

Introducing The
Quackenbush 9650B.

Positive Feed Plus
Peck Feed Technology
In One Drill.

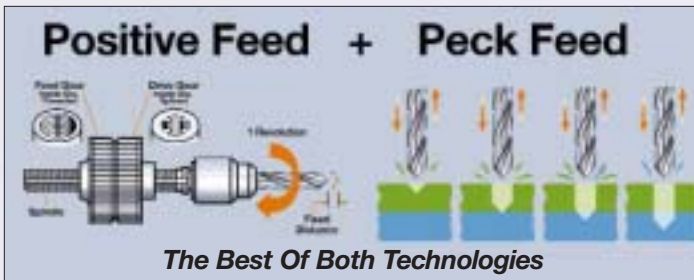


**COOPER** PowerTools

No Other Drill Combines Positive Feed

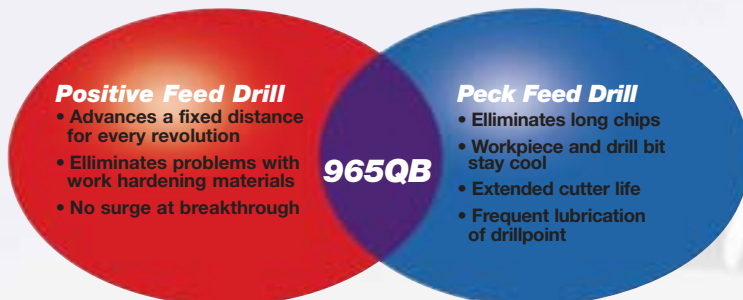
Two Technologies In One Unique Drill! Positive Feed + Peck Feed Drilling

With the new Quackenbush 965QB positive feed peck drill, you get the constant rate of feed and chip load that you expect from a positive feed drill, *and* the excellent chip removal of a peck drill.



No other tool on the market combines both technologies, *plus* offers you the countersinking capability as an option.

- Provides constant forward feed rate of positive feed
- Allows constant chip load of peck drilling
- Will not surge at breakthrough
- Simple to operate - only 2 adjustment parameters
- Assures consistent, precise holes with tight tolerances
- Modular design
- Commonality of parts and accessories



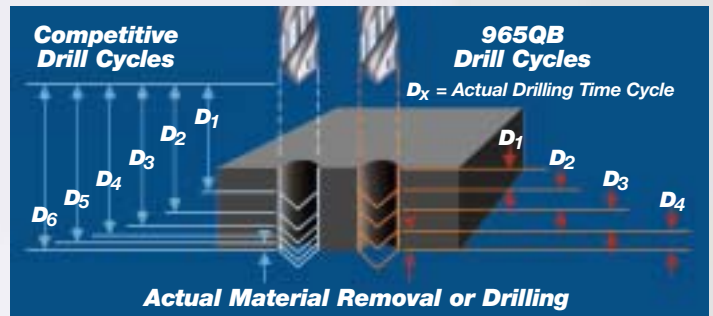
A Different Kind Of Drill For Different Types Of Materials

With the introduction of new aircraft platforms, traditional aircraft drilling is challenged with the introduction and combination of dissimilar stacks of aluminum, carbon fiber, titanium, and steel.



Equal Drill Time

During each peck, the peck timer circuit on competitive models combines the time to rapid advance, drill and retract. As you can see in the illustration below, actual drill time is progressively reduced as the hole depth is increased. With our Quackenbush 965QB drills, advancement and retraction times are separated from actual drill time, therefore the drill time is the same on each peck.



The net result is increased performance. Equal drill time and other parameters are preset with no drift in set-back which prevents damage caused by bottoming out on the forward stroke of the peck cycle. Operating the tool is particularly simple and requires only two adjustment parameters: the activation time of the adjustable peck frequency timer (0–30 seconds) and the adjustment of the peck activation approach timer (from 0–10 seconds).

Features Lighter, More Powerful Modular Design

With commonality of parts not only can this new tool drill and countersink, but – by design – it's lighter, more ergonomic, and even more powerful than our HT Series peck drills.

Its simple, modular construction shares parts and accessories with the 932QR family of drills to help

eed With Peck Drilling Technology.

you reduce your parts inventory, plus its robust design requires very little maintenance. The motor and gearing are our Dotco brand which has been relied upon for over 50 years in some of the most demanding applications.

Combined with Cooper Power Tools' high quality cutters, this new technology opens a gate for dramatically reducing

the amount of lubricant used to operate in difficult materials and near-to-dry drilling. The correct combination of the drill and cutter is vital to successful operation.

Let the new 965QB positive peck feed drill from Cooper Power Tools give you the advantage. Log onto www.cooperpowertools.com or call 1-800-845-5629 today.



Quackenbush™ 965QB

**Positive Feed + Peck Feed.
There's no other drill like it!**

Positive Feed + Peck Feed = Best

Tool shuts off at completion of drilling cycle.

Internal threaded spindles available for threaded cutters.



Accepts Quackenbush 15QDA noses with 1"-20 thread.



Optional concentric collet for locating surface to countersink

Peck feed automatically stops when spindle is retracted.



