

MAXION®

Jänsch & Ortlepp GmbH



*Drilling machines
Tapping machines
Drilling-Milling machines
Hand tools*

MAIN CATALOGUE

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since 1992



MAXION Jänsch & Ortlepp GmbH

is an owner managed company and located near the city of Jena in the east of Thuringia. 80 employees are producing high-quality products and are securing the continuous development of the company. MAXION is offering a wide-ranging product range with a high level of vertical integration. Main focus is placed on the manufacture of drilling and special purpose machines with drilling diameter up to 50 mm. The machines are distributed worldwide via a diversified dealer network. A quick-growing division is our commission processing sector with its specialization on deep-hole drilling. MAXION is highly specialized in this area, well-known mold-makers as well as the leading German automobile manufacturers are numbered among our key account. In addition we are manufacturing special purpose machines and devices for the furniture fitting industry as well as traditional hand tools like machine vices, drill stands for hand drills . Company MAXION is offering customer-oriented service, which includes among other things maintenance and repair for machines of the brands MAXION and IXION. Because of own apprenticeship training, targeted investments and realisation of own innovations MAXION is always up to date in modern technical developments and is securing our city of Pößneck as business location in the future.

We make sure, that you can trust in our products "Made in Germany".

Martin Ortlepp
Managing Director

Christoph Jänsch
Managing Director

- Up to 24,000 rpm
- Drilling 0.2 - 4 mm
- Smooth running
- Precise

Precision drilling machine with very high concentricity for drilling from 0.2 mm. The machine is optimally suited for precision mechanics and electronics assembly by means of stepless adjustable spindle rpm. Incl. LED-machine light and 1 pc. collet ER 11, diameter 1.0 (accuracy 5 µ)

Technical data SPEEDMAX	
Drilling capacity in E 335	0.2 - 4 mm
Spindle / Collet	ER 11
Spindle travel	60 mm
Spindle to column	215 mm
Spindle to table	60 - 345 mm
Table Surface	280 x 475 mm
T-slot width	14 mm
Column diameter	60 mm
Total height	780 mm
Weight approx.	65 kg
Pole changing motor	0.8 kW
Mains connection	230 V / 50 Hz
Stepless spindle rpm	700 - 24,000 rpm
Standard packaging	3 - parts

Options / Accessories

- Minimum quantity lubrication system



- collet chuck set ER 11 / 13 pcs. in the box
- Visualisation (camera and monitor)



further accessories from page 60



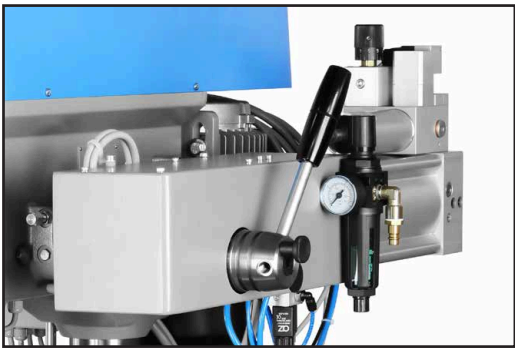
- *Precise*
- *High rpm*
- *Drilling 0.5 - 6 mm*

Precision drilling machine with very high concentricity, especially for electronic and precision engineering. Digital display showing spindle rpm, frequency-controlled motor, mains connection 230 V.

Technical Data BT 6 FREQUENZ	
Drilling capacity in E 335	0.5 - 6 mm
Spindle	B 12
Spindle travel	55 mm
Spindle to column	177 mm
Spindle to table	135 to 400 mm
Table surface	296 x 349 mm
T-slot width	12 mm
Column diameter	75 mm
Total height	810 mm
Weight approx.	98 kg
Frequency-controlled motor	0.55 kW
Mains Connection	230 V / 50 Hz
Stepless spindle rpm	1,000 - 9,000 rpm
Standard packaging	A 89x52x127 cm

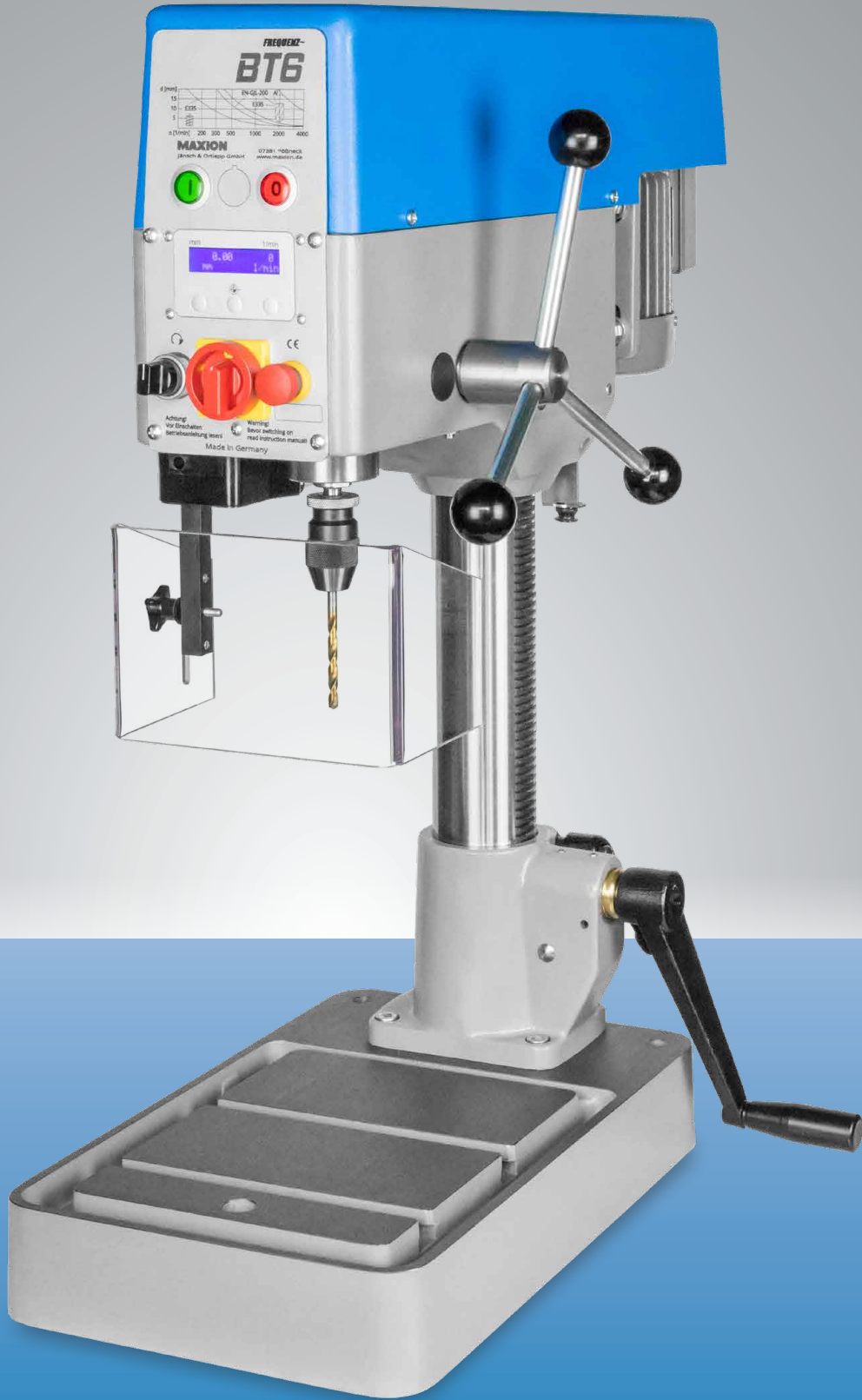
Options / Accessories

- Albrecht Super Drill chuck clamping range up to 6mm
- Spindle MT 1
- Digital display for drilling depth
- Drilling depth with fine adjustment
- PV feed unit



Floor unit

Dimensions 300 x 470 x 760 mm
Weight 40 kg



Picture including option digital display for drilling depth

- Solid and compact
- Perfect for education and hobby
- Stepless adjustment of spindle rpm

Precise and smooth running standard drilling machine in modern design. Digital display for rpm, adjustment of table via rack, emergency stop push button.

Technical data ECOMAX 14	
Constant capacity in E 335	14 mm
Standard capacity	15 mm
Spindle	MT 2
Spindle travel	70 mm
Spindle to column	180 mm
Spindle to table	up to 380 mm
Spindle to base	529 mm
Table surface	250 x 220 mm
T-slot width	10 mm
Column diameter	65 mm
Total height	890 mm
Weight approx.	80 kg
Pole changing motor	0.5 / 1.0 kW
Mains connection	400 V / 50 Hz
Stepless spindle rpm	420 - 2,100 rpm
Standard packaging	A 89x52x127 cm

Options / Accessories

• Drill package 14

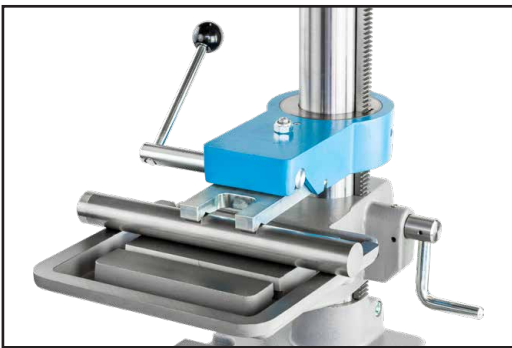
- 1 drill chuck taper. MT 2 / B16
- 1 reduction insert. MT 2 / MT 1
- 1 machine vice MSP 80
- 1 quick release chuck. 1 - 13 mm/B16



Picture similar

• MKF Quick clamping device

MKF 65 Z



• Electrical cooling unit

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve

• Floor unit

Dimensions 600 x 700 x 840 mm
Weight 60 kg



Options / Accessories

- Optimally suited for locations without three-phase current supply
- Big rpm range
- Programmable tapping depth (only TAP)
- Powerful



UNIMAX 1 FREQUENZ
Precise and smooth running standard drilling machine, high accuracy and quality. Reverse switch for tapping, table adjustment via rack and rotatable around column.

UNIMAX 1 TAP with integrated tapping unit and programmable digital display as standard. Three-phase motor, mains connection 230 V.

Technical data	UNIMAX 1 FREQUENZ	UNIMAX 1 TAP
Constant capacity in E 335	15 mm	15 mm
Standard capacity	18 mm	18 mm
Tapping capacity	M 8	M 8
Spindle	MT 2	MT 2
Spindle travel	80 mm	80 mm
Spindle to column	180 mm	180 mm
Spindle to table	up to 380 mm	up to 380 mm
Spindle to base	552 mm	552 mm
Table surface	250 x 220 mm	250 x 220 mm
T-slot width	10 mm	10 mm
Column diameter	65 mm	65 mm
Total height	910 mm	910 mm
Weight approx.	84 kg	84 kg
Frequency-controlled motor	1.1 kW	1.1 kW
Mains connection	230 V / 50 Hz	230 V / 50 Hz
Stepless spindle rpm	200 - 4,000 rpm	200 - 4,000 rpm
Rotation speeds for tapping		200 - 700 rpm
Standard packaging	A 89x52x127 cm	A 89x52x127 cm

• Drill package 1

- 1 drill chuck taper MT 2 / B16
- 1 reduction insert.....MT 2 / MT 1
- 1 machine vice MSP 80
- 1 quick-release chuck..... 1 - 13 mm / B16



• MKF Quick clamping device

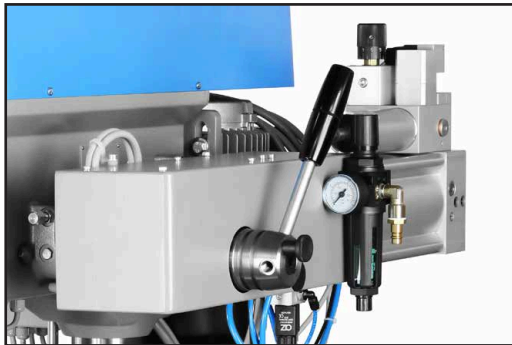
MKF 65Z

• Tapping chuck with quick-change insert and overload clutch



• PV feed unit

Drilling capacity.....12 mm



• Electrical cooling unit

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve

• Floor unit

Dimensions 660 x 380 x 225 mm
Weight 15 kg



UNIMAX 1 FREQUENZ

UNIMAX 1 TAP
Picture including option LED machine light

- **Powerful**
- **Optimally suited for locations without three-phase current supply**
- **Big rpm range**



Powerful and precise universal bench drilling machine with wide range of application. Table/ height adjustment via rack and pinion. Three-phase motor, reverse switch for tapping, digital display for rpm, adjustment of rpm via potentiometer. UNIMAX 2 T with height adjustment from front.

Technical data	UNIMAX 2 T	UNIMAX 2
Constant capacity in E 335	18 mm	18 mm
Standard capacity	20 mm	20 mm
Tapping capacity	M 12	M 12
Spindle	MT 2	MT 2
Spindle travel	100 mm	100 mm
Spindle to column	225 mm	225 mm
Spindle / Table	60 - 440 mm	55 - 880 mm
Table surface	345 x 372 mm	450 x 315 mm
T-slot width	14 mm	14 mm
Column diameter	90 mm	90 mm
Total height	max. 955 mm	max 1,745 mm
Weight approx.	150 kg	187 kg
Frequency-controlled motor	1.5 kW	1.5 kW
Mains connection	230 V / 50 Hz	230 V / 50 Hz
Stepless spindle rpm		
Range A	100 - 2,000 rpm	100 - 2,000 rpm
Range B	200 - 4,000 rpm	200 - 4,000 rpm
Standard packaging		
	B 110x85x130 cm	D 220x74x125 cm

Options / Accessories

• Drill package 2

- 1 drill chuck taper..... MT 2 / B16
- 1 reduction insert..... MT 2 / MT 1
- 1 machine vice MSP 120
- 1 quick-release chuck..... 1 - 16 mm / B16



Picture similar

• Cross table MF-3

- Table surface..... 600 x 240 mm
- X / Y traverse..... 350 / 160 mm
- Weight 74 kg

• Electrical cooling unit

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve



• Floor unit for UNIMAX 2 T

- Dimensions 345 x 602 x 730 mm
- Weight 45 kg



- **Powerful**
- **Programmable tapping depth**
- **Big rpm range**
- **Optimally suited for locations without three-phase current supply**



Very powerful, all-purpose drilling machine with wide range of application. Three-phase motor, integrated tapping unit as standard. LED machine light and programmable tapping depth. Rpm and drilling depth are shown in the display.

