

# Drill stands and clamping devices

Magnetic drill stand for conventional twist drilling machines and MobilCLAMP for magnetic drilling machines.

## EXPAND THE POSSIBILITIES OFFERED

## BY YOUR MACHINES



Magnetic drill stand

### Magnetic drill stand for manual drilling machines

With this practical magnetic drill stand, you can turn your manual drilling machine into a magnetic drilling machine.

The magnetic drill stand is suitable for commercially available manual drilling machines with 43 mm collar diameter.

The powerful magnet therefore allows safe work on a horizontal plane or overhead work (a safety lashing strap must also be used for these applications).

The slide has a working stroke of 180 mm.

#### Magnetic drill stand

##### Order no.

MBS 300

For commercially available manual drilling machines with 43 mm collar diameter,  
Stroke 180 mm



Industrial drill stand

### Industrial drill stand for manual drilling machines

Industrial drill stand for commercially available manual drilling machines with a 43 mm collar diameter.

Safe and stable thanks to cast base plate and slide with a working stroke of 180 mm.

Optional with drilling machine vice, 100 mm jaw width. Screws for T slots are also available for retention.

#### Industrial drill stand

##### ORDER NO.

ZBS 100.2

ZST 300 Prism vice

Screw for T slots

ZSM 100 Hexagon nut

Jaw width: 100 mm,  
Clamping range: 100 mm.

Vice and screws are not included in the scope of delivery.



MobilCLAMP – mobile work with magnetic core drilling machines

### MobilCLAMP for magnetic core drilling machines



The MobilCLAMP mobile clamping device has allowed the scope of application of a magnetic core drilling machine to be extended to the assembly line and workshop.

To this end, the magnetic core drilling machine is placed on the supporting surface and switched

on. Components can be securely clamped in the prism vice, and without having to expend a lot of effort you immediately have a flexible bench drilling machine.

#### MobilCLAMP

##### ORDER NO.

ZMC 200



# Adapters, drill chucks and accessories

For 19 mm direct arbor and morse taper MT 2 or MT 3.



1. Connect adapter to drill chuck.



2. Insert drill chuck into the direct arbor.



3. Ready for use for twist drills.

**Direct arbor**  
**19 mm Weldon (3/4")**



Adapter for drill chucks
<b>ORDER NO.</b>
ZAP 100
Weldon shank 19 mm (3/4") to 1/2" x 20 NF



Gear rim drill chuck			
ORDER NO.	INTERNAL THREAD	CLAMPING SIZE	
ZBI 113	1/2" x 20 NF	1 - 13 mm	
ZBI 116	1/2" x 20 NF	2.5 - 16 mm	



Quick-action drill chuck			
ORDER NO.	INTERNAL THREAD	CLAMPING SIZE	
ZSI 113	1/2" x 20 NF	1 - 13 mm	
ZSI 116	1/2" x 20 NF	3 - 16 mm	



1. Connect taper drift to drill chuck.



2. Insert drill chuck in MT arbor.



3. Ready for use for twist drills.

**Spindle taper**  
**MT 2 or MT 3**



Adapter for drill chucks
<b>ORDER NO.</b>
ZKD 216 DIN 238 - MT 2/B16
ZKD 316 DIN 238 - MT 3/B16



Gear rim drill chuck			
ORDER NO.	INTERNAL THREAD	CLAMPING SIZE	
ZBK 113	DIN 238-B16	1 - 13 mm	
ZBK 116	DIN 238-B16	2.5 - 16 mm	



Quick-action drill chuck			
ORDER NO.	INTERNAL THREAD	CLAMPING SIZE	
ZSB 113	DIN 238-B16	1 - 13 mm	
ZSB 116	DIN 238-B16	3 - 16 mm	



Ejector drift DIN 228		
ORDER NO.	SIZE	DIN STANDARD
ZAS 002	MT 2	DIN 228
ZAS 003	MT 3	DIN 228



Key for gear rim drill chuck	
ORDER NO.	
ZEZ 113	
ZEZ 116	



Chip protection	
ORDER NO.	MACHINE
ZSS 050	MAB 100 - MAB 525
ZSS 500	MAB 825 - MAB 855

## Safety lashing strap

<b>ORDER NO.</b>
40 0016 1

## Pump bottle

<b>ORDER NO.</b>
ZKP 100



Arbors  
and adapters

Accessories and  
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About BDS

# Carry case

For magnetic core drilling machines.

