

*Desoutter*



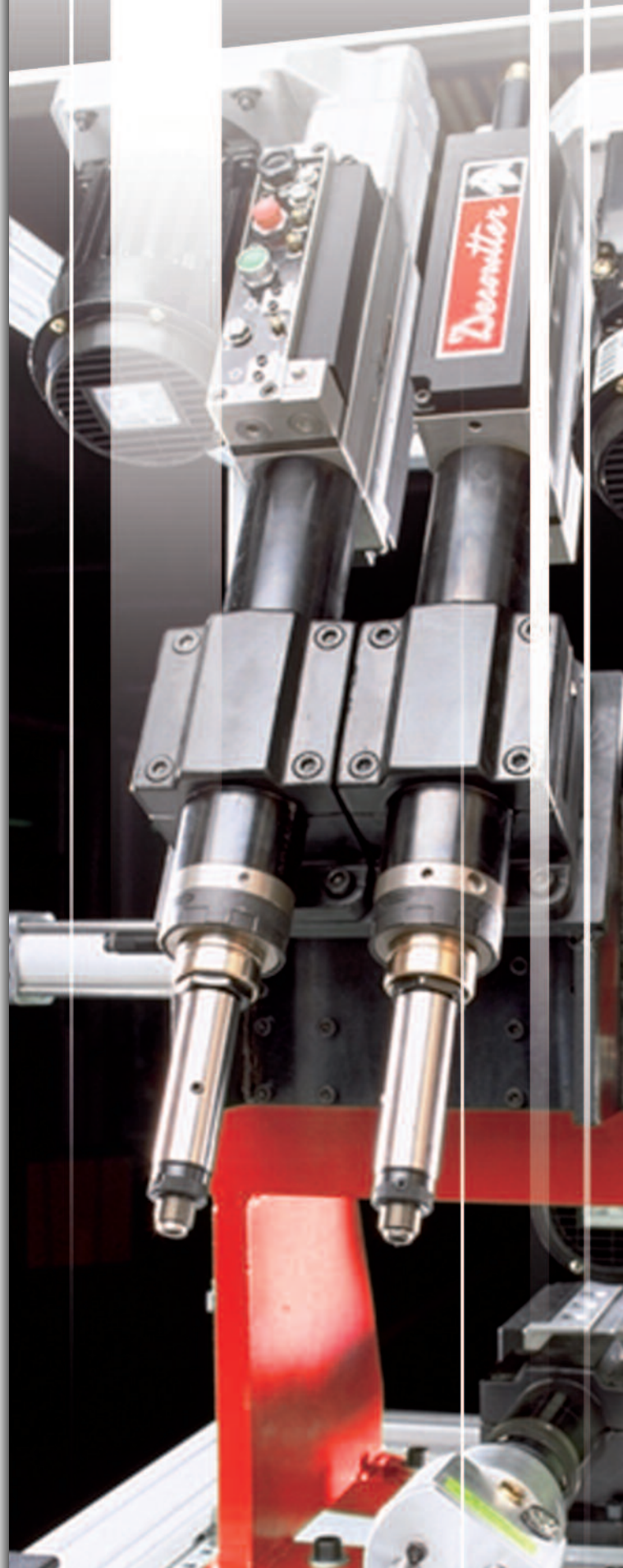
**Industrial** Tools



## *Auto Feed Drills & Tappers*

- *Comprehensive range*
- *Single spindle operations*
- *Multi-spindle processes*

**More Than Productivity**

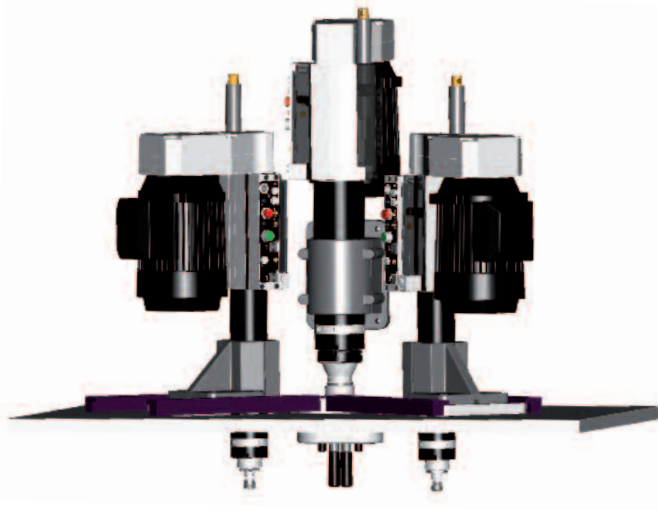
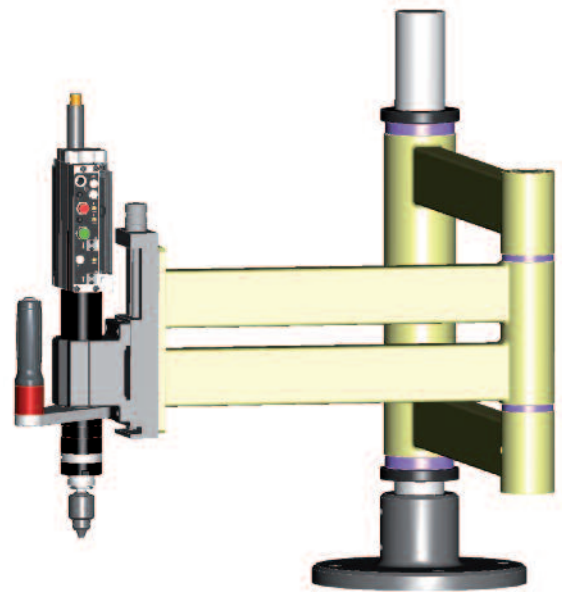


# AFD Applications

---

## Ease of Integration into Machine or Process

- Extensive range of mounting clamps
- Control interfaces to link AFD(E) to other equipment through pneumatics or electrically
- Single signal required for AFD(E) to perform cycle
- Output signals at datum and depth
- Electric motor mounting on 200, 400 and 600 series can be rotated 180°



## Comprehensive range of Product

- For single spindle operations to multi spindle processes
- Pneumatic and electric drive from 0.22 to 1.1kW (0.3 to 1.47hp) with thrusts from 1557N (72-350lbf)
- Reliability through quality

## Modular Design

- Flexibility of unit function and speed
- Common components in different models reduce inventory
- Multiple spindle head options
- Drilling and tapping options for all models



## Auto Feed Drills & Tappers

Auto Feed Drills & Tappers Features ..... 4

How to select your AFD ..... 5-7

### DRILLING

AFDE200 - AFDE230 (Electric drive) ..... 8-9

0.25 kW (0.34hp) - 850 to 11950 rpm

AFD205 - AFD215 (Pneumatic drive) ..... 10-11

0.22 kW (0.30hp) - 650 to 18700 rpm

AFDE400 - AFDE430 - AFDE410 - AFDE440 (Electric drive) ..... 12-13

0.33 - 0.75 kW (0.44 - 1hp) - 330 to 11950 rpm

AFD415 (Pneumatic drive) ..... 14-15

0.38 kW (0.5hp) - 490 to 18000 rpm

AFDE610 - AFDE620 - AFDE640 (Electric drive) ..... 16-17

0.75 - 1.1 kW (1 - 1.47hp) - 330 to 6300 rpm

AFD625 (Pneumatic drive) ..... 18-19

0.63 kW (0.85hp) - 40 to 3300 rpm

### TAPPING

AFTE480 (Electric drive) ..... 20-21

0.75 kW (1hp) - 180 to 1740 rpm

ACCESSORIES ..... 22-32

Control Block & Interfaces ..... 22

AFD Control Options ..... 23

Output Spindles - Chucks ..... 24-25

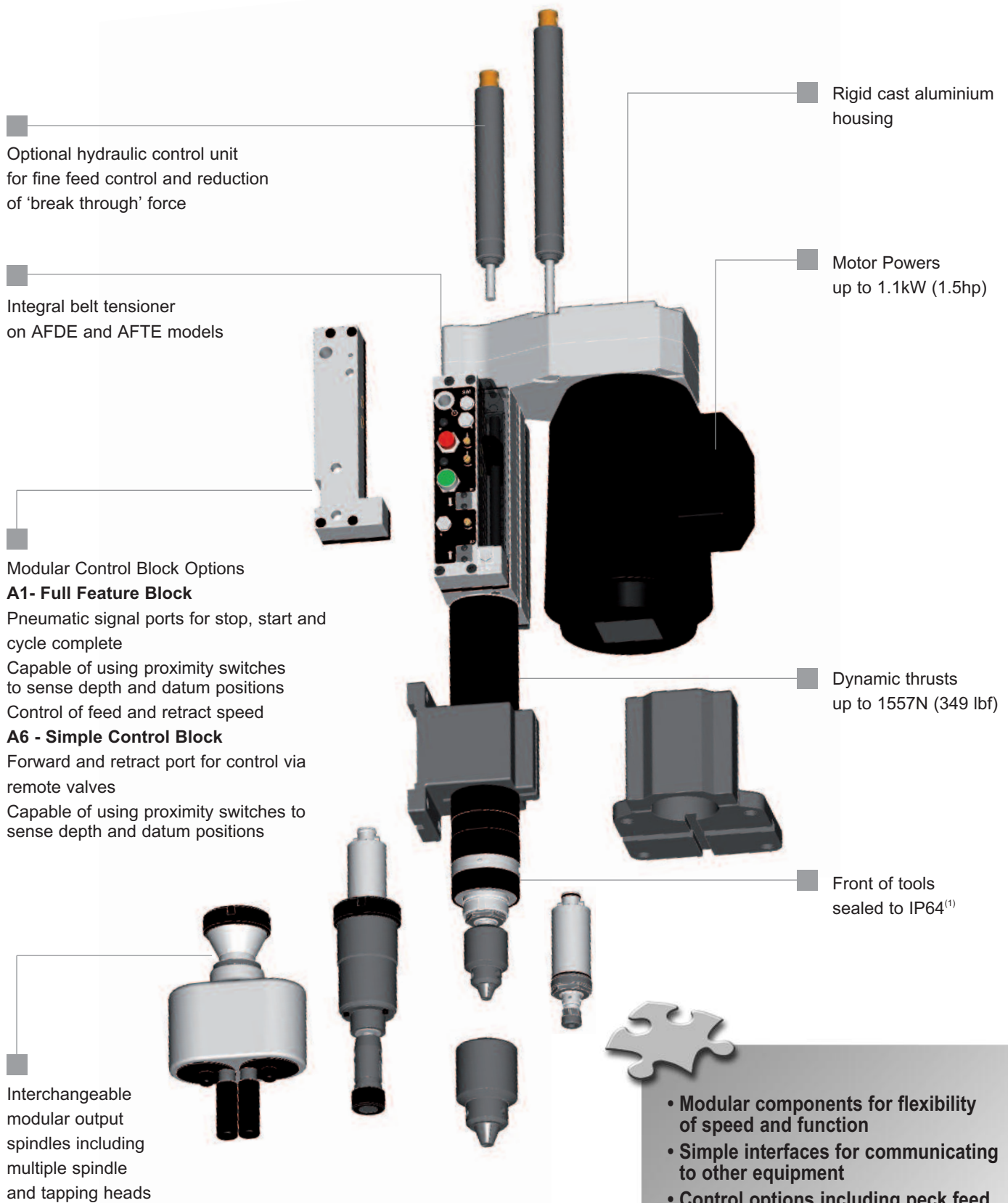
Multiple Spindle Heads ..... 26-27

Collets ..... 28

Clamps ..... 29-32

AFD Selection Program ..... 35

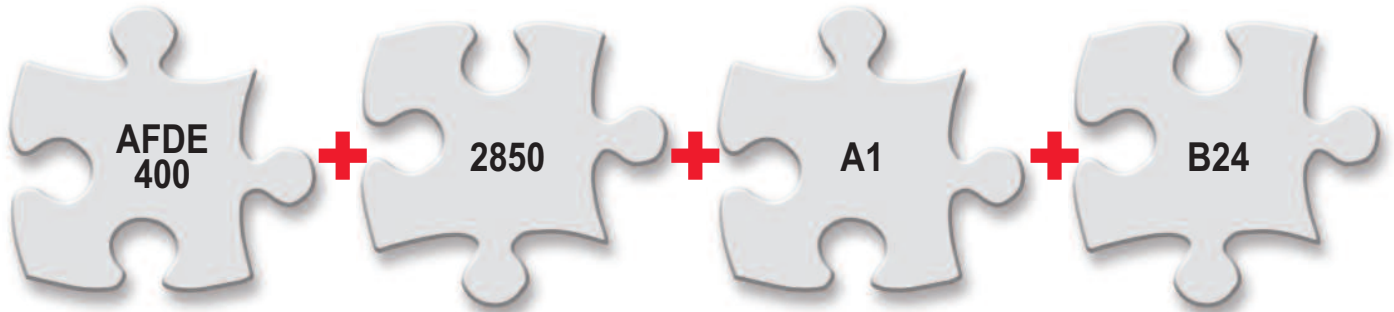
# Auto Feed Drills & Tappers Features



- Modular components for flexibility of speed and function
- Simple interfaces for communicating to other equipment
- Control options including peck feed, dwell, and skip feed
- Heavy duty belts and pulleys on AFDE and AFTE models

# How to select your AFD

How to Order :



## Model Type

### Pneumatic Feed and Drive

- AFD205 0.22kW (0.30hp)
- AFD215 0.22kW (0.30hp)
- AFD415 0.38kW (0.51hp)
- AFD625 0.63kW (0.85hp)

### Pneumatic Feed, Electric Drive

- AFDE200 0.25kW (0.34hp)
- AFDE400 0.33kW (0.44hp)
- AFDE410 0.75kW (1.00hp)
- AFDE610 0.75kW (1.00hp)
- AFDE620 1.10kW (1.50hp)

### Electric Feed and Drive via Leadscrew

- AFTE480 0.75kW (1.00hp)

## No Load Speed

The free output speed of the drill or tapper with no drilling or tapping load applied.

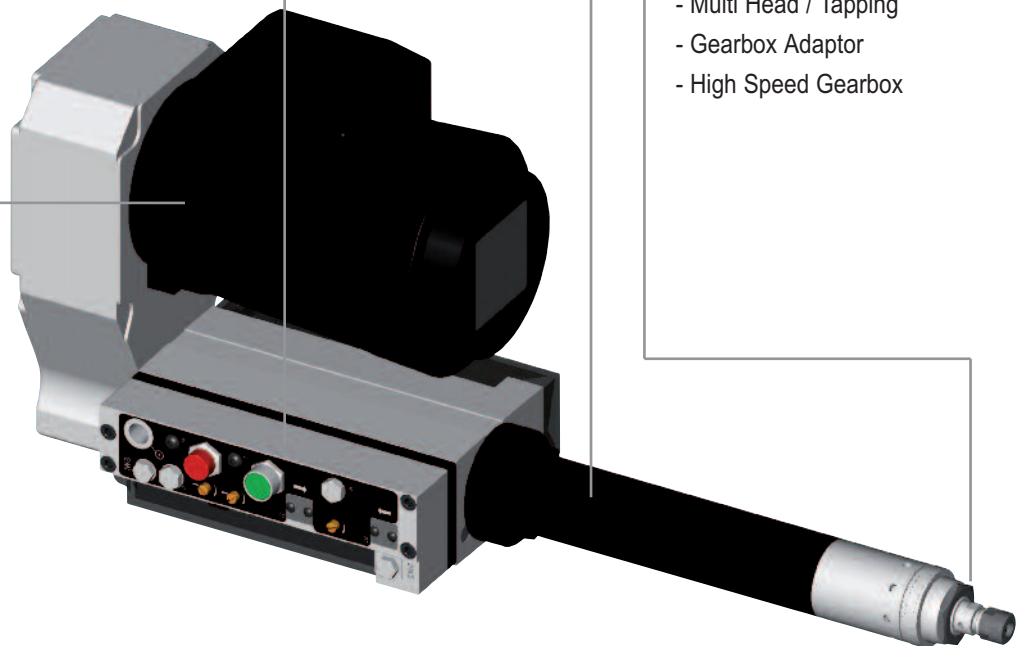
## Control Block

- A1 – Full feature type<sup>(1)</sup>
  - Automatic cycle
- A6 – Simple type<sup>(1)</sup>
  - Remote cycle control
- A7 – Leadscrew type – PNP
- A8 – Leadscrew type – NPN

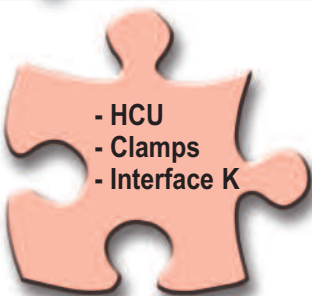
## Output Spindle

### Code Output type

- Chuck
- Collet (up to 8mm (5/16"))
- Preset Tooling DIN55058
- 1/4" & 5/16" Hex Clutch
- 6.5mm (1/4") & 8mm (5/16") Tapping Gearbox
- B16 Taper
- Jacobs No1 & No2
- ISO30 Taper
- Multi Head / Tapping
- Gearbox Adaptor
- High Speed Gearbox



## + OPTIONAL



- HCU
- Clamps
- Interface K

(1) Not required on AFTE models.

