

**Model Type – Pages 6-27**

**Pneumatic Feed and Drive**

AFD205	0.29HP (0.22kW)
AFD215	0.29HP (0.22kW)
AFD415	0.50HP (0.38kW)
AFD/AFT60	0.70HP (0.52kW)

**Pneumatic Feed, Electric Drive**

AFDE200	0.33HP (0.25kW)
AFDE400	0.40HP (0.33kW)
AFDE410	1.00HP (0.75kW)
AFDE600	0.40HP (0.33kW)
AFDE610	1.00HP (0.75kW)
AFDE620	1.50HP (1.10kW)
AFDE700	2.00HP (1.50kW)
AFDE710	3.00HP (2.20kW)

**Electric Feed and Drive via Leadscrew**

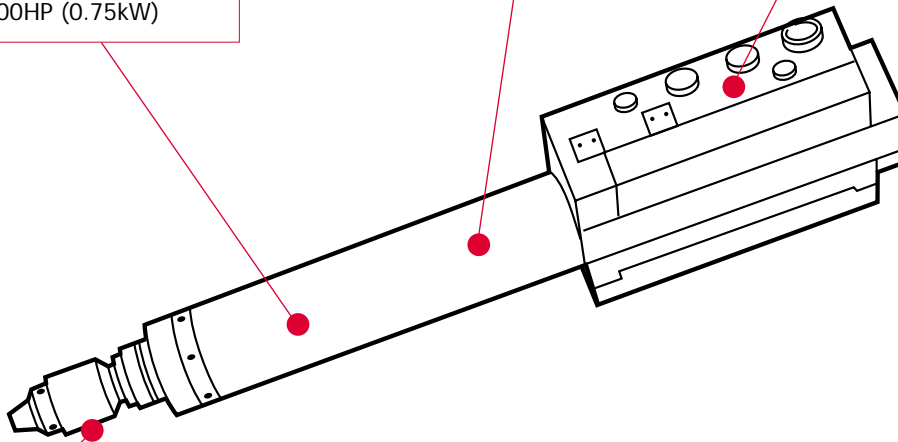
AFTE270	0.24HP (0.18kW)
AFTE470	0.50HP (0.38kW)
AFTE480	1.00HP (0.75kW)

**No Load Speed – Pages 6-27**

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

**Control Block – Page 28**

- 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



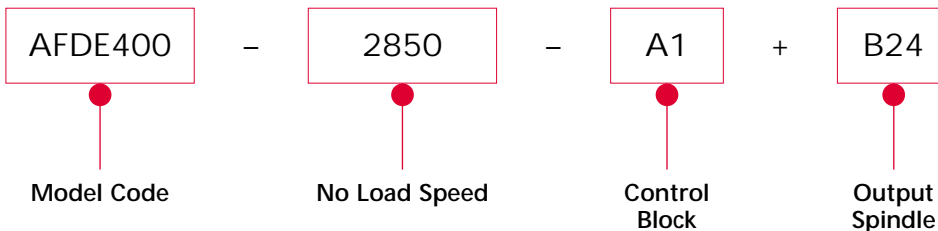
**Output Spindle<sup>(2)</sup> – Pages 30/31**

Output spindle to be supplied.

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

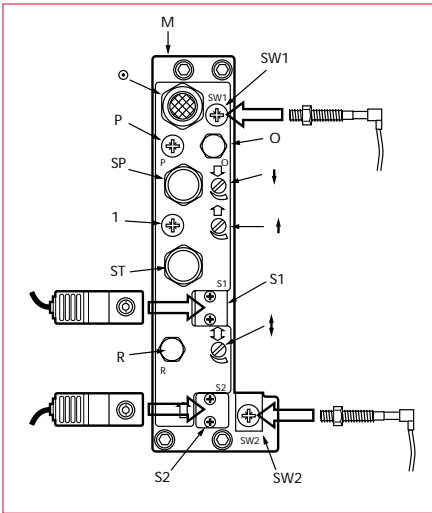
<sup>(2)</sup> Does not apply for AFD60 and AFT60.

