

ALZMETALL
we drive productivity

iTRONIC Drilling Machines

CATALOG No. 67i

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COMPANY PROFILE



ALZMETALL Deutschland



ALZMETALL Machine Tools (Taicang, China)

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

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

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

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

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

MACHINING CENTERS

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



DRILLING MACHINES

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



*Flexible production cell with pallet station.
ALZMETALL is using their proper machining centers.*

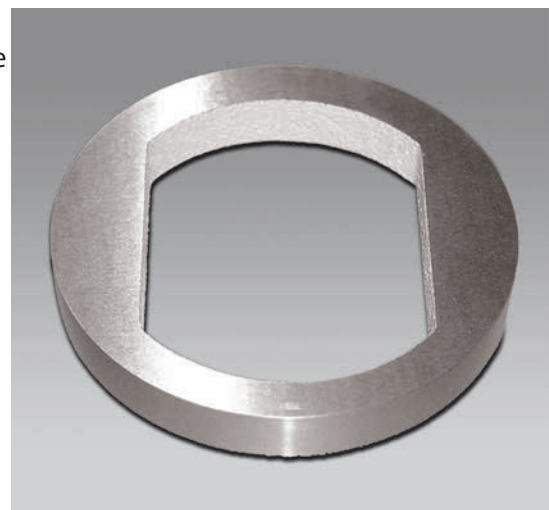


Assembly line for drilling machines

WHAT MAKES ALZMETALL DRILLING MACHINES STAND OUT?

Advantage for our customers

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



The standard in drilling includes:

- ★ **TFT - LCD-Display with Touch Function**
- ★ **Tapping function with all AX and AB Machines**
- ★ **Digital depth read out with zero setting**
- ★ **Virtual depth scale in the display**
- ★ **Stepless Spindle Speed Setting**
- ★ **24 month warranty**
- ★ **Exclusive design**

Contents

iTRONIC DRILLING MACHINES EDUCATIONAL OPTIONS

ALZTRONIC

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

ALZSTAR

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

AX

TOP-QUALITY
drilling with complete options

AB

TRENDSSETTERS
for high performance drilling.
Unmatched and highly precise

ALZFLOW AB-FLOW

ALZFLOW, AB-FLOW
flowdrilling, chipless drilling

RADIAL

RADIAL
for large and heavy parts

RFT

**1-6 PRESETTED
DRILLING STATIONS**

Accessories

Special equipment

**TFT Display with Touch Function
Education with ALZMETALL - Machines
Examples of options**

Integrated technology calculator,
combination table, precision depth adjuster
and fixed stop, belt technology, coolant
device A, tapping, training content

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Bench Drilling Machines
ALZTRONIC i6/i9/i12/i14/i16

Drilling capacity 6/9/12/14/16 mm
B 16 / Morse Taper 2

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Bench and Column Drilling Machines
ALZSTAR 18-T/S, ALZSTAR 23/30/40 iTRONIC

Drilling capacity 18/23/30/40 mm
Morse Taper 2 / 3 / 4

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Bench and Column Drilling Machines
AX 2/3/4 iTRONIC

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Morse Taper 2/3/4

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Column and Semi-Box Column Drilling Machines
AB 26/34/40 iTRONIC, AB 50/SV

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Column and Semi-Box Column Drilling Machines
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Flowdrilling capacity 12/20 mm
Morse Taper 3/4

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Radial Drilling Machines
AB 30/R-1000, AB 30/R-1400

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Multi-Head Drills
RFT 20/1
RFT 2 / RFT 3

Drilling capacity 23 – 55 mm
Morse Taper 2 – 4

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(Sliding) cross tables, vices, drill chucks, adapters, ejectors, reducers

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for all drilling machines: foot switches, machine tables, special lacquer etc.

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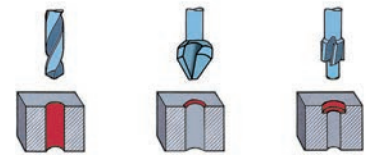
TRAINING WITH ALZMETALL-MACHINES – INVESTMENTS IN YOUR FUTURE



WORK TECHNIQUES

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

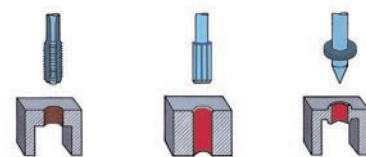
TRAINING CONTENTS



Drilling

Counter sink

Counter bore



Tapping

Reaming

Flow drilling

SAFETY

- Competent safety advices
- Specific safety concepts
- Spindle protection
- EMERGENCY-OFF switches
- Safety-checked auxiliary devices
- Documentations with safety warnings

STANDARDS UND OPTIONS



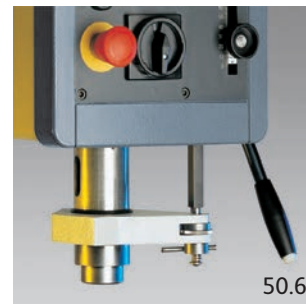
Coolant supply-system A

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



Combined drilling table

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



Micro drilling depth setting and fixed stop

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



Tapping device

A Tapping Device is offering a much more efficient use of a drilling machine. It is enabling an automatic reversed rotation of the Spindle (CW or CCW) at a certain chosen depth. Whenever the quill is arriving back in its original position, the spindle is rotating right (CW) again. The thread depth can be set with the mechanical end stop, with the foot switch [Pos.20.5] or numerically in the Touch Display (only AB). The basic tapping device is standard in all AX and AB machines (except for the AB 50).



Belt technology

Stepless RPM speed setting through mechanical variators. This photo is showing the AB 40 iTRONIC, n=70-4000 mechanical variator in combination with

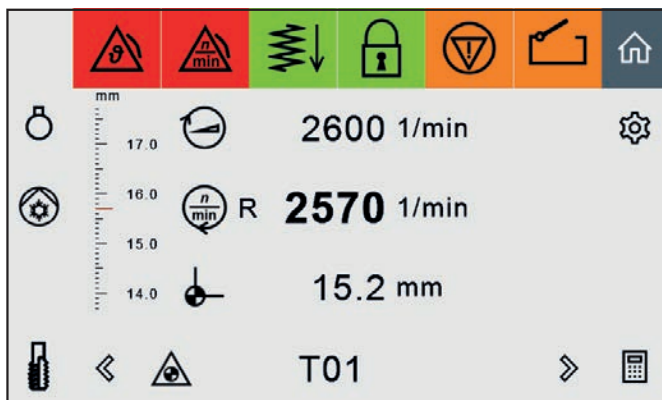
a two-step belt gear box (powerful low Rpm speeds and high speed. Upto 4000 rpm)

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

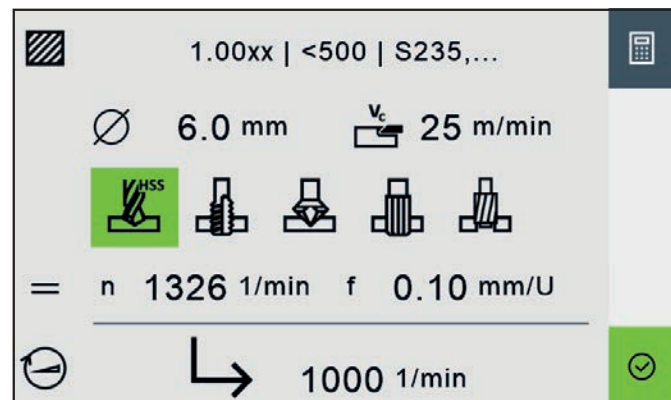


Added value with new iTRONIC Drilling Machines, STANDARDS INCLUDED

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



Main screen



Technology calculator [option]

