



Output Spindles



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

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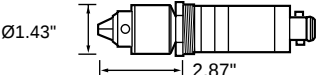
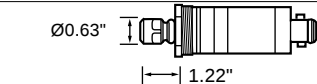
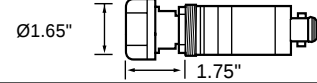
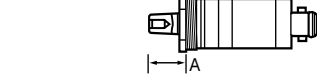
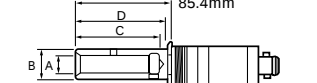
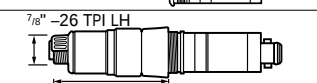
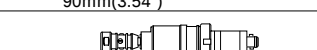
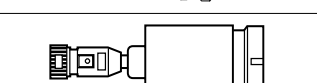
1 800 353 4676

FAX 1 401 679 0165

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	3/16"-5/16" (4.5-8.0mm) capacity	357193	≤1200 rpm

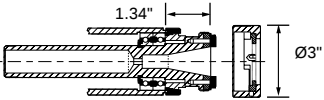
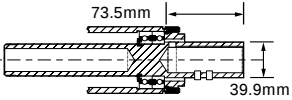
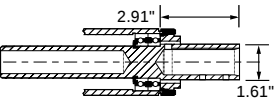
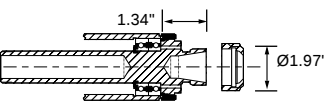
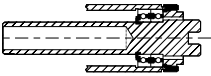
AFD415, AFDE400/410, AFDE600/610/620, AFTE470/480

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



31. Desoutter Inc 24415 Halstead Road Farmington Hills Michigan 48335 USA telephone +1 248 476 5358 facsimile +1 248 476 3819

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 28m diameter, 85mm deep	362453
	Tooling spindles for 'automotive' preset tooling.	T33	Preset tooling spindle to T.M. Smith standard 1 ¹ / ₁₆ " diameter, 3.3" deep	373333
	Accepts straight shank drills up to 20mm diameter (7/8")	T2	ER32 collet output spindle (See below for collets) Maximum drill depth 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.
0.020 - 0.039 (0.5 - 1.0)	52582	0.083 - 0.098 (2.1 - 2.5)	52622	0.161 - 0.197 (4.1 - 5.0)	52652
0.043 - 0.059 (1.1 - 1.5)	52592	0.102 - 0.118 (2.6 - 3.0)	52632	0.201 - 0.234 (5.1 - 6.0)	52662
0.063 - 0.079 (1.6 - 2.0)	52602	0.121 - 0.157 (3.1 - 4.0)	52642	0.240 - 0.276 (6.1 - 7.0)	52672

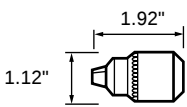
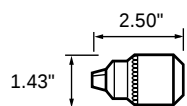
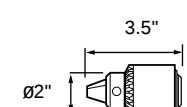
For use with R36 (389273) ER25 TYPE					
size	part no.	size	part no.	size	part no.
0.236 - 0.276 (6.0 - 7.0)	104942	0.397 - 0.433 (10.1 - 11.0)	104982	0.555 - 0.591 (14.1 - 15.0)	105032
0.279 - 0.315 (7.1 - 8.0)	104952	0.437 - 0.472 (11.1 - 12.0)	104992	0.594 - 0.630 (15.1 - 16.0)	105042
0.319 - 0.354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

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

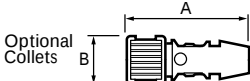


Chucks

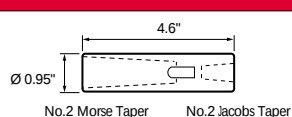
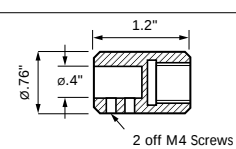
drilling chucks

	FUNCTION	DESCRIPTION	PART NO.
Max Drill Depth 0.59"  No. 1 Taper	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 1.34"  No. 2 Taper	3/8" Key Adjustable Chuck	Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24	34752
Max Drill Depth 2.04"  No. 2 Taper	1/2" Key Adjustable Chuck	Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24	34332

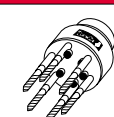
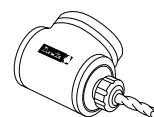
tapping chucks

		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	29462
			No. 1	64	2.5	27	1.1	4.5-8	3/16-5/16	29452
			No. 2	79	3.1	37	1.5	4.5-9.5	3/16-3/8	34742
	Spare or replacement Collets		5/64-3/16" (2-4.5mm) Capacity to suit 29462/29452							75142
			9/64-1/4" (3.5-6.5mm) Capacity to suit 29462/29452							29482
			3/16-5/16" (4.5-8mm) Capacity to suit 29462/29452							29472
			3/16-3/8" (4.5-9.5mm) Capacity to suit 34742							36172
			9/32-1/2" (9-12.5mm) Capacity to suit 34742							39242

drill bit/cutter adaptors

	FUNCTION	DESCRIPTION	PART NO.
	Morse Taper Adaptor	No. 2 Jacobs female taper to No. 2 Morse female taper	34862
	Ø 3/8" Shank Cutter Adaptor	Fits thread of Single Collet Chuck – Part Nos. 326573 and 384113 and Multi Heads – Part Nos. 104062, 104022, 104032, 104042, 104052, 52362, 52462, 52442, 52392, 52422	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 to cut	-



