

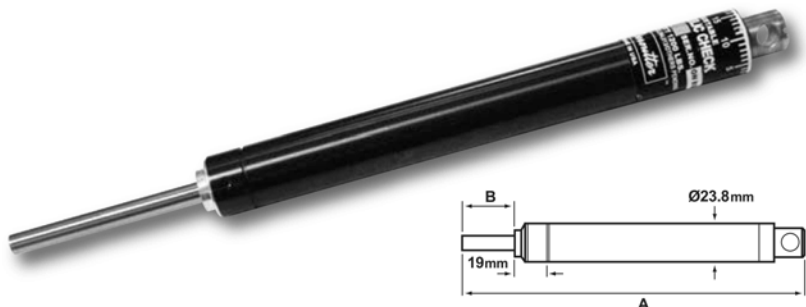
Accessories

AFD Control Options ■



Adjustable Hydraulic
Control Unit

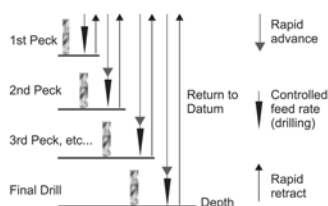
H.C.U



	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

Each of these H.C.U unit needs the conversion Kit Part Number 94982 to be installed

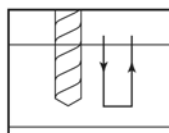
Peck feed control



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 A1 (0-10 seconds)

STROKE		PART NO.
D4	25mm (1")	92282
D5	50mm (2")	92292
D6	75mm (3")	92302

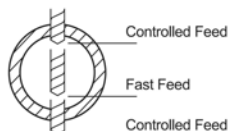
Dwell control



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

DESCRIPTION		PART NO.
E1	Dwell Control Unit Complete	92372

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 feeds, and fast travel through the empty space.

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