

CFD - Portable Feed Drill & PECK-CFD - Portable Peck Feed Drill

- These tools are designed to be fixture mounted and to produce high quality holes during the drilling process. Consequently, they provide optimum operator comfort and do not depend on the operator to exert the forces required for manual drilling.

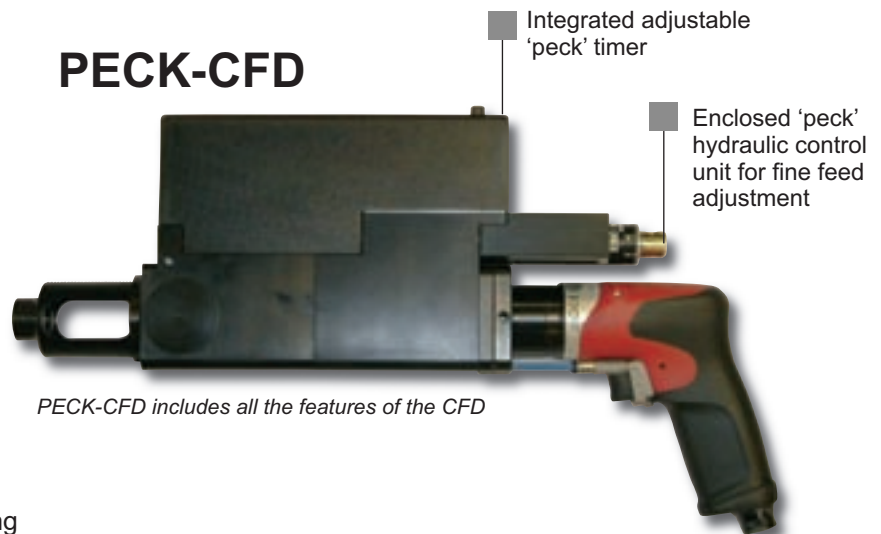
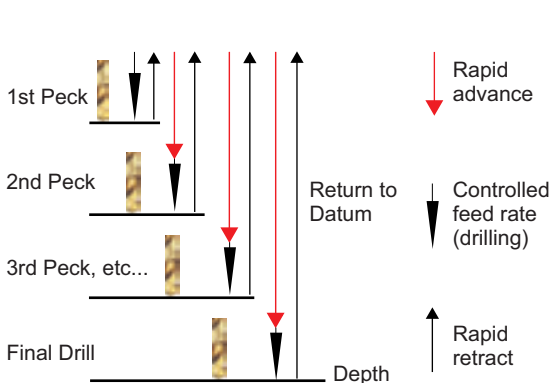
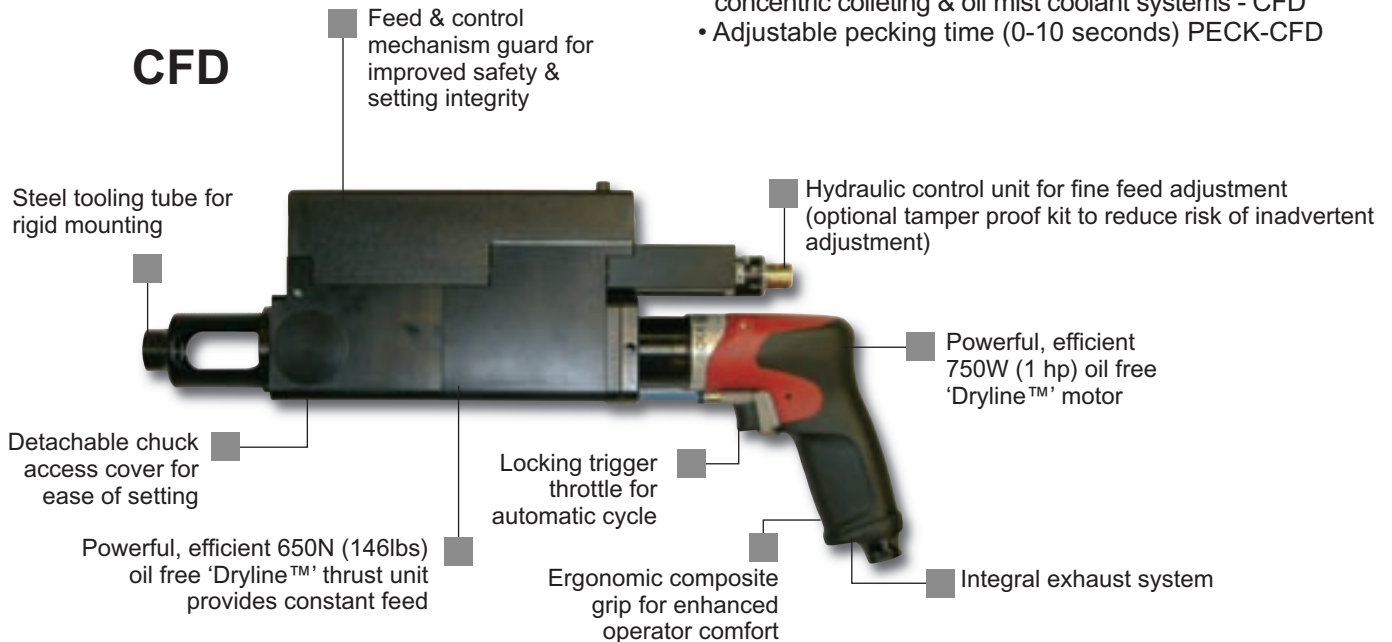
Ergonomics & Operator Comfort

