



EN

FLOTT
Werkzeugmaschinen



2023
GENERAL CATALOG



MADE IN GERMANY

High Quality. By Tradition.

In 1854, a small family company was set up in Remscheid which developed braces and breast drill machines of the highest quality and produced these for the German market.

With these products, the Arnz FLOTT company wrote industrial history and is therefore regarded in industry circles as a "pioneer" of drilling technology. Today, due to its formidable experience and product quality, the company enjoys a noted position on the international market. Always close to its customers. Because with its partners in Europe, FLOTT is not only one of the most traditional, but also Europe's leading manufacturer of state-of-the-art, high quality drilling, grinding and sawing machines.

Tradition demands – innovation.

FLOTT never idles. As a future- and user-oriented company, FLOTT continuously invests nearly 5% of its annual turnover in its own research and development projects.

Permanent optimisations and, above all, intelligent, industry-oriented innovations in drilling, grinding and sawing technology – as evidenced by numerous patents, property rights, customer and design awards – are more than clear proof of the innovative strength and the legendary pioneering spirit of the company.

For the customers, the acquisition of a FLOTT machine, means being able to rely on having purchased a perfectly mature piece of drilling, grinding and sawing technology. The product always reflects the most state-of-the-art production technology. With a winning warranty thrown in: traditionally highest quality and service.

Service determines – customer satisfaction.

Our experienced employees are ready for action every day to ensure that machines and devices are always up to date – or in the event of a repair that downtimes are reduced to a minimum.



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FLOTT-FAN ARTICLES

www.flott.shop



- In our new FLOTT-FAN SHOP you will find everything you need for your workshop. Mugs, folding rulers, pens, pads - pick out something you fancy!



A bench drill

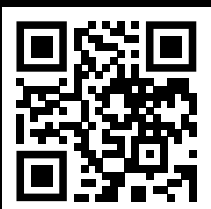
BEER TAP

Ever seen one of those before?

- ▶ For all FLÖTT fans, there is now the perfect addition to the workshop. You can get a freshly tapped, cool beer from our new table tap. The highlight for every party.
- ▶ The TZA 18 is a professional dispensing system with a cooling capacity of 18 litres of beer per hour.
- ▶ The system is supplied with an under-table unit, where there is plenty of room for the beer keg and the technology.

Only here: www.flott.shop




THE TZA18



Overview drilling machines

Machine	Drilling capacity /normal drilling performance in mm	Thread cutting performance	Revolutions per minute 1/min	Motor/FU kW	Page
Drilling machines-Vice [felix] 2.0					10
TB 10 Eco Plus	12		250-3,000	0.45 AC 230 V	14
TB 10 Basic Plus	12		250-3,000	0.45 AC 230 V	16
TB 10 Plus	10/12	max. M6	60-6,000	0.54 three-phase current, frequency-controlled, (network connection 230 V)	18
Turbo drill	6/8	max. M5	100-10,000	0.54 three-phase current, frequency-controlled, (network connection 230 V)	20
TB/TBZ/SB 13 Plus	13/15	max. M10	40-4,000	0.54 three-phase current, frequency-controlled, (network connection 230 V)	22
TB/TBZ/SB 15 Plus	15/18	max. M12	40-4,000	0.75 three-phase current, frequency-controlled, (network connection 230 V)	24
TB/TBZ/SB 18 Plus	18/20	max. M12	30-3,000	0.75 three-phase current, frequency-controlled, (network connection 230 V)	26
TB/TBZ/SB 20 Plus	20/23	max. M14	40-4,000	1.5 three-phase current, frequency-controlled, (400 V)	28
TB/TBZ/SB 23 Plus	R1 23/25 R2 20/23	R1 max. M16x1 R2 max. M12	20-2,000 R1 30-3,000 R2	1.5 three-phase current, frequency-controlled, (400 V)	30
TB/TBZ/SB 25 Plus	R1 23/25 R2 20/23	R1 max. M16x1 R2 max. M12	20-2,000 R1 30-3,000 R2	1.5 three-phase current, frequency-controlled, (400 V)	32
SB 30 Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M24x3 R2 max. M20x2.5 R3 max. M30x3.5	0-1,000 R1 0-1,600 R2 0-4,000 R3	3.0 three-phase current, frequency-controlled, (400 V)	34
SB 30 MV Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M24x3 R2 max. M20x2.5 R3 max. M30x3.5	0-1,000 R1 0-1,600 R2 0-4,000 R3	3.0 three-phase current, frequency-controlled, (400 V)	34
SB 30 NC Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M24x3 R2 max. M20x2.5 R3 max. M30x3.6	0-1,000 R1 0-1,600 R2 0-4,000 R3	3.0 three-phase current, frequency-controlled, (400 V)	36
SB 40 Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M30x3.5 R2 max. M24x3 R3 max. M36x4	0-1,000 R1 0-1,600 R2 0-4,000 R3	4.0 three-phase current, frequency-controlled, (400 V)	38
SB 40 MV Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M30x3.5 R2 max. M24x3 R3 max. M36x4	0-1,000 R1 0-1,600 R2 0-4,000 R3	4.0 three-phase current, frequency-controlled, (400 V)	38
SB 40 NC Plus	R1 27/32 R2 25/30 R3 30/35	R1 max. M30x3.5 R2 max. M24x3 R3 max. M36x4	0-1,000 R1 0-1,600 R2 0-4,000 R3	4.0 three-phase current, frequency-controlled, (400 V)	40
SB 20 FB Plus		M12	40-4,000	1.5 three-phase current, frequency-controlled, (400 V)	42
SB M3 ST	25/30	max. M20	125-4,000	0.9/1.45 three-phase current 400 pole-changeable	46
SB M5 ST	35/40	max. M30	100-2,000	1.5/3.0 three-phase current 400 V, pole-changeable	48
SB P30 ST	25/30	max. M20	125-4,000	0.9/1.45 three-phase current 400 pole-changeable	50
SB P30 STG PV	25/30	max. M20	125-4,000	0.9/1.45 three-phase current 400 pole-changeable	52
SB P40 ST	35/40	max. M30	100-2,000 R1 70-1,400 R2	1.5/3.0 three-phase current 400 V, pole-changeable	54
SB P40 STG PV	35/40	max. M30	100-2,000 70-1,400 R2	1.5/3.0 three-phase current 400 V, pole-changeable	56
GB 50 MV	50	max. M36	Gear stages	3.0 three-phase current 400 V	58
Multi-head drilling machine	on request				60

Colour description

Plus series	
Classic machines	
Gear drilling machines	

You can find the corresponding drill packages in the respective machine's technical data.

DRILLING TECHNOLOGY

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- ▶ 3-year warranty for single-shift operation (except GB 50 MV)
- ▶ Warranty extension to 4 or 5 years available! See 72-73

FLOTT Drilling Technology / Explanations

With its newly developed PLUS range of drilling machines, FLOTT offers a modular system that provides the user with an optimum selection in the drilling range from 0.5 to 50 mm.

The drilling machine types are **sorted** according to drilling or thread cutting capacity. The key **accessories / special equipment** are listed for the assemblies.

The FLOTT machines are characterised by modern, ergonomic **design**, and the technical progress has been documented with numerous **industrial property rights**.

Modern electronics such as **digital** depth and speed indicators and **electronic stepless** drives, have been part of FLOTT's standard equipment for years.

The robust construction and **durability** of our drilling machines are appreciated worldwide.

Safety has always been a top priority at FLOTT. That's why we observe all the current safety requirements.

Do you have any questions? The FLOTT team will be happy to advise you on your individual requirements!

Models



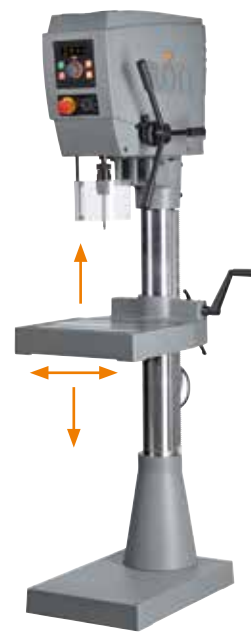
TB

Bench drill
with intermediate table
and optional base cabinet



TBZ

Bench drill
without intermediate table
with optional base cabinet



SB

Column drill press

Explanation of abbreviations

Flow forming
Mechanical feed, with electromagnetic clutch
Programmable feed with electromagnetic feed clutch, electronically controlled;
digital multifunction display
Gear drilling machine
Controlled z-axis (feed/return)

FB
MV
PV-
electronic
GB
NC

FLOTT drilling technology / control panel

The control panel with display (only for Plus Series)

- ▶ Clear control panel with central knob
- ▶ OLED display (Organic Light Emitting Diode)
Dust-protected with sealing lip in encased Hood cut-out

The menu functions

- ▶ Clear input menu that is easy to understand
- ▶ Selectable mode of operation: drilling/thread cutting
- ▶ Set the speed using the central knob
- ▶ Precisedisplay of drilling depth (target, actual), speed
- ▶ Counting function for drilling stroke
- ▶ Intelligent memory function for the parameters
- ▶ Energy-saving mode
- ▶ Spindle stop



The additional panel with touch operation (only for NC)

- ▶ Plus technology
- ▶ Programmable z-axis NC-Plus
- ▶ The 4.3" touch display is a convenient manmachine interface for programming the Z-axis (feed/reverse stroke).

It allows the selection of the following operating modes

- ▶ Drilling
- ▶ Reaming
- ▶ Countersinking
- ▶ Flow forming
- ▶ Thread cutting

In addition, there is the possibility of free programming



The (new) control panel with display (only for PV electronic)

- ▶ Overview of the most important functions, shown graphically
- ▶ Selectable mode of operation: drilling/thread cutting/drill feed
- ▶ Precise display of drilling depth (target, actual, speed)
- ▶ Optional additional functions can be easily activated and deactivated



HONORED

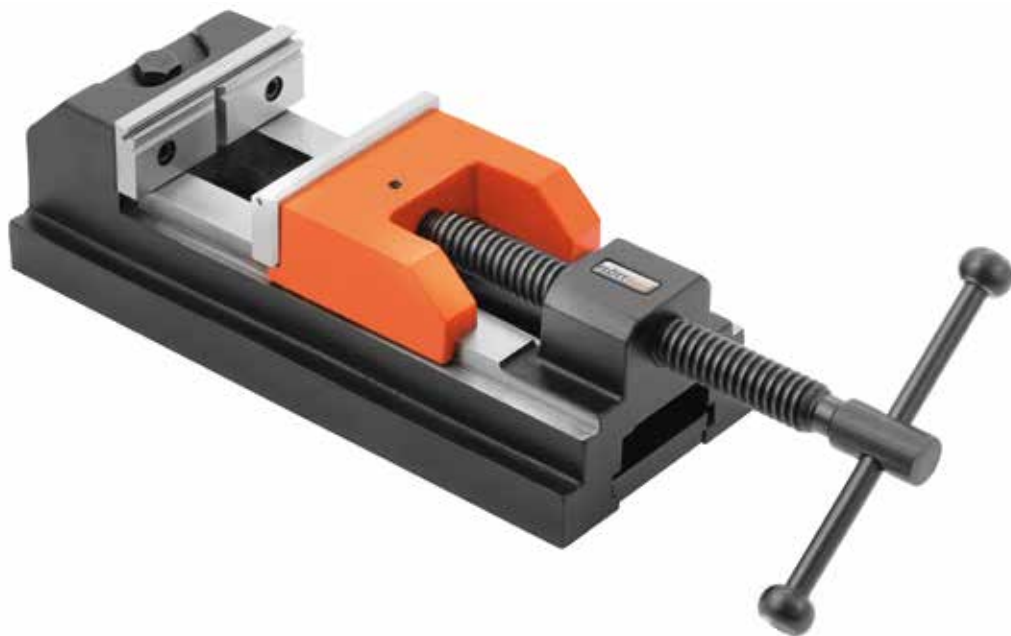
German
Labor Safety Award
2019

Drilling machines- Vice [felix] 2.0

FLÖTT [felix] 2.0

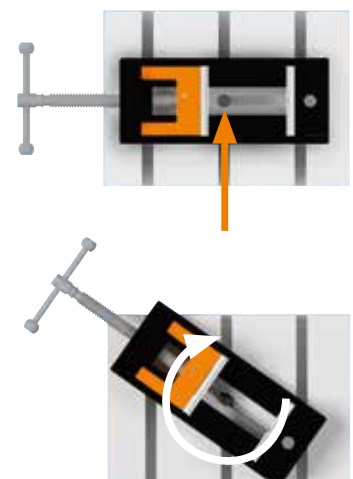
The drilling machine vice for free adjustable clamping of the workpiece.

Easy, fast, safe and better to use. The vice is clamped on the worktable in two easy steps, precisely adjusted and secured.



PLUS POINTS +++

- ▶ Patented clamping mechanism ensures that the vice can be clamped in one easy step
- ▶ No banging or turning of the vice, due to full work safety feature (anti-twist function)
- ▶ Freely positionable and full vice mobility
- ▶ **Short set-up time, fast clamping (up to 95 % time saving)**
- ▶ Increased travel and span



Standard equipment

- ▶ Prism jaws with shoulder, as well as horizontal and vertical recesses for clamping a wide range of workpieces
- ▶ Hardened and precision ground clamping jaws
- ▶ No additional clamping devices necessary



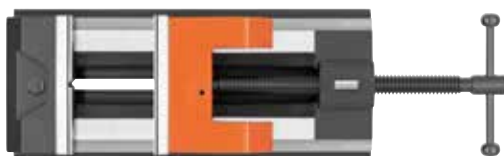
(felix) 80 2.0



(felix) 100 2.0



(felix) 120 2.0



(felix) 150 2.0

Technical data

Flott [felix] 80 2.0

Jaw width (mm)	80
Span width (mm)	0 - 120
Jaw height (mm)	28
Travel (mm)	150
Weight (kg)	11.6
Dimensions WxLxH (mm)	95 x 280 x 78
Order no.	281.140

Flott [felix] 100 2.0

Jaw width (mm)	100
Span width (mm)	0 - 135
Jaw height (mm)	32
Travel (mm)	165
Weight (kg)	12.8
Dimensions WxLxH (mm)	122 x 343 x 85
Order no.	281.141

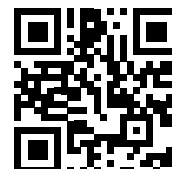
Flott [felix] 120 2.0

Jaw width (mm)	120
Span width (mm)	0 - 168
Jaw height (mm)	40
Travel (mm)	200
Weight (kg)	20.3
Dimensions WxLxH (mm)	140 x 395 x 105
Order no.	281.142

Flott [felix] 150 2.0

Jaw width (mm)	150
Span width (mm)	0 - 200
Jaw height (mm)	40
Travel (mm)	220
Weight (kg)	32.4
Dimensions WxLxH (mm)	170 x 451 x 103
Order no.	281.143

For further explanation, check our YouTube video!



PLUS POINTS +++ OUR SB P40 NC PLUS



Control panel with display

Convenient operation via 4.3" touch display.

High quality hood

Robust, high-quality hood, hinged at the side with ergonomically inclined front panel for better reading and input of machine and process parameters.

Main switch

Automatic feed drive with motor

This precise drive allows the cutting of M1.5 threads without a compensating chuck via synchronisation with the spindle speed.

Additional panel with touch operation

Programmable Z-axis NC Plus
Operating modes:
Drilling
Reaming
Countersinking
Flow forming
Thread cutting
Free programming

Switch lever automatic/manual

LED illumination

All machines have LED lighting as standard.

Optionally, there is another LED luminaire with articulated arm.

Large table surface working area

Optional machined base plate with integrated coolant system

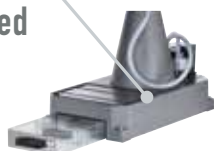


Fig.: SB 40 NC Plus with option

PLUS SERIES DRILLING MACHINES

Our Plus series drills with their sophisticated technology, stand for simple, intuitive operation and many new functions.

The control system with display and rotary knob is consistent across all the Plus drilling machines. Once trained, an operator can work on any machine immediately.

The belt drive* paired with German quality motors, frequency converters and innovative electronics result in powerful drills with high torques and a variable speed range.

The machines have a 3-year manufacturer's warranty for single-shift operation (optionally extendable on request).

The Plus Series is divided into three platforms:

- ▶ Small
bench and column drilling machines 10 - 15 Plus
- ▶ Medium
bench and column drilling machines 18 - 25 Plus
- ▶ Large
column drilling machines 30 - 40 Plus



* Optionally with electromagnetic double clutch
(speed series R3)

Bench drill in AC design TB 10 Eco ▶Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TB 10 Eco ▶Plus with special equipment

Standard equipment

- ▶ Robust, high-quality inclined rotary hood for easy reading of the speed
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Under-voltage release
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug (1.2 m)

Special equipment

- ▶ Height adjustment via threaded spindle
Order no. 290.302

Accessories

- ▶ Machine cabinet with door and intermediate plate
Height: 800 mm
Weight: 20 kg
Order no. 213.168
- ▶ Vice (felix) 80 2.0
Jaw width: 80 mm
Span: 0-120 mm
Order no. 281.140
- ▶ Twist drill set, DIN 338 HSSG
25-piece, ground, Split point 135°, Ø 1.0-13.0 x 0.5 mm
Order no. 285.124
- ▶ Quick-change drill chuck (1-13 mm), B16
rotational accuracy: 0.17 mm
Order no. 285.133
- ▶ Precision quick-change drill chuck ground, self-tightening, for clockwise/anti-clockwise rotation max. 8,000 1/min.
Span 1-13 mm
Socket B16
Rotational accuracy: 0.06 mm
Order no. 285.064

Drill package 1 (for B16)

- ▶ Vice [felix] 80 2.0
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.590



Technical data

Drilling capacity/normal drilling performance (mm)	10/12 (in E335/ST60)
Spindle	B16
Drilling depth (mm)	50
Distance column-spindle (mm)	180
Column diameter (mm)	50
Useable table surface (W x L) (mm)	300 x 200
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 100, 12/20
Speed indicator	digital
Drilling depth indicator	scale
Drilling depth stop	Quick-adjust thrust ring
Feed	by hand
Head/height adjustment	by hand
Three-phase current motor 230 V with frequency converter (kW)	0.45
Spindle speed, stepless (1/min)	250-3,000

TB 10 Eco Plus

Distance spindle/working surface (mm)	105-245
Machine dimensions without VP (mm)	400 x 248 x 460
Machine dimensions with VP (mm)	430 x 680 x 810
Weight (kg)	30

Order no. 217.200

Additional accessories from page 62

Bench drill

TB 10 Basic ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73



Fig.: TB 10 Basic ▶ Plus with special equipment

Fig.: TB 10 Basic ▶ Plus optional with intermediate table

Standard equipment

- ▶ Robust, high-quality inclined rotary hood for easy reading of the speed
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Under-voltage release
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug (1.2 m)

Special equipment

- ▶ Drill depth fixed stop for optimum repetition accuracy
Order no. 212.716

Accessories

- ▶ Machine cabinet with door and drawer
Height: 840 mm
Weight: 28 kg
Order no. 250.208
- ▶ Vice (felix) 80 2.0
Jaw width: 80 mm
Span: 0-120 mm
Order no. 281.140
- ▶ Quick-change drill chuck B16
Span range 1-13 mm
Rotational accuracy: 0.17 mm
Order no. 285.133
- ▶ Precision quick-change ground drill chuck self-tightening, for clockwise/anti-clockwise rotation max. 8,000 1/min.
Span range 1-13 mm
Socket B16
Rotational accuracy: 0.06 mm
Order no. 285.064

Drill package 1 (for B16)

- ▶ Vice (felix) 80 2.0
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.590



Technical data

Drilling capacity/normal drilling performance (mm)	12 (in E335/ST60)
Spindle	B16
Drilling depth (mm)	60
Distance column-spindle (mm)	220
Column diameter (mm)	70
Useable table surface (W x L) (mm)	300 x 250
T-slot size (arm), distance (mm), width measurement (mm)	Cross slots, quantity 2, 14/26
Speed indicator	digital
Drilling depth indicator	scale
Drilling depth stop	Quick-adjust thrust ring
Feed	by hand
Head/height adjustment	by hand
Three-phase current motor 230 V with (kW)	0.45
Spindle speed, stepless (1/min)	250-3,000

TB 10 Basic Plus

Distance spindle/working surface (mm)	105-245
Machine dimensions without VP (mm)	320 x 520 x 820
Machine dimensions with VP (mm)	452 x 700 x 1,130
Weight (kg)	44
Order no. (with drill head height adjustment)	217.400
Order no. (with intermediate table and table height adjustment via toothed rack)	217.410

Additional accessories from page 62

Bench drill

TB 10 ▶Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73



Fig.: TB 10 ▶Plus with special equipment

Fig.: TB 10 ▶Plus optional with intermediate table

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug

Special equipment

- ▶ Table height adjustment via toothed rack table with T-slots (instead of head height adjustment)
Useable table surface (W x L): 300 x 250 mm
Order no. 290.521
- ▶ Drill depth fixed stop for optimum repetition accuracy
Order no. 212.716

Accessories

- ▶ Machine cabinet with door and drawer
Height: 840 mm
Weight: 28 kg
Order no. 250.208
- ▶ Vice (felix) 80 2.0
Jaw width: 80 mm
Span: 0-120 mm
Order no. 281.140
- ▶ Quick-change drill chuck B16
Span range 1-13 mm
Rotational accuracy: 0.17 mm
Order no. 285.133
- ▶ Precision quick-change ground drill chuck self-tightening, for clockwise/anti-clockwise rotation max. 8,000 1/min.
Span range 1-13 mm
Socket B16
Rotational accuracy: 0.06 mm
Order no. 285.064
- ▶ Tap holder M4-M12 DIN 371
Span: 1-10 mm
Socket: B16
Total length: 80 mm
Order no. 285.109

