Auto Feed Drills and Tappers

Types          Code
AFD40-22000    111244
AFD40-12500    108194
AFD40-7000     115564
AFD40-5400     115224
AFD40-3400     113284
AFD40-2100     112394
AFD40-1250     109244
AFD40-790      116294
AFD40-490      114254
AFT40-1250     117264
AFT40-790      119204
AFT40-490      118234

Operating Instructions
Servicing Instructions
Parts List
## Parts List – Main Assembly/Control Top

### For parts location see front page

<table>
<thead>
<tr>
<th>Item No.</th>
<th>Part No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Item No.</th>
<th>Part No.</th>
<th>Description</th>
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- Indicates normal replacement items. It is recommended that adequate stocks are held for servicing requirements.
- Indicates updated parts.
- Always quote tool number, serial number and spare part number when ordering spares.
# Parts List – Motor & Gearbox

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Part List – Gearbox

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## Parts List – Gearbox

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- Always quote tool number, serial number and spare part number when ordering spares.
**Servicing Instruction/Parts List – Tapping Head**

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<td>531</td>
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<td>Tapping Head Complete</td>
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* Indicates normal replacement items. It is recommended that adequate stocks are held for servicing requirements. Always quote tool number, serial number and spare part number when ordering spares.

**SINGLE SPINDLE TAPPING HEAD**

**SERVICING**

**Tools**
- Service Tool Part No. 14663
- Separating item 524
- Spanner Part No. 55383 from item 524
- Wedges Part No. 75958 - Removing item 508

All other tools required will be found in a normal workshop.

**TO DISMANTLE**

Remove screw (502) and using the wedges detach the tapping chuck assembly (508).

Unscrew the tapping head complete (531) from the front of the tool and clamp the tapping head by its fluting in a vice. Remove the three screws (515) enabling the spindling housing (511), spring (512) and spindling housing (513), outer race (514) and case and balls (515) to be removed.

Unscrew the end cap complete (521) and remove with the chuck spindle (523) and the sun pinion (522).

Engage service tool 14653 with internal gear (524) and use spanner 55383 to unscrew whilst retaining the drive dog (525).

The remainder of the dismantling follows normal engineering practice with reference to the illustration.

**TO ASSEMBLE**

Reverse the dismantling instructions.