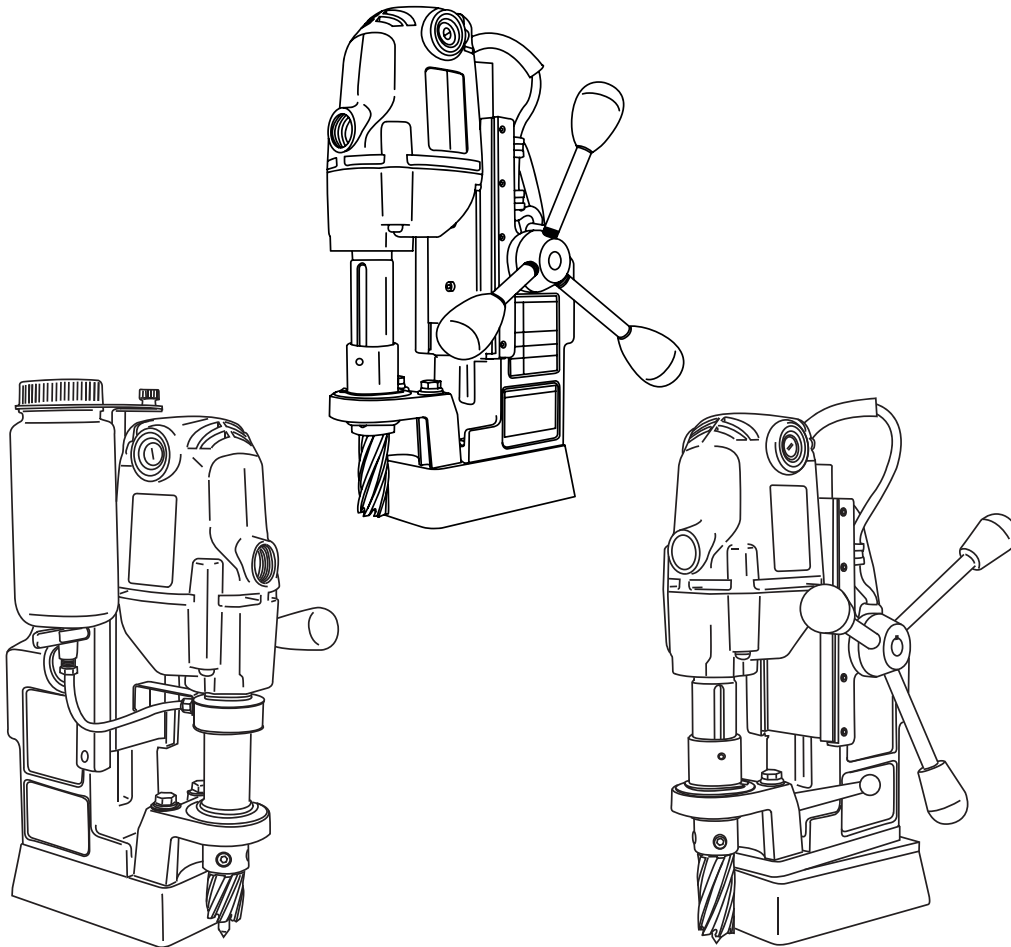




HMD904 SERIES PORTABLE MAGNETIC DRILL

OPERATOR'S MANUAL

COVERS DRILL PART NUMBER 0904101, 0904102 , 0904103,
0904201, 0904202 & 0904203



FOR USE WITH "12,000-SERIES" HOUGEN[®] CUTTERS

UNPACKING YOUR NEW MAGNETIC DRILL

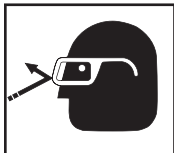
1. Open shipping carton and remove the literature and hardware packages.
2. **Read and Follow All Instructions** before attempting to operate your new Magnetic Drill.
3. Complete and mail the Product Registration Card now. It is important that Hougen Manufacturing, Inc. have a record of product ownership.
4. Open hardware package and check contents.
 - 10565 1/8" Hex wrench for Gib Adjustment
 - 04558 Feed handles (3)
 - 04532 Feed handle knobs (3)
 - 10506 Set screw for cutter installation (2)
 - 10730 Safety chain
 - 02635 Hex wrench for cutter installation
 - 13013 5/32" Hex wrench
5. Using the handle of Magnetic Drill, lift unit out of the shipping case.
6. Remove all packing and securing material from the drill unit.
7. Screw the three Knobs (04532) into the three Feed Handles (04558) and then screw Handles into the Hub Assembly (40254). Do not overtighten or may strip the knobs.
8. Your Magnetic Drill was factory adjusted prior to shipping. Check to make sure that all gib adjustment screws, motor mount screws, front support bracket screws, and magnet mounting screws are snug and have not vibrated loose in transit.
9. Your new Magnetic Drill comes complete with arbor mounted. The 3/4" diameter arbor bore fits all 3/4"-shank "12,000-Series" Hougen Cutters.

Reread Safety Warnings listed in the Operator's Manual and on the drill unit to avoid injury. Follow operating procedures.

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SAFETY FIRST



Always wear eye protection while using cutting tools, or in the vicinity of cutting.



CAUTION! Cutters are sharp. Wear gloves when installing or removing cutter from arbor. Do not grab a rotating cutter.



CAUTION! The slug is ejected at the end of the cut. Do not aim cutter or arbor so that ejected slug may hit someone around, or below you.



CAUTION! To prevent electric shock, do not use power tools near wet areas, or where power tool may become wet.

Important Safety Instructions



WARNING: When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock, and personal injury, including the following:

1. Read All Instructions

2. Grounding Instructions

This tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with a 3-conductor cord and a 3-prong grounding type plug to fit the proper grounding type receptacle. The green (or green and yellow) conductor in the cord is the grounding wire. Never connect the green (or green and yellow) wire to a live terminal. (Refer to Plug Diagram) Section A

3. Safe Electrical Connection

Your Mag Drill is rated for use on 115VAC (Plug A) or 230V (Plug B) at 50-60Hz. Do not attempt to use drill on power sources rated other than this. Wet electrical connections are shock hazards. To prevent the cutting fluid from traveling along the cord and contacting the plug or power outlet, tie a drip loop in the power cord. Also elevate extension cords or gang box connections.

4. Extension Cords

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-pole receptacles that accept the tool's plug. Replace or repair damaged cords. Make sure the conductor size is large enough to prevent excessive voltage drop which will cause loss of power and possible motor damage.

5. Do Not Force Tool

It will do the job better and faster at the rate for which it was intended.

6. Keep Work Area Clean

Cluttered areas and benches invite injuries. Keep dirt and chips from under the Cutter area.

7. Consider Work Area Environment

Do not expose tool to rain.
Do not use tool in damp or wet locations.
Keep work area well lit.
Do not use tool in presence of flammable liquids or gases. Disconnect from power source when changing cutters or maintaining drill.

8. Guard Against Electric Shock

Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges, refrigerator enclosures.

9. Keep Children Away

Do not let visitors contact tool. All visitors should be kept away from work area while in use.

10. Store Idle Tools

When not in use, tools should be stored in a dry, and high or locked-up place — out of reach of children.

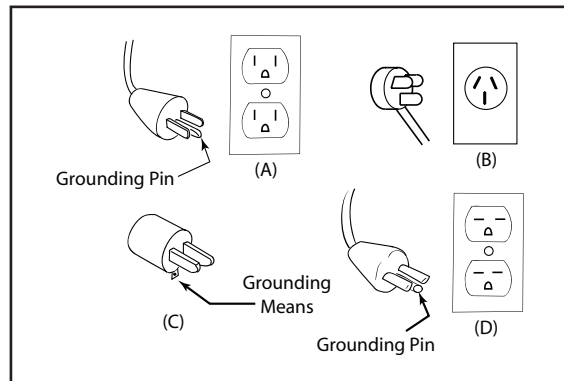
11. Use Right Tool

Do not force small tool or attachment to do the job of a heavy duty tool.
Do not use tool for purpose not intended — for example — do not use a circular saw for cutting tree limbs or logs.

Extension Cord Table

LENGTH OF CORD, FEET	RECOMMENDED WIRE GAUGE	RECOMMENDED WIRE GAUGE
	115V MOTOR 10 - 12 AMPS	230 V MOTOR 5 - 6 AMPS
UP TO 25	16	18
26 - 50	14	18
51 - 100	10	16
101 - 200	8	14
201 - 300	6	12
301 - 500	4	10

Plugs and Receptacles



12. Non-Conforming Cutting Tools

Your Mag Drill is designed to use Houghn Cutters. The use of drilling tools having different shank styles is not recommended as they may not tighten securely in the drill arbor with risk of accident or injury.

13. Secure Work

Use clamps or a vise to hold work. It is safer than using your hand and it frees both hands to operate tool.

14. Always Wear Safety Glasses or Goggles

15. Dress Properly

Do not wear loose clothing or jewelry. They might entangle with spinning chips or get caught in moving parts. Rubber gloves and nonskid foot wear are recommended when working outdoors. Wear sturdy leather gloves when working indoors. Wear protective hair covering to contain long hair.

16. Do Not Abuse Cord

Never carry drill unit by its cord or yank it to disconnect from receptacle. Keep cord away from heat, oil, and sharp edges.

