Desoutter Limited Eaton Road Hemel Hempstead Hertfordshire HP2 7DR telephone +44 1442 344300 facsimile +44 1442 344604

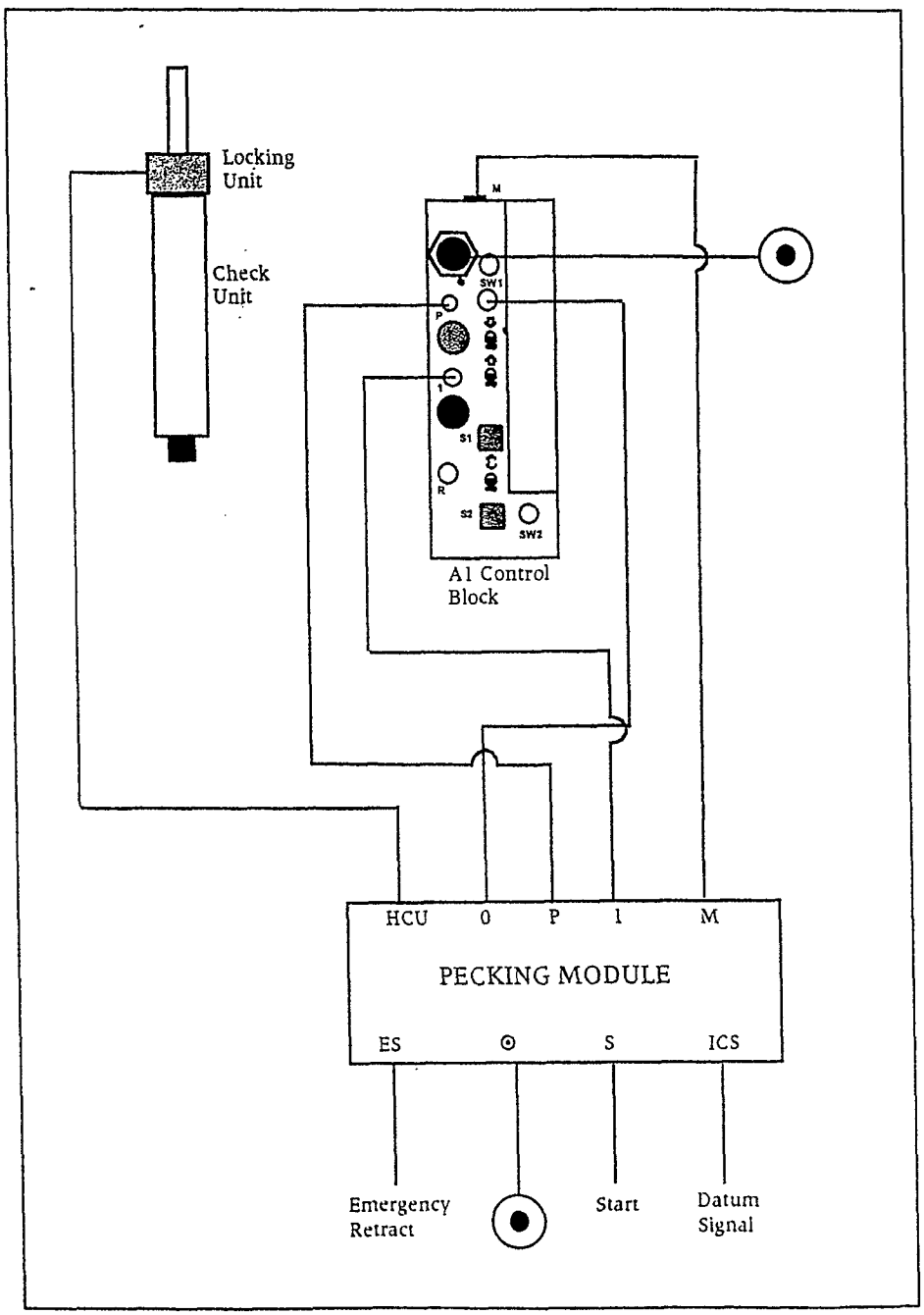
Peck Feed Kits

D4 25mm (1")
Part no. 92282

D5 50mm (2")
Part no. 92292

D6 75mm (3")
Part no. 92302

Fig 1. Circuit diagram



Parts List

The peck Feed Kit comprises;

D4 25mm (1") Stroke – Part no. 92282

Item	Part No.	Description	Qty
1	92902	Pecking Module	1
2	91972	Check Unit	1
3	92002	Locking Unit	1
4	62862	Tubing 4mm	10 m
5	62392	Stud M5-4mm	4
6	72102	Elbow M5-4mm	1
7	257023	Adaptor	1
8	257033	Lock Nut	1
9	250913	O Ring	1
10	62852	Blanking Plug	1

