

Slugger® Holemaker II

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.



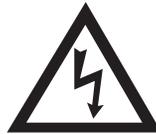
EYE PROTECTION
REQUIRED



HEARING PROTECTION
REQUIRED



NEVER PLACE
FINGERS NEAR
CUTTING AREA OR
MACHINE ARBOR



LINE VOLTAGE
PRESENT



BEWARE OF
ROTATING
MACHINE PARTS

United States Patent #5,415,503
Other patents pending



MODEL #USA200 (120V) OR #USA200-2 (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!

WARNING Read all safety warnings and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

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.*

IMPORTANT SAFETY INSTRUCTIONS

- 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.*
- 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 of 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 components. 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 chisel, dull or broken cutters.
- Never wear loose clothing or gloves when working near cutting area or machine motor.
- Always use provided safety strap and chip guard.
- Use proper tooling. Keep cutters securely fastened.
- Magnet will not hold properly on this material, 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.

Patent # 5,415,503
Other patents pending.

WARNING!

- To reduce the risk of injury, use must wear eye protection.
- **AVERTISSEMENT:** Pour réduire les risques de blessures, l'utilisateur doit porter le matériel de protection.
- **AVERTISSEMENT:** Evitez porter des lunettes de protection.
- **AVERTISSEMENT:** Évitez de porter des lunettes de protection.

CAUTION!

- Always wear hearing protection.
- **PRECAUTION:** Toujours porter des protections auditives.
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- **CAUTION:** Always wear hearing protection.
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**Slugger®
HOLEMAKER II**

MODEL: USA200
VOLTAGE: 120V – 50/60 HZ
AMPERAGE: 11.5A
RPM: 1300W
450 RPM N_A

CAUTION: FOLLOW SAFETY PROCEDURES!

JANCY ENGINEERING

ESTABLISHED 1978 • 2735 HICKORY GROVE RD., DOWNERS GROVE, ILL. 60414
563.391.1300 • WWW.JANCY.COM

SN: 021C-01001

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 Holemaker II 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.

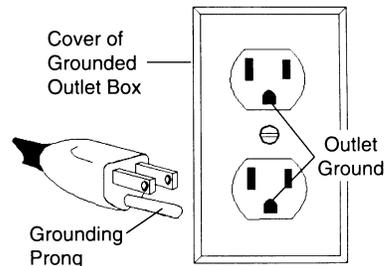


Fig. A



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.

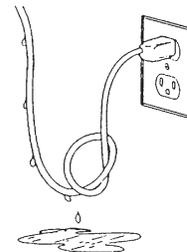
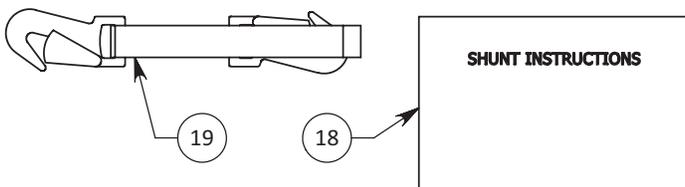
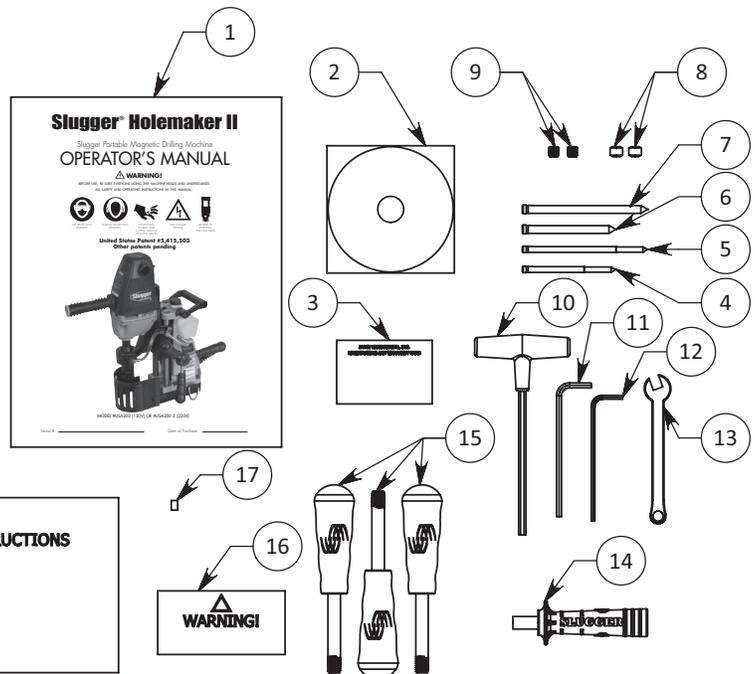


Fig. B

OPERATING INSTRUCTIONS AND CONTENTS OF PACKAGE

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

ITEM	DESCRIPTION	PART #	QTY
1	OPERATOR'S MANUAL	32208142020	1
2	PRODUCT DVD	34198142400	1
3	WARRANTY CARD	32298141050	1
4	3/16" PILOT, 1" DEPTH OF CUT	63134998001	1
5	3/16" PILOT, 2" DEPTH OF CUT	65134998002	1
6	1/4" PILOT, 1" DEPTH OF CUT	65134998003	1
7	1/4" PILOT, 2" DEPTH OF CUT	65134998004	1
8	M10 X 8 FPSSS	43098709000	2
9	M8 X 8 FPSSS	43098708040	2
10	5MM THANDLE HEX WRENCH	62998780040	1
11	4MM HEX WRENCH	62998780020	1
12	3MM HEX WRENCH	62998780010	1
13	8MM COMBINATION WRENCH	62998780060	1
14	SUPPORT HANDLE	64298130060	1
15	SPOKE HANDLE	64298121000	3
16	MAGNET WARNING NOTICE	34198142360	1
17	SHUNT (ATTACHED TO HANDLE)	30798753350	1
18	SHUNT INSTRUCTIONS	32298141020	1
19	SAFETY STRAP	64298110050	1



GETTING STARTED

CAUTION!

ALWAYS DISCONNECT HOLEMAKER II FROM POWER SOURCE BEFORE MAKING ADJUSTMENTS.

Assemble three spoke handles to feed hub. NOTE: Feed hub assembly is mounted on right side of machine frame from factory. **(Figure 1)** If necessary, it can be mounted for left hand operation. To do so, loosen screw until hub assembly is free (the screw will remain in the hub), move to left side and reattach hub.

