euroboor, Universal, Nitto, Jancy, Hougen, Magtron, Promac, Rotabroach and as well as for all types of magnetic drilling machines with Weldon shank.

Ø in mm	Prod.-No	Prod.-No.
Cutting Depth:	25 mm	50 mm
12.0	1907012025	1907012050
13.0	1907013025	1907013050
13.5	1907013525	1907013550
14.0	1907014025	1907014050
15.0	1907015025	1907015050
15.5	1907015525	1907015550
16.0	1907016025	1907016050
17.0	1907017025	1907017050
17.5	1907017525	1907017550
18.0	1907018025	1907018050
19.0	1907019025	1907019050
19.5	1907019525	1907019550
20.0	1907020025	1907020050
21.0	1907021025	1907021050
22.0	1907022025	1907022050
23.0	1907023025	1907023050
24.0	1907024025	1907024050
25.0	1907025025	1907025050
26.0	1907026025	1907026050
26.5	1907026525	1907026550
27.0	1907027025	1907027050
28.0	1907028025	1907028050
29.0	1907029025	1907029050
30.0	1907030025	1907030050
31.0	1907031025	1907031050
32.0	1907032025	1907032050
33.0	1907033025	1907033050
34.0	1907034025	1907034050
35.0	1907035025	1907035050
36.0	1907036025	1907036050
37.0	1907037025	1907037050
38.0	1907038025	1907038050
39.0	1907039025	1907039050
40.0	1907040025	1907040050
41.0	1907041025	1907041050
42.0	1907042025	1907042050
43.0	1907043025	1907043050
44.0	1907044025	1907044050
45.0	1907045025	1907045050
46.0	1907046025	1907046050
47.0	1907047025	1907047050
48.0	1907048025	1907048050
49.0	1907049025	1907049050
50.0	1907050025	1907050050
51.0	-	1907051050
52.0	1907052025	1907052050
53.0	-	1907053050
54.0	-	1907054050
55.0	1907055025	1907055050
56.0	-	1907056050
57.0	-	1907057050
58.0	-	1907058050
59.0	-	1907059050
60.0	1907060025	1907060050
Ejector Pin	1926500	1950500
Dimension mm:	6,35 x 77	6,35 x 102



Countersinking for RotaQuick® Weldon



High performance toothing with pre- (1) and post (2) cutter





ALFRA ROTABEST® – HSS BASIC Cutter Sets

With Weldon shank 19.0 mm



- An assortment of the most popular sizes of cutters clearly presented in a solid plastic case.
- Absolute protection of the teeth even in rough applications on the spot and in the workshop.
- We can manufacture your individual sets from Ø 12.0 to 30.0 mm on request.

Dimensions in inches available upon request

HSS BASIC Cutter Set

Cutting Depth **25 mm**

Prod.-No.

1907003025

6 pc. Cutter Set:

with 1 ea. of Ø 12.0 - 14.0 - 16.0 - 18.0 - 20.0 - 22.0 mm
in solid plastic case

incl. 1 ejector pin Prod.-No. 1926500

Prod.-No. 1907003025



HSS BASIC Cutter Set

Cutting Depth **25 mm**

Prod.-No.

1907001025

10 pc. Cutter Set:

with Ø 2 x 12.0 - 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 mm
in solid plastic case

incl. 2 ejector pins Prod.-No. 1926500

Prod.-No. 1907001025



HSS BASIC Cutter Set

Cutting Depth **50 mm**

Prod.-No.

1907003050

6 pc. Cutter Set:

with 1 ea. of Ø 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm
in solid plastic case

incl. 1 ejector pin Prod.-No. 1950500

Prod.-No. 1907003050



HSS BASIC Cutter Set

Cutting Depth **50 mm**

Prod.-No.

1907001050

10 pc. Cutter Set:

with Ø 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 - 1 x 24.0 - 1 x 26.0 mm
in solid plastic case

incl. 2 ejector pins Prod.-No. 1950500

Prod.-No. 1907001050





ALFRA ROTABEST® – HSS-Co-Eco Cutters

With Weldon shank 19.0 mm

Dimensions in inches available upon request

- With Weldon shank 19.0 mm, 2 clamping surfaces, 1 Countersinking for RotaQuick®
- Internal bore: 6.35 mm
- Steel quality: Special high-capacity speed steel, cobalt
- Ground section: high performance toothing with pre- and post cutter

suitable for:

ALFRA-Rotabest® (Weldon), ALFRA-RotaQuick® quick change system, BDS, Bux, Ruko, Magnetor, Euroboor, Universal, Nitto, Jancy, Hougen, Magtron, Promac, Rotabroach and as well as for all types of magnetic drilling machines with Weldon shank.

Ø in mm Cutting depth	Prod.-No.	Prod.-No.	Prod.-No.	Prod.-No.*
	25 mm	35 mm	50 mm	110 mm
12.0	1901012025	1901012035	1901012050	–
13.0	1901013025	1901013035	1901013050	–
13.5	1901013525	–	1901013550	–
14.0	1901014025	1901014035	1901014050	–
15.0	1901015025	1901015035	1901015050	–
15.5	1901015525	–	1901015550	–
16.0	1901016025	1901016035	1901016050	–
17.0	1901017025	1901017035	1901017050	–
17.5	1901017525	–	1901017550	–
18.0	1901018025	1901018035	1901018050	–
19.0	1901019025	1901019035	1901019050	–
19.5	1901019525	–	1901019550	–
20.0	1901020025	1901020035	1901020050	1901020110
21.0	1901021025	1901021035	1901021050	–
22.0	1901022025	1901022035	1901022050	1901022110
23.0	1901023025	1901023035	1901023050	–
24.0	1901024025	1901024035	1901024050	1901024110
25.0	1901025025	1901025035	1901025050	1901025110
26.0	1901026025	1901026035	1901026050	1901026110
26.5	1901026525	–	1901026550	–
27.0	1901027025	1901027035	1901027050	–
28.0	1901028025	1901028035	1901028050	1901028110
29.0	1901029025	1901029035	1901029050	–
30.0	1901030025	1901030035	1901030050	1901030110
31.0	1901031025	1901031035	1901031050	–
32.0	1901032025	1901032035	1901032050	1901032110
33.0	1901033025	1901033035	1901033050	–
34.0	1901034025	1901034035	1901034050	–
35.0	1901035025	1901035035	1901035050	1901035110
36.0	1901036025	1901036035	1901036050	–
37.0	1901037025	1901037035	1901037050	–
38.0	1901038025	1901038035	1901038050	–
39.0	1901039025	1901039035	1901039050	–
40.0	1901040025	1901040035	1901040050	1901040110
41.0	1901041025	–	1901041050	–
42.0	1901042025	–	1901042050	–
43.0	1901043025	–	1901043050	–
44.0	1901044025	–	1901044050	–
45.0	1901045025	–	1901045050	1901045110
46.0	1901046025	–	1901046050	–
47.0	1901047025	–	1901047050	–
48.0	1901048025	–	1901048050	–
49.0	1901049025	–	1901049050	–
50.0	1901050025	–	1901050050	1901050110
51.0	–	–	1901051050	–
52.0	1901052025	–	1901052050	–
53.0	–	–	1901053050	–
54.0	–	–	1901054050	–
55.0	1901055025	–	1901055050	–
56.0	–	–	1901056050	–
57.0	–	–	1901057050	–
58.0	–	–	1901058050	–
59.0	–	–	1901059050	–
60.0	1901060025	–	1901060050	–
Ejector Pins	1926500	1935500	1950500	2001502
Dimensions mm	6,35 x 77	6,35 x 87	6,35 x 102	8 x 160



Countersinking for RotaQuick® Weldon



High performance toothing with pre- (1) and post (2) cutter



* Attention: HSS-Co-Eco Cutters with cutting depth 110 mm can only be used with Tool Holder AMK 2 L (Prod.-No. 18003 L) or AMK 3 L (Prod.-No. 18025 L).



ALFRA ROTABEST® – HSS-Co-Eco Cutter Sets

With Weldon shank 19.0 mm



- An assortment of the most popular sizes of cutters clearly presented in a solid plastic case.
- Absolute protection of the teeth even in rough applications on the spot and in the workshop.
- We can manufacture your individual sets from Ø 12.0 to 30.0 mm on request.

Dimensions in inches available upon request

HSS-Co-Eco Cutter Set

Cutting Depth **25 mm**

Prod.-No.

1901003025

6 pc. Cutter Set:

with 1 ea. of Ø 12.0 - 14.0 - 16.0 - 18.0 - 20.0 - 22.0 mm

in solid plastic case
incl. 1 ejector pin Prod.-No. 1926500

Prod.-No. 1901003025



HSS-Co-Eco Cutter Set

Cutting Depth **25 mm**

Prod.-No.

1901001025

10 pc. Cutter Set:

with Ø 2 x 12.0 - 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 mm

in solid plastic case
incl. 2 ejector pins Prod.-No. 1926500

Prod.-No. 1901001025



HSS-Co-Eco Cutter Set

Cutting Depth **50 mm**

Prod.-No.

1901003050

6 pc. Cutter Set:

with 1 ea. of Ø 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm

in solid plastic case
incl. 1 ejector pin Prod.-No. 1950500

Prod.-No. 1901003050



HSS-Co-Eco Cutter Set

Cutting Depth **50 mm**

Prod.-No.

1901001050

10 pc. Cutter Set:

with Ø 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 - 1 x 24.0 - 1 x 26.0 mm

in solid plastic case
incl. 2 ejector pins Prod.-No. 1950500

Prod.-No. 1901001050



B



ALFRA ROTABEST® – HSS-Cobalt RQX Cutters, coated

With Weldon shank 19.0 mm • with Balzers Coating

- With Weldon shank 19.0 mm, 2 clamping surfaces, 1 Countersinking for RotaQuick®
- Internal bore: 6.35 mm
- Steel quality: special quality high-capacity speed steel with cobalt, **coated**
- Ground section: high performance tooling with pre- and post cutter

suitable for:

ALFRA-Rotabest® (Weldon), ALFRA-RotaQuick® quick change system, BDS, Bux, Ruko, Magnetor, Euroboor, Universal, Nitto, Jancy, Hougen, Magtron, Promac, Rotabroach and as well as for all types of magnetic drilling machines with Weldon shank.

