Concentric Collecting System

- Utilizing our existing Constant Feed Drill and Peck Feed Drill designs we are now able to offer both units with the added benefit of Concentric Collet jig mounting.

Ergonomics and Operator Comfort
- High power to weight ratio
- Simple to use system for ease of handling

Features
- All the great features of the Constant Feed Drill and Peck Feed Drill
- Virtually all popular sizes of collecting system can be accommodated
- Tailor made design and manufacture; service available

Reliability and Servicing
- Modular construction makes servicing easy.
- Minor and major service kits ensure service is performed properly the first time.
Concentric Colleting System

How to order ...

Constant Feed Drill  
---
**MODEL**  
---
**FREE SPEED**  
---
**STD. CHUCK SIZE**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>FREE SPEED</th>
<th>STD. CHUCK SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>CFD-DR750-P20000</td>
<td>20000</td>
<td>8</td>
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<tr>
<td>CFD-DR750-P6000</td>
<td>6000</td>
<td>8</td>
</tr>
<tr>
<td>CFD-DR750-P4100</td>
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<tr>
<td>CFD-DR750-P3300</td>
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<td>CFD-DR750-P2700</td>
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<tr>
<td>CFD-DR750-P750</td>
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</tr>
<tr>
<td>CFD-DR750-P400</td>
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</table>

Concentric collet  
---
(follow to next page to specify)

Hydraulic Control Unit

---
Pt No. 91942 – 25mm (1") stroke  
Pt No. 91952 – 50mm (2") stroke

How to order ...

Peck Feed Drill  
---
**MODEL**  
---
**FREE SPEED**  
---
**STD. CHUCK SIZE**

<table>
<thead>
<tr>
<th>MODEL</th>
<th>FREE SPEED</th>
<th>STD. CHUCK SIZE</th>
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<tbody>
<tr>
<td>PECK-CFD-DR750-P20000</td>
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<td>PECK-CFD-DR750-P4400</td>
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<tr>
<td>PECK-CFD-DR750-P400</td>
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</table>

Concentric collet  
---
(follow to next page to specify)

Hydraulic Control Unit

---
Pt No. 91972 – 25mm (1") stroke  
Pt No. 91982 – 50mm (2") stroke
Concentric Colleting System

The Concentric Collet automatically clamps to the fixture plate when the drill cycle is initiated. Once the drilling cycle is complete the concentric collet grip is retained until the interlock switch is pressed. The feed drill can then be removed from the fixture plate and moved to the next drilling operation.

Typical Concentric Collet Tooling:

Data required to specify concentric collet:

- Collet diameter (max. Ø31.75mm / Ø1.25") ________________
- Collet length ____________________________
- Standoff (jig plate thickness + standoff pad thickness) ________________
- Hole diameter (max 10mm / 3/8") ________________
- Max cutter body size _____________________
- Cutter length _____________________________
- Thickness of material to be drilled (max <50mm / <2") ________________
- Cutter type  
  Drill __________________________
  Combination Drill / Reamer __________________
  Combination Drill / Countersink __________________
  Other (please specify) ____________________
Accessories

Hydraulic Control Unit

<table>
<thead>
<tr>
<th>MAX. STROKE</th>
<th>A</th>
<th>B</th>
<th>PART NO.</th>
<th>USED ON</th>
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<tbody>
<tr>
<td>25 1</td>
<td>199</td>
<td>7.83</td>
<td>91942</td>
<td>CFD</td>
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<tr>
<td>50 2</td>
<td>215</td>
<td>8.46</td>
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<td>PECK-CFD</td>
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Bayonet plates

<table>
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<tr>
<th>A</th>
<th>Ø B</th>
<th>C</th>
<th>PART NO.</th>
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</thead>
<tbody>
<tr>
<td>Locating centres - 38mm (1.49&quot;)</td>
<td>25</td>
<td>1</td>
<td>215</td>
</tr>
<tr>
<td>Locating centres - 45mm (1.77&quot;)</td>
<td>50</td>
<td>2</td>
<td>292</td>
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CFD and PECK-CFD

ACCESSORIES INCLUDED

<table>
<thead>
<tr>
<th>ITEM</th>
<th>PART NO.</th>
</tr>
</thead>
</table>
| Chuck (without key) capacity 8mm - ¼"
Chuck Key
Chuck with key capacity 10mm (⅝")
Chuck Key
Tooling Tube ⅜" - 16 UN LH thread | 410203 410213 31132 29232 469883 |

OPTIONAL ACCESSORIES

<table>
<thead>
<tr>
<th>ITEM</th>
<th>PART NO.</th>
</tr>
</thead>
</table>
| Tooling Tube blank (for local customisation)
Hydraulic Control Unit - 25mm (1") stroke (for use with CFD only)
Hydraulic Control Unit - 50mm (2") stroke (for use with CFD only)
Hydraulic Control Unit - 50mm (2") stroke (for use with PECK-CFD only)
Hydraulic Control Unit - 25mm (1") stroke (for use with PECK-CFD only)
Dust Extraction kit
Collet spindle
Collet nut
Collet capacity ø 2.4mm to 3.2mm (⅜")
Collet capacity ø 5.2mm to 6mm (⅝")
Collet capacity ø 5.55mm to 6.35mm (⅞")
Collet capacity ø 7.2mm to 8mm (⅝")
Collet capacity ø 8.7mm to 9.5mm (⅞") | 471873 91942 91952 91972 91982 205 047 529 0 915 523 023 0 615 607 144 0 615 526 061 0 615 526 062 0 615 526 063 0 615 526 064 0 615 526 065 0 |