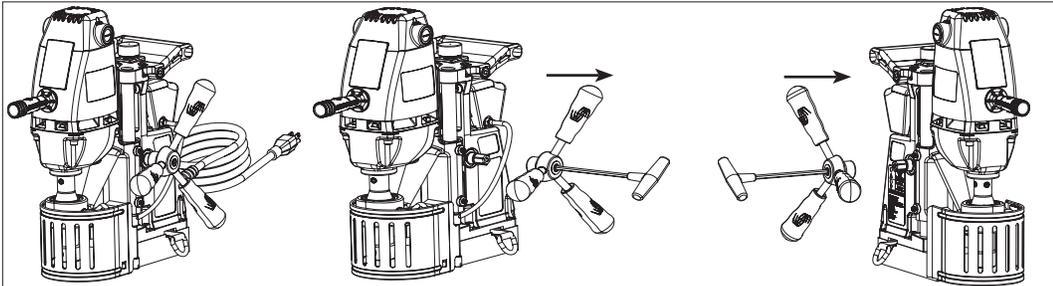


Figure 1

WHAT YOU SHOULD KNOW BEFORE YOU DRILL

1. 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, coolant and drilling time.
2. Material that has been flame cut may have become heat-treated and therefore difficult to drill. Avoid drilling near such areas whenever possible.
3. Drilling with the HOLEMAKER II in horizontal positions requires a special lubrication for Slugger® cutters. Consult Jancy Engineering for details.
4. Our new HOLEMAKER II incorporates state of the art design features such as our "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.
5. Remove any excessive mill scale or rust from surface to be drilled. Thin material, mill scale, rust, paint, existing holes, surface irregularities, coolant, chips and other factors could affect magnetic holding conditions.

BEFORE THE CUT

1. Select correct pilot pin (**Table 1**) 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, free from rust, scale, dirt and chips.
4. Place Slugger® machine on workpiece with pilot pin over the center of hole to be drilled. **(Figure 2)**
5. Connect machine to power source. **(Figure 3)**

Table 1

Pilot	For Cutter
63134998001	1" DOC, 1/2" (14MM) Dia and Smaller
63134998002	2" DOC, 1/2" (14MM) Dia and Smaller
63134998003	1" DOC, 9/16" (15MM) Dia and Larger
63134998004	2" DOC, 9/16" (15MM) Dia and Larger

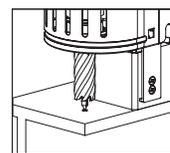


Figure 2

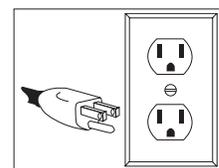


Figure 3

BEFORE THE CUT (CONT.)

6. Turn on coolant valve, located on left side of the frame. **(Figure 4)** Lower Slugger® cutter to surface of material to be cut. **NOTE:** Coolant flow starts when pilot pin contacts work surface. Coolant flow can be stopped by lifting pilot pin off work surface or moving the valve to the "off" position.

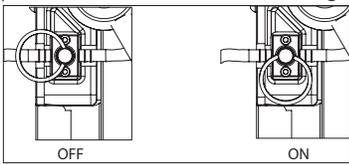


Figure 4

CAUTION!

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

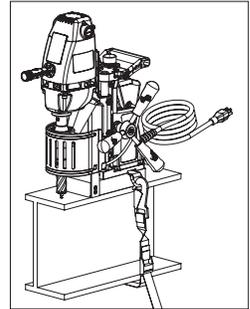


Figure 5

7. The safety strap must be securely fastened to machine and around work being drilled. Loop strap around work piece and connect strap ends by attaching to D-rings on drill. **(Figure 5)** **NOTE:** Safety strap is intended only to restrain the drill to the workpiece in the event of a power failure to the magnetic base.

8. Position chip guard toward work area before drilling.

(Figure 6)

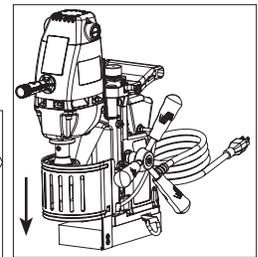
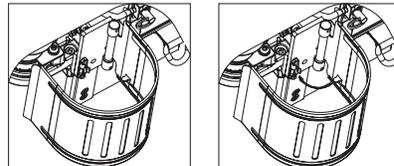


Figure 6

READY TO MAKE THE CUT

CAUTION!

CLOSE CHIP GUARD AND LOWER TO WORK SURFACE.

NOTE: IF ON/OFF SWITCHES ARE NOT ILLUMINATED, THERE IS NOT A PROPER MAGNETIC FIELD.

1. Move magnet switch to "ON" position. **(Figure 7)** Switch will illuminate to indicate power is present—magnetic base should be firmly secured to workpiece at this time. Thin materials may require an additional steel plate to achieve proper magnet adhesion.
 2. Start drill motor by depressing green motor "ON" button. **(Figure 8)**
 3. Using the feed handles, advance cutter into material until Slugger® cutter has established an external groove in the material. During the remainder of cut, apply smooth constant pressure without overloading motor. **(Figure 9)**
- NOTE:** Slugger® cutters are designed for uninterrupted cutting. Chips are evacuated during the cut. Do not peck drill when using Slugger® cutters.

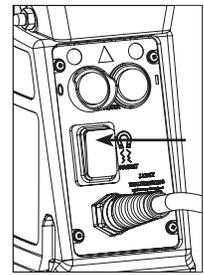


Figure 7

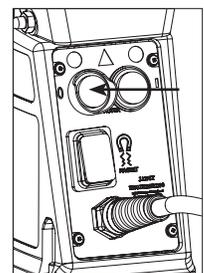


Figure 8

CAUTION!

IF DRILL MOTOR SHOULD STALL OR STOP BEFORE A COMPLETE CUT IS MADE, ALWAYS 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. **NOTE:** THIS MACHINE'S STANDARD UNMODIFIED CIRCUITRY WILL AUTOMATICALLY SHUT THE DRILL MOTOR OFF IF MAGNETIC BASE IS SEPARATED FROM ITS WORK SURFACE. IF YOUR MACHINE REQUIRES ADJUSTMENT, CONTACT JANCY'S SERVICE DEPARTMENT.

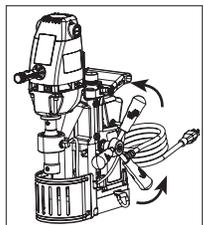


Figure 9

AFTER THE CUT

CAUTION: THE SLUG WILL BE HOT AND HAVE SHARP EDGES.

1. After the 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. **(Figure 10)**
2. Depress red motor "OFF" button. Wait until motor completely stops. **(Figure 11)**
3. Move magnet switch to "OFF" position when ready to release magnetic base from work surface. **(Figure 12)**
4. Residual magnetism may exist after magnet is turned off.

