



**PORTABLE MAGNETIC DRILLS**

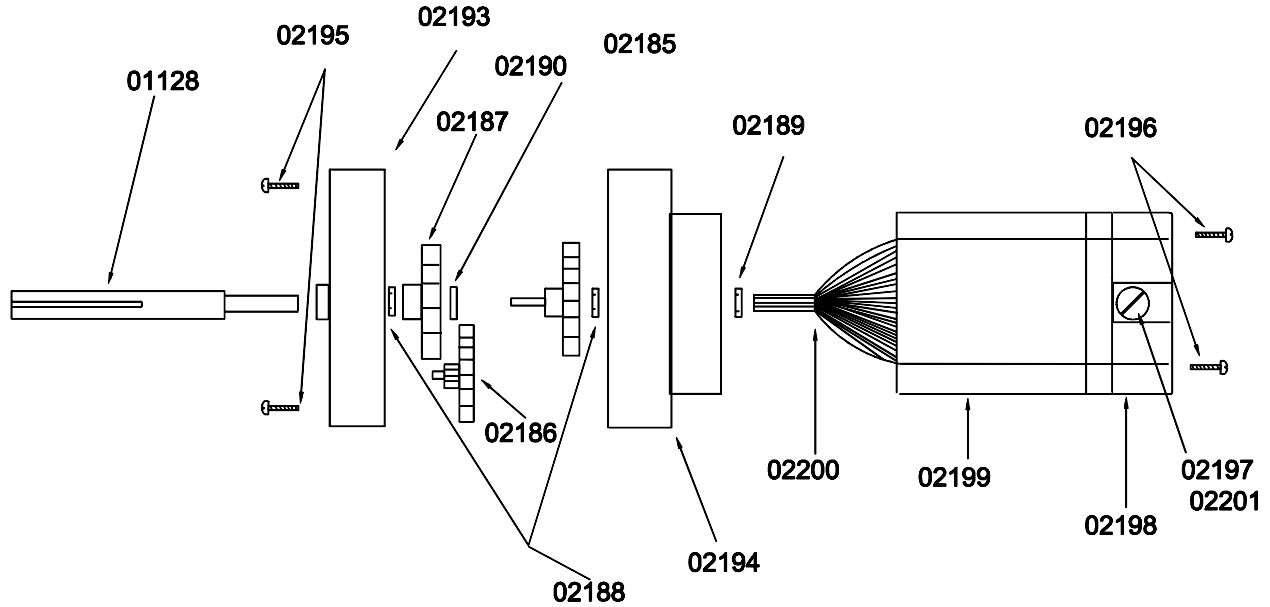
**OPERATOR'S MANUAL**

**10925 AND 10926**

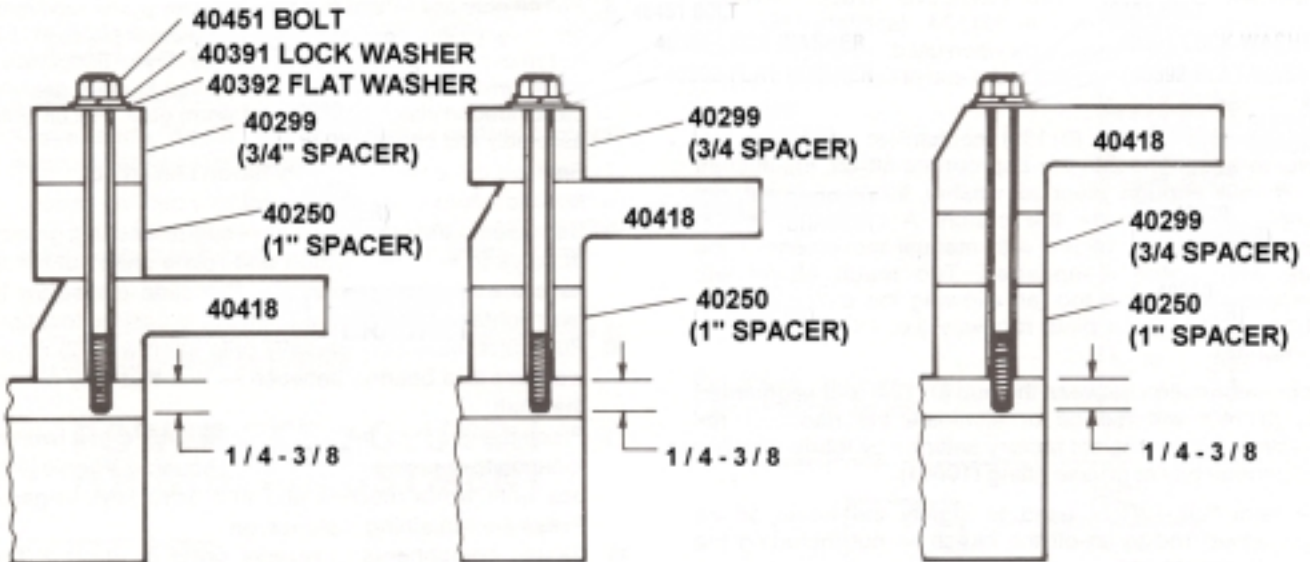


**FOR USE WITH "12,000-SERIES" ROTABROACH® CUTTERS**

# POWER FEED GEAR MOTOR



## ADJUSTING ARBOR SUPPORT BRACKET FOR DEPTH



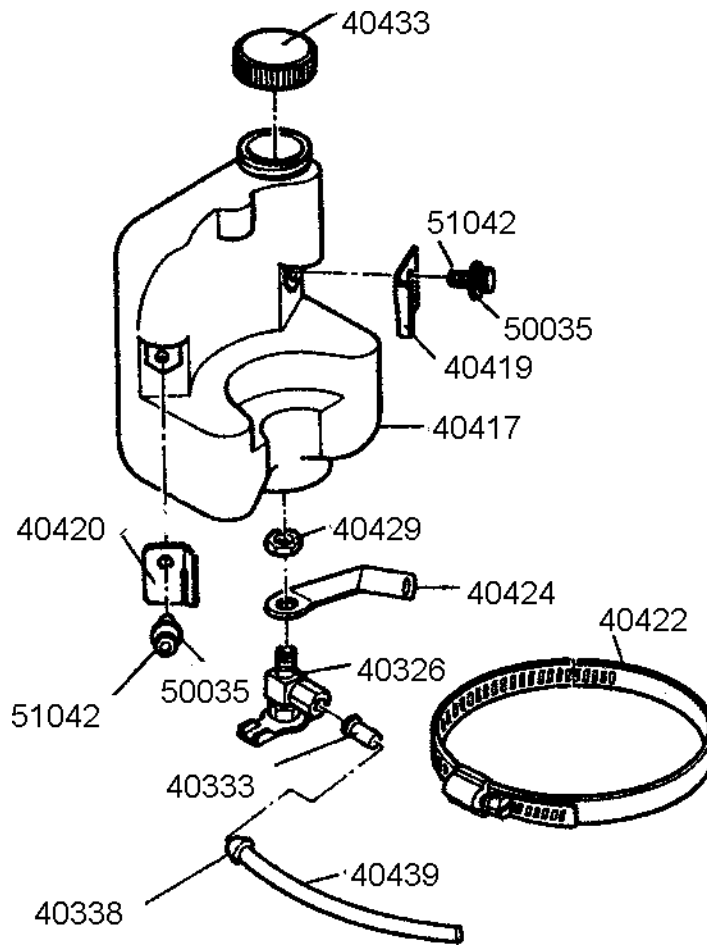
NOTE: Spacers must always be installed with short side toward arbor

Bracket in place for  
1" depth of cut

Bracket in place for  
2" depth of cut

Bracket in place for  
3" depth of cut

# COOLANT BOTTLE ASSEMBLY



## Checking Operation of Automatic Cutting Fluid Inducer

Note: The automatic cutting fluid inducer system works on a gravity flow basis. Therefore, it is only effective when the drill is mounted on a horizontal or slightly inclined work surface.

