

Quackenbush™

Introducing  
The New  
Quackenbush  
60QBSF-5 & 70QVBSF-7  
Back Spotfacer Tools



**COOPER** Tools

# Quackenbush 60QBSF-5 & 70QVBSF-7 Back Spotfacer Tools

## 60QBSF-5 Back Spotfacer

Capacity (Diameter):

- Aluminum – 1.18" (30mm)
- Titanium – .75" (20mm)
- Steel – .75" (20mm)

- Precision spot facing, countersinking, or counterboring of the rear side of a hole.
- Smooth and easy operation. Insert pilot (spindle) thru hole. Reach around and lock cutter on to pilot. Manually squeeze feed levers to pull cutter into workpiece.
- Micrometer depth adjustment
- Maintains distance from front surface to spot face.
- Variety of bayonet cutters – order separately from back page
- Note: Cutters must be left hand cut if acquired from another supplier



Model Number	Power & Speed	Order Number
60QBSF-5	.6 Horsepower 500 rpm	680027

**SPECIFICATIONS:**  
Air Inlet = 1/4 NPT  
Weight = 4.9 lbs (2.2 Kg)  
Air Consumption = 30 CFM (850 l/Min)

Max. Stroke = .4 inch (10 mm)  
Depth Repeatability = within .001 inch (0.025 mm)

**GENERAL INFORMATION:**  
Order Pilot Spindle & Cutter separately;

Operators must understand and follow Safety Practices at all times.

## 70QVBSF-7 Back Spotfacer

Capacity (Diameter):

- Aluminum – 1.18" (30mm)
- Titanium – .75" (20mm)
- Steel – .75" (20mm)

- Precision spot facing, countersinking, or counterboring of the rear side of a hole.
- Smooth and easy operation. Insert pilot (spindle) thru hole. Reach around and lock cutter on to pilot. Manually squeeze feed levers to pull cutter into workpiece.
- Governed variable speed motor
- Micrometer depth adjustment
- Maintains distance from front surface to spot face.
- Variety of bayonet cutters – order separately from back page
- Note: Cutters must be left hand cut if acquired from another supplier



