

Blue Max



Blue Max not only installs hinges and connecting fittings, it also drills hole lines for System 32.

A horizontal boring unit is also capable of drilling panel edge holes for Rastex connectors and dowels.

Blue Max is a technologically perfected range of machines. Providing more capabilities. For better workmanship. For higher productivity.

High-quality material, sturdy design and meticulous workmanship - exemplary in modern machine construction.

A 24-month warranty on all machine components speaks for the quality of Blue Max.



Hole line boring in System 32 with the integrated indexing stop system



Inserting an Intermat hinge ...



... and the VB 36 M connecting fitting

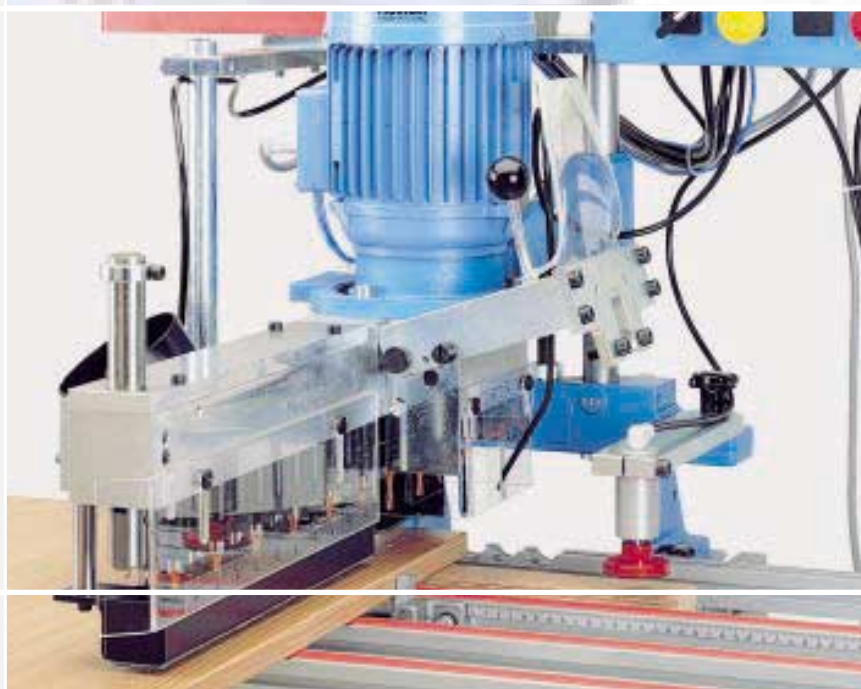
Do more, produce more, save more.

Installing hardware and much more ...

2

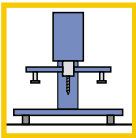


Horizontal boring unit for drilling panel edge holes, e.g. dowels ...



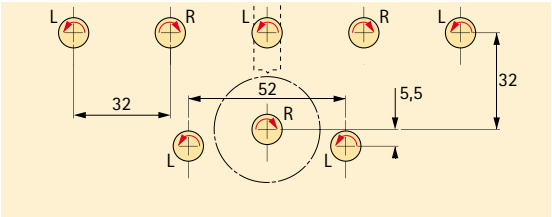
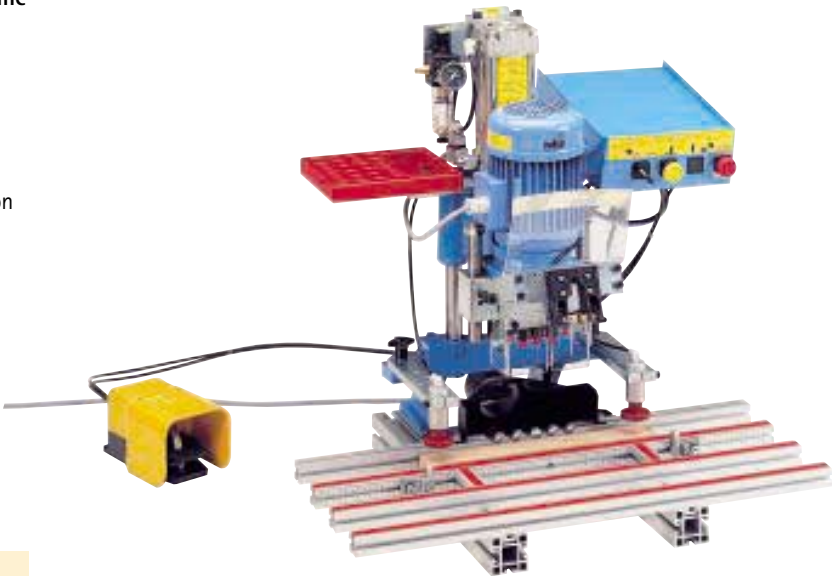
Blue Max 19 with 19-spindle boring head swivelled through 90° for full carcass processing.

Blue Max 8

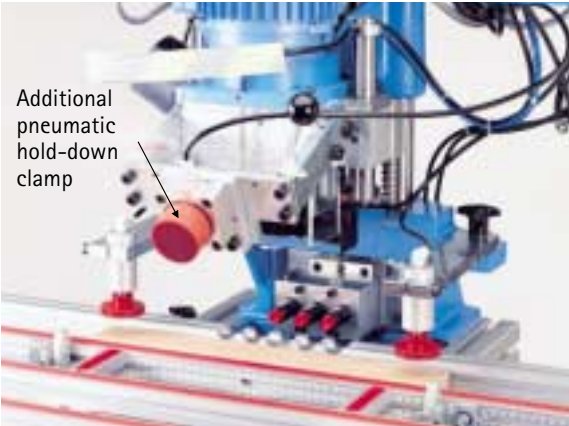


The versatile drilling and insertion machine with 8-spindle boring head, of which 5 spindles are used for hole line borings.

- Blue Max 8 with 8-spindle boring head
- Aluminium work top
- Stop systems with 3 fixed and 2 tilt stops
- Integrated hole line indexing pins
- Universal die for inserting Interimat, Ecomat, Slide-on and Selekt 4 hinges
- Foot pedal
- Optional machine versions complete with pre-installed horizontal boring unit
- All Blue Max 8 versions feature dust removal as standard equipment
- 400 V/50 Hz/3-phase
- Motor power rating 1.6 kW (2.1 PS)

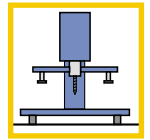


Article	Version	Order no.	PU
Blue Max 8FS	8-spindle boring head	061 234	1
Blue Max 8FS/HB 1S	8-spindle boring head equipped with 1-spindle horizontal boring unit	063 247	1
Blue Max 8FS/HB 3S	8-spindle boring head equipped with 3-spindle horizontal boring unit and additional pneumatic hold-down clamp for horizontal drilling	063 248	1
Blue Max 8FS/HB 5S	8-spindle boring head equipped with 5-spindle horizontal boring unit and additional pneumatic hold-down clamp for horizontal drilling	063 249	1



Blue Max 8 FS / HB 3S
with additional pneumatic hold-down clamp.

