



## 1.1 Product Range

# The Ultimate Power Tools

# Introduction



The international CP group, founded in 1901, continues to be a world leader in power tool technology.

Since 1960, CP have been providing machine builders with Automatic Feed Drills (AFD) for low cost, special purpose machine tools.

During this period production engineers have successfully introduced AFD's into their machining processes to reduce cycle times and increase productivity.

The flexibility of a unique modular design enables the user to easily adapt

existing equipment to perform a new operation.

By combining the benefits of long experience and a highly innovative approach to product design, Desoutter determine the trends others follow.

## What is an AFD?



The CP range of Auto Feed Drills and Tappers are fixture mounted tools combining linear feed and rotation for machining and tapping operations.

There are 3 basic model types:

AFD/AFT– Pneumatic Feed and Drive

AFDE – Pneumatic Feed with Electric Drive

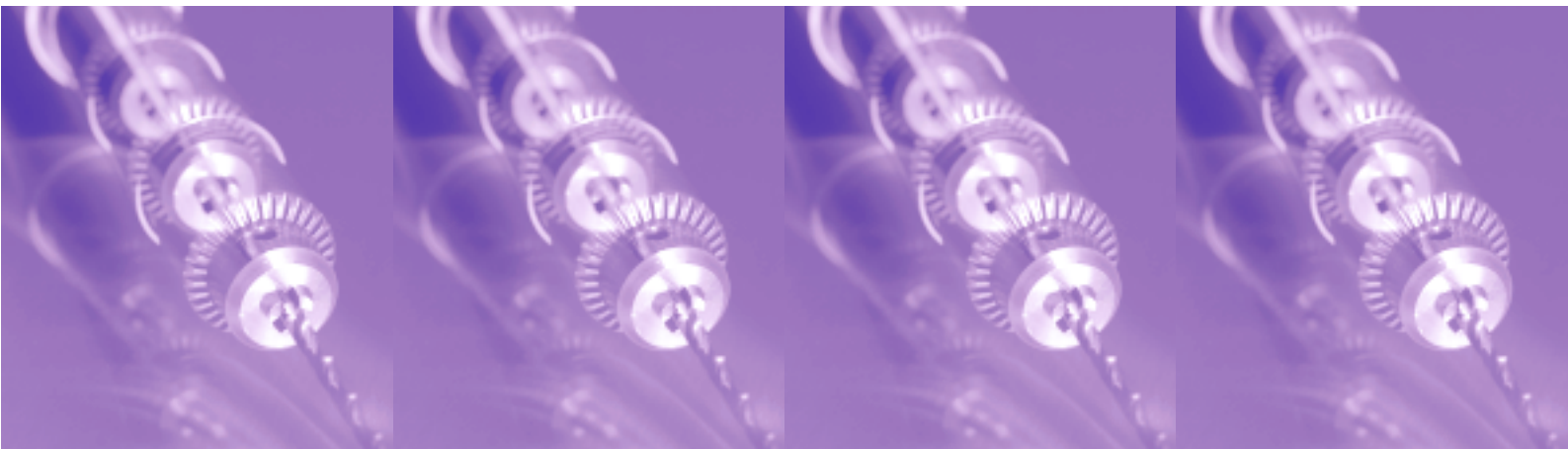
AFTE – Electric Drive and Feed via a Leadscrew

A wide range of accessories allow the tools to be configured to suit the application and include mounting clamps, output spindles, multiple spindle heads and various control options for interfacing with PLC's or pneumatics.

# Contents

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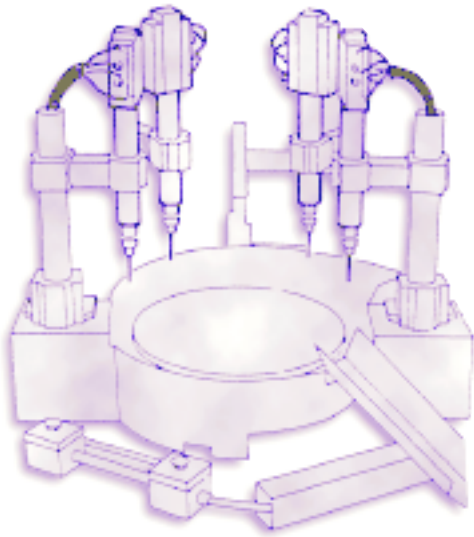
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| 5  | Model Codes and How to Order   |
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## General Information

- All performance data is obtained at a line pressure of  $6.3 \pm 0.15$  bar in accordance with ISO2787 (1984).
- All speeds are nominal.
- Performance data is subject to alteration without prior notice.
- Unless stated otherwise dimensions are in mm.
- All imperial dimensions and performance data have been calculated from the measured metric values.
- Sound levels are  $\pm 3\text{dB(A)}$  measured using EN ISO15744 test code.
- Before using an AFD always refer to the operating and warning instructions supplied with the tool.
- For optimum efficiency and minimum maintenance for AFD it is recommended that a Desoutter filter, regulator, lubricator is fitted to the airline. Further details can be obtained from your local Desoutter representative.
- For AFD models maximum power is achieved at 50% of no load speed.

# AFD Applications

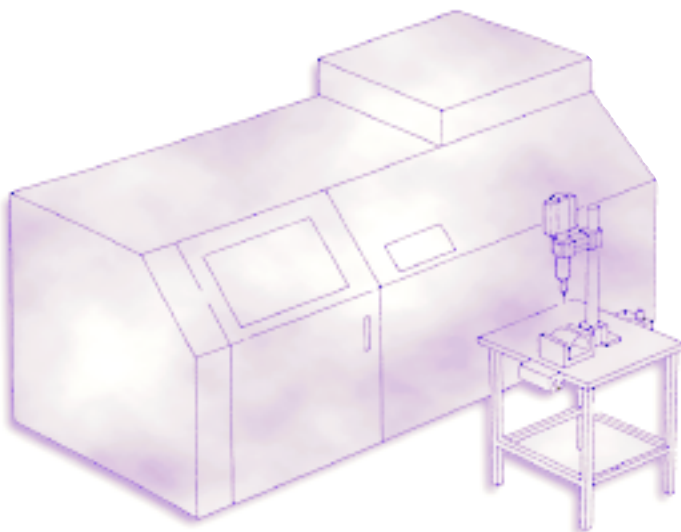
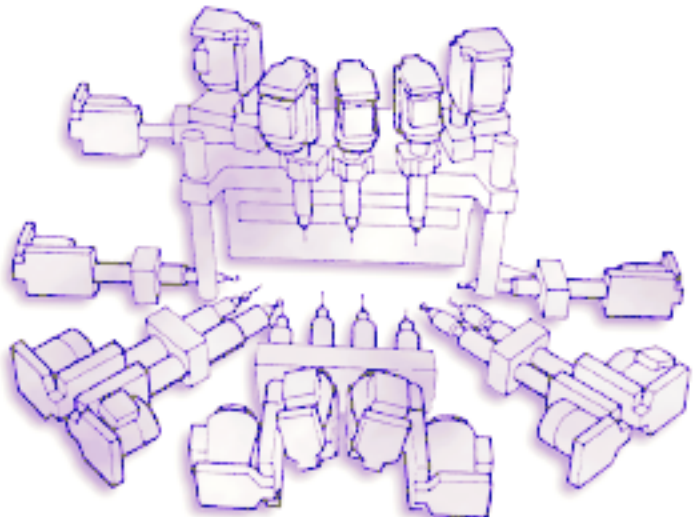


## Ease of Incorporation into Machine or Process

- 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 through 180°

## Modular Design

- Flexibility of unit function and speed
- Common components in differing models reducing inventory
- Multiple spindle head options
- Drill and tapping options for all models



## Comprehensive range of Product

- For single spindle operations to multi spindle processes
- Pneumatic and electric drive from 0.22 to 2.2kW (0.3-3.0HP) with thrusts from 320 to 1557N (72-350lbf)
- Reliability through quality

# Model Codes and How to Order

**Model Type – Pages 6-21**

**Pneumatic Feed and Drive**

|        |                 |
|--------|-----------------|
| AFD205 | 0.22kW (0.29HP) |
| AFD215 | 0.22kW (0.29HP) |
| AFD415 | 0.38kW (0.50HP) |

**Pneumatic Feed, Electric Drive**

|         |                 |
|---------|-----------------|
| AFDE200 | 0.25kW (0.33HP) |
| AFDE400 | 0.33kW (0.40HP) |
| AFDE410 | 0.75kW (1.00HP) |
| AFDE610 | 0.75kW (1.00HP) |

**Electric Feed and Drive via Leadscrew**

|         |                 |
|---------|-----------------|
| AFTE480 | 0.75kW (1.00HP) |
|---------|-----------------|

**No Load Speed – Pages 6-21**

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

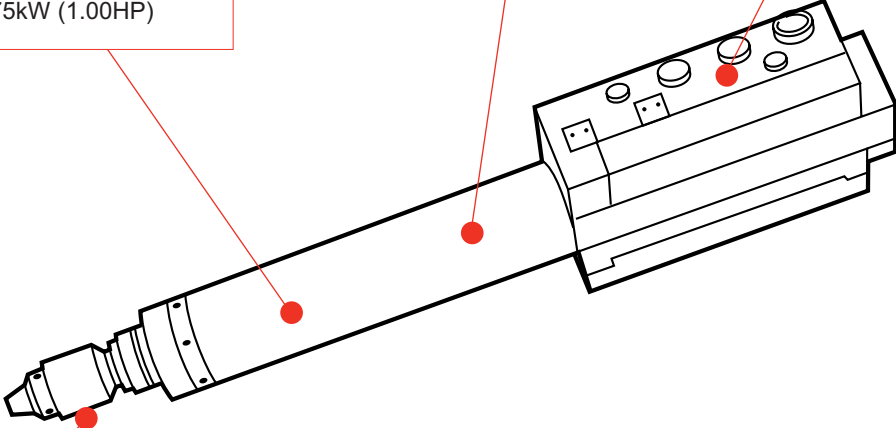
**Control Block – Page 22**

A1 – Full feature type<sup>(1)</sup> – Automatic cycle

A6 – Simple type<sup>(1)(2)</sup> – Remote cycle control

A7 – Leadscrew type – PNP

A8 – Leadscrew type – NPN



The diagram shows a side view of a drill or tapping tool. Four red dots are placed along the tool's length, with lines pointing to their respective descriptions in the surrounding text boxes: the front tip points to 'Output Spindle', the main body points to 'Model Type', the rear section points to 'No Load Speed', and the control block at the back points to 'Control Block'.

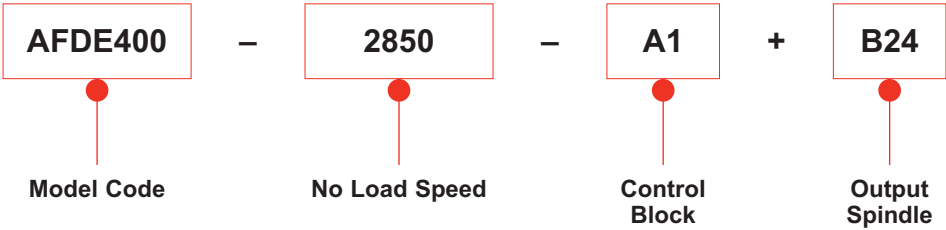
**Output Spindle<sup>(2)</sup> – Pages 24**

Output spindle to be supplied.

<sup>(1)</sup> Not required on AFTE models.

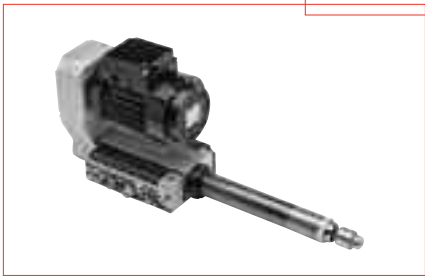
<sup>(2)</sup> Does not apply for AFD60 and AFT60.

## How to Order



# Drilling Electric Drive

AFDE200 electric drive

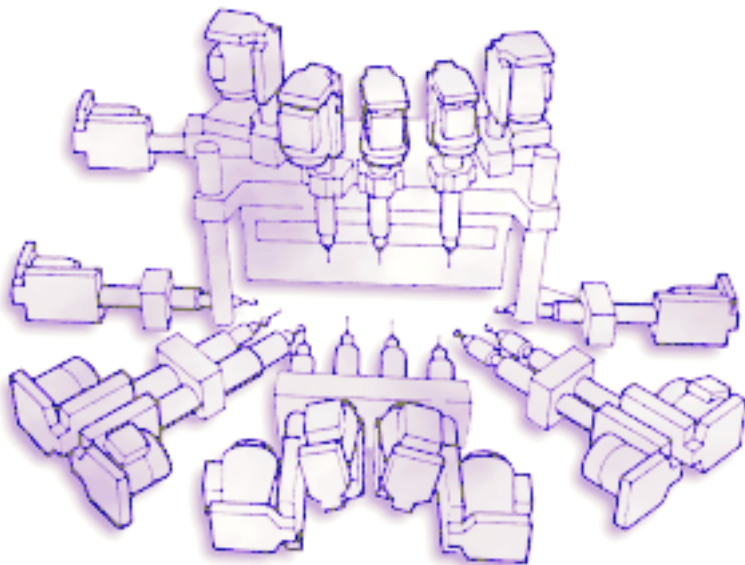


- Compact unit size
- High speed options up to 22400 rpm @ 50Hz, 26900 rpm @ 60Hz with K42 output
- Capacity up to 5mm (3/16") in aluminium
- Modular output spindles

## AFDE200

drilling performance **specification**

| TOOL TYPE     | SPEED |       | POWER       |      | CURRENT |      | THRUST         |     | STROKE         |     | WEIGHT |      | AIR CONSUMPTION |       | SOUND LEVEL |
|---------------|-------|-------|-------------|------|---------|------|----------------|-----|----------------|-----|--------|------|-----------------|-------|-------------|
|               | rpm   |       | kW          | HP   | Amps    |      | N              | lbf | mm             | ins | kg     | lb   | l/s²            | cfm   |             |
| model code    | 50Hz  | 60Hz  | motor power |      | 50Hz    | 60Hz | dynamic thrust |     | working stroke |     | weight |      | per cycle       |       |             |
| AFDE200-850   | 850   | 1020  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-1200  | 1200  | 1450  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-2350  | 2350  | 2820  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-2850  | 2850  | 3400  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-3750  | 3750  | 4500  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-4600  | 4600  | 5450  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-5250  | 5250  | 6300  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-8000  | 8000  | 9600  | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |
| AFDE200-10000 | 10000 | 11950 | 0.25        | 0.34 | 0.75    | 0.75 | 320            | 72  | 90             | 3.5 | 10.1   | 22.2 | <0.32           | <0.02 | <70         |