Technical data	UNIMAX 2 T TAP	UNIMAX 2 TAP
Constant capacity in E 335	18 mm	18 mm
Standard capacity	20 mm	20 mm
Tapping capacity	M 16 in S235	M 16 in S235
Spindle	MT 2	MT 2
Spindle travel	100 mm	100 mm
Spindle to column	225 mm	225 mm
Spindle / Table	60 - 440 mm	55 - 880 mm
Table surface	345 x 372 mm	450 x 315 mm
T-slot width	14 mm	14 mm
Column diameter	90 mm	90 mm
Total height	max. 955 mm	max 1,745 mm
Weight approx.	150 kg	187 kg
Frequency-controlled motor	1.5 kW	1.5 kW
Mains connection	230 V / 50 Hz	230 V / 50 Hz
LED machine light	included	included
Stepless spindle rpm		
Drilling Range A	100 - 2,000 rpm	100 - 2,000 rpm
Drilling Range B	200 - 4,000 rpm	200 - 4,000 rpm
Tapping Range A	100 - 500 rpm	100 - 500 rpm
Tapping Range B	200 - 1,000 rpm	200 - 1,000 rpm
Standard packaging		
	B 100x 85x130 cm	D 220x74x125 cm

Options / Accessories

- **Drill package 2**
1 drill chuck taper..... MT 2 / B16
1 reduction insert..... MT 2 / MT 1
1 machine vice MSP 120
1 quick-release chuck..... 1 - 16 mm / B16

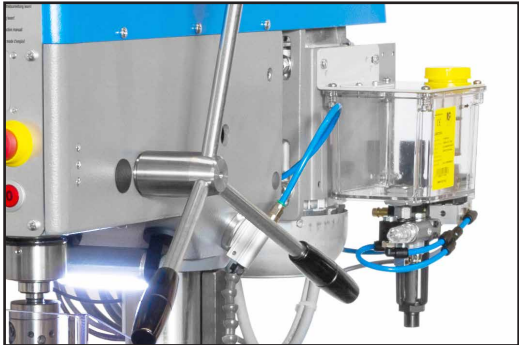


Picture similar

- **Tapping chuck with quick-change insert and overload clutch**



- **Minimum quantity lubrication system**
1 storage tank..... 1.2 l
Control..... electrical / pneumatic



- **Electrical cooling unit**
With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve
- **Floor unit for UNIMAX 2 T TAP**
Dimensions 345 x 602 x 730 mm
Weight 45 kg



UNIMAX 2 T TAP
Picture including option minimum quantity lubrication system.

- Innovative
- Modern
- Sturdy
- Top equipment

Powerful MT 2 machine equipped with easy-scroll-wheel and big display. Digital drilling depth, piece counter, drilling depth fine adjustment and LED machine light already as standard equipment. The new BT 20 combines innovative features with an old-established drive concept.

Technical data	BT 20	BTB 20
Standard capacity	20 mm	20 mm
Tapping capacity	M 16	M 16
Spindle	MT 2	MT 2
Spindle travel	100 mm	100 mm
Spindle to column	250 mm	250 mm
Spindle to table	-	20 - 430 mm
Spindle to base	185 - 541 mm	645 mm
Table surface	340 x 445 mm	450 x 315 mm
T-slot width	14 mm	table 14 mm base plate 14 mm
Column diameter	90 mm	90 mm
Total height	990 mm	1,100 mm
Weight approx.	130 kg	160 kg
Pole changing motor	0.6 / 1.2 kW	0.6 / 1.2 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
Stepless spindle rpm		
	100 - 1,800 rpm	100 - 1,800 rpm
	200 - 3,600 rpm	200 - 3,600 rpm
Standard packaging		
	B 100x85x130cm	B 100x85x130cm



BTB 20

Options / Accessories

- **Drill package 2**
1 drill chuck taper..... MT 2 / B16
1 reduction insert..... MT 2 / MT 1
1 machine vice MSP 120
1 quick-release chuck..... 1 - 16 mm / B16
- **Tapping unit**
Including programmable tapping depth
- **Cross table MF-3**
- **Floor unit for BT 20 / BTB 20**
Dimensions 345 x 602 x 730 mm
Weight 45 kg



- **Electrical cooling unit**
With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve
- **Also available as column machines!**



- Popular & powerful workshop machine
- Versatile
- Robust

Strong, precise drilling machine with big range of application. Height adjustment via rack and pinion. Reverse switch clockwise/counter-clockwise rotation, digital display showing spindle rpm, prepared for mill package, with drilled-through spindle.

Technical data	UNIMAX 3 T	UNIMAX 3
Constant capacity in E 335	25 mm	25 mm
Standard capacity	30 mm	30 mm
Tapping capacity	M 20	M 20
Spindle	MT 3	MT 3
Spindle travel	125 mm	125 mm
Spindle to column	260 mm	260 mm
Spindle / Table	220 - 600 mm	90 - 840 mm
Table surface	390 x 420 mm	550 x 400 mm
T-slot width	14 mm	14 mm
Column diameter	110 mm	110 mm
Total height	max. 1,200 mm	1,855 mm
Weight approx.	220 kg	270 kg
Pole changing motor	0.8/1.5 kW	0.8/1.5 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
Stepless spindle rpm		
Range A	80 - 1,440 rpm	80 - 1,440 rpm
Range B	180 - 3,200 rpm	180 - 3,200 rpm
Standard packaging		
	C 160x74x125 cm	D 220x74x125 cm

Options / Accessories

• Mill Package

- 1 fine feed / 1 cross table MF-3 / 1 clamping for quill /
- 1 milling chuck MT 3 / 1 draw-in rod /
- 3 collets 8, 10, 12 mm



• Drill Package 3

- 1 drill chuck taper..... MT 3 / B16
- 2 reduction inserts..... MT3 / MT2, MT3 / MT1
- 1 machine vice..... MSP 140
- 1 quick-release chuck..... 1 - 16 mm / B16



Picture similar

• Cross table MF-3

- Table surface..... 600 x 240 mm
- X / Y traverse..... 350 / 160 mm
- Weight..... 74 kg

• Electrical cooling unit

- With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve

• Floor units for UNIMAX 3 T

- Size..... 400 x 690 x 720 mm
- Weight..... 65 kg



- Programmable tapping depth
- Versatile
- Robust

The popular machine concept of UNIMAX 3 got extended by a programmable tapping unit. Together with the mill package (optional) this machine is one of the most versatile of its category.

Technical data	UNIMAX 3 T TAP	UNIMAX 3 TAP
Constant capacity in E 335	25 mm	25 mm
Standard capacity	30 mm	30 mm
Tapping capacity	M 20	M 20
Spindle	MT 3	MT 3
Spindle travel	125 mm	125 mm
Spindle to column	260 mm	260 mm
Spindle / Table	220 - 600 mm	90 - 840 mm
Table surface	390 x 420 mm	550 x 400 mm
T-slot width	14 mm	14 mm
Column diameter	110 mm	110 mm
Total height	max. 1,200 mm	1,855 mm
Weight approx.	220 kg	270 kg
Pole changing motor	0.8/1.5 kW	0.8/1.5 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
LED machine light	as standard	as standard
Stepless spindle rpm		
Range A	80 - 1,440 rpm	80 - 1,440 rpm
Range B	180 - 3,200 rpm	180 - 3,200 rpm
Standard packaging		
	C 160x74x125 cm	D 220x74x125 cm

Options / Accessories

- Tapping chuck with quick-change insert and overload clutch



- Drill Package 3

1 drill chuck taper..... MT 3 / B16
2 reduction inserts..... MT3 / MT2, MT3 / MT1
1 machine vice MSP 140
1 quick-release chuck..... 1 - 16 mm / B16

- Mill Package

1 fine feed / 1 cross table MF-3 / 1 clamping for quill /
1 milling chuck MT 3 / 1 draw-in rod /
3 collets 8, 10, 12 mm



- Cross table MF-3

Table surface..... 600 x 240 mm
X / Y traverse..... 350 / 160 mm
Weight 74 kg

- Electrical cooling unit

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve

- Floor units for UNIMAX 3 T TAP

Size 400 x 690 x 720 mm
Weight 65 kg



UNIMAX 3 T TAP

UNIMAX 3 TAP

- Innovative stepless automatic feed
- Top equipment
- Easy operation
- Versatile

Modern, precise production drilling machine according to the successful concept of UNIMAX 3, with stepless variable feed drive, automatic tool ejector and chip breaking function as standard. Digital display indicates feed rate, spindle rpm and drilling depth; programmable drilling depth.

Technical data	UNIMAX 3 T AV	UNIMAX 3 AV
Constant capacity in E 335	25 mm	25 mm
Standard capacity	30 mm	30 mm
Tapping capacity	M 20	M 20
Spindle	MT 3	MT 3
Automatic feed	30-400 mm/min	30-400 mm/min
Spindle travel programmable	125 mm	125 mm
Spindle to column	260 mm	260 mm
Spindle / Table	220 - 600 mm	90 - 840 mm
Table surface	390 x 420 mm	550 x 400 mm
T-slot width	14 mm	14 mm
Column diameter	110 mm	110 mm
Total height	max. 1,200 mm	1,900 mm
Weight approx.	230 kg	280 kg
Pole changing motor	0.8/1.5 kW	0.8/1.5 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
Stepless spindle rpm		
Range A	80 - 1,440 rpm	80 - 1,440 rpm
Range B	180 - 3,200 rpm	180 - 3,200 rpm
Standard packaging	C 160x74x125 cm	D 220x74x125 cm

Options / Accessories

- Chip removal
- Retention time at drill ground
- Tapping unit
- Drill Package 3

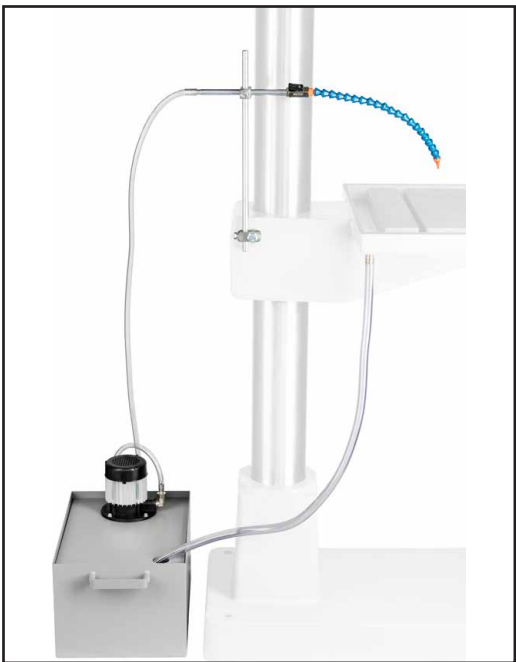
1 drill chuck taper..... MT 3 / B16
2 reduction inserts..... MT3 / MT2, MT3 / MT1
1 machine vice..... MSP 140
1 quick-release chuck..... 1 - 16 mm / B16



Picture similar

- Electrical cooling unit

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve



- LED machine light
- Floor units for UNIMAX 3 T AV

Size 400 x 690 x 720 mm
Weight 65 kg

- Mill Package not possible for this type!



UNIMAX 3 T AV



UNIMAX 3 AV

- *Innovative*
- *High Performance*
- *Top equipment*

Powerful MT 4 machine equipped with ea-
sy-scroll wheel and big display.Tapping func-
tion, programmable drilling depth including
chip-breaking, LED machine light, piece counter
and stepless variable feed drive as standard
equipment. The innovative drive of rpm and
automatic feed sets new standards in this class.

Technical Data	BT 36	BS 36
Constant capacity in E 335	35 mm	35 mm
Standard capacity	40 mm	40 mm
Tapping capacity	M 30	M 30
Spindle	MT 4	MT 4
Automatic feed	15-400 mm/min	15-400 mm/min
Spindle travel	160 mm	160 mm
Spindle to column	300 mm	300 mm
Spindle to table	245 - 747 mm	156 - 879 mm
Table Surface	390 x 420 mm	550 x 400 mm
T-slot width	14 mm	14 mm
Column diameter	120 mm	120 mm
Total height	1,368 mm	2,104 mm
Weight approx.	285 kg	385 kg
Pole changing motor	4.0 kW	4.0 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
Stepless Spindle Speed		
Range A	50 - 800 rpm	50 - 800 rpm
Range B	110 - 1,350 rpm	110 - 1,350 rpm
Range C	200 - 2,400 rpm	200 - 2,400 rpm
Standard packaging	G 170x80x145 cm	E 225x80x145 cm

Options / Accessories

- **Drill Package 4**
1 drill chuck taper..... MT4 / B16
3 reduction inserts MT4 / 3, MT4 / 2, MT4 / 1
1 machine vice MSP 140
1 quick-release-chuck 1 - 16 mm / B16
- **2 stepped automatic feeds**
Range A and B..... 0 - 712 mm/min
- **Chip removal**
- **Retention time at drill ground**
- **Table adjustment on front side (BS 36)**
- **Height adjustment on front side (BT 36)**



- **Motorised height adjustment**
- **Electrical cooling unit**
With provided 20 litre coolant tank, including pump, pipe
connections, flexible outlet and shut-off valve
- **Cooling unit in baseplate with T-slots (BS 36)**
- **Floor units for BT 36**
Size 400 x 690 x 720 mm
Weight 65 kg



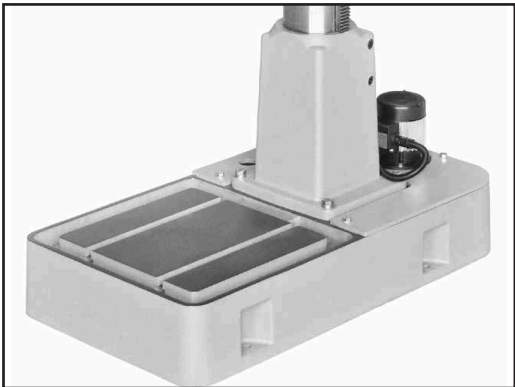
- High performance capability
- Programmable
- Tapping unit as standard
- Chip breaking function

Universal and very modern column drilling machine with spindle MT 4, LED machine light, tapping unit, high performance capability and very good price-performance ratio. Digital display showing feed rate, spindle rpm and program-mable drilling depth.

