

# Slugger® Magforce™

With Smart Magnet™ Circuitry

Slugger® Portable Magnetic Drilling Machine

## OPERATOR'S MANUAL

### **WARNING!**

BEFORE USE, BE SURE EVERYONE USING THIS MACHINE READS AND UNDERSTANDS ALL SAFETY AND OPERATING INSTRUCTIONS IN THIS MANUAL.



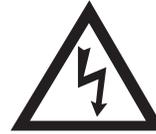
EYE PROTECTION  
REQUIRED



HEARING PROTECTION  
REQUIRED



NEVER PLACE  
FINGERS NEAR  
CUTTING AREA OR  
MACHINE ARBOR



LINE VOLTAGE  
PRESENT



BEWARE OF  
ROTATING  
MACHINE PARTS



MODEL: #06920 (120V) OR #06921 (220V)

Serial # \_\_\_\_\_

Date of Purchase \_\_\_\_\_

# Slugger® Portable Magnetic Drilling Machine

Congratulations on your purchase of a Slugger® portable magnetic drilling machine. Slugger® drilling machines are designed to deliver fast, efficient hole drilling performance in portable applications. Please take a moment to complete and mail your product warranty registration card. Doing so will validate your machine's warranty period and ensure prompt service if needed. Thank you for selecting a Slugger® product from Jancy Engineering Inc.™

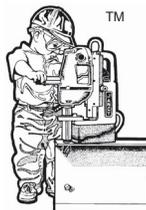
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## LIMITED WARRANTY

Jancy Engineering Inc.™ will, within one (1) year from the original date of purchase, repair or replace any goods found to be defective in materials or workmanship, provided the product warranty registration card has been returned to Jancy Engineering Inc.™ within thirty (30) days of purchase date. This warranty is void if the item has been damaged by accident, neglect, improper service or other causes not arising out of defects in materials or workmanship. This warranty does not apply to machines and/or components which have been altered, changed, or modified in any way, or subjected to use beyond recommended capacities and specifications. Electrical components are subject to respective manufacturers' warranties. All goods returned defective shall be returned prepaid freight to Jancy, which shall be the buyer's sole and exclusive remedy for defective goods. In no event shall Jancy Engineering be liable for loss or damage resulting directly or indirectly from the use of merchandise or from any other cause. Jancy Engineering is not liable for any costs incurred on such goods or consequential damages. No officer, employee or agent of Jancy is authorized to make oral representations of fitness or to waive any of the foregoing terms of sale and none shall be binding on Jancy.

**JANCY ENGINEERING INC.™ RESERVES THE RIGHT TO MAKE IMPROVEMENTS AND MODIFICATIONS TO DESIGN WITHOUT PRIOR NOTICE.**



# IMPORTANT SAFETY INSTRUCTIONS

## **WARNING!**

WHEN USING ELECTRIC TOOLS, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED TO REDUCE RISK OF FIRE, ELECTRIC SHOCK AND PERSONAL INJURY.

### **READ AND SAVE ALL INSTRUCTIONS FOR FUTURE REFERENCE.**

#### **1. Work Area Safety**

- a) Keep work area clean and well lit. *Cluttered or dark areas invite accidents.*
- b) Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. *Power tools create sparks which may ignite the dust or fumes.*
- c) Keep children and bystanders away while operating a power tool. *Distractions can cause you to lose control.*
- d) Secure work. Use clamps or a vise to hold work. *It's safer than using your hand and it frees both hands to operate tool.*

#### **2. Electrical safety**

- a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. *Unmodified plugs and matching outlets will reduce risk of electric shock.*
- b) Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. *There is an increased risk of electric shock if your body is earthed or grounded.*
- c) Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
- d) Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. *Damaged or entangled cords increase the risk of electric shock.*
- e) When operating a power tool outdoors, use an extension cord suitable for outdoor use. *Use of a cord suitable for outdoor use reduces the risk of electric shock.*
- f) If operating a power tool in a damp location is unavoidable, use a ground fault circuit interrupter (GFCI) or residual current device (RCD) protected supply. *Use of a GFCI or RCD reduces the risk of electric shock.*

#### **3. Personal safety**

- a) Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. *A moment of inattention while operating power tools may result in serious personal injury.*
- b) Use personal protective equipment. Always wear eye protection. *Protective equipment such as dust masks, non-skid safety shoes, hard hats or hearing protection used for appropriate conditions will reduce personal injuries.*
- c) Prevent unintentional starting. Ensure the switch is in the "OFF" position before connecting to power source and/or battery pack, picking up or carrying the tool. *Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.*

## IMPORTANT SAFETY INSTRUCTIONS

- d) Remove any adjusting key or wrench before turning the power tool on. *A wrench or key left attached to a rotating part of the power tool may result in personal injury.*
- e) Do not overreach. Keep proper footing and balance at all times. *This enables better control of the power tool in unexpected situations.*
- f) Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts. *Loose clothes, jewelry or long hair can be caught in moving parts.*
- g) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used. *Use of dust collection can reduce dust-related hazards.*

