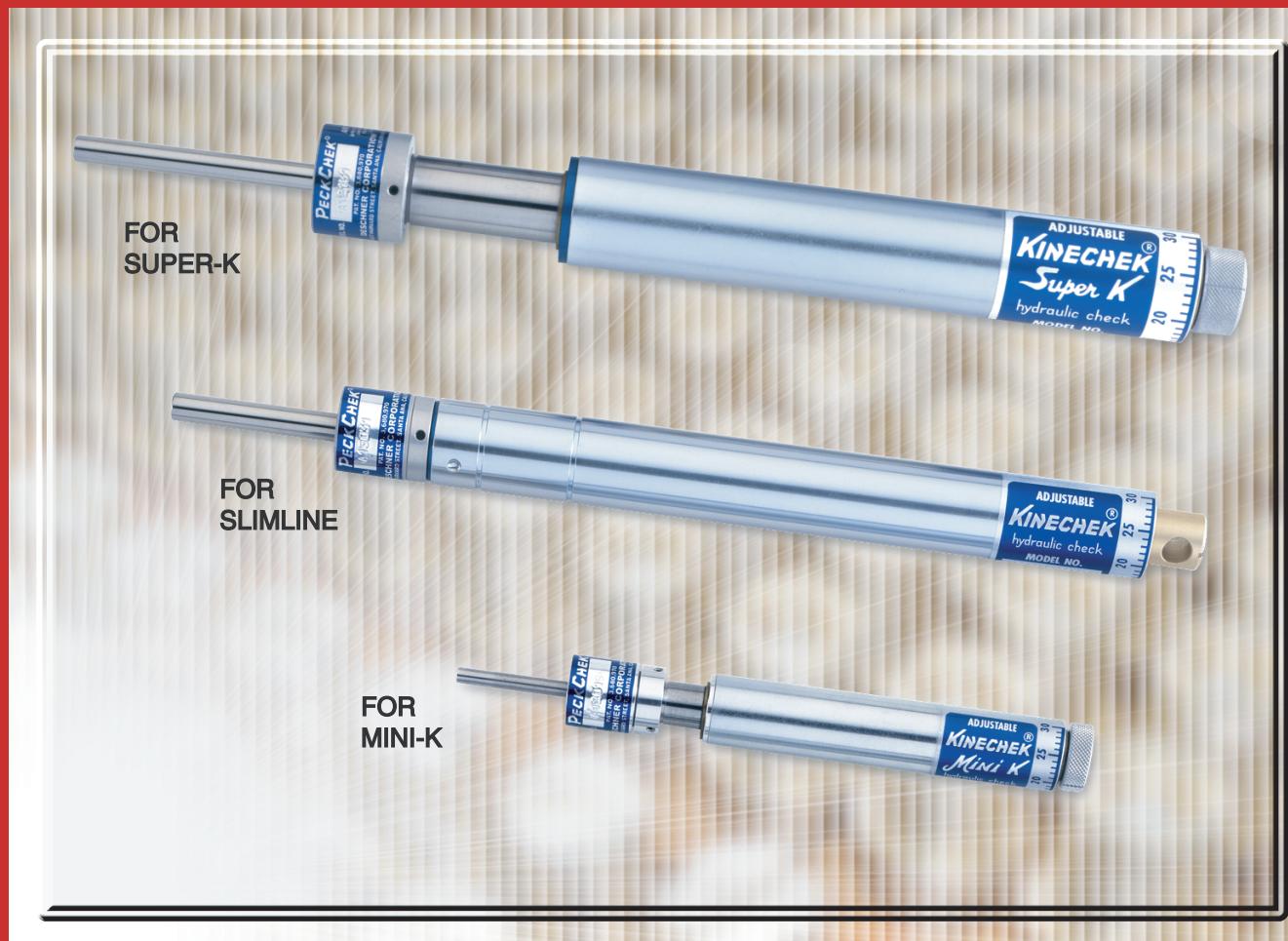


DESCHNER

PECKCHEK® CONTROLS



PRECISION
FEED CONTROL
FOR
DEEP HOLE
DRILLING



**STANDARD AND METRIC
SPECIFICATIONS**

DESCHNER PECKCHEK CONTROLS



PECKCHEK CONTROLS AND KINECHEKS SUITEABLE 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Drilling to a depth of more than three drill diameters often requires peck drilling where the drill is repeatedly withdrawn to remove waste cuttings while being advanced in steps deeper and deeper during each feed movement.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.