Technical data

Drilling capacity/normal drilling performance (mm)	10/12 (in E335/ST60)
Thread-cutting performance (depending on gradient) max.	M6
Spindle	B16
Drilling depth (mm)	60
Distance column-spindle (mm)	220
Column diameter (mm)	70
Useable table surface (W x L) (mm)	300 x 250
T-slot size (arm), distance (mm), width measurement (mm)	Cross slots, quantity 2, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Stop ring (positive-locking)
Feed	by hand
Head/height adjustment	by hand
Three-phase current motor 230 V with frequency converter (kW)	0.54
Spindle speed, stepless (1/min)	60-6,000

TB 10 Plus*

Distance spindle/working surface (mm)	140-315
Machine dimensions without VP (mm)	320 x 520 x 820
Machine dimensions with VP (mm)	452 x 700 x 1,130
Weight (kg)	44
Order no.	212.505

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Drill package 1 (for B16)

- ▶ Vice [felix] 80 2.0
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.590



Bench drill

Turbo drill



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73



Fig.: Turbo drill with special equipment

Fig.: Turbo drill optional with intermediate table

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug

Special equipment

- ▶ Table height adjustment via toothed rack table with T-slots (instead of head height adjustment)
Useable table surface (W x L): 300 x 250 mm
Order no. 290.521
- ▶ Drill depth fixed stop for optimum repetition accuracy
Order no. 212.716

Accessories

- ▶ Machine cabinet with door and drawer
Height: 840 mm
Weight: 28 kg
Order no. 250.208
- ▶ Vice (felix) 80 2.0
Jaw width: 80 mm
Span: 0-120 mm
Order no. 281.140
- ▶ Gear rimmed drill chuck for Turbo drill, B12
Span 0.5-8 mm
Rotational accuracy: 0.20 mm
Order no. 285.103
- ▶ Precision quick-change drill chuck for Turbo drill, B12
Span 0.5-6 mm
Rotational accuracy: 0.05 mm
Order no. 285.104

Technical data

Drilling capacity/normal drilling performance (mm)	6/8 (in E335/ST60)
Thread-cutting performance (depending on gradient) max.	M5
Spindle	B12
Drilling depth (mm)	60
Distance column-spindle (mm)	220
Column diameter (mm)	70
Useable table surface (W x L) (mm)	300 x 250
T-slot size (arm), distance (mm), width measurement (mm)	Cross slots, quantity 2, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Stop ring (positive-locking)
Feed	by hand
Head/height adjustment	by hand
Three-phase current motor 230 V with frequency converter (kW)	0.54
Spindle speed, stepless (1/min)	100 - 10,000

Turbo drill*

Distance spindle/working surface (mm)	140-315
Machine dimensions without VP (mm)	320 x 520 x 820
Machine dimensions with VP (mm)	452 x 700 x 1,130
Weight (kg)	44
Order no.	212.506
Additional accessories	from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Bench drill and column drill

TB 13 ▶ Plus

TBZ 13 ▶ Plus

SB 13 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TB 13 ▶ Plus with B16 and special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug

Special equipment

- ▶ Drill depth fixed stop for optimum repetition accuracy
Order no. 212.716

Accessories

- ▶ Machine cabinet with door and drawer (only for TB 13 Plus)
Height: 840 mm
Weight: 28 kg
Order no. 250.208
- ▶ Machine cabinet with door for TB/TBZ and intermediate plate
Height: 800 mm, weight: 36 kg
Order no. 212.860 (TB)
Order no. 201.160 (TBZ)

Drill package 1 (for B16)

- ▶ Vice [felix] 80 2.0
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.590

Drill package 2 (for MK II)

- ▶ Vice [felix] 80 2.0
- ▶ Taper mandrel MK II/B16
- ▶ Reduction sleeve MK II/MK I
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.591



Technical data

Drilling capacity/normal drilling performance (mm)	13/15 (in E335/ST60) 12Nm
Thread-cutting performance (depending on gradient) max.	M10
Spindle	B16, optional MK II
Drilling depth (mm)	60
Distance column-spindle (mm)	220
Column diameter (mm)	70
Useable table surface (W x L) (mm)	300 x 250
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Stop ring (positive-locking)
Feed	by hand
Table height adjustment	with toothed rack
Three-phase current motor 230 V with frequency converter (kW)	0.54
Spindle speed, stepless (1/min)	40-4,000

TB 13 Plus*

Distance spindle/working surface (mm)	85-370
Machine dimensions without VP (mm)	400 x 520 x 850
Machine dimensions with VP (mm)	452 x 700 x 1130
Weight (kg)	62
Order no. B16	212.500
Order no. MKII	212.503

TBZ 13 Plus*

Distance spindle/working surface (mm)	125-490
Centre offset	20 mm
Distance column-spindle (mm)	214
Column diameter (mm)	82
Machine dimensions (mm)	
with cabinet	370 x 495 x 1,800
with cabinet with VP	940 x 570 x 2,140
without cabinet	355 x 485 x 1,027
without cabinet with VP	940 x 570 x 1,600
Weight without cabinet (kg)	70
Order no. B16	212.650
Order no. MKII	212.655

SB 13 Plus*

Distance spindle/working surface (mm)	max. 750
Machine dimensions without VP (mm)	420 x 540 x 1,780w
Machine dimensions with VP (mm)	572 x 936 x 2,142
T-slot size, distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Weight (kg)	85
Order no. B16	212.502
Order no. MKII	212.504

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Bench drill and column drill

TB 15 ▶ Plus

TBZ 15 ▶ Plus

SB 15 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TB 15 ▶ Plus with special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug

Special equipment

- ▶ Drill depth fixed stop for optimum repetition accuracy
Order no. 212.716

Accessories

- ▶ Machine cabinet with door and drawer (only for TB 15 Plus)
Height: 840 mm
Weight: 28 kg
Order no. 250.208
- ▶ Machine cabinet with door for TB/TBZ and intermediate plate
Height: 800 mm, Weight: 36 kg
Order no. 212.860 (TB)
Order no. 201.160 (TBZ)
- ▶ Foot switch for clockwise and anti-clockwise rotation
Order no. 212.780

Drill package 2 (for MK II)

- ▶ Vice [felix] 80 2.0
- ▶ Taper mandrel MK II/B16
- ▶ Reduction sleeve MK II/MK I
- ▶ Quick-change drill chuck B16 1-13 mm (accuracy 0.17 mm)
Order no. 296.591



* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Technical data

Drilling capacity/normal drilling performance (mm)	15/18 (in E335/ST60) 17 Nm
Thread-cutting performance (depending on gradient) max.	MK12
Spindle	MK II
Drilling depth (mm)	70
Distance column-spindle (mm)	220
Column diameter (mm)	70
Useable table surface (W x L) (mm)	300 x 250
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Stop ring (positive-locking)
Feed	by hand
Table height adjustment	with toothed rack
Three-phase current motor 230 V with frequency converter (kW)	0.75
Spindle speed, stepless (1/min)	40-4,000

TB 15 Plus*

Distance spindle/working surface (mm)	85-370
Machine dimensions without VP (mm)	400 x 520 x 850
Machine dimensions with VP (mm)	452 x 700 x 1130
Weight (kg)	65
Order no.	212.755

TBZ 15 Plus*

Distance spindle/working surface (mm)	125-490
Centre offset	20 mm
Distance column-spindle (mm)	214
Column diameter (mm)	82
Machine dimensions (mm)	
with cabinet	370 x 495 x 1,800
with cabinet with VP	940 x 570 x 2,140
without cabinet	355 x 485 x 1,027
without cabinet with VP	940 x 570 x 1,600
Weight without cabinet (kg)	73
Order no.	212.765

SB 15 Plus*

Distance spindle/working surface (mm)	max. 750
Useable table surface (W x L) (mm)	300 x 240
Machine dimensions without VP (mm)	420 x 540 x 1,780
Machine dimensions with VP (mm)	572 x 936 x 2,142
T-slot size, distance (mm), width measurement (mm)	Quantity 2, 125, 14/26
Weight (kg)	88
Order no.	212.750

Additional accessories from page 62

Bench drill and column drill

TB 18 ▶ Plus

TBZ 18 ▶ Plus

SB 18 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TB 18 ▶ Plus with special equipment

Fig.: SB 18 ▶ Plus

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with two-pin earthed plug

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Machined base plate incl. integrated coolant system (only SB models)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160A
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340

Accessories

- ▶ Machine cabinet with door for TB/TBZ
Height: 800 mm
Weight: 36 kg
Order no. 201.160
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 225.029

Drill package 3

- ▶ Vice [felix] 100 2.0
- ▶ Taper mandrel MK II/B18
- ▶ Reduction sleeve MK II/MK I
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.592



Technical data

Drilling capacity/normal drilling performance (mm)	18/20 (in E335/ST 60) 22 Nm
Thread cutting performance max. (depending on gradient)	M12
Spindle	MK II
Drilling depth (mm)	100
Distance column-spindle (mm)	240
Column diameter (mm)	82
Useable table surface (W x L) (mm)	340 x 280
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Quick-adjust thrust ring
Feed	by hand
Table height adjustment	with toothed rack
Three-phase current motor 230 V with frequency converter (kW)	0.75
Spindle speed, stepless (1/min)	30-3,000

TB 18 Plus*

Distance spindle - working surface (mm)	
Table	155-415
Base	155-550
Machine dimensions without VP (mm)	355 x 705 x 1,065
Machine dimensions with VP (mm)	570 x 940 x 1,612
Weight (kg)	170
Order no.	218.303

TBZ 18 Plus*

Distance spindle - working surface (mm)	
Base	155-550
Column diameter (mm)	82
Machine dimensions (mm)	
with cabinet	370 x 705 x 1,845
with cabinet with VP	572 x 940 x 2,140
without cabinet	355 x 705 x 1,045
without cabinet with VP	570 x 940 x 1,600
Weight without cabinet (kg)	155
Order no.	218.309

SB 18 Plus*

Spindle/table (mm)	160-880
Machine dimensions without VP (mm)	355 x 705 x 1,825
Machine dimensions with VP (mm)	572 x 936 x 2,142
Weight (kg)	195
Order no.	218.308

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Bench drill and column drill

TB 20 ▶ Plus

TBZ 20 ▶ Plus

SB 20 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TB 20 ▶ Plus with special equipment

Fig.: SB 20 ▶ Plus with special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Machined base plate incl. integrated coolant system (only SB models)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160A
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 225.029

Accessories

- ▶ Machine cabinet with door for TB/TBZ
Height: 800 mm
Weight: 36 kg
Order no. 201.160

Drill package 3

- ▶ Vice [felix] 100 2.0
- ▶ Taper mandrel MK II/B18
- ▶ Reduction sleeve MK II/MK I
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.592



Technical data

Drilling capacity/normal drilling performance (mm)	20/23 (in E335/ST60)
Thread cutting performance max. (depending on gradient)	M12
Spindle	MK II
Drilling depth (mm)	100
Distance column-spindle (mm)	240
Column diameter (mm)	82
Useable table surface (W x L) (mm)	340 x 280
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Quick-adjust thrust ring
Feed	by hand
Table height adjustment	with toothed rack
Three-phase current motor 400 V with frequency converter (kW)	1.5
Spindle speed, stepless (1/min)	40-4,000

TB 20 Plus*

Distance spindle - working surface (mm)	
Table	155-415
Base	155-550
Machine dimensions without VP (mm)	355 x 705 x 1,065
Machine dimensions with VP (mm)	570 x 940 x 1,612
Weight (kg)	170
Order no.	220.105

TBZ 20 Plus*

Distance spindle - working surface (mm)	
Base	155-550
Column diameter (mm)	82
Machine dimensions (mm)	
with cabinet	370 x 705 x 1,845
with cabinet with VP	572 x 940 x 2,140
without cabinet	355 x 705 x 1,045
without cabinet with VP	570 x 940 x 1,600
Weight without cabinet (kg)	155
Order no.	220.110

SB 20 Plus*

Spindle/table (mm)	160-880
Machine dimensions without VP (mm)	355 x 705 x 1,825
Machine dimensions with VP (mm)	572 x 936 x 2,142
Weight (kg)	195
Order no.	220.100

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Bench drill and column drill

TB 23 ▶ Plus

TBZ 23 ▶ Plus

SB 23 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TBZ 23 ▶ Plus with special equipment

Fig.: SB 23 ▶ Plus with special equipment

Standard equipment

- ▶ Main switch
- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Machined base plate incl. integrated Coolant device (SB version only)
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160B
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 225.029

Accessories

- ▶ Machine cabinet with door for TB/TBZ
Height: 800 mm, Weight: 36 kg
Order no. 205.160

Drill package 3

- ▶ Vice [felix] 100 2.0
- ▶ Taper mandrel MK II/B18
- ▶ Reduction sleeve MK II/MK I
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.592



* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Technical data

Drilling capacity/normal drilling performance (mm)	R1	23/25 (in E335/ST60)
	R2	20/23 (in E335/ST60)
Thread cutting capacity max. (depending on gradient)	R1	M16x1
	R2	M12
Spindle		MK II
Drilling depth (mm)		100
Distance column-spindle (mm)		260
Column diameter (mm)		110
Useable table surface (W x L) (mm)		420 x 340
T-slot size (arm), distance (mm), width measurement (mm)		Quantity 2, 125, 13/26
Speed indicator		digital
Drilling depth indicator		digital
Drilling depth stop		Quick-adjust thrust ring
Feed		by hand
Table height adjustment		with toothed rack
Three-phase current motor 400 V with frequency converter (kW)		1.5
Spindle speed, stepless (1/min) with gearing		R1 20-2,000 R2 30-3,000

TB 23 Plus*

Distance spindle - working surface (mm)	
Table	230-590
Base	230-670
Machine dimensions without VP (mm)	430 x 715 x 1,250
Machine dimensions with VP (mm)	570 x 940 x 1,600
Weight (kg)	250
Order no. R1	223.021
Order no. R2	223.026

TBZ 23 Plus*

Distance spindle - working surface (mm)	
Base	230-730
Machine dimensions (mm)	
with cabinet	430 x 715 x 2,050
with cabinet with VP	637 x 1,096 x 2,120
without cabinet	430 x 715 x 1,250
without cabinet with VP	570 x 940 x 1,600
Weight without cabinet (kg)	235
Order no. R1	223.022
Order no. R2	223.027

SB 23 Plus*

Spindle/table	230-850
Machine dimensions without VP (mm)	430 x 715 x 1,800
Machine dimensions with VP (mm)	670 x 1,100 x 2,140
Weight (kg)	290
Order no. R1	223.020
Order no. R2	223.025

Additional accessories from page 62

Bench drill and column drill

TB 25 ▶ Plus

TBZ 25 ▶ Plus

SB 25 ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: TBZ 25 ▶ Plus with special equipment

Fig.: SB 25 ▶ Plus with special equipment

Standard equipment

- ▶ Main switch
- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Machined base plate incl. integrated Coolant device (SB version only)
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160B
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 225.029

Accessories

- ▶ Machine cabinet with door for TB/TBZ
Height: 800 mm, Weight: 36 kg
Order no. 205.160

Drill package 4

- ▶ Vice [felix] 120 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.593



* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Technical data

Drilling capacity/normal drilling performance (mm)	R1 R2	23/25 (in E335/ST 60) 20/23 (in E335/ST 60)
Thread cutting capacity max. (depending on gradient)	R1 R2	M16x1 M12
Spindle		MK III
Drilling depth (mm)		115
Distance column-spindle (mm)		260
Column diameter (mm)		110
Useable table surface (W x L) (mm)		420 x 340
T-slot size (arm), distance (mm), width measurement (mm)		Quantity 2, 125, 13/26
Speed indicator		digital
Drilling depth indicator		digital
Drilling depth stop		Quick-adjust thrust ring
Feed		by hand
Table height adjustment		with toothed rack
Three-phase current motor 400 V with frequency converter (kW)		1.5
Spindle speed, stepless (1/min) with gearing	R1 R2	20-2,000 30-3,000

TB 25 Plus*

Distance spindle - working surface (mm)		
Table		230-590
Base		230-670
Machine dimensions without VP (mm)		430 x 715 x 1,250
Machine dimensions with VP (mm)		570 x 940 x 1,600
Weight (kg)		250
Order no. R1		225.011
Order no. R2		225.016

TBZ 25 Plus*

Distance spindle - working surface (mm)		
Base		230-730
Machine dimensions (mm)		
with cabinet		430 x 715 x 2,050
with cabinet with VP		637 x 1,096 x 2,120
without cabinet		430 x 715 x 1,250
without cabinet with VP		570 x 940 x 1,600
Weight without cabinet (kg)		235
Order no. R1		225.012
Order no. R2		225.017

SB 25 Plus*

Spindle/table		230-850
Machine dimensions without VP (mm)		430 x 715 x 1,800
Machine dimensions with VP (mm)		670 x 1,100 x 2,140
Weight (kg)		290
Order no. R1		225.010
Order no. R2		225.015

Additional accessories from page 62

Column drill

SB 30 ▶Plus

SB 30 MV ▶Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB 30 ▶Plus with special equipment

Fig.: SB 30 MV ▶Plus with special equipment

Standard equipment

- ▶ Main switch
- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop switch
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug
- ▶ Mechanical feed for z-axis incl. electromagnetic clutch for (3) feed speeds (only SB 30 MV Plus)
- ▶ Drill handle with push-button (on/off) for feed (only SB 30 MV Plus)
- ▶ In thread cutting mode: Right-left ventilation via drill handle button (only SB 30 MV Plus)

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240 for 230.500 and 230.501
Order no. 290.241 for 230.502 and 230.506 and 230.507
- ▶ Combi drilling table with vice and square table 360° rotatable with scale
Jaw width 120 mm, span 105 mm
Table surface 350 x 350 mm
Order no. 290.135
- ▶ Machined foot plate
Order no. 290.175C
- ▶ Machined foot plate incl. integrated coolant system
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160C
- ▶ Coolant system (separate tank)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF (for MV feed ON and OFF)
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 231.000
- ▶ Commissioning the machine and briefing the operating staff
Order no. 229.931

Technical data

Drilling capacity/normal drilling performance (mm)	
R1 (measured Torque Nm)	27/32 (in E335/ST60) (100)
R2 (measured torque Nm)	25/30 (in E335/ST60) (70)
R3 (measured torque Nm)	30/35 (in E335/ST60) (200)
Thread cutting performance max. (depending on gradient)	
R1	M24x3
R2	M20x2.5
R3	M30x3.5
Spindle	MK III
Drilling depth (mm)	125
Distance column-spindle (mm)	300
Column diameter (mm)	125
Useable table surface (W x L) (mm)	590 x 450
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Spindle/table (mm)	150-700
Machine dimensions without VP (mm)	610 x 900 x 1,980
Machine dimensions with VP (mm)	670 x 1,100 x 2,140
Three-phase current motor 400 V with frequency converter (kW)	3.0
Spindle speed, stepless (1/min)	
R1 (1-stage)	0-1,000
R2 (1-stage)	0-1,600
R3 (2-stage with gearing)	0-4,000

SB 30 Plus

Feed	by hand
Weight (kg)	370
Order no. R1	230.500
Order no. R2	230.501
Order no. R3	230.502

SB 30 MV Plus

Feed (mm/rotation)	0.10/0.16/0.25
Weight (kg)	385
Order no. R1	230.505
Order no. R2	230.506
Order no. R3	230.507

Additional accessories from page 62

Accessories

Drill package 5

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.594



* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Column drill SB 30 NC ▶Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB 30 NC ▶Plus with special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop switch
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug
- ▶ Switch lever for manual/automatic mode
- ▶ Easy-read control panel with central metal knob
- ▶ Easily understandable input menu
- ▶ Selectable mode of operation: drilling/thread cutting
- ▶ Counting function for drilling stroke
- ▶ Additional panel for automatic mode (activation by moving switch lever to automatic)
- ▶ 4.3" touchscreen display
- ▶ Comfort operator/machine interface for programming the spindle sleeve feed
- ▶ Selectable mode of operation: Drilling, reaming, countersinking, flow forming, thread cutting
- ▶ Free-programming function
- ▶ Choice of machine settings

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.241
- ▶ Combi drilling table with vice and square table 360° rotatable with scale
Jaw width 120 mm, span 105 mm
Table surface 350 x 350 mm
Order no. 290.135
- ▶ Machined foot plate
Order no. 290.175C
- ▶ Machined foot plate incl. integrated coolant system
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160C
- ▶ Coolant system (separate tank)
Filling quantity: max. 30 l/min
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation

Technical data

Drilling capacity/normal drilling performance (mm)	
R1 (measured torque Nm)	27/32 (in E335/ST60) (100)
R2 (measured torque Nm)	25/30 (in E335/ST60) (70)
R3 (measured torque Nm)	30/35 (in E335/ST60) (200)
Thread cutting performance max. (depending on gradient)	
R1	M24x3
R2	M20x2.5
R3	M30x3.5
Spindle	MK III
Drilling depth (mm)	125
Distance column-spindle (mm)	300
Column diameter (mm)	125
Useable table surface (W x L) (mm)	590 x 450
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Spindle/table (mm)	150-700
Machine dimensions without VP (mm)	610 x 900 x 1,980
Machine dimensions with VP (mm)	670 x 1,100 x 2,200
Three-phase current motor 400 V with frequency converter (kW)	3.0
Spindle speed, stepless (1/min)	
R1 (1-stage)	0-1,000
R2 (1-stage)	0-1,600
R3 (2-stage with gearing)	0-4,000

SB 30 NC Plus

Feed/return stroke, infinitely variable (m/min)	0-1.5
Weight (kg)	400
Order no. R1	230.510
Order no. R2	230.511
Order no. R3	230.512