### 4. Power tool use and care

- a) Do not force the power tool. Use the correct power tool for your application. *The correct power tool will do the job better and safer at the rate for which it was designed.*
- b) Do not use the power tool if the switch does not turn it on and off. *Any power tool that cannot be controlled with the switch is dangerous and must be repaired.*
- c) Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories or storing power tools. *Such preventative safety measures reduce the risk of starting the power tool accidentally.*
- d) Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate power tool. *Power tools are dangerous in the hands of untrained users.*
- e) Maintain power tools. Check for misalignment or binding or moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use. *Many accidents are caused by poorly maintained power tools.*
- f) Keep cutting tools sharp and clean. *Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.*
- g) Use the power tool, accessories and tools etc. in accordance with these instructions, taking into account the working conditions and the work to be performed. *Use of the power tool for operations different from those intended could result in a hazardous situation.*
- h) Check for damaged parts. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check alignment of moving parts, binding of parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center.

### 5. Service

- a) Have your power tool serviced by a qualified repair person using only identical replacement parts. *This will ensure that the safety of the power tool is maintained.*

## SPECIAL INSTRUCTIONS

1. If you require an additional manual, please contact Jancy Engineering at (563) 391-1300 for a **FREE** copy.
2. Never place hands, fingers, gloves or clothing near cutting area or rotating machine parts.
3. Always disconnect machine from power source before changing cutters, clearing chips, refilling lubricant or performing adjustments.
4. Keep all safety features functioning and working properly.
5. Never wear loose clothing, gloves or jewelry when working near cutting area or rotating machine parts.
6. Always use eye and hearing protection.
7. Always use safety strap and chip guard provided with machine.
8. Always use proper tooling. Keep cutters securely fastened.
9. Do not use dull or broken cutters.
10. Do not use Slugger® drilling machines on surfaces or materials being welded. Doing so can damage the machine's electrical components.
11. Beware of slugs ejected at end of cut. They become HOT during the cut.
12. Magnet will not hold properly on thin materials or rough and dirty surfaces.
13. Keep bottom of magnet burr free and clear of chips and debris.
14. To reduce the risk of electrical shock, do not use machine in wet or damp areas.
15. Do not remove or alter electrical panels. Use only authorized service centers for repairs.

### **WARNING!**

DO NOT OPERATE MACHINE IF WARNING AND/OR INSTRUCTION LABELS ARE MISSING OR DAMAGED.  
CONTACT JANCY ENGINEERING FOR REPLACEMENT LABELS.



### **SAFETY INSTRUCTIONS**

- Read and follow operator's manual thoroughly. If you can not locate your operator's manual, call Jancy Engineering Inc. at 563.391.1300 for a free copy.
- Always stop machine completely and disconnect from power source before changing cutters, performing adjustments or servicing.
- Do not use altered, dull or broken cutters.
- Never wear loose clothing or gloves when working near cutting area or machine arbor.
- Always use provided safety strap and chip guard.
- Use proper tooling. Keep cutters securely fastened.
- Magnet will not hold properly on thin materials and rough or dirty surfaces. Keep magnet free of chips and debris.
- Keep all safety features functioning and working properly.
- Use only authorized service centers for repairs.

### **DANGER!**

**NEVER PLACE HANDS, FINGERS, GLOVES OR CLOTHING NEAR CUTTING AREA OR ROTATING MACHINE PARTS**



### **WARNING!**

-  Always use eye protection. Any tool can shatter.
-  Line voltage present. To reduce risk of electrical shock, the user must read and understand operator's manual.

### **CAUTION!**

-  Always wear hearing protection.
-  Beware of ejected slug at the end of the cut.

### **DANGER!**

Position safety guard toward work surface before starting drill motor.

## GROUNDING INSTRUCTIONS

### ⚠️ **WARNING!**

Improperly connecting the grounding wire can result in the risk of electrical shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with tool. Never remove the grounding prong from the plug. If the cord or plug is damaged, have it repaired before using. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician. The Magforce™ must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look like those in Figure A.

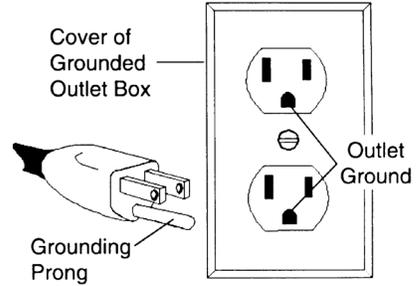


Fig. A

### ⚠️ **WARNING!**

**DO NOT USE SLUGGER® DRILLING MACHINES ON SURFACES OR MATERIALS BEING WELDED. DOING SO CAN RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER® DRILLING MACHINE.**

## 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 your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Jancy recommends using a minimum 12 gauge extension cord not to exceed 100 feet. The table below is supplied only as a guide to minimum gauge for extension cords, where the smaller the gauge number, the heavier the cord.

