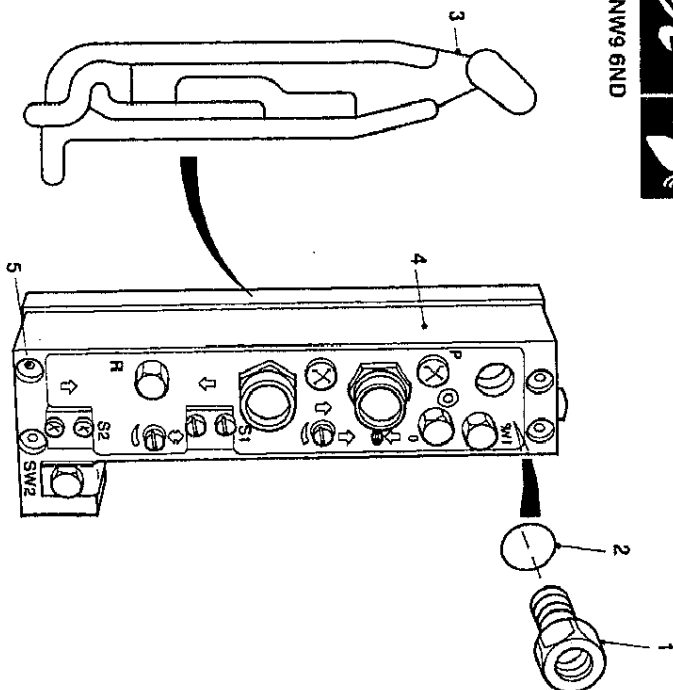


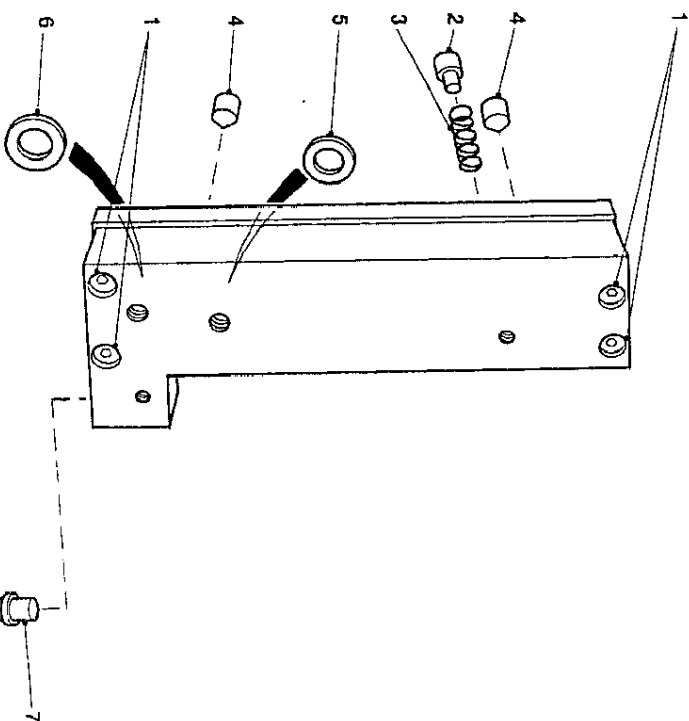
Control Blocks/Blocs de Commande/Steuerblöcke



r Limited, London NW9 6ND



Item No.	Part No.	Description	Qty
Pos. Nr.	Tel. Nr.		Measure
No. Article	Reference		Qte
1	47133	Adaptor	1
	(In NP)		
	42953	Adaptor	1
2	(In BSP)		
	69853	O-Ring	1
3	370393	Seal	1
4	364693	Block	1
5	273653	Screw	4
6		Service kit	
	370943	Seal Kit	1



Item No. Pos. Nr.	Part No. Toll. Nr.	Description	Qty Merge
No. Article	Reference		Clé
1	236373	Screw	4
2	325083	Pin	1
3	51863	Spring	1
4	325073	Pin	2
5	113413	O-Ring	1
6	200713	O-Ring	1
7	325053	Pin	1
8	325063	Bush	1
9	325043	Cap	1