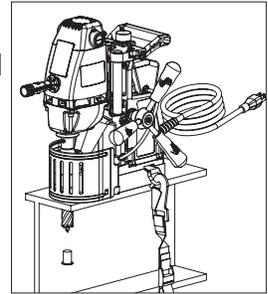


Figure 10

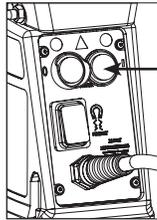


Figure 11

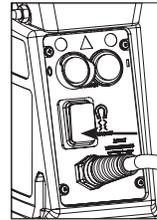


Figure 12

BASIC TROUBLESHOOTING

1. **Magnetic base not holding securely**
 - Material is too thin to engage magnet properly.
 - Surface of material being drilled must be free of chips, debris, rust and mill scale.
 - Size of cutter exceeds machine's rated capacity.
 - Excessive downfeed pressure.
 - Check magnet face for unevenness, nicks and burrs.
 - Welding equipment connected to material being drilled.
2. **Drill motor not running**
 - Insufficient magnetic field, "Smart Magnet"® circuitry functioning properly. (See page 7)
 - Check motor cord.
 - Check magnet resistance.
3. **Motor switches not illuminated**
 - Insufficient magnetic field, "Smart Magnet"® circuitry functioning properly. (See page 7)
 - Check switches for functionality.
4. **Drill motor running, arbor and spindle not turning**
 - Possible sheared spindle key.
5. **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.
6. **Slugs not ejecting from cutter**
 - Lack of coolant causing slugs to expand in cutter bore.
 - Incorrect pilot pin being used.
 - Possible broken internal arbor parts.

7. 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.
- Excessive arbor runout—see regular maintenance on page 10.
- Possible bent motor spindle or worn arbor sleeve.
- Improperly adjusted motor slide—see page 10.

8. Oversized or rough holes

- Insufficient coolant.
- Excessive feed pressure.
- Excessive cutter runout.
- Dull cutter.
- Worn support bracket roller bearing or arbor body sleeve.
- Bent motor spindle.
- Motor slide improperly adjusted.

REGULAR MAINTENANCE

1. The rail system may require adjustment after machine has been in service. Using feed handles, position motor/slide assembly in the full up position. **(Figure 13)** Using supplied 3mm hex wrench, slightly turn the two M6 X 10 adjustment screws equally on each of the two guide rods clockwise to increase rail tension, or counterclockwise to decrease rail tension. **(Figure 14)** Again using feed handles, position motor/slide to down position and insure even adjustment throughout travel. Do not over tighten adjustment screws as excessive rail tension can damage the machine. Properly adjusted, the motor/slide assembly should have no side-to-side movement and will remain where positioned without drifting.

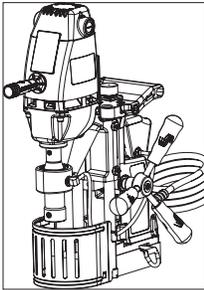


Figure 13

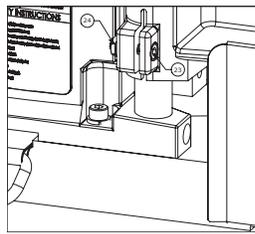


Figure 14

2. 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. **(Figure 15)**

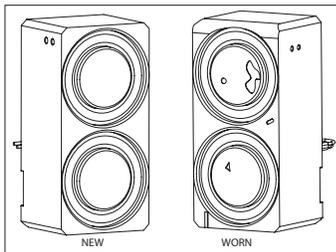


Figure 15

3. Periodically clean & lubricate motor slide rails. **(Figure 16)**

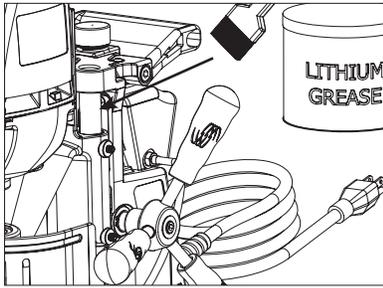


Figure 16

4. Visually inspect arbor, and support bracket for wear. **(Figure 17)**

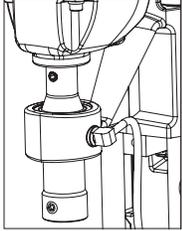


Figure 17

5. Visually inspect arbor for excessive runout. Arbor runout should not exceed .0035 inches per revolution. This is most accurately measured by placing a dial indicator needle inside of arbor bore and rotating arbor while observing indicator. **NOTE:** Always remove cutter from arbor body before measuring runout. Never use hands or fingers to rotate arbor or motor spindle.

6. Inspect motor brushes periodically and replace as needed. **(Figure 18)**

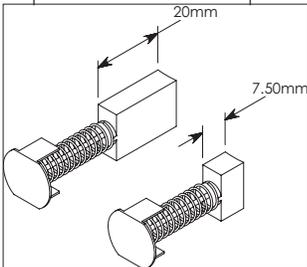
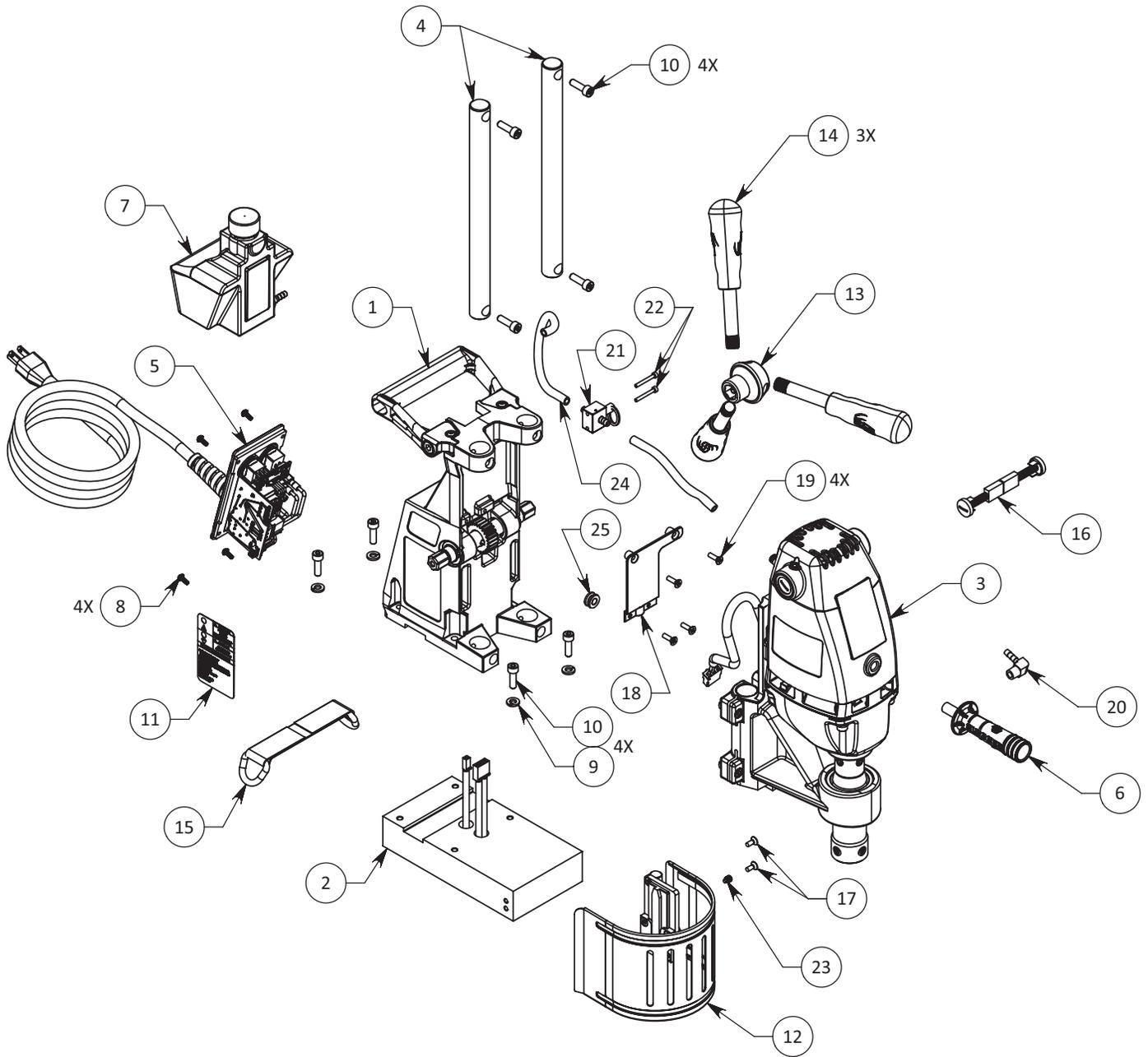


