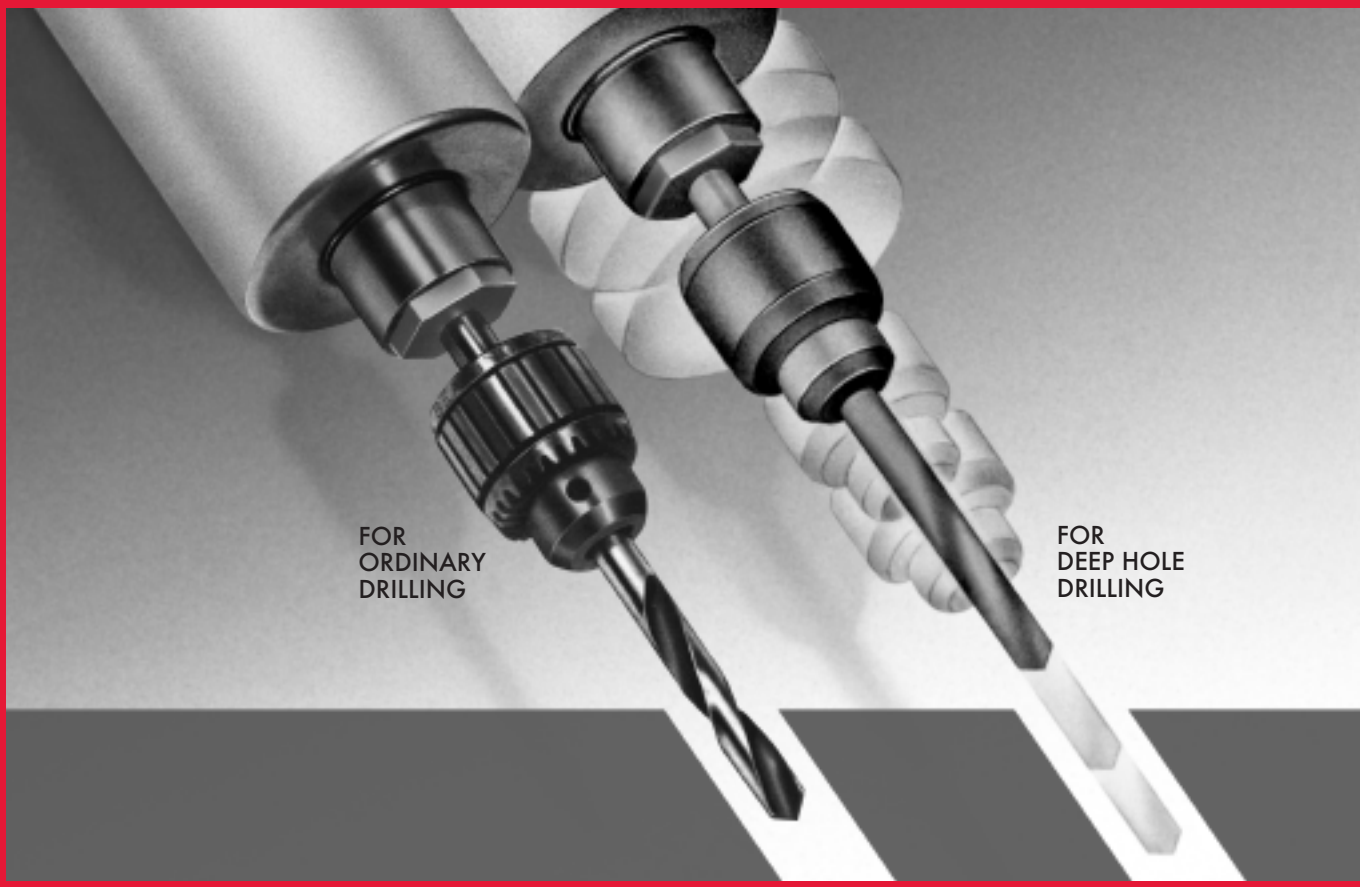
DESCHNER

PECKCHEK® CONTROLS



PRECISION FEED CONTROL FOR DEEP HOLE DRILLING

DESCHNER® FLUID POWER

PECKCHEK CONTROLS AND KINECHEKS SUITABLE FOR DEEP HOLE DRILLING

PECK DRILLING EXPLAINED

Drilling to a depth of more than three drill diameters often requires peck drilling where the drill is repeatedly withdrawn to remove waste cuttings while being advanced in steps deeper and deeper during each feed movement. For efficient peck drilling, the KINECHEK hydraulic feed control must be arranged to act only while the drill is cutting. This requires the KINECHEK plunger to remain virtually stationary during the intermittent retractions and reinsertions of the drill bit. After the hole is completed and the drill retracts for the last time before beginning a new hole, then and only then should the KINECHEK plunger fully extend to be in position to repeat the checking sequence. KINECHEKs with PECKCHEK CONTROL are designed to operate in this manner.

In addition, the Deschner PECKCHEK CONTROL protects the cutting tool by slightly overlapping the checking action. Each time the cutting tool is retracted to clear chips, the KINECHEK plunger rod is allowed to move out slightly (typically .005 inch). When the cutting tool reenters the hole, it is checked just ahead of its last stopping place, preventing the drill from impacting the work piece each time it reenters the hole. The production time lost by the slight overlapping of working strokes is negligible and more than offset by increased tool life and a reduction in down time to replace chipped or broken cutting tools. This feature is especially important when using carbide tooling. Please contact factory if increased stroke overlap is required for special applications.

KINECHEK INFORMATION