Added value with options

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

BENCH DRILLING MACHINES WITH DRILL HEAD HEIGHT ADJUSTMENT

Drilling capacity 6/9/12 mm

Photo with options



	ALZTRONIC i6	ALZTRONIC i9	ALZTRONIC i12
Drilling capacity steel E 335 (St 60)	6 mm	9 mm	12 mm
Tapping performance steel E 335 (St 60)	M 6	M 8	M 10
Drill chuck adapter (DIN 238)*	B 16	B 16	B 16
Z-travel of spindle	40 mm	40 mm	40 mm
Distance spindle to column	200 mm	200 mm	200 mm
Column diameter	50 mm	50 mm	50 mm
Machine table (intermediate)	without	without	without
Base plate, clamping area (width x depth)	300 x 240 mm	300 x 240 mm	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm	2 x 12 x 80 mm	2 x 12 x 80 mm
Distance spindle / base plate min. /max.	110/250 mm	110/250 mm	110/250 mm
Feed	manual	manual	manual
Drill head adjustment (trapezoid vice)	wheel	wheel	wheel
Height of the machine without options approx.	670 mm	670 mm	670 mm
Net weight approx.	64 kg	64 kg	64 kg
Drive System	infinitely variable	infinitely variable	infinitely variable
Motor	0,7 kW	0,7 kW	0,7 kW
Spindle Rpm range	700 - 10000 rpm	390 - 6500 rpm	250 - 5000 rpm

Standard Equipment:

5" TFT - LCD-MULTI-TOUCH Display:

Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

AC motor 230 Volt, 50 Hz

Plug, fully assembled, cable length 3 m

Stepless speed setting by potentiometer

Push button for starting the Right turn (CW),

Push Button for starting the Left turn (CCW),

Push Button for Spindle off

(Spindle stop by brake function)

Spindle protection electrically secured

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Control Tension 24 Volts

Protection Clas IP 54

Lacquer: DD-structured signal white RAL 9003,

PANTONE 7545c, black

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

BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 14/16 mm

Photo with options



	ALZTRONIC i14	ALZTRONIC i16
Drilling capacity steel E 335 (St 60)	14 mm	16 mm
Tapping performance steel E 335 (St 60)	M 10	M 12
Short spindle	MT 2	MT 2
Z-travel of spindle	80 mm	80 mm
Distance spindle to column	190 mm	190 mm
Column diameter	65 mm	65 mm
Machine table (intermediate), clamping area (width x depth)	300 x 240 mm	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm	2 x 12 x 80 mm
Distance spindle / table min. /max.	75/357 mm	75/357 mm
Base plate, clamping area (width x depth)	300 x 240 mm	300 x 240 mm
T-Slots, number x width x distance	2 x 12 x 80 mm	2 x 12 x 80 mm
Distance spindle / base plate min. /max.	437/437 mm	437/437 mm
Feed	manual	manual
Machine table (intermediate) Height adjustment	crank	crank
Height of the machine without options approx.	825 mm	825 mm
Net weight approx.	83 kg	83 kg
Drive System	infinitely variable	infinitely variable
Motor	0,7 kW	0,7 kW
Spindle Rpm range	230 - 4.000 rpm	100 - 2.000 rpm

OPTIONS

09.	Table/Bench for ALZTRONIC , w x d x h 700 x 600 x 840 mm, Net weight approx. 48 kg
12.	LED machine light , adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
800481	Quick action drill chuck SPIRO SK 10 , with B 16 inner bore*, clamping 0-10 mm, suitable for up to 10.000 Rpm and right – left rotation. (mainly for ALZTRONIC i6, i9 and i12)
800483	Quick action drill chuck SPIRO SK 13S with B 16 inner bore*, clamping 1-13 mm, suitable for up to 8.000 Rpm and right – left rotation. (mainly for ALZTRONIC i6, i9 and i12)
08.1	Packing for the Table/Bench (Pos. 09.) , W x D x H 1200 x 800 x 1300 mm, Packing weight approx. 16 kg

More Quick-Action drill chucks, tapers, adapters see Page 35 (for ALZTRONIC i14 and ALZTRONIC i16)

BENCH DRILLING MACHINES WITH TABLE HEIGHT ADJUSTMENT

Drilling capacity 18 mm

Photo with options



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

Standard Equipment:

Infinitely variable speed drive , mechanical variator with lever	Cable (w/o plug, 2 m)
Spindle protection electrically secured	Protection class IP 54
Reverse switch for tapping	Lacquer: DD-structured signal white RAL 9003,
Self-Locking Mushroom Button for Emergency-Off	PANTONE 7545c, black
Main switch with Overload Protection Switch lockable	

OPTIONS

09.	Table/Bench for ALZSTAR 18-T/S , W x D x H 700 x 600 x 840 mm, Net weight approx. 48 kg
12.	LED machine light , adjustable angle, 230 V, IP 65
08.	Packaging for the ALZSTAR 18-T/S , disposable L x W x H ca. 800 x 600 x 1050 mm packing weight approx. 10 kg
08.1	Packing for the Table/Bench (Pos. 09.) , W x D x H 1200 x 800 x 1300 mm, Packing weight approx. 16 kg

**BENCH DRILLING MACHINES
WITH TABLE HEIGHT ADJUSTMENT**

Drilling capacity 23 mm

Photo with options



	ALZSTAR 23-T iTRONIC
Drilling capacity steel E 335 (St 60)	23 mm
Tapping performance steel E 335 (St 60)	M 14
Tapping performance cast iron EN-GJL-200 (GG 20)	M 16
Short spindle	MT 2
Z-travel of spindle	100 mm
Distance spindle to column	250 mm
Column diameter	90 mm
Table clamping area (W x D)	370 x 300 mm
T-Slots, number x width x distance	2 x 14 x 160 mm
Distance Spindle-Machine table (intermediate) min.max.	125 / 455 mm
Table height adjustment	manual with crank
Base plate, clamping area (width x depth)	320 x 250 mm
T-Slots, number x width x distance	2 x 14 x 160 mm
Distance spindle / base plate min. /max.	625/625 mm
Feed	manual
Height of the machine without options approx.	1095 mm
Net weight approx.	155 kg
Drive System	infinitely variable
Motor: n = 750 / 1500 rpm	0,6 / 0,95 kW
Spindle Rpm range	125-2400 rpm
Motor: n = 750 / 1500 rpm	0,6 / 0,95 kW
Spindle Rpm range	225-4300 rpm

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Infinitely variable speed drive, mechanical variator with lever

Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Class IP 54

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

OPTIONS

09.1	Table/Bench for ALZSTAR 23-T iTRONIC, W x D x H 750 x 700 x 840 mm, Net weight approx. 66 kg
12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
08.	Packaging disposable, L x W x H 1100 x 800 x 1400 mm. net weight approx. 45 kg
08.1	Packing for the Table/Bench (Pos. 09.1), W x D x H 1200 x 800 x 1110 mm, Packing weight approx. 16 kg

