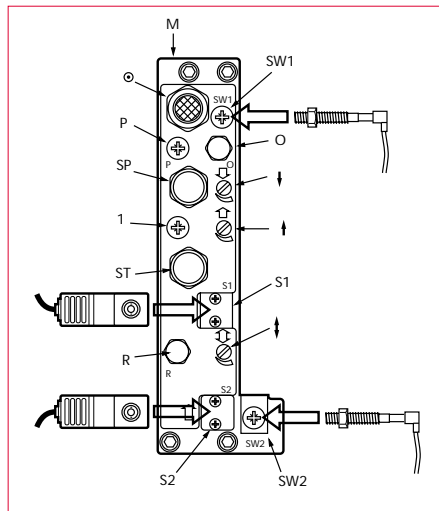
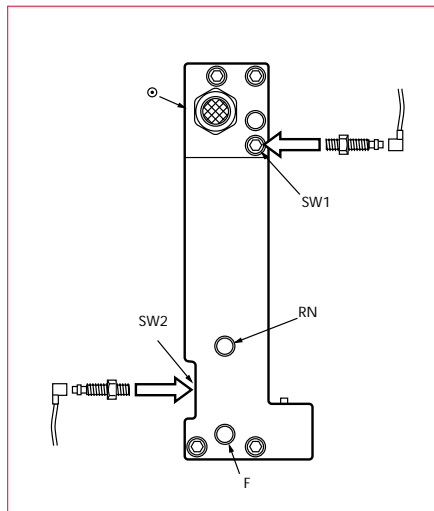


Control Blocks

A1 Full Feature Control Block Part No. 436313



A6 Simple Control Block Part No. 103862



Air Connections

- R Air Return Port – Connects to breather port in nose of tool to provide extra retract capability with heavy front end attachments (1/8" BSP)
- ST Start Button – For manual operation and set-up
- 1 Remote Start Signal Port Pulse (M5)
- SP Manual Stop Button – Interrupts cycle and returns AFD to datum
- P Remote Stop Signal Port – Requires external signal pulse for returning the unit to datum rest position (M5)
- O Air inlet (1/4" BSP or 1/4" NPT)
- M Work Cycle Complete Port – Used for sequence control with other AFD's clamps, index tables, etc (positive at datum position) (M5)
- O Depth Stop Signal Port – Used with external circuits such as dwell or pecking (1/8" BSP)
- ↑ Retract rate adjustment control
- ↓ Advance rate adjustment control
- ↕ Feed rate adjustment control
- F Feed port (1/8" BSP)
- RN Return port (1/8" BSP)

Electrical Connections

- S1 Start solenoid
- S2 Stop solenoid
- SW1 Datum return (M8 x 1.00)
- SW2 Depth position (M8 x 1.00)

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

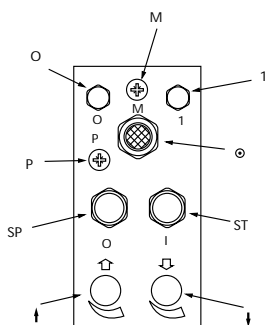
Solenoid Valves

- 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)*

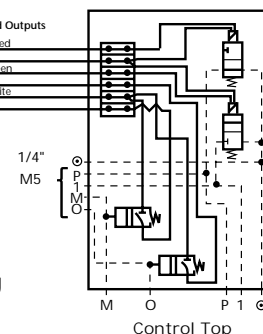


Air connection as above except M port which is negative at datum.
To invert signal use kit Part No. 104822

Electrical Inputs and Outputs

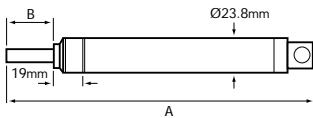
- 24VDC Switched Red
- 0V Common Black
- 24VDC Switched Green
- Switch Yellow
- Switch Common White
- Switch Blue

Electrical Interface
Part No. 79532
24V DC
Comprises:
2 metre cable
Adaptor and O ring
Interface block



adjustable feed control unit

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

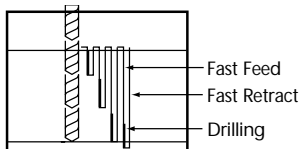


Adjustable Hydraulic Control Unit

	MIN. PLUNGER OPERATING LOAD		MAX. LOAD		MINIMUM FEED RATE AT 2230N (500LBS) LOAD		MAX. STROKE		A		B		PART NO.
	kg	lbs	kg	lbs	mm/sec	in/sec	mm	in	mm	in	mm	in	
D1	2.3	5	544	1200	0.73	0.029	25	1	199	7.83	30.1	1.19	91942
D2	2.3	5	544	1200	0.73	0.029	50	2	276	10.87	55.5	2.19	91952
D3	2.3	5	544	1200	0.73	0.029	75	3	352	13.86	80.9	3.19	91962
D7	4.1	9	357	785	0.45	0.018	102	4	417	16.42	106	4.17	104452
D8	4.1	9	357	785	0.45	0.018	127	5	474	18.66	132	5.20	104462

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

peck feed control

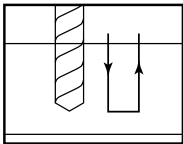


Peck Feed Control Unit

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.

D4	25mm (1") stroke	92282
D5	50mm (2") stroke	92292
D6	75mm (3") stroke	92302

dwell control

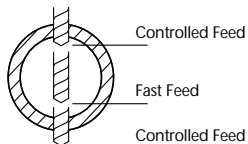


Dwell Control

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.

E1	Dwell Control Unit Complete	92372
-	Dwell for AFD60	78482

skip feed control



Skip Drilling

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.

