

# Rack Feed Drills

- The Rack Feed Drill is a semi-fixtured (nose mounted) portable drilling unit. Utilizing a manual feed through an integral "rack and pinion" mechanism to accommodate the approach drilling and retract cycles. This provides the user with complete control of the feed rate during drilling and allows the user to "feel" the feed rate required. Versatile and flexible, especially when drilling laminates and sandwich materials.
- RFD is suitable for drilling/reaming various materials used in the Aerospace industries e.g. Inconel, Titanium, Steel, Aluminium and Composites.
- A wide speed range from 60 rpm to 2800 rpm is available allowing the best speed to be selected to suit the application.
- RFD-100 provides 102mm (4") of adjustable working stroke length with a 13mm (1/2") chuck capacity.
- RFDT-125 provides 127mm (5") of adjustable working stroke length with a No. 2 Morse Taper drive spindle.
- Automatic motor start/stop – can be set to operate at any point within stroke setting for maximum economy of air.
- Various nose configurations can be provided.



## RFD Selection

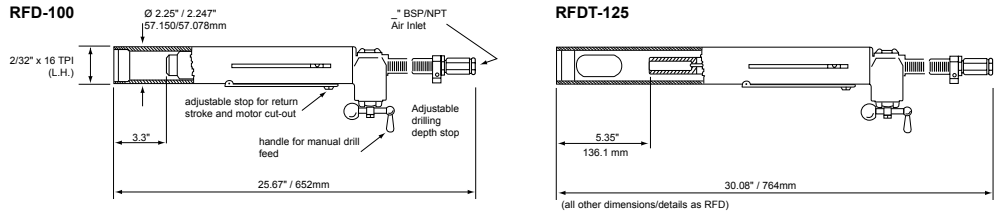
DRILL DIA.	MATERIAL			
	Inconel	Titanium	Mild Steel	Aluminium
	Tool type – r/min			
3mm 1/8"	RFD-330/500 RFD-330/500	RFD-500 RFD-500	RFD-2800	RFD-2800
5mm 3/16"	RFD-140/330 RFD-140/330	RFD-330/500 RFD-330/500	RFD-1850	RFD-2800
6mm 1/4"	RFD-140 RFD-140	RFD-140/330 RFD-140/330	RFD-800 RFD-800	RFD-1850
8mm 5/16"	RFD-140 RFD-140	RFD-140/330 RFD-140/330	RFD-800 RFD-800	RFD-800 RFD-800
10mm 3/8"	RFD-85/140 RFD-85/140	RFD-140 RFD-140	RFD-800 RFD-800	RFD-800 RFD-800
13mm 1/2"	RFD-60/85 RFD-60/85	RFD-85/140 RFD-85/140	RFD-500 RFD-500	RFD-800 RFD-800
16mm 5/8"		RFD-85/140 RFD-85/140	RFD-330 RFD-330	RFD-800 RFD-800
19mm 3/4"		RFD-60/85 RFD-60/85	RFD-85/140 RFD-85/140	RFD-330/500 RFD-330/500
25mm 1"			RFD-60/85 RFD-60/85	RFD-140/330 RFD-140/330

Use selection data as a guide only

All RFD-100 models supplied with 1/2" (13mm) chuck fitted

MODEL	PART NUMBER	FREE SPEED	MAX STROKE		OUTPUT SPINDLE	WEIGHT		AIR CONSUMPTION		AIR INLET	MIN. HOSE BORE		SOUND LEVEL
			r/min	in.		mm	lb	kg	cfm		l/s	BSP/NPT	
RFD-100-2800	681214	2800	4	102	1/2"-20 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-1850	681394	1850	4	102	1/2"-20 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-800	680084	800	4	102	5/8"-16 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-500	680164	500	4	102	5/8"-16 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-330	681244	330	4	102	5/8"-16 UN"	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-140	1457364	140	4	102	5/8"-16 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-85	1457374	85	4	102	5/8"-16 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFD-100-60	1457384	60	4	102	5/8"-16 UN	8.6	3.9	25	11.8	1/4	3/8	10	88
RFDT-125-800	1445654	800	5	127		12.1	5.5	25	11.8	1/4	3/8	10	88
RFDT-125-500	1445664	500	5	127	No. 2	12.1	5.5	25	11.8	1/4	3/8	10	88
RFDT-125-330	1445674	330	5	127	Morse	12.1	5.5	25	11.8	1/4	3/8	10	88
RFDT-125-140	1445504	140	5	127	Taper	12.1	5.5	25	11.8	1/4	3/8	10	88
RFDT-125-85	1445514	85	5	127		12.1	5.5	25	11.8	1/4	3/8	10	88
RFDT-125-60	1445524	60	5	127		12.1	5.5	25	11.8	1/4	3/8	10	88

