

QUACKENBUSH™

230QGDAB-SU-MS Series

Capacity:

Aluminum – 1.25" (31.75mm)

Titanium – .875" (22.2mm)

Stroke:

Max – .125" (3.18mm)

Min. – Unlimited

- 230 series motor develops 2.3 nominal horsepower.
- Single push-button starts motor and engages drill feed mechanism.
- Externally replaceable shear pin provides gear protection if chips pack or cutter binds.
- Rapid advance with manual speed control and low torque clutch protection if cutter advances into workpiece.
- Easily adapted to oil hole drilling using a solid spindle and a fluid chuck, or with the use of an oil hole spindle and a fluid swivel.
- Stroke is adjustable by positioning the stop collar.
- Spindle continues to rotate in forward direction on return stroke to eliminate withdrawal spiral in hole.
- Rapid spindle retraction.
- Spindle can be retracted at any point during feed cycle by lifting retract lever.
- Precision depth control with automatic retract after preset dwell period. (When equipped with depth sensing nose assembly)
- Positive depth stop is adjustable for desired hole depth.
- Cutter automatically retracts if tool senses thrust overload.
- Motor shuts off automatically after retract.

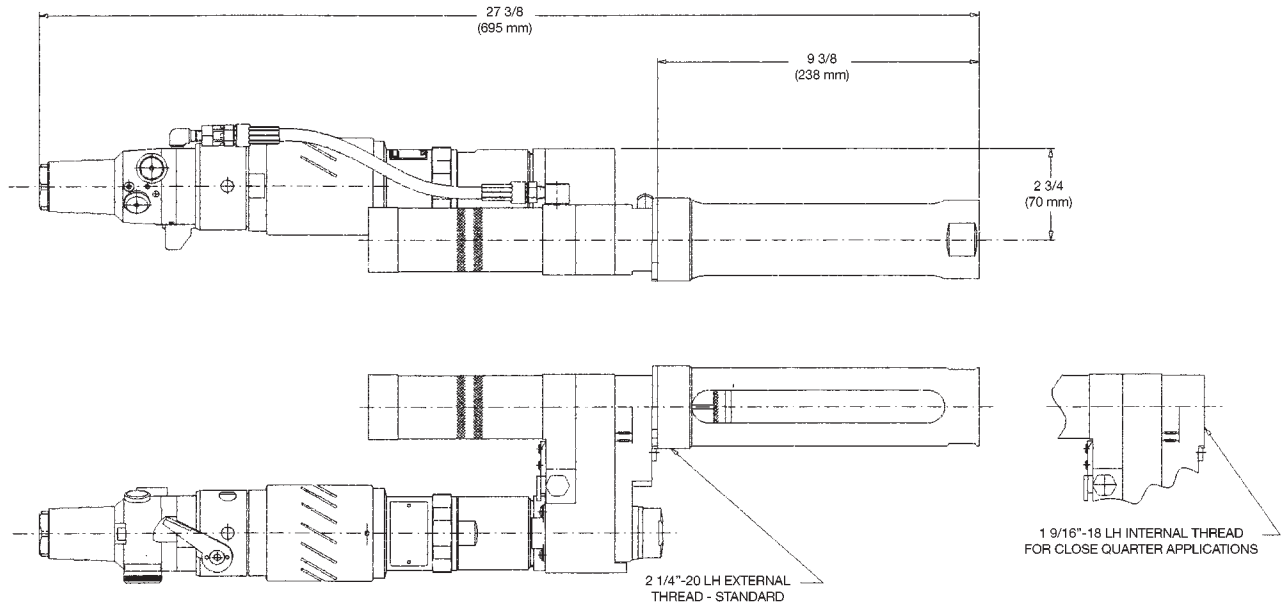


230QGDAB-SU-MS

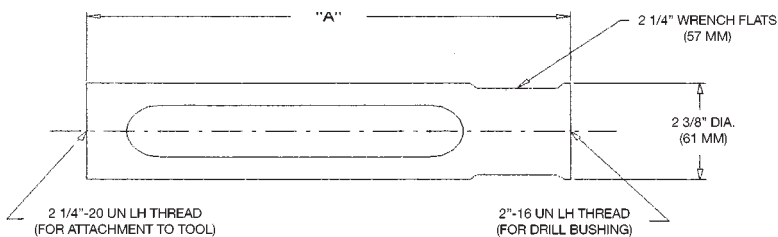
Model	Motor Configuration	Maximum Stroke		Weight*		Length		Spindle Speeds	Feed Per Revolution	Inlet	Minimum Hose Size
		in.	mm	lbs	kg	in.	mm				
230QGDAB-SU-MS	Piggy Back	NO LIMIT		17.5	7.9	27 .375	695	75, 97, 120, 150, 188, 240,307,310	.0005, .001, .002, .003, .0045, .006, .008, .012	.5" NPT	.5"
230QGDAB-SU-MS	Piggy Back	NO LIMIT		16.25	7.4	25 .375	644	390, 480, 585, 680, 825, 960, 1155, 1500	.0005, .001, .002, .003, .0045, .006, .008, .012	.5" NPT	.5"
230QGDABV-SU-MS	Piggy Back	NO LIMIT		18.8	8.2	27 7/8	707	75/187, 150/375	.0005, .001, .002, .003, .0045, .006, .008, .012	.5" NPT	.5"
230QGDABV-SU-MS	Piggy Back	NO LIMIT		16.75	7.6	25 7/8	657	330/780, 600/1500	.0005, .001, .002, .003, .0045, .006, .008, .012	.5" NPT	.5"

*Weight and Length will vary depending on rpm specified.
 Rated tool performance at 90 PSIG measured at tool inlet with motor running.
 When selecting speeds and feeds, see page I-5.
