



## Hydraulic Power Feed Units, Series A6 & J6

The Holomatic Hydraulic Power Feed Units use a Hydraulic Cylinder with a double acting Piston to develop stroke and thrust. The rear side of the Piston has a greater surface area than the front side. With constant pressure on the front of the Piston at all times, at cycle start, a Directional Control Valve opens to deliver pressurized hydraulic fluid to the rear of the Piston.

The rear area differential overcomes the constant pressure on the front of the Piston and the Spindle will advance. The Spindle moves forward with Cam "A" until the Rapid Travel Valve drops off the Cam and closes. Fluid is now directed through the ad-

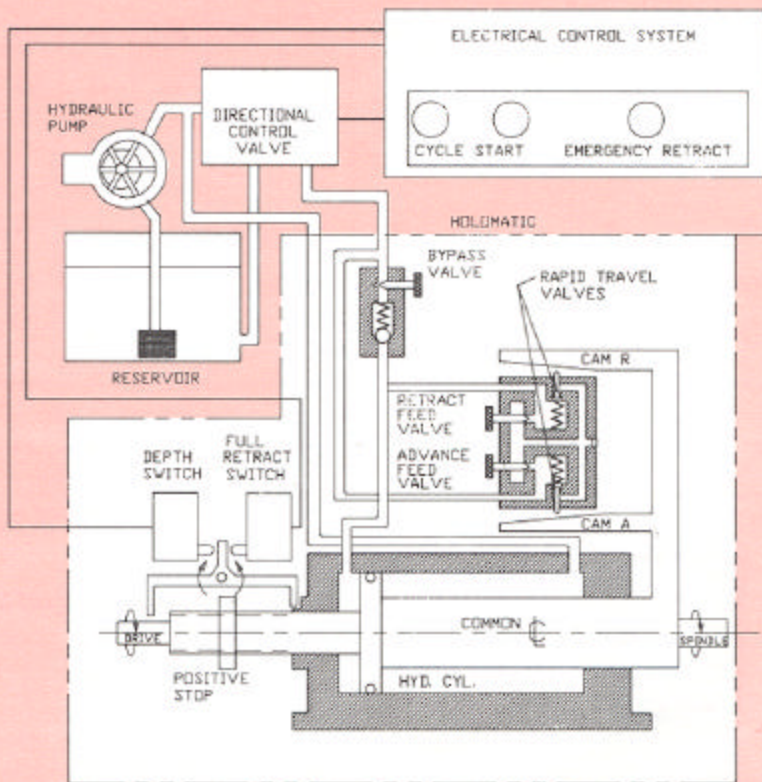
justable Advance Compensating Feed Valve, causing the Piston and Spindle to advance at a slower rate.

The amount of flow through the Feed Valve determines the Spindle feed rate. Opening the Feed Valve increases the amount of flow and increases the rate of Spindle feed. Turning the Feed Valve in the opposite direction will reduce flow and feed rate. The Positive Stop Nut will advance with the Spindle until it mechanically actuates the Depth Switch which shifts the Directional Control Valve to its original position, stopping flow of system pressure to the rear of the Cylinder. The Spindle will retract by the constant pressure on the front of the Piston. The Spindle

continues to retract until the Positive Stop actuates the Full Retract Limit Switch, which signals the end of the cycle.

Cam "R" in units that have a retract feed option, can be adjusted to provide retract feed for back feed applications. An optional Cam Bar can be used to provide rapid travel before retract feed, to allow the Spindle to work from an extended position. A retract midpoint Limit Switch can be furnished for interlock use.

The Positive Stop can be adjusted to provide a precision forward stroke limit. A telescoping Spline is used to transfer the rotational power to the Spindle.



## Hydraulic Systems

Capacity	Stroke	Retract Feed or Extended Stroke Control	Tapping or Threading Capability	Thrust LBS./80 PSI Air*	Deep Hole	Controls			Tooling			Model	Series	New Models	
						Motor Reverse	Dual Feed	Threading Head	Boring Spindle	Spindle Support	Quill Support				
5/8" Drill 7/16"-14 Tap or Thread	2"	x	x	@300 PSI 1050		xx	xx	xx		xx	xx	6290	J		
	2"							xx		xx	xx	6291	J		
	2"	x				x					xx		6294	J	
1-1/4" Drill 1"-8 Tap or Thread	4"	x	x	@500 PSI 2750		xx	xx	xx	xx	xx	xx	6494	A		
	4"							xx		xx	xx	6495	A		
	4"	x				x				xx	xx		6498	A	
	6"	x	x				xx	xx	xx	xx	xx	xx	6694	A	
	6"							xx		xx	xx	xx	6695	A	
	6"	x				x					xx		6698	A	
	10"	x	x				xx	xx	xx			xx	6194	A	
	10"							xx				xx	6195	A	
10"	x			x					xx		6198	A			
1-1/4" Drill 1"-8 Thread Fully Programmable Power Feed Unit	6"	x	x	@500 PSI 4000	x	xx	x	xx	xx	xx	xx	6609	A		

x - Furnished on Unit Shown  
xx - Optional Item

\*Unit thrust shown are to their theoretical stall points. For efficient operation, n thrust requirements in either direction should not exceed 2/3's of values show



Model 6495 Shown

### Standard Features on All Models

- Electric Depth Control
- Rapid Advance
- Advance Feed Control