



## Tool Selection

### SELF-FEED TOOL PERFORMANCE

TOOL SERIES	*MOTOR H.P.	*THRUST IN POUNDS	*AIR CONSUMPTION IN CUBIC FEET, AT WORKING SPEED	
			TYP. 6 SEC. CYCLE	ONE MIN. OPERATION
Bant-A-Matic 8245, 8246, 8248	1/4	90	1.5	15.0
Series 34A, Electra-feed	1/3	330	N/A	0.14 per cycle
Par-A-Matic 8255, 8256, 8258, 8266	1/2	170	2.3	23.0
<b>Series 54C, Electra-feed</b>	<b>1/2</b>	<b>330</b>	<b>N/A</b>	<b>0.14 per cycle</b>
Super Par-A-Matic 8265, 8268	3/4	250	2.9	29.0
<b>Series 74B, Electra-feed</b>	<b>3/4</b>	<b>330</b>	<b>N/A</b>	<b>0.14 per cycle</b>
Hi-Thrust 8670	1-1/4	500	5.0	50.0
Lead Screw Tapper, All	5/8	**	3.0	30.0

\*At 90 PSI at tool inlet while operating    \*\*Positive feed mechanism - no piston thrust

### SELF-FEED DRILL SELECTION GUIDE

**HOW TO USE CHART . . .** The selection chart below provides model recommendations based on factors of textbook speeds, actual drill test results, and judgements based on available power and thrust. It should be used as a guide only in selecting the model or models best suited to meet the general machining requirements of these materials. Proper selection of a feed tool for a specific application, however, must also take into account the density and hardness of the material to be drilled, the type of drill bit used, the cutting lubricant or coolant used, the production cycle desired, tool, life, and the amount of compressed air available.

Those models in italics are generally considered the more appropriate selections, but where more than one model is given the more powerful tool will do the job faster. Therefore, the best tool for the job will depend upon the desired production rate and the amount of available compressed air.

DRILL DIA.	ALUMINUM (2024-T4)		BRASS (SAE 72)		STEEL (SAE 1213)		WOOD, MEDIUM or FRP	
	Single Spindle	Twin Drill	Single Spindle	Twin Drill	Single Spindle	Twin Drill	Single Spindle	Twin Drill
1/16" (1.59 mm)	8245-203		8245-203			8258-C50		
	8255-101	8258-C50	8245-101	8258-C50	8245-B45	8248-B45	8245-203	8258-C50
1/8" (3.17 mm)	8245-B45	<i>8258-C50</i>	8245-B45	8258-C50	8265-46	8248-B30	8255-172	8248-B30
	<i>8255-101</i>	8268-A46	<i>8255-101</i>	8268-A46	8255-A50	8258-C28	8245-101	8258-C50
3/16" (4.76 mm)	8245-B30	8258-C28	8245-B30	8258-C28	8245-B8	8258-C14	8245-B30	8258-C28
	<i>8255-A50</i>	8268-A46	<i>8255-A50</i>	8268-A46	8265-25	8268-A12	<i>8255-A50</i>	8268-A25
1/4" (6.35 mm)	8245-B30	8258-C14	8245-B8	8258-C14	8255-A14	8258-C5	8245-B30	8258-C14
	<i>8255-A28</i>	8268-A46	<i>8255-A28</i>	8268-A46	8265-25	8268-A12	<i>8255-A28</i>	8268-A25
5/16" (7.92 mm)	8255-A14	8268-A25	8255-A28	8268-A25	8255-A5	8268-A12	<i>8255-A21</i>	8268-A25
	<i>8265-25</i>	8268-A12	<i>8265-25</i>	8268-A12	8265-12	8268-A6	8265-46	8265-A12
3/8" (9.52 mm)	8265-12	8268-A12	8265-12	8268-A12	8265-6	8268-A6	8255-A8	8258-A12
	8670-47	8268-A6	8670-47	8268-A6	8670-13	8268-A3	<i>8265-25</i>	8268-A25
7/16" (11.10 mm)	8265-12		8265-12		8265-6		8265-25	
	8670-47		8670-47		8670-13			
1/2" (12.70 mm)	8265-12		8265-12		8265-3		8265-12	
	8670-47		8670-28		8670-8		8670-47	
9/16" (14.27 mm)	8265-6		8265-6				8265-12	
	8670-28		8670-28		8670-8		8670-28	
5/8" (15.87 mm)	8265-3		8265-3				8265-6	
	8670-13		8670-13		8670-4		8670-28	
11/16" (17.45 mm)							8265-3	
	8670-8		8670-8		8670-4		8670-13	
3/4" (19.05 mm)	8670-8		8670-4		8670-4		8670-8	