



Series HSS-Co 8

Annular Cutters made from special steel with a high cobalt content.

- High heat resistance
- Better wear protection
- High cobalt content of 8%
- Suitable for higher loads in fine-grained steels and stainless materials
- Available with 19 mm or 32 mm Weldon shank
- Regrindable



KBK-CO

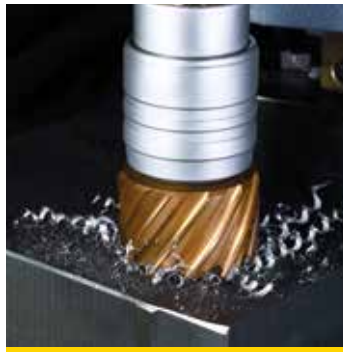
KBL-CO

Cutting depth
30 mm

Cutting depth
55 mm

Drilling diameter
12 – 130 mm

Drilling diameter
12 – 100 mm



Series HSS-VarioPLUS

High Speed Steel Annular Cutters with premium carbide coating.

- High-strength solid ground core drills
- Hardness-resistant layer in the range of 2.5 μ – for longer service life.
- More even chip evacuation, especially with long drills – an important point for work safety
- Regrindable



KBK-VP

KBL-VP

Cutting depth
30 mm

Cutting depth
55 mm

Drilling diameter
12 – 60 mm

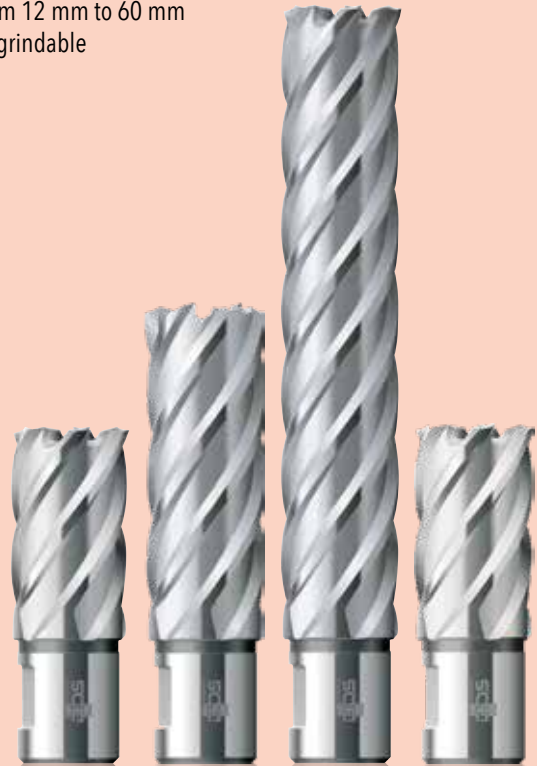
Drilling diameter
12 – 60 mm



Series HSS-Standard

Fully ground core drills made from high-performance high-speed steel.

- Tools with three different cutting depths: 30 mm, 55 mm and 110 mm
- Core drill diameter from 12 mm to 60 mm
- Regrindable



KBK

KBL

KEL

KBK-Z

Cutting depth
30 mm

Cutting depth
55 mm

Cutting depth
110 mm

Cutting depth
30 mm

Drilling diameter
12 – 60 mm

Drilling diameter
12 – 60 mm

Drilling diameter
20 – 50 mm

Drilling diameter
½" – 2 1/16"

TOOL HOLDERS / SHANK TYPE

BDS core drilling tools are available with various tool holders to suit different machines and applications. All BDS annular cutters come standard with the WELDON shank system. Cutters up to 60 mm in diameter feature a 19 mm Weldon shank, while cutters from 61 mm upwards use a 32 mm Weldon shank. BDS also offers annular cutters with, Nitto shank, Universal shank (a combination of Weldon and Nitto), 18 mm Quick-In shank. This versatility ensures compatibility with a wide range of magnetic drilling machines.



19 mm
Weldon shank (¾")



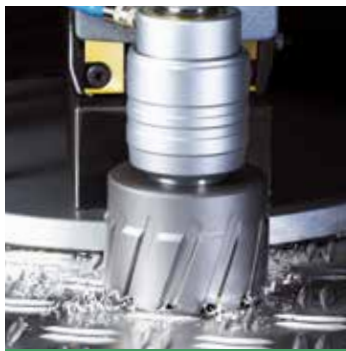
32 mm
Weldon shank (1¼")



18 mm
Quick-In shank



Carbide Annular Cutters option-
ally available as universal shank
(Nitto + Weldon)



BDS FULLY-GROUND ANNULAR CUTTERS.

**THEY MAKE THE DIFFERENCE: MAXIMUM
CUTTING PERFORMANCE FOR MORE HOLES!**

Series Carbide

Annular Cutters with tungsten carbide tips. Tungsten carbide tips are ultra-hard, wear-resistant inserts used to enhance the durability and cutting performance of tools. Ideal for drilling tough materials, they provide longer tool life, increased precision, and improved efficiency in demanding industrial applications.

- Cutting depths of 30 mm, 55 mm, 75 mm and 110 mm
- Diameter from 12 mm to 150 mm



Series Carbide-PLUS

Carbide PLUS additionally with wear-resistant hard coating up to 2.5 μ .



HKK-P

Cutting depth
30 mm

Drilling diameter
12 – 60 mm

Series Carbide-RAIL

Annular Cutter with tungsten carbide tips for drilling rail-way tracks and hard material.



HKK-R

Cutting depth
30 mm

Drilling diameter
17 – 36 mm

Series Quick-In HSS-Co 8-F / Carbide

Annular Cutters made of HSS tool steel or with tungsten carbide tip. Suitable for Quick-In holding systems. Annular Cutter with 18 mm shank for Quick-In mounting system.



