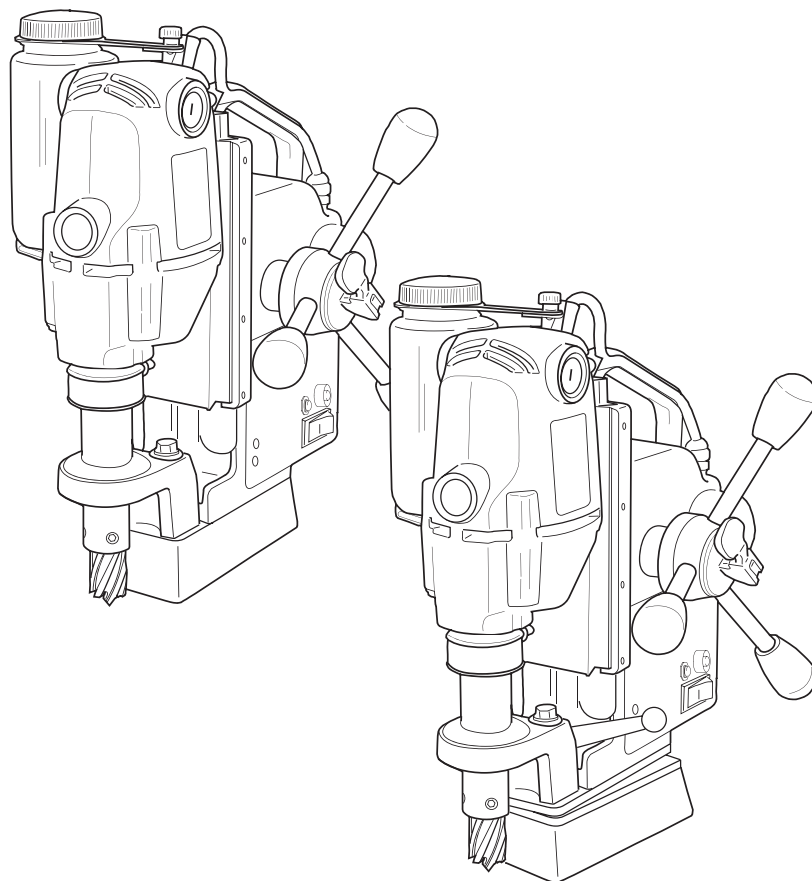




HMD925 SERIES POWER FEED MAGNETIC DRILL

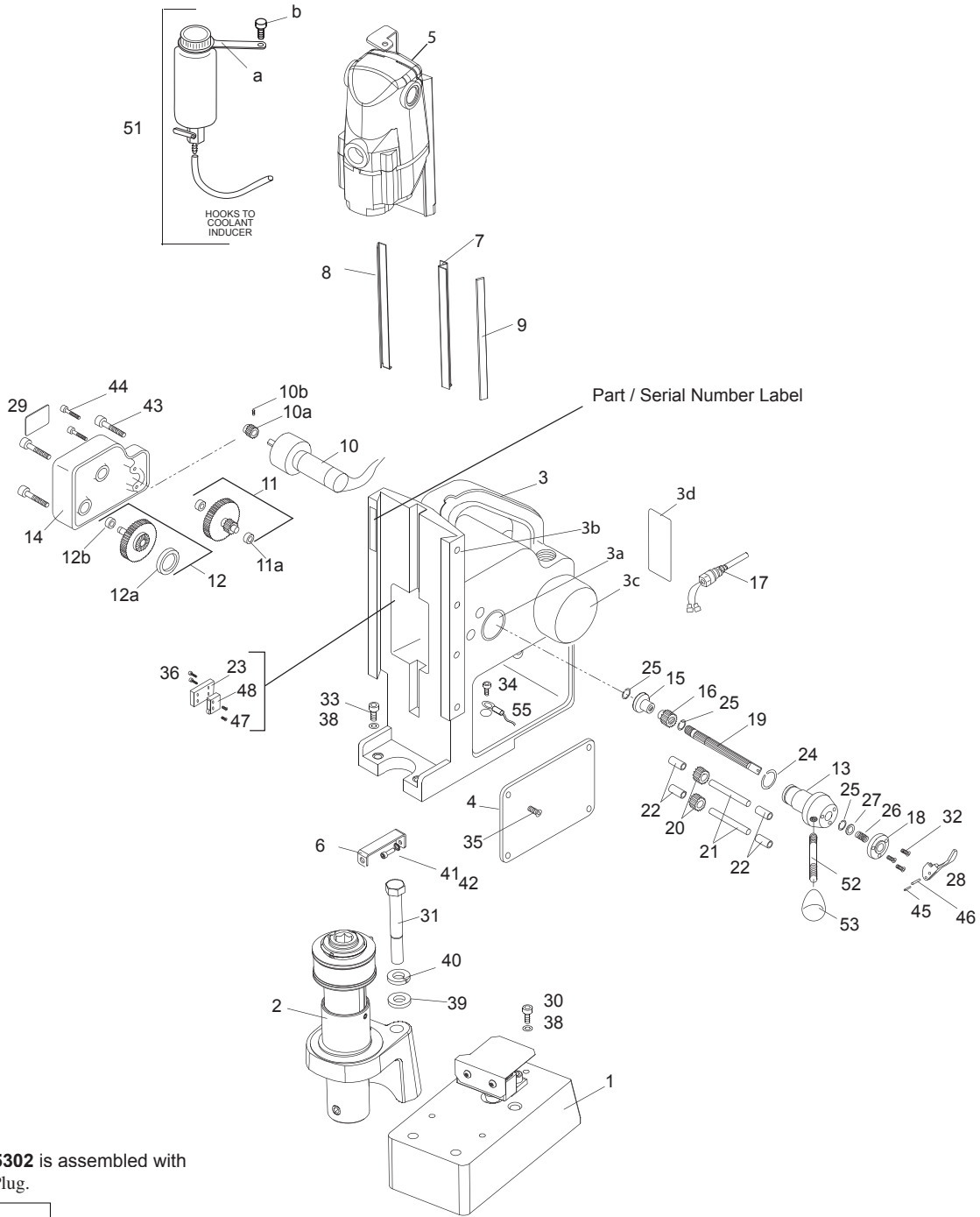
OPERATOR'S MANUAL

COVER DRILL PART NUMBERS 0925104, 0925202, 0925204,
0925302, 0925304, 0925402 & 0925404

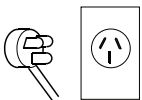


FOR USE WITH "12,000-SERIES" HOUGEN[®] CUTTERS

0925202 HMD925 230v Power Feed with Coolant
0925302 HMD925 230v, Power Feed with Coolant, Type I Plug
0925402 HMD925 230v, Power Feed with Coolant, No Plug



The **0925302** is assembled with a Type I Plug.



The **0925402** is assembled without an electrical plug at the end of the power cord.