Blue Max 19

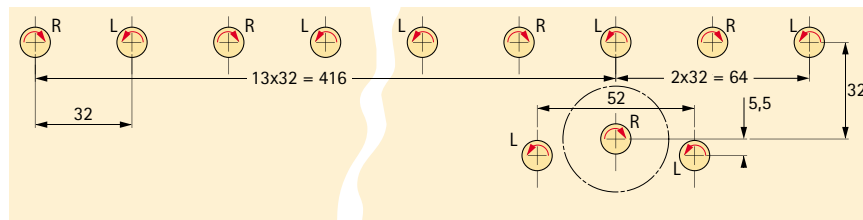
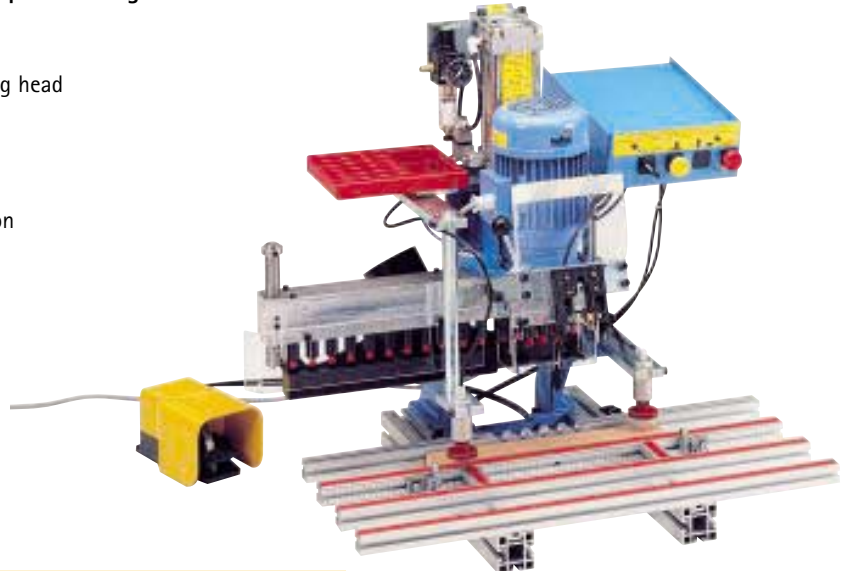


Maximum rating machine with swivel-mounted 19-spindle boring head.

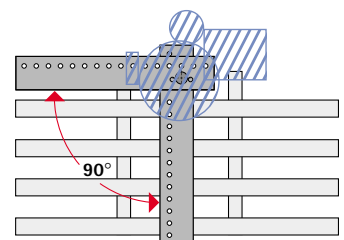
For full carcase processing.

16 spindles for hole line borings.

- Blue Max 19 with 19-spindle swivel-mounted boring head
- Aluminium work top
- Stop systems with 4 fixed and 2 tilt stops
- Integrated hole line indexing pins
- Universal die for inserting Interimat, Ecomat, Slide-on and Selekt 4 hinges
- Foot pedal
- Optional machine versions complete with pre-installed horizontal boring unit
- All Blue Max 19 versions feature dust removal as standard equipment
- 400 V/50 Hz/3-phase
- Motor power rating 1.6 kW (2.1 PS)



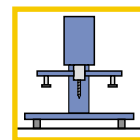
Article	Version	Order no.	PU
Blue Max 19FS	19-spindle boring head	061 240	1
Blue Max 19FS/HB 1S	19-spindle boring head equipped with 1-spindle horizontal boring unit	063 250	1
Blue Max 19FS/HB 3S	19-spindle boring head equipped with 3-spindle horizontal boring unit and additional pneumatic hold-down clamp for horizontal drilling	063 251	1
Blue Max 19FS/HB 5S	19-spindle boring head equipped with 5-spindle horizontal boring unit and additional pneumatic hold-down clamp for horizontal drilling	063 252	1



The swivel-mounted boring head allows holes to be drilled across the carcase side. This makes it possible to drill holes up to 540 mm from the carcase front edge.

Blue Max

Horizontal boring unit for retrofitting

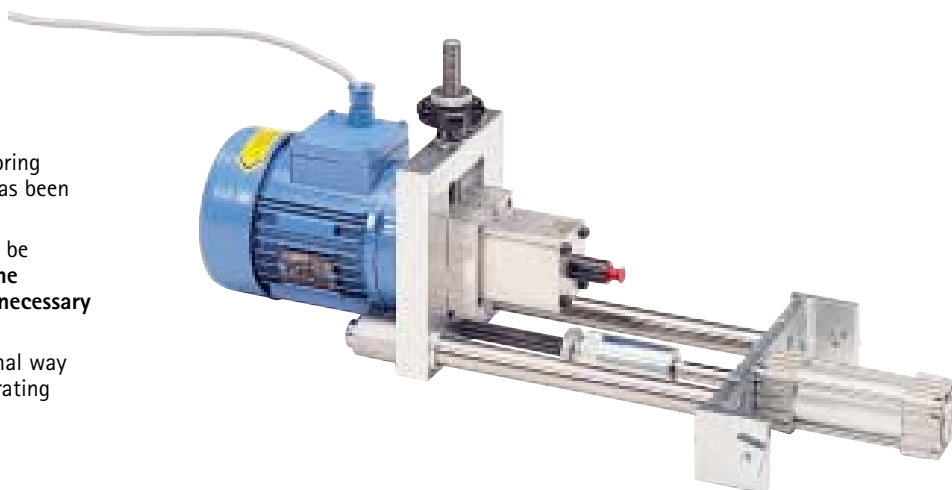


The Blue Max 8 and Blue Max 19 machines without horizontal boring units can be retrofitted e.g. for drilling panel edge dowel holes.

The pneumatically controlled horizontal boring unit can be started once vertical drilling has been completed.

This means that the workpiece only has to be clamped once to drill the holes for **both the Rastex connecting fitting** as well as the **necessary dowels**.

The drilling process is initiated in the normal way by means of the foot pedal, motor power rating 0.75 kW (1 PS).



Horizontal boring unit with single-spindle boring head

Article	Order no.	PU
HB 1S	061 333	1

for drilling panel edge holes, e.g. dowel holes

Horizontal boring unit with 3-spindle boring head

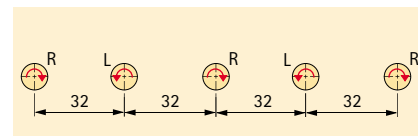
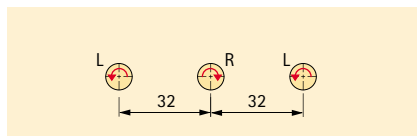
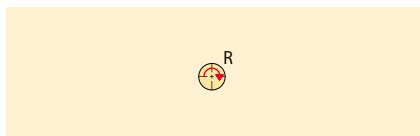
Article	Order no.	PU
HB 3S	061 335	1

for use if, e.g. using wooden dowels in addition to the expanding dowel.

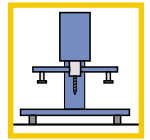
Horizontal boring unit with 5-spindle boring head

Article	Order no.	PU
HB 5S	061 337	1

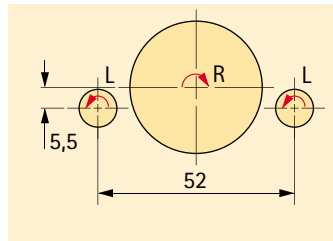
Ideal, e.g. for rationalising drawer production.



Installing hardware and a whole lot more ...

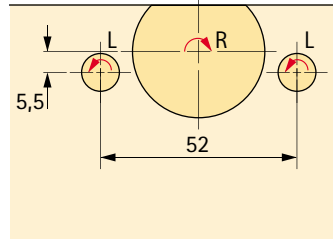


Blue Max not only installs hinges and connecting fittings, it also drills hole lines for System 32.
A horizontal boring unit is also capable of drilling panel edge holes for the Rastex connectors and dowels.



Intermat /Ecomat and Slide-on automatic hinges for compact furniture and the folding door hinges with offset pivot (see **group 3**).
Cup diameter 35 mm, hole line drilling for cross mounting plates.