# How to select your AFD

## ■ Electric drive - Pneumatic feed

| TYPE AND SPEED  | FREE SPEED |       | MAXIUM STROKE |      | DYNAMIC THRUST |     | MILD STEEL  | ALUMINIUM   | HARD WOOD   |     |             |             |             |
|---|------------|-------|---------------|------|----------------|-----|-------------|-------------|-------------|-----|-------------|-------------|-------------|
|   | 50Hz       | 60Hz  | mm            | in.  | N              | lbf |             |             |             |     |             |             |             |
| <b>AFDE200 Serie - 0.25 kW (0.34hp)</b>               |            |       |               |      |                |     | <b>Ø mm</b> | <b>Ø mm</b> | <b>Ø mm</b> |     |             |             |             |
| AFDE200-850   | 850        | 1020  | 90            | 3.54 | 320            | 72  | 4           | 5           | 7           |     |             |             |             |
| AFDE200-1200  | 1200       | 1450  |               |      |                |     | 4           | 5           | 6           |     |             |             |             |
| AFDE200-2350  | 2350       | 2820  |               |      |                |     | 3.5         | 4           | 5           |     |             |             |             |
| AFDE200-2850  | 2820       | 3400  |               |      |                |     | 2.5         | 3           | 4           |     |             |             |             |
| AFDE200-3750  | 3750       | 4500  |               |      |                |     | 2           | 2.5         | 2.5         |     |             |             |             |
| AFDE200-4600  | 4600       | 5450  |               |      |                |     | 2           | 2           | 2           |     |             |             |             |
| AFDE200-5250  | 5250       | 6300  |               |      |                |     | 1.5         | 2           | 2           |     |             |             |             |
| AFDE200-8000  | 8000       | 9600  |               |      |                |     | 1           | 1.5         | 1.5         |     |             |             |             |
| AFDE200-10000   | 10000      | 11950 |               |      |                |     | 0.5         | 1           | 1           |     |             |             |             |
| <b>AFDE400 Serie - 0.33 - 0.37 kW (0.44 - 0.49hp)</b> |            |       |               |      |                |     | <b>Ø mm</b> | <b>Ø mm</b> | <b>Ø mm</b> |     |             |             |             |
| AFDE400-330   | 330        | 400   | 100           | 3.94 | 724            | 163 | 10          | 12          | 16          |     |             |             |             |
| AFDE400-550   | 550        | 660   |               |      |                |     | 9.5         | 11          | 16          |     |             |             |             |
| AFDE400-900   | 900        | 1100  |               |      |                |     | 9           | 10.5        | 15          |     |             |             |             |
| AFDE400-1200  | 1200       | 1450  |               |      |                |     | 8           | 10          | 14          |     |             |             |             |
| AFDE400-1450  | 1450       | 1740  |               |      |                |     | 6           | 10          | 12          |     |             |             |             |
| AFDE400-1750  | 1750       | 2100  |               |      |                |     | 5           | 9           | 11          |     |             |             |             |
| AFDE400-2350  | 2350       | 2820  |               |      |                |     | 4           | 8           | 10          |     |             |             |             |
| AFDE400-2850  | 2850       | 3400  |               |      |                |     | 3           | 6           | 8           |     |             |             |             |
| AFDE400-3750  | 3750       | 4500  |               |      |                |     | 2.5         | 5           | 6           |     |             |             |             |
| AFDE400-4600  | 4600       | 5450  |               |      |                |     | 2           | 4.5         | 5.5         |     |             |             |             |
| AFDE400-5250  | 5250       | 6300  |               |      |                |     | 1.5         | 4           | 5           |     |             |             |             |
| AFDE400-8000  | 8000       | 9600  |               |      |                |     | 1           | 3.5         | 2.5         |     |             |             |             |
| AFDE400-10000   | 10000      | 11950 |               |      |                |     | 1           | 2           | 2           |     |             |             |             |
| <b>AFDE410 Serie - 0.75 kW (1hp)</b>                  |            |       |               |      |                |     | <b>Ø mm</b> | <b>Ø mm</b> | <b>Ø mm</b> |     |             |             |             |
| AFDE410-330   | 330        | 400   | 100           | 3.94 | 724            | 163 | 11          | 12          | 20          |     |             |             |             |
| AFDE410-550   | 550        | 660   |               |      |                |     | 10          | 12          | 20          |     |             |             |             |
| AFDE410-900   | 900        | 1100  |               |      |                |     | 9           | 11          | 19          |     |             |             |             |
| AFDE410-1200  | 1200       | 1450  |               |      |                |     | 8           | 10          | 18          |     |             |             |             |
| AFDE410-1450  | 1450       | 1740  |               |      |                |     | 7           | 10          | 16          |     |             |             |             |
| AFDE410-1750  | 1750       | 2100  |               |      |                |     | 6           | 9           | 14          |     |             |             |             |
| AFDE410-2350  | 2350       | 2820  |               |      |                |     | 5           | 8           | 12          |     |             |             |             |
| AFDE410-2850  | 2850       | 3400  |               |      |                |     | 4           | 6           | 11          |     |             |             |             |
| AFDE410-3750  | 3750       | 4500  |               |      |                |     | 2.5         | 6           | 10          |     |             |             |             |
| AFDE410-4600  | 4600       | 5450  |               |      |                |     | 2           | 5.5         | 7           |     |             |             |             |
| AFDE410-5250  | 5250       | 6300  |               |      |                |     | 2           | 5           | 6           |     |             |             |             |
| AFDE410-8000  | 8000       | 9600  |               |      |                |     | 1.5         | 4           | 4           |     |             |             |             |
| <b>AFDE610 Serie - 0.75 kW (1hp)</b>                  |            |       |               |      |                |     | <b>Ø mm</b> | <b>Ø mm</b> | <b>Ø mm</b> |     |             |             |             |
| AFDE610-330   | 330        | 400   |               |      |                |     | 100         | 3.94        | 1557        | 350 | 12          | 20          | 22          |
| AFDE610-550   | 550        | 660   | 10            | 18   | 20             |     |             |             |             |     |             |             |             |
| AFDE610-900   | 900        | 1100  | 10            | 16   | 20             |     |             |             |             |     |             |             |             |
| AFDE610-1200  | 1200       | 1450  | 7             | 14   | 16             |     |             |             |             |     |             |             |             |
| AFDE610-1450  | 1450       | 1740  | 6.5           | 12   | 14             |     |             |             |             |     |             |             |             |
| AFDE610-1750  | 1750       | 2100  | 6             | 12   | 14             |     |             |             |             |     |             |             |             |
| AFDE610-2350  | 2350       | 2820  | 4             | 10   | 11             |     |             |             |             |     |             |             |             |
| AFDE610-2850  | 2850       | 3400  | 3             | 6    | 8              |     |             |             |             |     |             |             |             |
| AFDE610-3750  | 3750       | 4500  | 2.5           | 5    | 6              |     |             |             |             |     |             |             |             |
| AFDE610-4600  | 4600       | 5450  | 2             | 4    | 5              |     |             |             |             |     |             |             |             |
| AFDE610-5250  | 5250       | 6300  | 1.5           | 3.5  | 4              |     |             |             |             |     |             |             |             |
| <b>AFDE620 Serie - 1.1 kW (1.47hp)</b>                |            |       |               |      |                |     |             |             |             |     | <b>Ø mm</b> | <b>Ø mm</b> | <b>Ø mm</b> |
| AFDE620-330   | 330        | 400   | 100           | 3.94 | 1557           | 350 |             |             |             |     | 15          | 20          | 26          |
| AFDE620-550   | 550        | 660   |               |      |                |     |             |             |             |     | 11          | 20          | 24          |
| AFDE620-900   | 900        | 1100  |               |      |                |     | 10          | 18          | 20          |     |             |             |             |
| AFDE620-1200  | 1200       | 1450  |               |      |                |     | 8           | 16          | 18          |     |             |             |             |
| AFDE620-1450  | 1450       | 1740  |               |      |                |     | 6           | 14          | 17          |     |             |             |             |
| AFDE620-1750  | 1750       | 2100  |               |      |                |     | 5           | 12          | 16          |     |             |             |             |
| AFDE620-2350  | 2350       | 2820  |               |      |                |     | 4           | 10          | 13          |     |             |             |             |
| AFDE620-2850  | 2850       | 3400  |               |      |                |     | 3           | 6           | 9           |     |             |             |             |
| AFDE620-3750  | 3750       | 4500  |               |      |                |     | 2.5         | 5           | 7           |     |             |             |             |
| AFDE620-4600  | 4600       | 5450  |               |      |                |     | 2           | 4           | 6           |     |             |             |             |
| AFDE620-5250  | 5250       | 6300  |               |      |                |     | 1.5         | 3.5         | 5           |     |             |             |             |

# How to select your AFD

## Pneumatic drive - Feed

| TYPE AND SPEED                         | FREE SPEED NO LOAD | MAXIUM STROKE |      | DYNAMIC THRUST |     | MILD STEEL | ALUMINIUM | HARD WOOD |
|--|--------------------|---------------|------|----------------|-----|------------|-----------|-----------|
|  |                    | rpm           | mm   | in.            | N   | lbf        | Ø mm      | Ø mm      |
| <b>AFD205 Serie - 0.22 kW (0.30hp)</b> |                    |               |      |                |     | Ø mm       | Ø mm      | Ø mm      |
| AFD205-650                             | 650                | 50            | 1.97 | 400            | 90  | 5          | 8         | 9.5       |
| AFD205-1000                            | 1000               |               |      |                |     | 4.5        | 7         | 9         |
| AFD205-2700                            | 2700               |               |      |                |     | 4          | 5         | 8         |
| AFD205-4350                            | 4350               |               |      |                |     | 2          | 4         | 6         |
| AFD205-10000                           | 10000              |               |      |                |     | 1          | 2         | 3         |
| AFD205-18700                           | 18700              | 0.5           | 1.2  | 1.5            |     |            |           |           |
| <b>AFD215 Serie - 0.22 kW (0.30hp)</b> |                    |               |      |                |     | Ø mm       | Ø mm      | Ø mm      |
| AFD215-650                             | 650                | 90            | 3.54 | 400            | 90  | 5          | 8         | 9.5       |
| AFD215-1000                            | 1000               |               |      |                |     | 4.5        | 7         | 9         |
| AFD215-2700                            | 2700               |               |      |                |     | 4          | 5         | 8         |
| AFD215-4350                            | 4350               |               |      |                |     | 2          | 4         | 6         |
| AFD215-10000                           | 10000              |               |      |                |     | 1          | 2         | 3         |
| AFD215-18700                           | 18700              | 0.5           | 1.2  | 1.5            |     |            |           |           |
| <b>AFD415 Serie - 0.38 kW (0.51hp)</b> |                    |               |      |                |     | Ø mm       | Ø mm      | Ø mm      |
| AFD415-490                             | 490                | 100           | 3.94 | 706            | 159 | 10         | 12        | 16        |
| AFD415-790                             | 790                |               |      |                |     | 10         | 11        | 16        |
| AFD415-1250                            | 1250               |               |      |                |     | 7          | 10.5      | 14        |
| AFD415-2100                            | 2100               |               |      |                |     | 6          | 10        | 12        |
| AFD415-3400                            | 3400               |               |      |                |     | 3          | 6         | 10        |
| AFD415-5400                            | 5400               | 2             | 4    | 6              |     |            |           |           |
| AFD415-7000                            | 7000               | 1.5           | 2.5  | 3.5            |     |            |           |           |
| AFD415-18000                           | 18000              | 1             | 1.5  | 2              |     |            |           |           |
| <b>AFD625 Serie - 0.63 kW (0.85hp)</b> |                    |               |      |                |     | Ø mm       | Ø mm      | Ø mm      |
| AFD625-2HM5-40                         | 40                 | 100           | 4    | 1735           | 390 | 14         | 20        | 22        |
| AFD625-2HM5-100                        | 100                |               |      |                |     | 13         | 20        | 22        |
| AFD625-2HM5-150                        | 150                |               |      |                |     | 13         | 20        | 22        |
| AFD625-2HM5-350                        | 350                |               |      |                |     | 12         | 19        | 20        |
| AFD625-2HM5-550                        | 550                |               |      |                |     | 11         | 16        | 16        |
| AFD625-2HM5-950                        | 950                | 8             | 12   | 14             |     |            |           |           |
| AFD625-2HM5-2100                       | 2100               | 4             | 8    | 12             |     |            |           |           |
| AFD625-2HM5-3300                       | 3300               | 3             | 6    | 10             |     |            |           |           |

## General Data

### Multi Spindle Drilling

To calculate the cross sectional area of a drill diameter use the formula  $u(r^2)$  ( $3.14 \times \text{radius}^2$ )  
 For example, Area of Ø 6mm hole  $3.14 \times 3 \times 3 = 28.26\text{mm}^2$

1. Calculate cross sectional area of hole by referring to the table below the formula.
2. Calculate the cross sectional area of a hole by the number of spindles.
3. Select the nearest greater hole cross sectional area from the table.
4. From the specification charts on pages 6 and 7 select the AFD with the appropriate capacity.

### Example - AFD415

5 off Ø 1.5mm holes to be drilled in aluminium -  $1.766 \times 5 = 8.83\text{mm}^2$   
 Ø 4mm hole has a cross sectional area of  $12.56\text{mm}^2$

Therefore AFD415-5400 has adequate capacity to drill 5 off Ø 1.5mm holes in aluminium.

The above data is a guide for reference purposes only. Please read carefully the safety operating and maintenance instructions supplied with the unit prior to installing your Desoutter Auto Feed Drill. The performance data for air drive and feed functions are obtained with an air inlet pressure of 6,3 bar, and the speeds indicated are nominal. The capacities listed in this catalogue are for guidance only, and actual test and / or consultation with your local Desoutter Sales Representative is always recommended. Specifications are subject to change without prior notice.

| Ø    |        | AREA            |        |
|------|--------|-----------------|--------|
| mm   | lbf.in | mm <sup>2</sup> | lbf.in |
| 1.0  | 1/32   | 0.785           | 0.0007 |
| 1.5  | 1/16   | 1.766           | 0.0003 |
| 2.0  | 3/32   | 3.14            | 0.006  |
| 2.5  | 1/8    | 4.91            | 0.012  |
| 3.0  | 5/32   | 7.06            | 0.019  |
| 4.0  | 3/16   | 12.56           | 0.027  |
| 5.0  | 7/32   | 19.62           | 0.037  |
| 6.0  | 1/4    | 28.26           | 0.049  |
| 7.0  | 9/32   | 38.47           | 0.062  |
| 8.0  | 5/16   | 50.24           | 0.076  |
| 9.0  | 11/32  | 63.59           | 0.092  |
| 10.0 | 3/8    | 78.50           | 0.110  |
| 11.0 | 13/32  | 94.99           | 0.129  |
| 12.0 | 7/16   | 113.04          | 0.150  |
| 13.0 | 15/32  | 132.67          | 0.172  |
| 14.0 | 1/2    | 153.86          | 0.196  |
| 15.0 | 9/16   | 176.63          | 0.248  |
| 16.0 | 5/8    | 200.96          | 0.306  |

# Electric drive - Pneumatic feed

## ■ AFDE200 - AFDE230

0.25 kW (0.34hp) - 850 to 11950 rpm

- High speed options up to 22400 rpm @ 50Hz, 26900 rpm @ 60Hz with K42 output
- Capacity up to 5mm (3/16") in aluminium
- Modular output spindles



For use with H21 Tapping Gearbox or Multi-spindle heads output spindle K35 is needed

Tapping gearbox & Accessories: see pages 22-32

| PIC. REF | MODEL         | MODEL Canada CSA 575V (60Hz) | SPEED |       | POWER       |      | CURRENT |                | THRUST         |     | STROKE |     | WEIGHT |      | TAPPING TORQUE AVAILABLE |        |
|----------|---------------|------------------------------|-------|-------|-------------|------|---------|----------------|----------------|-----|--------|-----|--------|------|--------------------------|--------|
|          |               |                              | 50HZ  | 60HZ  | Motor power | 50Hz | 60Hz    | Dynamic thrust | Working stroke | kg  | lb     | Nm  | lbf.in |      |                          |        |
|          |               |                              | rpm   | rpm   | kW          | hp   | Amps    | Amps           | N              | lbf | mm     | in. | kg     | lb   | Nm                       | lbf.in |
| A        | AFDE200-850   | AFDE230-1000                 | 850   | 1020  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | 2.4                      | 21.2   |
| A        | AFDE200-1200  | AFDE230-1450                 | 1200  | 1450  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | 1.8                      | 15.9   |
| A        | AFDE200-2350  | AFDE230-2800                 | 2350  | 2820  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-2850  | AFDE230-3400                 | 2850  | 3400  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-3750  | AFDE230-4500                 | 3750  | 4500  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-4600  | AFDE230-5500                 | 4600  | 5450  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-5250  | AFDE230-6300                 | 5250  | 6300  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-8000  | AFDE230-9600                 | 8000  | 9600  | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |
| A        | AFDE200-10000 | AFDE230-12000                | 10000 | 11950 | 0.25        | 0.34 | 0.75    | 0.75           | 320            | 72  | 90     | 3.5 | 10.1   | 22.2 | -                        | -      |

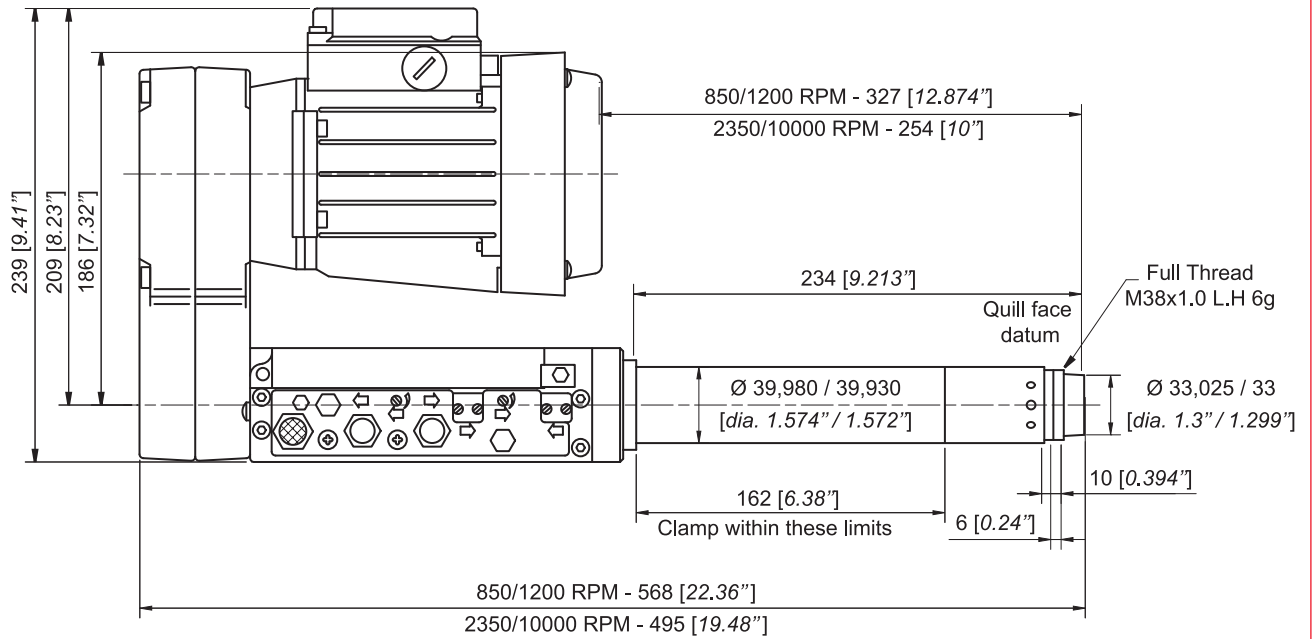
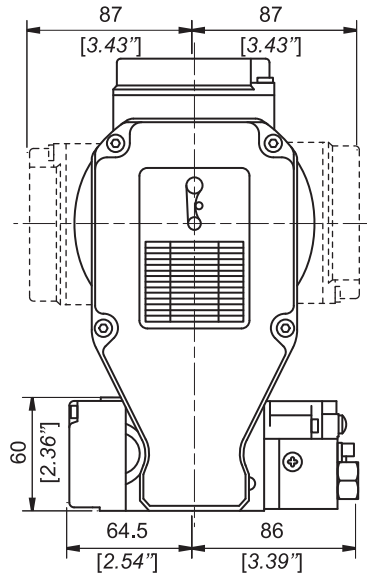
Drilling performance specification

Air consumption per cycle: <0.032 l/s (<0.02 cfm) - Sound level: <70 dB(A)