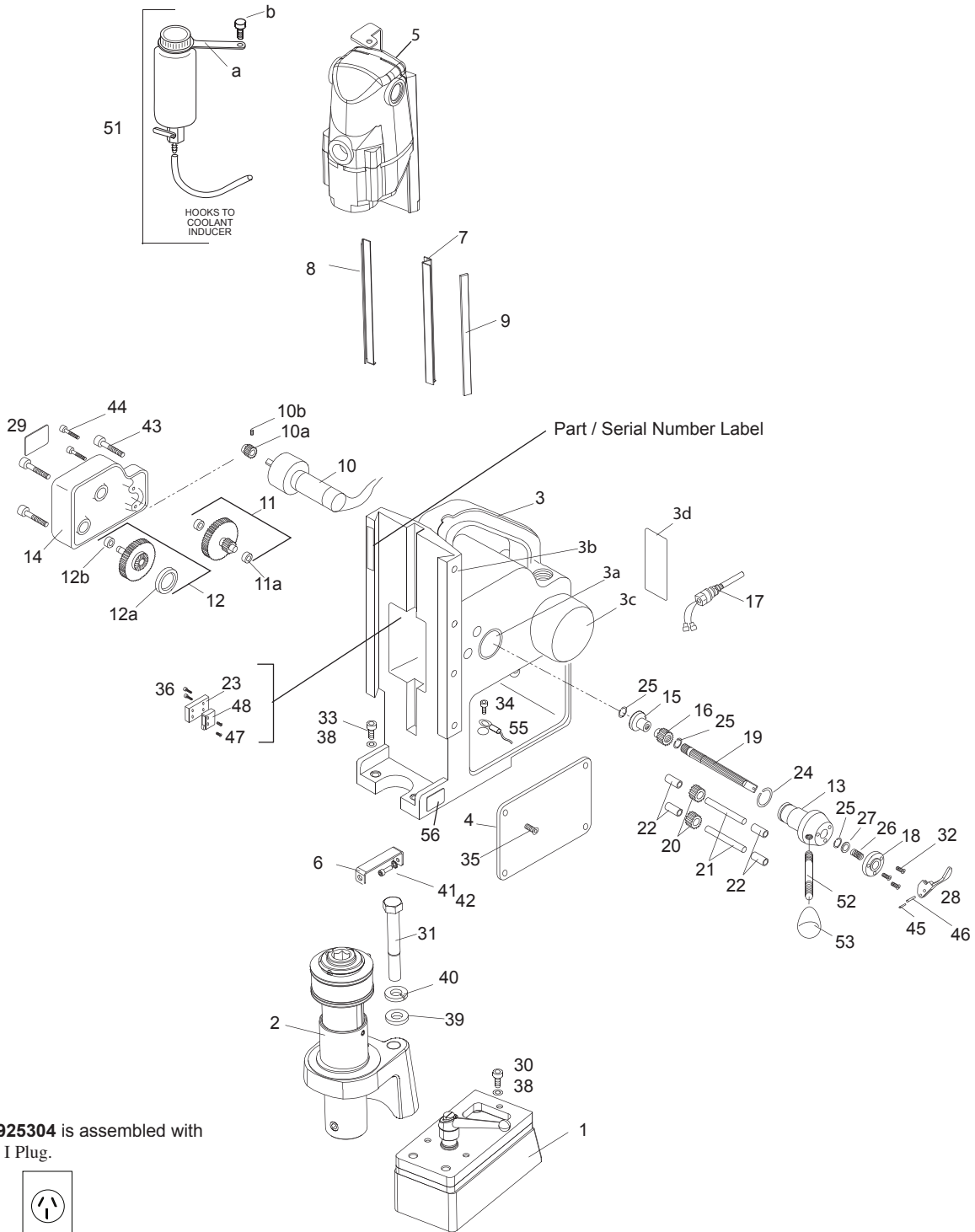
0925202, 0925302 & 0925402 Parts List

Item	Part #	Description	Qty	Item	Part #	Description	Qty
1	*05392	Magnet & Switch Assembly 230v	1	23	19018	Travel Switch Block	1
2	*07155	Arbor & Front Support Bracket Assembly	1	24	10836	Retain. Ring	1
3	19036	Housing Assembly 230v (includes 3a-3d)	1	25	01165	Retain. Ring 1/2 Shaft	3
3a	05108	Bronze Bearing	2	26	05114	Spring	1
3b	40237	Set Screw 1/4-28 X 1/2	4	27	05115	Flat Washer	1
3c	19024	Engagement Label	1	28	19040	Handle Lever	1
3d	19022	Safety Label Instructions 230v	1	29	19021	Motor Label	1
4	*19043	Control Panel Assembly 230v	1	30	40077	Screw SHC 1/4-20 X 1	1
5	*07219	Motor / Slide Assembly 230v 0925202 & 0925402	1	31	02460	Hex Bolt 3/8-24 X 2-3/4	2
	*07182	Motor / Slide Assembly 230v 0925302					
6	07163	Coolant Inducer Bracket	1	32	90077	Screw BHC #10-32 X 1/2	3
7	02429	Right Hand Brass Gib	1	33	10553	Screw SHC 1/4-20 X 7/8	2
8	02430	Left Hand Brass Gib	1	34	10648	Screw SHC #10-32 X 1/2	1
9	02431	Steel Gib	1	35	41044	Screw BHC #10-32 X 3/8	4
10	19026	Feed Motor Assembly (includes 10a-10b)	1	36	05203	Screw SHCS #8-32 X 3/4	2
10a	19027	Motor Gear	1	38	90028	Lock Washer 1/4	3
10b	02217	Set Screw #8-32 X .18	1	39	40392	Flat Washer 3/8	2
11	19028	Gear #1 Assembly	1	40	40391	Lock Washer	2
11a	24100	Ball Bearing	3	41	40038	Screw SHC #10-32 X 5/8	1
12	19029	Gear Shaft Clutch Assembly (includes 12a - 12b)	1	42	10560	Lock Washer	1
12a	05107	Ball Bearing 35mm X 47mm X 7mm	1	43	41048	Screw SHC #10-32 X 1-1/2	4