## EXTREMELY ROBUST

## YET LIGHTWEIGHT

- ▶ Portable – low weight coupled with high stability.
- ▶ Firmly locked – secure, large mechanical locks.
- ▶ Rolling instead of carrying – ABS wheels and telescopic handle.



### Hard-top case

ORDER NO.	SUITABLE FOR
ZHK 100	MAB 100K - MAB 155
ZHK 350	AutoMAB 350, AutoMAB 450
ZHK 400	MAB 455, MAB 465, MAB 485, MAB 525 incl. SB series
ZHK 800	MABasic 850

**Application:** Carry case for BDS magnetic core drilling machines.

**Design:** Sturdy hard shell case with handle and secure locks. With foam insert. No content.



### Carry case

ORDER NO.	SUITABLE FOR
ZPK 200	MABasic 200, 400, 450



### Carry case on wheels

ORDER NO.	SUITABLE FOR
ZHK 825	MAB 825, MAB 845

**Application:** Carry case on wheels for BDS magnetic core drilling machines.

**Design:** Sturdy transport case on wheels with handle and secure locks. No content.

### Carry case on wheels

ORDER NO.	SUITABLE FOR
ZHK 1300	MAB 1300
ZHK 1500	MAB 825 V/845 V/1300 V, MAB 825 KTS

**Application:** Carry case on wheels for BDS magnetic core drilling machines

**Design:** Sturdy transport case on wheels with handle and secure locks. No content.



BDS carry case for MAB 825/845. Machine not included in delivery!



# Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS category.

## DRILLING, COUNTERSINKING AND CUTTING QUICK AND SAFE

### Quick-change drill chucks and inserts for threads from M6 to M42

Magnetic core drilling machines of the ProfiPLUS category are ideal for thread cutting.

The basic requirements for this are: Clockwise/anticlockwise rotation, solid shaft control electronics and high motor output.

### Quick-change drill chucks

#### Sizes MT 2, MT 3 and MT 4

The large stroke range of the BDS magnet core drilling machines combined with the quick-change drill chuck allows quick and efficient working without having to realign and centre after changing tools. The quick-change drill chuck is designed for universal use when using quick-change inserts with and without a safety friction clutch.



### Version 1: Quick-change inserts with safety friction clutch

#### Thread from M6 to M42 –

BDS inserts with a safety friction clutch allow precise cutting of through-hole and blind-hole threads.

The safety friction clutch prevents the machine screw tap hitting the floor of the drill hole and shearing.

### Version 2: Standard quick-change inserts

Threads from M6 to M30 – BDS inserts for machine screw taps are suitable for accommodating machine screw taps for through-hole threads.



# Which machine, which thread?

Assignment of possible thread diameter to size of quick-change base holders and inserts.

## PRECISION WITH BDS SYSTEM ACCESSORIES

### Thread cutting systems

#### GSW quick-change drill chucks:

In MT 2, MT 3 and MT 4 versions.

To accommodate GSE or GSS quick-change inserts

GSW 222 size 2 MT 2

GSW 331 size 1 MT 3

GSW 332 size 2 MT 3

GSW 333 size 3 MT 3

GSW 442 size 2 MT 4

GSW 443 size 3 MT 4

GSW 444 size 4 MT 4



GSE standard quick-change insert  
Sizes 1, 2, 3



GSS quick-change insert with safety friction clutch  
sizes 2, 3, 4

#### ORDER NO.

GSW 222 quick-change drill chuck

GSW 331 quick-change drill chuck

GSW 332 quick-change drill chuck

GSW 333 quick-change drill chuck

GSW 442 quick-change drill chuck

GSW 443 quick-change drill chuck

GSW 444 quick-change drill chuck

GSE 103 - GSE 114 per unit

GSE 205 - GSE 222 per unit

GSE 314 - GSE 330 per unit

GSS 205 - GSS 222 per unit

GSS 312 - GSS 330 per unit

GSS 420 - GSS 442 per unit

### Machine screw tap adapters – making an affordable start

The machine screw tap is accommodated directly in the 19 mm or 32 mm Weldon system with an adapter. Only suitable for through-hole threads!



