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Desoutter™

utter Limited, London, NW9 8ND

FDE41/AFTE41

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- Osaluettelo
- Käyttöohjeet

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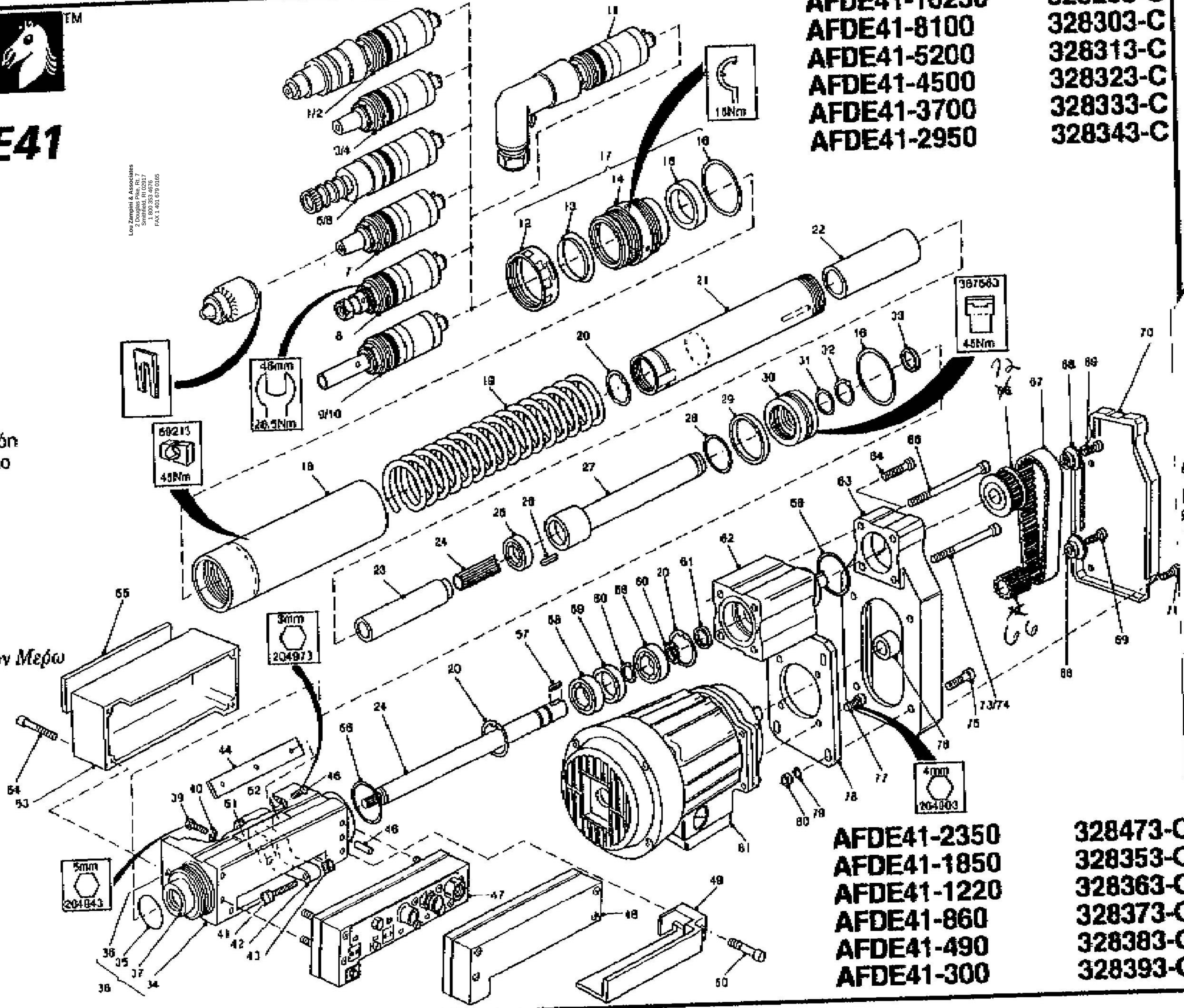
AFDE41-10250	328293-C
AFDE41-8100	328303-C
AFDE41-5200	328313-C
AFDE41-4500	328323-C
AFDE41-3700	328333-C
AFDE41-2950	328343-C



AFDE41-2350	328473-C
AFDE41-1850	328353-C
AFDE41-1220	328363-C
AFDE41-860	328373-C
AFDE41-490	328383-C
AFDE41-300	328393-C

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Parts List/Teileliste/Liste de Pièces

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Item No. / Pos. Nr. / No. Article	Part No. / Teil. Nr. / Référence	Description	Qty / Menge / Qté
1	324903	B5 Output	1
2	324913	B6 Output	1
3	356263	B32 Output	1
4	326593	B24 Output	1
5	92362	B7 Output	1
6	92893	B8 Output	1
7	327723	B1 Output	1
8	326573	B2 Output	1
9	326563	B3 Output	1
10	356373	B33 Output	1
11	324693	B4 Output	1
12	266153	Cover	1
13	322433	Seal	1
14	322083	Sleeve	1
*15	322113	Seal	2
*16	50763	O-Ring	1
17	327993	Sleeve	1
18	322403	Case	1
19	49483	Spring	3
*20	113173	Circlip	1
21	322093	Case	1
22	322123	Spacer	1
23	322133	Sleeve	1
24	322143	Shaft	1
*25	322463	Bearing	1
26	322243	Key	1
27	322173	Tube	1
*28	225553	O-Ring	1
*29	322443	Seal	1
30	322153	Piston	1
*31	67823	O-Ring	1
*32	322603	Circlip	1
*33	322453	Seal	1
34	322183	Housing	1
*35	203423	O-Ring	1
36	322393	Pin	1
37	322163	Bush	1
38	327833	Housing	1
39	228003	Screw	2
*40	6512	Washer	2
41	322493	Screw	1
42	321693	Cross Head	1
43	223203	Nut	1
44	322253	Key	1
45	323403	Screw	1
46	322193	Pin	1
47	324143	Control Block	1
48	324133	Control Block	1
49	326653	Cover	1
50	236373	Screw	2
51	355893	Cross Head	1
52	54853	Screw	2
53	325103	Cover	1
54	236313	Screw	2
55	266393	Nameplate	1
*56	322513	O-Ring	2
57	322293	Key	1
*58	116973	Bearing	2
59	322203	Spacer	1
*60	200703	Circlip	2
61	322213	Spacer	1
62	323913	Gearbox	1
63	322223	Housing	1
64	228003	Screw	2
65	209493	Screw	2
66	301873 (10,250RPM) (8,100RPM)	Pulley (56T)	1
	301833 (5,200RPM) (860RPM)	Pulley (46T)	1
	301883 (4,500RPM) (1,220RPM)	Pulley (40T)	1
	301843 (3,700RPM)	Pulley (33T)	1
	301853 (2,950RPM) (490RPM)	Pulley (26T)	1
	301863 (2,350RPM) (1,850RPM) (300RPM)	Pulley (16T)	1
67	301973 (10,250RPM) (8,100RPM)	Belt (82T)	1
	301983 (5,200RPM)	Belt (78T)	1
	302013 (4,500RPM)	Belt (73T)	1
	301943 (3,700RPM)	Belt (71T)	1
67	301953 (2,950RPM)	Belt (66T)	1
	301963 (2,350RPM) (1,850RPM) (300RPM)	Belt (61T)	1
	302843 (1,220RPM)	Belt	1
	302983 (860RPM)	Belt	1
	302963 (490RPM)	Belt	1
68	302363	Spacer	2
69	223113	Screw	6
70	322233	Cover	1
71	229353	Screw	4
72	322283 (10,250RPM) (1,220RPM)	Pulley (16T)	1
	322273 (8,100RPM) (2,350RPM)	Pulley (20T)	1
	322363 (5,200RPM) (4,500RPM) (3,700RPM) (2,950RPM) (1,850RPM) (860RPM) (490RPM) (300RPM)	Pulley (26T)	1
73	322543	Screw	2
74	322533	Screw	2
75	223193	Screw	4
76	222803	Spacer	1
77	223113	Screw	6
78	236153	Plate	1
79	223183	Washer	4
80	223203	Nut	4
81	325133 (328283) (328303) (328313) (328323) (328333) (328343) (328473) (328353) (328363)	Motor	1

