

Portable Magnetic Base Drilling Machine

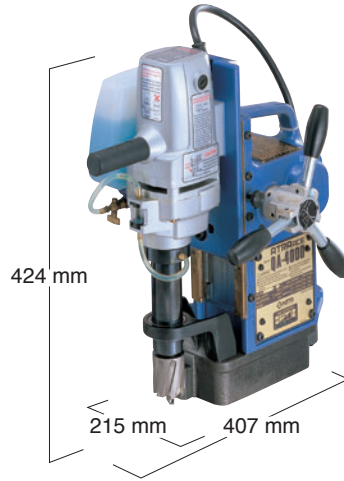
ATRA ACE quick auto

Fully automatic drilling for increased productivity and reduced cost

- Proven Automatic Technology (self feeding, automatic return, load detection for speed and feed regulation)

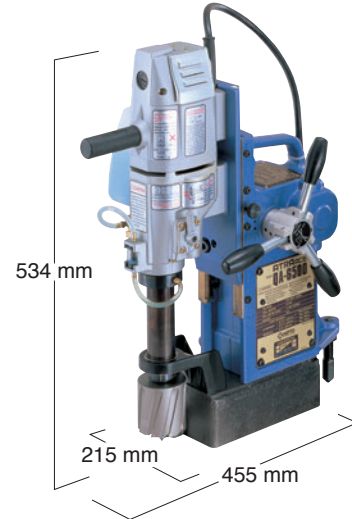
Model QA-4000 Non-CE

- Max. 40 mm dia. x 35 mm deep



Model QA-6500 Non-CE

- Max. 65 mm dia. x 50 mm deep

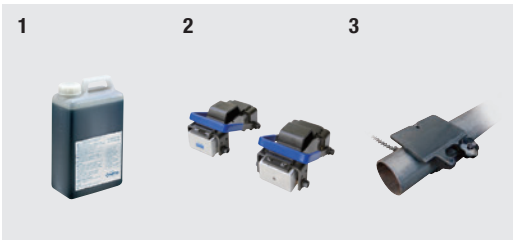


Specifications

Model		QA-4000		QA-6500		
Power Source (Single Phase)		110 - 120 V AC, 50/60 HZ		220 - 240 V AC, 50/60 Hz		
Electric Drill	Rated Power Consumption	W	680	1010		
	Rated Current	A	6.1	3.0		
	No-load Speed	min ⁻¹ (rpm)	750	400 / 750		
Magnet Power Consumption		W	50	75		
Hole Capacity mm	Cutter	Hole Diameter	Plate Thickness	Hole Diameter	Plate Thickness	
		One-touch Type JETBROACH 35L	17.5 to 40	9 to 35	17.5 to 40	9 to 35
		One-touch Type JETBROACH 50L	-	-	17.5 to 65	9 to 50
		One-touch Type HI-BROACH 25L	14 to 15	9 to 12	18 to 35	9 to 25
	16 to 18	9 to 25				
Max. Stroke		mm	75	88		
Magnet Holding Power		N(kgf)	6664 (680)	9800 (1000)		
Magnet Dimensions		mm	82 x 172	100 x 200		
Power Cord Length		m	4	5	5	
Mass (Weight)		kg	18.5	26		
Accessories Included		<ul style="list-style-type: none"> • Oil Tank • Cutting Oil 0.5L • Pilot Pin 08035 • Side Handle • 3 mm Hex. Socket Screw Key 		<ul style="list-style-type: none"> • 4 mm Hex. Socket Screw Key • 8 x 10 mm Spanner • Chain • Tool Box 		
		<ul style="list-style-type: none"> • 4 mm Hex. Socket Screw Key • 8 x 10 mm Spanner • Chip Stopper • Chain • Tool Box 				