COLUMN DRILLING MACHINES

Drilling capacity 23/30 mm

Photo with options



	ALZSTAR 23 iTRONIC	ALZSTAR 30 iTRONIC
Drilling capacity steel E 335 (St 60)	23 mm	30 mm
Tapping performance steel E 335 (St 60)	M 14	M 16
Tapping performance Cast iron EN-GJL-200 (GG 20)	M 16	M 20
Short spindle	MT 2	MT 3
Z-travel of spindle	100 mm	140 mm
Distance spindle to column	250 mm	293 mm
Column diameter	90 mm	115 mm
Table clamping area (W x D)	370 x 300 mm	514 x 360 mm
T-Slots, number x width x distance	2 x 14 x 160 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	140/670 mm	132/724 mm
Feed	manual	manual
Height of the machine without options approx.	1770 mm	1790 mm
Net weight approx.	175 kg	260 kg
Drive System	infinitely variable	infinitely variable
Motor: n = 750 / 1500 rpm	0,6 / 0,95 kW	1,0 / 1,6 kW
Spindle Rpm range	125-2400 rpm	225-4300 rpm
Motor: n = 750 / 1500 rpm	0,6 / 0,95 kW	1,0/1,6 kW
Spindle Rpm range	225-4300 rpm	100-1800 rpm

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured
Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off
EMERGENCY-OFF switch, self-locking
Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control
Control Tension 24 Volts
Protection Clas IP 54
Lacquer: DD-structured signal white RAL 9003,
 PANTONE 7545c, black

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
03.	Anchoring set
08.	Packaging disposable, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

COLUMN DRILLING MACHINES

Drilling capacity 40 mm

Photo with options



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

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured
Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off
EMERGENCY-OFF switch, self-locking
Main switch, lockable
Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts
Protection Clas IP 54
Lacquer: DD-structured signal white RAL 9003, PANTONE 7545c, black
Overload Protection Switch (ALZSTAR 40 iTRONIC-V)
Machine oil in separate bin (ALZSTAR 40 iTRONIC-V)

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
47.1.2	MT 4 Spindle instead of MT 3 Spindle
03.	Anchoring set
08.	Packaging disposable, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

BENCH AND COLUMN DRILLING MACHINES

Drilling capacity 23 mm

Photo with options



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

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

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 12 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, reduces stroke by 15 mm, with (depth) program functions for 4 tools in the Touch Display
Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured
Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking
Main switch, lockable
Right (CW) and Left (CCW) rotation under protective control
Control Tension 24 Volts
Protection Clas IP 54
Lacquer: DD-structured signal white RAL 9003, PANTONE 7545c, black

OPTIONS

09.1	Table/Bench for AX 2-T iTRONIC, W x D x H 750 x 700 x 840 mm, Net weight approx. 66 kg
12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A*, consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display (only for AX 2 iTRONIC)
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
50.6	Precision Mechanical Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm (spindle stroke reduced by 20 mm)
03.	Anchoring set for AX 2 iTRONIC
08.	Packaging disposable wood for AX 2-T iTRONIC, L x W x H 1100 x 800 x 1400 mm. net weight approx. 45 kg for AX 2 iTRONIC, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg
08.1	Packing for the Table/Bench (Pos. 09.1), W x D x H 1200 x 800 x 1110 mm, Packing weight approx. 16 kg for AX 2-T iTRONIC.

*) = Net weight increases with 80 kg

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COLUMN DRILLING MACHINES

Drilling capacity 40 mm

Photo with options



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

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

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) program functions for 4 tools in the Touch Display

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

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

Overload Protection Switch (AX 3 iTRONIC-V)

Machine oil in separate bin (AX 3 iTRONIC-V)

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A*, consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
42.	Column extension + 200 mm (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)
47.1.2	MT 4 Spindle instead of MT 3 Spindle
50.6	Precision Mechanical Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm
03.	Anchoring set
08.	Packaging disposable wood, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

*) = Net weight increases with 80 kg

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COLUMN DRILLING MACHINE

Drilling capacity 55 mm

Photo with options



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

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

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) program functions for 4 tools in the Touch Display

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

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

Overload Protection Switch

Machine oil in separate bin

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A*, consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
42.	Column extension + 200 mm (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.)
50.6	Precision Mechanical Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm (spindle stroke reduced by 10 mm)
03.	Anchoring set
08.	Packaging disposable wood L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

*) = Net weight increases with 60 kg

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**COLUMN AND SEMI-BOX COLUMN
DRILLING MACHINES**

Drilling capacity 30/40 mm

Photo with options



	AB 26 iTRONIC	AB 34 iTRONIC	AB 34 iTRONIC-HST
Drilling performance steel E 335 (St 60)	26 mm	34 mm	34 mm
Drilling performance Cast iron EN-GJL-200 (GG 20)	30 mm	40 mm	40 mm
Drilling capacity steel E 335 (St 60)	30 mm	40 mm	40 mm
Tapping performance steel E 335 (St 60)	M 20	M 24	M 24
Tapping performance Cast iron EN-GJL-200 (GG 20)	M 24	M 30	M 30
Short spindle	MT 3	MT 4	MT 4
Distance spindle to column	293 mm	300 mm	330 mm
Table clamping area	514 x 360 mm	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	90/675 mm	138/688 mm	266/928 mm
Column diameter / Box Column Dimensions	115 mm	145 mm	290 mm
Z-travel of spindle	160 mm	160 mm	160 mm
Feeds	0,1-0,2-0,3-0,4 mm/Rev	0,1-0,2-0,3-0,4 mm/Rev	0,1-0,2-0,3-0,4 mm/Rev
Height of the machine without options approx.	1865 mm	1865 mm	2110 mm
Net weight approx.	380 kg	470 kg	760 kg
Drive System	infinitely variable	infinitely variable	infinitely variable
Motor: n = 750/1500 rpm	1,0 / 1,6 kW	1,4 / 2,2 kW	1,4 / 2,2 kW
Spindle Rpm range	120-2200 rpm	100-1800 rpm	100-1800 rpm
The "Autodigit" version includes the basic machine with option 37.3.	AB 26 iTRONIC AUTODIGIT	AB 34 iTRONIC AUTODIGIT	AB 34 iTRONIC-HST AUTODIGIT
Motor: n = 750/1500 rpm	1,0 / 1,6 kW	1,4 / 2,2 kW	1,4 / 2,2 kW
Spindle Rpm range	120-2200 rpm	100-1800 rpm	100-1800 rpm

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

Option 37.3 AUTODIGIT with 4 tools. For each tool 4 parameters may be defined:



Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) program functions for 4 tools in the Touch Display

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

Motor Isolation Class "F" (155°)

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

Electro-Magnetic Feed Clutch with three Cross Handle Switches and Overload Protection

Machine oil in separate bin

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.4	Comfortable Spindle Reverse Switch at the Cross Lever for CW and CCW rotations during the tapping process
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A* , consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display (only for AB 26 iTRONIC and AB 34 iTRONIC)
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.3	AUTODIGIT Automatic Drill Depth Control with: Drill Depth programming, interval drilling and free cutting possibility. Multiple settings in the Touch Display (Autodigit). Memory for 4 tools.
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
42.	Column extension + 200 mm (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (only for AB 26 and AB34 iTRONIC)
50.6	Precision Mechanical Depth Adjuster and fixed stop, Precision adjustment to 0,1 mm
03.	Anchoring set
07	Wooden packing, disposable for AB 34 iTRONIC-HST L x W x H 2400 x 1000 x 1500 mm, net weight approx. 135 kg
08.	Packaging, disposable wood for AB 26 iTRONIC and AB 34 iTRONIC, L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

*) = Net weight increases with 80 kg (AB 26 iTRONIC), with 60 kg (AB 34 iTRONIC)