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

For AUTO: Programme start/stop
Order no. 231.000

- ▶ Commissioning the machine and briefing the operating staff
Order no. 229.931

Accessories

Drill package 5

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.594



Column drill

SB 40 ▶ Plus

SB 40 MV ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB 40 ▶ Plus with special equipment

Fig.: SB 40 MV ▶ Plus with special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop switch
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug
- ▶ Mechanical feed for z-axis incl. electromagnetic clutch for (3) feed speeds (only 40 MV Plus)
- ▶ Drill handle with push-button (on/off) for feed (only 40 MV Plus)
- ▶ In thread cutting mode: Right-left ventilation via drill handle button (only SB 40 MV Plus)

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240 for 230.530 and 230.531
Order no. 290.241 for 230.532 and 230.536 and 230.537
- ▶ Machined foot plate
Order no. 290.175D
- ▶ Combi drilling table with vice and square table 360° rotatable with scale, jaw width 120 mm, span 105 mm, column diameter 125 mm (deviating), table surface 350 x 350 mm
Order no. 290.138
- ▶ Machined foot plate incl. integrated coolant system
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160D
- ▶ Coolant system (separate tank)
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF (for MV feed ON and OFF)
Thread cutting function: Clockwise/anti-clockwise rotation
Order no. 231.000
- ▶ Commissioning the machine and briefing the operating staff
Order no. 229.931

Technical data

Drilling capacity/normal drilling performance (mm)	
R1 (measured torque Nm)	30/35 (in E335/ST60) (135)
R2 (measured torque Nm)	27/32 (in E335/ST60) (90)
R3 (measured torque Nm)	35/40 (in E335/ST60) (260)
Thread cutting performance max. (depending on gradient)	
R1	M30x3.5
R2	M24x3
R3	M36x4
Spindle	MK IV
Drilling depth (mm)	160
Distance column-spindle (mm)	300
Column diameter (mm)	140
Useable table surface (W x L) (mm)	590 x 450
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Spindle/table (mm)	150-700
Machine dimensions without VP (mm)	610 x 900 x 1,980
Machine dimensions with VP (mm)	670 x 1,100 x 2,200
Three-phase current motor 400 V with frequency converter (kW)	4.0
Spindle speed, stepless (1/min)	
R1 (1-stage)	0-1,000
R2 (1-stage)	0-1,600
R3 (2-stage with gearing)	0-4,000

SB 40 Plus

Feed	by hand
Weight (kg)	400
Order no. R1	230.530
Order no. R2	230.531
Order no. R3	230.532

SB 40 MV Plus

Feed (mm/rotation)	0.10/0.16/0.25
Weight (kg)	420
Order no. R1	230.535
Order no. R2	230.536
Order no. R3	230.537

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

Accessories

Drill package 6

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK IV/B18
- ▶ Reduction sleeve MK IV/MK III
- ▶ Reduction sleeve MK IV/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.595



Column drill SB 40 NC ▶Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB 40 NC ▶Plus with special equipment

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop switch
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug
- ▶ Switch lever for manual/automatic mode
- ▶ Easy-read control panel with central metal knob
- ▶ Easily understandable input menu
- ▶ Selectable mode of operation: drilling/thread cutting
- ▶ Counting function for drilling stroke
- ▶ Additional panel for automatic mode (activation by moving switch lever to automatic)
- ▶ 4.3" touchscreen display
- ▶ Comfort operator/machine interface for programming the spindle sleeve feed
- ▶ Selectable mode of operation: Drilling, reaming, countersinking, flow forming, thread cutting
- ▶ Free-programming function
- ▶ Choice of machine settings

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.241
- ▶ Machined foot plate
Order no. 290.175D
- ▶ Combi drilling table with vice and square table 360° rotatable with scale, jaw width 120 mm, span 105 mm, column diameter 125 mm (deviating), table surface 350 x 350 mm
Order no. 290.138
- ▶ Machined foot plate incl. integrated coolant system
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160D
- ▶ Coolant system (separate tank)
Filling quantity: max. 30 l/min
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Foot switch
Drilling function: Spindle ON and OFF
Thread cutting function: Clockwise/anti-clockwise rotation

Technical data

Drilling capacity/normal drilling performance (mm)	
R1 (measured torque Nm)	30/35 (in E335/ST60) (135)
R2 (measured torque Nm)	27/32 (in E335/ST60) (90)
R3 (measured torque Nm)	35/40 (in E335/ST60) (260)
Thread cutting performance max. (depending on gradient)	
R1	M30x3.5
R2	M24x3
R3	M36x4
Spindle	MK IV
Drilling depth (mm)	160
Distance column-spindle (mm)	300
Column diameter (mm)	140
Useable table surface (W x L) (mm)	590 x 450
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Spindle/table (mm)	150-700
Machine dimensions without VP (mm)	610 x 900 x 1,980
Machine dimensions with VP (mm)	670 x 1,100 x 2,200
Three-phase current motor 400 V with frequency converter (kW)	4.0
Spindle speed, stepless (1/min)	
R1 (1-stage)	0-1,000
R2 (1-stage)	0-1,600
R3 (2-stage with gearing)	0-4,000

SB 40 NC Plus

Feed/return stroke, infinitely variable (m/min)	0-1.5
Weight (kg)	440 kg
Order no. R1	230.540
Order no. R2	230.541
Order no. R3	230.542
Additional accessories	from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.

For AUTO: Programme start/stop
Order no. 231.000

- ▶ Commissioning the machine and briefing the operating staff
Order no. 229.931

Accessories

Drill package 6

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK IV/B18
- ▶ Reduction sleeve MK IV/MK III
- ▶ Reduction sleeve MK IV/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.595



Flow drilling machine SB 20 FB ▶ Plus



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Standard equipment

- ▶ Thread cutting system
- ▶ Control panel with OLED display
- ▶ Robust, high-quality drill head hood with ergonomically tilted front
- ▶ LED lighting
- ▶ Quick-adjust ergonomic depth stop
- ▶ Stepless speed regulation via the central knob
- ▶ Emergency stop button
- ▶ Thermal overload protection
- ▶ Spindle stop
- ▶ Drill protection with electrical fuse
- ▶ Connecting cable with CEE plug

Flow forming

Serves to produce extrusions in thin-walled metallic materials.

The flow forming procedure creates a sleeve in the existing material by reshaping it. This material extension increases the number of supporting threads to threefold to fivefold. The material is not machined but used to create durable connections.

The advantages of flow forming are

- ▶ low cost per thread
- ▶ highly durable connections
- ▶ high-quality threads
- ▶ no special equipment
- ▶ low start-up costs
- ▶ no external material
- ▶ fewer production steps
- ▶ no chip disposal

Accessories

- ▶ Vice [felix] 100 2.0
Order no. 281.106



Technical data

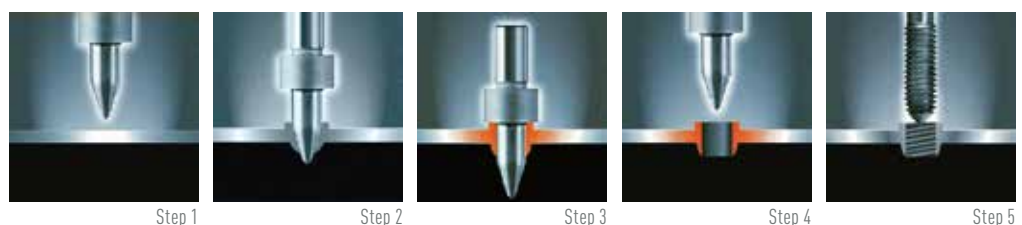
Flow forming at 3 mm sheet thickness (mm)	8
Spindle	MK II
Drilling depth (mm)	100
Distance column-spindle (mm)	240
Column diameter (mm)	82
Useable table surface (W x L) (mm)	340 x 280
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	Quick-adjust thrust ring
Feed	by hand
Table height adjustment	with toothed rack
Three-phase current motor 400 V with frequency converter (kW)	1.5
Spindle speed, stepless (1/min)	40-4,000

SB 20 FB Plus

Spindle/table (mm)	160-880
Machine dimensions without VP (mm)	355 x 705 x 1,825
Machine dimensions with VP (mm)	572 x 936 x 2,142
Weight (kg)	195
Order no.	220.115

Additional accessories from page 62

* The drilling machine is fitted with a frequency converter and complies with the standards DIN EN 55011:2016 & A1:2017.



Step 1

Step 2

Step 3

Step 4

Step 5

PROVEN AND GOOD +++ OUR SB P40 STG PV ELECTRONIC



Touch display

New revised touch display.

All important information at a glance. Various possibilities to combine the different options (chip breaking mode, piece counter, spindle stop and snap action).

Thread cutting device as standard

Adjustable via programmable depth indicator.

Main switch

Transparent hood

Transparent hood (ideal for training and schools), optionally also available with grey hood.

Stepless feed

With electromagnetic clutch.

LED illumination

LED lighting as standard, behind the drill spindle.

Large table surface working area

Optional machined base plate with integrated coolant system

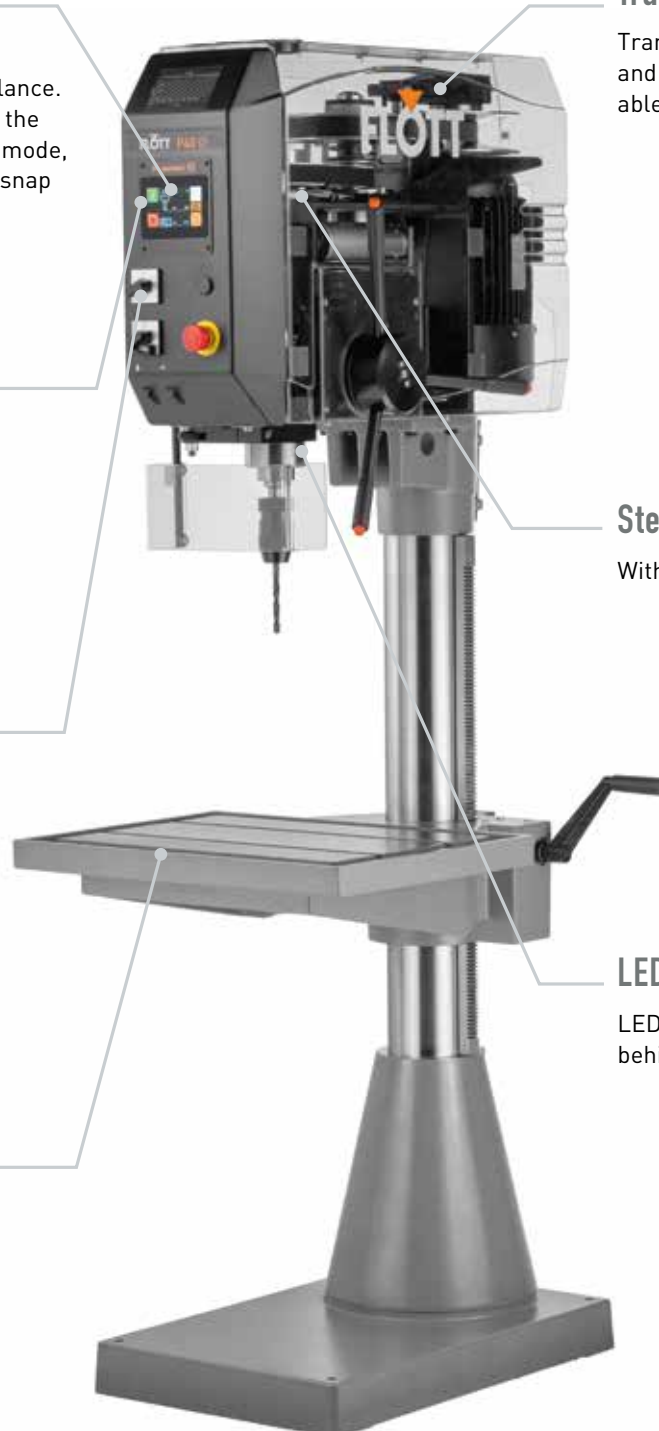


Fig. SB P40 STG PV electronic

CLASSIC DRILLING MACHINES

Our proven classic drilling machines -like all other FLOTT products, they stand for a very long service life.

They are designed to run on a simple underlying concept, as the speed adjustment runs mechanically via the belt pulley.

The drills have a variety of selectable displays: with a simple scale (M3 ST/M5 ST), with a purely digital display for drilling depth and speed (P30 ST/P40 ST) or the modern version, with the new "touch display" (P30 STG PV/P40 STG PV).

Of course, all machines also have a 3-year warranty (optionally extendable to 5 years).



Column drill SB M3 ST



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB M3 ST with special equipment

Standard equipment

- ▶ Stepless speed control
- ▶ Emergency stop button
- ▶ Manual reversing switch for clockwise and anti-clockwise rotation
- ▶ Under-voltage release
- ▶ Table height adjustment via toothed rack
- ▶ Drilling depth stop with fine adjustment
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ LED lighting in head
Order no. 290.070
- ▶ Machined base plate incl. integrated coolant system
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.160B
- ▶ Machined foot plate
Order no. 290.175B
- ▶ Combi drilling table with vice and square table
360° rotatable with scale, jaw width 120 mm, span 105 mm, table surface 350 x 350 mm
Order no. 290.125
- ▶ Coolant system (separate tank)
Filling quantity: max. 15 l/min
Delivery rate: max. 30 l/min
Order no. 290.340
- ▶ Large base
Column Ø 125 mm
Usable table surface (WxL) 590 x 450 mm
Order no. 205.036

Accessories

Drill package 4

- ▶ Vice [felix] 120 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18
3-16 mm (accuracy 0.17 mm)
Order no. 296.593



Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	25/30
Thread cutting performance max. (depending on gradient)	M20
Spindle	MK III
Drilling depth (mm)	125
Distance column-spindle (mm)	280
Column diameter (mm)	110
Useable table surface (W x L) (mm)	420 x 340 mm
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	scale
Drilling depth indicator	scale
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	520 x 820 x 1,900
Machine dimensions with VP (mm)	637 x 1,096 x 2,120
Three-phase current motor 400 V, pole-changeable (kW)	0.9/1.45
Spindle speeds with gearing, infinitely variable	
Revolutions per minute	125 - 4000 1/min
In 2 stages/stage 1	125 - 2000 1/min,
stage 2	250 - 4000 1/min
The step change takes place via belt-reversal	

SB M3 ST

Spindle/table (mm)	240-790
Weight (kg)	275
Order no.	205.180

Additional accessories from page 62

Column drill SB M5 ST



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB M5 ST with special equipment

Standard equipment

- ▶ Stepless speed control
- ▶ Emergency stop button
- ▶ Manual reversing switch for clockwise and anti-clockwise rotation
- ▶ Under-voltage release
- ▶ Table height adjustment via toothed rack
- ▶ Drilling depth stop with fine adjustment
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Spindle MK IV
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection

Special equipment

- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ LED lighting in head
Order no. 290.070
- ▶ Machined base plate incl. integrated coolant system
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.160C
- ▶ Machined foot plate
Order no. 290.175C
- ▶ Combi drilling table with vice and square table
360° rotatable with scale, jaw width 120 mm, span 105 mm, table surface 350 x 350 mm
Order no. 290.135
- ▶ Coolant system (separate tank)
Filling quantity: max. 15 l/min
Delivery rate: max. 30 l/min
Order no. 290.340

Accessories

Drill package 6

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK IV/B18
- ▶ Reduction sleeve MK IV/MK III
- ▶ Reduction sleeve MK IV/MK II
- ▶ Quick-change drill chuck B18
3-16 mm (accuracy 0.17 mm)
Order no. 296.595



Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	35/40
Thread cutting performance max. (depending on gradient)	M30
Spindle	MK IV
Drilling depth (mm)	160
Distance column-spindle (mm)	300
Column diameter (mm)	125
Useable table surface (W x L) (mm)	590 x 450 mm
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 160, 14/26
Speed indicator	scale
Drilling depth indicator	scale
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	610 x 850 x 1,920
Machine dimensions with VP (mm)	672 x 1,096 x 2,142
Three-phase current motor 400 V, pole-changeable (kW)	1.5/3.0
Spindle speed, stepless (1/min) with gearing	
Revolutions per minute	100-2,000 rpm

SB M5 ST

Spindle/table (mm)	150-700
Weight (kg)	440
Order no.	205.204

Additional accessories from page 62

Column drill SB P30 ST



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB P30 ST with special equipment

Standard equipment

- ▶ Drill depth adjustment with fine tuning and under-voltage release
- ▶ Emergency stop button
- ▶ Manual reversing switch (not applicable with thread cutting system option)
- ▶ Stepless speed control
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection
- ▶ Digital drilling depth and speed display

Special equipment

- ▶ Thread cutting system
Thread cutting capacity max M20
Adjusting the thread cutting depth via digital depth display
Order no. 290.622
- ▶ Combi drilling table with vice and square table 360° rotatable with scale
Jaw width 120 mm, span 105 mm
Table surface 350 x 350 mm
Order no. 290.125
- ▶ Machined foot plate
Order no. 290.175B
- ▶ Machined base plate incl. integrated coolant device
Filling capacity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.160B
- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.340

Accessories

Drill package 4

- ▶ Vice [felix] 120 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.593



Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	25/30
Thread cutting performance max. (depending on gradient)	M20
Spindle	MK III
Drilling depth (mm)	125
Distance column-spindle (mm)	280
Column diameter (mm)	110
Useable table surface (W x L) (mm)	420 x 340 mm
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	scale
Drilling depth indicator	scale
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	610 x 850 x 1,920
Machine dimensions with VP (mm)	637 x 1,096 x 2,120
Three-phase current motor 400 V, pole-changeable (kW)	1.5/3.0

SB P30 ST

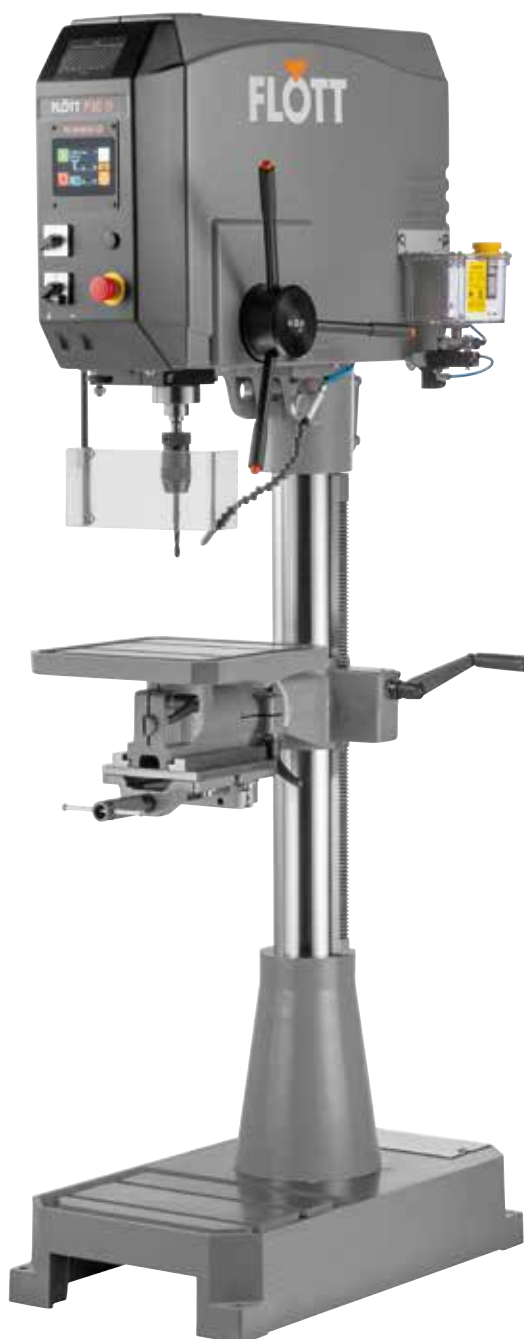
Spindle/table (mm)	240 - 790
Weight (kg)	275

Order no. 205.181

Additional accessories from page 62

Column drill SB P30 STG PV electronic

Also with
transparent hood



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73



Fig.: SB P30 STG PV electronic with options

Fig.: SB P30 STG PV electronic with transparent hood and options

Standard equipment

- ▶ Drill depth adjustment with fine tuning and under-voltage release
- ▶ Emergency stop button
- ▶ Stepless speed control
- ▶ Table height adjustment via toothed rack
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection
- ▶ Digital display for drill depth, speed and feed rate display
- ▶ Feed is electronically regulated and continuously variable incl. spindle monitoring
- ▶ Free cutting device
- ▶ Thread cutting system, thread cutting performance max. M20, thread cutting depth is set using the digital depth display
- ▶ Drill depth shut-off; programmable; easy operation
- ▶ Drill handle with push-button for turning the feed on/off
- ▶ Optional transparent protective hood at no extra price
- ▶ LED lighting as standard

Special equipment

- ▶ Combination drilling table with vice and square table, can be rotated 360° with scale
Jaw width 120 mm, span 105 mm
Table surface 350 x 350 mm
Order no. 290.125
- ▶ Machined foot plate
Order no. 290.175B
- ▶ Machined base plate incl. integrated coolant system
Filling quantity: max. 15 l
Delivery rate: max. 30 l/min
Order no. 290.160B
- ▶ LED lighting with articulated arm
Order no. 290.241
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.340

Software options that can be supplied for PV electronic

- ▶ Safety module – automatic spindle stop for drill spindle at the top
Order no. 290.613
- ▶ Chip breaking module – prevents the formation of long chips
Order no. 290.612
- ▶ Snap action – 4 freely selectable feed speeds per working stroke
Order no. 290.614

Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	25/30 (in E335/ST60)
Thread cutting performance max. (depending on gradient)	M20
Spindle	MK III
Drilling depth (mm)	125 mm
Distance column-spindle (mm)	280 mm
Column diameter (mm)	110 mm
Useable table surface (W x L) (mm)	420 x 340 mm
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 125, 13/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Three-phase current motor 400 V, pole-changeable (kW)	0.90/1.45
Spindle speed, stepless (1/min) with gearing (2 stages)	125-4,000
Stage I	125-2,000
Stage II	250-4,000
The step change takes place via belt-reversal	

SB P30 STG PV electronic

Feed, stepless (mm/min) incl. electromagnetic clutch; digital display	0-300
Spindle/table (mm)	240-790
Machine dimensions without VP (mm)	520 x 820 x 1,900
Machine dimensions with VP (mm)	670 x 1,100 x 2,200
Weight (kg)	320
Order no. transparent hood	207.220
Order no. grey hood	207.183
Additional accessories	from page 62

Accessories

Drill package 5

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK III/B18
- ▶ Reduction sleeve MK III/MK I
- ▶ Reduction sleeve MK III/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.594



Column drill SB P40 ST



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Standard equipment

- ▶ Drill depth adjustment with fine tuning and under-voltage release
- ▶ Emergency stop button
- ▶ Manual reversing switch
(not applicable with thread cutting system option)
- ▶ Stepless speed control
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection
- ▶ Digital drilling depth and speed display

Special equipment

- ▶ Thread cutting system
Thread cutting capacity max M30
Adjusting the thread cutting depth via digital depth display
Order no. 290.622
- ▶ Combination drilling table with vice and square table, can be rotated 360° with scale
jaw width 120 mm, span 105 mm
table surface 350 x 350 mm
Order no. 290.135
- ▶ Machined foot plate
Order no. 290.175C
- ▶ Machined base plate incl.
integrated coolant system
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.160C
- ▶ LED lighting with articulated arm
Order no. 290.240
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.340

Accessories

Drill package 6

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK IV/B18
- ▶ Reduction sleeve MK IV/MK III
- ▶ Reduction sleeve MK IV/MK II
- ▶ Quick-change drill chuck B18
3-16 mm (accuracy 0.17 mm)
Order no. 296.575



Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	35/40
Thread cutting performance max. (depending on gradient)	M30
Spindle	MK IV
Drilling depth (mm)	160
Distance column-spindle (mm)	300
Column diameter (mm)	125
Useable table surface (W x L) (mm)	590 x 450
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 160, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	610 x 850 x 1,920
Machine dimensions with VP (mm)	637 x 1,096 x 2,120
Three-phase current motor 400 V, pole-changeable (kW)	1.5/3.0
Spindle speed, stepless (1/min) with gearing	
Speed series R1	100 - 2,000
Speed series R2	70 - 1,400

SB P40 ST

Spindle/table (mm)	150-700
Weight (kg)	440
Order no. R1	205.205
Order no. R2	205.206

Additional accessories from page 62

Column drill SB P40 STG PV electronic

Also with
transparent hood



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Fig.: SB P40 STG PV R1 transparent electronic

Standard equipment

- ▶ Drill depth adjustment with fine tuning and under-voltage release
- ▶ Emergency stop button
- ▶ Stepless speed control
- ▶ Connecting cable (1.5 m) with CEE plug
- ▶ Drill protection with electrical fuse
- ▶ Thermal overload protection
- ▶ Digital display for drill depth, speed and feed rate display
- ▶ Feed is electronically regulated and continuously variable incl. spindle monitoring
- ▶ Free cutting device
- ▶ Thread cutting system, thread cutting performance max. M30, thread cutting depth is set using the digital depth display
- ▶ Drill depth shut-off; programmable; easy operation
- ▶ Drill handle with push-button for turning the feed on/off
- ▶ LED lighting as standard

Special equipment

- ▶ Combination drilling table with vice and square table, can be rotated 360° with scale jaw width 120 mm, span 105 mm table surface 350 x 350 mm
Order no. 290.135
- ▶ Machined foot plate
Order no. 290.175C
- ▶ Machined base plate incl. integrated coolant system
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.160C
- ▶ LED lighting with articulated arm
Order no. 290.241
- ▶ Coolant system (separate container)
Filling quantity: max. 15 l, Delivery rate: max. 30 l/min
Order no. 290.340

Software options that can be supplied for PV electronic

- ▶ Safety module – automatic spindle stop for drill spindle at the top
Order no. 290.613
- ▶ Chip breaking module – prevents the formation of long chips
Order no. 290.612
- ▶ Snap action – 4 freely selectable feed speeds per working stroke
Order no. 290.614

Our classic

Technical data

Drilling capacity/normal drilling performance (mm)	35/40 (in E335/ST60)
Thread cutting performance max. (depending on gradient)	M30
Spindle	MK IV
Drilling depth (mm)	160
Distance column-spindle (mm)	300
Column diameter (mm)	125
Useable table surface (W x L) (mm)	590 x 450
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 2, 160, 14/26
Speed indicator	digital
Drilling depth indicator	digital
Drilling depth stop	with fine tuning
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	610 x 850 x 1,920
Machine dimensions with VP (mm)	637 x 1,096 x 2,120
Three-phase current motor 400 V, pole-changeable (kW)	1.5/3.0
Spindle speed, stepless (1/min) with gearing	
Speed series R1	100-2,000
Speed series R2	70-1,400

SB P40 STG PV electronic

Feed, stepless (mm/min) incl. electromagnetic clutch; digital display	0-300
Spindle/table (mm)	150-700
Weight (kg)	440
Order no. transparent hood, R1	207.226
Order no. transparent hood, R2	207.227
Order no. grey hood, R1	207.208
Order no. grey hood, R2	207.209

Additional accessories from page 62

Accessories

Drill package 6

- ▶ Vice [felix] 150 2.0
- ▶ Taper mandrel MK IV/B18
- ▶ Reduction sleeve MK IV/MK III
- ▶ Reduction sleeve MK IV/MK II
- ▶ Quick-change drill chuck B18 3-16 mm (accuracy 0.17 mm)
Order no. 296.595



Gear drilling machine GB 50 MV



Fig.: GB 50 MV without special equipment

Standard equipment

- ▶ Mechanical spindle feed
- ▶ Machined base plate with T-slots and integrated coolant system
- ▶ Precise mechanical drill depth setting
- ▶ Circuit breaker with U-trip
- ▶ Emergency stop button
- ▶ Drill protection with electrical fuse
- ▶ Machine lighting
- ▶ Rotary and swivel table
- ▶ automatic tool ejector
- ▶ Gear wheels made of hardened, ground steel
- ▶ Gearwheel lubrication with automatic oil pump
- ▶ Handwheel for manual, fine hand feed
- ▶ Reversing switch for clockwise/anti-clockwise rotation
- ▶ 12-month warranty

Special equipment

- ▶ Thread cutting system
Order no. 287.045

Accessories

- ▶ Vice [felix] 150 2.0
Order no. 281.143
- ▶ Quick-change drill chuck,
Socket B18
Span 3-16 mm
Rotational accuracy: 0.17 mm
Order no. 285.165
- ▶ Tapered mandrel (insertion pin)
Dimension B 18/MK IV
Order no. 290.323

Further special equipment on request!

Technical data

Drilling capacity (mm)	50
Thread cutting performance max. (depending on gradient)	M36
Spindle	MK IV
Drilling depth (mm)	230
Distance column-spindle (mm)	400
Column diameter (mm)	200
Usable table surface (mm)	550 x 550
T-slot size (arm), distance (mm), width measurement (mm)	Quantity 3, 160, 16/28
Speed indicator	scale
Drilling depth indicator	scale
Distance spindle/table (mm)	50-850
Table height adjustment	with toothed rack
Machine dimensions without VP (mm)	600 x 1,060 x 2,450
Machine dimensions with VP (mm)	680 x 2,600 x 1,210
Three-phase current motor 400 V (kW)	3.0
Spindle speed in 9 stages (gears) (1/min)	54-75-109-169-237-344-507-712-1,032
Mechanical spindle feed (mm/rev)	0.1-0.2-0.3-0.4
GB 50 MV	
Weight (kg)	795
Order no.	287.040
Packaging	V0
Special colours (RAL) extra charge	on request

Multi-head drilling machines

Expandable at any tin
flexible arrangement



- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

We can put together the FLOTT multi-head drilling machine for you individually .

We would be happy to advise you!

Fig.: Drilling line with 6 drilling heads 40 NC►Plus

Standard equipment

- ▶ Fixed worktable
- ▶ Head height adjustment via hand crank
- ▶ Chip tray

Special equipment / accessories

- ▶ Foot switch on request
- ▶ Coolant system
- ▶ Minimum quantity lubrication
- ▶ Side tables for optional equipment

Features

- ▶ Can function modularly as a single machine or in series at any time
- ▶ Ideal also for operating while seated
- ▶ Individual modules can be easily moved, e.g. by forklift
- ▶ Base available either with open storage compartment or with drawer and lockable door

More options

- ▶ Can be combined with machines from 18 Plus to 40 NC Plus (**varying drill heads possible!**)

- ▶ 18 Plus
Order no. 218.304
- ▶ 20 Plus
Order no. 220.101
- ▶ 23 Plus R1
Order no. 223.024
- ▶ 23 Plus R2
Order no. 223.028
- ▶ 25 Plus R1
Order no. 225.013
- ▶ 25 Plus R2
Order no. 225.018
- ▶ P30 STG PV
Order no. 297.086
- ▶ 30 Plus R1
Order no. 231.100
- ▶ 30 Plus R2
Order no. 231.101
- ▶ 30 Plus R2
Order no. 231.102
- ▶ 30 MV Plus R1
Order no. 231.105
- ▶ 30 MV Plus R2
Order no. 231.106
- ▶ 30 MV Plus R3
Order no. 231.107

- ▶ 30 NC Plus R1
Order no. 231.110
- ▶ 30 NC Plus R2
Order no. 231.111
- ▶ 30 NC Plus R3
Order no. 231.112
- ▶ 40 Plus R1
Order no. 231.115
- ▶ 40 Plus R2
Order no. 231.116
- ▶ 40 Plus R3
Order no. 231.117
- ▶ 40 MV Plus R1
Order no. 231.120

- ▶ 40 MV Plus R2
Order no. 231.121
- ▶ 40 MV Plus R3
Order no. 231.122
- ▶ 40 NC Plus R1
Order no. 231.125
- ▶ 40 NC Plus R2
Order no. 231.126
- ▶ 40 NC Plus R3
Order no. 231.127
- ▶ 40 PV electronic R1
Order no. 297.087
- ▶ 40 PV electronic R2
Order no. 297.088

Technical data

Varying drill heads possible

Underframe

Usable table surface	590 x 450 mm (transverse slots 2 x 14 mm)
Fixed working height	900 mm
Distance spindle to column	300 mm
Column diameter	125 mm
Distance drill chuck to table	50 - 400 mm
Order no. Underframe with door and drawer	280.600
Order no. with cover and open storage compartment	280.610



Special equipment

Option 1

Machines with deviating special voltage
on request



Order no. 290.100

Option 5 and 6

Column extension
Ø 70
max. extension
200 mm

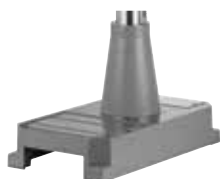
Column extension
Ø 82
max. extension
150 mm

Order no. Ø 70 296.286
Order no. Ø 82 296.287



Option 2

Machined base plate with T-slots. Only available for SB-version from a column diameter of 82 mm onwards



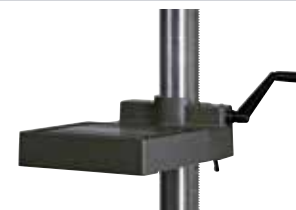
Order no. I Columns -Ø 82 mm 290.175A
Order no. I Columns -Ø 110 mm 290.175 B
Order no. I Columns -Ø 125 mm 290.175 C
Order no. I Columns -Ø 140 mm 290.175 D

Option 7 and 8

Column extension
Ø 110
max. extension
300 mm

Column extension
Ø 125
max. extension
300 mm

Order no. Ø 110 296.288
Order no. Ø 125 296.289



Option 3

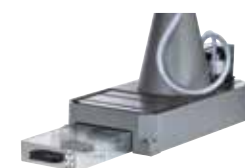
Foot switch as "EMERGENCY STOP"
(must be unlocked manually)



Order no. 290.320

Option 9

Machined base plate with coolant system
Filling capacity: max. 15 l,
Delivery rate max. 30 l/min



Order no. I Columns -Ø 82 mm 290.160A
Order no. I Columns -Ø 110 mm 290.160B
Order no. I Columns -Ø 125 mm 290.160C
Order no. I Columns -Ø 140 mm 290.160D

Option 4

Foot switch
following technical advice and creation of a requirement profile



Order no. on request

Option 10

Electric coolant system
complete with pump, tank, hoses, cable and switch from Series 18
Plus onwards
Filling capacity: max. 15 l
Delivery rate: max. 30 l/min



Order no. 290.340

Option 11

Drill depth fixed stop
for optimum repetition accuracy up to 25 Plus



Order no. 212.716

Option 16 and 17

Combination drill tables for 110/125/140 columns with vice and square table 360° rotatable with scale
Jaw width 120 mm
span 105 mm
Table surface 350 x 350 mm
Order no. 110
Order no. 125
Order no. 140



290.125
290.135
290.138

Option 12

Special colour
Base (RAL one-component paint)



Order no. 290.200

Option 13

Special colour
Plus hood
Possible on request!



Order no. 290.201

Option 14 and 15

Commissioning the machine
and instruction of the operating personnel
Online trainings:
www.flott.de
Advice and briefing



Order no. Com. 290.018
Order no. Online tr. 229.931

Option 18

Minimum quantity lubrication
Machines with deviating special voltage. A metering pump moves the undiluted lubricant to the metering nozzle orifice, where this is formed into a microfine lubricant spray cone with blower air. Lubricant and blower air are guided separately coaxially to the nozzle and are repeatedly adjustable independently of each other.



After activation, the lubricant emerges from the dosing nozzle without any time delay.

Large, stepless adjustment range of the dosing pump. From barely perceptible volume to the maximum delivery rate of 3 cm³/min. The compact dosing unit for minimum quantity lubrication: As little as possible, but as much as necessary - i.e. optimally dosed!

Order no. for 13-15 Plus 290.395 A
Order no. for 18 Plus 290.395 B
Order no. for 20-25 Plus 290.395 C
Order no. for 30-40 Plus 290.395 D

Accessories

F0 precision cross table

- ▶ Table size 230 x 164 mm
- ▶ Travel x/y 120 mm x 110 mm
- ▶ Scale marking 0.05
- ▶ Weight 16 kg
- ▶ Works with drilling machine type series 18/20/23/25 Plus
- ▶ Intermediate plate



Order no.

281.085

F1 precision cross table

- ▶ Table size 330 x 220 mm
- ▶ Travel x/y 190 mm x 130 mm
- ▶ Scale marking 0.05
- ▶ Weight 33 kg
- ▶ Works with drilling machine type series 18/20/23/25 Plus, series P30 and 30 Plus/MV/NC
- ▶ Intermediate plate



Order no.

281.090

F2 Precision cross table

- ▶ Table size 430 x 240 mm
- ▶ Travel x/y 240 mm x 160 mm
- ▶ Scale marking 0.05
- ▶ Weight 46 kg
- ▶ Suitable for drilling machine type series P40/40 Plus/MV/NC
- ▶ Intermediate plate



Order no.

281.095

Machine cabinet I narrow version

- ▶ Solid beech top, 30 mm thick, height-adjustable feet (up to 3 cm), bar-glued and finger-jointed, oil-treated to repel dirt and protect against warping
- ▶ Bearing capacity: 300 kg
- ▶ 1 drawer with roller guide
- ▶ 1 lockable door
- ▶ 60 x 60 x 84 cm



Order no.

250.208

Machine cabinet I wide version

- ▶ Solid beech top, 30 mm thick, height-adjustable feet (up to 3 cm), bar-glued and finger-jointed, oil-treated to repel dirt and protect against warping
- ▶ Bearing capacity: 300 kg
- ▶ 2 drawers with roller guides
- ▶ 2 lockable doors
- ▶ 120 x 60 x 84 cm



Order no. 250.180

LED lighting with 90° articulated arm

- ▶ Fixed mounted
- ▶ Spotlight 90° with flex shaft 225 mm and on/off switch on lamp head
- ▶ 200 lm, approx. 5500 Kelvin (daylight white), IP65



Order no. up to series 25 Plus 290.240
Order no. from P30 Plus R3 series 290.241

LED lighting with 90° articulated arm with straight magnetic base

- ▶ With 90° magnetic base and separate power supply unit 24 V (2.5 W)
- ▶ Spotlight 90° with flexible shaft 225 or 450 mm and on/off switch on lamp head
- ▶ 200 lm, approx. 5500 Kelvin (daylight white), IP65
- ▶ Magnetic holding force: 250 N



Order no. with 225 flex shaft 290.242
Order no. with 450 flex shaft 290.244

LED lighting with articulated arm with straight magnetic base

- ▶ With 90° magnetic base and separate power supply unit 24 V (2.5 W)
- ▶ Spotlight 90° with 450 mm and on/off switch on lamp head
- ▶ 200 lm, approx. 5500 Kelvin (daylight white), IP65
- ▶ Magnetic holding force: 250 N



Order no. 290.243

Accessories

Vice [felix] 80 2.0

- ▶ Jaw width: 80 mm
- ▶ Span: 0-120 mm
- ▶ Jaw height: 28 mm
- ▶ Travel: 150 mm
- ▶ Weight: 11.6 kg
- ▶ W x L x H: 95 x 280 x 78 mm



Order no.

281.140

Vice [felix] 100 2.0

- ▶ Jaw width: 100 mm
- ▶ Span: 0-135 mm
- ▶ Jaw height: 32 mm
- ▶ Travel: 165 mm
- ▶ Weight: 12.8 kg
- ▶ W x L x H: 122 x 343 x 85 mm



Order no.

281.141

Vice [felix] 120 2.0

- ▶ Jaw width: 120 mm
- ▶ Span: 0-168 mm
- ▶ Jaw height: 40 mm
- ▶ Travel: 200 mm
- ▶ Weight: 20.3 kg
- ▶ W x L x H: 140 x 395 x 105 mm



Order no.

281.142

Vice [felix] 150 2.0

- ▶ Jaw width: 150 mm
- ▶ Span: 0-200 mm
- ▶ Jaw height: 40 mm
- ▶ Travel: 220 mm
- ▶ Weight: 32.4 kg
- ▶ W x L x H: 170 x 451 x 103 mm



Order no.

281.143

Precision quick-change drill chuck

- ▶ Ground, self-tensioning
- ▶ Span 0.5-6 mm
- ▶ Socket B12
- ▶ Rotational accuracy:
0.05 mm



Order no.

285.104

Gear rimmed drill chuck

- ▶ Span 0.5-8 mm
- ▶ Socket B12 for turbo drill
- ▶ Rotational accuracy:
0.20 mm



Order no.

285.103

Precision ground quick-change drill chuck

- ▶ self-clamping, for clockwise/
anticlockwise rotation max.
8,000 1/min.
- ▶ Span 1-13 mm
- ▶ Socket B16
- ▶ Rotational accuracy:
0.06 mm



Order no.

285.064

Quick-change drill chuck, self-tensioning

- ▶ Span 1-13 mm
- ▶ Socket B16
- ▶ Rotational accuracy:
0.17 mm



Order no.

285.133

Accessories

Quick-change drill chuck, self-tensioning

- ▶ Span 3-16 mm
- ▶ Socket B18
- ▶ Rotational accuracy: 0.17 mm



Order no. 285.165

Taper mandrel (insertion pin)



Order no. for B16/MK I	285.310
Order no. for B16/MK II	285.320
Order no. for B18/MK II	285.321
Order no. for B18/MK III	285.323
Order no. for B18/MK IV	290.323
Order no. for B18/MK V	287.097

Tap holder

- ▶ no automatic loosening in case of vibrations due to laterally mounted spindle for M4-M12 DIN 371
- ▶ Span: 1-10 mm
- ▶ Socket: B16
- ▶ Total length: 80 mm



Order no. 285.109

Drill drift (Semi-automatic)



Order no. for 1-3	285.334
Order no. for 4-6	285.335

Reduction sleeves



Order no. for MK II/MK I	285.330
Order no. for MK III/MK II	285.331
Order no. for MK III/MK I	285.332
Order no. for MK IV/MK III	285.333
Order no. for MK IV/MK II	285.336
Order no. for MK V/MK IV	285.092

Multi-purpose collet for GBF 12

- ▶ Span 3.5-6.5 mm
- ▶ Span 6.5-10 mm



Order no. for 3.5-6.5 mm	285.084
Order no. for 6.5-10 mm	285.085

GBF 12/MK 2 (tapping chuck)

- ▶ Tapping chuck with gate pressure booster. Length compensation push/pull for clockwise and anti-clockwise rotation.
- ▶ Cutting range M3-M12
- ▶ Without collet



Order no.	285.083
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Multi-purpose collet for GBF 18

- ▶ Span 2.8-7 mm
- ▶ Span 7-13 mm



Order no. for 2.8- 7 mm	285.087
Order no. for 7-13 mm	285.088



Accessories

GBF 18/MK 3

- ▶ Tapping chuck with gate pressure booster. Length compensation push/pull for clockwise and anti-clockwise rotation.
- ▶ Cutting range M5-M18
- ▶ Without collet



Order no. for M5-M18

285.086

Multi-purpose collet for GBF 30

- ▶ Span 10-16 mm
- ▶ Span 16-23 mm



Order no. for 10 - 16 mm

285.090

Order no. for 16 - 23 mm

285.091

GBF 30/MK 4

- ▶ Tapping chuck with gate pressure booster. Length compensation push/pull for clockwise and anti-clockwise rotation.
- ▶ Cutting range M10-M30
- ▶ Without collet



Order no.