Technical data	UNIMAX 4 Basic Plus
Constant capacity in E 335	35 mm
Standard capacity	40 mm
Tapping capacity	M 30
Spindle	MT 4
Stepless automatic feed	20-400 mm/min
Drilling depth programmable	175 mm
Spindle to column	300 mm
Spindle / Table	70 - 830 mm
Table surface	650 x 500 mm
T-slot width	14 mm
Column diameter	140 mm
Total height	1,980 mm
Weight approx.	490 kg
Pole changing motor	1.5 / 3.0 kW
Mains connection	400 V / 50 Hz
Stepless spindle rpm	
Range A	120 - 2,500 rpm
Range B	60 - 1,250 rpm
Tapping unit	included
Chip breaking	included
Chip removal	included
Retention time at drill ground	included
Standard packaging	E 225x80x145 cm

Options / Accessories

- Drill Package 4
 - 1 drill chuck taper. MT 4 / B 16
 - 3 reduction inserts MT4 / 3, MT4 / 2, MT4 / 1
 - 1 machine vice MSP 140
 - 1 quick-release chuck. 1 - 16 mm / B 16
- Electrical cooling unit
 - With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve
- Electrical cooling unit in the baseplate



- Cycles programmable
- For complex work processes
- High functionality
- Touch screen

Column drilling machine with programmable cycles, also for complex work processes, with programmable spindle rpm and automatic feed. As simple as a conventional one, but with functions of a controlled machine. Adapted user interface for workshop needs.

Technical data	UNIMAX 4
Constant capacity in E 335	40 mm
Standard capacity	45 mm
Tapping capacity	M 36
Spindle	MT 4
Stepless feed	30 - 1,650 mm/min
Automatic feed	freely programmable
Spindle travel programmable	175 mm
Spindle to column	300 mm
Spindle / Table	70 - 830 mm
Table surface	650 x 500 mm
T-slot width	14 mm
Column diameter	140 mm
Total height	1,980 mm
Weight approx.	490 kg
Frequency-controlled motor	7.5 kW
Mains connection	400 V / 50 Hz
Stepless spindle rpm	30 - 2,400 rpm
Standard packaging	E 225x80x145 cm

Options / Accessories



- LED machine light
- Key-operated switch
for locking the programming
- Drill Package 4
1 drill chuck taper. MT 4 / B 16
3 reduction inserts. MT4 / 3, MT4 / 2, MT4 / 1
1 machine vice MSP 140
1 quick-release chuck. 1 - 16 mm / B 16
If required, for tapping with key type chuck.



- Electrical cooling unit, controlled
With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve
- Electrical cooling unit, controlled in baseplate with T-slots
Including pump, pipe connections, flexible outlet and shut-off valve

further accessories from page 60



- **Powerful up to 50mm**
- **4 fixed automatic feeds**
- **Individually customisable**

High performance drilling machine. Electro-magnetic clutch for feed. Stepless adjustment of spindle rpm. Gearing system in 2 steps. Oil circulation lubrication. Table adjustment from front side. Motor protection. Star knob control.

Technical data	BS 50 AVST
Constant capacity in E 335	50 mm
Tapping capacity	M 45
Spindle	MT 4
Fixed automatic feeds	4
Spindle travel	200 mm
Spindle to column	325 mm
Spindle / Table	80 - 675 mm
Table surface	650 x 500 mm
T-slot width	14 mm
Column diameter	160 mm
Total height	2,070 mm
Weight approx.	750 kg
Pole changing motor	2.0 / 3.8 kW
Mains connection	400 V / 50 Hz
Stepless spindle rpm	35 - 1,060 rpm
with auto feed	0.1-0.18-0.28-0.45 mm/t
Stepless spindle rpm	50 - 1,500 rpm
with auto feed	0.08-0.12-0.2-0.32 mm/t
Stepless spindle rpm	66 - 2,000 rpm
with auto feed	0.06-0.09-0.15-0.25 mm/t
Standard packaging	F 233x90x133 cm

Options / Accessories

- **Spindle MT 5**
- **Tapping unit**
- **Programmable drilling depth display**
- **Motorised height adjustment**



• **Cross table MF-4**

Table surface..... 800 x 240 mm
X / Y traverse.....470 / 245 mm
Weight 110 kg

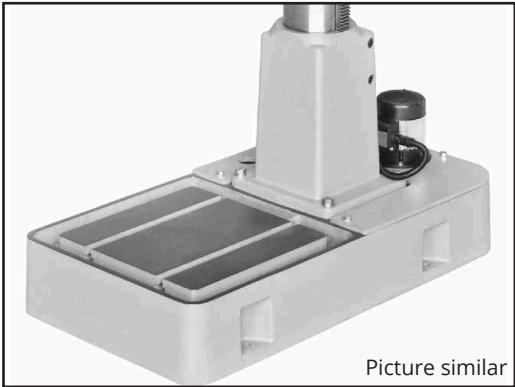


• **Electrical cooling unit**

With provided 20 litre coolant tank, including pump, pipe connections, flexible outlet and shut-off valve

• **Electrical cooling unit in baseplate with T-slots**

Including pump, pipe connections, flexible outlet and shut-off valve



Picture similar

further accessories from page 60



- *Horizontal unit*
- *Z- or U- design*
- *Serial production*
- *Reliable and smooth running*

Horizontal drilling unit in z- or compact u-form (see picture).
Frequency controlled spindle rpm´s, its range can be chosen flexibly and be adjusted via potentiometer.
Rotation speeds, drilling depth and feed rate is shown in touch display.
Drilling depth and feed rate get programmed via display. Including chip breaking.

Technical data	H 25 AV
Constant capacity	25 mm
Tapping capacity	M 5 - M 16
Spindle	MT 3
Depth of thread	100 mm
Stepless automatic feed	30-400 mm/min
Spindle height	125 mm
Weight approx.	145 kg
Frequency-controlled motor	230 V
Stepless spindle rpm	up to 3,200 min ⁻¹
Alternative drive	
Pole changing motor	400 V
Spindle rpm	individual
Standard packaging	A 89x52x127 cm
Further technical data on request	

Options / Accessories

- Tapping unit
- Retention time at drill ground
- Chip removal
- Electrical cooling unit
- Minimum quantity lubrication system
- Further options on request

further accessories from page 60



- **For manufacture of threads true to gauge M3 - M10**
- **Serial production**
- **Reliable and smooth running**
- **Standard and special thread sizes**

High performance tapping machine with lead screw. Safety arrangement for prevention of tool breakage. Programme for tapping single and continous cycles, programmable tapping depth, chip breaking during tapping, piece counter, LED machine light and electronically controlled motor braking for single cycle operation. Simple replacement of lead screw by means of quick coupling.

Technical data	BT 18 GL	BS 18 GL
Tapping capacity	M 3 - M 10	M 3 - M 10
Threads per hour	1,000	1,000
Standard capacity	15 mm	15 mm
Spindle	MT 2	MT 2
Depth of thread	60 mm	60 mm
Spindle travel	100 mm	100 mm
Spindle to column	250 mm	250 mm
Spindle / Table	185 - 541 mm	110 - 900 mm
Table surface	340 x 445 mm	450 x 315 mm
T-slot width	12 mm	12 mm
Column diameter	90 mm	90 mm
Total height	1,050 mm	1,810 mm
Weight approx.	135 kg	160 kg
Special motor	0.55 kW	0.55 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
4 fixed spindle rpm steps	320 rpm	320 rpm
	560 rpm	560 rpm
	1,000 rpm	1,000 rpm
	1,600 rpm	1,600 rpm
Standard packaging	B 100x85x130 cm	D 220x74x125 cm

Options / Accessories

• Transmission

The technical data change as follows:
Stronger Motor 0.75 kW
Tapping capacity M3 - M16
main rpm steps 160 - 280 - 500 - 800 rpm
further rpm steps after change of belt postion:
..... 210 , 360 , 620 , 1000 , 1600 , 3000 rpm

• Lead screw



Lead screw for BT 15 GL can still be used

• Tap Holder

GSIP-0 for M3 up to M10
GSIP-1 for M8 up to M18

• Die holder

• Bottoming release switch

• Force ventilated motor

• Column longer by 200 mm for BT 18 GL

• Flanged quill

• Foot impulse switch

• Two-hand start

• Minimum quantity lubrication system

1 storage tank 1.2 l
Control electrically / pneumatically

• Floor units

Size 345 x 602 x 730 mm
Weight 45 kg



- For manufacture of threads true to gauge M4 – M20
- Serial production
- Reliable and smooth running
- Standard and special thread sizes

High performance tapping machine with lead screw and optimum safety arrangement for prevention of tool breakage. Programme for tapping single and continuous cycles. Chip breaking during tapping, programmable tapping depth, piece counter and LED machine light. Electronically controlled motor braking for single cycle operation. Simple replacement of lead screw by means of quick coupling.

Technical Data	UNIMAX 3 T GL	UNIMAX 3 GL
Tapping capacity	M 4 - M 20	M 4 - M 20
Threads per hour	800	800
Standard capacity	28 mm	28 mm
Spindle	MT 3	MT 3
Depth of thread	90 mm	90 mm
Spindle travel	120 mm	120 mm
Spindle to column	260 mm	260 mm
Spindle / Table	220 - 600 mm	90 - 840 mm
Table surface	420 x 390 mm	400 x 550 mm
T-slot width	14 mm	14 mm
Column diameter	110 mm	110 mm
Total height	1,300 mm	1,955 mm
Weight approx.	210 kg	247 kg
Special motor	0.9 kW	0.9 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
9 fixed spindle rpm steps	95 / 160 / 200 / 350 / 420 / 450 / 750 / 900 / 1650	
Standard Packaging	C 160x74x125 cm	D 220x74x125 cm

Options / Accessories

- Lead screw



- Tap Holder

GSIP-0.....for M3 up to M10
GSIP-1.....for M8 up to M18



- Force ventilated motor
- Bottoming release switch
- Die holder



- Minimum quantity lubrication system
- Flanged quill
- Foot impulse switch



- Two-hand start
- LED Machine light
- Floor units for UNIMAX 3 T GL



UNIMAX 3 T GL Picture with option minimum quantity lubrication system

UNIMAX 3 GL

- *For manufacture of threads true to gauge M5 – M30*
- *Serial production*
- *Reliable and smooth running*
- *Standard and special thread sizes*

High performance tapping machine with lead screw and optimum safety arrangement for prevention of tool breakage. Programme for tapping single and continous cycles. Chip breaking during tapping, programmable tapping depth, piece counter and LED machine light. Electronically controlled motor braking for single cycle operation. Simple replacement of lead screw by means of quick coupling.

Technical Data	BT 36 GL	BS 36 GL
Tapping capacity	M 5 - M 30	M 5 - M 30
Threads per hour	800	800
Standard capacity	35 mm	35 mm
Spindle	MT 4	MT 4
Depth of thread	90 mm	90 mm
Spindle travel	160 mm	160 mm
Spindle to column	300 mm	300 mm
Spindle / Table	245 - 745 mm	156 - 879 mm
Table surface	390 x 420 mm	550 x 400 mm
T-slot width	14 mm	14 mm
Column diameter	120 mm	120 mm
Total height	1,520 mm	2,105 mm
Weight approx.	270 kg	305 kg
Special motor	1.2 kW	1.2 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
5 spindle rpm in 2 ranges	80 / 130 / 190 / 290 / 440	
5 spindle rpm in 2 ranges	160 / 260 / 380 / 580 / 880	
Standard packaging	G 170x80x145 cm	E 225x80x145 cm

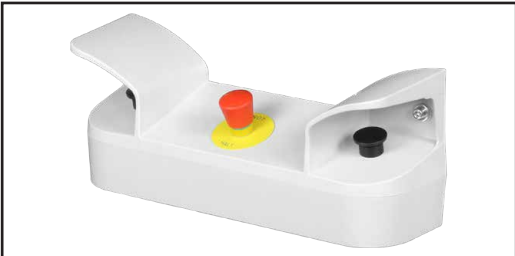
Options / Accessories

- **Tap Holder**
GSIP-0.....for M3 up to M10
GSIP-1.....for M8 up to M18



- **Lead Screw**

- **Force ventilated motor**
- **Bottoming release switch**
- **Minimum quantity lubrication system**
- **Die holder**
- **Flanged quill**
- **Two hand start**



- **Foot impulse switch**
- **Floor units for BT 36 GL**



- **Horizontal unit for manufacture of threads true to gauge M3 - M10**
- **Serial production**
- **Reliable and smooth running**
- **Standard and special thread sizes**

High performance tapping machine as horizontal unit, center height 125 mm with lead screw and optimum safety arrangement for prevention of tool breakage. Programme for tapping single and continous cycles. Electronically controlled motor braking for single cycle operation. Simple replacement of lead screw by means of quick coupling.