Figure 18

7. 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.
8. Regularly test machine by placing on non-ferrous material to test "SMART MAGNET"[®] circuitry. Engage magnet switch. On/off switches should not illuminate. Motor should not start when on button is pushed.

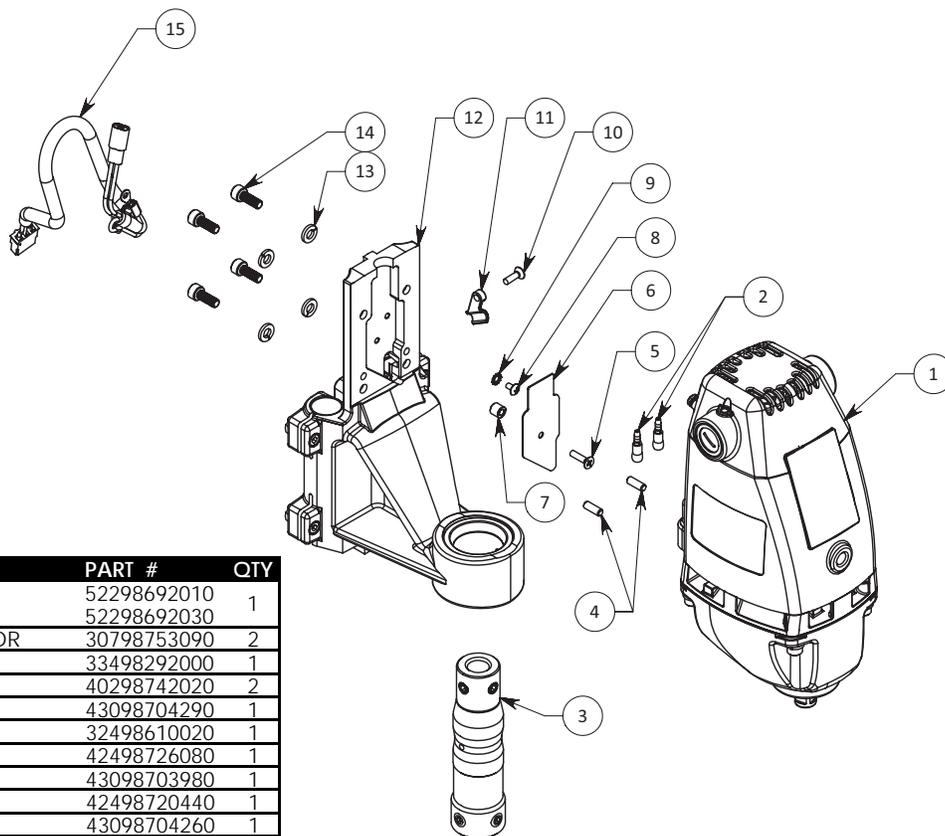
MACHINE BREAKDOWN



MACHINE PARTS LIST

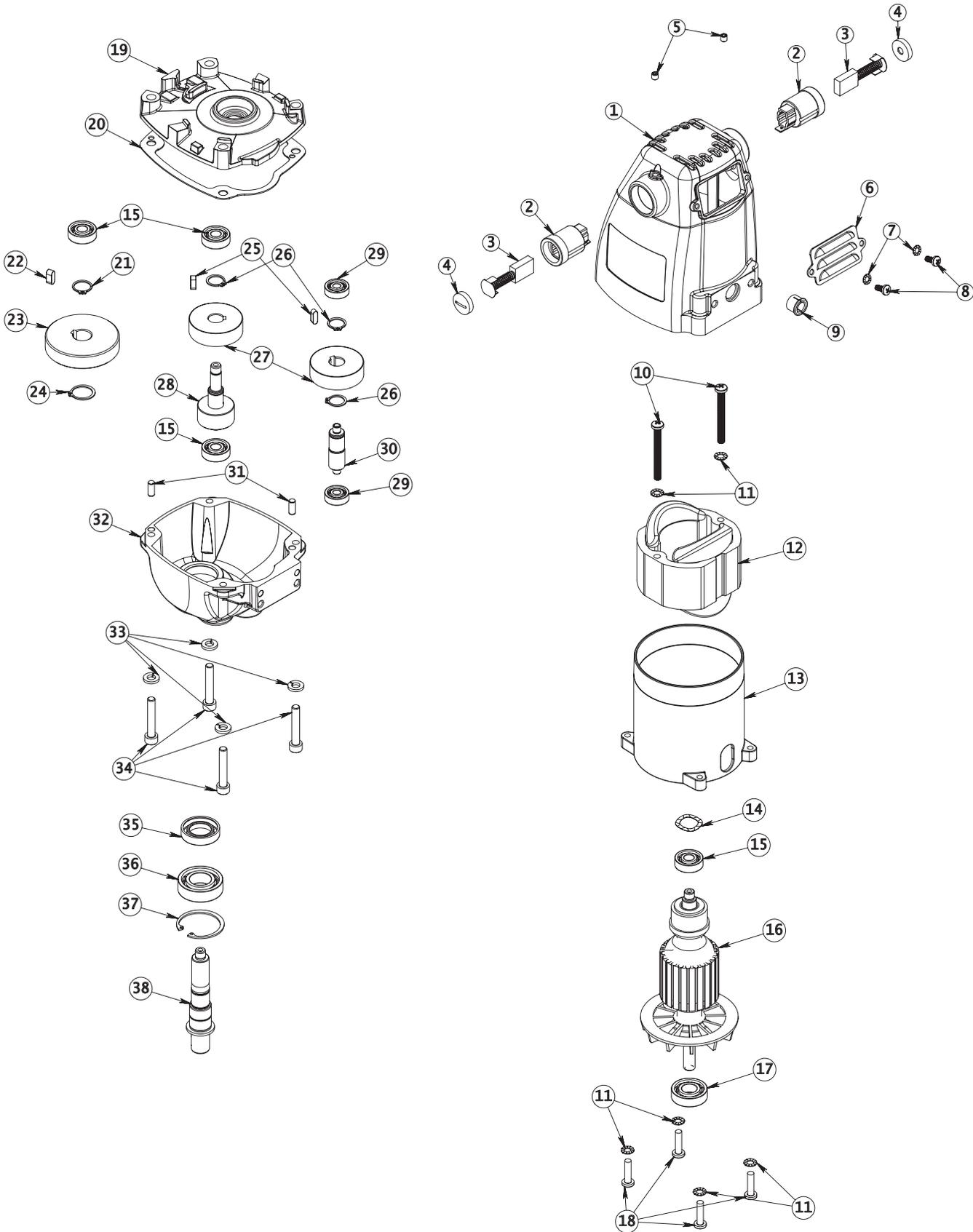
ITEM	DESCRIPTION	PART #	QTY
1	FRAME ASSEMBLY	33298392040	1
2	MAGNET ASSEMBLY, 120V, 220V	33298492000	1
3	MOTOR AND SLIDE ASSEMBLY, 120V	52298692130	1
	MOTOR AND SLIDE ASSEMBLY, 120V	52298692140	
4	GUIDE ROD	33298322020	2
5	PANEL ASSEMBLY, 120V	30798592010	1
	PANEL ASSEMBLY, 220V	30798592030	
6	SUPPORT HANDLE	64298130060	1
7	COOLANT BOTTLE ASSEMBLY	32198190050	1
8	M3.5 X 10 CRPHMS - ETLW	43098703230	4
9	1/4" LOCK WASHER	42498724020	4
10	M6 X 20 SHCS	43098706400	8
11	SHEET OF LABELS	32298140030	1
12	GUARD ASSEMBLY	64298160240	1
13	HUB ASSEMBLY	64298160160	1