#### Machine screw tap adapter with Weldon shank

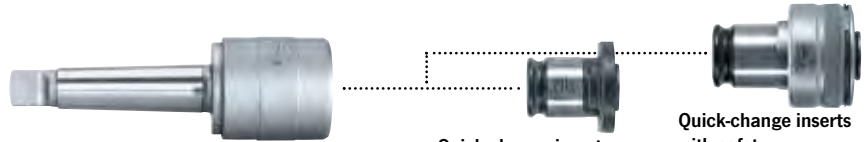
ORDER NO.	THREAD	SHANK Ø	SQUARE
ZGA 010	M10 DIN 376	7	5.5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14.5
ZGA 024	M24 DIN 376	18	14.5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18

Up to ZGA 020 with 19 mm Weldon shank (¾")

From ZGA 022 with 32 mm Weldon shank (1 ½")



**THREAD CUTTING SYSTEMS**



**Quick-change drill chucks GSW**

**Quick-change inserts  
Standard GSE**

**Quick-change inserts  
with safety  
friction clutch GSS**

MAB 1300	MAB 825 MAB 845	MAB 485 MAB 485 SB	MAB 525 MAB 525 SB	Order No. Quick-change drill chuck	Thread	Order No.	ø x square	Order No.	ø x square	
				GSW 222 Size 2 MT 2	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210-DIN 371	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0	
				GSW 331 Size 1 MT 3	M4	GSE 104	4.5 / 3.4			
					M5/M6	GSE 105	6 / 4.9			
					M8	GSE 108	8 / 6.2			
					M10	GSE 110	10 / 8.0			
					M12	GSE 112	9 / 7.0			
					M14	GSE 114	11 / 9.0			
				GSW 332 Size 2 MT 3	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210.1	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9	GSS 216	12 / 9	
					M18					GSE 218
					M20	GSE 220	16 / 12	GSS 220	16 / 12	
					*not suitable for MAB 525					M22/M24*
					GSW 333 Size 3 MT 3	M12			GSS 312	9 / 7.0
				M14		GSE 314	11 / 9	GSS 314	11 / 9	
				M16		GSE 316	12 / 9	GSS 316	12 / 9	
				M18		GSE 318	14 / 11	GSS 318	14 / 11	
				M20		GSE 320	16 / 12	GSS 320	16 / 12	
						M22/M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
						M30	GSE 330	22 / 18	GSS 330	22 / 18
				GSW 442 Size 2 MT 4		M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
					M6	GSS 206				
					M8		GSE 208	8 / 6.2	GSS 208	8 / 6.2
					M8	GSS 205				
					M10		GSE 210-DIN 371	10 / 8.0	GSS 210	7 / 5.5
					M10	GSE 210				
					M12		GSE 212	9 / 7.0	GSS 212	9 / 7.0
					M14	GSE 214				
					M16		GSE 216	12 / 9	GSS 216	12 / 9
					M18	GSE 218				
					M20		GSE 220	16 / 12	GSS 220	16 / 12
					M22/24	GSE 222				
					GSW 443 Size 3 MT 4	M12			GSS 312	9 / 7.0
				M14		GSE 314	11 / 9	GSS 314	11 / 9	
				M16		GSE 316	12 / 9	GSS 316	12 / 9	
				M18		GSE 318	14 / 11	GSS 318	14 / 11	
				M20		GSE 320	16 / 12	GSS 320	16 / 12	
				M22/24		GSE 322	18 / 14.5	GSS 322	18 / 14.5	
				M27		GSE 327	20 / 16	GSS 327	20 / 16	
				M30		GSE 330	22 / 18	GSS 330	22 / 18	
				GSW 444 Size 4 MT 4	M20			GSS 420	16 / 12	
					M22/24			GSS 422	18 / 14.5	
					M27			GSS 427	20 / 16	
					M30			GSS 430	22 / 18	
					M33			GSS 433	25 / 20	
					M36			GSS 436	28 / 22	
					M39/42			GSS 442	32 / 24	

