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PUNCHING



DRILLING



CUTTING



DEBURRING

**2. REVISED
EDITION**

QUALITY TOOLS AND MACHINES

100

PART B



WELCOME!

We take pride in our achievement - over 60% in-house manufacturing in four locations in Germany and a further 35.000 m² production facility in France. From our home town in the motorcar race city of Hockenheim, we ship our products on a regular basis to over 120 countries around the world. Our network of agents ensures that practically anybody - really anybody - can use our high-quality products and benefit from their various advantages.

What do we do at ALFRA? - To put it simple: We make holes!

This means, that we manufacture and sell implements, machines and tools for punching and drilling. These are mainly intended for applications in the field of metal-working, with material thickness ranging from 0.8 to more than 100 mm.

On top of that, our product range includes many supplementary items, e.g. in the field of cutting and deburring technology, etc.

Come and test us - we look forward to seeing you among our many satisfied customers.

Made in Germany - Made by ALFRA

Don't be satisfied with less!

Get our latest news from **www.alfra.de**.

Visit our new YouTube channel,

www.youtube.com/alfratools,

for the latest product and application videos.

Simply scan this QR code with your smartphone or tablet:



Made in Germany

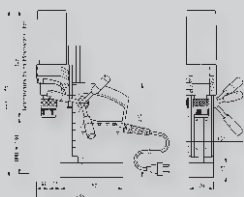
JOIN US IN PROMOTING "MADE IN GERMANY", FOR REASONS WHICH ARE TODAY EVEN MORE IMPORTANT AND VALID THAN EVER BEFORE:

- JOB SECURITY
- PROMOTION OF JOB TRAINING
- COMMUNICATION
- QUALITY MANAGEMENT
- ENVIRONMENTAL AWARENESS
- SAFEGUARDING THE FUTURE





Metal Core Drilling Machines
Pages B/4 - B/19



Dimensions
Pages B/20 - B/21



Accessories – Arbor
Pages B/22 - B/23



Accessories – Counterbore/Coolant
Page B/24



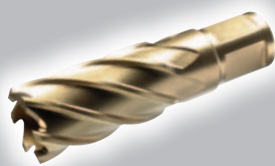
Accessories – Tapping attachment/Drill Bits
Page B/25



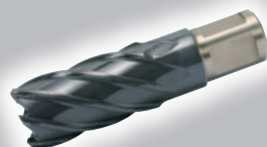
Accessories – Chip remover/Pipe Clamp/Vacuum Plate
Pages B/26 - B/27



Cutters - HSS-Basic
Pages B/28 - B/31



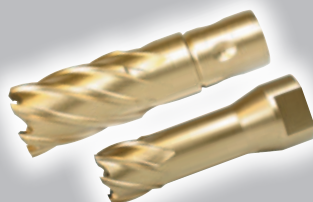
Cutters - HSS-Co-Eco
Pages B/32 - B/33



Cutters - HSS-Co RQX
Pages B/34 - B/35



Cutters ASP-30 Rail
Page B/36



Cutters - HSS-Co Eco Suitable for FEIN + Hitachi
Page B/37



HSS Twist Drills with Weldon Shank
Page B/38



Cutters - TCT Weldon
Pages B/39 - B/40



**Cutters - TCT AL
Cutters - Rail TCT**
Pages B/41 - B/42



Cutters - TCT suitable for FEIN + Hitachi
Page B/43



**RotaSpeed® - Metal Cutting Saw
RotaCut® - Mobile Band Saw Machine**
Pages B/44 - B/55



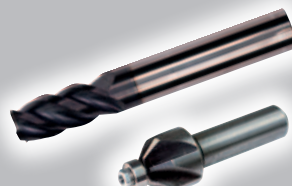
Hydraulic Punching Units, Single and Double Acting
Pages B/56 - B/62



Hydraulic Pumps
Pages B/58 - B/59 + B/61 - B/62



**Deburring Machines/
Bevel milling machines**
Pages B/67 - B/89



Milling Cutters
Pages B/82 - B/83



Deburring Machine SKS-15 Auto
Pages B/88 - B/89



HSS-Bi-Metal- and TCT-Hole Saws
Pages B/90 - B/107



**Multi-Step Drills
Precision Conical One-Lip Bits**
Pages B/108 - B/112



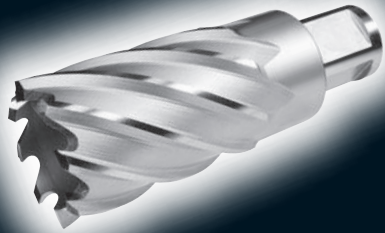
**Astroflex® Sabre Saw Blades
Sabre Saw and Jigsaw Blades**
Pages B/113 - B/116

Metal Core Drilling with

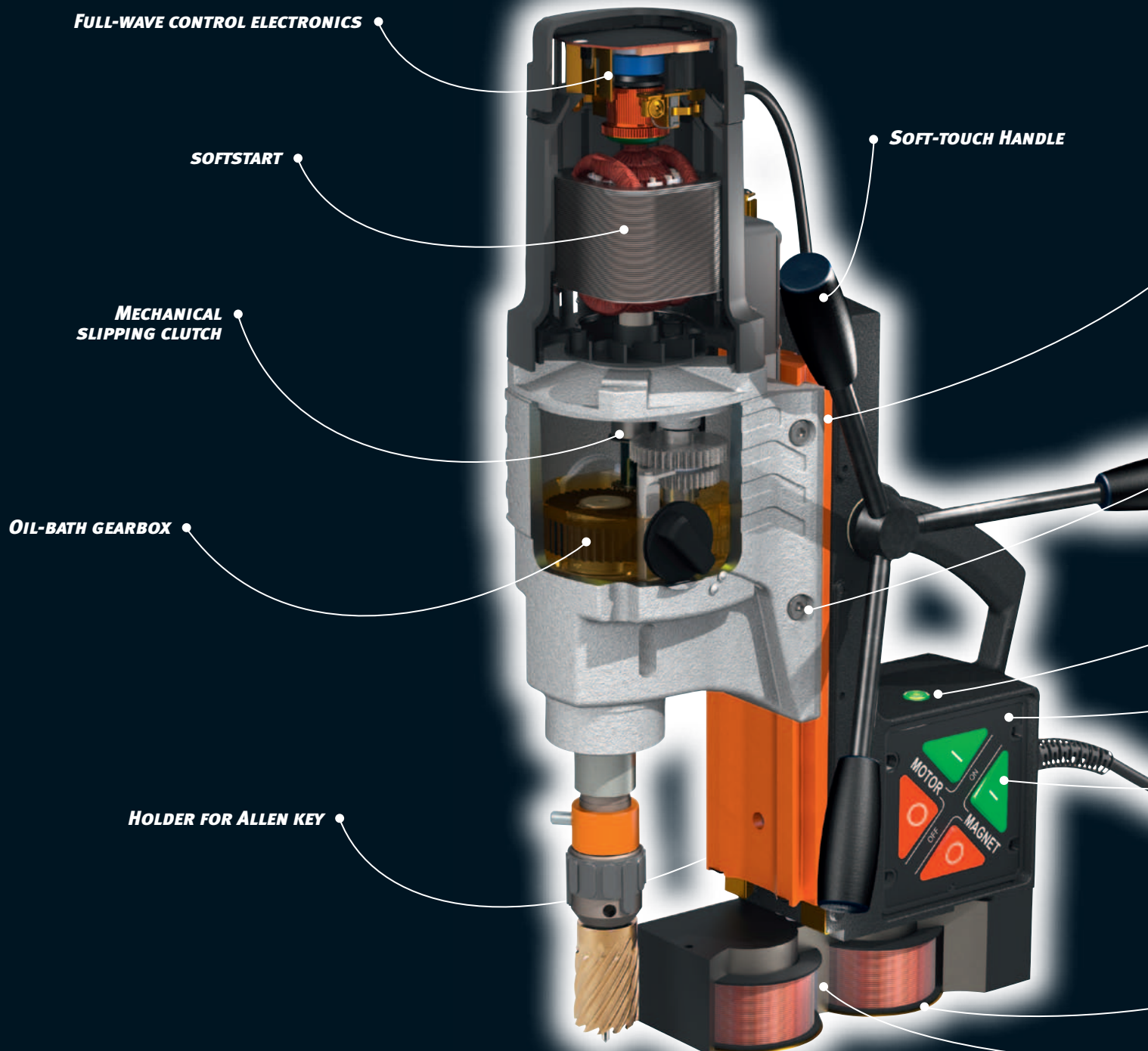


ALFRA ROTABEST®





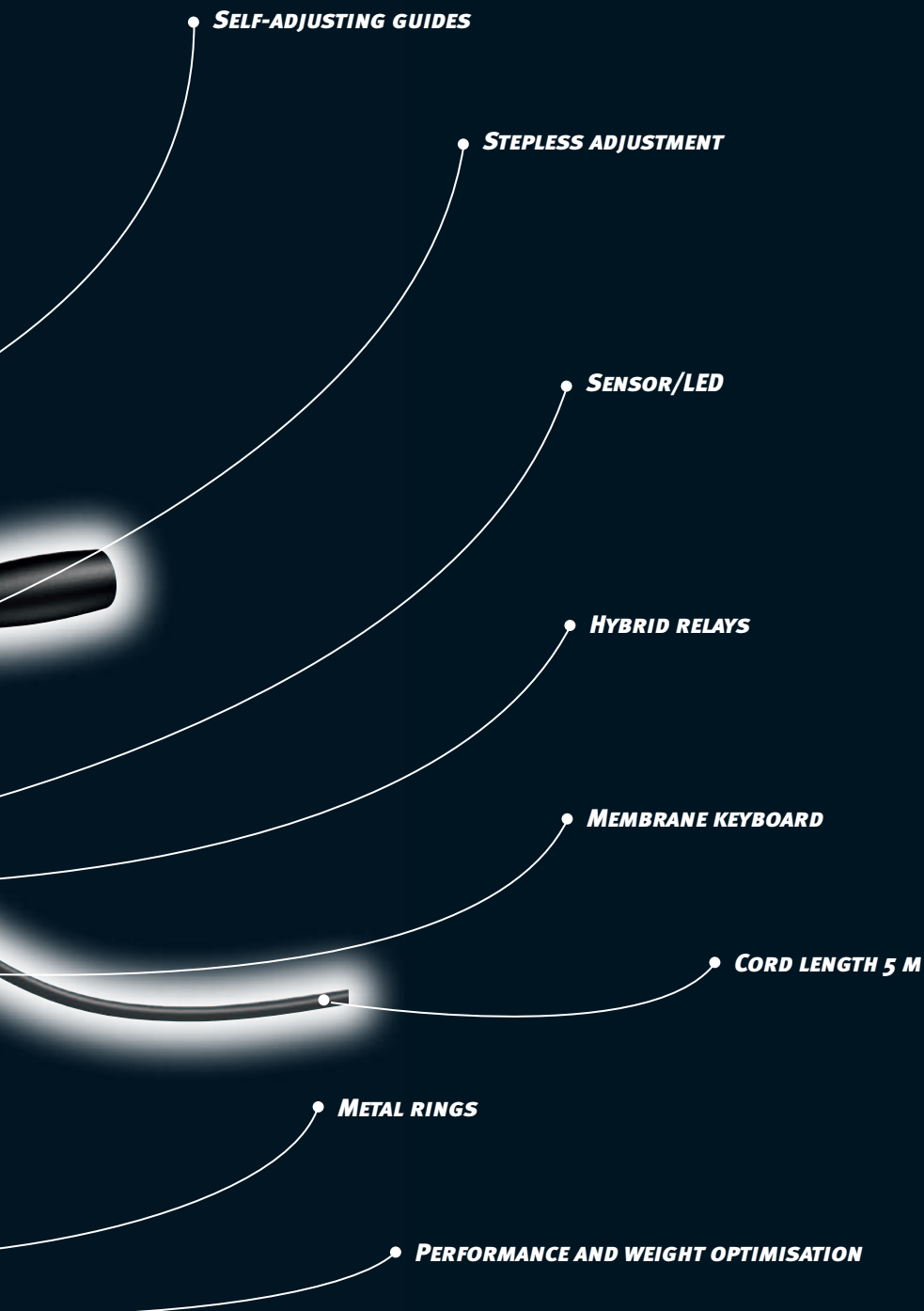
Metal Core Drilling with **ALFRA ROTABEST®**



PERFORMANCE GLOSSARY

Motor	
Smooth start	Minimises wear of motor, gearbox and electronics.
Hybrid relays	Drastically reduces contact burning on the relays. The life of the switching elements is significantly increased. Voltage fluctuations are reduced by approx. 10%.
Full-wave control electronics	Allow maximum power output from the motor.
Right/left run	Extends the range of application.

Gearbox	
Oil-bath gearbox	Reduces wear on the gearbox significantly, even under extreme conditions.
Mechanical slipping clutch	Protects the gearbox from overload and comes into action automatically.
Slide	
Stepless adjustment	The stroke can be increased continuously.
Self-adjusting guides	Self-locking comes into action automatically for perfect guiding.



Operation	
Soft-touch grips	Perfect "grip" on the handles - even with oily gloves.
Membrane keyboard	Perfect ergonomics with large keys. The entire keyboard is located in a protected area (even if the machine dops).
Holder for Allen key	Integrated Allen key-holder. No searching for the key.
Cord length 5 m	Extension cord and cable drums mostly not required.

Magnet	
Sensor/LED	Is there sufficient magnetic material under the drill? Are you pressing too hard, or is the tool blunt? Various LED displays on states of switching protect you and your machine.
Metal rings	Perfect protection for the magnets against penetration by metallic objects (chips, welding sputter, milling dust, etc...)
Performance and weight optimisation	Weight, dimensioning and coil sizing are ideally matched. This maximises the ToolForce (TM).
	