17. Do Not Overreach

Keep proper footing and balance at all time.

Important Safety Instructions - Continued

18. Maintain Tools With Care

Keep tools sharp and clean for better and safer performance. Do not use dull or broken Hougén Cutters. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have repaired by authorized service facility. Inspect extension cords periodically and, if damaged, have repaired by authorized service facility. Keep handles dry, clean, and free from oil and grease.

19. Disconnect Tools

Disconnect when not in use, before servicing, and when changing cutters or accessories.

20. Remove Adjusting Keys and Wrenches

Form a habit of checking to see that keys and wrenches are removed from tool before turning it on.

21. Check Damaged Parts

Before further use of the drill, a part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in this operator manual. Do not operate tool if switch does not turn it on and off.

22. Stay Alert

Watch what you are doing and use common sense. Do not operate tool when you are tired. Have defective switches replaced by authorized service center.

23. Outdoor Use Extension Cords

When tool is used outdoors, use only extension cords intended for use outdoors and so marked.

24. Additional Safety Precautions

Arbor and cutter should never be used as a hand-hold. Keep hands and clothing away from all moving parts. Do not use Hougén Cutters where ejected slug might cause injury (slug ejected at end of cut). Also, adhere to all operating instructions. Do not drill through any surface that may contain live electrical wiring. Drilling into a live wire could cause exposed metal parts of the drill to be made live. Remove chips wrapped around Cutter and arbor after each hole. With motor off and power disconnected, grasp chips with leather gloved hand or pliers and pull while rotating counterclockwise. Should the cutter become jammed in the work, stop the unit immediately to prevent personal injury. Disconnect the drill from the power supply and loosen jammed cutter by turning the arbor counterclockwise. Never attempt to free the jammed cutter by starting the motor. Service at authorized repair center only.

25. Operating Near Welding Equipment

DO NOT operate this unit on the same work surface that welding is being performed on. Severe damage to the unit, particularly the power cord, could occur. This could also result in personal injury to the operator.

26. Circuit Breaker

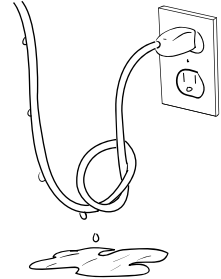
Changing of the circuit breaker to a higher amp rated breaker, or bypassing the circuit breaker is not recommended and will void product warranty.

27. Circuit Breaker Operation

The circuit breaker is a thermal breaker. When it reaches the higher temperature rating it will trip and cause the unit to shut down. This is a protective device and can be reset after 5 to 10. To reset the breaker, press the breaker button back in. If it does not reset, let the unit cool a little longer until you can push the button in and it stays in position.

28. Safe Electrical Connection

Wet electrical connections are shock hazards. To prevent the cutting fluid from traveling along the cord and contacting the plug or power outlet, tie a drip loop as shown. Also elevate extension cords or gang box connections.



29. Save these Instructions.

SAFETY SWITCH INDICATOR LIGHT

The Safety Switch Indicator Light is a Standard Safety Feature on HMD904 magnetic drills. Its purpose is to inform the user that an unsafe condition exists.

If light is Green:

In normal operation the safety switch light will be green. Motor "On" and "Off" Switches function normally.

If light is Red:

A condition with the safety switch exists that needs to be corrected.

Possible causes:

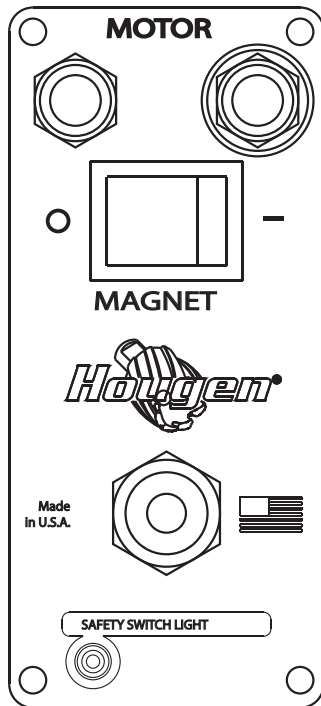
- Safety Switch is defective. Have drill serviced.
- Uneven work surface or material. Check work surface for flatness.
- Dirt or chips under magnet. Clean work surface.

Material should be a least 3/8" thick. Material thinner than 3/8" will cause a "weak" magnet condition.

HOUGEN MANUFACTURING RECOMMENDS THAT CONDITIONS ARE CORRECTED SO LIGHT TURNS GREEN. THIS ALLOWS FOR THE UNIT TO BE OPERATED IN A SAFE MANNER.

For any questions please contact Hougén Manufacturing's Technical Service at (810) 635-7111.

OPERATION OF CONTROLS BEFORE INSTALLING HOUGEN CUTTER



CONTROL PANEL SWITCH PLATE
FIGURE 2

IMPORTANT: Before turning on the machine, it is important that the operator understands the interrelated functions of the **SAFETY SWITCH, MAGNET SWITCH, AND MOTOR SWITCHES.**

READ SAFETY SWITCH INDICATOR LIGHT INSTRUCTIONS ON PREVIOUS PAGE.

SAFETY SWITCH — Located in base of drill. Enables motor operation only when magnet is properly seated on a clean and flat work surface. Turns motor off if switch detects lift of unit.

MAGNET ON/OFF SWITCH — Energizes and De-energizes the magnetic base and activates the safety switch. Motor can now be started by pushing the motor **START** switch.

MOTOR START/STOP SWITCHES — Starts and stops the motor (See instructions previous page).

1. Place Magnetic Drill on clean, flat steel plate that is at least 3/8" thick.
2. Plug unit into proper AC power source. **DO NOT use with DC Power.**
3. Locate the Magnet **ON** and **OFF** switch and the motor **STOP** and **START** switch (Fig. 2).
4. **NOTE: A loss of power will de-energize the magnetic base and deactivate the motor. When power is restored, the magnet will reenergize, however, the motor START switch must be depressed before the motor will start.**

OPERATING INSTRUCTIONS

Always remember that the magnet's holding power is directly related to the workpiece thickness and surface condition. Since magnetic attraction diminishes with thinner material or rough surfaces, mechanical clamping of drill unit to the workpiece should be used when cutting thin material (3/8" or less) or material with uneven surfaces.

1. Make sure workpiece and bottom of magnet are free of chips, oil, etc.
2. Position drill by sliding it and gently feeding Arbor so that pilot point is touching center of hole to be drilled.
3. **Secure unit to workpiece with safety chain.**
4. Turn magnet ON by pressing the magnet ON switch.
5. Turn Feed Handle, raising the cutter until the pilot is above the work surface.
6. Make certain that cutter is clear of workpiece and turn motor ON by pressing the motor START switch.
7. Feed Hougen Cutter slowly into workpiece. Only after cutting path is established to a depth of about 1/16" can full force be applied to feed handles.
8. Ease up on feed pressure as cutter starts breaking through.
9. At conclusion of cut, turn motor OFF by pressing motor STOP switch. Turn Feed Handles to raise Arbor thereby ejecting the slug if it hasn't already fallen free.
10. Turn magnet OFF by pressing the magnet OFF switch.
11. **Disconnect from power source.**
12. If necessary, remove chips from cutter and magnet, preferably wearing leather work gloves and/or with pliers. Disconnect safety chain and you are ready to move unit to new drilling position.

INSTALLING HOUGEN CUTTER IN ARBOR

1. Disconnect from power source.
2. Lay drill on its side with feed handles up or be sure Arbor clears table if unit is in normal operating position.
3. Turn Feed Handles until cutter mounting set screws are exposed and completely remove the set screws.
4. Insert proper pilot in shank end of Hougen Cutter.
5. Insert Hougen Cutter until flat on cutter shank is aligned with set screw holes and is exactly perpendicular to axis of set screw holes.
6. Insert set screws and tighten. Check to be certain that cutter is secure.

OPERATION OF CUTTING FLUID RESERVOIR

1. With Magnetic Drill in operating position, turn the feed handles so that cutter and pilot are above the work surface.
2. With magnet turned ON and motor OFF, fill reservoir by introducing cutting fluid through slots in Arbor.
Cutting fluid should not leak out.
3. Test metering capabilities of Arbor/Cutter/Pilot assembly (magnet ON-motor OFF) by feeding the Arbor gently toward work surface until pilot is pushed up into Cutter, thus allowing fluid to filter down onto work surface through groove in pilot.
4. For proper lubrication, all cutting fluid in reservoir should empty onto work surface in no less than 15 seconds and no longer than 30 seconds.