Output Spindles



- Interchangeable modular output spindles
- Precision option for collet types, R2 and R36

AFD205/AFD215, AFDE200, AFTE270

	FUNCTION	ORDER CODE	FEATURES	PART NO.	RECOMMENDED SPEED RANGE
	High Speed Output Spindle	K42	Collet Chuck can be fitted to any AFDE200 to step up speed by 4.28 : 1. Note: Max. allowable speed 27000 rpm. See page 29 for collets.	375263	≤5250 rpm
	Collet Chuck	K2	See page 31 for range of collets.	357183	≤18800 rpm
	No. 1 Jacobs Taper Output Spindle	K32	No. 1 Jacobs Taper and for use with chucks or multi spindle heads	382213	≤9600 rpm
	Tapping Head Output Spindle	H21	4.5-8.0mm (3/16"-5/16") capacity	357193	≤1200 rpm

AFD415, AFDE400/410, AFDE600/610/620, AFTE470/480

	FUNCTION	ORDER CODE	FEATURES	PART NO.	RECOMMENDED SPEED RANGE													
	10mm (3/8") Key Adjustable Chuck Output Spindle	B1	Part No. includes chuck key	327723	≤9600													
	Integral Collet Chuck Output Spindle	B2	Up to 7mm (0.276") collet capacity (see page 31 for Collet Range)	326573	≤18000													
		R2	Standard Output Assembly Precision Output Assembly	384113														
	Large Integral Collet Chuck Output Spindle	R36	Up to 16mm (0.63") collet capacity (see page 31 for Collets)	389273	≤18000													
		B24	No. 2 Jacobs Taper A = 30 (1.18")	326593														
	Taper Output Spindle and for use with chucks and multi spindle heads	B32	No. 1 Jacobs Taper A = 24.1 (0.95")	355263	≤9600													
		B16	B16 Taper Output A = 34.8 (1.37")	368163														
	Preset Tooling DIN55058 Output Spindle	<table border="1"> <thead> <tr> <th>ØA</th> <th>ØB</th> <th>C</th> <th>D</th> </tr> <tr> <th>mm</th> <th>mm</th> <th>mm</th> <th>mm</th> </tr> </thead> <tbody> <tr> <td>16</td> <td>25</td> <td>74</td> <td>79</td> </tr> </tbody> </table>			ØA	ØB	C	D	mm	mm	mm	mm	16	25	74	79		≤5450
		ØA	ØB	C	D													
mm	mm	mm	mm															
16	25	74	79															
B3	Standard Output Assembly	326563																
	Preset Tooling TMS Standard Output Spindle	<table border="1"> <thead> <tr> <th>ØA</th> <th>ØB</th> <th>C</th> <th>D</th> </tr> <tr> <th>ins</th> <th>ins</th> <th>ins</th> <th>ins</th> </tr> </thead> <tbody> <tr> <td>5/8"</td> <td>1</td> <td>2.62</td> <td>2.85</td> </tr> </tbody> </table>			ØA	ØB	C	D	ins	ins	ins	ins	5/8"	1	2.62	2.85		≤5450
		ØA	ØB	C	D													
ins	ins	ins	ins															
5/8"	1	2.62	2.85															
B33	Standard Output Assembly	356373																
	AFD415, AFDE400 Externally Adjustable Screwdriver Head Output Spindle	B5	1/4" fem. hex. drive. Torque range 0.3 - 11 Nm (2.7 - 100 ins. lbs.)	324903	≤2100													
		B6	5/16" fem. hex. drive. Torque range 0.3 - 11 Nm (2.7 - 100 ins. lbs.)	324913														
	AFD415, AFDE400/410 Tapping Head Output Spindle	B7	3.5 - 6.5mm (9/64" - 1/4") capacity	92362	≤1450													
		B8	4.5 - 8mm (3/16" - 5/16") capacity	92892														
	AFDE600/610 Tapping Head Output Spindle	J19	4.5 - 9.5mm (3/16" - 3/8") capacity For use with B24 output	383813	≤1450													

AFDE700/710

	FUNCTION	ORDER CODE	DESCRIPTION	PART NO.
	Standard machine taper. Adapts to numerous standard machining heads and equipment.	T34	ISO30 output taper, DIN 2080	362443
	Tooling spindles for 'automotive' preset tooling.	T3	Preset tooling spindle to DIN 55058 Accepts tooling to DIN 6327 28mm diameter, 85mm (3.35 inch) deep	362453
	Tooling spindles for 'automotive' preset tooling.	T33	Preset tooling spindle to T.M. Smith standard 1 1/8" diameter, 3.3" (84mm) deep	373333
	Accepts straight shank drills up to 20mm diameter (7/8")	T2	ER32 collet output spindle (See below for collets) Maximum drill depth 48mm (1.89")	362463
	Drive spindle for use with multi-head or angle head.	T35	Drive adaptor for multi-heads or angle head	373343

Collets

For use with B2 (326573), R2 (384113), K2 (357183), K42 (375263) ER11 TYPE					
size	part no.	size	part no.	size	part no.
0.5 - 1.0 (0.020 - 0.039)	52582	2.1 - 2.5 (0.083 - 0.098)	52622	4.1 - 5.0 (0.161 - 0.197)	52652
1.1 - 1.5 (0.043 - 0.059)	52592	2.6 - 3.0 (0.102 - 0.118)	52632	5.1 - 6.0 (0.201 - 0.234)	52662
1.6 - 2.0 (0.063 - 0.079)	52602	3.1 - 4.0 (0.121 - 0.157)	52642	6.1 - 7.0 (0.240 - 0.276)	52672

For use with R36 (389273) ER25 TYPE					
size	part no.	size	part no.	size	part no.
6.0 - 7.0 (0.236 - 0.276)	104942	10.1 - 11.0 (0.397 - 0.433)	104982	14.1 - 15.0 (0.555 - 0.591)	105032
7.1 - 8.0 (0.279 - 0.315)	104952	11.1 - 12.0 (0.437 - 0.472)	104992	15.1 - 16.0 (0.594 - 0.630)	105042
8.1 - 9.0 (0.319 - 0.354)	104962	12.1 - 13.0 (0.476 - 0.512)	105002		
9.1 - 10.0 (0.358 - 0.394)	104972	13.1 - 14.0 (0.516 - 0.551)	105022		