The KINECHEK is an exceptionally efficient feed control for use with many types of machines. The KINECHEK's hydraulic fluid is sealed in for life and filtered during every stroke. The unit is absolutely leakproof and never requires replenishment of fluid. Once set to a certain speed, it maintains that same speed for months of heavy production work. Readjustment is not necessary as it is with checks which have to be refilled periodically with none-too-clean hydraulic oil. Added to this is the advantage that the silicone fluid which the unit contains is much more constant in viscosity than ordinary oil, and speed changes due to temperature changes are imperceptible. There are no sliding seals to wear and leak. The KINECHEK does not require any maintenance if it is not abused. (See Bulletin S-66 for complete information.)

KINECHEKS are ideal for use in drilling applications. Their hermetically sealed design allows them to be used in any attitude and their wide range smooth adjustment makes it easy to dial in the optimum drill feed. For deep hole peck drilling applications, a KINECHEK with PECKCHEK CONTROL is almost indispensable.

PECKCHEK ATTACHMENTS FOR SLIMLINE AND SUPER K KINECHEKS

The PECKCHEK CONTROL for SLIMLINE and SUPER K KINECHEKS is a small pneumatically operated accessory that contains a ball clutch which prevents the automatic extension of the KINECHEK plunger rod. This ball clutch is released by the control system of the drilling machine which must provide compressed air at 25 to 125 psi to the PECKCHEK CONTROL air port during the final withdrawal of the drill. The PECKCHEK CONTROL may be operated with or without an inline oiler, since it is designed to operate without lubrication.

The PECKCHEK CONTROL mounts on a special KINECHEK that is equipped with a plunger rod that is hardened full length to withstand the brinelling action of the ball clutch and is approximately one-half inch longer than standard to accommodate the PECKCHEK CONTROL without loss of controlled stroke length.