ADJUSTMENT OF GIBS

1. Loosen all Gib Screws (40237).
 2. Feed the drill in and out a few times and then, with top of motor slide flush with top of housing, tighten the Gib Screws until you feel them touch the Steel Gib (02431).
 3. Feed the drill in and out again.
 4. Adjust Gib Screws so that there is uniform pressure from top to bottom. (Top of motor slide flush with top of housing.)
 5. Turn each Gib Screw in about 1/8 to 1/4 turn, depending upon your preference.
 6. Gibs should be tight enough so that slide moves up and down smoothly with no wobble or shaking. (Looseness will cause cutter breakage.)
- NOTE: Gibs should be lubricated regularly.**

ARBOR & FRONT SUPPORT BRACKET REMOVAL AND INSTALLATION

Removal

1. Loosen arbor support bracket bolts.
2. Loosen set screws holding arbor onto motor output shaft.
3. Remove arbor.

Installation

1. Hand tighten front support bracket bolts. Do not tighten all the way.
2. Slide arbor to full up position and hold arbor in position over hex drive motor output shaft.
3. Tighten two set screws to hold arbor onto motor output shaft.
4. Turn feed handle until motor and arbor are at the bottom of their travel.
5. Tighten front support bracket bolts to 400 in/lbs.
6. Run motor for 10 seconds. (If visual movement of arbor is noticed, restart at step 1)
7. Re-check for tightness of arbor set screws.

ARBOR ADJUSTMENT

Adjust Gibs before adjusting front support bracket.

1. Loosen Arbor Support Bracket Bolts.
2. Be sure top of arbor is flush with the shoulder on motor output shaft. Also make certain arbor is securely fastened.
3. Turn feed handle until motor and spindle are at the bottom of their travel.
4. Tighten Arbor Support Bolts.
5. Feed slide up and down a few times, checking for free and uniform movement.

NOTE: Check Arbor support bolts regularly to make certain they are tight. Tighten as required.

MAINTENANCE

In order to minimize wear on moving parts and to insure smoother operation and longer life for your magnetic drill, the following maintenance should be done periodically, based on use.

1. Regularly tighten all fasteners and replace all worn parts.
2. Check motor brushes and replace if worn. (Break in period - 30 minutes at no load speed)
3. Check power cord and cord from panel to motor and, if cracked or frayed, return to an authorized repair center for replacement.
4. Apply grease to the slide dovetails, brass gibs, and the feed gear rack. For best results use Shell Cyprina-RA or equivalent.
5. Remove arbor and pack the bearing in the front support bracket with grease. Use Shell Cyprina-RA or equivalent.

HINTS FOR SMOOTHER OPERATION

1. Keep insides of Hougén Cutter clear of chips. Chips will interfere with cutting to maximum depth, may impede the free oil flow and can cause cutter breakage.
2. Keep work, machine, arbor and Hougén Cutter free of chips and dirt.
3. Tighten all bolts and fasteners regularly.
4. We highly recommend using a light viscosity cutting fluid (preferably Hougén Cutting Fluid - Part No. 11742-4)
5. Occasionally check metering of cutting fluid flow. Lack of cutting fluid may cause Hougén Cutter to freeze in cut, slug to stick and may result in poor cutter life.
6. Always start cut with light feed pressure and then increase sufficiently to achieve maximum cutting rate.
7. Ease off on pressure as cutter begins to break through at the end of the cut.
8. Keep slide dovetails, brass gibs and feed rack lubricated and free of chips and dirt.
9. When slug hangs up in cutter, turn off motor and bring cutter down on a flat surface. This will normally straighten a cocked slug, allowing it to be ejected.
10. When cutting large diameter or deep holes it may be necessary to stop in the middle of the cut to add cutting fluid and remove the chips from around the arbor. (When doing this DO NOT raise the cutter out of the hole. Doing so can allow chips to get under the teeth of the cutter and make it difficult to restart the cut.)

#1 cause of cutter breakage and prematurely dull teeth is too little feed pressure*

*** "Babying" the cutter through the cut will only decrease tool life.**

REMEDIES FOR HOLEMAKING PROBLEMS

1. **Trouble: Magnetic base won't hold effectively to work.**
 - a. Cause: Chips or dirt under magnet.
Remedy: Clear area of chips and dirt.
 - b. Cause: Irregular surface on bottom of magnet or on workpiece.
Remedy: Lightly surface grind the bottom of the magnet flat and/or file imperfections flat on the work surface as needed.
2. **Trouble: Cutter tends to move across surface of work.**
 - a. Cause: Magnetic base not holding effectively.
Remedy: See causes and remedies under No. 1 above.
 - b. Cause: Too much feed pressure at start of cut.
Remedy: Light pressure until a groove is cut. The groove then serves as a stabilizer.
 - c. Cause: Worn pilot.
Remedy: Replace pilot
3. **Trouble: Out of round holes.**
 - a. Cause: Worn arbor support bracket bearing and or ejector collar.
Remedy: Replace: (only a few thousandths wear permissible.)
 - b. Cause: Misaligned support bracket
Remedy: Realign support bracket
 - c. Cause: Misaligned or loose arbor set screws.
Remedy: Tighten set screws.
4. **Trouble: Motor and slide won't stay in set position**
 - a. Cause: Gibs too loose
Remedy: Adjust gibs
5. **Trouble: Erratic or intermittent feed.**
 - a. Cause: Worn or pinion and/or rack.
Remedy: Replace worn parts.
6. **Trouble: Motor doesn't run when motor START button is pushed.**
 - a. Cause: Magnet is not turned on
Remedy: Push magnet ON button.
 - b. Cause: Magnet on rough or dirty work surface and safety switch not fully depressed.
Remedy: File work surface flat and clean all chips and oil from under magnet.
 - c. Cause: No power
Remedy: Check power source and extension cords.
 - e. Cause: Worn motor brushes
Remedy: Replace brushes
 - f. Cause: Faulty motor START switch
Remedy: Return unit to an authorized repair center to have switch replaced.

NOTE: If you are unable to correct any malfunction after trying the above, do not attempt to operate the drill. Return the unit to the factory or authorized repair center for service.

SWIVEL BASE ADJUSTMENTS

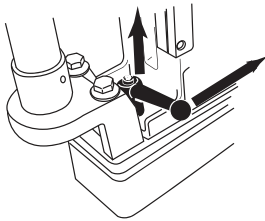
ATTENTION

The threads on the Clamp Handle Assembly are a Left Handed thread meaning,
Turning Clockwise would loosen the assembly
Turning Counter Clockwise would tighten the assembly.

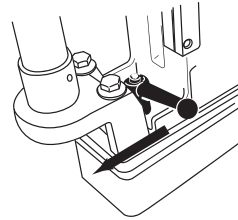
Also, the Clamp Handle Assembly is spring loaded so you will need to lift & turn the entire Clamp Handle Assembly when repositioning as if to be a ratchet device.

To Loosen the Swivel Plate Assembly

1. Lift the Clamp Handle Assembly, rotated counter-clockwise and release .
This will reposition the lever for more movement.



2. With the Clamp Handle Assembly now down, pull the Clamp Handle Assembly clockwise.



With this being a left handed thread this will loosen this assembly.

3. If more travel is needed lift the Clamp Handle Assembly, rotate counter clockwise and release.

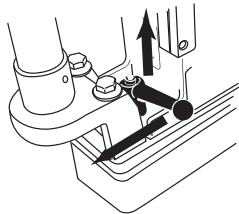
4. Pull the Clamp Handle Assembly clockwise again.

This amount of movement should be adequate to reposition the Drill Assembly.

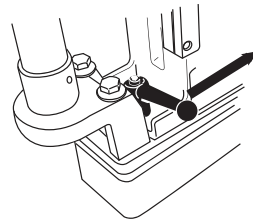
More movement than this may cause the Magnet Assembly to disengage from the drill base.

To Tighten the Swivel Plate Assembly.

1. Lift the Clamp Handle Assembly, rotated clockwise and release .
This will reposition the lever for more movement.



2. With the Clamp Handle Assembly now down, push the Clamp Handle Assembly counter clockwise.



With this being a left handed thread this will tighten this assembly.

3. If more travel is needed lift the Clamp Handle Assembly, rotate clockwise and release.

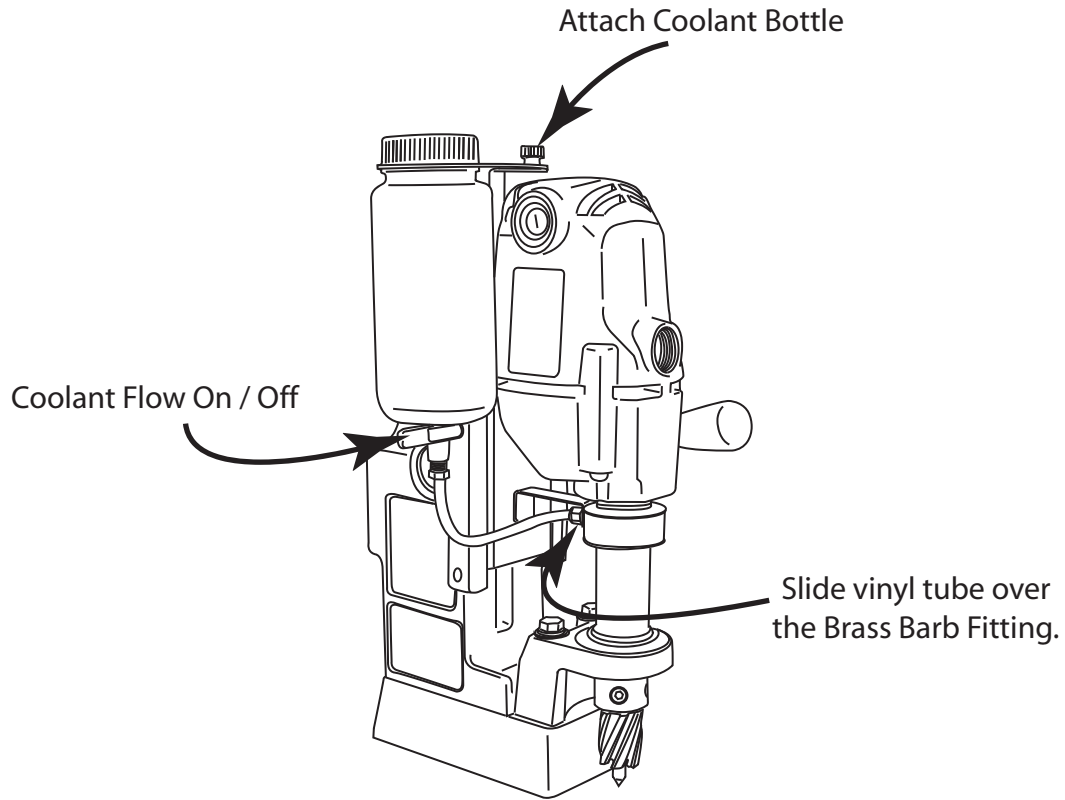
4. Push the Clamp Handle Assembly counter clockwise again.

