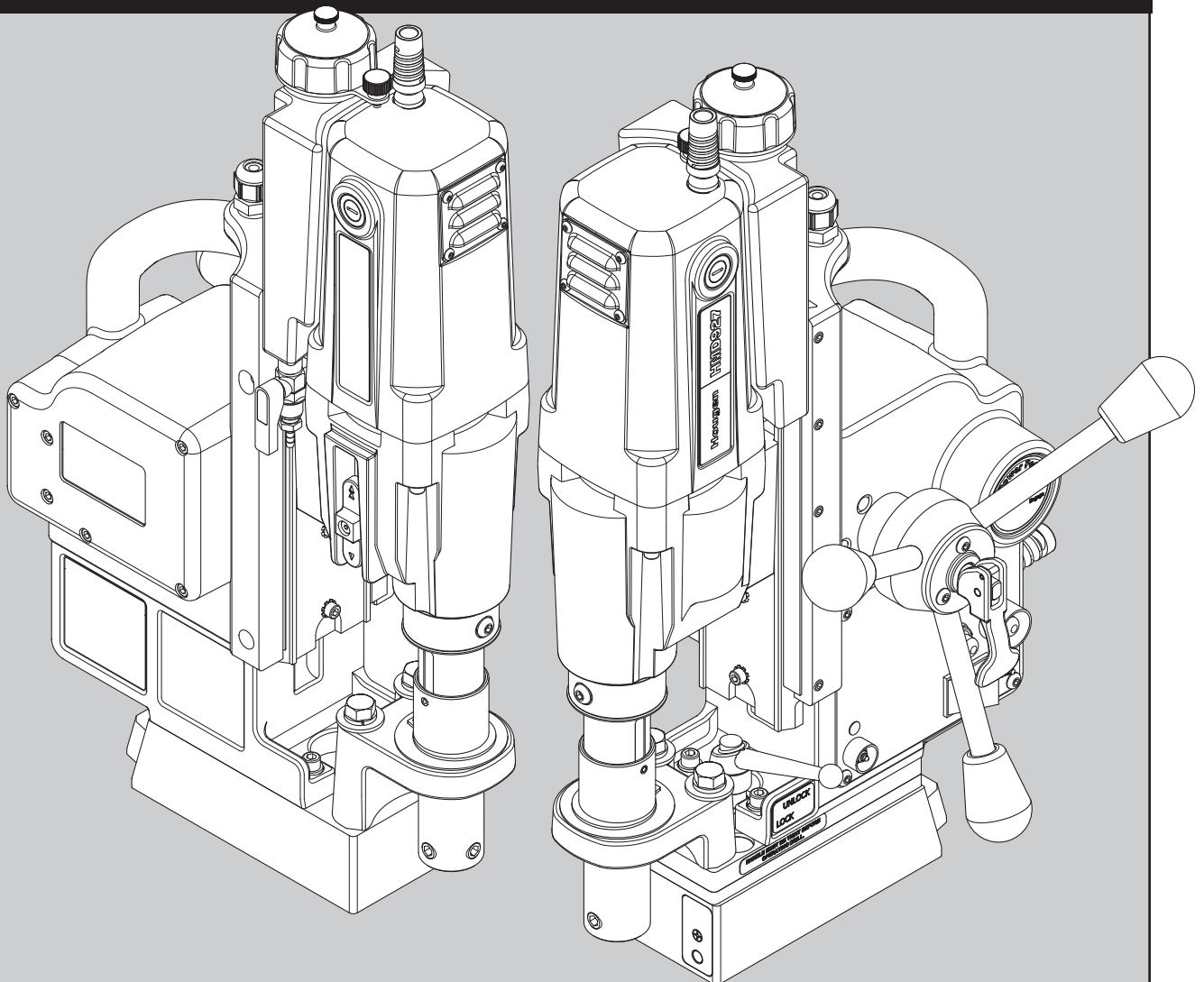




OPERATOR'S MANUAL

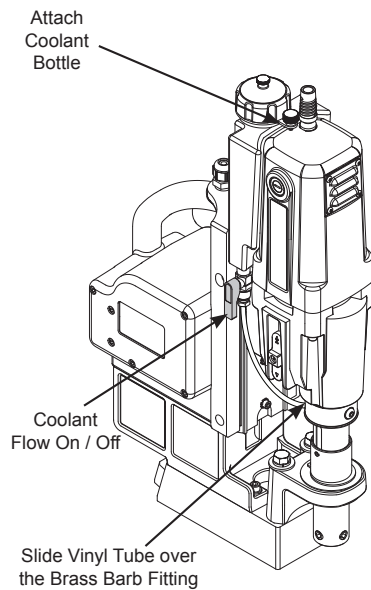
HMD927 SERIES POWER FEED MAGNETIC DRILL