285.089

HSS-G twist drill set in ABS box

- ▶ Multi-range drill bit with reinforced drill core and parabolically shaped flute for better chip evacuation DIN 338 - cross ground 130 degrees, 25-pcs., 1-13 mm x 0.5 mm



Order no.

285.123

HSS-G twist drill set in ABS box

- ▶ DIN 338 N, 25-pcs
1-13 mm x 0.5 mm



Order no.

285.124

HSS-E machine tap in ABS box

- ▶ DIN 371/376, M3 - M12,
form B, with core drill, 14
pcs. for through hole



Order no.

285.163

HSS-G taper and deburring countersink set in ABS box

- ▶ DIN 335 C, 90 degrees, 6 pcs.
6.3-8 mm
3-10 mm
4-12 mm
4-16 mm
5-20.5 mm



Order no.

285.162

HSS-E machine tap in ABS box

- ▶ DIN 371/376, M3 - M12,
Form C, 35 degrees RSP,
14 pcs. incl. core drill set and
thread for through holes



Order no.

285.164



Warranty extensions

Machine	for order no.	4 years warranty extension	5 years warranty extension	Page
TB 10 Eco Plus	217200	290.018.217.200	290.019.217.200	14
TB 10 Basic Plus with head height adjustment	217400	290.018.217.400	290.019.217.400	16
TB 10 Basic Plus with table adjustment	217410	290.018.217.410	290.019.217.410	16
TB 10 Plus	212505	290.018.212.505	290.019.212.505	18
Turbo drill	212506	290.018.212.506	290.019.212.506	20
TB 13 Plus	212500	290.018.212.500	290.019.212.500	22
TB 13 Plus MK2	212503	290.018.212.503	290.019.212.503	22
TBZ 13 Plus	212650	290.018.212.650	290.019.212.650	22
TBZ 13 Plus MK2	212655	290.018.212.655	290.019.212.655	22
SB 13 Plus	212502	290.018.212.502	290.019.212.502	22
SB 13 Plus MK2	212504	290.018.212.504	290.019.212.504	22
TB 15 Plus MK2	212755	290.018.212.755	290.019.212.755	24
SB 15 Plus MK2	212750	290.018.212.750	290.019.212.750	24
TB 18 Plus	218303	290.018.218.303	290.019.218.303	26
TBZ 18 Plus	218309	290.018.218.309	290.019.218.309	26
SB 18 Plus	218308	290.018.218.308	290.019.218.308	26
TB 20 Plus	220105	290.018.220.105	290.019.220.105	28
TBZ 20 Plus	220110	290.018.220.110	290.019.220.110	28
SB 20 Plus	220100	290.018.220.100	290.019.220.100	28
TB 23 Plus R1	223021	290.018.223.021	290.019.223.021	30
TB 23 Plus R2	223026	290.018.223.026	290.019.223.026	30
TBZ 23 Plus R1	223022	290.018.223.022	290.019.223.022	30
TBZ 23 Plus R2	223027	290.018.223.027	290.019.223.027	30
SB 23 Plus R1	223020	290.018.223.020	290.019.223.020	30
SB 23 Plus R2	223025	290.018.223.025	290.019.223.025	30
TB 25 Plus R1	225011	290.018.225.011	290.019.225.011	32
TBZ 25 Plus R1	225012	290.018.225.012	290.019.225.012	32
SB 25 Plus R1	225010	290.018.225.010	290.019.225.010	32
TB 25 Plus R2	225016	290.018.225.016	290.019.225.016	32
TBZ 25 Plus R2	225017	290.018.225.017	290.019.225.017	32
SB 25 Plus R2	225015	290.018.225.015	290.019.225.015	32



**Warranty
extension**

- ▶ 3-year warranty for single-shift operation
- ▶ Warranty extension to 4 or 5 years available! See page 72-73

Warranty extensions

Machine	for order no.	4 years warranty extension	5 years warranty extension	Page
SB 30 Plus R1	230500	290.018.230.500	290.019.230.500	34
SB 30 Plus R2	230501	290.018.230.501	290.019.230.501	34
SB 30 Plus R3	230502	290.018.230.502	290.019.230.502	34
SB 30 MV Plus R1	230505	290.018.230.505	290.019.230.505	34
SB 30 MV Plus R2	230506	290.018.230.506	290.019.230.506	34
SB 30 MV Plus R3	230507	290.018.230.507	290.019.230.507	34
SB 30 NC Plus R1	230510	290.018.230.510	290.019.230.510	36
SB 30 NC Plus R2	230511	290.018.230.511	290.019.230.511	36
SB 30 NC Plus R3	230512	290.018.230.512	290.019.230.512	36
SB 40 Plus R1	230530	290.018.230.530	290.019.230.530	38
SB 40 Plus R2	230531	290.018.230.531	290.019.230.531	38
SB 40 Plus R3	230532	290.018.230.532	290.019.230.532	38
SB 40 MV Plus R1	230535	290.018.230.535	290.019.230.535	38
SB 40 MV Plus R2	230536	290.018.230.536	290.019.230.536	38
SB 40 MV Plus R3	230537	290.018.230.537	290.019.230.537	38
SB 40 NC Plus R1	230540	290.018.230.540	290.019.230.540	40
SB 40 NC Plus R2	230541	290.018.230.541	290.019.230.541	40
SB 40 NC Plus R3	230542	290.018.230.542	290.019.230.542	40
SB 20 Plus FB	220115	290.018.220.115	290.019.220.115	42
SB M3 ST	205180	290.018.205.180	290.019.205.180	46
SB M5 ST	205204	290.018.205.204	290.019.205.204	48
SB P30 ST	205181	290.018.205.181	290.019.205.181	50
SB P30 STG PV electronic transparent	207220	290.018.207.220	290.019.207.220	52
SB P30 STG PV electronic grey	207183	290.018.207.183	290.019.207.183	54
SB P40 ST/R1	205205	290.018.205.205	290.019.205.205	56
SB P40 ST/R2	205206	290.018.205.206	290.019.205.206	56
SB P40 STG PV electronic/ R1 transparent	207226	290.018.207.226	290.019.207.226	58
SB P40 STG PV electronic/ R2 transparent	207227	290.018.207.227	290.019.207.227	58
SB P40 STG PV electronic/R1 grey	207208	290.018.207.208	290.019.207.208	58
SB P40 STG PV electronic/R2 grey	207209	290.018.207.209	290.019.207.209	58

Overview grinding machines

Double grinding machine	Grinding disc size mm	Revolutions per minute 1/min	Motor AC 230 V kW	Three-phase current motor 400 V kW	Weight kg	Suction socket Ø mm	Page
TS 175 SW	175 x 25 x 32	2,800	0.52	-	15	42	76
TS 175 SD P	175 x 25 x 32	2,740	-	0.7	15	42	76
TS 175 Pro	175x25x32	2,750	-	0.7	15	42	76
TS 200 SD P/Pro	200 x 32 x 32	2,550	-	1.0/0.75	20	42	78
TS 250 SD P/Pro	250 x 40 x 51	1,400	-	1.4 / 0.8	32	42	78
TS 300 SD P	300 x 40 x 51	1,250	-	2.2	40	42	82
TSB 250 P	250 x 40 x 51	1,400	-	1.4	35	42	84

Belt grinders	Belt length mm	Belt width mm	Motor AC 230 V kW	Three-phase current motor 400 V kW	Weight kg	Suction socket Ø mm	Page
TBSM 100	1,220	100	0.75 (1 x 230 V)	-	27	35	86
BSM 75	2,000	75	-	3.75	80	60	88
BSM 75 A	2,000	75	-	3.75	90	60	88
BSM 75 A/pol	2,000	75	-	3.0/3.75	105	60	88
BSM 150	2,000	150	-	3.75	90	60	90
BSM 150 A	2,000	150	-	3.75	100	60	90
BSM 150 A/pol	2,000	150	-	3.0/3.75	105	60	90

Brush deburring machine	Brush diameter mm	Brush width normal mm	Speed/ pole-changeable RPM	Drive power (Three-phase current motor) kW	Weight kg	Page
BEM 250 Plus	250	60	2,800/1,400	1.8/2.1	85	92
BEM 250 Pro	250 (3 pieces)	60	600-2,700	3	410	94

You can find corresponding dust extraction system in the technical data for the machine in question.



GRINDING TECHNOLOGY

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Double grinding machine

TS 175 SW

TS 175 SD P

TS 175 Pro



Fig.: TS 175 SW/TS 175 SD P

Standard equipment

- ▶ Smooth running, no-maintenance motor
- ▶ Protective hood closed at the sides
- ▶ Stable, adjustable workpiece supports
- ▶ High level of safety thanks to adjustable spark deflector
- ▶ Suitable for grinding, deburring and sharpening tools of all kinds, metal profiles etc.
- ▶ Circuit breaker and under-voltage release
- ▶ Spark/eye protection on both sides
- ▶ Connecting cable with two-pin earthed plug (for all SW models)
- ▶ Connecting cable with CEE plug 16 A (for all SD P models)
- ▶ 1x coarse and fine grinding wheel
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Machine stand with dip tank,
Dimensions: 355 x 300 mm, Weight: 12 kg
Order no. 350.435
- ▶ Wall bracket
Order no. 315.035
- ▶ Separate replacement grinding wheel
coarse standard corundum
Order no. for TS 175: 317.526
- ▶ Separate replacement grinding wheel
fine standard corundum
Order no. for TS 175: 317.527
- ▶ Wheel dresser
Order no. 350.101
- ▶ Dust extraction system MA 400 D
(only TS 175 SD P and TS 175 Pro)
Order no. 330.295

Technical data

Machine dimensions without VP (mm)	230 x 440 x 210
Machine dimensions with VP (mm)	260 x 450 x 250
Suction piece Ø (mm)	42

TS 175 SW

Dimensions of the grinding wheel (mm)	175 x 25 x 32
Speed (1/min)	2,800
Motor AC 230 V (kW)	0.52, S3-25% (periodic)
Weight (kg)	15
Order no.	317.766

TS 175 SD P

Dimensions of the grinding wheel (mm)	175 x 25 x 32
Speed (1/min)	2,740
Three-phase current motor 400 V (kW)	0.7, S2-30 min (short time operation)
Weight (kg)	15
Order no.	317.761

TS 175 Pro

Dimensions of the grinding wheel (mm)	175 x 25 x 32
Speed (1/min)	2,750
Motor AC 230 V (kW)	0.7, S1 (continuous operation)
Weight (kg)	15
Order no.	317.840

**Double grinding
machine**
TS 200 SD P/Pro
TS 250 SD P/Pro



Fig.: TS 200 SD P/Pro

Standard equipment

- ▶ Smooth running, no-maintenance motor
- ▶ Protective hood closed at the sides
- ▶ Stable, adjustable workpiece supports
- ▶ High level of safety due to adjustable spark deflector
- ▶ Suitable for grinding, deburring and sharpening tools of all kinds, metal profiles etc.
- ▶ Circuit breaker and under-voltage release
- ▶ Spark/eye protection on both sides
- ▶ Connecting cable with CEE plug 16 A
- ▶ 1x coarse and fine grinding wheel
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Different colour shade
(One-component RAL paint)
Order no. 309.010

Accessories

- ▶ Machine stand with dip tank,
Dimensions: 355 x 300 mm, Weight: 12 kg
(only TS 200 SD P)
Order no. 350.435
- ▶ Machine stand with dip tank,
Dimensions: 420 x 520 mm, Weight: 15 kg
(only TS 250 SD P)
Order no. 350.436
- ▶ Wall bracket (only TS 200 SD P)
Order no. 315.035
- ▶ Separate spare grinding wheel
coarse standard corundum
Order no. for TS 200: 317.532
Order no. for TS 250: 317.542
- ▶ Separate spare grinding wheel
fine standard corundum
Order no. for TS 200: 317.533
Order no. for TS 250: 317.543
- ▶ Wheel dresser
Order no. 350.101
- ▶ Dust extraction system MA 400 D
(only TS 200 SD P)
Order no. 330.295
- ▶ Dust extraction system MA 600 D
(only TS 250 SD P)
Order no. 330.080

Technical data

Suction piece Ø (mm)	42
TS 200 SD P/Pro	
Dimensions of the grinding wheel (mm)	200 x 32 x 32
Machine dimensions without VP (mm)	250 x 470 x 230
Machine dimensions with VP (mm)	300 x 480 x 275
Speed (1/min)	2,550
Weight (kg)	20
TS 200 SD P	
Three-phase current motor 400 V (kW) 1.0, S2-30 min (short-time operation)	
Order no.	317.762
TS 200 SD Pro	
Three-phase current motor 400 V (kW) 0.75, S1 (continuous operation)	
Order no.	317.845
TS 250 SD P/Pro	
Dimensions of the grinding wheel (mm)	250 x 40 x 51
Machine dimensions without VP (mm)	280 x 530 x 270
Machine dimensions with VP (mm)	325 x 540 x 310
Speed (1/min)	1,400
Weight (kg)	32
TS 250 SD P	
Three-phase current motor 400 V (kW) 1.4, S2-30 min (short-time operation)	
Order no.	317.763
TS 250 SD Pro	
Three-phase current motor 400 V (kW) 0.8, S1 (continuous operation)	
Order no.	317.850

Double grinding machine

TS 200 SD P/Pro

TS 250 SD P/Pro

As combination units always
with machine stand and brake
(optionally with extraction
system)



WHAT ELSE COULD YOU WISH FOR?
OUR DOUBLE GRINDING MACHINES

Fig.: TS 200 SD P/Pro with special equipment-foot switch

Standard equipment

- ▶ Smooth running, no-maintenance motor
- ▶ Emergency off push button
- ▶ Brake
- ▶ Machine stand/optionally with extraction system
- ▶ Protective hood closed at the sides
- ▶ Stable, adjustable workpiece supports
- ▶ High level of safety thanks to adjustable spark deflector
- ▶ Suitable for grinding, deburring and sharpening tools of all kinds, metal profiles etc.
- ▶ Circuit breaker and under-voltage release
- ▶ Spark/eye protection on both sides
- ▶ Connecting cable with CEE plug 16 A
- ▶ 1x coarse and fine grinding wheel
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Different colour shade (One-component RAL paint)
Order no. 309.010
- ▶ Foot switch emergency stop (can only be ordered in conjunction with brake, machine stand and/or extraction system)
Order no. 317.859

Accessories

- ▶ Separate spare grinding wheel coarse standard corundum
Order no. for TS 200: 317.532
Order no. for TS 250: 317.542
- ▶ Separate spare grinding wheel fine standard corundum
Order no. for TS 200: 317.533
Order no. for TS 250: 317.543
- ▶ Wheel dresser
Order no. 350.101

Technical data

Suction piece Ø (mm)	42
TS 200 SD P/Pro with brake and machine stand	
Dimensions of the grinding wheel (mm)	200 x 32 x 32
Machine dimensions without VP (mm)	270 x 470 x 1,050
Machine dimensions with VP (mm)	600 x 800 x 1,350
Speed (1/min)	2,550
Weight (kg)	60
TS 200 SD P with brake and machine stand	
Three-phase current motor 400 V(kW)	1.0, S2-30 min (short-time operation)
Order no.	317.774
TS 200 SD P with brake and machine stand with extraction system	
Three-phase current motor 400 V(kW)	1.0, S2-30 min (short-time operation)
Order no.	317.777
TS 200 Pro with brake and machine stand	
Three-phase current motor 400 V(kW)	0.75, S1 (continuous operation)
Order no.	317.846
TS 200 Pro with brake and machine stand with extraction system	
Three-phase current motor 400 V(kW)	0.75, S1 (continuous operation)
Order no.	317.847
TS 250 SD P/ Pro with brake and machine stand	
Dimensions of the grinding wheel (mm)	250 x 40 x 51
Machine dimensions without VP (mm)	520 x 530 x 1,110
Machine dimensions with VP (mm)	600 x 800 x 1,400
Speed (1/min)	1,400
Weight (kg)	85
TS 250 SD P with brake and machine stand	
Three-phase current motor 400 V(kW)	1.4, S2-30 min (short-time operation)
Order no.	317.775
TS 250 SD P with brake and machine stand with extraction system	
Three-phase current motor 400 V(kW)	1.4, S2-30 min (short-time operation)
Order no.	317.778
TS 250 SD Pro with brake and machine stand	
Three-phase current motor 400 V(kW)	0.8, S1 (continuous operation)
Order no.	317.851

Double grinding machine TS 300 SD P

Optionally combined
with brake, machine
stand and extraction
system



Fig.: TS 300 SD P with machine stand

Standard equipment

- ▶ Smooth running, no-maintenance motor
- ▶ with emergency stop button and brake
(only standard with art. no. 317.776 and 3177.779)
- ▶ Optional machine stand and extraction system
- ▶ Protective hood closed at the sides
- ▶ Stable, adjustable workpiece supports
- ▶ High safety comfort due to
adjustable spark deflectors
- ▶ Suitable for grinding, deburring and sharpening
of all kinds of tools, metal profiles, etc.
- ▶ Circuit breaker and under-voltage release
- ▶ Spark/eye protection on both sides
- ▶ Connecting cable with CEE plug 16 A
- ▶ 1x coarse and fine grinding wheel
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Different colour shade
(One-component RAL paint)
Order no. 309.010
- ▶ Foot switch emergency stop
(can only be ordered in conjunction with
brake, machine stand and/or extraction system)
Order no. 317.859

Accessories

- ▶ Separate replacement grinding wheel
coarse standard corundum
Order no. 317.622
- ▶ Separate replacement grinding wheel
fine standard corundum
Order no. 317.624
- ▶ Wheel dresser
Order no. 350.101
- ▶ Machine stand with dip tank,
Dimensions: 420 x 520 mm, Weight: 15 kg
(only for 317.764)
Order no. 350.436
- ▶ Machine stand with extraction unit MA 600 D
Motor 0.55 kW, extraction power 350 m³/h
(only for 317.764)
Order no. 330.080

Technical data

Suction piece Ø (mm)	42
TS 300 SD P	
Dimensions of the grinding wheel (mm)	300 x 40 x 51
Machine dimensions without VP (mm)	350 x 530 x 340
Machine dimensions with VP (mm)	800 x 600 x 500
Speed (1/min)	1,250
Three-phase current motor 400 V (kW)	2.2, S2-30 min (short-time operation)
Weight (kg)	55
Order no.	317.764
TS 300 SD P with brake and machine stand	
Machine dimensions without VP (mm)	540 x 530 x 1,180
Machine dimensions with VP (mm)	800 x 600 x 1,400
Weight (kg)	85
Order no.	317.776
TS 300 SD P with brake, machine stand and extraction system	
Machine dimensions without VP (mm)	540 x 530 x 1,180
Machine dimensions with VP (mm)	800 x 600 x 1,400
Weight (kg)	90
Three-phase current motor 400 V (kW)	0.55
Suction capacity m³/h	350
Order no.	317.779

**Combined
belt grinder /
grinding machine
TSB 250 P**



Fig.: TSB 250 P with machine stand

Standard equipment

- ▶ High performance
- ▶ Belt grinding system, height-adjustable, 0-90°
- ▶ Maximum useable surface grinding area
- ▶ Belt adjustment with fine tuning
- ▶ Longitudinal stop for material guiding
- ▶ Perfectly balanced and low vibration
- ▶ Connection for dust extraction system
Ø 50 mm on both sides
- ▶ Circuit breaker with under-voltage release
- ▶ Fixed stop
- ▶ 1 standard grinding belt (below), grain 80
- ▶ 1 grinding wheel 250 x 40 x 51 mm, grain 80
- ▶ Spark arrestor
- ▶ Connecting cable with CEE plug
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Grinding wheel 250 x 40 x 51 mm
Grain 36 coarse
Order no. 317.542
- ▶ Grinding wheel 250 x 40 x 51 mm
Grain 80 fine
Order no. 317.543
- ▶ Standard grinding belt (brown) 1,300 x 75 mm, 5 pieces,
grain 40
Order no. 316.042
- ▶ Standard grinding belt (brown) 1,300 x 75 mm, 5 pieces,
grain 80
Order no. 316.041
- ▶ Graphite coating 80 x 350 mm
Order no. 316.045
- ▶ Machine stand with dip tank
(only for 330.360)
Order no. 350.436
- ▶ Machine stand with integrated
dust extraction system (MA 600) (only for 330.360)
Order no. 330.080

Technical data

TSB 250 P

Dimensions of the grinding wheel (60 grain) (mm)	250 x 40 x 51
Machine dimensions without VP (mm)	600 x 320 x 700
Machine dimensions with VP (mm)	800 x 800 x 800
Speed (1/min)	1,400
Weight (kg)	35
Belt speed (m/s)	15
Band dimensions (mm)	1,300 x 75
Grain size	80
Sound level (dB (A))	78
Three-phase current motor 400 V (kW)	1.4

Measurement with grinding arm position (vertical) (mm)	560 x 320 x 680
Order no.	330.360

TSB 250 P with machine stand, EMERGENCY STOP push button and brake

Machine dimensions without VP (mm)	600 x 540 x 1,190
Machine dimensions with VP (mm)	1,200 x 800 x 1,000
Weight (kg)	65
Order no.	330.365

TSB 250 P with machine stand, EMERGENCY STOP push button, brake and extraction system

Machine dimensions without VP (mm)	600 x 540 x 1,190
Machine dimensions with VP (mm)	1,200 x 800 x 1,000
Weight (kg)	70
Order no.	330.370

Belt grinder TBSM 100



Fig.: TBSM 100

Standard equipment

- ▶ Compact, powerful machine
- ▶ Suitable for all grinding and deburring work
- ▶ Integrated EMERGENCY STOP button
- ▶ Connecting cable with two-pin earthed plug
- ▶ Low noise level
- ▶ Under-voltage release
- ▶ 1 grinding belt grain 80
- ▶ Suction piece Ø 35 mm
- ▶ Belt cover
- ▶ Fixed stop
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Graphite coating 310 x 105 mm
Order no. 371.764
- ▶ Grinding belt: 1,220 x 100 mm, 5 pieces, grain 40
Order no. 371.765
- ▶ Grinding belt: 1,220 x 100 mm, 5 pieces, grain 60
Order no. 371.766
- ▶ Grinding belt: 1,220 x 100 mm, 5 pieces, grain 80
Order no. 371.767
- ▶ Grinding belt: 1,220 x 100 mm, 5 pieces, grain 100
Order no. 371.768
- ▶ Grinding belt: 1,220 x 100 mm, 5 pieces, grain 120
Order no. 371.769
- ▶ Machine stand
height 792 mm
Order no. 371.762

Technical data

TBSM 100

Belt length (mm)	1,220
Belt width (mm)	100
Surface grinding area (mm)	310 x 100
Belt speed (m/sec)	19
Weight (kg)	27
Single phase motor 1 x 230 V (kW)	0.75
Machine dimensions without VP (mm)	650 x 380 x 260
Machine dimensions with VP (mm)	800 x 600 x 4,500
Order no.	371.760

Belt grinder
BSM 75
BSM 75 A
BSM 75 A pol.



