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

Model Type – *Pages 6-27*

Pneumatic Feed and Drive

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

Pneumatic Feed, Electric Drive

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

Electric Feed and Drive via Leadscrew

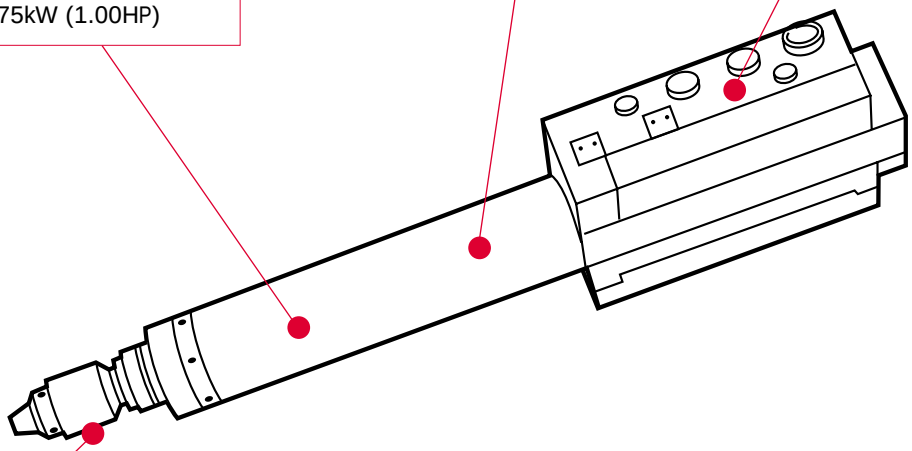
AFTE270	0.18kW (0.24HP)
AFTE470	0.38kW (0.50HP)
AFTE480	0.75kW (1.00HP)

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[1]	– Automatic cycle
A6 – Simple type[1][2]	– Remote cycle control
A7 – Leadscrew type	– PNP
A8 – Leadscrew type	– NPN



Output Spindle[2] – *Pages 30/31*

Output spindle to be supplied.

[1] Not required on AFTE models.
[2] Does not apply for AFD60 and AFT60.

How to Order

AFDE400	–	2850	–	A1	+	B24
Model Code		**No Load Speed**		**Control Block**		**Output Spindle**

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								
	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
2	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	19.0-57.1	0.75-2.25	9.50	0.374	–	107552	107572	107562	–	–	–	D
3 PCD	27.9-104.1	1.01-4.01	9.50	0.374	–	107582	107602	107592	–	–	–	D
4 PCD	42.7-118.9	1.68-4.68	9.50	0.374	–	–	107622	107612	–	–	–	D
Fixed	–	–	–	–	–	MSD100	MSD200	MSD200	MSD300	–	–	–

tapping[1]

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								
	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
2	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	19.0-57.1	0.75-2.25	9.50	0.374	–	107632	107652	107642	–	–	107552	D
3 PCD	27.9-104.1	1.01-4.01	9.50	0.374	–	107662	107682	107672	–	–	107582	D
4 PCD	42.7-118.9	1.68-4.68	9.50	0.374	–	–	107702	107692	–	–	–	D
Fixed	–	–	–	–	–	MST100	MST200	MST200	MSD300	–	MSD100	–

output spindles for use with multiple spindle heads[2]

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

[1] All tapping heads incorporate a reversing gearbox except heads for AFDE700/710 and AFTE270/470/480

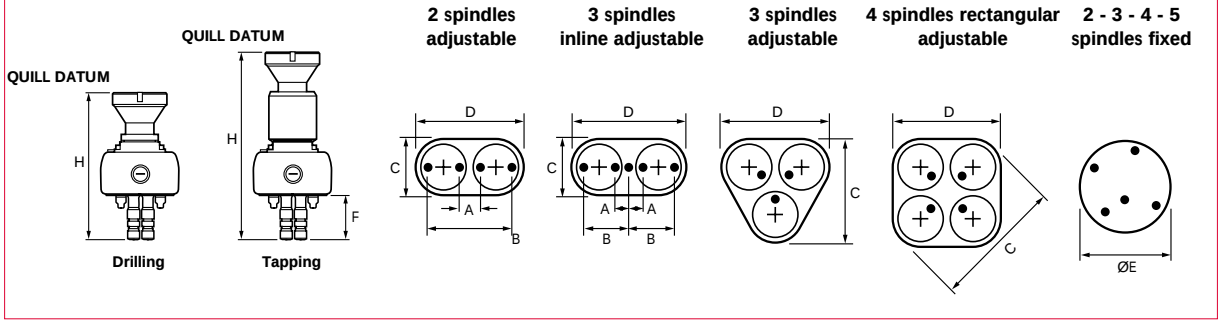
[2] **How to order**

Examples:

AFDE200-2850-A1 + K32 + 174183
AFD415-3400-A6 + B24 + 107552
AFDE610-900-A1 + B24 + 107672

AFD60-2100 + 52362
AFDE70-950-A1-T35 + MSD300

Multiple Spindle Heads dimensions



adjustable spindle

specification

PART NO.	MAXIMUM SPEED	MINIMUM/MAXIMUM CENTRES		PCD	MINIMUM	PCD	MAXIMUM	C		D		F		H	
	rpm	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	2.27	50.8	2.00	175.4	6.91
92152	5300	12.7 - 64	0.50 - 2.52	–	–	–	–	50.8	2.00	83	2.27	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	2.27	50.8	2.00	169.5	6.67
204173	5300	12.7 - 64	0.50 - 2.52	–	–	–	–	50.8	2.00	83	2.27	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.

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 A	B	C	D
mm	ins				
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	34902
3.3	0.130	60262	28032	52642	34932
3.4	0.134	60272	28042	52642	34942
3.5	0.138	60282	28052	52642	34952
3.6	0.142	60292	28062	52642	34962
3.7	0.146	60302	28082	52642	34982
3.8	0.150	60322	28092	52642	34992
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 A	B	C	D
mm	ins				
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