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**COLUMN AND SEMI-BOX COLUMN
DRILLING MACHINES**

Drilling capacity 50 mm

Photo with options

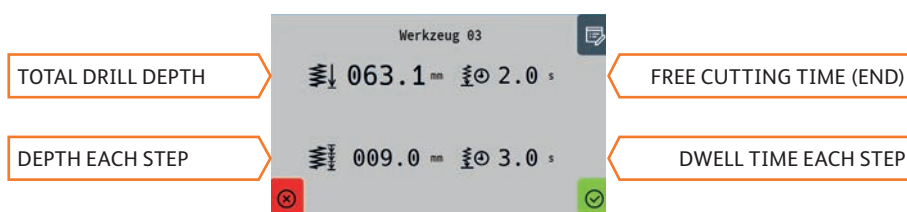


	AB 40 iTRONIC	AB 40 iTRONIC-HST
Drilling performance steel E 335* (St 60)	40 mm	40 mm
Drilling performance Cast iron EN-GJL-200* (GG 20)	46 mm	46 mm
Drilling capacity steel E 335* (St 60)	50 mm	50 mm
Tapping performance steel E 335* (St 60)	M 30	M 30
Tapping performance Cast iron EN-GJL-200*	M 36	M 36
Short spindle	MT 4	MT 4
Distance spindle to column	300 mm	330 mm
Table clamping area (W x D)	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	147/688 mm	266/928 mm
Column diameter / Box Column Dimensions	145 mm	290 mm
Z-travel of spindle	160 mm	160 mm
Feed(s)	0,1-0,2-0,3-0,4 mm/Rev	0,1-0,2-0,3-0,4 mm/Rev
Height of the machine without options approx.	1885 mm	2110 mm
Net weight approx.	470 kg	760 kg
Drive System	infinitely variable	infinitely variable
Motor: n = 750/1500 rpm	1,8 / 2,9 kW	1,8 / 2,9 kW
Spindle Rpm range	100-1600 rpm	100-1600 rpm
Motor: n = 750/1500 rpm (with gear)	1,8 / 2,9 kW	1,8 / 2,9 kW
Spindle Rpm range	70-4000 rpm	70-4000 rpm
The "Autodigit" version includes the basic machine with option 37.3.	AB 40 iTRONIC AUTODIGIT	AB 40 iTRONIC-HST AUTODIGIT
Motor: n = 750/1500 rpm	1,8 / 2,9 kW	1,8 / 2,9 kW
Spindle Rpm range	100-1600 rpm	100-1600 rpm

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

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

Option 37.3 AUTODIGIT with 4 tools. For each tool 4 parameters may be defined:



Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, **automatic Rpm Control**, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) program functions for 4 tools in the Touch Display

Infinitely variable speed drive, electrical Rpm setting (without lever)

Automatic Rpm control

Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

Motor isolation class „F“ (155°C)

Lacquer: DD-structured signal white RAL 9003,

PANTONE 7545c, black

Electro-Magnetic Feed Clutch with three Cross Handle

Switches and Overload Protection

Machine oil in separate bin

OPTIONS

12.	LED machine light , adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.4	Comfortable Spindle Reverse Switch at the Cross Lever for CW and CCW rotations during the tapping process
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A* , consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display (AB 40 iTRONIC).
25.	Coolant Attachment B , separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.3	AUTODIGIT Automatic Drill Depth Control with: Drill Depth programming, interval drilling and free cutting possibility. Multiple settings in the Touch Display (Autodigit). Memory for 4 tools.
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed.
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
42.	Column extension + 200 mm (tall operators, tapping devices, multi-spindle heads, turrets, reducer sleeves, etc.) (only for AB 40 iTRONIC)
50.6	Precision Mechanical Depth Adjuster and fixed stop , Precision adjustment to 0,1 mm (spindle stroke reduced by 20 mm)
51.1	Special "half" feeds Replacing the original feeds with 0,05 - 0,10 - 0,15 - 0,20 mm/Rot.
03.	Anchoring set
07	Wooden packing, disposable for AB 40 iTRONIC-HST , L x W x H 2400 x 1000 x 1500 mm, net weight approx. 135 kg
08.	Wooden packaging, disposable for AB 40 iTRONIC L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

*) = Net weight increases with 60 kg AB 40 iTRONIC

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COLUMN AND SEMI-BOX COLUMN DRILLING MACHINES

Drilling capacity 60 mm

Photo with options



	Column AB 50/SV	Semi-Box Column AB 50/HST
Drilling performance steel E 335* (St 60)	50 mm	50 mm
Drilling performance Cast iron EN-GJL-200* (GG 20)	60 mm	60 mm
Drilling capacity steel E 335* (St 60)	60 mm	60 mm
Tapping performance steel E 335* (St 60) <i>(Option 20.0 or 20.1 required)</i>	M 42	M 42
Tapping performance Cast iron EN-GJL-200* (GG 20) <i>(Option 20.0 or 20.1 required)</i>	M 60	M 60
Short spindle	MT 4	MT 4
Distance spindle to column	350 mm	330 mm
Table clamping area (W x D)	720 x 510 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max	138/874 mm	257/919 mm
Column diameter / Box Column Width	200 mm	290 mm
Z-travel of spindle	200 mm	200 mm
Feeds	0,15-0,2-0,3-0,36 mm/Rev	0,15-0,2-0,3-0,36 mm/Rev
Machine height without options approx.	1950 mm	2135 mm
Net weight approx.	605 kg	850 kg
Drive System	infinitely variable with gear box	
Motor: n = 1500/3000 rpm	3,6 / 4,3 kW	3,6 / 4,3 kW
Spindle Rpm range	60-1530 rpm	60-1530 rpm
Motor: n = 1500/3000 rpm	3,6 / 4,3 kW	3,6 / 4,3 kW
Spindle Rpm range	50-1280 rpm	50-1280 rpm

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

Standard Equipment:**Electro-magnetic feed clutch**

with Overload Protection and Electrical Cross Handle Switches

Main switch lockable**Self-Locking Mushroom Button** for Emergency-Off**Infinitely variable speed drive**, mechanical variator**Digital RPM Read-out****Protection class IP 54****Machined Base Plate**, with T-slots (AB 50/SV only),
clamping area 380 x 450 mm**Spindle protection** electrically secured**Lacquer:** DD-structured signal white RAL 9003,
PANTONE 7545c, black**Machine oil:** in separate bin**Attention:** W/O Tapping device (option 20.0 or 20.1)**OPTIONS**

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

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

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COLUMN DRILLING MACHINE FOR BOTH FLOW DRILLING AND STANDARD DRILLING

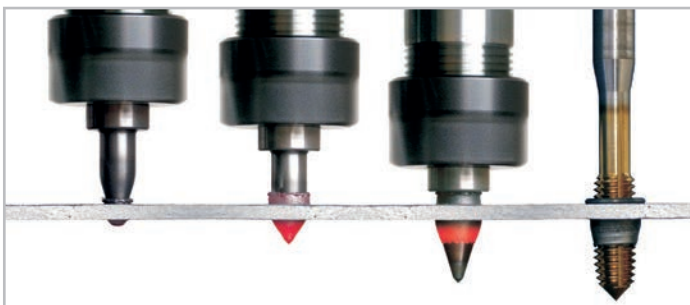
Flow Drilling capacity 12 mm

Photo with options



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

Chipless Flow Drilling and Cold roll threading



Process sequence



Examples

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) control functions for 4 tools in the Touch Display.

