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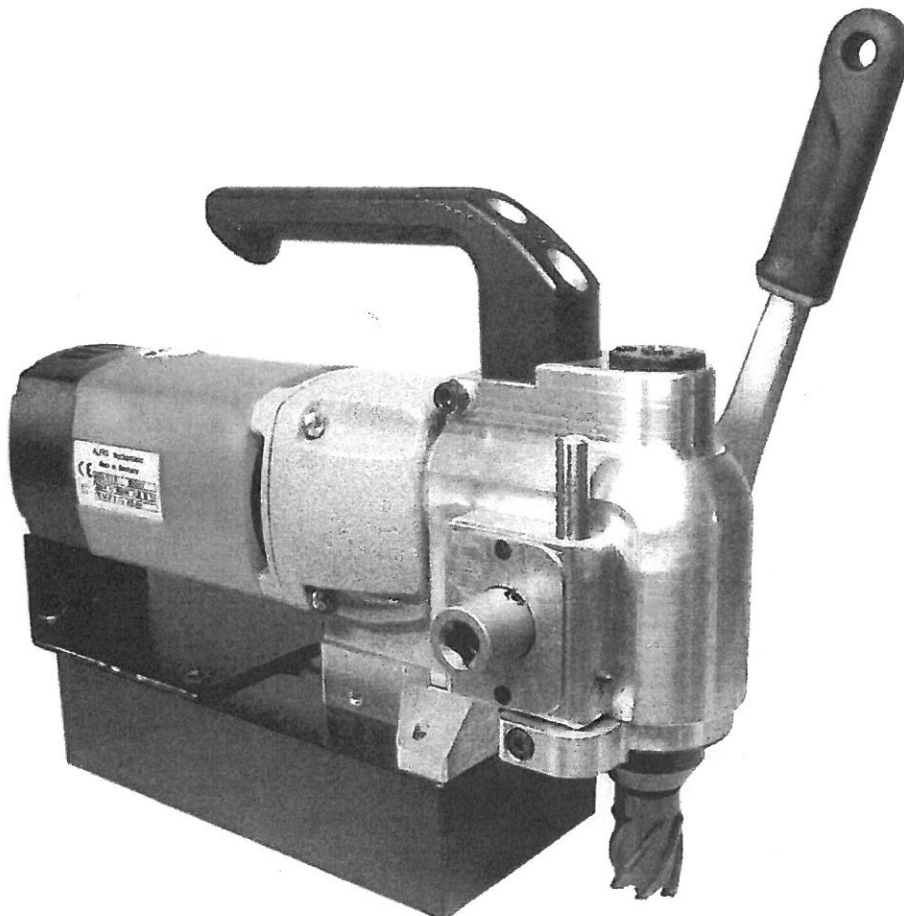
ENTGRATEN

***Bedienungsanleitung / Operation  
Instructions / Manuel d'utilisation /  
Manual de instrucciones***

**ALFRA ROTABEST V32**

- DE** Winkelbohrmaschine
- GB** Angular Metal Core Drilling Machine
- FR** Perceuse d'angle pour métaux
- ES** Taladro magnético de broca hueca para metal