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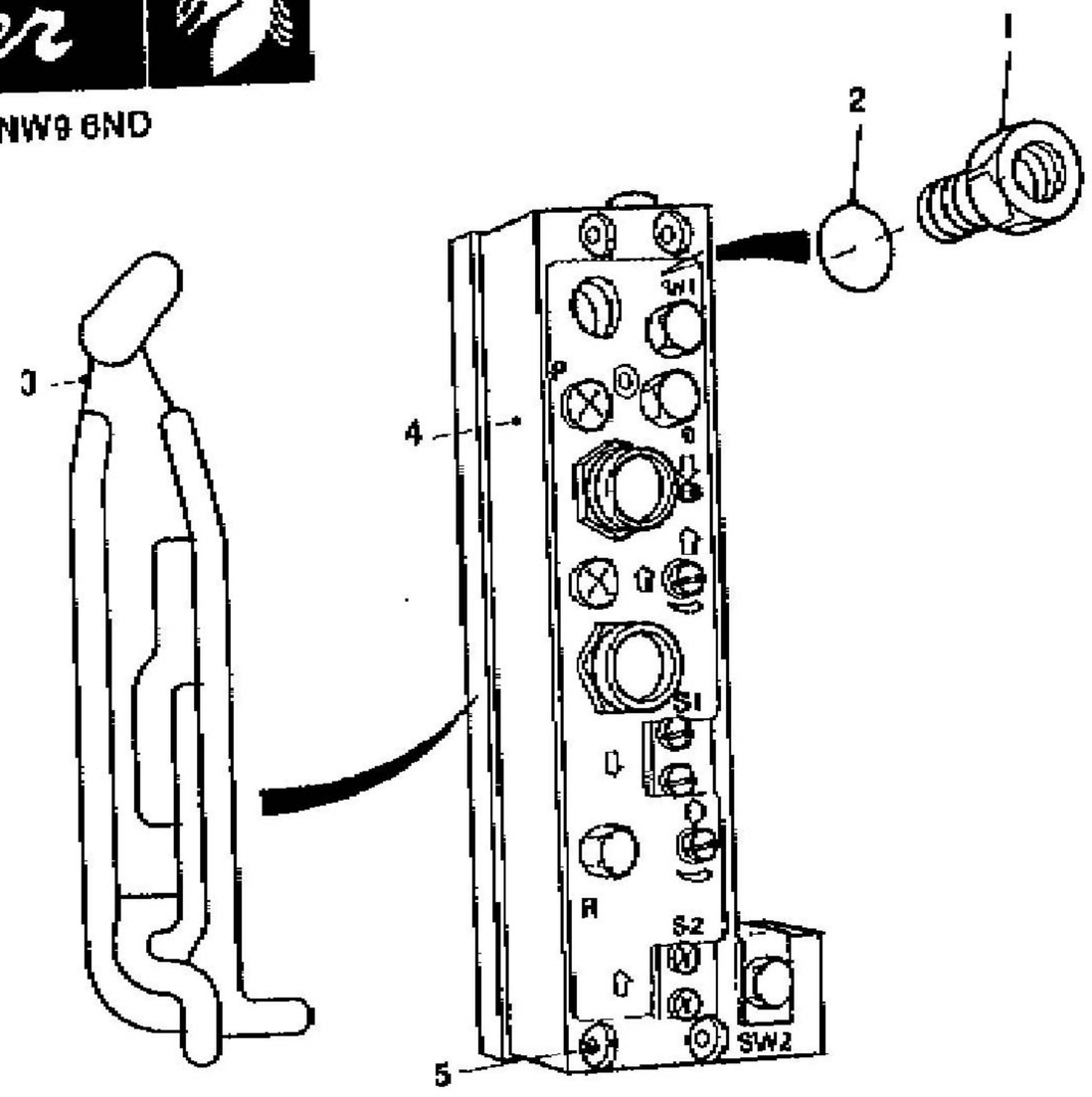
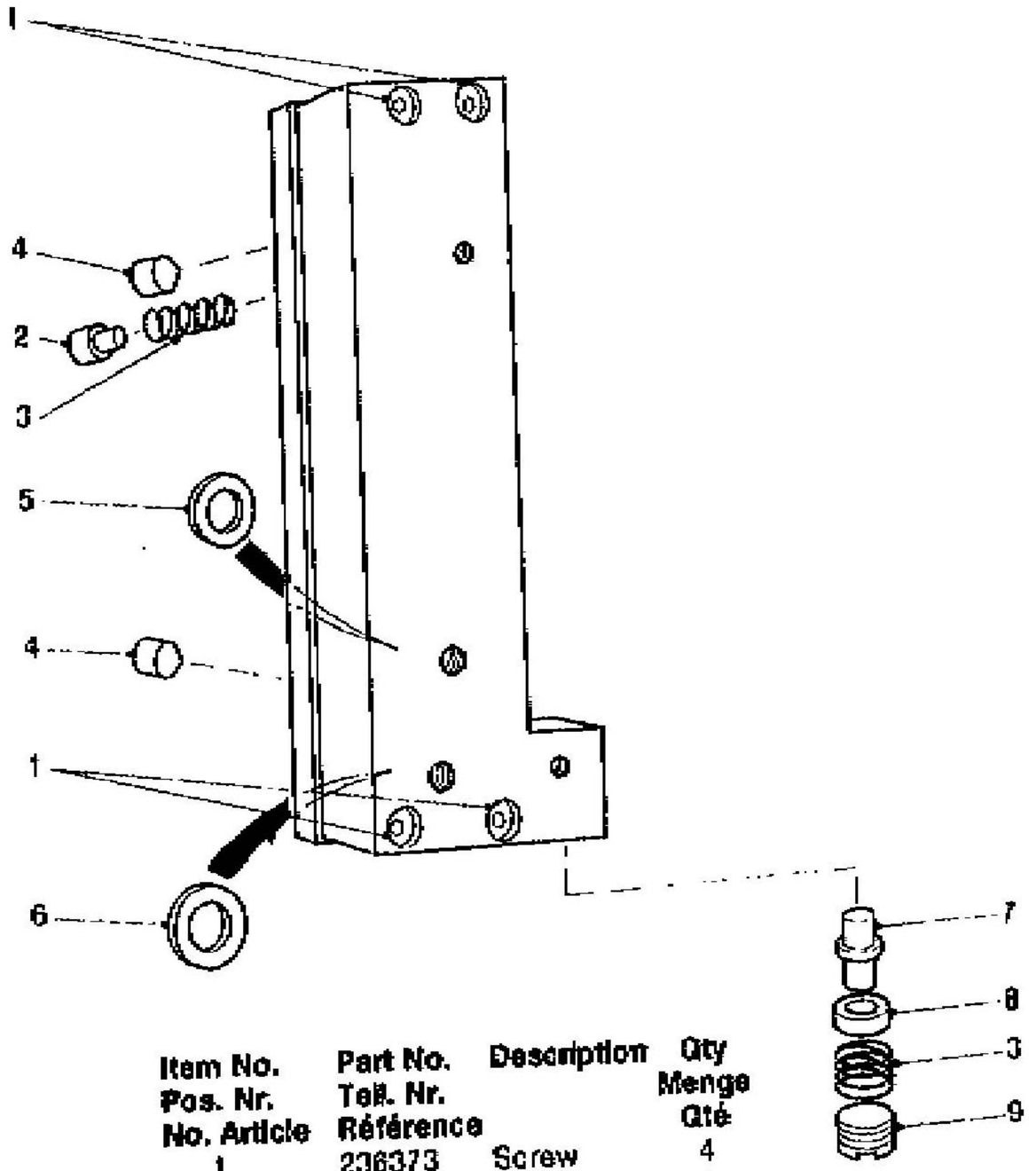


324143

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	47133 (¼in NPT)	Adaptor	1
	42953 (¼in BSP)	Adaptor	1
2	99863	O-Ring	1
3	370393	Seal	1
4	364693	Block	1
5	273653	Screw	4
	Service kit		
6	370943	Seal Kit	1



Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	236373	Screw	4
2	325063	Pin	1
3	51663	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

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WARNING:
(1) ALWAYS DISCONNECT THE TOOL FROM THE AIR SUPPLY BEFORE ATTEMPTING ANY REPLACEMENT, ADJUSTING, SERVICING OR DISMANTLING.