D5 50mm (2") Stroke – Part no. 92292

Item	Part No.	Description	Qty
1	92902	Pecking Module	1
2	91982	Check Unit	1
3	92002	Locking Unit	1
4	62862	Tubing 4mm	10 m
5	62392	Stud M5-4mm	4
6	72102	Elbow M5-4mm	1
7	257023	Adaptor	1
8	257033	Lock Nut	1
9	250913	O Ring	1
10	62852	Blanking Plug	1

D6 75mm (1") Stroke – Part no. 92302

Item	Part No.	Description	Qty
1	92902	Pecking Module	1
2	91972	Check Unit	1
3	92002	Locking Unit	1
4	62862	Tubing 4mm	10 m
5	62392	Stud M5-4mm	4
6	72102	Elbow M5-4mm	1
7	257023	Adaptor	1
8	257033	Lock Nut	1
9	250913	O Ring	1
10	62852	Blanking Plug	1

Fitting Instructions

Disconnect the air supply and electrical supply (if applicable) from the tool.

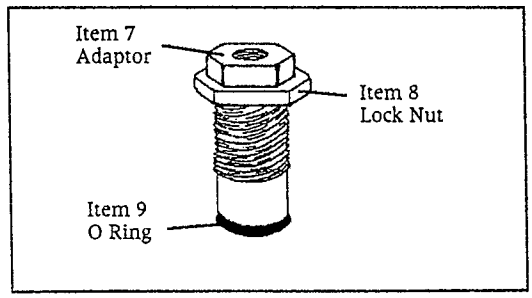
Fit the items (5), (6), (7), (8) and (9) as follows;

Port on A1 Control Block	Fitting
P	Item (5)
1	Item (5)
M	Item (5)
O	Items (5), (7), (8), (9)

Fit item (6) to the locking unit, item (3).

For the O port fittings screw the locking nut (8) onto the adaptor (7) and fit the O ring (9) to the bottom of the adaptor (7) as shown in fig. 2.

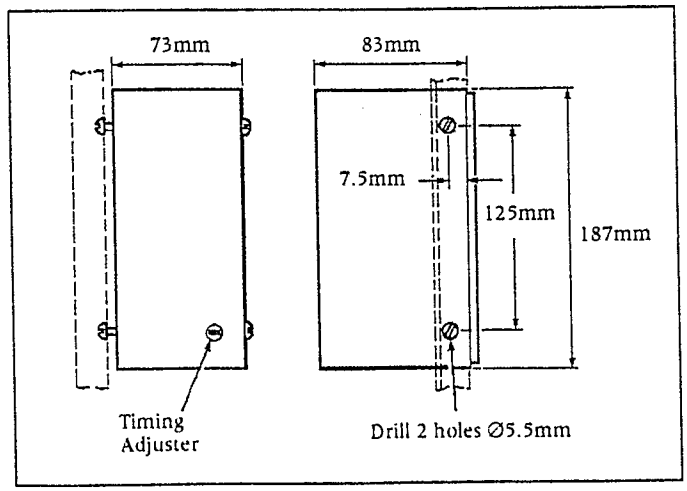
Fig. 2 Adaptor Assembly



Screw the adaptor (9) into the O port securely. Lock in position by tightening the locking nut (8) on to the face of the control block. Fit the stud (5) into the adaptor.

To mount the pecking module (1) into position on the machine use the two screws on the side of the module as per fig. 3.

Fig. 3 Mounting Dimensions for Pecking Module



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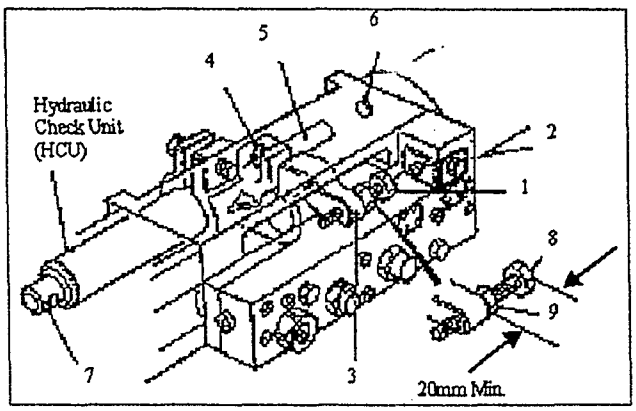
Measure and cut the tubing (4) and connect the ports on the control block and the locking unit (3) to the pecking module (1) with the tubing (as per fig. 1) ensuring the tubing is securely pushed into the fittings by pulling on them.