14	SPOKE HANDLE	64298121000	3
15	SAFETY STRAP LINK	64298110040	1
16	BRUSH AND CAP SET	52298691020	1
17	M4 X 10 CRFHMS	43098704080	2
18	MOTOR CORD COVER	33298331060	1
19	M4 X 14 CRFHMS	43098704260	4
20	BRASS BARB FITTING	31498761040	1
21	COOLANT VALVE ASSEMBLY	64298161120	1
22	M3 X 25 SHCS	43098703210	2
23	M6 X 6 NTSSS	43098706030	1
24	3/16" ID X 10" TUBING	31498760100	1
25	RUBBER GROMMET	30798757120	1

MOTOR SLIDE BREAKDOWN AND PARTS LIST



ITEM	DESCRIPTION	PART #	QTY
1	MOTOR, 120V	52298692010	1
	MOTOR, 240V	52298692030	
2	RED MALE BULLET CONNECTOR	30798753090	2
3	ARBOR ASSEMBLY	33498292000	1
4	M5 X 14 DOWEL PIN	40298742020	2
5	M4 X 16 CRFHMS	43098704290	1
6	WIRE COVER	32498610020	1
7	SPACER	42498726080	1
8	M4 X 6 CRTHMS	43098703980	1
9	M4 LOCK WASHER	42498720440	1
10	M4 X 14 CRFHMS	43098704260	1
11	CORD CLAMP	32498610040	1
12	SLIDE ASSEMBLY	31342621154	1
13	1/4" LOCK WASHER	42498724020	4
14	M6 X 16 SHCS	43098706240	4
15	MOTOR CORD ASSEMBLY	30798591040	1