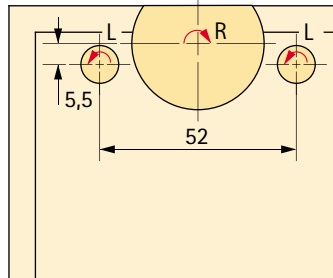
Fixed stop 22 mm on hinge scale.



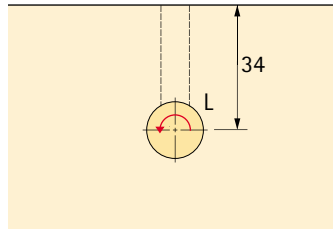
Selektta/Selektta Pro 2000 single-pivot hinges for office furniture.

Cup diameter 35 mm,
hole line boring for cross mounting plates.

Fixed stops for Selektta: 14 mm on hinge scale,
Selektta Pro 2000: 14 mm on hinge scale
+ distance pieces

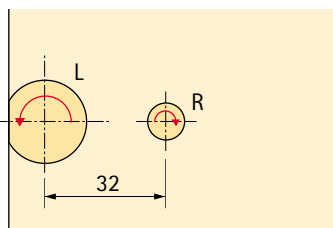


Konsul hinges for period furniture with rebated doors,
cup diameter 35 mm,
hole line boring for cross mounting plates.



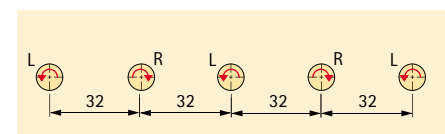
Hole for RASTEX connecting fittings.
Panel edge dowel holes drilled with horizontal boring unit. Hole line boring for dowel.

Fixed stop 37 mm on hole line scale.



Holes for connecting fittings, e.g. VB 36 M with centre stop. Hole line boring for dowel.

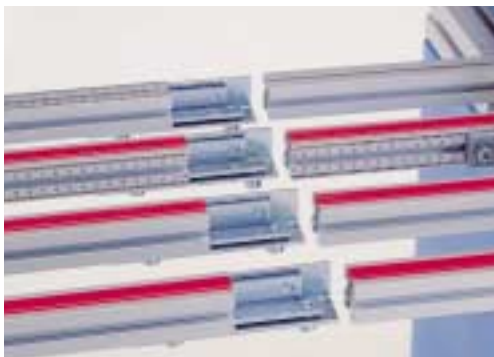
Fixed stop 37 mm on hole line scale.



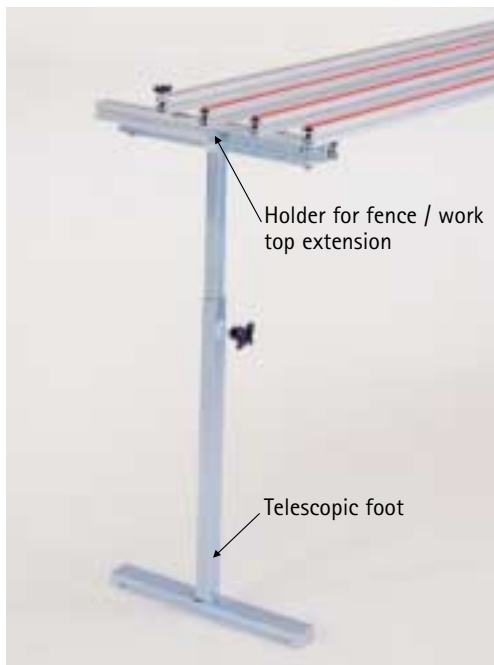
Blue Max 8/19

... accessories at a glance

2



Work top / fence extension

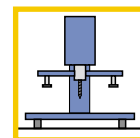


Extension arm for hold-down clamp, practical in conjunction with
 ● retrofitted single-spindle horizontal boring unit
 ● narrow workpieces

Accessory Blue Max 8/19	Order no.	PU
• Fence extension with scale, 1500 mm long, for right/left-hand use	061 266	1
• Fence extension with scale, 2000 mm long, for right/left-hand use	061 268	1
• Work top extension - 3 profiles, each 1500 mm long, for right/left-hand use, with plastic profiles	061 270	1 set
• Work top extension - 3 profiles, each 2000 mm long, for right/left-hand use, with plastic profiles	061 272	1 set
• Work top extension (1 profile) without scale, 1500 mm long, for right/left-hand use	061 829	1
• Work top extension (1 profile) without scale, 2000 mm long, for right/left-hand use	061 831	1
• Plastic profile for work top extension, 1500 mm long, red	061 830	1
• Plastic profile for work top extension, 2000 mm long, red	061 832	1
• Holder for fence/work top extension, for right/left-hand use	061 274	1
• Telescopic foot (for order no. 061 274)	061 276	1
• Machine base frame, height 760 mm (working height 850 mm)	061 278	1
• Ball bearing grease OKS 428, 1 x 250 g tube	065 559	1
• Tilt stop, right-hand	061 351	1
• Tilt stop, left-hand	061 353	1
• Pendulum stop for fence, for right/left-hand use	061 285	1
• Extension arm for hold-down clamp	061 280	1
• Air blow-off pistol, including hose and connector	061 282	1
• Additional pneumatic hold-down clamp for retrofit horizontal boring unit	065 563	1
All Blue Max 8 / 19 machines come complete with a factory-fitted dust removal system.		
The following suction extractor facilities can be retrofitted with ease		
• Suction extractor for Blue Max 8 machines without horizontal boring unit	065 560	1
• Suction extractor for Blue Max 8 machines with horizontal boring unit	074 613	1
• Suction extractor for Blue Max 19 machines with and without horizontal boring unit	074 614	1
• Suction extractor for supplementary horizontal boring unit for Blue Max 8/19	074 612	1

Correct suction extractor variant for machine type

Machine type	without horizontal boring unit	with horizontal boring unit
Blue Max 8	065 560	074 613 + 074 612
Blue Max 19	074 614	074 614 + 074 612



Set of drill bits for Blue Max 8



Die/distance pieces for Selekt Pro 2000 - T23



Die for VB 36

Accessory Blue Max 8/19

Order no.

PU

- Universal die for inserting
Intermat, Ecomat, Slide-on and Selekt 4 hinges 061 355 1
- Centre stop VB 18/19/20/21/36 061 287 1
- Die for VB 18/19/20/21 061 289 1
- Die for VB 36 068 637 1
- Die for knock-in mounting plate
System 9000 046 626 1
- Die/distance pieces for
Selekt Pro 2000, hole pattern T23 010 079 1
- Distance pieces for Selekt Pro 2000, hole pattern T23 071 699 1 set

Other dies on request

Drill bits, tungsten carbide tipped

- Set of drill bits for Blue Max 8, containing:
1 x $\varnothing$ 35 mm right, 2 x $\varnothing$ 10 mm left
3 x $\varnothing$ 5 mm left, 2 x $\varnothing$ 5 mm right 061 248 1 set
- Set of drill bits for Blue Max 19, containing:
1 x $\varnothing$ 35 mm right, 2 x $\varnothing$ 10 mm left
8 x $\varnothing$ 5 mm left, 8 x $\varnothing$ 5 mm right 061 250 1 set
- Set of drill bits for VB 36, containing:
1 x $\varnothing$ 20 mm left, 2 x $\varnothing$ 10 mm right 061 252 1 set
- Set of drill bits for VB 18/19/20/21, containing:
1 x $\varnothing$ 30 mm left, 2 x $\varnothing$ 10 mm right 061 254 1 set
- Drill bit retainer for quick release chucks 061 256 1
- Quick release chucks - machine section 061 258 1
- Chuck plug for quick release chucks,
plastic, red 040 657 1