MINIMUM GAUGE FOR EXTENSION CORDS				
VOLTS	TOTAL LENGTH OF CORD IN FEET			
	120V	0-25	26-50	51-100
240V	0-50	51-100	101-200	201-300
AMPERAGE				
0-6	18	16	16	14
6-10	18	16	14	12
10-12	16	16	14	12
12-16	14	12	NOT RECOMMENDED	
RECOMMENDED WIRE GAUGE				

NOTE: JANCY RECOMMENDS USING A MINIMUM 12 GAUGE EXTENSION CORD NOT TO EXCEED 100 FEET.

**DRIP LOOP:** To help prevent cutting fluids from traveling along power cord and contacting power source, tie a drip loop in power cord as shown in Figure B.

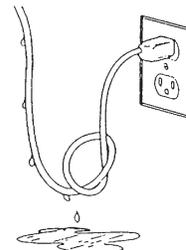


Fig. B

## CONTENTS OF PACKAGE

Remove all contents from packaging and inspect to ensure no damage was incurred during shipping. Package should also include the following:

DESCRIPTION	PART #	QTY
OPERATOR'S MANUAL	LIT107	1
PRODUCT DVD	LIT032	1
WARRANTY CARD	0070342	1
MAGNET WARNING NOTICE	0107D0C	1
3/16" PILOT, 1" DEPTH OF CUT	16001	1
3/16" PILOT, 2" DEPTH OF CUT	16002	1
1/4" PILOT, 1" DEPTH OF CUT	16003	1
1/4" PILOT, 2" DEPTH OF CUT	16004	1
M10 X 3 FPSSS	UH0900	2
3MM HEX WRENCH	UH8001	1
5MM THANDLE HEX WRENCH	UH8004	1
SAFETY STRAP	U11005	1
SPOKE HANDLE ASSEMBLY	06315	1
CARRYING CASE	06970	1
SHUNT (ATTACHED TO HANDLE)	UH5335	1
SHUNT INSTRUCTIONS	U14102	1

## GETTING STARTED



ALWAYS DISCONNECT **MAGFORCE™** FROM POWER SOURCE BEFORE MAKING ADJUSTMENTS.

Assemble spoke handle assembly (item #30) to pinion feed shaft (item #15) using screw which is attached to center of drive handle. **NOTE:** Handle can be mounted on right or left side of machine.

## WHAT YOU SHOULD KNOW BEFORE YOU DRILL

1. The Magforce™ incorporates state of the art design features such as "**SMART MAGNET™**" circuitry. This feature does not allow the motor to operate in unsafe magnetic holding conditions. Illuminated on/off switches indicate the existence of a sufficient magnetic field. If On/Off switches are not illuminated, there is not a proper magnetic field. When drilling materials under 3/8" thick, an additional steel plate may be required to achieve proper magnetic adhesion.
2. Type of material to be drilled, Brinnell or Rockwell hardness, material thickness and position should all be determined to ensure proper selection of Slugger® cutting tools, RPM, coolant and drilling time.
3. Remove any excessive mill scale or rust from surface to be drilled.
4. Material that has been flame cut may have become heat-treated and therefore difficult to drill. Avoid drilling near such areas whenever possible.
5. Drilling with the Magforce™ in horizontal positions requires a special lubrication for Slugger® cutters. Consult Jancy Engineering for details.
6. Do not use Slugger® drilling machines on surfaces or materials being welded. Doing so can damage the machine's electrical components.

## BEFORE THE CUT

1. Select correct pilot pin and place in cutter shank from the rear, align flats on cutter shank with arbor body set screws, insert cutter in arbor body.
2. Tighten set screws securely on cutter shank flats. **NOTE:** Set screws should be recessed in arbor body when tight.
3. The surface you are working on should be clean and flat, and free from rust, scale, dirt and chips.
4. Fill coolant reservoir with a water-soluble coolant.
5. Place Slugger® machine on workpiece with pilot pin over the center of hole to be drilled.
6. Connect machine to power source.
7. Lower Slugger® cutter to surface of material to be cut. Coolant will be released down the pilot into center of Slugger® cutter. Coolant flow can be stopped by lifting pilot pin off work surface.

### **CAUTION!**

ALWAYS USE SAFETY STRAP. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER® DRILLING MACHINE.

8. The safety strap must be securely fastened to machine and around work being drilled. Loop strap around workpiece and connect strap ends by attaching to D-rings on drill. Next, tighten safety strap by depressing thumb latch on cam buckle and pulling flat end of safety strap until excess slack is removed. **NOTE:** Safety strap is intended only to restrain the drill to the workpiece in the event of a power failure to the magnetic base.
9. Position chip guard toward work area before drilling.