MOTOR BREAKDOWN

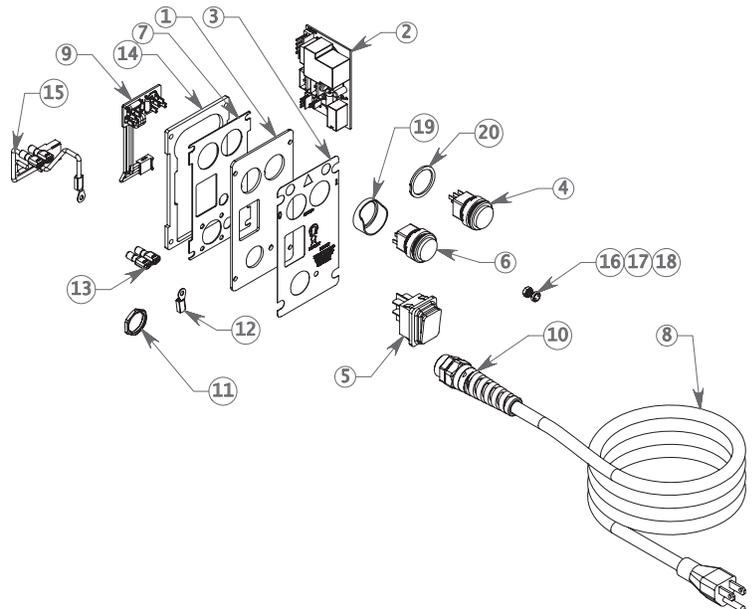


MOTOR PARTS LIST

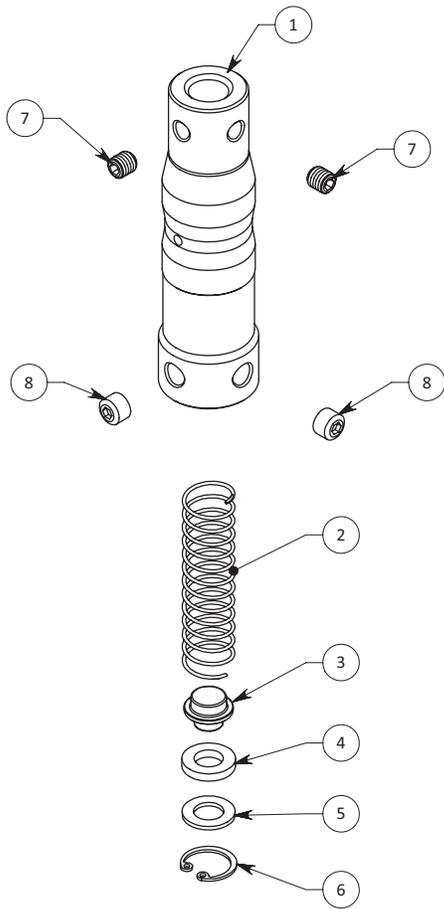
ITEM	DESCRIPTION	PART #	QTY
1	MOTOR HOUSING	31998631060	1
2	BRUSH HOLDER	30798651050	2
3	CARBON BRUSH	30798651060	2
4	CARBON BRUSH CAP	30798651080	2
5	M5 X 5 CPSSS	43098705000	2
6	INTAKE LOUVER	32498611020	1
7	M4 LOCK WASHER	42498720440	2
8	M4 X 10 CRPHMS	43098704200	2
9	STRAIN BUSHING	30798757000	1
10	M5 X 50 CRPHMS	43098705600	2
11	M5 LOCK WASHER	42498720500	6
12	FIELD, 120 V	51298651030	1
	FIELD, 230 V	51298651040	
13	FIELD INSULATOR	31998631040	1
14	WAVE WASHER	42498726140	1
15	BALL BEARING	41798730200	4
16	ARMATURE, 120 V	53298651010	1
	ARMATURE, 230 V	53298651020	
17	BALL BEARING	41798730390	1
18	M5 X 20 CRPHMS	43098705440	4
19	GEAR BOX COVER	31998631020	1
20	GASKET	32498611000	1
21	EXTERNAL RETAINING RING	42698740140	1
22	SHAFT KEY	40298745020	1
23	OUTPUT GEAR	33698681010	1
24	EXTERNAL RETAINING RING	42698740170	1
25	SHAFT KEY	40298745040	2
26	EXTERNAL RETAINING RING	42698740120	3
27	INTERMEDIATE GEAR	33698681030	2
28	OUTPUT PINION GEAR	33698681020	1
29	BALL BEARING	41798730120	2
30	INTERMEDIATE PINION	33698681040	1
31	M5 X 12 DOWEL PIN	40298742000	2
32	GEAR BOX CASTING	31998631010	1
33	1/4" LOCK WASHER	42498724020	4
34	M6 X 35 SHCS	43098706580	4
35	LIP SEAL	40698763020	1
36	BALL BEARING	41798730450	1
37	INTERNAL RETAINING RING	42698741350	1
38	MOTOR SPINDLE	33498621000	1

PANEL BREAKDOWN AND PARTS LIST

ITEM	DESCRIPTION	PART #	QTY
1	PANEL PLATE	30798512000	1
2	PCB BOARD, 120V	30798550020	1
3	PCB BOARD, 220V	30798550030	1
4	PANEL LABEL	32298142000	1
5	RED OFF PUSH BUTTON SWITCH	30798755040	1
6	GREEN LIGHTED ROCKER MAG	30798755000	1
7	GREEN ON PUSH BUTTON SWITCH	30798755020	1
8	PANEL PLATE INSULATOR	30798511000	1
9	POWER CORD	30798750000	1
10	PCB AND WIRE HARNESS ASSEMBLY	30798550040	1
11	STRAIN RELIEF	30798757040	1
12	STRAIN RELIEF NUT	30798757041	1
13	RED TERMINAL CRIMP	30798753260	1
14	FEMALE PUSH-ON TERMINAL	30798753160	2
15	PANEL GASKET	30798510020	1
16	PANEL BOARD CABLE ASSEMBLY	30798591065	1
17	M4 X 10 DSPHMS	43098704180	1
18	M4 LOCK WASHER	42498720460	1
19	M4 NUT	40298746040	1
20	SWITCH GUARD	32498520020	1
21	SPACER	32498520040	1