For use with T2 (362463) ER32 TYPE					
size	part no.	size	part no.	size	part no.
5.0 - 6.0 (0.197 - 0.236)	105092	10.1 - 11.0 (0.397 - 0.423)	105152	15.1 - 16.0 (0.594 - 0.630)	105202
6.1 - 7.0 (0.240 - 0.276)	105102	11.1 - 12.0 (0.437 - 0.472)	105162	16.1 - 17.0 (0.634 - 0.669)	105222
7.1 - 8.0 (0.279 - 0.315)	105122	12.1 - 13.0 (0.476 - 0.512)	105172	17.1 - 18.0 (0.673 - 0.709)	105232
8.1 - 9.0 (0.319 - 0.354)	105132	13.1 - 14.0 (0.516 - 0.551)	105182	18.1 - 19.0 (0.713 - 0.748)	105242
9.1 - 10.0 (0.358 - 0.394)	105142	14.1 - 15.0 (0.555 - 0.591)	105192	19.1 - 20.0 (0.752 - 0.787)	105252



Chucks

drilling chucks

	FUNCTION	DESCRIPTION	PART NO.
Max Drill Depth 15mm (0.59") No. 1 Taper	6.5mm (1/4") Key Adjustable Chuck	Part No. includes Chuck Key. Use with No. 1 standard Jacobs taper outputs K32 and B32	29492
Max Drill Depth 34mm (1.34") No. 2 Taper	10mm (3/8") Key Adjustable Chuck	Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24	34752
Max Drill Depth 52mm (2.04") No. 2 Taper	13mm (1/2") Key Adjustable Chuck	Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24	34332

tapping chucks

	FUNCTION	DESCRIPTION	CHUCK PART NO.
		JACOBS TAPER FITTING A B Ø TAP SHANK mm in mm in mm in	
Optional Collets	Tapping Chucks with flexible Collet (included)	No. 1 64 2.5 27 1.1 3.5-6.5 9/64-1/4 No. 1 64 2.5 27 1.1 4.5-8 3/16-5/16 No. 2 79 3.1 37 1.5 4.5-9.5 3/16-3/8	29462 29452 34742
	Spare or replacement Collets	2-4.5mm (5/64-3/16") Capacity to suit 29462/29452 3.5-6.5mm (9/64-1/4") Capacity to suit 29462/29452 4.5-8mm (3/16-5/16") Capacity to suit 29462/29452 4.5-9.5mm (3/16-3/8") Capacity to suit 34742 9-12.5mm (9/32-1/2") Capacity to suit 34742	75142 29482 29472 36172 39242

drill bit/cutter adaptors

	FUNCTION	DESCRIPTION	PART NO.
No.2 Morse Taper No.2 Jacobs Taper	Morse Taper Adaptor	No. 2 Jacobs female taper to No. 2 Morse female taper	34862
2 off M4 Screws	Ø 10mm Shank Cutter Adaptor	Fits thread of Single Collet Chuck – Part Nos. 326573 and 384113 and Multi Heads – Part Nos. 52362, 52462, 92162, 92172, 104022, 104062	53232

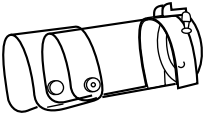
multiple spindle heads

	FUNCTION	DESCRIPTION	PART NO.
Multi-spindle drilling/tapping heads 	Fixed and adjustable spindle multi-heads (see page 34)	When ordering state number of spindles, diameter of holes, material to be drilled and hole pattern required	-
Angle heads/ Offset heads 	Angle heads available to order to suit AFDE400/410/600/610/620/700/710/AFD415	When ordering state details of application, material to be machined, size and depth of cut	-

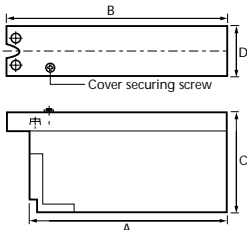


Guards

chuck guards

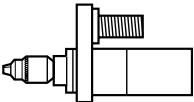
	FEATURES	TOOL TYPES	PART NO.
	To prevent the user inadvertently touching rotating parts	AFD205/215, AFDE200, AFTE270 AFD415, AFDE400/410, AFTE470/480 AFD60/AFDE600/610/620	66132 66122 304863

control head guard

	FEATURES	TOOL TYPES	PART NO.								
	Control Top Guard to enclose crosshead (supplied with AFD60 as standard)	AFD60, AFT60	259093								
	<table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>210mm (8.3")</td> <td>236mm (9.3")</td> <td>108mm (4.3")</td> <td>55mm (2.2")</td> </tr> </tbody> </table>	A	B	C	D	210mm (8.3")	236mm (9.3")	108mm (4.3")	55mm (2.2")		
A	B	C	D								
210mm (8.3")	236mm (9.3")	108mm (4.3")	55mm (2.2")								

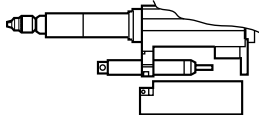
Silencers

AFD/AFT silencer

	FEATURES	TOOL TYPES	PART NO.
	Exhaust silencer fitted with 1/4" BSP screw-in silencer	AFD205, AFD215 AFD415 AFD60, AFT60	91262 70642 70652

Miscellaneous Accessories

AFD205/215 HCU inverting kit

	FEATURES	TOOL TYPES	PART NO.
	HCU Inverting Assembly	Particularly for use with AFD205 for applications with height restrictions	381003

AFD205/215, AFDE200, AFTE270 sealing ring

	FEATURES	TOOL TYPES	PART NO.
	Sealing Ring	Threaded on to nose of unit in place of protection cap. Forms seal on quill shaft to prevent ingress of swarf.	104432