KBK-CO 8 F HKK-F

Cutting depth
35 mm

Drilling diameter
12 – 60 mm

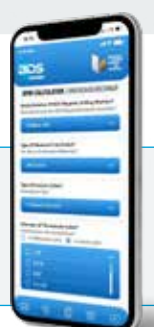
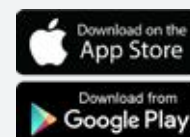
Cutting depth
35 mm

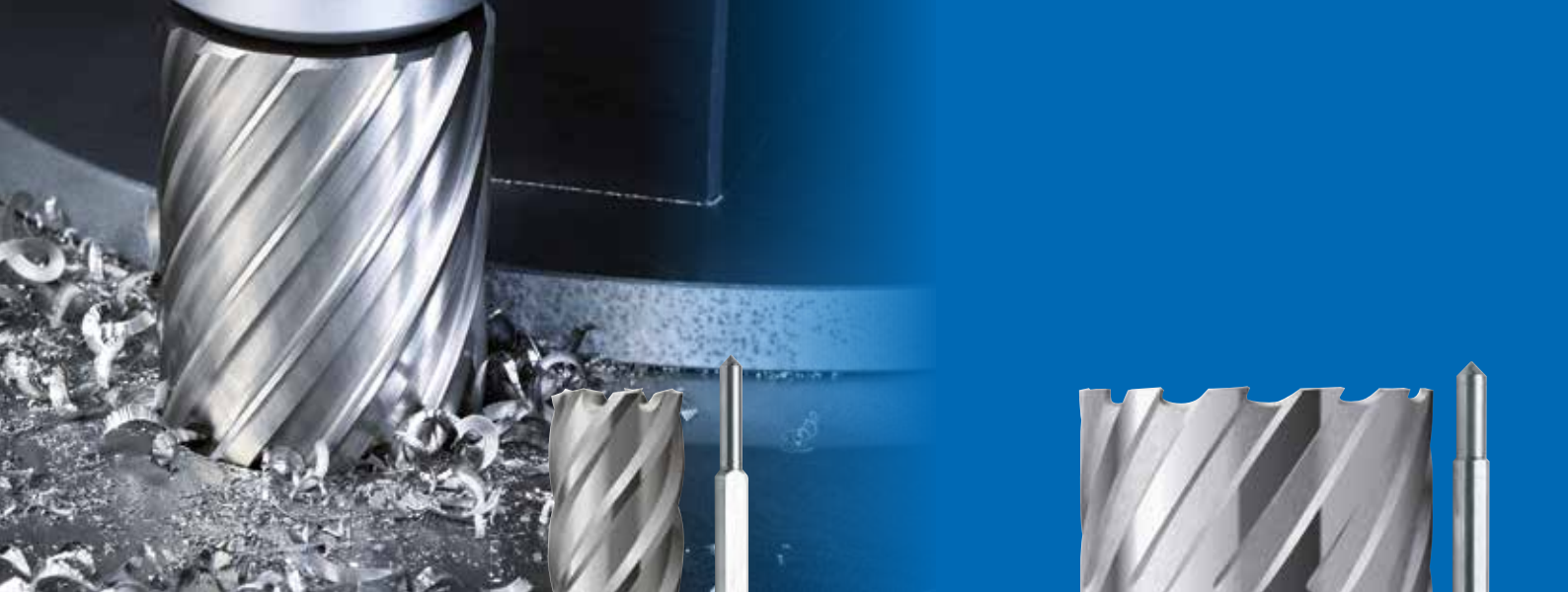
Drilling diameter
12 – 60 mm

HKK	HKL	HXX-L	HKE-L
Cutting depth 30 mm	Cutting depth 55 mm	Cutting depth 75 mm	Cutting depth 110 mm
Drilling diameter 12 – 150 mm	Drilling diameter 12 – 100 mm	Drilling diameter 18 – 120 mm	Drilling diameter 20 – 120 mm

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.





HSS-CO 8 ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank ($\frac{3}{4}$ "")



Ø mm	Order no.	Ø mm	Order no.
12	KBK-CO 012	36	KBK-CO 036
13	KBK-CO 013	37	KBK-CO 037
14	KBK-CO 014	38	KBK-CO 038
15	KBK-CO 015	39	KBK-CO 039
16	KBK-CO 016	40	KBK-CO 040
17	KBK-CO 017	41	KBK-CO 041
17.5	KBK-CO 175	42	KBK-CO 042
18	KBK-CO 018	43	KBK-CO 043
19	KBK-CO 019	44	KBK-CO 044
19.5	KBK-CO 195	45	KBK-CO 045
20	KBK-CO 020	46	KBK-CO 046
21	KBK-CO 021	47	KBK-CO 047
22	KBK-CO 022	48	KBK-CO 048
23	KBK-CO 023	49	KBK-CO 049
24	KBK-CO 024	50	KBK-CO 050
25	KBK-CO 025	51	KBK-CO 051
26	KBK-CO 026	52	KBK-CO 052
27	KBK-CO 027	53	KBK-CO 053
28	KBK-CO 028	54	KBK-CO 054
29	KBK-CO 029	55	KBK-CO 055
30	KBK-CO 030	56	KBK-CO 056
31	KBK-CO 031	57	KBK-CO 057
32	KBK-CO 032	58	KBK-CO 058
33	KBK-CO 033	59	KBK-CO 059
34	KBK-CO 034	60	KBK-CO 060
35	KBK-CO 035		

Ejector pin for KBK-CO Ø 12 - 60 mm

ZAK 075

HSS-CO 8 ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 32 mm Weldon shank (1 $\frac{1}{4}$ "")



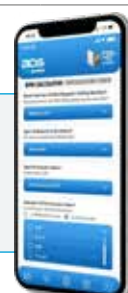
Ø mm	Order no.	Ø mm	Order no.
61	KBK-CO 061	84	KBK-CO 084
62	KBK-CO 062	85	KBK-CO 085
63	KBK-CO 063	86	KBK-CO 086
64	KBK-CO 064	87	KBK-CO 087
65	KBK-CO 065	88	KBK-CO 088
66	KBK-CO 066	89	KBK-CO 089
67	KBK-CO 067	90	KBK-CO 090
68	KBK-CO 068	91	KBK-CO 091
69	KBK-CO 069	92	KBK-CO 092
70	KBK-CO 070	93	KBK-CO 093
71	KBK-CO 071	94	KBK-CO 094
72	KBK-CO 072	95	KBK-CO 095
73	KBK-CO 073	96	KBK-CO 096
74	KBK-CO 074	97	KBK-CO 097
75	KBK-CO 075	98	KBK-CO 098
76	KBK-CO 076	99	KBK-CO 099
77	KBK-CO 077	100	KBK-CO 100
78	KBK-CO 078	105	KBK-CO 105
79	KBK-CO 079	110	KBK-CO 110
80	KBK-CO 080	115	KBK-CO 115
81	KBK-CO 081	120	KBK-CO 120
82	KBK-CO 082	125	KBK-CO 125
83	KBK-CO 083	130	KBK-CO 130