ALFRA ROTABEST® METAL CORE DRILLING MACHINES – OVERVIEW



RB 35 X



PICCOLO 35/50 X



RB 50 X



40 RL-E

Page	B/10		B/11		B/12		B/13		
Prod.-No.	230 V: 18700	110 V: 18700.110	230 V: 18701	110 V: 18701.110	230 V: 18750	110 V: 18750.110	230 V: 18611	110 V: 18611.110	
Cutter dimension	Ø 12.0 - 35.0 mm		Ø 12.0 - 35.0 mm		Ø 12.0 - 50.0 mm		Ø 12.0 - 50.0 mm		
Cutting depth	50.0 mm		50.0 mm		50.0 mm		50.0 mm		
Twist drill	Ø 1.0 - 13.0 mm DIN 1897 short		Ø 1.0 - 13.0 mm DIN 338		Ø 1.0 to 16.0 mm with MT 2 quick-release chuck to Ø 20.0 mm with MT 2 DIN 345 direct		Ø 1.0 to 16.0 mm with MT 2 quick-release chuck to Ø 20.0 mm with MT 2 DIN 345 direct		
Counterbore	Ø 10.0 - 40.0 mm		Ø 10.0 - 40.0 mm		Ø 10.0 - 40.0 mm		Ø 10.0 - 40.0 mm		
Tapping	-		-		with tapping attachment: M3 - M20		with tapping chuck: M3 - M14 with tapping attachment: M3 - M20		
Arbor	19 mm Weldon shank		19 mm Weldon shank		MT2		MT 2		
Stroke	120 mm		129 mm		190 mm		170 mm		
Height adjustment	-		86 mm		100 mm		100 mm		
Gearbox – on-load speed	450 rpm.		450 rpm.		1. Gear 250 rpm. 2. Gear 450 rpm.		Right/left 1. Gear 100 - 250 rpm. 2. Gear 180 - 450 rpm.		
Power consumption	1.100 W		1.100 W		1.200 W		1.200 W		
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		
Tool Force (10 mm) / magnetic holding force	2.100 N / 9.000 N		2.100 N / 9.000 N		3.500 N / 11.000 N		3.800 N / 16.000 N		
Min. Material Thickness	6 mm		6 mm		8 mm		10 mm		
Magnet foot	70 x 185 mm		70 x 185 mm		92 x 220 mm		80 x 230 mm		
Weight	10.6 kg		12 kg		15.0 kg		16.0 kg		

Motor

Smooth start	✓	✓	✓	✓
Hybrid relays	✓	✓	✓	-
Full-wave control electronics	-	-	-	✓
Right/left run	-	-	-	✓

Gearbox

Oil-bath gearbox	-	-	✓	✓
Mechanical slipping clutch	-	-	-	✓

Slide

Stepless adjustment	-	✓	✓	✓
Self-adjusting guides	✓	✓	✓	-

Operation

Soft-touch grips	✓	✓	✓	✓
Membrane keyboard	✓	✓	✓	✓
Holder for Allen key	✓	✓	✓	-
Cord length 5 m	✓	✓	✓	✓

Magnet

Sensor/LED	✓	✓	✓	-
Metal rings	✓	✓	✓	✓
Performance and weight optimisation	✓	✓	✓	-
MADE IN GERMANY	✓	✓	✓	✓


RB 80 X

60 RL-E

100 RL-E

130

V 32

B/14		B/15		B/16		B/18		B/17	
230 V: 18780	110 V: 18780.110	230 V: 18626	110 V: 18626.110	230 V: 18634	110 V: 18634.110	230 V: 18645	110 V: 18645.110	230 V: 18710	110 V: 18710.110
Ø 12.0 - 80.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)		Ø 12.0 - 80.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)		Ø 12.0 - 100.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)		Ø 12.0 - 130.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)		Ø 12.0 - 32.0 mm	
50.0 mm / 110.0 mm		50.0 mm / 110.0 mm		50.0 mm / 110.0 mm		50.0 mm / 110.0 mm		25.0 mm	
Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345		Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345		Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345		to Ø 45.0 mm with MT 4 DIN 345		-	
Ø 10.0 - 55.0 mm		Ø 10.0 - 55.0 mm		Ø 10.0 - 55.0 mm		Ø 10.0 - 80.0 mm		Ø 10.0 - 32.0 mm	
with tapping attachment: to M30		with tapping chuck: to M30 with tapping attachment: to M30		with tapping chuck: to M30 with tapping attachment: to M30		with tapping attachment: to M42		-	
MT3		MT 3		MT 3		MT 4		19 mm Weldon	
190 mm		190 mm		245 mm		230 mm		-	
100 mm		60 mm		116 mm		100 mm		-	
1. Gear	110 rpm.	right/left		right/left		1. Gear	30 - 80 rpm.	450 rpm.	
2. Gear	175 rpm.	1. Gear	50 - 110 rpm.	1. Gear	50 - 110 rpm.	2. Gear	50 - 120 rpm.		
3. Gear	245 rpm.	2. Gear	75 - 175 rpm.	2. Gear	75 - 175 rpm.	3. Gear	130 - 350 rpm.		
4. Gear	385 rpm.	3. Gear	105 - 245 rpm.	3. Gear	105 - 245 rpm.	4. Gear	210 - 550 rpm.		
1.800 W		1.800 W		2.500 W (230 V) 2.400 W (110 V)		2.500 W		900 W	
230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz		230 V 50/60 Hz / 110 V 50/60 Hz	
4.000 N / 13.000 N		4.200 N / 20.000 N		4.000 N / 20.000 N		5.000 N / 32.000 N		- / 16.000 N	
10 mm		10 mm		10 mm		10 mm		6 mm	
92 x 220 mm		80 x 230 mm, 30° adjustable, right and left, 10 mm front and rear		80 x 230 mm, 30° adjustable, right and left, 10 mm front and rear		90 x 400 mm		95 x 200 mm	
19.5 kg		22.0 kg		28.0 kg		34.5 kg		12.5 kg	

✓	-	-	-	Compact, horizontal
✓	-	-	-	
-	✓	✓	-	
-	✓	✓	-	
✓	✓	✓	✓	Compact mitre gear
✓	✓	✓	✓	
✓	✓	✓	-	2-sided pillar guidance
✓	-	-	-	
✓	✓	✓	✓	Space-saving – via ratchet
✓	✓	✓	✓	
✓	-	-	-	
✓	✓	✓	✓	
✓	-	-	-	-
✓	✓	✓	✓	✓
✓	-	-	-	✓
✓	✓	✓	✓	✓



ALFRA ROTABEST®-RB35X

35
mm



DRILLING RANGE UP TO Ø 35 MM

RB 35 X

Cutter dimension	Ø 12.0 - 35.0 mm
Cutting depth	50.0 mm
Twist drill	Ø 1.0 - 13.0 mm DIN 1897 short
Counterbore	Ø 10.0 - 40.0 mm
Tapping	-
Arbor	19 mm Weldon shank
Stroke	120 mm
Height adjustment	-
1-speed gearbox On-load speed	450 rpm.
Power consumption	1.100 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	2.100 N / 9.000 N
Magnet foot	70 x 185 mm
Weight	10.6 kg

Motor	
Smooth start	✓
Hybrid relays	✓
Slide	
Self-adjusting guides	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Holder for Allen key	✓
Cord length 5 m	✓
Magnet	
Sensor/LED	✓
Metal rings	✓
Performance and weight optimisation	✓
	✓



Scope of Supply:

- Metal core drilling machine RB 35 x
- Carrying case
- Safety belt
- Coolant equipment
- Operating manual

Prod.-No.

ALFRA Rotabest® RB 35 X	230 Volt	18700
ALFRA Rotabest® RB 35 X	110 Volt	18700.110



ALFRA ROTABEST® – PICCOLO 35/50 X



35
mm

DRILLING RANGE UP TO Ø 35 MM



PICCOLO 35/50 X

Cutter dimension	Ø 12.0 - 35.0 mm
Cutting depth	50.0 mm
Twist drill	Ø 1.0 - 13.0 mm DIN 338
Counterbore	Ø 10.0 - 40.0 mm
Tapping	-
Arbor	19 mm Weldon shank
Stroke	129 mm
Height adjustment	86 mm
1-speed gearbox On-load speed	450 rpm.
Power consumption	1.100 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	2.100 N / 9.000 N
Magnet foot	70 x 185 mm
Weight	12 kg

Motor	
Smooth start	✓
Hybrid relays	✓
Slide	
Stepless adjustment	✓
Self-adjusting guides	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Holder for Allen key	✓
Cord length 5 m	✓
Magnet	
Sensor/LED	✓
Metal rings	✓
Performance and weight optimisation	✓
	✓

Scope of Supply:

- Metal core drilling machine Piccolo 35/50 X
- Carrying case
- Safety belt
- Coolant equipment
- Operating manual

Prod.-No.

ALFRA Rotabest® Piccolo 35/50 X	230 Volt	18701
ALFRA Rotabest® Piccolo 35/50 X	110 Volt	18701.110



ALFRA ROTABEST®-RB 50 X

50
mm



DRILLING RANGE UP TO Ø 50 MM

RB 50 X

Cutter dimension dimension	Ø 12.0 - 50.0 mm
Cutting depth	50.0 mm
Twist drill	Ø 1.0 to 16.0 mm with MT 2 quick-release chuck to Ø 20.0 mm with MT 2 DIN 345 direct
Counterbore	Ø 10.0 - 40.0 mm
Tapping	with tapping attachment: M3 - M20
Arbor	MT2
Stroke	190 mm
Height adjustment	100 mm
2-speed gearbox On-load speed	1. Gear 250 rpm. 2. Gear 450 rpm.
Power consumption	1.200 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	3.500 N / 11.000 N
Magnet foot	92 x 220 mm
Weight	15.0 kg

Motor	
Smooth start	✓
Hybrid relays	✓
Gearbox	
Oil-bath gearbox	✓
Slide	
Stepless adjustment	✓
Self-adjusting guides	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Holder for Allen key	✓
Cord length 5 m	✓
Magnet	
Sensor/LED	✓
Metal rings	✓
Performance and weight optimisation	✓
	✓



Scope of Supply:

- Metal core drilling machine RB 50 x
- MT 2 tool holder with no internal cooling (Prod.-No. 18001)
- Carrying case
- Drilling spray
- Safety belt
- Operating manual

Prod.-No.

ALFRA Rotabest® RB 50 X	230 Volt	18750
ALFRA Rotabest® RB 50 X	110 Volt	18750.110

Accessories:

Coolant container	189412029
Tool holder AMT 2 with internal cooling	18003



ALFRA ROTABEST®-40 RL-E



50
mm

DRILLING RANGE UP TO Ø 50 MM



Scope of Supply:

- Metal core drilling machine 40 RL-E
- Carrying case
- Coolant equipment
- Drilling spray
- Quick-release chuck, 1 to 16 mm, MT 2
- Chip hook
- Safety belt
- Operating manual

40 RL-E

Cutter dimension	Ø 12.0 - 50.0 mm
Cutting depth	50.0 mm
Twist drill	Ø 1.0 to 16.0 mm with MT 2 quick-release chuck to Ø 20.0 mm with MT 2 DIN 345 direct
Counterbore	Ø 10.0 - 40.0 mm
Tapping	with tapping chuck: M3 - M14 with tapping attachment: M3 - M20
Arbor	MT 2
Stroke	170 mm
Height adjustment	100 mm
2-speed gearbox	right/left 1. Gear 100 - 250 rpm. 2. Gear 180 - 450 rpm.
Power consumption	1.200 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	3.800 N / 16.000 N
Magnet foot	80 x 230 mm
Weight	16.0 kg

Motor	
Smooth start	✓
Full-wave control electronics	✓
Right/left run	✓
Gearbox	
Oil-bath gearbox	✓
Mechanical slipping clutch	✓
Slide	
Stepless adjustment	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Cord length 5 m	✓
Magnet	
Metal rings	✓
	✓

Prod.-No.

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



ALFRA ROTABEST®-RB 80 X

80
mm

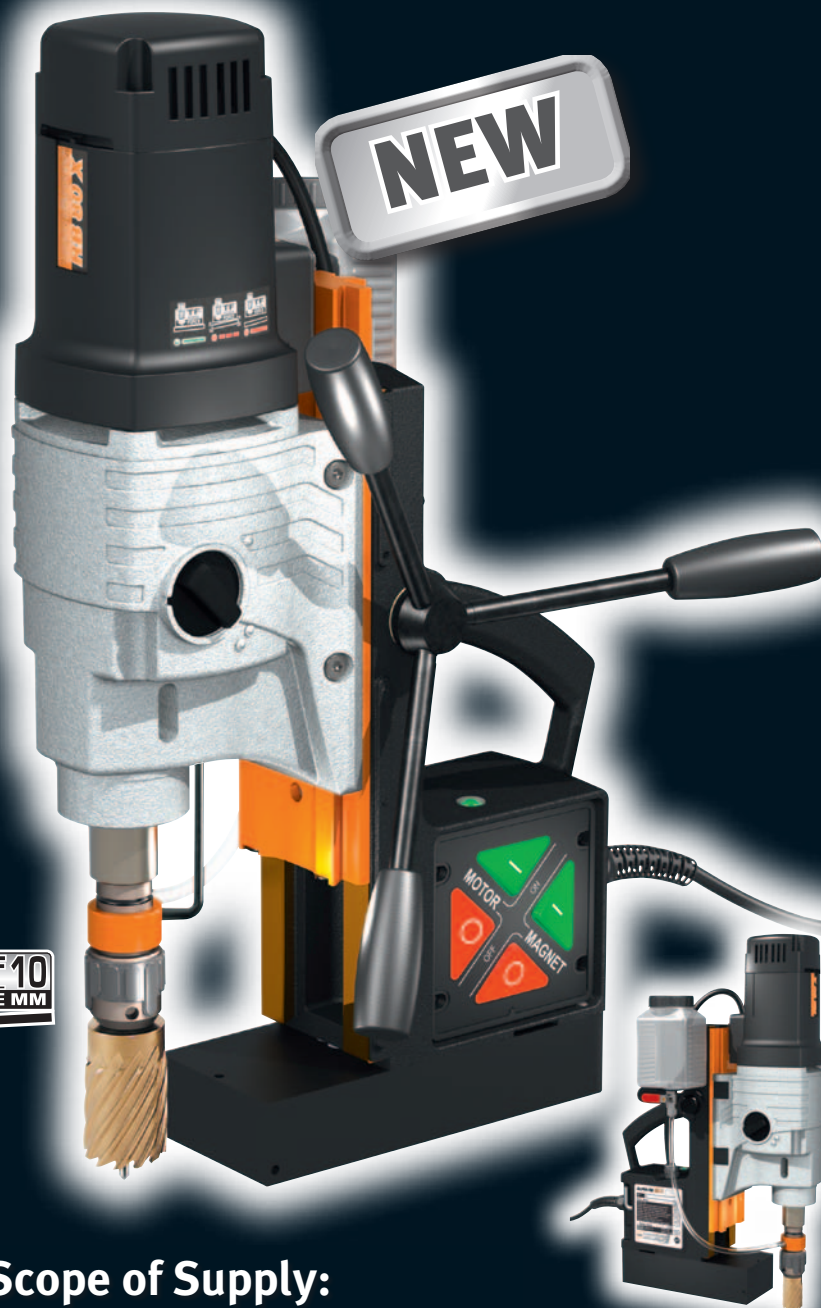


DRILLING RANGE UP TO Ø 80 MM

RB 80 X

Cutter dimension	Ø 12.0 - 80.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)
Cutting depth	50.0 mm / 110.0 mm
Twist drill	Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345
Counterbore	Ø 10 - 55.0 mm
Tapping	with tapping attachment: to M30
Arbor	MT3
Stroke	190 mm
Height adjustment	100 mm
4-speed gearbox On-load speed	1. Gear 110 rpm. 2. Gear 175 rpm. 3. Gear 245 rpm. 4. Gear 385 rpm.
Power consumption	1.800 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	4.000 N / 13.000 N
Magnet foot	92 x 220 mm
Weight	19.5 kg

Motor	
Smooth start	✓
Hybrid relays	✓
Gearbox	
Oil-bath gearbox	✓
Mechanical slipping clutch	✓
Slide	
Stepless adjustment	✓
Self-adjusting guides	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Holder for Allen key	✓
Cord length 5 m	✓
Magnet	
Sensor/LED	✓
Metal rings	✓
Performance and weight optimisation	✓
	✓



Scope of Supply:

- Metal core drilling machine RB 80 x
- AMT 3 tool holder with no internal cooling (Prod.-No. 18002)
- Carrying case
- Drilling spray
- Safety belt
- Operating manual

Prod.-No.