Multiple Spindle Heads



- Range of adjustable spindle positions for 2, 3 and 4 spindle heads
- Special fixed spindle heads available for non standard hole patterns or dedicated applications

drilling

specification

Multiple Spindle Head Part Numbers

NUMBER OF SPINDLES	SPINDLE CENTRES OR PCD		MAXIMUM COLLET SIZE		AFD205 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480	COLLET TYPE (SEE PAGE 36)
	mm	ins	mm	ins								
2	9.5-54	0.37-2.13	4.00	0.157	174183	92142	-	-	-	-	-	A
	12.7-64	0.50-2.52	6.50	0.256	-	92152	-	-	-	-	-	B
	18.4-87.3	0.72-3.44	7.00	0.276	-	92162	52362	104062	-	-	-	C
	19-95	0.75-3.74	9.50	0.374	-	106662	204183	106672	-	-	-	D
	41.1-109.9	1.62-4.33	7.00	0.276	-	92172	52462	104022	-	-	-	C
3 inline	19.0-57.1	0.75-2.25	9.50	0.374	-	107552	107572	107562	-	-	-	D
3 PCD	27.9-104.1	1.01-4.01	9.50	0.374	-	107582	107602	107592	-	-	-	D
4 PCD	42.7-118.9	1.68-4.68	9.50	0.374	-	-	107622	107612	-	-	-	D
Fixed	-	-	-	-	-	MSD100	MSD200	MSD200	MSD300	-	-	-

tapping⁽¹⁾

specification

Multiple Spindle Head Part Numbers

NUMBER OF SPINDLES	SPINDLE CENTRES OR PCD		MAXIMUM COLLET SIZE		AFD205 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480	COLLET TYPE (SEE PAGE 36)
	mm	ins	mm	ins								
2	9.5-54	0.37-2.13	4.00	0.157	-	-	-	-	-	174183	92142	A
	12.7-64	0.50-2.52	6.50	0.256	204173	92222	-	-	-	-	92152	B
	18.4-87.3	0.72-3.44	7.00	0.276	-	92232	-	104122	-	-	92162	C
	19-95	0.75-3.74	9.50	0.374	-	106682	204193	106692	-	-	106662	D
	41.1-109.9	1.62-4.33	7.00	0.276	-	92242	-	104072	-	-	92172	C
3 inline	19.0-57.1	0.75-2.25	9.50	0.374	-	107632	107652	107642	-	-	107552	D
3 PCD	27.9-104.1	1.01-4.01	9.50	0.374	-	107662	107682	107672	-	-	107582	D
4 PCD	42.7-118.9	1.68-4.68	9.50	0.374	-	-	107702	107692	-	-	-	D
Fixed	-	-	-	-	-	MST100	MST200	MST200	MSD300	-	MSD100	-

output spindles for use with multiple spindle heads⁽²⁾

specification

Multiple Spindle Head Part Numbers

AFD205 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480
K32	B24	-	B24	T35	K32	B24

⁽¹⁾ All tapping heads incorporate a reversing gearbox except heads for AFDE700/710 and AFTE270/470/480

⁽²⁾ How to order

Examples:

AFDE200-2850-A1 + K32 + 174183

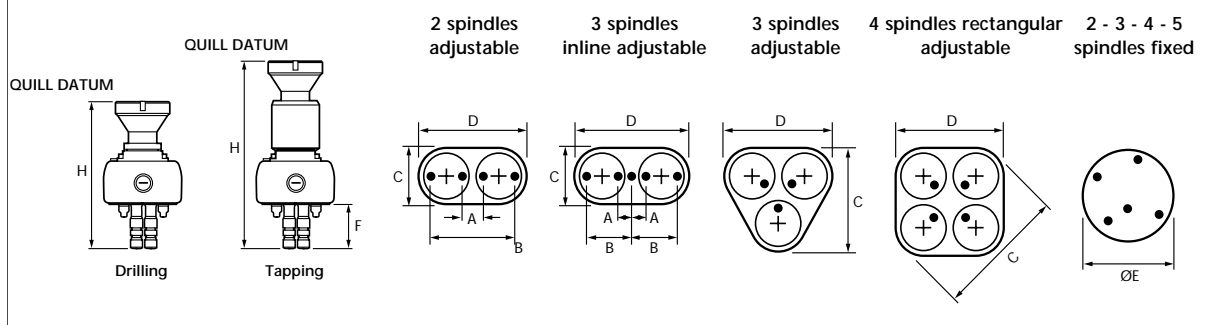
AFD415-3400-A6 + B24 + 107552

AFDE610-900-A1 + B24 + 107672

AFD60-2100 + 52362

AFDE70-950-A1-T35 + MSD300

Multiple Spindle Heads dimensions



adjustable spindle

specification

PART NO.	MAXIMUM SPEED	MINIMUM/MAXIMUM CENTRES		PCD		MINIMUM PCD		MAXIMUM PCD		C		D		F		H	
	rpm	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins
52362	8500	18.4 - 87.3	0.72 - 3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	193.5	7.62		
52462	8500	41.1 - 109.9	1.62 - 4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	193.5	7.62		
92142	5300	9.5 - 54	0.37 - 2.13	-	-	-	-	50.8	2.00	83	2.27	50.8	2.00	175.4	6.91		
92152	5300	12.7 - 64	0.50 - 2.52	-	-	-	-	50.8	2.00	83	2.27	50.8	2.00	175.4	6.91		
92162	8500	18.4 - 87.3	0.72 - 3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72		
92172	8500	41.1 - 109.9	1.62 - 4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
92222	1400	12.7 - 64	0.50 - 2.52	-	-	-	-	50.8	2.00	83	3.27	50.8	2.00	233.8	9.20		
92232	1400	18.4 - 87.3	0.72 - 3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	253	9.96		
92242	1400	41.1 - 109.9	1.62 - 4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	253	9.96		
104022	8500	41.1 - 109.9	1.62 - 4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
104062	8500	18.4 - 87.3	0.72 - 3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72		
104072	1400	41.1 - 109.9	1.62 - 4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	233.5	9.19		
104122	1400	18.4 - 87.3	0.72 - 3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72		
106662	5300	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	212	8.35		
106672	5300	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	211	8.31		
106682	1500	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	261.5	10.30		
106692	1500	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260	10.24		
107552	5300	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	212.3	8.36		
107562	5300	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	188	7.40		
107572	5300	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	212.3	8.36		
107582	5300	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	212.3	8.36		
107592	5300	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	211.2	8.31		
107602	5300	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	188	7.40		
107612	5300	-	-	42.7	-	118.9	4.68	147.6	5.81	130.4	5.13	68.3	2.69	211.2	8.31		
107622	5300	-	-	42.7	-	118.9	4.68	147.6	5.81	130.4	5.13	68.3	2.69	188	7.40		
107632	900	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	261.5	10.30		
107642	900	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	260	10.24		
107652	900	19 - 57.1	0.75 - 2.25	-	-	-	-	99.2	3.90	142.9	5.63	68.3	2.69	259.9	10.23		
107662	900	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	261.5	10.30		
107672	900	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	260	10.24		
107682	900	-	-	27.9	1.01	104.1	4.01	120.3	4.74	132.6	5.22	68.3	2.69	259.9	10.23		
107692	900	-	-	42.7	-	118.9	4.68	147.6	5.81	130.4	5.13	68.3	2.69	260	10.24		
107702	900	-	-	42.7	-	118.9	4.68	147.6	5.81	130.4	5.13	68.3	2.69	259.9	10.23		
174183	5300	9.5 - 54	0.37 - 2.13	-	-	-	-	50.8	2.00	83	2.27	50.8	2.00	169.5	6.67		
204173	5300	12.7 - 64	0.50 - 2.52	-	-	-	-	50.8	2.00	83	2.27	50.8	2.00	206.1	8.11		
204183	5300	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	188	7.40		
204193	700	19 - 95	0.75 - 3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260.4	10.25		

fixed spindle

specification

PART NO.	MAXIMUM SPEED	MINIMUM/MAXIMUM CENTRES		MINIMUM PCD		MAXIMUM PCD		OE		F		H	
	rpm	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins
MSD100	5300	9.5-63.5	0.37-2.52	9.5/12.7	0.37/0.50	63.5	2.50	56-81.8	2.20-3.22	37/40.5	1.46/1.59	168/175.4	6.61/6.91
MST100	1400	9.5-63.5	0.37-2.52	9.5/12.7	0.37/0.50	63.5	2.50	56-81.8	2.20-3.22	37/40.5	1.46/1.59	227.8/233.8	8.97/9.20
MSD200	5300	19-95	0.75-3.74	19	0.75	95	3.74	100.8-126.2	3.97-4.97	57.2	2.25	211.1	8.31
MST200	700	19-95	0.75-3.74	19	0.75	95	3.74	100.8-126.2	3.97-4.97	57.2	2.25	260	10.24
MSD300	3500	17.4-157	0.69-6.18	17.4	0.69	157	6.18	150-225	5.91-8.86	26-41	1.02-1.61	221-241	8.70-9.49
MST300	1500	17.4-157	0.69-6.18	17.4	0.69	157	6.18	150-225	5.91-8.86	26-41	1.02-1.61	221-241	8.70-9.49

For fixed spindle heads minimum centres are dependent on collet size, overall diameter on the distance between spindles and overall lengths on collet size. Desoutter can provide dimensions if required.

Always provide details of hole pattern, hole diameters and material to be machined when ordering a fixed spindle head.



Multiple Spindle Heads – Collets

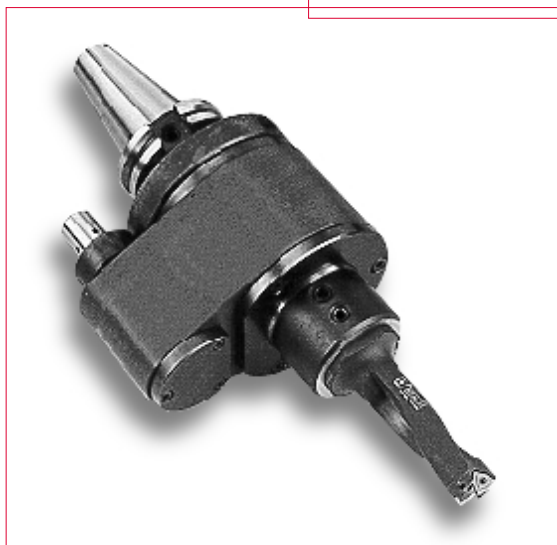


- Collets for multiple spindle heads
- Types A, B and D are threaded types
- Type C are ER11 type

SIZE		COLLET TYPE			
mm	ins	A	B	C	D
0.5	0.020			52582	
0.6	0.024			52582	
0.7	0.028			52582	
0.8	0.031			52582	
0.9	0.035			52582	
1	0.039	60002	39442	52582	
1.1	0.043	60022	39452	52592	
1.2	0.047	60032	39462	52592	
1.3	0.051	60042	39472	52592	
1.4	0.055	60052	39482	52592	
1.5	0.059	60062	39492	52592	
1.6	0.063	60072	27852	52602	
1.7	0.067	60082	39502	52602	
1.8	0.071	60092	27862	52602	
1.9	0.075	60102	39522	52602	
2	0.079	60122	27872	52602	39302
2.1	0.083	60132	27882	52622	39322
2.2	0.087	60142	27892	52622	39332
2.3	0.091	60152	27902	52622	39342
2.4	0.094	60162	27922	52622	39352
2.5	0.098	60172	27932	52622	39362
2.6	0.102	60182	27942	52632	39372
2.7	0.106	60192	27952	52632	39382
2.8	0.110	60202	27962	52632	39392
2.9	0.114	60222	27972	52632	39402
3	0.118	60232	27982	52632	39422
3.1	0.122	60242	27992	52642	39432
3.2	0.126	60252	28002	52642	34902
3.3	0.130	60262	28032	52642	34932
3.4	0.134	60272	28042	52642	34942
3.5	0.138	60282	28052	52642	34952
3.6	0.142	60292	28062	52642	34962
3.7	0.146	60302	28082	52642	34982
3.8	0.150	60322	28092	52642	34992
3.9	0.154	60332	28102	52642	35002
4	0.157	60342	28122	52642	35022
4.1	0.161		28132	52652	35032
4.2	0.165		28142	52652	35042
4.3	0.169		28152	52652	35052
4.4	0.173		28162	52652	35062
4.5	0.177		28172	52652	35072
4.6	0.181		28182	52652	35082
4.7	0.185		28192	52652	35092
4.8	0.189		28202	52652	35102
4.9	0.193		28222	52652	35122
5	0.197		28232	52652	35132