Dimensions in inches available upon request



Countersinking for RotaQuick® Weldon

Ø in mm	Cutting depth 25 mm	Prod.-No.
12.0		1902012025
13.0		1902013025
14.0		1902014025
15.0		1902015025
16.0		1902016025
17.0		1902017025
18.0		1902018025
19.0		1902019025
20.0		1902020025
21.0		1902021025
22.0		1902022025
23.0		1902023025
24.0		1902024025
25.0		1902025025
26.0		1902026025
27.0		1902027025
28.0		1902028025
29.0		1902029025
30.0		1902030025
31.0		1902031025
32.0		1902032025
33.0		1902033025
34.0		1902034025
35.0		1902035025
36.0		1902036025
37.0		1902037025
38.0		1902038025
39.0		1902039025
40.0		1902040025
41.0		1902041025
42.0		1902042025
43.0		1902043025
44.0		1902044025
45.0		1902045025
46.0		1902046025
47.0		1902047025
48.0		1902048025
49.0		1902049025
50.0		1902050025
51.0		
52.0		
53.0		
54.0		
55.0		
56.0		
57.0		
58.0		
59.0		
60.0		
Ejector pin 6.35 x 77 mm		1926500

Ø in mm	Cutting depth 50 mm	Prod.-No.
12.0		1902012050
13.0		1902013050
14.0		1902014050
15.0		1902015050
16.0		1902016050
17.0		1902017050
18.0		1902018050
19.0		1902019050
20.0		1902020050
21.0		1902021050
22.0		1902022050
23.0		1902023050
24.0		1902024050
25.0		1902025050
26.0		1902026050
27.0		1902027050
28.0		1902028050
29.0		1902029050
30.0		1902030050
31.0		1902031050
32.0		1902032050
33.0		1902033050
34.0		1902034050
35.0		1902035050
36.0		1902036050
37.0		1902037050
38.0		1902038050
39.0		1902039050
40.0		1902040050
41.0		1902041050
42.0		1902042050
43.0		1902043050
44.0		1902044050
45.0		1902045050
46.0		1902046050
47.0		1902047050
48.0		1902048050
49.0		1902049050
50.0		1902050050
51.0		1902051050
52.0		1902052050
53.0		1902053050
54.0		1902054050
55.0		1902055050
56.0		1902056050
57.0		1902057050
58.0		1902058050
59.0		1902059050
60.0		1902060050
Ejector pin 6.35 x 102 mm		1950500



High performance tooling with pre- (1) and post (2) cutter





ALFRA – HSS-Co RQX Cutter Sets

With Weldon shank 19.0 mm • with Balzers Coating

- An assortment of the most popular sizes of cutters clearly presented in a solid plastic case.
- Absolute protection of the teeth even in rough applications on the spot and in the workshop.
- We can manufacture your individual sets from \varnothing 12.0 to 30.0 mm on request.

Dimensions in inches available upon request

HSS-Co RQX Cutter Set

Cutting Depth **25 mm**

Prod.-No. 1902003025

6 pc. Cutter Set:
with 1 ea. of \varnothing 12.0 - 14.0 - 16.0 - 18.0 - 22.0 - 26.0 mm
in plastic box
incl. 1 ejector pin Prod.-No. 1926500

Prod.-No. 1902003025



HSS-Co RQX Cutter Set

Cutting Depth **25 mm**

Prod.-No. 1902001025

10 pc. Cutter Set:
with \varnothing 2 x 12.0 - 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 2 x 22.0 - 1 x 26.0 mm
in plastic box
incl. 2 ejector pins Prod.-No. 1926500

Prod.-No. 1902001025



HSS-Co RQX Cutter Set

Cutting Depth **50 mm**

Prod.-No. 1902003050

6 pc. Cutter Set:
with 1 ea. of \varnothing 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm
in plastic box
incl. 1 ejector pin Prod.-No. 1950500

Prod.-No. 1902003050



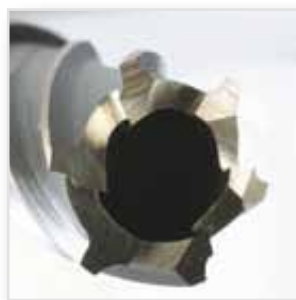
HSS-Co RQX Cutter Set

Cutting Depth **50 mm**

Prod.-No. 1902001050

10 pc. Cutter Set:
with \varnothing 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 - 1 x 24.0 - 1 x 26.0 mm
in plastic box
incl. 2 ejector pins Prod.-No. 1950500

Prod.-No. 1902001050



HSS-Cobalt Cutters for stack drilling (drilling in sandwich material) on request!
(Standard core drills aren't suitable.)

B



ALFRA ROTABEST® – ASP-30 Rail

With Weldon shank 19.0 mm



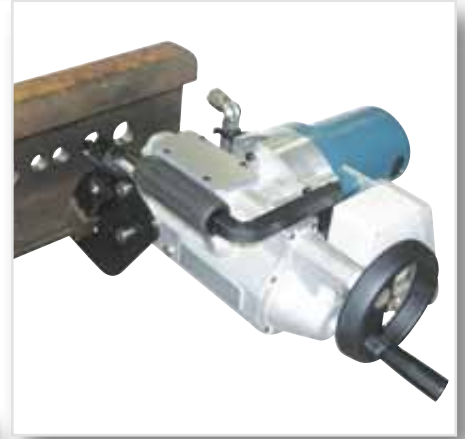
- With Weldon shank 19.0 mm
- Internal bore: 6.35 mm
- Steel quality: Cobalt high-capacity speed steel on powder-metallurgical base with high-purity and improved strength compared to older generation powder steel.
- Perfectly suitable for wear-intensive applications, such as drilling rails.
- These tools can also be used on all magnet drilling machines, especially with Weldon shank.

Suitable for:

all portable Magnet Drilling Machines with 19 mm Weldon arbor, but especially for Rail Drilling Machines of the makes:

- Cembre
- Erico
- KKT
- Dubuis
- Universal
- Magtron
- Rotabroach

Dimensions in inches available upon request



Ø in mm Cutting depth 25 mm Prod.-No.

14.0	1905014025
16.0	1905016025
17.0	1905017025
18.0	1905018025
19.0	1905019025
20.0	1905020025
22.0	1905022025
23.0	1905023025
24.0	1905024025
25.0	1905025025
26.0	1905026025
27.0	1905027025
27.5	1905027525
28.0	1905028025
30.0	1905030025
31.0	1905031025
32.0	1905032025
33.0	1905033025
34.0	1905034025
36.0	1905036025
Ejector pin 6.35 x 77 mm	1926500

Ø in mm Cutting depth 50 mm Prod.-No.

14.0	1905014050
16.0	1905016050
17.0	1905017050
18.0	1905018050
19.0	1905019050
20.0	1905020050
22.0	1905022050
23.0	1905023050
24.0	1905024050
25.0	1905025050
26.0	1905026050
27.0	1905027050
27.5	1905027550
28.0	1905028050
30.0	1905030050
31.0	1905031050
32.0	1905032050
33.0	1905033050
34.0	1905034050
36.0	1905036050
Ejector pin 6.35 x 102 mm	1950500

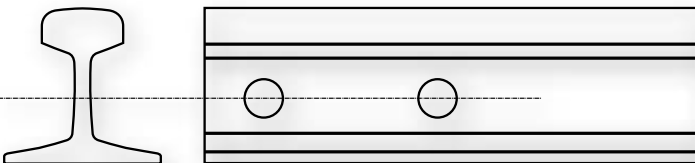


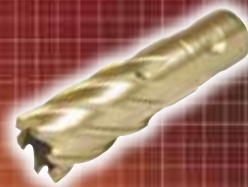
Tip:

Well-proven for drilling Hardox and similar high-tensile steels. Name your drilling problem, we are pleased to advise.

Another Tip:

ASP-60 for "impossible" drilling jobs on request.





B

ALFRA – HSS-Co-Eco Cutters for FEIN-QUICK IN

SUITABLE FOR FEIN MAGNET DRILLING MACHINES



- Suitable for FEIN Magnet Drilling Machines with Quick IN tool holder.
- You use FEIN Magnet Drilling Machines and do not want to do without ALFRA-Rotabest® Cutters? Here is our range of HSS-Co-Eco Cutters suitable for the various FEIN types of machines.
- Special shank 18.0 mm with 4 ball recesses
- Steel quality: Special high-capacity speed steel, cobalt
- Internal bore: 6.4 mm.
- suitable for: FEIN Quick-IN quick change arbor, FEIN core drilling machines with Quick-IN quick-change system of types KBM 32 Q, KBM 50 Q, KBM 65 Q, KBM 65 QF

Ø in mm	Cutting depth 35 mm	Prod.-No.
12.0		1909012035
13.0		1909013035
14.0		1909014035
15.0		1909015035
16.0		1909016035
17.0		1909017035
18.0		1909018035
19.0		1909019035
20.0		1909020035
21.0		1909021035
22.0		1909022035
23.0		1909023035
24.0		1909024035
25.0		1909025035
26.0		1909026035
27.0		1909027035
28.0		1909028035
29.0		1909029035
30.0		1909030035
31.0		1909031035
32.0		1909032035
Ejector pin	6,35 x 106 mm	1936500



Prod.-No. 1936500

Dimensions in inches available upon request



High performance toothing with pre- and post cutter

ALFRA – HSS-Co-Eco Cutters suitable for FEIN + Hitachi

- Adaptor with internal thread M18 x 6P 1.5
- Also suitable for Hitachi machines

Ø in mm	Cutting depth 50 mm	Prod.-No.
12.0		1908012050
13.0		1908013050
14.0		1908014050
15.0		1908015050
16.0		1908016050
17.0		1908017050
18.0		1908018050
19.0		1908019050
20.0		1908020050
21.0		1908021050
22.0		1908022050
23.0		1908023050
24.0		1908024050
25.0		1908025050
26.0		1908026050
27.0		1908027050
28.0		1908028050
29.0		1908029050
30.0		1908030050



METAL CORE CUTTERS HAVE GOT A NAME

ALFRA ROTABEST®

▶ **TUNGSTEN
CARBIDE TIPPED**



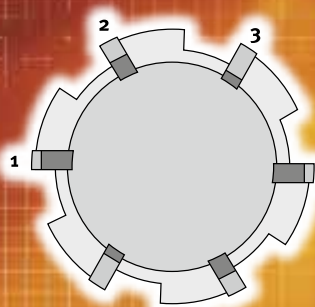
ALFRA ROTABEST MAGNETIC CORE DRILLING MACHINES + ALFRA ROTABEST CUTTERS BELONG TOGETHER. PERFECTLY TUNED WITH EACH OTHER.