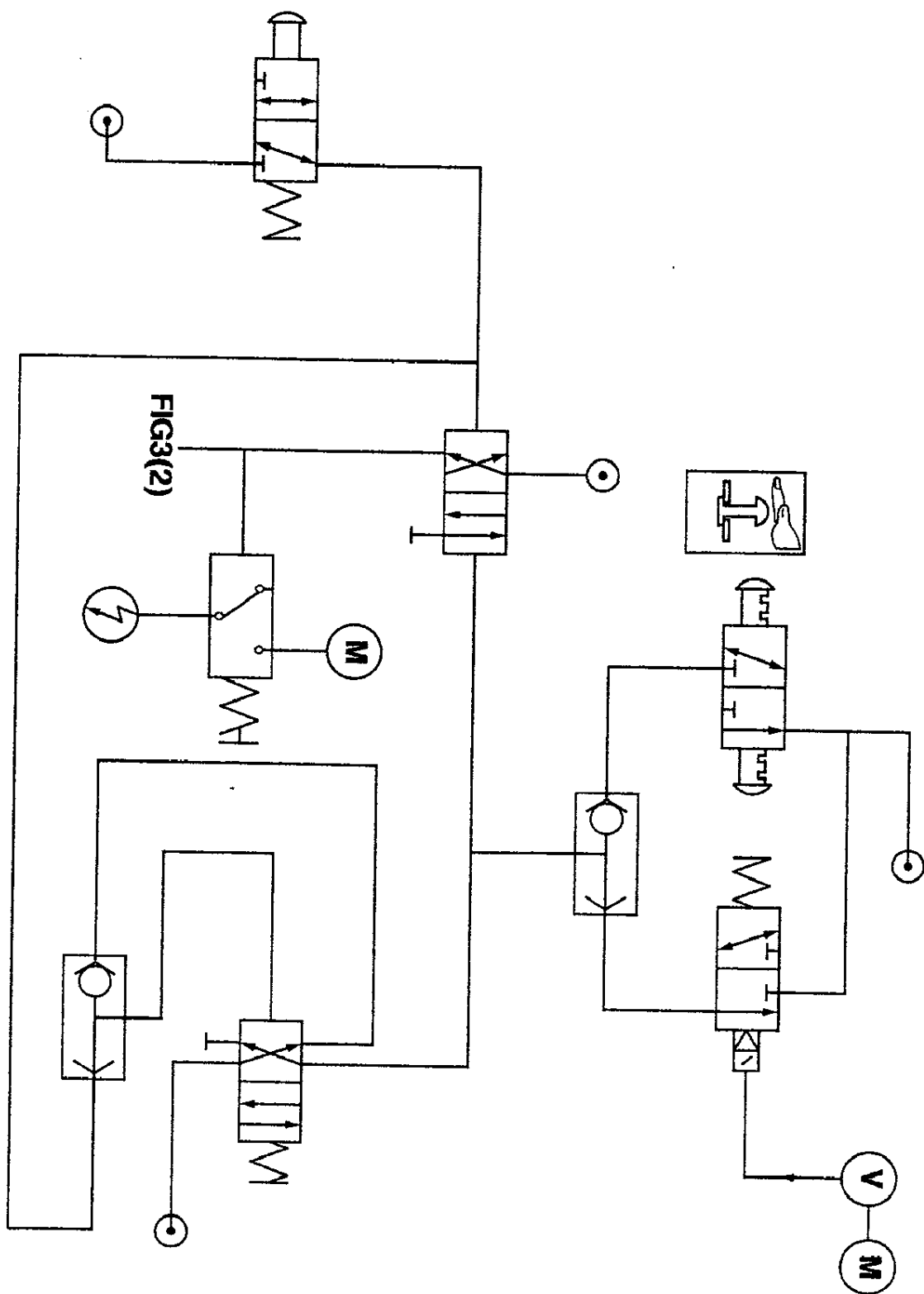
Desautter
Filter Limited, London NW9 6ND

Figure 2



Desoutter Limited, London NW9 6ND

DESOUTTER INSTRUCTIONS

Apply - Main

After free and filtered air supply is required, at a pressure of 6.3 (1.4 Psig), with a flow rate of 9.5 l/s (21 cu.ft/min) controlled by a pressure regulator selected from the Desoutter Air Line Service equipment Catalogue.

