

AIR HYDRAULIC DRILLING UNIT

BAHCO
DORTMUND



**AIR HYDRAULIC PRECISION
DRILLING UNIT BE(F)P 22**

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The basic design of the BE(F)P22 consists of a vane motor powered by compressed air, a pneumatic cylinder, and a closed hydraulic system. The BE(F)P 22 has a precision chuck with cone B10 for an extra high level of precision. Thanks to precision, separate and double ball bearing run-out amounts to a maximum of 0,01 mm. The total stroke length can be variably subdivided into rapid advance and working feed across the whole range. The throttle/check valve in the hydraulic system permits exact setting of the feed rate and high speed return.

- Precision design with a max. run-out at spindle nose of 0.01 mm
- Extremely compact design
- Built-in hydraulics for controlled working feed
- Adjustment of drilling depth with positive stop guarantees a high degree of accuracy
- Low noise level
- Minimal air consumption

Guidelines for choice of unit

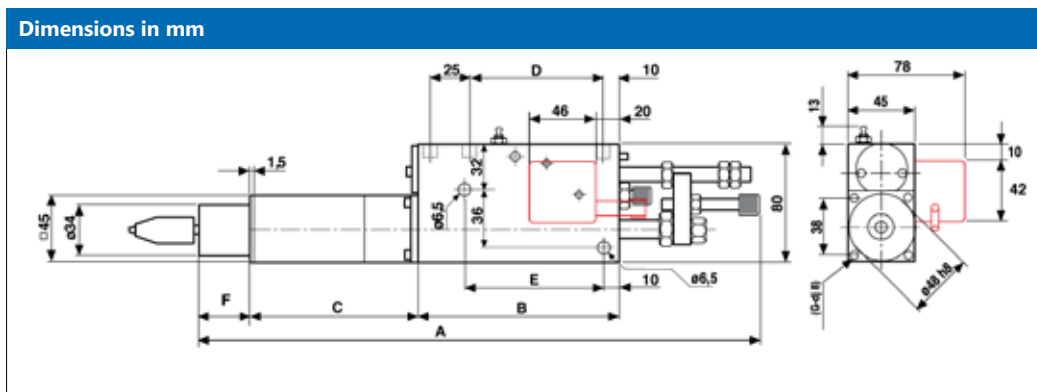
Drilling unit	Ø in Steel / mm			Ø in Aluminium & Brass / mm			Ø in Wood / Plastics / mm		
BE(F)P2222	5			9			12		
BE(F)P2236	4			7			10		
BE(F)P2249	3			6			8		
BE(F)P22150	2			3			4		
BEP22220	2			3			4		

Performance specifications at 6.3 bar

Thrust (max.)	600 N	Min. CC spindle spacing	45 mm	Air consumption	<0.3 m ³ /min.
Power	0.25 kW	Run-out at spindle nose (max.)	0.01 mm	Sound level	70 dB(A)
Stroke (max.)		Depth accuracy ±	0.01 mm		
BEP 100% (controlled)	30 mm	Rapid advance rate	10 m/min.		
BEFP total	60 mm	controlled feed rate	>0.01 m/min		
of which is controlled	45 mm	Working pressure range	6-7 bar		


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Drilling unit	Speed [idle] rpm	Speed rpm (at max. output)	Torque Nm (at max. output)
BEP2222	2200	1100	2.4
BEFP2222	2200	1100	2.4
BEP2236	3600	1800	1.5
BEFP2236	3600	1800	1.5
BEP2249	4900	2450	1.1
BEFP2249	4900	2450	1.1
BEP22150	15000	7500	0.25
BEFP22150	15000	7500	0.25
BEP22220	22000	11000	0.25




Drilling unit	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	Weight (kgs)
BEP2222	380	140	116	94.5	107	32	4.7
BEFP2222	485	200	146	154.5	167	2	6.7
BEP2236	380	140	116	94.5	107	32	4.7
BEFP2236	485	200	146	154.5	167	2	6.7
BEP2249	380	140	116	94.5	107	32	4.7
BEFP2249	485	200	146	154.5	167	2	6.7
BEP22150	380	140	116	94.5	107	32	4.7
BEFP22150	485	200	146	154.5	167	2	6.7
BEP22220	380	140	116	94.5	107	32	4.7

Necessary components

Chucks	Type
	Precision chucks Ø 0–3.0 mm Ø 0–5.0 mm (Standard chuck) Ø 0–8.0 mm

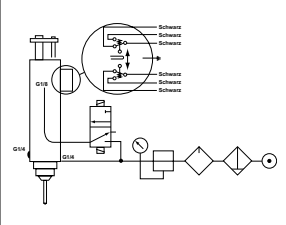
Collets	Type
	Precision collet chuck ER 11 Ø 0.5–7.0 mm

Collets	Type
	ER 11 Ø 0.5–7.0 mm

Limit switches

	Electric or Pneumatic
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Accessories

Controls
 <p>Connection example for BE22/33-units with: Elektric Pneumatic limit switches</p>

Mountings

	Mountings for BE(F)P22
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When requesting a quote or ordering please state: Model, Chuck (collet size), limit switches and if to be used in Lubrication-free operation.

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All information subject to change without further notice.
No responsibility is taken for the correctness of the named specifications.