

Circulation water supply



Product information

The stainless steel water container with two chambers collects the cooling water and returns it to the system with steady pressure ready for drilling and undercutting with diamond tipped façade drill bits.

- ▶ The bore dust will settle due to the two chamber system. The filter makes clean cooling water available at all times. The filter control will indicate, if the filter needs cleaning resp. changing.
- ▶ The strong, industrial pump will ensure a constant supply pressure, even if several drilling machines are connected.
- ▶ Usage of the cooling lubricant 532 500 035 will prolong the life time of the diamond tipped façade drill bit significantly and protect the metal parts covered in cooling water from corrosion.

Volt	Hertz	article no.
400 V, 3~	50 Hz	532 800 010

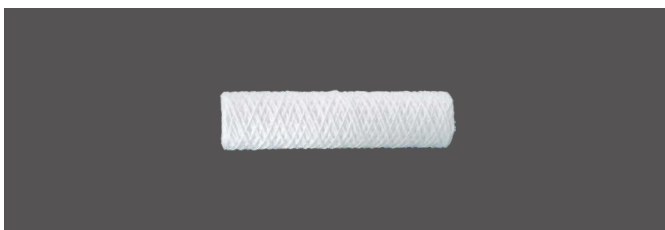
Usage

- ▶ Circulation water supply for one / several KEIL undercut drilling machines.

Design

- ▶ Stainless steel two-chamber water container
- ▶ Strong industrial pump
- ▶ Filter control
- ▶ incl. Fu switch and Y connector

Filter cartridge



suitable for	article no.
circulation water supply	532 870 020

Possible applications

- ▶ Filter for the circulation water supply

Water pressure tank



Product information

- ▶ Portable stainless steel pressure tank for the cooling water supply during drilling and undercutting with diamond tipped façade drill bits.
- ▶ The tank can not only be connected to the manual pump, but also to a compressed air supply, keeping the water pressure constant from the first up to the last drop.
- ▶ Water pressure should be set to more than 4 bar.

suitable for	article no.
KSDV / KRDV / KRT	532 500 032

Usage

- ▶ Circulation water supply for one KEIL undercut drilling machine.

Design

- ▶ Portable stainless steel pressure tank 10 l
- ▶ With manual pump and connector for pneumatic line.

Collecting tray for KRT



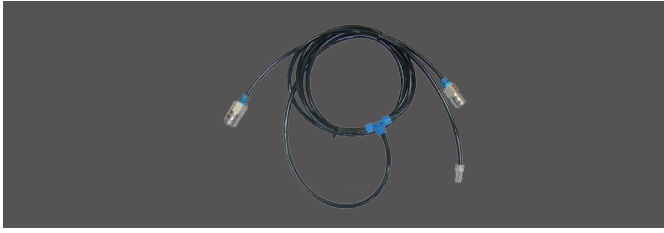
suitable for	article no.
KRT	532 800 027

Design

- ▶ Tray for collecting the cooling water.
- ▶ Stainless steel.
- ▶ Dimensions: 1,420 x 655 x 40 mm
- ▶ With hose connector.

INTERESTING FACTS
 ASSEMBLY INSTRUCTIONS
 UNDERCUT ANCHORS
 FIXING DEVICES
 DRILLING TOOLS
 DRILLING TECHNIQUE
 ASSEMBLY AIDS
 GENERAL INFORMATION

Air connector



suitable for	article no.
1 x 532 500 032	532 800 023

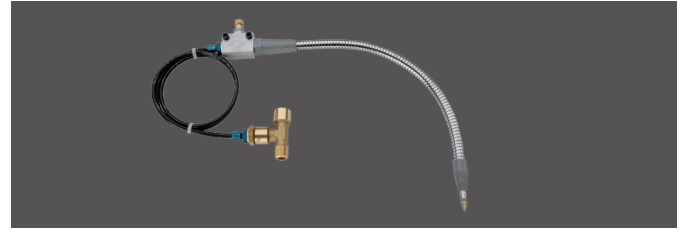
Usage

- ▶ Connecting hose (T-piece) for simultaneously connecting a water tank and a machine to a compressed air supply.

Design

- ▶ Compressed air hoses with T-piece, 2 clutches and one plug

Blow out nozzle for KSHV



suitable for	article no.
KSHV	532 500 106

Usage

- ▶ Nozzle for air ejection with cooling effect during drilling

Design

- ▶ Flexibly adjustable nozzle head.
- ▶ Control for discharge pressure.