• Drill bits Diameter

Length

Right

Left

PU

40 mm	57 mm	069 250		1
35 mm	57 mm	053 955	074 438	1
35 mm ¹⁾	57 mm	072 404		1
30 mm	57 mm	069 251	053 954	1
26 mm	57 mm	061 650	058 962	1
25 mm	57 mm	053 945		1
24 mm	57 mm	078 963	052 987	1
20 mm	57 mm	053 944	053 953	1
19 mm	57 mm	078 042	052 986	1
18 mm	57 mm	073 099	073 143	1
15 mm	57 mm	053 943	061 651	1
14 mm	57 mm	053 941	053 942	1
12 mm	57 mm	053 819	053 820	1
10 mm	57 mm	053 952	053 951	1
8 mm	57 mm	053 817	053 818	1
7,5 mm	57 mm	061 652	061 653	1
7 mm	57 mm	071 722	071 721	1
6 mm	57 mm	072 039	072 040	1
5 mm	57 mm	053 950	053 949	1
4 mm	57 mm	072 163	071 723	1
3 mm	57 mm	070 025	070 026	1
2 mm	57 mm	071 897	071 896	1
8 mm	70 mm	065 561	065 562	1
8 mm ²⁾	50 mm	058 961		1

¹⁾ without centring pin ²⁾ for lock-bush drilling

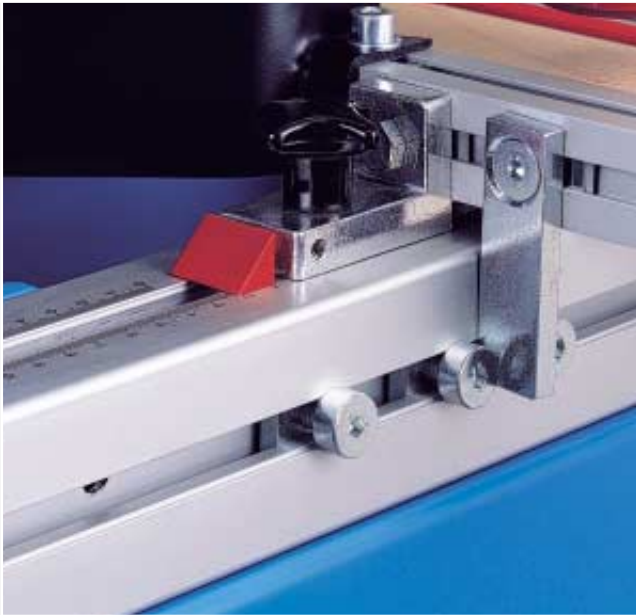
Blue Max 8/19

... the sum of all advantages for that decisive step ahead

Fitting sequence

"Inserting a concealed hinge"

2



- 1 Position fence against fixed stop at **dimension 22** on the **concealed hinge scale** (corresponds to C dimension = 4.5).



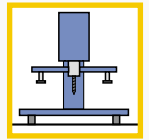
- 2 Set boring stroke limiter to "Concealed hinge" symbol. Unit always travels to top end position in this way for insertion unit to be swung down.



- 3 Set "Hold-down clamp" switch to "Concealed hinge" symbol. After drilling, the hold-down clamps lock in position and hold the workpiece in place for the hinge to be inserted.



- 4 ...universal die with Intermat hinge.



2



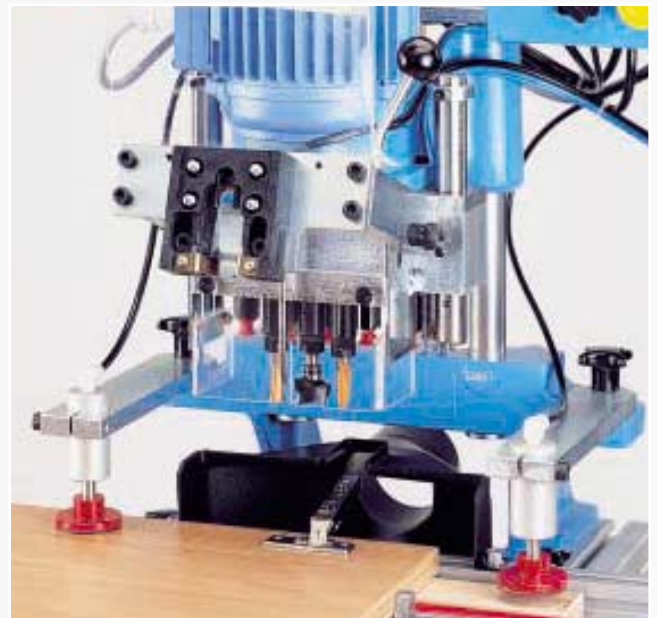
5 Drilling process is initiated by pressing the foot pedal.



6 Unit returns to the starting position ...



7 Insertion procedure: swing down insertion unit, press foot pedal ... hinge is inserted.



8 Hinge is seated perfectly in the door. Release the hold-down clamp (yellow button), and the workpiece is "free" for further insertion procedures.

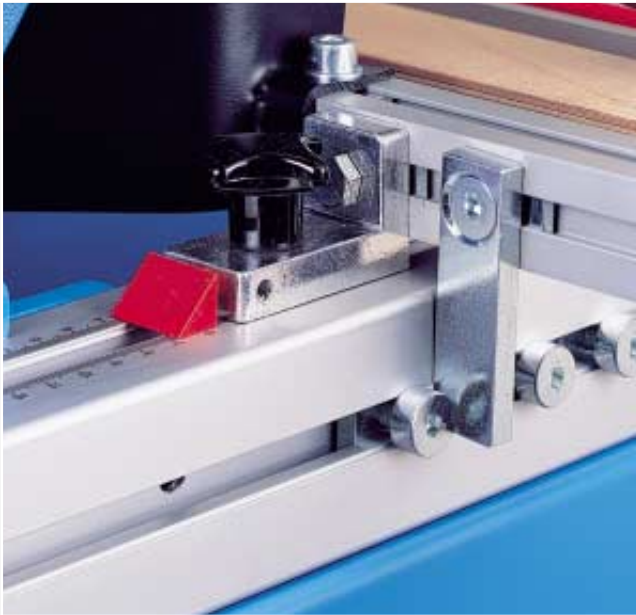
Blue Max 8/19

... the sum of all advantages for that decisive step ahead

Fitting sequence

"Inserting a connecting fitting"

2



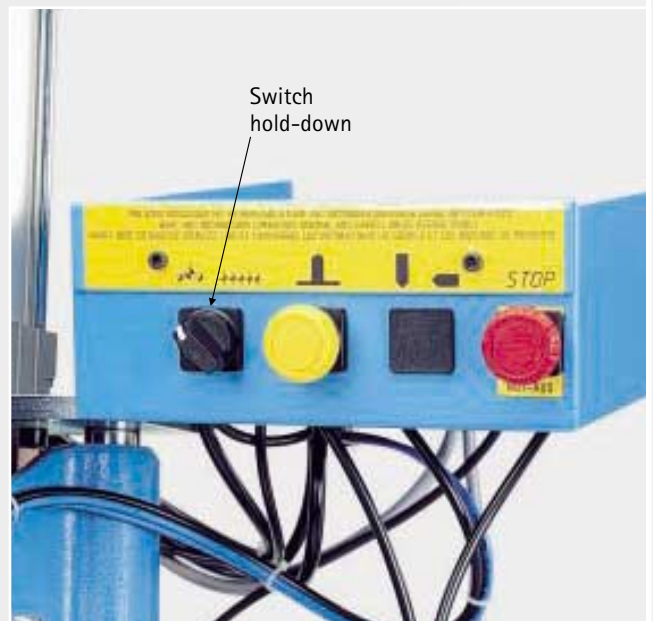
- 1 Position fence against fixed stop at dimension 37 on the hole line scale.