Stroke adjustment is simple with a depth stop nut inside the nose of the tool. Maximum stroke of 4"

Logic system assembly.
Positive Feed – Advances a fixed distance for every revolution, no hydraulics.
Peck Feed – Constant chip load, permits close tolerance drilling in one operation.

Shown with single cycle start trigger handle. Other options available.



Fully automatic. One button starts the tool cycle and the tool shuts off on retract.

Of Both Technologies In One Drill.

Optional thrust overload mechanism shuts off tool if cutter breaks (electronic or mechanical).

Through spindle lubrication or mist lubricator integrated micro pump (with or without cycle counter).



Air inlet

Circuit activation and emergency stop.

Adjustable Peck Frequency Timer – adjusts peck rate cycle up to 30 seconds.

Peck Activation Approach Timer – adjustable from 0–10 seconds.

Optional lubrication with manual or pneumatic counter.

Quackenbush™ 965QB

Quackenbush™ 965QB

Capacity: Aluminum - .50”(12.7mm)
Titanium - .375” (9.525mm)

Horsepower: .9 at spindle

Stroke: 4” (100mm)

Countersink Capability: Micrometer adjustment of drill depth with 0.001” (0.025mm) increments

- Positive feed drill with peck feed operation for drilling dissimilar materials and deep holes
- Positive feed operation provides constant rate of feed and constant chip load during drilling
- Peck feed cycle clears chips out of the hole providing excellent hole quality
- One shot drilling capability for dissimilar material stacks
- No drift in the set back point preventing cutter damage from bottoming out on forward stroke of peck cycle

- Adjustable activation of peck cycle from 0–30 seconds
- Adjustable peck time control from 0–10 seconds
- Automatic adjustment of the retraction stroke based on drilling depth
- Fluid spindle available for threaded shank cutters
- Peck feed automatically stops when spindle is retracted
- Tool automatically shuts off at completion of drilling cycle

Extra Cost Accessories

- Nosepiece
- Mounted lubricator with or without counter
- Concentric collet jig attachment
- Various handle configurations

Operating Range

- 90–110 psi.



Model	Motor Configuration	HP	Max. Stroke		Weight		Max. Length		Spindle Speeds (rpm)	Feed Per Revolution		Inlet	Min. Hose
			in.	mm	lbs	kg	in.	mm		Inches	mm		
965QB	Inline	.9	4	101.6	10	4.54	13.92	354	750, 1100	.001, .002, .003, .004, .006	.03, .05, .07, .10, .15	.375" NPT	.50"

Rated tool performance at 90 PSIG measured at tool inlet with motor running. 45 CFM at 90 PSIG.

DRILL CAPACITIES

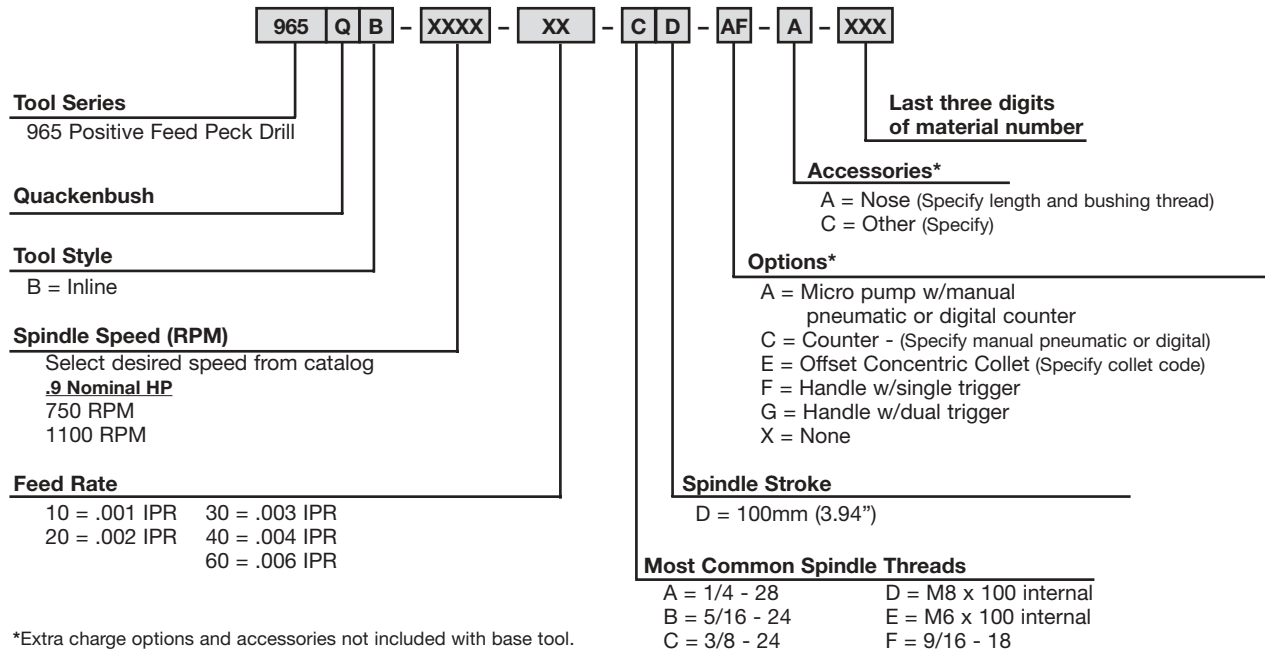
Peck drill allows larger diameter holes than conventional drilling with respect to motor horsepower. Maximum diameter capacity will depend on drill cutter chosen geometry and material. Stock thickness and lubrication need to be considered also.