Technical data	H 15 GL
Tapping capacity	M 3 - M 10
Threads per hour	800
Spindle	MT 2
Depth of thread	60 mm
Spindle height	125 mm
Total height	560 mm
Weight approx.	60 kg
Special motor	0.55 kW
4 fixed spindle rpm	320 - 1,600 rpm
Standard packing	A 89x52x127 cm

Options / Accessories

- **Tap holder**
GSIP-0.....for M3 up to M10

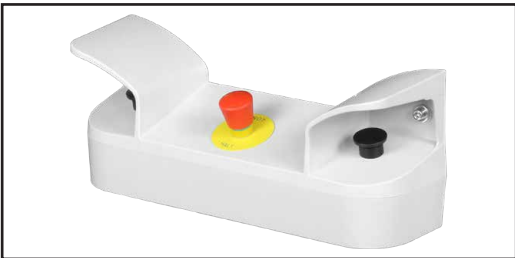
- **Lead screw**



- **Force ventilated motor**
- **Bottoming release switch**
- **Fine adjustment cam for tapping depth**

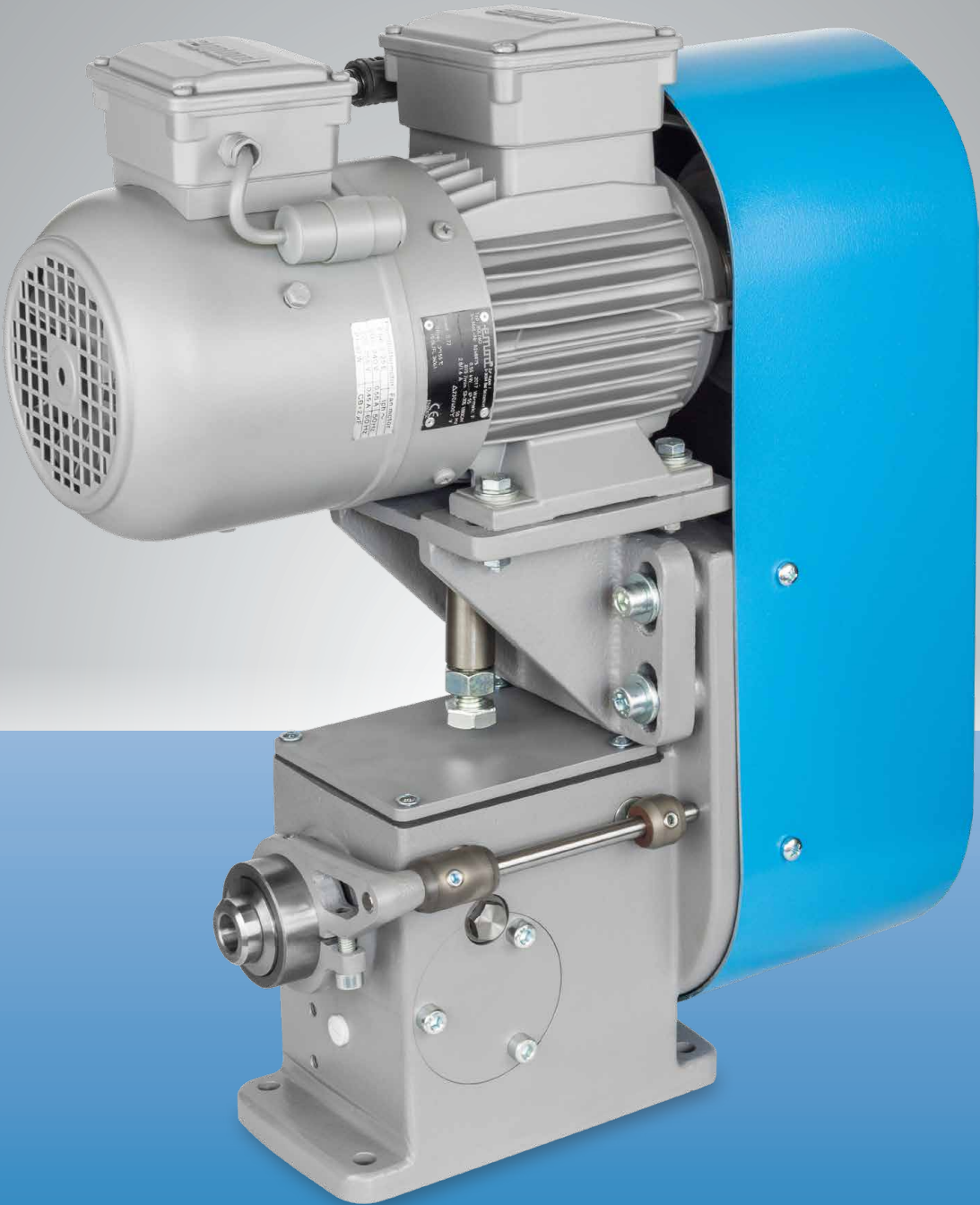


- **Minimum quantity lubrication system**
- **Die holder**
- **Two-hand start**



- **Foot impulse switch**

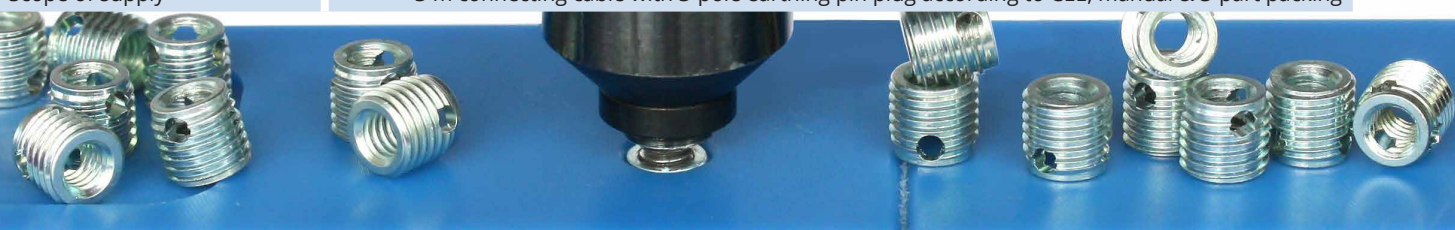
further accessories from page 60



Reliable tapping machine for quality-orientated tapping respectively thread moulding M1 to M18, screw in of thread inserts⁽¹⁾, rethreading and postforming as well as checking already manufactured threads. Thanks to the menu guided operation machine parameters can be entered fast and uncomplicated. For each particular machining process the ideal rotation speeds, drilling depth as well as the minimum and maximum tapping torque can be entered. If the machine leaves these parameters, the thread will be identified as defective. By means of an integrated piece counter an overview of already processed workpieces is provided everytime. For analysis and control of tapping processes the machine can be connected to a PC ⁽¹⁾.

(1) not for jobtap.

Maxtap / Jobtap	G 5	G 8	G 14	G 16
Tapping performance				
X5CrNi189/1.4435	M1 - M5	M2.5 - M8	M3.5 - M12	M4 - M14
9SMn28/1.0715	M1 - M6	M2.5 - M10	M3.5 - M14	M4 - M18
AlCuMgPb/3.1645	M1 - M6	M2.5 - M12	M3.5 - M16	M4 - M20
Max. tapping depth / stroke	45 / 65 mm	75 / 85 mm	75 / 85 mm	75 / 85 mm
Insert holder quick change system	SWS 0 incl. 5 inserts	SWS 1 incl. 6 inserts	SWS 2 incl. 7 inserts	SWS 3 incl. 9 inserts
Insert holder / spindle	B 10	B 12	B 12	B 12
Distance tool holder/work-table	0 - 280 mm	0 - 400 mm	0 - 400 mm	0 - 400 mm
Torque range Mz (stepless)	5 - 220 Ncm	50 - 700 Ncm	120 - 1,680 Ncm	150 - 2,100 Ncm
Spindle speed range (stepless)	250 - 2,200 rpm	300 - 3,000 rpm	125 - 1,250 rpm	100 - 1,000 rpm
Width	323 mm	312 mm	312 mm	312 mm
Depth	510 mm	530 mm	544 mm	544 mm
Height	780 mm	930 mm	930 mm	930 mm
Weight net	51.4 kg	61.7 kg	63.3 kg	63.3 kg
Column (adjustable with hand wheel)	600 mm	750 mm	750 mm	750 mm
Base plate in mm	280 x 475 x 50	280 x 475 x 50	280 x 475 x 50	280 x 475 x 50
2 x T-slot	M 12 x 14	M 12 x 14	M 12 x 14	M 12 x 14
Mains voltage	230 V / 50-60 Hz	230 V / 50-60 Hz	230 V / 50-60 Hz	230 V / 50-60 Hz
Power consumption	300 W	2,900 W	2,900 W	2,900 W
Scope of supply	3 m connecting cable with 3-pole earthing pin plug according to CEE, manual & 3-part packing			



Options

Maxtap / Jobtap	
ZAP	Z-axis controlled pneumatic feeding system
MMS	controllable minimum quantity lubrication unit
SWS & SZS	quick change tool holder system & optional fixed collet holder system
DSK	double spindle head adapter
SHV & HVS	column special size & horizontal adjustment
SSB / ASL	security key / audible signal light
Maxtap	
MPT	integrated manual positioning XY-table
WinPCA TAP	analysing PC software for comparison, evaluation of series of measurement and their storage



Gang drilling machines

- *Productive*
- *For serial production*
- *Individually customisable*
- *Solid*

The benchings are mounted on box-type stands and are deliverable for 3, 4, 5 or 6 units. Each box-type stand with two storage shelves. The heavy, torsionresistant cast-iron table has two T-slots. Electrical equipment is clearly installed in a central switch box. On BRK 35 the units are swivellable above table plate. From 2 units upwards with emergency stop button in the movable control panel as standard

Technical data	BRK 18	BRK 20	BRK 35
Distance between units	370 mm	450 mm	450 mm
Height of table	860 mm	830 mm	860 mm
table length = no. of units	by 370 mm	by 450 minus 140	by 450 mm
Depth of table	460 mm	600 mm	680 mm
T-slot width	12 mm	14 mm	14 mm
Throat working depth	340 mm	455 mm	460 mm
Possible machine heads	BT 6 freq., UNIMAX 1 TAP, UNIMAX 1 freq.,	BT 18 GL BT 20 UNIMAX 2T UNIMAX 2T TAP	BT 36, BT 36 GL, UNIMAX 3T, UNIMAX 3T AV, UNIMAX 3T GL UNIMAX 3T TAP, UNIMAX 4T Basic
Height adjustment from front	not available	not available	inclusive
Base for BRK 18 / 35			
	3 units	3 units	3 units
	4 units	4 units	4 units
	5 units	5 units	5 units
	6 units	-	6 units
Special packing	on request	on request	on request



Options / Accessories

- **Electrical cooling unit**
base unit with 60 l tank, return hose,
plus charge for supply of desired units
- **Other options / accessories**
See machine

Gang drilling machines



Drilling-Milling machines BT 25 FST / 35 FST

- For smaller milling operations
- Individually customisable
- Versatile

Precise, handy and versatile drilling-milling machine. Very smooth running drive and reliable clamping of spindle sleeve guarantee good surfaces at milling. Headstock can be swivelled to the side. Precisely guided and exactly adjustable cross table. Increments 0.05 mm, clamping in both axes. Motor protection.

Technical data	25 FST	35 FST
Spindle	MT 3	MT 4
Drawbar	M 12	M 16
Quill stroke	100 mm	130 mm
Standard capacity	30 mm	35 mm
Spindle / Cross table	80 to 450 mm	60 to 430 mm
Table surface	600 x 240 mm	800 x 240 mm
X- / Y- traverse	350 / 160 mm	470 / 245 mm
T-slot width	14 mm	14 mm
Column diameter	110 mm	120 mm
Total height	max. 1,920 mm	max. 1,970 mm
Weight approx.	425 kg	500 kg
Pole changing motor	0.8 / 1.5 kW	1.3 / 2.3 kW
Mains connection	400 V / 50 Hz	400 V / 50 Hz
Stepless spindle rpm BT 25 FST / BT 35 FST		
	80 - 1,400 rpm	80 - 1,400 rpm
	120 - 2,160 rpm	
	160 - 2,800 rpm	160 - 2,800 rpm
10 fixed spindle speeds BT25F 12 fixed spindle speeds BT35F	On request	On request
Scope of supply	Floor unit with door, cross table, drawbar, quill clamping, fine feed	
Standard packaging	D 220x74x125 cm	D 220x74x125 cm

Options / Accessories

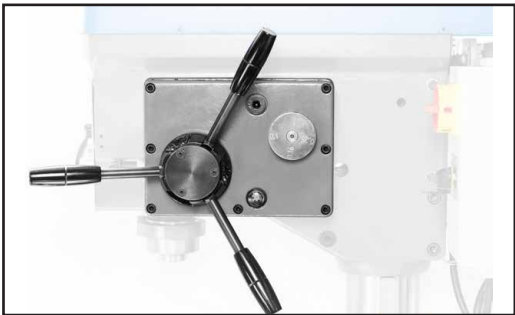
- Tapping unit
- Digital display for drilling depth
- Motorised height adjustment
- Electric cooling unit
- Security against torsion
- Accuracy on the spindle +/- 0,1 mm
- Height adjustment and clamping on front side
- Milling chuck



- Collet chuck
- Chip tray
- dimension: 1000 x 1005 mm
- Digital display table axes



- 3 fixed automatic feeds



- Spindle Seeger cone SK 30 (DIN 2079)
- Drill Package
- BT 25 F Drill Package 3
- BT 35 F Drill Package 4

Drilling-Milling machines BT 25 FST / 35 FST



BT 25 FST
with option chip tray

Coordinate drilling
compound table



- Operation via touch display
- High positioning accuracy
- High compatibility
- Quick and easy programming without any CNC knowledge

Modular coordinate drilling compound table that achieves high positioning accuracy through linear guides and the closed loop drive. Ideal for small series or continuous operation. Can be used individually or combined with other machines. Comfortable control via HMI 5.7" touch display with or without coupling to the drilling or tapping machine.

