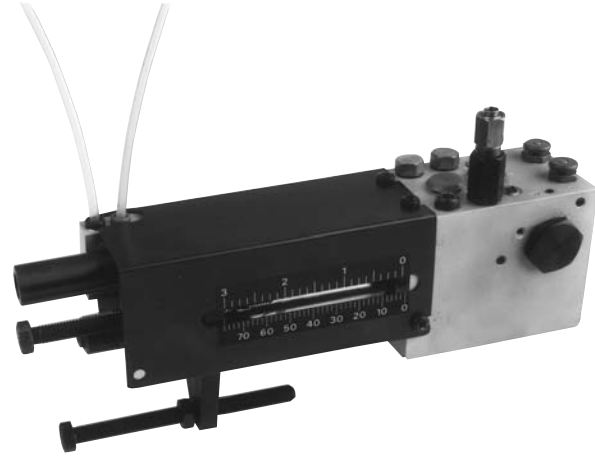


## Control Options & Accessories

### Return Limit Kit - PT8544/120

- 3 way NC valve that provides a signal when the self feed unit is fully retracted.
- Ideal for sequential circuits in conjunction with the motor tube signal.
- Accepts 4mm O.D. tubing.
- Mounts directly to the upper guard (fittings)



### Dwell Control Kit - PT8544/170

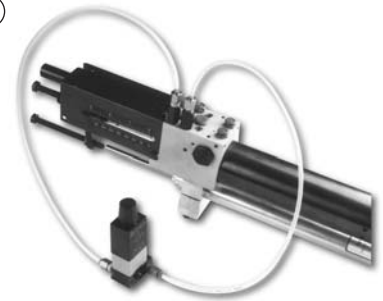
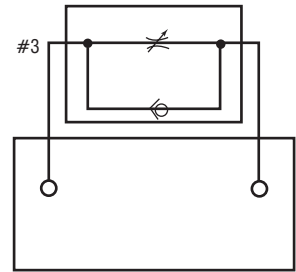
- Used to delay the automatic return signal from retracting the drill head for up to 1 second for depth control within 0.2mm or for counterbore or countersink application.
- Kit consists of a time delay and all necessary fittings and plugs.

**Note:** For a time delay of over 1 second, please specify.

#### To install

1. Install the set screw in the same manner as for bottom limit signal.
2. Connect the 1 port of the timer to the bottom limit port on the control head using the tubing supplied.
3. Connect the 3 port of the timer to the other port on the control head. (10) (Fig. 1, page 13).
4. Set timer for delay required.

#### SCHEMATIC



### Hydraulic Feed Control Units

- Used for applications requiring constant feed rate for varying loads.
- Used to reduce burrs and snatch on breakthrough when drilling through holes.
- Permits rapid advance of the head to the work, then controlled rate during the work cycle.
- Kits are complete with all necessary fittings. Standard tool guard protects against pinch



| Stroke     | 25(mm)      | 50(mm)      |
|------------|-------------|-------------|
| Kit Number | PT8544/122B | PT8544/122C |