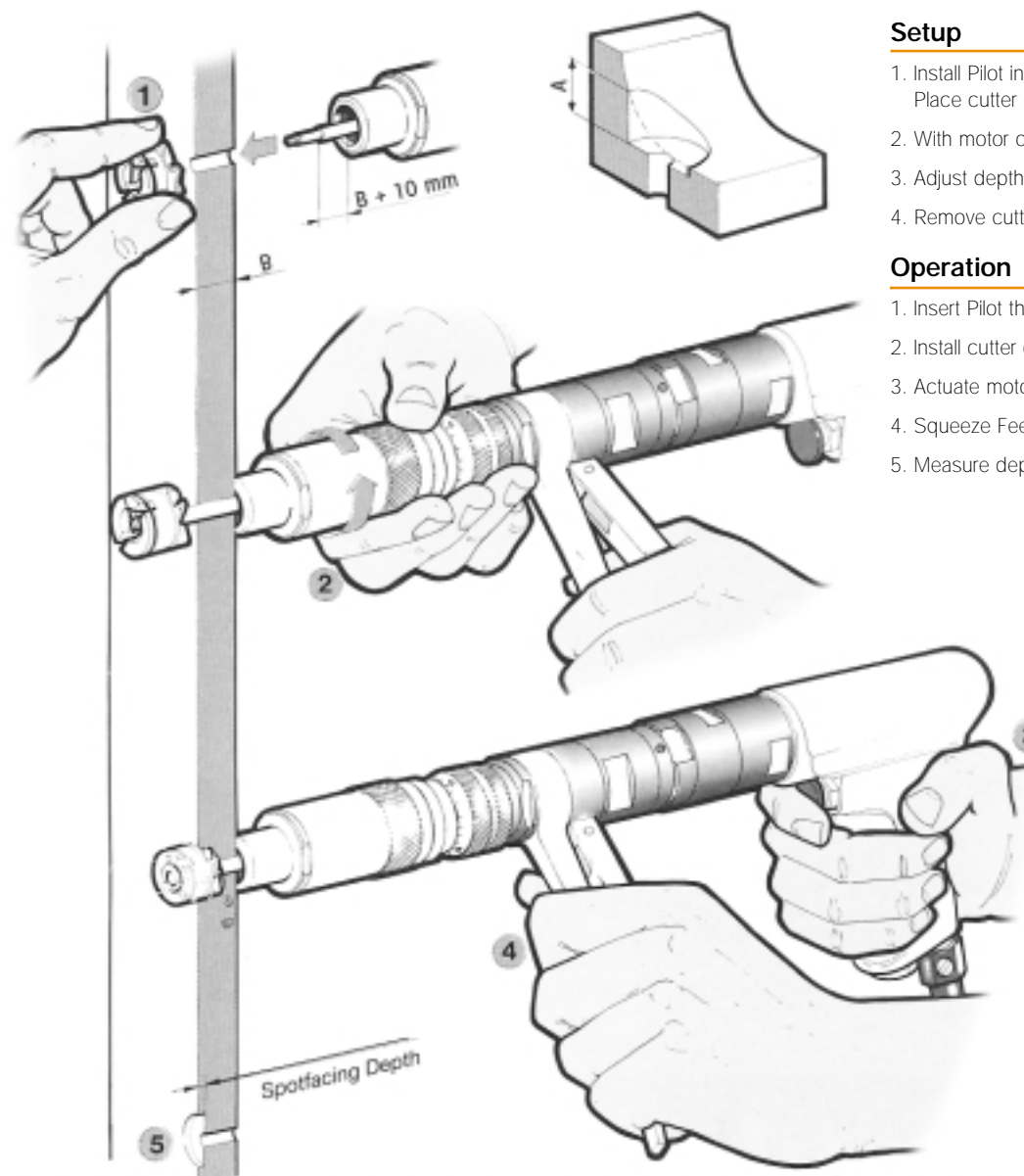
Model Number	Power & Speed	Order Number
70QVBSF-7	.7 Horsepower Variable Speed (150-550 rpm)	680021

**SPECIFICATIONS:**  
Air Inlet = 1/4 NPT  
Weight = 5.4 lbs (2.4 Kg)  
Air Consumption = 30 CFM (850 l/Min)

Max. Stroke = .59 inch (15 mm)  
Depth Repeatability = within .001 inch (0.025 mm)

**GENERAL INFORMATION:**  
Order Pilot Spindle & Cutter separately;

Operators must understand and follow Safety Practices at all times.

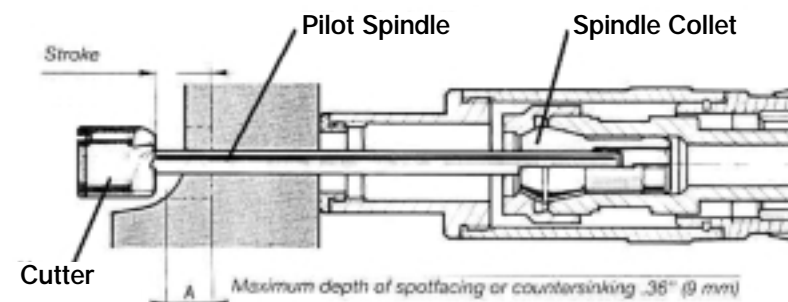


### Setup

1. Install Pilot into Spindle Collet. Place cutter on pilot and twist to lock.
2. With motor off, squeeze Feed Lever and measure depth "A".
3. Adjust depth adjustment to slightly greater than specification.
4. Remove cutter.

### Operation

1. Insert Pilot thru Workpiece.
2. Install cutter on to pilot.
3. Actuate motor trigger.
4. Squeeze Feed Lever until full depth is obtained.
5. Measure depth "A"; adjust Depth Adjustment as required.



### Ordering Information

When ordering a Quackenbush Back Spotfacer tool, it is necessary to also order the Spindle Collet, Pilot Spindle and Cutter. These parts are not automatically shipped with the tool.