ALFRA Rotabest® RB 80 X	230 Volt	18780
ALFRA Rotabest® RB 80 X	110 Volt	18780.110

Accessories:

Coolant container	189412029
Tool holder AMT 3 with internal cooling	18025



ALFRA ROTABEST®-60 RL-E



80
mm

DRILLING RANGE UP TO Ø 80 MM



Scope of Supply:

- Metal core drilling machine 60 RL-E
- Carrying case
- Coolant equipment
- Drilling spray
- Quick-release chuck, 1 to 16 mm, MT 3
- Chip hook
- Safety belt
- Operating manual

60 RL-E

Cutter dimension	Ø 12.0 - 80.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)
Cutting depth	50.0 mm / 110.0 mm
Twist drill	Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345
Counterbore	Ø 10 - 55.0 mm
Tapping	with tapping chuck: to M30 with tapping attachment: to M30
Arbor	MT 3
Stroke	190 mm
Height adjustment	60 mm
4-speed gearbox	right/left 1. Gear 50 - 110 rpm. 2. Gear 75 - 175 rpm. 3. Gear 105 - 245 rpm. 4. Gear 165 - 385 rpm.
Power consumption	1.800 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	4.200 N / 20.000 N
Magnet foot	80 x 230 mm, 30° adjustable, right and left, 10 mm front and rear
Weight	22.0 kg

Motor	
Full-wave control electronics	✓
Right/left run	✓
Gearbox	
Oil-bath gearbox	✓
Mechanical slipping clutch	✓
Slide	
Stepless adjustment	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Cord length 5 m	✓
Magnet	
Metal rings	✓
	✓

Prod.-No.

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



ALFRA ROTABEST®-100 RL-E

100
mm



DRILLING RANGE UP TO Ø 100 MM

100 RL-E

Cutter dimension	Ø 12.0 - 100.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)
Cutting depth	50.0 mm / 110.0 mm
Twist drill	Ø 1.0 - 16.0 mm with chuck to Ø 32.0 mm with MT 3 DIN 345
Counterbore	Ø 10.0 - 55.0 mm
Tapping	with tapping chuck: to M30 with tapping attachment: to M30
Arbor	MT 3
Stroke	245 mm
Height adjustment	116 mm
4-speed gearbox	right/left 1. Gear 50 - 110 rpm. 2. Gear 75 - 175 rpm. 3. Gear 105 - 245 rpm. 4. Gear 165 - 385 rpm.
Power consumption	2.500 W (230 V) 2.400 W (110 V)
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	4.000 N / 20.000 N
Magnet foot	80 x 230 mm, 30° adjustable, right and left, 10 mm front and rear
Weight	28.0 kg

Motor

Full-wave control electronics	✓
Right/left run	✓

Gearbox

Oil-bath gearbox	✓
Mechanical slipping clutch	✓

Slide

Stepless adjustment	✓
---------------------	---

Operation

Soft-touch grips	✓
Membrane keyboard	✓
Cord length 5 m	✓

Magnet

Metal rings	✓
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Scope of Supply:

- Metal core drilling machine 100 RL-E
- Carrying case
- Coolant equipment
- Chip hook
- Safety belt
- Drilling spray
- Quick-release chuck

Prod.-No.

ALFRA Rotabest® 100 RL-E
ALFRA Rotabest® 100 RL-E

230 Volt
110 Volt

18634
18634.110



ALFRA ROTABEST®-V32



32
mm

DRILLING RANGE UP TO Ø 32 MM



V32

Core drill	Ø 12.0 - 32.0 mm
Cutting depth	25.0 mm
Counterbore	Ø 10.0 - 32.0 mm
Arbor	19 mm Weldon
1-speed gearbox	450 rpm.
Power consumption	900 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	- / 16.000 N
Magnet foot	95 x 200 mm
Weight	12.5 kg

Motor	
Compact, horizontal	
Gearbox	
Compact mitre gear	
Slide	
2-sided pillar guidance	
Operation	
Space-saving – via ratchet	
Cord length 5 m	✓
Magnet	
Metal rings	✓
Performance and weight optimisation	✓
	✓

Scope of Supply:

- Metal core drilling machine V 32
- Coolant pressure flask
- Carrying case
- Allen key for Weldon shank
- Safety belt
- HSS Co cutter Ø 18 mm, cutting depth 25 mm
- Ejector pin 6.35 x 74 mm (specially for Rotabest® V32)
- Operating manual

Prod.-No.

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



ALFRA ROTABEST®-130

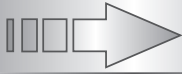
130
mm



DRILLING RANGE UP TO Ø 130 MM



SICHERHEITSHINWEISE
SAFETY ADVICE
CONSIGLIERE DI SICUREZZA
PAIS DE SÉCURITÉ



130
mm

DRILLING RANGE UP TO Ø 130 MM



Scope of Supply:

- Metal core drilling machine 130
- Carrying case
- Coolant container
- Chip hook
- Safety belt
- Operating manual

130

Cutter dimension	Ø 12.0 - 130.0 mm / Ø 20.0 - 50.0 mm (extra long 110 mm)
Cutting depth	50.0 mm / 110.0 mm
Twist drill	to Ø 45.0 mm with MT 4 DIN 345
Counterbore	Ø 10.0 - 80.0 mm
Tapping	with tapping attachment: To M42
Arbor	MT 4
Stroke	230 mm
Height adjustment	100 mm
4-speed gearbox	1. Gear 30 - 80 rpm. 2. Gear 50 - 120 rpm. 3. Gear 130 - 350 rpm. 4. Gear 210 - 550 rpm.
Power consumption	2,500 W
Voltage	230 V 50/60 Hz / 110 V 50/60 Hz
Tool Force (10 mm) / magnetic holding force	5,000 N / 32,000 N
Magnet foot	90 x 400 mm
Weight	34.5 kg

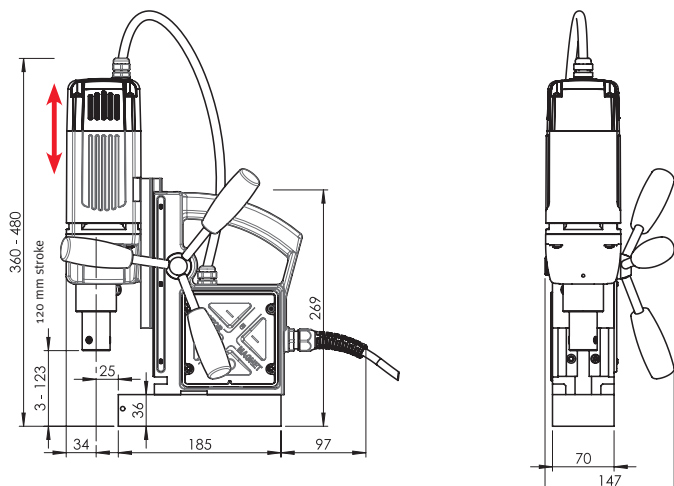
Gearbox	
Oil-bath gearbox	✓
Mechanical slipping clutch	✓
Operation	
Soft-touch grips	✓
Membrane keyboard	✓
Cord length 5 m	✓
Magnet	
Metal rings	✓
	✓

Prod.-No.

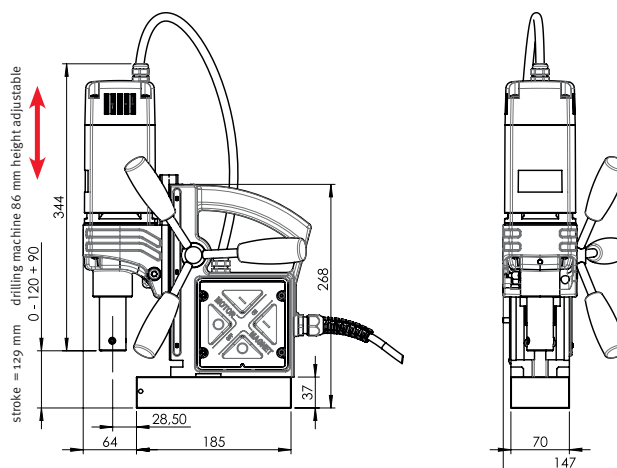
ALFRA Rotabest® 130	230 Volt	18645
ALFRA Rotabest® 130	110 Volt	18645.110