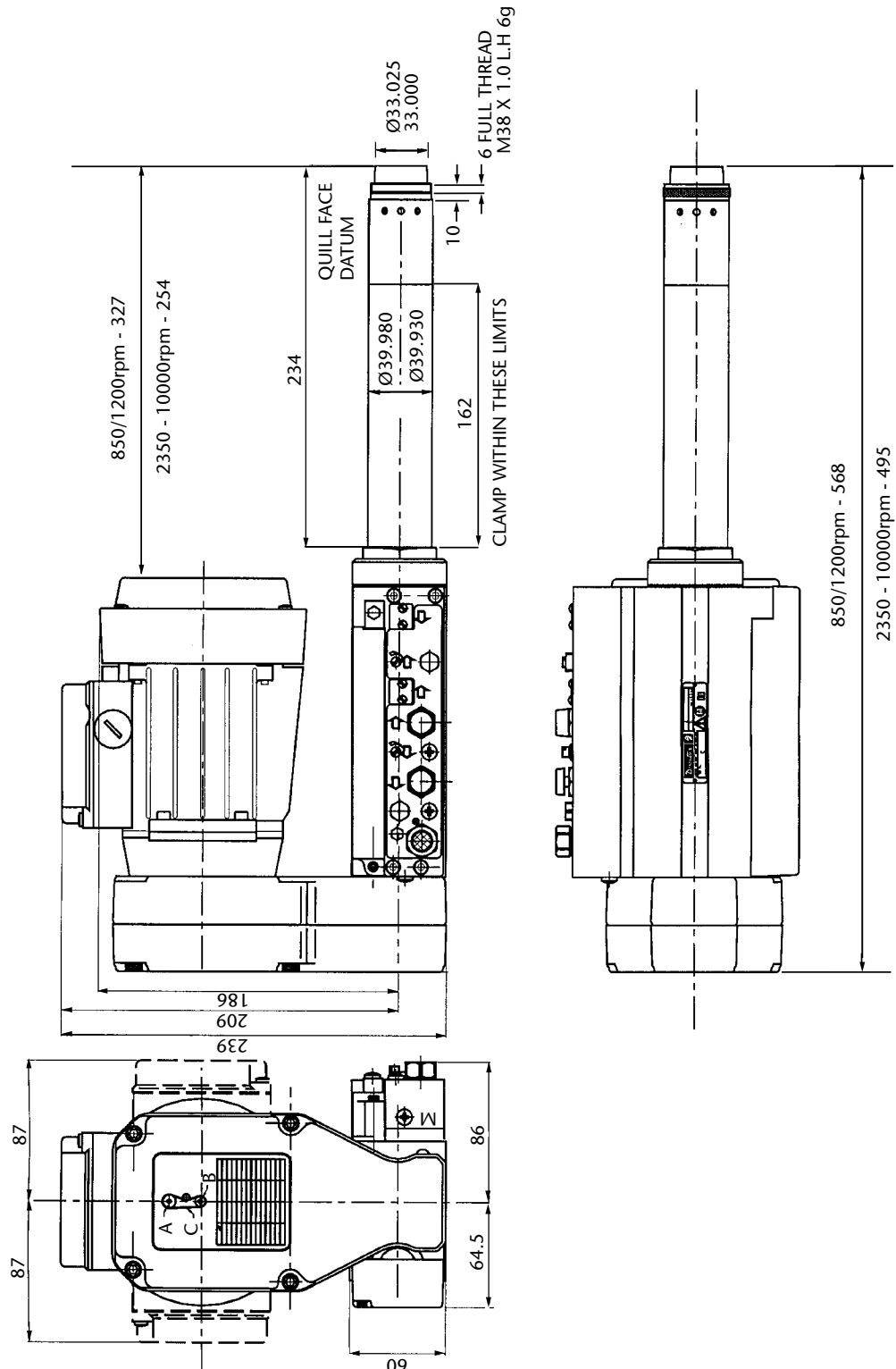


# Drilling Electric Drive

## AFDE200 accessories

| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Control Blocks         | 22   |
| Output Spindles        | 24   |
| Multiple Spindle Heads | 27   |
| Clamps                 | 30   |

### AFDE200 electric drive



# Drilling Electric Drive

## AFDE400/AFDE410 electric drive



- Comprehensive speed range 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 or 8mm (5/16") in mild steel
- Spindle sealed to IP64 standard
- Modular output spindles

## AFDE400

drilling performance **specification**

| TOOL TYPE     | SPEED |       | POWER       |      | CURRENT |      | THRUST         |     | STROKE         |      | WEIGHT |      | AIR CONSUMPTION  |       | SOUND LEVEL |
|---------------|-------|-------|-------------|------|---------|------|----------------|-----|----------------|------|--------|------|------------------|-------|-------------|
|               | rpm   |       | kW          | HP   | Amps    |      | N              | lbf | mm             | ins  | kg     | lb   | l/s <sup>2</sup> | cfm   | dB(A)       |
| model code    | 50Hz  | 60Hz  | motor power |      | 50Hz    | 60Hz | dynamic thrust |     | working stroke |      | weight |      | per cycle        |       |             |
| AFDE400-330   | 330   | 400   | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-550   | 550   | 660   | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-900   | 900   | 1100  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-1200  | 1200  | 1450  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-1450  | 1450  | 1740  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-1750  | 1750  | 2100  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-2350  | 2350  | 2820  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-2850  | 2850  | 3400  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-3750  | 3750  | 4500  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-4600  | 4600  | 5450  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-5250  | 5250  | 6300  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-8000  | 8000  | 9600  | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |
| AFDE400-10000 | 10000 | 11950 | 0.33        | 0.44 | 0.95    | 0.95 | 724            | 163 | 100            | 3.94 | 11.4   | 25.1 | <1               | <0.04 | <70         |

## AFDE410

drilling performance **specification**

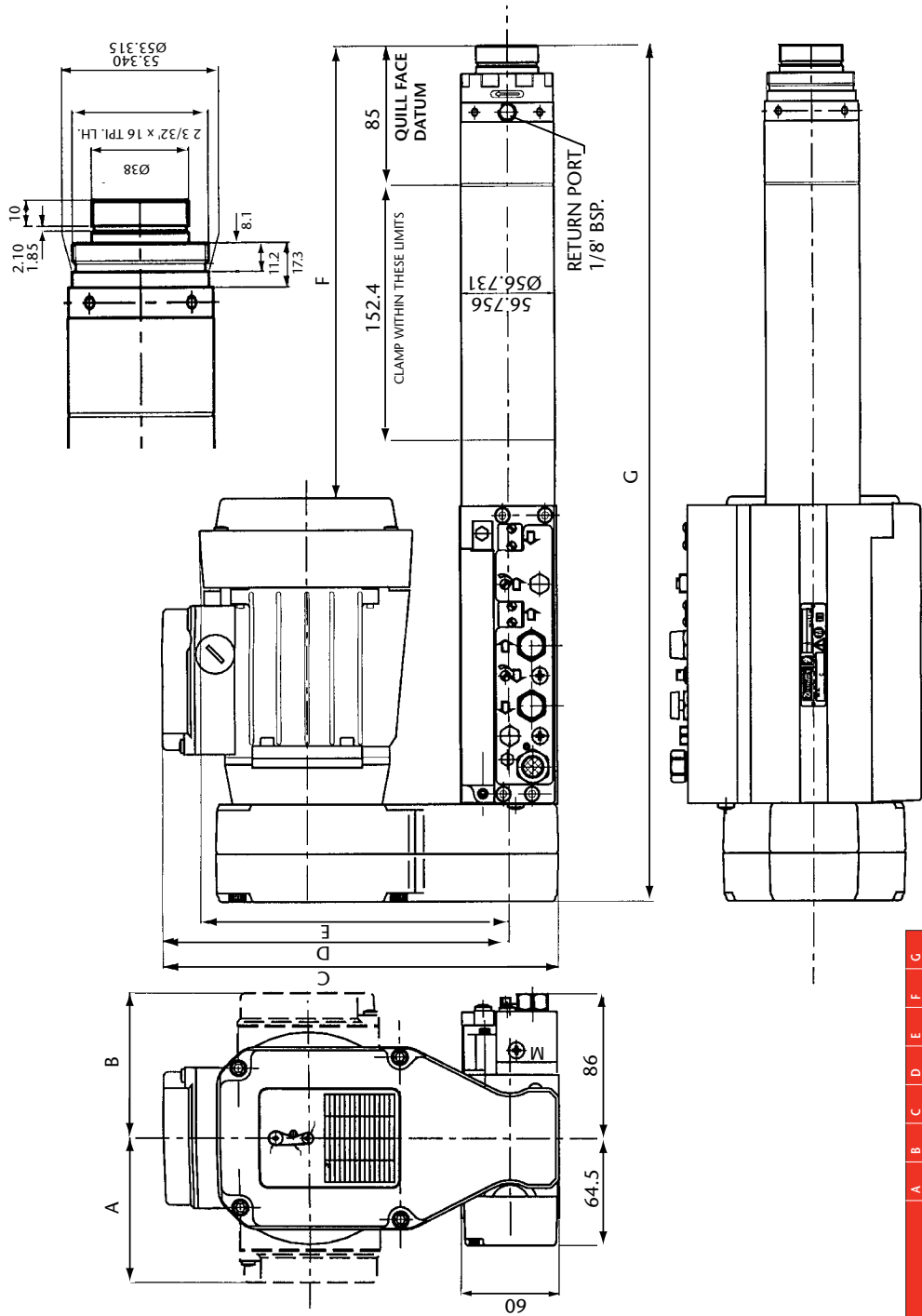
| TOOL TYPE    | SPEED |      | POWER       |      | CURRENT |      | THRUST         |     | STROKE         |      | WEIGHT |      | AIR CONSUMPTION  |       | SOUND LEVEL |
|--------------|-------|------|-------------|------|---------|------|----------------|-----|----------------|------|--------|------|------------------|-------|-------------|
|              | rpm   |      | kW          | HP   | Amps    |      | N              | lbf | mm             | ins  | kg     | lb   | l/s <sup>2</sup> | cfm   | dB(A)       |
| model code   | 50Hz  | 60Hz | motor power |      | 50Hz    | 60Hz | dynamic thrust |     | working stroke |      | weight |      | per cycle        |       |             |
| AFDE410-330  | 330   | 400  | 0.75        | 1.00 | 1.9     | 1.9  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-550  | 550   | 660  | 0.75        | 1.00 | 1.9     | 1.9  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-900  | 900   | 1100 | 0.75        | 1.00 | 1.9     | 1.9  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-1200 | 1200  | 1450 | 0.75        | 1.00 | 1.9     | 1.9  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-1450 | 1450  | 1740 | 0.75        | 1.00 | 1.9     | 1.9  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-1750 | 1750  | 2100 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-2350 | 2350  | 2820 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-2850 | 2850  | 3400 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-3750 | 3750  | 4500 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-4600 | 4600  | 5450 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-5250 | 5250  | 6300 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |
| AFDE410-8000 | 8000  | 9600 | 0.75        | 1.00 | 2.0     | 2.0  | 724            | 163 | 100            | 3.94 | 12.4   | 27.3 | <1               | <0.04 | <70         |

# Drilling Electric Drive

## AFDE400/AFDE410 accessories

| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Control Blocks         | 22   |
| Output Spindles        | 24   |
| Multiple Spindle Heads | 27   |
| Clamps                 | 30   |

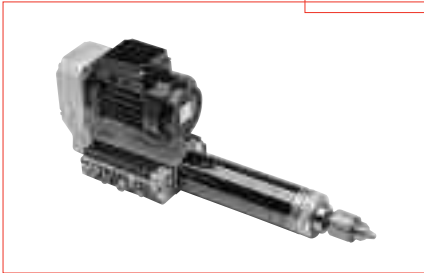
AFDE400/AFDE410 electric drive



| TOOL TYPE             | A   | B   | C   | D   | E   | F   | G   |
|-----------------------|-----|-----|-----|-----|-----|-----|-----|
| AFDE400-330/550       | 102 | 102 | 254 | 224 | 192 | 318 | 585 |
| AFDE400-900/1200/1450 | 102 | 102 | 254 | 224 | 192 | 245 | 512 |
| AFDE400-1750-10000    | 87  | 87  | 239 | 209 | 186 | 271 | 512 |
| AFDE410-330/550       | 112 | 112 | 264 | 234 | 201 | 295 | 585 |
| AFDE410-900/1200/1450 | 112 | 112 | 264 | 234 | 201 | 222 | 512 |
| AFDE410-1750-8000     | 102 | 102 | 254 | 224 | 192 | 245 | 512 |

# Drilling Electric Drive

**AFDE610**  
electric drive

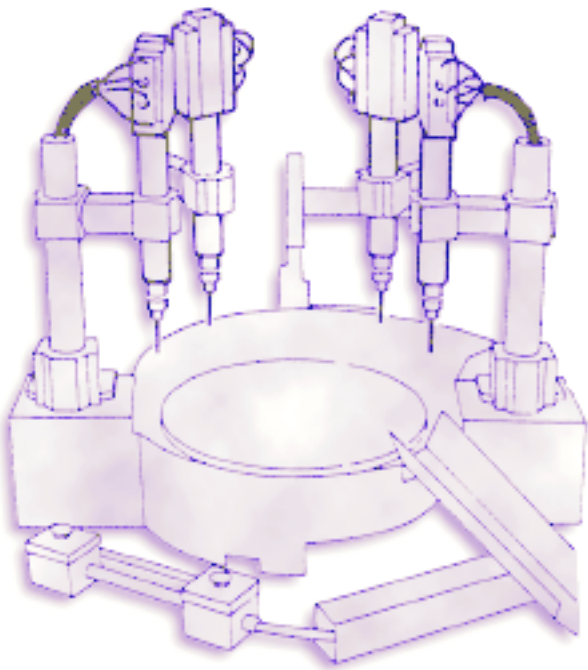


- Heavy duty belts and pulley drive with integral belt tensioner
- Capacity up to 12mm (1/2") in mild steel
- Spindle sealed to IP64 standard
- Modular output spindles