Ejector pin for KBK-CO Ø 61- 130 mm

ZAK 090

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



ANNULAR CUTTERS SERIES HSS-CO 8

FULLY-GROUND CORE DRILL MADE FROM HIGH-PERFORMANCE HIGH-SPEED STEEL.

The annular cutters in this series are characterized by high heat resistance and excellent wear protection. They are ideal for use with speed-controlled BDS magnetic drilling machines and are especially suitable for processing fine-grain steels and stainless materials.



Videos & documents

HSS-CO 8 ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (3/4")



Ø mm	Order no.	Ø mm	Order no.
12	KBL-CO 012	36	KBL-CO 036
13	KBL-CO 013	37	KBL-CO 037
14	KBL-CO 014	38	KBL-CO 038
15	KBL-CO 015	39	KBL-CO 039
16	KBL-CO 016	40	KBL-CO 040
17	KBL-CO 017	41	KBL-CO 041
17.5	KBL-CO 175	42	KBL-CO 042
18	KBL-CO 018	43	KBL-CO 043
19	KBL-CO 019	44	KBL-CO 044
19.5	KBL-CO 195	45	KBL-CO 045
20	KBL-CO 020	46	KBL-CO 046
21	KBL-CO 021	47	KBL-CO 047
22	KBL-CO 022	48	KBL-CO 048
23	KBL-CO 023	49	KBL-CO 049
24	KBL-CO 024	50	KBL-CO 050
25	KBL-CO 025	51	KBL-CO 051
26	KBL-CO 026	52	KBL-CO 052
27	KBL-CO 027	53	KBL-CO 053
28	KBL-CO 028	54	KBL-CO 054
29	KBL-CO 029	55	KBL-CO 055
30	KBL-CO 030	56	KBL-CO 056
31	KBL-CO 031	57	KBL-CO 057
32	KBL-CO 032	58	KBL-CO 058
33	KBL-CO 033	59	KBL-CO 059
34	KBL-CO 034	60	KBL-CO 060
35	KBL-CO 035		

HSS-CO 8 ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 32 mm Weldon shank (1 1/4")



Ø mm	Order no.	Ø mm	Order no.
61	KBL-CO 061	81	KBL-CO 081
62	KBL-CO 062	82	KBL-CO 082
63	KBL-CO 063	83	KBL-CO 083
64	KBL-CO 064	84	KBL-CO 084
65	KBL-CO 065	85	KBL-CO 085
66	KBL-CO 066	86	KBL-CO 086
67	KBL-CO 067	87	KBL-CO 087
68	KBL-CO 068	88	KBL-CO 088
69	KBL-CO 069	89	KBL-CO 089
70	KBL-CO 070	90	KBL-CO 090
71	KBL-CO 071	91	KBL-CO 091
72	KBL-CO 072	92	KBL-CO 092
73	KBL-CO 073	93	KBL-CO 093
74	KBL-CO 074	94	KBL-CO 094
75	KBL-CO 075	95	KBL-CO 095
76	KBL-CO 076	96	KBL-CO 096
77	KBL-CO 077	97	KBL-CO 097
78	KBL-CO 078	98	KBL-CO 098
79	KBL-CO 079	99	KBL-CO 099
80	KBL-CO 080	100	KBL-CO 100

Ejector pin for KBL-CO Ø 12 - 60 mm

ZAK 100

Ejector pin for KBL-CO Ø 61 - 100 mm

ZAK 120

Recommended lubricants

Order no. Article (suitable for all HSS-CO 8 Annular Cutters)

ZHS 005	BDS 5000 Cutting oil (5 liters)
ZHS 006	BDS 5000 Cutting oil (1 liter)
ZHS 570	BDS 7500 Cutting paste, 85 g Tube



Order no. Article (suitable for all HSS-CO 8 Annular Cutters)

ZHS 400	BDS 5200 lubrication spray, 1 x 400 ml Can
ZHS 406	BDS 5200 lubrication spray, 6 x 400 ml Can
ZHS 412	BDS 5200 lubrication spray, 12 x 400 ml Can



ANNULAR CUTTERS SERIES HSS-VarioPLUS



Videos & documents

Fully-ground core drill made of high-performance HSS with a hard material coating. Offers high economic efficiency thanks to extended service life and increased work safety, supported by excellent chip evacuation – especially with long annular cutters. For optimal performance, BDS recommends using BDS 5000 high-performance cutting oil.

HSS-VarioPLUS ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	KBK-VP 012	36	KBK-VP 036
13	KBK-VP 013	37	KBK-VP 037
14	KBK-VP 014	38	KBK-VP 038
15	KBK-VP 015	39	KBK-VP 039
16	KBK-VP 016	40	KBK-VP 040
17	KBK-VP 017	41	KBK-VP 041
17.5	KBK-VP 175	42	KBK-VP 042
18	KBK-VP 018	43	KBK-VP 043
19	KBK-VP 019	44	KBK-VP 044
19.5	KBK-VP 195	45	KBK-VP 045
20	KBK-VP 020	46	KBK-VP 046
21	KBK-VP 021	47	KBK-VP 047
22	KBK-VP 022	48	KBK-VP 048
23	KBK-VP 023	49	KBK-VP 049
24	KBK-VP 024	50	KBK-VP 050
25	KBK-VP 025	51	KBK-VP 051
26	KBK-VP 026	52	KBK-VP 052
27	KBK-VP 027	53	KBK-VP 053
28	KBK-VP 028	54	KBK-VP 054
29	KBK-VP 029	55	KBK-VP 055
30	KBK-VP 030	56	KBK-VP 056
31	KBK-VP 031	57	KBK-VP 057
32	KBK-VP 032	58	KBK-VP 058
33	KBK-VP 033	59	KBK-VP 059
34	KBK-VP 034	60	KBK-VP 060
35	KBK-VP 035		

