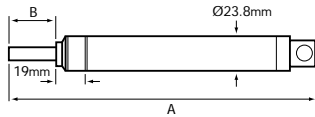


adjustable feed control unit



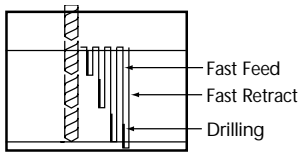
Adjustable Hydraulic Control Unit

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

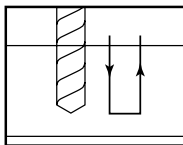


Peck Feed Control Unit

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

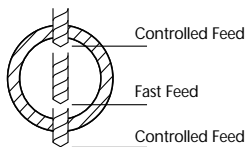


Dwell Control

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.