MANUFACTURER'S COMPETENCE
30 YEARS OF EXPERIENCE

Usable on Magnet Drilling - and Pillar Drilling Machines.
For constructional steels, hard-to-cut materials, such as
chrome-nickel steels and for non-ferrous metals, such as
aluminium or CuZn-alloys and many more.

Advantages of ALFRA ROTABEST® TCT Cutters

- Good concentricity through solid construction
- CAD - optimized cutting geometry for regular chip break
- Specially shaped chip flutes to avoid chip jamming
- Immediate centering
- No running off center
- Low torque
- Minimum demand for energy
- Quick core removal through ejector pin
- Long tool life



ALFRA "Chip-breaker system" Very precise drilling in 3 steps.

- 1 pre-cutter
- 2 middle-cutter
- 3 post-cutter



ALFRA ROTABEST® – TCT Cutters

With Weldon shank 19.0 mm

- With Weldon shank 19.0 mm
- Internal bore: $\varnothing 14 - 17 \text{ mm} = 6.35 \text{ mm}$
 $\varnothing 18 - 50 \text{ mm} = 8.0 \text{ mm}$
- Ground section: high performance toothing with pre- middle- and post cutter
- Perfectly suitable for wear-intensive applications.
- These tools can also be used on all magnetic drilling machines with Weldon shank.

Suitable for:

all magnetic drilling machines with Weldon shank. ALFRA-Rotabest® (Weldon), ALFRA-Rota-Quick® quick-change system, on BDS, Bux, Ruko, Magnetor, Euroboor, Universal, Nitto, Jancy, Hougen, Magtron, Promac, Rotabroach, etc.

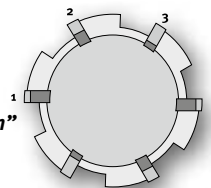


Ø in mm Cutting depth 35 mm Prod.-No.

14.0	2003014035
15.0	2003015035
16.0	2003016035
17.0	2003017035
18.0	2003018035
19.0	2003019035
20.0	2003020035
21.0	2003021035
22.0	2003022035
23.0	2003023035
24.0	2003024035
25.0	2003025035
26.0	2003026035
27.0	2003027035
28.0	2003028035
29.0	2003029035
30.0	2003030035
31.0	2003031035
32.0	2003032035
33.0	2003033035
34.0	2003034035
35.0	2003035035
36.0	-
37.0	-
38.0	-
39.0	-
40.0	-
41.0	-
42.0	-
43.0	-
44.0	-
45.0	-
46.0	-
47.0	-
48.0	-
49.0	-
50.0	-
-	-
Ejector Pin for $\varnothing 14 - 17 \text{ mm}$, 6.35 x 87 mm	1935500
Ejector Pin for $\varnothing 18 - 50 \text{ mm}$, 8 x 87 mm	2001500

Ø in mm Cutting depth 50 mm Prod.-No.

14.0	2003014050
15.0	2003015050
16.0	2003016050
17.0	2003017050
18.0	2003018050
19.0	2003019050
20.0	2003020050
21.0	2003021050
22.0	2003022050
23.0	2003023050
24.0	2003024050
25.0	2003025050
26.0	2003026050
27.0	2003027050
28.0	2003028050
29.0	2003029050
30.0	2003030050
31.0	2003031050
32.0	2003032050
33.0	2003033050
34.0	2003034050
35.0	2003035050
36.0	2003036050
37.0	2003037050
38.0	2003038050
39.0	2003039050
40.0	2003040050
41.0	2003041050
42.0	2003042050
43.0	2003043050
44.0	2003044050
45.0	2003045050
46.0	2003046050
47.0	2003047050
48.0	2003048050
49.0	2003049050
50.0	2003050050
-	-
Ejector Pin for $\varnothing 14 - 17 \text{ mm}$, 6.35 x 102	1950500
Ejector Pin for $\varnothing 18 - 50 \text{ mm}$, 8 x 102 mm	2001501



ALFRA "Chip-breaker system"

- 1 pre-cutter
- 2 middle-cutter
- 3 post-cutter

ALFRA ROTABEST® – TCT Cutters

Suitable for all core drilling, pillar drilling and milling machines



B



- Heavy industrial type **with keyway and feather key**
- In extensive test series, this special design with keyway and feather key has proven outstanding compared to the standard Weldon shank 32 mm. Optimal absorption of the high torsion forces.
- Ground section: high performance toothing with pre- middle- and post cutter.
- Required: Tool holder with internal cooling

AL 3	MT 3	Prod.-No. 20230
AL 4	MT 4	Prod.-No. 20240
AL 5	MT 5	Prod.-No. 20250

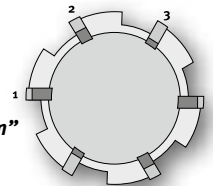
Dimensions in inches available upon request



Shorter, more stable tool setup.
ALFRA Design.
High concentricity.

ALFRA "Chip-breaker system"

- 1 pre-cutter
- 2 middle-cutter
- 3 post-cutter



Ø in mm	depth 50 mm	Prod.-No.
51.0	■	2002051050
52.0	■	2002052050
53.0	■	2002053050
54.0	■	2002054050
55.0		2002055050
56.0	■	2002056050
57.0	■	2002057050
58.0	■	2002058050
59.0	■	2002059050
60.0		2002060050
61.0	■	2002061050
62.0	■	2002062050
63.0	■	2002063050
64.0	■	2002064050
65.0		2002065050
66.0	■	2002066050
67.0	■	2002067050
68.0	■	2002068050
69.0	■	2002069050
70.0		2002070050
71.0	■	2002071050
72.0	■	2002072050
73.0	■	2002073050
74.0	■	2002074050
75.0		2002075050
76.0	■	2002076050
77.0	■	2002077050
78.0	■	2002078050
79.0	■	2002079050
80.0		2002080050
81.0	■	2002081050
82.0	■	2002082050
83.0	■	2002083050
84.0	■	2002084050
85.0		2002085050
86.0	■	2002086050
87.0	■	2002087050
88.0	■	2002088050
89.0	■	2002089050
90.0		2002090050
91.0	■	2002091050
92.0	■	2002092050
93.0	■	2002093050
94.0	■	2002094050
95.0		2002095050
96.0	■	2002096050
97.0	■	2002097050
98.0	■	2002098050
99.0	■	2002099050
100.0		2002100050
■ No series production		
Ejector pin 8 x 102 mm		2001501
Tool holder AL 2/MT 2		20220
Tool holder AL 3/MT 3		20230
Tool holder AL 4/MT 4		20240
Tool holder AL 5/MT 5		20250

Advantages of ALFRA TCT Cutters, "Heavy Industrial Type"

- Perfect cutting behaviour – even at the first bore
- Excellent centering properties
- Low cutting pressure – low power input
- Vibration-free work process
- Chip separation – no jamming of the chips
- Cutting depth can be achieved in one work step
- Drilled core ejected without effort



Prod.-No. 20230

B



ALFRA ROTABEST® – TCT Cutters, RAIL

With Weldon shank 19.0 mm



- With Weldon shank 19.0 mm
- Internal bore: 6.35 mm
- Perfectly suitable for wear-intensive applications, such as drilling rails.
- Ground section: high performance toothing with pre- middle- and post cutter

Suitable for:

all portable Magnet Drilling Machines with 19 mm Weldon arbor, but especially for Rail Drilling Machines of the following makes:

- Cembre
- Erico
- KKT
- Dubuis
- Universal
- Magtron
- Rotabroach

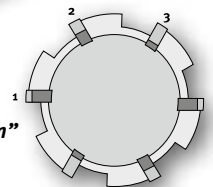
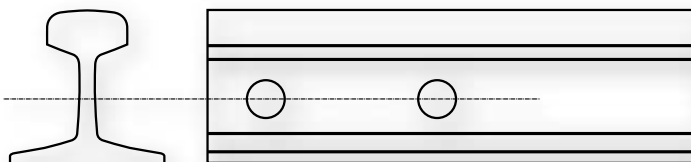


Ø in mm Cutting depth 25 mm Prod.-No.

19.0	2005019025
20.0	2005020025
21.0	2005021025
22.0	2005022025
23.0	2005023025
24.0	2005024025
25.0	2005025025
26.0	2005026025
27,5	2005027525
28.0	2005028025
30.0	2005030025
31.0	2005031025
32.0	2005032025
33.0	2005033025
34.0	2005034025
36.0	2005036025
Ejector pin 6.35 x 77 mm	1926500

Ø in mm Cutting depth 50 mm Prod.-No.

19.0	2005019050
20.0	2005020050
21.0	2005021050
22.0	2005022050
23.0	2005023050
24.0	2005024050
25.0	2005025050
26.0	2005026050
27,5	2005027550
28.0	2005028050
30.0	2005030050
31.0	2005031050
32.0	2005032050
33.0	2005033050
34.0	2005034050
36.0	2005036050
Ejector pin 6.35 x 102 mm	1950500



ALFRA "Chip-breaker system"

- 1 pre-cutter
- 2 middle-cutter
- 3 post-cutter





ALFRA – HSS Cutters suitable for FEIN + Hitachi



- 2008... with internal thread M18 x 6P 1.5.
Also suitable for Hitachi machines
- 2009... suitable for FEIN Magnet Drilling Machines with Quick IN tool holder.