Ejector pin for KBK-VP, Ø 12 - 60 mm

ZAK 075

HSS-VarioPLUS ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	KBL-VP 012	36	KBL-VP 036
13	KBL-VP 013	37	KBL-VP 037
14	KBL-VP 014	38	KBL-VP 038
15	KBL-VP 015	39	KBL-VP 039
16	KBL-VP 016	40	KBL-VP 040
17	KBL-VP 017	41	KBL-VP 041
17.5	KBL-VP 175	42	KBL-VP 042
18	KBL-VP 018	43	KBL-VP 043
19	KBL-VP 019	44	KBL-VP 044
19.5	KBL-VP 195	45	KBL-VP 045
20	KBL-VP 020	46	KBL-VP 046
21	KBL-VP 021	47	KBL-VP 047
22	KBL-VP 022	48	KBL-VP 048
23	KBL-VP 023	49	KBL-VP 049
24	KBL-VP 024	50	KBL-VP 050
25	KBL-VP 025	51	KBL-VP 051
26	KBL-VP 026	52	KBL-VP 052
27	KBL-VP 027	53	KBL-VP 053
28	KBL-VP 028	54	KBL-VP 054
29	KBL-VP 029	55	KBL-VP 055
30	KBL-VP 030	56	KBL-VP 056
31	KBL-VP 031	57	KBL-VP 057
32	KBL-VP 032	58	KBL-VP 058
33	KBL-VP 033	59	KBL-VP 059
34	KBL-VP 034	60	KBL-VP 060
35	KBL-VP 035		

Ejector pin for KBL-VP, Ø 12 - 60 mm

ZAK 100

Recommended lubricants

Order no.	Article (suitable for all HSS-VarioPLUS)
ZHS 005	BDS 5000 Cutting oil (5 liters)
ZHS 006	BDS 5000 Cutting oil (1 liter)
ZHS 570	BDS 7500 Cutting paste, 85 g Tube



Order no.	Article (suitable for all HSS-VarioPLUS)
ZHS 400	BDS 5200 lubrication spray, 1 x 400 ml Can
ZHS 406	BDS 5200 lubrication spray, 6 x 400 ml Can
ZHS 412	BDS 5200 lubrication spray, 12 x 400 ml Can



ANNULAR CUTTERS SERIES HSS-STANDARD

The essential annular cutter range for professional use. These fully-ground annular cutters are made from high-speed steel and are precision-manufactured on CNC-controlled grinding centers. They offer efficient chip evacuation and effortless drilling



Videos & documents

performance. For horizontal drilling applications, BDS recommends BDS 5200 high-performance grease spray.



Videos & documents

QUICK-IN HSS-Co 8-F ANNULAR CUTTER SHORT

- ▶ 35 mm Cutting depth
- ▶ 18 mm Schaft for Quick-In Chuck system



Ø mm	Order no.	Ø mm	Order no.
12	KBK-F 012	37	KBK-F 037
13	KBK-F 013	38	KBK-F 038
14	KBK-F 014	39	KBK-F 039
15	KBK-F 015	40	KBK-F 040
16	KBK-F 016	41	KBK-F 041
17	KBK-F 017	42	KBK-F 042
18	KBK-F 018	43	KBK-F 043
19	KBK-F 019	44	KBK-F 044
20	KBK-F 020	45	KBK-F 045
21	KBK-F 021	46	KBK-F 046
22	KBK-F 022	47	KBK-F 047
23	KBK-F 023	48	KBK-F 048
24	KBK-F 024	49	KBK-F 049
25	KBK-F 025	50	KBK-F 050
26	KBK-F 026	51	KBK-F 051
27	KBK-F 027	52	KBK-F 052
28	KBK-F 028	53	KBK-F 053
29	KBK-F 029	54	KBK-F 054
30	KBK-F 030	55	KBK-F 055
31	KBK-F 031	56	KBK-F 056
32	KBK-F 032	57	KBK-F 057
33	KBK-F 033	58	KBK-F 058
34	KBK-F 034	59	KBK-F 059
35	KBK-F 035	60	KBK-F 060
36	KBK-F 036		

QUICK-IN CARBIDE-F ANNULAR CUTTER LONG

- ▶ 35 mm Cutting depth
- ▶ 18 mm Schaft for Quick-In Chuck system



Ø mm	Order no.	Ø mm	Order no.
12	HKK-F 012	37	HKK-F 037
13	HKK-F 013	38	HKK-F 038
14	HKK-F 014	39	HKK-F 039
15	HKK-F 015	40	HKK-F 040
16	HKK-F 016	41	HKK-F 041
17	HKK-F 017	42	HKK-F 042
18	HKK-F 018	43	HKK-F 043
19	HKK-F 019	44	HKK-F 044
20	HKK-F 020	45	HKK-F 045
21	HKK-F 021	46	HKK-F 046
22	HKK-F 022	47	HKK-F 047
23	HKK-F 023	48	HKK-F 048
24	HKK-F 024	49	HKK-F 049
25	HKK-F 025	50	HKK-F 050
26	HKK-F 026	51	HKK-F 051
27	HKK-F 027	52	HKK-F 052
28	HKK-F 028	53	HKK-F 053
29	HKK-F 029	54	HKK-F 054
30	HKK-F 030	55	HKK-F 055
31	HKK-F 031	56	HKK-F 056
32	HKK-F 032	57	HKK-F 057
33	HKK-F 033	58	HKK-F 058
34	HKK-F 034	59	HKK-F 059
35	HKK-F 035	60	HKK-F 060
36	HKK-F 036		