(2) ENSURE THAT NO LOOSE ARTICLES OF CLOTHING, LOOSE HAIR, OR CLEANING MATERIAL CAN BE CAUGHT BY THE MOVING PARTS OF THE TOOL.

(3) ALWAYS ALLOW THE TOOL TO STOP BEFORE REMOVING THE WORK.

(4) ENSURE THAT THE WORK PIECE IS SECURELY CLAMPED BEFORE COMMENCEMENT OF OPERATION.

(5) CLEAR ALL LOOSE ITEMS FROM THE VICINITY.

(6) ENSURE THAT THE TOOL IS SECURELY CLAMPED AROUND THE OUTER CASE BEFORE COMMENCEMENT OF OPERATION.

(7) ENSURE THAT SAFETY GUARDS ARE FITTED.

(8) BEWARE OF TOOL OUTPUT. THIS ADVANCES AND ROTATES.

(9) EYE AND EAR PROTECTION MUST BE WORN WHEN OPERATING THE TOOL.

(10) DO NOT OPERATE THE TOOL IN EXPLOSIVE ATMOSPHERES.

(11) WHEN MACHINING HAZARDOUS MATERIALS, PROVISION MUST BE MADE FOR DUST COLLECTION OR SUPPRESSION.

(12) ENSURE THAT AN EMERGENCY STOP IS PROVIDED FOR THE TOOL, WHETHER USED ALONE OR BUILT INTO A MACHINE. A SUITABLE EMERGENCY STOP CIRCUIT IS DETAILED IN FIGURE 2.

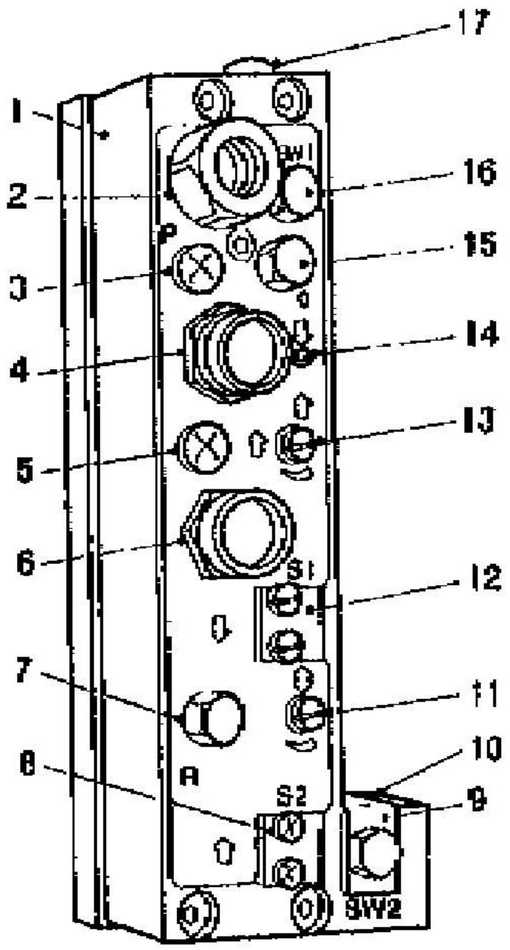

FIGURE 3 VALVE BLOCK MODULE COMPLETE

CONTROL VALVE (FIGURE 3)

The valve block module complete (1) contains all the control functions and signal originations for external control.

The controls and locations are identified below and detailed in the Drilling operation.

LOCATION:
2 Main Air Inlet port, tapped ¼in BSP or NPT.

3 'P' Input port, tapped M5. Signal point for peck feed or Dwell control kit circuit.

4 Manual Retract Button (Red).

5 'I' Remote Start Input port, tapped M5. Receives external signal to start the tool cycle.

6 Manual Start Button (Green).

7 'R' Retract Output port, tapped 1/8in BSP. supply for air return.

†8 Position for 'S2' Solenoid Valve for Electric Emergency Retract.

†9 Position for 'SW2' Proximity Switch, detects a signal at the end of a cycle for interface kit connection (i.e. it is High at depth.

10 Stroke Control Valve.

11 Feed Rate Regulating Screw.

†12 Position for 'S1' Solenoid Valve for Electric Start.

13 Retract Rate Regulating Screw.

14 Advance rate regulating Screw.

15 'O' port, tapped 1/8in BSP receives signal to return the feed to start position for peck feed or Dwell control.

†16 Position for 'SW1' Proximity Switch, detects a signal at the beginning of a cycle for interface kit connection. (i.e. is High in datum position).

17 'M' port, is tapped M5. Used for sequence control. The signal is produced when the tool is at rest.

NOTE: The 'M' port is intended for the operation of pilot valves. It must not be used as a source of air supply for other uses.

† Available in KIT form. See Desoutter Catalogue for details.

Control Valve Block Module - Basic (Figure 4)

This control valve block module is used when the tool is to be controlled remotely. Figure 4 details the signal originations.

NOTE: External circuitry will be required to control the speed of advance and retract feeds.

LOCATION

1. Advance Air port, tapped 1/8in BSP.

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81	(328373) (328383) (328393) 325143 (348623) (348633) (348643) (348653) (348663) (348673) (348683) (348703) (348713) (348723) (348733)	Motor	1
	239003 (363483) (363493) (363503) (363513) (363523) (363533) (363543) (362573) (363553) (363563) (363573)	Motor	1

* Indicates normal replacement items. It is recommended that adequate stocks are held for servicing requirements.

Always quote tool model number, serial number and spare part number when ordering spares.

* Bedeutet normale Verschleißteile. Es empfiehlt sich eine angemessene Menge für Wartungszwecke auf Lager zu halten.

Bei der Bestellung von Ersatzteilen, bitte immer angeben: Typennummer der Bohrmaschine, Werknummer und Ersatzteilnummer.

* Le symbole astérisque (*) indique des articles de rechange normaux. Il est recommandé d'en conserver des stocks suffisants pour assurer toutes les opérations d'entretien courant.

Lors de la commande de pièces de rechange, toujours citer le numéro de modèle de l'outillage, son numéro de série et le numéro de référence de chaque pièce de rechange.

*Indica elementos de reposición regular. Se recomienda tener una cantidad adecuada de los mismos en reserva a efectos de mantenimiento.

Al encargar piezas de recambio, siempre debe indicarse el número de modelo de la herramienta, su número de serie y el número de la pieza de recambio.

* Indica itens que são substituídos regularmente. É recomendado que estoques adequados sejam mantidos para requisitos de manutenção.

Cite sempre o número do modêlo da ferramenta, número de série, e número da peça acessória quando pedindo acessórios.

*L'asterisco denota ricambi normali. Si consiglia di mantenere scorte adeguate alle esigenze della manutenzione.

Nell'ordinazione di ricambi citare il numero di modello dell'utensile, il numero di matricola e quello di catalogo del pezzo.

* Σημαίνει συνηθισμένα είδη (τεμάχια) για αντικατάσταση. Σας συνιστούμε να έχετε αρκετό απόθεμα από τα είδη που χρειάζονται αντικατάσταση.

Όταν παραγγέλνετε ανταλλακτικά πάντα να γράφετε τον αριθμό μοντέλου του εργαλείου, τον αριθμό σειράς και τον αριθμό ανταλλακτικού.

* Betekent normale reserveartikelen. Het verdient aanbeveling om voldoende voor onderhoudsbehoeften voorradig te hebben.

Bij bestelling van reserveonderdelen geef altijd modelnummer, volgnummer en reserveonderdeelnummer van het werktuig op.

* Indikerer normale udskiftningsemner. Det anbefales at have rigelige forsyninger af dele til brug i forbindelse med eftersyn.

Opgiv altid det korrekte værktøjsmodelnummer, serienummer og reservedelsnummer ved bestilling af reservedele.

* Angir normale reservedeler. Det anbefales at tilstrekkelig antall reservedeler holdes på lager.

Ved bestilling av deler må man alltid oppgi verktøyets modellnr., serienr. og reservedelens nr.

* Utmärker normala reservdelar. Vi rekommenderar att tillräckligt antal lagras för serviceändamål.

Uppge alltid verktygets modellnummer, serienummer samt reservdelens nummer vid beställning av reservdelar.

* Viittaa tavallisiin varaosiin. Suosittelemme, että riittäviä määriä pidetään varastossa huoltotarpeita varten.

Työkalun mallinumero, sarjanumero ja varaosan numero on aina mainittava tilattaessa.