Ø in mm	Prod.-No.	Prod.-No.
	M18 x 6P 1.5 Cutting Depth 50 mm	Quick IN Cutting depth 35 mm
12.0	2008012050	2009012035
13.0	2008013050	2009013035
14.0	2008014050	2009014035
15.0	2008015050	2009015035
16.0	2008016050	2009016035
17.0	2008017050	2009017035
18.0	2008018050	2009018035
19.0	2008019050	2009019035
20.0	2008020050	2009020035
21.0	2008021050	2009021035
22.0	2008022050	2009022035
23.0	2008023050	2009023035
24.0	2008024050	2009024035
25.0	2008025050	2009025035
26.0	2008026050	2009026035
27.0	2008027050	2009027035
28.0	2008028050	2009028035
29.0	2008029050	2009029035
30.0	2008030050	2009030035
31.0	2008031050	2009031035
32.0	2008032050	2009032035
33.0	2008033050	2009033035
34.0	2008034050	2009034035
35.0	2008035050	2009035035
36.0	2008036050	2009036035
37.0	2008037050	2009037035
38.0	2008038050	2009038035
39.0	2008039050	2009039035
40.0	2008040050	2009040035
41.0	2008041050	2009041035
42.0	2008042050	2009042035
43.0	2008043050	2009043035
44.0	2008044050	2009044035
45.0	2008045050	2009045035
46.0	2008046050	2009046035
47.0	2008047050	2009047035
48.0	2008048050	2009048035
49.0	2008049050	2009049035
50.0	2008050050	2009050035
51.0	2008051050	2009051035
52.0	2008052050	2009052035
53.0	2008053050	2009053035
54.0	2008054050	2009054035
55.0	2008055050	2009055035
57.0	2008057050	2009057035
58.0	2008058050	2009058035
59.0	2008059050	2009059035
60.0	2008060050	2009060035
61.0	2008061050	2009061035
62.0	2008062050	2009062035
63.0	2008063050	2009063035
64.0	2008064050	2009064035
65.0	2008065050	2009065035
Ejector pin 6.35 x 106 mm	-	1936500



Prod.-No. 2008...



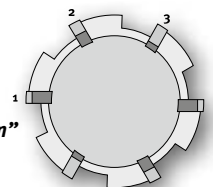
Thread adaptor M18 x 6P1.5



Prod.-No. 2009...



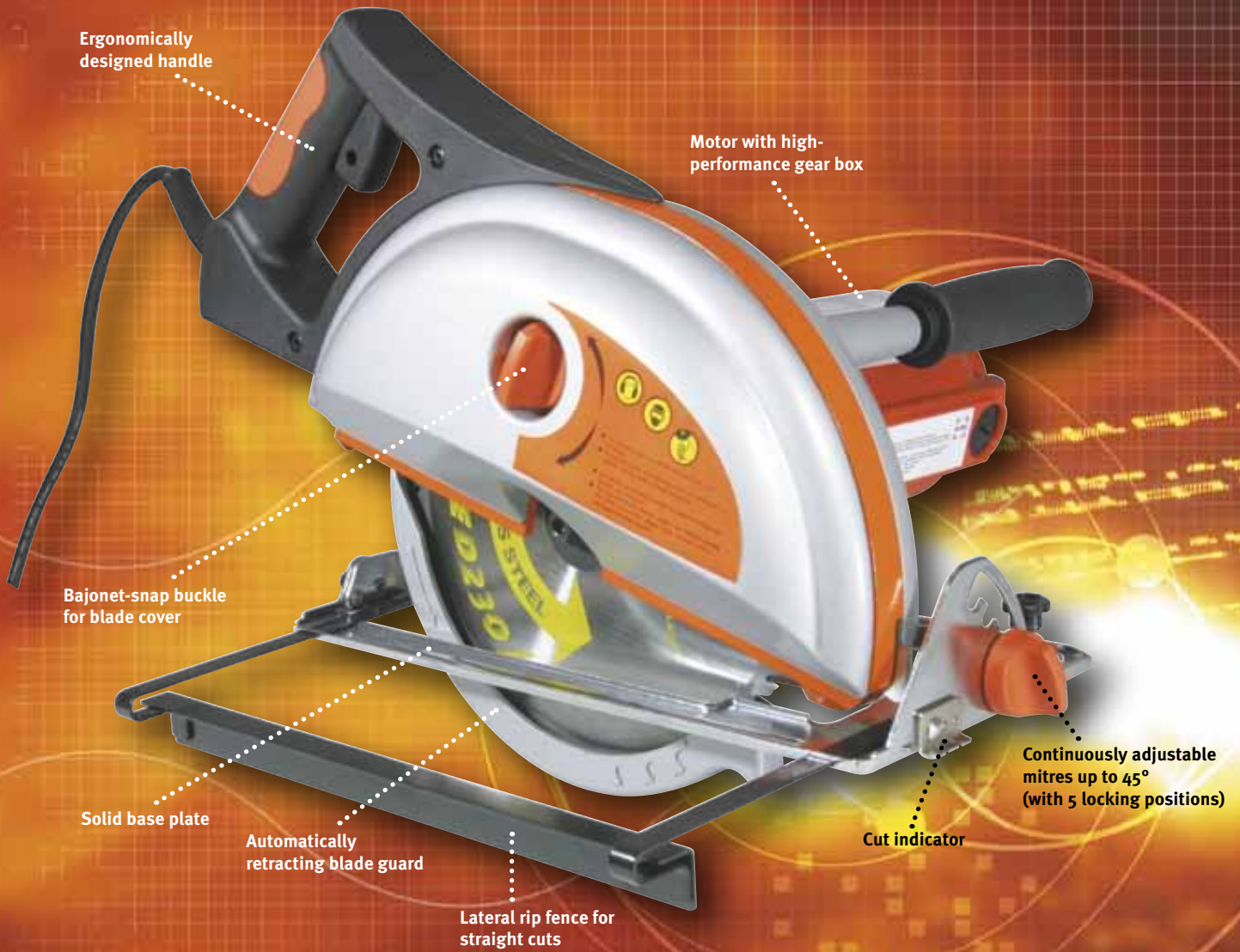
Prod.-No. 1936500



ALFRA "Chip-breaker system"

- 1 pre-cutter
- 2 middle-cutter
- 3 post-cutter

ALFRA ROTASPEED®





ALFRA ROTASPEED® – Metal Cutting Saw RS 200 + RS 230



The ideal machine for worksite and workshop, for almost burr-free cutting without cooling.

For fast and clean cuts in pipes, threaded rods, profiles, wire ducts, corrugated and trapezoidal sheets, sandwich panels, dry mortarless construction profiles and many more.

Advantages at a glance:

- 1700 Watt high-performance motor for exact cuts without coolant.
- Fast and easy change of saw blade.
- Continuously adjustable cutting depth to 67 mm at RS 200 and 82 mm at RS 230.
- The base blade is adjustable for mitre cuts up to 45°.
- Chip collector.
- The ideal machine for site assembly companies, facade builders, repair shops, locksmitheries, rack builders, roofers, booth builders, welding shops, plumbing and heating contractors.
- Ideally applicable, where angle grinders aren't strong enough or clean enough.
- Ideal for weld preparation by mitre cutting.

ALFRA RotaSpeed® RS 200

Saw blade diameter:	200 mm (8")
Saw blade arbor:	30/25.4/20 mm
Power:	1700 Watts
Speed, rpm:	3700
Mitre:	0 - 45°
Cutting capacity mm 0°:	67
Cutting capacity mm 45°:	42
Max. material thickness (depending on material):	6 mm
Voltage:	230 - 50/60 Hz
Weight:	6.3 kg

Prod.-No.
22400

Alfra RotaSpeed® RS 200

ALFRA RotaSpeed® RS 230

Saw blade diameter:	230 (9")
Saw blade tool holder:	30/25.4/20 mm
Power:	1700 Watts
Speed, rpm:	2600
Mitre:	0 - 45°
Cutting capacity mm 0°:	82
Cutting capacity mm 45°:	56
Max. material thickness (depending on material):	6 - 8 mm
Voltage:	230 - 50/60 Hz
Weight:	7.1 kg

Prod.-No.
22410

Alfra RotaSpeed® RS 230

Scope of Supply:

Machine with 2 TCT Saw Blades (premium quality), Operation Manual, Rip Fence, Set of Tools, Distance sleeve for Saw Blade Arbor, in cardboard box.



We reserve the right to make technical changes.



ALFRA CIRCULAR SAW BLADES – RotaSpeed®

ALFRA-ROTA SPEED® TCT CIRCULAR SAW BLADES. • MADE IN GERMANY

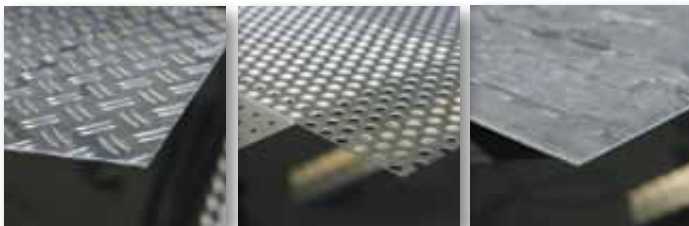
- Tungsten carbide tipped, suitable for metal cutting saws from: ALFRA, Flex, Euroboor, Evolution, Hitech, Jepson, Metallkraft, Ridgid, etc.
- These special TCT circular saws ensure fast and clean cuts in pipes, threaded rods, profiles, corrugated and trapezoidal sheets, wire ducts, sandwich panels, dry mortarless construction profiles, fastening profiles (DIN rails), grates using dry cutting method.
- For use on metals, CrNi steel*, aluminium.
- High cutting performance and tool life. The excellent price/performance ratio makes these saws highly economical.
- **The corresponding manufacturer's machine guidelines and notes on use must be observed when using these saw blades.**

Premium Quality

Cutting Ø mm	Application	Dimensions mm	No. of teeth	Prod.-No.
180/7"	Steel*	180 x 20	34	22205
180/7"	Aluminium	180 x 20	48	22206
200/8"	Steel*	200 x 20	42	22255
200/8"	Aluminium	200 x 20	54	22256
200/8"	for trapezoidal sheets	200 x 20	68	22257
230/9"	Steel*	230 x 25.4	48	22305
230/9"	Aluminium	230 x 25.4	62	22306
230/9"	for trapezoidal sheets	230 x 25.4	80	22307

* With stainless steel, the tool life will be lower in relation to the material thickness.

