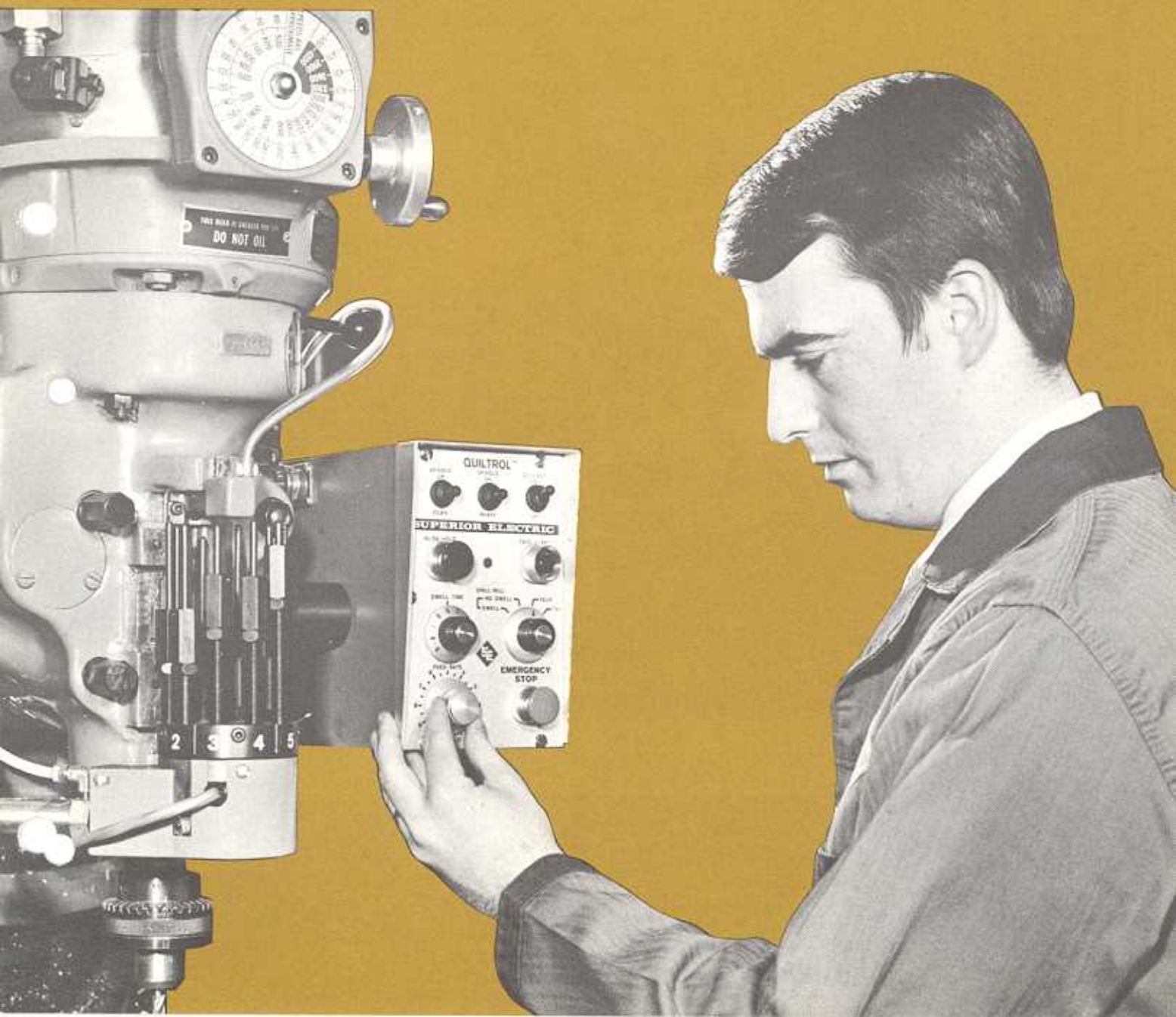


SUPERIOR ELECTRIC

QUILTROL™ ACTUATORS

- Safe, 24 volt power system
- Detachable 10-station feed and depth stop turret
- Drill, mill and tap operating modes
- Adjustable dwell timer for drill/mill mode
- Peck cycle for deep-hole drilling
- Motor and brake controls available
- Spindle and coolant on-off from tape (with motor control)
- Can be used with Tapmatic or similar tapping heads
- Slide hold control
- Emergency stop • Tape start