12b	24100	Ball Bearing	1	44	51044	Screw SHC #10-32 X 1-1/4	2
13	19030	Feed Hub w/Spline Assembly	1	45	02902	Roll Pin 1/8 X 5/8	1
14	19004	Gear Box Assembly	1	46	40277	Dowel Pin 3/16 X 5/8	1
15	19005	Clutch Drive	1	47	05187	Screw SHC #2-56 X 1/2	2
16	19008	Gear w/Spline	1	48	19042	Limit Switch	1
17	07299	Power Cord Assembly 230v	1	49	19022	Safety Instruction Label	1
	04495	Power Cord Assembly 230v Type I	1	50	05207	Jumper Wire	1
18	19010	Hub Plate	1	51	*05060	Coolant Bottle Assembly	1
19	19013	Spline Shaft	1	a	05059	Coolant Bottle Holder	1
20	19016	20 Tooth Gear	2	b	05061	Thumb Screw	1
21	19017	.4375 Diam. Shaft	2	52	04558	Feed Handle .50 X 4.50	3
22	19020	Gear Spacer	4	53	04532	Oval Knob	3

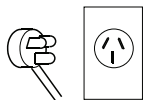
* SEE FOLLOWING PAGES FOR ASSEMBLY BREAKDOWNS

The **07299** is assembled with a standard U.S.A 230v Plug at the end of the Power Cord. When installing this Power Cord into a 0925402, the plug will need to be changed.

0925104 HMD925 115v Power Feed with Coolant & Swivel Base
0925204 HMD925, 230v Power Feed with Coolant & Swivel Base
0925304 HMD925, 230v ,Power Feed with Coolant & Swivel Base, Type I Plug
0925404 HMD925, 230v, Power Feed with Coolant & Swivel Base, No Plug



The **0925304** is assembled with a Type I Plug.



The **0925404** is assembled without an electrical plug at the end of the power cord.

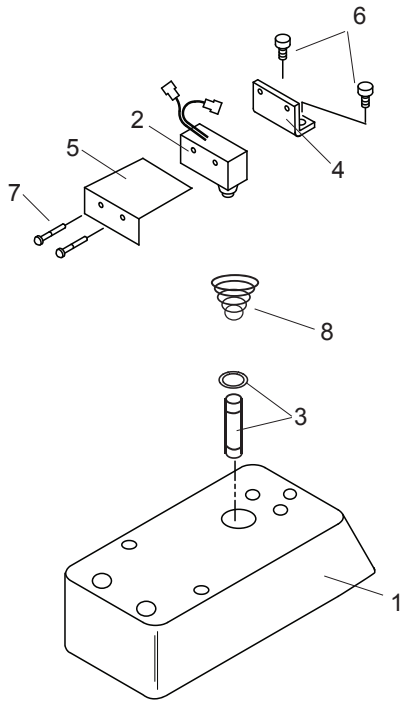
0925104, 0925204, 0925304 & 0925404 Parts List