- High Power to Weight ratio
- Lightweight for ease of handling to fixture mount

- PECK-CFD - Utilising our existing Constant Feed Drill design with the added advantage of 'peck' drilling.

Features

- Powered by a full 750W (1 hp) oil free motor
- Feed unit provides in excess of 650N (146lbs) thrust
- Working stroke 50mm (2")
- Chuck capacity Ø10mm max. (3/8")
- Adjustable dwell control (0-4 seconds) - ideal for countersinking & spotfacing application
- Depth repeatability $\leq 0.0127\text{mm}$ ($\leq 0.0005\text{"}$)
- Integrated feed ports to activate external accessories e.g. concentric colleting & oil mist coolant systems - CFD
- Adjustable pecking time (0-10 seconds) PECK-CFD



Reliability and Servicing

- Modular construction provides ease of servicing
- Minor and major service kits available to ensure a 'right first time' service

Portable Feed Drill

Drilling Speed Selection Guide

FREE SPEED	TITANIUM		STAINLESS STEEL		SOFT CAST IRON MILD STEEL		ALUMINUM BRASS COPPER		COMPOSITE	
rpm			9-15 m/min	30-50 ft/min	20-25 m/min	65-115 ft/min	50-80 m/min	165-265 ft/min	50-100 m/min	165-330 ft/min
Drill Ø										
20000	-	-	-	-	-	-	2mm	5/64"	4mm	5/32"
6000	-	-	-	-	-	-	4mm	5/32"	5mm	3/16"
4100	-	-	-	-	-	-	6mm	1/4"	8mm	5/16"
3300	-	-	-	-	3mm	1/8"	8mm	5/16"	10mm	3/8"
2700	-	-	-	-	4mm	5/32"	10mm	3/8"	-	-
1300	2mm	5/64"	4mm	5/32"	9mm	11/32"	-	-	-	-
750	3mm	1/8"	7mm	9/32"	10mm	3/8"	-	-	-	-
400	3mm	1/8"	7mm	9/32"	10mm	3/8"	-	-	-	-

CFD - PECK-CFD



Max. working stroke 50mm (2")

MODEL		FREE SPEED	STD. CHUCK SIZE		MOTOR POWER		DYNAMIC THRUST		WEIGHT		AIR FLOW		AIR INLET	HOSE INT. Ø	
		rpm	mm	in.	kW	Hp	N	lbf	kg	lb	l/s	cfm	BSP/NPT	mm	in.
CFD-DR750-P20000	PECK-CFD-DR750-P20000	20000	8	5/16	0.75	1.00	650	146	4.5	9.90	14	30	1/4	10	3/8
CFD-DR750-P6000	PECK-CFD-DR750-P6000	6000	8	5/16	0.75	1.00	650	146	4.5	9.90	14	30	1/4	10	3/8
CFD-DR750-P4100	PECK-CFD-DR750-P4100	4100	8	5/16	0.75	1.00	650	146	4.5	9.90	14	30	1/4	10	3/8
CFD-DR750-P3300	PECK-CFD-DR750-P3300	3300	10	3/8	0.75	1.00	650	146	4.5	9.90	14	30	1/4	10	3/8
CFD-DR750-P2700	PECK-CFD-DR750-P2700	2700	10	3/8	0.75	1.00	650	146	4.5	9.90	14	30	1/4	10	3/8
CFD-DR750-P1300	PECK-CFD-DR750-P1300	1300	10	3/8	0.75	1.00	650	146	5.0	11.00	14	30	1/4	10	3/8
CFD-DR750-P750	PECK-CFD-DR750-P750	750	10	3/8	0.75	1.00	650	146	5.0	11.00	14	30	1/4	10	3/8
CFD-DR750-P400	PECK-CFD-DR750-P400	400	10	3/8	0.75	1.00	650	146	5.0	11.00	14	30	1/4	10	3/8

How to order...