 SEE PAGES I-11-I-13 FOR SAFETY PRECAUTIONS.

EXTRA EQUIPMENT:
 Tool Nose, Spindle
WHEN ORDERING TOOL:
 Tool nose and spindle must be specified.
 Specify EITHER 2.25" L. H. External Thread OR 1.5625"-20 L.H. Internal Thread.



Standard Tool Nose



Steel Tool Noses (Select One)

Length "A"	Thread	Part No.
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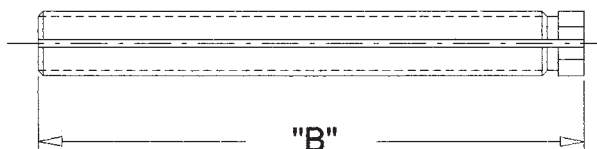
S400 Series

9.5" (241mm)	.75" - 16 L.H.	621235
9.5" (241mm)	1" - 14 L.H.	621236
9.5" (241mm)	1.25" - 12 L.H.	621237
9.5" (241mm)	1.5" - 12 L.H.	621238
9.375" (238mm)	2" - 16 L.H.	614751

S600 Series

11.5" (282mm)	1" - 14 L.H.	621244
11.5" (282mm)	1.25" - 12 L.H.	621245
11.5" (282mm)	1.5" - 12 L.H.	621246
11.375" (279mm)	2" - 16 L.H.	614757

Standard Spindles



Spindles (Select One)

Spindle Type	Length "B"	Max. Stroke	Thread Description	Part No.
Oil Hole	9" (229mm)	4" (103mm)	.5625"-18 Internal Thread with Counterbore and 118° Angle	382599
Oil Hole	9" (229mm)	4" (103mm)	.625"-18 Internal Thread with Counterbore and 118° Angle	382346
Solid	9" (229mm)	4" (103mm)	No. 2 Short Morse Taper with side Knock-Out	382628

- 2.25"-20 L.H. Nose Thread Attachment on standard tool accepts S400 and S600 Tool Noses and accessories. For close quarter applications, a special tool with 1.5625"-20 L.H. Internal Nose Attachment Thread is available.
- With the 1.5625"-20 L.H. Internal Thread, order Nose Adapter (614244) to attach S150 and S275 (2" O.D.) Tool Noses and accessories, OR Nose Adapter (614228) to attach S400 and S600 (2.375" O. D.) Tool Noses and accessories. (See pg. 2-21)
- Nose Indexers - 1.5625"-20 Nose Thread use (381326; for 2.25"-20 L.H. Nose Thread use (381327) (NOTE: Tool must be equipped with 1.5625"-20 L.H. Nose Attachment Threads.)
New design indexers: 1 9/16-20 - 641261
2.25-20 - 641262

- When adapting a 3-jaw chuck to .5625"-18 Internal Thread Spindle, order Chuck Adapter (623643) for .75" cap. chuck OR Chuck Adapter (619400) for .5" cap chuck. (See pgs. 1-40)
- Fluid Swivels used with oil hole spindles and selection of Fluid Chucks. (See pg. 1-41)
- Other Noses and Spindles are available at extra charge. (See pg. 2-21)