SIZE		COLLET TYPE			
mm	ins	A	B	C	D
5.1	0.201		28252	52662	35152
5.2	0.205		28272	52662	35172
5.3	0.209		28282	52662	35182
5.4	0.213		28292	52662	35192
5.5	0.217		28302	52662	35202
5.6	0.220		28322	52662	35222
5.7	0.224		28332	52662	35232
5.8	0.228		28342	52662	35242
5.9	0.232		28352	52662	35252
6	0.236		28372	52662	35272
6.1	0.240		28382	52672	35282
6.2	0.244		28392	52672	35292
6.3	0.248		28402	52672	35302
6.4	0.252		39532	52672	35332
6.5	0.256		39542	52672	35342
6.6	0.260			52672	35352
6.7	0.264			52672	35362
6.8	0.268			52672	35382
6.9	0.272			52672	35392
7	0.276			52672	35402
7.1	0.280				35422
7.2	0.283				35432
7.3	0.287				35452
7.4	0.291				35462
7.5	0.295				35472
7.6	0.299				35492
7.7	0.303				35502
7.8	0.307				35522
7.9	0.311				35532
8	0.315				35552
8.1	0.319				35562
8.2	0.323				35572
8.3	0.327				35582
8.4	0.331				35592
8.5	0.335				35602
8.6	0.339				35622
8.7	0.343				35632
8.8	0.346				35652
8.9	0.350				35672
9	0.354				35682
9.1	0.358				35692
9.2	0.362				35722
9.3	0.366				35732
9.4	0.370				35752
9.5	0.374				35762

Spindle Coolant Adaptor for the AFDE700 Series



Two types of spindle coolant adaptors are now available for the AFDE700/710.

The adaptors are available with the ER32 style collet holder (maximum collet 20mm) or a 32mm 'U' drill holder. Both are supplied with DIN2080 ISO30 male tapers to fit the T34 output and include a support pillar mounted to the front of the AFDE to take the torque reaction.

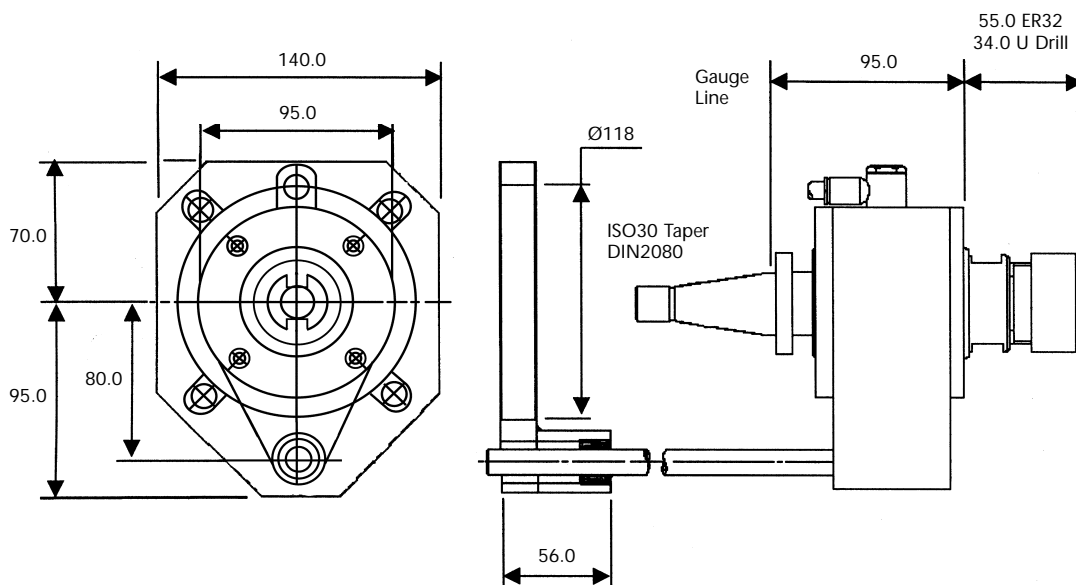
The heads are fully sealed and coolant enters the head via a port on the side of the head suitable for 10mm O.D. and 7mm I.D. pipe.

Maximum Speed – 5000 rpm
 Maximum Coolant Pressure – 25 bar
 Weight – Approx 7 kg (15.5lbs)