## AFDE610

drilling performance **specification**

| TOOL TYPE    | SPEED |      | POWER       |      | CURRENT |      | THRUST         |     | STROKE         |      | WEIGHT |      | AIR CONSUMPTION  |       | SOUND LEVEL |
|--------------|-------|------|-------------|------|---------|------|----------------|-----|----------------|------|--------|------|------------------|-------|-------------|
|              | rpm   |      | kW          | HP   | Amps    |      | N              | lbf | mm             | ins  | kg     | lb   | l/s <sup>2</sup> | cfm   | dB(A)       |
| model code   | 50Hz  | 60Hz | motor power |      | 50Hz    | 60Hz | dynamic thrust |     | working stroke |      | weight |      | per cycle        |       |             |
| AFDE610-330  | 330   | 400  | 0.75        | 1.00 | 1.9     | 1.9  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-550  | 550   | 660  | 0.75        | 1.00 | 1.9     | 1.9  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-900  | 900   | 1100 | 0.75        | 1.00 | 1.9     | 1.9  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-1200 | 1200  | 1450 | 0.75        | 1.00 | 1.9     | 1.9  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-1450 | 1450  | 1740 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-1750 | 1750  | 2100 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-2350 | 2350  | 2820 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-2850 | 2850  | 3400 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-3750 | 3750  | 4500 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-4600 | 4600  | 5450 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |
| AFDE610-5250 | 5250  | 6300 | 0.75        | 1.00 | 2.0     | 2.0  | 1557           | 350 | 100            | 3.94 | 18.4   | 40.5 | <2.5             | <0.09 | <70         |

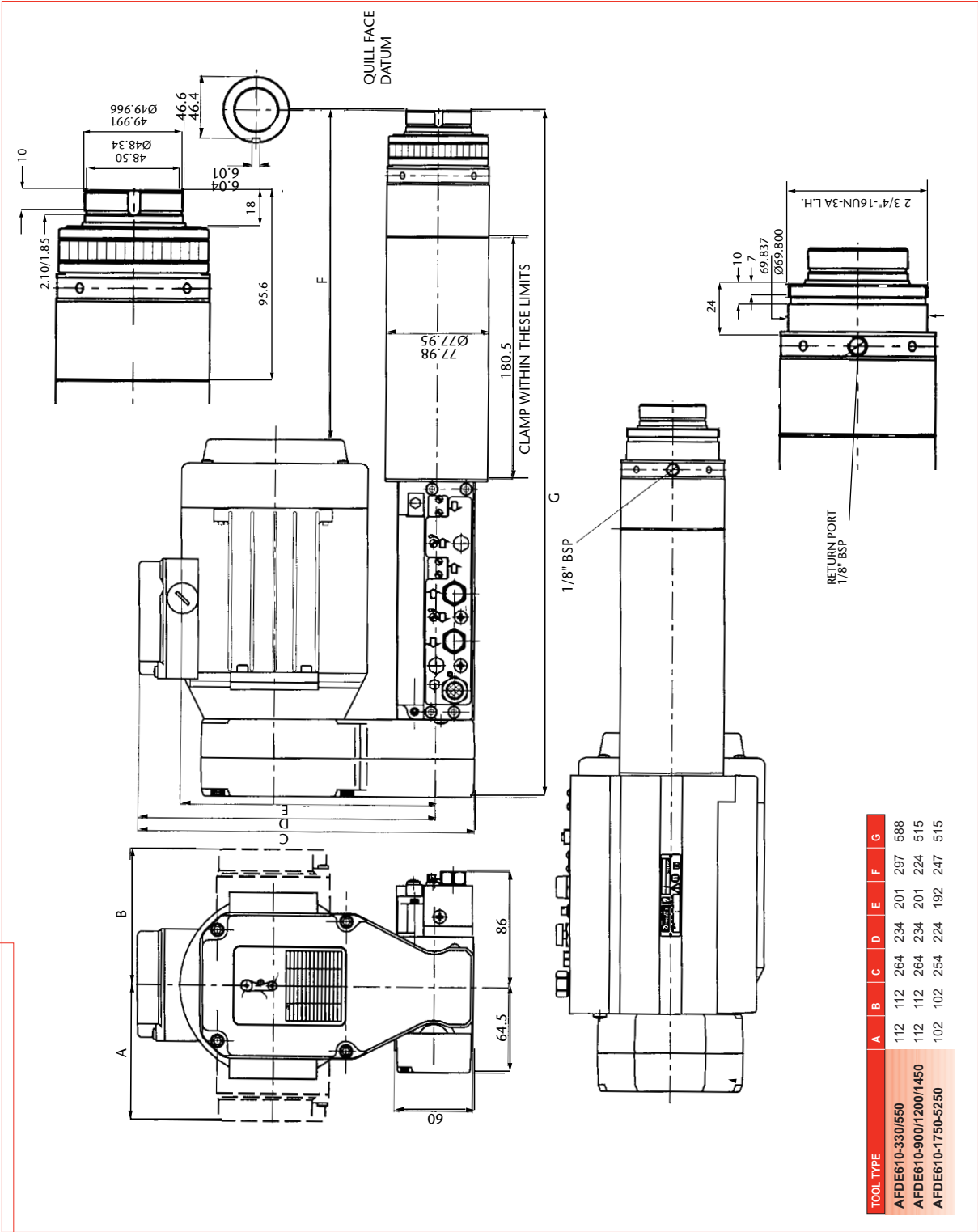


# Drilling Electric Drive

## AFDE610 accessories

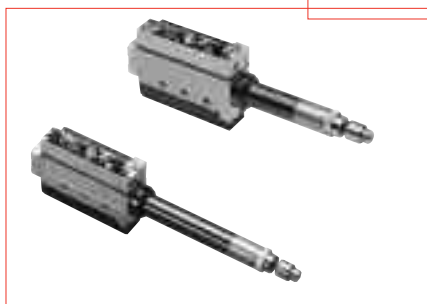
| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Control Blocks         | 22   |
| Output Spindles        | 24   |
| Multiple Spindle Heads | 27   |
| Clamps                 | 30   |

AFDE610 electric drive



# Drilling Pneumatic Drive

## AFD205/AFD215 pneumatic drive



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

## AFD205

drilling performance **specification**

| TOOL TYPE    | SPEED         |  | POWER       |      | THRUST         |     | STROKE         |      | WEIGHT |     | AIR CONSUMPTION    |     | SOUND LEVEL |
|--------------|---------------|--|-------------|------|----------------|-----|----------------|------|--------|-----|--------------------|-----|-------------|
|              | rpm           |  | kW          | HP   | N              | lbf | mm             | ins  | kg     | lb  | l/s <sup>2</sup>   | cfm | dB(A)       |
| model code   | no load speed |  | motor power |      | dynamic thrust |     | working stroke |      | weight |     | continuous running |     |             |
| AFD205-650   | 650           |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |
| AFD205-1000  | 1000          |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |
| AFD205-2700  | 2700          |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |
| AFD205-4350  | 4350          |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |
| AFD205-10000 | 10000         |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |
| AFD205-18700 | 18700         |  | 0.22        | 0.30 | 400            | 90  | 50             | 1.97 | 3.9    | 8.6 | 9.5                | 20  | 75          |

## AFD215

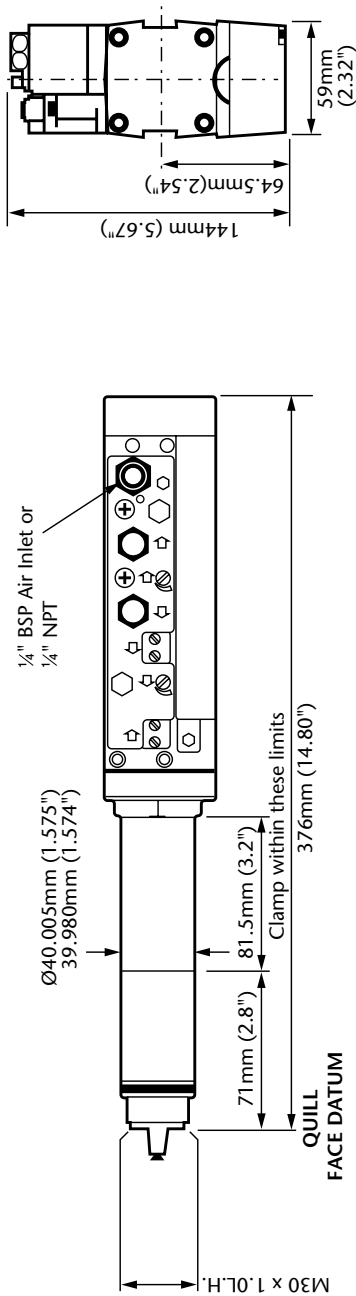
drilling performance **specification**

| TOOL TYPE    | SPEED         |  | POWER       |      | THRUST         |     | STROKE         |      | WEIGHT |     | AIR CONSUMPTION    |     | SOUND LEVEL |
|--------------|---------------|--|-------------|------|----------------|-----|----------------|------|--------|-----|--------------------|-----|-------------|
|              | rpm           |  | kW          | HP   | N              | lbf | mm             | ins  | kg     | lb  | l/s <sup>2</sup>   | cfm | dB(A)       |
| model code   | no load speed |  | motor power |      | dynamic thrust |     | working stroke |      | weight |     | continuous running |     |             |
| AFD215-650   | 650           |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |
| AFD215-1000  | 1000          |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |
| AFD215-2700  | 2700          |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |
| AFD215-4350  | 4350          |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |
| AFD215-10000 | 10000         |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |
| AFD215-18700 | 18700         |  | 0.22        | 0.30 | 400            | 90  | 90             | 3.54 | 4.2    | 9.2 | 9.5                | 20  | 75          |

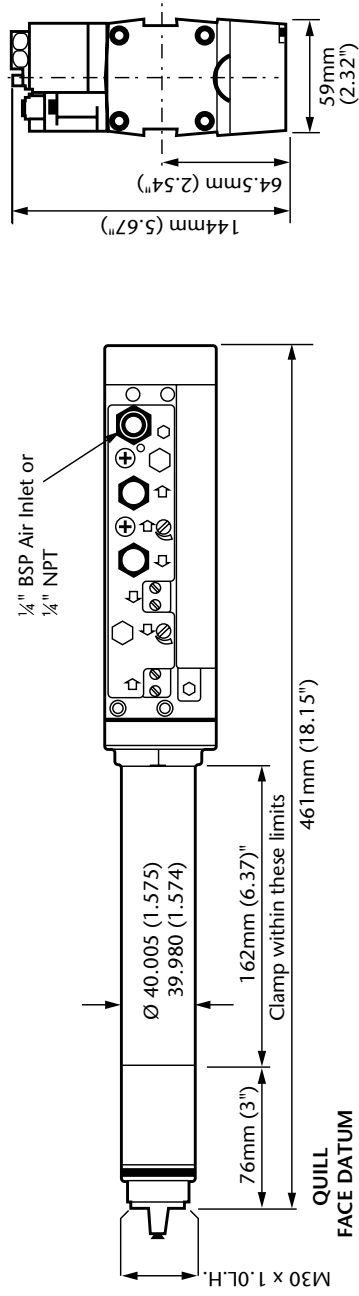
## AFD205/AFD215 accessories

| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Control Blocks         | 22   |
| Output Spindles        | 24   |
| Multiple Spindle Heads | 27   |
| Clamps                 | 30   |

## AFD205 pneumatic drive



**AFD215** pneumatic drive



**AFD205/AFD215** pneumatic drive

# Drilling Pneumatic Drive

AFD415 pneumatic drive

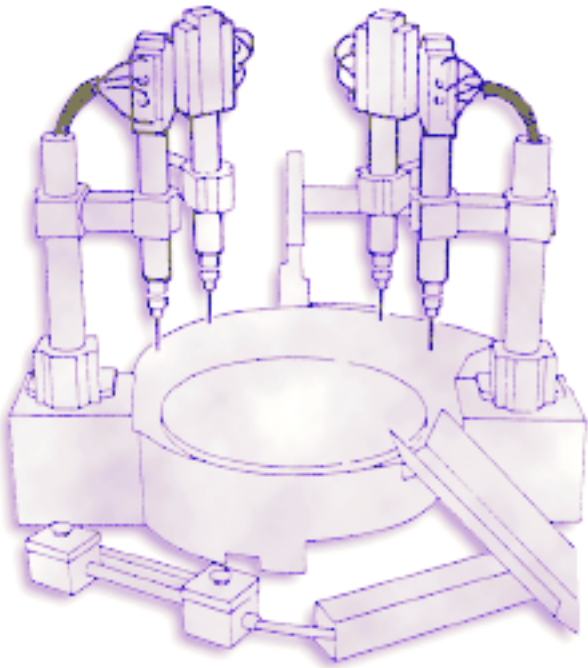


- Compact unit design
- Long working stroke of 100mm (3.94")
- Spindle sealed to IP64 standard
- Capacity up to 8mm (5/16") in mild steel, 10mm (3/8") in aluminium
- Modular output spindles

## AFD415

drilling performance **specification**

| TOOL TYPE    | SPEED         |  | POWER       |      | THRUST         |     | STROKE         |      | WEIGHT |      | AIR CONSUMPTION    |     | SOUND LEVEL |
|--------------|---------------|--|-------------|------|----------------|-----|----------------|------|--------|------|--------------------|-----|-------------|
|              | rpm           |  | kW          | HP   | N              | lbf | mm             | ins  | kg     | lb   | l/s <sup>2</sup>   | cfm | dB(A)       |
| model code   | no load speed |  | motor power |      | dynamic thrust |     | working stroke |      | weight |      | continuous running |     |             |
| AFD415-490   | 490           |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-790   | 790           |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-1250  | 1250          |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-2100  | 2100          |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-3400  | 3400          |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-5400  | 5400          |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-7000  | 7000          |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |
| AFD415-18000 | 18000         |  | 0.38        | 0.51 | 706            | 159 | 100            | 3.94 | 6.2    | 13.7 | 9.9                | 21  | 75          |

