



“Winslow” Nutplate Drillmotor

“Winslow” Ultralite Variable-spacing Nutplate Drillmotor Selection Chart

Customer: _____ Location: _____
 Contact: _____ Contact Phone: _____
 E-mail: _____ Fax: _____

Diagram labels: (PILOT HOLE DIA) ⚠, (C'SINK DIA) ⚠, (RIVET SHANK DIA) ⚠, (RIVET HEAD DIA) ⚠, (DRILL DIA) ⚠, (MATERIAL) ALUM TIT STL, (MAT'L THK), ("A" DIM)

MODEL NO. ("A" DIM) SW _____
 CUTTER _____
 FOOT ASSY _____
 COLLET, CLAMP _____
 MANDREL, CLAMP _____
 BUSHING, COLLET _____
 SPRING, COLLET _____
 Spacer Block _____
 Tool RPM _____
 Lift Finger _____
 OTHER _____

Diagram labels: (C'SINK DIA) ⚠, (DRILL DIA) ⚠, (PILOT HOLE DIA) ⚠, (RIVET SHANK DIA) ⚠, (RIVET HEAD DIA) ⚠, (MATERIAL) ALUM TIT STL, (MAT'L THK), ("A" DIM)

MODEL NO. ("A" DIM) MM _____
 CUTTER _____
 FOOT ASSY _____
 COLLET, CLAMP _____
 MANDREL, CLAMP _____
 BUSHING, COLLET _____
 SPRING, COLLET _____
 Spacer Block _____
 Tool RPM _____
 Lift Finger _____
 OTHER _____

Diagram labels: (PILOT HOLE DIA) ⚠, (C'SINK DIA) ⚠, (DRILL DIA) ⚠, (RIVET SHANK DIA) ⚠, (RIVET HEAD DIA) ⚠, (MATERIAL) ALUM TIT STL, (MAT'L THK), ("B" DIM)

MODEL NO. ("B" DIM) DW _____
 CUTTER _____
 FOOT ASSY _____
 COLLET, CLAMP _____
 MANDREL, CLAMP _____
 BUSHING, COLLET _____
 SPRING, COLLET _____
 Spacer Block _____
 Tool RPM _____
 Lift Finger _____
 OTHER _____

- ⚠ RIVET SHANK DIA DETERMINES DRILL DIA. REFER TO "CUTTER DRILL & C'SINK COMBINATIONS" TABLE FOR DRILL DIA.
- ⚠ THEORETICAL MAX RIVET HEAD DIA DETERMINES C'SINK DIA. REFER TO "CUTTER DRILL & C'SINK COMBINATIONS" TABLE FOR C'SINK DIA.
- ⚠ SPINDLE SPEED OF 7000 RPM RECOMMENDED FOR DRILLING OF ALUM. SPINDLE SPEED OF 700 RPM RECOMMENDED FOR DRILLING OF TIT & STL'S.
- ⚠ CLEARANCE HOLE FOR FASTENER, (TO BE DETERMINED BY USER) ALSO CLAMPING HOLE FOR EXPANDING COLLET.

For any questions or other precision drilling applications, please
 contact us at: 800-832-7009 Fax: 972-660-5491
www.innovativetooling.com

CUTTER DRILL & C'SINK COMBINATIONS		
RIVET SHANK DIA	DRILL DIA	MAX C'SINK & CUTTER SHANK DIA
1/16	.0670	.1250
		.1875
3/32	.0980	.1875
		.2500
1/8	.1285	.2500
		.3125
5/32	.1590	.3125