Ejector pin for HSS-Co 8-F, Ø 12 - 60 mm

ZAK 075

Ejector pin for HKK-F, Ø 12 - 60 mm

ZAK 075

Order no. Article (suitable for all HSS-VarioPLUS)

ZHS 005 BDS 5000 Cutting oil (5 liters)

ZHS 006 BDS 5000 Cutting oil (1 liter)

ZHS 570 BDS 7500 Cutting paste, 85 g Tube



Order no. Article (suitable for all HSS-VarioPLUS)

ZHB 001 BDS 6000 Lubricant concentrate

ZHS 400 BDS 5200 Lub. spray 1 x 400 ml Can

ZHS 570 BDS 7500 Cutting paste, 85 g Tube



ANNULAR CUTTERS SERIES HSS-STANDARD

The standard Annular Cutter range for professional use. These fully-ground annular cutters are made from high-speed steel and manufactured on CNC-controlled grinding centers. They ensure good chip evacuation and effortless drilling. For horizontal applications, BDS recommends the BDS 5200 high-performance grease spray.

HSS-STANDARD ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	KBK 012	36	KBK 036
13	KBK 013	37	KBK 037
14	KBK 014	38	KBK 038
15	KBK 015	39	KBK 039
16	KBK 016	40	KBK 040
17	KBK 017	41	KBK 041
17.5	KBK 175	42	KBK 042
18	KBK 018	43	KBK 043
19	KBK 019	44	KBK 044
19.5	KBK 195	45	KBK 045
20	KBK 020	46	KBK 046
21	KBK 021	47	KBK 047
22	KBK 022	48	KBK 048
23	KBK 023	49	KBK 049
24	KBK 024	50	KBK 050
25	KBK 025	51	KBK 051
26	KBK 026	52	KBK 052
27	KBK 027	53	KBK 053
28	KBK 028	54	KBK 054
29	KBK 029	55	KBK 055
30	KBK 030	56	KBK 056
31	KBK 031	57	KBK 057
32	KBK 032	58	KBK 058
33	KBK 033	59	KBK 059
34	KBK 034	60	KBK 060
35	KBK 035		

Ejector pin for KBK, Ø 12 - 60 mm

ZAK 075

HSS-STANDARD ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	KBL 012	36	KBL 036
13	KBL 013	37	KBL 037
14	KBL 014	38	KBL 038
15	KBL 015	39	KBL 039
16	KBL 016	40	KBL 040
17	KBL 017	41	KBL 041
17.5	KBL 175	42	KBL 042
18	KBL 018	43	KBL 043
19	KBL 019	44	KBL 044
19.5	KBL 195	45	KBL 045
20	KBL 020	46	KBL 046
21	KBL 021	47	KBL 047
22	KBL 022	48	KBL 048
23	KBL 023	49	KBL 049
24	KBL 024	50	KBL 050
25	KBL 025	51	KBL 051
26	KBL 026	52	KBL 052
27	KBL 027	53	KBL 053
28	KBL 028	54	KBL 054
29	KBL 029	55	KBL 055
30	KBL 030	56	KBL 056
31	KBL 031	57	KBL 057
32	KBL 032	58	KBL 058
33	KBL 033	59	KBL 059
34	KBL 034	60	KBL 060
35	KBL 035		

Ejector pin for KBL, Ø 12 - 60 mm

ZAK 100

Recommended lubricants

Order no. Article (suitable for all HSS-CO 8 Annular Cutters)

ZHS 005 BDS 5000 Cutting oil (5 liters)

ZHS 006 BDS 5000 Cutting oil (1 liter)

ZHS 570 BDS 7500 Cutting paste, 85 g Tube



Order no. Article (suitable for all HSS-CO 8 Annular Cutters)

ZHS 400 BDS 5200 lubrication spray, 1 x 400 ml Can

ZHS 406 BDS 5200 lubrication spray, 6 x 400 ml Can

ZHS 412 BDS 5200 lubrication spray, 12 x 400 ml Can





Videos & documents

HSS-STANDARD ANNULAR CUTTER EXTRA LONG

- ▶ 110 mm Cutting depth
- ▶ 19 mm Weldon shank (3/4")



Ø mm	Order no.	Ø mm	Order no.
20	KEL 020	36	KEL 036
21	KEL 021	37	KEL 037
22	KEL 022	38	KEL 038
23	KEL 023	39	KEL 039
24	KEL 024	40	KEL 040
25	KEL 025	41	KEL 041
26	KEL 026	42	KEL 042
27	KEL 027	43	KEL 043
28	KEL 028	44	KEL 044
29	KEL 029	45	KEL 045
30	KEL 030	46	KEL 046
31	KEL 031	47	KEL 047
32	KEL 032	48	KEL 048
33	KEL 033	49	KEL 049
34	KEL 034	50	KEL 050
35	KEL 035		

HSS ANNULAR CUTTERS AVAILABLE IN INCH DIAMETERS

High-Quality Annular Cutter – Inch Sizes, 1 3/16" (30 mm) Cutting Depth. Designed for precise and efficient metal drilling, this robust annular cutter is made from high-performance steel, ensuring long tool life and clean cuts. Its compact length provides excellent control, even in confined spaces, making it ideal for professional use in both industry and trade.