Continue this process until the Swivel Assembly is tight.



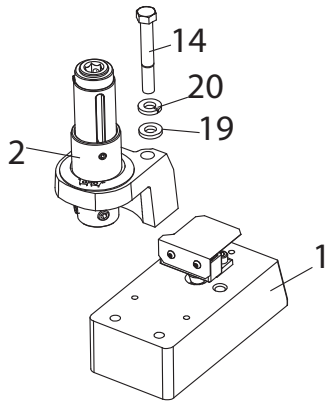
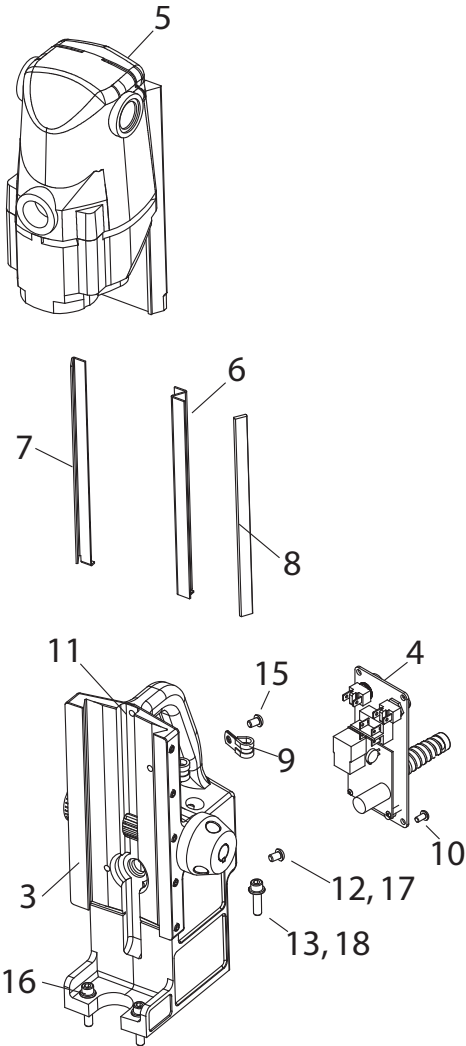
WARNING :
CLAMP HANDLE MUST BE TIGHT PRIOR TO CUTTING HOLES -
EQUIPMENT DAMAGE OR PERSONAL INJURY COULD OCCUR

Coolant Bottle Assembly



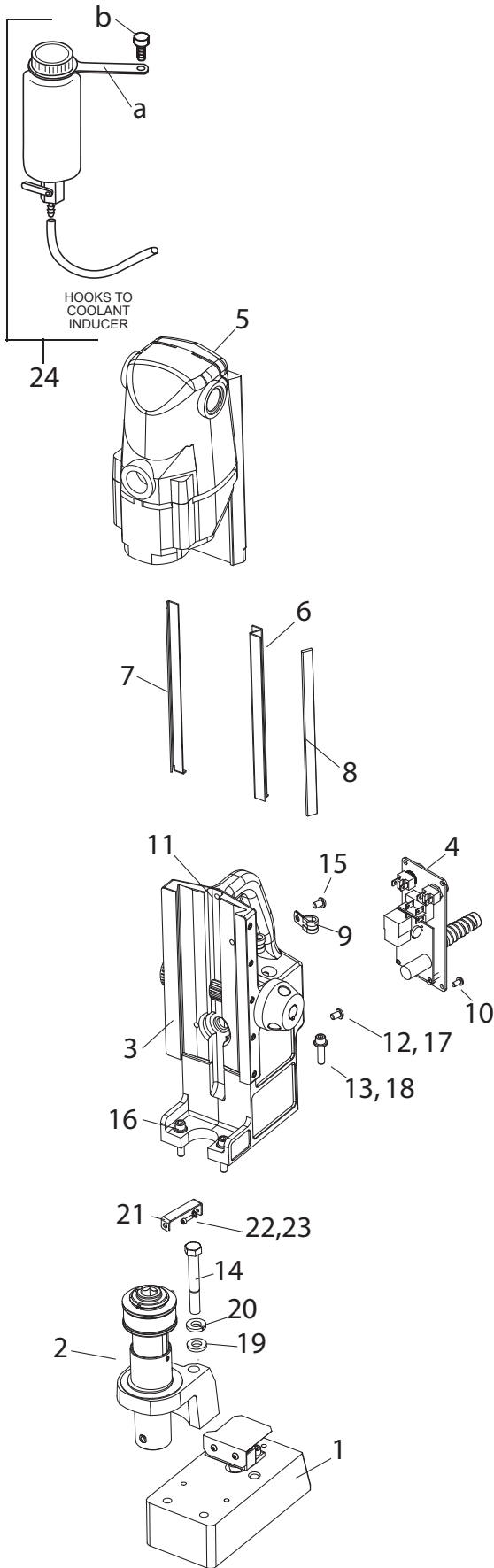
05060 Coolant Bottle Assembly	
05064	Round Bottle
05059	Coolant Bottle Bracket
05065	Ball Valve
05067	Brass Barb Fitting (bottom of the bottle)
40304	Vinyl Tube
07080	Brass Fitting (vinyl tube to coolant inducer) not included in 05060 kit.

Main Assembly Breakdown Standard Base



0904101 120v Mag Base Drill 0904201 230v Mag Base Drill			
Item	Part #	Description	Qty
1	*05378	Magnet & Switch Assembly Standard Base 120v	1
	*05392	Magnet & Switch Assembly Standard Base 230v	1
2	*05470	Arbor/Front Support Assembly	1
3	*07122	Housing Assembly 120v	1
	*07122	Housing Assembly 230v	1
4	*05188	Panel Assembly 120v	1
	*05290	Panel Assembly 230v	1
5	*05482	Motor Slide Assembly 120v	1
	*07179	Motor Slide Assembly 230v	1
6	02429	Brass Gib Right Hand	1
7	02430	Brass Gib Left Hand	1
8	02431	Steel Gib	1
9	02420	Cable Clamp	1
10	41044	Screw BHC #10-32 X 3/8	4
11	40432	Screw SHC 1/4-28 X 3/8	1
12	40214	Screw SHC #6-32 X 1/2 (ground)	1
13	40077	Screw SHC 1/4-20 X 1	1
14	02460	Hex Bolt 3/8-24 X 2-3/4	2
15	02461	Screw BHC 1/4-28 X 3/8	1
16	10553	Screw SHC 1/4-20 X 7/8	2
17	90052	Lock Washer	1
18	90028	Lock Washer	3
19	40392	Flat Washer	2
20	40391	Lock Washer	2
* See Following Pages for Detailed Breakdowns			

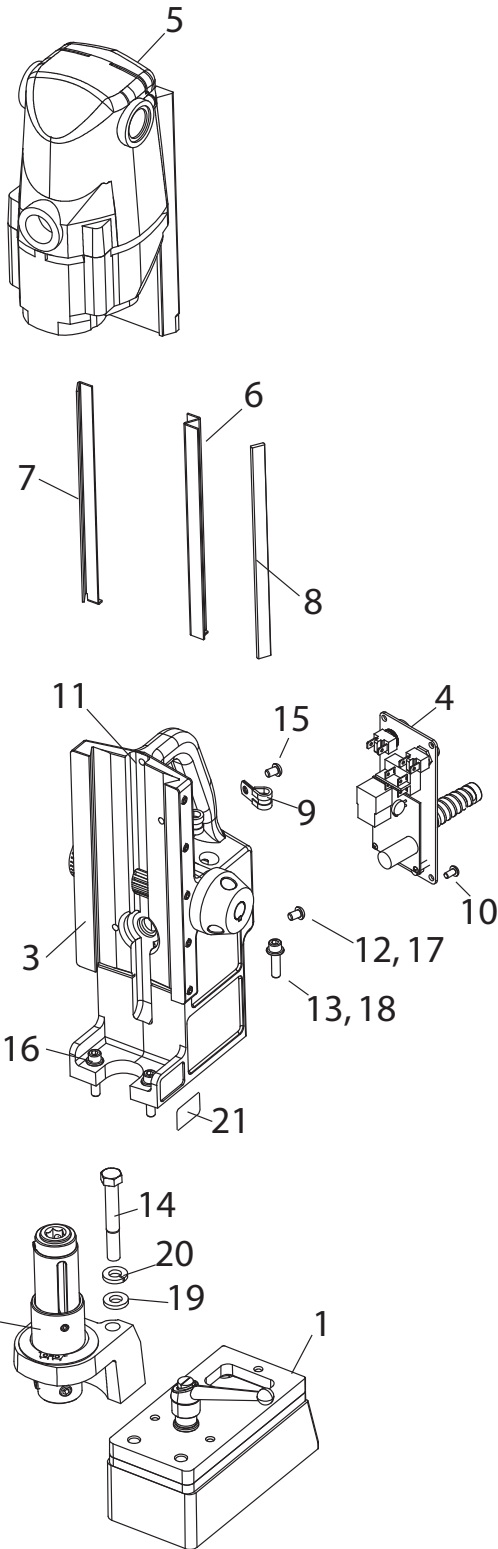
Main Assembly Breakdown Standard Base with Coolant



