

# Self-Feed Multiple Spindle Head Drills

## BUCKEYE®

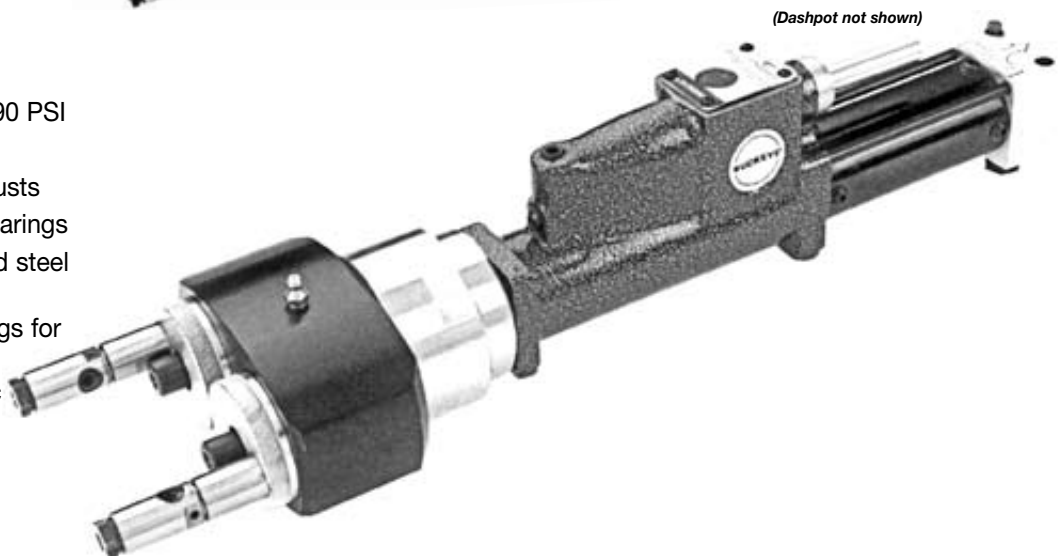
### 21LD Series

- .4 Horsepower
- 130 lbs. Thrust (578 N) @ 90 PSI
- 1 1/4" (32mm) & 2" (51mm) Stroke
- Spindle position easily adjusts
- Heavy-duty roller thrust bearings
- Hardened precision-ground steel spindles
- Caged needle roller bearings for lateral stability
- 1" (25mm) stroke hydraulic dashpot standard



### 31LD Series

- .6 Horsepower
- 200 lbs. Thrust (889 N) @ 90 PSI
- 3" (76mm) Stroke
- Spindle position easily adjusts
- Heavy-duty roller thrust bearings
- Hardened precision-ground steel spindles
- Caged needle roller bearings for lateral stability
- 2" (51mm) stroke hydraulic dashpot standard



Models			Free Speed RPM	Maximum Collet Size		Nominal Drilling Capacity		Maximum Torque per Spindle		Thrust @ 90 PSI	
Stroke Length						Mild Steel					
1 1/4" (32mm)	2" (51mm)	3" (76mm)		in.	mm	in.	mm	in.-lbs.	Nm	lb.	N
<b>Type 400 Multiple Spindle Head</b>											
21LD-772-402			3500	.156	4.0	5/32	4.0	19.2	2.2	130	578
21LD-773-402    21LD-703-402			2800	.156	4.0	5/32	4.0	19.2	2.2	130	578
<b>Type 650 Multiple Spindle Head</b>											
21LD-702-652			3500	.250	6.4	5/32	4.0	26.4	3.0	130	578
31LD-802-652			3000	.250	6.4	3/16	4.8	26.4	3.0	200	889
<b>Type 800 Multiple Spindle Head</b>											
31LD-805-802			1100	.312	7.9	5/16	7.9	50.4	5.7	200	889

#### Specifications:

Recommended Air Pressure: 90 PSI (6.2 bar)  
 Air Inlet Size: 1/4" N.P.T.  
 Remote Control Ports: 1/8" N.P.T.  
 Recommended Hose Size: 3/8" (9.5 mm) I.D.