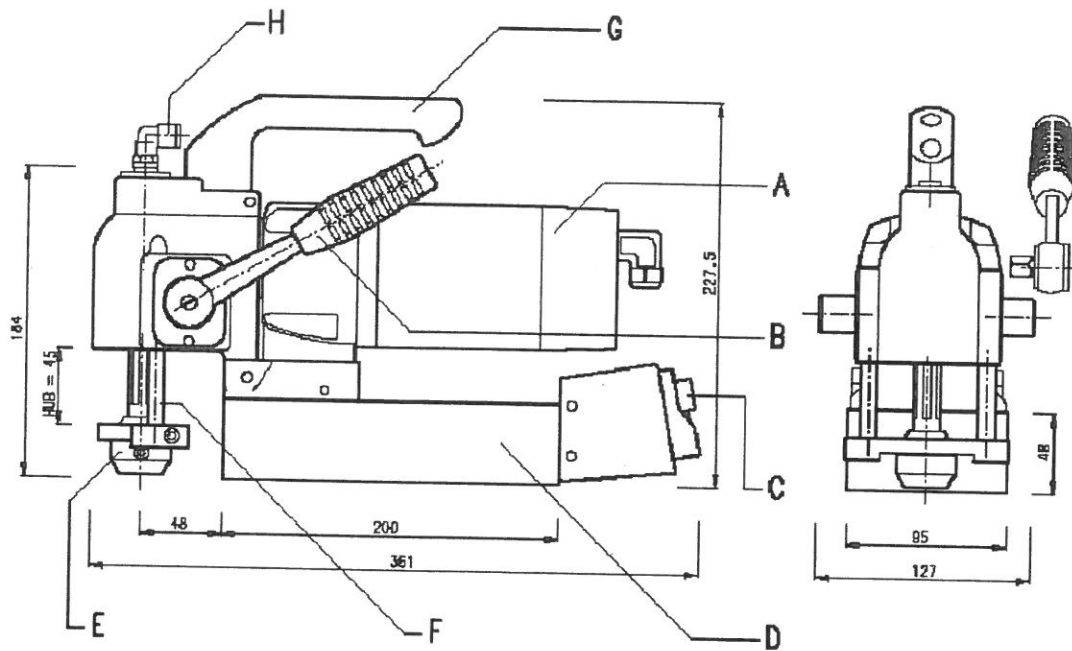
Artikel Nr. 18710 / Prod.-No. 18710 / N° de produit 18710 / Artículo n.º 18710



## Technical Data

Prod. – No.:	18710
Name:	ALFRA Rotabest Angular Metal Core Drilling Machine V 32
Input:	900 Watt
Load rpm:	450 rpm
Tool holder:	19 mm Weldon
Coolant supply:	internal, automatically through the spindle
Voltage:	230 V
Magnetic Adhesion:	16000 N
Drilling performance core drills:	12 – 32 mm
Cutting Depth:	25 mm
Operational range:	227 / 1895 mm
Size of Magnet Foot:	90 x 200 mm (rigid)
Weight:	12,5 kg

## Description

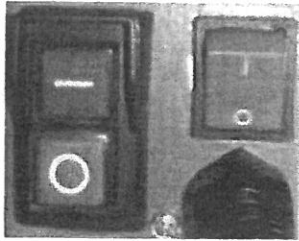


- |  |   |
|--|---|
| A) Motor   | E) Weldon shank   |
| B) ratcheted wrench for pre and return stroke, adjustable left and right | F) rack for pre and return stroke   |
| C) Control panel   | G) Handle<br>by taking off the handle the total height can be reduced to 185 mm |
| D) Magnet foot   | H) Connection for coolant hose, movable   |

## Standard scope of supply

- 1 coolant pressure bottle with hose and nipple
- 1 Transport case
- 1 allen wrench for weldon tool holder
- 1 Safety Belt
- 1 HSS Co core drill  $\varnothing$  18 mm, cutting depth 25 mm
- 1 ejector pin 6.35 x 70 mm (art.-no. 1924500)
- 1 Manual Book

## Switching on and off



- Check connecting line and plug on damages first.
- Push the button MAGNET ON so that the magnet adheres and the grip of the drill stand is ensured.



**When drilling in a material thickness less than 6 mm, a steel plate of appropriate thickness has to be placed underneath the workpiece to ensure the full magnetic adhesive force of the magnet foot.**

- For non-magnetisable materials use the Rotabest Vacubest (Prod.-No. 18150).
- When working on walls and ceilings secure the machine with the safety belt.  
At this work we recommend cooling the tool with a spray. For example Alfra BIO 4000, prod. No. 21040.
- Push the green button to start the motor.



- To switch off the machine proceed in reverse order, MOTOR OFF and then MAGNET OFF.

First push red button on the left

then push red button on the right



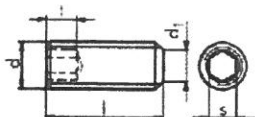
## How to work with core drills

- Push ejector pin (center pin) through head of the annular cutter.