QUILTROL™

QUILTROL Actuators have all the operating features needed to handle virtually any machining operation. Each actuator includes a control head, automatic 10-station depth stop turret, air filter and regulator. All components of the spindle feed are fully enclosed for safety and protection from dust and chips. The quill can be manually operated without disengaging the actuator for use when setting up.

MODELS

QUILTROL Actuator type BHM144222-G1 is recommended for use with spindles rated less than 3 hp. For multiple spindle applications or for spindles rated 3 hp or more, type BHM144278-G1 should be specified. Adapter kits are not interchangeable between the two models. Be sure to order the correct adapter kit for the machine model and QUILTROL Actuator type used. Consult the factory when ordering a QUILTROL Actuator for a multiple spindle application.



10-STATION TURRET

The tape actuated turret has ten stations with individually adjustable feed engagement controls and depth stops at each station. The turret can be easily detached with the feed and depth stop adjustments in place, allowing the entire setup to be retained for future production of the same part.

PECKING FOR DEEP HOLE DRILLING

In the pecking mode, the unit will periodically raise the tool from the work to clear all chips and allow coolant to flow into the hole. The tool will retract just beyond the original feed engagement point and will return at rapid speed to approximately 1/32" from the previous depth, then change to slow feed.

TAPPING MODE

When operating in the tapping mode, the unit will feed and retract the quill at the same rate, eliminating the need for synchronizing separate feed and retract settings.

EMERGENCY STOP

An Emergency Stop button located on the panel will stop all table motion, retract the tool, turn off the spindle motor and coolant and apply the spindle brake.

SLIDE HOLD

Table motion can be interrupted at any time by pressing the Slide Hold button on the actuator panel or on the N/C. A lamp on the N/C panel will indicate when the Slide Hold is activated.

TAPE START

The Tape Start function can be initiated from the actuator control panel or from the N/C.

DWELL TIME

When operating in the Drill/Mill mode a Dwell Timer controls tool dwell interval. During drilling operations, the tool will stay down for this preset interval before retracting. For milling, the tool must remain at the bottom of its stroke for this interval before table motion will begin. A No-Dwell mode can also be selected.

OPTIONAL FEATURES

MOTOR CONTROL

The motor control allows starting and stopping of the spindle motor and coolant pump from tape or from the actuator control panel. Contacts are also available to operate a lubricant pump for the machine lead screws and ways. Motor control part numbers for specific spindle horsepower ranges are listed in the chart.

SPINDLE HORSE POWER	MOTOR CONTROL TYPE
less than 3 hp	BHM144214-G1
3 hp or more	BHM144214-G2