The following operating modes are available:

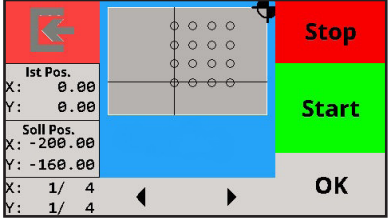
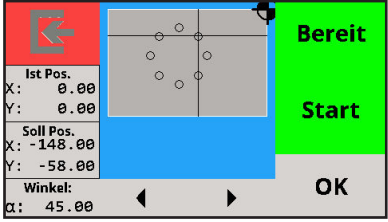
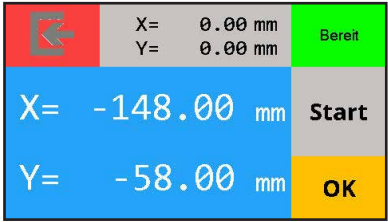
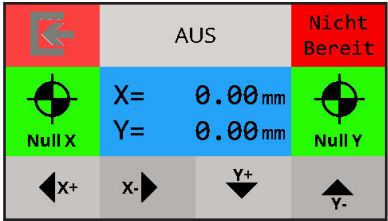
Manual operation

- Coordinate input
- Probing functions

Automatic mode

- Program file
- Hole circle cycle
- Hole line cycle
- Create and save programs

Technical Data	KBT 1	KBT 2	KBT 3	KBT 4
Table surface	600 x 240 mm	600 x 240 mm	800 x 240 mm	800 x 240 mm
Table Height	188 mm	215 mm	215 mm	215 mm
Travel	270 / 230 mm	340 / 230 mm	470 / 230 mm	470 / 350 mm
T-slot width	6 x 8 mm	3 x 12 mm	3 x 12 mm	3 x 12 mm
Speed	4,500 rpm	4,500 rpm	4,500 rpm	4,500 rpm
Mains Connection	230 V / 50 Hz	400 V / 50 Hz	400 V / 50 Hz	400 V / 50Hz
Weight approx.	120 kg	120 kg	200 kg	200 kg
Positioning accuracy	+/- 0.03	+/- 0.03	+/- 0.03	+/- 0.03

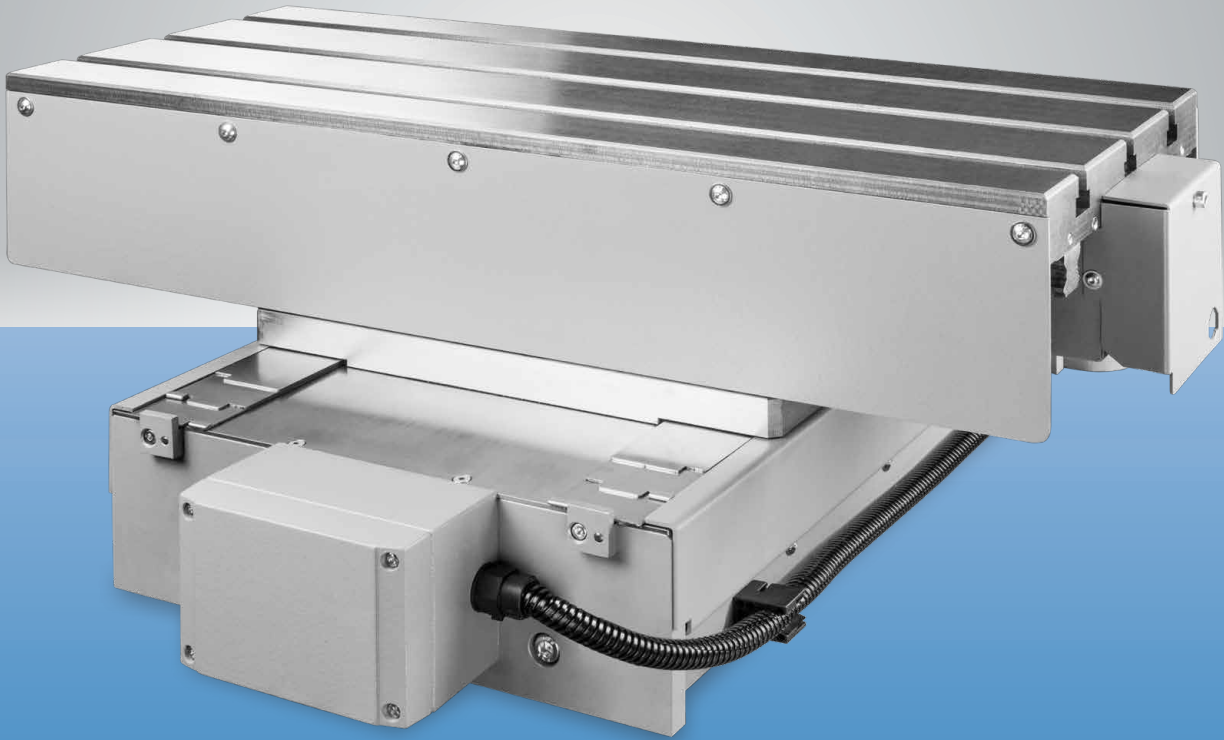


Options / Accessories

• PC Software

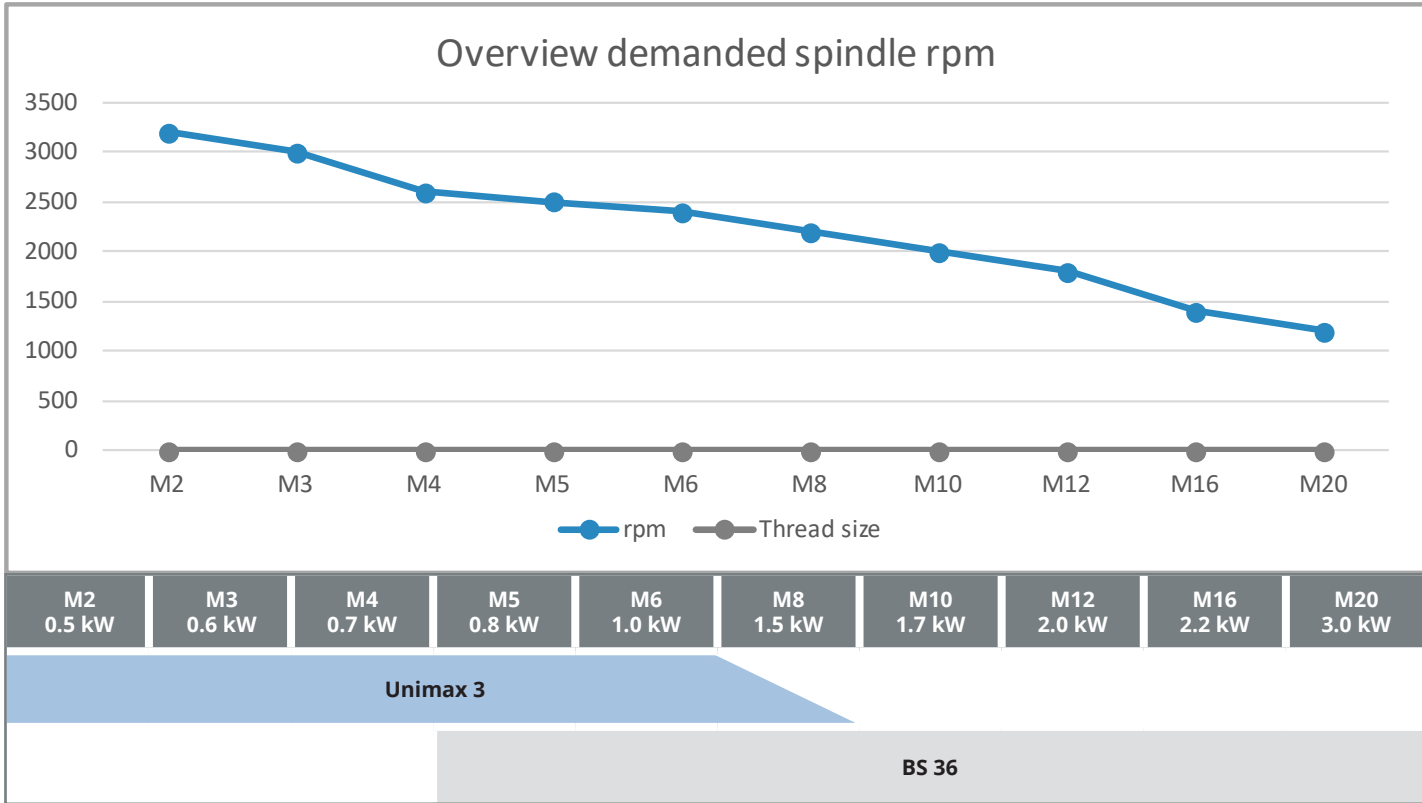
For creating the drilling coordinates, with clear visualisation.

Koordinatenbohrtisch



Flow drilling is a manufacturing method during which a tool is pressed against a thin-walled metallic material by using relatively high rpm and axial force. During this procedure the accruing frictional heat plasticizes the material, so that the drill can be lead through the workpiece. The material is mainly flowing to the underside and is building a „bushing“, which is 3 to 5 times thicker than the original thickness of material.

For flow drilling we are suggesting two machines out of our standard range of products: UNIMAX 3 series and starting from M8 the new BS 36 machine. Please use the chart below for required demand values.



NEW



The MAXION Revolver drill head with up to 6 spindle stations and electric-pneumatic control is the ideal extension to our UNIMAX 4. In combination with our BT 36 and the coordinate drilling table, it perfects automatic machining. If necessary, the MAXION Revolver drilling head can be integrated into existing production lines.

Technical Data	RBK3 / RBK4
Number of spindle stations	6
Tool holder	Collet ER32
Driver	MT3 / MT 4
Maximum speed when shifting	500 rpm
Standard capacity	16mm
Ratio	1:1
Weight	approx.12 kg
Dimension	approx. 300 x 300 x 260mm

Options / Accessories

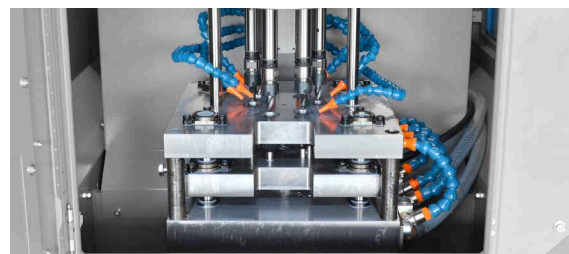
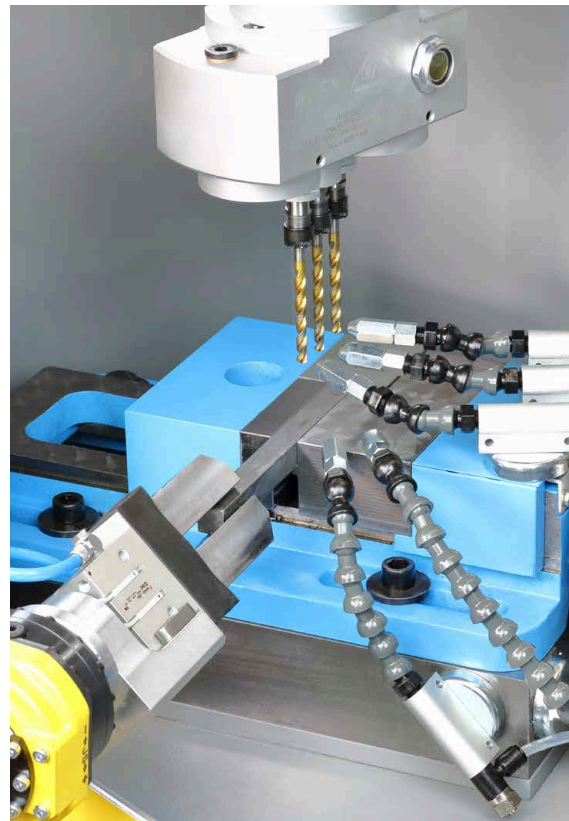
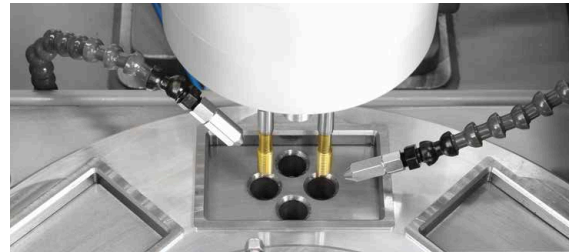
- Collet ER 32
- Further options / accessories on request

Out of our machine components we are able to offer you workpiece related special purpose machines.

- *Automatic drilling/tapping*
- *Outreach enlargement*
- *Shifting table*
- *Shifting units*
- *Rotary table*
- *Bar feeder*
- *Multi-sided machining*
- *Multi-spindle machining*

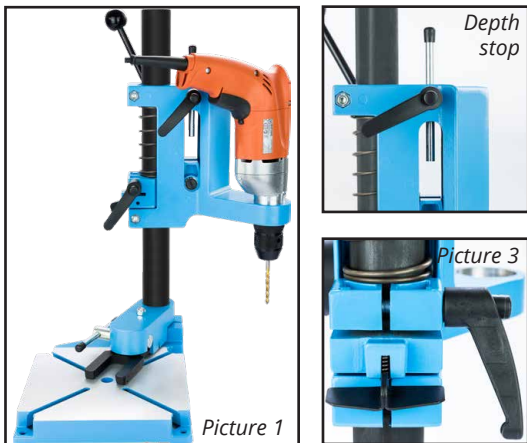
Many paths can lead to one destination.
We provide consulting for the right solution.