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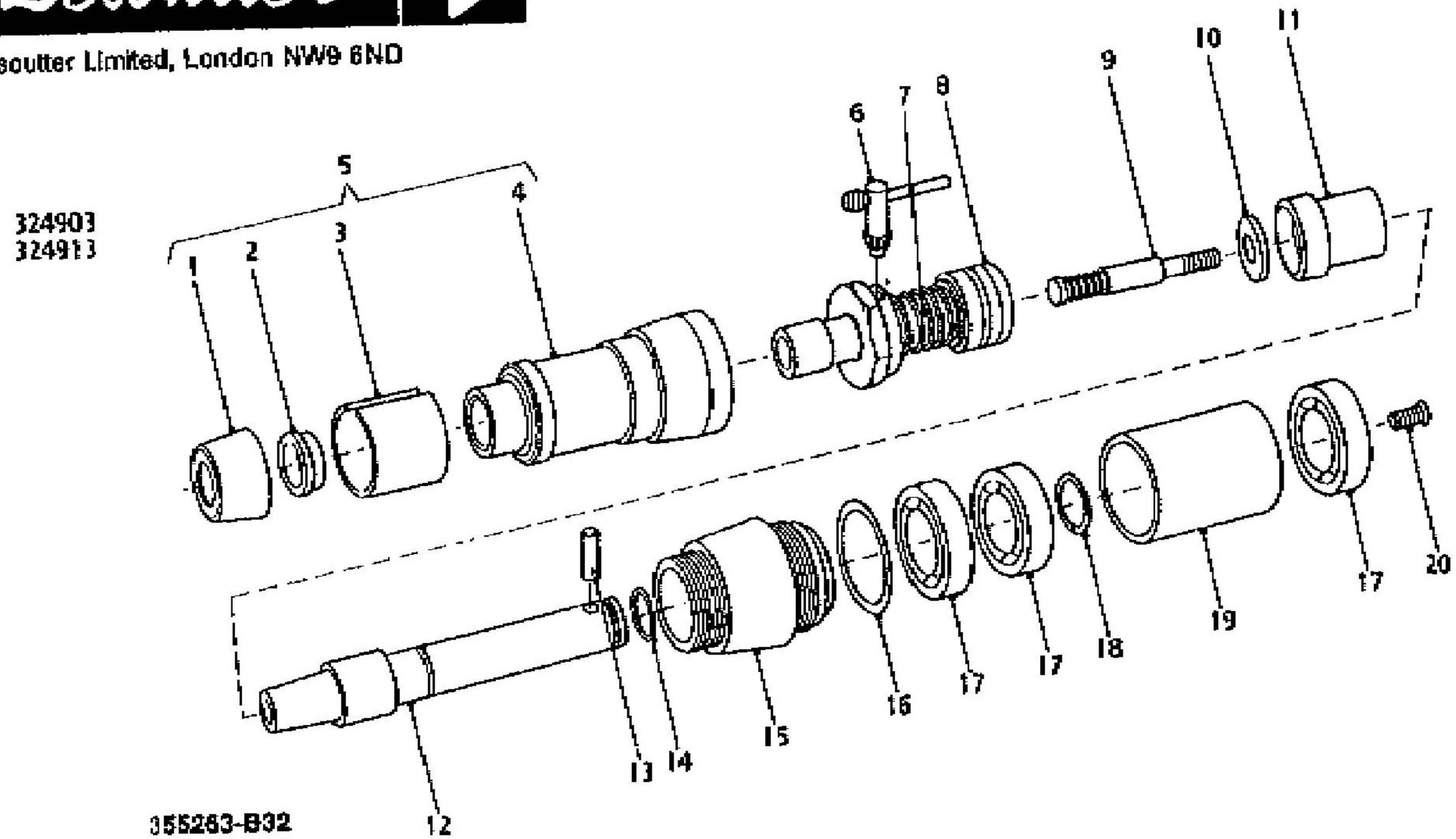
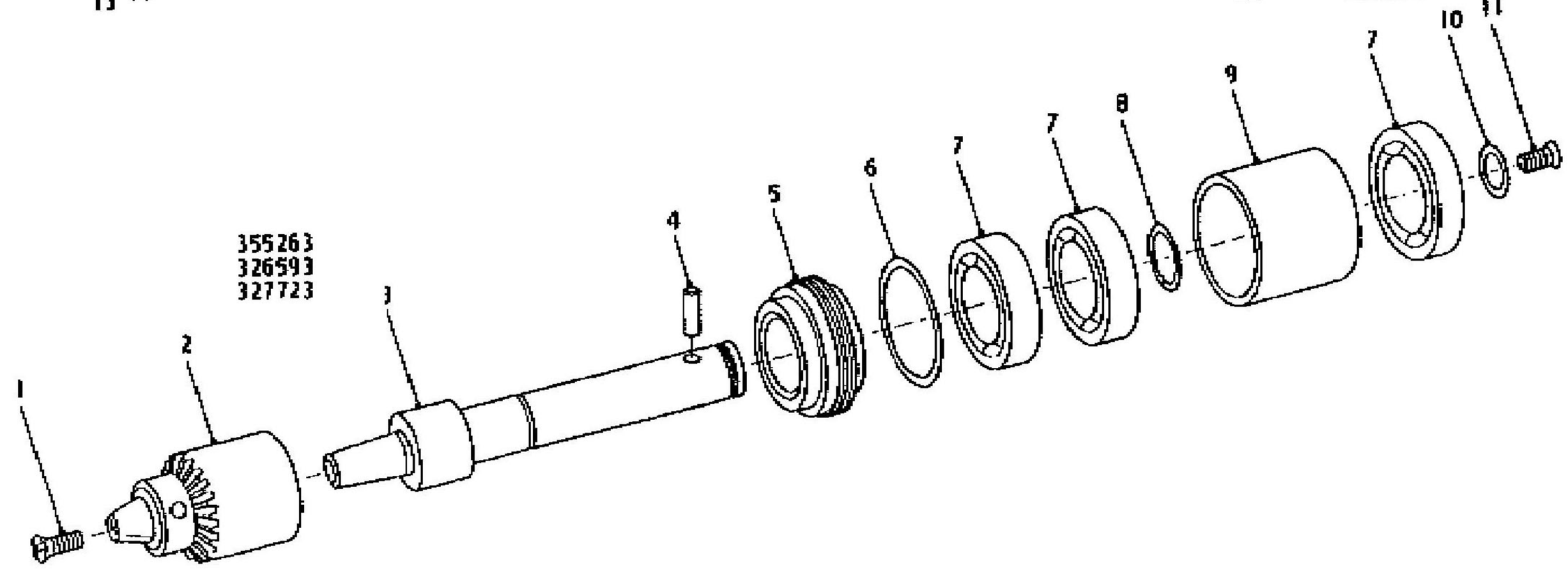


355263-B32
326593-B24
327723-B1

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	327713	Screw	1
2	34752	Chuck	1
	(327723)		
3	355273	Shaft	1
	(355263)		
	322413	Shaft	1
	(326593)		
	322063	Shaft	1
	(327723)		
4	329343	Pin	1
5	322073	Nut	1
*6	500993	O-Ring	1
7	116973	Bearing	3
8	206703	Circlip	1
9	322103	Spacer	1
10	500983	O-Ring	1
11	209953	Screw	1



324903-B5
324913-B6

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	74088	Cap	1
2	73798	Bush	1
3	76713	Clip	1
4	251533	Case	1
5	251543	Case	1
6	28902	Key	1
7	71378	Spring	1
	71318	Spring	1
	68448	Spring	1
8	295863	Clutch 1/4	1
	(324903)		
	295823	Clutch 9/16	1
	(324913)		
9	324553	Spindle	1
10	324563	Washer	1
11	324543	Cam	1
12	322063	Shaft	1
13	329343	Pin	1
*14	500993	O-Ring	1
15	324533	Adapter	1
*16	500993	O-Ring	1
*17	116973	Bearing	3
18	206703	Circlip	1
19	322103	Spacer	1
20	209953	Screw	1

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Output Modules/Modules de Sortie/Ausgabemodule