0904102 120v with Coolant 0904202 230v with Coolant			
Item	Part #	Description	Qty
1	*05378	Magnet & Switch Assembly Standard Base 120v	1
	*05392	Magnet & Switch Assembly Standard Base 230v	1
2	*07155	Arbor/Front Support Assembly	1
3	*07122	Housing Assembly 120v	1
	*04540	Housing Assembly 230v	1
4	*05188	Panel Assembly 120v	1
	*05290	Panel Assembly 230v	1
5	*05676	Motor Slide Assembly 120v	1
	*07180	Motor Slide Assembly 230v	1
6	02429	Brass Gib Right Hand	1
7	02430	Brass Gib Left Hand	1
8	02431	Steel Gib	1
9	02420	Cable Clamp	1
10	41044	Screw BHC #10-32 X 3/8	4
11	40432	Screw SHC 1/4-28 X 3/8	1
12	40214	Screw SHC #6-32 X 1/2 (ground)	1
13	40077	Screw SHC 1/4-20 X 1	1
14	02460	Hex Bolt 3/8-24 X 2-3/4	2
15	02461	Screw BHC 1/4-28 X 3/8	1
16	10553	Screw SHC 1/4-20 X 7/8	2
17	90052	Lock Washer	1
18	90028	Lock Washer	3
19	40392	Flat Washer	2
20	40391	Lock Washer	2
21	07163	Coolant Inducer Bracket	1
22	40038	Screw SHC #10-32 X 5/8	1
23	10560	Lock Washer	1
24	05060	Coolant Bottle Assembly	1
a	05059	Coolant Bottle Holder	1
b	05061	Thumb Screw	1

* See Following Pages for Detailed Breakdowns

Main Assembly Breakdown Swivel Base

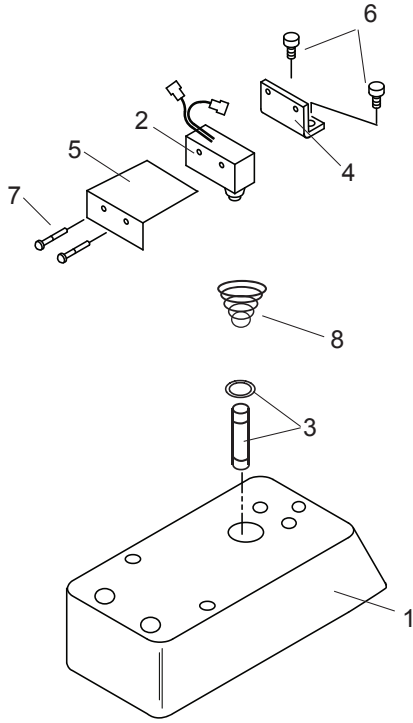


0904103 120v Swivel Base 0904203 230v Swivel Base

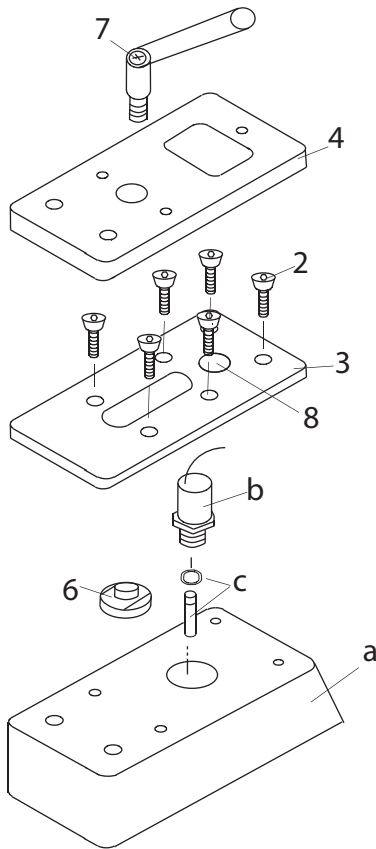
Item	Part #	Description	Qty
1	*05648	Magnet & Switch Assembly Swivel Base 120v	1
	*05894	Magnet & Switch Assembly Swivel Base 230v	1
2	*05733	Arbor/Front Support Assembly	1
3	*04540	Housing Assembly	1
4	*05188	Panel Assembly 120v	1
	*05290	Panel Assembly 230v	1
5	*05667	Motor Slide Assembly 120v	1
	*07180	Motor Slide Assembly 230v	1
6	02429	Brass Gib Right Hand	1
7	02430	Brass Gib Left Hand	1
8	02431	Steel Gib	1
9	02420	Cable Clamp	1
10	41044	Screw BHC #10-32 X 3/8	4
11	40432	Screw SHC 1/4-28 X 3/8	1
12	40214	Screw SHC #6-32 X 1/2 (ground)	1
13	40077	Screw SHC 1/4-20 X 1	1
14	05736	Hex Bolt 3/8-24 X 2	2
15	02461	Screw BHC 1/4-28 X 3/8	1
16	10553	Screw SHC 1/4-20 X 7/8	2
17	90052	Lock Washer	1
18	90028	Lock Washer	3
19	40392	Flat Washer	2
20	40391	Lock Washer	2
21	07015	Swivel Base Label lock/unlock	1

* See Following Pages for Detailed Breakdowns

Magnet Assembly Breakdowns

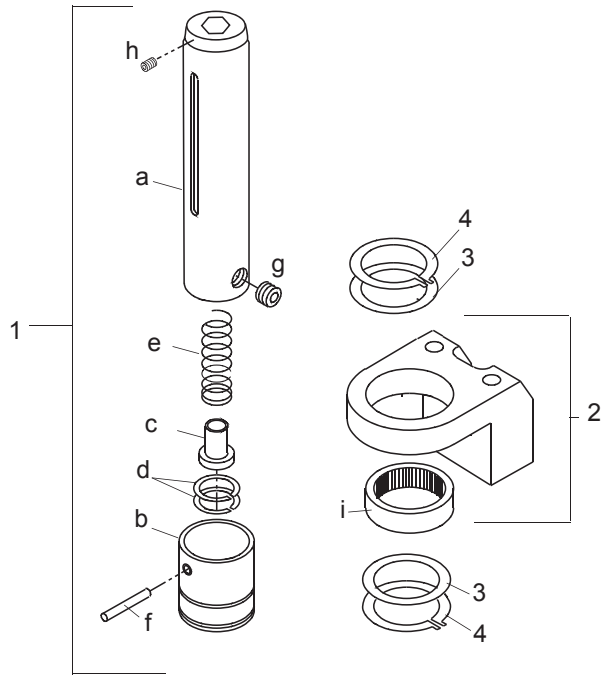


05378 Magnet Assembly 120v			
05392 Magnet Assembly 230v			
Item	Part #	Description	Qty
1	05377	Magnet Assembly 120v	1
	05391	Magnet Assembly 230v	1
2	04885	Safety Switch Assembly	1
3	04910	Plunger Assembly	1
4	04909	Safety Switch Bracket	1
5	10983	Micro Switch Shield	1
6	10971	Screw SHC 1/4-20 X 1/2	2
7	10972	Screw BHC #6-32 X 7/8	2
8	17271	Tapered Spring	1

