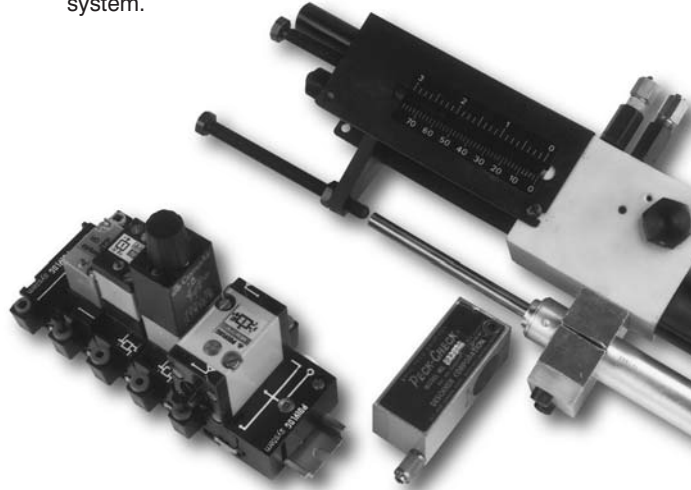


# Control Options & Accessories

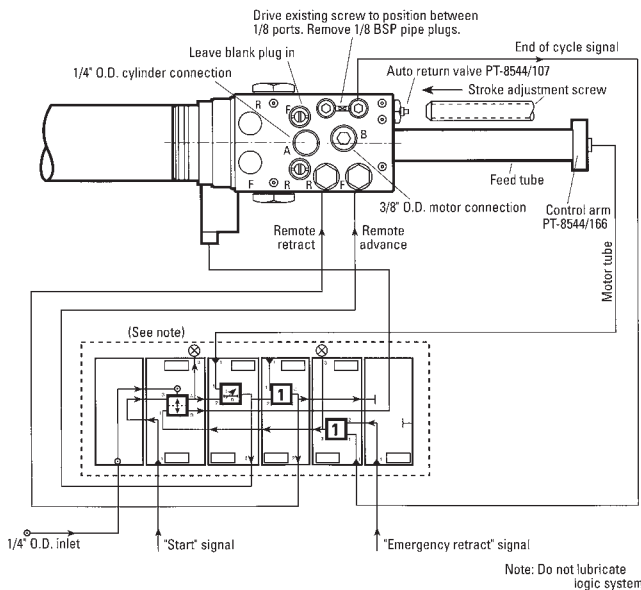
## Peck Feed Kits - PT8544/201 & PT8544/202

- Used when it is necessary to drill a hole in more than one step in order to clear swarf and to provide for coolant penetration.
- Drill will advance to work piece and drill at a constant feed rate for a predetermined time.
- The unit will then rapid retract to the full back position and then rapid advance to within 0.2mm of the point at which drilling was interrupted and will again drill at a controlled rate.
- Cycle repeats until the unit reaches the depth required, at which time it retracts and the peck feed
- The depth of each step is controlled by the time delay in the control module.
- The control circuit used in the module is shown below, for an application that requires the circuits to be included in a main control system.



Peck Feed Kit	Stroke (mm)
PT8544/201	25
PT8544/202	50

### Peck Control Circuit



### To set up Peck Control Unit

1. Select Peck Check that has at least 6mm more stroke than desired hole depth.
2. Set required Feed Rate on Hydraulic Feed Unit. Note: Drill bit must be more than 6mm from the work piece in rest condition.
3. Set Depth Stop to correct depth desired.
4. Set Hydraulic Feed Unit Depth Screw to engage piston approximately 3mm before drill bit engages the work piece.
5. Set Time Adjustment to obtain required number of steps. The rule of thumb is to set the first depth 3 times the drill diameter.
6. Remote retract and advance signals must be connected to control head through valves supplied.