

Multiple Spindle Drill Head Assembly

Buckeye Twin-Spindle adjustable center heads for use with Self-Feed tools for two hole drilling operations. Available as factory installed on tool order. For use on 21L, 31L, 42L, and 46L Self-Feed tools. Dashpot accessory is recommended for drilling metal. To order with a dashpot, add "D" to the model number.

EXAMPLE: 21LD-XXX

Type 400

3/8" (9.5mm) to 2-1/8" (54mm) between holes.

- Drill sizes up to: 5/32" (4.0mm)
- Tap sizes up to: 5/32" (4.0mm)
- Maximum input: 10000 RPM

Type 650

1/2" (13mm) to 2-1/2" (64mm) between holes.

- Drill sizes up to: 1/4" (6.5mm)
- Tap sizes up to: 3/16" (5.0mm)
- Maximum input: 7000 RPM

Type 800

5/8" (16mm) to 3-1/8" (79mm) between holes.

- Drill sizes up to: 5/16" (8.0mm)
- Tap sizes up to: 1/4" (6.5mm)
- Maximum input: 6000 RPM

Type 950

3/4" (19mm) to 3-3/4" (95mm) between holes.

- Drill sizes up to: 3/8" (9.5mm)
- Tap sizes up to: 5/16" (8.0mm)
- Maximum input: 5000 RPM

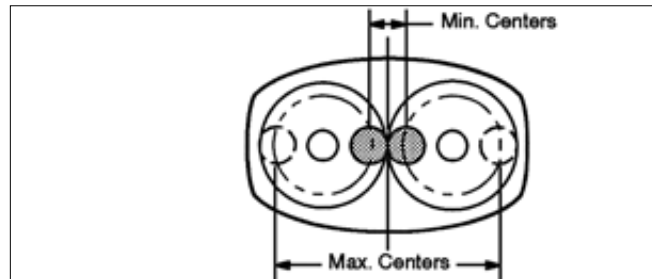
Type 1250

1" (25mm) to 5" (127mm) between holes.

- Drill sizes up to: 1/2" (13mm)
- Tap sizes up to: 3/8" (10mm)

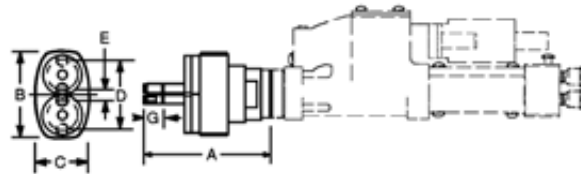
Spindle Centers

Type	Spindle Centers			
	Minimum		Maximum	
	in.	mm	in.	mm
400	.375	9.5	2.125	54
650	.500	12	2.500	64
800	.625	16	3.125	79
950	.750	19	3.750	95
1250	1.00	25	5.000	127



Multiple Spindle Heads† Ordering Information:

- 1) The Multiple Spindle Heads (M.S.H.) are sold only as accessories to the Self-Feed tools.
- 2) When specifying the tool speed code be sure to take into account the maximum input RPM.
- 3) When ordering only a M.S.H. specify the assembly part number only.
- 4) When ordering a M.S.H. head with a Self-Feed tool, specify the head code number from the table below.
EXAMPLE: 31L-803-652 (1025771 multiple spindle head) or 21L-705-652 (1025768 multiple spindle head).
- 5) For other multiple spindle head options contact Cooper Power Tools.



*Multiple Spindle Head		Part Number	Drill Cap. Mild Steel & Max. Collet Size		Dimensions												Max. Torque Per Spindle	
Type	Code		in.	mm	A		B		C		D		E		G**		in.-lb.	Nm
Use on 21L																		
400	-402	1025767	.156	4.0	6.92	176	2.84	72	2.00	51	2.125	54	.375	9.5	.875	22	19.2	2.2
650	-652	1025768	.250	6.4	7.09*	180	3.25	83	2.05	52	2.500	64	.500	13	.937	24	26.4	3.0
Use on 31L and 42L																		
650	-652	1025771	.250	6.4	6.64	169	3.25	83	2.05	52	2.500	64	.500	13	.937	24	26.4	3.0
800	-802	1025772	.312	7.9	7.44	189	4.00	102	2.50	64	3.125	79	.625	16	1.156	29	50.4	5.7
950	-952	1025773	.375	9.5	8.09	205	4.87	124	3.05	77	3.750	95	.750	19	1.375	35	79.2	8.9
Use on 46L																		
950	-952	1025774	.375	9.5	8.44	214	4.87	124	3.05	77	3.750	95	.750	19	1.375	35	79.2	8.9
1250	-122	1025775†	.50	13	11.69	297	6.50	165	4.02	102	5.000	127	1.000	25	2.000	51	120.0	13.6

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

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

‡ NOTE: 21L-800 series tools require conversion parts to accept the multiple spindle drill head assembly. Contact the factory for details. 31L, 42L, and 46L series do not require conversion.

† Quotation required.

*Additional three, four, and five adjustable and fixed spindle heads are available upon request as well as multi-spindle tappers. Contact Technical Support for more information.

NOTE: Refer to appropriate tool series page for overall length (dimension "F") of tool with multiple spindle drill head assembly.

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