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	20.5-55.5	0.81-2.19	7.00	0.276	–	92182	52442	104032	–	–	–	C
3 PCD	27.3-96.2	1.07-3.79	7.00	0.276	–	92192	52392	104042	–	–	–	C
4 PCD	41.1-109.9	1.62-4.33	7.00	0.276	–	92202	52422	104052	–	–	–	C
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	20.5-55.5	0.81-2.19	7.00	0.276	–	92252	–	104082	–	–	92182	C
3 PCD	27.3-96.2	1.07-3.79	7.00	0.276	–	92262	–	104092	–	–	92192	C
4 PCD	41.1-109.9	1.62-4.33	7.00	0.276	–	92272	–	104102	–	–	92202	C
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** + **92182**

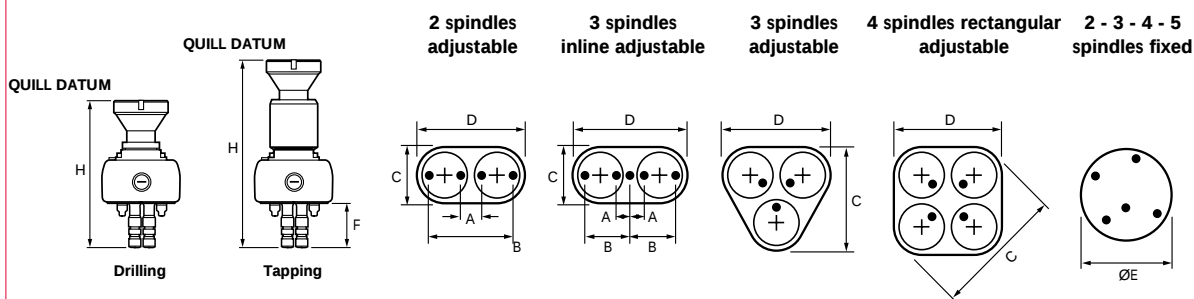
AFDE610-900-A1 + **B24** + **104092**

AFD60-2100 + **52442**

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
174183	5300	9.5-66.7	0.37-2.63	-	-	-	-	50.8	2.00	83	3.27	50.8	2.00	169.5	6.67		
204173	5300	12.7-64	0.50-2.52	-	-	-	-	50.8	2.00	83	3.27	50.8	2.00	206.1	8.11		
92142	5300	9.5-54	0.37-2.13	-	-	-	-	50.8	2.00	83	3.27	50.8	2.00	175.4	6.91		
92152	7000	12.7-64	0.50-2.52	-	-	-	-	50.8	2.00	83	3.27	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		
106662	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	212	8.35		
92172	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
92182	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
92192	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	196	7.72		
92202	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	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	18.4-64	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	253	9.96		
106682	1500	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	261.5	10.30		
92242	1400	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	253	9.96		
92252	1400	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	253	9.96		
92262	1400	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	253	9.96		
92272	1400	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	253	9.96		
52362	8500	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	193.5	7.62		
204183	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	188	7.40		
52462	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	193.5	7.62		
52442	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	193.5	7.62		
52392	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	193.5	7.62		
52422	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	193.5	7.62		
204193	700	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260.4	10.25		
104062	8500	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72		
106672	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	211	8.31		
104022	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
104032	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72		
104042	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	196	7.72		
104052	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	196	7.72		
104122	1400	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72		
106692	1500	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260	10.24		
104072	1400	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	233.5	9.19		
104082	1400	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	233.5	9.19		
104092	1400	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	233.5	9.19		
104102	1400	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	233.5	9.19		

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
MSD100	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
MST200	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			
		A	B	C	D
ins	mm				
0.020	0.5			52582	
0.024	0.6			52582	
0.028	0.7			52582	
0.031	0.8			52582	
0.035	0.9			52582	
0.039	1	60002	39442	52582	
0.043	1.1	60022	39452	52592	
0.047	1.2	60032	39462	52592	
0.051	1.3	60042	39472	52592	
0.055	1.4	60052	39482	52592	
0.059	1.5	60062	39492	52592	
0.063	1.6	60072	27852	52602	
0.067	1.7	60082	39502	52602	
0.071	1.8	60092	27862	52602	
0.075	1.9	60102	39522	52602	
0.079	2	60122	27872	52602	39302
0.083	2.1	60132	27882	52622	39322
0.087	2.2	60142	27892	52622	39332
0.091	2.3	60152	27902	52622	39342
0.094	2.4	60162	27922	52622	39352
0.098	2.5	60172	27932	52622	39362
0.102	2.6	60182	27942	52632	39372
0.106	2.7	60192	27952	52632	39382
0.110	2.8	60202	27962	52632	39392
0.114	2.9	60222	27972	52632	39402
0.118	3	60232	27982	52632	39422
0.122	3.1	60242	27992	52642	39432
0.126	3.2	60252	28002	52642	34902
0.130	3.3	60262	28032	52642	34932
0.134	3.4	60272	28042	52642	34942
0.138	3.5	60282	28052	52642	34952
0.142	3.6	60292	28062	52642	34962
0.146	3.7	60302	28082	52642	34982
0.150	3.8	60322	28092	52642	34992
0.154	3.9	60332	28102	52642	35002
0.157	4	60342	28122	52642	35022
0.161	4.1		28132	52652	35032
0.165	4.2		28142	52652	35042
0.169	4.3		28152	52652	35052
0.173	4.4		28162	52652	35062
0.177	4.5		28172	52652	35072
0.181	4.6		28182	52652	35082
0.185	4.7		28192	52652	35092
0.189	4.8		28202	52652	35102
0.193	4.9		28222	52652	35122
0.197	5		28232	52652	35132

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