Arbors  
and adapters

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# Arbors for BDS core drills

Three systems are available – they allow a friction-type, convenient and secure connection between the core drill and the magnetic core drilling machine.

## ACCOMMODATING OF EVERY DRILL

Arbors for BDS core drills with 19 mm ( $\frac{3}{4}$ " Weldon shank



**KEYLESS quick-change drilling system**

ORDER NO.	SPINDLE ARBOR
ZSS 200	MT 2
ZSS 300	MT 3

With automatic internal lubrication for core drills with 19 mm ( $\frac{3}{4}$ " Weldon shank. With tube and quick-lock coupling. Quick tool change without wrench.



**Reducing bush DIN 2185**

ORDER NO.	EXTERNAL	INTERNAL
ZRH 210	MT 2	MT 1
ZRH 320	MT 3	MT 2
ZRH 430	MT 4	MT 3

Arbors for BDS core drills with 19 mm ( $\frac{3}{4}$ " and 32 mm ( $1\frac{1}{4}$ " Weldon shank



**Industrial arbor with manual internal lubrication**

ORDER NO.	SPINDLE ARBOR
ZIA 219-M	MT 2
ZIA 319-M	MT 3
ZIA 419-M	MT 4

For core drills with 32 mm ( $1\frac{1}{4}$ " Weldon shank



**Extension sleeve DIN 2178**

ORDER NO.	EXTERNAL	INTERNAL
ZVH 220	MT 2	MT 2
ZVH 230	MT 2	MT 3
ZVH 320	MT 3	MT 2
ZVH 330	MT 3	MT 3

Arbors for BDS core drills with 19 mm ( $\frac{3}{4}$ " and 32 mm ( $1\frac{1}{4}$ " Weldon shank



**Industrial arbor with automatic internal lubrication**

ORDER NO.	SPINDLE ARBOR
ZIA 219-KN	MT 2
ZIA 319-KN	MT 3
ZIA 419-KN	MT 4

For core drills with 32 mm ( $1\frac{1}{4}$ " Weldon shank

With tube and quick-lock coupling.

# Adapters with Weldon shank

With the relevant adapters, BDS core drills with a Weldon shank are compatible with commercially available machines and arbor systems.

## WE ARE OPEN TO ALL SYSTEMS

32 mm (1 1/4")



**Adapter**  
**ORDER NO.**  
 ZAP 200  
 From 32 mm (1 1/4") Weldon shank  
 To 19 mm (3/4") Weldon shaft

19 mm (3/4")



**Adapter**  
**ORDER NO.**  
 ZAF 002  
 For fine core drills with M18 x 6 P1.5 female thread incl. 1 ZAK 125 ejector pin

19 mm (3/4")



**Adapter**  
**ORDER NO.**  
 ZAF 003  
 For fine core drills with QUICK-IN shank incl. 1 ZAK 115 ejector pin

19 mm (3/4")



**Extension**  
**ORDER NO.**  
 ZAP 300  
 80 mm, 19 mm Weldon shank (3/4"), incl. 1 ZAK 080 ejector pin

Adapters for Nitto One-Touch



**Adapter**  
**ORDER NO.**  
 ZAF 005  
 With Nitto One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Adapters for Fine QUICK-IN



**Adapter**  
**ORDER NO.**  
 ZAF 004  
 With Quick-In One-Touch arbor for core drill with 19 mm (3/4") Weldon shank incl. 1 each of ZAK 107 and 125 ejector pin

Arbors and adapters

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# PowerCLEANER

The ideal multi-function tool



## USE OF BDS

## GENUINE ACCESSORIES ADVISED

### PowerCLEANER

PowerCLEANER

ORDER NO.