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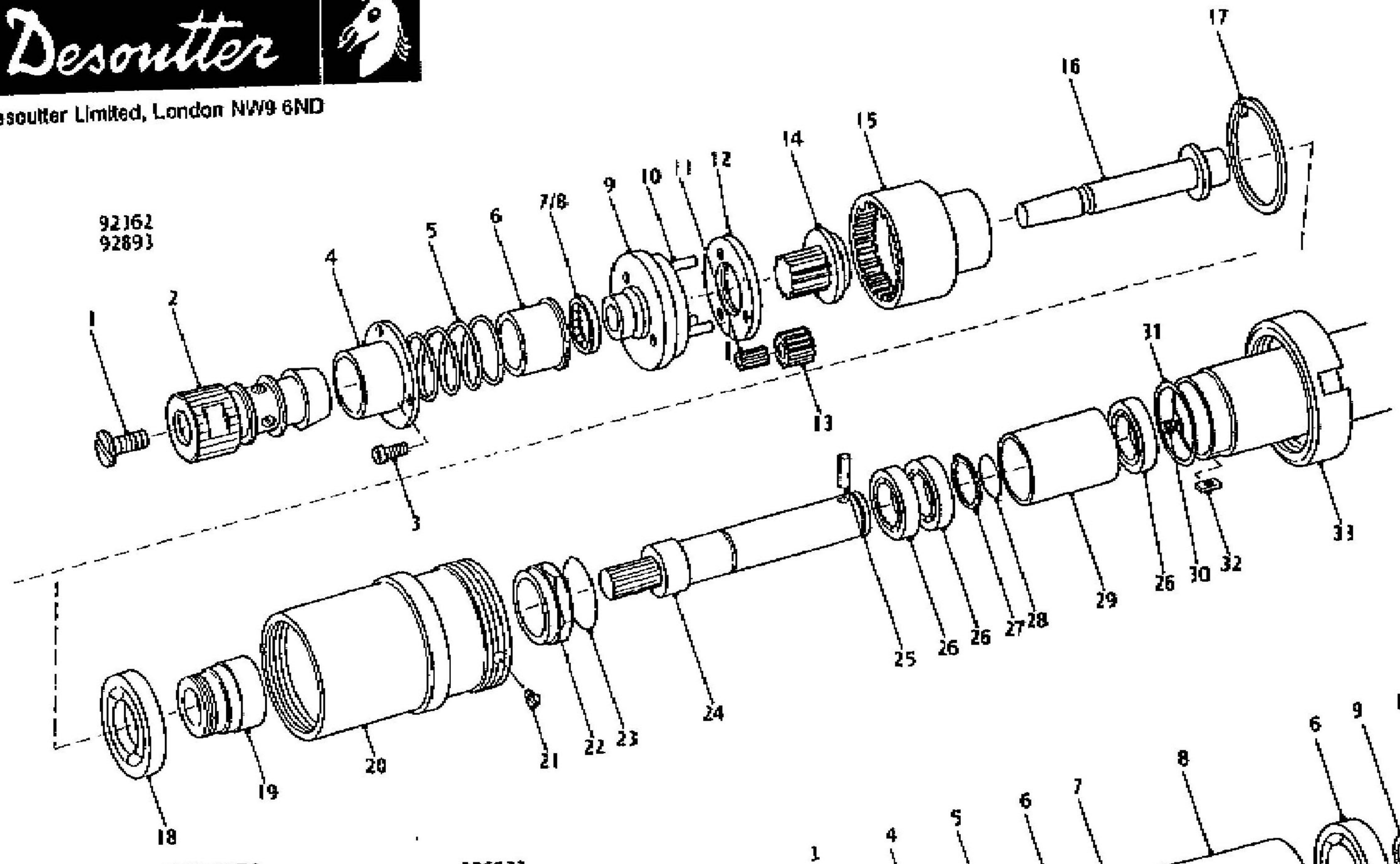
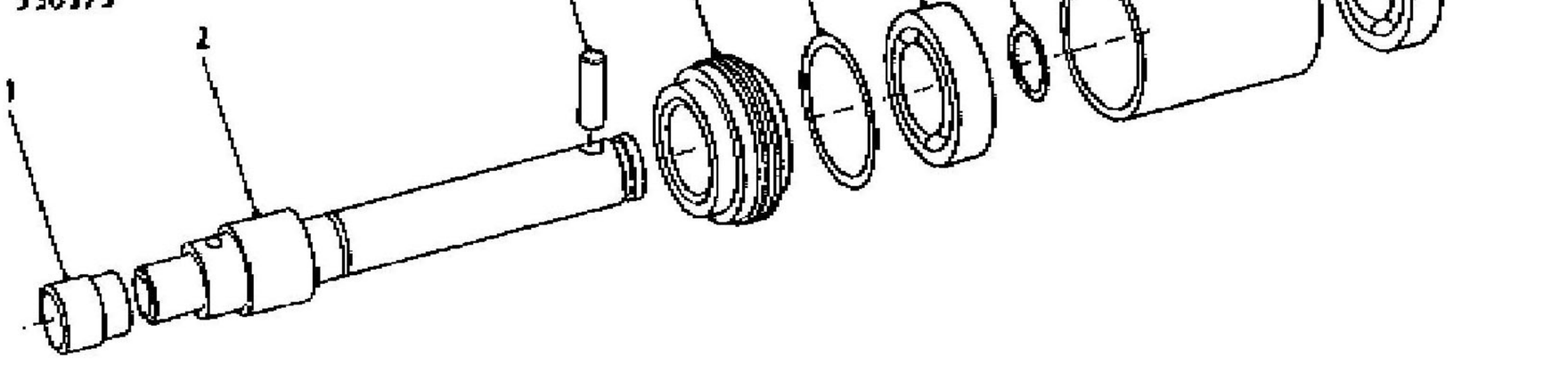


92362-B7
92893-B8

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	79783	Screw	1
2	29452 (92362)	Chuck	1
	29462 (92893)	Chuck	1
3	57003	Screw	3
4	62153	Housing	1
5	62293	Spring	1
6	62143	Housing	1
*7	68828	Cage and Balls	1
*8	68818	Outer Race	1
9	61553	Cage	1
10	10753	Pin	2
11	502093	Bearing	2
12	61553	End Cap	2
*13	1443	Wheel	2
14	10713	Pinion	1
15	10703	Gear	1
16	77753	Spindle	1
17	263403	Circlip	1
*18	1483	Bearing	1
19	326783	Coupling	1
20	324613	Case	1
21	324103	Screen	1
22	322073	Nut	1
*23	500993	O-Ring	1
24	324623	Shaft	1
25	329343	Pin	1
*26	116973	Bearing	3
27	200703	Circlip	1
*28	500963	O-Ring	1
29	322103	Spacer	1
30	209953	Screw	1
31	296583	Circlip	1
32	324093	Key	1
33	324113	Nut	1

326573-B2

326573
356373



Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	116803	Nut	1
2	322413	Shaft	1
3	329343	Pin	1
4	322073	Nut	1
*5	500993	O-Ring	1
*6	116973	Bearing	2
7	200703	Circlip	1
8	349883	Spacer	1
*9	500963	O-Ring	1
10	209953	Screw	1