Covers Drill Part Numbers:

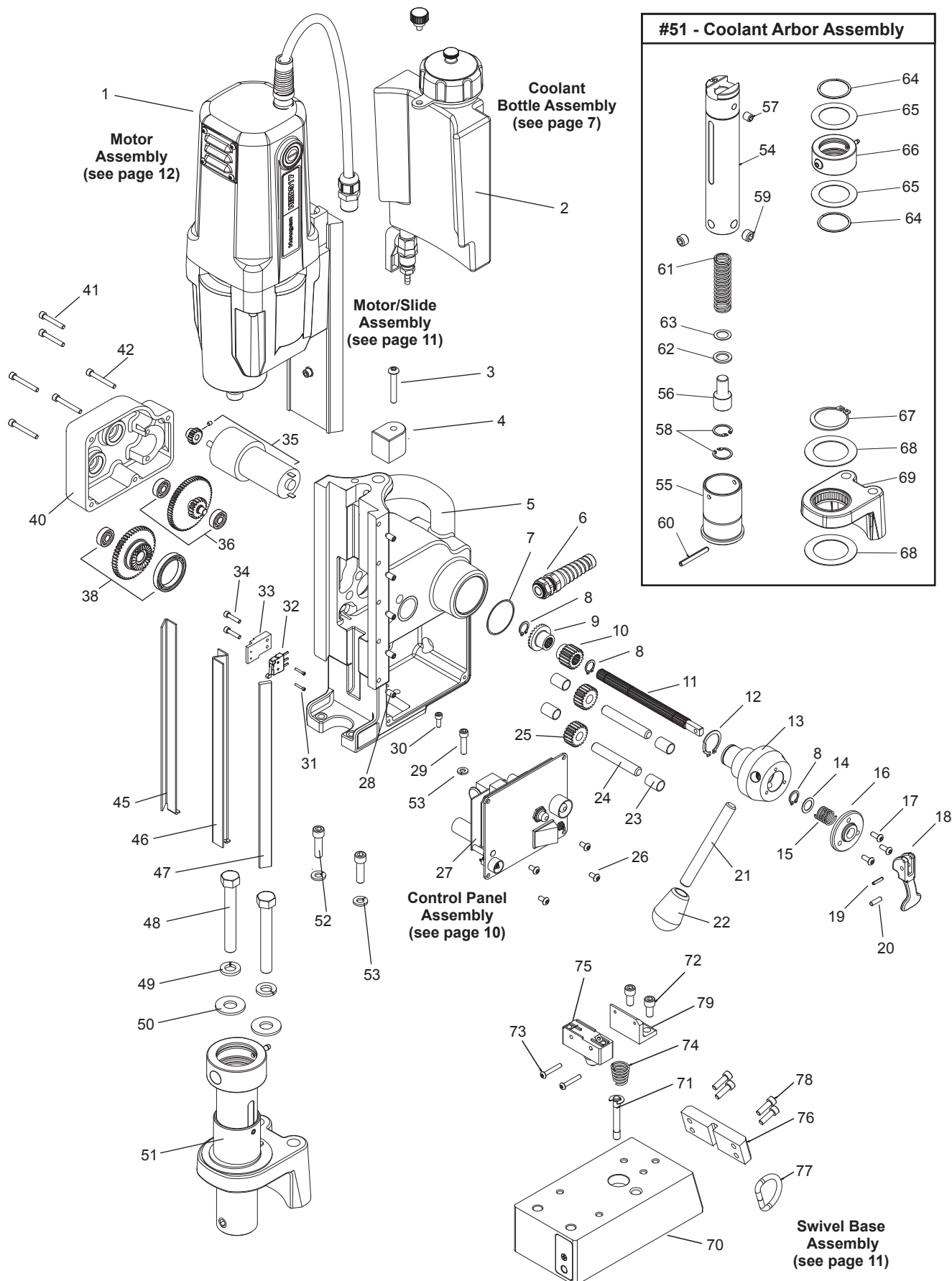
0927202	0927302	0927402
0927204	0927304	0927404