Optional Accessories

Ref. No.	PN	Description	Sales Unit	Applicable Model	
				QA-4000	QA-6500
1	TB01507	Cutting Oil 2L	1 piece	●	●
2	TB04374	Supporting Magnet Ass'y	1 piece	●	●
3	TB07696	Pipe Attachment Ass'y	1 piece	●	●
		One-touch Type JETBROACH 35L	1 piece	●	●
		One-touch Type JETBROACH 50L	1 piece	●	●
		One-touch Type HI-BROACH 12L	1 piece	●	●
		One-touch Type HI-BROACH 25L	1 piece	●	●

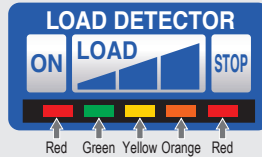


Automatic Return

Once drilling is completed and the slug is ejected from the hole, the cutting bit is quickly retracted. This quick drill motor retraction allows the user to move onto the next hole more quickly.

Self Feeding & Load Detection

The feeding is controlled by an onboard microcomputer. The feed rate begins slowly and then increases to the appropriate speed for the cutter size and load condition. The load detector clearly shows the amount of resistance on the cutter at anytime.



Built-in Motion Sensor

If any lateral movement or excess vibration is detected, both the drill and the feed motor stop. Nitto Kohki is the first company to incorporate this feature into magnetic base drills.

Step Feed

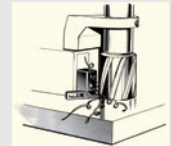
When cutting through difficult materials, the load sensor will automatically activate the Step Feed Program to help penetrate material.

Limit Switch

The ATRA ACE Automatic Drills utilize a limit switch that resets the machine when it retracts to the starting position after hole completion, also shuts down the motors in the event of an over-travel at the bottom of the stroke.

Chip Breaker

This chip breaker prevents the cutter from becoming jammed with metal shavings.



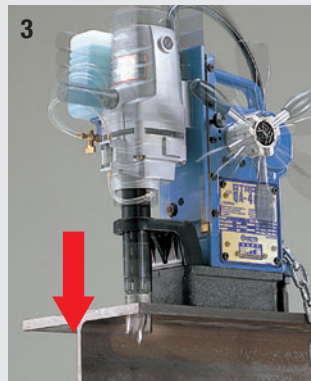
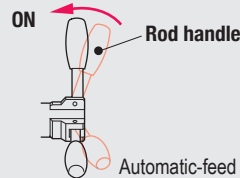
Automatic-feed Hole-cutting Procedure



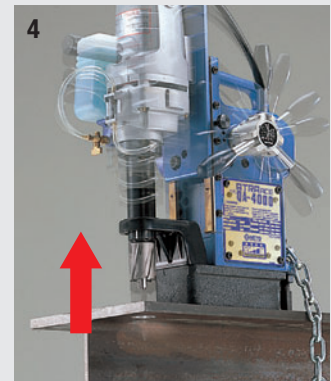
Align the pilot pin with the center punch mark of the hole to be drilled. Attach the machine to the beam with the proper safety chain and engage the magnet. Lower the drill down from the top limit switch location to the point of the pilot pin making contact with the material and engage the motor.



Engage the clutch by pushing the handles in towards the drill and the motor will begin feeding automatically.



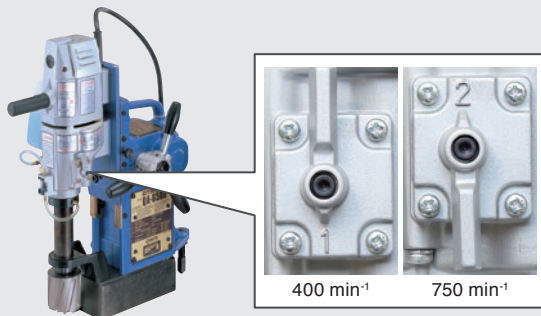
Slow start mechanism cuts smoothly through the mill scale. Then, speed and feed rate is controlled by the sensors to achieve efficient drilling.



After the hole is completed, the QA Series machines will quickly return and stop at the top of the stroke, ready for the next hole.

Two Speed Selection (QA-6500)

Speed can be changed to suit the type and size of the cutter.



One-touch Cutter Replacement

Replacement is quick and easy with our unique push fit self-centering cutter system.



Mounting the cutter



Removing the cutter