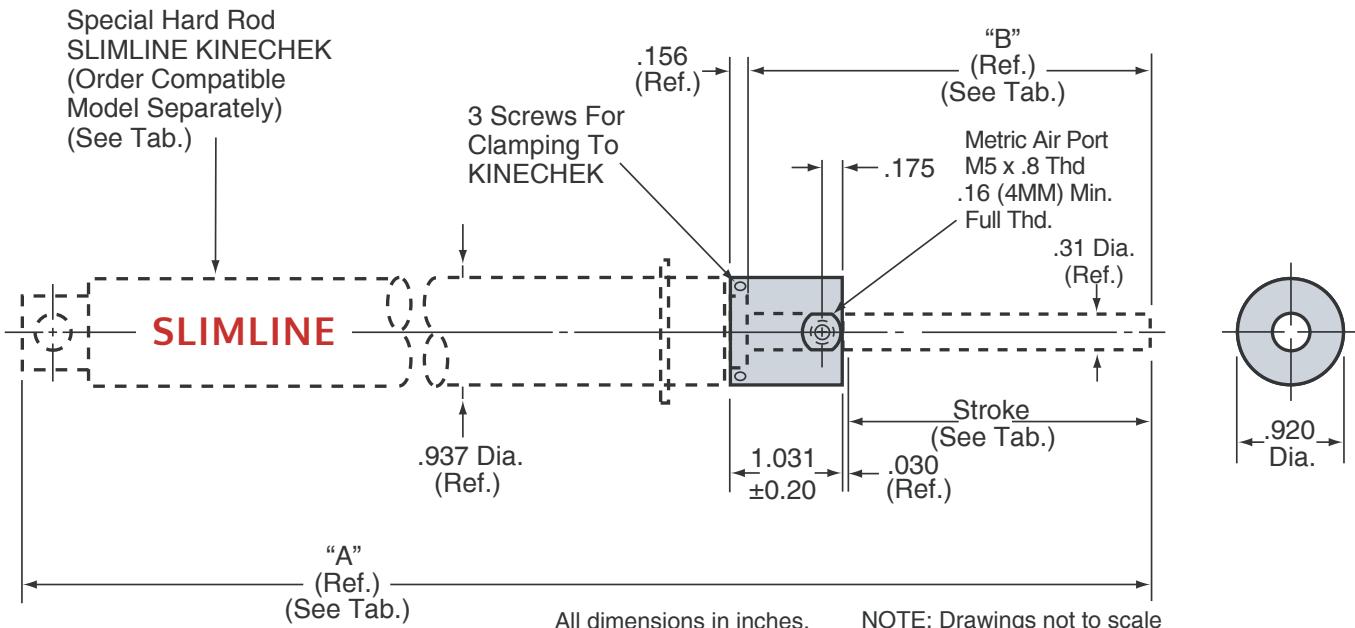
GUARANTEE AND LIMITATION OF LIABILITY



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.



SLIMLINE PECKCHEK (STANDARD SPECIFICATIONS)



A13031 (FOR 1, 2, 3" SLIMLINE KINECHEKS)

PECKCHEK	COMPATIBLE SLIMLINE KINECHECKS*			
PART NO.	MODEL NO.	STROKE	A	B
A13031	1202U-31-1	1 in.	8.55	1.905
	1202U-31-2	2 in.	11.59	2.905
	1202U-31-3	3 in.	14.59	3.905

*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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