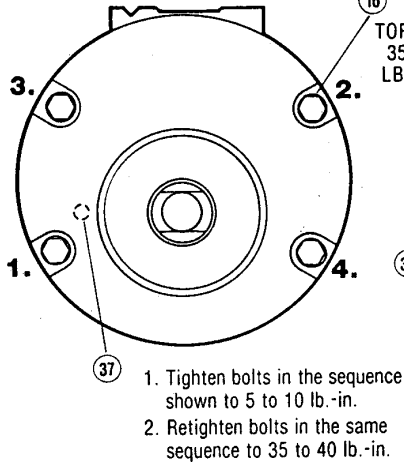
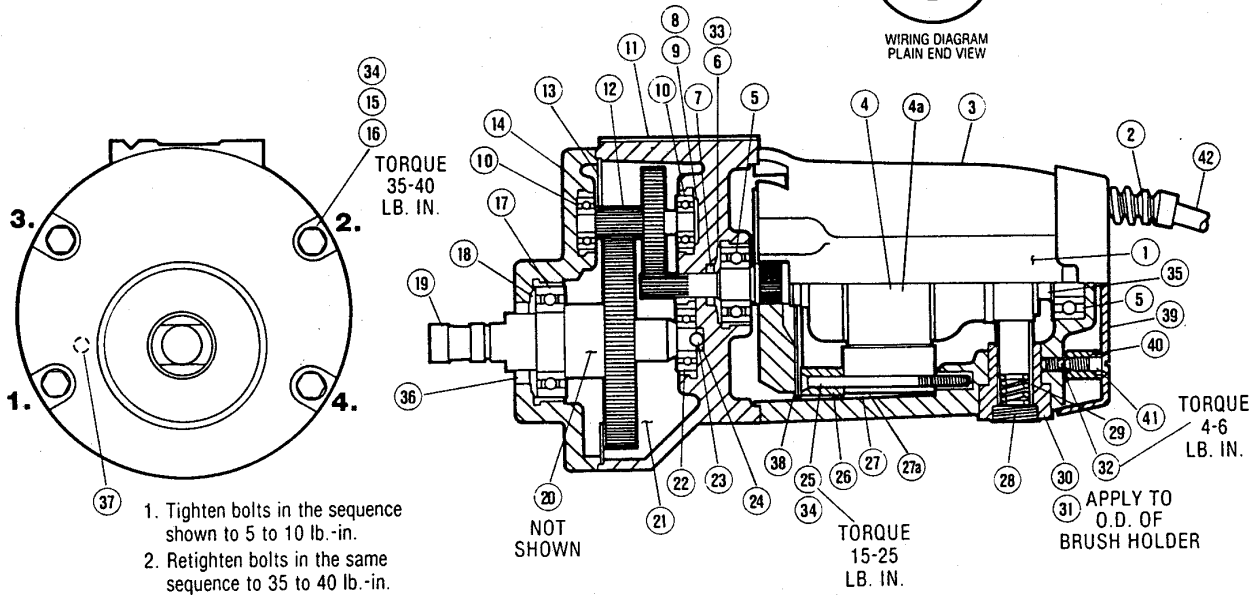
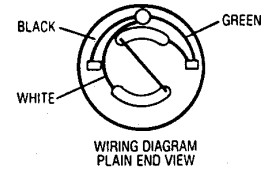
1. With Magnetic Drill in operation position, turn feed handle so that the cutter and pilot are above the work surface.
2. Fill cutting fluid bottle with cutting fluid.
3. To test automatic cutting fluid inducer (with the magnet ON and motor OFF), feed the arbor gently toward the work surface until the pilot is pushed up into the cutter. Open the needle valve until fluid is visible filling the plastic tube. Fluid should filter down onto the work surface through the groove in the pilot.
4. To insure proper cutter lubrication, always make sure that the slot in the pilot is kept clean from residual buildup.

## Checking Operation of Cutting Fluid Reservoir

1. With magnetic drill in operating position, turn feed handle 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 more than 30 seconds.