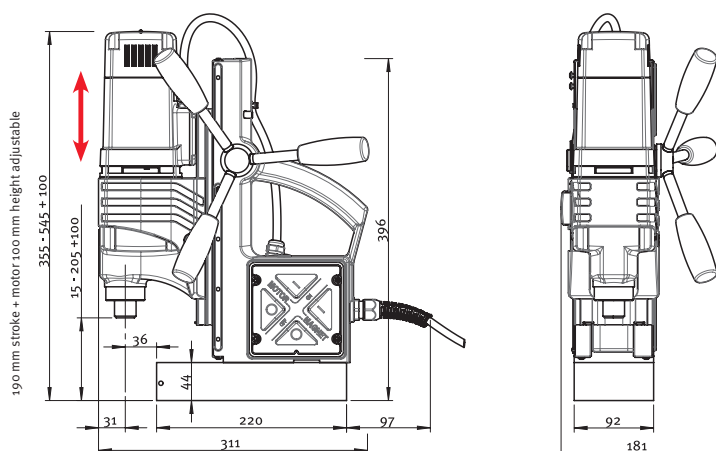
RB 35 X



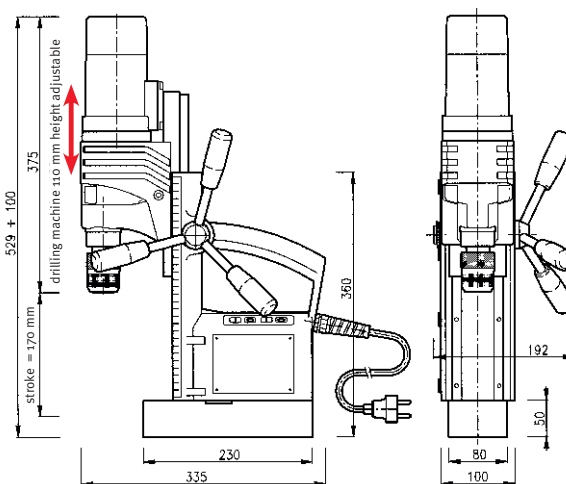
Piccolo 35/50 X



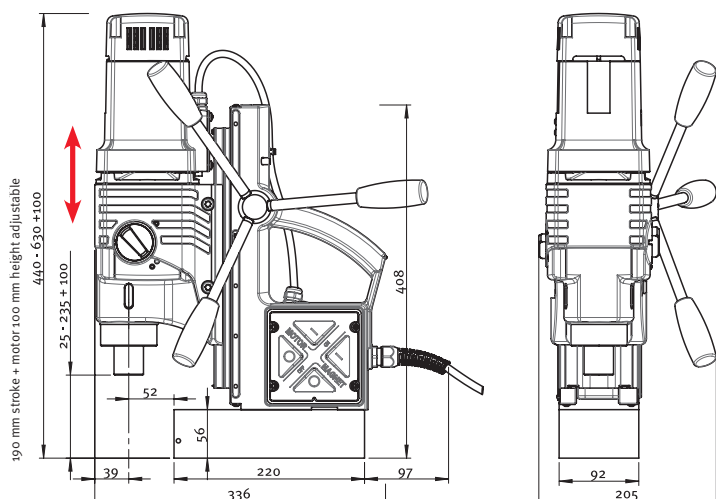
RB 50 X



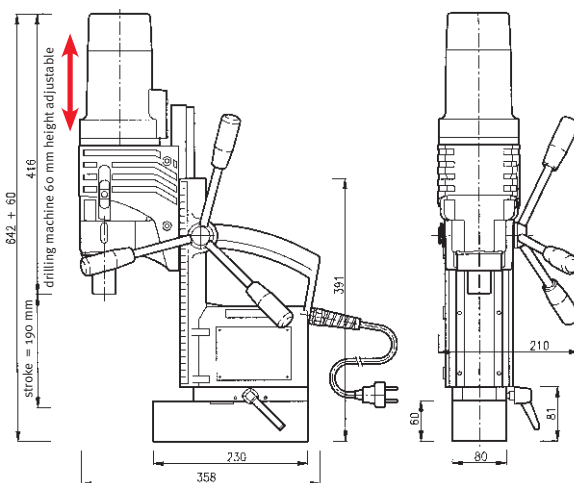
40 RL-E



RB 80 X



60 RL-E

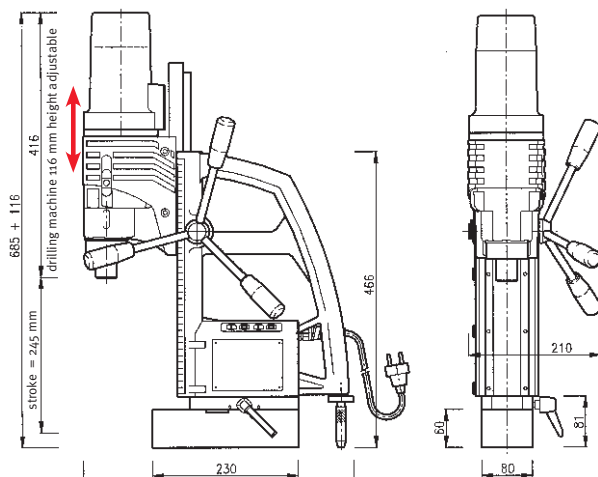




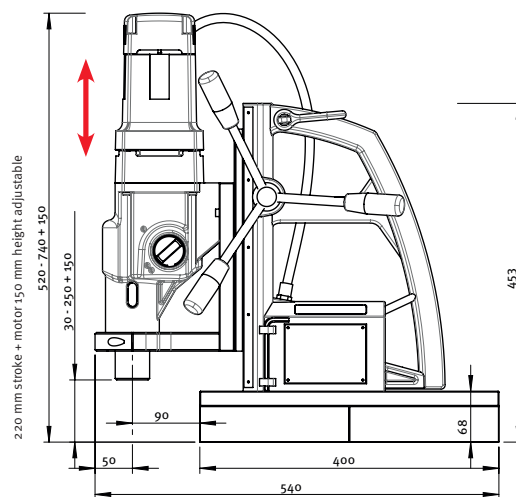
MACHINE DIMENSIONS – ALFRA ROTABEST®



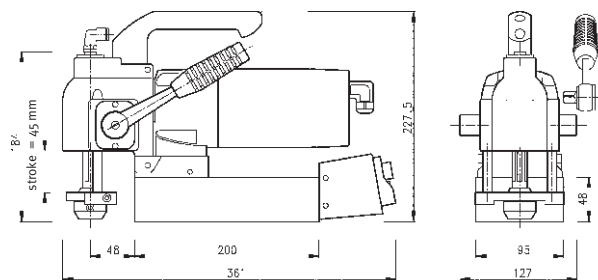
100 RL-E



130



V 32





ACCESSORIES – ARBORS

Description	Prod.-No.	RB 35 X Piccolo 35/50 X	RB 50 X 40 RL-E	RB 80 X 60 RL-E	100 RL-E	
Quick-release chuck with Weldon shank for twist drill Ø 1 - 13 mm	18107	■				 Prod.-No. 18107
Quick-release chuck with Morse taper 2 for twist drill Ø 1 - 16 mm	18008		■	With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2	 Prod.-No. 18008 / 18009
Quick-release chuck with Morse taper 3 for twist drill Ø 1 - 16 mm	18009			■	■	 Prod.-No. 18003 / 18025
AMT-2 tool holder – Morse taper 2 for cutter With Weldon shank Ø 12 - 60 mm With automatic internal cooling – Suitable for all machines with MT 2 drill spindle	18003		■	With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2	 Prod.-No. 18001 / 18002
AMT-2 tool holder with no internal cooling	18001		■	With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2	 Prod.-No. 18001 / 18002
MT 3/2 adapter sleeve	18023			■	■	 Prod.-No. 18023
AMT-3 tool holder with no internal cooling	18002		■	■		
AMT-3 tool holder – Morse taper 3 for cutter with Weldon shank Ø 12 - 60 mm with automatic internal cooling – suitable for all machines with MT 3 drill spindle	18025		■	■		
AMT-3 tool holder – extended version with Weldon shank Ø 12 - 50 mm, cutting depth 110 mm with automatic internal cooling – suitable for all machines with MT 3 drill spindle	18025L			■	■	 Prod.-No. 18025L
AL3 tool holder - Morse taper 3 for heavy-duty cutters, Ø 51 - 100 mm, with keyway with automatic internal cooling	20230			■	■	 Prod.-No. 20230
Rota-Quick® quick-change tool-holder Morse taper 2 with automatic internal cooling – suitable for all machines with MT 2 drill spindle Application range up to maximum 40 mm of cutter Ø	18650		■	With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2	 Prod.-No. 18650 + 18651
Rota-Quick® quick-change tool-holder Morse taper 3 with automatic internal cooling – suitable for all machines with MT 3 drill spindle Application range up to maximum 40 mm of cutter Ø	18651			■	■	



ACCESSORIES – ADAPTORS



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

Prod.-No.

Adapter with internal thread, M18 x 6P 1.5
 Adapter for use with Rotabest® HSS-Co-Eco and HSS-Co RQX cutters with
 Ø 12.0 - 32.0 mm and Rotabest carbide-cutters with Ø 14.0 - 32.0 mm on:
 FEIN core drilling machines, type KBM 542

20201



Weldon



FEIN/Hitachi
 M18 x 6P 1.5
 Internal thread

Prod.-No. 20201

Adapter with external thread (incl. ejector pin)
 Adapter for use with FEIN cutters with internal thread,
 M18 x 6P 1.5 on metal core drilling machines with Weldon shank.

20202



FEIN/Hitachi
 M18 x 6P 1.5
 Internal thread



Weldon

Prod.-No. 20202

Ejector pin suitable for Prod.-No. 20202 – individual

20203

Adapter
 Adapter for use with all cutters with Weldon shank on
 Fein Quick IN quick-change system.

20204

This adapter eliminates the need to use our HSS-Eco cutter series prod.-
 no. 1909... and 2009...

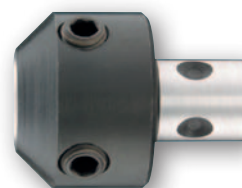
Ejector pin for HSS cutter cutting depth 25 mm
 Ejector pin for HSS cutter cutting depth 50 mm

1950500

1975500

Prod.-No. 20204

Weldon



FEIN-Quick IN

Extension adapter
 With Weldon shank and ejector pin.

20206

For use with cutters with 25 – 35 – 50 mm cutting depths, when the outer
 surface of the material to be drilled is lower than the standing surface of
 the machine. The first ejector pin triggers the second ejector pin, and the
 coolant flows through the bore hole to the cutter.

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



Prod.-No. 20206

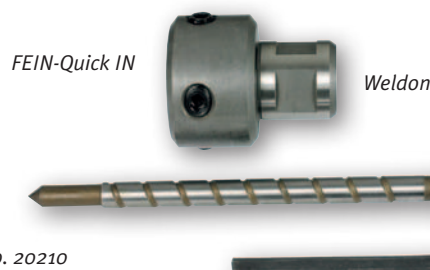
Adapter cpl. with ejector pin + Allen key
 Adapter for use with cutters with FEIN-Quick IN shank on
 metal core drilling machines with Weldon holder.

20210

Replacement ejector pin (for adapter only) 6.35 x 125 mm

1936501

Prod.-No. 20210



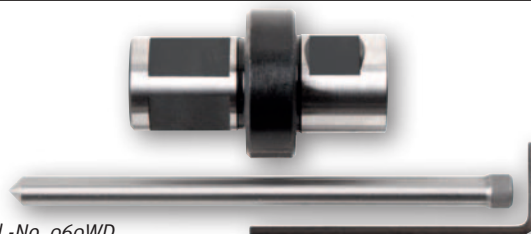
FEIN-Quick IN

Weldon

Adapter for carbide-tipped compass saws, type MBS
 on metal core drilling machines with Weldon holder
 (including ejector pin Prod.-No. 1950500)

o6oWD

Prod.-No. o6oWD

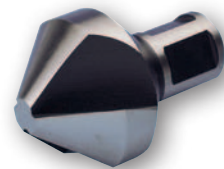


B

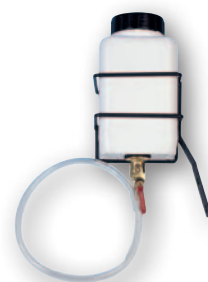


ACCESSORIES – COUNTERBORE // COOLANT

Description	Prod.-No.	RB 35 X Piccolo 35/50 X	RB 50 X 40 RL-E	RB 80 X 60 RL-E	100 RL-E
HSS taper and deburring counterbore with Weldon shank Ø 25 mm	18533	■	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651
HSS taper and deburring counterbore with Weldon shank Ø 30 mm	18536	■	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651
HSS taper and deburring counterbore with Weldon shank Ø 40 mm	18534	■	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651	■ With tool holder 18003/18025 18650+18651
HSS taper and deburring counterbore with Weldon shank Ø 55 mm	18537			■	■
Coolant system for Piccolo 35/50 X, 40 RL-E, 60 RL-E, 100 RL-E, 130	18104	■	■	■	■
Coolant system for RB 35 X	189311241	■			
Coolant system for RB 50 X and 80 X Suitable for tool holder with internal cooling AMT-2 (Prod.-No. 18003) and AMT-3 (Prod.-No. 18025)	189412029		■	■	
Coolant pressure bottle, 0.5 litre suitable for Rotabest® V32	18103				
ALFRA 2000 Cutting and drilling spray Tin, 405 ml	21010				
ALFRA 4000 High-performance cutting oil spray Tin, 300 ml	21040				
High-performance wax crayon Ideal for core-drilled holes in walls or ceilings (overhead drilling), as paste adheres to the cutting edge.	09012				



Prod.-No. 18533



Prod.-No. 18104



Prod.-No. 189311241



Prod.-No. 189412029



Prod.-No. 18103



Prod.-No. 21010, 21040, 09012



ACCESSORIES – TAPPING



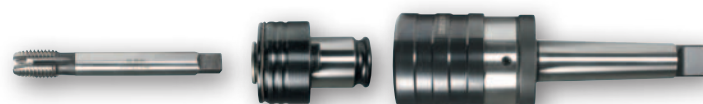
Description	Shank	Prod.-No.
Tapping attachment M3 - M12 Scope of Supply: With Rota-Quick® and MT 2, replaceable, plastic case, operating manual	MT2 + RotaQuick®	18652
Tapping attachment M10 - M20 Scope of Supply: with Rota-Quick® and MT 2, replaceable, plastic case, operating manual	MT2 + RotaQuick®	18653
Adapter sleeve for Tapping attachment		18023

Tapping chuck with quick-change inserts for Rotabest® RL-E, models with right/left rotation.

Tapping set Gr. 1 in wooden case Consisting of: Tapping quick-change chuck Gr. 1 MT 2 Per 1 x quick-change insert Gr. 1 M3 – M4 – M5 – M6 – M8 – M10 – M12 – M14	18660
Tapping set Gr. 2 in wooden case Consisting of: Tapping quick-change chuck Gr. 2 MT 3 Per 1 x quick-change insert Gr. 2 M6 – M8 – M10 – M12 – M14 – M16 – M18 – M20 – M22	18680
Tapping quick-change chuck Gr. 1 MT 2, individual	18661
Tapping quick-change chuck Gr. 2 MT 3, individual	18681

Tap Collets with clutch

	Shank Ø	Square	Screw tap	
Gr. 1 M3	3.5	2.7	DIN 371	18662
Gr. 1 M4	4.5	3.4	DIN 371	18663
Gr. 1 M5	6.0	4.9	DIN 371	18664
Gr. 1 M6	6.0	4.9	DIN 371	18678
Gr. 1 M8	8.0	6.2	DIN 371	18665
Gr. 1 M10	10.0	8.0	DIN 371	18666
Gr. 1 M12	9.0	7.0	DIN 376	18667
Gr. 1 M14	11.0	9.0	DIN 376	18668
Gr. 2 M6	6.0	4.9	DIN 371	18682
Gr. 2 M8	8.0	6.2	DIN 371	18683
Gr. 2 M10	10.0	8.0	DIN 371	18684
Gr. 2 M12	9.0	7.0	DIN 376	18685
Gr. 2 M14	11.0	9.0	DIN 376	18686
Gr. 2 M16	12.0	9.0	DIN 376	18687
Gr. 2 M18	14.0	11.0	DIN 376	18688
Gr. 2 M20	16.0	12.0	DIN 376	18689
Gr. 2 M22	18.0	14.5	DIN 376	18690

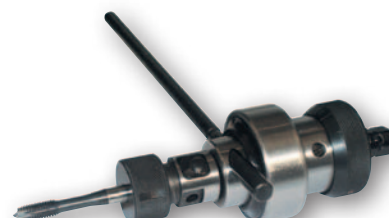


Prod.-No. 18681 – See assembly instructions

RB 50 X	RB 80 X	100
With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2	With Adapter sleeve MT 3/2



Prod.-No. 18023



Prod.-No. 18652 + 18653



Prod.-No. 18680

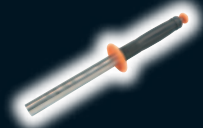


Prod.-No. 18682 (M6)

Prod.-No. 18681



B



ALFRA – MAGNETIC CHIP REMOVER

Based on a magnet moving in a stainless cylindrical pipe. The powerful magnet attracts the metal chips - pull the rod on top and the chips fall off. For greater cleanliness on your worksite.

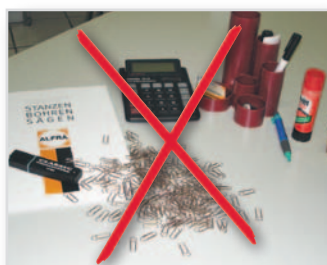
Prod.-No.

ALFRA magnetic chip remover, length 400 mm

18654



Prod.-No. 18654





ACCESSORIES – MECHANICAL PIPE-FIXING SYSTEM



For all types

Description

For application on round surfaces.
Our mechanical attachment for clamping pipes with tension chains enables the use of Magnetic Core Drilling Machines on pipes from Ø 80 mm. The adjustment is carried out by means of clamping jaws. For pipes of various Ø.

Prod.-No.

Attachment for Clamping Pipes with 1 tension chain Ø 80 - 300 mm
Base plate for magnet foot 100 x 235 mm, Weight 7.5 kg

18019

Attachment for Clamping Pipes with 2 tension chains Ø 80 - 900 mm
Base plate for magnet foot 100 x 280 mm, Weight 12 kg

18020

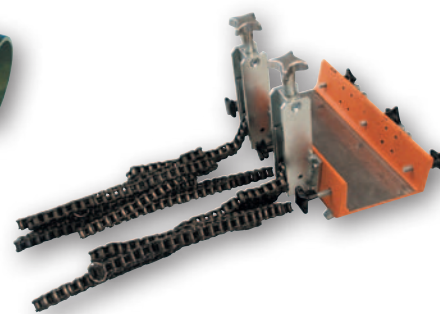
Attachment for Clamping Pipes with tension belt Ø 80 - 900 mm
Base plate for magnet foot 100 x 235 mm, Weight 6.5 kg

18021

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



Prod.-No. 18019



Prod.-No. 18020



Prod.-No. 18021

ROTABEST® – VACUBEST VACUUM ATTACHMENT

For all types

Description

Vacuum Attachment Vacubest

Prod.-No.

18150

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

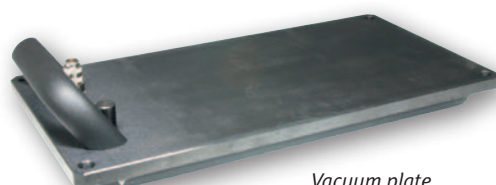
Vacuum capacity: 1.5 m³/h - 25 l/min.
Max vacuum: 200 mbar (abs)
Overpressure: 300 mbar
Dimension of vacuum plate: 400 x 200 mm

Scope of Supply:

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

TIP:

Name your application problem - we will be pleased to advise.