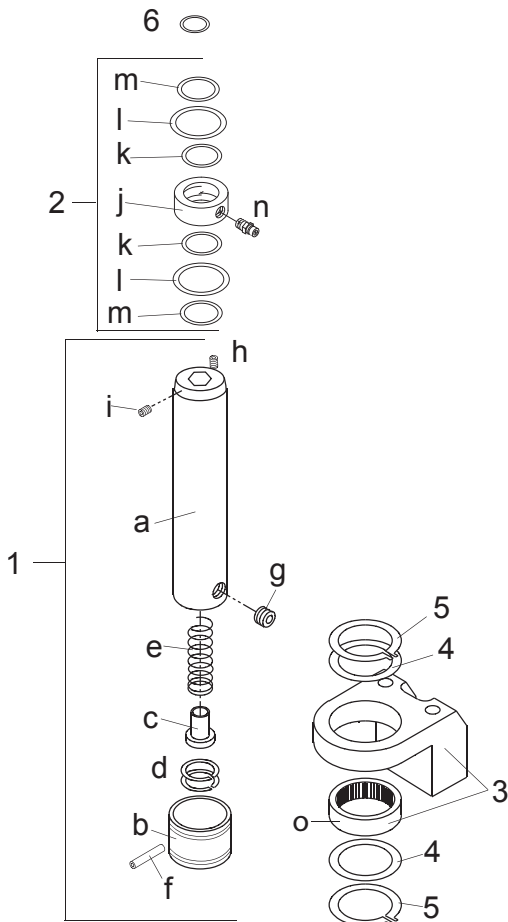


05648 Swivel Magnet Assembly 120v			
05894 Swivel Magnet Assembly 230v			
Item	Part #	Description	Qty
1	05649	Magnet/Safety Switch Assembly 120v includes a-c	1
	05895	Magnet/Safety Switch Assembly 230v includes a-c	
a	05650	Magnet Assembly 120v	1
	05896	Magnet Assembly 230v	1
b	05652	Ball Switch Assembly	1
c	04910	Plunger	1
2	05743	Screw FHC 1/4-20 X 3/4	6
3	05657	Slide Housing	1
4	05656	Swivel Housing	1
5	01169	Dowel Pin 1/8 X 3/8	1
6	05658	Pivot Rod	1
7	05659	Clamp Handle Assembly	1
8	10771	Grommet	1

Arbor/Front Support Assembly Breakdowns



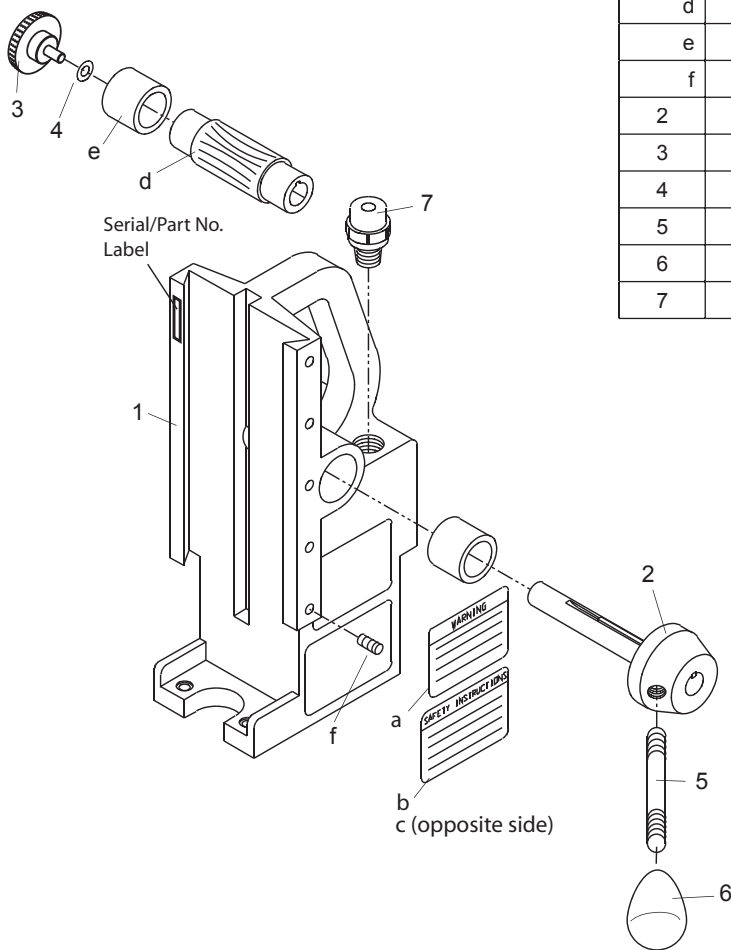
05470 Arbor & Front Support Bracket Assy. non-swivel			
05733 Arbor & Front Support Bracket Assy. swivel			
Item	Part #	Description	Qty
1	05469	Arbor & Collar Assembly (swivel & non-swivel base)	1
a	05458	Arbor Body	1
b	01441	Ejection Collar	1
c	01439	Spring Seat	1
d	10517	Retain. Ring	2
e	05049	Spring	1
f	40312	Roll Pin	1
g	10506	Set Screws 3/8-24 X .305	2
h	05473	Set Screw #10-32 X 3/8	2
2	04375	Front Support Bracket (non-swivel)	1
	05734	Front Support Bracket (swivel)	1
i	40232	Needle Bearing	1
3	40234	Thrust Washer	2
4	40398	Retain. Ring	2



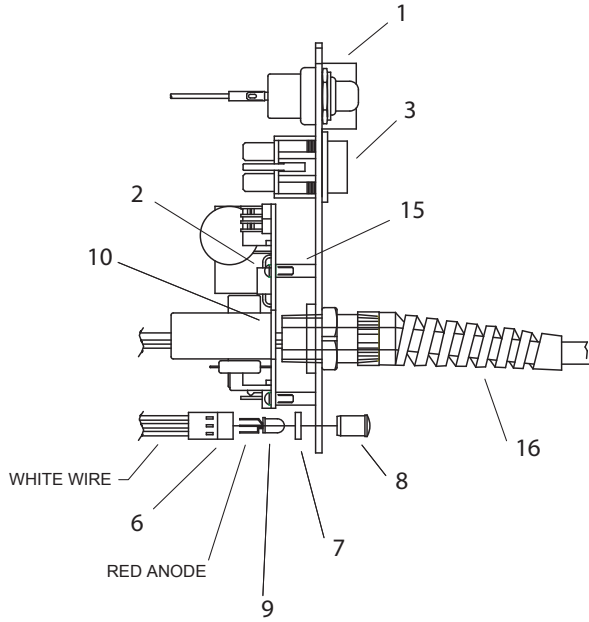
07155 Coolant Arbor Assembly			
Item	Part #	Description	Qty
1	07157	Arbor & Collar Assembly	1
a	07159	Arbor Body	1
b	07162	Ejection Collar	1
c	07161	Spring Seat	1
d	10517	Retain. Ring	2
e	05049	Spring	1
f	40312	Roll Pin	1
g	10506	Set Screws 3/8-24 X .305	2
h	07083	Set Screw m6 X 1 X 5mm	2
i	05628	Set Screw 1/4-28 X 3/8	2
2	07158	Coolant Inducer Assembly	1
j	07160	Inducer Ring	1
k	40300	O-Ring	2
l	40301	Washer	2
m	40302	Retain Ring	2
n	07080	Hose Fitting	1
3	04375	Front Support Bracket Assembly	1
o	40232	Needle Bearing	1
4	40234	Thrust Washer	2
5	40398	Retain. Ring	2
6	04391	O-Ring	1

Housing Assembly Breakdown

07122 Housing Assembly (CSA) 04540 Housing Assembly			
Item	Part #	Description	Qty
1	07121	Housing Assembly for 07122 assy. (includes a-f)	1
	04541	Housing Assembly for 04540 assy. (includes a-f)	
a	07027	CSA Warning Label for 07122 assy.	2
	04530	Warning Label for 04540 assy.	2
b	04529	Safety Label (shown)	1
c	07028	CSA Safety Chain Label for 07122 assy	1
	04553	Safety Chain Label for 04540 assy	1
d	40229	Feed Gear	1
e	40231	Bronze Bushing	2
f	40237	Gib Screws	5
2	40254	Hub Assembly	1
3	05839	Comfort Grip Knob	1
4	10679	Flat Washer	1
5	04558	Feed Handle	3
6	04532	Feed Handle Knob	3
7	02411	Strain Relief	1

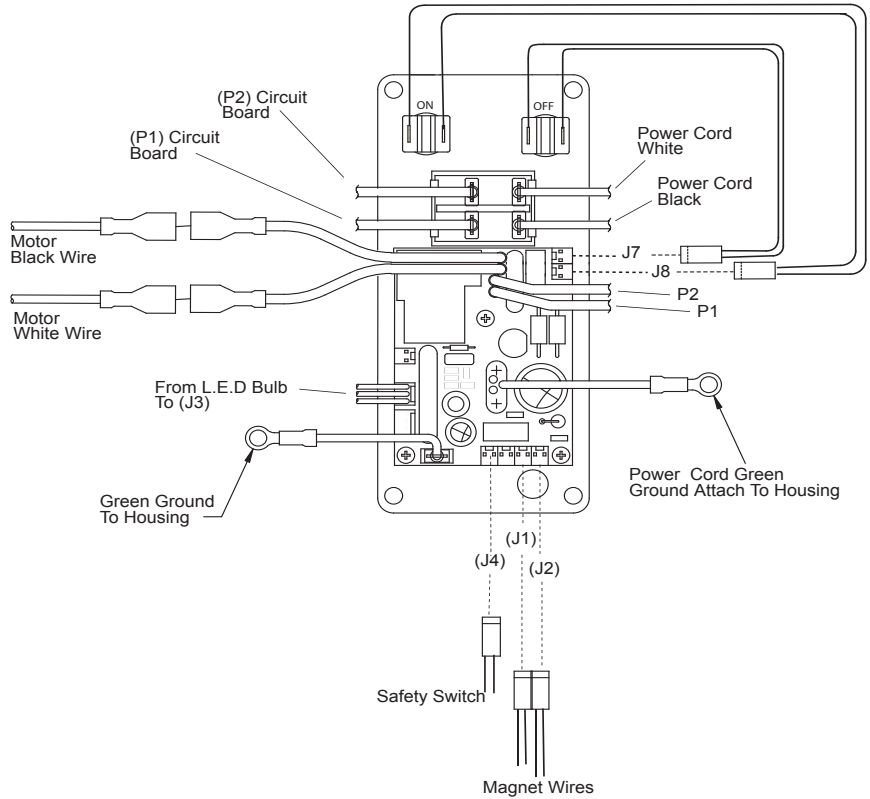
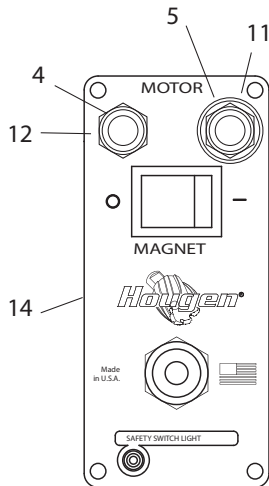