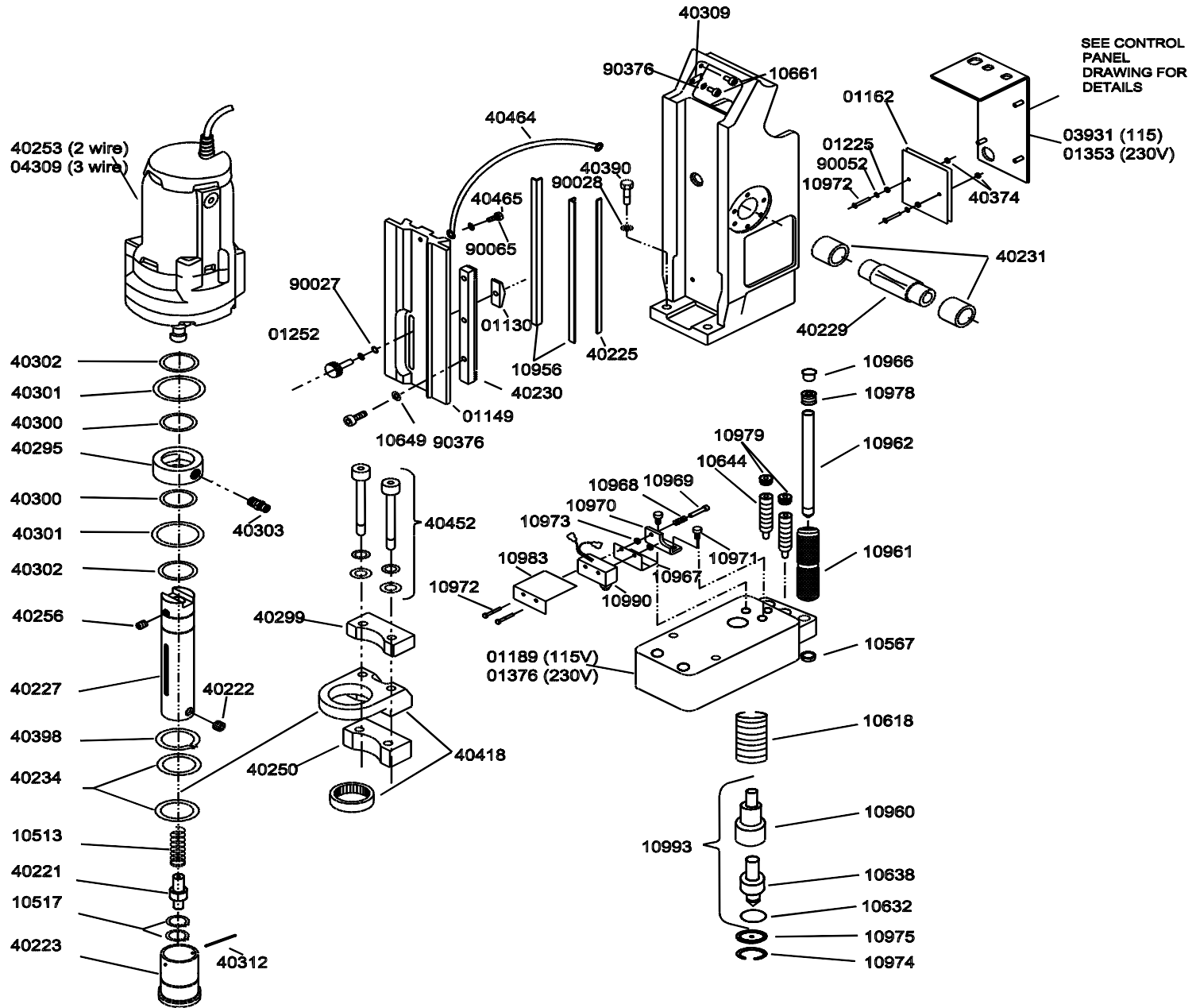
# Motor Parts Diagram

**IMPORTANT: DO NOT EXCEED RECOMMENDED TORQUES  
WHEN TIGHTENING DETAILS 15, 25 AND 32**



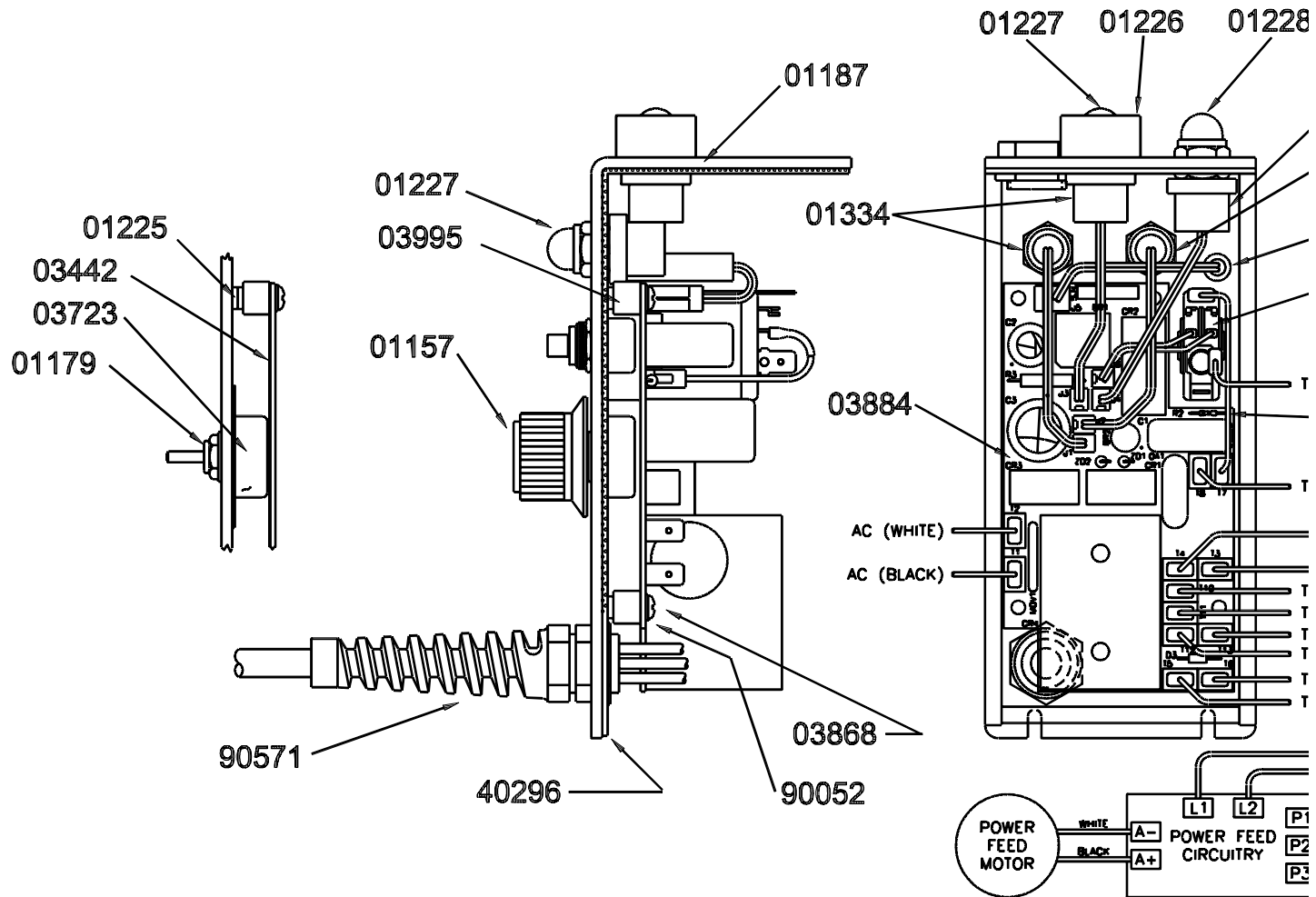
Detail No.	Part No.	Description	No. Req'd.	Detail No.	Part No.	Description	No. Req'd.
1	40291	Connector	1	25	40383	Screw #10-32	2
2	40445	Strain relief	1	26	40384	Spacer, Baffle	1
3	40260	Housing, Brush End	1	27	40284	Field Assy 115V (2 wire)	1
4	40261	Armature Assy. - 115V	1		04308	Field Assy 115V (3 wire)	1
4a	01087	Armature Assy. - 230V	1	27a	01088	Field Asst 230V	1
5	40262	Bearing	2	28	40285	Brush Plug	2
6	40263	Spring, Flat	1	29	40286	Brush Carbon	2
7	40264	Seal	1	30	40287	Brush Holder	2
8	40265	Spring, Flat	1	31		Loctite 271	
9	40266	Washer	1	32	40289	Screw #10-32 x 1/4"	2
10	40267	Bearing	2	33	40290	Washer	1
11	40268	Housing, Gear	1	34		Loctite 242	
12	40269	Gear, Cluster	1	35	40292	Retaining Ring	1
13	40270	Gasket	1	36	40348	Seal	1
14	40271	Cap, Gear Housing	1	37	40349	Plug	1
15	40298	Screw 1/4-20x 3-1/2	4	38	40382	Baffle	1
16	40273	Lock Washer 1/4"	4	39	40441	End Cap	1
17	40274	Bearing	1	40	40449	Spacer	2
18	40275	Spring, Flat	2	41	40450	Screw #10-32x1"	2
19	40276	Gear, Output	1	42	40258	Motor Cord (2 Wire)	1
20	40277	Pin, Locating	1		04204	Motor Cord (3 Wire)	1
21	40350	Grease, Syntech	8 oz	*	90424	Clip, Brush Holder	2
22	40279	Bearing	1				
23	40280	Ball	1				
24	40281	Slug	1				