# Accessories



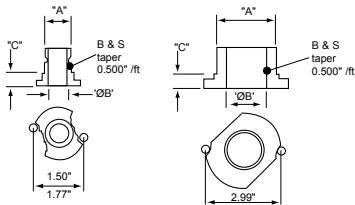
## RFD-100 / RFDT-125

### ACCESSORIES INCLUDED

	PART NO.	
	RFD	RFDT
• Chuck with key capacity 1/2" (13mm)	29142	
• Extended Nose (1" x 14 TPI LH nose thread)	251043	
• Bayonet Plate – 1.50" (45mm) centers	251063	
• Bayonet Plate – 2.99" (76mm) centers		35323

### OPTIONAL ACCESSORIES

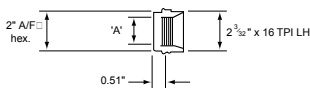
	PART NO.
	RFD
• Chuck Key	29242



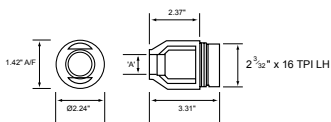
### Bayonet Plates

	'A'	'ØB'	'C'	PART NO.
• Locating centers – 1.50" (38mm)	3/4" x 16 TPI (LH)	0.559" (14.2mm)	0.374" (9.5mm)	251053
• Locating centers – 1.50" (38mm)	7/8" x 20 TPI (LH)	0.559" (14.2mm)	0.374" (9.5mm)	30623
• Locating centers – 1.77" (45mm)	1" x 14 TPI (LH)	0.75" (19.05mm)	0.374" (9.5mm)	251063
• Locating centers – 1.77" (45mm)	1 1/8" x 20 TPI (LH)	0.75" (19.05mm)	0.374" (9.5mm)	31113
• Locating centers – 2.99" (76mm)	2 3/32" x 16 TPI (LH)	1.50" (38.1mm)	0.50" (12.7mm)	35323

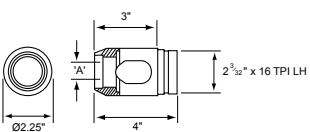
Nose Attachment 1



Nose Attachment 2



Nose Attachment 3

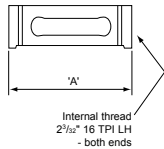


### Nose Attachments

Nose type	To suit bayonet plate centers	Thread 'A'	PART NO.
1	1.50" (38mm)	3/4" x 16 TPI (LH)	235773
2	1.50" (38mm)	3/4" x 16 TPI (LH)	251033
2	1.77" (45mm)	1" x 14 TPI (LH)	251043
3	–	1 1/4" x 12 TPI (LH)	235213
3	–	1 1/2" x 12 TPI (LH)	235223
3	–	2" x 16 TPI (LH)	235343

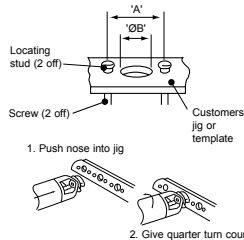
### Extension Tubes

Nominal stroke available to drill	Length 'A'	PART NO.
2.36" (60mm)	5.90" (150mm)	250933
3.15" (80mm)	6.69" (170mm)	250923



### Jig Plates

Centres 'A'	PART NO.	
	LOCATING STUD	SCREW
1.50" (38mm)	17632	17642
1.77" (45mm)	17632	17642
2.99" (76mm)	18422	18432



For dimension 'ØB' please ask for details of our range of drill bushings.

# CFD – Portable Feed Drill



## How to select ...

DR750-P6000-C8  
Drill power unit

fitted with

Constant Feed  
Module

+

Hydraulic Control  
Unit

Pt No. 470153

Pt No. 91942 – 25mm stroke  
Pt No. 91952 – 50mm stroke

MODEL	PART NUMBER	FREE SPEED	STD. CHUCK SIZE	
		r/min	in.	mm
DR750-P6000	1465124	6000	5/16	8
DR750-P4100	1465114	4100	5/16	8
DR750-P3300	1465104	3300	3/8	10
DR750-P2700	1465094	2700	3/8	10
DR750-P1300	1465084	1300	3/8	10
DR750-P750	1465074	750	–	–

For alternative chuck, or collet spindle,  
please select from accessories section.

