

**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**

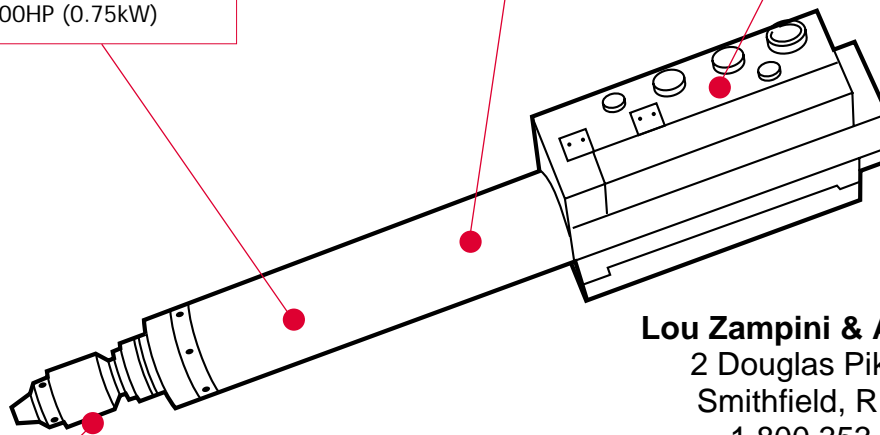
AFTE270	0.24HP (0.18kW)
AFTE470	0.50HP (0.38kW)
AFTE480	1.00HP (0.75kW)

**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.

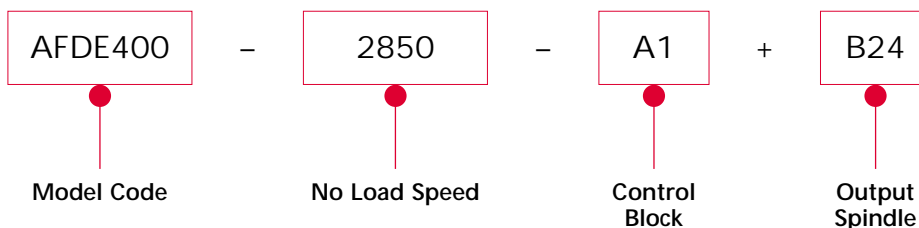
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<sup>(1)</sup> Not required on AFTE models.

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

# How to Order



## 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 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480	COLLET TYPE (SEE PAGE 36)
	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	52362	104062	-	-	-	C
	19-95	0.75-3.74	9.50	0.374	-	106662	204183	106672	-	-	-	D
	41.1-109.9	1.62-4.33	7.00	0.276	-	92172	52462	104022	-	-	-	C
3 inline	20.5-55.5	0.81-2.19	7.00	0.276	-	92182	52442	104032	-	-	-	C
3 PCD	27.3-96.2	1.07-3.79	7.00	0.276	-	92192	52392	104042	-	-	-	C
4 PCD	41.1-109.9	1.62-4.33	7.00	0.276	-	92202	52422	104052	-	-	-	C
Fixed	-	-	-	-	-	MSD100	MSD200	MSD200	MSD300	-	-	-

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

specification

Multiple Spindle Head Part Numbers												
NUMBER OF SPINDLES	SPINDLE CENTRES OR PCD		MAXIMUM COLLET SIZE		AFD205 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480	COLLET TYPE (SEE PAGE 36)
	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	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	204193	106692	-	-	106662	D
	41.1-109.9	1.62-4.33	7.00	0.276	-	92242	-	104072	-	-	92172	C
3 inline	20.5-55.5	0.81-2.19	7.00	0.276	-	92252	-	104082	-	-	92182	C
3 PCD	27.3-96.2	1.07-3.79	7.00	0.276	-	92262	-	104092	-	-	92192	C
4 PCD	41.1-109.9	1.62-4.33	7.00	0.276	-	92272	-	104102	-	-	92202	C
Fixed	-	-	-	-	-	MST100	MST200	MST200	MSD300	-	MSD100	-

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

specification

Multiple Spindle Head Part Numbers						
AFD205 AFD215 AFDE200	AFD415 AFDE400 AFDE410	AFD60	AFDE600 AFDE610 AFDE620	AFDE700 AFDE710	AFTE270	AFTE470 AFTE480
K32	B24	-	B24	T35	K32	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

