







## Bevelling made easy

BDS offers a range of professional machines for easy and perfect processing of milling edges: For the preparation of welding seams with the fully automatic AutoCUT 500 or the manually guided SKF 25. The machines of the EKF series are ideally suited for deburring and making visible edges and chamfers, also on internal and external radii.

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# SKF 25 – good preparation is everything

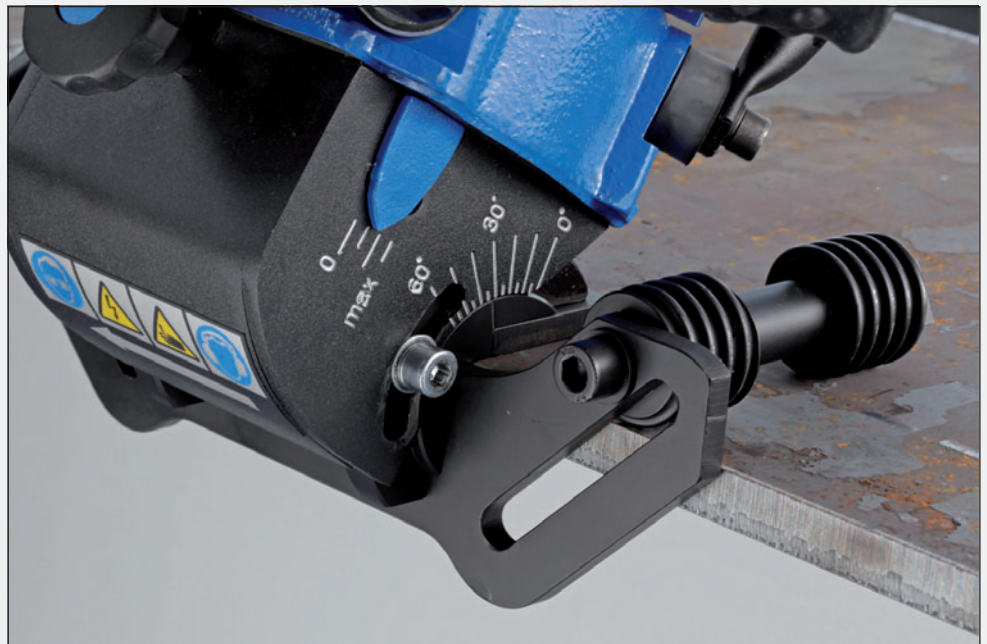
Good work preparation, good results. This universal bevel edge milling machine with integrated tube enables perfect weld preparation.

**SKF 25 - This new hand-guided BDS machine is ideally suited for easy and quick preparation of welded seams.** On account of its low weight of 22 Kg, it is easy to handle and can be guided exactly and easily with smooth-running rollers. The end result is uniformly milled edges for perfect welded seams.

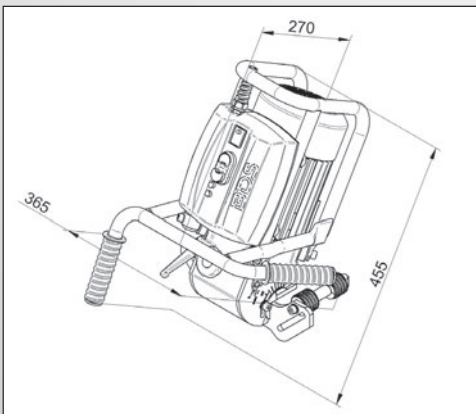
The SKF 25 of BDS is suitable for machining

- ▶ normal steel
- ▶ stainless steel
- ▶ aluminium
- ▶ non-ferrous metals

The chamfer angle can be adjusted continuously from 15° to 60° with a maximum chamfer width of 15 mm.



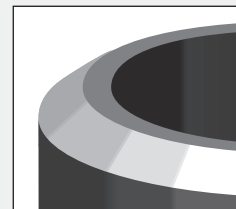
Large guide rollers and a continuous angle adjustment from 15 to 60° render the system practical.



Technical drawing



Edge processing of pipes in a vertical position.



Milling edge









## The advantages of the SKF 25

- > Wide chamfers – up to 15 mm
- > Continuous angle adjustment – from 15 to 60°
- > Handy – with ergonomic handle arrangement
- > Easily guided – with guide rollers



### SPECIFICATION

	Motor output:	1.1 kW
	Voltage:	220-240 V AC, 50-60 Hz
	Feed:	manual
	Speed range 1:	2850 min <sup>-1</sup>
	Chamfer width:	15 mm
	Angle adjustment:	15 – 60° continuously
	Safety:	automatic overload cutout / restart lockout
	Weight:	22 kg
	Tools:	Arbor milling cutter, double-row, with 10 sintered carbide reversible disks

### ACCESSORIES

#### ORDER NO.

#### Arbor milling cutter

ZFR 250 1 pc.