Planning, design, manufacturing and
assembly under one roof.



Please check our website for further examples: www.maxion.de

Solid construction for precise drillings. Because of the asymmetric arrangement of 40 mm column to the base-plate arises additional free space. Milled working area with clamping slot for fixing of e.g. vices. The angled machine support allows easy reading of depth scaling. With integrated release spring and depth stop. Maximum drilling depth of 65 mm can be achieved without displacing your hand. Machine support can be swivelled around column (picture 1), so that very long pieces can be drilled as well when attached to the end of the working bench. Safety technology assures riskless adjustment to desired working height. Machine support is fastened to column with clamping lever. No danger of injuries and drill breakage. (picture 3)



Technical data	
Clamping neck (European standard)	43 mm
Throat (centre of column)	165 mm
Column diameter	40 mm
Column length	500 mm
Working stroke	65 mm
Base plate	220 x 213 mm
Weight	5 kg

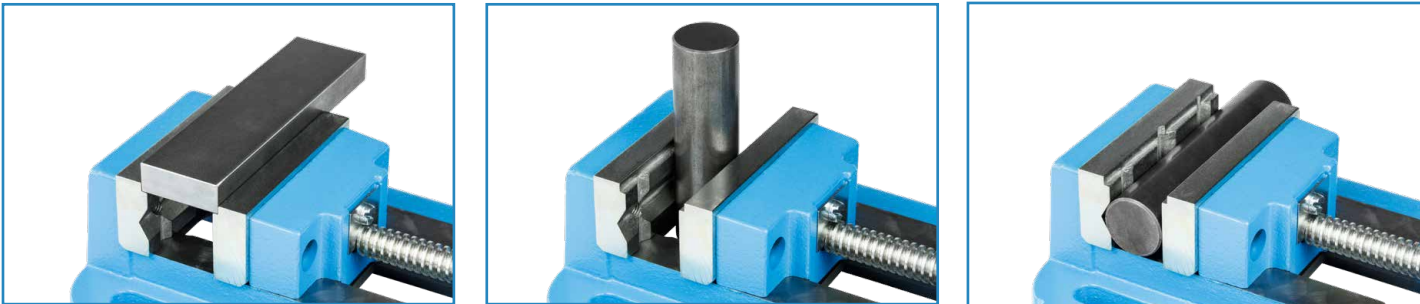
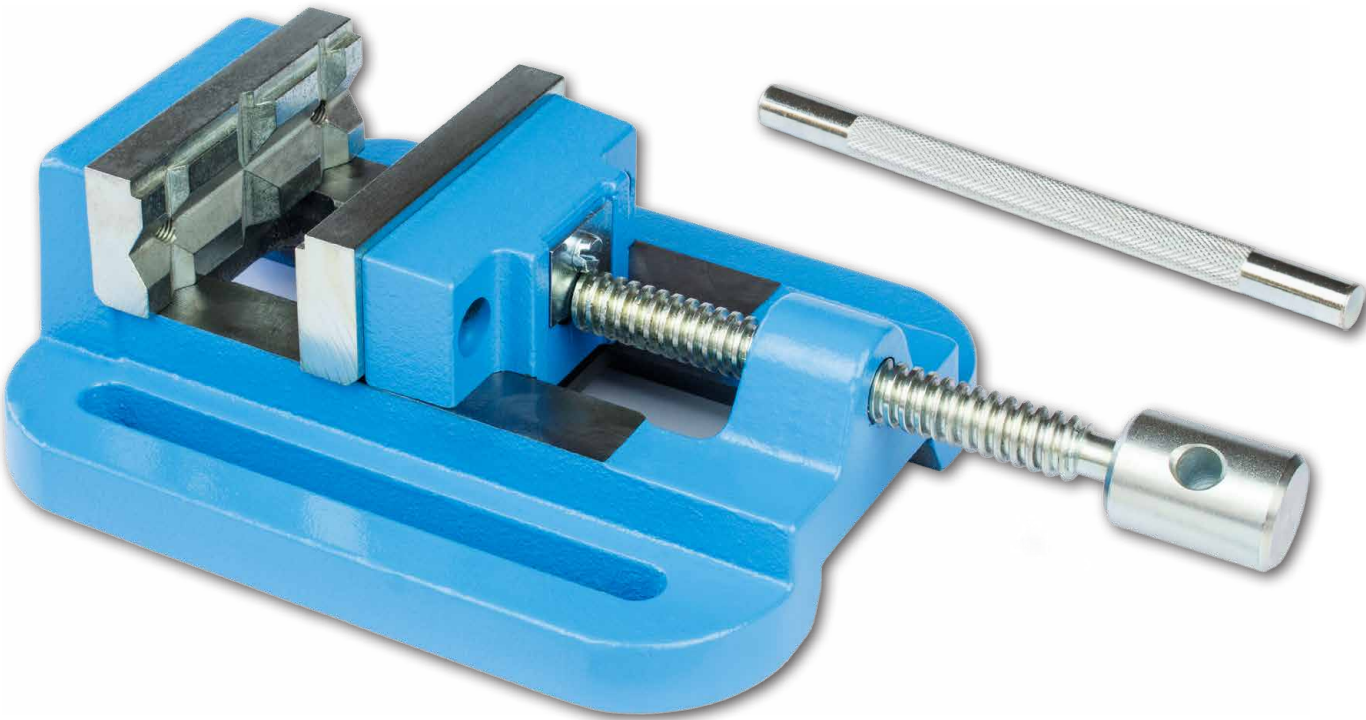


MBS 165
Picture with MKF 40 (optional)
Delivery without drilling machine !

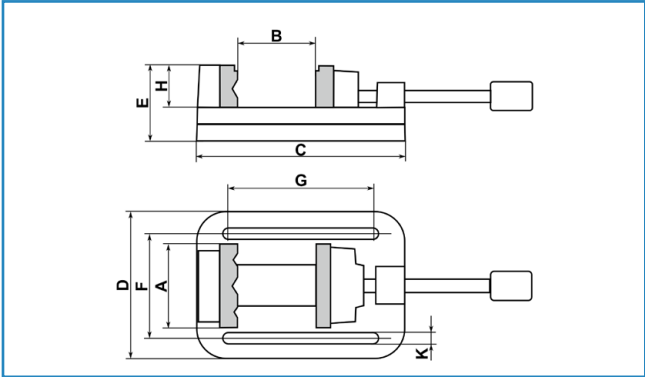
Accessory: MKF 40 - Quick clamping device for sheet metal pipes and profiles, swivellable around column.

Extremely robust and heavy machine vice for production and handicraft.
Base made of high-strength malleable iron or modular graphite casting, hardened and grinded jaws, powerful trapezoidal threaded spindles with long locking handle for maximum clamping forces.

Both jaws with area surface for plain parts. Steel jaws with longitudinal and transverse prisms for perfect adaptation to the workpiece geometry. Corrosion-protected jaws, spindles and handles



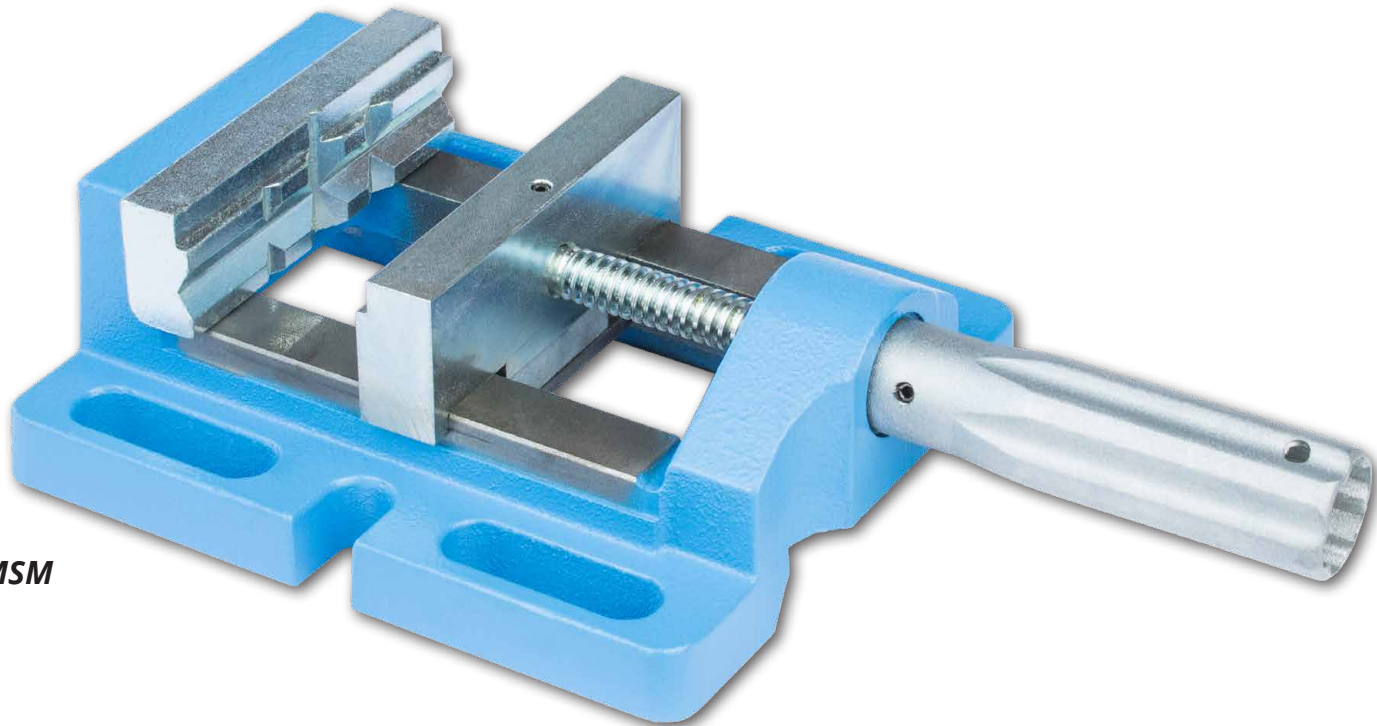
Clamping examples



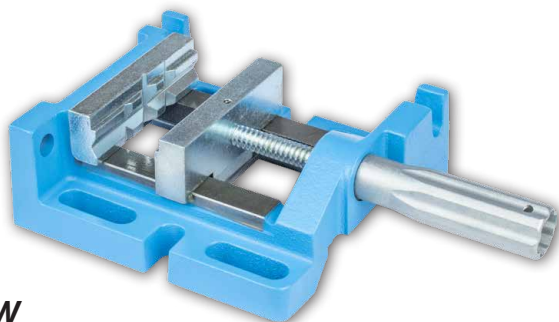
	A	B	C	D	E	F	G	H	K	Weight (kg)
MSP 80	80	80	200	140	60	100	140	40	M 10	5.0
MSP 100	100	90	220	175	75	125	150	40	M 12	7.5
MSP 120	120	120	260	215	86	160	170	40	M 16	11.5
MSP 140	140	155	300	220	86	165	210	40	M 16	13.5

MSM - Medium-heavy machine vices
Optimal machine vices for drilling, flow-drilling and tapping. With precise outside guidance, covered spindle running inside of ergonomically designed hollow handle, accurately milled seating surfaces.
MSM 120 with high-precision jaw guiding because of additional cast iron jaws guided on the outside.

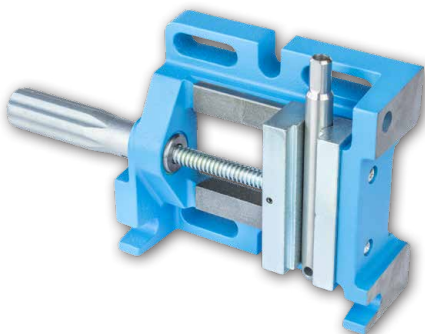
MSW - Angle machine vices
General purpose angle machine vice with 100 mm jaw width and three plain milled seating surfaces for processing parts in two or three vertical levels at one clamping.