Item	Part #	Description	Qty	Item	Part #	Description	Qty
1	*05648	Magnet & Switch Assembly 120v	1	22	19020	Gear Spacer	4
	*05894	Magnet & Switch Assembly 240v	1	23	07070	Travel Switch Block	1
2	*07156	Arbor & Front Support Bracket Assembly	1	24	10836	Retain. Ring	1
3	19036	Housing Assembly (includes 3a-3d)	1	25	01165	Retain. Ring 1/2 Shaft	3
3a	05108	Bronze Bearing	2	26	05114	Spring	1
3b	40237	Set Screw 1/4-28 X 1/2	4	27	05115	Flat Washer	1
3c	19024	Engagement Label	1	28	19040	Handle Lever	1
3d	19022	Safety Label Instructions	1	29	19021	Motor Label	1
4	*19037	Control Panel Assembly 115v	1	30	40077	Screw SHC 1/4-20 X 1	1
	*19043	Control Panel Assembly 230v	1	31	05736	Hex Bolt 3/8-24 X 2	2
5	*07218	Motor Slide Assembly 115v	1	32	90077	Screw BHC #10-32 X 1/2	3
	*07220	Motor Slide Assembly 230v	1	33	10553	Screw SHC 1/4-20 X 7/8	2
6	07163	Coolant Inducer Bracket	1	34	10648	Screw SHC #10-32 X 1/2	1
7	02429	Right Hand Brass Gib	1	35	41044	Screw BHC #10-32 X 3/8	4
8	02430	Left Hand Brass Gib	1	36	05203	Screw SHCS #8-32 X 3/4	2
9	02431	Steel Gib	1	38	90028	Lock Washer 1/4	3
10	19026	Feed Motor Assembly (includes 10a-10b)	1	39	40392	Flat Washer 3/8	2
10a	19027	Motor Gear	1	40	40391	Lock Washer	2
10b	02217	Set Screw #8-32 X .18	1	41	40038	Screw SHC #10-32 X 5/8	1
11	19028	Gear #1 Assembly	1	42	10560	Lock Washer	1
11a	24100	Ball Bearing	3	43	41048	Screw SHC #10-32 X 1-1/2	4
12	19029	Gear Shaft Clutch Assembly (includes 12a - 12b)	1	44	51044	Screw SHC #10-32 X 1-1/4	2
12a	05107	Ball Bearing 35mm X 47mm X 7mm	1	45	02902	Roll Pin 1/8 X 5/8	1
12b	24100	Ball Bearing	1	46	40277	Dowel Pin 3/16 X 5/8	1
13	19030	Feed Hub w/Spline Assembly	1	47	05187	Screw SHC #2-56 X 1/2	2
14	19004	Gear Box Assembly	1	48	19042	Limit Switch	1
15	19005	Clutch Drive	1	49	19022	Safety Instruction Label	1
16	19008	Gear w/Spline	1	50	05207	Jumper Wire	1
17	90571	Power Cord Assembly 115v	1	51	*05060	Coolant Bottle Assembly	1
	07299	Power Cord Assembly 230v	1	a	05059	Coolant Bottle Holder	1
	04495	Power Cord Assembly 230v Type I	1	b	05061	Thumb Screw	1
18	19010	Hub Plate	1	52	04558	Feed Handle .50 X 4.50	3
19	19013	Spline Shaft	1	53	04532	Oval Knob	3
20	19016	20 Tooth Gear	2	55	05207	Jumper Wire	1
21	19017	.4375 Diam. Shaft	2	56	07015	Lock / un-lock label	1

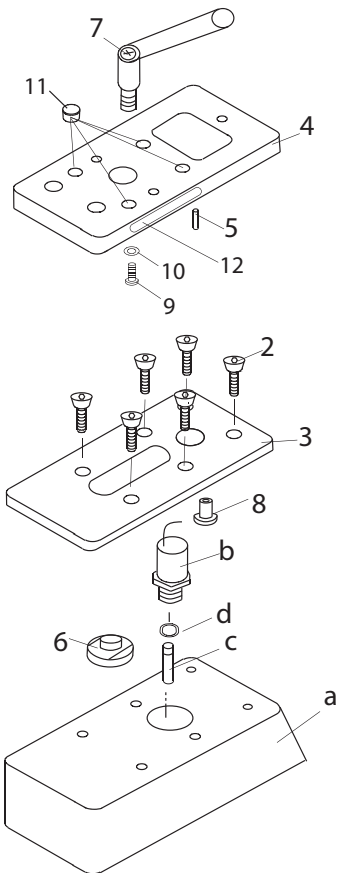
* SEE FOLLOWING PAGES FOR ASSEMBLY BREAKDOWNS

The **07299** is assembled with a standard U.S.A 230v Plug at the end of the Power Cord. When installing this Power Cord into a 0925404, the plug will need to be changed.

1150



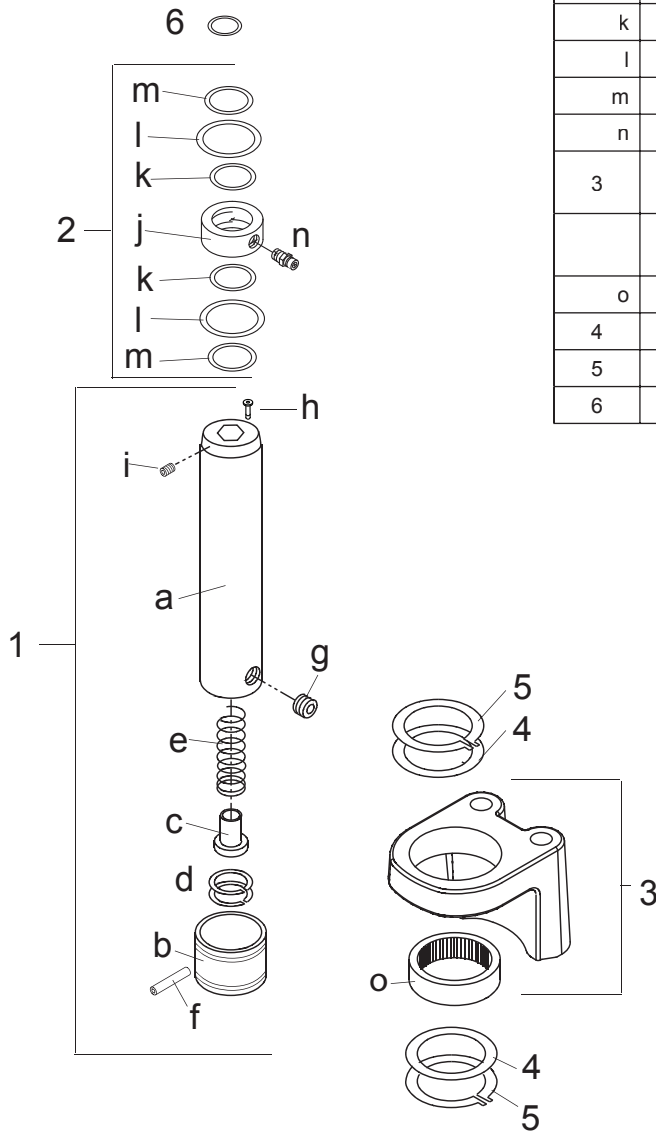
05392 Magnet Assembly 230v			
Item	Part #	Description	Qty
1	05391	Magnet Assembly 230v	1
2	04885	Safety Switch Assembly	1
3	04910	Plunger Assembly	1
4	04909	Safety Switch Bracket	1
5	10983	Micro Switch Shield	1
6	10971	Screw SHC 1/4-20 X 1/2	2
7	10972	Screw BHC #6-32 X 7/8	2
8	17271	Tapered Spring	1