Vacuum plate



Pump



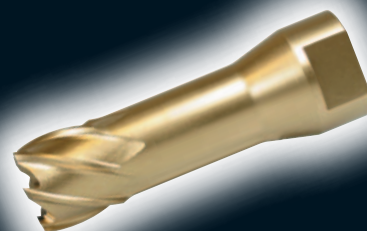
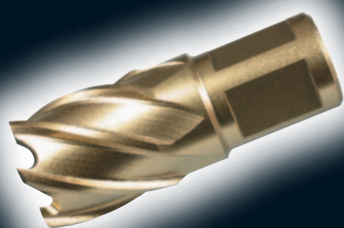
B

Metal Core Cutters have got a name



ALFRA ROTABEST®

- ▶ HSS-BASIC
- ▶ HSS-CO-Eco
- ▶ HSS-CO RQX COATED
- ▶ ASP-30 RAIL
- ▶ TWIST DRILL WITH WELDON SHANK



B

Advantages of ALFRA ROTABEST® Cutters

- Design** Specially designed cutting geometry
- Advantages**
- Immediate centering
 - No running off center
 - Good concentricity
 - Suitable for NC and CNC machines

**35 years of
manufacturing expertise**

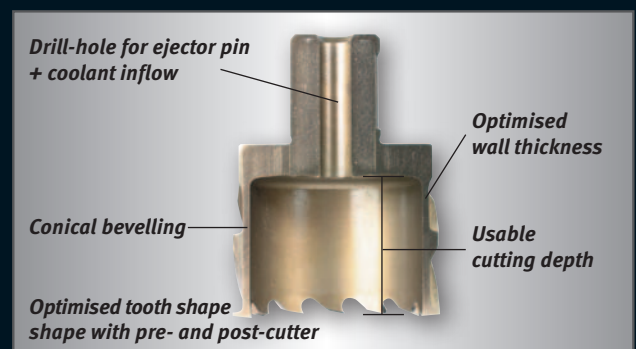
- Design** Optimum regular chip break
- Advantages**
- Smooth cutting
 - Excellent cutting capacity
 - Good chip production at each tooth
 - Regular chip flow

- Design** Minimum cross section of chip removing surface
- Advantages**
- Easy cutting
 - Low torque
 - Minimum demand for energy

- Design** High tooth hardness due to optimum raw material and special heat treatment
- Advantages**
- Long tool life
 - Also suitable for material difficult to cut

- Design** High tenacity of cutter, specially graduated hardness
- Advantages**
- Low risk of tool break,
 - especially under rough working conditions

- Industrial scale manufacturing by state-of-the-art CNC technology**
- Best reproducibility
 - Constant quality





ALFRA ROTABEST® – HSS BASIC CUTTERS

With 19.0 mm Weldon shank

- With 19.0 mm Weldon shank, 2 clamping surfaces, 1 counterbore for RotaQuick®
- Internal bore 6.35 mm
- Steel quality: Special super-high performance high-speed steel
- Polished section: with pre- and post-cutting

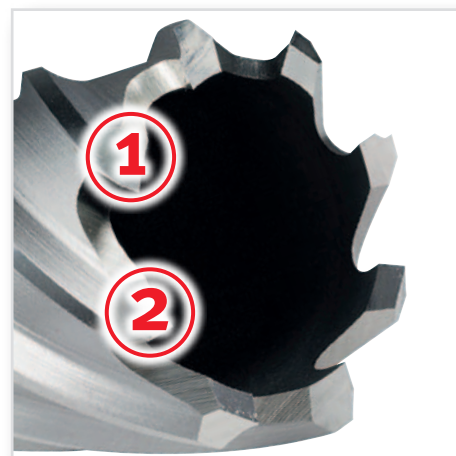
Ø in mm Cutting depth	Prod.-No. 25 mm	Prod.-No. 50 mm
12.0	1907012025	1907012050
13.0	1907013025	1907013050
13.5	1907013525	1907013550
14.0	1907014025	1907014050
15.0	1907015025	1907015050
15.5	1907015525	1907015550
16.0	1907016025	1907016050
17.0	1907017025	1907017050
17.5	1907017525	1907017550
18.0	1907018025	1907018050
19.0	1907019025	1907019050
19.5	1907019525	1907019550
20.0	1907020025	1907020050
21.0	1907021025	1907021050
22.0	1907022025	1907022050
23.0	1907023025	1907023050
24.0	1907024025	1907024050
25.0	1907025025	1907025050
26.0	1907026025	1907026050
26.5	1907026525	1907026550
27.0	1907027025	1907027050
28.0	1907028025	1907028050
29.0	1907029025	1907029050
30.0	1907030025	1907030050
31.0	1907031025	1907031050
32.0	1907032025	1907032050
33.0	1907033025	1907033050
34.0	1907034025	1907034050
35.0	1907035025	1907035050
36.0	1907036025	1907036050
37.0	1907037025	1907037050
38.0	1907038025	1907038050
39.0	1907039025	1907039050
40.0	1907040025	1907040050
41.0	1907041025	1907041050
42.0	1907042025	1907042050
43.0	1907043025	1907043050
44.0	1907044025	1907044050
45.0	1907045025	1907045050
46.0	1907046025	1907046050
47.0	1907047025	1907047050
48.0	1907048025	1907048050
49.0	1907049025	1907049050
50.0	1907050025	1907050050
51.0	–	1907051050
52.0	1907052025	1907052050
53.0	–	1907053050
54.0	–	1907054050
55.0	1907055025	1907055050
56.0	–	1907056050
57.0	–	1907057050
58.0	–	1907058050
59.0	–	1907059050
60.0	1907060025	1907060050
Ejector pin	1926500	1950500
Dimensions	6.35 x 77	6.35 x 102

Suitable for:

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

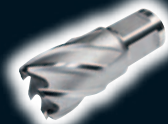


Counterbore for RotaQuick® Weldon



High-performance tooting with pre- (1) and post-cutting (2)





ALFRA ROTABEST® – HSS BASIC CUTTER SETS



With 19.0 mm Weldon shank

- An assortment of commonly used cutters in a sturdy plastic case.
- Effective protection for the teeth during rough use during assembly and in the workshop.
- Upon request we can make individual sets with diameters ranging from Ø 12.0 mm to 30.0 mm.

Dimensions in inches available upon request



Prod.-No. 1907125

HSS BASIC Cutter Set

Cutting depth **25 mm**

Prod.-No.

1907125

3-pc cutter set:

comprising 1 x Ø 14.0 - 18.0 - 22.0 mm

In a robust box

Including 1 ejector pin Prod.-No. 1926500

HSS BASIC Cutter Set

Cutting depth **25 mm**

Prod.-No.

1907003025

6-pc cutter set:

comprising 1 x Ø 12.0 - 14.0 - 16.0 - 18.0 - 20.0 - 22.0 mm

in a sturdy case

including 1 ejector pin Prod.-No. 1926500



Prod.-No. 1907003025

HSS BASIC Cutter Set

Cutting depth **25 mm**

Prod.-No.

1907001025

10-pc cutter set:

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

in a sturdy case

Including 2 ejector pins Prod.-No. 1926500



HSS BASIC Cutter Set

Cutting depth **50 mm**

Prod.-No.

1907003050

Prod.-No. 1907001025

6-pc cutter set:

comprising 1 x Ø 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm

in a sturdy case

including 1 ejector pin Prod.-No. 1950500

HSS BASIC Cutter Set

Cutting depth **50 mm**

Prod.-No.

1907001050

10-pc cutter set:

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

in a sturdy case

including 2 ejector pins Prod.-No. 1950500

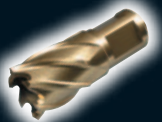


Prod.-No. 1907003050



Prod.-No. 1907001050

B



ALFRA ROTABEST® – HSS-Co-Eco CUTTERS

With 19.0 mm Weldon shank

Dimensions in
inches available
upon request

- With 19.0 mm Weldon shank,
2 clamping surfaces, 1 counterbore for RotaQuick®
- Internal bore 6.35 mm
- Steel quality: Special high-capacity speed steel, cobalt
- Polished section: with pre- and post-cutting

Suitable for:

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

Ø in mm	Prod.-No.	Prod.-No.	Prod.-No.	Prod.-No.*
Cutting depth	25 mm	35 mm	50 mm	110 mm
12.0	1901012025	1901012035	1901012050	–
13.0	1901013025	1901013035	1901013050	–
13.5	1901013525	–	1901013550	–
14.0	1901014025	1901014035	1901014050	–
15.0	1901015025	1901015035	1901015050	–
15.5	1901015525	–	1901015550	–
16.0	1901016025	1901016035	1901016050	–
17.0	1901017025	1901017035	1901017050	–
17.5	1901017525	–	1901017550	–
18.0	1901018025	1901018035	1901018050	–
19.0	1901019025	1901019035	1901019050	–
19.5	1901019525	–	1901019550	–
20.0	1901020025	1901020035	1901020050	1901020110
21.0	1901021025	1901021035	1901021050	–
22.0	1901022025	1901022035	1901022050	1901022110
23.0	1901023025	1901023035	1901023050	–
24.0	1901024025	1901024035	1901024050	1901024110
25.0	1901025025	1901025035	1901025050	1901025110
26.0	1901026025	1901026035	1901026050	1901026110
26.5	1901026525	–	1901026550	–
27.0	1901027025	1901027035	1901027050	–
28.0	1901028025	1901028035	1901028050	1901028110
29.0	1901029025	1901029035	1901029050	–
30.0	1901030025	1901030035	1901030050	1901030110
31.0	1901031025	1901031035	1901031050	–
32.0	1901032025	1901032035	1901032050	1901032110
33.0	1901033025	1901033035	1901033050	–
34.0	1901034025	1901034035	1901034050	–
35.0	1901035025	1901035035	1901035050	1901035110
36.0	1901036025	1901036035	1901036050	–
37.0	1901037025	1901037035	1901037050	–
38.0	1901038025	1901038035	1901038050	–
39.0	1901039025	1901039035	1901039050	–
40.0	1901040025	1901040035	1901040050	1901040110
41.0	1901041025	–	1901041050	–
42.0	1901042025	–	1901042050	–
43.0	1901043025	–	1901043050	–
44.0	1901044025	–	1901044050	–
45.0	1901045025	–	1901045050	1901045110
46.0	1901046025	–	1901046050	–
47.0	1901047025	–	1901047050	–
48.0	1901048025	–	1901048050	–
49.0	1901049025	–	1901049050	–
50.0	1901050025	–	1901050050	1901050110
51.0	–	–	1901051050	–
52.0	1901052025	–	1901052050	–
53.0	–	–	1901053050	–
54.0	–	–	1901054050	–
55.0	1901055025	–	1901055050	–
56.0	–	–	1901056050	–
57.0	–	–	1901057050	–
58.0	–	–	1901058050	–
59.0	–	–	1901059050	–
60.0	1901060025	–	1901060050	–
Ejector pin	1926500	1935500	1950500	2001502
Dimensions	6.35 x 77	6.35 x 87	6.35 x 102	8 x 160



Counterbore for RotaQuick® Weldon



High-performance tooting with pre- (1) and post-cutting (2)



* Important: HSS-Co-Eco cutters with a cutting depth of 110 mm can now be used with AMT 2 L (Prod.-No. 18003 L) or AMT 3 L (Prod.-No. 18025 L) tool holders.



ALFRA ROTABEST® – HSS-Co-Eco CUTTER SETS



With 19.0 mm Weldon shank

- An assortment of commonly used cutters in a sturdy plastic case.
- Effective protection for the teeth during rough use during assembly and in the workshop.
- Upon request we can make individual sets with diameters ranging from Ø 12.0 mm to 30.0 mm.

Dimensions in inches available upon request



Prod.-No. 1901125

HSS-Co-Eco Cutter Set

Cutting depth **25 mm**

Prod.-No.

1901125

3-pc cutter set:
comprising 1 x Ø 14.0 - 18.0 - 22.0 mm
in a robust box
including 1 ejector pin Prod.-No. 1926500

HSS-Co-Eco Cutter Set

Cutting depth **25 mm**

Prod.-No.

1901003025

6-pc cutter set:
comprising 1 x Ø 12.0 - 14.0 - 16.0 - 18.0 - 20.0 - 22.0 mm
in a sturdy case
including 1 ejector pin Prod.-No. 1926500



Prod.-No. 1901003025

HSS-Co-Eco Cutter Set

Cutting depth **25 mm**

Prod.-No.

1901001025

10-pc cutter set:
comprising 1 x Ø 2 x 12.0 - 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 mm
in a sturdy case
including 2 ejector pins Prod.-No. 1926500



Prod.-No. 1901001025

HSS-Co-Eco Cutter Set

Cutting depth **50 mm**

Prod.-No.

1901003050

6-pc cutter set:
comprising 1 x Ø 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm
in a sturdy case
including 1 ejector pin Prod.-No. 1950500



Prod.-No. 1901003050

HSS-Co-Eco Cutter Set

Cutting depth **50 mm**

Prod.-No.

1901001050

10-pc cutter set:
Comprising Ø 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 - 1 x 24.0 - 1 x 26.0 mm
in a sturdy case
including 2 ejector pins Prod.-No. 1950500



Prod.-No. 1901001050

B



ALFRA ROTABEST® – HSS-Co CUTTERS RQX COATED

With 19.0 mm Weldon shank

- With 19.0 mm Weldon shank, 2 clamping surfaces, 1 counterbore for RotaQuick®
- Internal bore 6.35 mm
- Steel quality: Special super-high performance high-speed steel cobalt, **coated**
- Polished section: with pre- and post-cutting

Suitable for:

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



Counterbore for RotaQuick® Weldon

Ø in mm Cutting depth 25 mm Prod.-No.

12.0	1902012025
13.0	1902013025
14.0	1902014025
15.0	1902015025
16.0	1902016025
17.0	1902017025
18.0	1902018025
19.0	1902019025
20.0	1902020025
21.0	1902021025
22.0	1902022025
23.0	1902023025
24.0	1902024025
25.0	1902025025
26.0	1902026025
27.0	1902027025
28.0	1902028025
29.0	1902029025
30.0	1902030025
31.0	1902031025
32.0	1902032025
33.0	1902033025
34.0	1902034025
35.0	1902035025
36.0	1902036025
37.0	1902037025
38.0	1902038025
39.0	1902039025
40.0	1902040025
41.0	1902041025
42.0	1902042025
43.0	1902043025
44.0	1902044025
45.0	1902045025
46.0	1902046025
47.0	1902047025
48.0	1902048025
49.0	1902049025
50.0	1902050025
51.0	
52.0	
53.0	
54.0	
55.0	
56.0	
57.0	
58.0	
59.0	
60.0	

Ejector pin 6.35 x 77 mm 1926500

Ø in mm Cutting depth 50 mm Prod.-No.