Fig.: BSM 75

Standard equipment

- ▶ High-quality construction
- ▶ The drive roller is cyclical (this is how the grinding belt automatically centres itself in the middle of the roller)
- ▶ Completely vulcanised contact roll for the longest possible service life and best possible smoothness
- ▶ Changing the grinding belt does not require any tools and is therefore a faster and simple process
- ▶ Continuous height adjustment for optimum setup of the belt grinder to suit the user
- ▶ Freely adjustable metal stop for optimum and safe guiding of workpieces when using the large surface grinding area
- ▶ Belt speed optimised from a construction point of view to exclude the possibility of the workpiece being burned to the greatest extent possible
- ▶ Model equipped with extraction system with robust and flexible suction hoses
- ▶ Circuit breaker with CEE industrial connector incl. phase inverter
- ▶ Motor brake (except BSM 75 A pol)
- ▶ Incl. grinding belt grain 60
- ▶ Dust bag (only with extraction system)
- ▶ 5-year warranty on the drive motor for single-shift operation

Accessories

- ▶ Connecting cable with CEE plug (3 m)
Order no. 488.761
- ▶ Suction hose
(length: 1.50 m, total length in 2 parts)
Order no. 330.109
- ▶ Graphite coating 75 x 620 mm
Order no. 374.042
- ▶ Dust bag
Order no. 371.055
- ▶ Spark guide plate BSM 75
Order no. 374.071
- ▶ Grinding belt: 2,000 x 75 mm, 5 pieces, grain 40
Order no. 371.150
- ▶ Grinding belt: 2,000 x 75 mm, 5 pieces, grain 60
Order no. 371.151
- ▶ Grinding belt: 2,000 x 75 mm, 5 pieces, grain 80
Order no. 371.152
- ▶ Grinding belt: 2,000 x 75 mm, 5 pieces, grain 100
Order no. 371.153
- ▶ Grinding belt: 2,000 x 75 mm, 5 pieces, grain 120
Order no. 371.154
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 75 mm, 5 pieces, grain 40
Order no. 371.824

Technical data

Belt length (mm)	2,000
Belt width (mm)	75
Surface grinding area (mm)	600
Colour (RAL)	9007
Machine dimensions without VP (mm)	1,100 x 550 x 1,035
Machine dimensions with VP (mm)	800 x 700 x 1,400

BSM 75

Belt speed (m/s)	30
Three-phase current motor 400 V (kW)	3.75
Extraction capacity (m³/h)	–
Suction motor (kW)	–
Weight (kg)	80
Order no.	374.000

BSM 75 A

Belt speed (m/s)	30
Three-phase current motor 400 V (kW)	3.75
Extraction capacity (m³/h)	approx. 630
Suction motor (kW)	0.37
Weight (kg)	90
Order no.	374.001

BSM 75 A pol.

Belt speed (m/s)	15/30
Three-phase current motor 400 V (kW)	3.0/3.75
Extraction capacity (m³/h)	approx. 630
Suction motor (kW)	0.37
Weight (kg)	105
Order no.	374.002

- ▶ Grinding belt for steel and grey cast iron:
2,000 x 75 mm, 5 pieces, grain 60
Order no. 371.825
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 75 mm, 5 pieces, grain 80
Order no. 371.826
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 75 mm, 5 pieces, grain 120
Order no. 371.827

Belt grinder
BSM 150
BSM 150 A
BSM 150 A pol.



Fig.: BSM 150 A with extraction system



Fig.: BSM 150 A Pol with option

Standard equipment

- ▶ High-quality construction
- ▶ The drive roller is cyclical (this is how the grinding belt automatically centres itself in the middle of the roller)
- ▶ Completely vulcanised contact roll for the longest possible service life and best possible smoothness
- ▶ Changing the grinding belt does not require any tools and is therefore a faster and simple process
- ▶ Continuous height adjustment for optimum setup of the belt grinder to suit the user
- ▶ Freely adjustable metal stop for optimum and safe guiding of workpieces when using the large surface grinding area
- ▶ Belt speed optimised from a construction point of view to exclude the possibility of the workpiece being burned to the greatest extent possible
- ▶ Model equipped with extraction system with robust and flexible suction hoses
- ▶ Circuit breaker with CEE industrial connector incl. phase inverter
- ▶ Motor brake (except BSM 150 A pol)
- ▶ Incl. grinding belt grain 60
- ▶ Dust bag (only with extraction system)
- ▶ 5-year warranty on the drive motor for single-shift operation

Accessories

- ▶ Connecting cable with CEE plug (3 m)
Order no. 488.761
- ▶ Suction hose
(length: 1.50 m, total length in 2 parts)
Order no. 330.109
- ▶ Graphite coating 150 x 620 mm
Order no. 374.043
- ▶ Dust bag
Order no. 371.055
- ▶ Spark guide plate BSM 150
Order no. 374.070
- ▶ Grinding belt: 2,000 x 150 mm, 5 pieces, grain 40
Order no. 371.125
- ▶ Grinding belt: 2,000 x 150 mm, 5 pieces, grain 60
Order no. 371.126
- ▶ Grinding belt: 2,000 x 150 mm, 5 pieces, grain 80
Order no. 371.127
- ▶ Grinding belt: 2,000 x 150 mm, 5 pieces, grain 100
Order no. 371.128
- ▶ Grinding belt: 2,000 x 150 mm, 5 pieces, grain 120
Order no. 371.129
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 150 mm, 5 pieces, grain 40
Order no. 371.828

Technical data

Belt length (mm)	2,000
Belt width (mm)	150
Surface grinding area (mm)	600
Colour (RAL)	9007
Machine dimensions without VP (mm)	1,100 x 550 x 1,035
Machine dimensions with VP (mm)	800 x 700 x 1,400

BSM 150

Belt speed (m/s)	30
Three-phase current motor 400 V (kW)	3.75
Extraction capacity (m³/h)	–
Suction motor (kW)	–
Weight (kg)	90
Order no.	374.020

BSM 150 A

Belt speed (m/s)	30
Three-phase current motor 400 V (kW)	3.75
Extraction capacity (m³/h)	approx. 630
Suction motor (kW)	0.37
Weight (kg)	100
Order no.	374.021

BSM 150 A pol.

Belt speed (m/s)	15/30
Three-phase current motor 400 V (kW)	3.0/3.75
Extraction capacity (m³/h)	approx. 630
Suction motor (kW)	0.37
Weight (kg)	105
Order no.	374.022

- ▶ Grinding belt for steel and grey cast iron:
2,000 x 150 mm, 5 pieces, grain 60
Order no. 371.829
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 150 mm, 5 pieces, grain 80
Order no. 371.830
- ▶ Grinding belt for steel and grey cast iron:
2,000 x 150 mm, 5 pieces, grain 120
Order no. 371.831

Brush deburring machine BEM 250 Plus



Fig.: BEM 250 Plus

Standard equipment

- ▶ Robust industrial three-phase current motor
- ▶ Adjustable eye protection
- ▶ Easily adjustable sliding unit (via adjustment screw) in case of wear of the deburring brush to the workpiece support
- ▶ Combined workpiece support both for round material (prism) , flat and rectangular profiles (movable)
- ▶ Adjustable upper cover strip using the clamping lever (serves the purpose of adaptation to fit material size)
- ▶ Ø 80 mm suction piece with end plate (for connection to external extraction system)
- ▶ Machine colour:
 - Machine body RAL 7035
 - Side cover: RAL 7005
- ▶ 1 set of machine feet (4 pieces) with adjustment screw
- ▶ 1 round deburring brush 250 x 60/0.35 mm steel wire corrugated
- ▶ Connecting cable with CEE plug
- ▶ Incl. operating tools
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Round deburring brush 250 x 60, steel wire 0.35 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm
Order no. 373.176
- ▶ Round deburring brush 250 x 60, steel wire 0.20 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for small and thin-walled pipes/profiles)
Order no. 373.177
- ▶ Round deburring brush 250 x 60, steel wire 0.50 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for thick-walled pipes/profiles)
Order no. 373.178
- ▶ Round deburring brush 250 x 60, steel wire 0.35 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for steel pipes/profiles)
Order no. 373.179

Other brushes for materials - such as aluminium or anodised profiles - on request

Technical data

BEM 250 Plus

Brush diameter (mm)	250
Brush width normal (mm)	60
Socket bore (mm)	50.8
Max. material size (mm)	70 x 140
Working height (mm)	930
Speed/ pole-changeable (rpm)	2,800/1,400
Drive power (kW)	2.1/1.8
Electrical connection (V/Hz)	400/50
Weight (kg)	85
Machine dimensions (mm)	500 x 560 x 1,250
Machine dimensions with VP (mm)	1,400 x 750 x 1,350
Order no.	373.150

Brush deburring machine BEM 250 Pro



Fig.: BEM 250 Pro

Standard equipment

- ▶ High-performance deburring system for interior and exterior deburring of profiles and pipes in one working cycle (approx. 3 secs)
- ▶ Compact and robust construction
- ▶ High-performance industrial-drive three-phase current motor, frequency-regulated for optimum setting of the required speed (600-2,700 1/min) stepless
- ▶ For deburring pipes and profiles (max. material size horizontal/vertical) 120 mm
- ▶ Easily adjustable work table height (can be set and locked) for the material size in question
- ▶ Adjustable, lockable feed (sledges) on the deburring brushes for the work bench using a large handwheel (with locking function)
- ▶ Easily removable dust residue drawer
- ▶ Robust sheet steel housing construction with preparation (opening) for connection to an external extraction system
- ▶ Easily accessible housing hoods (folding) for changing the brushes
- ▶ Machine colour:
 - Machine body RAL 7035
 - Side cover: RAL 7005
- ▶ 1 set of machine feet (4 pieces) with adjustment screw
- ▶ 3 round deburring brushes 250 x 60/0.35 mm steel wire corrugated
- ▶ Connecting cable with CEE plug
- ▶ Incl. operating tools
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Round deburring brush 250 x 60, steel wire 0.35 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm
Order no. 373.176
- ▶ Round deburring brush 250 x 60, steel wire 0.20 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for small and thin-walled pipes/profiles)
Order no. 373.177
- ▶ Round deburring brush 250 x 60, steel wire 0.50 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for thick-walled pipes/profiles)
Order no. 373.178
- ▶ Round deburring brush 250 x 60, steel wire 0.35 mm corrugated bore 50.8 mm, double keyway 13 x 7 mm (for steel pipes/profiles)
Order no. 373.179

Other brushes for materials - such as aluminium or anodised profiles - on request




Technical data




BEM 250 Pro*




Brush diameter (mm)	250 (3 pieces)
Brush width normal (mm)	60
Socket bore (mm)	50.8
Working height (mm)	1,050
Speed, stepless (rpm)	600-2,700
Drive power, frequency-regulated (kW)	3
Electrical connection (V/Hz)	400/50
Weight (kg)	410
Machine dimensions (mm)	680 x 1,200 x 1,380
Machine dimensions with VP (mm)	1.150 x 680 x 1.440
Order no.	373.155




* The brush deburring machine is fitted with a frequency converter and complies with the standard DIN EN 55011:2016 + A1:2017.

Overview saws

Horizontal bandsaws	Band saw blade size mm	 * at 0° mm	 * at 0° mm	 * at 0° mm	Page
HBS 225 A	2,720 x 27 x 0.9	230	275 x 200	230 x 230	98
HBS 230 ANC	2,720 x 27 x 0.9	230	275 x 180	230 x 230	100
HBS 250 A	2,910 x 27 x 0.9	250	320 x 190	240 x 240	102
HBS 250 HA	2,910 x 27 x 0.9	250	320 x 190	240 x 240	104
HBS 350 HA	4,780 x 34 x 1.1	350	510 x 350	350 x 350	106
HBS 350 ANC	4,780 x 34 x 1.1	350	510 x 350	350 x 350	108
HBS 350 SANC	4,780 x 34 x 1.1	350	420 x 350	350 x 350	110
HBS 450 HA	5,200 x 34 x 1.1	450	610 x 450	450 x 450	112
HBS 450 SANC	6,020 x 41 x 1.3	450	520 x 450	450 x 450	114

Vertical bandsaws	Saw blade Ø mm	 * at 0° mm	 * at 0° mm	 * at 0° mm	Page
VBS 400 Plus	3,600 x 13 x 0.9		400 x 390		116

Metal circular saw	Saw blade Ø mm	 * at 0° mm	 * at 0° mm	 * at 0° mm	Page
KS315M	315 x 32	95	100 x 70	80	118

Portable metal band saws	Band saw blade size mm	 * at 0° mm	 * at 0° mm	 * at 0° mm	Page
PBS 120 Plus	1,620 x 13 x 0.65	120	60 x 70	120 x 120	120

*Mitre cuts are possible. Please see the catalogue pages that are indicated for further information.

Explanation of abbreviations

Lowering (Hydraulic cylinder)	A	Automatic NC	ANC	Vertical band saw	VBS
Semi-automatic	HA	Column-guided automatic NC	SANC	Circular saw	KS
		Horizontal bandsaw	HBS	Portable band saw	PBS



SAWING TECHNOLOGY

Horizontal bandsaws	98-115
Circular saw	118-119
Portable band saw	120-121
Accessories	122-123



FLOTT

Metal band saw

HBS 225 A



Precise guiding
the saw blade is guided
precisely using
ground carbide plates



Saw blade break monitoring
the saw blade tension is
fitted with a saw blade tension
monitoring and saw blade break
monitoring device



Round supporting table
the machine has a supporting table
that rotates with the mitre cuts.
This means no slits



Operating elements
All operating elements are
accessible from the front of
the machine



**Powered
chip removal brush**

Standard equipment

- ▶ New saw concept with a multitude of standards – for every workshop
- ▶ Torsion-resistant, robust cast saw frame
- ▶ Powered chip removal brush
- ▶ High-performance industrial worm geared drive motor
- ▶ Independent switching-off at the end of the cut
- ▶ Mechanical saw blade tensioning with electrical blade break monitoring system
- ▶ Quick-change vice, sliding
- ▶ Hydraulic saw frame lowering with fast-action function (stepless control)
- ▶ Electric coolant pump
- ▶ Precision carbide saw blade guides, ground (adjustable)
- ▶ Large, round supporting table, rotates along with mitre cuts, mitre display (scale) for the operator
- ▶ Easily removable chip collection container
- ▶ Material stop 500 mm with scale
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Laser line for cutting
Order no. 570.172
- ▶ Micro spraying system
Order no. 570.170
- ▶ LED work light
Order no. 570.174

Accessories

- ▶ Blade tension measurement device with dial indicator (Flottomat-BS)
Order no. 570.175
- ▶ Connection L-SR (steel coil), left, 330 mm wide (incl. fastening set)
Order no. 570.176
- ▶ Connection L-SR (steel coil), right, 330 mm wide (incl. fastening set)
Order no. 570.177
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 2,000 mm, 150 kg/m
Order no. 570.178
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 3,000 mm, 150 kg/m
Order no. 570.179
- ▶ Extension roller conveyor L-SR (steel coil), 2,000 mm, 150 kg/m
Order no. 570.180
- ▶ Extension roller conveyor L-SR (steel coil), 3,000 mm, 150 kg/m
Order no. 570.181

Technical data

HBS 225 A

Three-phase current motor 400 V, pole-changeable (kW)	0.7/1.1
Saw blade dimensions (mm)	2,720 x 27 x 0.9
Flywheels Ø (mm)	300
Cutting speed (m/min)	40/80
Vice span (mm)	275
Working height (mm)	978
Machine dimensions (mm)	1,150 x 1,588 x 1,477
Weight (kg)	370
Order no.	570.050
Additional accessories	from page 122

Sawing area

	0 °	45° R	45° L	60° R
○	230	190	170	120
□	275 x 180	190 x 150	185 x 100	120 x 100
□	230 x 230	180 x 180	150 x 150	100 x 100

HSS Bi-Metal (M42) Band Saw Blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.200	2,720 x 27 x 0.9	4/6	1
570.201	2,720 x 27 x 0.9	5/8	1
570.202	2,720 x 27 x 0.9	6/10	1
570.203	2,720 x 27 x 0.9	10/14	1

¹ Other bandsaw blades on request

- ▶ Adjustable vertical rollers
Order no. 570.190
- ▶ Adjustable vertical rollers
Order no. 570.188
- ▶ Starter band saw blade package 2,720 x 27 x 0.9 mm each consisting of 1 pc. combi-toothings 4/6, 5/8, 6/10, 10/14
Order no. 570.233
- ▶ Manual material stop 3 m with measuring tape
Order no. 570.195
- ▶ Manual material stop 3 m with digital display
Order no. 570.240
- ▶ Manual material stop 2 m with measuring tape
Order no. 570.194
- ▶ Manual material stop 2 m with digital display
Order no. 570.199
- ▶ further measuring stops on request

FLOTT

Metal band saw

HBS 230 ANC



Fig.:Option roller conveyor

Standard equipment

- ▶ Fully hydraulic lowering and lifting function of the sawframe, NC control, fully automatic
- ▶ Hydraulic opening and closing of the vice
- ▶ Switches off after end of cutting, saw arm guided back to the starting position
- ▶ Torsion-resistant saw frame made of cast steel (multi-ribbed)
- ▶ feed vice mounted on linear guides
- ▶ Precisely ground carbide saw blade guides, adjustable
- ▶ Electric coolant pump
- ▶ Manual blade tensioning with display, including electrical saw blade and cutting pressure monitoring system
- ▶ Hydraulic cutting feed incl. automatic cutting pressure regulation
- ▶ Chip removal brush, rotating
- ▶ Positioning plate rotatable, for mitre cuts with cutting channel, mitre adjustment manual, reading via scale
- ▶ Minimum remaining piece length 180 mm, smallest possible diameter 5 mm
- ▶ Feed length (single stroke) 490 mm, max. stroke repetition 999
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Chip rinsing pistol
Order no. 570.110
- ▶ Laser line for cutting
Order no. 570.172
- ▶ Micro spraying system
Order no. 570.170
- ▶ LED work lighting
Order no. 570.174

Accessories

- ▶ Connecting track L-SR (steel roller), right, 330 mm wide (incl. connection set)
Order no. 570.370
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 2,000 mm, 150 kg/m
Order no. 570.178
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 3,000 mm, 150 kg/m
Order no. 570.179
- ▶ Extension roller conveyor L-SR (steel coil), 2,000 mm, 150 kg/m
Order no. 570.180
- ▶ Extension roller conveyor L-SR (steel coil), 3,000 mm, 150 kg/m
Order no. 570.181




Technical data

HBS 230 ANC

Three-phase current motor 400 V, pole-changeable (kW)	0.7/1.1
Saw blade dimensions (mm)	2,720 x 27 x 0.9
Flywheels Ø (mm)	300
Cutting speed (m/min)	40/80
Vice span (mm)	275
Working height (mm)	768
Machine dimensions (mm)	2,440 x 1,650 x 1,970
Weight (kg)	500
Order no.	570.040

Additional accessories from page 122

Sawing area

	0 °	45° R	60° R
	230	170	120
	275 x 180	185 x 100	120 x 100
	230 x 230	150 x 150	100 x 100

HSS Bi-Metal (M42) Band Saw Blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.200	2,720 x 27 x 0.9	4/6	1
570.201	2,720 x 27 x 0.9	5/8	1
570.202	2,720 x 27 x 0.9	6/10	1
570.203	2,720 x 27 x 0.9	10/14	1

¹ Other bandsaw blades on request

- ▶ Adjustable vertical rollers
Order no. 570.190
- ▶ Adjustable vertical rollers
Order no. 570.188
- ▶ Starter band saw blade package 2,720 x 27 x 0.9 mm each consisting of 1 pc. combi-toothing 4/6, 5/8, 6/10, 10/14
Order no. 570.233

FLOTT

Metal band saw

HBS 250 A



Pistol for rinsing away
the chips
(optional)



Roller conveyor with
vertical rollers
(accessory)

Standard equipment

- ▶ High-performance band saw with hydraulic saw frame lowering (control valve) for mitre cuts from 0° to 60° right/45° left
- ▶ Saw frame made from a stable cast construction (torsion-resistant)
- ▶ Cut feed over frame weight
- ▶ High-quality industrial three-phase current motor (spur gear) for all requirements (frequency-controlled)
- ▶ Chip removal brush, rotating
- ▶ Precisely ground carbide saw blade guides, adjustable
- ▶ Quick-change vice, sliding
- ▶ Large, heavy, round supporting table, rotates along with mitre cuts with the fixed cutting channel, mitre display via scale
- ▶ Mitre settings and clamping are manual
- ▶ Removable chip collection container
- ▶ Electric coolant pump
- ▶ Material stop 500 mm with scale
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Chip rinsing pistol
Order no. 570.110
- ▶ Laser line for cutting
Order no. 570.172
- ▶ Micro spraying system
Order no. 570.170
- ▶ LED work light
Order no. 570.174