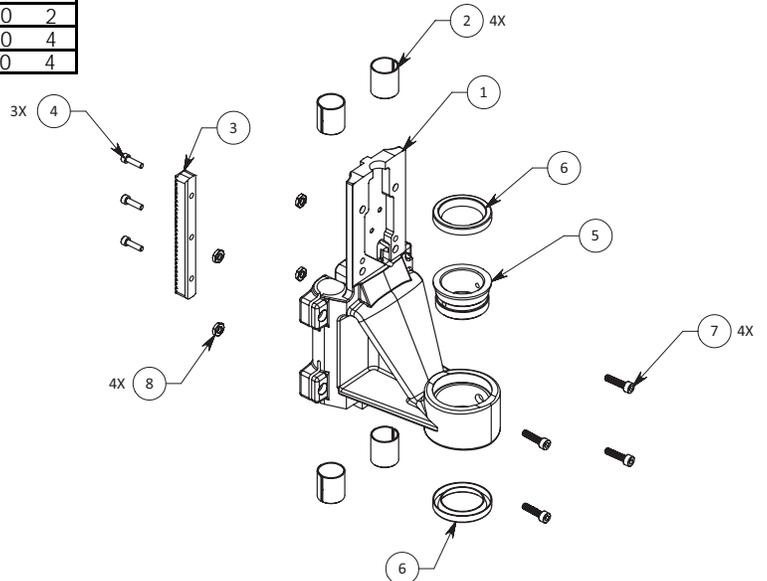
ARBOR BREAKDOWN AND PARTS LIST



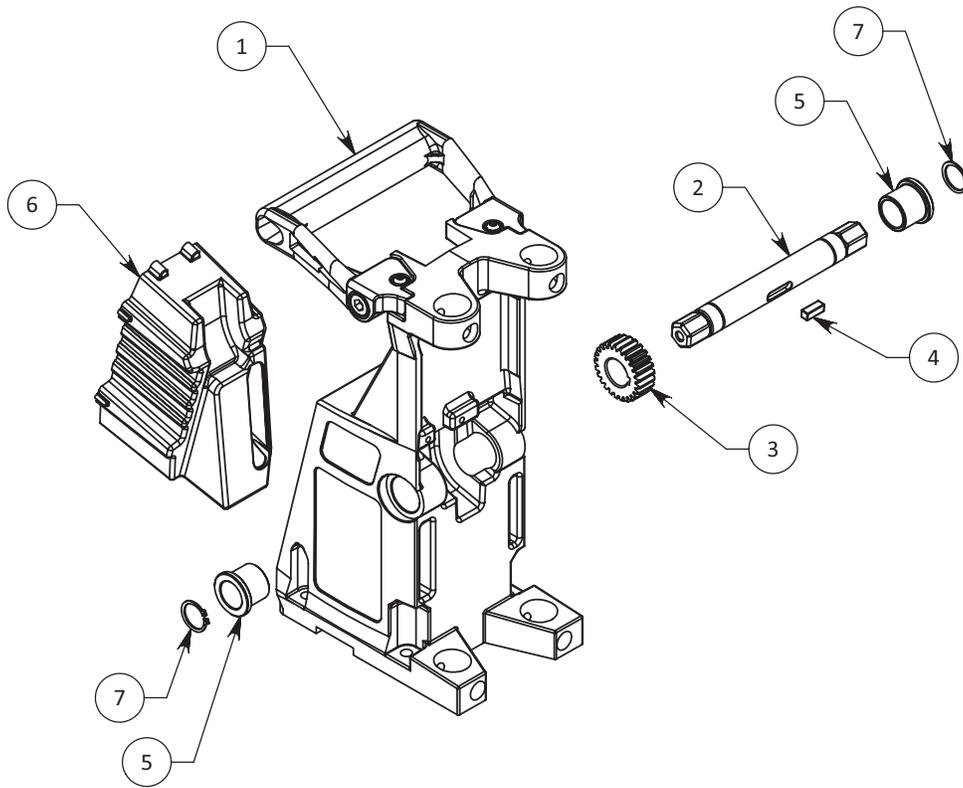
ITEM	DESCRIPTION	PART #	QTY
1	ARBOR	33498222100	1
2	SPRING	30998744100	1
3	ARBOR FLOATING PISTON	33498221060	1
4	RUBBER WASHER	42498726040	1
5	STEEL WASHER	42498726060	1
6	INTERNAL RETAINING RING	42698741190	1
7	M8 X 8 FPSS	43098708040	2
8	M10 X 8 FPSS	43098709000	2

ARBOR SUPPORT BREAKDOWN AND PARTS LIST

ITEM	DESCRIPTION	PART #	QTY
1	SLIDE	31998632020	1
2	GUIDE ROD BUSHING	33498622060	4
3	GEAR RACK	33698680040	1
4	M4 X 10 SHCS	43098704120	3
5	ARBOR BUSHING	33498622000	1
6	LIP SEAL	40698763000	2
7	M5 X 20 SHCS	43098705420	4
8	M5 NUT	42098746090	4

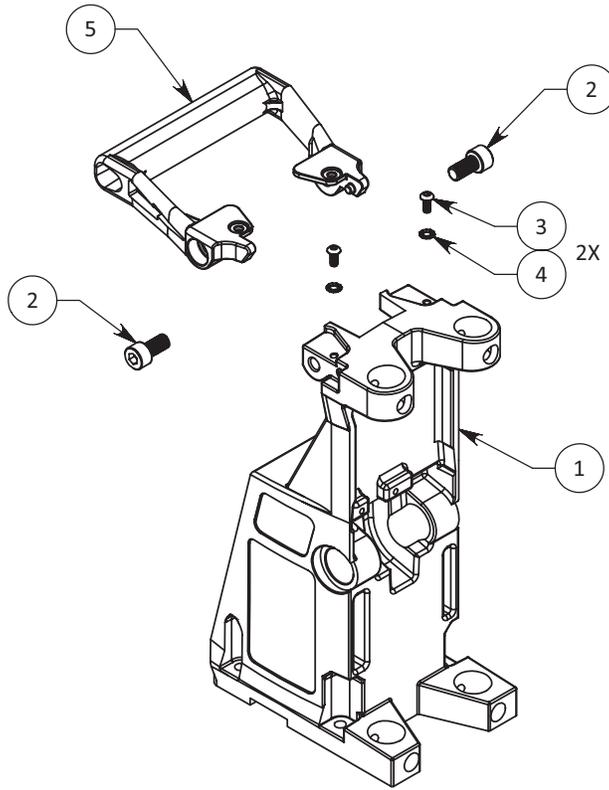


FRAME BREAKDOWN AND PARTS LIST



ITEM	DESCRIPTION	PART #	QTY
1	FRAME AND HANDLE ASSEMBLY	33298332000	1
2	PINION SHAFT	33298320040	1
3	PINION GEAR	64298160120	1
4	KEY	40298745000	1
5	FLANGE BUSHING	33298320080	2
6	BUSH SHAFT	33298320060	2
7	ENCLOSURE	31498532000	1
8	EXTERNAL RETAINING RING	42698740160	2

