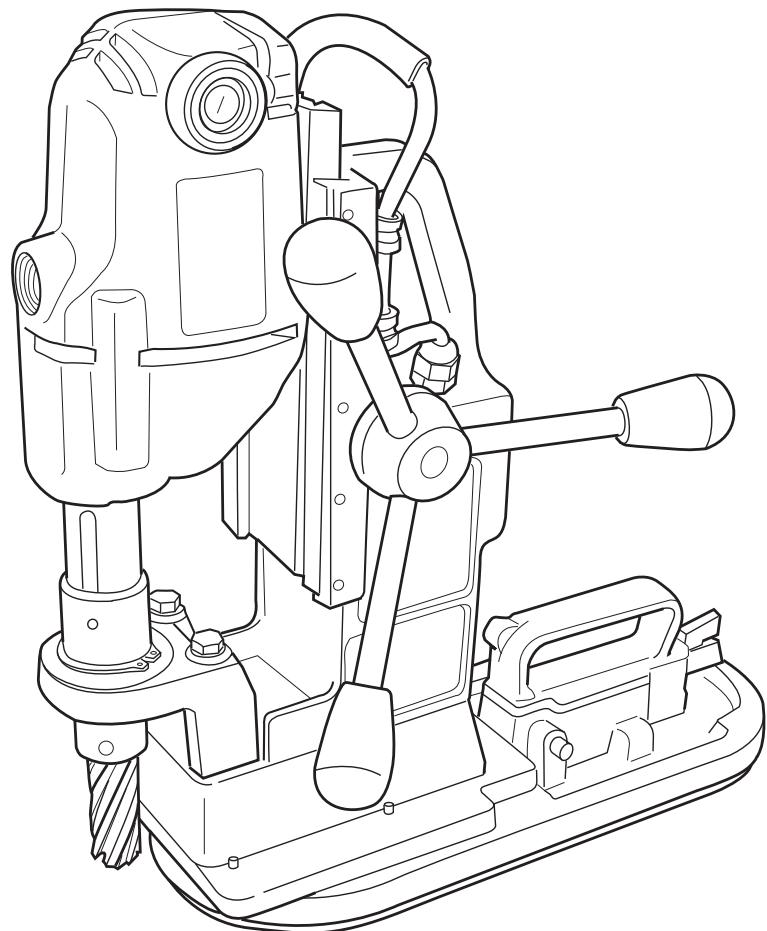




# VAC-PAD™ ATTACHMENT

## OPERATOR'S MANUAL MODEL 05000



For use with Hougen Non-Swivel Base Portable Mag  
Drill Models: HMD904, 905, 925 & 927

# **HOUGEN® VAC-PAD™**

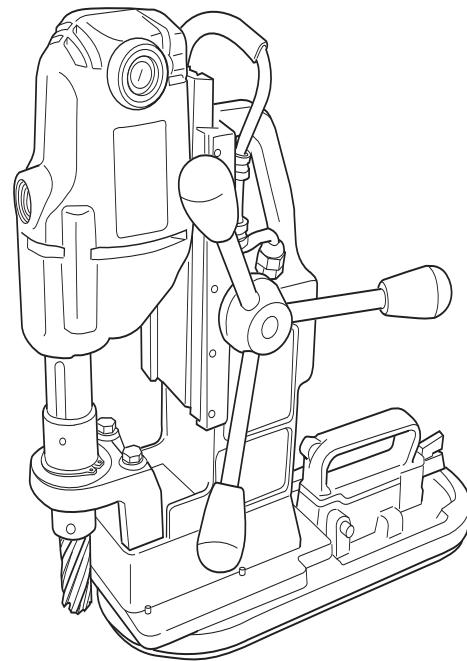
## **VACUUM PLATE ATTACHMENT**

### **MODEL 05000**

## **WELCOME TO HOUGEN**

Congratulations on your purchase of the Hougen® Vac-Pad™ vacuum attachment. Your Vac-Pad is designed to help you produce superior holes quickly and efficiently. Through constant innovation and development, Hougen is committed to provide you with hole-producing tools and products to help you be more productive.