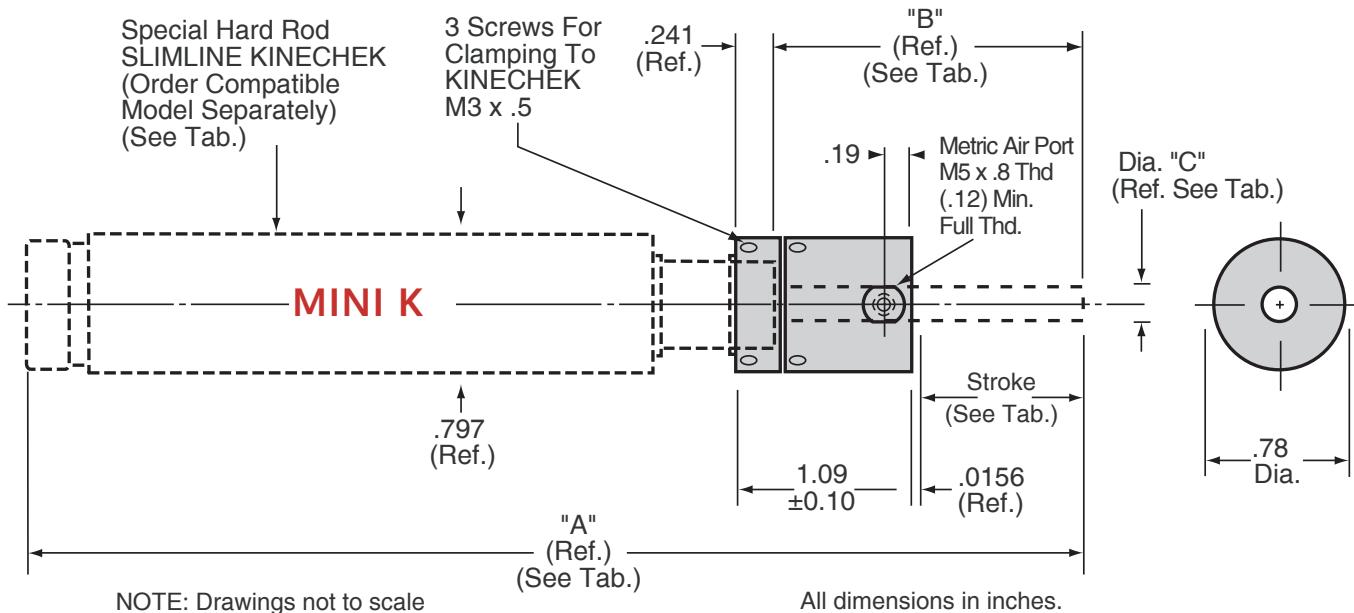
CAUTION- A13031 PECKCHEK CONTROL must be operated only with Model 1202U-31-Tab SLIMLINE KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for Model 1202U-31 units are the same as shown in bulletin S-66 for the Model 1002-31 of the same stroke, except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

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MINI-K PECKCHEK (STANDARD SPECIFICATIONS)



A12019 (FOR 1, 1 1/4 & 1 1/2" STROKE MINI K KINECHEKS)

PECKCHEK PART NO.	COMPATIBLE MINI K MODELS*				
	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

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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



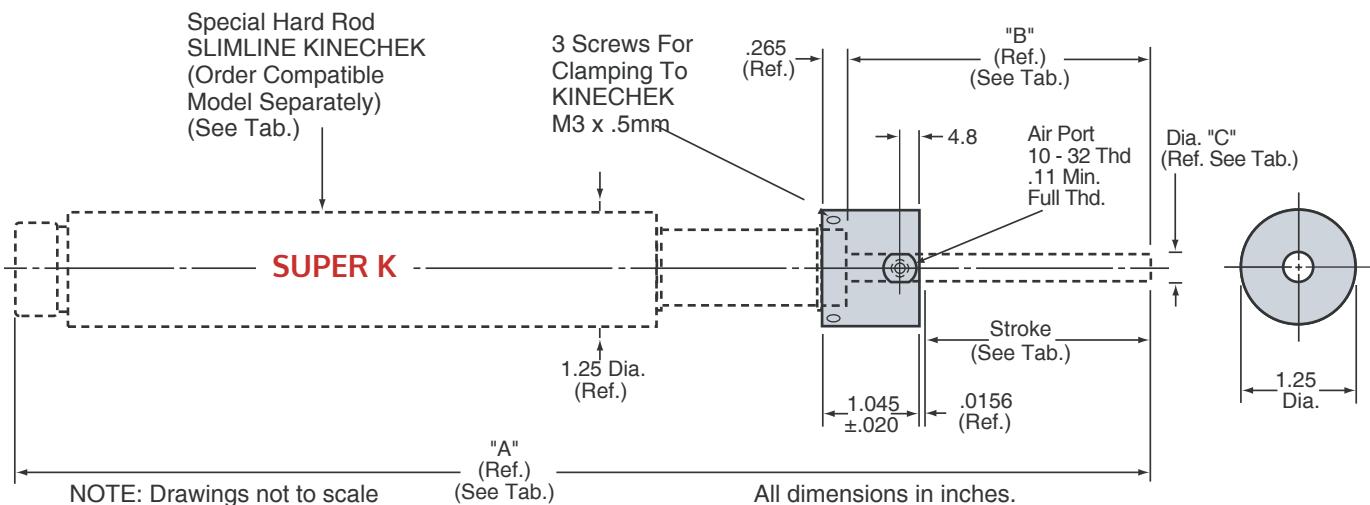
CAUTION- PECKCHEK CONTROL P/N A12019 must be operated only with a special KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for special KINECHEK Model 3222-tab are the same as shown in bulletin S-66 for the Mini K Model 3022 of the same stroke length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