Infinitely variable speed drive, mechanical variator with lever
Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

Motor Isolation Class "F" (155°)

Lacquer: DD-structured signal white RAL 9003,

PANTONE 7545c, black

OPTIONS

12.	LED machine light, adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
25.	Coolant Attachment B, separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
03.	Anchoring set
08.	Packaging, disposable wood L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg

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COLUMN DRILLING MACHINE FOR BOTH FLOW DRILLING AND STANDARD DRILLING

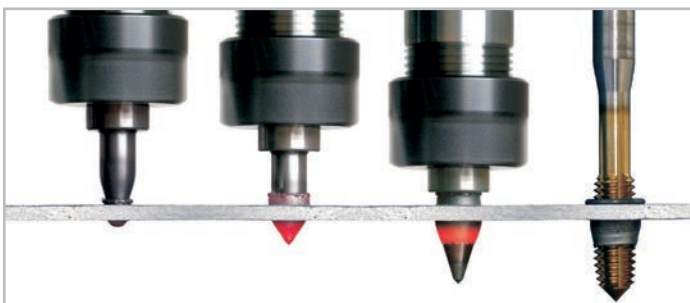
Flow Drilling capacity 20 mm

Photo with options



	AB-FLOW 40 iTRONIC	AB-FLOW 40 iTRONIC-HST
Flow Drilling capacity steel DC 01A (St 12.03) (sheet metal thickness 2,5 mm)	20 mm	20 mm
Flow Tapping performance steel DC 01A (St 12.03)	M 20	M 20
Drilling capacity steel E 335 (St 60)	40 mm	40 mm
Tapping performance steel E 335 (St 60)	M 30	M 30
Tapping performance Cast iron EN-GJL-200 (GG 20)	M 36	M 36
Short spindle	MT 4	MT 4
Z-travel of spindle	160 mm	160 mm
Distance spindle to column	300 mm	330 mm
Column diameter/ box column dimensions	145 mm	290 x 325 mm
Table clamping area (W x D)	615 x 430 mm	742 x 460 mm
T-Slots, number x width x distance	2 x 14 x 224 mm	2 x 14 x 224 mm
Distance spindle/table min./max.	147/688 mm	267/947 mm
Feed	0,1-0,2-0,3-0,4 mm/Rot.	0,1-0,2-0,3-0,4 mm/Rot.
Height of the machine without options approx.	1885 mm	2110 mm
Net weight approx.	470 kg	760 kg
Drive System	infinitely variable	infinitely variable
Motor: n = 1500 rpm	4,0 kW (with gear)	4,0 kW (with gear)
Spindle Rpm range	140-4000 rpm	140-4000 rpm

Chipless Flow Drilling and Cold roll threading



Process sequence



Examples

Standard Equipment:

7" TFT - LCD-MULTI-TOUCH Display: Memorization of a nominal spindle speed, **automatic Rpm Control**, read out of the actual spindle speed, actual drill depth read out with zero setting (drill start), virtual depth scale, machine's status indicators, warnings, service information, language selection DE/EN/FR/ES/IT/NL/RU.

Tapping Attachment w/o foot switch, max. 6 tapped holes per minute (tapping capacity depending on Rpm speed) with adjustable mechanical depth stop, with (depth) program functions for 4 tools in the Touch Display.

Infinitely variable speed drive, electrical Rpm setting (without lever)

Automatic Rpm control

Spindle protection electrically secured

Push button for starting the Right turn (CW), Push Button for starting the Left turn (CCW), Push Button for Spindle off

EMERGENCY-OFF switch, self-locking

Main switch, lockable

Right (CW) and Left (CCW) rotation under protective control

Control Tension 24 Volts

Protection Clas IP 54

Motor isolation class „F“ (155°C)

Lacquer: DD-structured signal white RAL 9003,

PANTONE 7545c, black

Electro-Magnetic Feed Clutch with three Cross Handle Switches and Overload Protection

Machine oil in separate bin

OPTIONS

12.	LED machine light , adjustable angle, connecting tension 24 V, protection class IP 65, with On/Off control function in the Touch Display
20.4	Comfortable Spindle Reverse Switch at the Cross Lever for CW and CCW rotations during the tapping process
20.5	Foot Pedal Reverse Switch for CW and CCW rotations during the tapping process
24.	Coolant Attachment A* , consisting of: Coolant base plate with machined surface 320 x 320 mm and 2 slots, overload protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display (AB-FLOW 40 iTRONIC).
25.	Coolant Attachment B , separate container (33 l), with overload-protected pump, backflow valve and accessories, with multiple On/Off control functions in the Touch Display
37.3	AUTODIGIT Automatic Drill Depth Control with: Drill Depth programming, interval drilling and free cutting possibility. Multiple settings in the Touch Display (Autodigit). Memory for 4 tools.
37.5	Technology Calculator in the Touch Display - calculation of cutting parameters by choosing a process, by inputting the tool diameter, by selecting a listed material and its cutting speed. The calculated value can be memorized in the main screen, visualizing the nominal speed vs. the actual speed
37.6	Maximum Drill Depth Readout in the Touch Display - measuring function for gauging the actual machined drill depth or counterbore depth. Useful for calibration purposes
50.6	Precision Mechanical Depth Adjuster and fixed stop , Precision adjustment to 0,1 mm
51.1	Special "half" feeds Replacing the original feeds with 0,05 - 0,10 - 0,15 - 0,20 mm/Rot.
03.	Anchoring set
07	Wooden packing, disposable for AB 40 iTRONIC-HST L x W x H 2400 x 1000 x 1600 mm, net weight approx. 135 kg
08.	Wooden packaging, disposable for AB-FLOW 40 iTRONIC L x W x H 1200 x 800 x 2100 mm. net weight approx. 75 kg
	* Net weight increases with 80 kg AB-FLOW 40 iTRONIC

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

Drilling capacity 45/50 mm

Photo with options



	AB 30/R-1000 AB 30/R-1400	AB 30/R-1000 AB 30/R-1400
	with 1,5 kW Motor	with 3,0 kW Motor
Drilling performance steel E 335 (St 60)	32 mm	40 mm
Drilling performance Cast iron EN-GJL-200* (GG 20)	45 mm	50 mm
Drilling capacity steel E 335 (ST 60)	45 mm	50 mm
Tapping performance steel E 335 (St 60) (Option 20.0 or 20.1 required)	M 30	M 30
Tapping performance Cast iron EN-GJL-200(GG 20) (Option 20.0 or 20.1 required)	M 42	M 42
Short spindle	MT 4	
Diameter of Column with AB 30/R-1000 / with AB 30/R-1400	220 mm / 300 mm	
Travel Motor	0,75 kW	
4 feeds	0,15-0,2-0,3-0,36 mm/Rev	
Z-travel of spindle (Alt. Pos. 54)	160 mm	
Net weight approx. with AB 30/R-1000	1250 kg	
Net weight approx. with AB 30/R-1400	1650 kg	
Drive System	Gear box	
Motor: n = 1500 rpm	1,5 kW	3,0 kW •
Spindle Rpm range	40-56-80-112-160-224-315-450-630-900-1250-1800 rpm or 28-40-56-80-112-160-224-315-450-630-900-1250 rpm or 56-80-112-160-224-315-450-630-900-1250-1800-2500 rpm	nur möglich 56-2500 rpm

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

Standard Equipment:

Electromagnetic Feed Clutch with overload protection and cross handle switches
Contact Control for Clockwise Spindle Rotation incl. motor protection circuit breaker for spindle motor and feed motor
Control Transformer (VDE 0113)
Main switch lockable
Base plate with T-slots