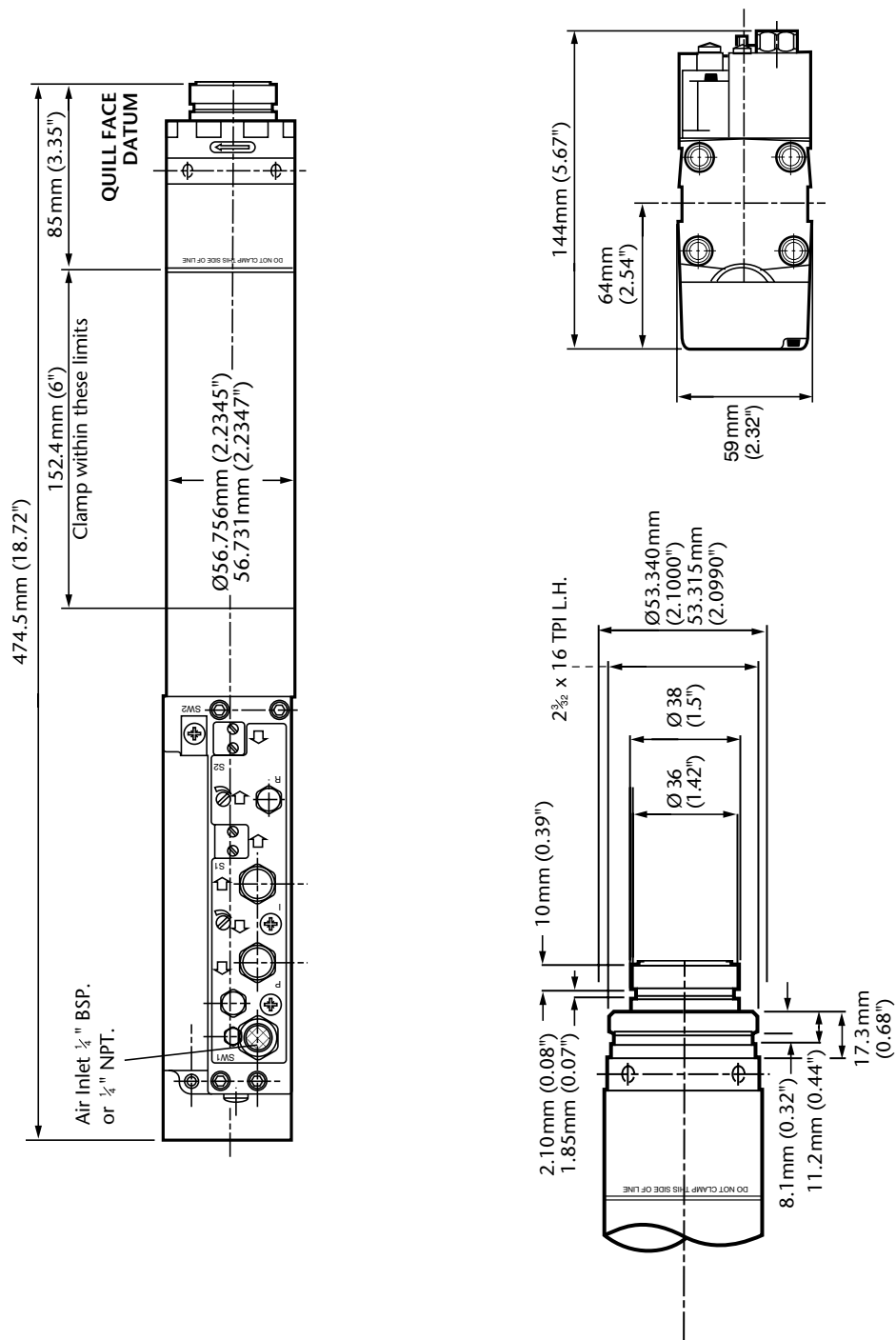


# Drilling Pneumatic Drive

## AFD415 accessories

| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Control Blocks         | 22   |
| Output Spindles        | 24   |
| Multiple Spindle Heads | 27   |
| Clamps                 | 30   |

AFD415 pneumatic drive



# Tapping Electric Drive

## AFDE tappers



- Comprehensive range of tapping tools
- Tapping gearboxes feature push-pull drive which automatically reverses when the tool returns
- Capacity up to 16mm (5/8") in aluminium, 10mm (3/8") in mild steel

## tapping electric drive with pneumatic feed – *push-pull*

tapping performance **specification**

| TOOL TYPE    | SPEED |      | POWER       |      | CURRENT |      | TORQUE                   |         | STROKE         |      | WEIGHT |      | AIR CONSUMPTION  |       | SOUND LEVEL |
|--------------|-------|------|-------------|------|---------|------|--------------------------|---------|----------------|------|--------|------|------------------|-------|-------------|
|              | rpm   |      | kW          | HP   | Amps    |      | Nm                       | lbf ins | mm             | ins  | kg     | lb   | l/s <sup>2</sup> | cfm   |             |
| model code   | 50Hz  | 60Hz | motor power |      | 50Hz    | 60Hz | tapping torque available |         | working stroke |      | weight |      | per cycle        |       |             |
| AFDE200-850  | 850   | 1020 | 0.25        | 0.34 | 0.75    | 0.75 | 2.4                      | 21.2    | 90             | 3.5  | 11.1   | 24.4 | <0.32            | <0.02 | <70         |
| AFDE200-1200 | 1200  | 1450 | 0.25        | 0.34 | 0.75    | 0.75 | 1.8                      | 15.9    | 90             | 3.5  | 11.1   | 24.4 | <0.32            | <0.02 | <70         |
| AFDE400-330  | 330   | 400  | 0.33        | 0.44 | 0.95    | 0.95 | 8.6                      | 76.1    | 100            | 3.94 | 12.8   | 28.2 | <1               | <0.04 | <70         |
| AFDE400-550  | 550   | 660  | 0.33        | 0.44 | 0.95    | 0.95 | 5.2                      | 46.0    | 100            | 3.94 | 12.8   | 28.2 | <1               | <0.04 | <70         |
| AFDE400-900  | 900   | 1100 | 0.33        | 0.44 | 0.95    | 0.95 | 3.2                      | 28.3    | 100            | 3.94 | 12.8   | 28.2 | <1               | <0.04 | <70         |
| AFDE400-1200 | 1200  | 1450 | 0.33        | 0.44 | 0.95    | 0.95 | 2.4                      | 21.2    | 100            | 3.94 | 12.8   | 28.2 | <1               | <0.04 | <70         |
| AFDE410-330  | 330   | 400  | 0.75        | 1.00 | 1.9     | 1.9  | 19.6                     | 173.5   | 100            | 3.94 | 13.8   | 30.4 | <1               | <0.04 | <70         |
| AFDE410-550  | 550   | 660  | 0.75        | 1.00 | 1.9     | 1.9  | 11.8                     | 104.4   | 100            | 3.94 | 13.8   | 30.4 | <1               | <0.04 | <70         |
| AFDE410-900  | 900   | 1100 | 0.75        | 1.00 | 1.9     | 1.9  | 7.2                      | 63.7    | 100            | 3.94 | 13.8   | 30.4 | <1               | <0.04 | <70         |
| AFDE410-1200 | 1200  | 1450 | 0.75        | 1.00 | 1.9     | 1.9  | 5.4                      | 47.8    | 100            | 3.94 | 13.8   | 30.4 | <1               | <0.04 | <70         |
| AFDE610-330  | 330   | 400  | 0.75        | 1.00 | 1.9     | 1.9  | 19.6                     | 173.5   | 100            | 3.94 | 21.1   | 46.4 | <2.5             | <0.09 | <70         |
| AFDE610-550  | 550   | 660  | 0.75        | 1.00 | 1.9     | 1.9  | 11.8                     | 104.4   | 100            | 3.94 | 21.1   | 46.4 | <2.5             | <0.09 | <70         |
| AFDE610-900  | 900   | 1100 | 0.75        | 1.00 | 1.9     | 1.9  | 7.2                      | 63.7    | 100            | 3.94 | 21.1   | 46.4 | <2.5             | <0.09 | <70         |
| AFDE610-1200 | 1200  | 1450 | 0.75        | 1.00 | 1.9     | 1.9  | 5.4                      | 47.8    | 100            | 3.94 | 21.1   | 46.4 | <2.5             | <0.09 | <70         |

The following tools require suitable output spindles to fit a tapping head:

| TOOL TYPE | OUTPUT SPINDLE<br>(SEE PAGE 30) |
|-----------|---------------------------------|
| AFDE200   | K32                             |
| AFDE610   | B24                             |

### How to order

Examples:

AFDE200-850-A1 + K32 + 357193(H21)

AFDE400-550-A1 + B7

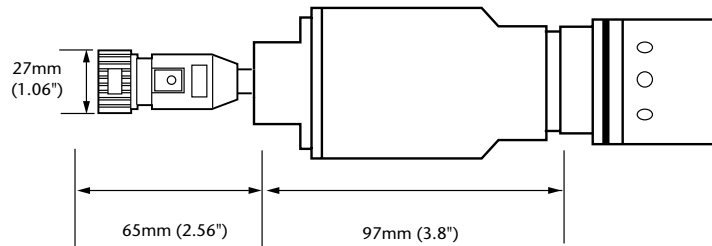
AFDE610-900-A1 + B24 + 383813(J19)

# Tapping Electric Drive

## AFDE tappers accessories

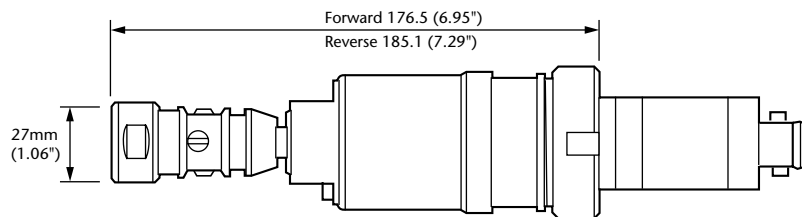
| ACCESSORIES RANGE      | PAGE  |
|------------------------|-------|
| Control Blocks         | 22    |
| Multiple Spindle Heads | 24    |
| Clamps                 | 30-33 |
| Collets                | 29    |

### AFDE200 electric drive



**H21 Tapping Gearbox**  
**Part No. 357193**  
Capacity 4.5-8mm  
(3/16"-5/16")  
Use with K32 output

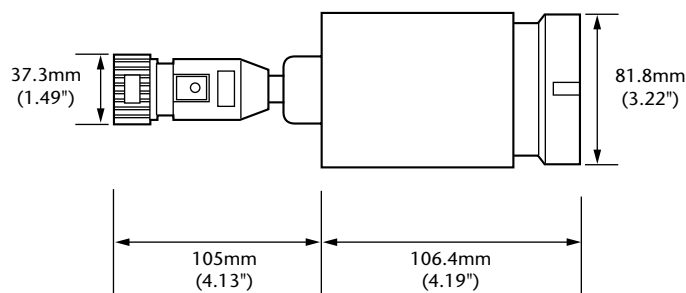
### AFDE400/410 electric drive



**B7 Tapping Gearbox**  
**Part No. 92362**  
Capacity 3.5-6.5mm  
(9/64"-1/4")

**B8 Tapping Gearbox**  
**Part No. 92892**  
Capacity 4.5-8mm  
(3/16"-5/16")

### AFDE610 electric drive



**J19 Tapping Gearbox**  
**Part No. 383813**  
Capacity 4.5-9.5mm  
(3/16"-3/8")  
Use with B24 output

# Tapping Pneumatic Drive

## AFD/AFT tappers



- Compact tapping units
- Tapping gearboxes feature push-pull drive which automatically reverses when the tool returns
- Capacity up to 12mm (1/2") in aluminium, 8mm (5/16") in mild steel

## tapping pneumatic drive and feed – *push-pull*

tapping performance **specification**

| TOOL TYPE   | SPEED   |                       | POWER       |      | TORQUE                   |         | STROKE         |      | WEIGHT |      | AIR CONSUMPTION  |     | SOUND LEVEL |
|-------------|---------|-----------------------|-------------|------|--------------------------|---------|----------------|------|--------|------|------------------|-----|-------------|
|             | rpm     |                       | kW          | HP   | Nm                       | lbf ins | mm             | ins  | kg     | lb   | l/s <sup>2</sup> | cfm |             |
| model code  | no load | load (75% of no load) | motor power |      | tapping torque available |         | working stroke |      | weight |      | per cycle        |     |             |
| AFD205-650  | 650     | 490                   | 0.22        | 0.30 | 4.3                      | 38.1    | 50             | 1.97 | 4.5    | 9.9  | 9.5              | 20  | 75          |
| AFD205-1000 | 1000    | 750                   | 0.22        | 0.30 | 2.8                      | 24.8    | 50             | 1.97 | 4.5    | 9.9  | 9.5              | 20  | 75          |
| AFD215-650  | 650     | 490                   | 0.22        | 0.30 | 4.3                      | 38.1    | 90             | 3.54 | 4.8    | 10.6 | 9.5              | 20  | 75          |
| AFD215-1000 | 1000    | 750                   | 0.22        | 0.30 | 2.8                      | 24.8    | 90             | 3.54 | 4.8    | 10.6 | 9.5              | 20  | 75          |
| AFD415-490  | 490     | 370                   | 0.38        | 0.51 | 9.9                      | 87.6    | 100            | 3.94 | 6.6    | 14.5 | 9.9              | 21  | 75          |
| AFD415-790  | 790     | 595                   | 0.38        | 0.51 | 6.1                      | 54.0    | 100            | 3.94 | 6.6    | 14.5 | 9.9              | 21  | 75          |
| AFD415-1250 | 1250    | 940                   | 0.38        | 0.51 | 3.9                      | 34.5    | 100            | 3.94 | 6.6    | 14.5 | 9.9              | 21  | 75          |

The following tools require suitable output spindles to fit a tapping head:

| TOOL TYPE | OUTPUT SPINDLE<br>(SEE PAGE 30) |
|-----------|---------------------------------|
| AFD205    | K32                             |
| AFD215    | K32                             |

### How to order

Examples:

AFD205-650-A1 + K32 + 357193(H21)

AFD215-1000-A6 + K32 + 357193(H21)

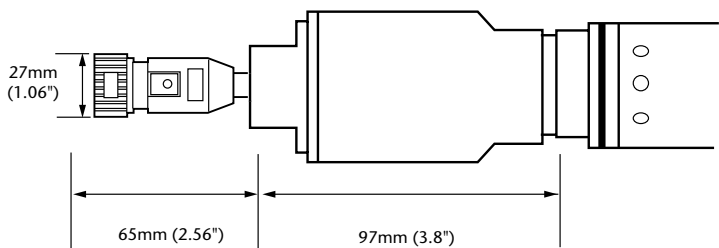
AFD415-790-A1 + B7

# Tapping Pneumatic Drive

## AFD tappers accessories

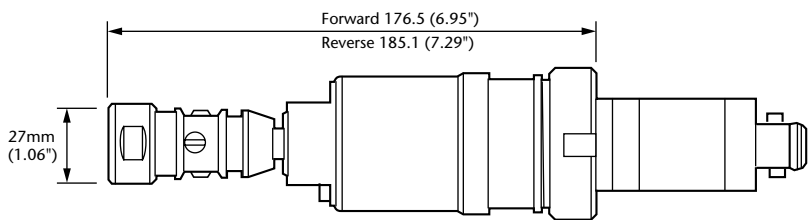
| ACCESSORIES RANGE      | PAGE  |
|------------------------|-------|
| Control Blocks         | 22    |
| Multiple Spindle Heads | 24    |
| Clamps                 | 30-33 |
| Collets                | 29    |