## READY TO MAKE THE CUT

### **CAUTION!**

POSITION CHIP GUARD TOWARD WORK AREA BEFORE DRILLING.

1. Move magnet switch to "I" position to engage magnet. Red lamp will illuminate to indicate power is present. Magnet base should be firmly secured to workpiece at this time. **NOTE:** Thin materials may require an additional steel plate to achieve proper magnetic adhesion.
2. Start drill motor by depressing motor "I" button.
3. Using the feed handles, advance cutter into material until cutter has established an external groove in the material. During the remainder of the cut, apply smooth, constant pressure without overloading motor. **NOTE:** Slugger® cutters are designed for uninterrupted cutting. Chips are evacuated during the cut. Do not peck drill when using Slugger® cutters.

### **CAUTION!**

IF DRILL MOTOR SHOULD STALL OR STOP BEFORE A COMPLETE CUT IS MADE, ALWAYS SHUT MOTOR OFF AND THEN REMOVE CUTTER FROM HOLE BEFORE ATTEMPTING TO RESTART MOTOR. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER® DRILLING MACHINE.

## AFTER THE CUT

1. After Slugger® cutter has finished the cut, the "slug", or uncut center portion of material, will be expelled when motor is returned to the full up position.
2. Return machine into full upright position and depress red motor "O" button. Wait until motor completely stops.
3. Move magnet switch to "O" position when ready to release magnetic base from work surface.
4. Residual magnetism may exist after the magnet is turned off.

## BASIC TROUBLESHOOTING

1. **Magnetic base not holding securely**
  - Material is too thin to engage magnet.
  - Surface of material being drilled must be free of chips, debris, rust and mill scale.
  - Size of cutter exceeds machine's rated capacity.
  - Check magnet face for unevenness, nicks and burrs.
  - Welding equipment connected to material being drilled.
2. **Motor slows when drilling**
  - If an extension cord is being used, see page 6 for recommended wire gauges and cord lengths.
  - Excessive downfeed pressure during drilling cycle will cause motor to slow and overheat.
  - Cutting tool needs to be resharpened.
3. **Coolant system not working**
  - Coolant system is gravity dependent, machine must be in an upright position to operate properly.
  - Check coolant lines for blockage.
  - Dirt or debris in coolant tank.
  - Consistency of coolant mixture too thick.
  - Incorrect pilot pin being used.
  - Vent hole in coolant tank lid blocked.
4. **Slugs not ejecting from cutter**
  - Lack of coolant causing slugs to expand in cutter bore.
  - Incorrect pilot pin being used.
5. **Breaking cutters**
  - Coolant must be supplied to interior of cutter.
  - Excessive feed pressure being applied when cutter initially contacts work surface.
  - Confirm material hardness.
  - Drilling stacked materials with incorrect cutter.
  - Dull cutters; dull or chipped cutting edges require excessive feed pressure, resulting in breakage.
6. **Oversized or rough holes**
  - Insufficient coolant.
  - Excessive feed pressure.
  - Dull cutter.

## REGULAR MAINTENANCE

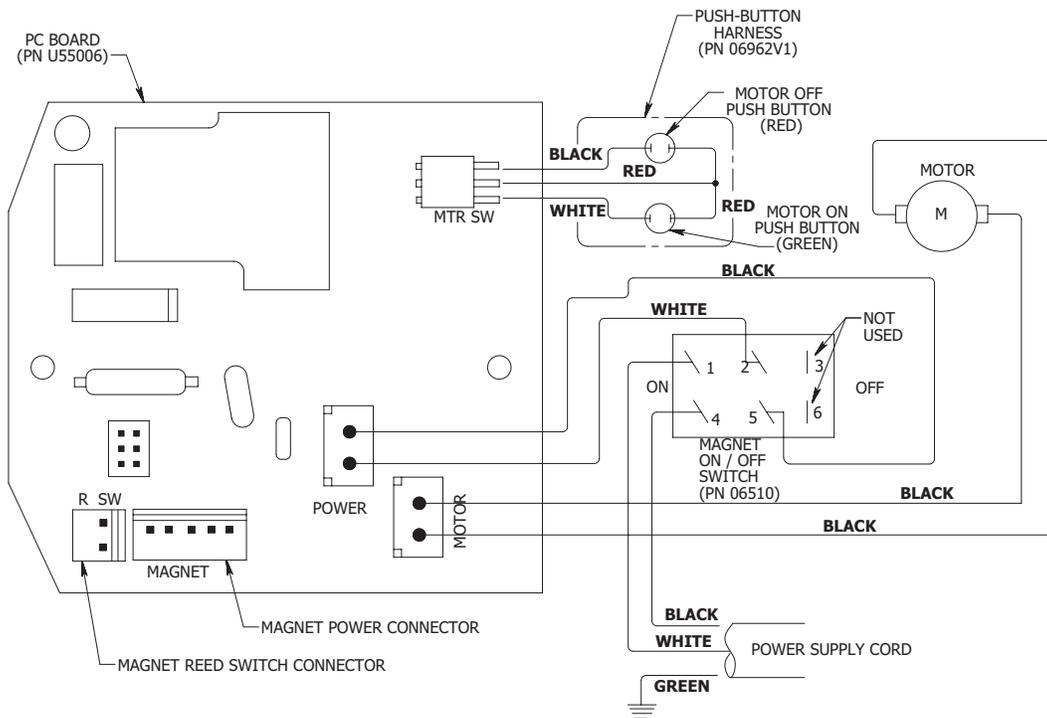
1. Keep bottom of magnet clean, free of chips, burrs, nicks, oil and other contaminants. Inspect magnet face to ensure surface is flat and square. A worn magnet surface dramatically reduces magnetic holding force.