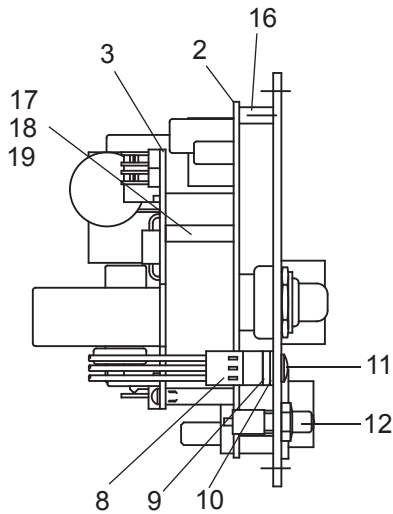
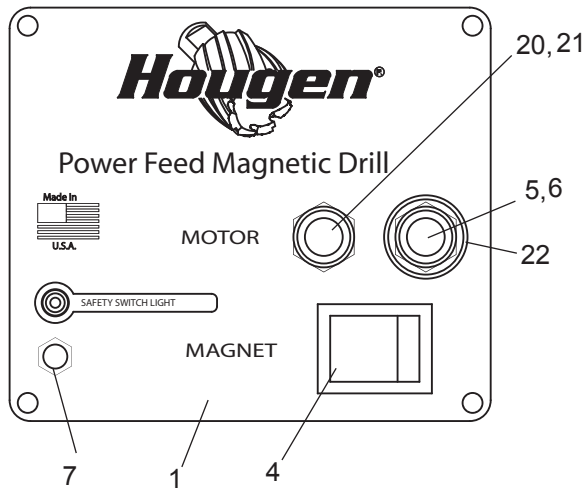


05648 Swivel Magnet Assembly 115v			
05894 Swivel Magnet Assembly 230v			
Item	Part #	Description	Qty
1	05649	Magnet/Safety Switch Assembly 115v includes a-d	1
	05895	Magnet/Safety Switch Assembly 230v includes a-d	
a	05650	Magnet Assembly 115v	1
	05896	Magnet Assembly 230v	1
b	05652	Ball Switch Assembly	1
c	05653	Plunger	1
d	05670	Retain. Ring	1
2	05743	Screw FHC 1/4-20 X 3/4	6
3	05657	Slide Housing	1
4	05656	Swivel Housing	1
5	02898	Dowel Pin	1
6	05658	Pivot Rod	1
7	05659	Clamp Handle Assembly	1
8	07215	Bushing Flange	1
9	41044	Screw BHC #10-32 X 3/8	1
10	90237	Flat Washer #10	1
11	07216	9/16 Hole Plug	4
12	07230	Safety Label	1

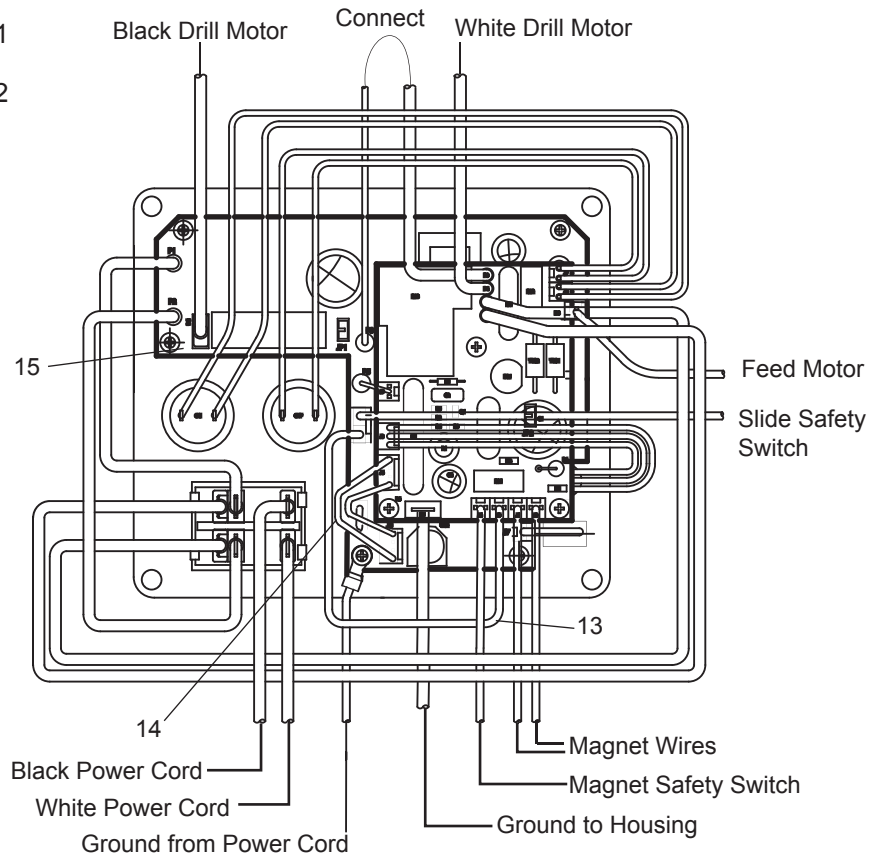
07155 Coolant Arbor Assembly
07156 Coolant / Swivel Arbor Assembly