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SUPER-K PECKCHEK (STANDARD SPECIFICATIONS)



A12131 (FOR 4" STROKE SUPER K KINECHEKS)

PECKCHEK	
PART NO.	
A12131	

COMPATIBLE SUPER K MODEL*				
MODEL NO.	STROKE	A	B	C
5402-31-4	4 in.	14.686	4.843	.312

* Order Separately

A12137 (FOR 6" STROKE SUPER K KINECHEKS)

PECKCHEK	
PART NO.	
A12137	

COMPATIBLE SUPER K MODEL*				
MODEL NO.	STROKE	A	B	C
5402-37-6	6 in.	19.929	6.843	.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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



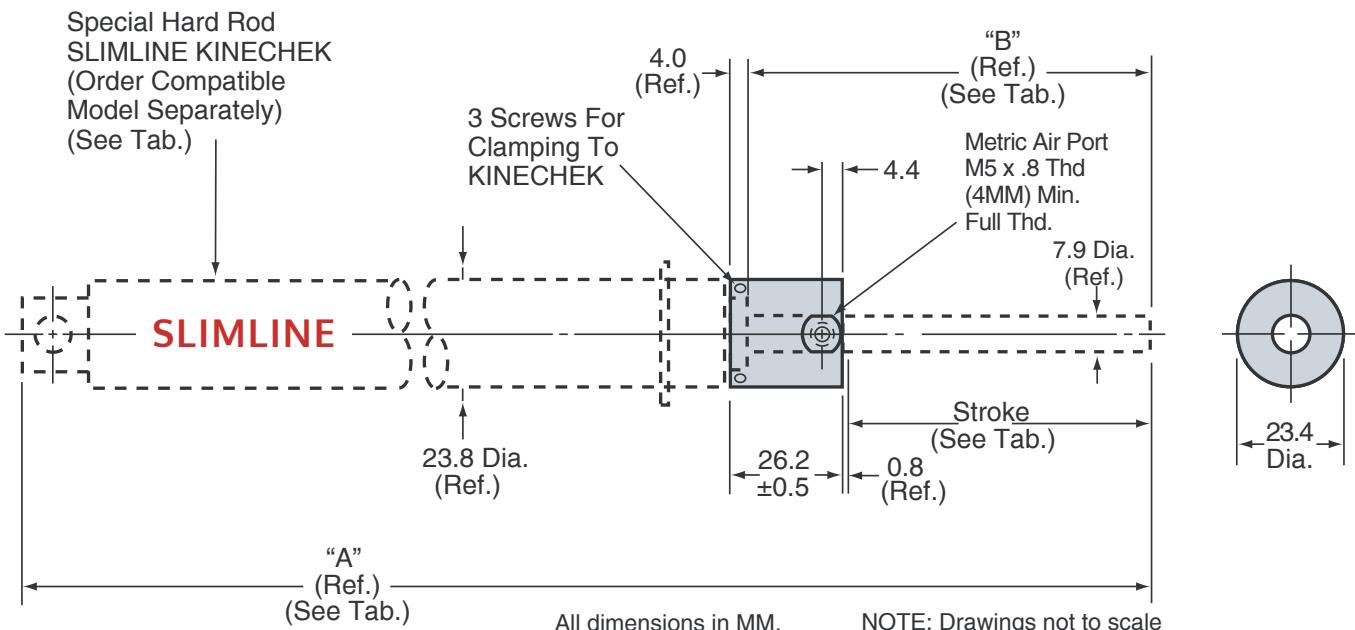
CAUTION- PECKCHEK CONTROL P/N(s) A12131 and A12137 must be operated only with a special KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for special KINECHEK Model 5402-tab are the same as shown in bulletin S-66 for the Super K Model 5002 of the same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