1. Specify Tool Ordering Number
2. Specify Spindle Collet Part Number (Note: Collet diameter must equal Pilot Spindle diameter)
3. Specify Pilot Spindle Part Number
4. Specify Cutter Number.

# Accessories

## Spindle Collets (order separately)



Diameter		Part Number
MM	Inch	
2.00	0.078	70110200
2.50	0.098	70110250
3.00	0.118	70110300
3.50	0.138	70110350
4.00	0.158	70110400
4.80	0.188	70110480
5.00	0.197	70110500
5.50	0.217	70110550
6.00	0.236	70110600
6.35	0.250	70110635
7.94	0.312	70110794
9.52	0.375	70110952

Collet diameter must equal pilot spindle diameter.

## Pilot Spindle – Bayonet Lock



Cutter Hole Dia.	Pilot Spindle Dia. 0 -0.02		Pilot Part Number
	mm	Inch	
3	3	.118	31400000
3	3.2	.126	31400004
3	3.5	.137	31400005
3	3.9	.153	31400010
3	4	.157	31400015
3	5	.196	31400020
4	4	.157	31400100
4	4.5	.177	31400105
4	4.8	.188	31400110
4	5	.196	31400115
4	5.4	.212	31400120
4	6	.236	31400125
5	5	.196	31400200
5	6	.236	31400210
5	7	.275	31400225
5	8	.314	31400230
6	6	.236	31400300
6	6.3	.248	31400305
6	7	.275	31400315
6	8	.314	31400320
6	9	.354	31400325
6	9.5	.374	31400330
6	10	.393	31400335

## Back Spotfacing Cutters with, Bayonet Lock – High Speed Cobalt Steel



Required Tools: Cutter – 31300250  
Pilot – 31400125

Ring Number	Spotfacing Diameter		Standard Radius R mm	H mm	Cutter Hole Diameter		Cutter Number
	mm	Inch			mm	Ø D1	
91825010	8	.315	0.5	10	3	8	31300000
91825010	10	.394	0.5	10	3	8	31300025
91825015	12	.472	0.5	10	3	10	31300050
91825015	12.7	.500	1	10	3	10	31300075
91825015	13	.512	1	10	3	10	31300100
91825015	14	.551	1	10	3	10	31300125
91825015	14	.551	1	16	4	10	31300150
91825025	15	.591	1	16	4	14	31300175
91825025	16	.630	1	16	4	14	31300200
91825025	17	.670	1	16	4	14	31300225
91825025	18	.709	1	16	4	14	31300250
91825025	19	.748	1	16	4	14	31300275
91825025	20	.787	1	16	4	14	31300300
91825035	22	.866	2	18	5	20	31300325
91825035	24	.945	2	18	5	20	31300350
91825035	26	1.024	2	20	6	20	31300375*
91825035	28	1.102	2	20	6	20	31300400*
91825035	30	1.181	2	20	6	20	31300425*
91825035	32	1.260	2	20	6	20	31300450*

## Back Countersink Cutters, 4 Flutes with Bayonet Lock – High Speed Cobalt Steel



Required Tools: Cutter – 31305250  
Pilot – 31400125

Ring Number	Spotfacing Diameter		H mm	Cutter Hole Diameter mm	Cutter Number α: 90°	Cutter Number α: 100°	Cutter Number α: 120°
	mm	Inch					
91825010	8	.315	10	3	31305000*	31306000	31307000
91825010	10	.394	10	3	31305025*	31306025	31307025
91825020	12	.472	10	3	31305050*	31306050	31307050
91825020	12.7	.500	10	3		31306075	
91825020	13	.512	10	3		31306100	
91825025	14	.551	10	3		31300125	
91825025	14	.551	16	4	31305150*	31306150	31307150
91825025	15	.591	16	4		31306175	
91825030	16	.630	16	4	31305200*	31306200	31307200
91825030	17	.669	16	4		31306225	
91825030	18	.709	16	4	31305250*	31306250	31307250



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