ER Collet Type
 32mm 'U' Drill Type

Part No. 107792 (specify collet size at time of order)
 Part No. 107802

dimensions

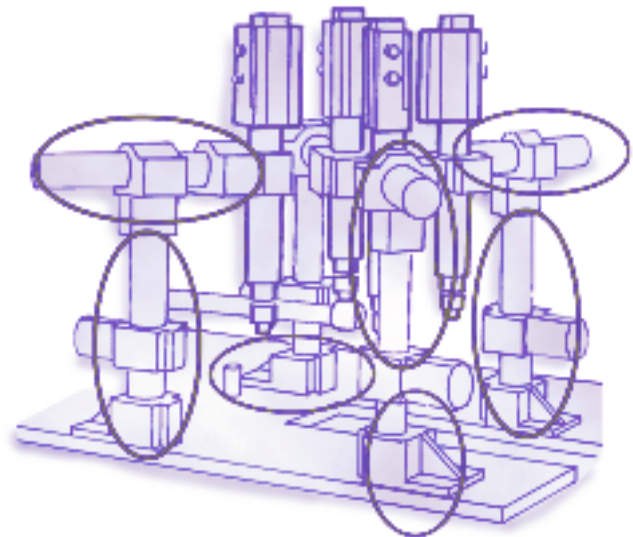
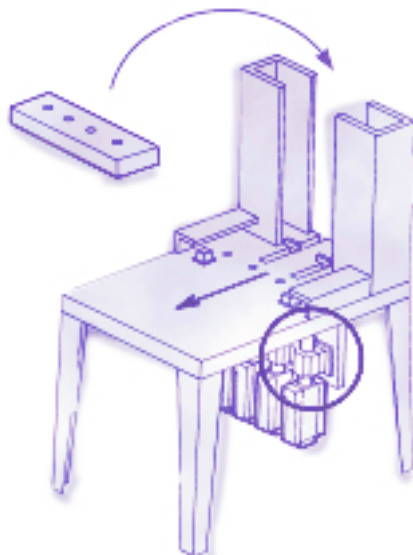
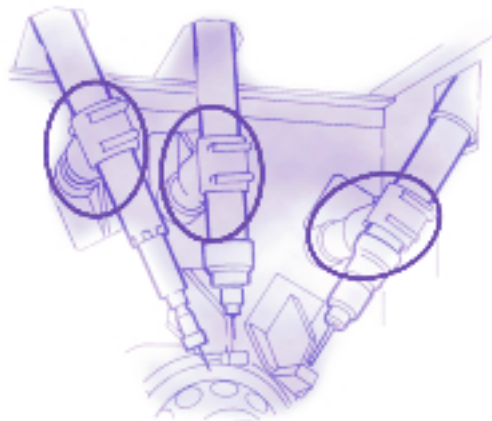




mounting clamps



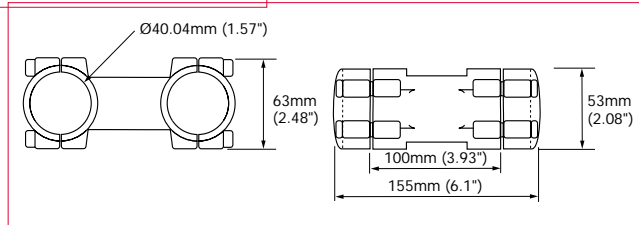
- Extensive range of mounting clamps to allow any orientation of the tool
- All clamps manufactured from aluminium



AFD205, AFDE200, AFTE270

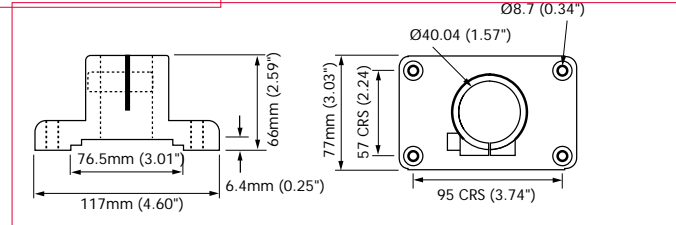
Parallel Clamp

Part No. 61832



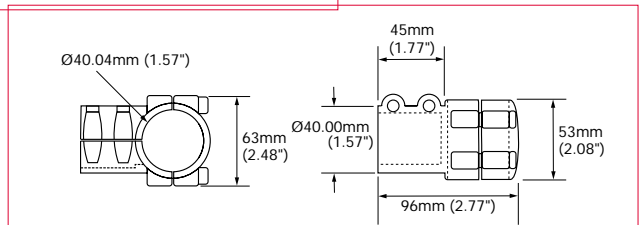
Base Clamp

Part No. 61842



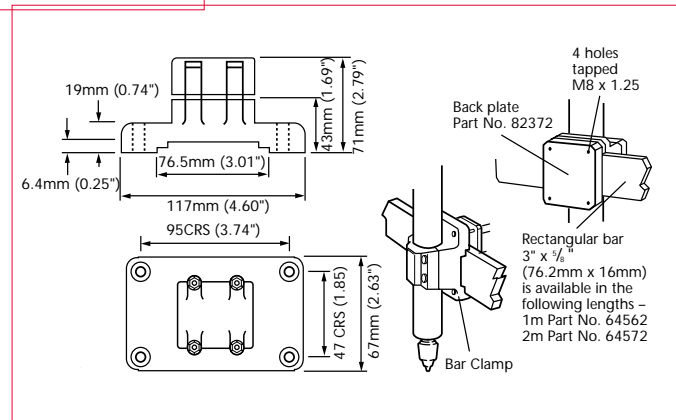
Right Angle Clamp

Part No. 61822



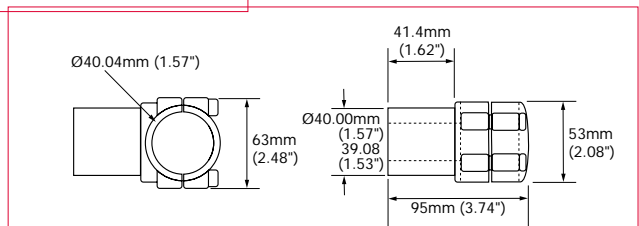
Bar Clamp

Part No. 61852



Swivel Clamp

Part No. 61802



Mounting Tube

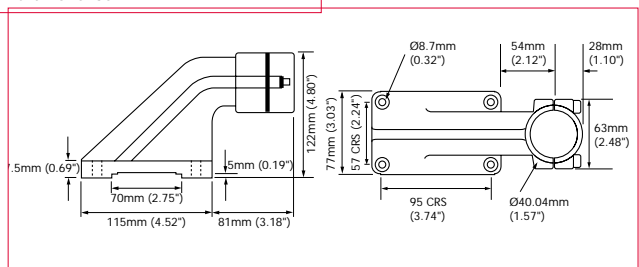


Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

TUBING LENGTH		TUBING Ø		PART NO.
mm	ins	mm	ins	
228	9			39702
305	12	39.97/	1.574/	39722
457	18	40.00	1.575	39732
610	24			39742
760	30			39752