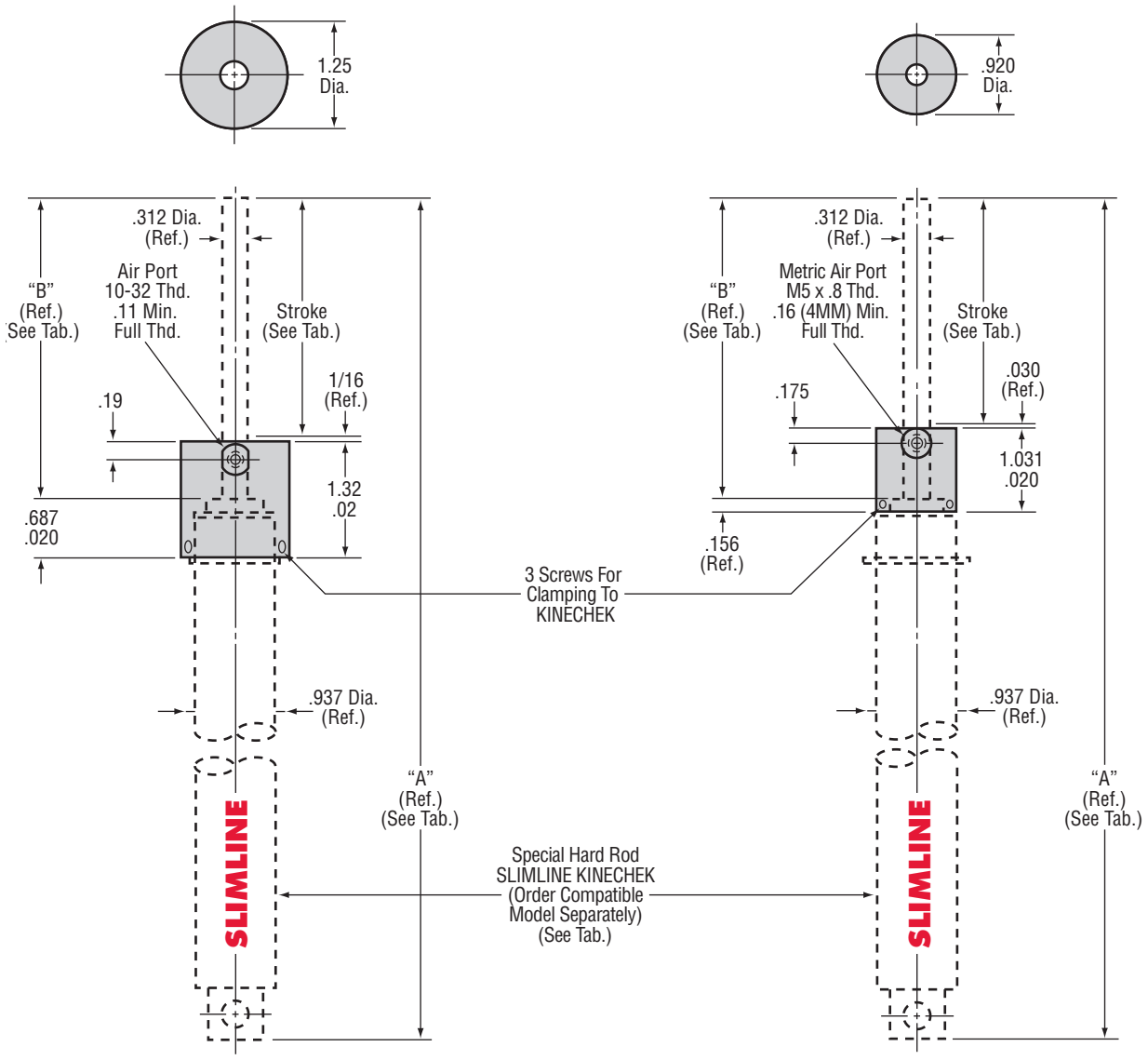
This combination of PECKCHEK CONTROL plus special KINECHEK forms a unitary device which provides efficient hydraulic feed control for drilling machines during ordinary drilling or peck drilling.