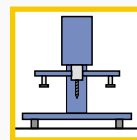
- 2 Position the centre stop for connecting fitting edge distance.



- 3 Set boring stroke limiter to "Concealed hinge" symbol. Unit always travels to top end position in this way for insertion unit to be swung down.

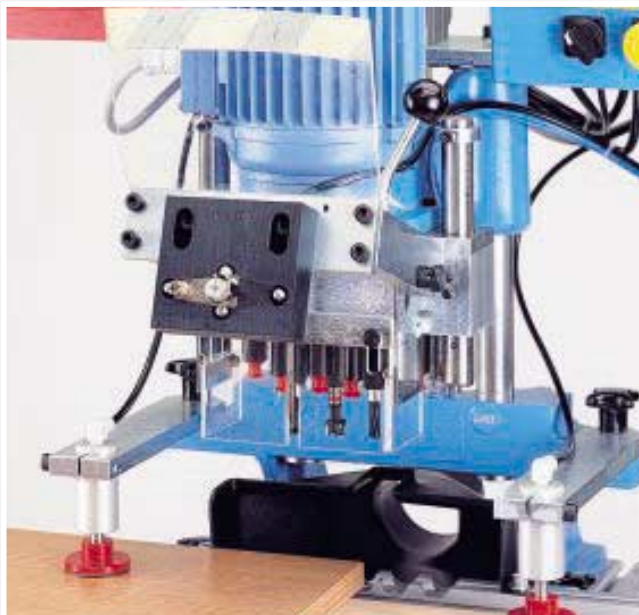


- 4 Set "Hold-down clamp" switch to "Concealed hinge" symbol. After drilling, the hold-down clamps lock in position and hold the workpiece in place for the fitting to be inserted.

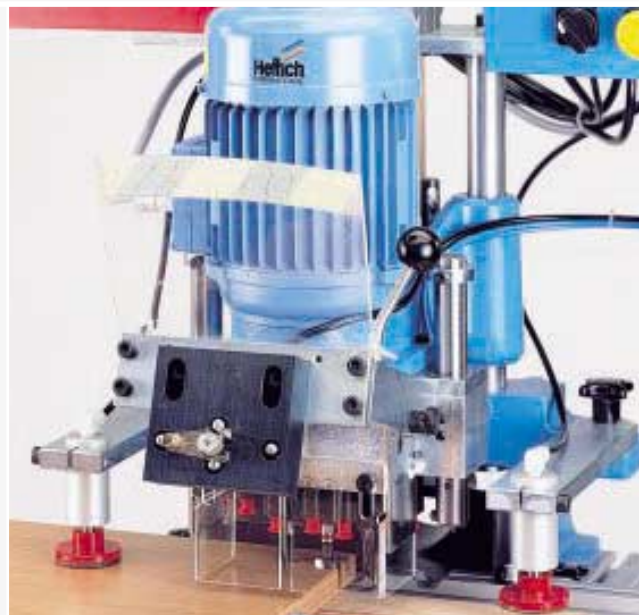


The connecting fittings centre stop allows the workpiece to be drilled on the left and right-hand side without moving the fence!

2



5 ... die for connecting fitting centre stop, in this case, for example, VB 36 M



6 ... drilling process initiated by pressing the foot pedal.



7 Unit returns to the starting position



8 Insertion procedure: swing down insertion unit, press foot pedal ... connecting fitting is inserted.



9 Connecting fitting is perfectly seated in the shelf, release the hold-down clamps (yellow button) ...

Blue Max 8/19

... the sum of all advantages for that decisive step ahead

Fitting sequence

"Drilling a 32 mm hole line"

2



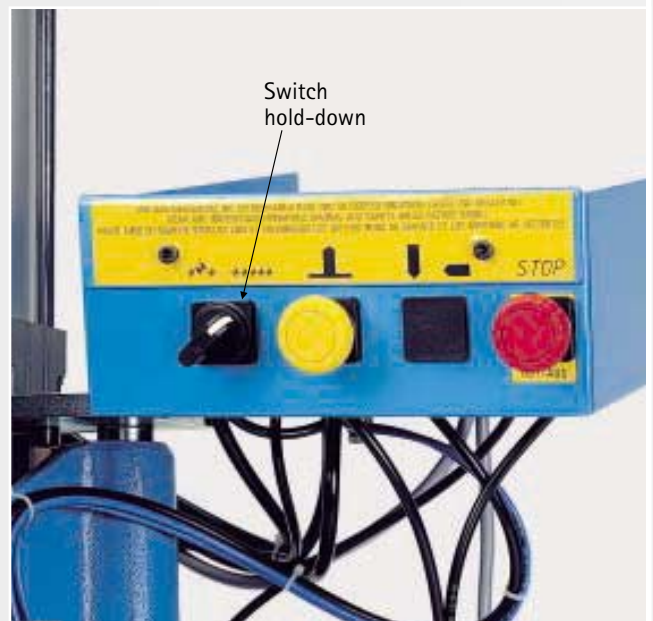
- 1 Position fence against fixed stop at dimension 37 on hole line scale.



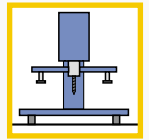
- 2 Position centre stop for dowel edge distance.



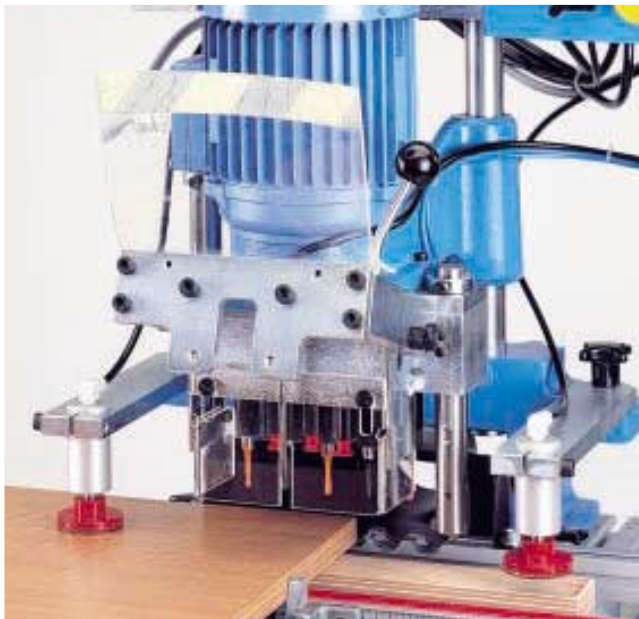
- 3 Set boring stroke limiter to "hole line" symbol, thereby defining the optimum distance between unit and workpiece.