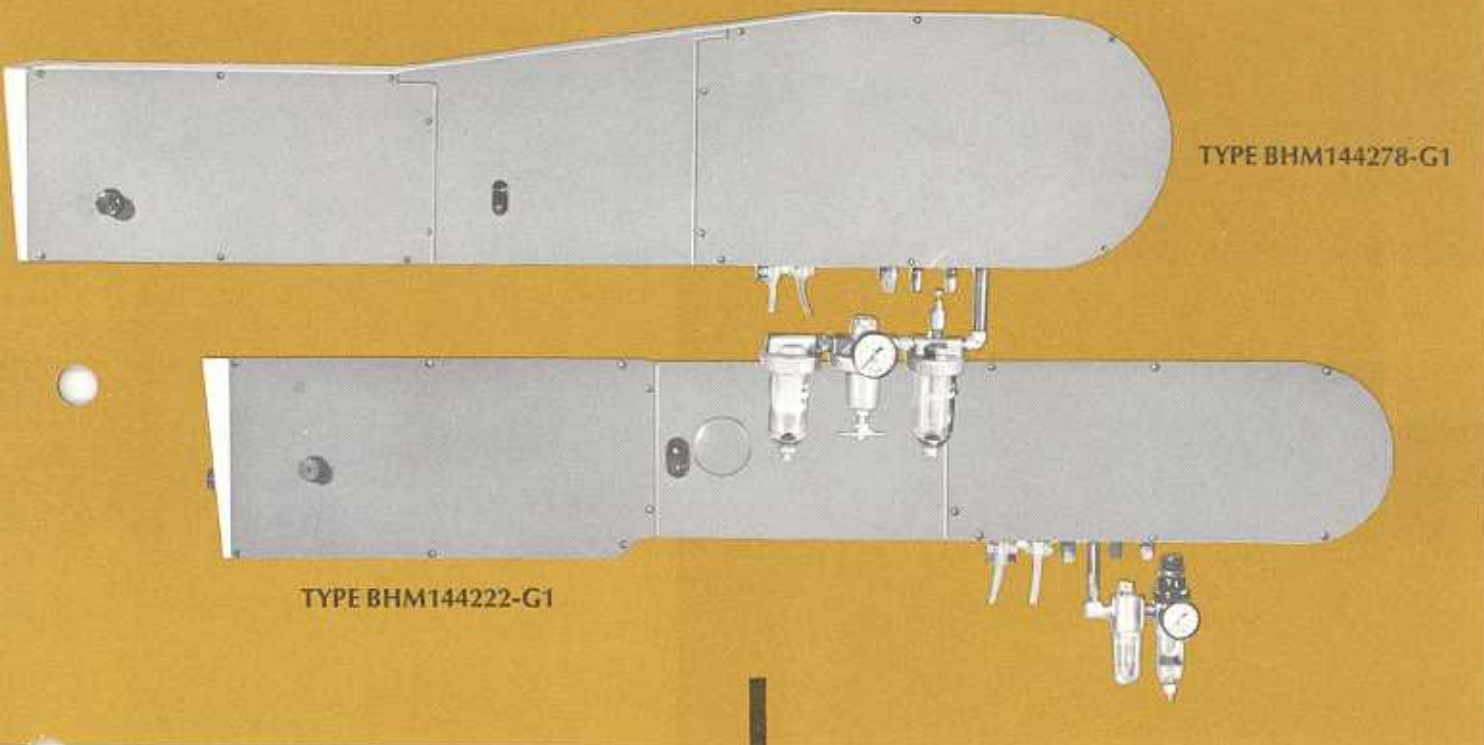
BRAKE CONTROL

The brake control kit is used in conjunction with the motor control. It consists of an air cylinder and the machine parts needed to power the existing manually operated brake. The brake can be actuated and held on by the motor control. Be sure to select the correct brake control kit for your machine.

SPARE TURRET AND PIN ASSEMBLY (PART NO. DHM144249-G1)

Spare turret and pin assemblies are offered for use where it is desirable to retain feed and depth stop adjustments for specific part requirements. The assembly includes ten depth stops and feed engagement pins and a mounting drum.

ACTUATORS



TYPE BHM144222-G1

TYPE BHM144278-G1



ACCESSORIES FOR TYPE BHM144278-G1 QUILTRON ACTUATOR

MACHINE		ADAPTER KIT	BRAKE* KIT
MAKE	MODEL		
BRIDGEPORT	Series II	BHM144293-G2	BHM144221-G12
GORTON	1-22, 2-28	BHM144293-G3	—
SHIZUOKA	AN-S	BHM144293-G1	BHM144221-G7

*Must be used with appropriate motor control.