Before attempting to operate your Vac-Pad attachment, please read all instructions first. With proper use, care and maintenance, your Vac-Pad will provide you with years of effective hole drilling performance. Once again, thank you for selecting our product and welcome to Hougen.



## **Instructions for Model 05000 Vac-Pad in use with Models HMD904, 905, 908, 925 & 927 Non-Swivel Base Portable Magnetic Drills**

The Vac-Pad Model 05000 is intended for use only with a Hougen Non-Swivel Base Portable Magnetic Drill. It is intended for cutting through thin material but can cut a hole up to 1" deep using Hougen Cutters.

### **VAC-PAD Operation**

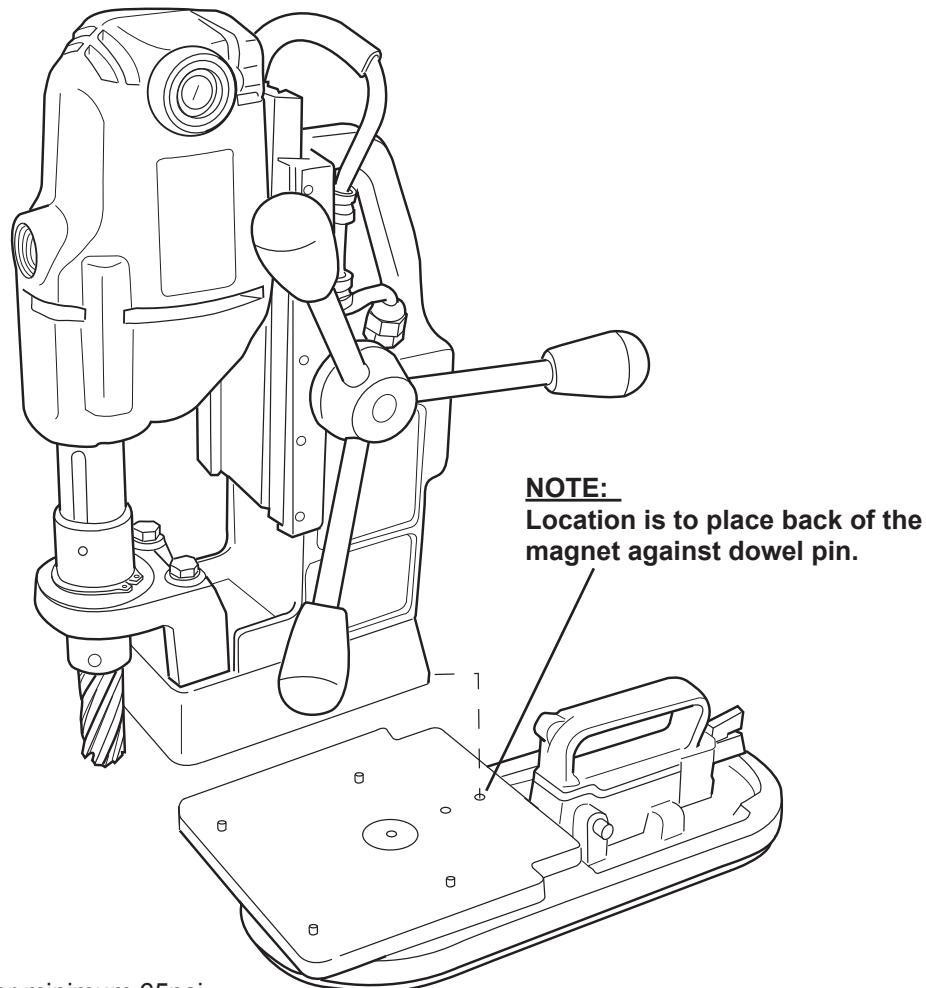
1. Place magnetic drill on Vac-Pad locating the magnet using the (5) locating pins and ensuring mag drill safety switch is located on the motor shut-off cylinder and spring loaded glide posts are resting in the pockets provided for them.
2. Connect mag drill power cord to power supply and activate the magnet (see operators manual for your model of mag drill).
3. Ensure that the area where the Vac-Pad is to be placed is free of dust and other debris.
4. Connect the Vac-Pad air inlet to a filtered air supply. Maximum operating pressure is 120psi and minimum pressure is 65psi. At 85psi the Vac-Pad consumes 2 cfm.
5. Turn air inlet valve to "ON" position and place Vac-Pad on work surface with Hougen Cutter and pilot at desired point.
6. Press down on Vac-Pad to fully open bottom vacuum valve (any air heard escaping to the atmosphere should be coming from the exhaust chamber only).
7. Turn drill motor on and cut hole (see operator's manual for your model of drill).
8. After drilling operation is complete, and motor is turned off (magnet may be left energized), press the manual release button to release Vac-Pad for repositioning. This valve should be used regularly to clean vacuum filter in base.