### AFD205/AFD215 pneumatic drive



**H21 Tapping Gearbox**  
**Part No. 357193**  
Capacity 4.5-8mm  
(3/16"-5/16")  
Use with K32 output

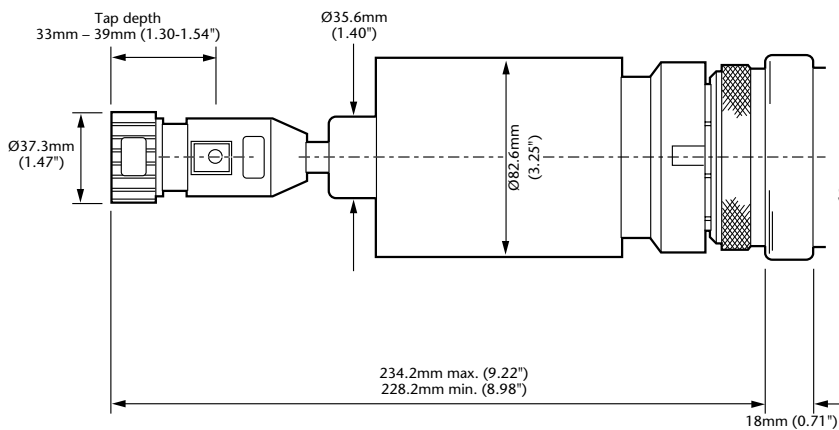
### AFD415 pneumatic drive



**B7 Tapping Gearbox**  
**Part No. 92362**  
Capacity 3.5-6.5mm  
(9/64"-1/4")

**B8 Tapping Gearbox**  
**Part No. 92892**  
Capacity 4.5-8mm  
(3/16"-5/16")

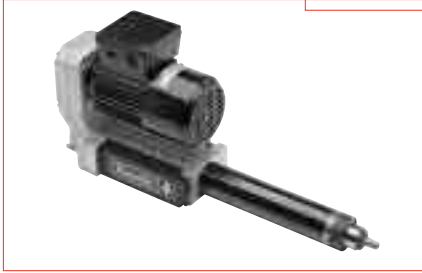
### AFT60 pneumatic drive



Supplied fitted to tool

# Tapping Leadscrew

## AFTE480 leadscrew



- High power brake motors with 0.75kW (1.00HP)
- 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

## AFTE480

tapping performance **specification**

| TOOL TYPE    | SPEED |      | POWER       |      | CURRENT |      | TORQUE                   |         | STROKE                  |      | WEIGHT |      | SOUND LEVEL |
|--------------|-------|------|-------------|------|---------|------|--------------------------|---------|-------------------------|------|--------|------|-------------|
|              | rpm   |      | kW          | HP   | Amps    |      | Nm                       | lbf ins | mm                      | ins  | kg     | lb   |             |
| model code   | 50Hz  | 60Hz | motor power |      | 50Hz    | 60Hz | tapping torque available |         | pitch controlled stroke |      | weight |      |             |
| AFTE480-180  | 180   | 215  | 0.75        | 1.00 | 2.0     | 2.0  | 35.8                     | 316.8   | 60                      | 2.36 | 26.5   | 58.3 | <70         |
| AFTE480-330  | 330   | 400  | 0.75        | 1.00 | 2.0     | 2.0  | 19.5                     | 172.8   | 60                      | 2.36 | 26.5   | 58.3 | <70         |
| AFTE480-550  | 550   | 660  | 0.75        | 1.00 | 2.0     | 2.0  | 11.7                     | 103.7   | 60                      | 2.36 | 26.5   | 58.3 | <70         |
| AFTE480-900  | 900   | 1080 | 0.75        | 1.00 | 2.0     | 2.0  | 7.2                      | 63.4    | 60                      | 2.36 | 26.5   | 58.3 | <70         |
| AFTE480-1200 | 1200  | 1440 | 0.75        | 1.00 | 2.0     | 2.0  | 5.4                      | 47.5    | 60                      | 2.36 | 26.5   | 58.3 | <70         |
| AFTE480-1450 | 1450  | 1740 | 0.75        | 1.00 | 2.0     | 2.0  | 4.4                      | 39.3    | 60                      | 2.36 | 26.5   | 58.3 | <70         |

## leadscrew/nut assemblies AFTE480

| SHAPE | REPLACEMENT ORDERING LEADSCREW/ NUT ONLY |     |        | THREAD SIZE/ PITCH | REPLACEMENT ORDERING LEADSCREW/ NUT ONLY |  |                   | THREAD SIZE/ PITCH |
|-------|------------------------------------------|-----|--------|--------------------|------------------------------------------|--|-------------------|--------------------|
|       | part no.                                 |     | CODE   |                    | part no.                                 |  | CODE              |                    |
|       | 380373                                   | L34 | 0.25   | 350823             | L12                                      |  | 32 TPI            |                    |
|       | 369933                                   | L33 | 0.30   | 350833             | L13                                      |  | 28 TPI            |                    |
|       | 369923                                   | L32 | 0.35   | 350843             | L14                                      |  | 26 TPI            |                    |
|       | 359303                                   | L31 | 0.40   | 350853             | L15                                      |  | 24 TPI            |                    |
|       | 359293                                   | L30 | 0.45   | 350863             | L16                                      |  | 22 TPI            |                    |
|       | 350713                                   | L1  | 0.50   | 350873             | L17                                      |  | 20 TPI            |                    |
|       | 350723                                   | L2  | 0.60   | 350883             | L18                                      |  | 19 TPI            |                    |
|       | 350733                                   | L3  | 0.70   | 350893             | L19                                      |  | 18 TPI            |                    |
|       | 350743                                   | L4  | 0.75   | 350903             | L20                                      |  | 16 TPI            |                    |
|       | 350753                                   | L5  | 0.80   | 350913             | L21                                      |  | 14 TPI            |                    |
|       | 350763                                   | L6  | 1.00   | 402793             | L39                                      |  | 12 TPI            |                    |
|       | 350773                                   | L7  | 1.25   |                    |                                          |  |                   |                    |
|       | 350783                                   | L8  | 1.50   | 350993             | L22                                      |  | 1/8" NPT (27 TPI) |                    |
|       | 350793                                   | L9  | 1.75   | 350923             | L23                                      |  | 0 BA              |                    |
|       | 402723                                   | L38 | 80 TPI | 350933             | L24                                      |  | 1 BA              |                    |
|       | 391533                                   | L36 | 64 TPI | 350943             | L25                                      |  | 2 BA              |                    |
|       | 391543                                   | L37 | 56 TPI | 350953             | L26                                      |  | 3 BA              |                    |
|       | 390333                                   | L35 | 48 TPI | 350963             | L27                                      |  | 4 BA              |                    |
|       | 350803                                   | L10 | 40 TPI | 350973             | L28                                      |  | 5 BA              |                    |
|       | 350813                                   | L11 | 36 TPI | 350983             | L29                                      |  | 6 BA              |                    |

Other leadscrews available to special order.

### Control Blocks

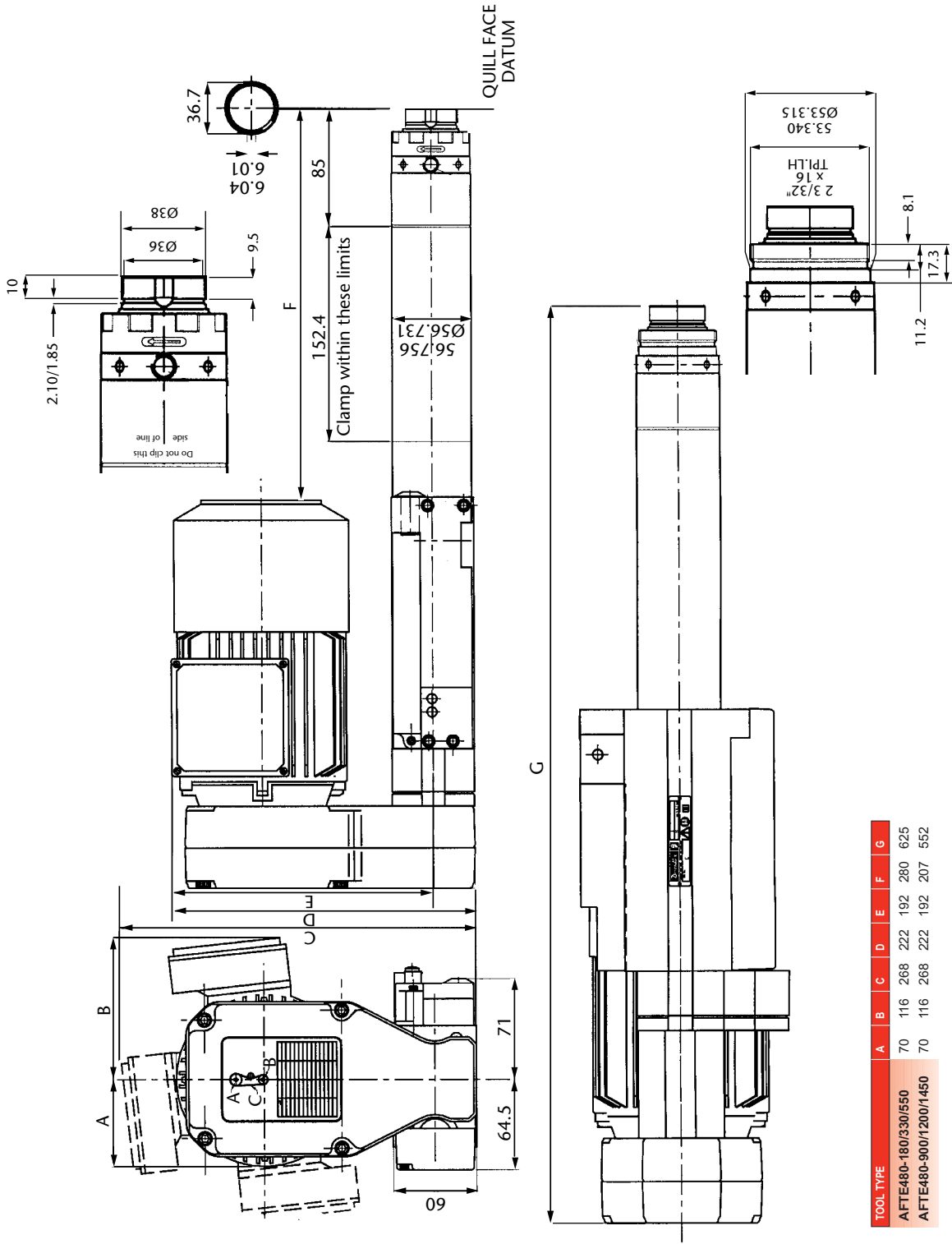
A7 – PNP Switches  
A8 – NPN Switches

# Tapping Leadscrew

## AFTE480 accessories

| ACCESSORIES RANGE      | PAGE |
|------------------------|------|
| Output Spindles        | 30   |
| Multiple Spindle Heads | 34   |
| Clamps                 | 39   |

AFTE480 leadscrew

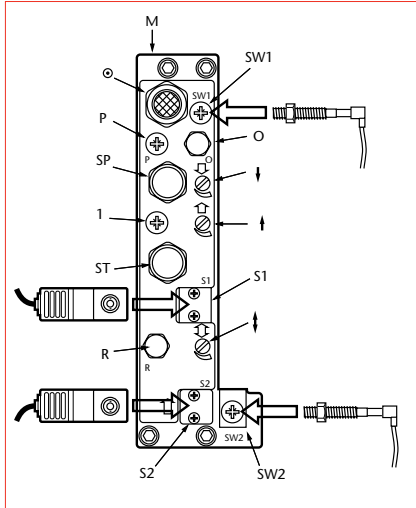


| TOOL TYPE             | A  | B   | C   | D   | E   | F   | G   |
|-----------------------|----|-----|-----|-----|-----|-----|-----|
| AFTE480-180/330/550   | 70 | 116 | 268 | 222 | 192 | 280 | 625 |
| AFTE480-900/1200/1450 | 70 | 116 | 268 | 222 | 192 | 207 | 552 |

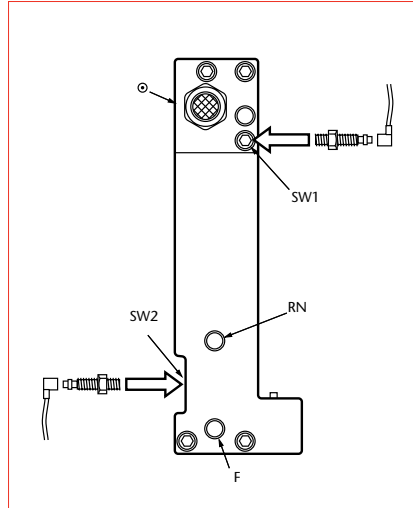
# Control Blocks and Interfaces

## 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 nose of tool to provide extra retract capability with heavy front end attachments (1/8" BSP)
- ST** Start Button – For manual operation and set-up
- I** Retract rate adjustment control
- 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 (M5)
- O** 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) (M5)
- O** Depth Stop Signal Port – Used with external circuits such as dwell or pecking (1/8" BSP)
- ↑** Retract rate adjustment control
- ↓** Advance rate adjustment control
- F** Feed rate adjustment control
- F** Feed port (1/8" BSP)
- RN** Return port (1/8" BSP)

#### 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)*

### C10 Part No. 438223

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

### C11 Part No. 438233

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

### 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

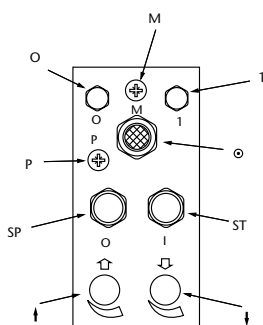
### Solenoid Valves

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

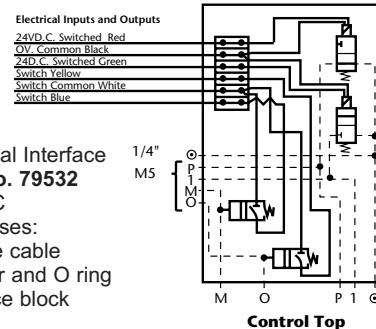
### Proximity Switches

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

### AFD60/AFT60 Control Block *(Supplied fitted)*



Air connection as above except M port which is negative at datum.  
To invert signal use kit **Part No. 104822**



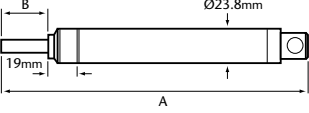
**Electrical Interface  
Part No. 79532**  
24V DC  
Comprises:  
2 metre cable  
Adaptor and O ring  
Interface block

**Control Top**

# Accessories AFD Control Options

## adjustable feed control unit

Minimises burring on breakthrough. Constant feed maintained in all operating conditions. Hydraulic fluid sealed for life.