HSS STANDARD ANNULAR CUTTER, SHORT, INCH

- ▶ 30 mm (≈ 1 3/16")
- ▶ 19 mm (3/4") Weldon shank



Ø Zoll	Ø mm	Order no.
1/2"	12.700	KBK-Z 1/2
9/16"	14.288	KBK-Z 9/16
5/8"	15.875	KBK-Z 5/8
11/16"	17.463	KBK-Z 11/16
3/4"	19.050	KBK-Z 3/4
13/16"	20.638	KBK-Z 13/16
7/8"	22.225	KBK-Z 7/8
15/16"	23.813	KBK-Z 15/16
1"	25.400	KBK-Z 1
1 1/16"	26.988	KBK-Z 1 1/16
1 1/8"	28.575	KBK-Z 1 1/8
1 3/16"	30.136	KBK-Z 1 3/16
1 1/4"	31.750	KBK-Z 1 1/4
1 5/16"	33.338	KBK-Z 1 5/16
1 3/8"	34.925	KBK-Z 1 3/8
1 7/16"	36.513	KBK-Z 1 7/16
1 1/2"	38.100	KBK-Z 1 1/2
1 9/16"	39.688	KBK-Z 1 9/16
1 5/8"	41.276	KBK-Z 1 5/8
1 11/16"	42.863	KBK-Z 1 11/16
1 3/4"	44.450	KBK-Z 1 3/4
1 13/16"	46.038	KBK-Z 1 13/16
1 7/8"	47.625	KBK-Z 1 7/8
1 15/16"	49.213	KBK-Z 1 15/16
2"	50.800	KBK-Z 2
2 1/16"	52.388	KBK-Z 2 1/16

Ejector pin for KEL, Ø 20 – 50 mm

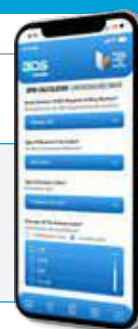
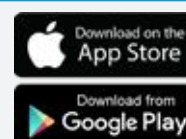
ZAK 275 2-part construction

Ejector pin for KBK-Z, Ø 1/2" – 2 1/16"

ZAK 075

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



SERIES CARBIDE TUNGSTEN CARBIDE TIPPED (TCT) ANNULAR CUTTERS

CARBIDE ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



CARBIDE ANNULAR CUTTER SHORT

- ▶ 30 mm Cutting depth
- ▶ 32 mm Weldon shank (1¼")



Ø mm	Order no.	Ø mm	Order no.
12	HKK 012	37	HKK 037
13	HKK 013	38	HKK 038
14	HKK 014	39	HKK 039
15	HKK 015	40	HKK 040
16	HKK 016	41	HKK 041
17	HKK 017	42	HKK 042
18	HKK 018	43	HKK 043
19	HKK 019	44	HKK 044
20	HKK 020	45	HKK 045
21	HKK 021	46	HKK 046
22	HKK 022	47	HKK 047
23	HKK 023	48	HKK 048
24	HKK 024	49	HKK 049
25	HKK 025	50	HKK 050
26	HKK 026	51	HKK 051
27	HKK 027	52	HKK 052
28	HKK 028	53	HKK 053
29	HKK 029	54	HKK 054
30	HKK 030	55	HKK 055
31	HKK 031	56	HKK 056
32	HKK 032	57	HKK 057
33	HKK 033	58	HKK 058
34	HKK 034	59	HKK 059
35	HKK 035	60	HKK 060
36	HKK 036		

Ejector pin for HKK, Ø 14 - 60 mm

ZAK 075

Ø mm	Order no.	Ø mm	Order no.
61	HKK 061	86	HKK 086
62	HKK 062	87	HKK 087
63	HKK 063	88	HKK 088
64	HKK 064	89	HKK 089
65	HKK 065	90	HKK 090
66	HKK 066	91	HKK 091
67	HKK 067	92	HKK 092
68	HKK 068	93	HKK 093
69	HKK 069	94	HKK 094
70	HKK 070	95	HKK 095
71	HKK 071	96	HKK 096
72	HKK 072	97	HKK 097
73	HKK 073	98	HKK 098
74	HKK 074	99	HKK 099
75	HKK 075	100	HKK 100
76	HKK 076	105	HKK 105
77	HKK 077	110	HKK 110
78	HKK 078	115	HKK 115
79	HKK 079	120	HKK 120
80	HKK 080	125	HKK 125
81	HKK 081	130	HKK 130
82	HKK 082	135	HKK 135
83	HKK 083	140	HKK 140
84	HKK 084	145	HKK 145
85	HKK 085	150	HKK 150

Ejector pin for HKK, Ø 61 - 150 mm

ZAK 090

Recommended lubricants

Order no. Article (suitable for all TCT Annular Cutters)

ZHB 001	BDS 6000 Lubricant concentrate
ZHS 550	BDS 5500 Cutting paste, 1000 g
ZHS 570	BDS 7500 Cutting paste, 85 g Tube



Order no. Article (suitable for all TCT Annular Cutters)

ZHS 400	BDS 5200 lubrication spray, 1 x 400 ml Can
ZHS 406	BDS 5200 lubrication spray, 6 x 400 ml Can
ZHS 412	BDS 5200 lubrication spray, 12 x 400 ml Can



Tungsten Carbide Tipped (TCT) Annular Cutters – High Performance for Tough Materials
Carbide annular cutters deliver exceptional cutting performance, enabling fast and efficient drilling through hard materials such as steel, stainless steel, and cast iron. Their extreme hardness and wear resistance ensure long-lasting sharpness, significantly extending tool life.



Videos & documents

CARBIDE ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



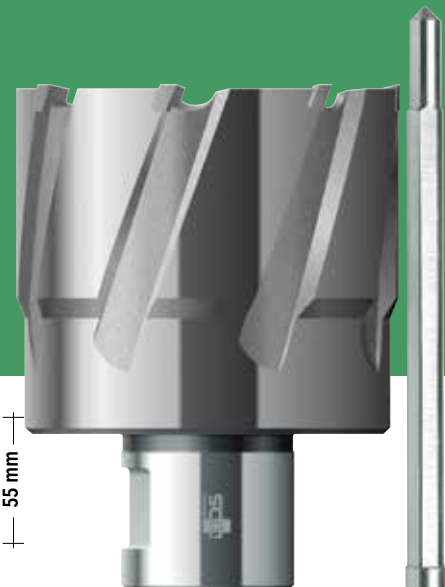
Ø mm	Order no.	Ø mm	Order no.
12	HKL 012	37	HKL 037
13	HKL 013	38	HKL 038
14	HKL 014	39	HKL 039
15	HKL 015	40	HKL 040
16	HKL 016	41	HKL 041
17	HKL 017	42	HKL 042
18	HKL 018	43	HKL 043
19	HKL 019	44	HKL 044
20	HKL 020	45	HKL 045
21	HKL 021	46	HKL 046
22	HKL 022	47	HKL 047
23	HKL 023	48	HKL 048
24	HKL 024	49	HKL 049
25	HKL 025	50	HKL 050
26	HKL 026	51	HKL 051
27	HKL 027	52	HKL 052
28	HKL 028	53	HKL 053
29	HKL 029	54	HKL 054
30	HKL 030	55	HKL 055
31	HKL 031	56	HKL 056
32	HKL 032	57	HKL 057
33	HKL 033	58	HKL 058
34	HKL 034	59	HKL 059
35	HKL 035	60	HKL 060
36	HKL 036		