### **WARNING!**

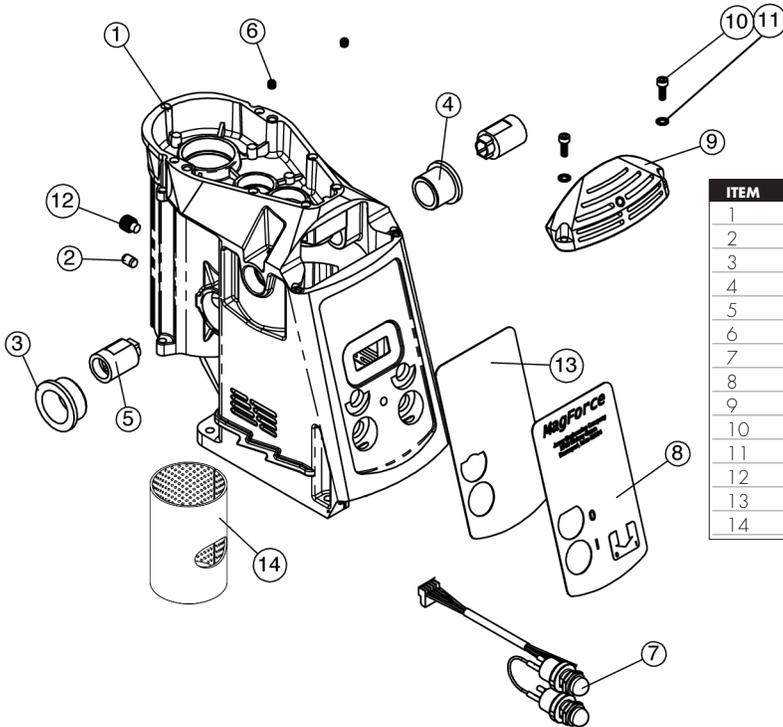
ALWAYS REMOVE CUTTER FROM DRILL BEFORE MEASURING RUNOUT.  
NEVER USE HANDS OR FINGERS TO ROTATE QUILL.

2. Quill runout should not exceed .0035 inches per revolution. This is most accurately measured by placing a dial indicator needle inside of quill bore and rotating quill while observing indicator. **NOTE:** Always remove cutter from quill body before measuring runout. Never use hands or fingers to rotate quill or motor spindle.
3. Inspect motor brushes and replace as needed.
4. Replace any worn parts and regularly tighten fasteners that have become loose during usage.  
**NOTE:** Never operate machine with worn or missing parts. Use only Jancy replacement parts.
5. Regularly test machine by placing machine on non-ferrous material. Engage magnet switch. Motor should not start.