Constant Feed Drill



Hydraulic Control Unit

PART NUMBER	MODEL	FREE SPEED	STD. CHUCK SIZE	
		rpm	mm	in.
205 147 221 4	CFD-DR750-P20000	20000	8	5/16
205 147 220 4	CFD-DR750-P6000	6000	8	5/16
205 147 219 4	CFD-DR750-P4100	4100	8	5/16
205 147 218 4	CFD-DR750-P3300	3300	10	3/8
205 147 217 4	CFD-DR750-P2700	2700	10	3/8
205 147 216 4	CFD-DR750-P1300	1300	10	3/8
205 147 215 4	CFD-DR750-P750	750	10	3/8
205 147 214 4	CFD-DR750-P400	400	10	3/8

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



For alternative chuck or collet spindle, please select from accessories section.

How to order...

Peck Feed Drill



Hydraulic Control Unit

PART NUMBER	MODEL	FREE SPEED	STD. CHUCK SIZE	
		rpm	mm	in.
205 147 367 4	PECK-CFD-DR750-P20000	20000	8	5/16
205 147 366 4	PECK-CFD-DR750-P6000	6000	8	5/16
205 147 365 4	PECK-CFD-DR750-P4100	4100	8	5/16
205 147 364 4	PECK-CFD-DR750-P3300	3300	10	3/8
205 147 363 4	PECK-CFD-DR750-P2700	2700	10	3/8
205 147 362 4	PECK-CFD-DR750-P1300	1300	10	3/8
205 147 361 4	PECK-CFD-DR750-P750	750	10	3/8
205 147 360 4	PECK-CFD-DR750-P400	400	10	3/8

Pt No. 91972 – 25mm (1") stroke
Pt No. 91982 – 50mm (2") stroke



For alternative chuck or collet spindle, please select from accessories section.

Concentric Colleting System

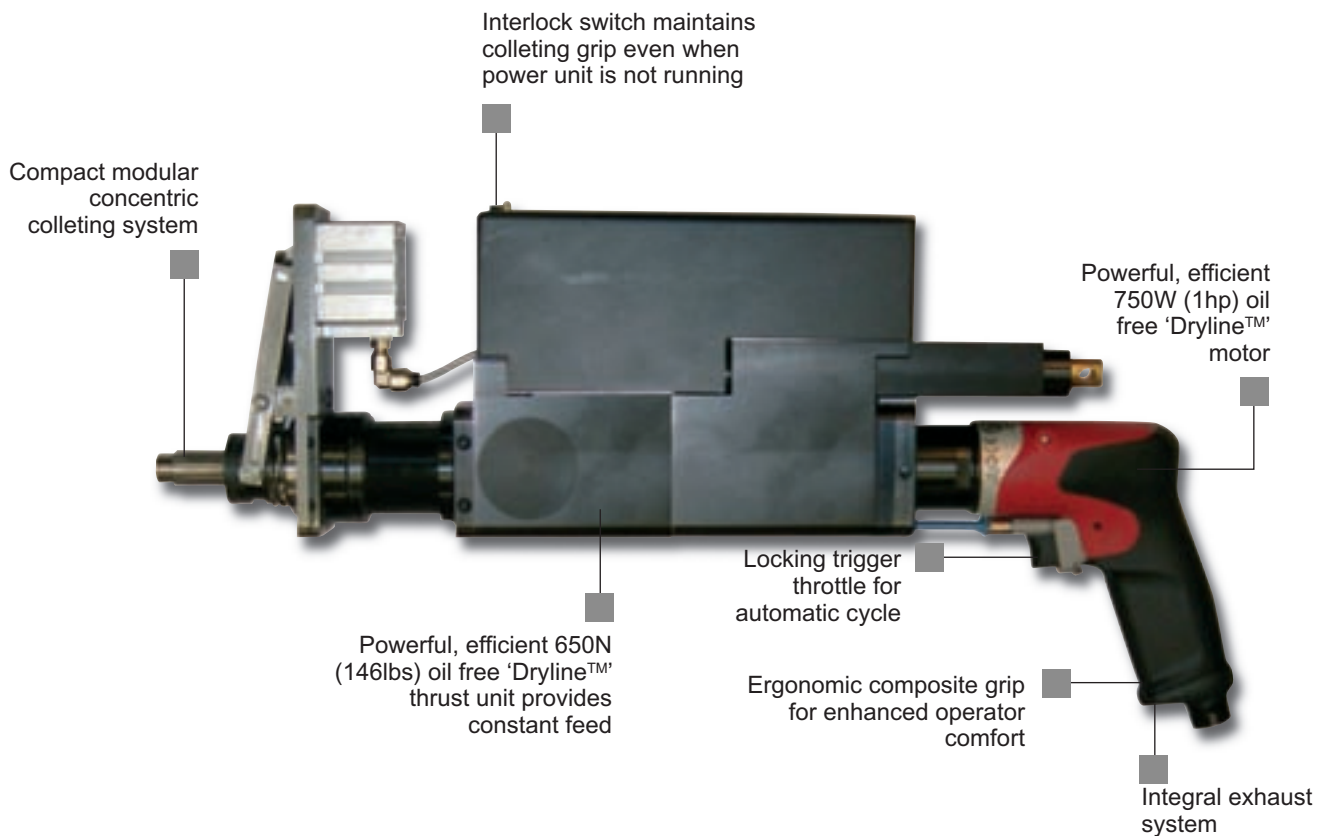
- Utilising our existing Constant Feed Drill & Peck Feed Drill designs we are now able to offer both units with the added benefit of Concentric Collet jig mounting