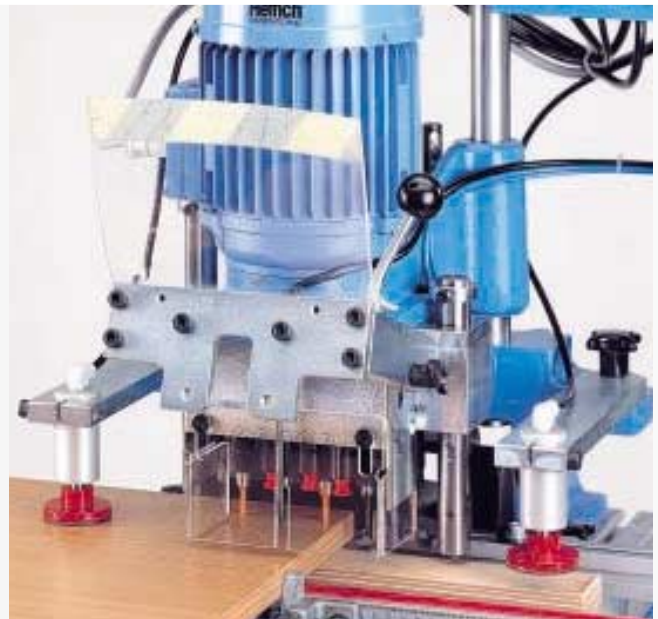
- 4 Set "hold-down clamp" switch to "hole line" symbol
After drilling, the hold-down clamps unlock automatically, releasing the workpiece for the next cycle ...



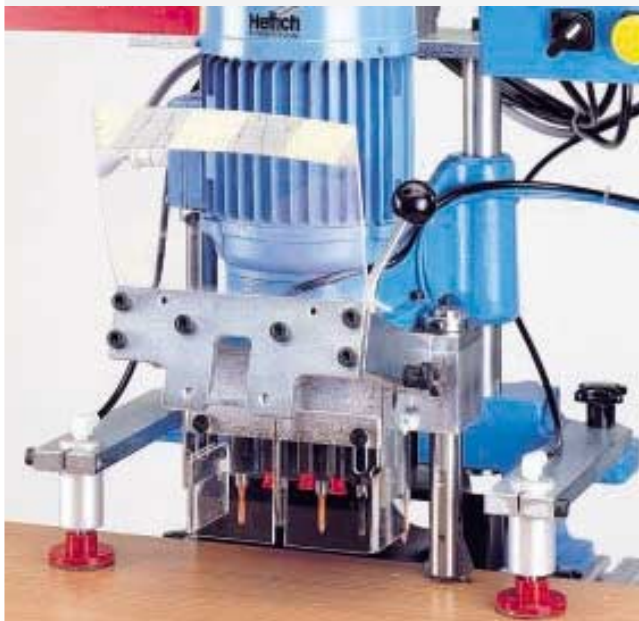
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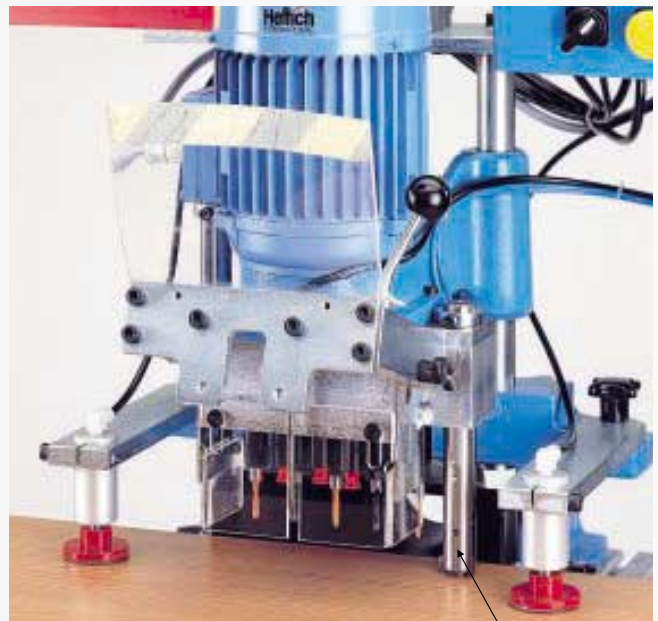
- 5 Equip unit with the required drill bits, then position side against the centre stop.



- 6 ...initiate drilling process by pressing the foot pedal.



- 7 Continue "cycle" by sliding the panel along the fence until the indexing pin locates into the last drilled hole. The next set of holes can now be drilled. The hole line indexing stop can be precision adjusted for thicknesses up to 60 mm by means of an integrated height adjuster.



Hole line
indexing pin

Blue Max mini

The machine system for
entry-level and advanced users ...

Blue Max mini automatic drilling and insertion machine

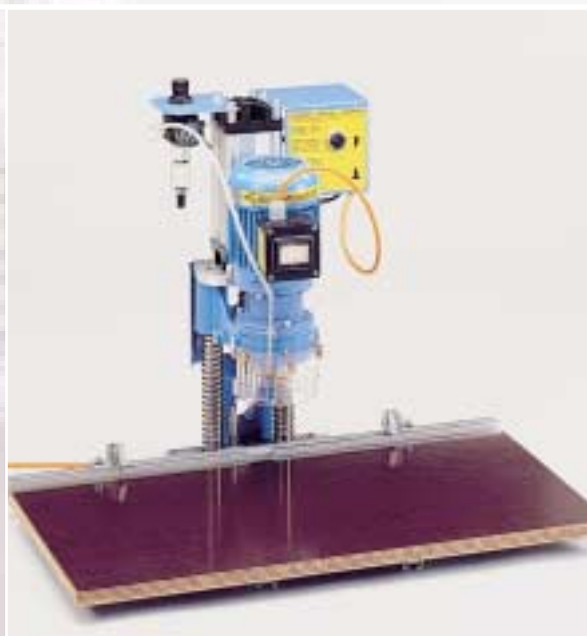
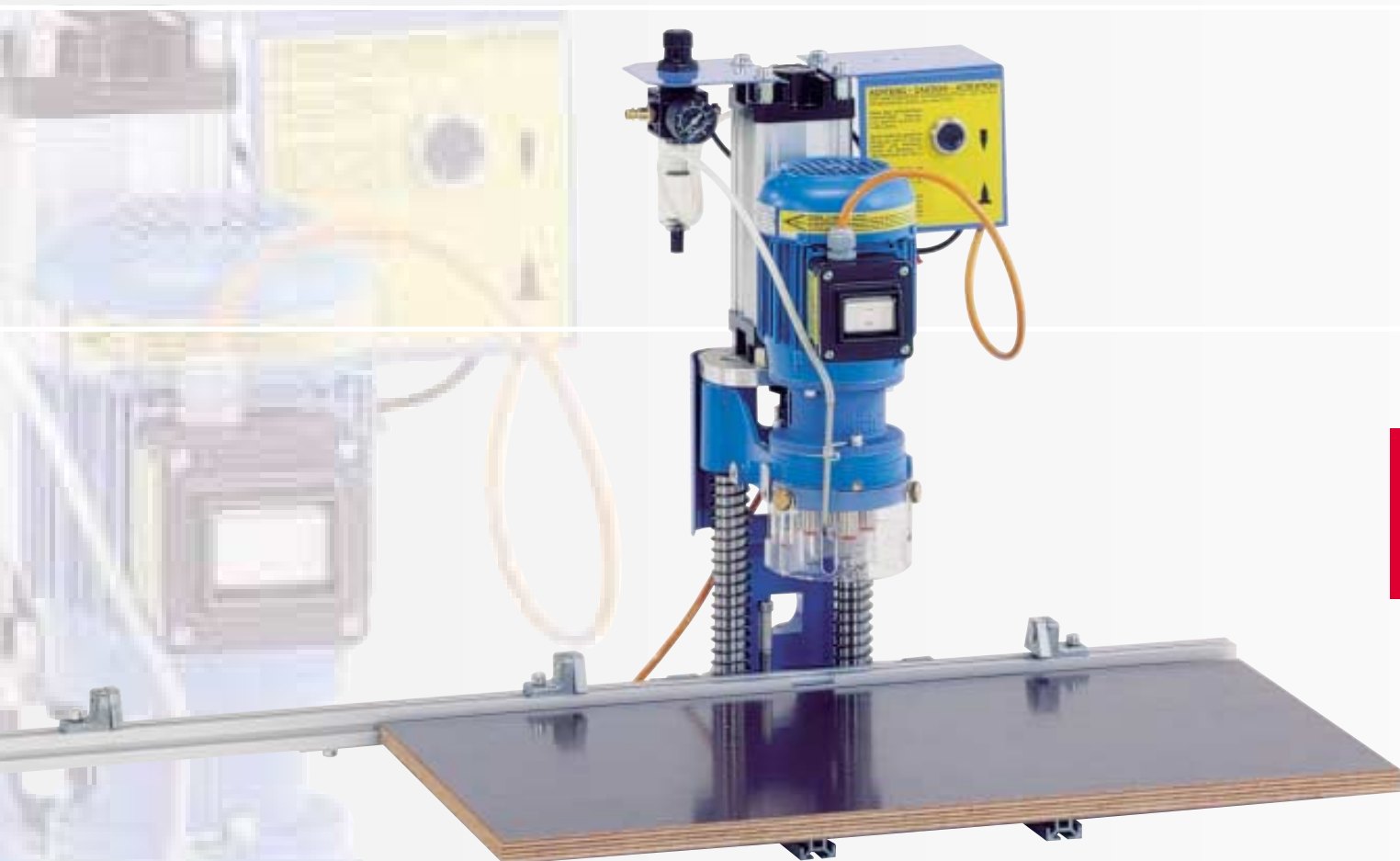
- Installation of hinges, connecting fittings and mounting plates
- Ideal introduction to hardware technology
- Practical complement to existing machinery, e.g. hole line drilling machine ...
- Easily transported, suitable for on-site use
- Available in different versions up to model with pneumatic stroke movement, 6 spindles and three-phase connection ...