COOLANT BOTTLE ASSEMBLY



07950 Coolant Bottle Assembly	
Part #	Description
08255	Round Bottle
08061	Coolant Bottle Bracket (Bottle to Bracket)
41044	SCR-BHC 10-32 x 3/8
05065	Ball Valve
05067	Brass Barb Fitting (bottom of the bottle)
40304	Vinyl Tube
24124	Cap - Coolant Bottle

HMD927 MAG BASE DRILL



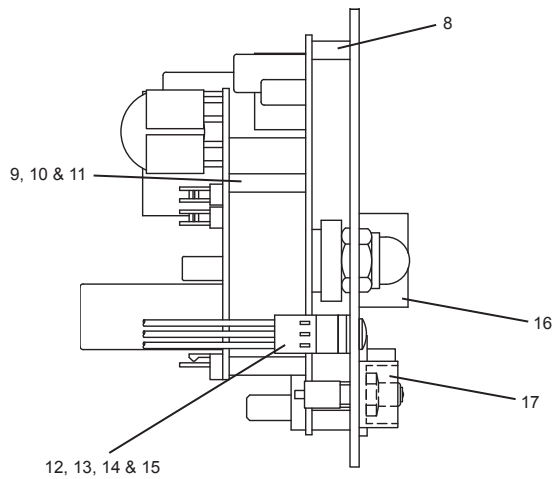
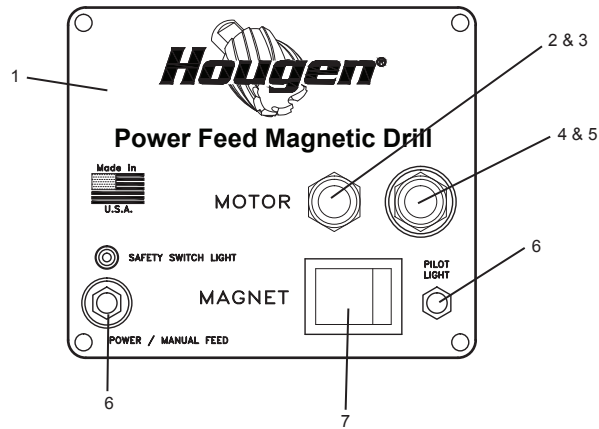
HMD927 Breakdown			
Item	Part #	Description	Qty
1	08140	Motor / Slide Assy.	1
2	07950	Coolant Bottle Assy.	1
3	10559	SCR BHC #10-32 x 1-1/4 LG	1
4	07833	Stop Block	1
5	08159	Drill Housing Assembly	1
6	19571	Power Cord Assembly	1
7	19024	Engagement Label	1
8	01165	Retaining Ring	3
9	19005	Drive Clutch	4
10	19008	Gear Spur Removable #2	1
11	08643	Shaft - Spline	1
12	10836	Retaining Ring	1
13	19030	Feed Hub Assembly	1
14	05115	Washer - Flat .505 x .75 x .03	1
15	05114	Spring - Comp	1
16	19010	Plate - Hub Engagement	1
17	90077	SCR BHC #10-32 x 1/2 LG	3
18	08642	Handle - Lever	1
19	02902	Pin - Roll 1/2 x 5/8	1
20	40277	Pin - Dowel 3/16 x 5/8	1
21	04558	Feed Handle	3
22	04532	Knob - Oval	3
23	19020	Spacer	4
24	19017	Shaft - 20 Tooth Gear	2
25	19016	Gear Spur Removable #1	2
26	41044	SCR BHC #10-32 x 3/8 LG	4
27	08142	Control Panel Assembly	1
28	40237	Gib Screws	5
29	40077	SCR SHC 1/4-20 x 1" LG	1
30	10648	SCR SHC #10-32 x 1/2 LG	1
31	05187	SCR SHC #2-56 x 1/2	2
32	19042	Switch Assembly	1
33	19018	Plate - Travel Switch - Non-Swivel	1
	07070	Plate - Travel Switch - Swivel	1
34	05203	SCR SHC #8-32 x 3/4	2
35	19026	Feed Motor Assembly	1
	02217	Set SCR #8-32 x 3/16	1
	19027	Motor Gear	1
36	19028	Gear - #4 & #5 Assembly	1
38	19029	Gear #3 & Clutch Assembly	1
	05107	Ball Bearing 35mm x 47mm x 7mm	1
	24100	Ball Bearing	3
40	08161	Gear Box Cover	1
41	51044	SCR SHC #10-32 x 1-1/4	2
42	41048	SCR SHC #10-32 x 1-1/2	4
45	07834	Gib - Right Hand	1
46	07838	Gib - Left Hand	1
47	07842	Gib	1