# Electric drive - Pneumatic feed

AFDE200 - AFDE230 ■



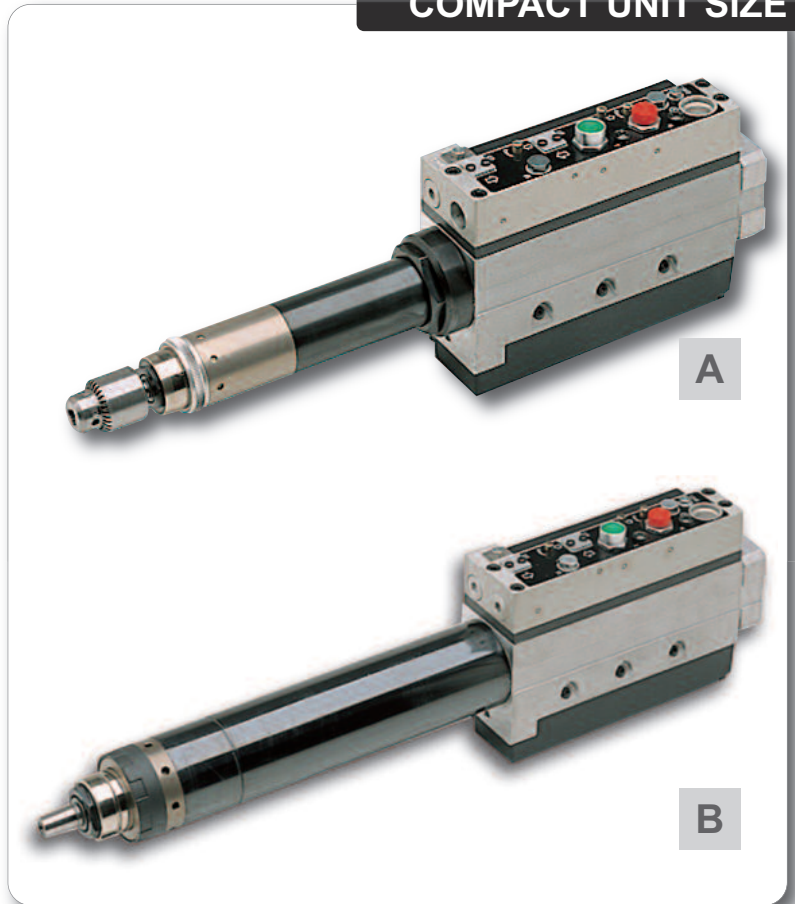
# Pneumatic drive - feed

## ■ AFD205 - AFD215

0.22 kW (0.30hp) - 650 to 18700 rpm

- Options of compact AFD205 or long stroke AFD215
- High thrust/size ratio
- Capacity up to 5mm (3/16") in aluminium
- Modular output spindles

**COMPACT UNIT SIZE**



For use with H21 Tapping Gearbox or Multi-spindle heads output spindle K35 is needed

Tapping gearbox & Accessories: see pages 22-32

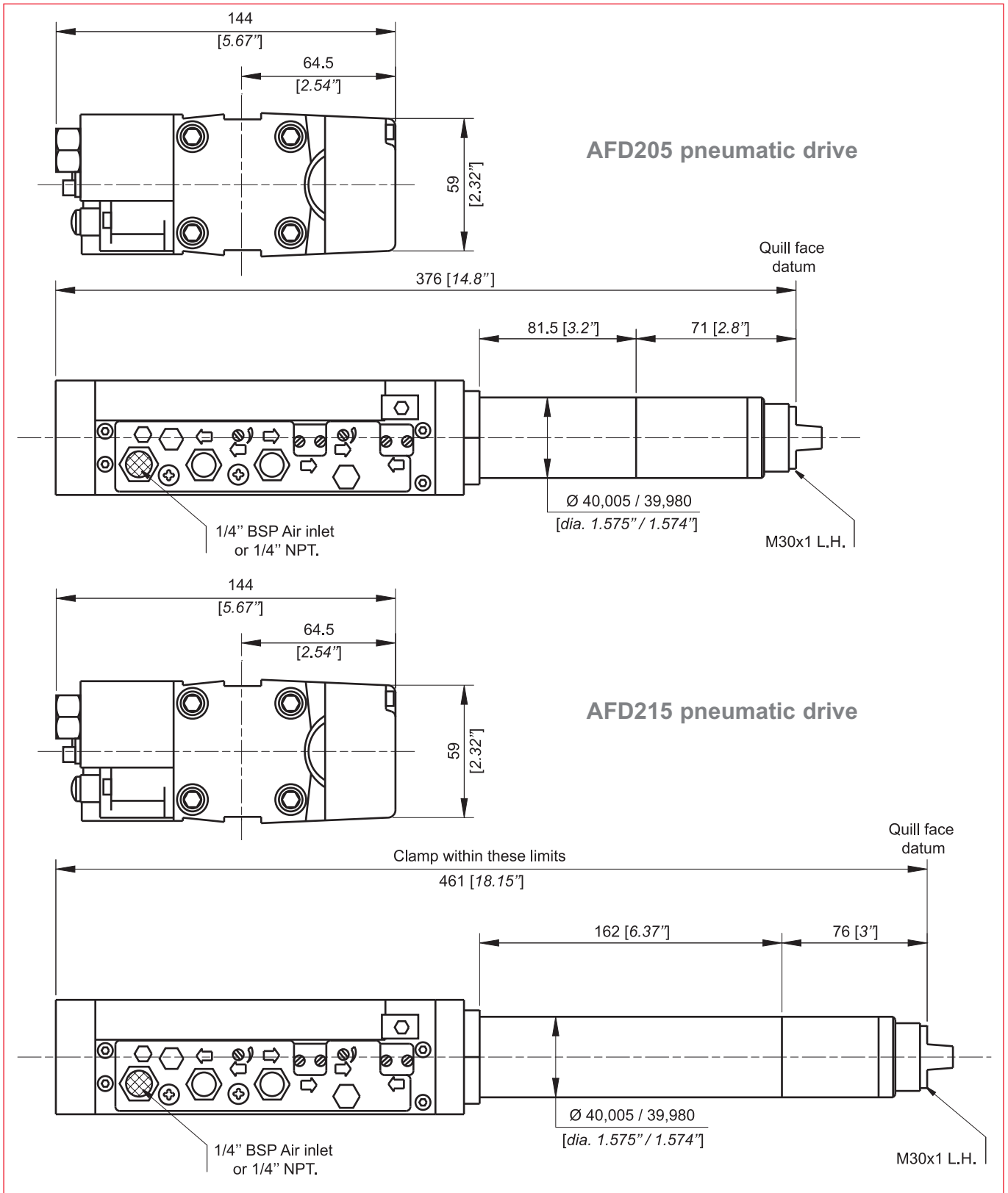
| PIC. REF      | MODEL        | SPEED NO LOAD | POWER       |      | THRUST         |     | STROKE         |      | WEIGHT |     | TAPPING TORQUE AVAILABLE |        |
|---------------|--------------|---------------|-------------|------|----------------|-----|----------------|------|--------|-----|--------------------------|--------|
|               |              |               | Motor power |      | Dynamic thrust |     | Working stroke |      |        |     |                          |        |
|               |              | rpm           | kW          | hp   | N              | lbf | mm             | in.  | kg     | lb  | Nm                       | lbf.in |
| <b>AFD205</b> |              |               |             |      |                |     |                |      |        |     |                          |        |
| A             | AFD205-650   | 650           | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 4.3                      | 38.1   |
| A             | AFD205-1000  | 1000          | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 2.8                      | 24.8   |
| A             | AFD205-2700  | 2700          | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | -                        | -      |
| A             | AFD205-4350  | 4350          | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | -                        | -      |
| A             | AFD205-10000 | 10000         | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | -                        | -      |
| A             | AFD205-18700 | 18700         | 0.20        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | -                        | -      |
| <b>AFD215</b> |              |               |             |      |                |     |                |      |        |     |                          |        |
| B             | AFD215-650   | 650           | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 4.3                      | 38.1   |
| B             | AFD215-1000  | 1000          | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 2.8                      | 24.8   |
| B             | AFD215-2700  | 2700          | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | -                        | -      |
| B             | AFD215-4350  | 4350          | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | -                        | -      |
| B             | AFD215-10000 | 10000         | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | -                        | -      |
| B             | AFD215-18700 | 18700         | 0.20        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | -                        | -      |

Drilling performance specification

Air consumption per cycle: 9.5 l/s (20 cfm) - Sound level: <75 dB(A)

# Pneumatic drive - feed

AFD205 - AFD215 ■



# Electric drive - Pneumatic feed

## ■ AFDE400 - AFDE430 - AFDE410 - AFDE440

0.33 - 0.75 kW (0.44 - 1hp) - 330 to 11950 rpm

- 330-10000 rpm @ 50Hz, 400-11900 rpm @ 60Hz
- 0.33kW (0.44HP) and 0.75kW (1.00HP) options
- Capacity up to 10mm (3/8") in aluminium, 8mm (5/16") in mild steel
- Spindle sealed to IP64 standard
- Modular output spindles

**VERSATILE RANGE**



For use with Multi-spindle heads output spindle B24 is needed

Tapping gearbox & Accessories: see pages 22-32

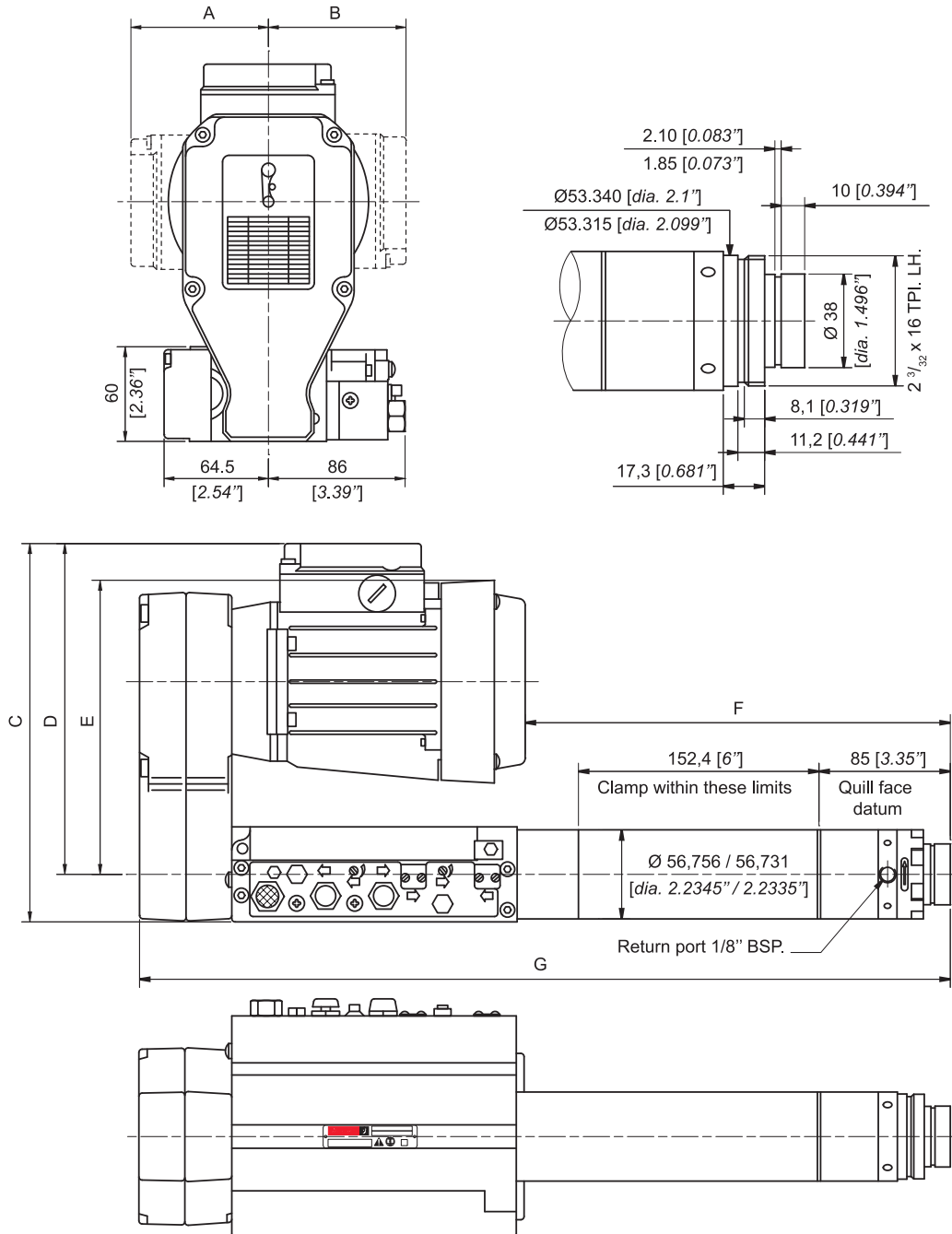
| PIC. REF                 | MODEL         | MODEL CANADA CSA 575V (60HZ) | SPEED    |          | POWER          |      | CURRENT   |           | THRUST           |     | STROKE            |      | WEIGHT |      | TAPPING TORQUE AVAILABLE |        |
|--------------------------|---------------|------------------------------|----------|----------|----------------|------|-----------|-----------|------------------|-----|-------------------|------|--------|------|--------------------------|--------|
|                          |               |                              | 50Hz rpm | 60Hz rpm | Motor power kW | hp   | 50Hz Amps | 60Hz Amps | Dynamic thrust N | lbf | Working stroke mm | in.  | kg     | lb   | Nm                       | lbf.in |
| <b>AFDE400 / AFDE430</b> |               |                              |          |          |                |      |           |           |                  |     |                   |      |        |      |                          |        |
| A                        | AFDE400-330   | AFDE430-400                  | 330      | 400      | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 14.4   | 31.7 | 8.6                      | 76.1   |
| A                        | AFDE400-550   | AFDE430-660                  | 550      | 660      | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 14.4   | 31.7 | 5.2                      | 46.0   |
| A                        | AFDE400-900   | AFDE430-1100                 | 900      | 1100     | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 13.4   | 29.5 | 3.2                      | 28.3   |
| A                        | AFDE400-1200  | AFDE430-1450                 | 1200     | 1450     | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 13.4   | 29.5 | 2.4                      | 21.2   |
| A                        | AFDE400-1450  | AFDE430-1750                 | 1450     | 1740     | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 13.4   | 29.5 | -                        | -      |
| A                        | AFDE400-1750  | AFDE430-2100                 | 1750     | 2100     | 0.37           | 0.49 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-2350  | AFDE430-2800                 | 2350     | 2820     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-2850  | AFDE430-3400                 | 2850     | 3400     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-3750  | AFDE430-4500                 | 3750     | 4500     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-4600  | AFDE430-5500                 | 4600     | 5450     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-5250  | AFDE430-6300                 | 5250     | 6300     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-8000  | AFDE430-9600                 | 8000     | 9600     | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| A                        | AFDE400-10000 | AFDE430-11950                | 10000    | 11950    | 0.33           | 0.44 | 0.95      | 0.95      | 724              | 163 | 100               | 3.94 | 11.4   | 25.1 | -                        | -      |
| <b>AFDE410 / AFDE440</b> |               |                              |          |          |                |      |           |           |                  |     |                   |      |        |      |                          |        |
| A                        | AFDE410-330   | AFDE440-400                  | 330      | 400      | 0.75           | 1.00 | 1.9       | 1.9       | 724              | 163 | 100               | 3.94 | 16.0   | 35.3 | 19.6                     | 173.5  |
| A                        | AFDE410-550   | AFDE440-660                  | 550      | 660      | 0.75           | 1.00 | 1.9       | 1.9       | 724              | 163 | 100               | 3.94 | 16.0   | 35.3 | 11.8                     | 104.4  |
| A                        | AFDE410-900   | AFDE440-1100                 | 900      | 1100     | 0.75           | 1.00 | 1.9       | 1.9       | 724              | 163 | 100               | 3.94 | 15.0   | 33.1 | 7.2                      | 63.7   |
| A                        | AFDE410-1200  | AFDE440-1450                 | 1200     | 1450     | 0.75           | 1.00 | 1.9       | 1.9       | 724              | 163 | 100               | 3.94 | 15.0   | 33.1 | 5.4                      | 47.8   |
| A                        | AFDE410-1450  | AFDE440-1750                 | 1450     | 1740     | 0.75           | 1.00 | 1.9       | 1.9       | 724              | 163 | 100               | 3.94 | 15.0   | 33.1 | -                        | -      |
| A                        | AFDE410-1750  | AFDE440-2100                 | 1750     | 2100     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-2350  | AFDE440-2800                 | 2350     | 2820     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-2850  | AFDE440-3400                 | 2850     | 3400     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-3750  | AFDE440-4500                 | 3750     | 4500     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-4600  | AFDE440-5500                 | 4600     | 5450     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-5250  | AFDE440-6300                 | 5250     | 6300     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |
| A                        | AFDE410-8000  | AFDE440-9600                 | 8000     | 9600     | 0.75           | 1.00 | 2.0       | 2.0       | 724              | 163 | 100               | 3.94 | 12.4   | 27.3 | -                        | -      |

Drilling performance specification

Air consumption per cycle: <1 l/s (<0.04 cfm) - Sound level: <70 dB(A)

# Electric drive - Pneumatic feed

AFDE400 - AFDE430 - AFDE410 - AFDE440 ■



| MODEL                   | A   |     | B   |     | C   |      | D   |     | E   |     | F   |      | G   |      |
|-------------------------|-----|-----|-----|-----|-----|------|-----|-----|-----|-----|-----|------|-----|------|
|                         | mm  | in. | mm  | in. | mm  | in.  | mm  | in. | mm  | in. | mm  | in.  | mm  | in.  |
| AFDE400-330/-500        | 102 | 4.0 | 102 | 4.0 | 254 | 10.0 | 224 | 8.8 | 192 | 7.6 | 318 | 12.5 | 585 | 23.0 |
| AFDE400-900/-1200/-1450 | 102 | 4.0 | 102 | 4.0 | 254 | 10.0 | 224 | 8.8 | 192 | 7.6 | 245 | 9.6  | 512 | 20.2 |
| AFDE400-1750 to 10000   | 87  | 3.4 | 87  | 3.4 | 239 | 9.4  | 209 | 8.2 | 186 | 7.3 | 271 | 10.7 | 512 | 20.2 |
| AFDE410-330/-550        | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 295 | 11.6 | 585 | 23.0 |
| AFDE410-900/-1200/-1450 | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 222 | 8.7  | 512 | 20.2 |
| AFDE410-1750 to 8000    | 102 | 4.0 | 102 | 4.0 | 254 | 10.0 | 224 | 8.8 | 192 | 7.6 | 245 | 9.6  | 512 | 20.2 |

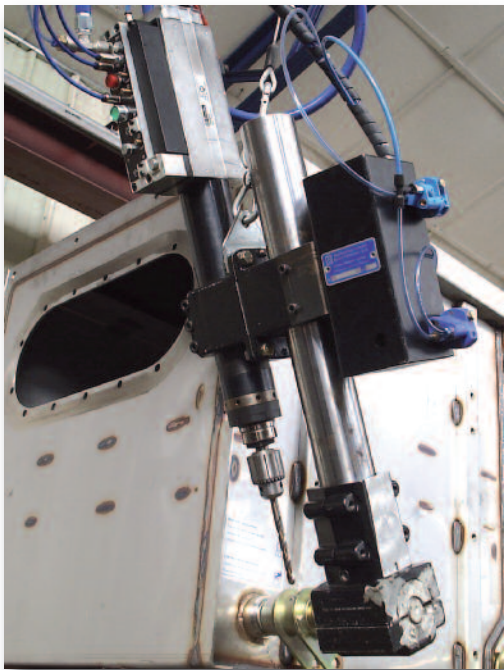
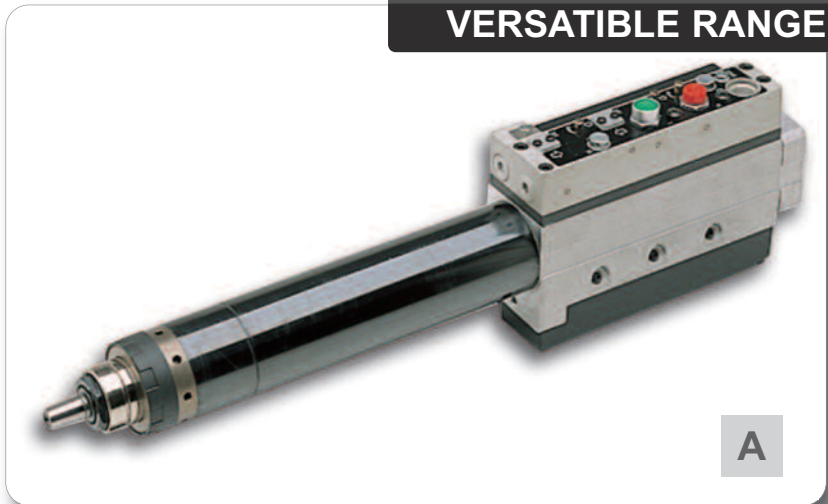
# Pneumatic drive - feed