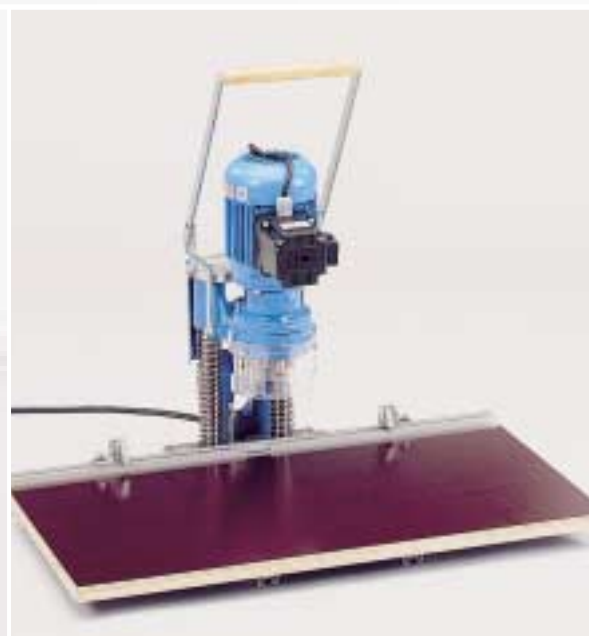
The boring head is constantly covered by a transparent guard.

Basic configuration with insertion unit with universal die





Blue Max mini Type 3
... the pneumatic model



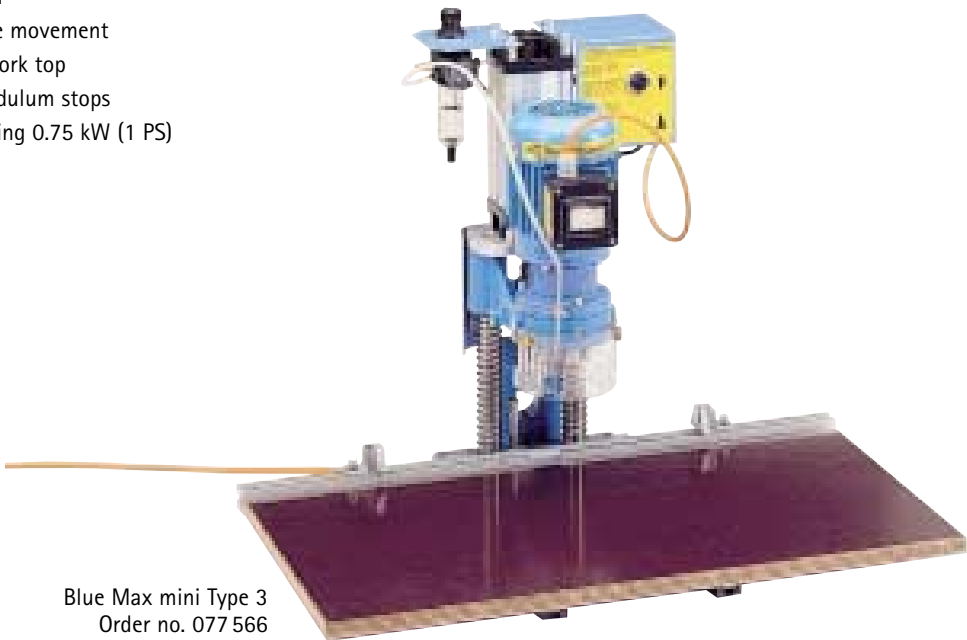
Blue Max mini Type 2
... the simple model

Blue Max mini

Blue Max mini Type 3

Basic configuration

- Pneumatic stroke movement
- Machine base, work top
- Fence and 2 pendulum stops
- Motor power rating 0.75 kW (1 PS)



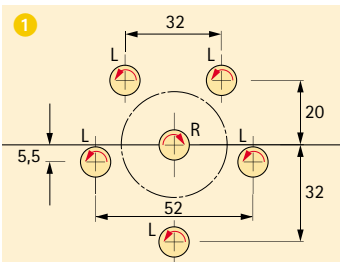
Blue Max mini Type 3
Order no. 077 566

Blue Max mini Type 3 with 6-spindle boring head

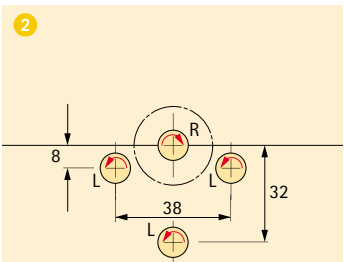
Suitable for
installing

- hinges
- cross mounting plates
- knock-in mounting plates
- connecting fittings
- dowels

Standard drilling
hinges



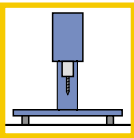
Boring unit
for Unimat hinges



Blue Max mini Type 3 with 6-spindle boring head

Version			PU
400V/50Hz 3-phase	230V/50Hz 3-phase	230V/50Hz 1-phase	
Order no.	Order no.	Order no.	