Control Panel Breakdown 120v



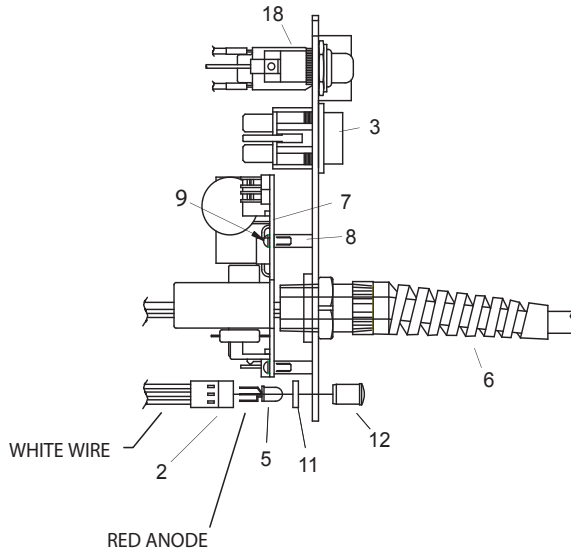
NOTE: WHEN INSERTING L.E.D. DETAIL#5 INTO HARNESS DETAIL#2 MAKE SURE FLAT ON BULB LINES UP WITH WHITE WIRE ON HARNESS.

05188 120v Panel Assembly			
Item	Part #	Description	Qty.
1	01226	Switch Guard	1
2	02547	#4-40 x 5/16 Screw	3
3	04614	Magnet Switch	1
4	04643	Red Switch Cover	1
5	04644	Green Switch Cover	1
6	04877	Wire Harness	1
7	04878	Spacer	1
8	04879	Clear Lens	1
9	04881	Bulb L.E.D	1
10	05826	Circuit Board	1
11	05871	Motor ON Switch	1
12	05872	Motor OFF Switch	1
13	*05205	Green Wire Assembly	1
14	07011	Faceplate	1
15	07012	Stand-Off 3/16 x 9/16 LG	3
16	90571	Power Cord	1
17	*90690	Cable Tie	1
		*not shown	

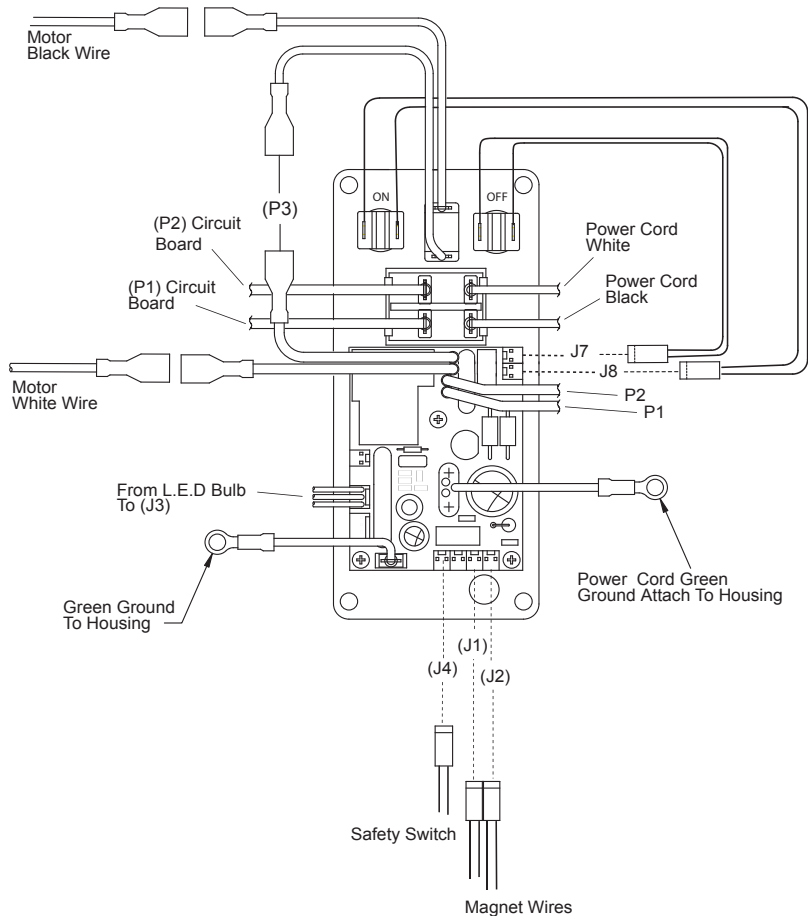
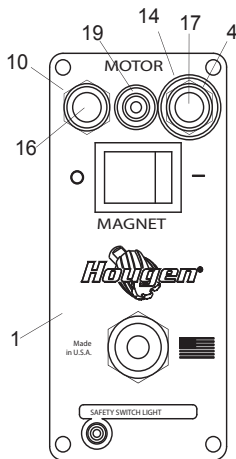


Control Panel Breakdown 230v

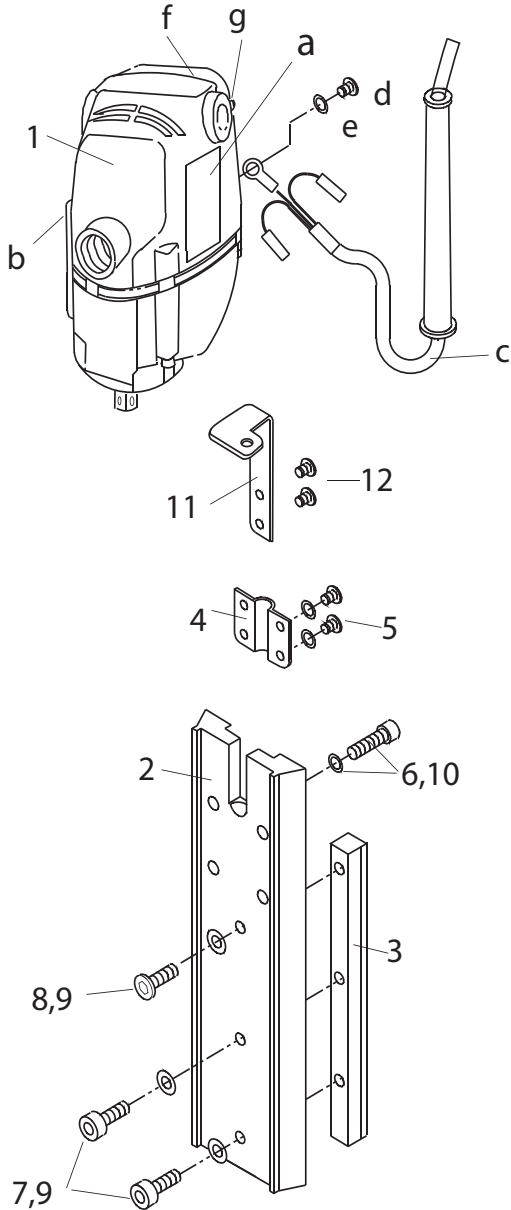
05290 230v Panel Assembly			
Item	Part #	Description	Qty.
1	05929	Faceplate	1
2	04877	Wire Harness	1
3	04664	Magnet Switch	1
4	05871	Motor ON Switch	1
5	04881	Bulb L.E.D	1
6	05424	Power Cord (230v)	1
7	05827	Circuit Board (230v)	1
8	02548	Stand-Off 3/16 x 9/16 LG	3
9	02547	#4-40X5/16 Phillips Head Screw	3
10	05872	Motor OFF Switch	1
11	04878	Spacer	1
12	04879	Clear Lens	1
13	*90690	Cable Tie	1
14	01226	Switch Guard	1
15	*05205	Wire Harness (board to housing)	1
16	04643	Red Switch Cover	1
17	04644	Green Switch Cover	1
18	05926	Circuit Breaker	1
19	05928	Rubber Boot Seal	1
		*not shown	



NOTE: WHEN INSERTING L.E.D. DETAIL#5 INTO HARNESS DETAIL#2 MAKE SURE FLAT ON BULB LINES UP WITH WHITE WIRE ON HARNESS.