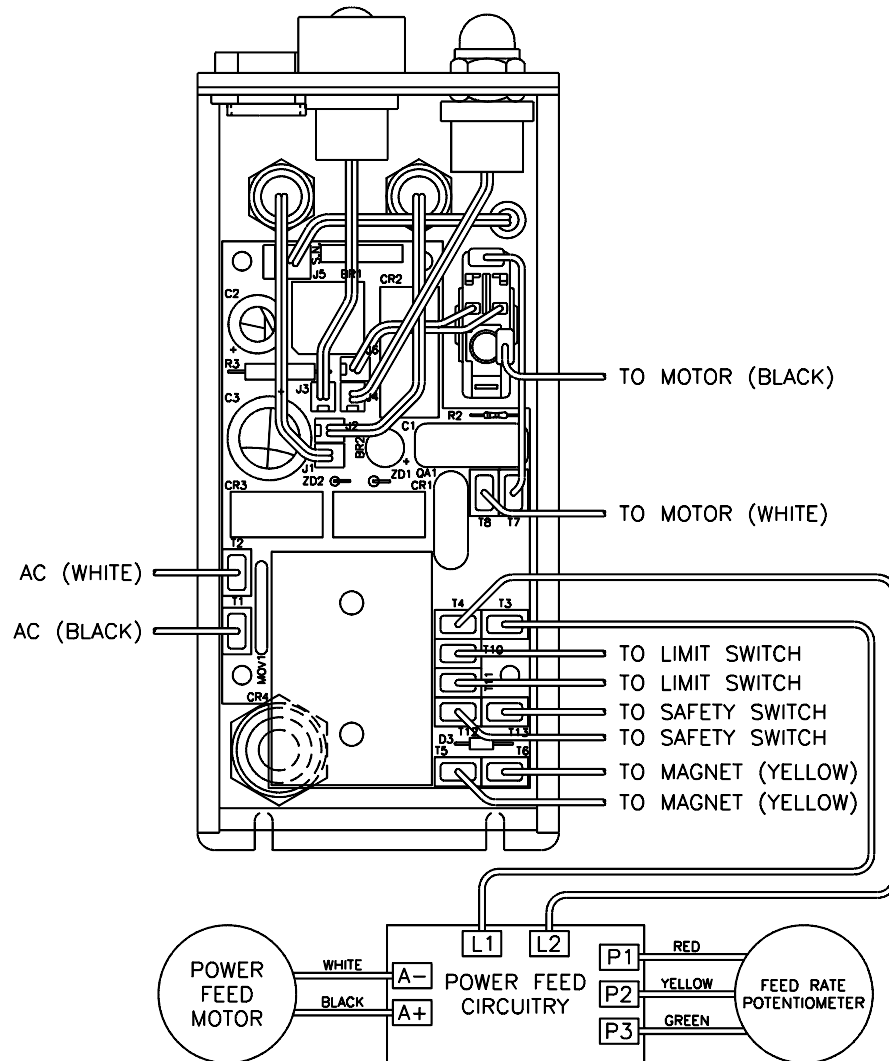


# Electrical Panel Layout Diagram

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# Electrical Panel Hook-up Diagram



**NOTE: ALL DRILLS BUILT AFTER JUNE 1999 SHOULD HAVE THIS CONFIGURATION. THAT MEANS ANY DRILL WITH A SERIAL NUMBER OF 967001 AND EARLIER WILL NEED PART NUMBER #03937 (REPLAC. KIT)  
03937 KIT INCLUDES A CIRCUIT BOARD, CIRCUIT BREAKER, PILOT LIGHT AND THE NECESSARY HARDWARE. DOES NOT REPLACE SWITCHES, FACEPLATE OR POWER CORD.**