## ■ AFD415

0.38 kW (0.51hp) - 490 to 18000 rpm

- Long working stroke of 100mm (3.94")
- Spindle sealed to IP64 standard
- Capacity up to 10mm (3/8") in aluminium, 8mm (5/16") in mild steel
- Modular output spindles

### COMPACT UNIT AND VERSATILE RANGE



For use with Multi-spindle heads output spindle B24 is needed

Tapping gearbox & Accessories: see pages 22-32

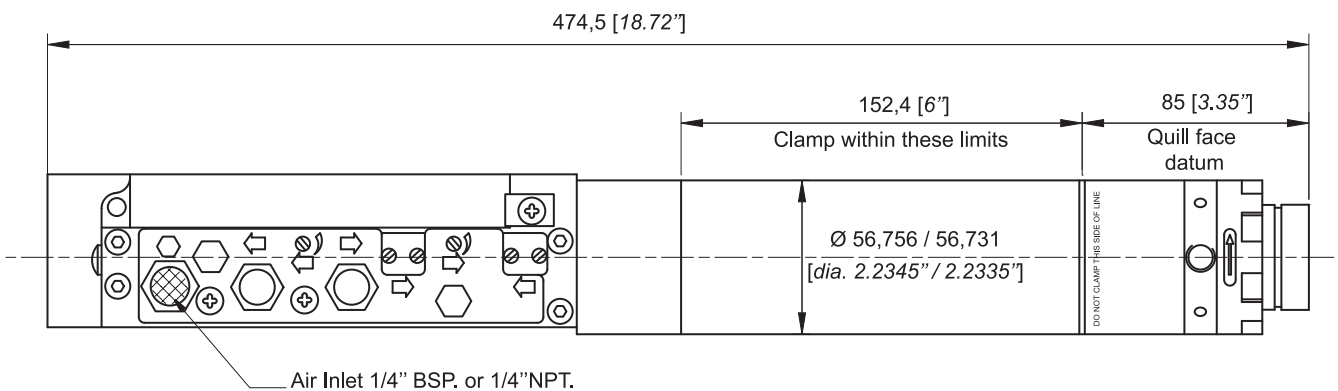
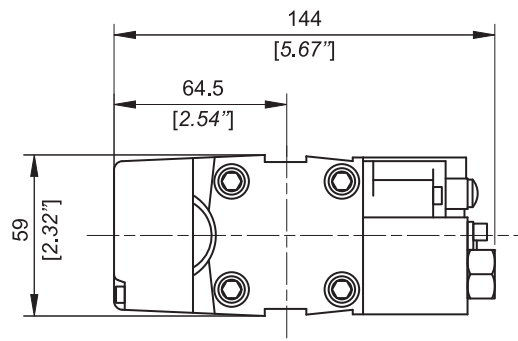
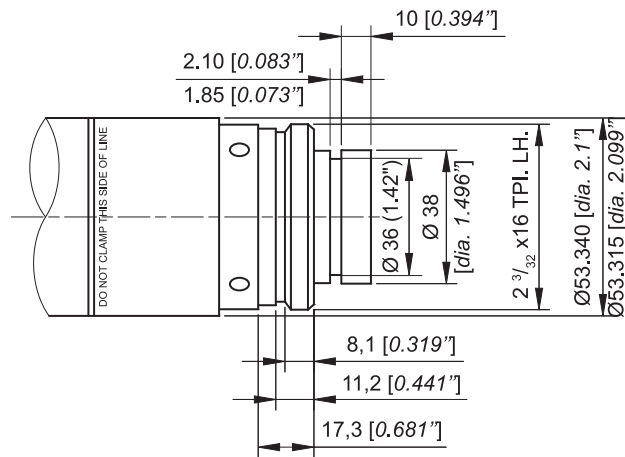
| PIC. REF | MODEL        | FREE SPEED<br>NO LOAD | POWER       |      | THRUST         |     | STROKE         |      | WEIGHT |      | TAPPING TORQUE AVAILABLE |        |
|----------|--------------|-----------------------|-------------|------|----------------|-----|----------------|------|--------|------|--------------------------|--------|
|          |              |                       | Motor power |      | Dynamic thrust |     | Working stroke |      | kg     | lb   | Nm                       | lbf.in |
|          |              | rpm                   | kW          | hp   | N              | lbf | mm             | in.  |        |      |                          |        |
| A        | AFD415-490   | 490                   | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                      | 87.6   |
| A        | AFD415-790   | 790                   | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 6.1                      | 54.0   |
| A        | AFD415-1250  | 1250                  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 3.9                      | 34.5   |
| A        | AFD415-2100  | 2100                  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | -                        | -      |
| A        | AFD415-3400  | 3400                  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | -                        | -      |
| A        | AFD415-5400  | 5400                  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | -                        | -      |
| A        | AFD415-7000  | 7000                  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | -                        | -      |
| A        | AFD415-18000 | 18000                 | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | -                        | -      |

Drilling performance specification

Air consumption per cycle: 9.9 l/s (21 cfm) - Sound level: 75 dB(A)

# Pneumatic drive - feed

AFD415 ■



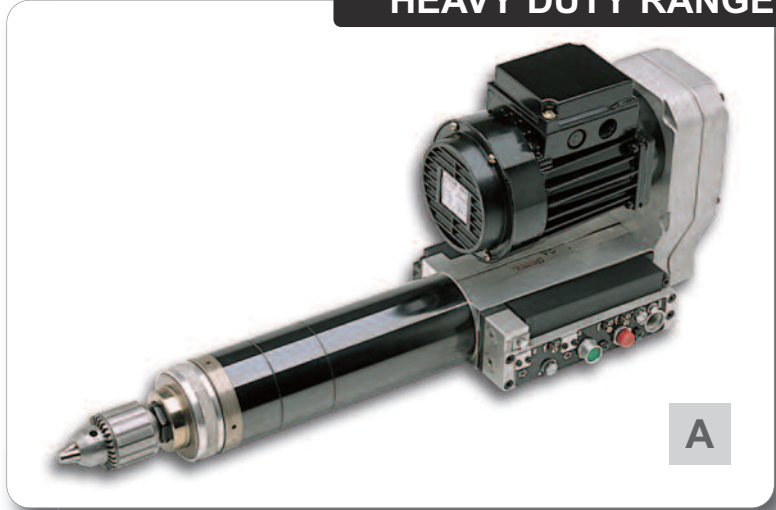
# Electric drive - Pneumatic feed

## ■ AFDE610 - AFD620 - AFDE640

0.75 to 1.1 kW (1 - 1.47hp) - 330 to 6300 rpm

- 2 power ratings to give optimum power/thrust combination
- Heavy duty belts and pulley drive with integral belt tensioner
- Capacity up to 12mm (1/2") in mild steel
- Spindle sealed to IP64 standard
- Modular output spindles

**HEAVY DUTY RANGE**



For use with J19 Tapping Gearbox or Multi-spindle heads output spindle B24 is needed see pages 24-25

Tapping gearbox & Accessories: see pages 22-32

| PIC. REF                 | MODEL        | MODEL CANADA CSA 575V (60HZ) | SPEED    |          | POWER          |      | CURRENT   |           | THRUST           |     | STROKE            |      | WEIGHT |      | TAPPING TORQUE AVAILABLE |        |
|--------------------------|--------------|------------------------------|----------|----------|----------------|------|-----------|-----------|------------------|-----|-------------------|------|--------|------|--------------------------|--------|
|                          |              |                              | 50Hz rpm | 60Hz rpm | Motor power kW | hp   | 50Hz Amps | 60Hz Amps | Dynamic thrust N | lbf | Working stroke mm | in.  | kg     | lb   | Nm                       | lbf.in |
| <b>AFDE610 / AFDE640</b> |              |                              |          |          |                |      |           |           |                  |     |                   |      |        |      |                          |        |
| A                        | AFDE610-330  | AFDE640-400                  | 330      | 400      | 0.75           | 1.00 | 1.9       | 1.9       | 1557             | 350 | 100               | 3.94 | 21.0   | 46.3 | 19.6                     | 173.5  |
| A                        | AFDE610-550  | AFDE640-660                  | 550      | 660      | 0.75           | 1.00 | 1.9       | 1.9       | 1557             | 350 | 100               | 3.94 | 21.0   | 46.3 | 11.8                     | 104.4  |
| A                        | AFDE610-900  | AFDE640-1100                 | 900      | 1100     | 0.75           | 1.00 | 1.9       | 1.9       | 1557             | 350 | 100               | 3.94 | 20.0   | 44.1 | 7.2                      | 63.7   |
| A                        | AFDE610-1200 | AFDE640-1450                 | 1200     | 1450     | 0.75           | 1.00 | 1.9       | 1.9       | 1557             | 350 | 100               | 3.94 | 20.0   | 44.1 | 5.4                      | 47.8   |
| A                        | AFDE610-1450 | AFDE640-1750                 | 1450     | 1740     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 20.0   | 44.1 | -                        | -      |
| A                        | AFDE610-1750 | AFDE640-2100                 | 1750     | 2100     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |
| A                        | AFDE610-2350 | AFDE640-2800                 | 2350     | 2820     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |
| A                        | AFDE610-2850 | AFDE640-3400                 | 2850     | 3400     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |
| A                        | AFDE610-3750 | AFDE640-4500                 | 3750     | 4500     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |
| A                        | AFDE610-4600 | AFDE640-5500                 | 4600     | 5450     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |
| A                        | AFDE610-5250 | AFDE640-6300                 | 5250     | 6300     | 0.75           | 1.00 | 2.0       | 2.0       | 1557             | 350 | 100               | 3.94 | 18.4   | 40.5 | -                        | -      |

### AFDE620

|   |              |  |      |      |     |      |     |     |      |     |     |      |      |      |      |       |
|---|--------------|--|------|------|-----|------|-----|-----|------|-----|-----|------|------|------|------|-------|
| A | AFDE620-330  |  | 330  | 400  | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 21.0 | 46.3 | 19.6 | 173.5 |
| A | AFDE620-550  |  | 550  | 660  | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 21.0 | 46.3 | 11.8 | 104.4 |
| A | AFDE620-900  |  | 900  | 1100 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 20.0 | 44.1 | 7.2  | 63.7  |
| A | AFDE620-1200 |  | 1200 | 1450 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 20.0 | 44.1 | 5.4  | 47.8  |
| A | AFDE620-1450 |  | 1450 | 1740 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-1750 |  | 1750 | 2100 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-2350 |  | 2350 | 2820 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-2850 |  | 2850 | 3400 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-3750 |  | 3750 | 4500 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-4600 |  | 4600 | 5450 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |
| A | AFDE620-5250 |  | 5250 | 6300 | 1.1 | 1.47 | 2.8 | 2.8 | 1557 | 350 | 100 | 3.94 | 22   | 48.4 | -    | -     |

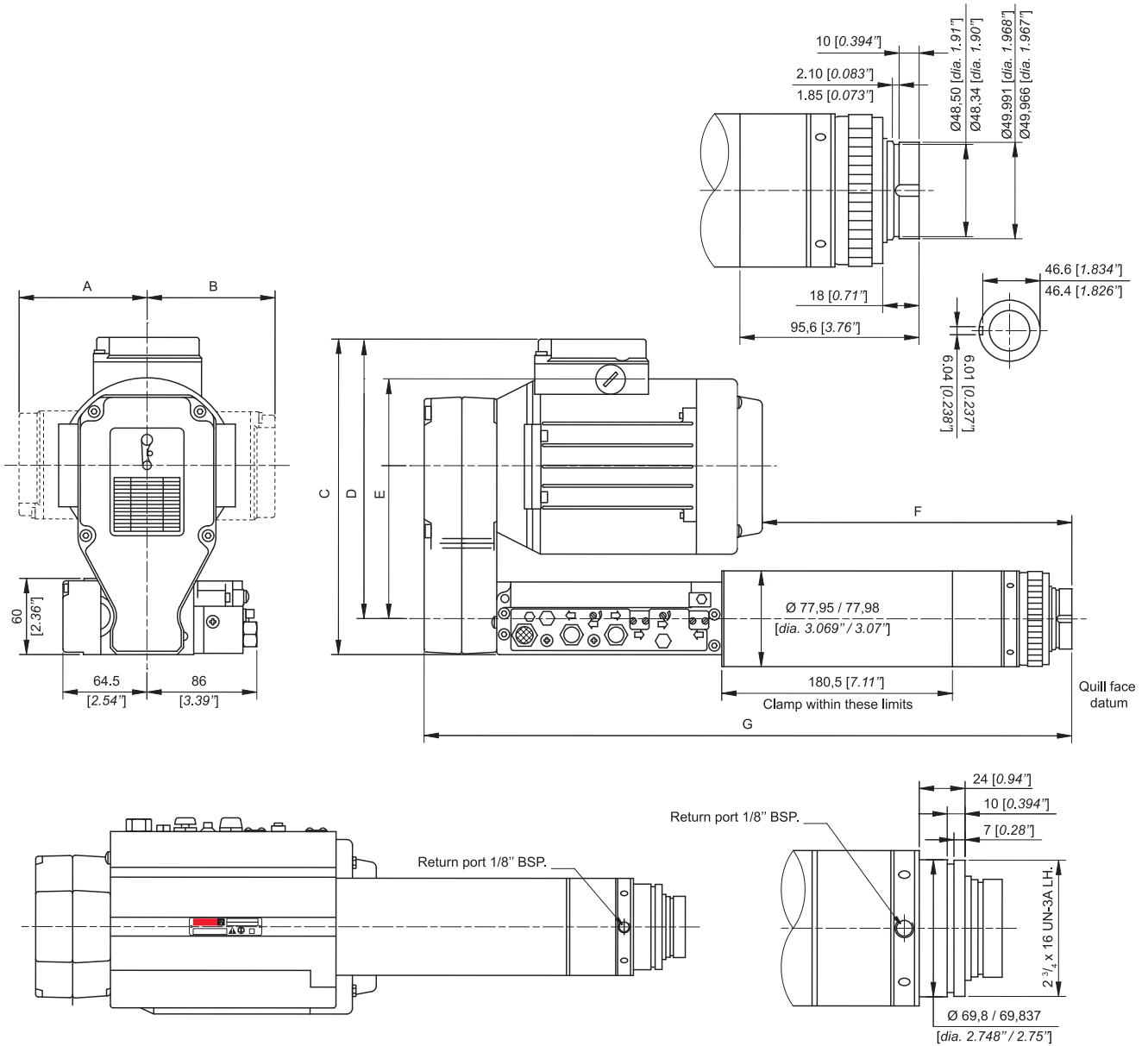
Drilling performance specification

Air consumption per cycle: <2.5 l/s (<0.09 cfm) - Sound level: <70 dB(A)



# Pneumatic drive - feed

## AFDE610 - AFDE640

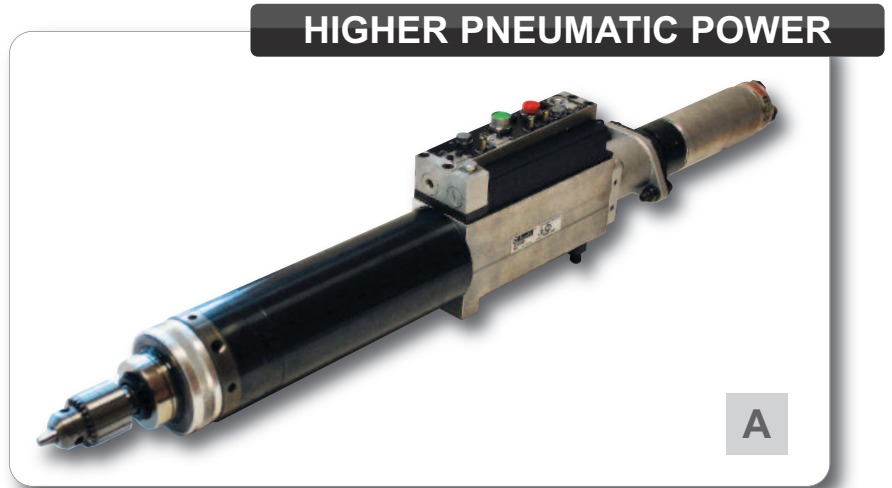


| MODEL                 | A   |     | B   |     | C   |      | D   |     | E   |     | F   |      | G   |      |
|-----------------------|-----|-----|-----|-----|-----|------|-----|-----|-----|-----|-----|------|-----|------|
|                       | mm  | in. | mm  | in. | mm  | in.  | mm  | in. | mm  | in. | mm  | in.  | mm  | in.  |
| AFDE610-330/550       | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 297 | 11.7 | 588 | 23.1 |
| AFDE610-900/1200/1450 | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 224 | 8.8  | 515 | 20.3 |
| AFDE610-1750-5250     | 102 | 4.0 | 102 | 4.0 | 254 | 10.0 | 224 | 8.8 | 192 | 7.6 | 247 | 9.7  | 515 | 20.3 |
| AFDE620-330/550       | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 297 | 11.7 | 588 | 23.1 |
| AFDE620-900 to 5250   | 112 | 4.4 | 112 | 4.4 | 264 | 10.4 | 234 | 9.2 | 201 | 7.9 | 224 | 8.8  | 515 | 20.3 |

# Pneumatic drive - feed

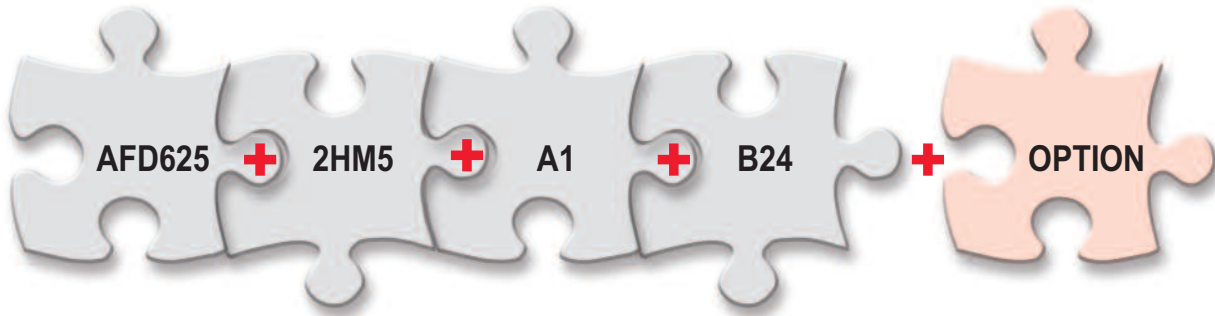
## ■ AFD625

0.63 kW (0.85hp) - 40 to 3300 rpm



For use with J19 Tapping Gearbox or Multi-spindle heads output spindle B24 is needed