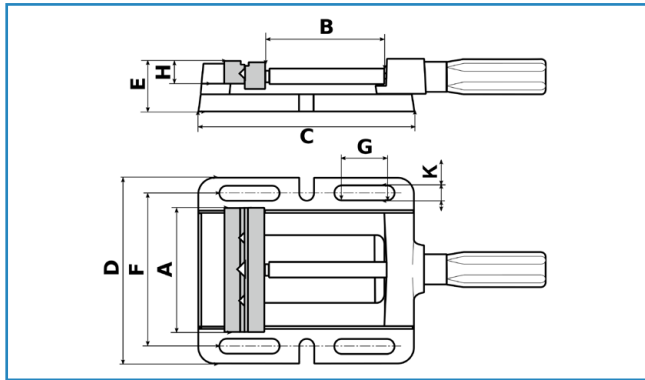
MSM



MSW

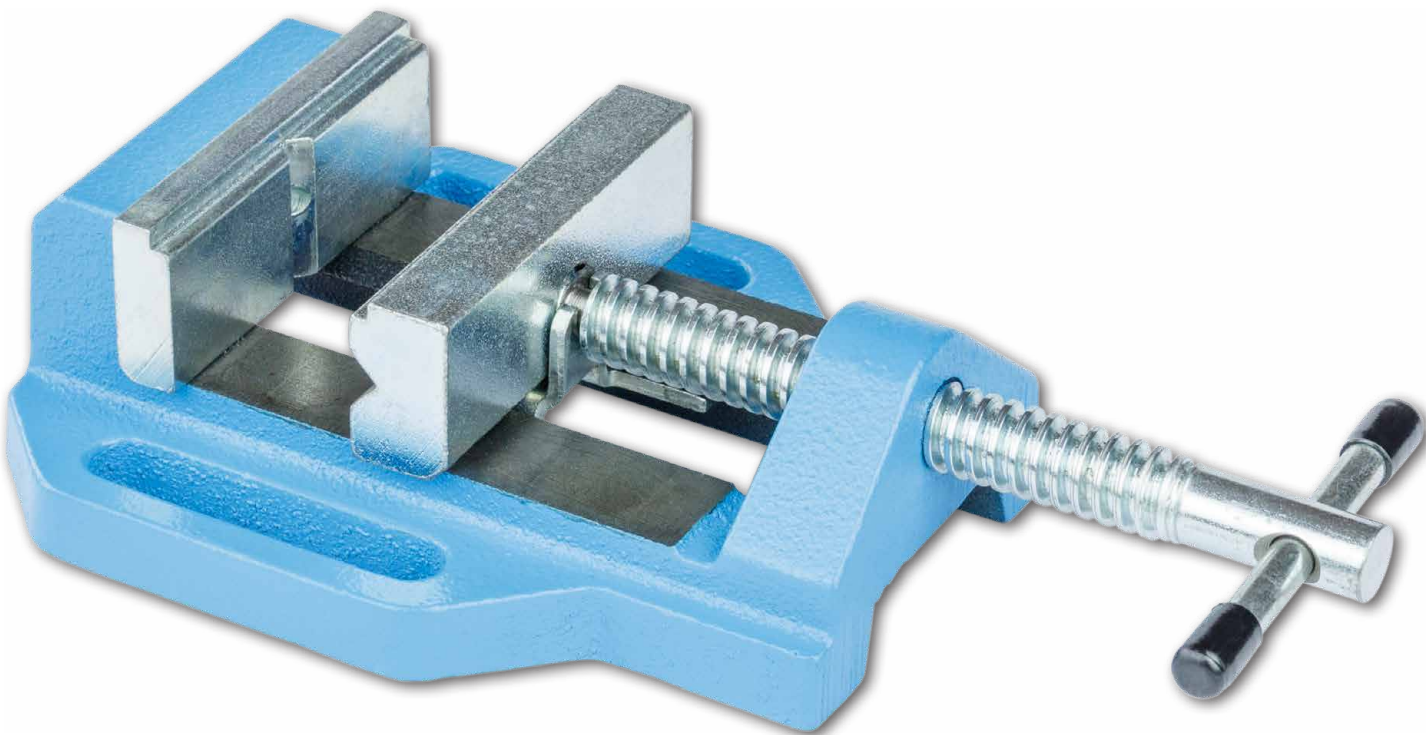


MSW

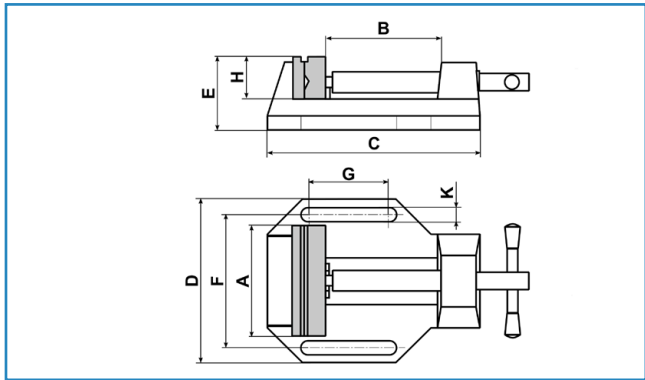


	A	B	C	D	E	F	G	H	K	Weight (kg)
MSM 85	85	70	155	144	62	110	30	30	M 10	3.3
MSM100	100	95	175	152	64	125	35	30	M 12	4.0
MSM120	120	105	225	180	65	148	48	30	M 12	6.6
MSW100	100	85	185	154	64	125	32	30	M 12	4.9

MSL - Light machine vices
for the ambitious do-it-yourselfer. Base made of machine casting, jaws and spindle made of steel, with practical and captive insert-through locking handle.



MSL

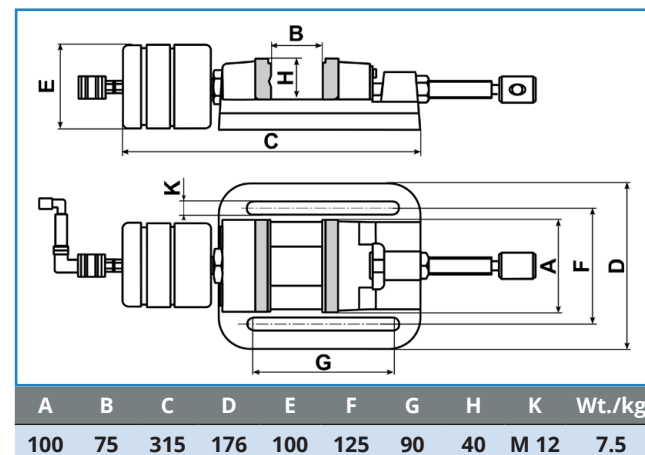
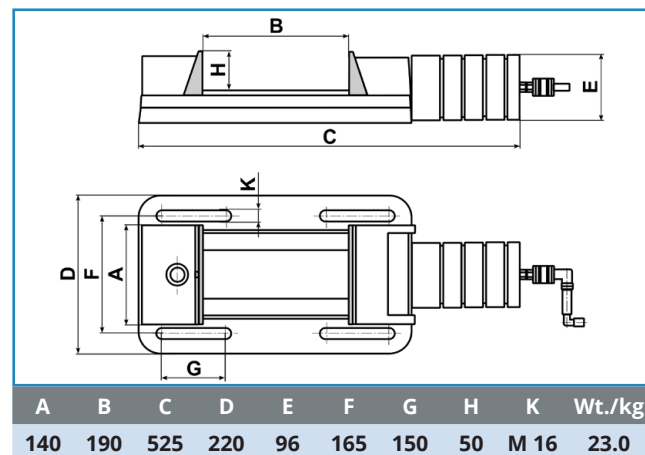


	A	B	C	D	E	F	G	H	K	Weight (kg)
MSL 63	63	65	125	105	43	80	45	25	M 8	1.2
MSL 80	80	85	150	130	45	100	60	25	M 12	1.7
MSS 63	63	65	225	98	52	80	50	25	M 8	0.8
MSS 80	80	80	240	115	52	95	60	25	M 8	0.9

Pneumatic vices for working safely and efficiently in serial production, operation by means of hand- or optional foot valve. Controllable for automatic operations via drilling or tapping machine, or when using feeding systems for material handling. Attention: only for lubricated compressed air!

MSD 100 Clamping force adjustable up to max. 6,000 N at 7 bar. Fast adjustment of span width because of self-locking and additionally lockable trapezoidal threaded spindle.

MSD 140 Strong and precise vice equipped with pull-down jaws, clamping force adjustable up to max. 11,000 at 7 bar. Adjustment of span width via fixed jaw, which engages into base toothing.



Spindle made of machinery steel, zinc coated and chromated. Body made of precision steel tube, blue coated, RAL 5012. Fast height adjustment with Allen key. Self-locking metric thread for fine adjustment of height. Stacked applicable. Thread M16 in base of screw jack.

Available as set with transport cart or individually, see table.

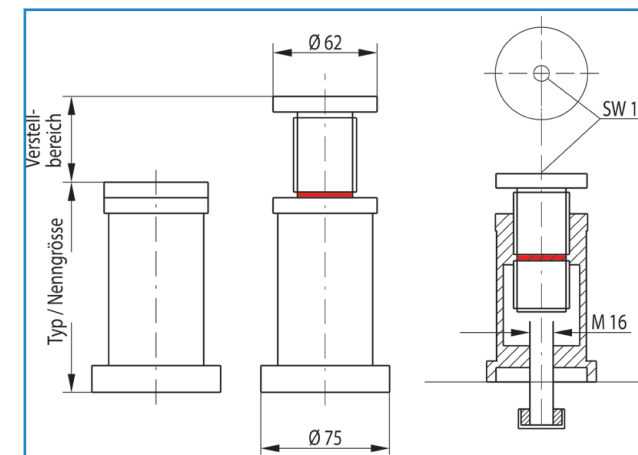
Transport cart with each 4 screw jacks of types MB 125, MB 175, MB 275, MB 400 and MB 525. Dimensions: 500 x 800 x 1,050 mm



Clamping example



Transport cart



MB	adjusting range (mm)	load capacity (kN)
MB 125	125 - 175	58
MB 175	175 - 275	58
MB 275	275 - 400	58
MB 400	400 - 525	58
MB 525	525 - 650	50
MB 650	650 - 775	35
MB 775	775 - 900	26
MB 900	900 - 1,025	20

Feed units PV



Pneumatic-hydraulic feed unit for productive, semi-automatic drilling up to 12 or 16 mm drilling capacity. Stepless adjustable automatic feeds.

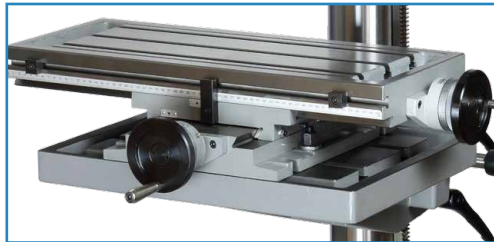
As option also available with retention time at drilling ground and chip breaking function/foot switch for feed start.

Working cycle:

- 1. Rapid feed to workpiece
- 2. Drilling with constant, stepless feed rate
- 3. Rapid return to start position

Technical data	PV 12	PV 16
max. spindle travel	UNIMAX 1 - 78 mm	BT 15/18/20 - 78 mm
max. feed rate	3,000 mm/min	2,300 mm/min
max. compound power at 5 bar	2,100 N	3,300 N
max. compound power at 6 bar	2,500 N	4,000 N
max. compound power at 7 bar	3,000 N	4,800 N
Repetition accuracy of the spindle	0.1 mm	0.1 mm
Air consumption	1.2 l per stroke	1.8 l per stroke

Cross tables



Cross tables
For approaching X / Y positions. Clamping device for both axes. Division on scale ring: 0.05 mm

Digital display table axes
Optional for: MF - 2, MF - 3, MF - 4

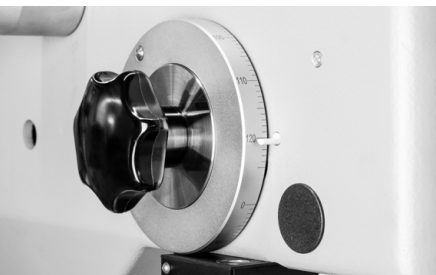


Digital display

Techn. data	MF-0	MF-2	MF-3	MF-4
for machines	UNIMAX 1	BT 6, UNIMAX 2	BT 20, UNIMAX 2 / 3	BT/BS 36, BS 50, UNIMAX 4
Table surface	230 x 164 mm	430 x 240 mm	600 x 240 mm	800 x 240 mm
X / Y traverse	120 / 110 mm	240 / 160 mm	350 / 160 mm	470 / 245 mm
Weight	16 kg	57 kg	74 kg	110 kg
X axis motorized	—	—	Option	Option

Technical information

Drilling depth stop



Star knob control



Automatic feed is easily switched on/ off by pushing the feed lever slightly in- or outwards.
For machines with tapping unit the rotating direction is changed when pushing the feed lever.

Quick-release drill chuck

1 - 13 mm
3 - 16 mm



Tap holder

GSIP-0 for M3-M10
GSIP-1 for M8-M18
incl. taper MT...



Drill chuck taper

MT 1 - 5



Milling chuck

ER 32



Collet chuck ER 32



Clamping range 3 - 20 mm

Milling chuck HW 3 - 25



With 15 collet chucks 3 -20 mm in the box

Die holder

Picture including intake and die



For dies MT 2 or MT 3, corresponding die holder necessary!