HMD927 Breakdown			
Item	Part #	Description	Qty
48	40594	Bolt - Hex HD 3/8-24 x 3" Non-Swivel	2
	07088	Bolt - Hex HD 3/8-24 x 2-1/4" Swivel	2
49	40391	Lock Washer - Helical 3/8	2
50	40392	Washer - Flat 3/8 Type A	2
51	07831	Arbor Assembly Non-Swivel	1
	08115	Arbor Assembly Swivel	1
52	10553	SCR SHC 1/4-20 x 7/8 LG	2
53	90028	Lock Washer - Helical 1/4	3
Accessories Included			
	10565	Hex Key 1/8 wrench	1
	04558	Feed Handles	3
	04532	Feed Handle Knobs	3
	10730	Safety Chain 3/16 X 5' w/Snap Hook	1
	24166	T-Handle Hex Key Wrench	1
	13013	5/32" Allen Wrench	1

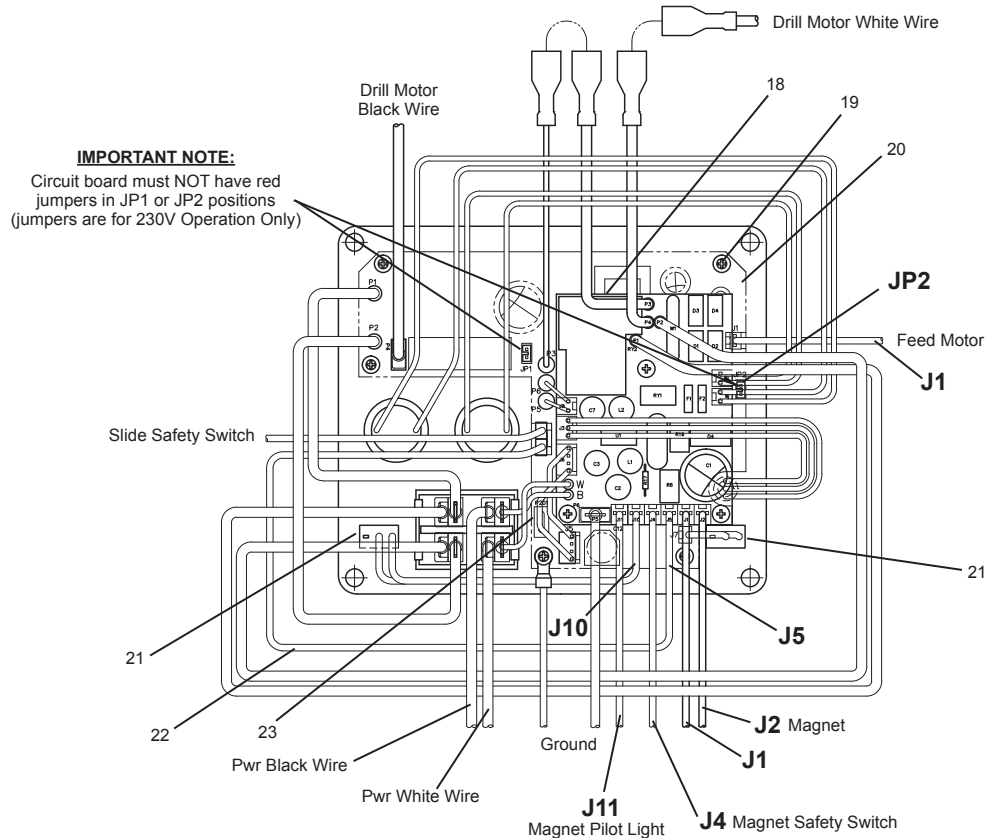
08013 Magnet Assembly			
Item	Part #	Description	Qty
70	08014	Magnet Assembly	1
71	04910	Plunger Assembly	1
72	10971	SCR SHC 1/4-20 x 1/2" LG	2
73	10972	SCR BHC #6-32 x 7/8" LG	2
74	17271	Spring - Taper, Comp.	1
75	04885	Microswitch Assy.	1
76	07887	Plate - Ring Retaining	1
77	24144	D-Ring	1
78	41046	SCR SHC #10-32 x 1/2" LG	4
79	04909	Bracket - Safety Switch	1

07831 Coolant Arbor Assembly Non-Swivel 08115 Coolant Arbor Assembly Swivel			
Item	Part #	Description	Qty
54	07872	Arbor - Coolant	1
55	07162	Collar Ejector	1
56	07079	Spring Seat	1
57	40256	SCR Set 5/16-18 x 3/8 Oval Pt	1
58	10517	Ring - Retaining Internal	2
59	40222	SCR Set 7/16-14 x .305	2
60	40312	Pin-Roll 3/16 dia x 1.564 Altered	1
61	05049	Spring - Comp	1
62	07436	Washer - Rubber	1
63	07440	Washer - Shim 12 x 18 x .5mm	1
64	40302	Ring - Retaining	2
65	40301	Washer, Thrust 1-3/8 x 2-1/16 x 1/32	2
66	07445	Coolant Inducer	1
	40300	O-Ring (<i>not shown</i>)	1
	07447	Hose Fitting (<i>not shown</i>)	1
	07082	SCR BHC 1/4-28 x 1/4 (<i>not shown</i>)	1
67	40398	Ring - Retaining	1
68	40234	Washer, Thrust	2
69	08113	Front Support Bracket Assy. Swivel	1
	07870	Front Support Bracket Assy. Non-Swivel	1