**Only use injector pins, prod. No. 1924500, 6.35 x 70 mm.**

- Core drills with Weldon shank are tightened with clamping screws (DIN 913) on both clamping surfaces.



- First place core drill with ejector pin on a marked centre or marking.
- Set the cutter and spot-drill, until the entire cut edge is formed as a circle.
- During the drilling process, cool the core drill permanently using the coolant pressure bottle and suitable coolant.



**Keep coolant fluid away from switch box.**

- Do not switch off the motor during drilling . Pull back the core drill with running motor after the drilling process .
- Remove chips and core after each drilling.



**Remove chips with Chip-Remover. Do not touch with bare hands. Danger of injury!**

### Cleaning and care



**Pull plug prior to cleaning. Danger of injury by unintentional switching on.**

- Check connecting lines on damages.
- Clean and oil side guide racks regularly.
- Carbon brushes should be replaced after appr. 250 hours running time.
- After the work is finished we recommend to store the metal core drilling machine in the transport case.

### Maintenance and repair

Maintenance, checks and repairs are only to be made by electronic specialists according to the valid regulations of the respective country.



**Only use genuine ALFRA spare parts.**



**Spare part list at the end of this operation manual.**

The metal core drilling machine Alfra Rotabest should be serviced after appr. 250 hours running time by our Alfra workshop or appointed dealers.

## **CE Declaration of Conformity**

Herewith we

Alfra GmbH  
2. Industrie Str. 10  
68766 Hockenheim

declare that the Metal Core Drilling Machine

### **ALFRA Rotabest V32**

corresponds to the following standards:

Machine standard: 2006/42/EG  
Low voltage standard: 2006/95/EG  
Electro-magnetic compatibility (EMC): 2004/108/EG

Following standards or standard documents were applied:

EMC- standard:  
EN 55014-1:2006  
EN 55014-2:1997+A1:2001  
EN 61000-3-2:2006  
EN 61003-3-3:1995+A1:2001+A2:2005

Authorized for the compilation of the documents:

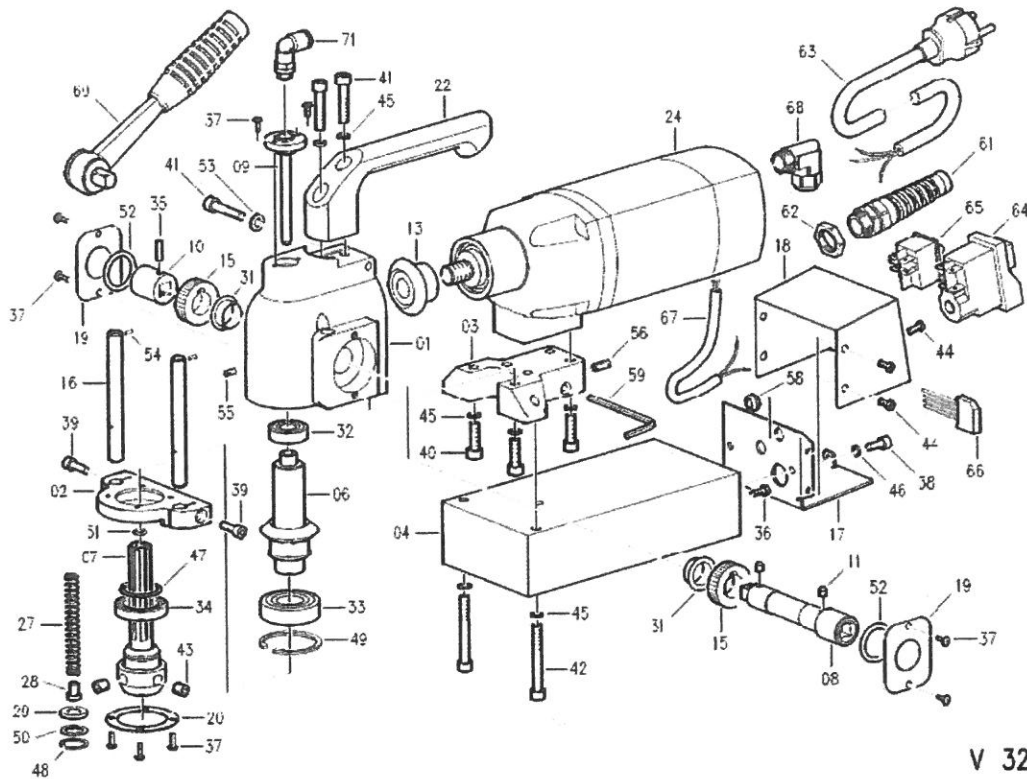
Alfra GmbH  
2. Industriestr. 10  
68766 Hockenheim, Germany