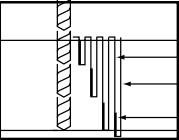
**Adjustable Hydraulic Control Unit**

|           | 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   |               |
| <b>D1</b> | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 25          | 1  | 199 | 7.83  | 30.1 | 1.19 | <b>91942</b>  |
| <b>D2</b> | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 50          | 2  | 276 | 10.87 | 55.5 | 2.19 | <b>91952</b>  |
| <b>D3</b> | 2.3                         | 5   | 544       | 1200 | 0.73                                     | 0.029  | 75          | 3  | 352 | 13.86 | 80.9 | 3.19 | <b>91962</b>  |
| <b>D7</b> | 4.1                         | 9   | 357       | 785  | 0.45                                     | 0.018  | 102         | 4  | 417 | 16.42 | 106  | 4.17 | <b>104452</b> |
| <b>D8</b> | 4.1                         | 9   | 357       | 785  | 0.45                                     | 0.018  | 127         | 5  | 474 | 18.66 | 132  | 5.20 | <b>104462</b> |

To fit an adjustable Hydraulic Control Unit to an AFD60 use kit Part No. **94982**.

## 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.

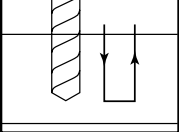


**Peck Feed Control Unit**

|           |                  |              |
|-----------|------------------|--------------|
| <b>D4</b> | 25mm (1") stroke | <b>92282</b> |
| <b>D5</b> | 50mm (2") stroke | <b>92292</b> |
| <b>D6</b> | 75mm (3") stroke | <b>92302</b> |

## dwell control

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



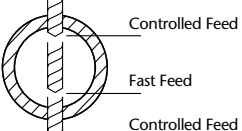
**Dwell Control**

|           |                             |              |
|-----------|-----------------------------|--------------|
| <b>E1</b> | Dwell Control Unit Complete | <b>92372</b> |
| –         | Dwell for AFD60             | <b>78482</b> |

## 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 feed movements linked by a distance of fast travel.

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



**Skip Drilling**

|   |  |  |
|---|--|--|
| – |  |  |
|---|--|--|

To fit Peck Feed or Skip Feed Control to an AFD60 order kit Part No. **94982** in addition to the above.

# Accessories Outputs and Collets

## Output Spindles



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

### AFD205/AFD215, AFDE200

|  | 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                                                                      | 382213   | ≤9600 rpm               |
|  | Tapping Head Output Spindle       | H21        | 4.5-8.0mm (3/16"-5/16") capacity                                                                                                       | 357193   | ≤1200 rpm               |

### AFD415, AFDE400/410, AFDE610, 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                  |
|  | Large Integral Collet Chuck Output Spindle                            | R2         | Standard Output Assembly                                              | 384113   |                         |
|  |                                                                       | R36        | Precision Output Assembly                                             | 389273   | ≤18000                  |
|  | Taper Output Spindle and for use with chucks and multi spindle heads  | B24        | No. 2 Jacobs Taper A = 30 (1.18")                                     | 326593   |                         |
|  |                                                                       | B32        | No. 1 Jacobs Taper A = 24.1 (0.95")                                   | 355263   | ≤9600                   |
|  |                                                                       | B16        | B16 Taper Output A = 34.8 (1.37")                                     | 368163   |                         |
|  | Preset Tooling DIN55058 Output Spindle                                | B3         | Standard Output Assembly                                              | 326563   | ≤5450                   |
|  | Preset Tooling TMS Standard Output Spindle                            | B33        | Standard Output Assembly                                              | 356373   | ≤5450                   |
|  | 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 Chucks, Guards, Silencers, Misc.

## Chucks

### drilling chucks

|                                                                                                    | FUNCTION                          | DESCRIPTION                                                                           | PART NO. |
|----------------------------------------------------------------------------------------------------|-----------------------------------|---------------------------------------------------------------------------------------|----------|
| <p>Max Drill Depth 15mm (0.59")</p> <p>28.4mm (1.12")</p> <p>49mm (1.92")</p> <p>No. 1 Taper</p>   | 6.5mm (1/4") Key Adjustable Chuck | Part No. includes Chuck Key. Use with No. 1 standard Jacobs taper outputs K32 and B32 | 29492    |
| <p>Max Drill Depth 34mm (1.34")</p> <p>36.2mm (1.43")</p> <p>63.2mm (2.50")</p> <p>No. 2 Taper</p> | 10mm (3/8") Key Adjustable Chuck  | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24          | 34752    |
| <p>Max Drill Depth 52mm (2.04")</p> <p>52mm (2")</p> <p>90mm (3.5")</p> <p>No. 2 Taper</p>         | 13mm (1/2") Key Adjustable Chuck  | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24          | 34332    |

### tapping chucks

|                                     | FUNCTION                                       | DESCRIPTION          | CHUCK PART NO. |
|-------------------------------------|------------------------------------------------|----------------------|----------------|
| <p>Optional Collets</p>             | Tapping Chucks with flexible Collet (included) | JACOBS TAPER FITTING |                |
|                                     |                                                | A                    | B              |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
|                                     |                                                | mm                   | in             |
| <p>Spare or replacement Collets</p> |                                                | No. 1                | 29462          |
|                                     |                                                | No. 1                | 29482          |
|                                     |                                                | No. 2                | 29472          |
|                                     |                                                | No. 2                | 36172          |
|                                     |                                                | No. 1                | 39242          |
|                                     |                                                | No. 1                | 39242          |
|                                     |                                                | No. 2                | 39242          |
|                                     |                                                | No. 2                | 39242          |

### drill bit/cutter adaptors

|                                                                                   | FUNCTION                    | DESCRIPTION                                                                                                                             | PART NO. |
|-----------------------------------------------------------------------------------|-----------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|----------|
| <p>116mm (4.6")</p> <p>24mm (0.95")</p> <p>No.2 Morse Taper No.2 Jacobs Taper</p> | Morse Taper Adaptor         | No. 2 Jacobs female taper to No. 2 Morse female taper                                                                                   | 34862    |
| <p>30mm (1.2")</p> <p>10mm (0.4")</p> <p>19mm (0.75")</p> <p>2 off M4 Screws</p>  | Ø 10mm Shank Cutter Adaptor | Fits thread of Single Collet Chuck – Part Nos. 326573 and 384113 and Multi Heads – Part Nos. 52362, 52462, 92162, 92172, 104022, 104062 | 53232    |

### multiple spindle heads

|                                             | FUNCTION                                                                      | DESCRIPTION                                                                                                 | PART NO. |
|---------------------------------------------|-------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|----------|
| <p>Multi-spindle drilling/tapping heads</p> | Fixed and adjustable spindle multi-heads (see page 34)                        | When ordering state number of spindles, diameter of holes, material to be drilled and hole pattern required | –        |
| <p>Angle heads/Offset heads</p>             | Angle heads available to order to suit AFDE400/410/600/610/620/700/710/AFD415 | When ordering state details of application, material to be machined, size and depth of cut                  | –        |

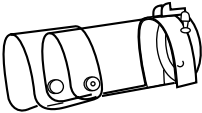
# Accessories Collets, Guards, Silencers, Misc.

## Collets

| For use with B2 (326573), R2 (384113), K2 (357183), K42 (375263) ER11 TYPE |          |                           |          |                           |          |
|----------------------------------------------------------------------------|----------|---------------------------|----------|---------------------------|----------|
| size                                                                       | part no. | size                      | part no. | size                      | part no. |
| 0.5 - 1.0 (0.020 - 0.039)                                                  | 52582    | 2.1 - 2.5 (0.083 - 0.098) | 52622    | 4.1 - 5.0 (0.161 - 0.197) | 52652    |
| 1.1 - 1.5 (0.043 - 0.059)                                                  | 52592    | 2.6 - 3.0 (0.102 - 0.118) | 52632    | 5.1 - 6.0 (0.201 - 0.234) | 52662    |
| 1.6 - 2.0 (0.063 - 0.079)                                                  | 52602    | 3.1 - 4.0 (0.121 - 0.157) | 52642    | 6.1 - 7.0 (0.240 - 0.276) | 52672    |

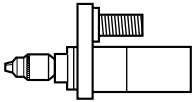
## Guards

### chuck guards

|                                                                                   | FEATURES                                                  | TOOL TYPES                                                                                | PART NO.                 |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------|-------------------------------------------------------------------------------------------|--------------------------|
|  | To prevent the user inadvertently touching rotating parts | AFD205/215, AFDE200, AFTE270<br>AFD415, AFDE400/410, AFTE470/480<br>AFD60/AFDE600/610/620 | 66132<br>66122<br>304863 |

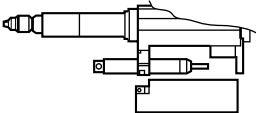
## Silencers

### AFD/AFT silencer

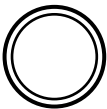
|                                                                                     | FEATURES                                                | TOOL TYPES               | PART NO.       |
|-------------------------------------------------------------------------------------|---------------------------------------------------------|--------------------------|----------------|
|  | Exhaust silencer fitted with 1/4" BSP screw-in silencer | AFD205, AFD215<br>AFD415 | 91262<br>70642 |

## Miscellaneous Accessories

### AFD205/215 HCU inverting kit

|                                                                                     | FEATURES               | TOOL TYPES                                                                 | PART NO. |
|-------------------------------------------------------------------------------------|------------------------|----------------------------------------------------------------------------|----------|
|  | HCU Inverting Assembly | Particularly for use with AFD205 for applications with height restrictions | 381003   |

### AFD205/215, AFDE200, AFTE270 sealing ring

|                                                                                     | FEATURES     | TOOL TYPES                                                                                                        | PART NO. |
|-------------------------------------------------------------------------------------|--------------|-------------------------------------------------------------------------------------------------------------------|----------|
|  | Sealing Ring | Threaded on to nose of unit in place of protection cap.<br>Forms seal on quill shaft to prevent ingress of swarf. | 104432   |

# Accessories Multiple Spindle Heads

## 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

## drilling

specification

| Multiple Spindle Head Part Numbers |                        |           |                     |       |                             |                              |         |         |                              |
|------------------------------------|------------------------|-----------|---------------------|-------|-----------------------------|------------------------------|---------|---------|------------------------------|
| NUMBER OF SPINDLES                 | SPINDLE CENTRES OR PCD |           | MAXIMUM COLLET SIZE |       | AFD205<br>AFD215<br>AFDE200 | AFD415<br>AFDE400<br>AFDE410 | AFDE610 | AFTE480 | COLLET TYPE<br>(SEE PAGE 29) |
|                                    | mm                     | ins       | mm                  | ins   |                             |                              |         |         |                              |
| 2                                  | 9.5-54                 | 0.37-2.13 | 4.00                | 0.157 | 174183                      | 92142                        | –       | –       | A                            |
|                                    | 12.7-64                | 0.50-2.52 | 6.50                | 0.256 | –                           | 92152                        | –       | –       | B                            |
|                                    | 18.4-87.3              | 0.72-3.44 | 7.00                | 0.276 | –                           | 92162                        | 104062  | –       | C                            |
|                                    | 19-95                  | 0.75-3.74 | 9.50                | 0.374 | –                           | 106662                       | 106672  | –       | D                            |
|                                    | 41.1-109.9             | 1.62-4.33 | 7.00                | 0.276 | –                           | 92172                        | 104022  | –       | C                            |
| 3 inline                           | 19.0-57.1              | 0.75-2.25 | 9.50                | 0.374 | –                           | 107552                       | 107562  | –       | D                            |
| 3 PCD                              | 27.9-104.1             | 1.01-4.01 | 9.50                | 0.374 | –                           | 107582                       | 107592  | –       | D                            |
| 4 PCD                              | 42.7-118.9             | 1.68-4.68 | 9.50                | 0.374 | –                           | –                            | 107612  | –       | D                            |
| Fixed                              | –                      | –         | –                   | –     | –                           | MSD100                       | MSD200  | –       | –                            |

## tapping<sup>(1)</sup>

specification

| Multiple Spindle Head Part Numbers |                        |           |                     |       |                             |                              |         |         |                              |
|------------------------------------|------------------------|-----------|---------------------|-------|-----------------------------|------------------------------|---------|---------|------------------------------|
| NUMBER OF SPINDLES                 | SPINDLE CENTRES OR PCD |           | MAXIMUM COLLET SIZE |       | AFD205<br>AFD215<br>AFDE200 | AFD415<br>AFDE400<br>AFDE410 | AFDE610 | AFTE480 | COLLET TYPE<br>(SEE PAGE 29) |
|                                    | mm                     | ins       | mm                  | ins   |                             |                              |         |         |                              |
| 2                                  | 9.5-54                 | 0.37-2.13 | 4.00                | 0.157 | –                           | –                            | –       | 92142   | A                            |
|                                    | 12.7-64                | 0.50-2.52 | 6.50                | 0.256 | 204173                      | 92222                        | –       | 92152   | B                            |
|                                    | 18.4-87.3              | 0.72-3.44 | 7.00                | 0.276 | –                           | 92232                        | 104122  | 92162   | C                            |
|                                    | 19-95                  | 0.75-3.74 | 9.50                | 0.374 | –                           | 106682                       | 106692  | 106662  | D                            |
|                                    | 41.1-109.9             | 1.62-4.33 | 7.00                | 0.276 | –                           | 92242                        | 104072  | 92172   | C                            |
| 3 inline                           | 19.0-57.1              | 0.75-2.25 | 9.50                | 0.374 | –                           | 107632                       | 107642  | 107552  | D                            |
| 3 PCD                              | 27.9-104.1             | 1.01-4.01 | 9.50                | 0.374 | –                           | 107662                       | 107672  | 107582  | D                            |
| 4 PCD                              | 42.7-118.9             | 1.68-4.68 | 9.50                | 0.374 | –                           | –                            | 107692  | –       | D                            |
| Fixed                              | –                      | –         | –                   | –     | –                           | MST100                       | MST200  | MSD100  | –                            |

## output spindles for use with multiple spindle heads<sup>(2)</sup>

specification

| Multiple Spindle Head Part Numbers |                              |         |         |
|------------------------------------|------------------------------|---------|---------|
| AFD205<br>AFD215<br>AFDE200        | AFD415<br>AFDE400<br>AFDE410 | AFDE610 | AFTE480 |
| K32                                | B24                          | B24     | B24     |