Note: If fitting the peck kit to an AFD60 fit a signal inversion kit (part no. 104822) in the line from the M port on the control block to the M port on the pecking module (1).

Fitting the check unit and setting the depth on the tool

To set the depth on the AFD(E) tools the drill bit should be as close as possible to the work to reduce the cycle time.

Fig. 4 Depth Setting



Depth is set by adjusting the gap between the adjusting screw (1) and the depth valve (2). The gap should be equal to the depth to be drilled, plus the distance of the drill bit above the work piece and any clearance through the other side (refer to the operating instructions for the tool service sheet). Slide the crosshead (3) to the correct position and locking it in that position using screw (4).

Use the setting screw (8) to finally set the depth and lock in position with nut (9).

To fit the check unit, slide the check unit into the crosshead (3), align the flat on the check unit with that in the crosshead and set the gap between the check unit rod (5) and the housing (6) to the distance required above the work piece. Lock the check unit in position with screw on crosshead.

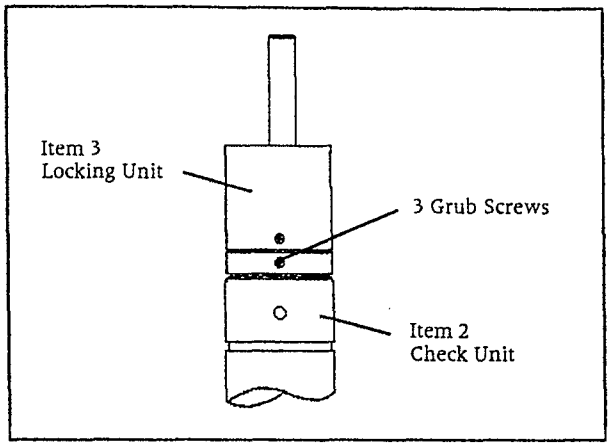
Unscrew the check unit adjuster (7) away from the check unit to adjust the control rate to a minimum. On the A1 control block adjust the flow regulators ⇧,⇳ and ⇩as per the operating instructions for the tool.

Fitting the Locking Unit

Remove the tubing from the "HCU" port on the pecking module (1). Connect the tube to an air supply and turn the air on. This releases the lock.

Slide the locking unit (3)on to the check unit (2) as per fig. 5. Secure in position by tightening the 3 grub screws.

Fig. 5 Mounting the Locking Unit



Switch off the air supply and disconnect the tube and reconnect to the "HCU" port on the pecking module (1).

Connection to the Mains Air Supply

Ensure that the air supply is turned off.

The air supply to the pecking module should be filtered (minimum of 30µm filter) and non-lubricated. A suitable supply can be found by connecting between the filter and the lubricator on the Desoutter range of filter, regulator, lubricator units.

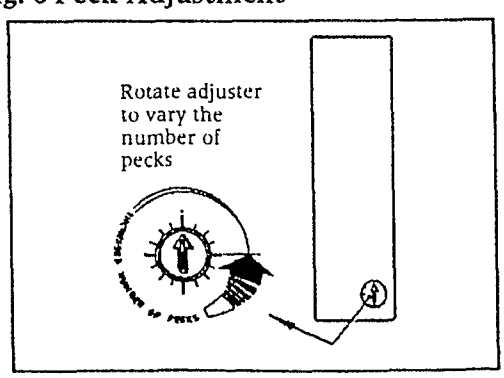
A minimum pressure of 6 bar (90psi) is required.

Connect the ⊙ port on the pecking module (1) to the air supply using an appropriate fitting. Ensure all fittings are secure prior to turning the air supply on.

Setting the Peck Adjustment

To set the pecking timer rotate the adjuster to the zero rate of pecking (see fig.6).

Fig. 6 Peck Adjustment



Set up a trial drilling operation and set the adjuster to give the required number of pecks dictated by the component material and the depth of drilling.

Connecting to an External Circuit

The pecking unit can be controlled by using the following pneumatic signals;

Start – Apply a pulse of air for 0.5-1 seconds into the "S" port on the pecking module (1). The tool will cycle automatically.

Emergency Retract – Apply a pulse of air for 0.5-1 seconds into the "ES" port on the pecking module (1). The tool will cycle return to datum automatically.

Tool at Datum Signal – A positive continuous air signal is emitted from the "ICS" port when the tool is at the datum position. This signal decays when the tool is cycling. This port should be blanked off using the blanking plug (10) when not in use.