Motor Slide Assembly Breakdown



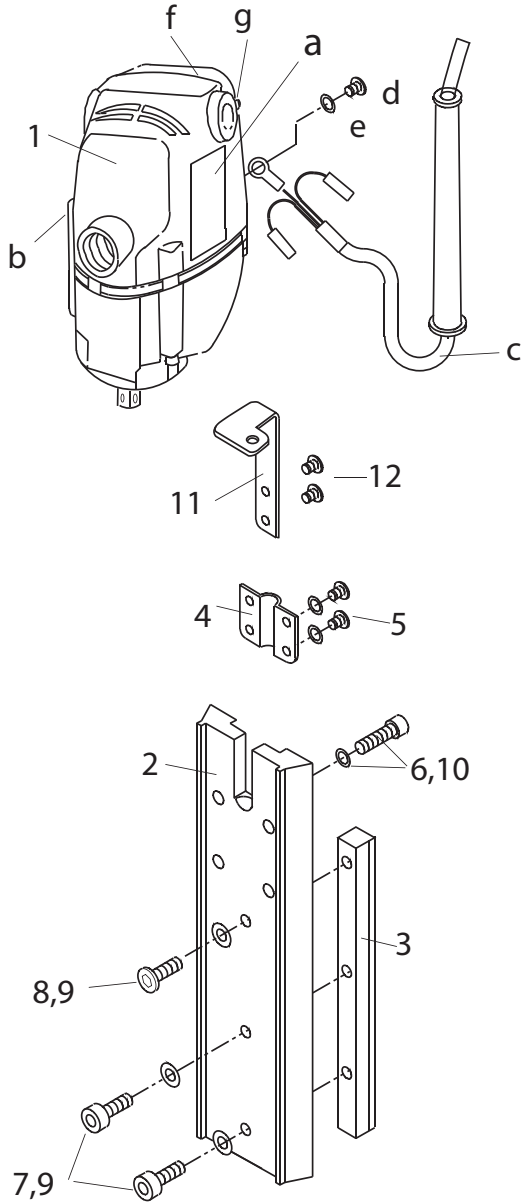
05482 Motor & Slide Assembly 120v 07179 Motor & Slide Assembly 230v

Item	Part #	Description	Qty
1	05477	Motor Assembly 120v	1
	07181	Motor Assembly 230v	1
a	04527	Motor Label	1
b	04528	Specs Label 120v	1
	04042	Specs Label 230v	1
c	02413	Motor Cord	1
d	11053	Screw BHS #8-32 X 3/16	1
e	10538	Lock Washer	1
f	04502	Inspection Cover	1
g	75289	Screw Pan Head M5 X 8MM	2
2	04500	Slide	1
3	02428	Rack Gear	1
4	02422	Motor Cord Bracket	1
5	41044	Screw BHC #10-32 X 3/8	4
6	75156	Screw SHC M6 X 1 X 15mm	4
7	40038	Screw SHC #10-32 X 5/8	2
8	90077	Screw BHC #10-32 X 1/2	1
9	10560	Lock Washer	3
10	90028	Lock Washer	4

05676 Motor/Slide Assembly 120v with Coolant 07180 Motor/Slide Assembly 230v with Coolant

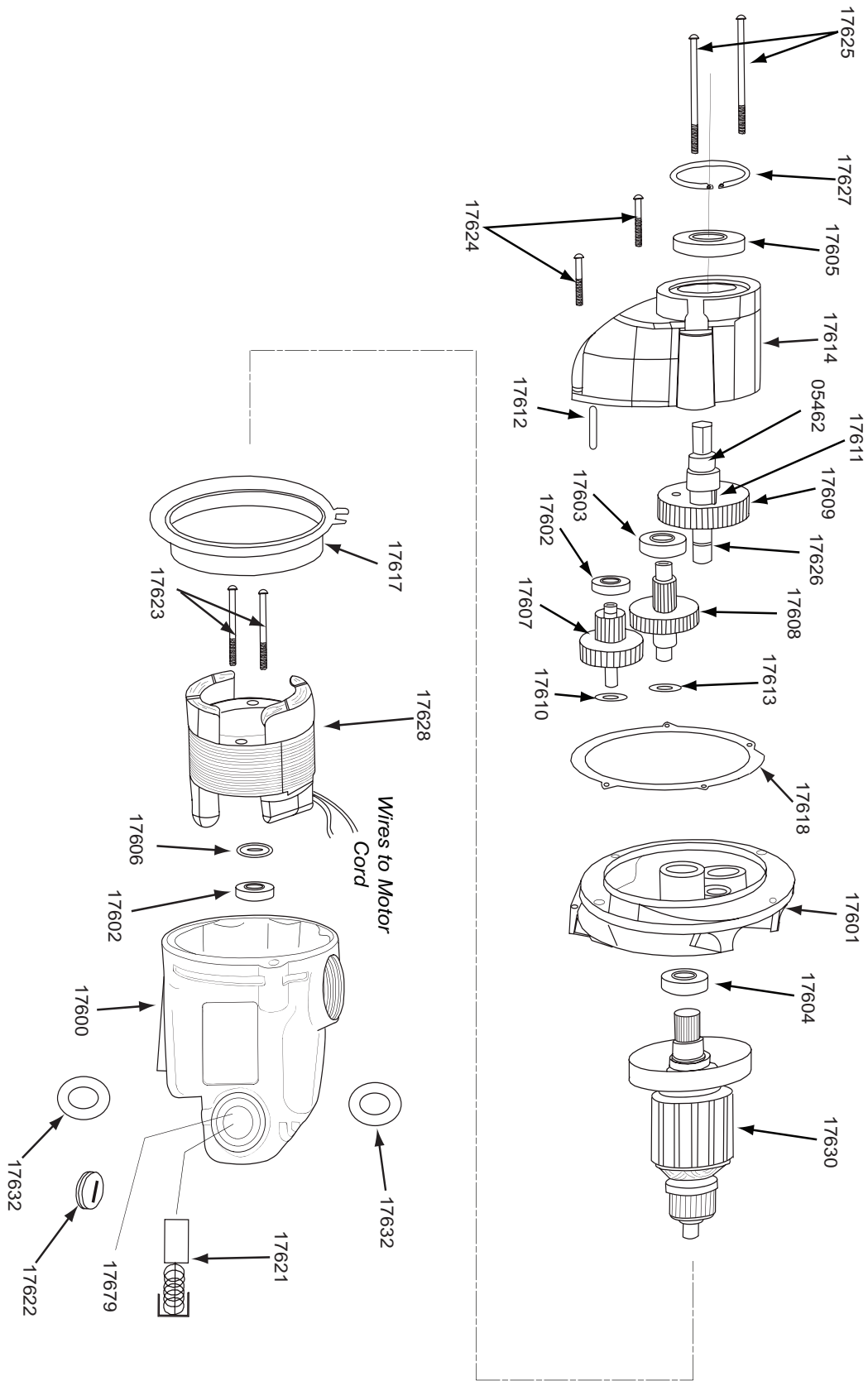
Item	Part #	Description	Qty
1	05477	Motor Assembly 120v includes a-g	1
	07181	Motor Assembly 230v includes a-g	1
a	04527	Motor Label (both assemblies)	1
b	04528	Specs Label (05676 assembly)	1
	04042	Specs Label (07180 assembly)	1
c	02413	Motor Cord	1
d	11053	Screw BHS #8-32 X 3/16	1
e	10538	Lock Washer	1
f	04502	Inspection Cover	1
g	75289	Screw Pan Head M5 X 8MM	2
2	04500	Slide (05676 assembly)	1
	05824	Slide (07180 assembly)	1
3	02428	Rack Gear (05676 assembly)	1
	05825	Rack Gear (07180 assembly)	1
4	02422	Motor Cord Bracket	1
5	41044	Screw BHC #10-32 X 3/8	4
6	75156	Screw SHC M6 X 1 X 15mm	4
7	40038	Screw SHC #10-32 X 5/8	2
8	90077	Screw BHC #10-32 X 1/2	1
9	10560	Lock Washer	3
10	90028	Lock Washer	4
11	05057	Bottle Holder Bracket	1
12	05988	Screw FHC #10-32 X 1/2	2

Motor Slide Assembly Breakdown



05667 Motor & Slide Assembly 120v Swivel			
Item	Part #	Description	Qty
1	05477	Motor Assembly 120v	1
a	04527	Motor Label	1
b	04528	Specs Label	1
c	02413	Motor Cord	1
d	11053	Screw BHS #8-32 X 3/16	1
e	10538	Lock Washer	1
f	04502	Inspection Cover	1
g	75289	Screw Pan Head M5 X 8MM	2
2	05668	Slide - Swivel Base	1
3	05669	Rack Gear - Swivel Base	1
4	02422	Motor Cord Bracket	1
5	41044	Screw BHC #10-32 X 3/8	4
6	75156	Screw SHC M6 X 1 X 15mm	4
7	40038	Screw SHC #10-32 X 5/8	2
8	90077	Screw BHC #10-32 X 1/2	1
9	10560	Lock Washer	3
10	90028	Lock Washer	4
Items 11 & 12 are for Machines with Coolant			
11	05057	Bottle Holder Bracket	1
12	05988	Screw FHC #10-32 X 1/2	2

MOTOR PARTS DIAGRAM 120v



MOTOR PARTS DIAGRAM 230v