- | | | | | |
|---|---------|---------|---------|---|
| 1 Basic configuration | 077 566 | 077 567 | 078 987 | 1 |
| 1 Basic configuration with
hold-down clamp, insertion unit
and foot pedal | 077 610 | | | 1 |
| 2 Basic configuration
with 38/8 boring unit
for Unimat hinges | 077 565 | | | 1 |



Blue Max mini Type 2

Basic configuration

- Machine base, work top
- Fence and 2 pendulum stops
- Hand lever
- Motor power rating 0.75 kW (1 PS)



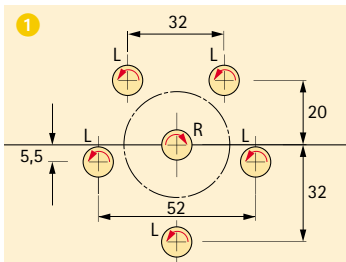
Blue Max mini type 2
Order no. 071 542

Blue Max mini Type 2 with 6-spindle boring head

Suitable for
installing

- hinges
- cross mounting plates
- knock-in mounting plates
- connecting fittings
- dowels

Standard drilling
hinges

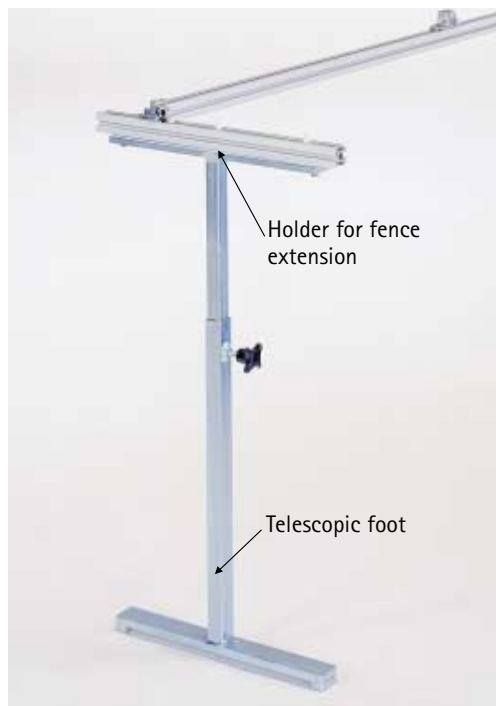


Article	Version	PU
	400 V / 50 Hz 3-phase Order no.	
1 Blue Max mini Type 2 with 6-spindle boring head and hand lever	071 542	1

Blue Max mini

Accessory

2

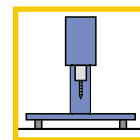


Set of fixed stops



Set of quick clamping levers

Accessories for Blue Max mini, Type 2 / Type 3	Order no.	PU
• Fence extension with scale, 1500 mm long, for right-hand/left-hand use	061 266	1
• Fence extension with scale, 2000 mm long, for right-hand/left-hand use	061 268	1
• Holder for fence extension	072 150	1
• Telescopic foot (for order no. 072 150)	061 276	1
• Set of fixed stops for fence fixed positions	072 151	1 set
• 2 quick clamping levers for adjusting fence	072 152	1 set
• Pendulum stop for fence, Right-hand/left-hand	061 285	1
• Pneumatic hold-down clamp complete	072 146	1
• Retrofit suction extractor housing for Blue Max mini Type 2/3	073 949	1
• Insertion unit without die for Blue Max mini Type 3	070 032	1
• Insertion unit without die for Blue Max mini Type 2	072 446	1
• Universal die for Intermat, Ecomat, Slide-on and Selekt 4 hinges	061 355	1
• Die for Selekt Pro 2000, hole pattern T23	010 079	1
• Die for knock-in mounting plate system 9000	046 796	1
• Die for VB 18/19/20/21	072 147	1
• Die for VB 36	072 148	1
Other dies on request		



Pneumatic hold-down clamp



Die for VB 36



Set of drill bits for Blue Max mini



Insertion unit for Blue Max mini Type 3 equipped with universal die

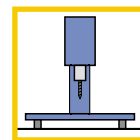
Accessories for Blue Max mini, Type 2/Type 3	Order no.	PU
Drill bits, tungsten carbide tipped		
• Set of drill bits for Blue Max mini Type 2 and Type 3 with 4-spindle boring head , containing: 1 x $\varnothing$ 35 mm right-hand, 2 x $\varnothing$ 10 mm left-hand	072 144	1 set
• Set of drill bits for Blue Max mini Type 3 with 6-spindle boring head , containing: 1 x $\varnothing$ 35 mm right-hand, 2 x $\varnothing$ 10 mm left-hand 2 x $\varnothing$ 5 mm left-hand	070 033	1 set
• Set of drill bits for VB 36, containing: 1 x $\varnothing$ 20 mm right-hand, 1 x $\varnothing$ 10 mm left-hand	070 034	1 set
• Set of drill bits for VB 18/19/20/21, containing: 1 x $\varnothing$ 30 mm right-hand, 1 x $\varnothing$ 10 mm left-hand	070 035	1 set
• Chuck plug	076 497	1

• Drill bits				
Diameter	Length	right-hand	left-hand	PU
40 mm	57 mm	069 250		1
35 mm	57 mm	053 955	074 438	1
35 mm ¹⁾	57 mm	072 404		1
30 mm	57 mm	069 251	053 954	1
26 mm	57 mm	061 650	058 962	1
25 mm	57 mm	053 945		1
24 mm	57 mm	078 963	052 987	1
20 mm	57 mm	053 944	053 953	1
19 mm	57 mm	078 042	052 986	1
18 mm	57 mm	073 099	073 143	1
15 mm	57 mm	053 943	061 651	1
14 mm	57 mm	053 941	053 942	1
12 mm	57 mm	053 819	053 820	1
10 mm	57 mm	053 952	053 951	1
8 mm	57 mm	053 817	053 818	1
7,5 mm	57 mm	061 652	061 653	1
7 mm	57 mm	071 722	071 721	1
6 mm	57 mm	072 039	072 040	1
5 mm	57 mm	053 950	053 949	1
4 mm	57 mm	072 163	071 723	1
3 mm	57 mm	070 025	070 026	1
2 mm	57 mm	071 897	071 896	1
8 mm	70 mm	065 561	065 562	1
8 mm ²⁾	50 mm	058 961		1

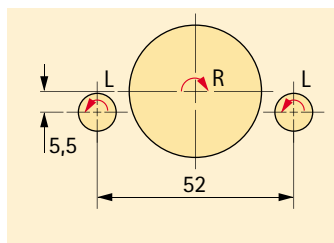
¹⁾ without centring pin

²⁾ for lock-bush drilling

Installing hardware

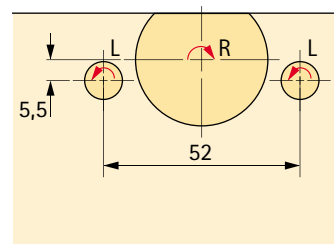


Blue Max mini installs hinges, connecting fittings and knock-in mounting plates.



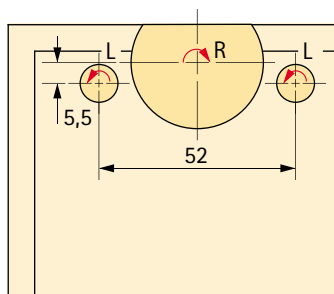
Intermat / Ecomat and Slide-on concealed hinges for compact furniture and folding door hinges with pivot offset (see **group 3**)
Cup diameter 35 mm

Additional holes for cross mounting plate on Blue Max mini Type 3 with 6-spindle boring head!



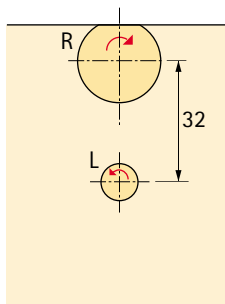
Selekt/Selekt Pro 2000 single-pivot hinges for office furniture,
Cup diameter 35 mm

Additional holes for cross mounting plate on Blue Max mini Type 3 with 6-spindle boring head!



Konsul hinges for period furniture with rebated doors,
Cup diameter 35 mm

Additional holes for cross mounting plate on Blue Max mini Type 3 with 6-spindle boring head!



Holes for connecting fitting and dowel