Ejector pin for HKL, Ø 14 – 60 mm

ZAK 100

CARBIDE ANNULAR CUTTER LONG

- ▶ 55 mm Cutting depth
- ▶ 32 mm Weldon shank (1¼")



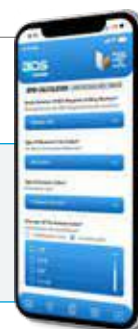
Ø mm	Order no.	Ø mm	Order no.
61	HKL 061	81	HKL 081
62	HKL 062	82	HKL 082
63	HKL 063	83	HKL 083
64	HKL 064	84	HKL 084
65	HKL 065	85	HKL 085
66	HKL 066	86	HKL 086
67	HKL 067	87	HKL 087
68	HKL 068	88	HKL 088
69	HKL 069	89	HKL 089
70	HKL 070	90	HKL 090
71	HKL 071	91	HKL 091
72	HKL 072	92	HKL 092
73	HKL 073	93	HKL 093
74	HKL 074	94	HKL 094
75	HKL 075	95	HKL 095
76	HKL 076	96	HKL 096
77	HKL 077	97	HKL 097
78	HKL 078	98	HKL 098
79	HKL 079	99	HKL 099
80	HKL 080	100	HKL 100

Ejector pin for HKL, Ø 61 – 100 mm

ZAK 120

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.



ANNULAR CUTTERS SERIES CARBIDE TUNGSTEN CARBIDE TIPPED (TCT)



Videos & documents

CARBIDE ANNULAR CUTTER LONG PLUS

- ▶ 75 mm Cutting depth
- ▶ up to Ø 60 mm: 19 mm Weldon shank (¾")
- ▶ from Ø 61 mm: 32 mm Weldon shank (1¼")



Ø mm	Order no.	Ø mm	Order no.
18	HKX-L 018	44	HKX-L 044
19	HKX-L 019	45	HKX-L 045
20	HKX-L 020	46	HKX-L 046
21	HKX-L 021	47	HKX-L 047
22	HKX-L 022	48	HKX-L 048
23	HKX-L 023	49	HKX-L 049
24	HKX-L 024	50	HKX-L 050
25	HKX-L 025	51	HKX-L 051
26	HKX-L 026	52	HKX-L 052
27	HKX-L 027	53	HKX-L 053
28	HKX-L 028	54	HKX-L 054
29	HKX-L 029	55	HKX-L 055
30	HKX-L 030	56	HKX-L 056
31	HKX-L 031	57	HKX-L 057
32	HKX-L 032	58	HKX-L 058
33	HKX-L 033	59	HKX-L 059
34	HKX-L 034	60	HKX-L 060
35	HKX-L 035	65	HKX-L 065
36	HKX-L 036	70	HKX-L 070
37	HKX-L 037	75	HKX-L 075
38	HKX-L 038	80	HKX-L 080
39	HKX-L 039	90	HKX-L 090
40	HKX-L 040	100	HKX-L 100
41	HKX-L 041	110	HKX-L 110
42	HKX-L 042	120	HKX-L 120
43	HKX-L 043		

CARBIDE ANNULAR CUTTER EXTRA LONG

- ▶ 110 mm Cutting depth
- ▶ up to Ø 60 mm: 19 mm Weldon shank (¾")
- ▶ from Ø 61 mm: 32 mm Weldon shank (1¼")



Ø mm	Order no.	Ø mm	Order no.
20	HKE-L 020	45	HKE-L 045
21	HKE-L 021	46	HKE-L 046
22	HKE-L 022	47	HKE-L 047
23	HKE-L 023	48	HKE-L 048
24	HKE-L 024	49	HKE-L 049
25	HKE-L 025	50	HKE-L 050
26	HKE-L 026	51	HKE-L 051
27	HKE-L 027	52	HKE-L 052
28	HKE-L 028	53	HKE-L 053
29	HKE-L 029	54	HKE-L 054
30	HKE-L 030	55	HKE-L 055
31	HKE-L 031	56	HKE-L 056
32	HKE-L 032	57	HKE-L 057
33	HKE-L 033	58	HKE-L 058
34	HKE-L 034	59	HKE-L 059
35	HKE-L 035	60	HKE-L 060
36	HKE-L 036	65	HKE-L 065
37	HKE-L 037	70	HKE-L 070
38	HKE-L 038	75	HKE-L 075
39	HKE-L 039	80	HKE-L 080
40	HKE-L 040	90	HKE-L 090
41	HKE-L 041	100	HKE-L 100
42	HKE-L 042	110	HKE-L 110
43	HKE-L 043	120	HKE-L 120
44	HKE-L 044		

Ejector pin for HKX-L, Ø 18 - 120 mm

ZAK 225 2-piece for Annular Cutter Cutting depth 75 mm Ø 19 - 60

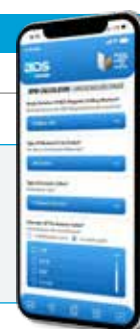
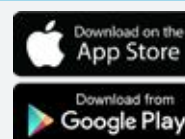
ZAK 245 2-piece for Annular Cutter Cutting depth 75 mm Ø 61 - 120

Ejector pin for HKE-L, Ø 20 - 120 mm

ZAK 275 2-part design

CUTTING SPEED CALCULATOR APP

The first and only app to calculate the optimal cutting speed for annular cutters and magnetic drilling machines.





Videos & documents



Videos & documents

CarbidePLUS ANNULAR CUTTER

TCT Annular Cutters with Premium Carbide Coating – High durability and precision for hard metals.