Hockenheim, 03.04.2017



**Markus A. Döring**  
(Managing Director)

Explosionszeichnung / Exploded drawing / Vue éclatée



V 32

Stückliste / Parts list / Liste des pieces

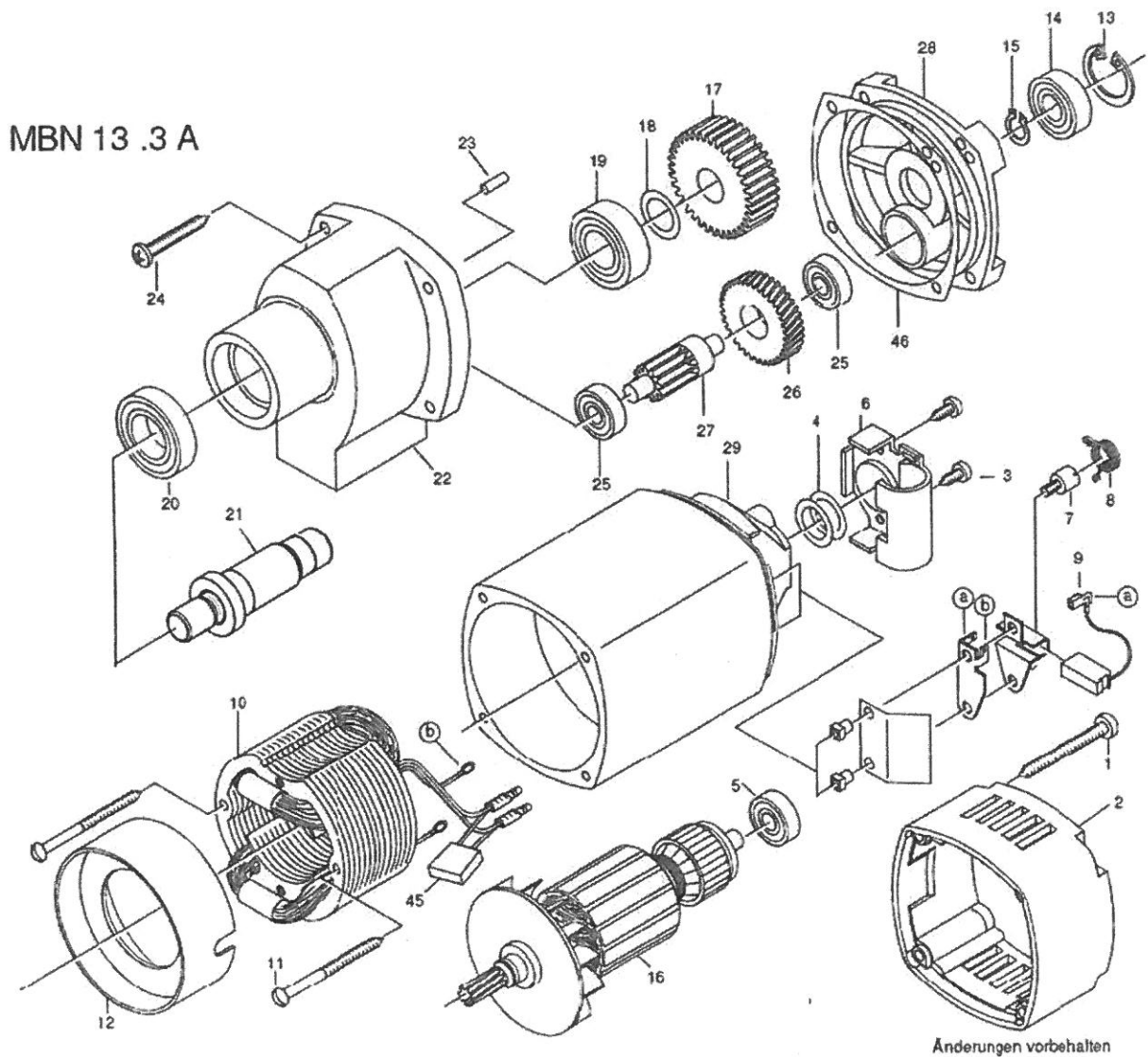
Pos.	Art.-Nr.	St.	Beschreibung	Description
01	189201001	1	Gehäuse	housing
02	189201002	1	Bügel	bail
03	189201003	1	Sockel	socket
04	189411028	1	Magnetfuß	magnet food
05				
06	189201004	1	Getriebewelle	shaft
07	189201005	1	Keilwelle	spline shaft
08	189201006	1	Welle 4kt 3/8"	arbor
09	189201007	1	Kühlmittelrohr	cooling unit tube
	189201007B		Kühlmittelrohr	cooling unit tube
10	189201008	1	Hülse 4kt 3/8"	bushing
11	189201009	2	Stift	set screw
12				
13	189201010	1	Kegelrad 1	pnion
14				
15	189201011	2	Zahnrad	gear
16	189201012	2	Zahnstange	rack
17	189201013	1	Grundblech	base plate
18	189201014	1	Blechhaube	plate
19	189201015	2	Deckungsblech 1	cover plate 1
20	189201016	1	Deckungsblech 2	cover plate 2
21				