#### Standard Equipment:

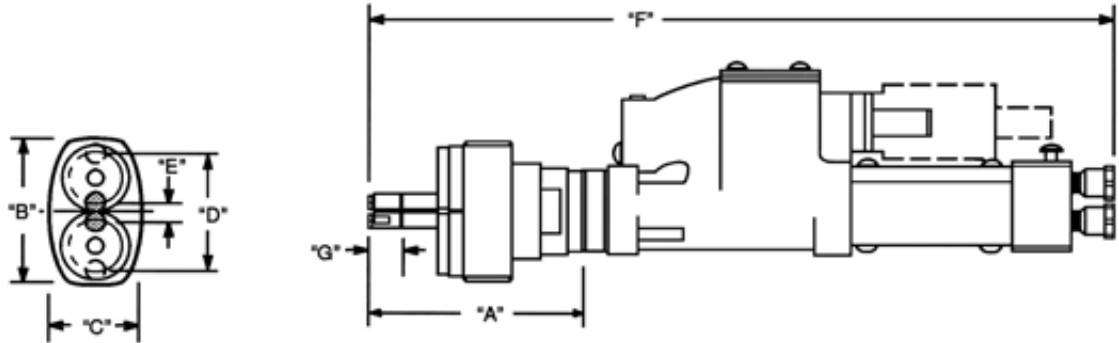
21LD Series: Supplied standard with 1" stroke hydraulic dashpot, 1024850.  
 31LD Series: Supplied standard with 2" stroke hydraulic dashpot, 1024852.

#### Extra Cost Accessories:

Collets: page 43  
 L - Bracket 21LD: 1021862  
 L - Bracket 31LD: 1023793  
 NOTE: Contact factory for pricing and additional head configurations available.

## 21LD Series Mounting Dimensions

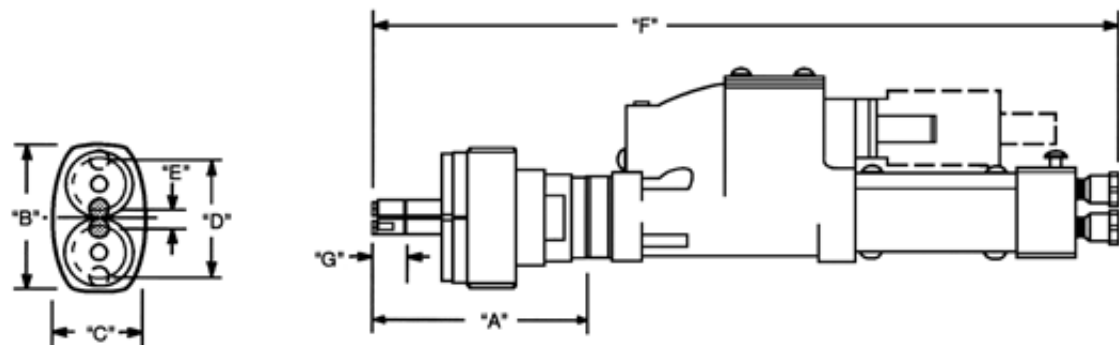
Designer's full scale dimensional layouts available online at [www.cooperpowertools.com](http://www.cooperpowertools.com).



Refer to page 7 for additional mounting dimensional information.

## 31LD Series Mounting Dimensions

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Refer to page 9 for additional mounting dimensional information.

Multiple Spindle Head		Part Number	Dimensions													
Type	Code		A		B		C		D		E		F		G**	
			in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm
<b>1-1/4" (32mm) Stroke Models</b>																
400	-402	1025767	6.92	176	2.84	72	2.00	51	2.125	54	.375	9.5	16.42	417	.875	22
650	-652	1025768	7.09*	180	3.25	83	2.05	52	2.500	64	.500	13	16.59	421	.937	24
<b>2" (51mm) Stroke Models</b>																
400	-402	1025767	6.92	176	2.84	72	2.00	51	2.125	54	.375	9.5	17.17	436	.875	22
650	-652	1025768	7.09*	180	3.25	83	2.05	52	2.500	64	.500	13	17.34	440	.937	24
650	-652	1025771	6.64	169	3.25	83	2.05	52	2.500	64	.500	13	19.81	503	0.937	24
800	-802	1025772	7.44	189	4.00	102	2.50	64	3.125	79	.625	16	20.61	523	1.156	29
950	-952	1025773	8.09	205	4.87	124	3.05	77	3.750	95	.750	19	21.26	540	1.375	35

\* Note: "A" Dimension for 900 RPM tool is 8.15" (207).

\*\* Note: "G" Dimension indicates collet depth.

**Note:**

- Specify collet diameter desired when placing an order. Price of collets not included in price of assembly package.
- Assembly number includes all hardware needed to mount the chosen multi spindle onto the applicable self-feed drill.