

For Example Only

1. Application

- A. Drill D_c 3/8" "
- B. Material K_c (1020STL) = 290,000 See page 59
- C. Tooling
- 1) Speed V_c 150 SFM (Reference Tool Company or page 58)
- 2) Feed f_n .009 ipr
- D. Stroke > 3-7/8" "

2. Parameters

- A. Thrust F_f 230 ($F_f = .235 \times D_c \times K_c \times f_n$)
- B. Torque M_c 367 ($M_c = .375 \times D_c \times K_c \times f_n$)
- C. HP P_c 1.11 ($P_c = D_c \times K_c \times f_n \times V_c / 132,000$)
- D. RPM N 1528 ($N = SFM \times 3.82 / D_c$)

3. Power feed unit selection

When using standard unit, choose power source (air or hydraulic), spindle nose and RPM.
Example: Assuming that we choose the shortest stroke unit that will work.

Power Source	Model	Thrust	Torque	HP	RPM
Pneumatic	FD56-100	345#	550 in-lb	2	1528
Hydraulic	FD62-100	3000#		2	1528

Work Area

1. Application

- A. Drill D_c _____
- B. Material K_c _____
- C. Tooling
- 1) Speed V_c _____
- 2) Feed f_n _____
- D. Stroke > _____

2. Parameters

- A. Thrust F_f _____
- B. Torque M_c _____
- C. HP P_c _____
- D. RPM N _____

3. Results

Product Selection Work Area

Pneumatic Drilling Units

- ___ **Model FD3-55** Spindle Options – Pg. 50
 ___ ER16 ___ JT1 ___ JT2
- ___ **Model FD3-80** Spindle Options – Pg. 50
 ___ ER16 ___ JT1 ___ JT2
- ___ **Model FD55-80** Spindle Options – Pg. 50
 ___ ER20 ___ JT6
- ___ **Model FD56-100** Spindle Options – Pg. 50
 ___ ER20 ___ JT6 ___ AS22 ___ ER25 ___ JT6Multi

Hydraulic Drilling Units

- ___ **Model FD6-130** Spindle Options – Pg. 51
 ___ ER20 ___ JT6 ___ AS22 ___ MT3 ___ ER25 ___ JT6 Multi ___ MT2
- ___ **Model FD62-100** Spindle Options – Pg. 51
 ___ ER20 ___ JT6 ___ AS22 ___ ER25 ___ JT6 Multi
- ___ **Model FD7-150** Spindle Options – Pg. 52
 ___ AS32 ___ ER40 ___ FB30 ___ MT3A ___ MT3B ___ MT3B Multi
- ___ **Model FD75-100** Spindle Options – Pg. 52
 ___ ER40 ___ FB30 ___ MT3A Multi
- ___ **Model FD8-150** Spindle Options – Pg. 52-53
 ___ ER40 ___ FB30 ___ NT40 ___ ER50 ___ MT4A
 ___ MT4B ___ MT4B Multi
- ___ **Model FD85-100** Spindle Options – Pg. 53
 ___ FB30 ___ MT4A ___ MT4B Multi

Tapping Units

- ___ **Model F2N-60** Spindle Options – Pg. 53
 ___ ER16 ___ JT1
- ___ **Model F6N-60** Spindle Options – Pg. 53
 ___ ER20 ___ JT6 ___ AS22
- ___ **Model F7N-80** Spindle Options – Pg. 53-54
 ___ AS32 ___ MT3B Multi ___ NT40
 ___ FB20
- ___ **Model F8N-90** Spindle Options – Pg. 54
 ___ MT4B Multi ___ AS36 ___ FB30
- ___ **Model F85N-90** Spindle Options – Pg. 54
 ___ FB30

Drilling-Tapping Units

- ___ **Model FTD63-120/80** Spindle Options – Pg. 51
 ___ ER20 ___ JT6* ___ AS22 ___ MT3
 ___ ER25 ___ JT6 Multi ___ MT2
- ___ **Model FTD9-150/90** Spindle Options – Pg. 54
 ___ Drilling Spindle – Flange Only FB45
 ___ Tapping Spindle – Flange Only FB45