Accessories

- ▶ Blade tension measurement device with dial indicator (Flottomat-BS)
Order no. 570.175
- ▶ L-SR (steel coil), left, 330 mm wide (incl. fastening set)
Order no. 570.282
- ▶ L-SR (steel coil), right, 330 mm wide (incl. fastening set)
Order no. 570.281
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 2,000 mm, 150 kg/m
Order no. 570.178
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 3,000 mm, 150 kg/m
Order no. 570.179
- ▶ Extension roller conveyor L-SR (steel coil), 2,000 mm, 150 kg/m
Order no. 570.180
- ▶ Extension roller conveyor L-SR (steel coil), 3,000 mm, 150 kg/m
Order no. 570.181

Technical data

HBS 250 A

Three-phase current motor 400 V, frequency-regulated (kW)	1.5
Saw blade dimensions (mm)	2,910 x 27 x 0.9
Flywheels Ø (mm)	325
Cutting speed (m/min)	20-120
Vice span (mm)	320
Working height (mm)	760
Machine dimensions (mm)	1,480 x 1,700 x 2,000
Weight (kg)	390
Order no.	570.005
Additional accessories	from page 122

Sawing area

	0 °	45° R	45° L	60° R
○	250	220	180	130
□	300 x 240	240 x 190	240 x 100	130 x 100
□	240 x 240	210 x 210	160 x 160	100 x 100

HSS Bi-Metal (M42) Band Saw Blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.206	2,910 x 27 x 0.9	2/3	1
570.207	2,910 x 27 x 0.9	3/4	1
570.208	2,910 x 27 x 0.9	4/6	1
570.209	2,910 x 27 x 0.9	5/8	1
570.210	2,910 x 27 x 0.9	10/14	1

¹ Other bandsaw blades on request

- ▶ Adjustable vertical rollers
Order no. 570.190
- ▶ Adjustable vertical rollers
Order no. 570.188
- ▶ Starter band saw blade package 2,910 x 27 x 0.9 mm each consisting of 1 pc. combi-toothing 2/3, 3/4, 4/6, 5/8, 10/14
Order no. 570.234
- ▶ Manual material stop 2 m with measuring tape
Order no. 570.194
- ▶ Manual material stop 3 m with measuring tape
Order no. 570.195
- ▶ Manual material stop 2 m with digital display
Order no. 570.199
- ▶ Manual material stop 3 m with digital display
Order no. 570.240
- ▶ further measuring stops on request

FLOTT

Metal band saw

HBS 250 HA



Mitre reading display



Saw blade guide
made from carbide



Laser line for
cutting
(optional)



LED lighting
for the working area
(optional)



Pistol for rinsing away
the chips
(optional)

Standard equipment

- ▶ Fully hydraulic lowering and lifting system for the saw frame
- ▶ Hydraulic opening and closing of the vice
- ▶ Switches off after end of cutting, saw arm guided back to the starting position
- ▶ Torsion-resistant saw frame made from cast steel (multiple ribbed)
- ▶ Hydraulic short-stroke cylinder for vice
- ▶ Precisely ground carbide saw blade guides, adjustable
- ▶ Electric coolant pump
- ▶ Manual blade tensioning with display, including electrical saw blade and cutting pressure monitoring system
- ▶ Hydraulic vice (opening and closing)
- ▶ Chip removal brush, rotating
- ▶ Large, heavy, round supporting table, rotates along with mitre cuts with the fixed cutting channel, manual mitre setting, can be read from scale
- ▶ Material stop 500 mm with scale
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Chip rinsing pistol
Order no. 570.110
- ▶ Laser line for cutting
Order no. 570.172
- ▶ Micro spraying system
Order no. 570.170
- ▶ LED work light
Order no. 570.174

Accessories

- ▶ Blade tension measurement device with dial indicator (Flottomat-BS)
Order no. 570.175
- ▶ Flashing L-SR (steel coil), left, 330 mm wide (incl. fastening set)
Order no. 570.282
- ▶ Flashing L-SR (steel coil), right, 330 mm wide (incl. fastening set)
Order no. 570.281
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 2,000 mm, 150 kg/m
Order no. 570.178
- ▶ Roller conveyor L-SR (steel coil), 330 mm wide, basic version 3,000 mm, 150 kg/m
Order no. 570.179
- ▶ Extension roller conveyor L-SR (steel coil), 2,000 mm, 150 kg/m
Order no. 570.180
- ▶ Extension roller conveyor L-SR (steel coil), 3,000 mm, 150 kg/m
Order no. 570.181

Technical data

HBS 250 HA

Three-phase current motor 400 V, frequency-regulated (kW)	1.5
Saw blade dimensions (mm)	2,910 x 27 x 0.9
Flywheels Ø (mm)	325
Cutting speed (m/min)	20-120
Vice span (mm)	320
Working height (mm)	760
Machine dimensions (mm)	1,480 x 1,700 x 2,000
Weight (kg)	390
Order no.	570.010

Additional accessories from page 122

Sawing area

	0 °	45° R	45° L	60° R
○	250	220	180	130
□	300 x 240	240 x 190	240 x 100	130 x 100
□	240 x 240	210 x 210	160 x 160	100 x 100

HSS Bi-Metal (M42) Band Saw Blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.206	2,910 x 27 x 0.9	2/3	1
570.207	2,910 x 27 x 0.9	3/4	1
570.208	2,910 x 27 x 0.9	4/6	1
570.209	2,910 x 27 x 0.9	5/8	1
570.210	2,910 x 27 x 0.9	10/14	1

¹ Other bandsaw blades on request

- ▶ Adjustable vertical rollers
Order no. 570.190
- ▶ Adjustable vertical rollers
Order no. 570.188
- ▶ Starter band saw blade package 2,910 x 27 x 0.9 mm each consisting of 1 pc. combi-toothing 2/3, 3/4, 4/6, 5/8, 10/14
Order no. 570.234
- ▶ Manual material stop 2 m with measuring tape
Order no. 570.194
- ▶ Manual material stop 3 m with measuring tape
Order no. 570.195
- ▶ Manual material stop 2 m with digital display
Order no. 570.199
- ▶ Manual material stop 3 m with digital display
Order no. 570.240
- ▶ further measuring stops on request

FLOTT

Metal band saw

HBS 350 HA



Pistol for rinsing away the chips
(optional)



Full-lift cylinder for the vice



Pressure regulation for the vice
(optional)



Bundle tensioning device
Enables layers and bundles to be tensioned using an additional vertical tensioning unit (optional)



Blade tension display
For monitoring the optimum saw blade tension even while the machine is in operation (standard)

Standard equipment

- ▶ Ergonomic, robust welded frame construction, new concept in appealing design for mitre cuts from 0° to 60° right /left
- ▶ Stable, low vibration frame construction with bearing hinged arm joint
- ▶ Simple operation console for the operators
- ▶ Simple, easy-to-understand control system
- ▶ Precisely ground carbide saw blade guides (adjustable) for the highest demands on cutting accuracy
- ▶ Synchronous powered chip removal brush
- ▶ Semi-automatic sawing cycle: fully hydraulic
- ▶ Hydraulic cutting feed incl. automatic cutting pressure regulation
- ▶ Mitre settings and clamping (manual)
- ▶ Hydraulic full-lift cylinder for the vice (Pull-down design) floating vice
- ▶ Blade tension and saw blade break monitoring system
- ▶ Integrated coolant supply (30l tank capacity)
- ▶ Easily removable chip collection containers
- ▶ Hydraulic Blade tension display
- ▶ LED work light
- ▶ Digital mitre display
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Chip rinsing pistol
Order no. 570.110
- ▶ Laser line for cutting
Order no. 570.109
- ▶ Hydraulic bundle tensioning device
Order no. 570.107
- ▶ Clamping pressure regulation for vice
Order no. 570.076

Accessories

- ▶ Material stop 500 mm (measuring scale)
Order no. 570.268
- ▶ Connecting track (steel coil), left, 540 mm wide (incl. fastening set)
Order no. 570.111
- ▶ Connecting track (steel coil), right, 540 mm wide (incl. fastening set)
Order no. 570.112
- ▶ Roller conveyor T-SR (steel coil), 540 mm wide, basic version 2,000 mm, 600 kg/m
Order no. 570.113
- ▶ Roller conveyor T-SR (steel coil), 540 mm wide, basic version 3,000 mm, 600 kg/m
Order no. 570.114
- ▶ Extension roller conveyor T-SR (steel coil), 2,000 mm, 600 kg/m
Order no. 570.115
- ▶ Extension roller conveyor T-SR (steel coil), 3,000 mm, 600 kg/m
Order no. 570.116

Technical data

HBS 350 HA

Three-phase current motor 400 V, frequency-regulated (kW)	3
Saw blade dimensions (mm)	4,780 x 34 x 1.1
Flywheels Ø (mm)	450
Cutting speed (m/min)	20-120
Vice span, full-lift cylinder (mm)	510
Working height (mm)	761
Machine dimensions (mm)	2,568 x 1,070 x 1,500
Weight (kg)	710
Order no.	570.520
Additional accessories	from page 122

Sawing area

	0 °	45° R	45° L	60° R	60° L
○	350	350	350	250	270
□	510 x 350	400 x 100	415 x 100	260 x 100	280 x 100
□	350 x 350	340 x 340	350 x 350	240 x 240	260 x 260

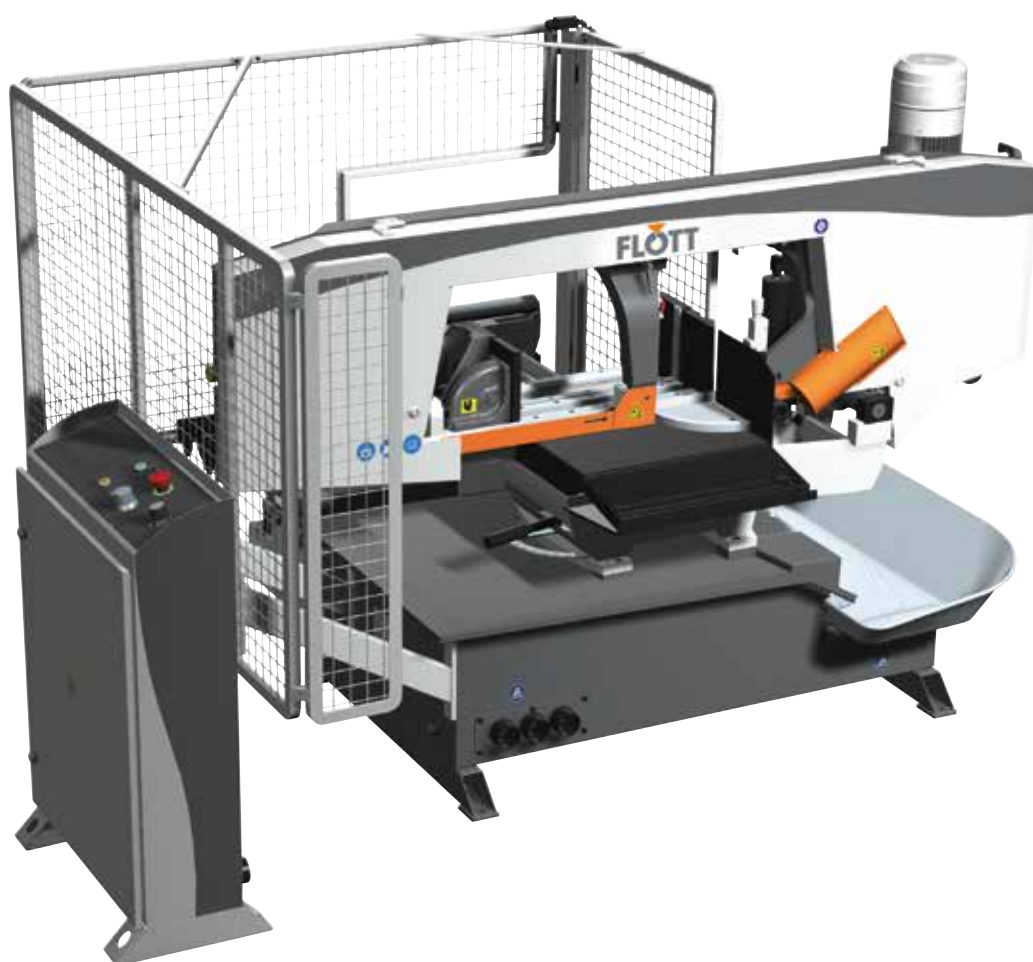
HSS Bi-Metal (M42) Band saw blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.213	4,780 x 34 x 1.1	2/3	1
570.214	4,780 x 34 x 1.1	3/4	1
570.215	4,780 x 34 x 1.1	4/6	1
570.216	4,780 x 34 x 1.1	5/8	1
570.217	4,780 x 34 x 1.1	8/12	1

¹ Other bandsaw blades on request

- ▶ Adjustable vertical rollers
Order no. 570.119
- ▶ Fixed vertical rollers
Order no. 570.120
- ▶ Starter band saw blade package 4,780 x 34 x 1.1 mm each consisting of 1 pc. combi-toothing 2/3, 3/4, 4/6, 5/8, 8/12
Order no. 570.235
- ▶ Manual measuring stop 2 m with digital
Order no. 570.127
- ▶ Manual measuring stop 3 m with measuring tape
Order no. 570.123
- ▶ Manual measuring stop 2 m with measuring tape
Order no. 570.122
- ▶ Manual measuring stop 3 m with digital
Order no. 570.128
- ▶ Manual material stop 3 m with digital display
Order no. 570.240
- ▶ further measuring stops on request

FLOTT
Metal band saw
HBS 350 ANC



Standard equipment

- ▶ The perfect combination of semi-automatic/automatic high-performance band saws for mitre cuts from 0° to 60° right
- ▶ Automatic operation only at 0° (in accordance with cutting data)
- ▶ Appealing design
- ▶ Saw frame with joint bearing, in robust welded frame construction
- ▶ Freely positionable console with an easy to read LCD control panel
- ▶ Integrated material feed (plain bearing) in automatic operation
- ▶ Feed length (single stroke) 600 mm
- ▶ Feed via hydraulic cylinder
- ▶ Max. stroke repetition: 999
- ▶ Smallest diameter for sawing: 10 mm
- ▶ Rest length: 60 mm
- ▶ The smallest cut piece (L x H): 15 x 5 mm
- ▶ Hydraulic full-lift cylinder for the vice (Pull-down design)
- ▶ Cut feed including automatic cutting pressure regulation
- ▶ Double-pump hydraulic unit
- ▶ Precisely ground carbide saw blade guides (adjustable)
- ▶ Clamping pressure regulation for vice
- ▶ Floating vice
- ▶ Blade tension and saw blade break monitoring system
- ▶ Easily removable chip collection containers
- ▶ Integrated coolant supply (30 l tank capacity)
- ▶ LED work light
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Hydraulic bundle tensioning device
Order no. 570.064
- ▶ Hydraulic blade tension display
Order no. 570.065
- ▶ Micro spraying system 24 V
Order no. 570.254
- ▶ Laser line for cutting
Order no. 570.109

Accessories

- ▶ Connecting track T-SR, left (incl. connection set)
Order no. 570.284
- ▶ Connecting track T-SR, right, (incl. connection set)
Order no. 570.112
- ▶ Roller conveyor T-SR (steel roller), 540 mm wide, Basic version 2,000 mm, 600 kg/m
Order no. 570.113
- ▶ Roller conveyor T-SR (steel roller), 540 mm wide, Basic version 3,000 mm, 600 kg/m
Order no. 570.114




Technical data

HBS 350 ANC

Three-phase current motor 400 V, frequency-regulated (kW)	3
Saw blade dimensions (mm)	4,780 x 34 x 1.1
Flywheels Ø (mm)	450
Cutting speed (m/min)	20-120
Vice span (mm)	510
Working height (mm)	761
Machine dimensions (mm)	2,440 x 2,880 x 1,540
Weight (kg)	950
Order no.	570.025

Additional accessories from page 122

Sawing area

	0°	45° R	60° R
	350	350	250
	510 x 350	400 x 100	260 x 100
	350 x 350	340 x 340	240 x 240

HSS Bi-Metal (M42) Band saw blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.213	4,780 x 34 x 1.1	2/3	1
570.214	4,780 x 34 x 1.1	3/4	1
570.215	4,780 x 34 x 1.1	4/6	1
570.216	4,780 x 34 x 1.1	5/8	1
570.217	4,780 x 34 x 1.1	8/12	1

¹ Other bandsaw blades on request

- ▶ Extension roller conveyor T-SR (steel roller), 2,000 mm, 600 kg/m
Order no. 570.115
- ▶ Extension roller conveyor T-SR (steel roller), 3,000 mm, 600 kg/m
Order no. 570.116
- ▶ Starter band saw blade package 4,780 x 34 x 1.1 mm each consisting of 1 pc. combi-toothings 2/3, 3/4, 4/6, 5/8, 8/12
Order no. 570.235
- ▶ Manual measuring stop 2 m with digital
Order no. 570.127
- ▶ Manual measuring stop 3 m with measuring tape
Order no. 570.123
- ▶ Manual measuring stop 2 m with measuring tape
Order no. 570.122
- ▶ Manual measuring stop 3 m with digital
Order no. 570.128
- ▶ Manual material stop 3 m with digital display
Order no. 570.240
- ▶ further measuring stops on request

FLOTT
Metal band saw
HBS 350 SANC



Standard equipment

- ▶ Fully automatic 2-column horizontal high-performance automatic band saw – perfect for industrial use
- ▶ The saw frame is guided by two robust columns and is unilaterally backlash free in a pretensioned linear guide
- ▶ 3-side precision HM saw blade guiding for optimum cutting results
- ▶ Blade tension and saw blade break monitoring system
- ▶ Synchronous powered chip removal brush
- ▶ Fully hydraulic sawing process:
 - Material feed (plain bearing)
 - Feed length (single stroke) 600 mm
 - Feed via hydraulic cylinder
- ▶ Max. stroke repetition: 999
- ▶ Smallest diameter for sawing 10 mm
- ▶ Rest length: 20 mm
- ▶ The smallest cut piece (L x H): 10 x 5 mm
- ▶ Hydraulic Cutting feed on the saw arm (incl. automatic cutting pressure regulation) saw frame lift height limiter via limit stop switch
- ▶ Simple and clear operation of the control panel (can be freely positioned) simple programming with display (steps) on the control panel display
- ▶ Hydraulic Full-lift cylinder for the vice
- ▶ Double-pump hydraulic unit
- ▶ Hydraulic Bundle tensioning device
- ▶ Clamping pressure regulation for vice, split vice, floating
- ▶ Integrated coolant supply (45 l tank capacity)
- ▶ LED work light
- ▶ Scraper floor-chip conveyor directly under the cutting channel
- ▶ Incl. saw blade combination toothing 4/6
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Saw feed speed display
Order no. 570.063
- ▶ Micro spraying system 24 V
Order no. 570.254
- ▶ Additional [3] coolant supply units
Order no. 570.173
- ▶ Chip rinsing pistol
Order no. 570.110
- ▶ Hydraulic blade tension display
Order no. 570.065

Accessories

- ▶ Connecting track X-SR, left (incl. fastening set)
Order no. 570.255
- ▶ Roller conveyor X-SR (steel coil x 2 pieces), 450 mm wide, basic version 2,000 mm, 1,500 kg/m
Order no. 570.256
- ▶ Roller conveyor X-SR (steel coil x 3 pieces), 450 mm wide, basic version 3,000 mm, 1,500 kg/m
Order no. 570.258




Technical data

HBS 350 SANC

Three-phase current motor 400 V, frequency-regulated (kW)	3
Saw blade dimensions (mm)	4,780 x 34 x 1.1
Flywheels Ø (mm)	450
Cutting speed (m/min)	20-120
Vice span (mm)	420
Working height (mm)	780
Machine dimensions (mm)	2,300 x 2,050 x 2,000
Weight (kg)	1,200
Order no.	570.030

Additional accessories from page 122

Sawing area

	Ø °
	350
	420 x 350
	350 x 350

HSS Bi-Metal (M42) Band saw blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.213	4,780 x 34 x 1.1	2/3	1
570.214	4,780 x 34 x 1.1	3/4	1
570.215	4,780 x 34 x 1.1	4/6	1
570.216	4,780 x 34 x 1.1	5/8	1
570.217	4,780 x 34 x 1.1	8/12	1

¹ Other bandsaw blades on request

- ▶ Extension roller conveyor X-SR (steel coil x 2 pieces), 2,000 mm, 1,500 kg/m
Order no. 570.260
- ▶ Extension roller conveyor X-SR (steel coil x 3 pieces), 3,000 mm, 1,500 kg/m
Order no. 570.262
- ▶ Starter band saw blade package 4,780 x 34 x 1.1 mm each consisting of 1 pc. combi-toothings 2/3, 3/4, 4/6, 5/8, 8/12
Order no. 570.235
- ▶ further measuring stops on request

FLOTT

Metal band saw

HBS 450 HA



Pistol for rinsing away the chips
(optional)



Full-lift cylinder for the vice



Pressure regulation for the vice
(optional)



Bundle tensioning device
Enables layers and bundles to be tensioned using an additional vertical tensioning unit (optional)



Blade tension display
For monitoring the optimum saw blade tension even while the machine is in operation (standard)