<sup>(1)</sup> All tapping heads incorporate a reversing gearbox except heads for AFDE700/710 and AFTE270/470/480

<sup>(2)</sup> **How to order**

Examples:

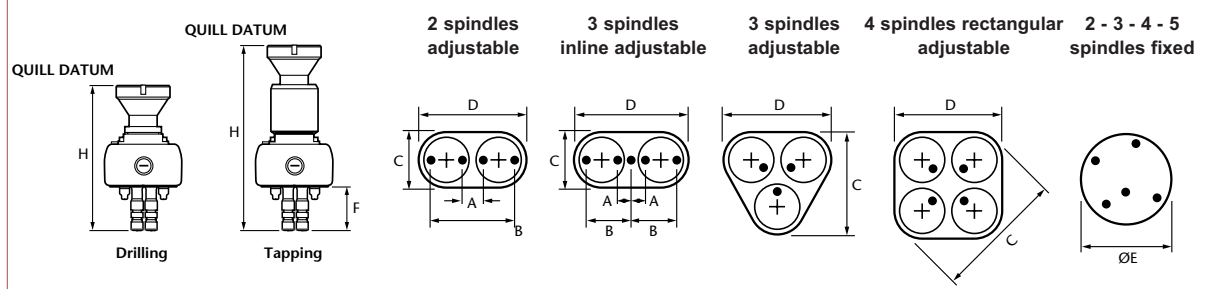
AFDE200-2850-A1 + K32 + 174183

AFD415-3400-A6 + B24 + 107552

AFDE610-900-A1 + B24 + 107672

# Accessories Multiple Spindle Heads

## Multiple Spindle Heads dimensions



## adjustable spindle

specification

| PART NO. | MAXIMUM SPEED | MINIMUM/MAXIMUM CENTRES |             | PCD  |      | MINIMUM PCD |      | MAXIMUM PCD |      | C     |      | D    |      | F     |       | H  |     |
|----------|---------------|-------------------------|-------------|------|------|-------------|------|-------------|------|-------|------|------|------|-------|-------|----|-----|
|          | rpm           | mm                      | ins         | mm   | ins  | mm          | ins  | mm          | ins  | mm    | ins  | mm   | ins  | mm    | ins   | mm | ins |
| 52362    | 8500          | 18.4 - 87.3             | 0.72 - 3.44 | —    | —    | —           | —    | 62          | 2.44 | 115   | 4.53 | 60   | 2.36 | 193.5 | 7.62  |    |     |
| 52462    | 8500          | 41.1 - 109.9            | 1.62 - 4.33 | —    | —    | —           | —    | 62          | 2.44 | 137   | 5.39 | 60   | 2.36 | 193.5 | 7.62  |    |     |
| 92142    | 5300          | 9.5 - 54                | 0.37 - 2.13 | —    | —    | —           | —    | 50.8        | 2.00 | 83    | 3.27 | 50.8 | 2.00 | 175.4 | 6.91  |    |     |
| 92152    | 5300          | 12.7 - 64               | 0.50 - 2.52 | —    | —    | —           | —    | 50.8        | 2.00 | 83    | 3.27 | 50.8 | 2.00 | 175.4 | 6.91  |    |     |
| 92162    | 8500          | 18.4 - 87.3             | 0.72 - 3.44 | —    | —    | —           | —    | 62          | 2.44 | 115   | 4.53 | 60   | 2.36 | 196   | 7.72  |    |     |
| 92172    | 8500          | 41.1 - 109.9            | 1.62 - 4.33 | —    | —    | —           | —    | 62          | 2.44 | 137   | 5.39 | 60   | 2.36 | 196   | 7.72  |    |     |
| 92222    | 1400          | 12.7 - 64               | 0.50 - 2.52 | —    | —    | —           | —    | 50.8        | 2.00 | 83    | 3.27 | 50.8 | 2.00 | 233.8 | 9.20  |    |     |
| 92232    | 1400          | 18.4 - 87.3             | 0.72 - 3.44 | —    | —    | —           | —    | 62          | 2.44 | 115   | 4.53 | 60   | 2.36 | 253   | 9.96  |    |     |
| 92242    | 1400          | 41.1 - 109.9            | 1.62 - 4.33 | —    | —    | —           | —    | 62          | 2.44 | 137   | 5.39 | 60   | 2.36 | 253   | 9.96  |    |     |
| 104022   | 8500          | 41.1 - 109.9            | 1.62 - 4.33 | —    | —    | —           | —    | 62          | 2.44 | 137   | 5.39 | 60   | 2.36 | 196   | 7.72  |    |     |
| 104062   | 8500          | 18.4 - 87.3             | 0.72 - 3.44 | —    | —    | —           | —    | 62          | 2.44 | 115   | 4.53 | 60   | 2.36 | 196   | 7.72  |    |     |
| 104072   | 1400          | 41.1 - 109.9            | 1.62 - 4.33 | —    | —    | —           | —    | 62          | 2.44 | 137   | 5.39 | 60   | 2.36 | 233.5 | 9.19  |    |     |
| 104122   | 1400          | 18.4 - 87.3             | 0.72 - 3.44 | —    | —    | —           | —    | 62          | 2.44 | 115   | 4.53 | 60   | 2.36 | 196   | 7.72  |    |     |
| 106662   | 5300          | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 212   | 8.35  |    |     |
| 106672   | 5300          | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 211   | 8.31  |    |     |
| 106682   | 1500          | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 261.5 | 10.30 |    |     |
| 106692   | 1500          | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 260   | 10.24 |    |     |
| 107552   | 5300          | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 212.3 | 8.36  |    |     |
| 107562   | 5300          | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 188   | 7.40  |    |     |
| 107572   | 5300          | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 212.3 | 8.36  |    |     |
| 107582   | 5300          | —                       | —           | 27.9 | 1.01 | 104.1       | 4.01 | 120.3       | 4.74 | 132.6 | 5.22 | 68.3 | 2.69 | 212.3 | 8.36  |    |     |
| 107592   | 5300          | —                       | —           | 27.9 | 1.01 | 104.1       | 4.01 | 120.3       | 4.74 | 132.6 | 5.22 | 68.3 | 2.69 | 211.2 | 8.31  |    |     |
| 107602   | 5300          | —                       | —           | 27.9 | 1.01 | 104.1       | 4.01 | 120.3       | 4.74 | 132.6 | 5.22 | 68.3 | 2.69 | 188   | 7.40  |    |     |
| 107612   | 5300          | —                       | —           | 42.7 | —    | 118.9       | 4.68 | 147.6       | 5.81 | 130.4 | 5.13 | 68.3 | 2.69 | 211.2 | 8.31  |    |     |
| 107622   | 5300          | —                       | —           | 42.7 | —    | 118.9       | 4.68 | 147.6       | 5.81 | 130.4 | 5.13 | 68.3 | 2.69 | 188   | 7.40  |    |     |
| 107632   | 900           | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 261.5 | 10.30 |    |     |
| 107642   | 900           | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 260   | 10.24 |    |     |
| 107652   | 900           | 19 - 57.1               | 0.75 - 2.25 | —    | —    | —           | —    | 99.2        | 3.90 | 142.9 | 5.63 | 68.3 | 2.69 | 259.9 | 10.23 |    |     |
| 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 |    |     |
| 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 |    |     |
| 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 |    |     |
| 107692   | 900           | —                       | —           | 42.7 | —    | 118.9       | 4.68 | 147.6       | 5.81 | 130.4 | 5.13 | 68.3 | 2.69 | 260   | 10.24 |    |     |
| 107702   | 900           | —                       | —           | 42.7 | —    | 118.9       | 4.68 | 147.6       | 5.81 | 130.4 | 5.13 | 68.3 | 2.69 | 259.9 | 10.23 |    |     |
| 174183   | 5300          | 9.5 - 54                | 0.37 - 2.13 | —    | —    | —           | —    | 50.8        | 2.00 | 83    | 3.27 | 50.8 | 2.00 | 169.5 | 6.67  |    |     |
| 204173   | 5300          | 12.7 - 64               | 0.50 - 2.52 | —    | —    | —           | —    | 50.8        | 2.00 | 83    | 3.27 | 50.8 | 2.00 | 206.1 | 8.11  |    |     |
| 204183   | 5300          | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 188   | 7.40  |    |     |
| 204193   | 700           | 19 - 95                 | 0.75 - 3.74 | —    | —    | —           | —    | 76          | 2.99 | 124   | 4.88 | 68.3 | 2.69 | 260.4 | 10.25 |    |     |

## fixed spindle

specification

| PART NO. | MAXIMUM SPEED | MINIMUM/MAXIMUM CENTRES |           | MINIMUM PCD |           | MAXIMUM PCD |      | OE          |           | F       |           | H           |           |
|----------|---------------|-------------------------|-----------|-------------|-----------|-------------|------|-------------|-----------|---------|-----------|-------------|-----------|
|          | rpm           | mm                      | ins       | mm          | ins       | mm          | ins  | mm          | ins       | mm      | ins       | mm          | ins       |
| MSD100   | 5300          | 9.5-63.5                | 0.37-2.52 | 9.5/12.7    | 0.37/0.50 | 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 |
| MST100   | 1400          | 9.5-63.5                | 0.37-2.52 | 9.5/12.7    | 0.37/0.50 | 63.5        | 2.50 | 56-81.8     | 2.20-3.22 | 37/40.5 | 1.46/1.59 | 227.8/233.8 | 8.97/9.20 |
| MSD200   | 5300          | 19-95                   | 0.75-3.74 | 19          | 0.75      | 95          | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2    | 2.25      | 211.1       | 8.31      |
| MST200   | 700           | 19-95                   | 0.75-3.74 | 19          | 0.75      | 95          | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2    | 2.25      | 260         | 10.24     |
| 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     | 8.70-9.49 |
| 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     | 8.70-9.49 |

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.

# Accessories Multiple Spindle Heads – Collets

## Multiple Spindle Heads – Collets



- Collets for multiple spindle heads
- Types A, B and D are threaded types
- Type C are ER11 type

| SIZE |       | COLLET TYPE |       |       |       |
|------|-------|-------------|-------|-------|-------|
| mm   | ins   | A           | B     | C     | D     |
| 0.5  | 0.020 |             |       | 52582 |       |
| 0.6  | 0.024 |             |       | 52582 |       |
| 0.7  | 0.028 |             |       | 52582 |       |
| 0.8  | 0.031 |             |       | 52582 |       |
| 0.9  | 0.035 |             |       | 52582 |       |
| 1    | 0.039 | 60002       | 39442 | 52582 |       |
| 1.1  | 0.043 | 60022       | 39452 | 52592 |       |
| 1.2  | 0.047 | 60032       | 39462 | 52592 |       |
| 1.3  | 0.051 | 60042       | 39472 | 52592 |       |
| 1.4  | 0.055 | 60052       | 39482 | 52592 |       |
| 1.5  | 0.059 | 60062       | 39492 | 52592 |       |
| 1.6  | 0.063 | 60072       | 27852 | 52602 |       |
| 1.7  | 0.067 | 60082       | 39502 | 52602 |       |
| 1.8  | 0.071 | 60092       | 27862 | 52602 |       |
| 1.9  | 0.075 | 60102       | 39522 | 52602 |       |
| 2    | 0.079 | 60122       | 27872 | 52602 | 39302 |
| 2.1  | 0.083 | 60132       | 27882 | 52622 | 39322 |
| 2.2  | 0.087 | 60142       | 27892 | 52622 | 39332 |
| 2.3  | 0.091 | 60152       | 27902 | 52622 | 39342 |
| 2.4  | 0.094 | 60162       | 27922 | 52622 | 39352 |
| 2.5  | 0.098 | 60172       | 27932 | 52622 | 39362 |
| 2.6  | 0.102 | 60182       | 27942 | 52632 | 39372 |
| 2.7  | 0.106 | 60192       | 27952 | 52632 | 39382 |
| 2.8  | 0.110 | 60202       | 27962 | 52632 | 39392 |
| 2.9  | 0.114 | 60222       | 27972 | 52632 | 39402 |
| 3    | 0.118 | 60232       | 27982 | 52632 | 39422 |
| 3.1  | 0.122 | 60242       | 27992 | 52642 | 39432 |
| 3.2  | 0.126 | 60252       | 28002 | 52642 | 39402 |
| 3.3  | 0.130 | 60262       | 28032 | 52642 | 39432 |
| 3.4  | 0.134 | 60272       | 28042 | 52642 | 39442 |
| 3.5  | 0.138 | 60282       | 28052 | 52642 | 39452 |
| 3.6  | 0.142 | 60292       | 28062 | 52642 | 39462 |
| 3.7  | 0.146 | 60302       | 28082 | 52642 | 39482 |
| 3.8  | 0.150 | 60322       | 28092 | 52642 | 39492 |
| 3.9  | 0.154 | 60332       | 28102 | 52642 | 35002 |
| 4    | 0.157 | 60342       | 28122 | 52642 | 35022 |
| 4.1  | 0.161 |             | 28132 | 52652 | 35032 |
| 4.2  | 0.165 |             | 28142 | 52652 | 35042 |
| 4.3  | 0.169 |             | 28152 | 52652 | 35052 |
| 4.4  | 0.173 |             | 28162 | 52652 | 35062 |
| 4.5  | 0.177 |             | 28172 | 52652 | 35072 |
| 4.6  | 0.181 |             | 28182 | 52652 | 35082 |
| 4.7  | 0.185 |             | 28192 | 52652 | 35092 |
| 4.8  | 0.189 |             | 28202 | 52652 | 35102 |
| 4.9  | 0.193 |             | 28222 | 52652 | 35122 |
| 5    | 0.197 |             | 28232 | 52652 | 35132 |

