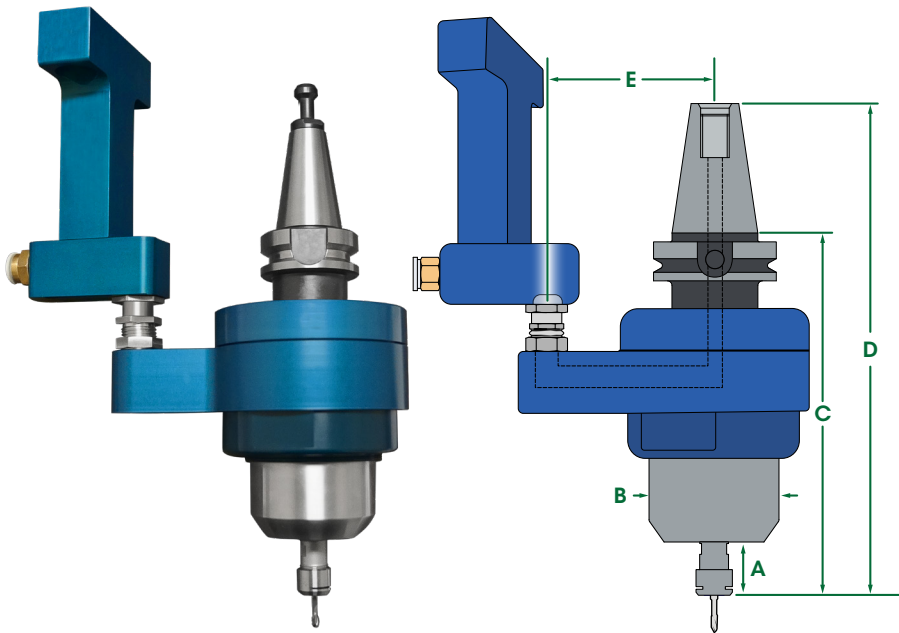


625DT
Drill-Tap CNC Spindle Series



Just fit the patented, single turbine 625DT Series spindle to your Drill-Tap machine magazine for increased production with tool automatic tool change functionality. Increase milling and drilling feed rates with no duty cycle for true 24/7 unattended production – 30,000, 40,000, 50,000 or 65,000 RPM, up to 0.55 HP (0.41 kW). For automatic loading from the Drill-Tap magazine, install the spindle mounted manifold block and align the nozzle to block connector, which supplies clean, dry 90 psi (6.2 bar) air to the spindle.

625DT Dimensions



All fittings, couplings, and hoses must have a minimum of 6 mm internal diameter.

Table with dimensions A, B, C, D, and E for different machine models (Robodril, Brother TC, Haas DT).

625DT Specifications

Table with specifications: Speed, Power Rating, Inlet Air Pressure, Air Consumption Idle, Air Consumption Working Flow, Air Hoses and Fittings Minimum Size, Sound Level, Max Shank Capacity, Spindle & TMA Collar Weight.

Accessories

Table with 2 columns: Model, Part Number. Lists accessories like High Flow Filter, Tube, and Hose & Fitting.

625DT Equipment Included

- 625BT30 Spindle
TMA Block
TMA Collar
Combo Filter Extractor
ER11 UP Collet System
Collet Wrenches
Air Hose
Fittings
Plug
Coolant Guard
Carrying Case

Standard Equipment

ER11 UP collet system. 1/4" or 6 mm standard, other sizes are available.
Oil-free 90 psi / 6.2 bar clean, dry air supply required.



Scan to consult full user instructions.

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Supply is subject to Air Turbine Technology Inc. (ATT) distributor policies and upon terms and conditions contained in the ATT distributor agreement. Subject to availability, change of specifications, price and terms without notice. Always use a 0.3 micron filter/extractor and check specified air flow. 6.2 bar / 90 psi clean, dry, oil-free air only. Use eye protection and follow safety instructions. All specifications approximate. All tools are tested and rated to be within 10% of designated speed. © 2025 Air Turbine Technology, Inc. All rights reserved.

# 625DT

## Drill-Tap CNC Spindle Series



### 625DT Series Part Numbers

| Model                   | Collet System | Part Number |            |            |            |
|-------------------------|---------------|-------------|------------|------------|------------|
|                         |               | 30,000 RPM  | 40,000 RPM | 50,000 RPM | 65,000 RPM |
| 625DTBT30<br>Robodrill  | ER11 UP 1/4"  | 65350       | 65352      | 65354      | 65356      |
|                         | ER11 UP 6 mm  | 65351       | 65353      | 65355      | 65357      |
| 625DTBT30<br>Brother TC | ER11 UP 1/4"  | 65358       | 65360      | 65362      | 65364      |
|                         | ER11 UP 6 mm  | 65359       | 65361      | 65363      | 65365      |
| 625DTBT30<br>Haas DT-1  | ER11 UP 1/4"  | 64642       | 64644      | 64646      | 65304      |
|                         | ER11 UP 6 mm  | 64643       | 64645      | 64647      | 65305      |