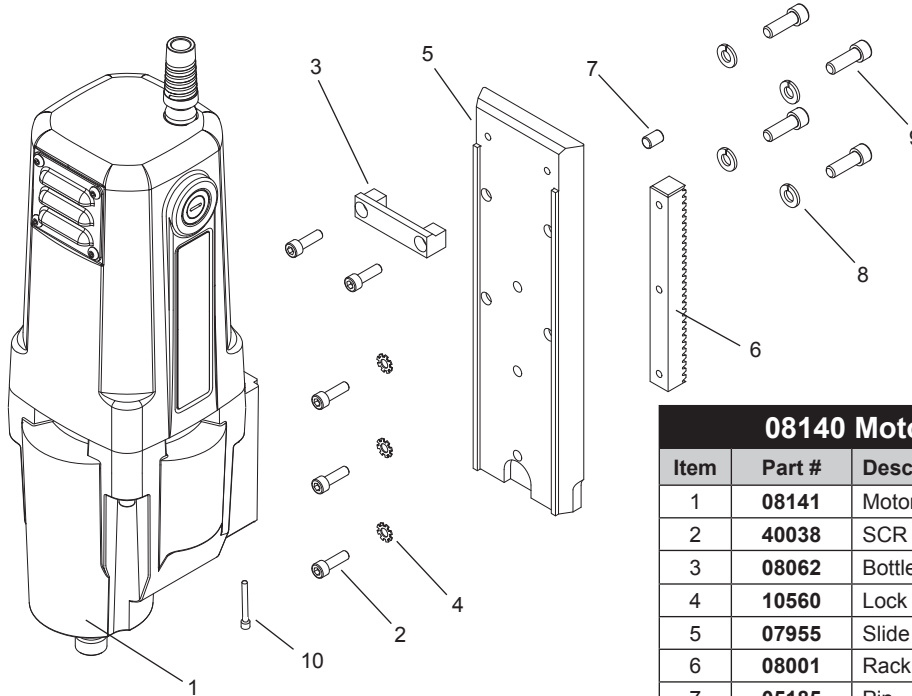
CONTROL PANEL BREAKDOWN & WIRING



08142 Panel Assembly 230V			
Item	Part #	Description	Qty
1	08139	Faceplate	1
2	01335	Switch - Motor Off	1
3	01228	Cover - Switch Red	1
4	01334	Switch - Motor On	1
5	02409	Cover - Switch Green	1
6	05336	Boot - Mini, Toggle Switch	1
7	04614	Switch - Rocker Illuminated	1
8	04891	Standoff - 3/8 LG	5
9	05832	Standoff - Nylon	3
10	05320	SCR-SLOT HD	3
11	05319	Nut - Plastic	3
12	04877	Wire Harness	1
13	04878	Spacer - LED	1
14	04881	Bulb - LED	1
15	04879	Lens - LED	1
16	01226	Guard - Switch	1
17	07392	Guard - Toggle Switch	1
18	08673	Circuit Board - Power	1
19	05355	SCR-PHMS #4-40 x 1/4	5
20	08156	Circuit Board - Autofeed	1
21	05335	Mini Toggle Switch Asm	2
22	05331	Jumper - Two Wire	1
23	05332	Jumper Two Wire	1