Packaging unit = 1 piece



Prod.-No. 18654

Magnetic Chip Remover

In a stainless steel round rod, you can move a magnet back and forth. The strong magnet picks up metal chips – pull a knob and the chips fall off. For more cleanliness in the work place.

Prod.-No.

ALFRA Magnetic Chip Remover, Length 400 mm

18654



ALFRA ROTADRY® – Drycutter 355

Arguments which are convincing in quality, performance and pricing:

- For almost burr-free cutting of profiles and pipes out of steel, iron, copper, brass, aluminium, plastics, composites and stainless steel without cooling.
- Application e.g. in steel construction, cabinet making, interior fittings etc.
- With depth fence for accurate cutting
- Angle and parallel stopper for mitre cuts up to 45°
- With a removable chip collecting sump
- With arbor adjustment for changing the saw blades
- Easy to transport

ALFRA RotaDry® 355

Saw blade diameter	355 mm	
Motor	230 V/50 Hz	
Input	2200 W	
Speed	1300 rpm	
Cutting capacity 90°	13 mm wall thickness	180 x 105 mm
Cutting capacity 90°	13 mm wall thickness	120 x 120 mm
Cutting capacity 90°	13 mm wall thickness	135 mm
Cutting capacity 45°	13 mm wall thickness	110 x 100 mm
Cutting capacity 45°	13 mm wall thickness	100 x 100 mm
Cutting capacity 45°	13 mm wall thickness	105 mm
Weight	23 kg	

Alfra RotaDry® 355, with 1 TCT Saw Blade 72 T (teeth)	Prod.-No. 22420
---	---------------------------



Prod.-No. 22420

Spare TCT Circular Saw Blades

also suitable for cutting-off machines, such as:

Jepson/Global/Ridgid/Ryobi

The universal TCT saw blade for fast cutting of:

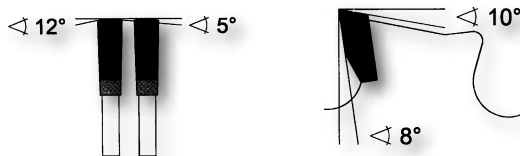
steel – copper – aluminium – profiles – cable – sheet metal – solid material

- without coolant
- Regrindable
- Low noise due to laser ornaments

Deliverable dimensions	Steel	Stainless steel*	Prod.-No.
305 x 2.2 x 25.4 60 T	•	–	32100
305 x 2.2 x 25.4 80 T	•	•	32101
355 x 2.6 x 25.4 72 T	•	–	32104
355 x 2.6 x 25.4 80 T	•	•	32103
355 x 2.6 x 25.4 90 T	•	•	32102
355 x 2.6 x 25.4 90 T	coated		32105

Other tooth counts upon request.

* With stainless steel, the tool life will be lower in relation to the material thickness.



355 x 2.6 x 25.4 • 90 T • coated

ALFRA



RBX 120 HV



RBX 180 HV

ROTAFLEX®

Portable Band Saw Machines for Professionals

There is a variety of portable band saw machines, but only a few of them are suitable for industrial applications or at a construction site. Pricing is usually being more important than reliability and durability.

Our new machines have an excellent price-performance-ratio and are setting new standards. The robust and compact design makes it ideal for handling in the machine shop or the construction site.

Ideally qualified for locksmiths, plumbing, metal-, heating-, pipeline- and mechanical workshops. Also for construction companies, public utilities with or without mobile workshops, power stations, schools, technical learning and teaching facilities.

Special Features:

- Portable
- Mobile
- Change from horizontal or vertical cutting within seconds. With help of the vertical section notches or contours can be cut out easily from radius 85 mm on.
- For vertical section 0 - 45 ° stepless
- Very fast band saw blade-change, as the change is on the front side
- Cutting pressure adjustment in 4 steps, matched to the material cross section
- Safe material clamping due to quick-vice application
- Robust high-performance single-phase-motor
- 4-fold ball bearings-blade guide RBX 120 HV
- 8-fold ball bearings-blade guide RBX 180 HV
- Adjustable ball bearings-blade guide for angular cutting

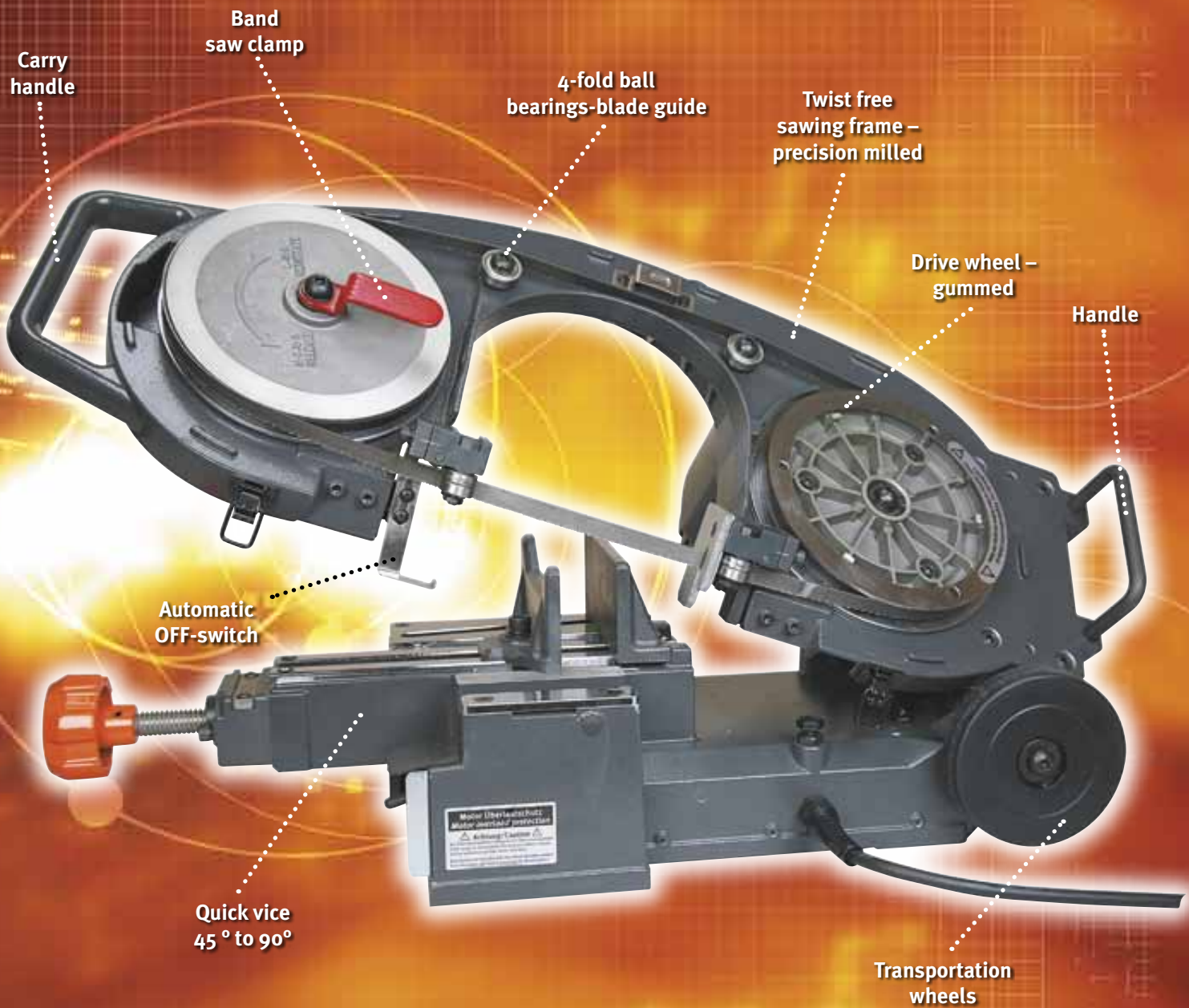


B



ALFRA Band Saw Machine

RBX 120 HV



ALFRA BAND SAW MACHINE – RBX 120 HV

Our portable Band Saw Machine RBX 120 HV cuts reliably gas pipes and conduits as well as thin walled pipes made of stainless steel, construction steel, aluminium and PVC. Furthermore it's particularly suitable for cutting flat and profiled materials.

