Fitting a Multi Head to AFD(E) 41 or 400 or 600 series or AFT(E) 470/480 Series

Basic Layout:

- AFD(E) or AFT
- Output Spindle B24
- Multi Head – Comprising:
  - Lock Nut
  - Snap Ring
  - Drive Adaptor
  - Body

Step One: Fit B24 Output Spindle

Step Two: Fit Lock Nut and Snap Ring – From Multiple Spindle Assembly

Ensure Drive Pin Locates In final drive from the AFD Unit

Lock Nut
R.H.T. 20ftlbs (+/- 10%)

NOTE:
It is easier to fit the snap ring and lock nut with the tool extended. This can be done with two people, one holding the tool forward against the spring return while the other fits the multi-head.
Auto Feed Drills and Tappers  Multi Head Mounting

Step Three  Fit the Drive Adaptor

Step Four  Attach the Multi Head Body

Locks on to Jacob’s No.2 Taper
Retained by screw and washer

Locate Key on Body with Key way on Tool

Turn Lock Nut to Attach Body
Ensure Drive Adaptor Locates In the Drive to the Spindles – Rotate the Spindles To Engage if Necessary
Some multiheads allow the spindle body to be rotated independently of the mounting adaptor through bolts on the head face. If the head does not allow this then to Re-Orientate the Head Relative to the drill unit use the HCU Mounting Bracket – Also for Stroke Adjustment.