### How to Order AFD625:



Tapping gearbox & Accessories: See pages 22-32

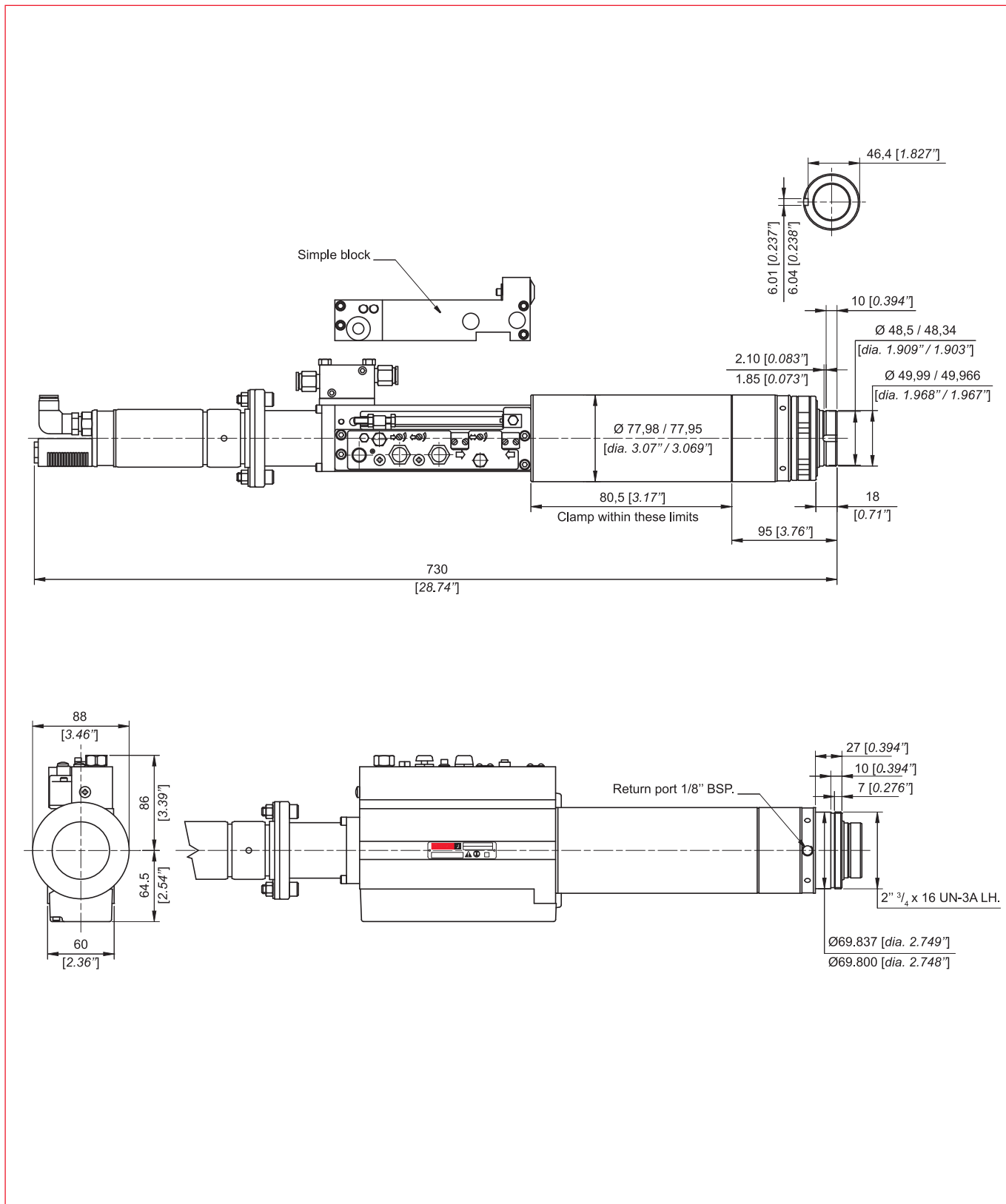
| PIC. REF | MODEL            | SPEED | POWER       |                | THRUST         |     | STROKE |     | WEIGHT |      | TAPPING TORQUE AVAILABLE |     |
|----------|------------------|-------|-------------|----------------|----------------|-----|--------|-----|--------|------|--------------------------|-----|
|          |                  |       | Motor power | Dynamic thrust | Working stroke | kg  | lb     | Nm  | lbf.in |      |                          |     |
|          |                  | rpm   | kW          | hp             | N              | lbf | mm     | in. |        |      |                          |     |
| A        | AFD625-2HM5-40   | 40    | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 41.0                     | 363 |
| A        | AFD625-2HM5-100  | 100   | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 41.0                     | 363 |
| A        | AFD625-2HM5-150  | 150   | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 41.0                     | 363 |
| A        | AFD625-2HM5-350  | 350   | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 31.0                     | 274 |
| A        | AFD625-2HM5-550  | 550   | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 21.0                     | 186 |
| A        | AFD625-2HM5-950  | 950   | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 13.0                     | 115 |
| A        | AFD625-2HM5-2100 | 2100  | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 5.6                      | 50  |
| A        | AFD625-2HM5-3300 | 3300  | 0.63        | 0.85           | 1735           | 390 | 100    | 4   | 12.8   | 28.2 | 3.8                      | 34  |

Drilling performance specification

Air consumption per cycle: 16.5 l/s (35 cfm) - Sound level: <87 dB(A)

# Pneumatic drive - feed

AFD625 ■



# Electric drive - Leadscrew feed

## ■ AFTE480

0.75 kW (1hp) - 180 to 1740 rpm

- High power brake motors with 0.75kW (1 HP)
- Supplied fitted with proximity switches for depth, datum and 'no hole' sensing, PNP or NPN
- Quick release interchangeable leadscrew and nut assembly
- Capacity up to 10mm (3/8") in mild steel, 16mm (5/8") in aluminium depending on thread form

### HIGH POWER AND ACCURACY



- Control Blocks  
A7 - PNP Switches  
A8 - NPN Switches

### Leadscrew/nut assemblies AFTE480

| SHAPE   | REPLACEMENT LEADSCREW / NUT ONLY | ORDERING CODE | THREAD SIZE / PITCH | REPLACEMENT LEADSCREW / NUT ONLY | ORDERING CODE | THREAD SIZE / PITCH |
|---|----------------------------------|---------------|---------------------|----------------------------------|---------------|---------------------|
|   | PART NO.                         |               |                     | PART NO.                         |               |                     |
| <p>Proximity Sensor</p> <p>Leadscrew Nut</p> <p>Leadscrew</p> | 350713                           | L01           | 0.50mm              | 350833                           | L13           | 28TPI               |
|   | 350723                           | L02           | 0.60mm              | 350853                           | L15           | 24TPI               |
|   | 350733                           | L03           | 0.70mm              | 350873                           | L17           | 20TPI               |
|   | 350743                           | L04           | 0.75mm              | 350893                           | L19           | 18TPI               |
|   | 350753                           | L05           | 0.80mm              | 350903                           | L20           | 16TPI               |
|   | 350763                           | L06           | 1.00mm              | 350943                           | L25           | 2BA                 |
|   | 350773                           | L07           | 1.25mm              | 350993                           | L22           | 1/8"NPT             |
|   | 350783                           | L08           | 1.50mm              | 359293                           | L30           | 0.45mm              |
|   | 350793                           | L09           | 1.75mm              | 369933                           | L33           | 0.30mm              |
|   | 350803                           | L10           | 40TPI               | 380373                           | L34           | 0.25mm              |
|   | 350823                           | L12           | 32TPI               |                                  |               |                     |

Quick release Leadscrew and Nut Assembly

Other leadscrews available to special order.

Accessories: see pages 22-32

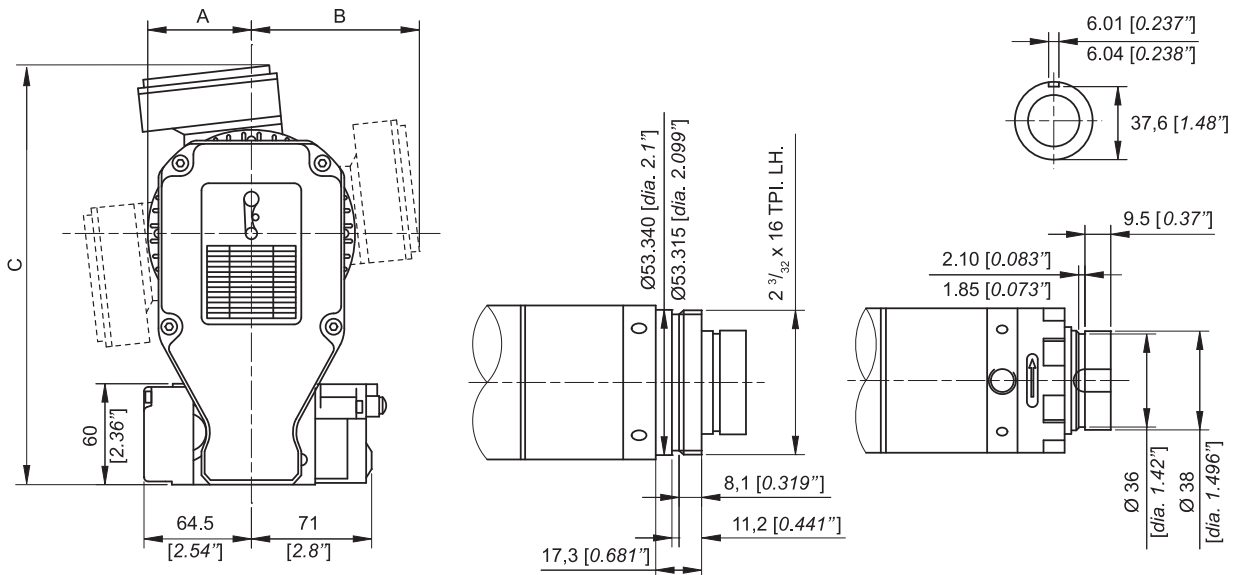
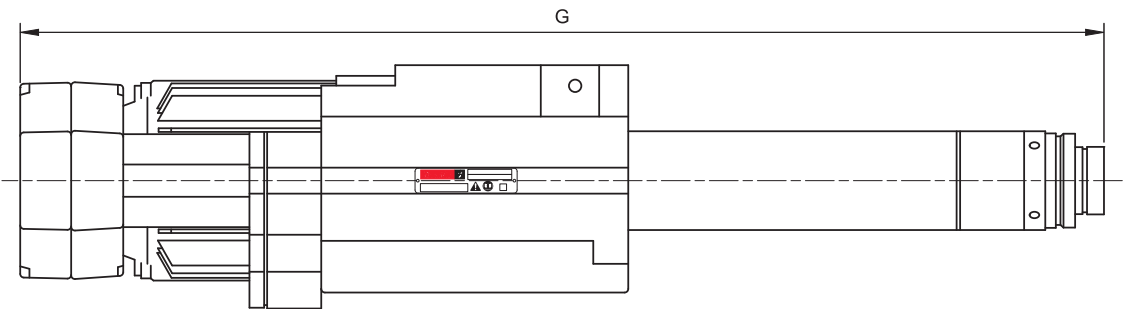
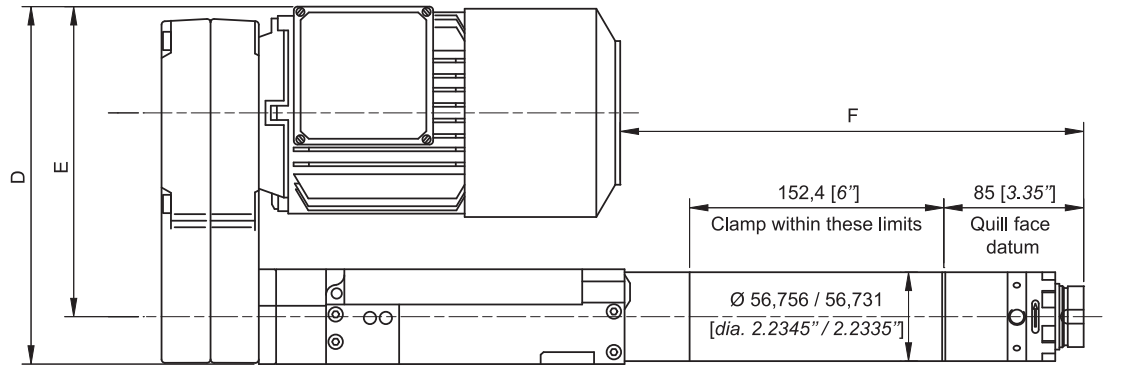
| PIC. REF | MODEL        | SPEED |      | POWER       |      | CURRENT |      | TORQUE                   |        | STROKE                  |      | WEIGHT |      |
|----------|--------------|-------|------|-------------|------|---------|------|--------------------------|--------|-------------------------|------|--------|------|
|          |              | 50Hz  | 60Hz | Motor power |      | 50Hz    | 60Hz | Tapping torque available |        | Pitch controlled stroke |      | kg     | lb   |
|          |              | rpm   | rpm  | kW          | hp   | Amps    | Amps | Nm                       | lbf.in | mm                      | in.  |        |      |
| A        | AFTE480-180  | 180   | 215  | 0.75        | 1.00 | 2.0     | 2.0  | 35.8                     | 316.8  | 60                      | 2.36 | 26.5   | 58.3 |
| A        | AFTE480-330  | 330   | 400  | 0.75        | 1.00 | 2.0     | 2.0  | 19.5                     | 172.8  | 60                      | 2.36 | 26.5   | 58.3 |
| A        | AFTE480-550  | 550   | 660  | 0.75        | 1.00 | 2.0     | 2.0  | 11.7                     | 103.7  | 60                      | 2.36 | 26.5   | 58.3 |
| A        | AFTE480-900  | 900   | 1080 | 0.75        | 1.00 | 2.0     | 2.0  | 7.2                      | 63.4   | 60                      | 2.36 | 26.5   | 58.3 |
| A        | AFTE480-1200 | 1200  | 1440 | 0.75        | 1.00 | 2.0     | 2.0  | 5.4                      | 47.5   | 60                      | 2.36 | 26.5   | 58.3 |
| A        | AFTE480-1450 | 1450  | 1740 | 0.75        | 1.00 | 2.0     | 2.0  | 4.4                      | 39.3   | 60                      | 2.36 | 26.5   | 58.3 |

Drilling performance specification

Sound level: <70 dB(A)

# Electric drive - Leadscrew feed

AFTE480 ■

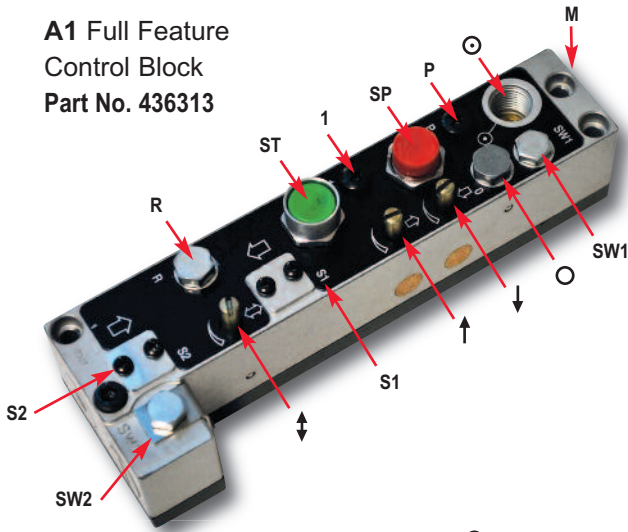


| MODEL                 | A  |     | B   |     | C   |      | D   |     | E   |     | F   |      | G   |      |
|-----------------------|----|-----|-----|-----|-----|------|-----|-----|-----|-----|-----|------|-----|------|
|                       | mm | in. | mm  | in. | mm  | in.  | mm  | in. | mm  | in. | mm  | in.  | mm  | in.  |
| AFTE480-180/330/550   | 70 | 2.8 | 116 | 4.6 | 268 | 10.6 | 222 | 8.7 | 192 | 7.6 | 280 | 11.0 | 625 | 24.6 |
| AFTE480-900/1200/1450 | 70 | 2.8 | 116 | 4.6 | 268 | 10.6 | 222 | 8.7 | 192 | 7.6 | 207 | 8.2  | 552 | 21.7 |

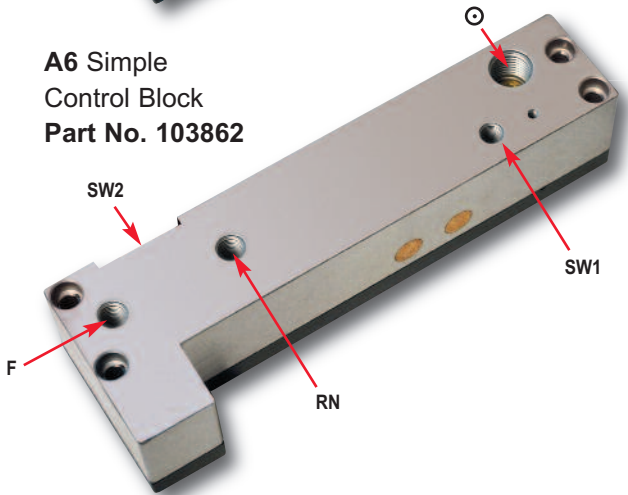
# Control Blocks and Interfaces

## Control Blocks

**A1 Full Feature Control Block**  
Part No. 436313



**A6 Simple Control Block**  
Part No. 103862



### Air Connections

- R** Air Return Port – Connects to breather port in the nose of the tool to provide extra retract capability with heavy front end attachments (10-32)
- ST** Start Button – For manual operation and set-up
- 1** Remote Start Signal Port Pulse (10-32)
- SP** Manual Stop Button – Interrupts cycle and returns AFD to datum
- P** Remote Stop Signal Port – Requires external signal pulse for returning the unit to datum rest position (10-32)
- ⊙** Air inlet (1/4" BSP or 1/4" NPT)
- M** Work Cycle Complete Port – Used for sequence control with other AFD's clamps, index tables, etc (positive at datum position) (10-32)
- Depth Stop Signal Port – Used with external circuits such as dwell or pecking (10-32)
- ↑** Retract rate adjustment control
- ↓** Advance rate adjustment control
- ↕** Feed rate adjustment control
- F** Feed port (1/8" NPT)
- RN** Return port (1/8" NPT)

### Electrical Connections

- S1** Start solenoid
- S2** Stop solenoid
- SW1** Datum return (M8 x 1.00)
- SW2** Depth position (M8 x 1.00)

## Electrical Interfaces (not included with control blocks)

### C3 Part No. 104002

Comprises:  
2 x M8 Proximity Switches PNP (NO)  
2 x Plug-in Cables

### C5 Part No. 104842

Comprises:  
2 x M8 Proximity Switches NPN (NO)  
2 x Plug-in Cables

### Solenoid Valves

All 24V DC  
NC – Valve normally closed  
NO – Valve normally open

### Proximity Switches

All 10-30V DC  
NC – Normally closed  
NO – Normally open

### C10 Part No. 438223

Comprises:  
2 x M8 Proximity Switches PNP  
2 x Plug-in Cables  
2 x Solenoid Valves (NC)

### C11 Part No. 438233

Comprises:  
2 x M8 Proximity Switches PNP  
2 x Plug-in Cables  
1 x Solenoid Valve (NC)  
1 x Solenoid Valve (NO)