Cooling lubricant



Product information

- ▶ KEIL recommend usage of cooling lubricant in addition to the cooling water. This is an anticorrosive additive, which is added to the cooling water (approx. 2 %)

Advantages:

- ▶ The machine parts covered in cooling water are protected from corrosion, which can significantly prolong the lifetime of the diamond tipped façade drill bits, especially when used for very hard and dense panel materials (e.g. fine porcelain stoneware).

variant	article no.
5l	532 500 035

Usage

- ▶ Anticorrosive additive for cooling water.

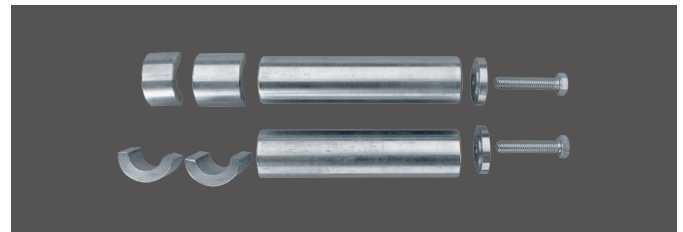
Design

- ▶ SK 88

Instructions for use

- ▶ Check the tolerance of the cooling lubricant to the panel material before use.

Conversion set KRT "Front face related drilling"



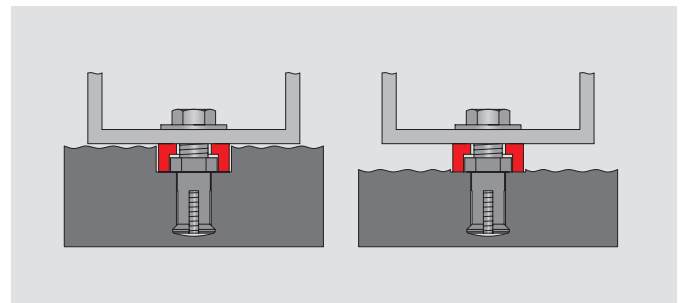
suitable for	article no.
KRT	532 500 135

Design

- ▶ For panel thicknesses 20 and 30 mm.

Note

- ▶ Necessary for front face related drilling for balancing tolerances in panel thickness with the KEIL drilling table with roller conveyor KRT.



Drilling unit KG



Volt	Hertz	article no.
230 V, 3~	37.5–150 Hz	532 200 055

Usage

- ▶ For drilling and undercutting.

Possible applications

- ▶ With KEIL diamond tipped façade drill bits.

Instructions for use

- ▶ Usage of the cooling lubricant 532 500 035 (p. 49) will prolong the life time of the diamond tipped façade drill bit significantly and protect the metal parts covered in cooling water from corrosion.

Design



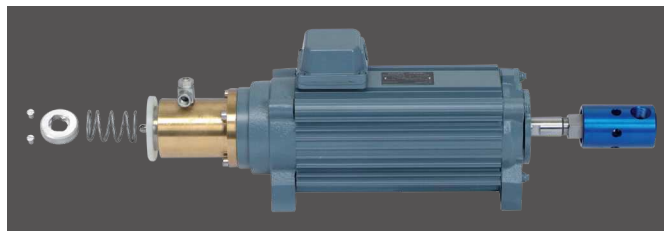
- ▶ For automatic drilling machines incl. water supply and pneumatic drill feed.

- ▶ Dimensions: 220 x 690 x 400 mm

Notes

- ▶ 2,100–8,730 rpm. (HM approx. 2,100 rpm; Dia approx. 7,000 rpm.)
- ▶ Driven via frequency converter (not included in delivery).

Undercut unit HSE



Product information

- ▶ The KEIL undercut unit for drilling plants is the optimal automated unit for drilling and undercutting.
- ▶ Nearly all available drilling and milling systems can be retrofitted with this unit.
- ▶ The undercut unit will receive the diamond or carbide tipped façade drill bit, depending on the panel material.
- ▶ As soon as the preselected drilling depth has been reached, the drill head will be pneumatically deflected for undercutting. When the diamond tipped façade drill bit is in use, water will be supplied centrally through the shaft.
- ▶ The KEIL undercut unit is carried by the carriage of the machine with frequency controlled engine, allowing for the engine's rotational speed to be adjusted to drilling with the carbide tipped façade drill bit (approx. 2,000 rpm) or with the diamond tipped façade drill bit (approx. 7,000 rpm).

Volt	Hertz	article no.
230 V, 3~	37.5–150 Hz	532 200 023

Usage

- ▶ For drilling and undercutting

Possible applications

- ▶ With KEIL diamond tipped façade drill bits.