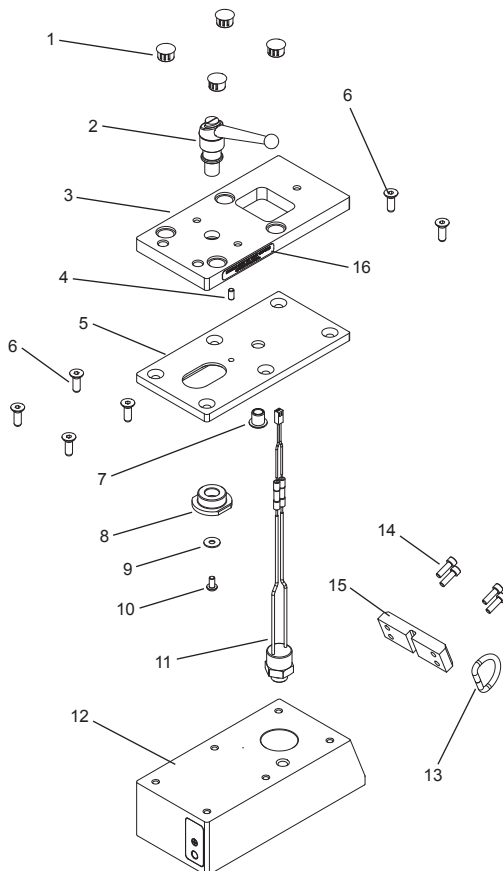
MOTOR SLIDE ASSEMBLY BREAKDOWN



08140 Motor & Slide Assembly

Item	Part #	Description	Qty
1	08141	Motor Complete Assembly	1
2	40038	SCR BHC #10-32 x 5/8 LG	5
3	08062	Bottle Support	1
4	10560	Lock Washer Ext. #10	3
5	07955	Slide - Dovetail	1
6	08001	Rack - Gear	1
7	05185	Pin - Dowel	1
8	90028	Lock Washer Helical 1/4	4
9	10624	SCR SHC 1/4-20 x 3/4	4
10	51044	SCR SHC #10-32 x 1-1/4	1

