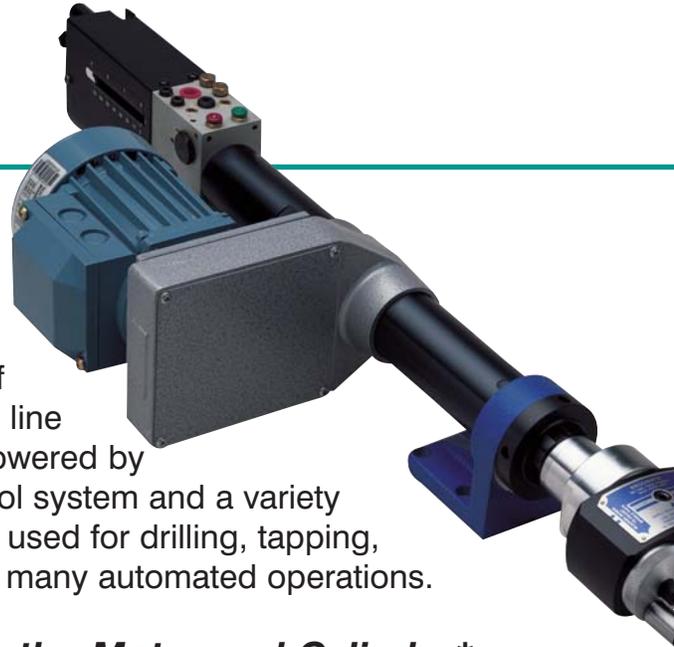


Self Feed Units

A Versatile Unit to Meet a Wide Range of Needs

The Self Feed Unit combines a motor with a double acting, self lubricating cylinder into a clean line package. The motor can be powered by air or electricity. With the control system and a variety of attachments, the unit can be used for drilling, tapping, screwdriving and nutrunning in many automated operations.



Single or Double Feed to the Motor and Cylinder*

Incorporated into the design of the tool, this feature enables both the motor and the cylinder to be fed with air through one connection or separately through two connections which can have different air pressures – an advantage when drilling or tapping small holes.

*Applies to pneumatic units only.

Adjustable Stroke Length

The unit can be set for any stroke from 8mm to 75mm ($\frac{5}{16}$ " to 3") to provide for deep hole drilling applications, while providing a greater clearance for fixtures and indexing tables etc. The stroke is adjusted by means of an adjustment screw. An indicator on the upper guard makes set up quick and easy.

Double Acting Air Cylinder to Maintain Set Thrust

The main advantage delivered by this method of applying thrust is that the set thrust can be maintained throughout the full 75mm (3") stroke. This provides greatly improved cycle times as the drill bit will cut more efficiently. It will also enable the feed rate to be accurately controlled, thus prolonging drill life and preventing tap breakage. The control head incorporates valves that control the rate of feed and retraction of the cylinder, as well as porting for dwell control. For manual control, start and stop push buttons are provided, while for partial or fully automatic control, check valves are supplied.