Suitable drilling tools

- ▶ Diamond tipped façade drill bit (p. 28, 32)
- ▶ Diamond tipped façade drill bit with countersink (p. 29, 33)

Spare parts

- ▶ Chuck HSE
- ▶ Flushing head HSE
- ▶ Fastener set 2
- ▶ Fastener set 3

Design



- ▶ For drilling plants with flushing chuck
- ▶ Dimensions: 500 x 110 x 170 mm

Notes

- ▶ 2,100–8,730 rpm.
- ▶ Driven by frequency converter (not included in delivery)

Control for drilling unit KG



suitable for	article no.
1 x 532 200 055	532 200 051
2 x 532 200 055	532 200 052

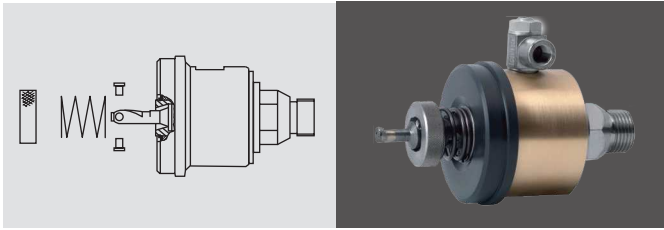
Usage

- ▶ SPS control incl. touch panel and frequency converter for drilling unit KG.

Design

- ▶ For controlling the drilling unit KG.

Chuck P



Product information

- ▶ The chuck can be attached to any available drilling or milling plant (mount according to customer's demand).
- ▶ Several connection requirements have to be fulfilled for the KEIL chuck P with pneumatic deflection to be mounted to existing machines.
- ▶ The rotational speed of the shaft must be approx. 6,000–7,000 rpm. for water cooled drilling with the diamond tipped façade drill bit and approx. 2,000 rpm for drilling with the carbide tipped façade drill bit. Bearing at zero clearance and flawless running of the drill shaft are requirements for a precise undercut and a long lifetime of the façade drill bits. Locking in the different feed directions is required as well.
- ▶ For drilling with the diamond tipped façade drill bit, water is supplied through the drill shaft (water pressure > 4 bar). We recommend the use of a water filter in order to avoid possible water outages, which may lead to unsoldering of the diamond surface.

To be carried out by the customer:

- ▶ Screwing chuck in or inserting it into the collet chuck.
- ▶ Mounting spin-lock for chuck.
- ▶ The chuck can be controlled either mechanically or programme controlled, depending on the machine. For the mechanical control, a KEIL pneumatic unit has to be mounted, which is controlled by an end switch for starting the undercutting process.

variant	article no.
R 1/2"	581 000 023

Usage

- ▶ For drilling and undercutting.

Possible applications

- ▶ With diamond tipped KEIL façade drill bits.

Instructions for use

- ▶ Usage of the cooling lubricant 532 500 035 (p. 49) will prolong the life time of the diamond tipped façade drill bit significantly and protect the metal parts covered in cooling water from corrosion.

Accessories

- ▶ Fastener set 2 (p. 53)
- ▶ Fastener set 3 (p. 53)

Design

- ▶ Chuck for mounting to suitable drilling / milling / CNC machines.
- ▶ Pneumatic deflection of the façade drill bit.
- ▶ Drive R 1/2"
- ▶ Water supply through shaft
- ▶ For drilling plants
- ▶ With integrated support and throttle check valve.
- ▶ Façade drill bit not included.

Transport case for KSDV, KSHV, KR DV

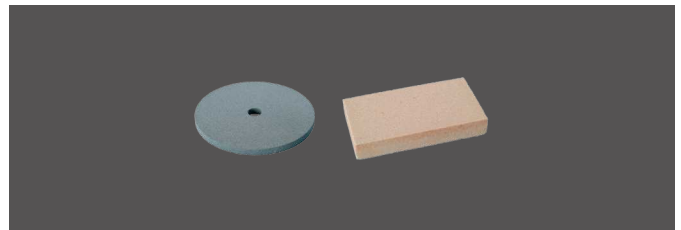


suitable for	article no.
KSDV / KSHV / KR DV	532 500 120

Application

- ▶ Sturdy wooden case for transport and storage.

Whetstones



variant	suitable for	article no.
Ø 175 x 10	e.g. fine porcelain stoneware	532 110 351
155 x 82 x 25	e.g. natural stone	532 110 352

Application

- ▶ For whetting diamond tipped façaded drill bits.

Main Point Karlin, Prag, CZ, Ditz Fejer © Rieder Group