22	189201017	1	Handgriff	handle	
23					
24	18215	1	Bohrmaschine 230 Volt	drilling machine	
25	18215.110		Bohrmaschine 110 Volt	drilling machine	
26					
27	189201018	1	Druckfeder 2	pressure spring 2	
28	189201019	1	Kolben	cock	
29	189201020	1	Scheibe	disc	
30					
31	189201021	2	Gleitlager	bushing bearing	
32	189201022	1	Rillenkugellager	grooved ball bearing	DIN 625-6001 2RSR
33	189201023	1	Rillenkugellager	grooved ball bearing	DIN 625-6004 2RSR
34	189201024	1	Rillenkugellager	grooved ball bearing	DIN 625-61805 2RSR
35	189160416	1	Spannstift	dowel pin	DIN 1481-4x16
36	189120410	1	Zylinderschraube	cylinder head screw	DIN 84-M4x10-Ms
37	189140308	10	Linsenschraube	lens head srew	ISO 7380-M3x8
38	189140512	2	Zylinderschraube	cylinder head screw	DIN 7984-M5x12-8.8
39	189010516	2	Zylinderschraube	cylinder head screw	DIN 912-M5x16-8.8
40	189010620	6	Zylinderschraube	cylinder head screw	DIN 912-M6x20-8.8
41	189010630	3	Zylinderschraube	cylinder head screw	DIN 912-M6x30-8.8
42	189010650	3	Zylinderschraube	cylinder head screw	DIN 912-M6x50-8.8
43	189621036	2	Gewindestift	set screw	DIN 913-M8x8-45H
44	189090410	5	Linsenschraube	lens head srew	ISO 7380-M4x10- 10.9
45	189060006	11	Federring	lock washer	DIN 7980-B6-FSt
46	189060005	2	Federring	lock washer	DIN 7980-B5-FSt
47	189201025	1	Sicherungsring	circlip	DIN 471-25x1.2
48	189621037	1	Sicherungsring	circlip	DIN 472-19x1
49	189201026	2	Sicherungsring	circlip	DIN 472-42x1.75
50	189311011	1	KUPFERRING	copper ring	19x13x1-Cu
51	189201027	1	O-Ring	o-ring	DIN 3770-7x2-NBR
52	189201028	2	O-Ring	o-ring	DIN 3770-17x3.5- NBR
53	189080006	1	Scheibe	disc	DIN 125-A6.4-140HV
54	189201029	2	Zylinderstift	cylinder shaft	DIN 7-2m6x6-St50K
55	189201030	1	Federndes Druckstück	resilient thrust piece	GN 615-M4-K-PFB
56	189201031	1	Federndes Druckstück	resilient thrust piece	GN 615-M6-K-PFB
57					
58	189201032	1	Durchführungstülle	grommet	DK-PVC 6/9/12-2
59	189480018	1	Sechskant-Stiftschlüssel	hexagon wrench key	DIN 911-4
60	189201033	1	Umschaltknarre 4kt 3/8"	ratchet wrench	
61	189490602	1	Kabelverschraubung	cable connexion	
62	189490601	1	Gegenmutter	locknut	
63	189480276	1	Anschlussleitung Euro	supply cable Euro	
	189480276GB		Anschlussleitung GB	supply cable GB	
	189480276UL		Anschlussleitung UL	supply cable UL	
	189480276CH		Anschlussleitung CH	supply cable CH	
	189480276AUS		Anschlussleitung AUS	supply cable AUS	
	189480276HO		Anschlussleitung HO	supply cable HO	