### C12 Part No. 438243

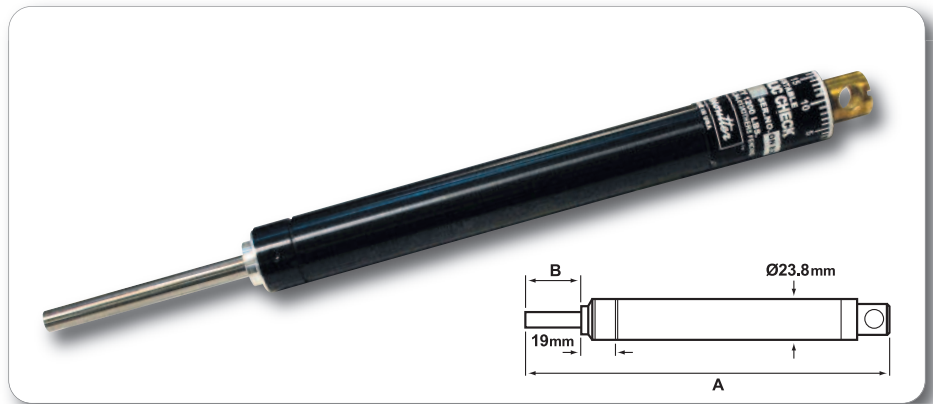
Comprises:  
2 x M8 Proximity Switches NPN  
2 x Plug-in Cables  
2 x Solenoid Valves (NC)

# Accessories

## AFD Control Options

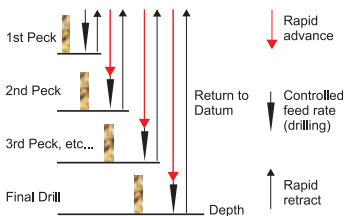


Adjustable Hydraulic Control Unit



|    | MIN. PLUNGER OPERATING LOAD |     | MAX. LOAD |      | MINIMUM FEED RATE AT 2230N (500LBS) LOAD |        | MAX. STROKE |    | A   |       | B    |      | PART NO. |
|----|-----------------------------|-----|-----------|------|--|--------|-------------|----|-----|-------|------|------|----------|
|    | kg                          | lbs | kg        | lbs  | mm/sec                                   | in/sec | mm          | in | mm  | in    | mm   | in   |          |
| D1 | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 25          | 1  | 199 | 7.83  | 30.1 | 1.19 | 91942    |
| D2 | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 50          | 2  | 276 | 10.87 | 55.5 | 2.19 | 91952    |
| D3 | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 75          | 3  | 352 | 13.86 | 80.9 | 3.19 | 91962    |
| D7 | 4.1                         | 9   | 357       | 785  | 0.45                                     | 0.018  | 102         | 4  | 417 | 16.42 | 106  | 4.17 | 104452   |

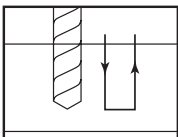
### Peck feed control



Used when hole depth is five times hole diameter. Helps clear chips, avoids overheating and bit breakage. Hole accuracy is improved. For use with Full Feature Control Block

|    | STROKE    | PART NO. |
|----|-----------|----------|
| D4 | 25mm (1") | 92282    |
| D5 | 50mm (2") | 92292    |
| D6 | 75mm (3") | 92302    |

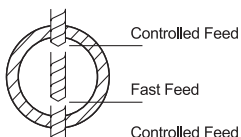
### Dwell control



Used to dwell drill bit at the bottom of the stroke. Can be used to spot face, blind hole polish, friction weld plastic components and spin rivet. For use with Full Feature Control Block.

|    | DESCRIPTION                 | PART NO. |
|----|-----------------------------|----------|
| E1 | Dwell Control Unit Complete | 92372    |

### Skip feed control



Skip drilling - custom H.C.U's available on request. Skip control ensures minimum cycle times without breakthrough burrs when drilling tubes, pocketed castings etc, with two controlled feeds, and fast travel through the empty space.

- Information Required
1. Depth of first cut
  2. Depth of skip
  3. Depth of second cut
  4. Drill point angle

# Accessories

## OUTPUT SPINDLES

- Interchangeable modular output spindles
- Precision option for collet types, R2 and R36



### AFDE200/230 - AFD205 - AFD215

|  | FUNCTION                          | ORDER CODE | FEATURES   | PART NO. | RECOMMENDED SPEED RANGE |
|--|-----------------------------------|------------|--|----------|-------------------------|
|  | High Speed Output Spindle         | K42        | Collet Chuck can be fitted to any AFDE200 to step up speed by 4.28 : 1. Note: Max. allowable speed 27000 rpm. See page 29 for collets. | 375263   | ≤ 5250 rpm              |
|  | Collet Chuck                      | K2         | See page 31 for range of collets.  | 357183   | ≤ 18800 rpm             |
|  | No. 1 Jacobs Taper Output Spindle | K32        | No. 1 Jacobs Taper and for use with chucks or multi spindle heads  | 449733   | ≤ 9600 rpm              |
|  | Tapping Head Output Spindle       | H21        | 4.5-8.0mm (3/16"-5/16") capacity   | 357193   | ≤ 1200 rpm              |


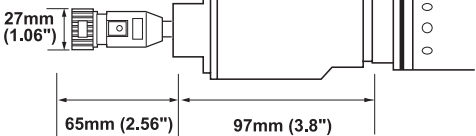

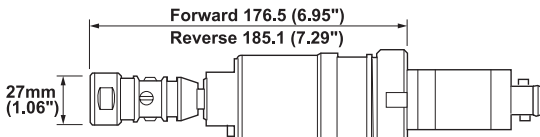
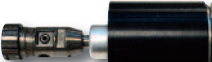
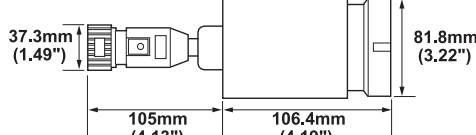
### AFDE400/430 - AFDE410/440 - AFD415 - AFDE610/640 - AFDE620 - AFDE625 - AFTE480

|    | FUNCTION  | ORDER CODE | FEATURES   | PART NO. | RECOMMENDED SPEED RANGE |   |   |    |    |    |    |    |    |    |    |  |        |
|----|---|------------|--|----------|-------------------------|---|---|----|----|----|----|----|----|----|----|--|--------|
|    | 10mm (3/8") Key Adjustable Chuck Output Spindle                       | B1         | Part No. includes chuck key  | 327723   | ≤ 9600                  |   |   |    |    |    |    |    |    |    |    |  |        |
|    | Integral Collet Chuck Output Spindle                                  | B2         | Up to 7mm (0.276") collet capacity (see page 31 for Collet Range)  | 326573   | ≤ 18000                 |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   | R2         | Standard Output Assembly   | 384113   |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | Large Integral Collet Chuck Output Spindle                            | R36        | Up to 16mm (0.63") collet capacity (see page 31 for Collets)   | 389273   | ≤ 18000                 |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   |            | Precision Output Assembly  |          |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | Taper Output Spindle and for use with chucks and multi spindle heads  | B24        | No. 2 Jacobs Taper A = 30 (1.18")  | 326593   | ≤ 9600                  |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   | B32        | No. 1 Jacobs Taper A = 24.1 (0.95")  | 355263   |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   | B16        | B16 Taper Output A = 34.8 (1.37")  | 368163   |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | Preset Tooling DIN55058 Output Spindle                                |            | <table border="1"> <thead> <tr> <th>ØA</th> <th>ØB</th> <th>C</th> <th>D</th> </tr> <tr> <th>mm</th> <th>mm</th> <th>mm</th> <th>mm</th> </tr> </thead> <tbody> <tr> <td>16</td> <td>25</td> <td>74</td> <td>79</td> </tr> </tbody> </table> | ØA       | ØB                      | C | D | mm | mm | mm | mm | 16 | 25 | 74 | 79 |  | ≤ 5450 |
|    |   | ØA         | ØB   | C        | D                       |   |   |    |    |    |    |    |    |    |    |  |        |
| mm | mm  | mm         | mm   |          |                         |   |   |    |    |    |    |    |    |    |    |  |        |
| 16 | 25  | 74         | 79   |          |                         |   |   |    |    |    |    |    |    |    |    |  |        |
| B3 | Standard Output Assembly  | 326563     |  |          |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | AFD415, AFDE400 Externally Adjustable Screwdriver Head Output Spindle | B5         | 1/4" fem. hex. drive. Torque range 0.3 - 11 Nm (2.7 - 100 ins. lbs.)   | 324903   | ≤ 2100                  |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   | B6         | 5/16" fem. hex. drive. Torque range 0.3 - 11 Nm (2.7 - 100 ins. lbs.)  | 324913   |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | AFD415, AFDE400/410 Tapping Head Output Spindle                       | B7         | 3.5 - 6.5mm (9/64" - 1/4") capacity  | 92362    | ≤ 1450                  |   |   |    |    |    |    |    |    |    |    |  |        |
|    |   | B8         | 4.5 - 8mm (3/16" - 5/16") capacity   | 92892    |                         |   |   |    |    |    |    |    |    |    |    |  |        |
|    | AFDE600/610 Tapping Head Output Spindle                               | J19        | 4.5 - 9.5mm (3/16" - 3/8") capacity For use with B24 output  | 383813   | ≤ 1450                  |   |   |    |    |    |    |    |    |    |    |  |        |

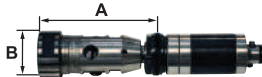



# Accessories

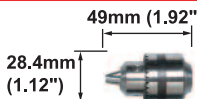
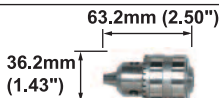
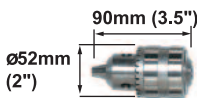
## TAPPING HEADS

|                      |   |   |  |  |
|----------------------|---|---|--|--|
| <b>AFDE200 Serie</b> |  |  | <b>H21 Tapping Gearbox</b><br><b>Part No. 357193</b><br>Capacity 4.5-8mm (3/16"-5/16")<br>Use with K32 output  |  |
| <b>AFDE400 Serie</b> |  |  | <b>B7 Tapping Gearbox</b><br><b>Part No. 92362</b><br>Capacity 3.5-6.5mm (9/64"-1/4")                          | <b>B8 Tapping Gearbox</b><br><b>Part No. 92892</b><br>Capacity 4.5-8mm (3/16"-5/16") |
| <b>AFDE610 Serie</b> |  |  | <b>J19 Tapping Gearbox</b><br><b>Part No. 383813</b><br>Capacity 4.5-9.5mm (3/16"-3/8")<br>Use with B24 output |  |

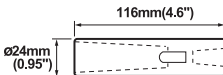
## TAPPING CHUCKS

|                  | FUNCTION  | JACOBS TAPER FITTING                           | A     |     | B   |     | Ø TAP SHANK |         | CHUCK PART NO. |   |
|------------------|---|--|-------|-----|-----|-----|-------------|---------|----------------|---|
|                  |   |  | mm    | in. | mm  | in. | mm          | in.     |                |   |
| Optional Collets |  | Tapping Chucks with flexible Collet (included) | No. 1 | 64  | 2.5 | 27  | 1.1         | 3.5-6.5 | 9/64-1/4       | 29462   |
|                  |   |  | No. 1 | 64  | 2.5 | 27  | 1.1         | 4.5-8   | 3/16-5/16      | 29452   |
|                  |   |  | No. 2 | 79  | 3.1 | 37  | 1.5         | 4.5-9.5 | 3/16-3/8       | 34742   |
|                  |  | Spare or replacement Collets                   |       |     |     |     |             |         |                | 2-4.5mm (5/64-3/16") Capacity to suit 29462/29452<br>3.5-6.5mm (9/64-1/4") Capacity to suit 29462/29452<br>4.5-8mm (3/16-5/16") Capacity to suit 29462/29452<br>4.5-9.5mm (3/16-3/8") Capacity to suit 34742<br>9-12.5mm (9/32-1/2") Capacity to suit 34742 |

## DRILLING CHUCKS

|                              | FUNCTION  | DESCRIPTION                       | PART NO.  |       |
|------------------------------|---|-----------------------------------|---|-------|
| Max Drill Depth 15mm (0.59") |  | 6.5mm (1/4") Key Adjustable Chuck | Part No. includes Chuck Key. Use with No. 1 standard Jacobs taper outputs K32 and B32 | 29492 |
| Max Drill Depth 34mm (1.34") |  | 10mm (3/8") Key Adjustable Chuck  | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24          | 34752 |
| Max Drill Depth 52mm (2.04") |  | 13mm (1/2") Key Adjustable Chuck  | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24          | 34332 |

## MORSE ADAPTOR

|                  | FUNCTION  | DESCRIPTION         | PART NO.  |       |
|------------------|---|---------------------|---|-------|
| No.2 Morse Taper |  | Morse Taper Adaptor | No. 2 Jacobs female taper to No. 2 Morse female taper | 34862 |

# Multiple Spindle Heads



- Range of adjustable spindle positions for 2, 3 and 4 spindle heads
- Special fixed spindle heads available for non standard hole patterns or dedicated applications

| TYPE OF HEAD    | NUMBER OF SPINDLES | SPINDLE CENTRE OR PC |           | MAXIMUM COLLET SIZE |       | AFD205<br>AFD215<br>AFDE200/230 | AFD415<br>AFDE400/430<br>AFDE410/440 | AFDE610/640<br>AFD625 | AFTE480  | COLLET TYPE<br>(SEE PAGE 28) |
|-----------------|--------------------|----------------------|-----------|---------------------|-------|---------------------------------|--------------------------------------|-----------------------|----------|------------------------------|
|                 |                    | mm                   | in.       | mm                  | in.   | PART NO.                        | PART NO.                             | PART NO.              | PART NO. |                              |
| <b>DRILLING</b> |                    |                      |           |                     |       |                                 |                                      |                       |          |                              |
| A               | 2                  | 9.5-54               | 0.37-2.13 | 4.0                 | 0.157 | 174183                          | 92142                                |                       |          | A                            |
| A               | 2                  | 12.7-64              | 0.50-2.52 | 6.5                 | 0.256 |                                 | 92152                                |                       |          | B                            |
| A               | 2                  | 18.4-87.3            | 0.72-3.44 | 7.0                 | 0.276 |                                 | 92162                                |                       |          | C                            |
| A               | 2                  | 19.0-95              | 0.75-3.74 | 9.5                 | 0.374 |                                 | 106662                               | 106672                |          | D                            |
| A               | 2                  | 41.1-109.9           | 1.62-4.33 | 7.0                 | 0.276 |                                 | 92172                                |                       |          | C                            |
| B               | 3 inline           | 19.0-57.1            | 0.75-2.25 | 9.5                 | 0.374 |                                 | 107552                               | 107562                |          | D                            |
| C               | 3PCD               | 27.9-104.1           | 1.01-4.01 | 9.5                 | 0.374 |                                 |                                      | 107592                |          | D                            |
| D               | FIXED              |                      |           |                     |       |                                 | MSD100                               | MSD200                |          | D                            |

|                |          |            |           |     |       |        |        |        |        |   |
|----------------|----------|------------|-----------|-----|-------|--------|--------|--------|--------|---|
| <b>TAPPING</b> |          |            |           |     |       |        |        |        |        |   |
| A              | 2        | 9.5-54     | 0.37-2.13 | 4.0 | 0.157 |        |        |        | 92142  | A |
| A              | 2        | 12.7-64    | 0.50-2.52 | 6.5 | 0.256 | 204173 | 92222  |        | 92152  | B |
| A              | 2        | 18.4-87.3  | 0.72-3.44 | 7.0 | 0.276 |        |        |        | 92162  | C |
| A              | 2        | 19.0-95    | 0.75-3.74 | 9.5 | 0.374 |        | 106682 | 106692 | 106662 | D |
| A              | 2        | 41.1-109.9 | 1.62-4.33 | 7.0 | 0.276 |        |        |        | 92172  | C |
| B              | 3 inline | 19.0-57.1  | 0.75-2.25 | 9.5 | 0.374 |        |        |        | 107552 | D |
| C              | 3PCD     | 27.9-104.1 | 1.01-4.01 | 9.5 | 0.374 |        | 107662 |        |        | D |
| D              | FIXED    |            |           |     |       |        | MST100 | MST200 | MSD100 | D |

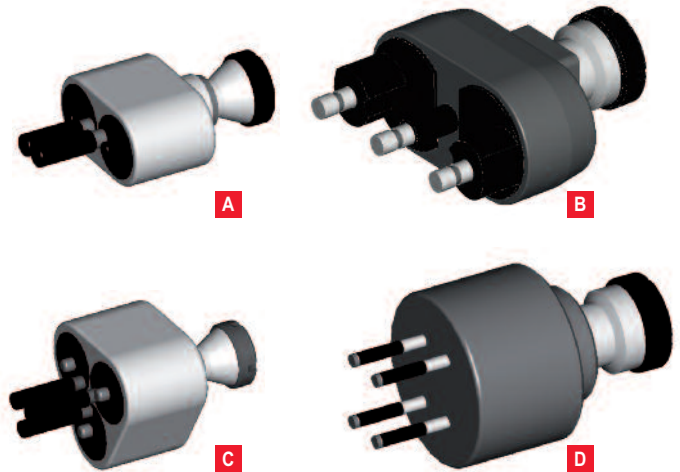
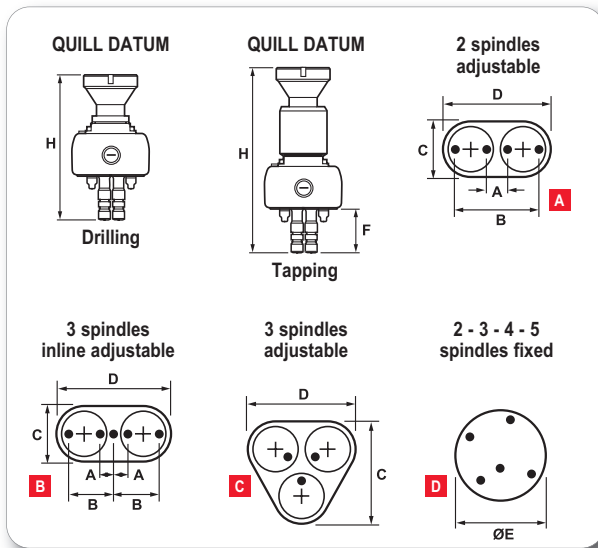
## Output spindles for use with multiple spindle heads (2)

| MAXIMUM COLLET SIZE | AFD205<br>AFD215<br>AFDE200/230 | AFD415<br>AFDE400/430<br>AFDE410/440 | AFDE610/640<br>AFD625 |
|---------------------|---------------------------------|--------------------------------------|-----------------------|
| PART NO.            | PART NO.                        | PART NO.                             | PART NO.              |
| K32                 | B24                             | B24                                  | B24                   |

(2) How to order  
 Examples:  
 AFDE200-2850-A1-K32 + 174183  
 AFD415-3400-A6-B24 + 107552  
 AFDE610-900-A1-24 + 10672