90°	∅	120 mm; 4-3/4"
	□	105 mm; 4-1/8"
	●	60 mm; 3-3/8"
45°	∅	50 mm; 2"
	□	50 mm; 2"



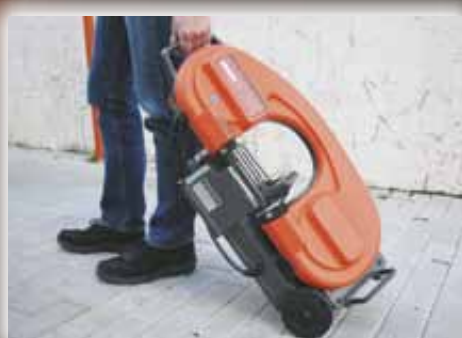
Technical Data:

Induction motor, capacity	400 Watts
Power	230 V
Cutting speed	40.5 m/min ⁻¹ – 50 Hz 49.0 m/min ⁻¹ – 60 Hz
Feed	Automatic
Cutting pressure adjustment:	4 steps
Mitre	0 - 45°
Band saw measurements	1430 x 13 x 0.65 mm; 56-1/3" x 1/2" x 0.025"
90°	∅ 120 mm; 4-3/4" □ 105 mm; 4-1/8" ● 60 mm; 3-3/8"
45°	∅ 50 mm; 2" □ 50 mm; 2"
ED:	40 %
Sound level (during no-load operation)	75 dB(A)
Unit size (mm)	length 780, width 340, high 335
Weight:	35 kg; 77 lbs



Standard Accessories:

- Portable Band Saw Machine RBX 120 HV – 230 V (110 V on demand)
- HSS Bi-Metal Band saw blade
- Operator protection plug
- Tool kit
- Operation manual



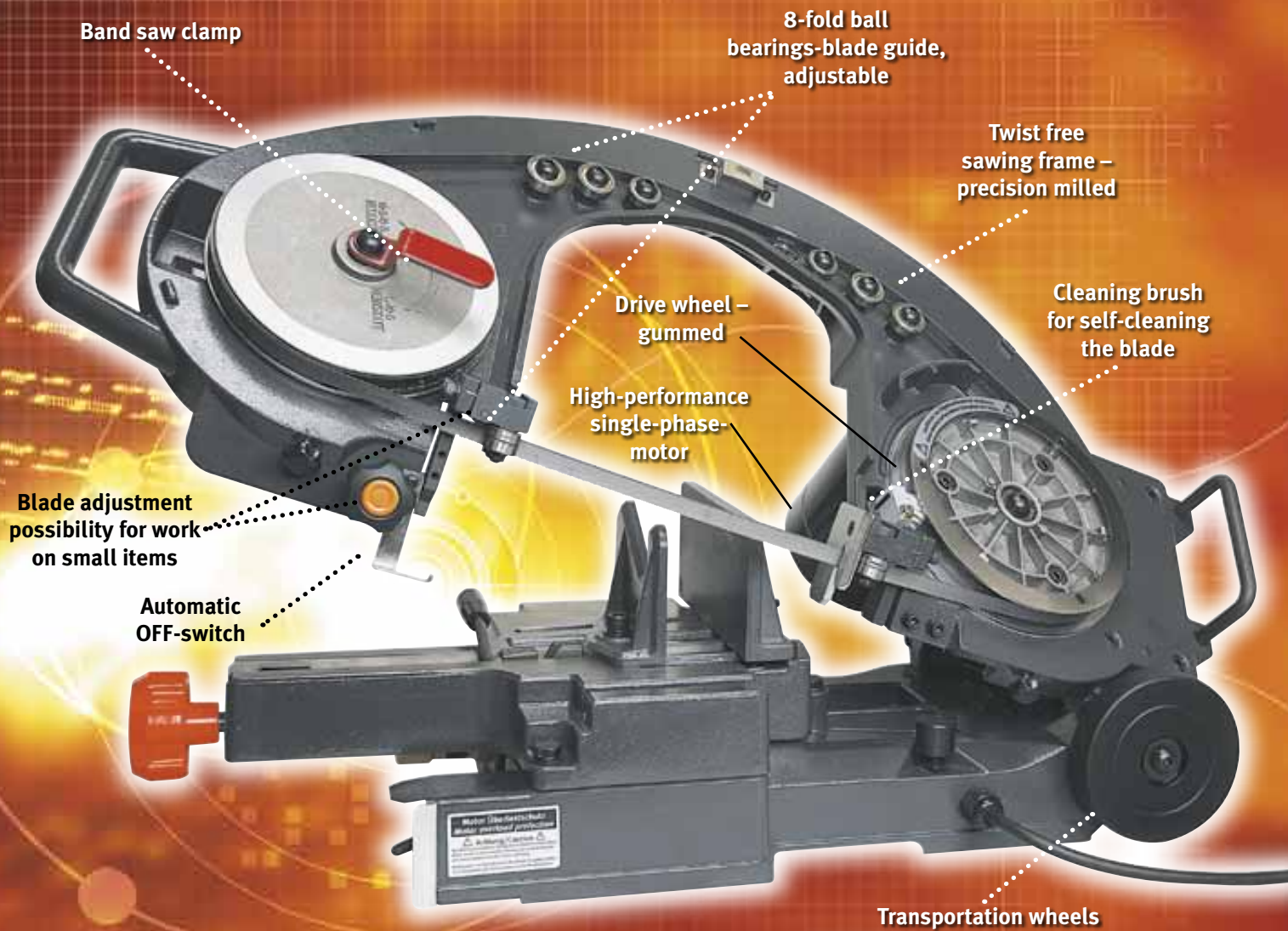
			Prod.-No.
Band Saw Machine RBX 120 HV			22500
Special Accessories			
Enlarged saw table 150 x 100 mm; 6" x 3-15/16"			22523
Replacement Band Saw Blades HSS-Bi-Metal			
1430 x 13 x 0.65 mm; 56-1/3" x 1/2" x 0.025"			
HSS Bi-Metal	10 tpi	IPU = 10 pcs	22510
HSS Bi-Metal	14 tpi	IPU = 10 pcs	22511
HSS Bi-Metal	6/10 tpi	IPU = 10 pcs	22512
HSS Bi-Metal	8/12 tpi	IPU = 10 pcs	22513
HSS Bi-Metal	10/14 tpi	IPU = 10 pcs	22514

B



ALFRA Band Saw Machine

RBX 180 HV



Optional:
Chain vice for pipes and profiles (90° only)



ALFRA BAND SAW MACHINE – RBX 180 HV

Our Band Saw Machine RBX 180 HV features all technical advantages of the small one but with extended capacity:

90°	∅	180 mm, 7"
	□	150 mm; 6"
45°	∅	80 mm, 3-5/32"
	□	80 mm, 3-5/32"

The standard quick-clamping flat vice can be changed into a chain vice within seconds. Therefore big diameter tubes can be clamped tightly and machined.



Technical Data:

Induction motor, capacity	380 Watts
Power	230 V
Cutting speed	40.5 m/min ⁻¹ – 50 Hz 49.0 m/min ⁻¹ – 60 Hz
Feed	Automatic
Cutting pressure adjustment	4 steps
Mitre	0-45° with quick clamp flat vice; 90° with chain vice
Band saw measurements:	1625 x 13 x 0, 65 mm; 64" x 1/2" x 0.025"
90°	∅ 180 mm, 7" □ 150 mm; 6"
45°	∅ 80 mm, 3-5/32" □ 80 mm, 3-5/32"
ED:	40 %
Sound level (during no-load operation)	75 dB(A)
Unit size (mm)	length 865, width 335, high 415
Weight	41 kg, 90 lbs with chain vice; 46 kg, 101 lbs with quick clamp flat vice



Chain vice
(optional)

Cutting pressure adjustable



Standard Accessories:

- Portable Band Saw Machine RBX 180 HV – 230 V (110 V on demand)
- Quick clamp flat vice
- 1 HSS Bi-Metal Band saw blade
- Operator protection plug
- Tool kit
- Operation manual

		Prod.-No.
Band Saw Machine RBX 180 HV		22520
Chain vice		22522
Special accessories		
Enlarged saw table 150 x 100 mm; 6" x 3-15/16"		22523
Replacement Band Saw Blades HSS-Bi-Metal 1625 x 13 x 0.65 mm; 64" x 1/2" x 0.025"		
HSS Bi-Metal	10 tpi IPU = 10 pcs	22530
HSS Bi-Metal	14 tpi IPU = 10 pcs	22531
HSS Bi-Metal	6/10 tpi IPU = 10 pcs	22532
HSS Bi-Metal	8/12 tpi IPU = 10 pcs	22533
HSS Bi-Metal	10/14 tpi IPU = 10 pcs	22534

ALFRA RBX BAND SAW MACHINES IN ACTION



Enlarged saw table



Automatic OFF Switch
RBX 120 HV + 180 HV



Mitre Saw up to 45°
RBX 120 HV + 180 HV



Vertical cutting, here with extended support surface, RBX 120 HV + 180 HV



Cleaning brush
RBX 180 HV



Quick vice
RBX 180 HV



Change from quick vice to chain vice within seconds – RBX 180 HV



Changeable chain vice in action
RBX 180 HV



Clamped pipe in chain vice
RBX 180 HV

ALFRA - PRESS

HYDRAULIC PUNCHING UNITS

- ▶ EASILY PORTABLE, FULLY AUTOMATIC HYDRAULIC PUNCHING UNITS FOR STEEL-, BRIDGE-, CONTAINER-, CRANE- AND METAL CONSTRUCTION
- ▶ MOBIL USE, NO TRANSPORT OF MATERIAL
- ▶ ALMOST NOISELESS PUNCHING
- ▶ EASY POSITIONING THROUGH STOP-FUNCTION OF THE PUNCH
- ▶ FOR CHOICE:
SINGLE OR DOUBLE ACTING

Double Acting

Single Acting

APS -120

APS-70 Eco – Set

APS-110-D








ALFRA PRESS HYDRAULIC PUNCHES – Overview



Made in Germany by ALFRA



	 Page B/68	 Page B/68	 Page B/68
	APS 60	APS 70	APS 120
Prod.-No.	23001	23002	23004
Max. hole Ø	18 mm 11/16"	22 mm 7/8"	25 mm 1-1/16"
Max. oblong hole	–	22 x 14 mm 7/8" x 9/16"	25 x 18 mm 1" x 11/16"
Max. material thickness 410 - 490 N/mm²	10 mm 3/8"	13 mm 1/2"	16 mm 5/8"
Total punching time with pump ...	SC 05 II-B: approx. 7 sec. SC 17: approx. 4 sec.	SC 05 II-B: approx. 10 sec. SC 17: approx. 4 sec.	SC 05 II-B: approx. 16 sec. SC 17: approx. 5 sec.
Throat depth	60 mm 2-3/8"	70 mm 2-3/4"	110 mm 4-3/8"
Max. pressure	700 bar 10150 psi	700 bar 10150 psi	700 bar 10150 psi
Punching force	22 t	30 t	44 t
Punch stroke	16 mm 5/8"	18 mm 11/16"	25 mm 15/16"
Weight	17 kg / 37 lbs	21 kg / 46 lbs	35 kg / 77 lbs
Scope of delivery	Hydraulic hose 5 m / Spanner Punch/die Ø 14 mm	Hydraulic hose 5 m / Spanner Punch/die Ø 18 mm Depth fence, suspension bracket	Hydraulic hose 5 m / Spanner Punch/die Ø 22 mm Depth fence, suspension bracket

ALFRA – Hydraulic Pumps

Made in Germany by ALFRA

		SC 05 II-B	SC 17	
Prod.-No.		23007	23170	
Max. pressure		750 bar / 10670 psi	750 bar / 10670 psi	
Pumping capacity		0.94 l/min at 2770 rpm	1.5 l/min at 1370 rpm	
Motor power		1100 W, 230V (50 Hz)*	1500 W, 230V (50 Hz)*	
		* On request: 230V (60 Hz); 110 V (50 Hz); 110V (60 Hz)		
Oil quantity		5 l	17 l	
Weight incl. oil		27 kg	45 kg	



ALFRA PRESS HYDRAULIC PUNCHES – Overview

Made in Germany by ALFRA



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APS 110 D

23181

25 mm
1-1/16"

25 x 18 mm
1" x 11/16"

16 mm
5/8"

SC 17 D: approx. 8 sec.