Carbide reversible disks are not included in delivery. Please clearly order them as an extra.

#### Carbide reversible disks

SHM 800 1 pc.

SHM 400-E 1 pc.

1 set = 10 carbide reversible disks



Arbor milling cutter ZFR 250



Carbide reversible disk



Angle adjustment 15 - 60°

### ORDER NO.

SKF 25 / 230 Volt

SKF 25 / 110 Volt

### SCOPE OF DELIVERY

1 Bevel edge milling machine

1 Carry case

1 Arbor milling cutter ZFR 250 with  
10 carbide reversible disks

SHM 800

1 Offset screwdriver SW 8

1 Operating manual

1 Screwdriver TX 15

# AutoCUT 500

Automatic edge processing for weld preparation – simple and secure handling with guide rails on both sides.

**AutoCUT 500** – This BDS machine is perfectly suited for straightforward and quick weld preparation. The system is characterised by easy handling and evenly milled sides for a perfect weld.

Bevel edge milling with automated and continually adjustable speed rate: fast, flexible and variable milling angle adjustment.

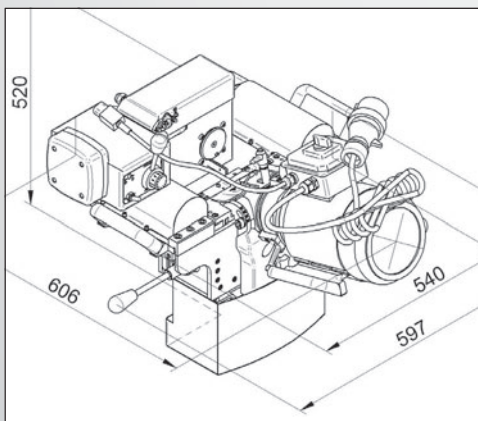
The guide rails make handling the AutoCUT 500 especially simple and secure. The milling angle can be continuously adjusted from 15 to 60°.

Advantages of the BDS AutoCUT 500

- ▶ Easy, safe handling
- ▶ No restrictions of the working length
- ▶ Work without carriage, i.e., independent of floor conditions
- ▶ Cutting up to a plate thickness of 40 mm
- ▶ Face milling head with carbide reversible plates



The AutoCUT 500 with automatic forward and return



Technical drawing



AutoCUT 500 guide rails



Chamfer width 30 mm max.



Visit our homepage to experience  
live the AutoCUT demo video.  
[http://www.kernbohrer.de/downloads  
/downloads.html#tab\\_4](http://www.kernbohrer.de/downloads/downloads.html#tab_4)



## The advantages of AutoCUT 500

- > Fully automatic – forward and return motion via guide rollers
- > Powerful – Milling up to a plate thickness of 40 mm, unlimited working length
- > Guided on the plate, independent of floor conditions

### SPECIFICATION

	Motor output:	1.1 kW
	Voltage:	380 V
	Weight:	50 kg
	Feed:	Automatic, continuously adjustable up to a maximum of 500 mm/min
	Speed range 1:	2750 min <sup>-1</sup>
	Chamfer width:	max. 30 mm
	Angle adjustment:	15 – 60° continuously
	Milling cutter:	Arbor milling cutter with 6 sintered carbide reversible disks

### ACCESSORIES

#### ORDER NO.

#### Arbor milling cutter

ZFR 500 1 pc.

Carbide reversible disks are not included in delivery. Please clearly order them as an extra.

#### Carbide reversible disks

SHM 400 1 pc.

SHM 400-E 1 pc.

1 set = 6 carbide reversible disks SHM 400



Arbor milling cutter ZFR 500



Carbide reversible disk SHM 400

### ORDER NO.

AutoCUT 500 / 380 Volt

### SCOPE OF DELIVERY

1 AutoCUT 500	1 Jaw spanner M 19
1 Arbor milling cutter with 6 carbide reversible disks SHM 400	1 Screwdriver with T-handle SW 5
1 Operating manual	1 Offset screwdriver SW 6, SW 8, SW 10 each
1 Guide rail on both left and right side	1 Screwdriver TX 15



# EKF 300.3 – EKF 450.3 – EKF 452.3

Deburring and chamfering machines for quick and precise edge processing 20°, 45° or R 2.5 mm.

**Deburring and chamfering with machines from the EKF series.** The BDS deburring and chamfering machine can be universally used for industry and craft: In mould making, boiler construction, plant construction, mechanical engineering and for sheet metal working.