## CONNECTION DIAGRAM

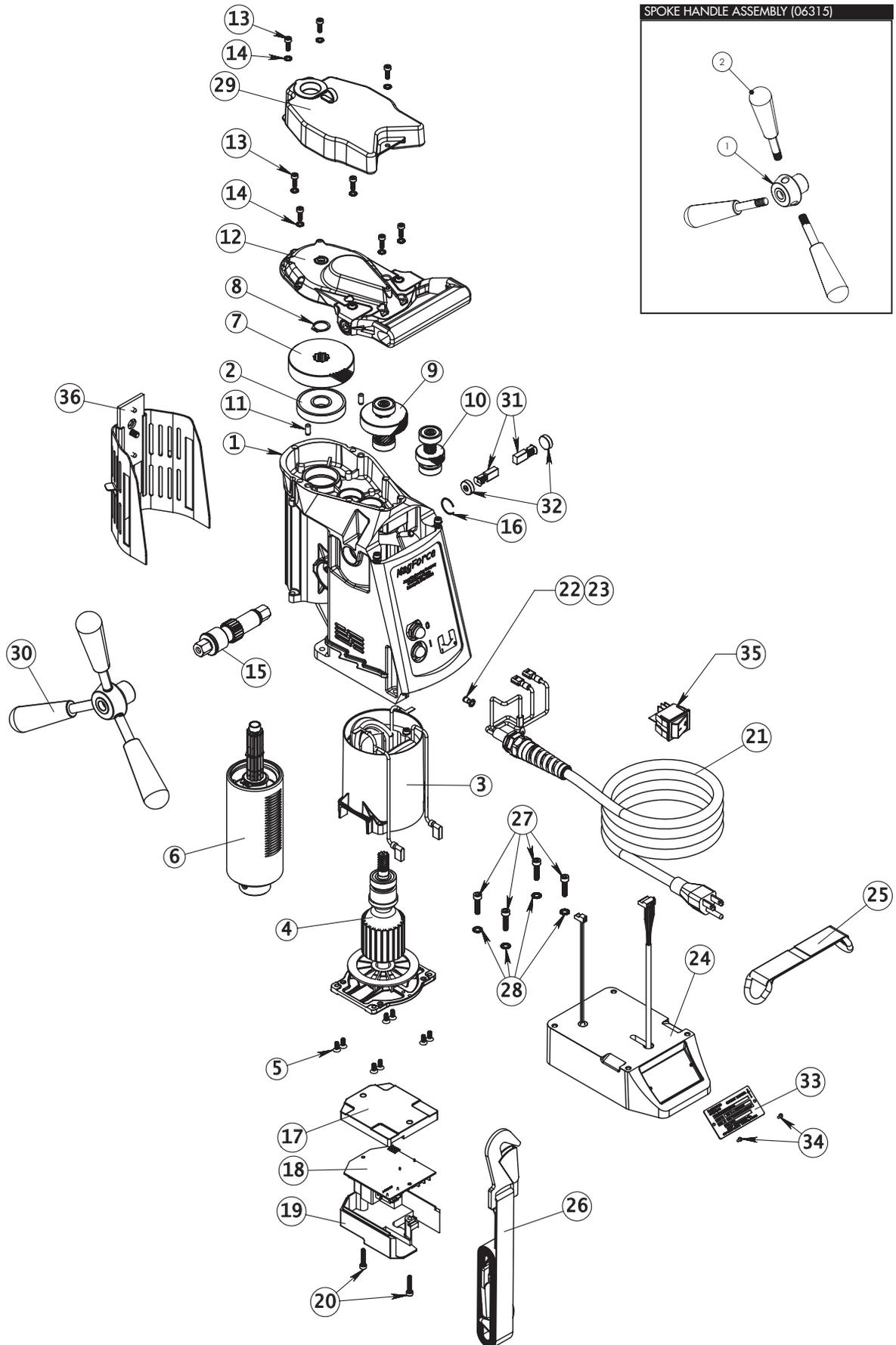


## MACHINE FRAME BREAKDOWN AND PARTS LIST



ITEM	DESCRIPTION	PART #	QTY
1	MACHINED FRAME	06302	1
2	1/4" X 3/8" DOWEL PIN	UH4318	1
3	FLANGE BEARING	UH3320	1
4	FLANGE BEARING	UH3310	1
5	MOTOR BRUSH HOLDER	04551	2
6	M5 X 5 CPSSS	UH0500	2
7	PUSH BUTTON SWITCH ASSY.	06962V1	1
8	OVERLAY	06410	1
9	LOUVER ASSEMBLY	06939	1
10	M4 X 12 SHCS	UH0422	2
11	M4 LOCK WASHER	UH2044	2
12	M10 X 10 NTSSS	UH0902	1
13	PLUG PLATE	06106V1	1
14	INNER SLEEVE BUSHING	06719	1