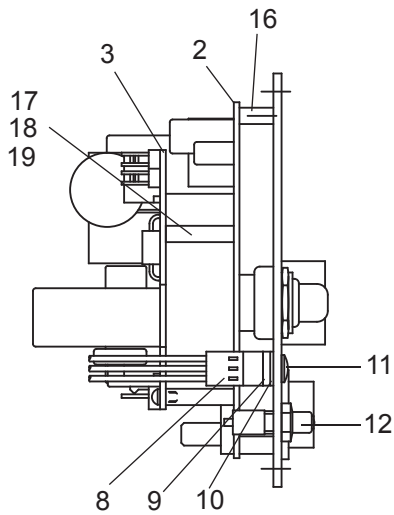
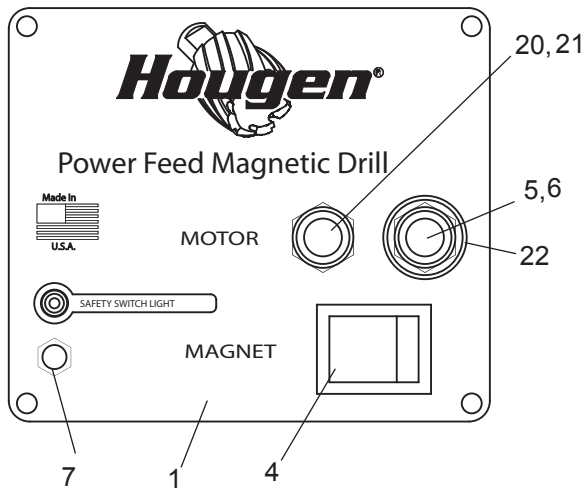
Item	Part #	Description	Qty
1	07157	Arbor & Collar Assembly	1
a	07159	Arbor Body	1
b	07162	Ejection Collar	1
c	07161	Spring Seat	1
d	10517	Retain. Ring	2
e	05049	Spring	1
f	40312	Roll Pin	1
g	10506	Set Screws 3/8-24 X .305	2
h	40344	Rivet .31 diameter	1
i	05628	Set Screw 1/4-28 X 3/8	2
2	07158	Coolant Inducer Assembly	1
j	07160	Inducer Ring	1
k	40300	O-Ring	2
l	40301	Washer	2
m	40302	Retain Ring	2
n	07080	Hose Fitting	1
3	04375	Front Support Bracket Assembly used with 07155 Assembly	1
	05734	Front Support Bracket Assembly used with 07156 Assembly	1
o	40232	Needle Bearing	1
4	40234	Thrust Washer	2
5	40398	Retain. Ring	2
6	04391	O-Ring	1