Standard equipment

- ▶ Ergonomic, robust welded frame construction, new concept in appealing design for mitre cuts from 0° to 60° right /left
- ▶ Stable, low vibration frame construction with bearing hinged arm joint
- ▶ Simple operation console for the operators
- ▶ Simple, easy-to-understand control system
- ▶ Precisely ground carbide saw blade guides (adjustable) for the highest demands on cutting accuracy
- ▶ Synchronous powered chip removal brush
- ▶ Semi-automatic sawing cycle: fully hydraulic
- ▶ Hydraulic cutting feed incl. automatic cutting pressure regulation
- ▶ Mitre settings and clamping (manual)
- ▶ Hydraulic full-lift cylinder for the vice (Pull-down design) floating vice
- ▶ Blade tension and saw blade break monitoring system
- ▶ Easily removable chip collection containers
- ▶ Hydraulic Blade tension display
- ▶ Integrated coolant supply (30 l tank capacity)
- ▶ LED work light
- ▶ Digital mitre display
- ▶ Incl. saw blade combination toothing 3/4
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Laser line for cutting
Order no. 570.109
- ▶ Clamping pressure regulation for vice
Order no. 570.076
- ▶ Hydraulic bundle tensioning device
Order no. 570.066

Accessories




- ▶ Material stop 500 mm (measuring scale)
Order no. 570.269
- ▶ Connecting track (steel coil), left, 640 mm wide (incl. fastening set)
Order no. 570.067
- ▶ Connecting track (steel coil), right, 640 mm wide (incl. fastening set)
Order no. 570.068
- ▶ Roller conveyor T-SR (steel coil), 640 mm wide, basic version 2,000 mm, 600 kg/m
Order no. 570.069
- ▶ Roller conveyor T-SR (steel coil), 640 mm wide, basic version 3,000 mm, 600 kg/m
Order no. 570.070
- ▶ Extension roller conveyor T-SR (steel coil), 2,000 mm, 600 kg/m
Order no. 570.071

Technical data

HBS 450 HA

Three-phase current motor 400 V, frequency-regulated (kW)	3
Saw blade dimensions (mm)	5,200 x 34 x 1.1
Flywheels Ø (mm)	480
Cutting speed (m/min)	20-120
Vice span, full-lift cylinder (mm)	610
Working height (mm)	781
Machine dimensions (mm)	2,780 x 1,440 x 1,560
Weight (kg)	800
Order no.	570.525
Additional accessories	from page 122

Sawing area

	0°	45° R	45° L	60° R	60° L
	450	450	450	300	300
	610 x 450	450 x 250	450 x 400	300 x 290	300 x 290
	450 x 450	370 x 370	450 x 450	300 x 300	300 x 300

HSS Bi-Metal (M42) Band saw blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.220	5,200 x 34 x 1.1	2/3	1
570.221	5,200 x 34 x 1.1	3/4	1
570.222	5,200 x 34 x 1.1	4/6	1
570.223	5,200 x 34 x 1.1	5/8	1

¹ Other bandsaw blades on request

- ▶ Extension roller conveyor T-SR (steel roller), 3,000 mm, 600 kg/m
Order no. 570.080
- ▶ Adjustable vertical rollers
Order no. 570.083
- ▶ Fixed vertical rollers
Order no. 570.084
- ▶ Starter band saw blade package 5,200 x 34 x 1.1 mm each consisting of 1 pc. combi-toothing 2/3, 3/4, 4/6, 5/8
Order no. 570.236
- ▶ Manual measuring stop 2 m with digital
Order no. 570.127
- ▶ Manual measuring stop 3 m with measuring tape
Order no. 570.123
- ▶ Manual measuring stop 2 m with measuring tape
Order no. 570.122
- ▶ Manual measuring stop 3 m with digital
Order no. 570.128

FLOTT
Metal band saw
HBS 450 SANC



Standard equipment

- ▶ Fully automatic 2-column horizontal high-performance automatic band saw – perfect for industrial use
- ▶ The saw frame is guided by two robust columns and is unilaterally backlash free in a pretensioned linear guide
- ▶ Saw frame lift height limiter via limit switch
- ▶ Hydraulic Cutting feed on the saw arm (incl. double-side cutting pressure regulation)
- ▶ 3-side precision HM saw blade guiding for optimum cutting results
- ▶ Synchronous powered chip removal brush
- ▶ Blade tension and saw blade break monitoring system
- ▶ Fully hydraulic sawing process:
 - Material feed (linear bearings)
 - Feed length (single stroke) 600 mm
 - Feed via hydraulic cylinder
- ▶ Max. stroke repetition: 999
- ▶ Smallest diameter for sawing: 10 mm
- ▶ Rest length: 25 mm
- ▶ The smallest cut piece (L x H): 10 x 5 mm
- ▶ Simple and clear programming with display (steps) on the control panel display
- ▶ Hydraulic full-lift cylinder for the vice
- ▶ Double-pump hydraulic unit
- ▶ Hydraulic Bundle tensioning device
- ▶ Clamping pressure regulation for vice
- ▶ LED work light
- ▶ Scraper floor-chip conveyor directly under the cutting channel
- ▶ Integrated coolant supply (45 l tank capacity)
- ▶ Incl. saw blade combination toothing 3/4
- ▶ Machine colour:
 - Saw frame RAL 7035 /- Machine body RAL 7005
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Saw feed speed display
Order no. 570.063
- ▶ Micro spraying system 24 V
Order no. 570.254
- ▶ Additional (3) coolant supply units
Order no. 570.173
- ▶ Chip rinsing pistol
Order no. 570.110

Accessories




- ▶ Connecting part X-SR, left (incl. fastening set)
Order no. 570.136
- ▶ Roller conveyor X-SR (steel coil x 4 pieces), 550 mm wide, basic version 2,000 mm, 1,500 kg/m

Technical data

HBS 450 SANC

Three-phase current motor 400 V, frequency-regulated (kW)	4
Saw blade dimensions (mm)	6,020 x 41 x 1.3
Flywheels Ø (mm)	550
Cutting speed (m/min)	20-120
Vice span (mm)	520
Working height (mm)	780
Machine dimensions (mm)	2,890 x 2,055 x 2,030
Weight (kg)	1,600
Order no.	570.035
Additional accessories	from page 122

Sawing area

	0°
	450
	520 x 450
	450 x 450

HSS Bi-Metal (M42) Band saw blades ¹

Order no.	Dimensions in mm	Combination toothing	VPE set = 2 pcs.
570.227	6,020 x 41 x 1.3	2/3	1
570.228	6,020 x 41 x 1.3	3/4	1
570.229	6,020 x 41 x 1.3	4/6	1
570.230	6,020 x 41 x 1.3	5/8	1

¹ Other bandsaw blades on request

Order no. 570.139

- ▶ Roller conveyor X-SR (steel coil x 6 pieces), 550 mm wide, basic version 3,000 mm, 1,500 kg/m
Order no. 570.141
- ▶ Extension roller conveyor X-SR (steel coil x 4 pieces), 2,000 mm, 1,500 kg/m
Order no. 570.143
- ▶ Extension roller conveyor X-SR (steel coil x 6 pieces), 3,000 mm, 1,500 kg/m
Order no. 570.145
- ▶ Starter band saw blade package 6,020 x 41 x 1.3 mm each consisting of 1 pc. combi-toothings 2/3, 3/4, 4/6, 5/8
Order no. 570.237
- ▶ further measuring stops on request

FLOTT

Vertical band saw

VBS 400 Plus



Minimum quantity
lubrication
Order no. 410.031



Longitudinal stop
Order no. 410.030



Standard height-adjust-
able guide arm

Standard equipment

- ▶ Manual vertical band saw with a cutting width of 400 mm
- ▶ Elegant and rigid welded construction
- ▶ Precise drive powered by a frequency converter
- ▶ Digital speed display
- ▶ Stepless band speed
- ▶ Balanced discs
- ▶ Running surfaces coated with hard rubber
- ▶ Hardened and ground guiding jaws
- ▶ LED workspace light
- ▶ Height-adjustable guide arm
- ▶ Machine colour RAL 7005 / RAL 7035
- ▶ 12-month warranty for single-shift operation

Special equipment

- ▶ Table manually moveable via crank
Order no. 410.032
- ▶ Saw blade welding device
Order no. 410.033
- ▶ Tilting table, 15° to the left, right, front and back
Order no. 410.034
- ▶ Longitudinal stop für 90° cuts
Order no. 410.030
- ▶ Minimal lubrication
Order no. 410.031

Accessories

- ▶ Band saw blade: 3,600 x 13 x 0.9 mm, 5 pieces, Tothing 14 teeth
Order no. 410.040
- ▶ Band saw blade: 3,600 x 13 x 0.9 mm, 5 pieces, Tothing 10/14 teeth
Order no. 410.041
- ▶ Band saw blade: 3,600 x 13 x 0.9 mm, 5 pieces, Tothing 6 teeth
Order no. 410.042
- ▶ Starter band saw blade package: 3,600 x 13 x 0.9 mm each consisting of 1 pc. combi tothing 14, 10/14, 6
Order no. 410.050
- ▶ Further band saw blades on request

Technical data

VBS 400 Plus

Table model	Fixed
Table dimensions (mm)	600 x 600
Cutting width (mm)	400
Cutting height (mm)	390
Cutting speed (m/min)	50-1,000
Saw blade dimensions (mm)	3,600 x 13 x 0.9
Drive type	Three-phase current motor, electronically regulated
Connected value (kW/A)	4.0/7.5
Machine dimensions (mm)	2,225 x 1,120 x 770
Weight (kg)	465
Order no.	410.010
With minimum quantity lubrication and longitudinal stop	
Order no.	410.020
Additional accessories	from page 122

FLOTT
Metal circular saw
KS 315 M



Standard equipment

- ▶ With swivelling head (left/right) for mitre cuts
- ▶ Two speeds
- ▶ Stable cast machine housing construction
- ▶ Reduction gear in oil bath consisting of bronze wheel and hardened, ground steel worm wheel
- ▶ Quick-change vice with counter-tension device for double work piece tensioning
- ▶ Long life mechanical coolant pump
- ▶ Adjustable length stop
- ▶ Operating tool
- ▶ Machine colour: RAL 7037
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Steel underframe (with VP - 250 x 720 x 840 mm)
Order no. 560.830

Technical data

KS 315 M

Three-phase current motor 400 V, pole-changeable (kW)	1.3/1.9
Vice span (mm)	110
Cooling tank capacity (l)	5
Work height with underframe (mm)	980
2 speeds (rpm)	41/82
Machine dimension with underframe without VP (mm)	1,000 x 1,100 x 1,800
Machine dimensions with underframe with VP (mm)	630 x 1,030 x 880
Not included in scope of delivery	
Saw blade (mm)	Ø 315 x 32
Order no.	560.835

Sawing area

	45° L	0°	45° R
	90	95	90
	80 x 70	100 x 70	80 x 70
	75	80	75

Metal circular saw blades ¹

Order no.	Dimensions in mm	Number of teeth	VPE
560.316	315 x 2.5 x 32	240	1
560.311	315 x 2.5 x 32	160	1

¹ different saw blades on request

FLOTT

Metal band saw

PBS 120 Plus



3D object – Separation from
the base plate – Detail
(optional)



3D object – Separation from
the base plate
(optional)

Standard equipment

- ▶ Portable manual metal band saw with two band speeds for mitre cuts from 0° to 60°
- ▶ Manual arm feed to the cut
- ▶ Two band speeds
- ▶ Saw blade guide made from carbide
- ▶ Cast iron vice with quick-release lever
- ▶ Option to connect a longitudinal stop
- ▶ Saw blade cooling at the point of machining
- ▶ incl. saw blade combi tothing 8/12
- ▶ 12-month warranty for single-shift operation

Accessories

- ▶ Underframe
can only be ordered together with coolant tray
Order no. 570.508
- ▶ Coolant tray
(can only be ordered together with underframe)
Order no. 570.509
- ▶ Material stop 300 mm
Order no. 570.510
- ▶ Connecting track, left
Order no. 570.511
- ▶ Connecting track, right
Order no. 570.512
- ▶ Roller conveyor, 2 m (150 kg/m)
Order no. 570.507
- ▶ Starter band saw blade package 1,620 x 13 x 0.65 mm each consisting of 1 pc. combi-tothing 6/10, 8/12, 10/14
Order no. 570.519

Technical data

PBS 120 Plus

Belt speed (m/min)	35/75
Band saw blade size (mm)	1,620 x 13 x 0.65
Motor 230V (kW)	0.25 / 0.37
Machine dimensions (mm)	810 x 530 x 450
Weight (kg)	38
Order no.	570.505

Sawing area

	0 °	45°R	60°R
	120	90	55
	60 x 70	100 x 90	55 x 65
	120 x 120	90 x 90	55 x 55

Metal band saw blades ¹

Order no.	Dimensions in mm	Teeth per inch	VPE set = 5 pcs.
570.514	1,620 x 13 x 0.65	6/10	1
570.515	1,620 x 13 x 0.65	8/12	1
570.516	1,620 x 13 x 0.65	10/14	1

¹ Other bandsaw blades on request

Accessories

Roller conveyor system L-SR/K330

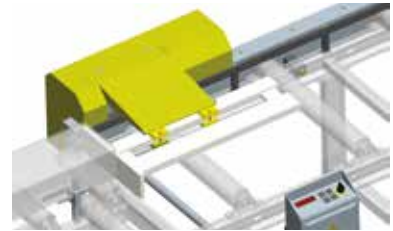
Highly flexible solution for handling tasks with medium-weight materials. Thanks to the unique profile system, the roller conveyors can be adapted to customer requirements very easily.



on request

Digital measuring stop

Digital material stop with handwheel and pneumatic brake



on request

Stop systems

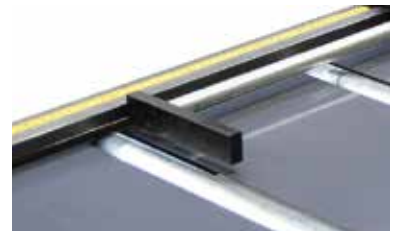
Stop systems - from simple, convenient manual length measuring units to NC controlled modern measuring devices, incl. programme memory.



on request

Manual measuring stop

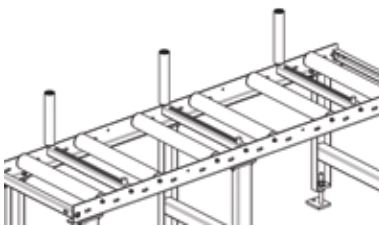
The support surface of the stop enables stable fixation of the material before cutting the desired length.



on request

Roll-off safety system

The roll-off safety system serves to prevent the pipes from rolling off in an uncontrolled manner and the associated danger that this creates for the operating personnel and persons in close proximity.



on request

Hydraulic bundle tensioning

The hydraulic bundle tensioning device enables the tensioning of layers and bundles with an additional hydraulic vertical tensioning unit.



on request

Digital measuring stop - display

The stop carriage is adjusted manually and the position is shown on the digital display with an accuracy of 0.1 mm. The stop arm can be folded upwards for the material to pass through.



on request

Controlled material feed



on request

Vertical rollers

In the ideal arrangement, the vertical rollers ensure precise perpendicular alignment, easier operations and safety for operators and people near the equipment.



on request

Adjustable vertical rollers

Adjustable vertical rollers are essential for cutting layers/bundles. The cut pieces are secured and their shape is maintained when combined with fixed built-in vertical rollers.



on request

Plastic rollers series L-K

The rollers used are stable, solid tubes made of high-quality plastic. Thanks to their properties, the supplied material is protected from damage.



on request

Connecting parts

Each band saw has an adapted connecting part, including the fasteners.



on request

Security systems for individual solutions on request!



Information contents

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Werkzeugmaschinen

INFORMATION



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FLOTT drilling technology safety

Efficient LED illumination

- ▶ The positioning of the power LEDs in the front area of the machine illuminates the drill hole. The work piece does not create any disruptive shadows. Direct glare is prevented by the positioning of the LEDs.



Standard electrical drilling protection

- ▶ In accordance with the European Machine Directive No. 2006/42/EC, all drilling machines are fitted with drilling protection with an electrical fuse.



Standard electrical drilling protection

Safe drilling

- ▶ Standard EMERGENCY OFF switch and spindle stop function (spindle stops when it reaches the starting position)

Vice [felix] 2.0

- ▶ Patented single clamping via hexagon head screw
- ▶ Anti-twist protection through internal hexagon head screw

FLOTT [felix] 2.0



Double grinding machine with optional brake and extraction system

- ▶ Optionally with emergency stop push-button and foot emergency stop
- ▶ The grinding wheels come to a standstill within just a few seconds



Double grinding machine



Belt grinder

Belt grinder with brake and easy belt change, as well as optional extraction system

- ▶ The grinding wheel comes to a standstill within just a few seconds
- ▶ The grinding wheel can be changed without any tools



see. understand. learn.



FLOTT AKADEMIE

The FLOTT ACADEMY with Felix Röwekämper. He will show you how it's done.

Learn the basics of drilling technology.

Here you will find more videos on drilling, sawing and grinding.

www.flott.de



YouTube

FLOTT service

Our FLOTT team will be happy to serve!

FLOTT technical service

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The direct link
to your
service partner



FLOTT spare parts service

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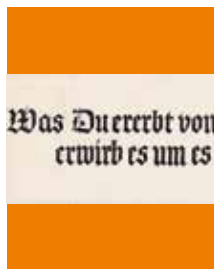
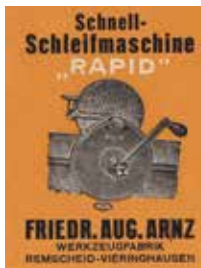
Note:

For the quickest possible processing of your spare parts request, please keep the **machine number** and the **machine type** ready!



Extract from our Terms of Sale

- ▶ Delivery ex works, excluding packaging.
Shipping location: 42857 Remscheid
 - ▶ Extra charges incurred for "seaworthy" packaging.
 - ▶ Standard colour (one-component paint)
 - Series TB 10 Eco Plus to 20 Plus (hood 7005 and base black RAL 9005)
 - series from 23 Plus completely in RAL 7005
 - grinding machines RAL 9007
 - saws: saw frame RAL 7035, machine body RAL 7005
 - ▶ Construction particulars and dimensions are subject to change without notice even during the term of an order.
 - ▶ Non-binding price recommendation in EUR
- plus statutory VAT.
 - ▶ Machine prices excluding packaging.
Flat rates for packaging in accordance with the price list
 - ▶ Accessories and replacement parts excluding packaging.
 - ▶ Warranty:
36 months for drilling machines, except:
GB 50 MV, here 12 months for single-shift operation
12 months for grinding machines and saws
for single-shift operation from delivery, except
wearing parts, 6 months on spare parts
 - ▶ Complete GTC at www.flott.de



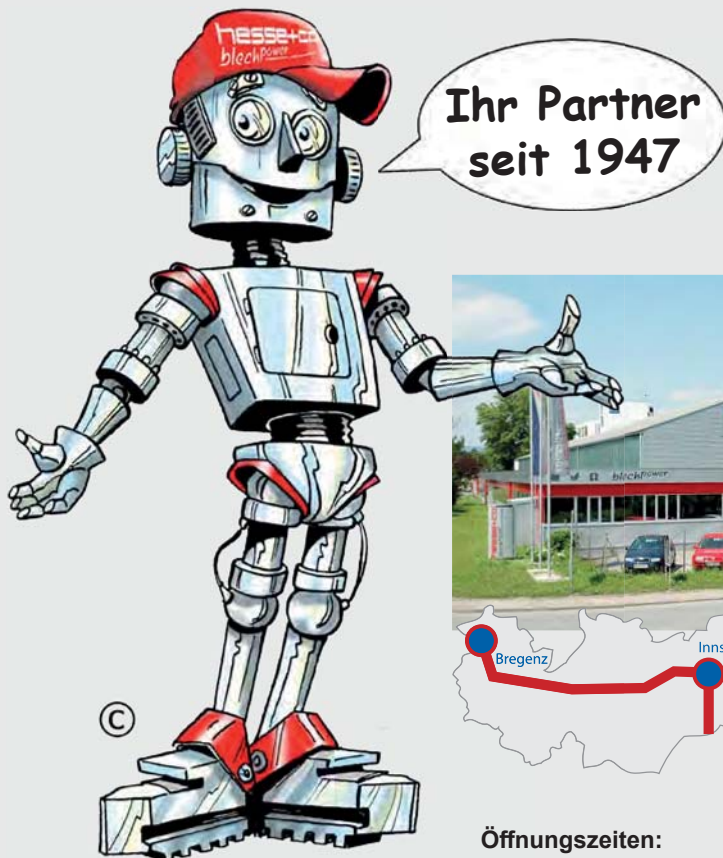
Vertrauen Sie auf über 70 Jahre Erfahrung!

Die Firma HESSE+CO wurde 1947 als Hersteller von Blechbearbeitungsmaschinen gegründet. Seit 1980 sind wir auf den Handel mit neuen sowie gebrauchten Blechbearbeitungs- und Werkzeugmaschinen spezialisiert. Wir haben ständig etwa 300 Maschinen in unserer 2.000 m² großen Ausstellungshalle, die nur 20 Minuten vom internationalen Flughafen Wien entfernt ist.

Trust in more than 70 years of experience!

HESSE+CO was established in 1947 as a manufacturer of sheet metal working machines. Since 1980 we are specialized in dealing with new and second hand sheet metal processing machines and machine tools. We always have approximately 300 machines available in our 2.000 m² showroom, which is located only 20 minutes from the Vienna International Airport, waiting for your inspection.

www.hesse-maschinen.com



Öffnungszeiten:

Mo - Do 8:00 - 16:30 Uhr
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Industriezentrum NÖ-Süd
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A-2351 Wiener Neudorf
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