# Accessories

## Multiple Spindle Heads



| TYPE OF HEAD              | PART NO. | MAX. SPEED | MIN./MAX. CENTRES A - B |           | MIN. PCD |      | MAX. PCD |      | C     |       | DIMENSIONS D |      | F    |       | H     |       |
|---------------------------|----------|------------|-------------------------|-----------|----------|------|----------|------|-------|-------|--------------|------|------|-------|-------|-------|
|                           |          |            | mm                      | in.       | mm       | in.  | mm       | in.  | mm    | in.   | mm           | in.  | mm   | in.   | mm    | in.   |
| <b>ADJUSTABLE SPINDLE</b> |          |            |                         |           |          |      |          |      |       |       |              |      |      |       |       |       |
| A                         | 92142    | 5300       | 9.5-54.0                | 0.37-2.13 |          |      |          |      | 50.8  | 2.00  | 83           | 2.27 | 50.8 | 2.00  | 175.4 | 6.91  |
| A                         | 92152    | 5300       | 12.7-64.0               | 0.50-2.52 |          |      |          | 50.8 | 2.00  | 83    | 2.27         | 50.8 | 2.00 | 175.4 | 6.91  |       |
| A                         | 92162    | 8500       | 18.4-87.3               | 0.72-3.44 |          |      |          | 62.0 | 2.44  | 115   | 4.53         | 60.0 | 2.36 | 196   | 7.72  |       |
| A                         | 92172    | 8500       | 41.1-109.9              | 1.62-4.33 |          |      |          | 62.0 | 2.44  | 137   | 5.39         | 60.0 | 2.36 | 196   | 7.72  |       |
| A                         | 92222    | 1400       | 12.7-64.0               | 0.50-2.52 |          |      |          | 50.8 | 2.00  | 83    | 3.27         | 50.8 | 2.00 | 233.8 | 9.20  |       |
| A                         | 106662   | 5300       | 19.0-95.0               | 0.75-3.74 |          |      |          | 76.0 | 2.99  | 124   | 4.88         | 68.3 | 2.69 | 212   | 8.35  |       |
| A                         | 106672   | 5300       | 19.0-95.0               | 0.75-3.74 |          |      |          | 76.0 | 2.99  | 124   | 4.88         | 68.3 | 2.69 | 211   | 8.31  |       |
| A                         | 106682   | 1500       | 19.0-95.0               | 0.75-3.74 |          |      |          | 76.0 | 2.99  | 124   | 4.88         | 68.3 | 2.69 | 261.5 | 10.30 |       |
| A                         | 106692   | 1500       | 19.0-95.0               | 0.75-3.74 |          |      |          | 76.0 | 2.99  | 124   | 4.88         | 68.3 | 2.69 | 260   | 10.24 |       |
| B                         | 107552   | 5300       | 19.0-57.1               | 0.75-2.25 |          |      |          | 99.2 | 3.90  | 142.9 | 5.63         | 68.3 | 2.69 | 212.3 | 8.36  |       |
| B                         | 107562   | 5300       | 19.0-27.1               | 0.75-2.25 |          |      |          | 99.2 | 3.90  | 142.9 | 5.63         | 68.3 | 2.69 | 188   | 7.40  |       |
| B                         | 107592   | 5300       |                         |           | 27.9     | 1.01 | 104.1    | 4.01 | 120.3 | 4.74  | 132.6        | 5.22 | 68.3 | 2.69  | 211.2 | 6.31  |
| A                         | 107662   | 900        |                         |           | 27.9     | 1.01 | 104.1    | 4.01 | 120.3 | 4.74  | 132.6        | 5.22 | 68.3 | 2.69  | 261.5 | 10.30 |
| C                         | 107672   | 900        |                         |           | 27.9     | 1.01 | 104.1    | 4.01 | 120.3 | 4.74  | 132.6        | 5.22 | 68.3 | 2.69  | 260   | 10.24 |
| A                         | 107682   | 900        |                         |           | 27.9     | 1.01 | 104.1    | 4.01 | 120.3 | 4.74  | 132.6        | 5.22 | 68.3 | 2.69  | 259.9 | 10.23 |
|                           | 174183   | 5300       | 9.5-54.0                | 0.37-2.13 |          |      |          |      | 50.8  | 2.00  | 83           | 2.27 | 50.8 | 2.00  | 169.5 | 6.67  |
|                           | 204173   | 700        | 12.7-64                 | 0.50-2.52 |          |      |          |      | 50.8  | 2.00  | 83           | 2.27 | 50.8 | 2.00  | 206.1 | 8.11  |

| TYPE OF HEAD         | PART NO. | MAX. SPEED | MIN./MAX. CENTRES A - B |           | MIN. PCD |          | MAX. PCD |      | ØE          |           | DIMENSIONS F |             | H          |           |
|----------------------|----------|------------|-------------------------|-----------|----------|----------|----------|------|-------------|-----------|--------------|-------------|------------|-----------|
|                      |          |            | mm                      | in.       | mm       | in.      | mm       | in.  | mm          | in.       | in.          | mm          | in.        | mm        |
| <b>FIXED SPINDLE</b> |          |            |                         |           |          |          |          |      |             |           |              |             |            |           |
| D                    | MSD100   | 5300       | 9.5-63.5                | 0.37-2.52 | 9.5-12.7 | 0.37-0.5 | 63.5     | 2.50 | 56-81.8     | 2.20-3.22 | 37/40.5      | 1.46/1.59   | 168/175.4  | 6.61/6.91 |
| D                    | MST100   | 1400       | 9.5-63.5                | 0.37-2.52 | 9.5-12.7 | 0.37-0.5 | 63.5     | 2.50 | 56-81.8     | 2.20-3.22 | 37/40.5      | 1.46/1.59 2 | 27.8/233.8 | 8.97/9.20 |
| D                    | MSD200   | 5300       | 19.0-95                 | 0.75-3.74 | 19.0     | 0.75     | 95.0     | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2         | 2.25        | 211.1      | 8.31      |
| D                    | MST200   | 700        | 19.0-95                 | 0.75-3.74 | 19.0     | 0.75     | 95.0     | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2         | 2.25        | 260        | 10.24     |
| D                    | MSD300   | 3500       | 17.4-157                | 0.69-6.18 | 17.4     | 0.69     | 157      | 6.18 | 150-225     | 5.91-8.86 | 26-41        | 1.02-1.61   | 221-241    | 8.70-9.79 |
| D                    | MST300   | 1500       | 17.4-157                | 0.69-6.18 | 17.4     | 0.69     | 157      | 6.18 | 150-225     | 5.91-8.86 | 26-41        | 1.02-1.61   | 221-241    | 8.70-9.79 |

For fixed spindle heads minimum centres are dependent on collet size, overall diameter on the distance between spindles and overall lengths on collet size. Desoutter can provide dimensions if required.

Always provide details of hole pattern, hole diameters and material to be machined when ordering a fixed spindle head.

# Collets

## Collets for multiple spindle heads Type A - Threaded types



| SIZE Ø |       | PART NO. | SIZE Ø |       | PART NO. |
|--------|-------|----------|--------|-------|----------|
| mm     | in.   |          | mm     | in.   |          |
| 1.0    | 0.039 | 60002    | 2.5    | 0.098 | 60172    |
| 1.1    | 0.043 | 60022    | 2.6    | 0.102 | 60182    |
| 1.2    | 0.047 | 60032    | 2.7    | 0.106 | 60192    |
| 1.3    | 0.051 | 60042    | 2.8    | 0.110 | 60202    |
| 1.4    | 0.055 | 60052    | 2.9    | 0.114 | 60222    |
| 1.5    | 0.059 | 60062    | 3.0    | 0.118 | 60232    |
| 1.6    | 0.063 | 60072    | 3.1    | 0.122 | 60242    |
| 1.7    | 0.067 | 60082    | 3.2    | 0.126 | 60252    |
| 1.8    | 0.071 | 60092    | 3.3    | 0.130 | 60262    |
| 1.9    | 0.075 | 60102    | 3.4    | 0.134 | 60272    |
| 2.0    | 0.079 | 60122    | 3.5    | 0.138 | 60282    |
| 2.1    | 0.083 | 60132    | 3.6    | 0.142 | 60292    |
| 2.2    | 0.087 | 60142    | 3.7    | 0.146 | 60302    |
| 2.3    | 0.091 | 60152    | 3.8    | 0.150 | 60322    |
| 2.4    | 0.094 | 60162    | 3.9    | 0.154 | 60332    |
|        |       |          | 4.0    | 0.157 | 60342    |

## Collets for multiple spindle heads Type D - Threaded types



| SIZE Ø |       | PART NO. | SIZE Ø |       | PART NO. |
|--------|-------|----------|--------|-------|----------|
| mm     | in.   |          | mm     | in.   |          |
| 2.0    | 0.079 | 39302    | 5.8    | 0.228 | 35242    |
| 2.1    | 0.083 | 39322    | 5.9    | 0.232 | 35252    |
| 2.2    | 0.087 | 39332    | 6.0    | 0.236 | 35272    |
| 2.3    | 0.091 | 39342    | 6.1    | 0.240 | 35282    |
| 2.4    | 0.094 | 39352    | 6.2    | 0.244 | 35292    |
| 2.5    | 0.098 | 39362    | 6.3    | 0.248 | 35302    |
| 2.6    | 0.102 | 39372    | 6.4    | 0.252 | 35332    |
| 2.7    | 0.106 | 39382    | 6.5    | 0.256 | 35342    |
| 2.8    | 0.110 | 39392    | 6.6    | 0.260 | 35352    |
| 2.9    | 0.114 | 39402    | 6.7    | 0.264 | 35362    |
| 3.0    | 0.118 | 39422    | 6.8    | 0.268 | 35382    |
| 3.1    | 0.122 | 39432    | 6.9    | 0.272 | 35392    |
| 3.2    | 0.126 | 34902    | 7.0    | 0.276 | 35402    |
| 3.3    | 0.130 | 34932    | 7.1    | 0.280 | 35422    |
| 3.4    | 0.134 | 34942    | 7.2    | 0.283 | 35432    |
| 3.5    | 0.138 | 34952    | 7.3    | 0.287 | 35452    |
| 3.6    | 0.142 | 34962    | 7.4    | 0.291 | 35462    |
| 3.7    | 0.146 | 34982    | 7.5    | 0.295 | 35472    |
| 3.8    | 0.150 | 34992    | 7.6    | 0.299 | 35492    |
| 3.9    | 0.154 | 35002    | 7.7    | 0.303 | 35502    |
| 4.0    | 0.157 | 35022    | 7.8    | 0.307 | 35522    |
| 4.1    | 0.161 | 35032    | 7.9    | 0.311 | 35532    |
| 4.2    | 0.165 | 35042    | 8.0    | 0.315 | 35552    |
| 4.3    | 0.169 | 35052    | 8.1    | 0.319 | 35562    |
| 4.4    | 0.173 | 35062    | 8.2    | 0.323 | 35572    |
| 4.5    | 0.177 | 35072    | 8.3    | 0.327 | 35582    |
| 4.6    | 0.181 | 35082    | 8.4    | 0.331 | 35592    |
| 4.7    | 0.185 | 35092    | 8.5    | 0.335 | 36602    |
| 4.8    | 0.189 | 35102    | 8.6    | 0.339 | 35622    |
| 4.9    | 0.193 | 35122    | 8.7    | 0.342 | 35632    |
| 5.0    | 0.197 | 35132    | 8.8    | 0.346 | 35652    |
| 5.1    | 0.201 | 35152    | 8.9    | 0.350 | 35672    |
| 5.2    | 0.205 | 35172    | 9.0    | 0.354 | 35682    |
| 5.3    | 0.209 | 35182    | 9.1    | 0.358 | 35692    |
| 5.4    | 0.213 | 35192    | 9.2    | 0.362 | 35722    |
| 5.5    | 0.217 | 35202    | 9.3    | 0.366 | 35732    |
| 5.6    | 0.220 | 35222    | 9.4    | 0.370 | 35752    |
| 5.7    | 0.224 | 35232    | 9.5    | 0.374 | 35762    |

## Collets for multiple spindle heads Type B - Threaded types



| SIZE Ø |       | PART NO. | SIZE Ø |       | PART NO. |
|--------|-------|----------|--------|-------|----------|
| mm     | in.   |          | mm     | in.   |          |
| 1.0    | 0.039 | 39442    | 3.8    | 0.150 | 28092    |
| 1.1    | 0.043 | 39452    | 3.9    | 0.154 | 28102    |
| 1.2    | 0.047 | 39462    | 4.0    | 0.157 | 28122    |
| 1.3    | 0.051 | 39472    | 4.1    | 0.161 | 28132    |
| 1.4    | 0.055 | 39482    | 4.2    | 0.165 | 28142    |
| 1.5    | 0.059 | 39492    | 4.3    | 0.169 | 28152    |
| 1.6    | 0.063 | 27852    | 4.4    | 0.173 | 28162    |
| 1.7    | 0.067 | 39502    | 4.5    | 0.177 | 28172    |
| 1.8    | 0.071 | 27862    | 4.6    | 0.181 | 28182    |
| 1.9    | 0.075 | 39522    | 4.7    | 0.185 | 28192    |
| 2.0    | 0.079 | 27872    | 4.8    | 0.189 | 28202    |
| 2.1    | 0.083 | 27882    | 4.9    | 0.193 | 28222    |
| 2.2    | 0.087 | 27892    | 5.0    | 0.197 | 28232    |
| 2.3    | 0.091 | 27902    | 5.1    | 0.201 | 28252    |
| 2.4    | 0.094 | 27922    | 5.2    | 0.205 | 28272    |
| 2.5    | 0.098 | 27932    | 5.3    | 0.209 | 28282    |
| 2.6    | 0.102 | 27942    | 5.4    | 0.213 | 28292    |
| 2.7    | 0.106 | 27952    | 5.5    | 0.217 | 28302    |
| 2.8    | 0.110 | 27962    | 5.6    | 0.220 | 28322    |
| 2.9    | 0.114 | 27972    | 5.7    | 0.224 | 28332    |
| 3.0    | 0.118 | 27982    | 5.8    | 0.228 | 28342    |
| 3.1    | 0.122 | 27992    | 5.9    | 0.232 | 28352    |
| 3.2    | 0.126 | 28002    | 6.0    | 0.236 | 28372    |
| 3.3    | 0.130 | 28032    | 6.1    | 0.240 | 28382    |
| 3.4    | 0.134 | 28042    | 6.2    | 0.244 | 28392    |
| 3.5    | 0.138 | 28052    | 6.3    | 0.248 | 28402    |
| 3.6    | 0.142 | 28062    | 6.4    | 0.252 | 39532    |
| 3.7    | 0.146 | 28082    | 6.5    | 0.256 | 39542    |

## Collets for multi spindle heads Type C For use with B2 (326573), R2 (384113), K2 (357183), K42 (375263)



| SIZE Ø  |             | PART NO. | SIZE Ø  |             | PART NO. |
|---------|-------------|----------|---------|-------------|----------|
| mm      | in.         |          | mm      | in.         |          |
| 0.5-1.0 | 0.020-0.039 | 52582    | 3.1-4.0 | 0.122-0.157 | 52642    |
| 1.1-1.5 | 0.043-0.059 | 52592    | 4.1-5.0 | 0.161-0.197 | 52652    |
| 1.6-2.0 | 0.063-0.079 | 52602    | 5.1-6.0 | 0.201-0.234 | 52662    |
| 2.1-2.5 | 0.083-0.098 | 52622    | 6.1-7.0 | 0.240-0.276 | 52672    |
| 2.6-3.0 | 0.102-0.118 | 2632     |         |             |          |

## For use with R36 (389273), ER25 TYPE

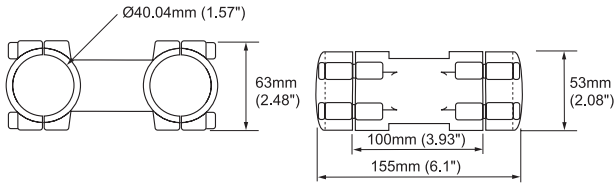


| SIZE Ø    |             | PART NO. | SIZE Ø    |             | PART NO. |
|-----------|-------------|----------|-----------|-------------|----------|
| mm        | in.         |          | mm        | in.         |          |
| 6.0-7.0   | 0.236-0.276 | 104942   | 11.1-12.0 | 0.437-0.472 | 104992   |
| 7.1-8.0   | 0.279-0.315 | 104952   | 12.1-13.0 | 0.476-0.512 | 105002   |
| 8.1-9.0   | 0.319-0.354 | 104962   | 13.1-14.0 | 0.516-0.551 | 105022   |
| 9.1-10.0  | 0.358-0.394 | 104972   | 14.1-15.0 | 0.555-0.591 | 105032   |
| 10.1-11.0 | 0.397-0.433 | 104982   | 15.1-16.0 | 0.594-0.630 | 105042   |

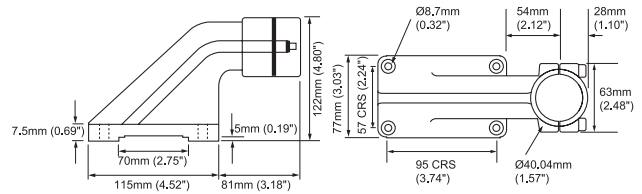
# Clamps

## AFDE200/230 - AFD205/215

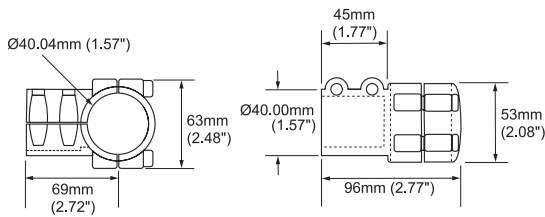
### Parallel Clamp



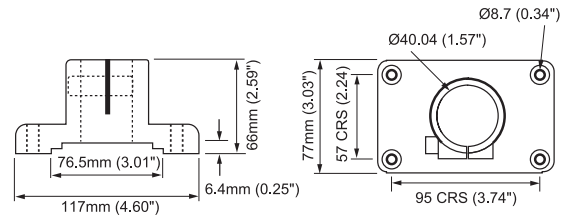
### Swan Neck Clamp



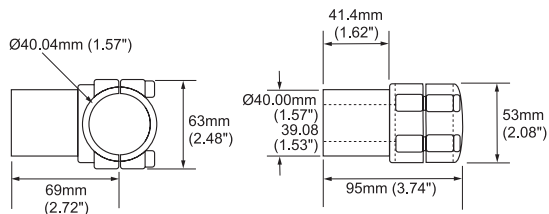
### Right Angle Clamp



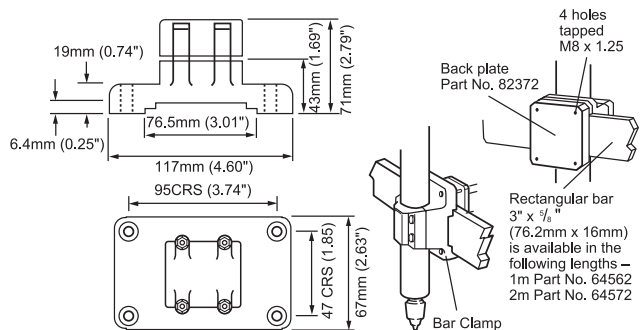
### Base Clamp



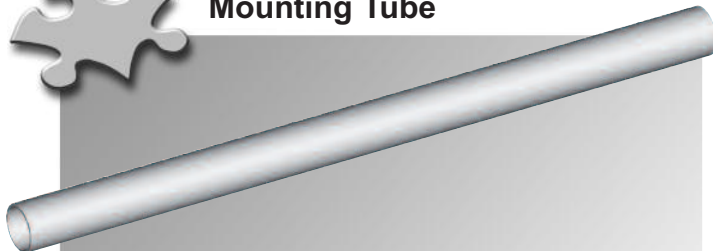
### Swivel Clamp



### Bar Clamp



### Mounting Tube



Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

## AFDE200/230 - AFD205/215

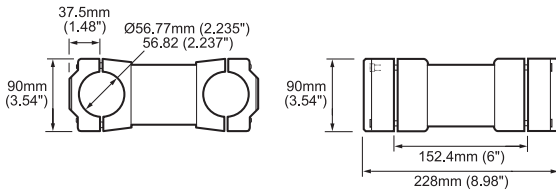
### ACCESSORIES

|  | PART NO. |
|--|----------|
| • Parallel clamp   | 61832    |
| • Right Angle clamp  | 61822    |
| • Swivel clamp   | 61802    |
| • Swan Neck clamp  | 61862    |
| • Base clamp   | 61842    |
| • Bar clamp  | 61852    |
| • Mounting Tube 228 (9") length, $\text{Ø} 39.97\text{-}40$ (1.574"-1.575")  | 39702    |
| • Mounting Tube 457 (18") length, $\text{Ø} 39.97\text{-}40$ (1.574"-1.575") | 39732    |
| • Mounting Tube 610 (24") length, $\text{Ø} 39.97\text{-}40$ (1.574"-1.575") | 39742    |
| • Mounting Tube 760 (30") length, $\text{Ø} 39.97\text{-}40$ (1.574"-1.575") | 39752    |