Swan Neck Clamp

Part No. 61862



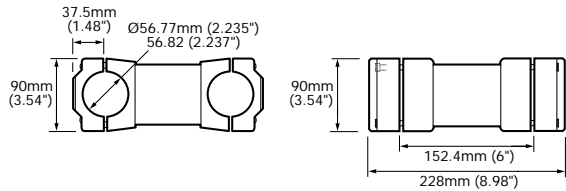
Desouller

Accessories - Grinders

AFD415, AFDE400/410, AFTE470/480

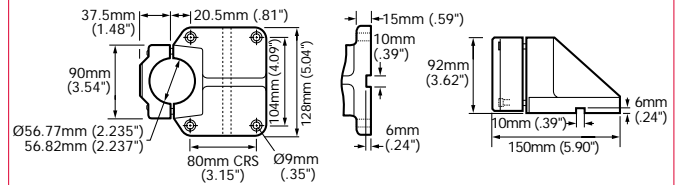
Parallel Clamp

Part No. 76352



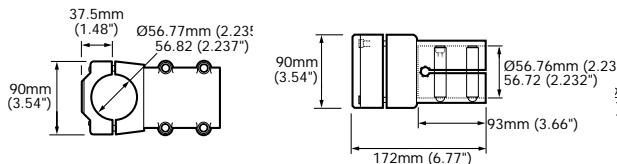
Base Clamp

Part No. 76302



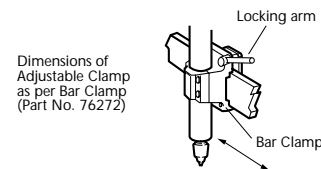
Right Angle Clamp

Part No. 76342



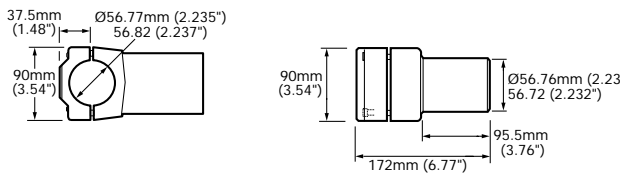
Adjustable Bar Clamp

Part No. 97042



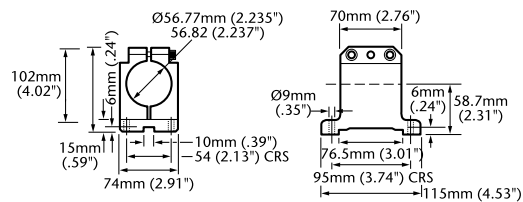
Swivel Clamp

Part No. 76332



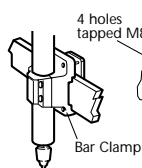
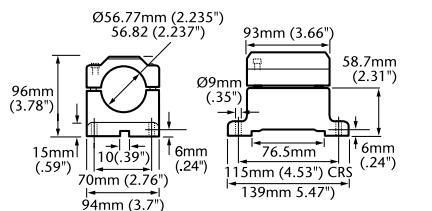
Narrow Bar Clamp

Part No. 76292



Bar Clamp

Part No. 76272



4 holes tapped M8 x 1.25

Rectangular bar $3" \times \frac{1}{4}"$ (76.2mm x 16mm) is available in the following lengths -
1m Part No. 64562
2m Part No. 64572

Back plate Part No. 77782 for use with Bar clamp
Back plate Part No. 77792 for use with Narrow Bar Clamp

Mounting Tube



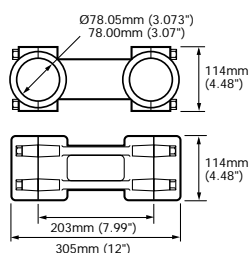
Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

TUBING LENGTH		TUBING Ø		PART NO.
mm	ins	mm	ins	
228	9			9452
305	12	56.76	2.225	9462
457	18	56.73	2.233	9472
610	24			9482
762	30			9492

AFD60, AFT60, AFDE600/610/620

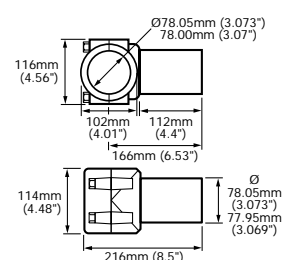
Parallel Clamp

Part No. 32492



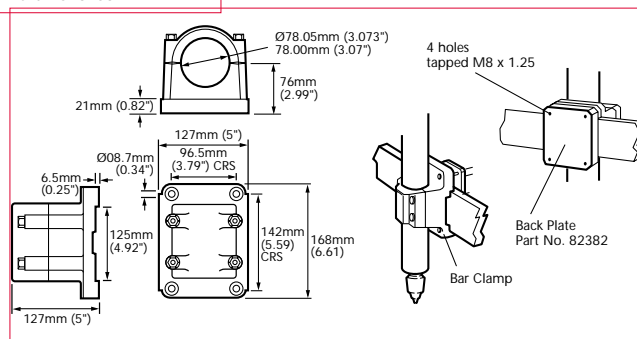
Swivel Clamp

Part No. 32502



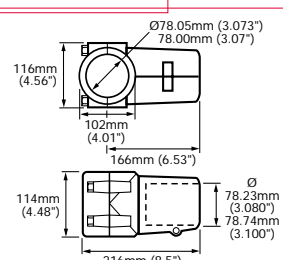
Bar Clamp

Part No. 32532



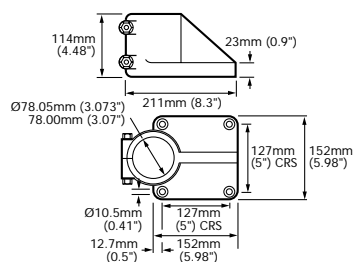
Right Angle Clamp

Part No. 32522



Base Clamp

Part No. 32542



Mounting Tube



Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

TUBING LENGTH		TUBING Ø		PART NO.
mm	ins	mm	ins	
610	24			32562
915	36	77.95/	3.069	32572
1220	48	77.97		32582

Auto Feed Drills and Tappers Product Range



1.1

Product Range