POW 200

With special hook for removing drilling chips and lockable cleaning brush for cleaning the working surface.



Removal of drilling chips with sharp edges



Cleaning of working surface

## PowerCLEANER starter kit

Save money with the BDS starter kit at the bargain price!

Start with the right basic equipment for every magnetic core drilling machine. In a pack at a particularly good price.

- ▶ 5 short core drills in the most common diameters: 14 mm, 18 mm and 22 mm.
- ▶ 1 litre of BDS 5000 high-performance cutting oil.
- ▶ And a BDS PowerWORKER or BDS PowerCLEANER.

BDS PowerCLEANER starter kit

ORDER NO.

ZST 200

Contents:

- 1 standard core drill box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 l BDS 5000 high-performance cutting oil
- 1 BDS PowerCLEANER POW200



BDS ÖkoLogisch

PRICE ADVANTAGE

# PowerWORKER

Cleans up all magnetic drilling chips.  
The indispensable helpmate for every workshop.

## TIDIER WORK AREA

### PowerWORKER

PowerWORKER

ORDER NO.

POW 100



The PowerWORKER cleans up all magnetic drilling chips. With this practical tool and its strong magnetic force, chips are easily collected and then quickly and easily disposed of in the scrap container. Magnetisation, collection, stripping – done.

## PowerWORKER starter kit

Save money with the BDS starter kit  
at the bargain price!



BDS PowerWORKER starter kit

ORDER NO.

ZST 100

#### Contents:

- 1 standard core drill box with
- 2 KBK – Ø 14 mm
- 2 KBK – Ø 18 mm
- 1 KBK – Ø 22 mm
- 1 l BDS 5000 high-performance cutting oil
- 1 BDS PowerWORKER POW100



**PRICE ADVANTAGE!**

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### High-performance cutting oil **BDS 5000**

### Cooling lubricant concentrate **BDS 6000**



Purely vegetable oil that does not come under the category of hazardous goods in terms of customs & transport regulations.  
The raw materials used are not listed in the Catalogue of Substances Hazardous to Water.  
BDS 5000 is not subject to any labelling requirements.

- ▶ Biological raw material with additives
- ▶ Water hazard level 1
- ▶ Biodegradable, optimum basic adjustment of viscosity for use of BDS core drills, problem-free use for subsequent tin plating



For high standards based on synthetic raw materials

- ▶ Can be mixed with water, biologically stable and mild in odour
- ▶ Extends the service life of the core drill
- ▶ Toxicologically harmless, Water Hazard Class 1

Cutting Oil (For HSS Core Drills)		
ORDER NO.	NAME	CONTENT
ZHS 005	BDS 5000 cutting oil	5-litre can
ZHS 006	BDS 5000 cutting oil	1-litre can

Cooling Lubricant (For TCT Core Drills)		
ORDER NO.	NAME	CONTENT
ZHB 001	BDS 6000 cooling lubricant concentrate	1-litre can

# Cutting oil, lubrication spray, cutting paste and cooling lubricant

High-performance products that can be used effectively and in an ecologically sound manner.

**BEST RESULTS**

**KIND ON**

**THE ENVIRONMENT**

## High-performance lubrication spray **BDS 5200**



For working in awkward positions (overhead and on a horizontal plane), also suitable for high-alloy materials. Foam-like spray with very high adhesive strength.

Advantages: Precise dosing of lubrication spray and therefore optimum lubrication directly on the cutting edges. No dripping or splashing, thus ensuring maximum safety when working on ladders and scaffolds.