Apply - Remote

Basic requirements are as above but the pressure must be at 2.7 bar (40 Psig) and the flow requirement when signalling is 1.5 l/s (3.3 cu.ft/min). The signal duration should be kept to the minimum to reduce air consumption.

Application

Lubrication is vital for maximum performance of the tool and the lubricator selected from the Desoutter Air Line Service equipment Catalogue should be fitted into the system downstream of the tool.

We recommend the use of an ISO Viscosity Classified oil, number ISO VG 15, in the lubricator.

The tool can be operated on dry line.

Electrical Supply

The motor must be connected to a three phase supply in accordance with the VOLTAGE CHART and provided with a starter with an overload protection.



Voltage Chart - 3 Phase (AFDE41) (AFDEC41)

Recommended Starter Cradtree BD 15	Voltage V	Frequency Hz	Motor Connections Link	Overload Setting
20100/EB	220 to 240	50	Delta	1.4 - 1.6 Amps
20100/EB	220 to 264	60	Delta	1.4 - 1.6 Amps
20100/DJ	360 to 440	50	Star	0.8 - 1.0 Amps
20100/EH 440/480 60 Hz Coil	360 to 480	60	Star	0.6 - 0.8 Amps

Voltage Chart - 3 Phase (AFDE41H) (AFDE41HC)

Recommended Starter Cradtree BD 15	Voltage V	Frequency Hz	Motor Connections Link	Overload Setting
20101/HB	220 to 240	50	Delta	3.1 to 3.5 Amps
20101/HB	220 to 264	60	Delta	3.3 to 3.8 Amps
20101/FJ	360 to 440	60	Star	1.9 to 2.4 Amps
20101/FH	360 to 520	60	Star	1.9 to 2.4 Amps

Connecting to the Electrical Supply

WARNING: (1) ENSURE THE SUPPLY IS OFF BEFORE MAKING CONNECTIONS.

(2) STAR AND DELTA CONNECTIONS ARE TO BE STRICTLY IN ACCORDANCE WITH THE SUPPLY VOLTAGE GIVEN IN THE CHART. ANY DEVIATION FROM THE CHART WILL RESULT IN DAMAGE TO THE MOTOR.

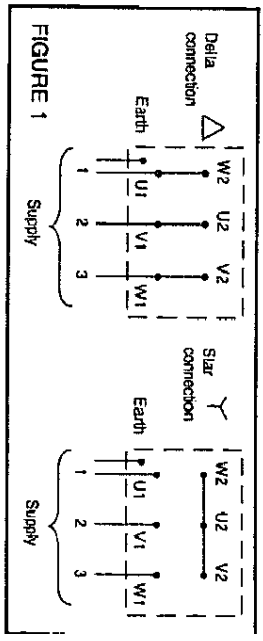
Determine the supply voltage and refer to the voltage chart for motor connections details.

For Y (star) connection, couple terminal W2 to U2 and U2 to V2. For Δ (Delta) connection, couple terminal W2 to U1, U2 to V1 and V2 to W1.

In both methods the motor will be direct on line connected.

NOTE: The terminals are fitted with 4mm positive screws and the connecting links are connected between the screws. The earth connection is a 4mm positive screw for which a suitable screwdriver will be required.

IMPORTANT: Do not remove or loosen the bottom nut on the terminals.