64	189411057	1	Motorschalter 230 Volt	motor switch 230 volt	
64	189411057.110		Motorschalter 110 Volt	motor switch 110 volt	
65	189411056	1	Magentschalter	magnet switch	
66	189411058	1	Gleichrichter 230 Volt	commutator 230 volt	
	189411058.110		Gleichrichter 110 Volt	commutator 110 volt	
67					
68	189490610	1	Winkel-Kabelverschraubung	cable connexion	
69					
70					
71	189201034	1	Winkel-Verschraubung	angle bolting	

**Explosionszeichnung Motor / Exploded drawing motor / Vue éclatée moteur**



Stückliste Motor / Parts list motor / Liste des pieces moteur

Pos.	Art.Nr.	St.	Beschreibung	Description	
1	189502002	4	Blechsschrauben 4,8x 50	screw 4,8 x 50	
2	189302002	1	Motorkappe	motor housing, compl.	
3	189302003	2	Blechschaube 4,2 x1 3	screw	
4	189302004	2	Passscheibe 16/22 x 0,5	washer	
5	189812011	1	Rillenkugellager 608 2Z	deep groove ball bearing 608.2Z	
6	189302006	1	Kondensatoren- aufnahme	condenser holde	
7	189302007	1	Federschraube	screw for feather	
8	189302008	1	Drahtformfeder	feather	
9	189302009	2	Kohlebürsten	carbon brush	
10	189302010	1	Feld 230 V	field, compl. 230 V	
11	189502043	2	Blechschauben 3,9 x 60	screw 3,9 x 60	
12	189302012	1	Luftleitring	fan shroud	
13	189601017	1	Sicherungsring 28/1,2	retaining ring	
14	189601018	1	Rillenkugellager 6001 2Z	deep groove ball bearing 6001.2 Z	
15	189502056	1	Sicherungsring 10/1	retaining ring	
16	189302016	1	Anker 230 V	armature, compl. 230 V	
17	189302017	1	Spindelrad	spindel gear	
18	189302018	1	Passscheibe 17/24x0,2	washer	
19	189302019	1	Rillenkugellager 6003.2.RS	deep groove ball bearing 6003.2RS	
20	189302020	1	Rillenkugellager 6904.2RS	deep groove ball bearing 6904.2RS	
21	189302054	1	Arbeitsspindel	motor spindle	
22	189302053	1	Getriebegehäuse	gear box	
23	189502011	1	Steckkerbstift 4x12	dowel pin	
24	189302024	4	Blechschaube 4,8x38	screw	
25	189502037	1	Rillenkugellager 608	deep groove ball bearing 608	
26	189302026	1	Zwischenrad	gear block 2	
27	189302027	1	Ritzelwelle	pinion shaft	
28	189302028	1	Getriebelagerschild	gear box flange	
29	189302029	1	Motorgehäuse kpl.	motor housing, compl.	
45	189502065	1	Entstörkondensator	interference capacitor	
46	189302051	1	Getriebedichtung	gear sealing	