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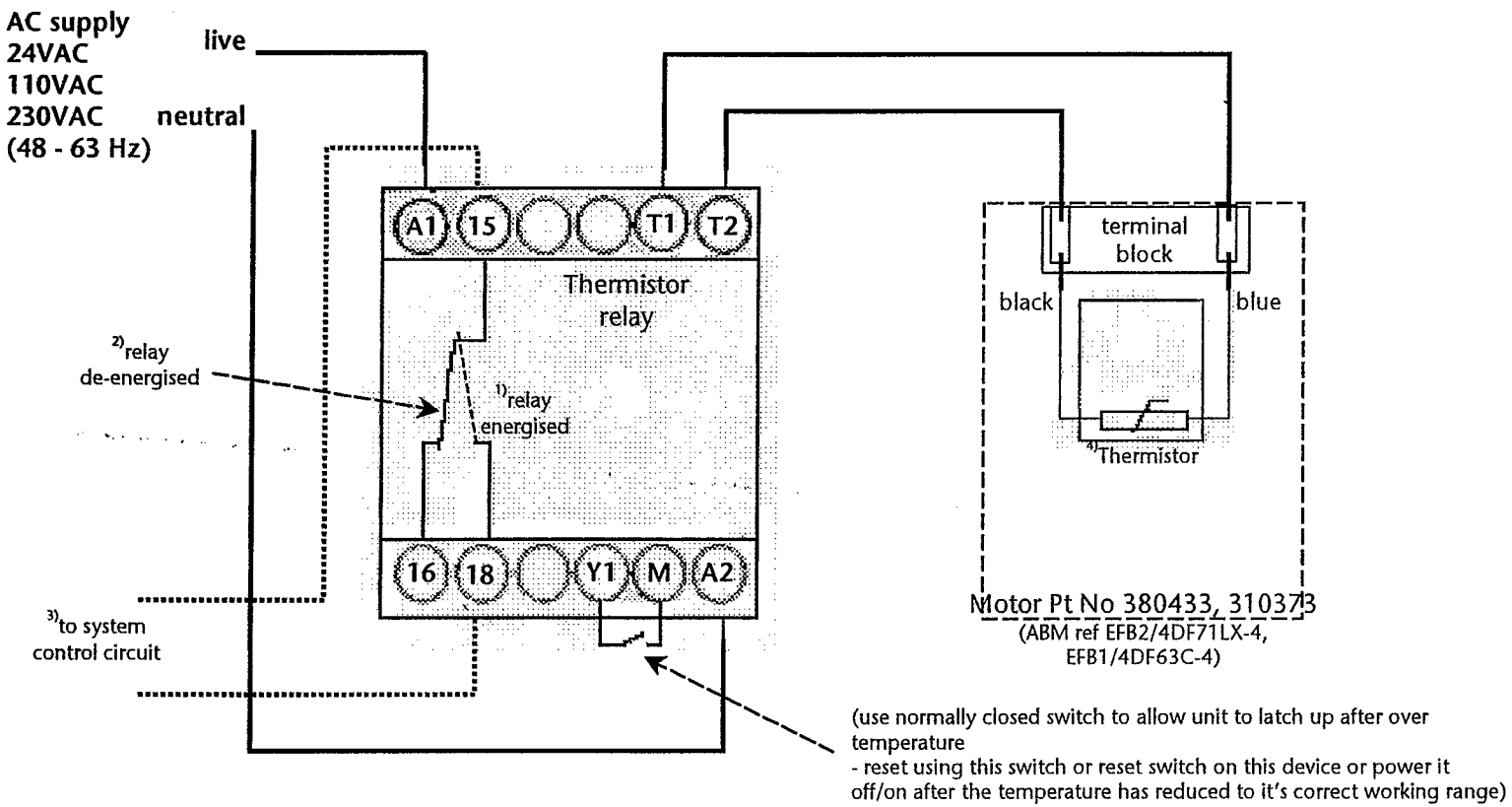
For motor connection instructions refer to 'operating instructions' supplied with the AFTE480 in conjunction with this document.
The following supersedes the instruction concerning the 'thermal cut-out' connections.

The brake motors used on the AFTE480 and AFTE470 now contain a built in Thermistor Detector PTC(in place of the thermal cut-out) that is used for motor overload protection.
To enable the thermistor to be utilised an external thermistor relay is required.
Suitable thermistor relays are available from electrical/electronic suppliers.
Below shows a typical connection diagram using a thermistor relay:



[1] relay energised when temperature OK.
[2] relay de-energised when over temperature or short circuit in thermistor circuit.
[3] connect in series with holding coil in the supply contactor or to TC1 & TC2 of the Desoutter control box.
[4] "Release" (Over temperature) resistance is] 3990Ω, "Reset" (Temperature within acceptable range) resistance is *1