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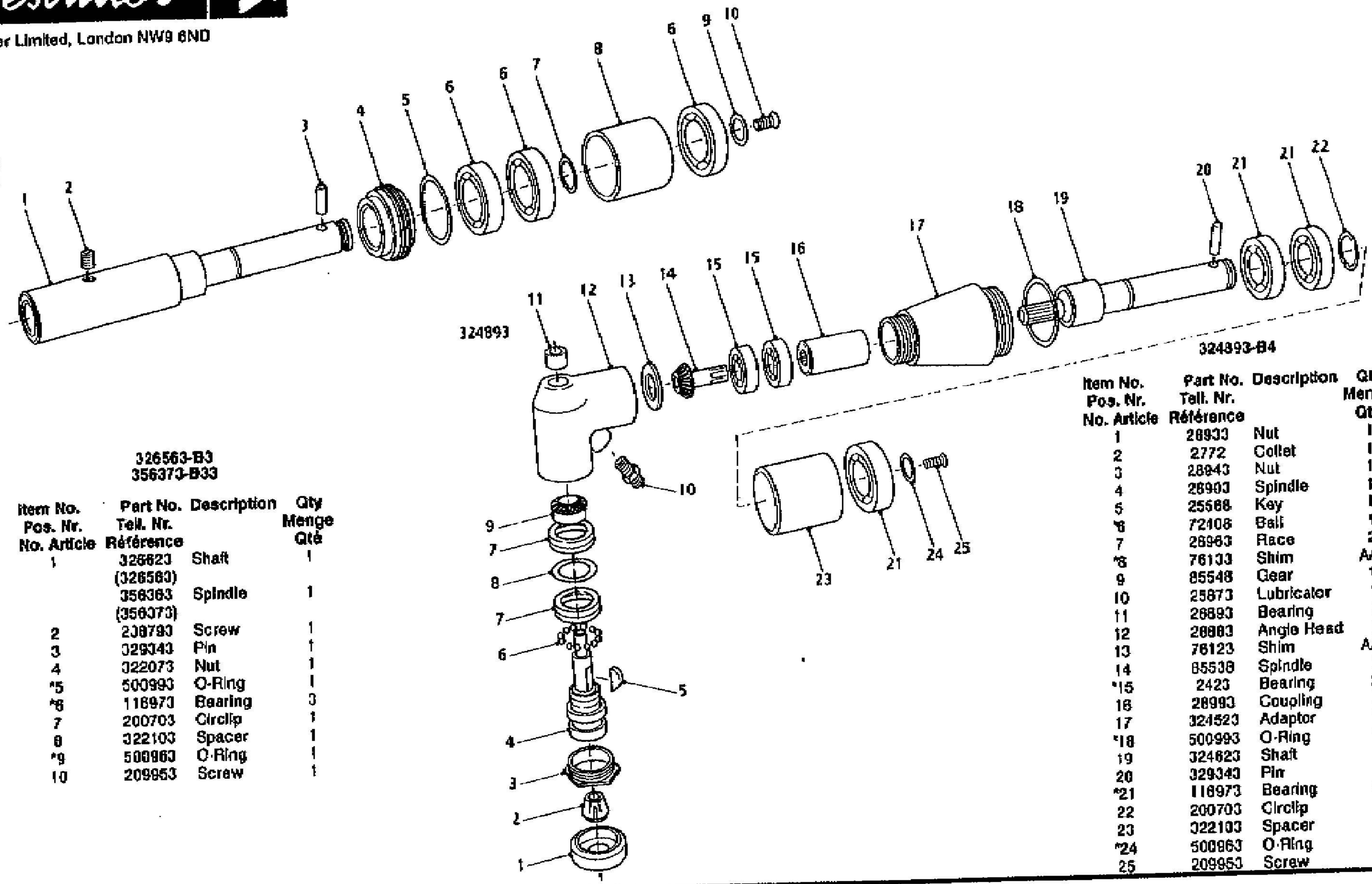

326563-B3
356373-B33

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	326623 (326563)	Shaft	1
	356363 (356373)	Spindle	1
2	209793	Screw	1
3	329343	Pin	1
4	322073	Nut	1
*5	500993	O-Ring	1
*6	116973	Bearing	3
7	200703	Circlip	1
8	322103	Spacer	1
*9	500963	O-Ring	1
10	209953	Screw	1

324893-B4

Item No. Pos. Nr. No. Article	Part No. Teil. Nr. Référence	Description	Qty Menge Qté
1	28933	Nut	1
2	2772	Collet	1
3	28943	Nut	1
4	28903	Spindle	1
5	25568	Key	1
*6	72108	Ball	1
7	28963	Race	2
*8	76133	Shim	A/R
9	85548	Gear	1
10	25873	Lubricator	1
11	28893	Bearing	1
12	28883	Angle Head	1
13	76123	Shim	A/R
14	85538	Spindle	1
*15	2423	Bearing	2
16	28993	Coupling	1
17	324523	Adaptor	1
*18	500993	O-Ring	1
19	324623	Shaft	1
20	329343	Pin	1
*21	116973	Bearing	3
22	200703	Circlip	1
23	322103	Spacer	1
*24	500963	O-Ring	1
25	209953	Screw	1

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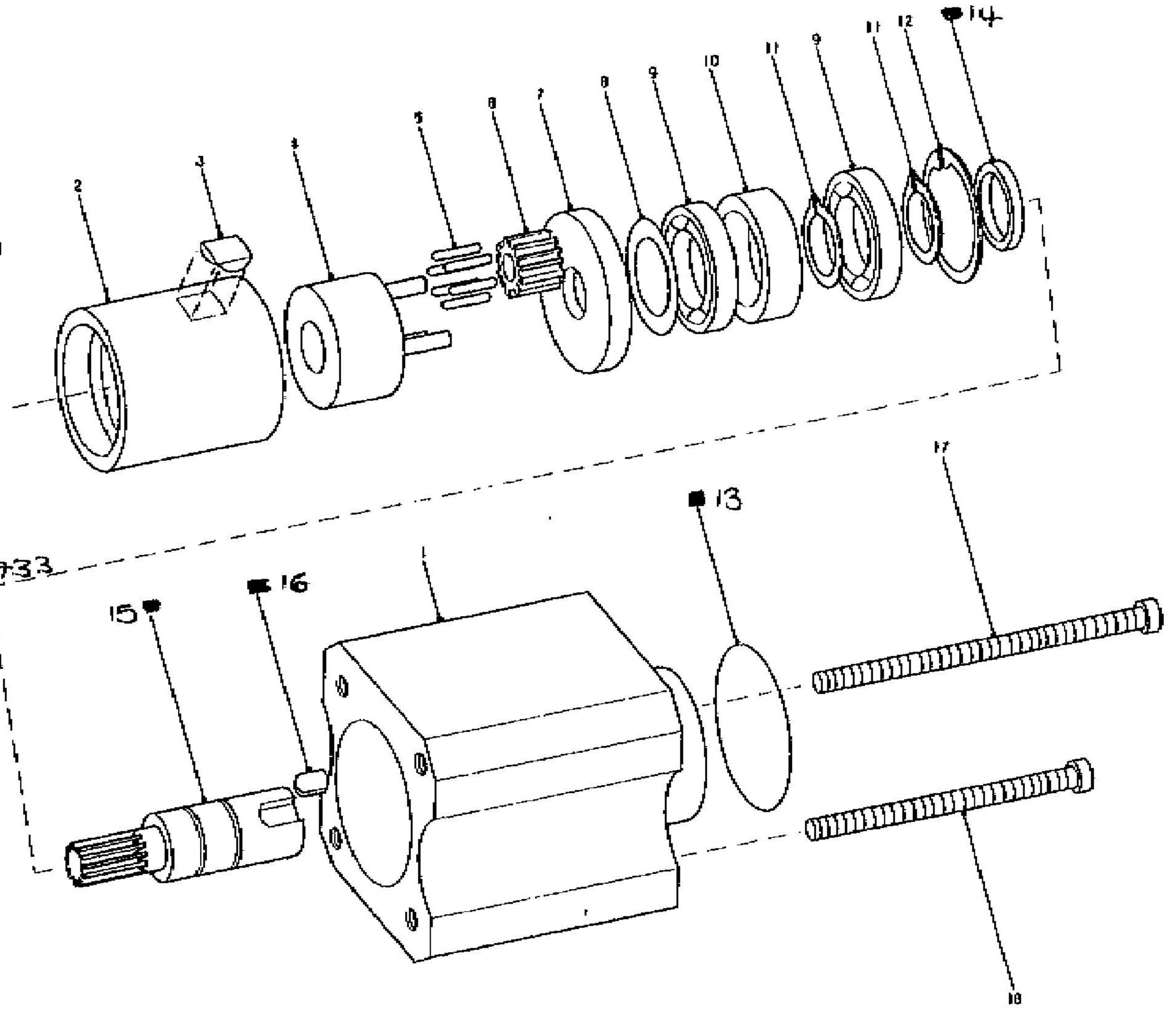
323913



Item No. / Pos. Nr. / No. Article	Part No. / Teil. Nr. / Référence	Description	Qty / Menge / Qté
1	322383	Housing	1
2	322333	~~Gear~~ RING	1
3 25368	~~25368~~	Key	1
4	322313	Cage	1
5	89993	Bearing	6
6	322323	Wheel	3
7	322303	~~Spacer~~ WASHER	1
8	113203	Washer	1
9	~~116873~~	Bearing	2
10	322283	Spacer	1
11	200703	Circlip	2
12	113173	Circlip	1
*13	329383	~~Spacer~~ SEAL	1
14	322213	~~Shaft~~ SPACER	1
15	322363	~~Key~~ SHAFT	1
16	322293	~~Seal~~ KEY	1
17	322543	Screw	2
18	322533	Screw	2