- ▶ White adhesive lubricant containing PTFE with corrosion protection
- ▶ Free from PCB, PCT, CFCs and chlorine
- ▶ Active substance: Mineral-based lithium grease with additives and solvents
- ▶ Compressed gas: Propane/butane, subject to labelling requirements

## High-performance cutting paste **BDS 5500**

## High-Tech metal-free cutting paste **BDS 7500**



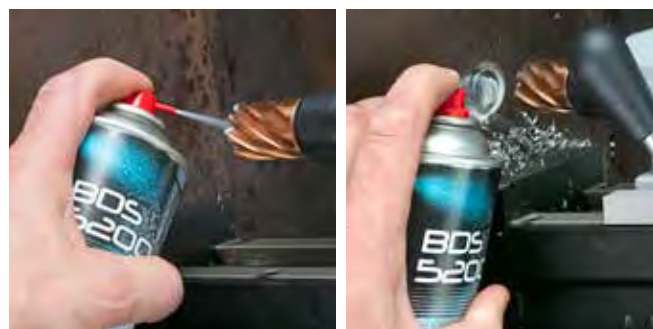
BDS 5500: Ideal for material types that are hard to machine. Suitable for use overhead and work in awkward positions.

BDS 7500: Base oil: Medicinal white oil. Extremely high heat resistance up to 1,400°C. For manual lubrication of high-alloy steel, Hardox steel and stainless and heat-resistant steel. For extremely high standards.

BDS high-performance lubricants and cleaning spray are tailored precisely to the respective intended purpose. The highly efficient composition allows sparing and environmentally friendly use.

The following are particularly recommended: BDS high-performance cutting oil or high-performance cooling lubricant concentrate. These products are fully biologically degradable and toxicologically harmless. However, also highly effective in the required lubrication and cooling performance. The BDS 6000 concentrate can also be mixed with water in a ratio of 1:10 and is therefore extremely efficient.

**Caution: Please do not use liquid lubricants for overhead work or work on vertical surface. There is a risk that oil will get into the motor, thus causing a short-circuit. Please use BDS high-performance lubrication spray BDS 5200 or the BDS 5500/7500 cutting paste.**



Step 1: Prior to drilling, spray high-performance lubrication spray directly into the drill.

Step 2: During drilling, spray high-performance lubrication spray onto the tip of the drill and into the borehole.

Lubricants and adjuvants		
ORDER NO.	NAME	CONTENT
ZHS 550	BDS 5500 cutting paste	1000 g can
ZHS 570	BDS 7500 cutting paste	85 g tube
ZHS 572	BDS 7500 cutting paste	12 x 85 g tubes

Lubricants and adjuvants		
ORDER NO.	NAME	CONTENT
ZHS 400	BDS 5200 lubrication spray	1 x 400 ml tin
ZHS 406	BDS 5200 lubrication spray	6 x 400 ml tin
ZHS 412	BDS 5200 lubrication spray	12 x 400 ml tin





## Clamping device for pipes with a diameter of 80 mm to 500 mm

The BDS pipe clamping devices are as standard suitable for pipes with a diameter of 80 mm to 250 mm and 150 mm to 500 mm. Flexible and quick clamping is possible in every drilling situation. Tension chains fix the clamping device to the pipe with swivelling prisms. Adjustment of the drilling position to the pipe is easy and safe. These devices significantly expand the range of possible applications of the ProfiPLUS magnetic core drilling machines.



ZRO 250



ZRO 500

### Pipe clamping device

#### ORDER NO.

ZRO 250

ZRO 500

ZRO 250: for MAB 455, 485, 525

For pipe  $\varnothing$ : 80 – 250 mm, chain length: 900 mm

ZRO 500: for MAB 825, 845, MABasic 850

For pipe  $\varnothing$ : 150 – 500 mm, chain length: 1650 mm

# Clamping devices

Can be used for magnetic core drilling machines from the ProfiPLUS, ProfiSTART and ProfiBASIC categories.

## FOR MACHINING PIPES

## AND DRILLING NON-FERROUS METALS

## AND STAINLESS STEEL

### Vacuum clamping devices for non-ferrous metals

Magnetic core drilling machines from the ProfiPLUS can also be used fully to machine non-ferrous metals and stainless steel. To this end, BDS offers clamping devices that build up a vacuum with a pump lubricated by means of oil circulation, thus creating a secure connection between the magnetic core drilling machine and the workpiece.



