

**SPECIFICATIONS**  
Ref.: Dwg. 21795-01

<b>Capacity</b>	Taps and threads to 1 inch—8 pitch in mild steel when properly equipped with high torque drive.
<b>Stroke (3 models)</b>	Adjustable 0 to 4 inches. Adjustable 0 to 6 inches. Adjustable 0 to 10 inches.
<b>Cycle Control</b>	Three-way directional control air valve with manual bleeder pilot poppets built in. Use electric solenoid or air pressure operated pilot valves for remote actuation.
<b>Thrust Power</b>	Developed by area differential type air cylinder from factory compressed air supply. Advance thrust is offset by continuous air pressure applied to smaller area retract end of cylinder.
<b>Input Pressure . . .</b>	40 to 150 PSI.
<b>**Developed Thrust . .</b>	Advance—varies from a few ounces in normal operation to 440 lbs. when stalled with 80 PSI air input. Retract—varies from a few ounces in normal operation to 240 lbs. when stalled with 80 PSI air input.
<b>Air Cylinder Displacement</b>	8.5 cubic inches per inch of stroke (total for both directions) when used pressure offset as recommended.
<b>Stroke Movement Control, Air</b>	Elastic action, developed by metering air into rear of cylinder during advance and out of rear of cylinder during retract thru built-in rapid travel and feed valves. Quill moves in a virtual state of balance when unopposed.
<b>Advance Rapid Distance</b>	Adjustable 0 to maximum stroke length of unit model.
<b>Advance Rapid Travel Rate</b>	Approximately 900 inches per minute with 80 PSI air.
<b>Advance Feed Rate</b>	Adjustable 13 to 400 inches per minute. (21102-01 Feed Valve) Adjustable 12 to 150 inches per minute. (21102-00 Feed Valve)
<b>Retract Rapid Travel Distance with Retract Stroke Control</b>	Full stroke except when retract stroke control is installed. Adjustable maximum stroke of unit model to 0 inches with feed before rapid motion.
<b>Retract Rapid Travel Rate</b>	Approximately 600 inches per minute with 80 PSI air input.
<b>Retract Feed Rate</b>	Adjustable 13 to 200 inches per minute. (21102-01 Feed Valve) Adjustable 12 to 71 inches per minute. (21102-00 Feed Valve)
<b>Stroke Depth Repeatability</b>	.015 inch with standard adjustable positive stop.
<b>Mounting Positions</b>	Unlimited, mount in any position at any angle.
<b>Weight</b>	Average less motor, 4"—95 lbs., 6"—120 lbs., 10"—175 lbs.; with 56C frame motor, add 25 lbs.

\*\* These are theoretical stall point values with no allowance for internal or external resistance due to friction or weight. For efficient operation, the estimated maximum thrust requirement in either direction should not exceed  $\frac{2}{3}$  of these values.