FRAME SUB-ASSEMBLY BREAKDOWN AND PARTS LIST

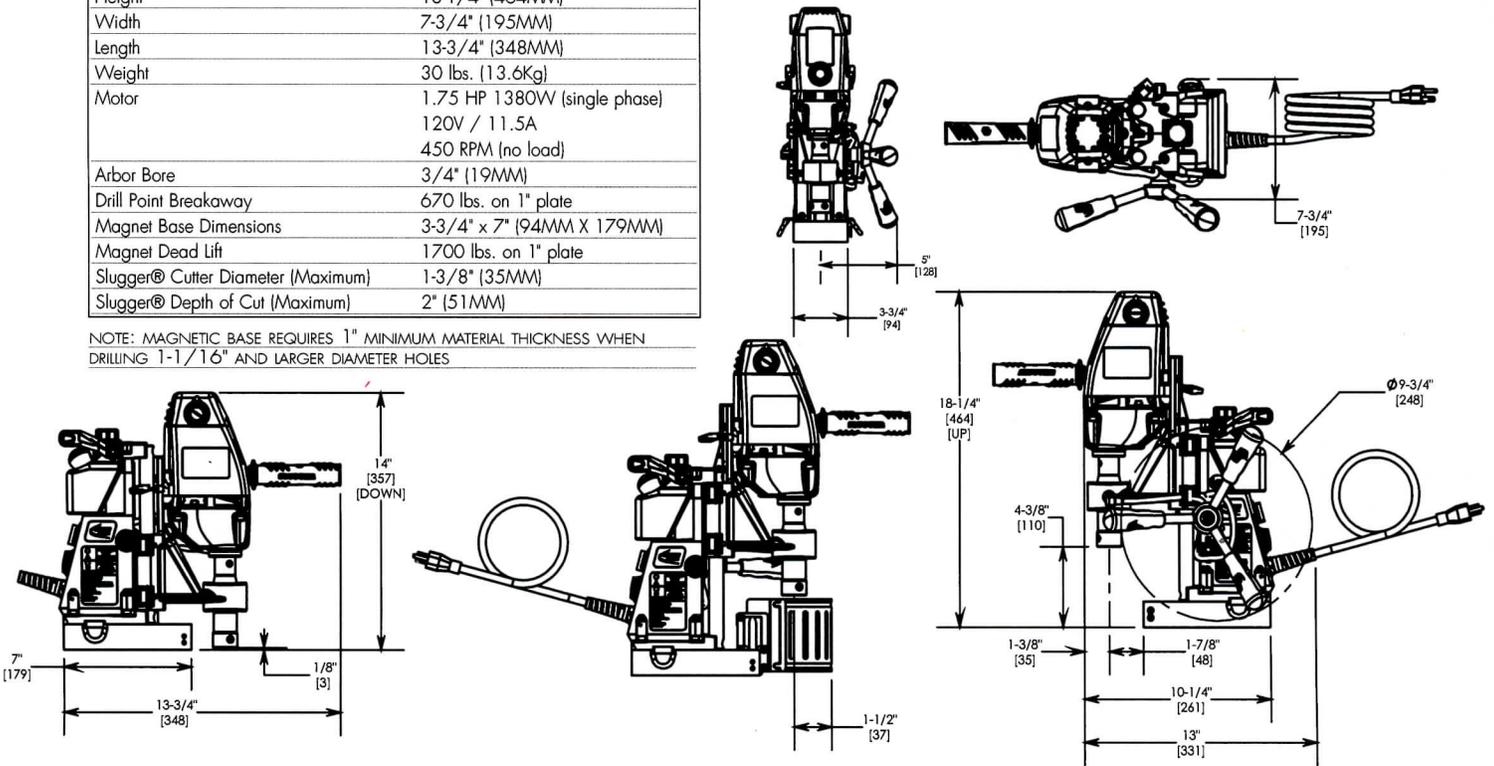


ITEM	DESCRIPTION	PART #	QTY
1	FRAME	33298332040	1
2	M8 X 16 SHCS	43098708100	2
3	M4 X 10 BHSCS	43098704060	2
4	M4 LOCK WASHER	42498720440	2
5	HANDLE	33298330020	1

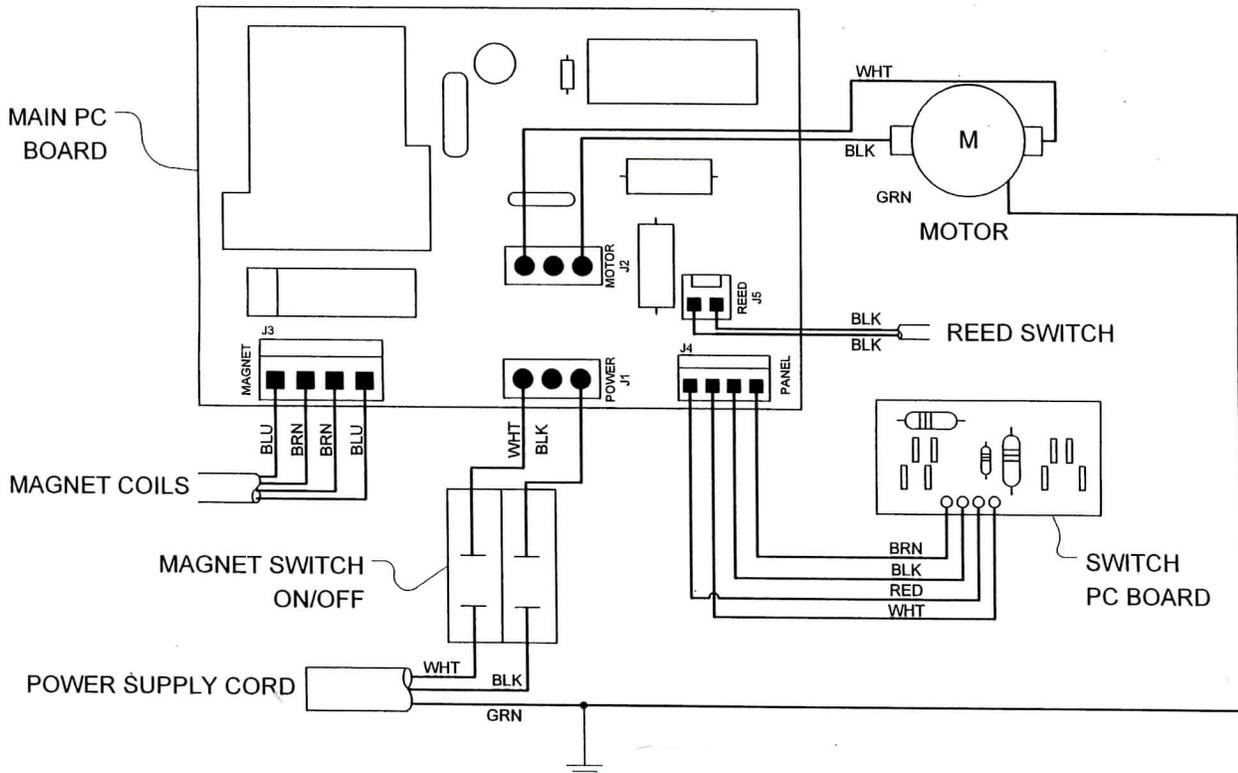
DIMENSIONS AND SPECIFICATIONS

DIMENSIONS AND SPECIFICATIONS	
Height	18-1/4" (464MM)
Width	7-3/4" (195MM)
Length	13-3/4" (348MM)
Weight	30 lbs. (13.6Kg)
Motor	1.75 HP 1380W (single phase) 120V / 11.5A 450 RPM (no load)
Arbor Bore	3/4" (19MM)
Drill Point Breakaway	670 lbs. on 1" plate
Magnet Base Dimensions	3-3/4" x 7" (94MM X 179MM)
Magnet Dead Lift	1700 lbs. on 1" plate
Slugger® Cutter Diameter (Maximum)	1-3/8" (35MM)
Slugger® Depth of Cut (Maximum)	2" (51MM)

NOTE: MAGNETIC BASE REQUIRES 1" MINIMUM MATERIAL THICKNESS WHEN DRILLING 1-1/16" AND LARGER DIAMETER HOLES



WIRING DIAGRAM



OTHER AVAILABLE SLUGGER® DRILLS

DESCRIPTION	MODEL #	MAX DIAMETER	DEPTH CAPACITY
USA5 120V	18066	2-3/8"	3"
USA5 240V	18080	2-3/8"	3"
USA101 120V	USA101	1-1/2"	2"
USA101 240V	USA101-2	1-1/2"	2"
2 X 2 120V	17980	2"	2"
2 X 2 240V	17982	2"	2"
4 X 4 120V	17985	4"	3"
4 X 4 240V	17987	4"	3"
MAGFORCE 120V	06920	1-5/8"	2"
MAGFORCE 240V	06921	1-5/8"	2"

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