Self-Locking Mushroom Button for EMERGENCY OFF
Spindle protection electrically secured
Protection class IP 54
Lacquer: DD-structured signal white RAL 9003, PANTONE 7545c, black
Machine oil

OPTIONS

1.11	Anchor and levelling elements (6 elements)
12.2	Protected tube light incl. lamp
20.0	Tapping Attachment w/o foot switch , max. 6 tapped holes per minute, incl. smooth-start clutch in gear box
22.	Light transformer , for special voltages (not necessary with 230 or 400 V with usable O-conductor and light voltage 230 V) (only with Pos. 12.2)
24.	Coolant Attachment A , integrated in standard base plate with overload-protected pump, backflow valve and accessories
28.	Electrically controlled free-cutting system when depth is reached cutter remains for a controllable time in position. Incl. time-limit relay and feed brake.
42.6 •	Outboard support (an extra built-in switch will cut circuit to elevating motor when outboard support is locked)
47.2.1	Long spindle MT 4 with key bore DIN 1807
50.6	Precision depth adjuster and fixed stop precision adjustment to 0,1 mm
53.2	Portable boxed clamping table , length 560 mm, width 480 mm, H 500 mm, clamping area at top 560 x 480 mm, with 3 T-slots 14 mm, at distance 150 mm / clamping area at side 560 x 330 mm, with 2 T-slots 14 mm, at distance 150 mm, weight 200 kg
54.	Spindle travel 200 mm
58	Central clamping system for sliding drill unit = mechanic, for column and arm = pneumatic/hydraulic
58.1	Central clamping system for sliding drill unit and arm = mechanic, for column = pneumatic
01.	Special Lacquer: DD-brillant
02.	Special Lacquer: DD-structured
05.	Special voltages
	Packing: on wooden bars at no costs, Net weight approx. 100 kg

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

Photo with options



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

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

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

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

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

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

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

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

Photo with options



	Casted Table RFT 2/2	Casted Table RFT 2/3	Special Equipment
Tool Cabinet	see Pos. 09.1	see Pos. 09.1	09.1 Built-in Tool Cabinet with door
Height of Table	930 mm	930 mm	4 drawers (w x d x h):
Width of Table	900 mm	1350 mm	3 pieces
Clamping Area at Table (width x depth)	750 x 330 mm	1200 x 330 mm	500 x 430 x 100 mm
Clamping Slots (number x width x distance)	2 x 12 x 224 mm	2 x 12 x 224 mm	1 piece
Approximate Weight w/o Heads	200 kg	300 kg	500 x 430 x 150 mm
Number of Drill Heads	2	3	door can be locked

Assembly of heads for	RFT 2/2 - 2/3	
Drill head, height adjustable 500 mm	AX 2 iTRONIC	
Short spindle	MT 2	
Distance spindle to column	235 mm	
Distance Spindle Nose to Table max.	660 mm	
Distance Spindle Nose to Table min.	160 mm	
Z-travel of spindle	100 mm	
Weight	75 kg	
Motor	750/1500 rpm	750/1500 rpm
kW	0,6/0,95 kW	0,6/0,95 kW
Spindle Rpm range, mechanical variator	125-2400 rpm	225-4300 rpm

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

OPTIONS

35.	Coolant attachment system B, with 48 l container, overload protected pump, backflow valve and complete accessories - for 2 Drill heads
35.1	- for 3 Drill heads
35.2	- for 4 Drill heads
35.3	- for 5 Drill heads
35.4	- for 6 Drill heads
42.6	Drill Heads 700 mm adjustable (RFT 3)
01.	Special Lacquer: DD-brillant, table only
02.	Special Lacquer: DD-structured, table only
03.	Anchoring set (set of 4 pieces) up to RFT 3/3
03.	Anchoring set (set of 6 pieces) RFT 3/4 and 3/5
03.	Anchoring set (set of 8 pieces) RFT 3/6
	Packing on wooden bars only, no costs. Net weight approx. 40-150 kg

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

Photo with options



	Casted table RFT 3/2	Casted table RFT 3/3	Casted table RFT 3/4	Casted table RFT 3/5	Casted table RFT 3/6
Height of Table	780	780	780	780	780
Width of Table	1150	1650	2150	2650	3150
Clamping Area at Table (width x depth)	1000 x 350	1500 x 350	2000 x 350	2500 x 350	3000 x 350
Clamping Slots (number x width x distance)	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224	2 x 14 x 224
Approximate Weight w/o Heads	350 kg	520 kg	680 kg	840 kg	990 kg
Number of Drill Heads	2	3	4	5	6




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

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

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

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

ACCESSORIES

 <p>Two-axis production table with copying device</p>	810776 *)	Two-axis Production Table (sliding) 760 x 425 mm, clamping area 600 x 325 mm, Height 170 mm, Travel 400 mm in X, 200 mm in Y, with adjustable end limiters, with 2 T-Slots 14 mm at distance 160 mm, max. admissible load approx. 150 kgs, max. admissible drill force 15000 N (starting from AB 34), weight approx. 140 kg
	816600 *)	Two-axis Production Table (sliding) 880 x 425 mm, clamping area 820 x 410 mm Travel 400 mm in X, 200 mm in Y. Weight approx. 190 kg
	37721	Two-axis Production Table (sliding) (810776) with Positioning Device / Copying Device
	37804	Two-axis Production Table (sliding) (816600) with Positioning Device / Copying Device
	37648	Templates for positioning device size 1 160 x 220 mm
	37630	size 2, 290 x 220 mm
	37622	size 3, 420 x 220 mm
	101.5	Customised Hole Patterns with hardened inserts A5 x 12, DIN 179, per hole
 <p>Compound table</p>	*)	Compound Table with drum grips for X and Y, with mm scale for X, Positioning accuracy 0.1 mm
	810854 *)	Size 200 , cross traverse 160 mm, longitudinal traverse 240 mm Clamping area with coolant groove 430 x 240 mm, 3 T-slots Weight approx. 46 kg
	810856 *)	Size 300 , cross traverse 160 mm, longitudinal traverse 350 mm Clamping area with coolant groove 600 x 240 mm, 3 T-slots Weight approx. 56 kg
	810858 *)	Size 400 cross traverse 240 mm, longitudinal traverse 470 mm Clamping area with coolant groove 800 x 240 mm, 3 T-slots Weight approx. 86 kg
	810860 *)	Size 500 , cross traverse 300 mm, longitudinal traverse 470 mm Clamping area with coolant groove 800 x 320 mm, 4 T-slots Weight approx. 122 kg
	836682 *)	Mounting bars for cross table 200 to ALZSTAR 23 and AX 2
	102.5	Numerical Position Display for Compound Table, sizes 400 and 500 with support hook for mounting to drilling machine, display in steps of 0,005 or 0.010 mm (switchable), incl. Preset and Memofix, covered incremental scales.
 <p>Vices 125/155</p>	10637	Machine Vice, size 125 height 85 mm, width of jaws 125 mm, clamping width 155 mm, weight 14 kgs
	10660	including prism jaws (1 longitudinal and 2 cross prisms)
	42143	Machine Vice, size 155 height 112 mm, width of jaws 155 mm, clamping width 230 mm, weight 29 kgs
	42168	including prism jaws (1 longitudinal and 2 cross prisms)
		Packing for two-axis production table, W x D x H, 1200 x 800 x 450
		Packing for crosstable 200, W x D x H, 800 x 600 x 400
		Packing for crosstable 300-500, W x D x H, 1200 x 800 x 400