## Drilling speed selection guide:

FREE SPEED	TITANIUM	STAINLESS STEEL	SOFT CAST IRON, MILD STEEL	ALUMINIUM, BRASS, COPPER, BRONZE	COMPOSITE
r/min		30-50ft/min	65-115ft/min	165-265ft/min	165-330ft/min
Drill Ø (mm)					
6000	–	–	–	5/32"	3/16"
4100	–	–	–	1/4"	5/16"
3300	–	–	1/8"	5/16"	3/8"
2700	–	–	5/32"	3/8"	–
1300	5/128-5/64"	5/32"	11/32"	–	–
750	1/8"	9/32"	3/8"	–	–

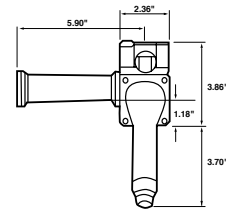
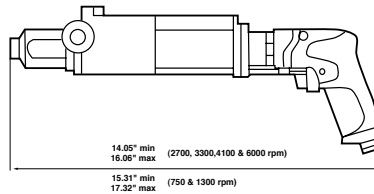
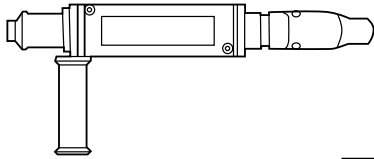
Max. working stroke 2"

Sound level: 75dB(A) with silencing kit fitted

Air inlet: 1/4" BSP/NPT. Vibration level: <2.5 m/s<sup>2</sup>.

MODEL	FREE SPEED	STD. CHUCK SIZE		MOTOR POWER		DYNAMIC THRUST		WEIGHT		AIR FLOW		MIN. HOSE BORE	
	r/min	in.	mm	Hp	kW	lbf	N	lb	kg	cfm	l/s	in.	mm
CFD-DR750-P6000	6000	3/8	8	1.00	0.75	146	650	1.70	3.75	30	14	3/8	10
CFD-DR750-P4100	4100	3/8	8	1.00	0.75	146	650	1.70	3.75	30	14	3/8	10
CFD-DR750-P3300	3300	3/8	10	1.00	0.75	146	650	1.70	3.75	30	14	3/8	10
CFD-DR750-P2700	2700	3/8	10	1.00	0.75	146	650	1.70	3.75	30	14	3/8	10
CFD-DR750-P1300	1300	3/8	10	1.00	0.75	146	650	1.93	4.25	30	14	3/8	10
CFD-DR750-P750	750	3/8	–	1.00	0.75	146	650	1.93	4.25	30	14	3/8	10

# Accessories



## CFD-DR750-..

### ACCESSORIES INCLUDED

ITEM	PART NO.		
	6000 & 4100 r/min	3300, 2700 & 1300 r/min	750 r/min*
1 Chuck (without key) capacity 5/16" (8mm)	410203		
• Chuck Key	410213		
1 Chuck with key capacity 3/8" (10mm)		31132	
• Chuck Key		29232	
• No chuck*			3/8"-24 spindle
2 Tooling Tube 3/4" - 16 UN LH thread	469883	469883	469883
• Sound reduction kit (75 dB(A))	tba	tba	tba

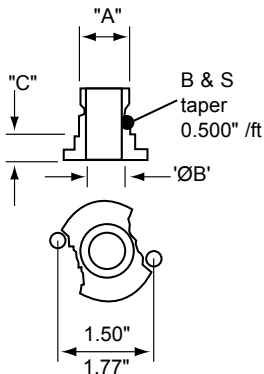
### OPTIONAL ACCESSORIES

	PART NO.
3 Tooling Tube blank (for local customisation)	471873
• Hydraulic Control Unit – 25mm 1" stroke	91942
• Hydraulic Control Unit – 50mm 2" stroke	91952
• Tamper proof HCU cap	110632
• Micrometer depth adjustment module	tba
• Dust extraction kit	tba
• Self colleting mandrel – nose mount	tba
4 Collet Spindle – max capacity 3/8" (Ø9.5mm)	6155230230
5 Collet Nut	6156071440
6 Collet – capacity 1/8" (Ø2.4 to 3.2mm)	6155260610
6 Collet – capacity 7/32" (Ø5.2 to 6.0mm)	6155260620
6 Collet – capacity 1/4" (Ø5.55 to 6.35mm)	6155260630
6 Collet – capacity 5/16" (Ø7.2 to 8.0mm)	6155260640
6 Collet – capacity 3/8" (Ø8.7 to 9.5mm)	6155260640

### Bayonet Plates

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\* Tooling tube (3/4" - 16 UN LH) is suitable for use with 21000 series drill bushings.



Bushings available on request.  
Please ask for further details.