For all voltages: The supply cable (min. cable rating: armoured flexible 1.0mm conductors) is connected to the motor terminals U1, V1, W1 and earth, which are in the terminal box (see Figure 1). A suitable cable clamp should be fitted; the terminal box is provided with four (19mm diameter) "KNOCK-OUTS".

The Electric Motor

The motor is a totally enclosed, fan-cooled three-phase squirrel cage, class B minimum insulation with working ambient temperature of 40°C. Looking at the fan end of the motor the rotation should be anti-clockwise. If the rotation is opposite, interchange connections U1 and V1 to correct the rotation.

DATA

Maximum air pressure Pmax = 8bar
Minimum air pressure Pmin = 6bar
Sound pressure level = < 70 dBA
(CAGI-PNEUROP Test Code)
Weight = 17.5 kg

Statement of Use

The tool is designed for drilling holes, but may be adapted for other specified purposes, using Desoutter approved accessories.

NOTE: Provision must be made for an Emergency Stop if the tool is used alone or built into a machine. A suitable circuit diagram for manufacturing an Emergency Stop is provided in Figure 2.

Desauter



Desauter Limited, London NW9 6ND



Peck Feed Drills - The Desauter Peck Feed Drill System should be used when the depth of the hole to be drilled is five or more times the hole diameter. This helps clear drill chips and avoids excessive overheating of drill bit. Hole size accuracy can be improved and drill bit run-out can be kept to the minimum. Request information from Desauter.

Dust Extraction Kits

Extension tube	Nominal Stroke Length	Locking Screw Length	Kit Part No.
250953	20 mm	90 mm	52152
250943	40 mm	130 mm	52162

The extraction kit must be used in conjunction with an extension tube. The sleeve outlet fits over the tube chuck key insertion slot, and is locked by two screws. Dust Extraction Kits must be used with an external vacuum collection system.

SETTING DRILLING OPERATION (See Figure 5)

The drill must be at least 6mm (0.25in) above the work piece.

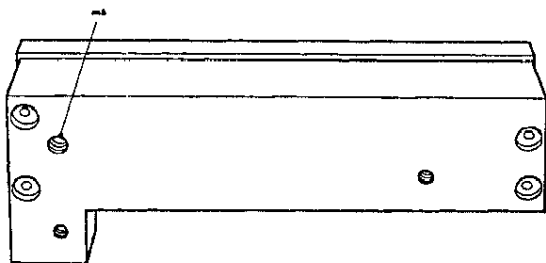


FIGURE 4 VALVE BLOCK MODULE BASIC

series

Clamping Clamps - A range of clamps bases and columns are available. Full details obtained from Desauter.

Hydraulic Check Unit (HCU) - The tool will function satisfactorily, drilling a blind hole at the set feed rate. Should it be required to drill through the material and possibly through into another hole, acceleration will occur with possible drill breakage. To obviate the risk of an HCU is strongly recommended. Request information from Desauter.

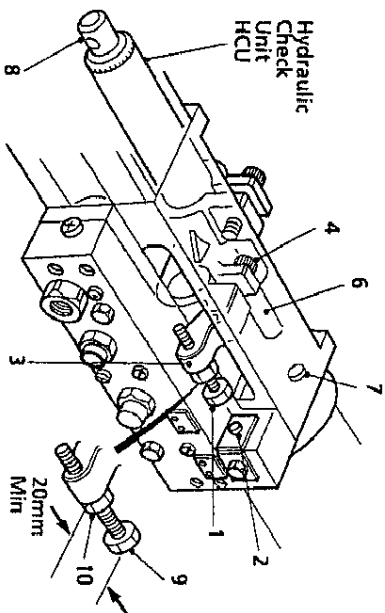


FIGURE 5 HYDRAULIC CHECK UNIT (HCU)

NOTE: This setting details a unit with a HCU, reference to the HCU should be ignored when setting the standard tool.