The EKF machine is ideally suited for deburring and chamfering of parts made of steel, stainless steel, non-ferrous metals, brass and plastic. Due to its handy, compact design, the machine can be used on straight edges, internal and external radii and for drill holes from  $\varnothing$  22 mm. The fine adjustment allows slight chamfers for deburring up to the preparation of welding seams.

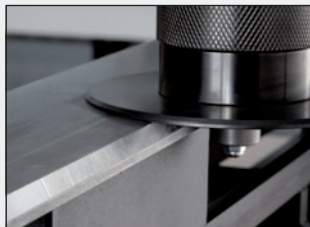
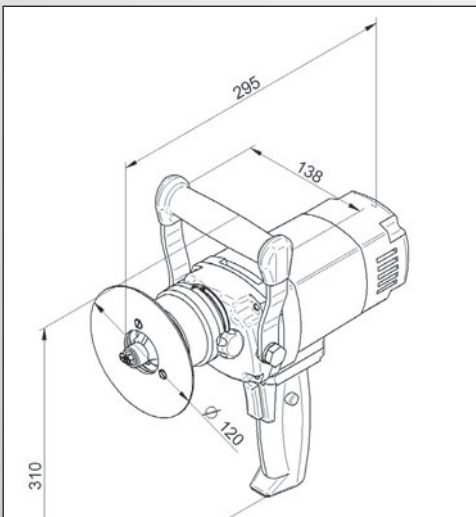


Three milling cutters with a chamfering angle of 45°, optionally 30° or a radius of 2.5 mm are available.

The reversible disks can be used in 3 ways. Due to the small guiding roller, insertion into drill holes from  $\varnothing$  22 mm is possible without any problems.



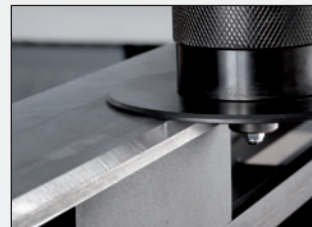
Edge processing with the EKF - the workpiece is securely fixed with the MagnetCLAMP magnetic clamping device. See page 79.



Cutting angle  
30°



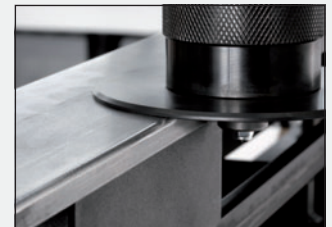
EKF 300.3 with milling cutter ZFR



Cutting angle  
45°



EKF 450.3 with milling cutter ZFR 450.3



Radius  
R 2.5 mm



EKF 452.3 with milling cutter ZFR 452.3









Visit our homepage to experience live the EKF demo video.  
[http://www.kernbohrer.de/downloads/downloads.html#tab\\_4](http://www.kernbohrer.de/downloads/downloads.html#tab_4)

## The advantages of the EKF

- > Straightforward – easy handling, low weight
- > Variable – 3 milling cutters optionally 45°, 30°, or R 2.5 mm
- > Powerful – 1.5 kW motor



### SPECIFICATION

	Motor output:	1500 Watt
	Voltage:	220 - 240 V AC, 50-60 Hz
	Speed range 1:	6000 min <sup>-1</sup>
	Feed:	manual
	Milling cutter optional:	Fase 45° – width continuously 0 - 6 mm Fase 30° – width continuously 0 - 5 mm Radius R 2.5 mm
	Carbide reversible disks:	3 per milling cutter
	Weight:	4.6 kg

### ACCESSORIES

#### ORDER NO.

#### Milling cutter

ZFR 300.3 – 30°

ZFR 450.3 – 45°

ZFR 452.3 – R 2.5

Carbide reversible disks are not included in delivery. Please clearly order them as an extra.

#### Carbide reversible disks

SHM 200 1 pc.

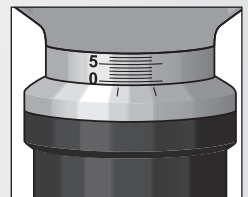
SHM 200-E 1 pc.

SHM 202 1 pc.

1 set = 3 carbide reversible disks SHM



Changeable carbide reversible



Fine adjustment

### ORDER NO.

EKF 300.3 / 230 Volt

EKF 300.3 / 110 Volt

EKF 450.3 / 230 Volt

EKF 450.3 / 110 Volt

EKF 452.3 / 230 Volt

EKF 452.3 / 110 Volt

### SCOPE OF DELIVERY

1 Deburring and chamfering machine

1 Milling cutter

3 Carbide reversible disks

1 Jaw spanner SW 22

1 Carry case

1 Sickle spanner

1 Torx screwdriver T9

1 Operating manual