# Parts Listing

Part No.	Description	Qty. Req'd.	Part No.	Description	Qty. Req'd.
01084	GEAR HOUSING	1	01993	HEX BOLT #10-32 X 3/4	3
01124	HUB	1	02153	POTENTIOMETER	1
01125	LEVER	1	02185	HIGH SPEED GEAR	1
01128	SHAFT P/F MOTOR	1	02186	GEAR INTER HIGH SPEED	1
01129	FEED MOTOR SHAFT KEY	2	02187	OUTPUT GEAR	1
01130	LIMIT SWITCH ACTIVATOR	1	02188	BEARING KIT	2
01132	DRIVE KEY	3	02189	P/F MOTOR SPACERS	1
01134	CLUTCH SPACER	1	02190	RETAINING RING	1
01135	HOUSING CLUTCH P/F	1	02193	HOUSING-ASSY GEAR	1
01137	DISENGAGE LINKAGE	1	02194	COVER-GEAR HSNG. ASSY.	1
01138	HUB DRIVE PIN	1	02195	SCR_TORX #6-32	4
01139	DISENGAGE LVR. HANDLE	1	02196	SCR-TORX #10-32	4
01140	HUB LOC. RING SEGMENT	2	02197	PLUG-BRUSH HOLDER	2
01141	ENGAGEMENT ROD	1	02198	MOTOR HOUSING COVER	1
01145	KEY	1	02199	HOUSING MOTOR STATOR	1
01148	GEARBOX COVER PLATE	2	02200	ARMATURE ASSEMBLY	1
01149	SLIDE MOTOR MOUNT	1	02201	BRUSH ASSEMBLY P/F	2
01152	SCREW SHC 1/4-20 X 3-1/4	4	02211	BRACKET	1
01153	DOWEL PIN .1877 X .5	1	03184	CLUTCH PLATE P/F	1
01155	THRUST BEARING	3	03185	CLUTCH COVER P/F	1
01156	BRONZE BUSHING	1	03234	CLUTCH ASSY REPLAC.	1
01157	POTENTIOMETER KNOB	1	03235	WORM GEAR	1
01158	SCR. BUTTON HEAD #4-40	8	03442	PC BOARD INSULATOR	1
01162	SPEED CONTROL BOARD	1	03685	SWITCH ASSY.	1
01163	GEARBOX PLUG	1	03721	JUMPER CIRCUIT BOARD	1
01164	BEARING SLEEVE	1	03723	POTENTIOMETER ASSY.	1
01165	RETAINING RING	2	03857	SCR-HEX HEAD #4-40	4
01167	GROMMET	1	03868	PAN-SCREW	4
01168	DOWEL PIN .125	2	03880	PILOT LIGHT ASSY.	1
01169	DOWEL PIN .1252 X .38	2	03884	CIRCUIT BOARD REPLAC.	1
01171	NUT HEX 3/8-32	1	03931	CONTROL PANEL ASSY.	1
01172	PUSH BUTTON SWITCH	1	03937	CIRCUIT BD. ASSY REPLAC.	1
01173	SCREW LOW SOC HEAD	6	03995	VIBRATION MOUNT	4
01175	ROLL PIN	1	04204	MOTOR CORD (3WIRE)	1
01176	ROLL PIN	3	04308	FIELD ASSY. 115V (3 WIRE)	1
01179	"O" RING	1	04309	REP. MOTOR CORD (3 WIRE)	1
01180	HELI LOCKWASHER #8	6	10513	ARBOR SPRING	1
01181	SLEEVE BEARING	1	10517	RETAINING RING	2
01189	MAGNET ASSEMBLY	1	10567	JAMB NUT	1
01224	SWITCH LOCKING RING	1	10569	FEED HANDLE	3
01225	P/F CIRC BOARD SPACER	2	10570	KNOB	3
01226	PUSHBUTTON GUARD	1	10618	S/S COMP. SPRING	1
01227	SWITCH SEAL GREY/BLK	2	10619	SPRING	1
01228	SWITCH SEAL RED	2	10632	RETAINING RING	1
01251	P/F MOTOR ASSY.	1	10638	S/S BEARING ASSY.	1
01252	KNOB SCREW 1/4-20 X 3/4	1	10644	GLIDE POST	2
01253	LEVER HANDLE ASSY.	1	10648	SCREW S/H #10-32- 1/2	3
01257	DRILL HOUSING ASSY.	1	10649	SCREW SHC #10-32	2
01334	SWITCH ASSY. ON	2	10661	SCREW BHC #10-24	2
01335	SWITCH ASSY. OFF	2	10681	GREASE FITTING	1
01343	P/F CONTROL BOARD 230V	1	10956	BRASS BIGS (PAIR)	1
01353	CONTROL PANEL ASSY. 230V	1	10960	PLUNGER BODY	1
01376	MAGNET ASSY 230V	1	10961	SLIDE HAMMER	1

