Model Type - Pages 6-27

**Pneumatic Feed and Drive**
- AFD205 0.29HP (0.22kW)
- AFD215 0.29HP (0.22kW)
- AFD415 0.50HP (0.38kW)
- AFD/AFT60 0.70HP (0.52kW)

**Pneumatic Feed, Electric Drive**
- AFDE200 0.33HP (0.25kW)
- AFDE400 0.40HP (0.33kW)
- AFDE410 1.00HP (0.75kW)
- AFDE600 0.40HP (0.33kW)
- AFDE610 1.00HP (0.75kW)
- AFDE620 1.50HP (1.10kW)
- AFDE700 2.00HP (1.50kW)
- AFDE710 3.00HP (2.20kW)

**Electric Feed and Drive via Leadscrew**
- AFTE270 0.24HP (0.18kW)
- AFTE470 0.50HP (0.38kW)
- AFTE480 1.00HP (0.75kW)

**No Load Speed** - Pages 6-27
The free output speed of the drill or tapper with no drilling or tapping load applied.

Control Block - Page 28
- A1 – Full feature type\(^{(1)}\) – Automatic cycle
- A6 – Simple type\(^{(1),(2)}\) – Remote cycle control
- A7 – Leadscrew type – PNP
- A8 – Leadscrew type – NPN

Output Spindle\(^{(2)}\) - Pages 30/31
Output spindle to be supplied.

---

(1) Not required on AFTE models.
(2) Does not apply for AFD60 and AFT60.

**How to Order**

AFDE400 - 2850 - A1 + B24

- Model Code
- No Load Speed
- Control Block
- Output Spindle
Control Blocks

A1 Full Feature Control Block
Part No. 436313

A6 Simple Control Block
Part No. 103862

Electrical Interfaces (not included with control blocks)

C10 Part No. 438223
Comprises:
2 x M8 Proximity Switches PNP (NO)
2 x Plug-in Cables
2 x Solenoid Valves (NC)

C11 Part No. 438233
Comprises:
2 x M8 Proximity Switches PNP (NO)
2 x Plug-in Cables
1 x Solenoid Valve (NC)
1 x Solenoid Valve (NO)

C12 Part No. 438243
Comprises:
2 x M8 Proximity Switches NPN (NO)
2 x Plug-in Cables
2 x Solenoid Valves (NC)

C3 Part No. 104002
Comprises:
2 x M8 Proximity Switches PNP (NO)
2 x Plug-in Cables

C5 Part No. 104842
Comprises:
2 x M8 Proximity Switches NPN (NO)
2 x Plug-in Cables

Solenoid Valves
All 24V DC
NC - Valve normally closed
NO - Valve normally open

Proximity Switches
All 10-30V DC
NC - Normally closed
NO - Normally open

AFD60/AFT60 Control Block (Supplied fitted)

Air connection as above except M port which is negative at datum.
To invert signal use kit Part No. 104822
adjustable feed control unit

Minimises burring on breakthrough. Constant feed maintained in all operating conditions. Hydraulic fluid sealed for life.

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>MIN. PLUNGER STROKE</th>
<th>MAX. LOAD AT 2230N (500LBS) LOAD</th>
<th>MAXIMUM FEED RATE AT 2230N (500LBS) LOAD</th>
<th>MAX. STROKE</th>
<th>A (in)</th>
<th>B (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>D1</td>
<td>199</td>
<td>7.83</td>
<td>30.1</td>
<td>1.19</td>
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<td></td>
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<tr>
<td>D2</td>
<td>276</td>
<td>10.87</td>
<td>55.5</td>
<td>2.19</td>
<td></td>
<td></td>
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<tr>
<td>D3</td>
<td>352</td>
<td>13.86</td>
<td>80.9</td>
<td>3.19</td>
<td></td>
<td></td>
</tr>
<tr>
<td>D7</td>
<td>417</td>
<td>16.42</td>
<td>106</td>
<td>4.17</td>
<td></td>
<td></td>
</tr>
<tr>
<td>D8</td>
<td>474</td>
<td>18.66</td>
<td>132</td>
<td>5.20</td>
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<td></td>
</tr>
</tbody>
</table>

To fit an adjustable Hydraulic Control Unit to an AFD60 use kit Part No. 94982.

peck feed control

Used when hole depth is five times hole diameter. Helps clear chips, avoids overheating and bit breakage. Hole accuracy is improved. For use with Full Feature Control Block.

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>D4</td>
<td>1&quot; (25mm) stroke</td>
</tr>
<tr>
<td>D5</td>
<td>2&quot; (50mm) stroke</td>
</tr>
<tr>
<td>D6</td>
<td>3&quot; (75mm) stroke</td>
</tr>
</tbody>
</table>

To fit Peck Feed or Skip Feed Control to an AFD60 order kit Part No. 94982 in addition to the above.

dwell control

Used to dwell drill bit at bottom of stroke. Can be used to spot face, blind hole polish, friction weld plastic components and spin rivet. For use with Full Feature Control Block.

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>E1</td>
<td>Dwell Control Unit Complete</td>
</tr>
<tr>
<td>-</td>
<td>Dwell for AFD60</td>
</tr>
</tbody>
</table>

skip feed control

Skip Drilling – custom H.C.U.’s available on request. Skip control ensures minimum cycle times without breakthrough burrs when drilling tubes, pocketed castings etc, with two controlled feed movements linked by a distance of fast travel.

Information Required
1. Depth of first cut
2. Depth of skip
3. Depth of second cut
4. Drill point angle

To fit Peck Feed or Skip Feed Control to an AFD60 order kit Part No. 94982 in addition to the above.