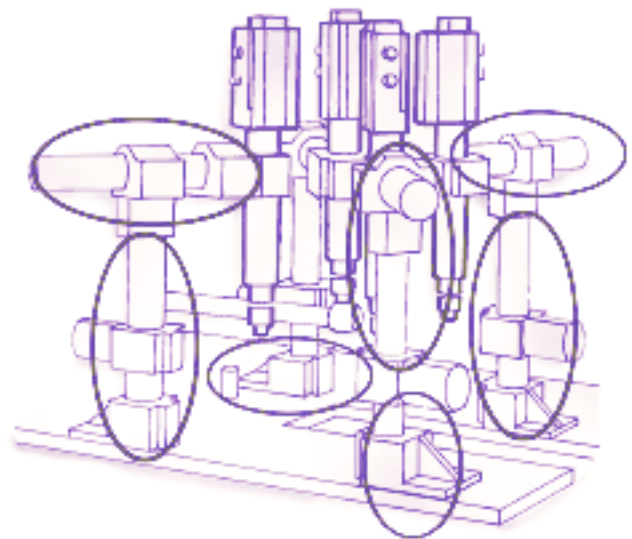
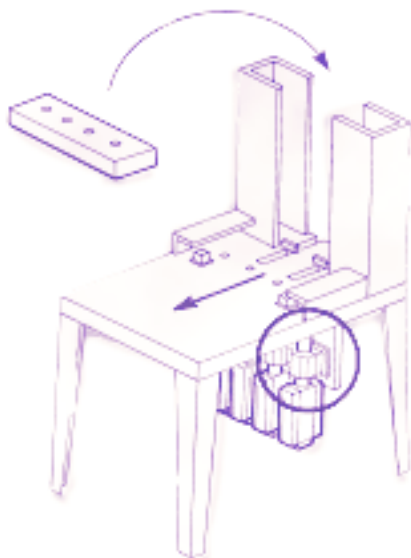
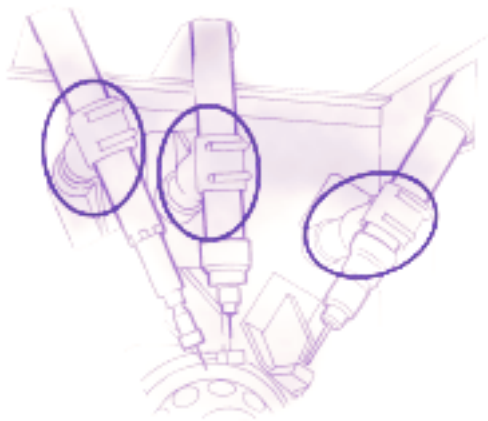
| SIZE |       | COLLET TYPE |       |       |       |
|------|-------|-------------|-------|-------|-------|
| mm   | ins   | A           | B     | C     | D     |
| 5.1  | 0.201 |             | 28252 | 52662 | 35152 |
| 5.2  | 0.205 |             | 28272 | 52662 | 35172 |
| 5.3  | 0.209 |             | 28282 | 52662 | 35182 |
| 5.4  | 0.213 |             | 28292 | 52662 | 35192 |
| 5.5  | 0.217 |             | 28302 | 52662 | 35202 |
| 5.6  | 0.220 |             | 28322 | 52662 | 35222 |
| 5.7  | 0.224 |             | 28332 | 52662 | 35232 |
| 5.8  | 0.228 |             | 28342 | 52662 | 35242 |
| 5.9  | 0.232 |             | 28352 | 52662 | 35252 |
| 6    | 0.236 |             | 28372 | 52662 | 35272 |
| 6.1  | 0.240 |             | 28382 | 52672 | 35282 |
| 6.2  | 0.244 |             | 28392 | 52672 | 35292 |
| 6.3  | 0.248 |             | 28402 | 52672 | 35302 |
| 6.4  | 0.252 |             | 39532 | 52672 | 35332 |
| 6.5  | 0.256 |             | 39542 | 52672 | 35342 |
| 6.6  | 0.260 |             |       | 52672 | 35352 |
| 6.7  | 0.264 |             |       | 52672 | 35362 |
| 6.8  | 0.268 |             |       | 52672 | 35382 |
| 6.9  | 0.272 |             |       | 52672 | 35392 |
| 7    | 0.276 |             |       | 52672 | 35402 |
| 7.1  | 0.280 |             |       |       | 35422 |
| 7.2  | 0.283 |             |       |       | 35432 |
| 7.3  | 0.287 |             |       |       | 35452 |
| 7.4  | 0.291 |             |       |       | 35462 |
| 7.5  | 0.295 |             |       |       | 35472 |
| 7.6  | 0.299 |             |       |       | 35492 |
| 7.7  | 0.303 |             |       |       | 35502 |
| 7.8  | 0.307 |             |       |       | 35522 |
| 7.9  | 0.311 |             |       |       | 35532 |
| 8    | 0.315 |             |       |       | 35552 |
| 8.1  | 0.319 |             |       |       | 35562 |
| 8.2  | 0.323 |             |       |       | 35572 |
| 8.3  | 0.327 |             |       |       | 35582 |
| 8.4  | 0.331 |             |       |       | 35592 |
| 8.5  | 0.335 |             |       |       | 35602 |
| 8.6  | 0.339 |             |       |       | 35622 |
| 8.7  | 0.343 |             |       |       | 35632 |
| 8.8  | 0.346 |             |       |       | 35652 |
| 8.9  | 0.350 |             |       |       | 35672 |
| 9    | 0.354 |             |       |       | 35682 |
| 9.1  | 0.358 |             |       |       | 35692 |
| 9.2  | 0.362 |             |       |       | 35722 |
| 9.3  | 0.366 |             |       |       | 35732 |
| 9.4  | 0.370 |             |       |       | 35752 |
| 9.5  | 0.374 |             |       |       | 35762 |

# Accessories **Clamps**

## mounting clamps



- Extensive range of mounting clamps to allow any orientation of the tool
- All clamps manufactured from aluminium

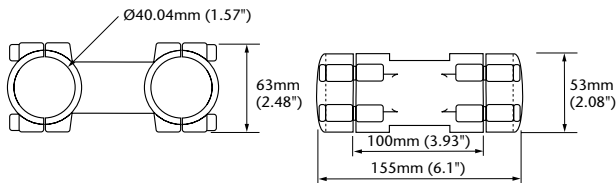


# Accessories Clamps

AFD205, AFDE200

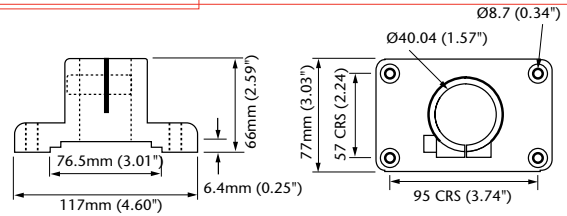
## Parallel Clamp

Part No. 61832



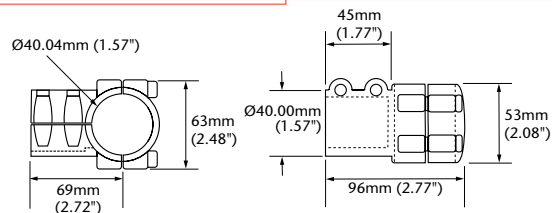
## Base Clamp

Part No. 61842



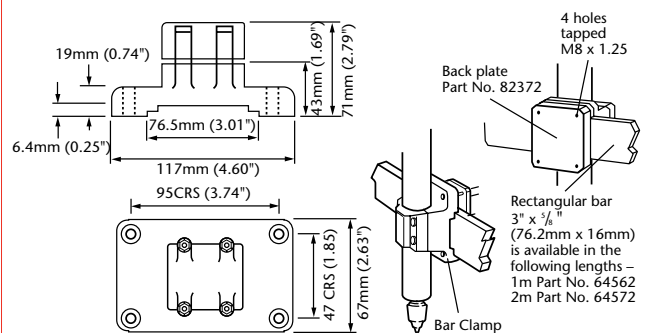
## Right Angle Clamp

Part No. 61822



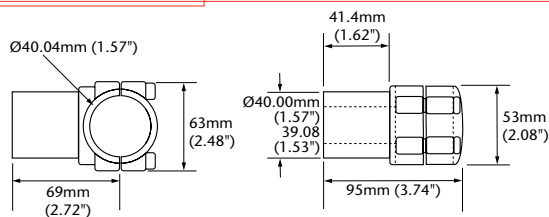
## Bar Clamp

Part No. 61852



## Swivel Clamp

Part No. 61802



## Mounting Tube



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

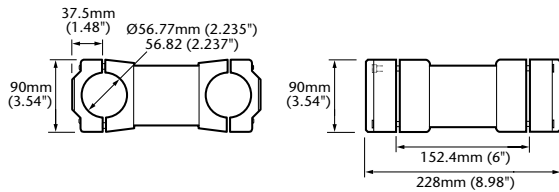
| TUBING LENGTH |     | TUBING Ø |        | PART NO. |
|---------------|-----|----------|--------|----------|
| mm            | ins | mm       | ins    |          |
| 228           | 9   |          |        | 39702    |
| 305           | 12  | 39.97/   | 1.574/ | 39722    |
| 457           | 18  | 40.00    | 1.575  | 39732    |
| 610           | 24  |          |        | 39742    |
| 760           | 30  |          |        | 39752    |

# Accessories Clamps

AFD415, AFDE400/410, AFTE480

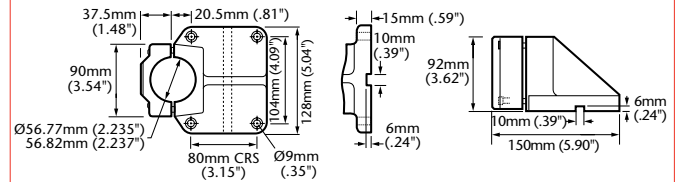
## Parallel Clamp

Part No. 76352



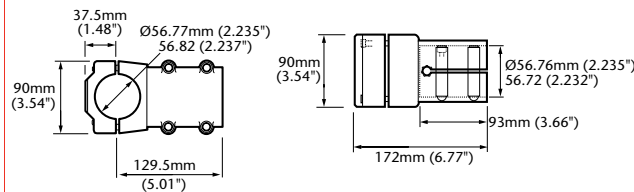
## Base Clamp

Part No. 76302



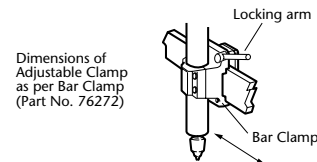
## Right Angle Clamp

Part No. 76342



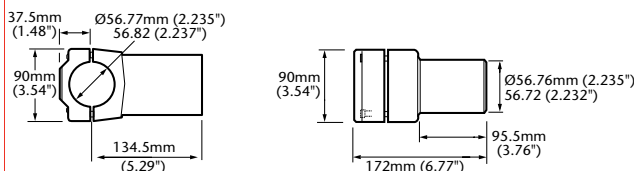
## Adjustable Bar Clamp

Part No. 97042



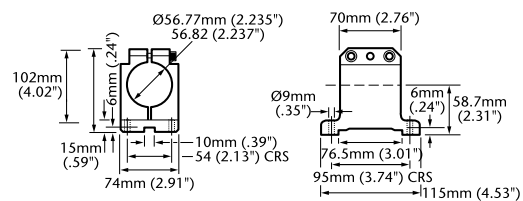
## Swivel Clamp

Part No. 76332



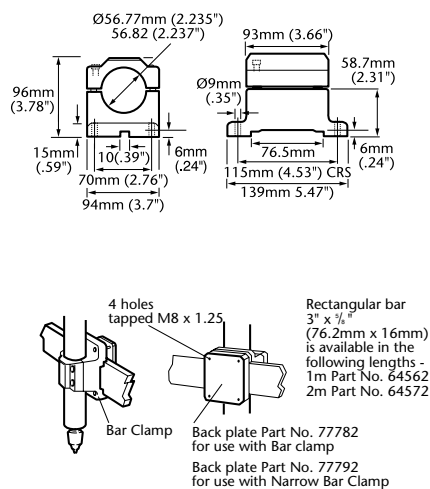
## Narrow Bar Clamp

Part No. 76292



## Bar Clamp

Part No. 76272



## Mounting Tube



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

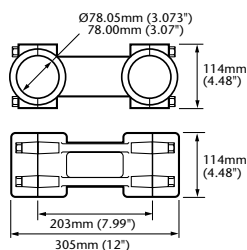
| TUBING LENGTH |     | TUBING Ø |       | PART NO. |
|---------------|-----|----------|-------|----------|
| mm            | ins | mm       | ins   |          |
| 228           | 9   |          |       | 9452     |
| 305           | 12  | 56.76    | 2.225 | 9462     |
| 457           | 18  | 56.73    | 2.233 | 9472     |
| 610           | 24  |          |       | 9482     |
| 762           | 30  |          |       | 9492     |

# Accessories Clamps

AFTE610

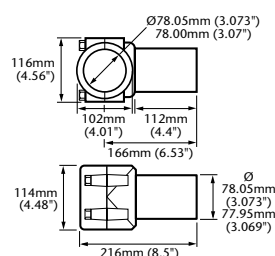
## Parallel Clamp

Part No. 32492



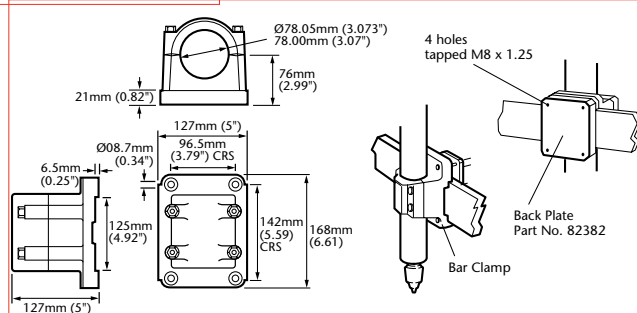
## Swivel Clamp

Part No. 32502



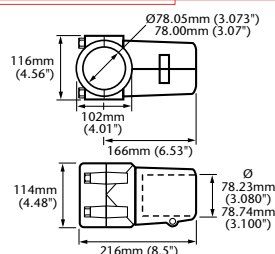
## Bar Clamp

Part No. 32532



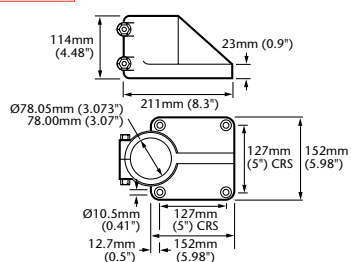
## Right Angle Clamp

Part No. 32522



## Base Clamp

Part No. 32542



## Mounting Tube



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

| TUBING LENGTH |     | TUBING Ø        |       | PART NO. |
|---------------|-----|-----------------|-------|----------|
| mm            | ins | mm              | ins   |          |
| 610           | 24  | 77.95/<br>77.97 | 3.069 | 32562    |
| 915           | 36  |                 |       | 32572    |
| 1220          | 48  |                 |       | 32582    |

# AFD Selection Program

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The Desoutter AFD selection program is a drilling and tapping selection program based on the data used in the AFD Selection Handbook using cutting tools from Dormer Tools (Sheffield) Ltd.

The program allows you the user 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)

A tool can be selected together with accessories and a hard copy printed displaying the calculated values, application parameters and part numbers selected.

All the screens are Windows based and the program is to be used with Windows 95 on an IBM PC or 100% compatible running a 486DX processor at 33MHz with over 4 Mbytes of RAM.

For further details please contact your local Desoutter representative.