12.0	1902012050
13.0	1902013050
14.0	1902014050
15.0	1902015050
16.0	1902016050
17.0	1902017050
18.0	1902018050
19.0	1902019050
20.0	1902020050
21.0	1902021050
22.0	1902022050
23.0	1902023050
24.0	1902024050
25.0	1902025050
26.0	1902026050
27.0	1902027050
28.0	1902028050
29.0	1902029050
30.0	1902030050
31.0	1902031050
32.0	1902032050
33.0	1902033050
34.0	1902034050
35.0	1902035050
36.0	1902036050
37.0	1902037050
38.0	1902038050
39.0	1902039050
40.0	1902040050
41.0	1902041050
42.0	1902042050
43.0	1902043050
44.0	1902044050
45.0	1902045050
46.0	1902046050
47.0	1902047050
48.0	1902048050
49.0	1902049050
50.0	1902050050
51.0	1902051050
52.0	1902052050
53.0	1902053050
54.0	1902054050
55.0	1902055050
56.0	1902056050
57.0	1902057050
58.0	1902058050
59.0	1902059050
60.0	1902060050

Ejector pin 6.35 x 102 mm 1950500



High-performance tothing with pre- (1) and post-cutting (2)





ALFRA ROTABEST® – HSS-Co CUTTER RQX SETS



With 19.0 mm Weldon shank

- An assortment of commonly used cutters in a sturdy plastic case.
- Effective protection for the teeth during rough use during assembly and in the workshop.
- Upon request we can make individual sets with diameters ranging from Ø 12.0 mm to 30.0 mm.

Dimensions in inches available upon request

HSS-Co Cutter RQX Set

Cutting depth **25 mm**

Prod.-No.

1902003025

6-pc cutter set:

comprising 1 x Ø 12.0 - 14.0 - 16.0 - 18.0 - 22.0 - 26.0 mm
in a plastic case
including 1 ejector pin Prod.-No. 1926500

Prod.-No. 1902003025



HSS-Co Cutter RQX Set

Cutting depth **25 mm**

Prod.-No.

1902001025

10-pc cutter set:

comprising Ø 2 x 12.0 - 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 2 x 22.0 - 1 x 26.0 mm
In plastic case
including 2 ejector pins Prod.-No. 1926500

Prod.-No. 1902001025



HSS-Co Cutter RQX Set

Cutting depth **50 mm**

Prod.-No.

1902003050

6-pc cutter set:

comprising 1 x Ø 14.0 - 16.0 - 18.0 - 20.0 - 22.0 - 26.0 mm
In a plastic case
including 1 ejector pin Prod.-No. 1950500

Prod.-No. 1902003050



HSS-Co Cutter RQX Set

Cutting depth **50 mm**

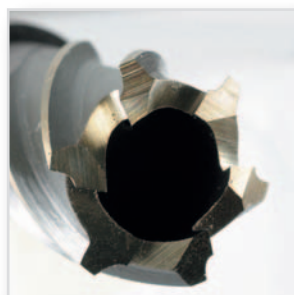
Prod.-No.

1902001050

10-pc cutter set:

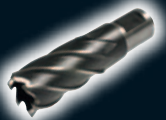
comprising Ø 2 x 14.0 - 1 x 16.0 - 2 x 18.0 - 1 x 20.0 - 2 x 22.0 - 1 x 24.0 - 1 x 26.0 mm
In plastic case
including 2 ejector pins Prod.-No. 1950500

Prod.-No. 1902001050



HSS-Co cutter with special geometries for processing stacked metal plates (multi-layer drill) upon request! (Standard-cutters are not suitable for this purpose.)

B



ALFRA ROTABEST® - ASP-30 RAIL

With 19.0 mm Weldon shank



- With 19.0 mm Weldon shank,
- Internal bore 6.35 mm
- Steel quality: Powder-metallurgical based cobalt high-performance high-speed steel with optimal purity and improved toughness compared to traditional powder steel.
- Excellently suitable for intensive-use applications such as on railway tracks.
- These tools can also be used on all magnet drilling machines, especially with Weldon shank.

Suitable for:

All portable magnetic drilling machines with 19 mm Weldon shank, especially for rail drilling units from the following manufacturers:

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

Dimensions in inches available upon request



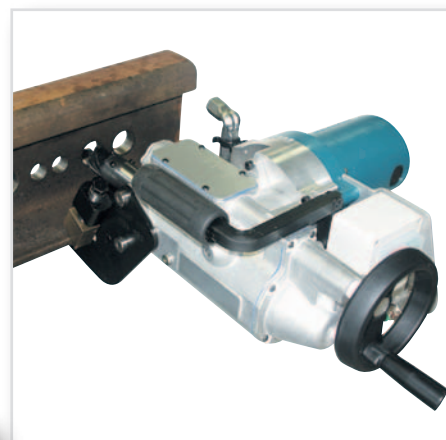
Ø in mm Cutting depth 25 mm Prod.-No.

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



Ø in mm Cutting depth 50 mm Prod.-No.

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

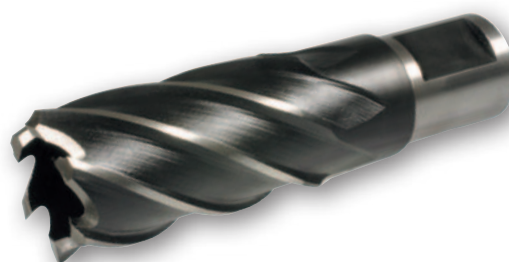
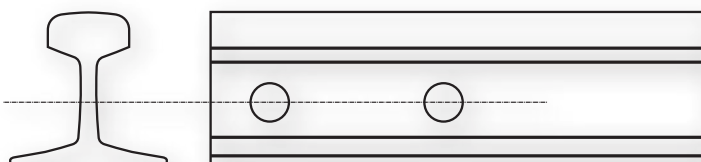


Tip:

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

And another tip:

ASP-60 for "impossible" drilling applications upon request.





ALFRA – HSS-Co-Eco CUTTERS FOR FEIN-QUICKIN



Suitable for FEIN magnetic drilling machines

- Suitable for FEIN magnetic drilling machines with Quick IN arbor.
- You are using FEIN magnetic drilling machines and do not want to do without your ALFRA-Rotabest® cutters? Take a look at our selection of HSS and carbide-tipped cutters suitable for the various types of FEIN machines.
- Special shank, 18.0 mm with 4 bearing recesses
- Steel quality: Special high-capacity speed steel, cobalt
- Internal bore 6.4 mm
- Suitable for: FEIN Quick-IN quick-change arbor, FEIN core drilling machines with KBM 32 Q, KBM 50 Q, KBM 65 Q, KBM 65 QF Quick-IN quick-change systems

Ø in mm Cutting depth 35 mm

Prod.-No.

12.0	1909012035
13.0	1909013035
14.0	1909014035
15.0	1909015035
16.0	1909016035
17.0	1909017035
18.0	1909018035
19.0	1909019035
20.0	1909020035
21.0	1909021035
22.0	1909022035
23.0	1909023035
24.0	1909024035
25.0	1909025035
26.0	1909026035
27.0	1909027035
28.0	1909028035
29.0	1909029035
30.0	1909030035
31.0	1909031035
32.0	1909032035

Ejector pin 6.35 x 106 mm

1936500



Prod.-No. 1936500



High-performance toothing with pre- and post-cutting

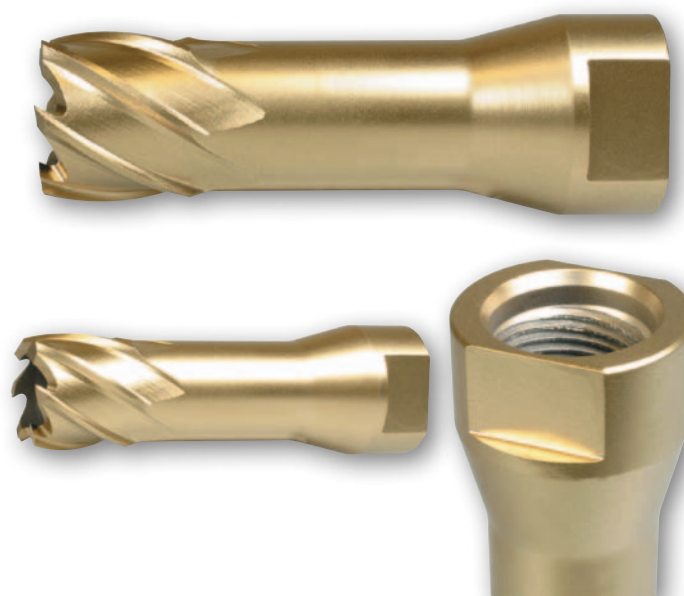
ALFRA – HSS-Co-Eco CUTTERS SUITABLE FOR FEIN + HITACHI

- Threaded arbor, internal thread, M18 x 6P 1.5.
- Also compatible with Hitachi machines.

Ø in mm Cutting depth 50 mm

Prod.-No.

12.0	1908012050
13.0	1908013050
14.0	1908014050
15.0	1908015050
16.0	1908016050
17.0	1908017050
18.0	1908018050
19.0	1908019050
20.0	1908020050
21.0	1908021050
22.0	1908022050
23.0	1908023050
24.0	1908024050
25.0	1908025050
26.0	1908026050
27.0	1908027050
28.0	1908028050
29.0	1908029050
30.0	1908030050



Dimensions in inches available upon request.

B/37



HSS-TWIST DRILLS

With 19.0 mm Weldon shank

- Suitable for magnetic drilling machines with Weldon shank.
- Ideal for drilling smaller diameters, < Ø 12 mm.

HSS twist drill

Ø in mm HSS twist drill with Weldon shank

Prod.-No.

6.0 0802606

8.0 0802608

9.0 0802609

10.0 0802610

11.0 0802611

12.0 0802612

Prod.-No. 0802606

Prod.-No. 0802608

Prod.-No. 0802609

Prod.-No. 0802610

Prod.-No. 0802611

Prod.-No. 0802612



HSS twist drill set

6-pc HSS twist drill set with Weldon shank
comprising 1 x Ø 6.0 - 8.0 - 9.0 - 10.0 - 11.0 - 12.0 mm
In a plastic case

Prod.-No.

08026



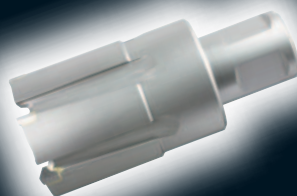
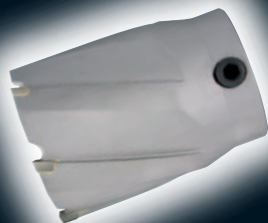
Prod.-No. 08026

Metal Core Cutters have got a name

ALFRA ROTABEST®



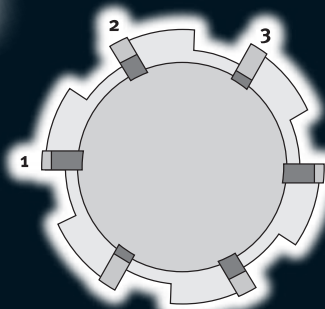
► CARBIDE-TIPPED



Applicable on magnetic and column drills. For structural steels, difficult-to-machine materials such as chrome-nickel steels and for non-ferrous metals such as aluminium or Cu-Zn alloys, and much more.

Advantages of ALFRA ROTABEST® TCT Cutters

- High concentricity due to solid design
- CAD-optimised cutting geometry for steady flow of chips
- Uniquely shaped chip grooves to prevent chip jamming
- Instant centring
- No running off center
- Minimal torque
- Low energy consumption
- Rapid drill core removal by ejector pin
- Extended tool life

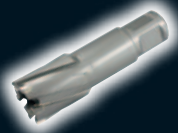


ALFRA "Chip-Breaker System"

Extremely precise drilling in 3 simple steps.

- 1 Pre-cutter
- 2 Middle cutter
- 3 Post-cutter

B



ALFRA ROTABEST® – TGT CUTTERS

With 19.0 mm Weldon shank

- With 19.0 mm Weldon shank,
- Internal bore: Ø 14 - 17 mm = 6.35 mm
Ø 18 - 50 mm = 8.0 mm
- Polished section: pre-, middle- and post-cutters
- For the highest standards in cutting and lifespan.

Suitable for:

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

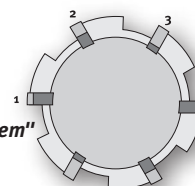


Ø in mm Cutting depth 35 mm Prod.-No.

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

Ø in mm Cutting depth 50 mm Prod.-No.

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



ALFRA "Chip-Breaker System"

- 1 Pre-cutter
- 2 Middle cutter
- 3 Post-cutter



ALFRA ROTABEST® – TCT CUTTERS



Suitable for all core drilling, pillar drilling and milling machines

- Heavy industry design with **keyway and feather key**
- Long-term tests series have shown that this specialised design with keyway and feather key has proved outstanding compared to a standard 32 mm Weldon shank. Optimal containment of high torsion forces.
- Polished section: pre-, middle- and post-cutters.
- Required: Tool holder with internal cooling

AL 3	MT 3	Prod.-No. 20230
AL 4	MT 4	Prod.-No. 20240
AL 5	MT 5	Prod.-No. 20250
- Upon request, cutting depth of 100 mm with ejector pin 8 x 160 mm Prod.-No. 2001502



Shorter and sturdier tool design. ALFRA design. Excellent running precision.

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

Advantages of "Heavy Industry Design" ALFRA TCT Cutters

- Perfect cutting behaviour – even at the first drill-hole
- Excellent centring properties
- Low cutting pressure – low power use
- Vibration-free working
- Chip distribution – no chip jamming
- Drilling depth can be reached in a single operation
- Drill core can be easily ejected



Prod.-No. 20230



ALFRA ROTABEST® – TGT CUTTERS RAIL

With 19.0 mm Weldon shank



- With 19.0 mm Weldon shank,
- Internal bore 6.35 mm
- For the highest standards in cutting and lifespan when drilling railway tracks
- Polished section: pre-, middle- and post-cutters

Suitable for:

All portable magnetic drilling machines with 19 mm Weldon shank, especially for rail drilling units from the following manufacturers:

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

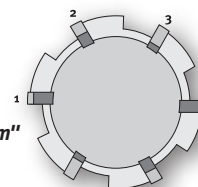
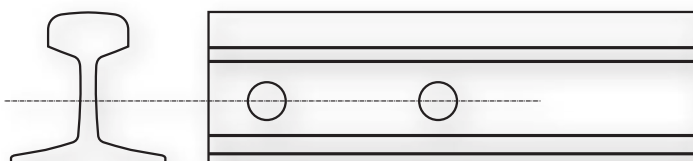


Ø in mm Cutting depth 25 mm Prod.-No.