# Parts Listing

PART NO.	DESCRIPTION	QTY. REQ'D.	Part No.	Description	Qty. Req'd.
10962	IMPACTOR	1	40419	TAB-RET RIGHT	1
10966	DUST CAP	1	40420	TAB-RET LEFT	1
10967	M/S MOUNT SPRING	1	40422	CLAMP HOSE 6"	1
10968	M/S ADJUST SPRING	1	40424	FINGER ANTI-ROTATE	1
10969	M/S ADJUST SCREW	1	40429	NUT LOCKING 1/8 NPT	1
10970	S/S ADJUST BRACKET	1	40433	CAP ASSEMBLY	1
10971	SCREW SHC 1/4-20 X 1/2	2	40439	TUBE CUTTING FLUID	1
10972	SCREW B/H #6-32 X 7/8	2	40442	COOLANT BOTTLE ASSY	1
10973	NYLON NUT #6-32	2	40452	3/8" BOLT KIT FSB	1
10974	RET RING	1	40464	GROUND STRAP	1
10975	PIVOT POINT SEAL	1	40465	1/4-20 X 1/2 BOLT	1
10977	BHS 1/4-20	1	40650	MOTOR REPLAC. 230V	1
10978	BHS 5/16-24 X 3/8	1	50035	WASHER LOCK 1/4" INT	2
10979	GLIDE POST LOCK SCREW	2	50038	HELI LOCK WASHER	3
10983	M/S INSULATING SHIELD	1	51042	SCREW SHC 1/4-20 X 3/8	2
10990	MICROSWITCH ASSY.	1	90027	FLAT WASHER 1/4	1
10993	S/S PIVOT ASSY	1	90028	HELI LOCK WASHER	6
40020	THRUST RACE	8	90052	LOCK WASHER EXT #6	2
40221	SPRING SEAT	1	90065	1/4" STAR WASHER	2
40222	SET SCR 7/16-14	2	90352	SCREW SHC 1/4-28 X 1	4
40223	EJECTOR COLLAR	1	90356	#10 INT WASHER	3
40225	STEEL GIB	1			
40227	ARBOR BODY	1			
40229	FEED GEAR	1			
40230	GEAR RACK	1			
40231	BRONZE BUSHING	2			
40234	THRUST WASHER	2			
40237	SET SCR 1/4-28 X 1/2 DOG	5			
40250	SPACER 1" FSB	1			
40253	REPLAC. MOTOR (2) WIRE	1			
40255	WARNING TAG	1			
40256	SET SCR 5/16-18 X 3/8	1			
40294	MOTOR MOUNT SLIDE	1			
40295	INDUCER RING	1			
40297	SCR BHC #6-32 X 1/2	4			
40299	SPACER 3/4" BLOCK	1			
40300	"O" RING	2			
40301	THRUST WASHER	2			
40302	RETAINING RING	2			
40303	FITTING	1			
40309	CORD CLAMP	1			
40312	ROLL PIN	1			
40326	CUTTING FLUID VALVE	1			
40332	INDUCER ASSY.	1			
40333	BRASS INSERT	1			
40338	FERRULE FOR 1/4" OD	1			
40374	HEX NUT #6-32	1			
40390	HEX BOLTS 1/4-20 X 1"	3			
40391	WASHER LOCK 3/8"	2			
40392	WASHER FLAT 3/8"	2			
40398	RETAINING RING	1			
40417	COOLANT BOTTLE	1			
40418	FRONT SUPPORT BRACKET	1			