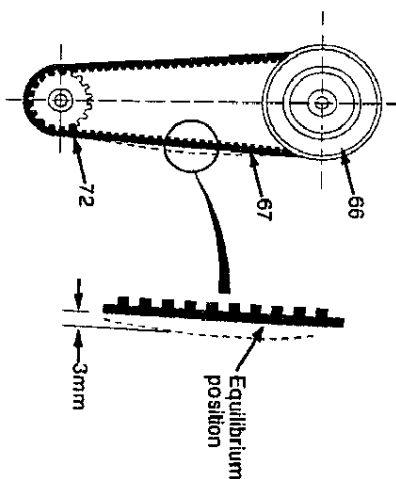


FIGURE 6 ADJUSTING THE TIMING BELT

Set the gap between the (1) and (2) to equal the depth of drilling required PLUS the distance the bit is above the work piece, by sliding (3). Lock in position with (4) to the recommended torque.

Position the HCU in (3). Set the gap between (6) and (7) to a distance as required above the work piece.

Unscrew (8) away from the HCU to adjust the resistance within the HCU to the minimum.

Fully open the Figure 3 (13).

Close Figure 3 (11).

Connect the air supply and press Figure 3 (6).

Adjust figure 3 (11/13) to give required advance, retract feeds for the operator.

Use Figure for the final depth adjustment 5 (9).

Lock using Figure 5 (10).

Carry out a set of trial drillings to determine the ideal advance and HCU settings using Figure 3 (11).

SETTING TAPPING OPERATION

NOTE: 1. It is important that the advance rate of the tool is set to match the pitch of the thread which is to be tapped. An incorrect advance rate will result in a deformed thread, this will be more noticeable in plastics or light alloy materials.



limited, London NW9 6ND

he retract rate should be set to withdraw the tap at a slightly faster rate than it advanced, this will ensure a lean withdrawal.

it, with the selected tap securely retained in the chuck, block to carry out sample tapping operations.

the tap MUST be at least 14mm (9/16in) above the test piece for the tapping head reversing engagement travel. Between Figure 5 (2) and (1) to equal the tapping depth stance the tap is above the work piece.

re 3 (1/1/3) to give the required advance, retract feeds titon.

trial tapping operation and inspect the finished thread t as necessary Figure 3 (1/1/3) and repeat until in NOTES 1 and 2 are satisfied.

REQUIREMENTS

tes

flowing lubricants:

3P FG00 EP, for bearings.
Juckhams Type Q5618, for gears, splines and threads.
Molykote PG75 Plastislip, for 'O' rings and seals.

its:

lainer to immerse components.

nd quality clean paraffin.

components in the container containing the paraffin. immersion, agitate components to ensure that air re flushed through. Remove components from the thoroughly dry and blow through air passages to remove place components in an air tight container until required y. Dispose of the dirty paraffin in accordance with health regulations.



MAINTENANCE

It is recommended that the tool is serviced at 1000hrs running time.

WARNING

THE BEARING SLEEVE COMPLETE IS UNDER SPRING (19) COMPRESSION. WHILST RESISTING THE THRUST DUE TO THE SPRING (19), CAREFULLY UNSCREW AND REMOVE THE BEARING SLEEVE COMPLETE FOLLOWED BY THE SPRING.

Dismantle the tool using the exploded view. Clean all components and inspect for wear or damage, exchange if necessary. Apply new lubricant to the relevant parts in accordance with list. Assemble the tool using the exploded view.

Torque values given are $\pm 5\%$.

Special tools shown in exploded view are in addition to normal workshop tools.

NOTE: Protective gloves and eye protection should be worn during cleaning of parts. Eating or smoking is prohibited when cleaning, dismantling or assembling tool.
Worn components should be carefully handled and disposed of safely.

© Copyright 1994, Desouter, London NW9 6ND, UK.
All rights reserved

Any unauthorized use or copying of the contents or part thereof is prohibited. This applies in particular to trademarks, model denominations, part numbers and drawings.

Use only authorized parts. Any damage or malfunction caused by the use of unauthorized parts is not covered by Warranty or Product Liability.