GUARANTEE AND LIMITATION OF LIABILITY

Every unit is fully guaranteed against defects in workmanship or material. Within one year from the date of shipment to the original purchaser, any unit which is proven defective will be repaired without charge, F.O.B. factory, when unit is shipped prepaid to factory. The Company is not responsible for any damage resulting from tampering, abuse, or incorrect application. The Company's liability on any claim of any kind including negligence, for any loss or damage arising out of, connected with or resulting from the design, manufacture, sale, delivery, resale, installation or installation advice, inspection, repair, operation, or use of any equipment described herein shall in no case exceed the price allocable to the equipment which gives rise to the claim, and shall terminate four years after the date of original shipment. The purchaser, by acceptance of any of the Company's products described herein, assumes all liability of the consequence of the use of those products.

DESCHNER® FLUID POWER

PECKCHEK CONTROLS (FOR SLIMLINE KINECHEKS)



NOTE: Drawings not to scale

A12031

COMPATIBLE SLIMLINE KINECHEK MODELS* FOR A12031

MODEL NO.	STROKE	A	B
1202-31-1	1 in.	8.33	1.69
1202-31-2	2 in.	11.37	2.69
1202-31-3	3 in.	14.37	3.69

*Order Separately

A13031

COMPATIBLE SLIMLINE KINECHEK MODELS* FOR A13031

MODEL NO.	STROKE	A	B
1202U-31-1	1 in.	8.55	1.91
1202U-31-2	2 in.	11.59	2.91
1202U-31-3	3 in.	14.59	3.91