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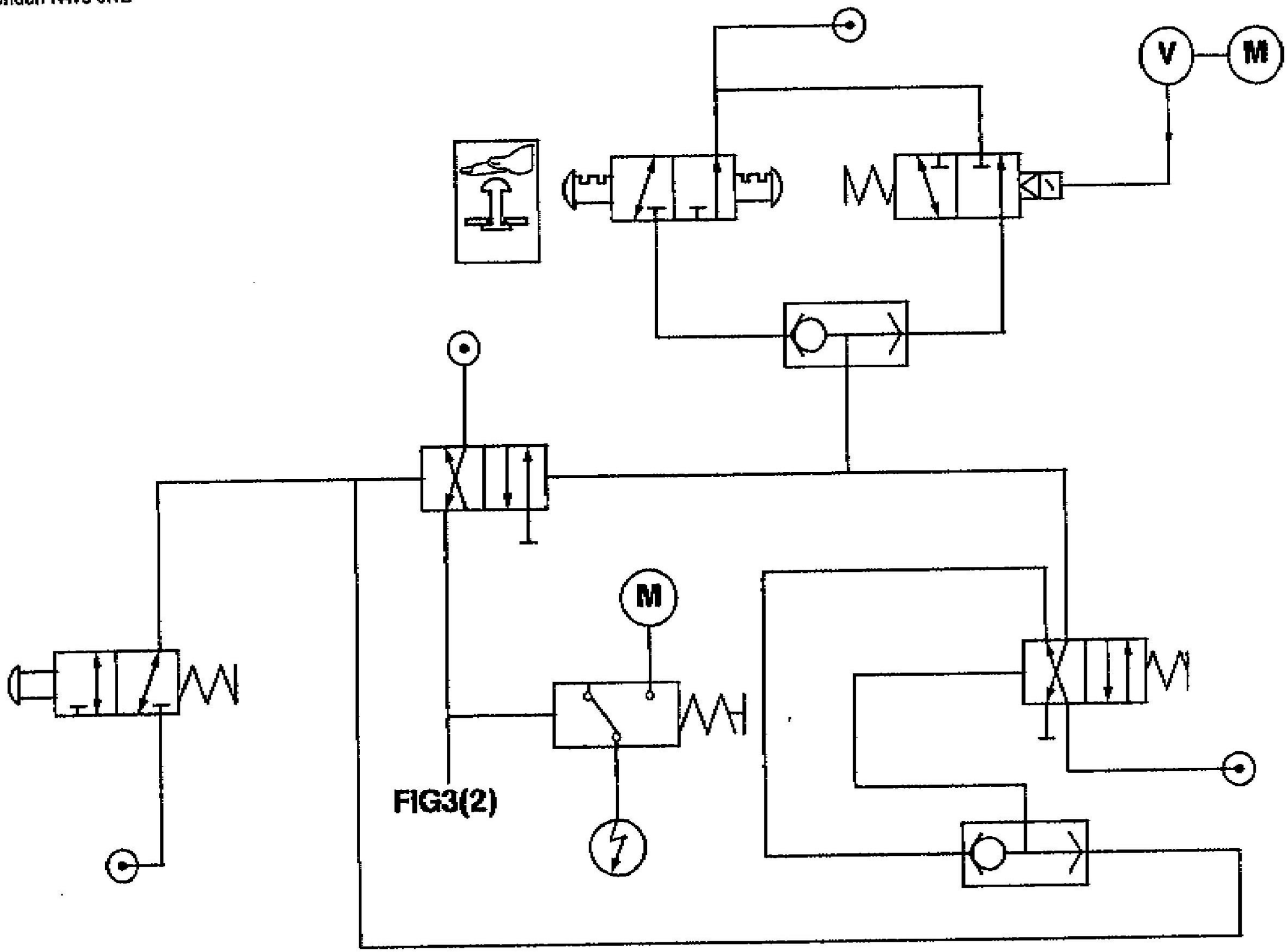

Figure 2

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OPERATORS INSTRUCTIONS

Air Supply - Main

A water free and filtered air supply is required, at a pressure of 6.3 bar (91.4 Psig), with a flow rate of 9.9l/s (21cu.ft/min) controlled by a pressure regulator selected from the Desoutter Air Line Service Equipment Catalogue.

Air Supply - Remote

The basic requirements are as above but the pressure must be at least 2.7bar (40 Psig) and the flow requirement when signalling is 0.47 l/s (1cu.ft/min). The signal duration should be kept to the minimum to reduce air consumption.

Lubrication

Correct lubrication is vital for maximum performance of the tool and an airline lubricator selected from the Desoutter Air Line Service Equipment Catalogue should be fitted into the system down stream of the filter.

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

The tool can be operated on dry line.

Electricity Supply

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

Voltage Chart - 3 Phase (AFDE41) (AFDEC41)

Recommended Starter Crabtree BD 15	Voltage V	Frequency Hz	Motor Connections Link	Overload Setting
20100/EB	220 to 240	50	Delta	14 - 16 Amps
20100/EB	220 to 264	60	Delta	1.4 - 1.6 Amps
20100/DJ	380 to 440	50	Star	0.8 - 1.0 Amps
20100/EH 440/480 60 Hz Coil	380 to 480	60	Star	0.8 - 0.8 Amps

Voltage Chart - 3 Phase (AFDE41H) (AFDE41HC)

Recommended Starter Crabtree 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	380 to 440	60	Star	1.9 to 2.4 Amps
20101/FH	380 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 pozidrive screws and the connecting links are connected between the screws. The earth connection is a 4mm pozidrive screw for which a suitable screwdriver will be required.

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

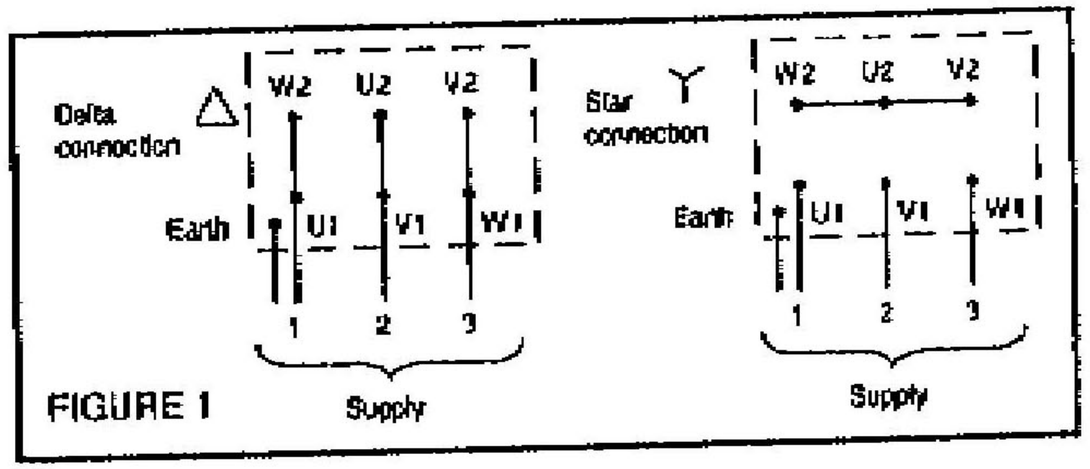

FIGURE 1

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.

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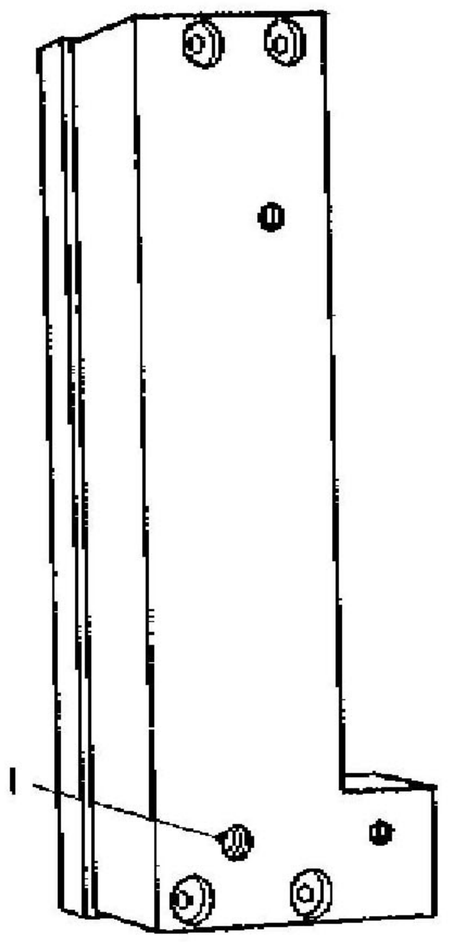

FIGURE 4 VALVE BLOCK MODULE BASIC

ccessories

Mounting Clamps - A range of clamps bases and columns are vailable. Full details obtained from Desoutter.