Ergonomics & 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 colleting system can be accommodated
- Tailor made design & manufacture service available



Reliability & Servicing

- Modular construction provides ease of servicing
- Minor & major service kits available to ensure a 'right first time' service

Concentric Colleting System



How to order...

Constant Feed Drill

fitted with

Concentric collet
(refer to next page for specifications)



Hydraulic Control Unit

MODEL	FREE SPEED	STD. CHUCK SIZE	
	rpm	mm	in
CFD-DR750-P20000	20000	8	5/16
CFD-DR750-P6000	6000	8	5/16
CFD-DR750-P4100	4100	8	5/16
CFD-DR750-P3300	3300	10	3/8
CFD-DR750-P2700	2700	10	3/8
CFD-DR750-P1300	1300	10	3/8
CFD-DR750-P750	750	10	3/8
CFD-DR750-P400	400	10	3/8

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



How to order...

Peck Feed Drill

fitted with

Concentric collet
(refer to next page for specifications)

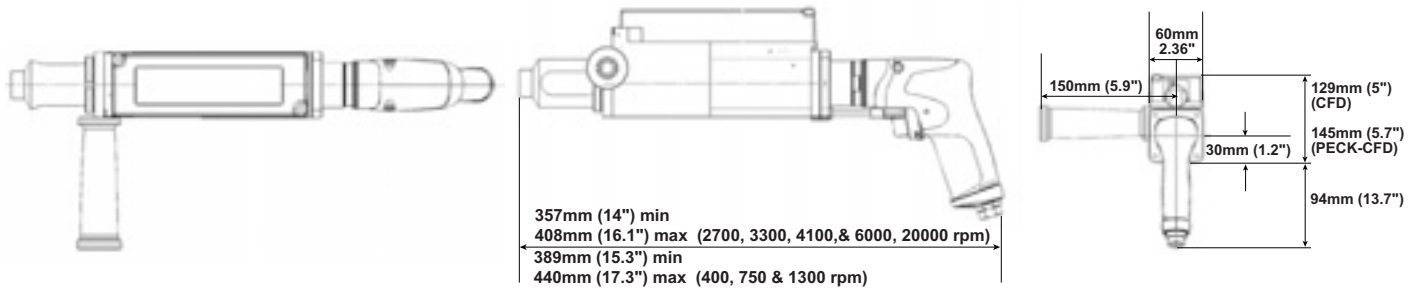


Hydraulic Control Unit

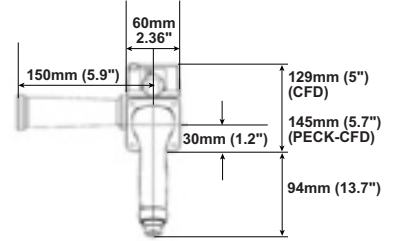
MODEL	FREE SPEED	STD. CHUCK SIZE	
	rpm	mm	in
PECK-CFD-DR750-P20000	20000	8	5/16
PECK-CFD-DR750-P6000	6000	8	5/16
PECK-CFD-DR750-P4400	4100	8	5/16
PECK-CFD-DR750-P3300	3300	10	3/8
PECK-CFD-DR750-P2700	2700	10	3/8
PECK-CFD-DR750-P1300	1300	10	3/8
PECK-CFD-DR750-P750	750	10	3/8
PECK-CFD-DR750-P400	400	10	3/8