Die cutter intake



For various dimensions

Lead screw



For various tapping sizes

Quick-release chuck



MK2 oder MK 3
M3-M12, M6-M20 or M14-M33

Quick-change insert



Gr. 1, Gr. 2 and Gr. 3

Multi spindle heads
Revolving drilling heads

On request



LED Machine light



24 V / 230 V, 3 W

Floor unit ECOMAX 14



600 x 700 x 840mm, 60kg

Floor unit

BT6 / BT36 / UNIMAX



BT 6
300x470x760mm 40kg
UNIMAX 3T / BT 36
400x690x720mm 65kg
UNIMAX 2T / BT 20
345x602x730mm 45kg

Drill Packages



Picture alike

Drill Package 1

1 drill chuck taper	MT 2 / B 16
1 reduction insert	MT2 / MT1
1 machine vice	MSP 80
1 quick-release drill chuck	1 - 13 mm / B 16

Drill Package 2

1 drill chuck taper	MT 2 / B 16
1 reduction insert	MT2 / MT1
1 machine vice	MSP 120
1 quick-release drill chuck	3 - 16 mm / B 16

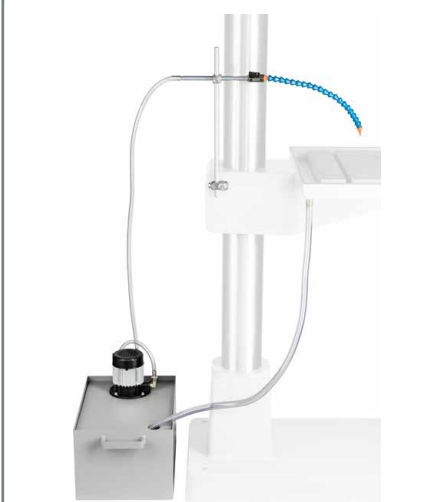
Drill Package 3

1 drill chuck taper	MT 3 / B 16
2 reduction inserts	MT3 / MT2, MT3 / MT1
1 machine vice	MSP 140
1 quick-release drill chuck	1 - 16 mm / B 16

Drill Package 4

1 drill chuck taper	MT 4 / B 16
3 reductions inserts	MT4 / 3, MT4 / 2, MT4 / 1
1 machine vice	MSP 140
1 quick-release drill chuck	1 - 16 mm / B 16

Electric cooling unit



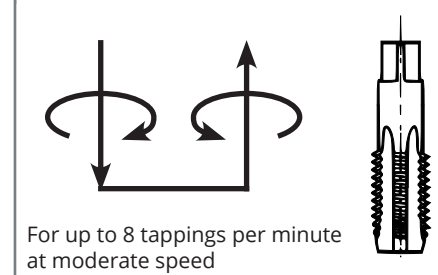
With provided 20 litre coolant tank including pump, pipe connections, flexible outlet and shut-off valve

Cooling unit



in baseplate with T-slots for BS 36, BS 50, UNIMAX 4 Basic / Basic + and UNIMAX 4 (controlled)

Tapping unit



For up to 8 tappings per minute at moderate speed

Flanged quill



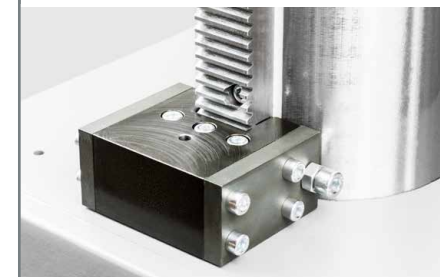
RAL - special colours



Foot impulse switch



Security against torsion



3 automatic feeds (fixed steps) for drilling



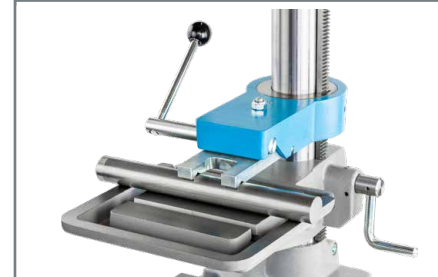
Table adjustment on front side



Height adjustment on front side



MKF Quick clamping device

LCD for drilling depth
LCD for drilling depth programmable

Extended column

200 mm for bench machines
100 mm for column machines
Other lengths on request.

Minimum quantity lubrication system

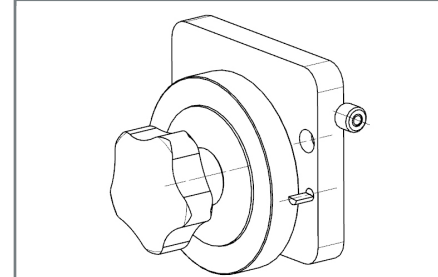


Including 1.2 l storage tank and activation, also available with multiple nozzles (flexible or rigid).

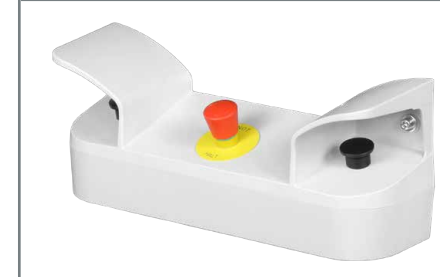
Motorised height adjustment



Drilling depth with fine adjustment



Two-hand start



Chip tray



Motorised height adjustment



Including safety stop in end position, manual clamping

Fine adjustment cam for tapping depth only for H15GL



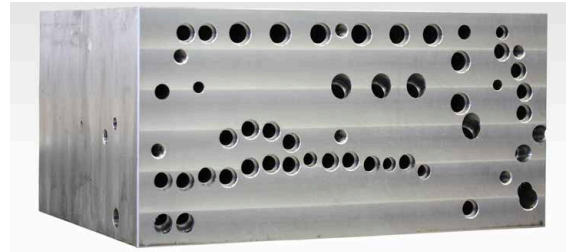
Further or individual options and accessories on request

More than 20 years experience in deep hole drilling

- Manufacturing of hydraulic - and temperature control circuits, as well as every other kind of deep hole drilling
- Angular drillings in two angles
- Machining of different tool shapes and materials
- Highly demanding machining, also for materials with difficult machining characteristics
- Most modern data acquisition and -processing (IGES, CATIA V5, STEP)
- Customer-specific special solutions can be realized in short-term
- Extensive tool stock guarantees short-term processing time

Deep hole drilling, CNC-milling, -turning and -cylindrical grinding

The expert for deep hole drilling in Thuringia



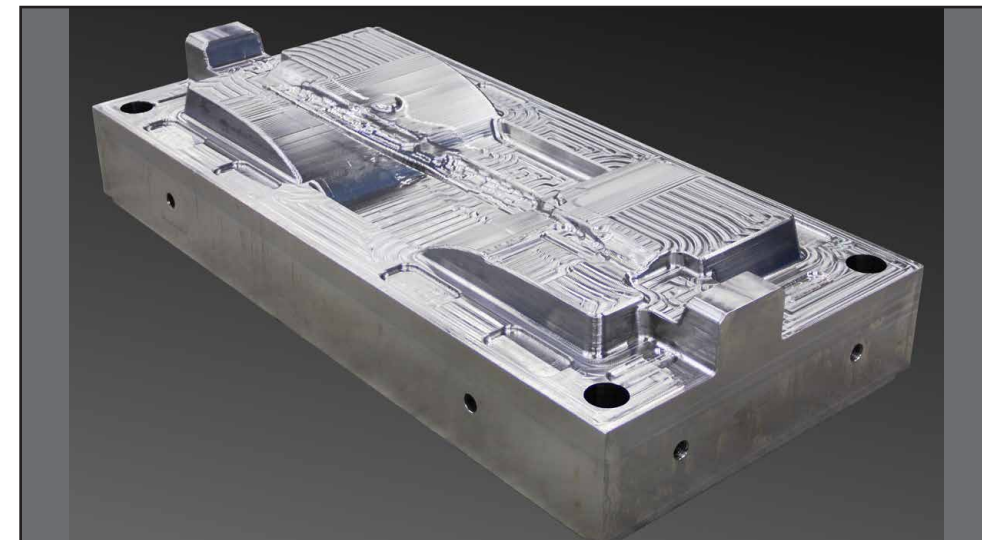
DEEP HOLE DRILLING:

- **Drilling capacity:**
3.0 mm - 36 mm
- **Maximum travel**
X 2,000 mm
Y 1,100 mm
Z 2,000 mm
- **Maximum weight**
12 t
- **Maximum drilling depth**
1,900 mm from one side



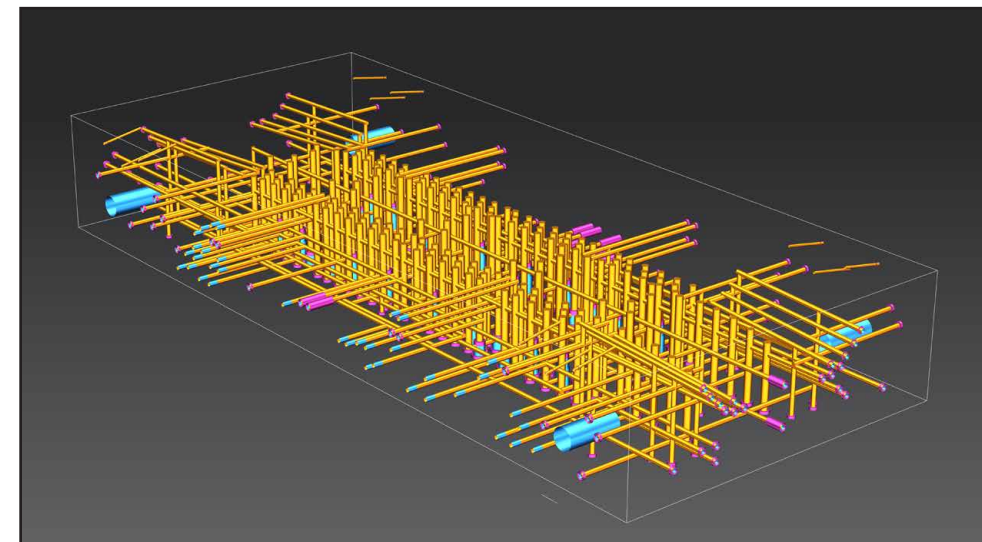
MILLING:

- **Maximum dimensions**
X 3,000 mm
Y 1,700 mm
Z 850 mm
- **Maximum weight**
7 t
- **Range of application**
Pre-roughing of 3D contours
Face milling
Pocket milling
Slot milling
Column drillings



GENERAL:

- **Range of application**
Glass moulds
Injection moulding tools
Moulding dies
Die-cutting tools
- **Materials**
Steel (up to 45 HRC)
Stainless steel
Aluminium
Copper
Brass
PVC
Cast iron
Hastelloy
Densimet
Inconel
Titan



fast, precise, cost-effective

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Feel free to ask for spare parts for your
MAXION and IXION machines.
We maintain for you an extensive stock of spare parts.

service@maxion.de
+49 3647 4106-18



Head Office

Tel:	+49 3647 4106-0	email:	info@maxion.de
Fax:	+49 3647 415800		

Drilling machines; Special purpose machines

Tel:	+49 3647 4106-16	email:	verkauf@maxion.de
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Service, Spare Parts, System Machines

Tel:	+49 3647 4106-18	email:	service@maxion.de
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International Sales

Tel:	+49 3647 4106-36	email:	sales@maxion.de
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Shipping

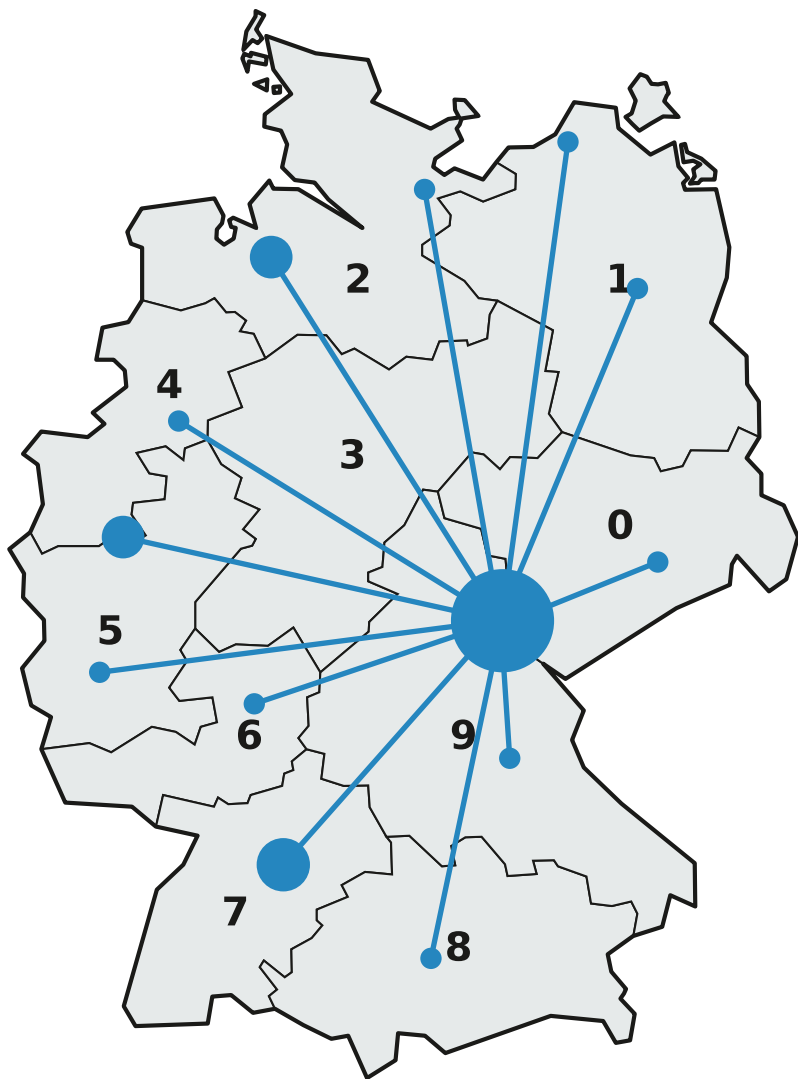
Tel:	+49 3647 4106-17	email:	koch@maxion.de
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Deep Hole Drilling/Commission Processing

Quotations, Organisation	phone:	+49 3647 4106-48
	fax:	+49 3647 4106-33
	email:	ludwig@maxion.de
Data processing	phone:	+49 3647 4106-45
	fax:	+49 3647 4106-33
	email:	fertigung@maxion.de

Shipping standards

CE	Following EU-Machinery Directive.
Colour	Machine grey RAL 7037, machine cover blue 5012, special colour against additional charge.
Electricity	230 / 400 V 50 Hz 3-/5- conductor net. Special electrical system against additional charge. All machines delivered with a 3 m connecting cable and CEE-plug-5 pole/shock-proof plug.
Drill guard	All machines are serially equipped with electrically secured drill guard.
Safety	Machines with fixed rpm steps are serially equipped with automatic spindle stop and anti-restart protection



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dealer network we are able to solve
your service cases in a short time.
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antees short access time. We can
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all MAXION machines as well as
for many IXION drilling machines.
Even when your machines are old-
er than 30 years, please feel free to
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07381 Pößneck/Thuringia
Germany
Tel.-Nr. +49 3647/4106-18

Delivery conditions and warranty

We are delivering according to VDW 502, latest edition, ORGALIME General Conditions SE 2001 latest edition,
and to our standard business conditions. Non-obligatory guide prices, VAT and packing excluded. Delivery
ex works. Warranty period in Germany two years, apart from wearing parts. Changes and errors excepted.

MAXION®

Jänsch & Ortlepp GmbH

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Changes and errors excepted.
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