### Spindle Only Part Numbers

| Model     | Collet System | Part Number |            |            |            |
|-----------|---------------|-------------|------------|------------|------------|
|           |               | 30,000 RPM  | 40,000 RPM | 50,000 RPM | 65,000 RPM |
| 625DTBT30 | ER11 UP 1/4"  | 64210       | 64212      | 64306      | 65138      |
|           | ER11 UP 6 mm  | 64211       | 64213      | 64307      | 65139      |

### TMA (Block + Collar) Part Numbers

| Model              | Part Number |
|--------------------|-------------|
| 625DT - Robodrill  | 36302       |
| 625DT - Brother TC | 36303       |
| 625DT - Haas DT-1  | 36305       |

### Block Assembly Only Part Numbers

| Model              | Part Number |
|--------------------|-------------|
| 625DT - Robodrill  | 36314       |
| 625DT - Brother TC | 36315       |
| 625DT - Haas DT-1  | 36316       |

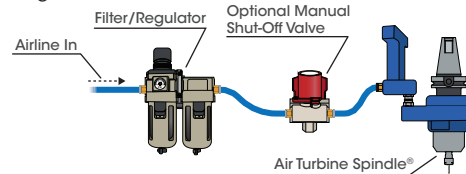
### Collar Assembly Only Part Numbers

| Model              | Part Number |
|--------------------|-------------|
| 625DT - Robodrill  | 36318       |
| 625DT - Brother TC | 36320       |
| 625DT - Haas DT-1  | 36324       |

Mounting blocks for other CNC machines are available.

### Initial Installation

Install a new dedicated clean air line from the included filter/regulator to your Air Turbine Spindle® as shown below. **Ensure all air lines, couplings and fittings meet the minimum internal diameter (ID) of 6 mm.** Any connections smaller than 6 mm will restrict air flow and reduce power to your Air Turbine Spindle®. Additionally, place a plug in any air inlet that is not being used.



Air flow restrictions (such as air leaks) will cause underpower performance and drag your tool through the material, damaging the bearings. **Some fittings with nominal internal dimensions may have an internal diameter passage that is smaller than stated and restrict air flow and power.** It only takes one fitting with an internal diameter that is too small to reduce air flow and power of your Air Turbine Spindle®.

### Air Requirements

**Do not oil or lubricate. Use dry, clean, oil free 90 psi (6.2 bar) air supply only.** Ensure there is sufficient volume of clean compressed air flow at 90 psi (6.2 bar) with **11 CFM - 20 CFM (5.19 L/s - 9.44 L/s)** to maintain working air consumption. Depending on application, consider peak or stall capacity consumption.

Our patented governor increases air flow volume on demand to keep rotation at the high speed when your tool starts to cut. **Air pressure and flow volume must be available on demand and remain constant with no drop over time or when cutting.** Avoid pressure below 90 psi / 6.2 bar, which causes rapid bearing wear and underpowered performance. Do not use more than 100 psi / 6.9 bar pressure which will burst the turbine power producer. Air pressure and flow must remain constant with no drops under cutting load. Insufficient flow will cause the rotation of your tool to slow or stop suddenly, damaging the bearings. If a drop in psi (bar) occurs below 90 psi (6.2 bar), your compressor may not have enough CFM (L/s) to power the Air Turbine Spindle® or there is a flow restriction in the air line.

### Maintenance

**Your Air Turbine Spindle® must be run at least 10 minutes every 30 days from manufacture date to maintain optimal performance. Run at least 10 minutes before initial use.** The airline must be impeccably clean with no coupling or hose smaller than 6 mm internal diameter. The included 0.3 micron filter extractor regulator combination is a necessary accessory for Air Turbine Spindles® to eliminate impurities in your air supply. Contamination will damage your turbine components and require repair. **Filter elements need to be changed periodically, and extractor drained in regular maintenance cycles.** Replacement elements and a repair service are available on our website.

### Operation

**Purge the line of contamination and run at least 10 minutes before initial use to ensure the bearing lubrication does not solidify.**

Monitor the air pressure gauge during operation of your Air Turbine Spindle®. The key to successful high-speed machining and optimized tool performance is to program light passes at very high feed rates. Start with a light pass observing surface finish quality and gradually step down or increase your rate of advance for optimal cutting conditions. Do not try to cut too aggressively. You will overload your turbine causing your cutting tool to stall or drag in the material. Dragging your tool on the work or a sudden stop will cause stress to the bearings and force the grease out, causing premature failure.



#### WARNING

Connection to air supply starts motor rotation. Do not connect air to your tool until installation is complete.

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