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

Machine vice



Vice BON

- 137067** Machine Vice Type BON with prism jaws size 1 height 60 mm, width of jaws 80 mm, clamping width 70 mm, weight 7,5 kg
- 137075** size 2 height 72 mm, width of jaws 100 mm, clamping width 110 mm, weight 9,5 kg
- 137083** size 3 height 80 mm, width of jaws 125 mm, clamping width 130 mm, weight 13,5 kg
- 137091** size 4 height 95 mm, width of jaws 160 mm, clamping width 220 mm, weight 25 kg

Quick action drill chucks SUPRA



- 138107** Type 136 clamping width 1-13 mm B 16
 - 140251** Type 136 clamping width 3-16 mm B 16
 - 150466** Type 136 clamping width 3-16 mm B 18
 - 189290** Type 136 clamping width 0-10 mm B 16
- Permitted for spindle Rpm range up to max. 5000 rpm.
Not suitable for CCW rotation

Tapers KD, DIN 238 for quick action drill chucks SUPRA



- 138115** Type 236 MT 2 B 16
- 139048** Type 236 MT 3 B 16
- 150474** Type 236 MT 3 B 18
- 160820** Type 236 MT 4 B 16
- 320283** Type 236 MT 4 B 18

Reduction inserts RH, DIN 2185



- 161075** Type 261 N MT 2/1
- 190256** Type 261 N MT 3/1
- 150482** Type 261 N MT 3/2
- 160838** Type 261 N MT 4/1
- 160846** Type 261 N MT 4/2
- 160853** Type 261 N MT 4/3

Expeller for taper DIN 228



- 81950** MT 2
- 150490** MT 3
- 161018** MT 4

Semi-automatic expeller for morse taper DIN 228



- 17277** MT 1 - 3
- 18952** MT 3 - 6

Special equipment

Pos.	Description
17.	Foot Emergency-OFF Switch
21.	Control Transformer, for special voltages only
22.	Light Transformer for special voltages only
41.	° Machined Base Plate with clamp surface 320 x 320 mm and 2 T-slots (AB50/SV = 450x460 mm)
44.0	° Combination Sq. Table (400 x 400 mm), for drilling under angles with at opposite side sliding mounted vice with clamping width 125 mm, including prism jaws, clamp surface 350 x 350 mm, Net weight increases by approx. 80 kg
48.5	Flange Quill incl. Double Return Spring to compensate up to 40 kg max. (at AB 50 up to 50 kg)
01.	Special Painting DD-Brillant, (small parts DD-structured)
02.	Special Painting DD-structured
05.	Special voltages
<i>Special equipments upon request</i> ° only for round column types; # with AB 40 standard	

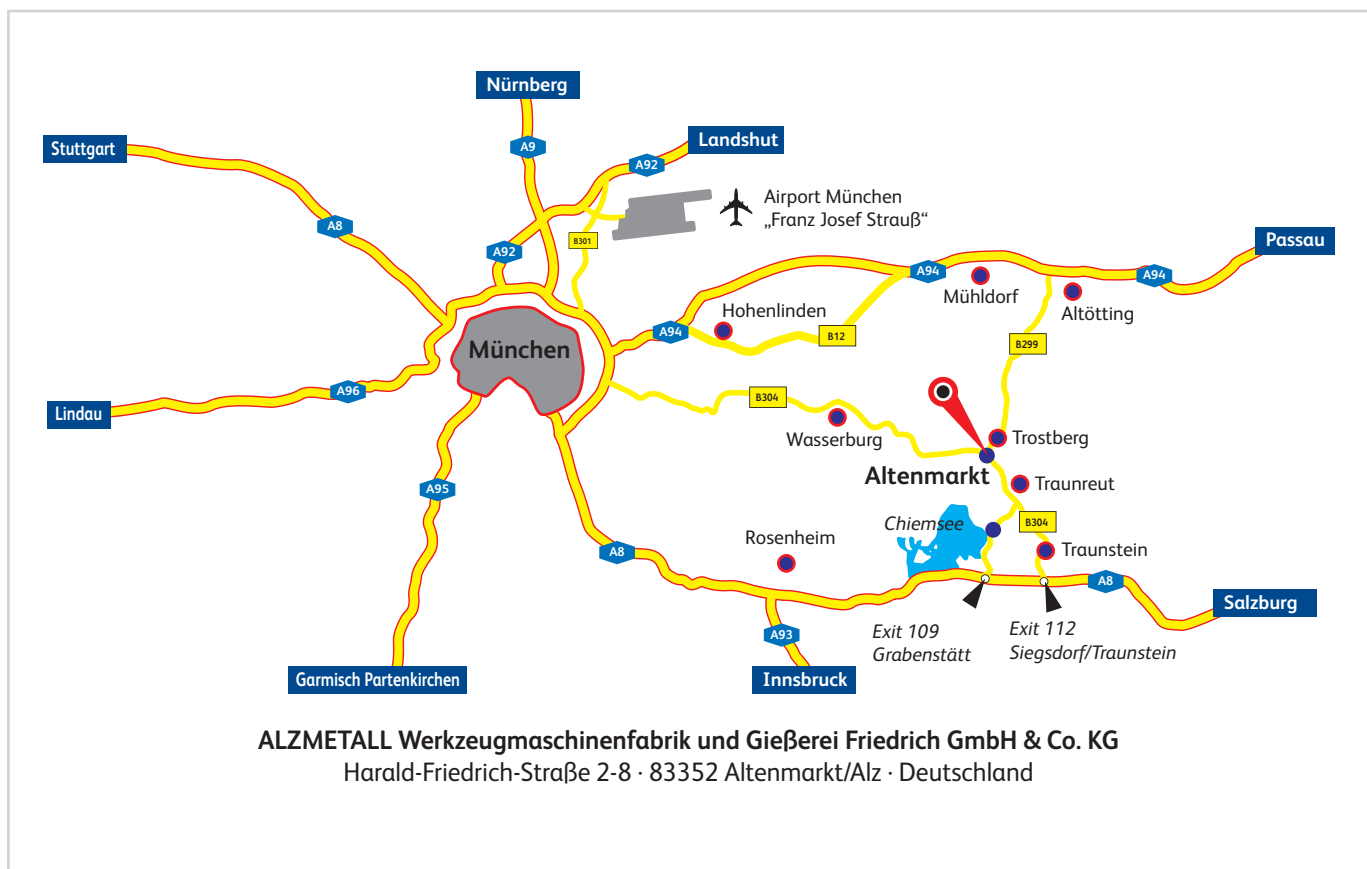
Decision matrix for mounting compound tables and two-axis production table; Versions see page 34