ACCESSORIES FOR TYPE BHM144222-G1 QUILTRON ACTUATOR

MACHINE		ADAPTER KIT	BRAKE* KIT
MAKE	MODEL		
BEAVER	Mark II	BHM144220-G1	—
BRIDGEPORT	9BRJ, 12BRJ	BHM144220-G2	BHM144221-G6
	9BR2J, 12BR2J	BHM144220-G2	BHM144221-G1
CINCINNATI	HV Toolmaster styles 1B, 1C, 1D, 1E	BHM144220-G3	—
EX-CELL-O	602	BHM144220-G4	BHM144221-G2
FAMCO	120, 200	BHM144220-G8	BHM144221-G5
GORTON	1-22	BHM144220-G5	—
	2-28		
INDEX	745, 747	BHM144220-G9	†
	756, 856	BHM144220-G10	†
	847, 857, 845	BHM144220-G11	†
INDUMA	1/S	BHM144220-G6	BHM144221-G1
LAGUN	FT-1	BHM144220-G13	BHM144221-G13
SOUTH BEND	all models	BHM144220-G7	BHM144221-G4

*Must be used with appropriate motor control.
† Available from machine manufacturer.

WEIGHT

TYPE BHM144222-G1
TYPE BHM144278-G1

..... 80 lbs.
..... 185 lbs.



slo-syn[®] NUMERICAL CONTROL EQUIPMENT

QUILTROL Actuators can be used with the following SLO-SYN Numerical Controls.

SLO-SYN NUMERICAL TAPE CONTROLS

NCI Series (Point-to-Point/Straight Line Milling)

- Two- or three-axis models
- Positioning rates to 300 ipm
- Up to seven unassigned miscellaneous functions
 - Manual data input plus jog control
 - Mirror image
 - Single block operating mode
 - Adjustable backlash compensation
- Low feed range controlled manually or from tape
 - Manual override of tape low feed rate
 - True 45° path in low feed range
 - Tape actuated rapid traverse
 - Slide hold
- EIA codes standard, ASCII optional



SLO-SYN CONTINUOUS PATH CONTOURING CONTROLS

NCC Series

- Two- or three-axis models
- Positioning rates to 300 ipm
- Up to six unassigned miscellaneous functions
- Linear and circular interpolation in low feed range
- Constant cutting rate in low feed range regardless of tool path
- Low feed controlled manually or from tape
- Manual override of tape controlled feed rate
- Tape actuated rapid traverse
- Manual data input plus jog
- Single block operating mode
- Buffer storage
- Slide hold
- Accept EIA or ASCII codes
- Mirror image



The complete line of SLO-SYN Numerical Control Equipment also includes

- SLO-SYN NUMERICAL TAPE CONTROLS NCP Series (Point-to-Point only)
- SLO-SYN POSITIONING TABLES
 - SLO-SYN ROTARY TABLE
- SLO-SYN HYDRAULIC AMPLIFIERS
- SLO-SYN PRECISION N/C MILLING MACHINE
- SLO-SYN N/C POSITIONING SYSTEMS

WARRANTY

The Superior Electric Company, Bristol, Connecticut warrants its apparatus to be free from defects in material and workmanship under normal use and service for a period of one year from date of shipment from the factory or a Superior Electric Company warehouse. The obligation under this warranty is limited to repair or replacement of the apparatus or parts thereof at the factory of The Superior Electric Company. This warranty is in lieu of all other warranties, expressed or implied, and no other representative or person is authorized to assume for us any other liability. This warranty does not apply to any apparatus which has been tampered with or altered in any way or which has been subjected to misuse, neglect or accident.

Before returning any apparatus or parts thereof under the terms of this warranty, written authorization must be obtained from The Superior Electric Company otherwise the shipment cannot be accepted.

The sender is responsible for all transportation charges to and from the factory at Bristol, Connecticut or a Superior Electric service center.

THE SUPERIOR ELECTRIC COMPANY Bristol, Connecticut, U. S. A.

The right to make engineering refinements on all products is reserved. Dimensions and other details are subject to change. When dimensions are critical, detailed drawings should be obtained from the factory.



THE
SUPERIOR ELECTRIC
COMPANY

Bristol, Connecticut 06010