# MACHINE AND SPOKE HANDLE BREAKDOWN



# MACHINE AND SPOKE HANDLE PARTS LIST

## MACHINE PARTS LIST

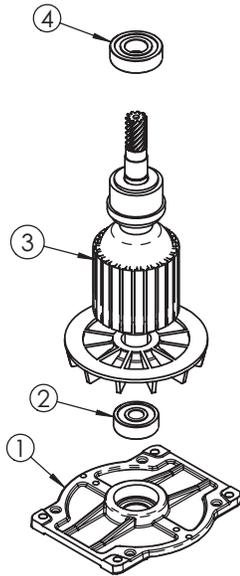
ITEM	DESCRIPTION	PART #	QTY
1	FRAME ASSEMBLY	06936V1	1
2	BALL BEARING	UH3045	1
3	FIELD, 120V FIELD, 220V	06922A 06923A	1
4	ARMATURE ASSEMBLY, 120V ARMATURE ASSEMBLY, 220V	06914 06915	1
5	M4 X 10 FHSCS	UH0410	8
6	QUILL ASSEMBLY	06908	1
7	HELICAL GEAR	06802	1
8	EXTERNAL RETAINING RING	UH4016	1
9	OUTPUT PINION ASSEMBLY	06910	1
10	INTERMEDIATE PINION ASSEMBLY	06912	1
11	M5 X 12 DOWEL PIN	UH4200	2
12	GEARBOX COVER ASSEMBLY	06944	1
13	M4 X 12 SHCS	UH0422	8
14	M4 LOCK WASHER	UH2044	8
15	PINION FEED SHAFT	06206	1
16	EXTERNAL RETAINING RING	UH4050	1
17	PCB BASE	06328	1
18	PC BOARD, 120V PC BOARD, 220V	U55006 U55008	1
19	PCB COVER	06330	1
20	M4 X 20 SHCS	UH0434	2
21	POWER CORD ASSEMBLY, 120V POWER CORD ASSEMBLY-AS SPECIFIED, 220V	06935	1
22	M3 X 5 CRPHMS	UH0300	1
23	M3 LOCK WASHER	UH2035	1
24	MAGNET ASSEMBLY, 120V MAGNET ASSEMBLY, 220V	06907 06905	1
25	SAFETY STRAP LINK	U11004	1
26	SAFETY STRAP	U11005	1
27	M5 X 20 SHCS	UH0542	4
28	M5 LOCK WASHER	UH2054	4
29	COOLANT BOTTLE ASSEMBLY	06934	1
30	SPOKE HANDLE ASSEMBLY	06315	1
31	MOTOR BRUSH	04549	2
32	BRUSH CAP	04552	2
33	SPECIFY 2 OR 4 BUTTON AND VOLTAGE	CALL	1
34	#2 X 3/16" DRIVE SCREW	UH1002	2
35	MAGNET SWITCH ASSEMBLY	06511	1
36	GUARD ASSEMBLY	06940	1

## SPOKE HANDLE ASSEMBLY PARTS LIST

ITEM	DESCRIPTION	PART #	QTY
1	HUB	U12004	1
2	SPOKE HANDLE	U12200	3
3	M6 X 30 SHCS (NOT SHOWN)	UH0654	1
4	1/4" PUSH NUT (NOT SHOWN)	UH4600	1

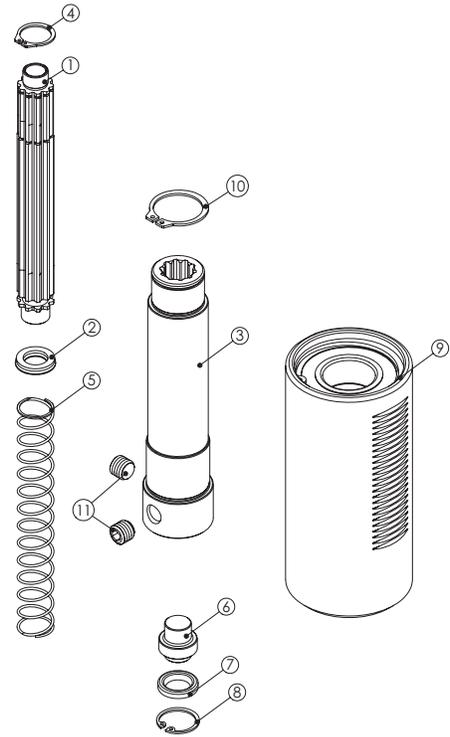
# ARMATURE, QUILL AND GEARBOX COVER BRAKEDOWN AND PARTS LIST

ARMATURE ASSEMBLY - 120V (06914) - 220V (06915)



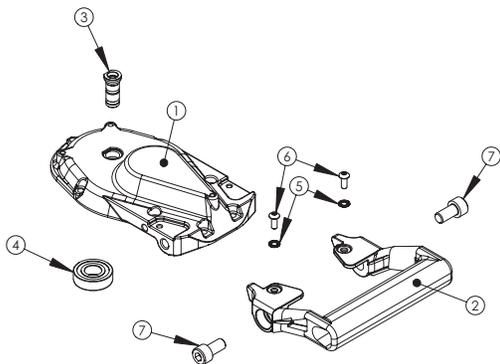
ITEM	DESCRIPTION	PART #	QTY
1	ARMATURE SUPPORT BRACKET	06324	1
2	BALL BEARING	UH3024	1
3	ARMATURE, 120V ARMATURE, 220V	06582 06586	1
4	BALL BEARING	UH3039	1

QUILL ASSEMBLY (06908)



ITEM	DESCRIPTION	PART #	QTY
1	SPLINE DRIVE SHAFT	06210	1
2	HYDRAULIC SEAL	06706	1
3	QUILL SHAFT	06208	1
4	EXTERNAL RETAINING RING	UH4016	1
5	SPRING	0151431	1
6	QUILL PISTON	06212	1
7	LIP SEAL	06704	1
8	INTERNAL RETAINING RING	UH4119	1
9	QUILL CARRIER ASSEMBLY	06906	1
10	EXTERNAL RETAINING RING	UH4025	1
11	M10 X 8 FPSS	UH0900	2

GEARBOX COVER ASSEMBLY (06944)