110 mm
4-3/8"

700 bar
10150 psi

44 t

25 mm
15/16"

35 kg / 77 lbs

Hydraulic hose 5 m / Spanner
Punch/die Ø 22 mm
Depth fence, suspension bracket

€CO



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APS 70 €CO

23002.Eco

22 mm
7/8"

22 x 14 mm
7/8" x 9/16"

13 mm
1/2"

SC 03: approx. 18 sec.

70 mm
2-3/4"

700 bar
10150 psi

30 t

18 mm
11/16"

21 kg / 46 lbs

Hydraulic hose 3 m / Spanner



SC 17 D

23186

750 bar / 10670 psi

1.4 l/min at 1370 rpm

1500 W, 230V (50 Hz)*



SC 03

23006

700 bar / 10150 psi

0.52 l/min at 2720 rpm

550 W, 230V (50 Hz)*



* On request: 230V (60 Hz); 110V (50 Hz); 110V (60 Hz)

17 l

47 kg

2.5 l

18 kg





ALFRA PRESS – Hydraulic Punches, single-acting

MADE IN GERMANY BY ALFRA

ALFRA-Press APS 60

Prod.-No.

Hydraulic Punching Unit with automatic return by means of neoprene spring

23001

Technical data:

max. hole Ø mm	18 mm
max. material thickness with St. 42	10 mm
Total punching time with pump SC 05 II B	approx. 7 sec.
with pump SC 17	approx. 4 sec.
Throat depth	60 mm
max. pressure	700 kg/cm ² (10000 psi)
Punching force	22 t
Punch stroke	16 mm
Weight	17 kg

Scope of Supply:

punching unit, control cable, hydraulic hose 5 m, spanner, 1 punch and die each, Ø 14 mm



Prod.-No. 23001

ALFRA-Press APS 70

Prod.-No.

Hydraulic Punching Unit with automatic return by means of neoprene spring

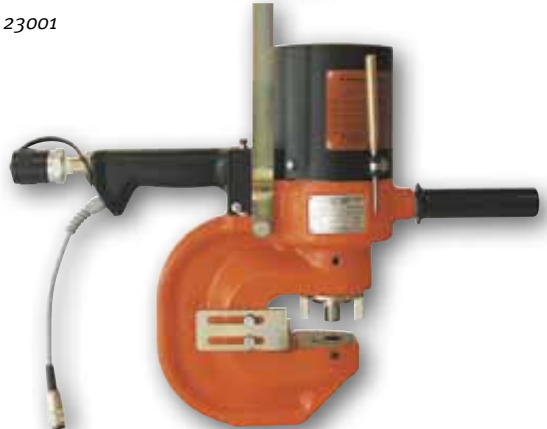
23002

Technical data

max. hole Ø mm	22 mm
Oblong holes max.	22 x 14 mm
max. material thickness with St. 42	13 mm
Total punching time with pump SC 05 II B	10 sec.
with pump SC 17	4 sec.
Throat depth	70 mm
max. pressure	700 kg/cm ² (10000 psi)
Punching force	30 t
Punch stroke	18 mm
Weight	21 kg

Scope of Supply:

punching unit, control cable, hydraulic hose 5 m, spanner, 1 punch and die each, Ø 18 mm, 1 depth fence, 1 suspension bracket



Prod.-No. 23002

ALFRA-Press APS 120

Prod.-No.

Hydraulic Punching Unit with automatic return by means of neoprene spring

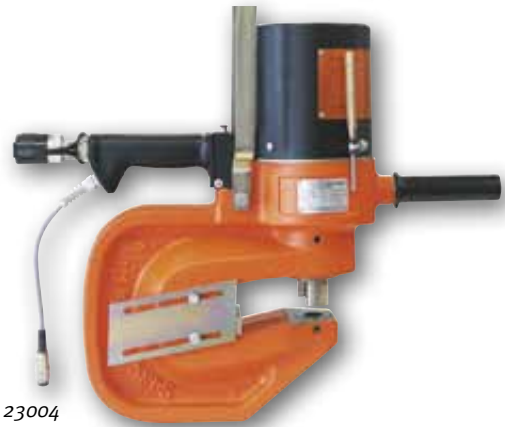
23004

Technical data

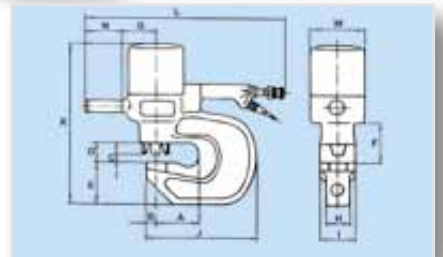
max. hole Ø mm	25 mm
Oblong holes max.	25 x 18 mm
max. material thickness with St. 42	16 mm
Total punching time with pump SC 05 II B	16 sec.
with pump SC 17	5 sec.
Throat depth	110 mm
max. pressure	700 kg/cm ² (10000 psi)
Punching force	44 t
Punch stroke	25 mm
Weight	35 kg

Scope of Supply:

punching unit, control cable, hydraulic hose 5 m, spanner, 1 punch and die each, Ø 22 mm, 1 depth fence, 1 suspension bracket



Prod.-No. 23004



Type	A	B	C	D	E	F	G	H	I	J	K	L	M	N
APS 60	60	17	12	51	73	92	75	40	74	162	360	552	110	135
APS 70	70	24	15	51	85	100	80	40	80	204	382	562	125	135
APS 120	110	25	18	51	111	110	90	68	100	285	442	585	144	135

Important technical notice:

The standard punching units are not suitable for punching high-tensile tool steels, stainless steels or boiler plates. Ask for our technical advice for punching jobs in this application range.



B



ALFRA – Hydraulic Pumps

MADE IN GERMANY BY ALFRA

For the use of our Punching Units, there are two Hydraulic Pumps available

ALFRA Hydraulic Pump SC 05 II-B for APS 60, 70, 120

		Prod.-No.
ALFRA Hydraulic Pump SC 05 II-B	230V 50 Hz	23007
ALFRA Hydraulic Pump SC 05 II-B	230V 60 Hz	23007.230-60Hz*
ALFRA Hydraulic Pump SC 05 II-B	110V 50 Hz	23007.110-50Hz*
ALFRA Hydraulic Pump SC 05 II-B	110V 60 Hz	23007.110-60Hz*

Technical data:

Operating pressure max.	750 kg/cm ² (10670 psi)	
Pumping capacity	0.94 l/min at 2770 rpm	
Oil quantity	5.0 l	
Single-phase motor 2770 rpm	1100 W	110V or 230V 50 Hz or 60 Hz
Weight incl. oil	27 kg	

*On request

Prod.-No. 23007



ALFRA Hydraulic Pump SC 17 for APS 60, 70, 120

		Prod.-No.
ALFRA Hydraulic Pump SC 17	230V 50 Hz	23170
ALFRA Hydraulic Pump SC 17	230V 60 Hz	23170.230-60Hz*
ALFRA Hydraulic Pump SC 17	110V 50 Hz	23170.110-50Hz*
ALFRA Hydraulic Pump SC 17	110V 60 Hz	23170.110-60Hz*

Complete with control and switch box.

This new pump was especially developed to drastically reduce the punching time. Specially suitable for the use in the workshop.

Technical data:

Operating pressure max.	750 kg/cm ² (10670 psi)	
Pumping capacity	50 HZ	1.50 l/min at 1370 rpm
Oil quantity	17 l	
Single-phase motor 1450 rpm	1500 W	230 V 50 Hz
Weight incl. oil and transport rollers	45 kg	
Dimensions L x W x H	550 x 370 x 560 mm	

*On request

Prod.-No. 23170



SC 17



ALFRA PRESS – Hydraulic Punching Units, double-acting

MADE IN GERMANY BY ALFRA

ALFRA-Press APS 110D

Prod.-No.

Hydraulic Punching Unit with automatic return

23181

Technical data

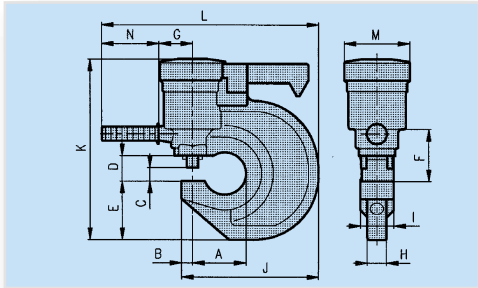
max. hole Ø mm	25 mm
Oblong holes max.	25 x 18 mm
max. material thickness with St. 42	16 mm
Total punching time with pump SC 17-D	8 sec.
Throat depth	110 mm
max. pressure	700 kg/cm ² (10000 psi)
Punching force	44 t
Punch stroke	25 mm
Weight	35 kg

Scope of Supply:

Punching unit, control cable, hydraulic hose 5 m, spanner, 1 punch and die each, Ø 22 mm, 1 depth fence, 1 suspension bracket



Prod.-No. 23181



Type	A	B	C	D	E	F	G	H	I	J	K	L	M	N
APS 110D	110	24	18	55	90	112	73	41	78	295	387	468	141	124



Important technical notice:

The standard punching units are not suitable for punching high-tensile tool steels, stainless steels or boiler plates. Ask for our technical advice for punching jobs in this application range.