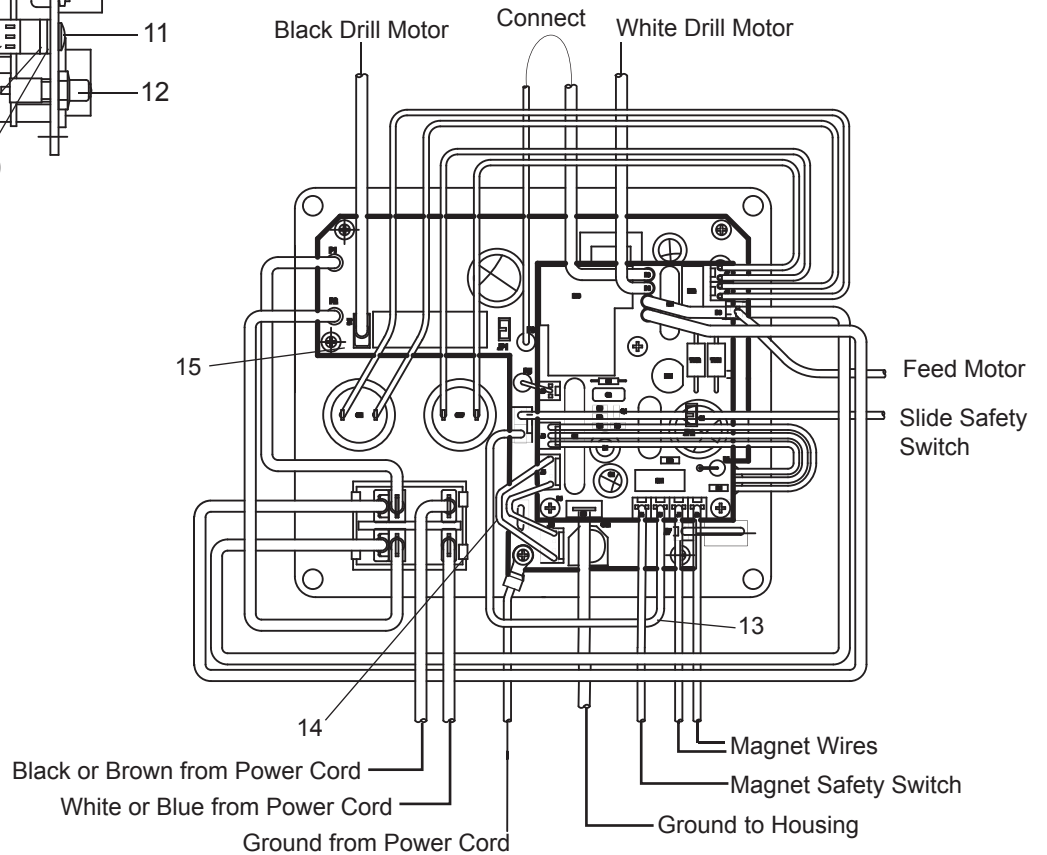


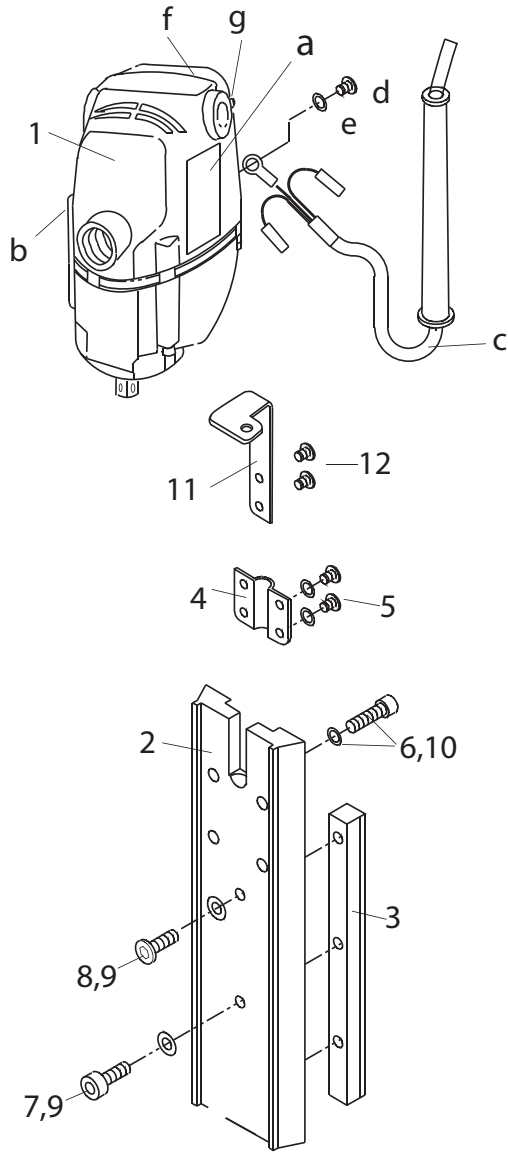
19037 115v Control Panel			
Item	Part #	Description	Qty
1	05831	Faceplate	1
2	05852	Power Feed Circuit Board	1
3	05826	Circuit Board 115v	1
4	04614	Rocker Switch	1
5	01334	Motor ON Switch	1
6	02409	Green Switch Cover	1
7	05335	Mini Toggle Switch	1
8	04877	Wire Harness	1
9	04878	L.E.D Spacer	1
10	04881	L.E.D. Bulb	1
11	04879	L.E.D Lens	1
12	05336	Toggle Switch Boot	1
13	05331	Jumper Wire J5-J3	1
14	05332	Jumper Wire J6-J5	1
15	05355	Screw #4-40 X 1/4	5
16	04891	3/8 lg. Standoff	5
17	05832	Nylon Standoff	3
18	05320	Screw #4-40 x 1	3
19	05319	Nylon Nut	3
20	01335	Motor OFF Switch	1
21	01228	Red Switch Cover	1
22	01226	Switch Guard	1





19043 230v Control Panel Assembly			
Item	Part #	Description	Qty
1	05831	Faceplate	1
2	05868	Power Feed Circuit Board	1
3	05827	Circuit Board 230v	1
4	04664	Rocker Switch	1
5	01334	Motor ON Switch	1
6	02409	Green Switch Cover	1
7	05335	Mini Toggle Switch	1
8	04877	Wire Harness	1
9	04878	L.E.D Spacer	1
10	04881	L.E.D. Bulb	1
11	04879	L.E.D Lens	1
12	05336	Toggle Switch Boot	1
13	05331	Jumper Wire J5-J3	1
14	05332	Jumper Wire J6-J5	1
15	05355	Screw #4-40 X 1/4	5
16	04891	3/8 lg. Standoff	5
17	05832	Nylon Standoff	3
18	05320	Screw #4-40 x 1	3
19	05319	Nylon Nut	3
20	01335	Motor OFF Switch	1
21	01228	Red Switch Cover	1
22	01226	Switch Guard	1