WHEN ORDERING TOOL:

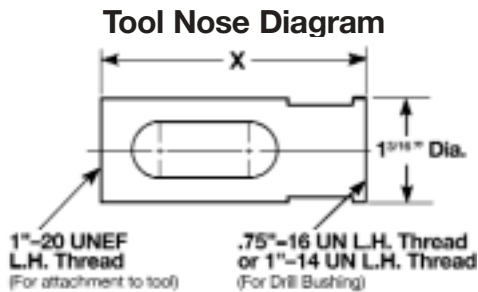
Tool nose, spindle, rpm, feed rate and extra cost accessories must be specified when tool is ordered.

Please specify the rpm, feed rate, and spindle which are part of the base tool cost. Options and accessories are specified with the model number. Options and accessories are extra charge items.

Quackenbush 965QB Model Number Nomenclature



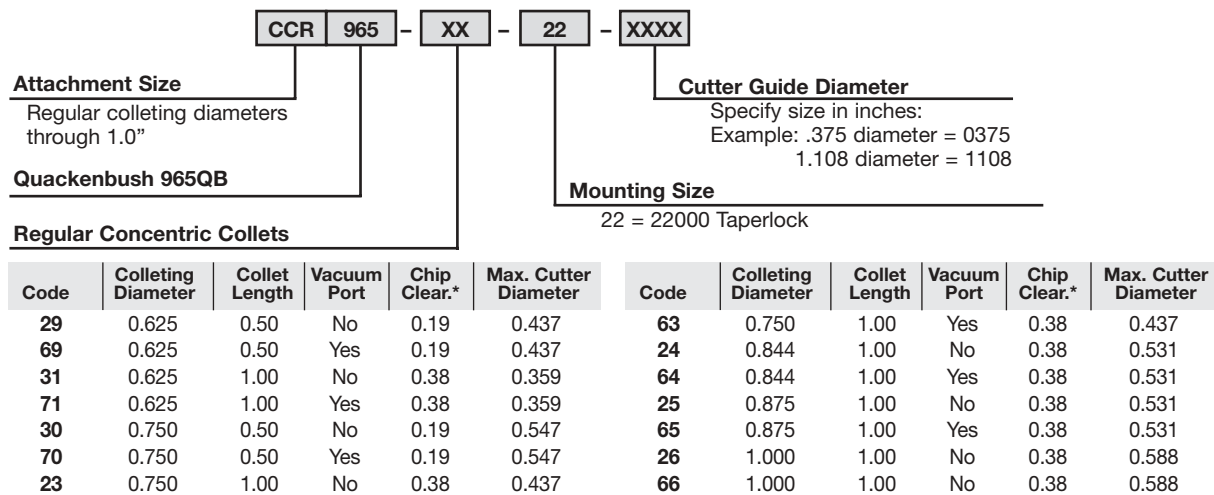
Quackenbush 965QB Tool Noses & Spindle Assemblies



Standard Tool Noses

Bushing Thread	Length X	Part Number
.75 - 16 UN LH	2.0"	614615
.75 - 16 UN LH	3.0"	614905
.75 - 16 UN LH	4.0"	614824
1" - 14 UN LH	2.0"	614718
1" - 14 UN LH	3.0"	614906
1" - 14 UN LH	4.0"	629528

Quackenbush 965QB Concentric Collet Attachment Specification



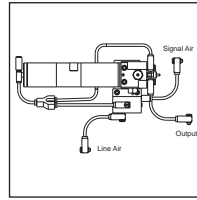
*Chip clearance is distance from end of collet to end of collet body. Normally, end of collet body contacts workpiece, but for non-depth drilling, contact is not necessary.

Quackenbush 965QB Accessories



Single Trigger Handle – 22009966

Ergonomic pistol grip handle with single trigger for cycle starts.



Micropump System

wo/ counter – 22007067*

w/manual counter – 22007057*

w/digital counter – 22007057E*

Micropump system allows accurate adjustment of lubricant and air volume.



Dual Trigger Handle – 22009967

Ergonomic pistol grip handle with dual trigger for cycle start and control of locking device (concentric collet). Clamping trigger must engage before cycle start trigger will activate drilling.



Optional Offset Concentric Collet by Recoules

Available with dual trigger handle option or no handle.



Pneumatic Counter – 22008167*

Manual pneumatic counter counts number of cycles.

Digital Counter – 22008167E*

Digital counter counts up to a selected number giving operator a red blinking signal.



Parts & Tool Kits

Complete spare parts kit – **23501031**

Emergency spare parts kit – **23501032**

Maintenance tool kit – **23501033**

*Micropump/counter bracket – **22008274**



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