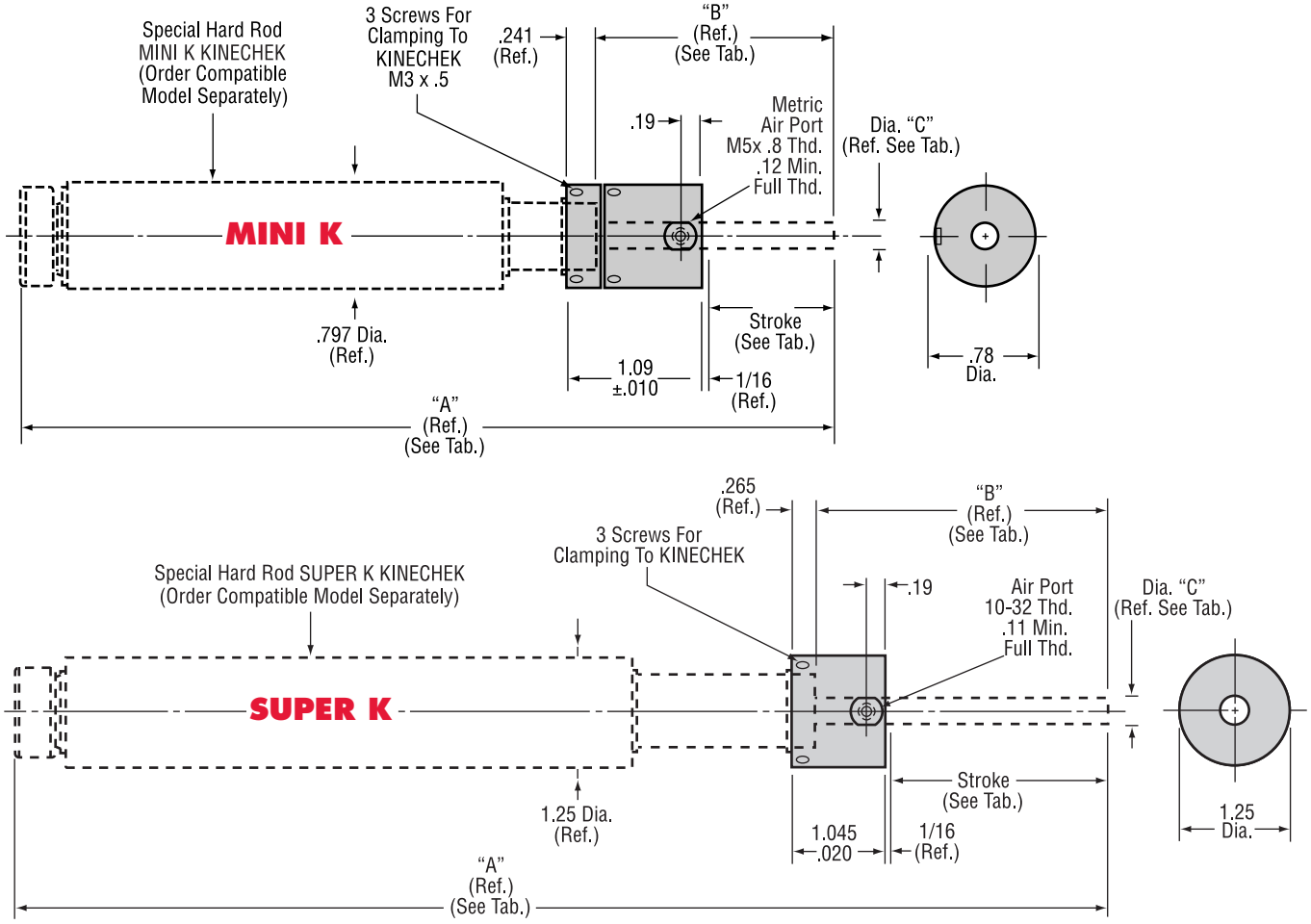
*Order Separately

NOTES

OPERATION- Application of 25 to 125 psi air pressure will release clutch and extend plunger to ready KINECHEK for next operation. Maintain air pressure until plunger rod has extended. Remove air pressure for PECKCHEK operation and KINECHEK plunger rod will not extend during periodic withdrawals of tool for chip clearing.

CAUTION- A12031 and A13031 PECKCHEK CONTROLS must be operated only with a Model 1202-31-Tab or 1202U-31-Tab SLIMLINE KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for Model 1202 and 1202U-31 units are the same as shown in bulletin S-66 for the Model 1002-31 of the same stroke, except that the plunger rod will be longer per tabulated Dim. "B".

PECKCHEK CONTROL (FOR MINI K & SUPER K KINECHEKS)



NOTE: Drawings not to scale

A12019 (FOR 1, 1¼ & 1½" STROKE MINI K KINECHEKS)

PECKCHEK	COMPATIBLE MINI K MODELS*				
PART NO.	MODEL NO.	STROKE	A	B	C
A12019	3222-19-1	1 in.	6.51	1.91	0.187
	3222-19-1 1/4	1 1/4 in.	7.37	2.16	0.187
	3222-19-1 1/2	1 1/2 in.	7.86	2.41	0.187

*Order Separately

A12131 (FOR 4" STROKE SUPER K KINECHEKS)

PECKCHEK	COMPATIBLE SUPER K MODEL*				
PART NO.	MODEL NO.	STROKE	A	B	C
A12131	5402-31-4	4 in.	14.69	4.84	.312

*Order Separately

A12137 (FOR 6" STROKE SUPER K KINECHEKS)

PECKCHEK	COMPATIBLE SUPER K MODEL*				
PART NO.	MODEL NO.	STROKE	A	B	C
A12137	5402-37-6	6 in.	19.93	6.84	.375

*Order Separately

NOTES

OPERATION- Application of 25 to 125 psi air pressure will release clutch and extend plunger to ready KINECHEK for next operation. Maintain air pressure until plunger rod has extended. Remove air pressure for PECKCHEK operation and KINECHEK plunger rod will not extend during periodic withdrawals of tool for chip clearing.

CAUTION- PECKCHEK CONTROL P/N(s) A12019, A12131, and A12137 must be operated only with a special KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for special KINECHEK Model 3222-tab and 5402-tab are the same as shown in bulletin S-66 for the Mini K Model 3022 and Super K Model 5002 of the same stroke length except that the plunger rod is longer per tabulated Dim. "B".

DESCHNER CORPORATION

3211 West Harvard Street
Santa Ana, California 92704
Telephone: (714) 557-1261
Toll Free: 1-(800) 457-6666 Fax: (714) 557-4762
Email: info@deschner.com Web: www.deschner.com

DESCHNER® FLUID POWER