## **Motor Shut-off Cylinder**

Motor shut off cylinder controls the operation of the mag drill motor safety switch. It is imperative that the magnet is flat on the steel plate of the Vac-Pad and properly aligned with the cylinder (see troubleshooting).

## **Vac-Pad Seal Replacement**

1. Lay Vac-Pad upside down on flat surface.
2. Firmly grip the old seal and pull it to remove it.
3. Scrap away any remnants of old seal and glue from groove to leave a clean surface for new seal.
4. Apply rubber contact cement to top of the thinnest edge of seal (note that seal is tapered) making sure entire top surface is coated with a thin layer of contact cement. (Do not apply cement to sides of seal or groove).
5. Apply thin layer of contact cement to groove of Vac-Pad and allow to set for 10 minutes.
6. Press seal evenly into groove and place Vac-Pad right side up. Turn vacuum on and press on Vac-Pad to ensure seal is properly seated.
7. Turn vacuum on and off several times to allow seal to settle into groove.



## **Troubleshooting**

1. Check air supply for minimum 65psi.
2. Ensure air inlet valve is in "ON" position.
3. Clean vacuum filter on underside of Vac-Pad if needed.
4. Check rubber seal for damage.
5. If drill motor will not start, check vacuum cylinder (drill safety switch control) to see if it is operable.
6. When working on thin materials, the material must be well supported in the area of the Vac-Pad. If the material is allowed to flex, you may experience a loss of holding power or the drill motor may shut off.

## COMMERCIAL / INDUSTRIAL LIMITED WARRANTY

Hougen Manufacturing, Incorporated warrants its Portable Magnetic Drills and its Electro-hydraulic Hole Punchers for a period of 1 year and other products for ninety (90) days from date of purchase against defects due to faulty material or workmanship and will repair or replace (at its option) without charge any items returned. This warranty is void if the item has been damaged by accident or unreasonable use, neglect, improper service, or other causes not arising out of defects in material or workmanship. No other expressed warranty is given or authorized. Hougen Manufacturing, Inc. disclaims any implied warranty of MERCHANTABILITY or FITNESS for any period beyond the expressed warranty and shall not be liable for incidental or consequential damages. Some states do not allow exclusions of incidental or consequential damages or limitation on how long an implied warranty lasts and, if the law of such a state governs your purchase, the above exclusion and limitation may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service: return the item(s), transportation prepaid, to your nearest Factory Authorized Warranty Repair Center or to Hougen Manufacturing, Inc., 3001 Hougen Drive, Swartz Creek, Michigan 48473.

Hougen Drills are warranted against manufacturing defects only. Subject to Hougen Manufacturing inspection.

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## HOUGEN AUTHORIZED WARRANTY REPAIR CENTERS

Hougen Authorized Warranty Repair Centers have been factory trained to properly service and repair Hougen Portable Magnetics Drills. To locate an Authorized Warranty Repair Centers near you, please visit:

[www.hougen.com](http://www.hougen.com)



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