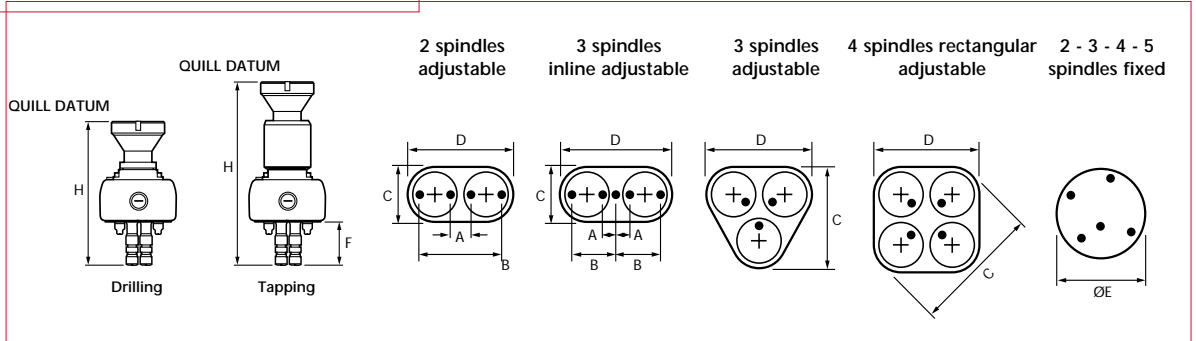
AFD415-3400-A6 + B24 + 92182

AFDE610-900-A1 + B24 + 104092

AFD60-2100 + 52442

AFDE70-950-A1-T35 + MSD300

## Multiple Spindle Heads dimensions



### adjustable spindle

specification

PART NO.	MAXIMUM SPEED	MINIMUM/MAXIMUM CENTRES		PCD		MINIMUM		MAXIMUM		C		D		F		H	
	rpm	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins	mm	ins
174183	5300	9.5-66.7	0.37-2.63	-	-	-	-	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	-	-
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	7000	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	-	-
106662	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	212	8.35	-	-
92172	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72	-	-
92182	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72	-	-
92192	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	196	7.72	-	-
92202	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	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	18.4-64	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	253	9.96	-	-
106682	1500	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	261.5	10.30	-	-
92242	1400	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	253	9.96	-	-
92252	1400	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	253	9.96	-	-
92262	1400	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	253	9.96	-	-
92272	1400	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	253	9.96	-	-
52362	8500	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	193.5	7.62	-	-
204183	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	188	7.40	-	-
52462	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	193.5	7.62	-	-
52442	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	193.5	7.62	-	-
52392	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	193.5	7.62	-	-
52422	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	193.5	7.62	-	-
204193	700	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260.4	10.25	-	-
104062	8500	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72	-	-
106672	5300	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	211	8.31	-	-
104022	8500	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72	-	-
104032	8500	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	196	7.72	-	-
104042	8500	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	196	7.72	-	-
104052	8500	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	196	7.72	-	-
104122	1400	18.4-87.3	0.72-3.44	-	-	-	-	62	2.44	115	4.53	60	2.36	196	7.72	-	-
106692	1500	19-95	0.75-3.74	-	-	-	-	76	2.99	124	4.88	68.3	2.69	260	10.24	-	-
104072	1400	41.1-109.9	1.62-4.33	-	-	-	-	62	2.44	137	5.39	60	2.36	233.5	9.19	-	-
104082	1400	20.5-55.5	0.81-2.19	-	-	-	-	62	2.44	137	5.39	60	2.36	233.5	9.19	-	-
104092	1400	-	-	27.3	1.07	96.2	3.79	108	4.25	116	4.57	60	2.36	233.5	9.19	-	-
104102	1400	-	-	41.1	1.62	109.9	4.33	138	5.43	116	4.57	60	2.36	233.5	9.19	-	-

### 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.

## 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			
ins	mm	A	B	C	D
0.020	0.5			52582	
0.024	0.6			52582	
0.028	0.7			52582	
0.031	0.8			52582	
0.035	0.9			52582	
0.039	1	60002	39442	52582	
0.043	1.1	60022	39452	52592	
0.047	1.2	60032	39462	52592	
0.051	1.3	60042	39472	52592	
0.055	1.4	60052	39482	52592	
0.059	1.5	60062	39492	52592	
0.063	1.6	60072	27852	52602	
0.067	1.7	60082	39502	52602	
0.071	1.8	60092	27862	52602	
0.075	1.9	60102	39522	52602	
0.079	2	60122	27872	52602	39302
0.083	2.1	60132	27882	52622	39322
0.087	2.2	60142	27892	52622	39332
0.091	2.3	60152	27902	52622	39342
0.094	2.4	60162	27922	52622	39352
0.098	2.5	60172	27932	52622	39362
0.102	2.6	60182	27942	52632	39372
0.106	2.7	60192	27952	52632	39382
0.110	2.8	60202	27962	52632	39392
0.114	2.9	60222	27972	52632	39402
0.118	3	60232	27982	52632	39422
0.122	3.1	60242	27992	52642	39432
0.126	3.2	60252	28002	52642	34902
0.130	3.3	60262	28032	52642	34932
0.134	3.4	60272	28042	52642	34942
0.138	3.5	60282	28052	52642	34952
0.142	3.6	60292	28062	52642	34962
0.146	3.7	60302	28082	52642	34982
0.150	3.8	60322	28092	52642	34992
0.154	3.9	60332	28102	52642	35002
0.157	4	60342	28122	52642	35022
0.161	4.1		28132	52652	35032
0.165	4.2		28142	52652	35042
0.169	4.3		28152	52652	35052
0.173	4.4		28162	52652	35062
0.177	4.5		28172	52652	35072
0.181	4.6		28182	52652	35082
0.185	4.7		28192	52652	35092
0.189	4.8		28202	52652	35102
0.193	4.9		28222	52652	35122
0.197	5		28232	52652	35132

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