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
14	HKK-P 014	38	HKK-P 038
15	HKK-P 015	39	HKK-P 039
16	HKK-P 016	40	HKK-P 040
17	HKK-P 017	41	HKK-P 041
18	HKK-P 018	42	HKK-P 042
19	HKK-P 019	43	HKK-P 043
20	HKK-P 020	44	HKK-P 044
21	HKK-P 021	45	HKK-P 045
22	HKK-P 022	46	HKK-P 046
23	HKK-P 023	47	HKK-P 047
24	HKK-P 024	48	HKK-P 048
25	HKK-P 025	49	HKK-P 049
26	HKK-P 026	50	HKK-P 050
27	HKK-P 027	51	HKK-P 051
28	HKK-P 028	52	HKK-P 052
29	HKK-P 029	53	HKK-P 053
30	HKK-P 030	54	HKK-P 054
31	HKK-P 031	55	HKK-P 055
32	HKK-P 032	56	HKK-P 056
33	HKK-P 033	57	HKK-P 057
34	HKK-P 034	58	HKK-P 058
35	HKK-P 035	59	HKK-P 059
36	HKK-P 036	60	HKK-P 060
37	HKK-P 037		

Ejector pin for HKK-P, Ø 14 – 60 mm

ZAK 075

CarbideRAIL ANNULAR CUTTER

Special TCT Annular Cutters for Railway Track Drilling. Made with a higher grade of carbide for enhanced durability and performance in tough rail steel.

- ▶ 30 mm Cutting depth
- ▶ 19 mm Weldon shank (¾")



Ø mm	Order no.	Ø mm	Order no.
12	HKK-R 012	28	HKK-R 028
13	HKK-R 013	29	HKK-R 029
14	HKK-R 014	30	HKK-R 030
15	HKK-R 015	31	HKK-R 031
17	HKK-R 017	32	HKK-R 032
18	HKK-R 018	33	HKK-R 033
19	HKK-R 019	34	HKK-R 034
20	HKK-R 020	35	HKK-R 035
21	HKK-R 021	36	HKK-R 036
22	HKK-R 022	37	HKK-R 037
23	HKK-R 023	38	HKK-R 038
24	HKK-R 024	39	HKK-R 039
25	HKK-R 025	40	HKK-R 040
26	HKK-R 026	50	HKK-R 050
27	HKK-R 027		

Ejector pin for HKK-R, Ø 12 – 50 mm

ZAK 075

Recommended lubricants

Order no. Article (suitable for all CarbidePLUS & Rail)

ZHB 001 BDS 6000 Lubricant concentrate

ZHS 550 BDS 5500 Cutting paste, 1000 g

ZHS 570 BDS 7500 Cutting paste, 85 g Tube



Order no. Article (suitable for all CarbidePLUS & Rail)

ZHS 400 BDS 5200 lubrication spray, 1 x 400 ml Can

ZHS 406 BDS 5200 lubrication spray, 6 x 400 ml Can

ZHS 412 BDS 5200 lubrication spray, 12 x 400 ml Can



BDS ANNULAR CUTTER BOXES & CASSETTES

SIMPLY WELL SORTED!

Five BDS Annular Cutters in the most commonly used sizes in a compact box.

- ▶ Available in 30 mm and 55 mm cutting depth
- ▶ 19 mm Weldon shank ($\frac{3}{4}$ ")



HSS STANDARD ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK 014
BOX1	2 x KBK 018
	1 x KBK 022

HSS STANDARD ANNULAR CUTTER LONG



Order no. Content

KBL	2 x KBL 014
BOX1	2 x KBL 018
	1 x KBL 022

HSS VARIOPLUS ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK-VP 014
BOX1-V	2 x KBK-VP 018
	1 x KBK-VP 022

HSS VARIOPLUS ANNULAR CUTTER LONG



Order no. Content

KBL	2 x KBL-VP 014
BOX1-V	2 x KBL-VP 018
	1 x KBL-VP 022

HSS COBALT 8% ANNULAR CUTTER SHORT



Order no. Content

KBK	2 x KBK-CO 014
BOX1-CO	2 x KBK-CO 018
	1 x KBK-CO 022

CARBIDE (TCT) ANNULAR CUTTER SHORT



Order no. Content

HKK	2 x HKK 014
BOX	2 x HKK 018
	1 x HKK 022

BDS ANNULAR CUTTER CASSETTES

6 ANNULAR CUTTERS PLUS EJECTOR PIN

Six BDS Annular Cutters in the most commonly used sizes in a sturdy cassette.

- ▶ High Speed Steel
- ▶ 30 mm cutting depth
- ▶ 19 mm Weldon shank ($\frac{3}{4}$ ")
- ▶ Suitable ejector pin
- ▶ Premium quality cassette

HSS COBALT 8% ANNULAR CUTTER



Order no. Content

KBK-CO 001	2 x KBK-CO 014
	2 x KBK-CO 018
	2 x KBK-CO 022
	1 x ZAK 075

KBK-CO 002	1 x KBK-CO 013
	1 x KBK-CO 014
	1 x KBK-CO 017
	1 x KBK-CO 018
	1 x KBK-CO 021
	1 x KBK-CO 022
	1 x ZAK 075

HSS VARIOPLUS ANNULAR CUTTER



Order no. Content

KBK 001	2 x KBK 014
	2 x KBK 018
	2 x KBK 022
	1 x ZAK 075

KBK 002	1 x KBK 013
	1 x KBK 014
	1 x KBK 017
	1 x KBK 018
	1 x KBK 021
	1 x KBK 022
	1 x ZAK 075

HSS STANDARD ANNULAR CUTTER



Order no. Content

KBK-VP 001	2 x KBK-VP 014
	2 x KBK-VP 018
	2 x KBK-VP 022
	1 x ZAK 075

KBK-VP 002	1 x KBK-VP 013
	1 x KBK-VP 014
	1 x KBK-VP 017
	1 x KBK-VP 018
	1 x KBK-VP 021
	1 x KBK-VP 022
	1 x ZAK 075