ALFRA Hydraulic Pump SC 17D for APS 110D

Double Acting

Prod.-No.

ALFRA Hydraulic-Pump SC 17D	230V 50 Hz	23186
ALFRA Hydraulic-Pump SC 17D	230V 60 Hz	23186.230-60Hz*
ALFRA Hydraulic-Pump SC 17D	110V 50 Hz	23186.110-50Hz*
ALFRA Hydraulic-Pump SC 17D	110V 60 Hz	23186.110-60Hz*

Complete with control and switch box.
*On request

With connector for double hose package.

This new pump was especially developed to drastically reduce the punching time. Specially suitable for the use in the workshop.

Technical data:

Operating pressure max.	750 kg/cm ² (10670 psi)
Pumping capacity	50 HZ 1.40 l/min at 1370 rpm
Oil quantity	17 l
Single-phase motor 1450 rpm	1500 W 230 V 50 Hz
Weight incl. oil and transport rollers	47 kg
Dimensions L x W x H	550 x 370 x 560 mm



Connector for double hose package



Prod.-No. 23186

SC 17 D



ALFRA PRESS – Hydraulic Punching Units, Eco

MADE IN GERMANY BY ALFRA

ALFRA Press APS 70 €co

	Prod.-No.
Hydraulic Punching Unit with automatic return by means of neoprene spring	23002.Eco

Technical data:

max. hole Ø mm	22 mm
max. material thickness with St. 42	13 mm
Total punching time with Pump AHP 03-03	approx. 20 sec.
Throat depth	70 mm
max. pressure	700 kg/cm ² (10150 psi)
Punching force	30 t
Punch stroke	18 mm
Weight	21 kg

Scope of Supply:

APS 70 Eco hydraulic punching unit, control cable, hydraulic hose 3 m, spanner,



Prod.-No. 23002.Eco

ALFRA Hydraulic Pump SC 03 for APS 70 €co

	Prod.-No.
Electrohydraulic pump SC 03	230V 50 Hz 23006
Electrohydraulic pump SC 03	230V 60 Hz 23006.230-60Hz*
Electrohydraulic pump SC 03	110V 50 Hz 23006.110-50Hz*
Electrohydraulic pump SC 03 complete with hand switch, 2.0 m hydraulic hose with quick coupling	23006.110-60Hz*

*On request

Optional:

Foot switch with 2-pedals, start-stop function	03866
--	-------

Technical data:

Motor voltage:	230V / 50Hz; 230V / 60Hz; 110V / 50Hz; 110V / 60Hz
Motor power:	0.55 KW, 2,720 rpm
Max. operating pressure:	700 bar
Pump capacity:	62 l/min. at 60 Hz 0.52 l/min. at 50 Hz
Tank volume:	2.5 l / useable: 1.5 l
Temperature switch:	80°C +/- 5°
Weight:	17 kg
Dimensions L x W x H:	330 x 180 x 350 mm

Prod.-No. 23006



ALFRA Press APS 70 €co-Set

	Prod.-No.
Complete set	23003

Scope of Supply:

ALFRA APS 70 Eco Hydraulic Punching Unit
ALFRA Hydraulic Pump SC 03, 230V / 50Hz
Hydraulic hose, 3m
Foot switch
Spanner



Prod.-No. 23003 Eco-Set

For ALFRA Press Hydraulic Punching Units

Prod.-No.

with **locking device**, spring fracture safety device, cable 2.0 m

9362 B	15 - 20 kg	23150
9363 B	20 - 25 kg	23151
9366 B	35 - 45 kg	23152

Note:

Actuation of spring hoist only with suspended Punching Unit resp. under load.



Prod.-No. 23152

ALFRA – Service-Boy

Made in Germany by ALFRA

for APS hydraulic pump bracket, all types – TÜV-tested –

This handy time- and energy saving cart makes the handling of our Hydraulic Punching Units more comfortable.

Absolutely necessary for every structural steel worker- even where our Hydraulic Punching Units are already used.

- Easy positioning of the Punching Head at the steel girder due to gas pressure shock absorber.
- Being located on the Service Boy the hydraulic pump does not need to be carried any longer.
- Tool cabinet with drawers for clean arrangement of the punching tools and accessories.
- Solid and safe construction with TÜV certificate (tested by the German Technical Supervision Authority) - less expensive than any "self-made" construction.
- Dimensions (L x W x H): 900 x 530 x 2000 mm

Prod.-No.

Complete with tool cabinet and drawers	23160
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- **IMPORTANT:**
Please indicate the punch model with your order
(APS 70 – 120 – 110 D)



Prod.-No. 23160 (Tools and Punching Unit/Pump not included)



B



ALFRA – Original Tools

MADE IN GERMANY BY ALFRA

Punches for

APS 120/120 €co	APS 70/70 €co	APS 60	Ø mm	Prod.-No.
■	■	■	7	23-01-07
■	■	■	8	23-01-08
■	■	■	9	23-01-09
■	■	■	10	23-01-10
■	■	■	11	23-01-11
■	■	■	12	23-01-12
■	■	■	13	23-01-13
■	■	■	14	23-01-14
■	■	■	15	23-01-15
■	■	■	16	23-01-16
■	■	■	17	23-01-17
■	■	■	18	23-01-18
■	■	-	19	23-01-19
■	■	-	20	23-01-20
■	■	-	21	23-01-21
■	■	-	22	23-01-22
■	-	-	23	23-01-23
■	-	-	24	23-01-24
■	-	-	25*	23-01-25

*) with tension nut Prod.- No. 23004-056 B



Prod.-No. 23-01-..



Prod.-No. 23-02-..

Dies for

APS 120/120 €co	APS 70/70 €co	APS 60	Ø mm	Prod.-No.
■	■	-	7	23-02-07
■	■	-	8	23-02-08
■	■	-	9	23-02-09
■	■	-	10	23-02-10
■	■	-	11	23-02-11
■	■	-	12	23-02-12
■	■	-	13	23-02-13
■	■	-	14	23-02-14
■	■	-	15	23-02-15
■	■	-	16	23-02-16
■	■	-	17	23-02-17
■	■	-	18	23-02-18
■	■	-	19	23-02-19
■	■	-	20	23-02-20
■	■	-	21	23-02-21
■	■	-	22	23-02-22
■	-	-	23	23-02-23
■	-	-	24	23-02-24
■	-	-	25	23-02-25
-	-	■	7	23-03-07
-	-	■	8	23-03-08
-	-	■	9	23-03-09
-	-	■	10	23-03-10
-	-	■	11	23-03-11
-	-	■	12	23-03-12
-	-	■	13	23-03-13
-	-	■	14	23-03-14
-	-	■	15	23-03-15
-	-	■	16	23-03-16
-	-	■	17	23-03-17
-	-	■	18	23-03-18



Tip:
Punches and Dies are interchangeable with Nitto/Selfer Punching Systems.

Tip:
Please oil punch from time to time, when material is heavily oxidized.

Important:

For material St 37: max. material thickness = 0.8 x hole Ø
For material St 42: max. material thickness = 0.5 x hole Ø



5°-bevelled Dies for

APS 120 APS 110D	APS 70	Ø mm	Prod.-No.
■	■	10	23-04-10
■	■	11	23-04-11
■	■	12	23-04-12
■	■	13	23-04-13
■	■	14	23-04-14
■	■	15	23-04-15
■	■	16	23-04-16
■	■	17	23-04-17
■	■	18	23-04-18
■	■	19	23-04-19
■	■	20	23-04-20
■	■	21	23-04-21
■	■	22	23-04-22
■	-	23	23-04-23
■	-	24	23-04-24
■	-	25	23-04-25



Prod.-No. 23-04-.. (for girders with bevelled flanges)

Oblong tools for

mm	APS 120 APS 110D	APS 70	Punch Prod.-No.	Die Prod.-No.
16 x 8	■	■	23-01-1608	23-02-1608
18 x 9	■	■	23-01-1809	23-02-1809
18 x 11	■	■	23-01-1811	23-02-1811
20 x 10	■	■	23-01-2010	23-02-2010
20 x 12	■	■	23-01-2012	23-02-2012
20 x 14	■	■	23-01-2014	23-02-2014
22 x 11	■	■	23-01-2211	23-02-2211
22 x 14	■	■	23-01-2214	23-02-2214
24 x 12	■	-	23-01-2412	23-02-2412
25 x 9*	■	-	23-01-2509	23-02-2509
25 x 12*	■	-	23-01-2512	23-02-2512
25 x 13*	■	-	23-01-2513	23-02-2513
25 x 14*	■	-	23-01-2514	23-02-2514
25 x 18*	■	-	23-01-2518	23-02-2518



Prod.-No. 23-02-..

Prod.-No. 23-01-..

*) with tension nut Prod.-No. 23004-56B
Other dimensions on request

Spare parts

	Prod.-No.
Spare high-pressure connection hose, 3 m (for Eco series only) complete with control cable and coupling	23010
Spare high pressure connection hose, 5 m complete with control cable and coupling	23015
Spare high pressure connection hose, *10 m complete with control cable and coupling	23016
Spare high-pressure connection hose, *15 m complete with control cable and coupling	23017
Spare high pressure connection hose, 5 m For APS 110D (double-acting) complete with control cable and coupling	23020

Note:

The pressure build up is 4 sec longer with 10 m, 6 sec longer with 15 m

Tensioning nut for punch Ø 7 - 24 mm	23004-56A
Tension nut for punches Ø 25 mm (only APS 120)	23004-56B
Tensioning nut for punch Ø 26 mm (on request)	23004-56C



Prod.-No. 23015



Prod.-No. 23020



Prod.-No. 23004-056A
For punch Ø 7 - 24 mm



Prod.-No. 23004-056B
For punch Ø 25 mm