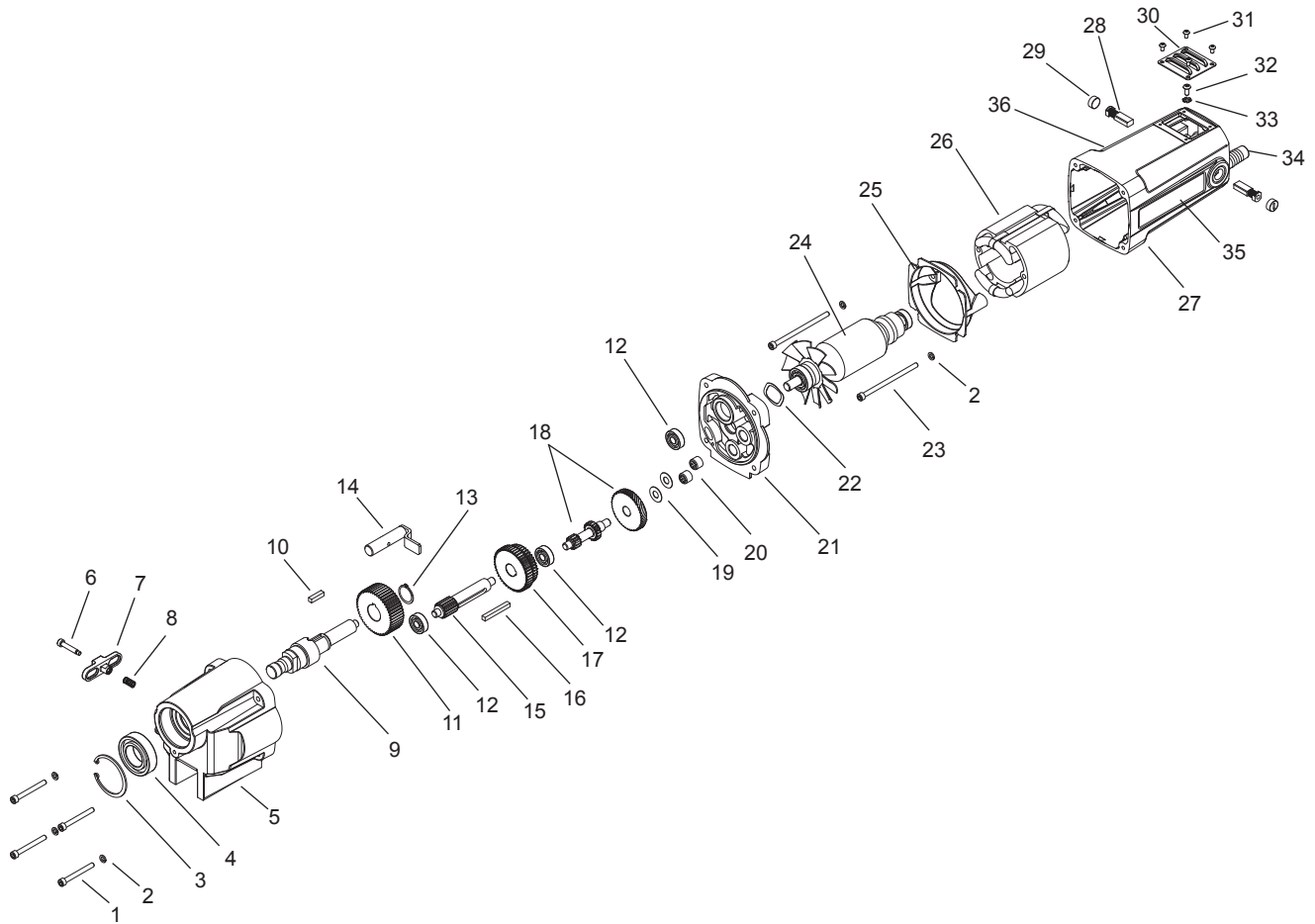
SWIVEL BASE MAGNET ASSEMBLY BREAKDOWN



08103 Swivel Magnet Assembly

Item	Part #	Description	Qty
1	07216	Plug Hole	4
2	05659	Clamp Handle Assembly	1
3	08094	Swivel Plate	1
4	02898	Dowel Pin	1
5	08095	Slide Plate	1
6	05743	SCR FHC 1/4-20 x 3/4 LG	6
7	07215	Bushing - Flange	1
8	05658	Pivot - Rod	1
9	90237	Washer - Flat #10	1
10	41044	SCR BHC #10-32 x 3/8 LG	1
11	05652	Ball Switch Assembly	1
12	08104	Magnet & Safety Switch Asm	1
	05653	Plunger <i>(not shown)</i>	1
13	24144	D - Ring	1
14	41046	SCR SHC #10-32 x 1/2" LG	4
15	07887	Plate - Retaining Ring	1
16	07230	Label - Swivel Warning	1

MOTOR PARTS DIAGRAM



08141 Motor Assembly

Item	Part #	Description	Qty	Item	Part #	Description	Qty
1	08234	SCR SHC #10-32 X 1-5/8	4	21	07969	Gear Box Cover	1
2	50038	Washer - Lock Helical #10	6	22	08070	Washer - Spring	1
3	07860	Retaining Ring	1	23	08025	SCR - SHC #10-32 x 3-1/4 LG	2