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SLIMLINE PECKCHEK (METRIC SPECIFICATIONS)



A13031 (FOR 1, 2, 3" SLIMLINE KINECHEKS)

PECKCHEK	COMPATIBLE SLIMLINE KINECHECKS*			
PART NO.	MODEL NO.	STROKE	A	B
A13031	1202U-31-1	25.4mm	217.2mm	48.5mm
	1202U-31-2	50.8mm	294.4mm	73.9mm
	1202U-31-3	76.2mm	370.6mm	99.3mm

*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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



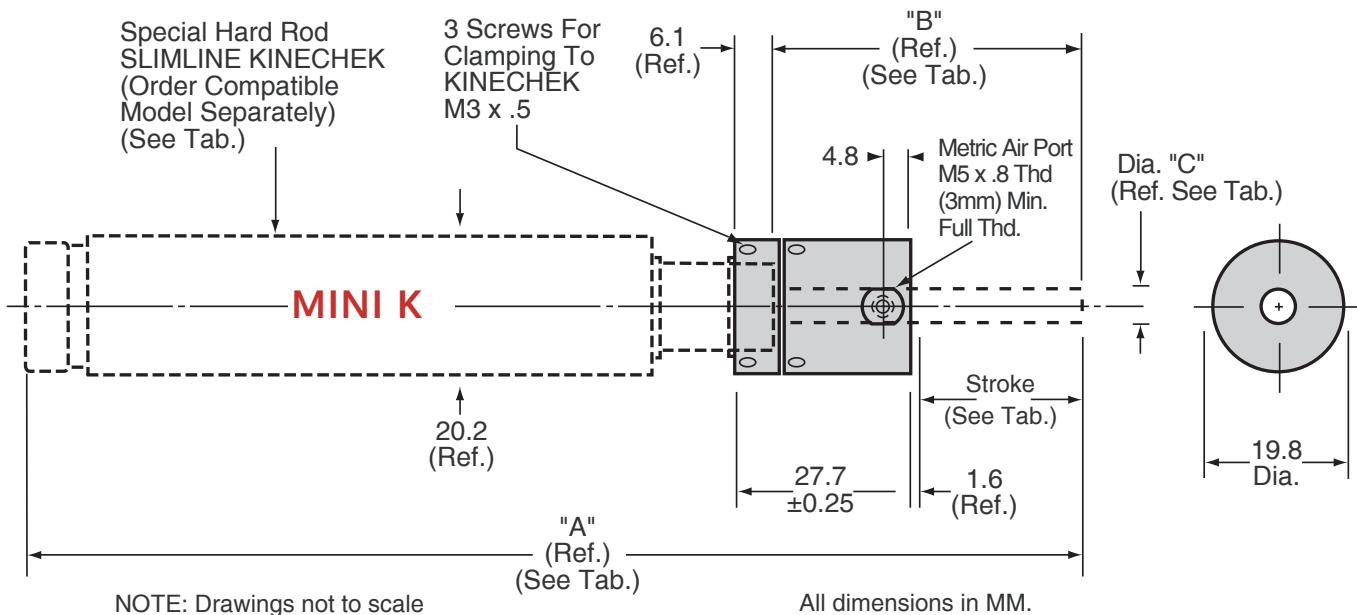
CAUTION- A13031 PECKCHEK CONTROL must be operated only with Model 1202U-31-Tab SLIMLINE KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for Model 1202U-31 units are the same as shown in bulletin S-66 for the Model 1002-31 of the same stroke, except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