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

Peck Feed Drills - The Desoutter 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 Desoutter.

Dust Extraction Kits

Extension tube	Nominal Stroke Length	Locking Screw Length	Kit Part No.
250950	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.

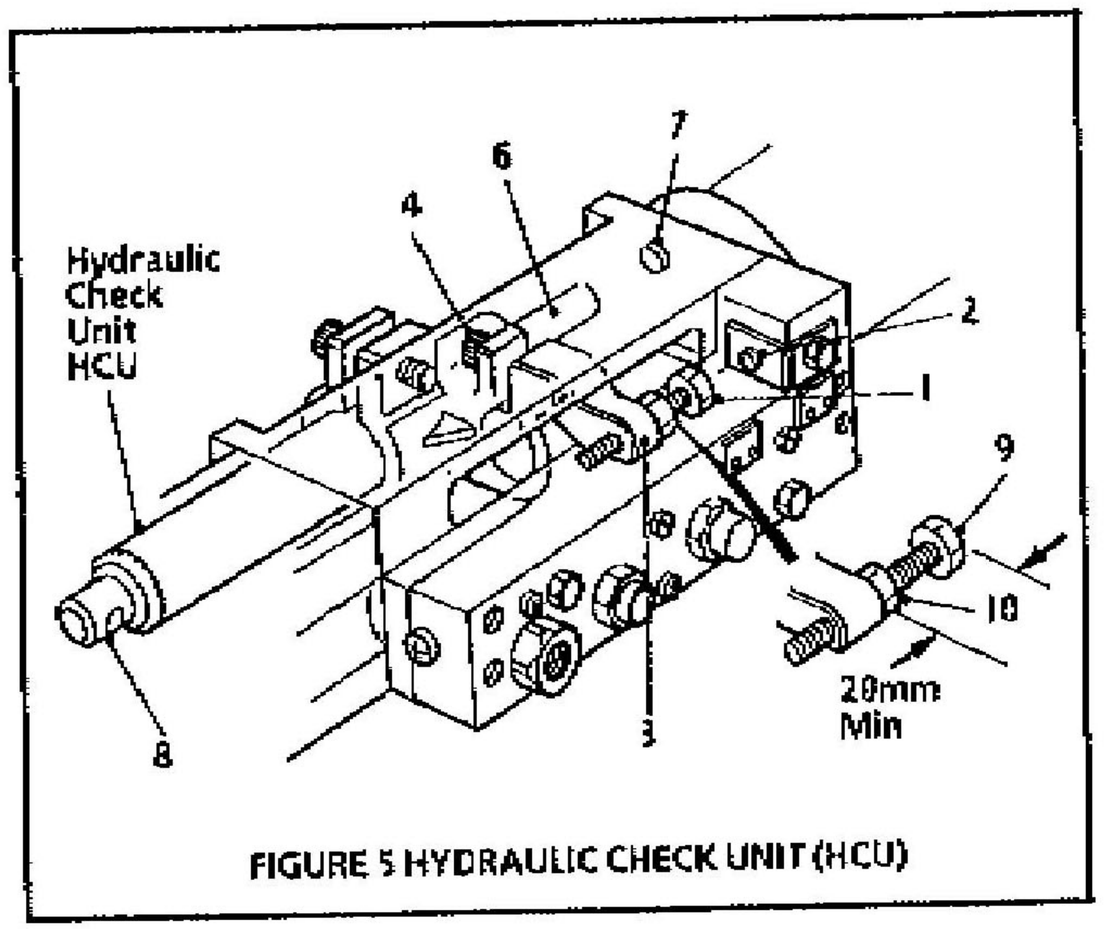

FIGURE 5 HYDRAULIC CHECK UNIT (HCU)

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

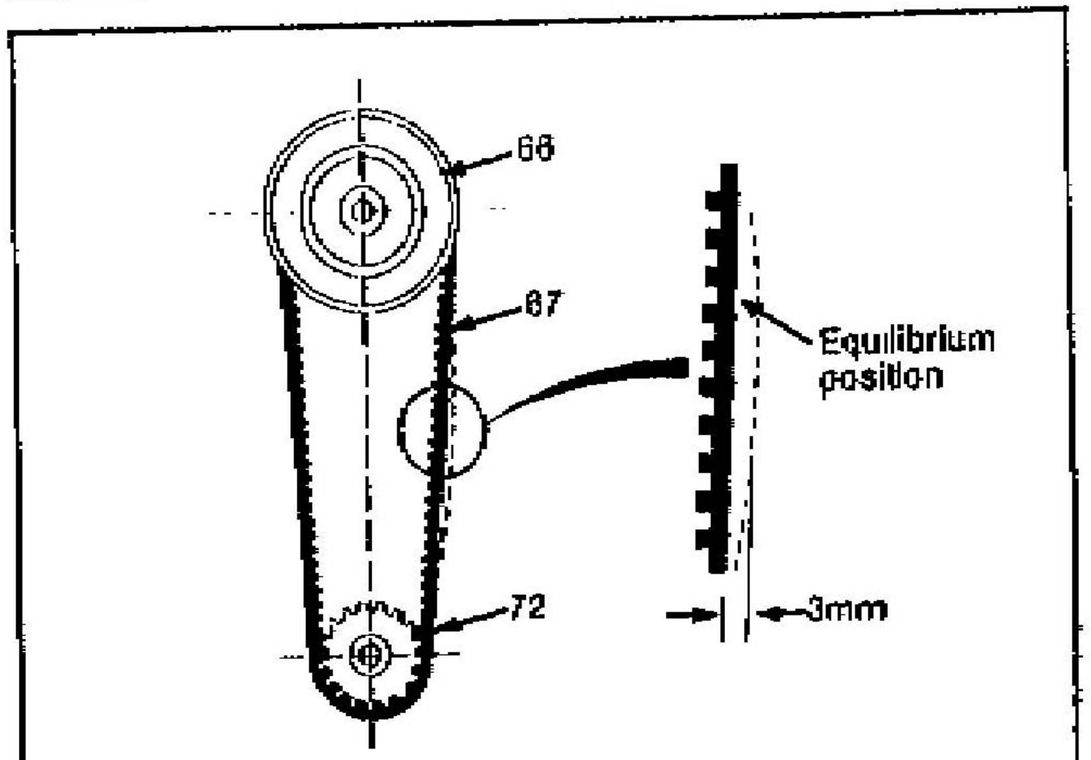

FIGURE 6 ADJUSTING THE TIMING BELT

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.

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

fount a tool, with the selected tap securely retained in the chuck, ove a test block to carry out sample tapping operations.

The end of the tap MUST be at least 14mm (9/16in) above the test ock, to allow for the tapping head reversing engagement travel. st the gap between Figure 5 (2) and (1) to equal the tapping depth LUS the distance the tap is above the work piece.

Adjust Figure 3 (11/13) to give the required advance, retract feeds r the operation.

Carry out a trial tapping operation and inspect the finished thread orm, adjust as necessary Figure 3 (11/13) and repeat until nformation in NOTES 1 and 2 are satisfied.

SERVICING REQUIREMENTS

General Notes

Use the following lubricants:

Grease - BP FG00 EP, for bearings.
Grease - Duckhams Type Q5618, for gears, splines and threads.
Grease - Molykote PG75 Plastislip, for 'O' rings and seals.

Cleaning

Requirements:

(1) Container to immerse components.

(2) Good quality clean paraffin.

Soak the components in the container containing the paraffin. Ensure full immersion, agitate components to ensure that air passages are flushed through. Remove components from the container, thoroughly dry and blow through air passages to remove moisture. Place components in an air tight container until required for assembly. Dispose of the dirty paraffin in accordance with health and safety 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 ±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.

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Part No. 359823 Issue 1 11.94

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