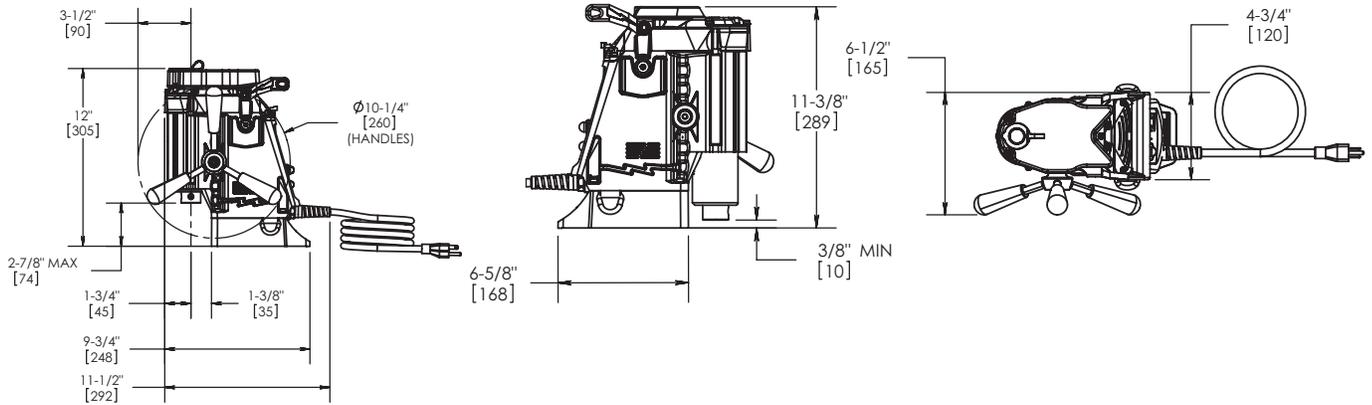
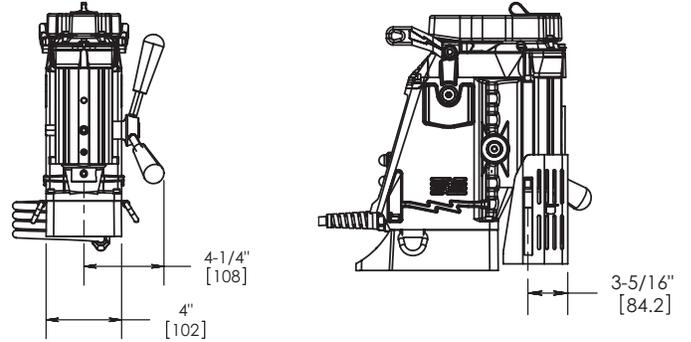


ITEM	DESCRIPTION	PART #	QTY
1	COVER	06304J	1
2	HANDLE	06305	1
3	COOLANT FITTING ASSEMBLY	06916	1
4	BALL BEARING	UH3039	1
5	M4 LOCK WASHER	UH2044	2
6	M4 X 10 BHSCS	UH0406	2
7	M8 X 10 SHCS	UH0810	2

# DIMENSIONS AND SPECIFICATIONS

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Height	12" (305mm)
Height (without coolant bottle)	11-3/8" (289mm)
Width	6-1/2" (165mm)
Length	11-1/2" (292mm)
Weight	27 lbs. (12.25kg)
Motor	1.6 HP 1200W (single phase) 120V / 10.2 ~ 220V / 5.1A 395 RPM (no load) - 280 RPM (load)
Bore	3/4" (19.05mm)
Drill point breakaway	1096 lbs. on 1" plate (497 Kg on 25mm Plate)
Magnet base dimensions	4" x 6-1/2" (101.6 x 165mm)
Magnet dead lift	1810 lbs. on 1" plate (821 kg on 25mm Plate)
Sluggler cutter diameter (maximum)	1-5/8" (41mm)
Sluggler depth of cut (maximum)	2" (52mm)
Spindle CL to Guard Face	3-5/16" (84.2mm)
Spindle CL to Magnet Face	1-3/8" (35mm)
Spindle CL to Motor Face	1-3/4" (45mm)
Total travel	2-9/16" (65mm)



## OTHER AVAILABLE SLUGGER® DRILLS

DESCRIPTION	MODEL #	MAX DIAMETER	DEPTH CAPACITY
USA5 120V	18066	2-3/8"	3"
USA5 220V	18080	2-3/8"	3"
USA101 120V	USA101	1-1/2"	2"
USA101 220V	USA101-2	1-1/2"	2"
USA200 120V	HOLEMAKER II	1-3/8"	2"
USA200 220V	HOLEMAKER II	1-3/8"	2"
2 X 2 120V	17980	2"	2"
2 X 2 220V	17982	2"	2"
4 X 4 120V	17985	4"	3"
4 X 4 220V	17987	4"	3"

YOUR DISTRIBUTOR



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