Pt No. 91972 – 25mm (1") stroke
Pt No. 91982 – 50mm (2") stroke



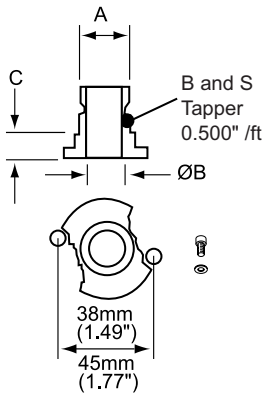
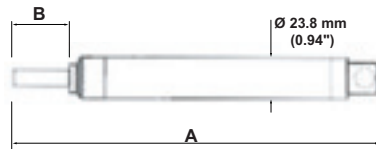


357mm (14") min
 408mm (16.1") max (2700, 3300, 4100, & 6000, 20000 rpm)
 389mm (15.3") min
 440mm (17.3") max (400, 750 & 1300 rpm)



Hydraulic Control Unit

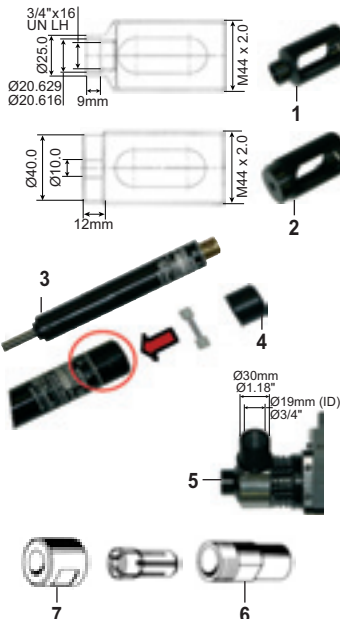
MAX. STROKE	A		B		PART NO.	USED ON	
	mm	in.	mm	in.			
25	1	199	7.83	30.1	1.19	91942	CFD
50	2	276	10.9	55.5	2.19	91952	CFD
25	1	215	8.46	56.3	2.22	91972	PECK-CFD
50	2	292	11.50	81.7	3.22	91982	PECK-CFD



Bayonet plates

	A	Ø B	C	PART NO.
• Locating centres - 38mm (1.49")	3/4" x 16 TPI (LH)	14.2mm (0.56")	9.5mm (3/8")	251053
• Locating centres - 45mm (1.77")	1" x 14 TPI (LH)	19.05mm (3/4")	9.5mm (3/8")	251063
• Locating centres - 45mm (1.77")	1 1/8" x 20 TPI (LH)	19.05mm (3/4")	9.5mm (3/8")	31113

CFD and PECK-CFD



ACCESSORIES INCLUDED

ITEM	20000, 6000 & 4100 rpm	3300, 2700, 1300 & 750 & 400 rpm
• Chuck (without key) capacity 8mm - 5/16"	410203	
• Chuck Key	410213	
• Chuck with key capacity 10mm (3/8")		31132
• Chuck Key		29232
1 Tooling Tube 3/4" - 16 UN LH thread	469883	469883

OPTIONAL ACCESSORIES

ITEM	PART NO
2 Tooling Tube blank (for local customisation)	471873
3 Hydraulic Control Unit - 25mm (1") stroke (for use with CFD only)	91942
3 Hydraulic Control Unit - 50mm (2") stroke (for use with CFD only)	91952
3 Hydraulic Control Unit - 25mm (1") stroke (for use with PECK-CFD only)	91972
3 Hydraulic Control Unit - 50mm (2") stroke (for use with PECK-CFD only)	91982
4 Hydraulic Control Unit Tamper proof HCU cap	110632
5 Dust Extraction kit	205 047 954 3
6 Collet spindle	615 523 023 0
7 Collet nut	615 607 144 0
• Collet capacity ø 2.4mm to 3.2mm (1/8")	615 526 061 0
• Collet capacity ø 5.2mm to 6mm (7/32")	615 526 062 0
• Collet capacity ø 5.55mm to 6.35mm (1/4")	615 526 063 0
• Collet capacity ø 7.2mm to 8mm (5/16")	615 526 064 0
• Collet capacity ø 8.7mm to 9.5mm (3/8")	615 526 065 0