# How to Order

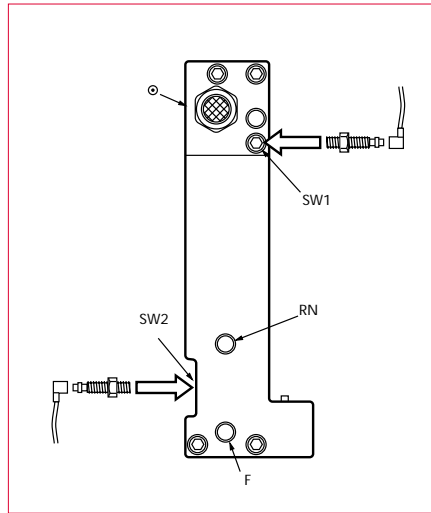


## Control Blocks

**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 (10-32)
- ST** Start Button – For manual operation and set-up
- 1** Remote Start Signal Port Pulse (10-32)
- SP** Manual Stop Button – Interrupts cycle and returns AFD to datum
- P** Remote Stop Signal Port – Requires external signal pulse for returning the unit to datum rest position (10-32)
- 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) (10-32)
- O** Depth Stop Signal Port – Used with external circuits such as dwell or pecking (10-32)
- ↑ Retract rate adjustment control
- ↓ Advance rate adjustment control
- ↕ Feed rate adjustment control
- F** Feed port (1/8" NPT)
- RN** Return port (1/8" NPT)

### Electrical Connections

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

## Electrical Interfaces *(not included with control blocks)*

**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

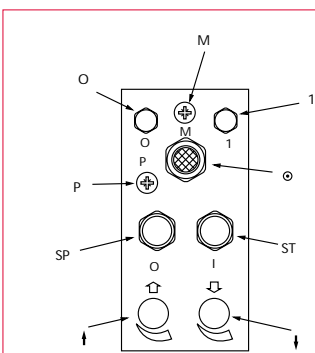
### Solenoid Valves

- 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)*

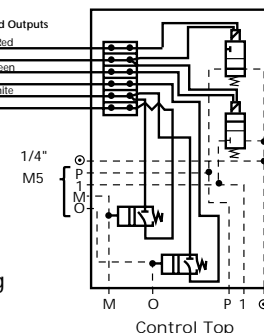


Air connection as above except M port which is negative at datum.  
To invert signal use kit **Part No. 104822**

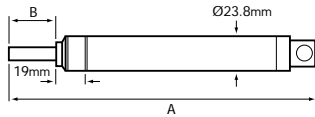
### Electrical Inputs and Outputs

- 24VDC Switched Red
- 0V Common Black
- 24VDC Switched Green
- Switch Yellow
- Switch Common White
- Switch Blue

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



## adjustable feed control unit



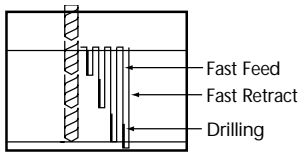
Adjustable Hydraulic Control Unit

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

	MIN. PLUNGER OPERATING LOAD		MAX. LOAD		MINIMUM FEED RATE AT 2230N (500LBS) LOAD		MAX. STROKE		A		B		PART NO.
	kg	lbs	kg	lbs	mm/sec	in/sec	mm	in	mm	in	mm	in	
D1	2.3	5	544	1200	0.73	0.029	25	1	199	7.83	30.1	1.19	91942
D2	2.3	5	544	1200	0.73	0.029	50	2	276	10.87	55.5	2.19	91952
D3	2.3	5	544	1200	0.73	0.029	75	3	352	13.86	80.9	3.19	91962
D7	4.1	9	357	785	0.45	0.018	102	4	417	16.42	106	4.17	104452
D8	4.1	9	357	785	0.45	0.018	127	5	474	18.66	132	5.20	104462

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

## peck feed control

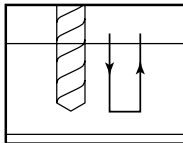


Peck Feed Control Unit

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.

D4	1" (25mm) stroke	92282
D5	2" (50mm) stroke	92292
D6	3" (75mm) stroke	92302

## dwell control

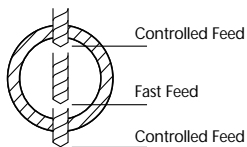


Dwell Control

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.

E1	Dwell Control Unit Complete	92372
-	Dwell for AFD60	78482

## skip feed control



Skip Drilling

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

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

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