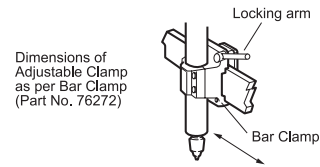
# Clamps

## AFDE400/430/410/440 - AFD415

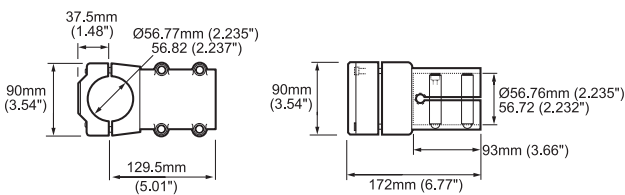
### Parallel Clamp



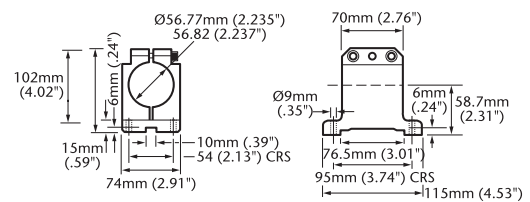
### Adjustable Bar Clamp



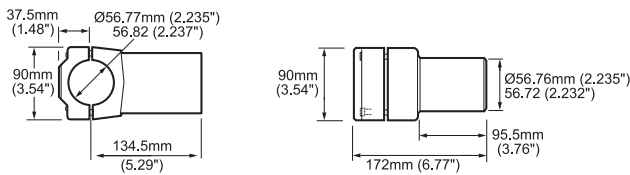
### Right Angle Clamp



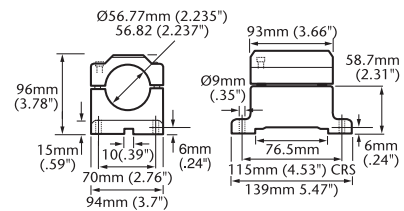
### Narrow Bar Clamp



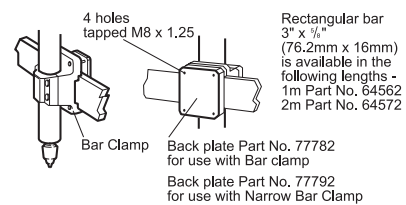
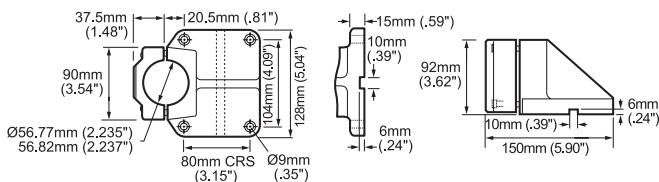
### Swivel Clamp



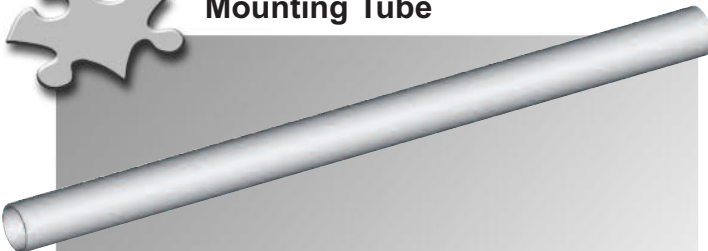
### Bar Clamp



### Base Clamp



### Mounting Tube



Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

## AFDE400/430/410/430 - AFD415

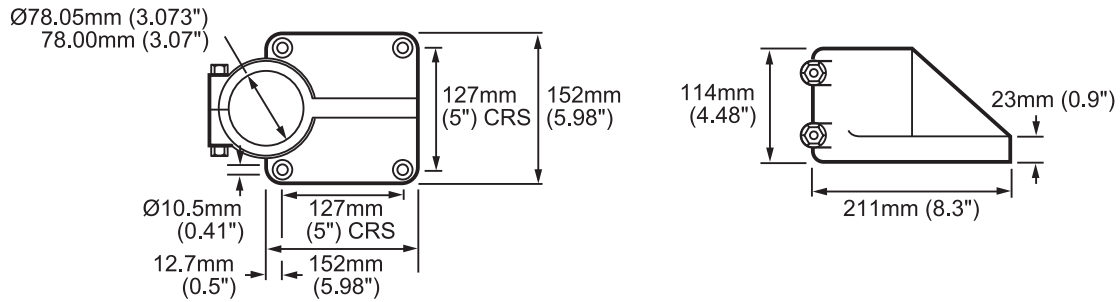
### ACCESSORIES

|  | PART NO. |
|--|----------|
| • Parallel clamp   | 76352    |
| • Right Angle clamp  | 76342    |
| • Swivel clamp   | 76332    |
| • Bar clamp  | 76272    |
| • Base clamp   | 76302    |
| • Adjustable bar Clamp   | 97042    |
| • Narrow bar Clamp   | 76292    |
| • Mounting Tube 305 (12 length, Ø 56.5-56.71 (2.225"-2.233"))  | 9462     |
| • Mounting Tube 457 (18" length, Ø 56.5-56.71 (2.225"-2.233")) | 9472     |
| • Mounting Tube 610 (24" length, Ø 56.5-56.71 (2.225"-2.233")) | 9482     |
| • Mounting Tube 760 (30" length, Ø 56.5-56.71 (2.225"-2.233")) | 9492     |

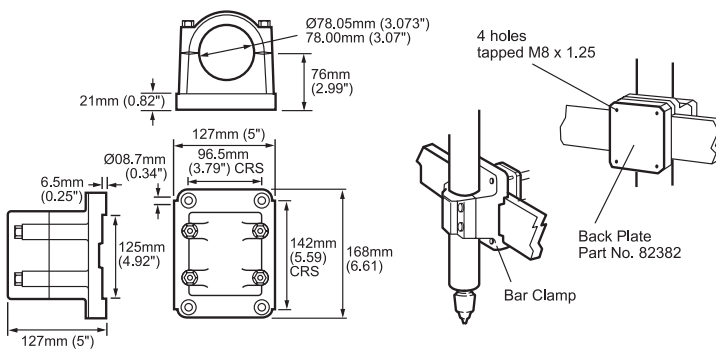
# Clamps

AFDE610/640 - AFD625 ■

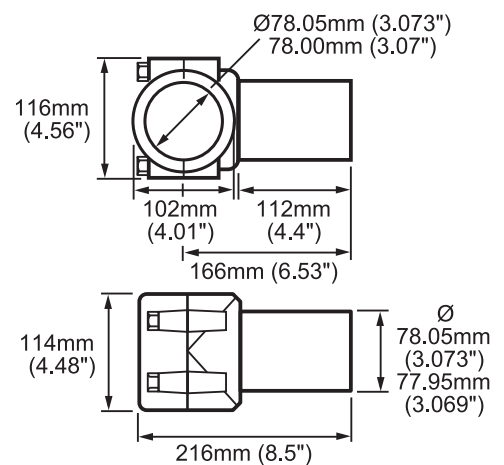
## Base Clamp



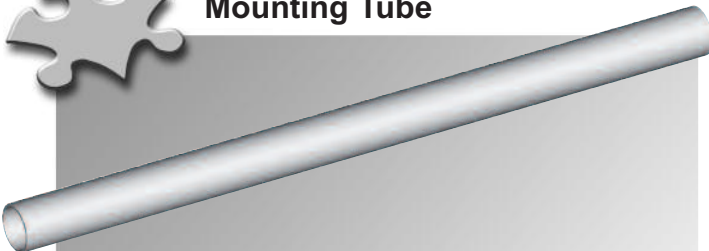
## Bar Clamp



## Swivel Clamp



## Mounting Tube



Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

## AFDE610/640 - AFD625

### ACCESSORIES

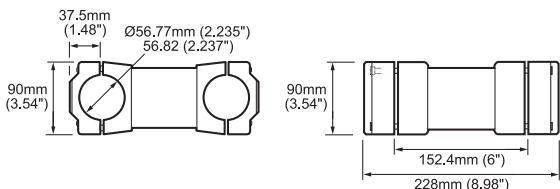
### PART NO.

|   |       |
|---|-------|
| • Base clamp                                    | 32542 |
| • Bar clamp                                     | 32532 |
| • Swivel clamp                                  | 32502 |
| • Mounting Tube 610 (24") length, Ø 78 (3.069") | 32562 |
| • Mounting Tube 915 (36") length, Ø 78 (3.069") | 32572 |

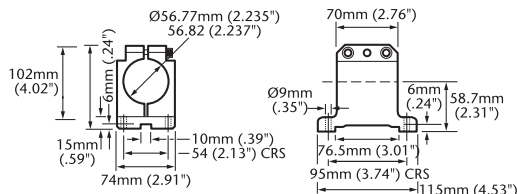
# Clamps

## AFTE480

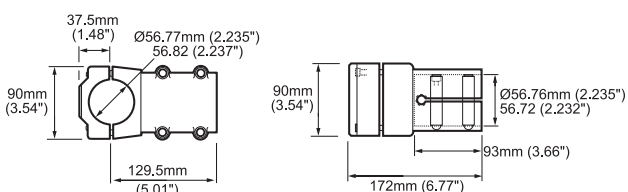
### Parallel Clamp



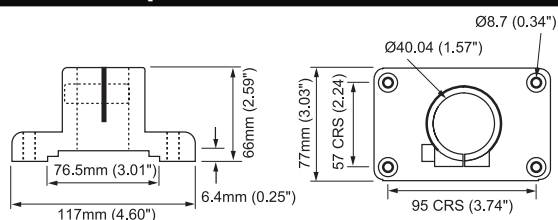
### Narrow Bar Clamp



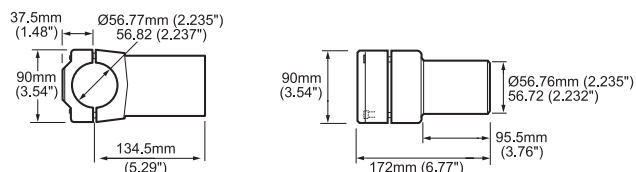
### Right Angle Clamp



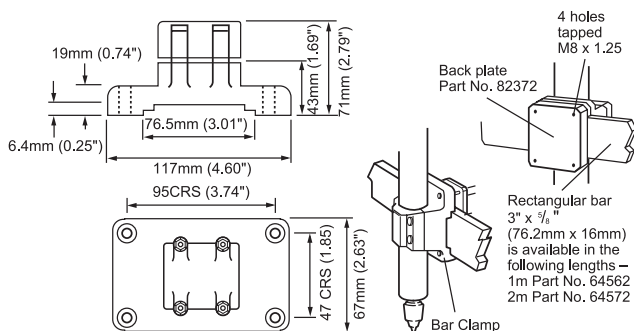
### Base Clamp



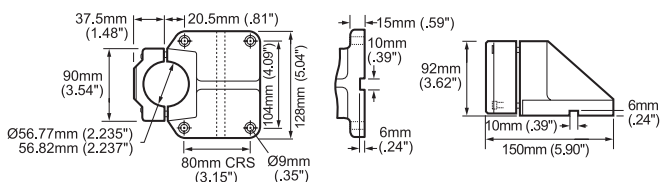
### Swivel Clamp



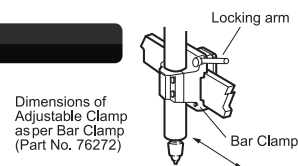
### Bar Clamp



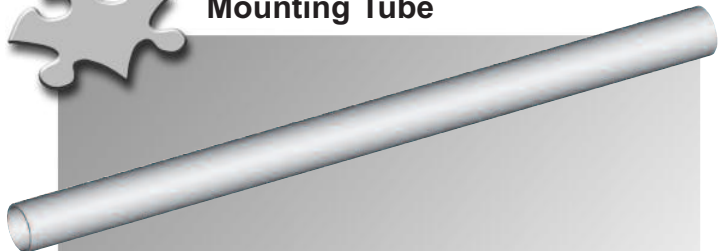
### Base Clamp



### Adjustable Bar Clamp



### Mounting Tube



Tubing is of the same outside diameter as the auto feed unit and is available in the following standard lengths.

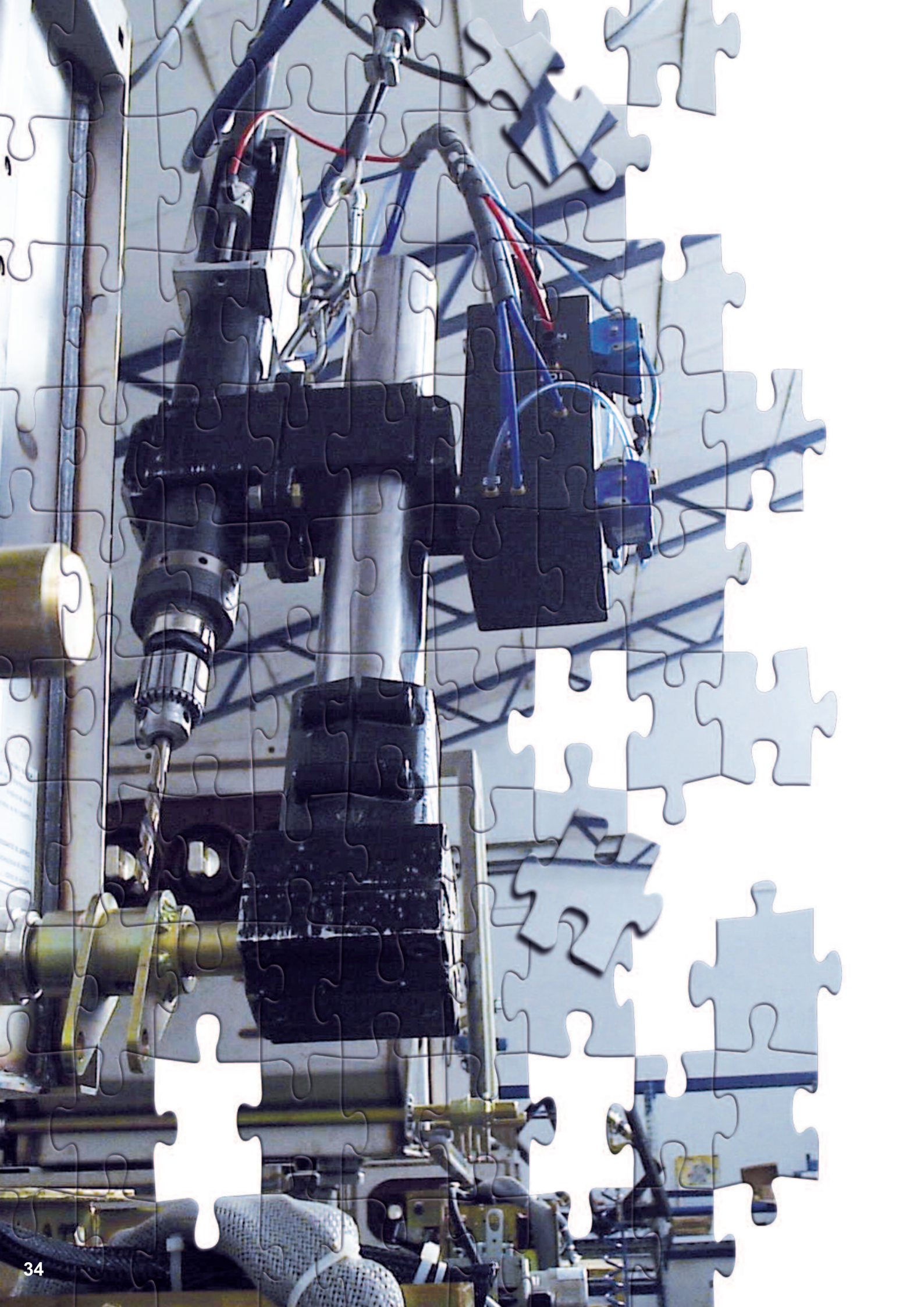
## AFTE480

### ACCESSORIES

|  | PART NO. |
|--|----------|
| • Parallel clamp   | 76352    |
| • Right Angle clamp  | 76342    |
| • Swivel clamp   | 76332    |
| • Bar clamp  | 76272    |
| • Base clamp   | 76302    |
| • Adjustable Bar Clamp   | 97042    |
| • Narrow bar Clamp   | 76292    |
| • Mounting Tube 305 (12 length, Ø 56.5-56.71 (2.225"-2.233"))  | 9462     |
| • Mounting Tube 457 (18" length, Ø 56.5-56.71 (2.225"-2.233")) | 9472     |
| • Mounting Tube 610 (24" length, Ø 56.5-56.71 (2.225"-2.233")) | 9482     |
| • Mounting Tube 760 (30" length, Ø 56.5-56.71 (2.225"-2.233")) | 9492     |







# AFD Selection Program

The Desoutter AFD selection program allows you to select Auto Feed Drills or Tappers for applications where the following parameters are available:

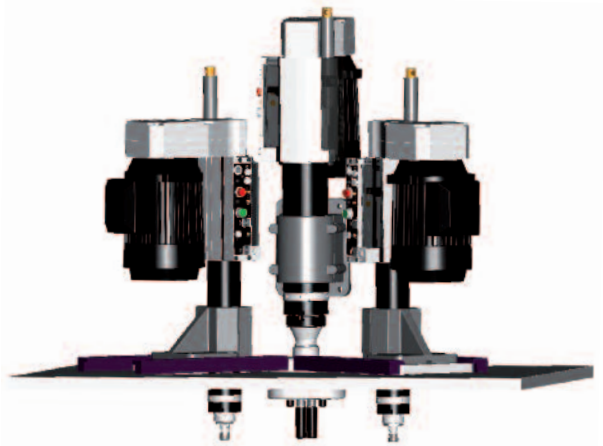
- Hole diameter or thread size
- Hole or thread depth
- Thread pitch (tapping only)
- Number of holes
- Material to be drilled or tapped
- Blind or through hole (tapping only)

For further details please contact your local Desoutter representative.

The screenshot displays the Desoutter AFD Selection Program software. The top window shows a 'DRILL' selection table with columns for material, hole size, and tool type. The bottom window shows a detailed 'Calculated Parameters and Thread Dimensions' section with various input fields and output tables for drilling and tapping.



CAD drawing files for the Desoutter Auto Feed Drills and Tappers are available on [www.desouttertools.com/cadfiles](http://www.desouttertools.com/cadfiles)



For more information about Desoutter tools, please ask for the Desoutter catalogue 2050484013 or visit [www.desouttertools.com](http://www.desouttertools.com) and look in the Industrial Tools on line catalogue

# More Than Productivity



[www.desouttertools.com](http://www.desouttertools.com)

English LT1212  
© Copyright 2010  
Printed in Europe - January 2010 - Issue 1