19.0	2005019025
20.0	2005020025
21.0	2005021025
22.0	2005022025
23.0	2005023025
24.0	2005024025
25.0	2005025025
26.0	2005026025
27.5	2005027525
28.0	2005028025
30.0	2005030025
31.0	2005031025
32.0	2005032025
33.0	2005033025
34.0	2005034025
36.0	2005036025
Ejector pin 6.35 x 77 mm	1926500

Ø in mm Cutting depth 50 mm Prod.-No.

19.0	2005019050
20.0	2005020050
21.0	2005021050
22.0	2005022050
23.0	2005023050
24.0	2005024050
25.0	2005025050
26.0	2005026050
27.5	2005027550
28.0	2005028050
30.0	2005030050
31.0	2005031050
32.0	2005032050
33.0	2005033050
34.0	2005034050
36.0	2005036050
Ejector pin 6.35 x 102 mm	1950500



ALFRA "Chip-Breaker System"

- 1 Pre-cutter
- 2 Middle cutter
- 3 Post-cutter

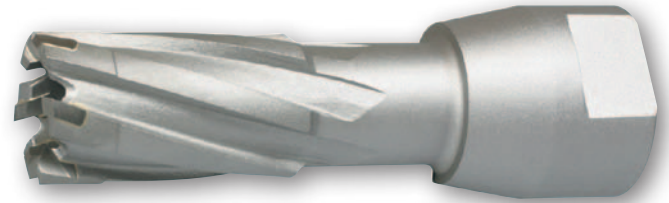


ALFRA – TGT CUTTERS SUITABLE FOR FEIN + HITACHI



- 2008... with Threaded arbor, internal thread, M18 x 6P 1.5.
- Also compatible with Hitachi machines.
- 2009... with Quick IN Arbor.
- Suitable for FEIN magnetic drilling machines with Quick IN arbor.

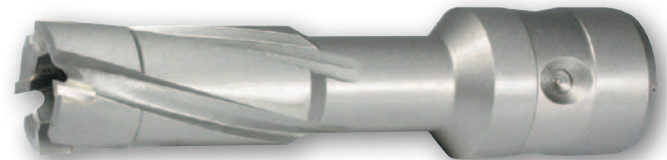
Ø in mm	Prod.-No. M18 x 6P 1.5 Cutting depth 50 mm	Prod.-No. Quick IN Cutting depth 35 mm
12.0	2008012050	2009012035
13.0	2008013050	2009013035
14.0	2008014050	2009014035
15.0	2008015050	2009015035
16.0	2008016050	2009016035
17.0	2008017050	2009017035
18.0	2008018050	2009018035
19.0	2008019050	2009019035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



Prod.-No. 2008...



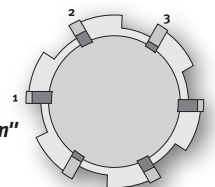
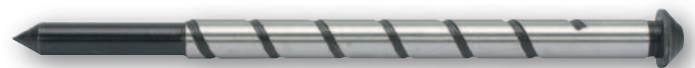
Threaded arbor, M18 x 6P1,5



Prod.-No. 2009...



Prod.-No. 1936500



ALFRA "Chip-Breaker System"

- 1 Pre-cutter
- 2 Middle cutter
- 3 Post-cutter



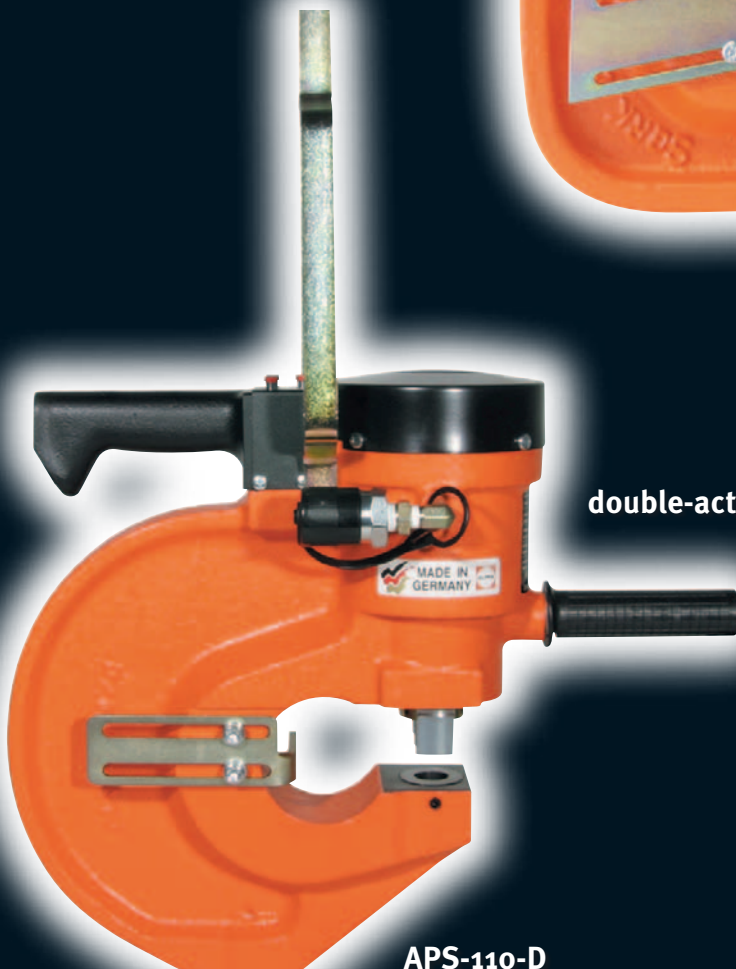
ALFRA PRESS

single-acting



APS-120

double-acting



APS-110-D

B

ALFRA HYDRAULIC PUNCHING UNITS



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



ALFRA-PRESS HYDRAULIC PUNCHES – @OVERVIEW

Made in Germany by ALFRA



APS 60



APS 70

Page	B/60	B/60	
Prod.-No.	23001	23002	
Max. hole Ø	18 mm 11/16"	22 mm 7/8"	
Max. oblong hole	–	22 x 14 mm 7/8" x 9/16"	
Max. material thickness (S235)	10 mm 3/8"	13 mm 1/2"	
Overall punch time with pump ...	SC 05 II-B: approx. 7 sec. SC 17: approx. 4 sec.	SC 05 II-B: approx. 10 sec. SC 17: approx. 4 sec.	
Throat depth	60 mm 2-3/8"	70 mm 2-3/4"	
Max. pressure	700 bar 10.150 psi	700 bar 10.150 psi	
Punching force	22 t	30 t	
Punch stroke	16 mm 5/8"	18 mm 11/16"	
Weight	20.8 kg / 45.8 lbs	29.9 kg / 65.9 lbs	
Scope of Supply	Hydraulic hose, 5 m / spanner Punch/die Ø 14 mm	Hydraulic hose, 5 m / spanner Punch/die Ø 18 mm Depth adjustment, suspension bracket	



HYDRAULIC PUMPS FOR



SC 05 II-B

Page	B/61	
Prod.-No.	23007	
Max. pressure	750 bar / 10.670 psi	
Pumping capacity	0.94 l/min at 2.770 rpm	
Motor power	1.100 W, 230V (50 Hz)* * upon request: 230V (60 Hz); 110 V (50 Hz); 110V (60 Hz)	
Oil flow	5 l	
Weight including oil fill volume	28.2 kg / 62.2 lbs	



ALFRA-PRESS HYDRAULIC PUNCHES – OVERVIEW

Made in Germany by ALFRA



APS 120

B/60

23004

25 mm

1-1/16"

25 x 18 mm

1" x 11/16"

16 mm

5/8"

SC 05 II-B: approx. 16 sec.

SC 17: approx. 5 sec.

110 mm

4-3/8"

700 bar

10.150 psi

44 t

25 mm

15/16"

47.3 kg / 104.2 lbs

Hydraulic hose, 5 m / spanner
Punch/die Ø 22 mm
Depth adjustment, suspension bracket



APS 110 D

B/62

23181

25 mm

1-1/16"

25 x 18 mm

1" x 11/16"

16 mm

5/8"

SC 17 D: approx. 8 sec.

110 mm

4-3/8"

700 bar

10.150 psi

44 t

25 mm

15/16"

38.5 kg / 84.8 lbs

Hydraulic hose, 5 m / spanner
Punch/die Ø 22 mm
Depth adjustment, suspension bracket

APS 60 / 70 / 120



SC 17

B/61

23170

750 bar / 10.670 psi

1.5 l/min at 1.370 rpm

1.500 W, 230V (50 Hz)*

* upon request:

230V (60 Hz); 110V (50 Hz); 110V (60 Hz)

17 l

64 kg / 141 lbs

**HYDRAULIC PUMPS
FOR APS 110D**



SC 17 D

B/62

23186

750 bar / 10.670 psi

1.4 l/min at 1.370 rpm

1.500 W, 230V (50 Hz)*

* upon request:

230V (60 Hz); 110V (50 Hz); 110V (60 Hz)

17 l

67 kg / 148 lbs



B



ALFRA-PRESS – HYDRAULIC PUNCHES, SINGLE-ACTION

Made in Germany by ALFRA

ALFRA-Press APS 60

Prod.-No.

Hydraulic punching unit with
Automatic return using Neoprene spring

23001

Technical specifications:

max. hole Ø mm	18 mm
max. material thickness as per DIN S275	10 mm
total punch time	
with pump SC 05 II B	approx. 7 sec.
with pump SC 17	approx. 4 sec.
throat depth	60 mm
max. pressure	700 bar (10.000 psi)
punching force	22 t
punch stroke	16 mm
weight	20.8 kg

Scope of Supply:

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



Prod.-No. 23001

ALFRA-Press APS 70

Prod.-No.

Hydraulic punching unit with
Automatic return using Neoprene spring

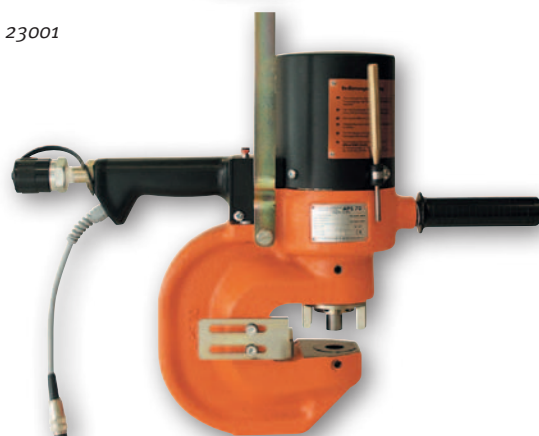
23002

Technical specifications

max. hole Ø mm	22 mm
max. oblong holes	22 x 14 mm
max. material thickness as per DIN S275	13 mm
total punch time	
with pump SC 05 II B	10 sec.
with pump SC 17	4 sec.
throat depth	70 mm
max. pressure	700 bar (10.000 psi)
punching force	30 t
punch stroke	18 mm
weight	29.9 kg

Scope of Supply:

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



Prod.-No. 23002

ALFRA-Press APS 120

Prod.-No.

Hydraulic punching unit with
automatic return using Neoprene spring

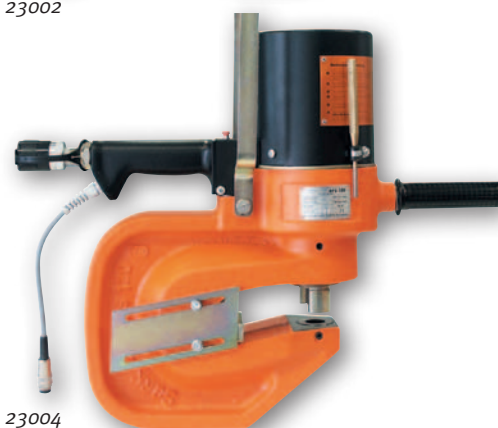
23004

Technical specifications

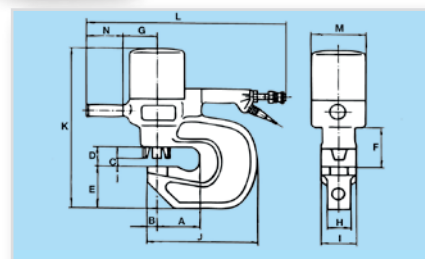
max. hole Ø mm	25 mm
max. oblong holes	25 x 18 mm
max. material thickness as per DIN S275	16 mm
total punch time	
with pump SC 05 II B	16 sec.
with pump SC 17	5 sec.
throat depth	110 mm
max. pressure	700 bar (10.000 psi)
punching force	44 t
punch stroke	25 mm
weight	47.3 kg

Scope of Supply:

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



Prod.-No. 23004



Important technical notice:

Standard punching units are not normally suitable for punching high-strength tooling steel, stainless steels or boiler-plate steel.
Refer to us for technical advice for punching work in this application range.

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



Two hydraulic pumps are fitted to operate the punching unit

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

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

Technical specifications:

max. operating pressure	750 bar (10.670 psi)
pump output	0.94 l/min at 2.770 rpm.
oil fill amount	5.0 l
single-phase motor, 2.770 rpm.	1.100 W 110V or 230V 50 Hz or 60 Hz
weight incl. oil fill volume	28.2 kg

* Upon request

Prod.-No. 23007



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

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

Complete with control system and switching cases.

These new hydraulic pumps were developed in order to drastically reduce punching times. These are particularly suited to workshop use.

Technical specifications:

max. operating pressure	750 bar (10.670 psi)
pump output	at 50 Hz, 1.50 l/min. at 1.370 rpm.
oil fill amount	17 l
single-phase motor, 1.450 rpm.	1.500 W 230 V 50 Hz
weight including oil fill volume	
and transport rollers	64 kg
dimensions L x W x H	550 x 370 x 560 mm

* Upon request

Prod.-No. 23170



SC 17



ALFRA-PRESS – HYDRAULIC HOLE PUNCHES, DOUBLE-ACTION

Made in Germany by ALFRA

ALFRA-Press APS 110D

Hydraulic punching unit with automatic return

Prod.-No.

