

AIR HYDRAULIC DRILLING UNIT

BAHCO
DORTMUND



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

BAHCO

The basic design of the BE(F)22 consists of a vane motor powered by compressed air, a pneumatic cylinder, and a closed hydraulic system. 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 rate and high speed return.

- 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			
	1	2	3	4	1	2	3	4	1	2	3	4
No. of spindles	1	2	3	4	1	2	3	4	1	2	3	4
BE(F)225	6	5	2,5	1,5	11	8	6	4	16	11	9	7
BE(F)228	6	5	2,5	1,5	11	8	6	4	16	11	9	7
BE(F)2211	6	4	2,5	1,5	10	8	6	4	14	11	9	7
BE(F)2222	5	3	2	1,5	9	7	5	4	12	9	8	6
BE(F)2236	4	2,5	1,5	1	7	6	4	3	10	8	7	5
BE(F)2249	3	1,5	1,5	1	6	4	3	2,5	8	6	6	4
BE(F)22150	2				3				4			
BE22220	2				3				4			

Technical data at 6,3 bar

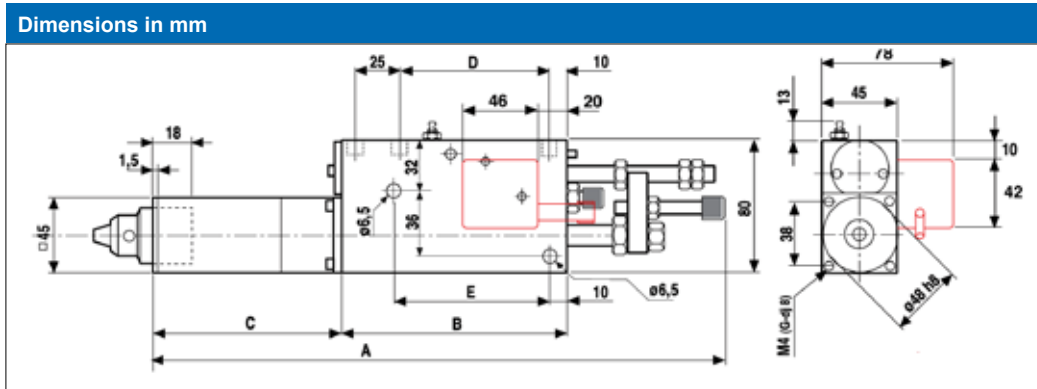
Thrust (max.)	600 N	Min. center to center spacing		contr. feed rate	>0,01 m/min
Power	0,25 kW	single spindle	45 mm	Work. press. range	6 - 7 bar
Stroke (max.)		Double-spindle head	11 mm	Air consumption	<0,3 m ³ /Min.
BE 100% (controlled)	30 mm	Run-out at spindle nose (max.)	0,03 mm	Sound level	70 dB(A)
BEF total	60 mm	Depth accuracy ±	0,01 mm		
of which is controlled	45 mm	Rapid advance rate	10 m/min.		

Drilling unit	Speed (idle) rpm	Speed (rpm) (at max. output)	Drehmoment Nm (at max. output)
BE(F)225	500	250	9,9
BE(F)228	800	400	6,0
BE(F)2211	1100	550	4,3
BE(F)2222	2200	1100	2,4
BE(F)2236	3600	1800	1,5
BE(F)2249	4900	2450	1,1
BE(F)22150	15000	7500	0,25
BE22220	22000	11000	0,25

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Drilling unit	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	Weight (kg)
BE225	384	140	147	94.5	107	5.1
BEF225	519	200	177	154.5	167	7.1
BE228	384	140	147	94.5	107	5.1
BEF228	519	200	177	154.5	167	7.1
BE2211	384	140	147	94.5	107	5.1
BEF2211	519	200	177	154.5	167	7.1
BE2222	353	140	116	94.5	107	4.7
BEF2222	488	200	146	154.5	167	6.7
BE2236	353	140	116	94.5	107	4.7
BEF2236	488	200	146	154.5	167	6.7
BE2249	353	140	116	94.5	107	4.7
BEF2249	488	200	146	154.5	167	6.7
BE22150	353	140	116	94.5	107	4.7
BEF22150	488	200	146	154.5	167	6.7
BE22220	353	140	116	94.5	107	4.7

Necessary components

Chucks	Type	Limit switch
	Key chucks Ø 0.5-6.5 mm (Standard) Ø 0.8-10.0 mm	 Electric or Pneumatic
	Collet chucks Ø 1.0-7.0 mm ER11 Ø 1.0-13.0 mm ER20 Ø 2.0-20.0 mm ER32	
Collets	Type	When requesting a quote or ordering please state: model, chuck (collet size), limit switches and if it is to be used in lubrication-free operation.
	ER11 Ø 1.0-7.0 mm ER20 Ø 1.0-13.0 mm ER32 Ø 2.0-20.0 mm	

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