4	40274	Bearing 25mm x 47mm x 12mm	1	24	08045	Armature Assembly	1
5	07966	Gear Box Housing	1	25	07958	Baffle	1
6	08069	SCR - Shsld 3/16 x 7/8	1	26	08046	Field	1
7	07908	Switch	1	27	07953	Motor/Brush Holder Assembly	1
8	07910	Spring - Comp	1	28	07961	Carbon Brushes	2
9	07976	Spindle - Motor Drive	1	29	07960	Brush Holder Cap	2
10	07904	Key - 3/16 x 3/16 x 3/4	1	30	07848	Cover - Brush Access	1
11	07975	Gear Spur Removable - 49 Tooth	1	31	02385	SCR BHC #6-32 x 1/4	4
12	24100	Ball Bearing	3	32	41042	SCR BHC #8-32 x 3/8 LG	1
13	24160	Retaining Ring	1	33	10538	Washer - Lock #8	1
14	07977	Shift Control Rod Arm	1	34	08337	Motor Cord	1
15	07974	Gear Spur Removable - 15 Tooth	1	35	08136	Motor Label	1
16	07978	Key - 3/16 x 3/16 x 1-1/2	1	36	08044	Motor Specs Labels	1
17	07973	Assembly - Change Gear 250/450	1				
18	07972	Assembly - Gears #2 & #3	1				
19	17610	Washer - Flat 8mm	2				
20	07903	Needle Bearing	2				