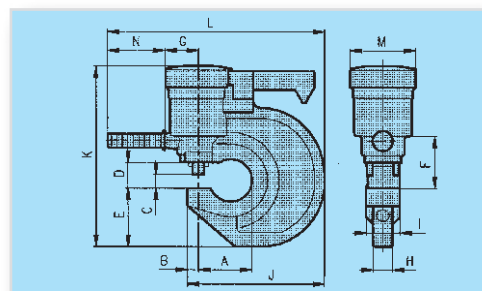
23181

Technical specifications

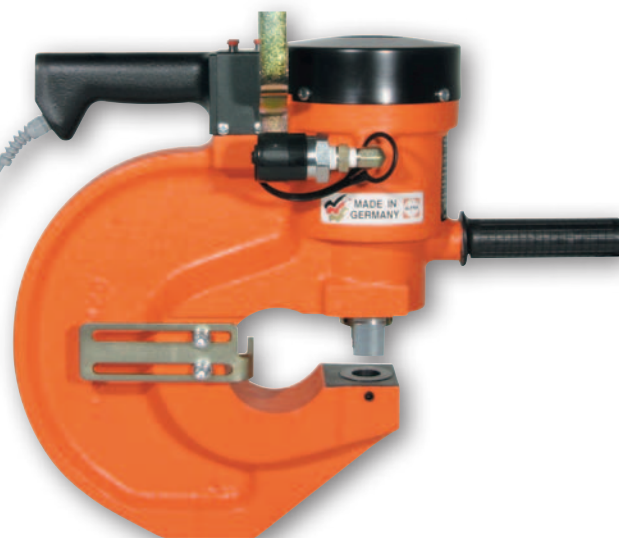
max. hole Ø mm	25 mm
max. oblong holes	25 x 18 mm
max. material thickness as per DIN S275	16 mm
total punch time	
with pump SC 17-D	8 sec.
throat depth	110 mm
max. pressure	700 bar (10.000 psi)
punching force	44 t
punch stroke	25 mm
weight	38.5 kg

Scope of Supply:

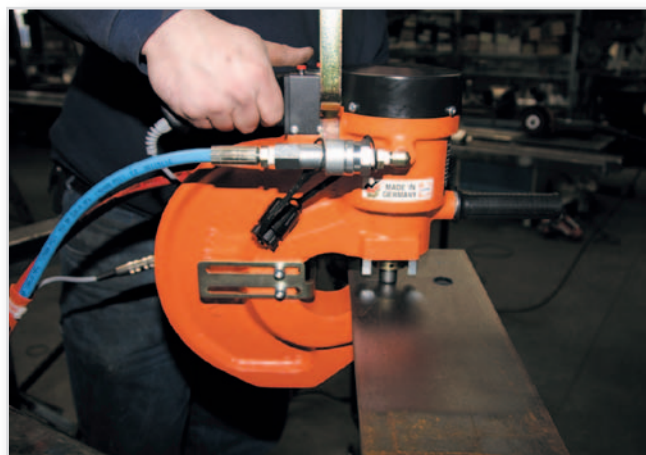
Punching unit, control cable, hydraulic hose 5 m, spanner, 1 x punch and die each Ø 22 mm, 1 depth adjustment, 1 suspension bracket



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



Prod.-No. 23181



Important technical notice:

Standard punching units are not normally suitable for punching high-strength tooling steel, stainless steels or boiler-plate steel. Refer to us for technical advice for punching work in this range of application.

ALFRA Hydraulic Pump SC 17D for APS 110D

Dual-action

Prod.-No.

ALFRA hydraulic pump SC 17D	230V 50 Hz	23186
ALFRA hydraulic pump SC 17D	230V 60 Hz	23186.230-60Hz*
ALFRA hydraulic pump SC 17D	110V 50 Hz	23186.110-50Hz*
ALFRA hydraulic pump SC 17D	110V 60 Hz	23186.110-60Hz*

* Upon request

With connection for double hose package

These new hydraulic pumps were developed in order to drastically reduce punching times. These are particularly suited to workshop use.

Technical specifications:

max. operating pressure	750 bar (10.670 psi)
pump output	50 HZ 1.40 l/min. at 1.370 rpm.
oil fill amount	17 l
single-phase motor, 1.450 rpm.	1.500 W 230 V 50 Hz
weight including oil fill volume	
and transport rollers	67 kg
dimensions L x W x H	550 x 370 x 560 mm



Connection for double hose package



Prod.-No. 23186

SC 17 D



APS Go

For all types of APS hydraulic punching units.



For all types of APS hydraulic punching units

APS GO enables you to easily move our punching units over the steel bar.

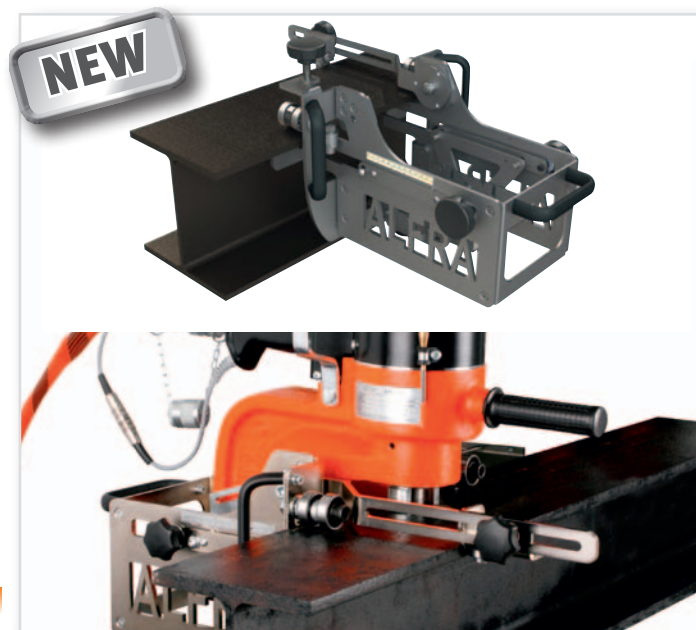
An adapter plate connects the punching unit to the moving system, and allows this to be removed at any time.

This generates enormous time savings, especially when punching at identical space intervals, as the measurement needs only to be set once, and the interval lengths are easy to measure.

Massive, solid heavy-duty rollers and the side-mounted hand grips enable completely effortless movement over the steel bar.

Dimensions (L x W x H): 700 x 355 x 280 mm

Weight: 14 kg / 30.8 lbs



Prod.-No.
23155

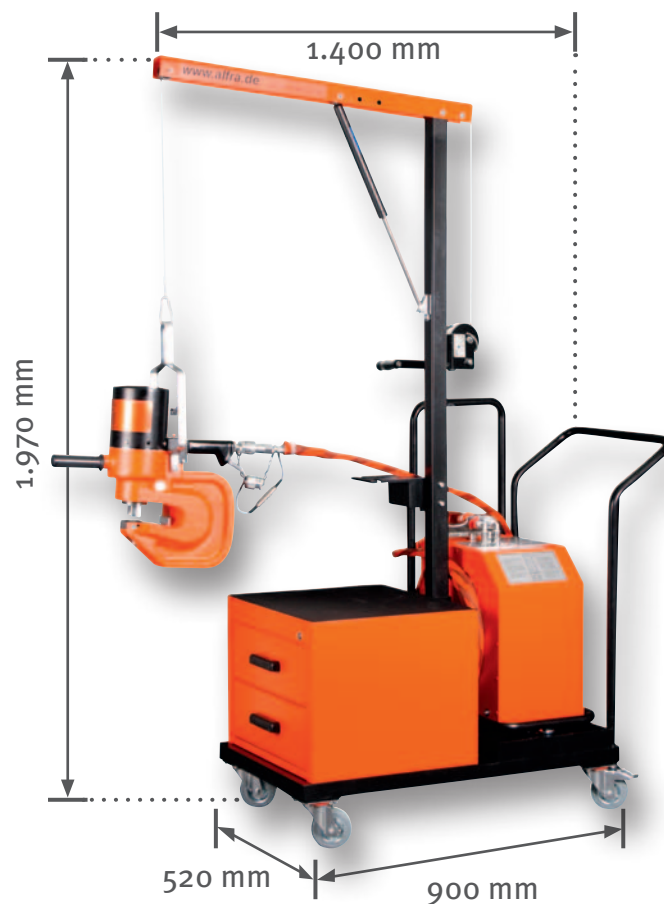
APS Go

SERVICE-BOY

For all types of APS hydraulic punching units

This practical, time and energy-saving trolley makes handling of our ALFRA Press hydraulic punching units much easier. Absolutely necessary for every steel and metal worker wherever punching units are already in use.

- Gas pressure shock absorbers allow the easy positioning of the punching head on the steel bar.
- The hydraulic pump remains on the trolley, and must not be dragged along behind you.
- Work tool cabinet with drawers for the clear arrangement of punching work tools and accessories.
- Solid and secure, TÜV-tested design – and more cost-effective than any "DIY-build".
- Dimensions (L x W x H): 900 x 520 x 1.970 mm
- Weight: 74 Kg / 163 lbs



Prod.-No.
23160

Service-Boy
Complete with tool cabinet and drawers

Prod.-No. 23160 (no punching unit / pump + accessories)

B



ALFRA – SPRING BALANCERS

For ALFRA-Press hydraulic hole punches

Prod.-No.

With **clamping device**, spring fracture safety device, wire rope hoist, 2.0 m

9362 B	15 - 20 kg	23150
9363 B	20 - 25 kg	23151
9366 B	35 - 45 kg	23152
9367 B	45 - 55 kg	23154

according to EN 15112

Note:

The spring balancer should only be operated when the punching unit is suspended and/or under load.



Prod.-No. 23152



Punch for

APS 120 / APS 110D	APS 70	APS 60	Ø mm	Ø Inches	Prod.-No.
■	■	■	7	1/4"	23-01-06-IN
■	■	■	8	5/16"	23-01-07
■	■	■	9		23-01-08-IN
■	■	■	10		23-01-08
■	■	■	11	3/8"	23-01-09
■	■	■	12		23-01-10-IN
■	■	■	13		23-01-10
■	■	■	14	7/16"	23-01-11
■	■	■	15		23-01-11-IN
■	■	■	16	1/2"	23-01-12
■	■	■	17		23-01-12-IN
■	■	■	18		23-01-13
■	■	■	19	9/16"	23-01-14
■	■	■	20		23-01-14-IN
■	■	■	21	5/8"	23-01-15
■	■	■	22		23-01-16-IN
■	■	■	23		23-01-16
■	■	■	24	11/16"	23-01-17
■	■	■	25		23-01-17-IN
■	■	■	26		23-01-18
■	■	■	27	3/4"	23-01-19
■	■	■	28		23-01-19-IN
■	■	■	29		23-01-20
■	■	■	30	13/16"	23-01-21
■	■	■	31		23-01-21-IN
■	■	■	32		23-01-22
■	■	■	33	7/8"	23-01-23
■	■	■	34		23-01-23-IN
■	■	■	35	15/16"	23-01-24
■	■	■	36		23-01-24-IN
■	■	■	37		23-01-25
■	■	■	38	1"	23-01-25-IN

*) with lock nut, Prod.-No. 23004-056 B

Dies for

APS 120 / APS 110D	APS 70	Ø mm	Ø Inches	Prod.-No.
■	■	7	1/4"	23-02-06-IN
■	■	8	5/16"	23-02-07
■	■	9		23-02-08-IN
■	■	10		23-02-08
■	■	11	3/8"	23-02-09
■	■	12		23-02-10-IN
■	■	13		23-02-10
■	■	14	7/16"	23-02-11
■	■	15		23-02-11-IN
■	■	16	1/2"	23-02-12
■	■	17		23-02-13-IN
■	■	18		23-02-13
■	■	19	9/16"	23-02-14
■	■	20		23-02-14-IN
■	■	21	5/8"	23-02-15
■	■	22		23-02-16-IN
■	■	23		23-02-16
■	■	24	11/16"	23-02-17
■	■	25		23-02-17-IN
■	■	26		23-02-18
■	■	27	3/4"	23-02-19
■	■	28		23-02-19-IN
■	■	29		23-02-20
■	■	30	13/16"	23-02-21
■	■	31		23-02-21-IN
■	■	32		23-02-22
■	■	33	7/8"	23-02-23
■	■	34		23-02-23-IN
■	■	35	15/16"	23-02-24
■	■	36		23-02-24-IN
■	■	37		23-02-25
■	■	38	1"	23-02-25-IN



Prod.-No. 23-01-..



Prod.-No. 23-02-..

Dies for

APS 60	Ø mm	Ø Inches	Prod.-No.
■	7		23-03-07
■	8		23-03-08
■	9		23-03-09
■	10		23-03-10
■	11		23-03-11
■	12		23-03-12
■	13		23-03-13
■	14		23-03-14
■	15		23-03-15
■	16		23-03-16
■	17		23-03-17
■	18		23-03-18

When selecting your tool, please note:

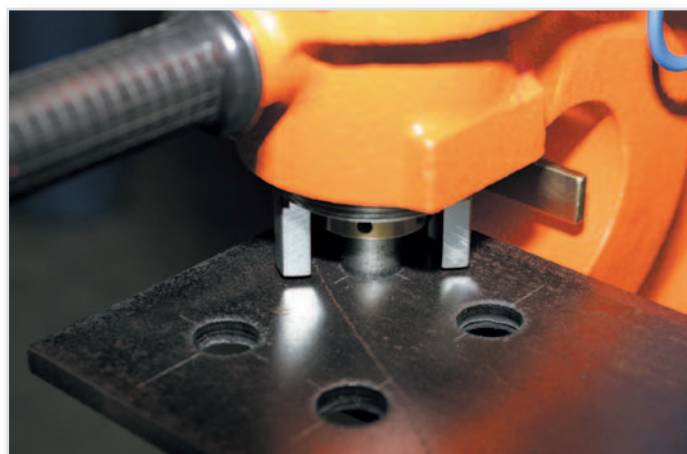
For material DIN S233: maximum material thickness = 0.8 x hole Ø
For material DIN S275: maximum material thickness = 0.5 x hole Ø

Tip:

Punches and dies can be replaced and used for Nitto / Selfer Punching systems.

Tip:

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





ALFRA – ORIGINAL TOOLS

Made in Germany by ALFRA

5°-bevelled dies for

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



Prod.-No. 23-04-.. (For girders with angled flanges)

Oblong punches for

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

*) with lock nut, Prod.-No. 23004-56B

Other dimensions are available upon request

Spare parts

	Prod.-No.
Spare HD connection cable, 5 m complete with control cable and coupling	23015
Spare HD connection cable, *10 m complete with control cable and coupling	23016
Spare HD connection cable, *15 m complete with control cable and coupling	23017
Spare HD connection cable, 5 m For APS 110D (dual-action) complete with control cable and coupling	23020

Note:

The pressure build-up extends at 10 m to approx. 4 sec., and at 15 m to approx. 6 sec.

Lock nut for punch Ø 7 - 24 mm	23004-056A
Lock nut for punch Ø 25 mm (APS 120 / 110D only)	23004-056B
Lock nut for punch Ø 26 mm (upon request)	23004-056C



Prod.-No. 23-02-..



Prod.-No. 23-01-..



Prod.-No. 23015



Prod.-No. 23020



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



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