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

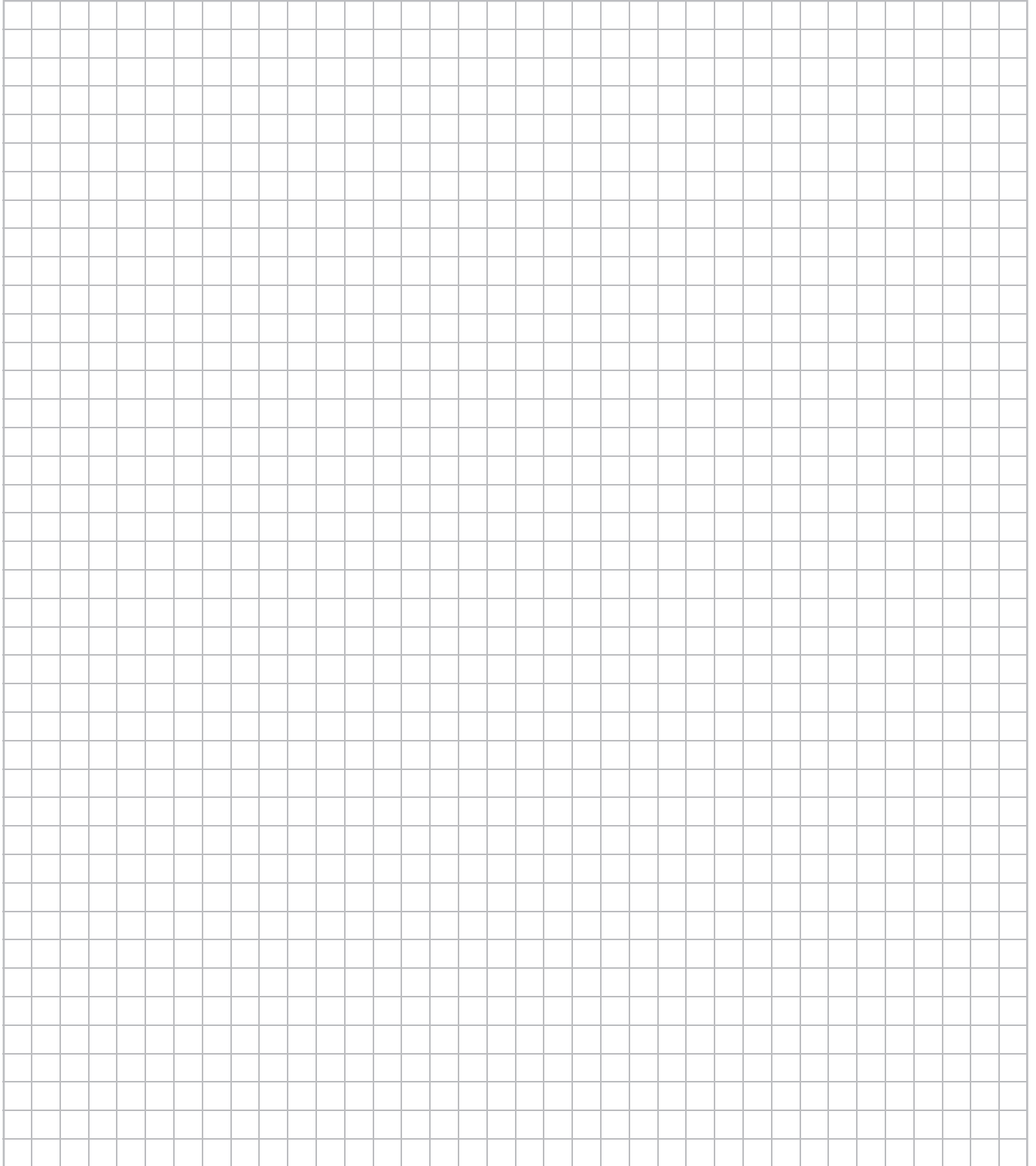
- = mounting not possible, • = mounting possible, •• = possible only with mounting bars see Page 34, Accessories Nr. 836682.
For models with combi table 44.0, this matrix is not valid!



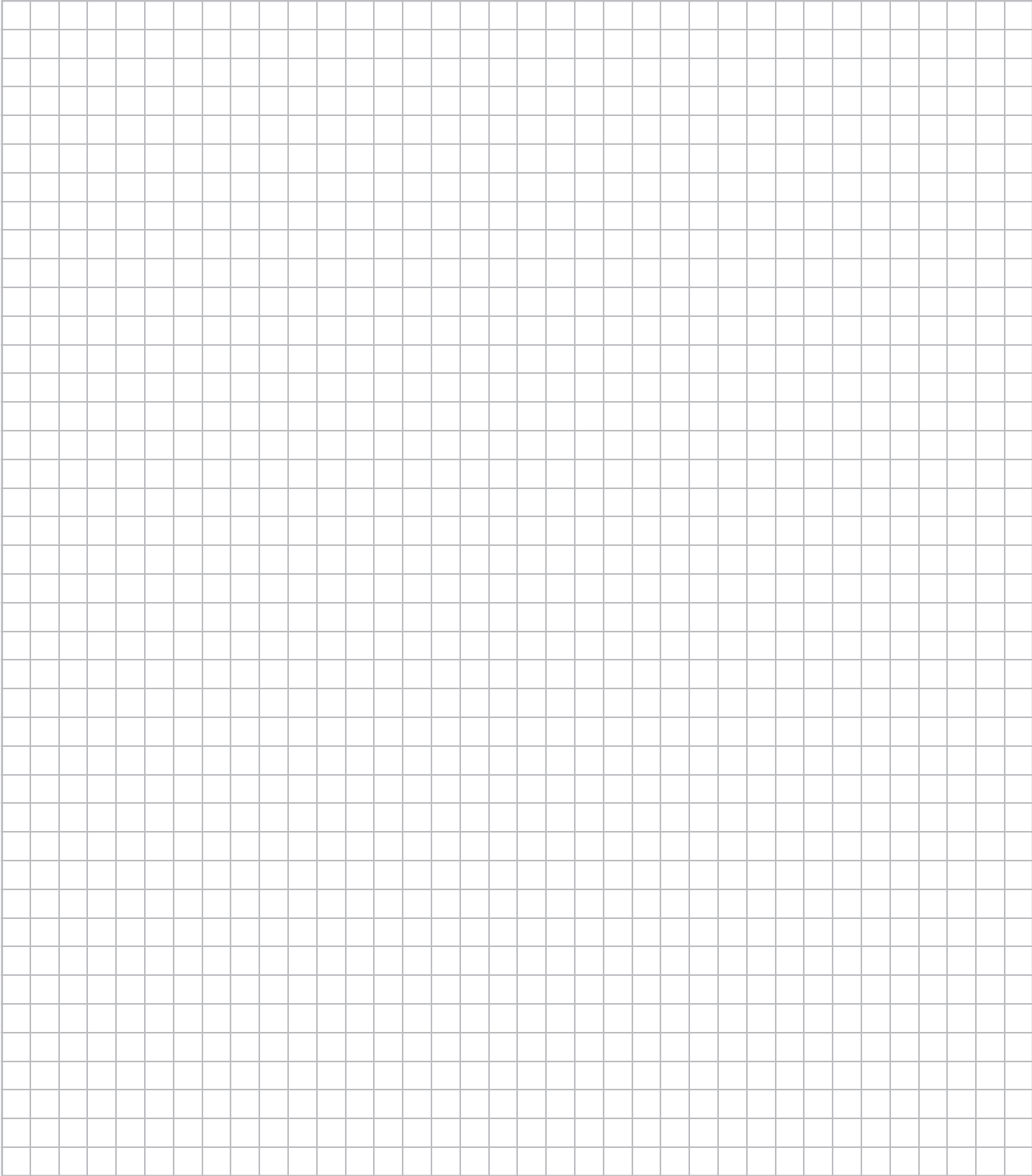
Where to find us



NOTES



NOTES



Short notice of our delivery terms

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

Machining centres



GS 600

CNC Rapid Radial Drilling Machines



Donau Werkzeugmaschinen GmbH
83352 Altenmarkt, www.donau-wzm.de



Machining centres



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

Foundry and processing technology

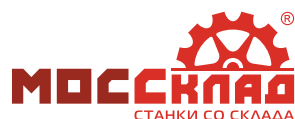


ALZMETALL is operating their proper foundry at 11.000 tons per year and is a sub-contractor for many industries. Activities consist of casting, machining, lacquering.

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