

Self Feed Units – The Selection Process

ITEMS	NOTES
1. Select Base Unit See page 4	
a) Pneumatic or Electric	
b) Correct rpm	b) Metric $R = \frac{318.5 \times \text{Surface Metres Per Minute}}{\text{Drill dia. (mm)}}$ b) Imperial $R = \frac{3.82 \times \text{Surface Feet Per Minute}}{\text{Drill dia. (inches)}}$
2. Select Front End Attachment See page 18-20	
a) Chuck	<ul style="list-style-type: none"> Base drill standard with 10 mm ($\frac{3}{8}$") chuck.
b) Collet Holder & Collet	<ul style="list-style-type: none"> For Tappers the tapping head is included (single spindle only)
c) Multiple Spindle Head	<ul style="list-style-type: none"> Multiple spindle head collets need to be ordered separately
d) Offset Head	<ul style="list-style-type: none"> For drilling applications
e) Spindle Positioners	<ul style="list-style-type: none"> To facilitate rapid changeover where alternative settings are required on Multi-Spindle heads
3. Selecting Mounting Bracket See page 21-23	
a) Nose angle bracket	
b) Nose flange	
c) Column and clamp options	
4. Select Control Options See page 24-27	
a) Return limit kit	<ul style="list-style-type: none"> Sends out a positive signal at the retract end of self feed cycle
b) Dwell Control	<ul style="list-style-type: none"> Used to dwell for a set period of time in the extended position
c) Hydraulic feed control	<ul style="list-style-type: none"> Sets a constant feed rate through the material
d) Peck feed kit	<ul style="list-style-type: none"> Allows pecking of unit for drilling deep holes
e) Swarf exclusion kit	<ul style="list-style-type: none"> Protects drill unit from swarf
f) Exhaust collector	<ul style="list-style-type: none"> Reduces noise and protects drill unit from swarf. Allows piping off exhaust
g) Bottom limit kit	<ul style="list-style-type: none"> Sends a signal when drill unit is fully extended
h) PLC interface module	<ul style="list-style-type: none"> Permits Programmable Logic Controller to communicate with Self Feed Units
i) Skipcheck Unit	<ul style="list-style-type: none"> Enables drill units to economically transit tubular sections