Vacuum plate for smooth surfaces

**ORDER NO.**

ZAV 400

**Application:** For smooth surfaces.

**Design:** High-performance vacuum pump with oil circulation lubrication. Clamping plate with two suction surfaces and an internal drilling area.  
Dimensions: 440 x 260 mm,  
Elongated hole: 50 x 120 mm



Vacuum plate for smooth corrugated sheet metal/gussets

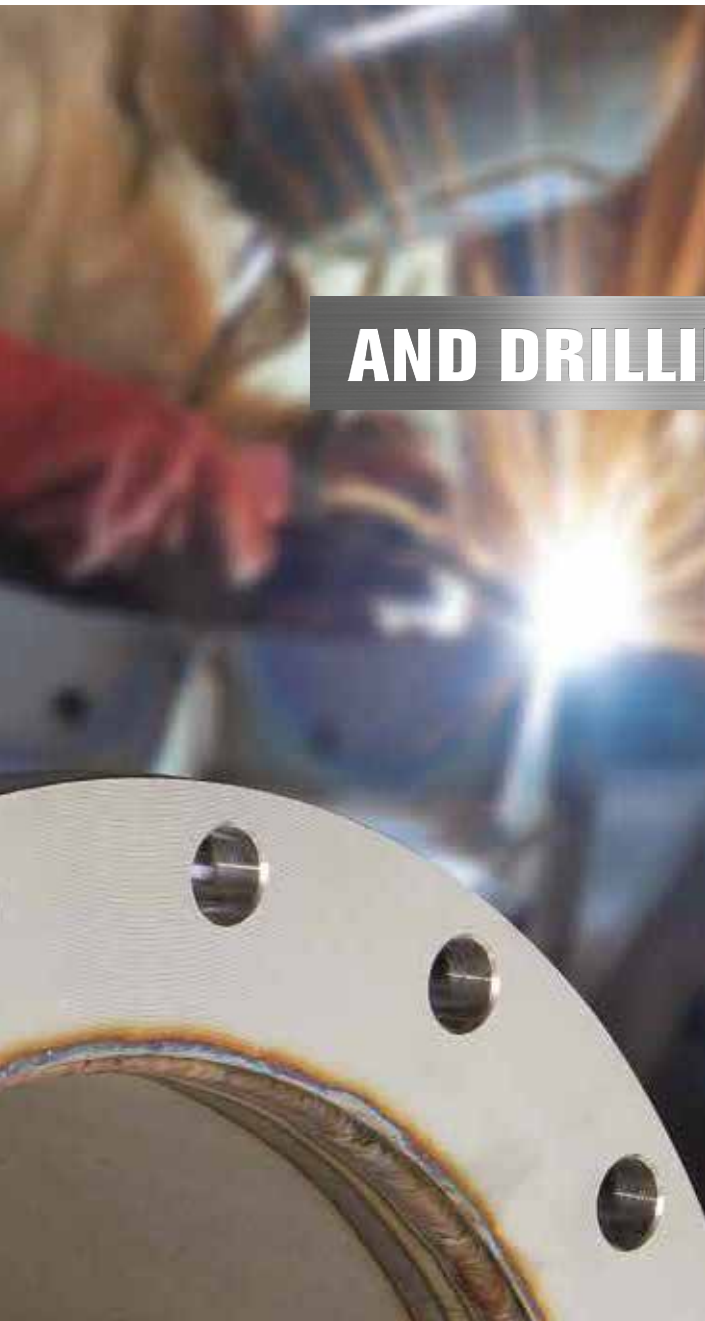
**ORDER NO.**

ZAV 300

**Application:** Suitable for corrugated sheet metal, gussets and smooth surfaces.

**Design:** High-performance vacuum pump with oil circulation lubrication. Clamping plate  $\varnothing$  300 mm.

Delivery without machines



ZAV 400  
Vacuum clamping  
device for smooth  
surfaces



ZAV 300  
Vacuum clamping  
device for corrugated  
sheet metal and  
gussets