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MINI-K PECKCHEK (METRIC SPECIFICATIONS)



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

PECKCHEK		COMPATIBLE MINI K MODELS*			
PART NO.		MODEL NO.	STROKE	A	B
	A12019	3222-19-1	25.4mm	165.4mm	48.5mm
		3222-19-1 1/4	31.7mm	187.2mm	54.9mm
		3222-19-1 1/2	38.1mm	199.6mm	61.2mm

* 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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



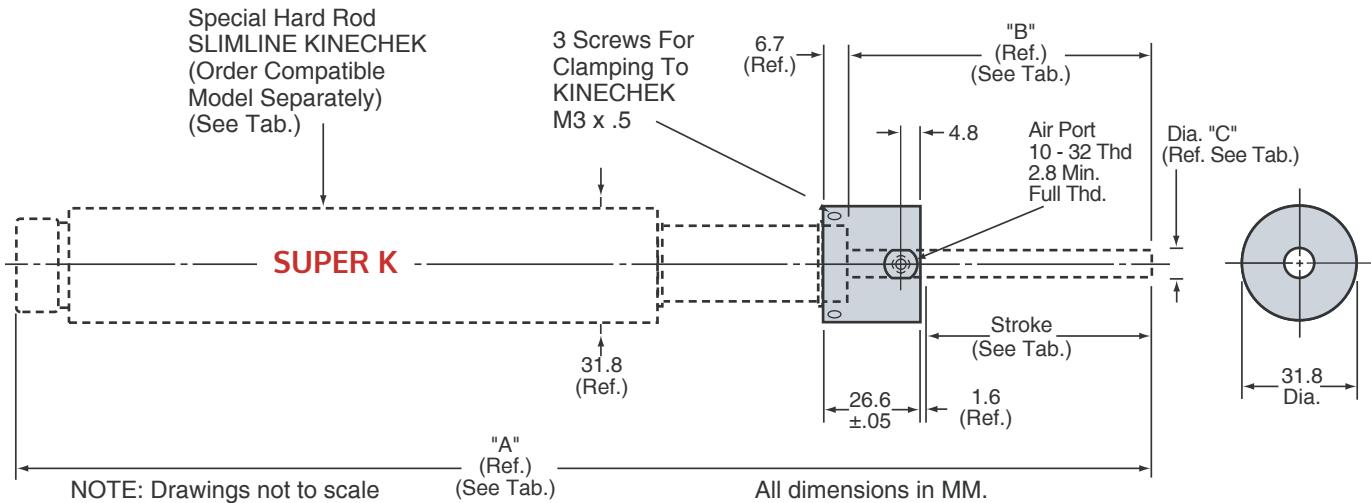
CAUTION- PECKCHEK CONTROL P/N A12019 must be operated only with a special KINECHEK which incorporates a specially hardened and polished plunger rod. Dimensions and performance for special KINECHEK Model 3222-tab are the same as shown in bulletin S-66 for the Mini K Model 3022 of the same stroke length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

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SUPER-K PECKCHEK (METRIC SPECIFICATIONS)



A12131 (FOR 4" STROKE SUPER K KINECHEKS)

PECKCHEK	
PART NO.	
A12131	

COMPATIBLE SUPER K MODEL*				
MODEL NO.	STROKE	A	B	C
5402-31-4	101.6mm	373mm	123mm	7.9mm

* Order Separately

A12137 (FOR 6" STROKE SUPER K KINECHEKS)

PECKCHEK	
PART NO.	
A12137	

COMPATIBLE SUPER K MODEL*				
MODEL NO.	STROKE	A	B	C
5402-37-6	152.4mm	506.2mm	173.7mm	9.5mm

* 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. KINECHEK plunger rod should not extend during periodic withdrawals of tool for chip clearing.



CAUTION- PECKCHEK CONTROL P/N(s) 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 5402-tab are the same as shown in bulletin S-66 for the Super K Model 5002 of the same stroke length except that the plunger rod is longer per tabulated Dim. "B".

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