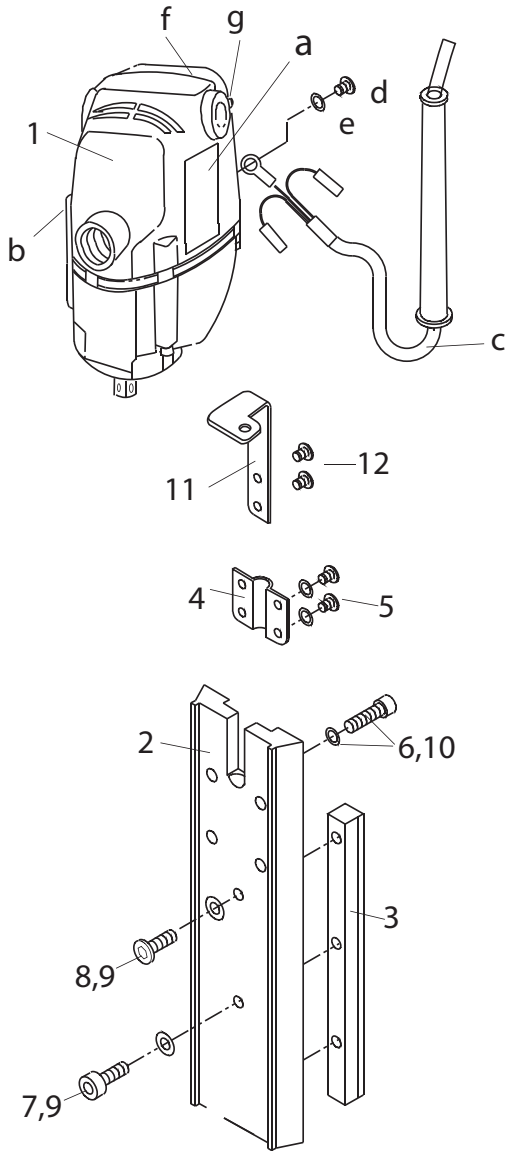




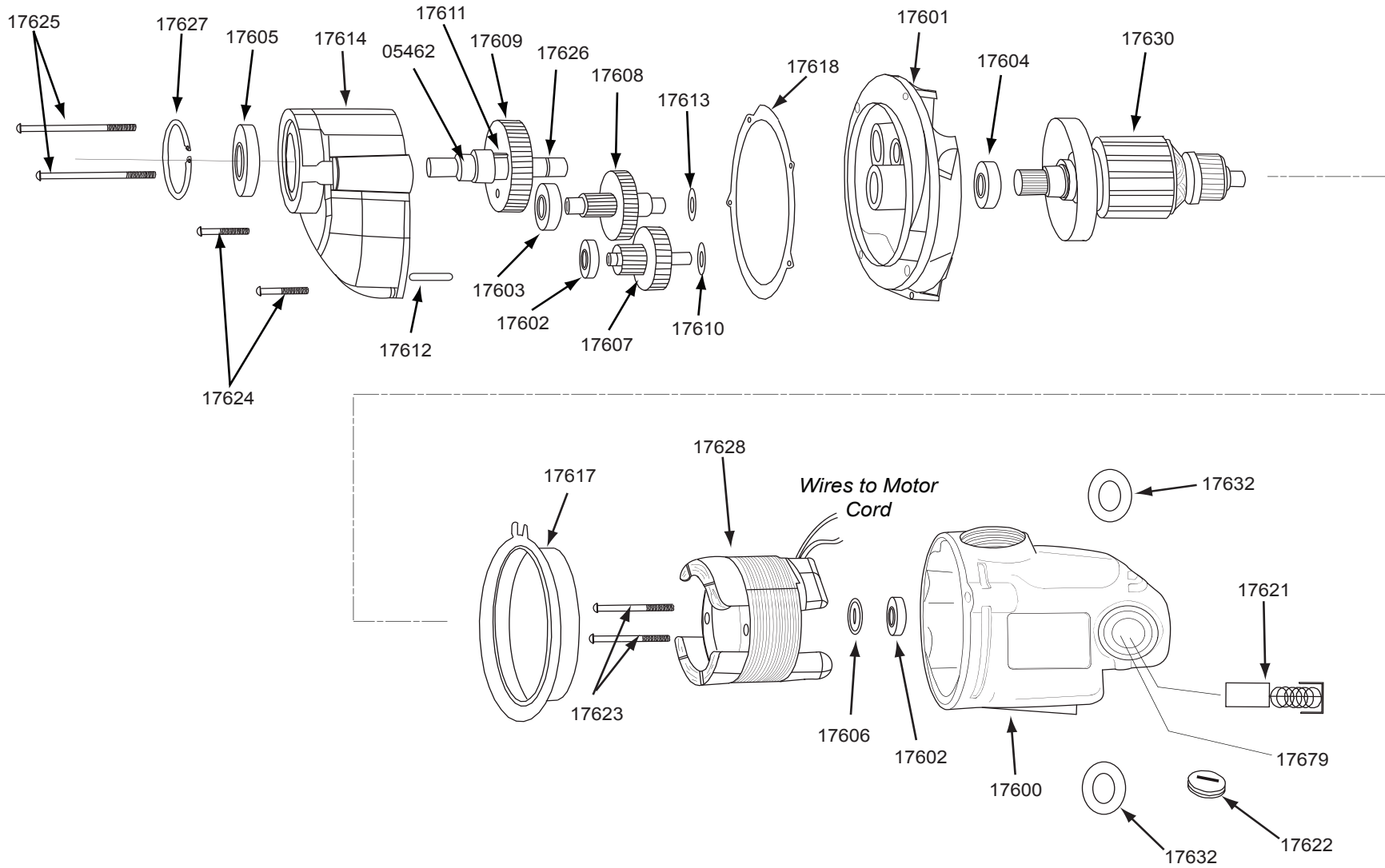
07218 115v Motor / Slide Assembly for Swivel			
Item	Part #	Description	Qty
1	05479	Motor Assembly 115v	1
a	19021	Motor Label	1
b	04528	Motor Specs Label	1
c	19033	Motor Cord	1
d	11053	Screw BHC #8-32 X 3/16	1
e	10538	#8 Washer	1
f	04502	Inspection Cover	1
g	75289	Screw M5 X 8mm	2
2	05824	Dove Tail Slide (07218 Assy.)	1
3	05825	Rack Gear (7218 Assy.)	1
4	02422	Motor Cord Bracket	1
5	41044	Screw BHC #10-32 X 3/8	2
6	75156	Screw SHC M6 X 1 X 15mm	4
7	40038	Screw SHC #10-32 X 5/8	1
8	90077	Screw BHC #10-32 X 1/2	1
9	10560	#10 Lock Washer	2
10	90028	1/4 Lock Washer	4
11	05057	Bottle Bracket	1
12	05988	Screw FHC #10-32 X 1/2	2
13	05185	1/4 X 3/8 lg.	1

07219 230v Motor / Slide Assembly
07220 230v Motor / Slide Assembly for Swivel

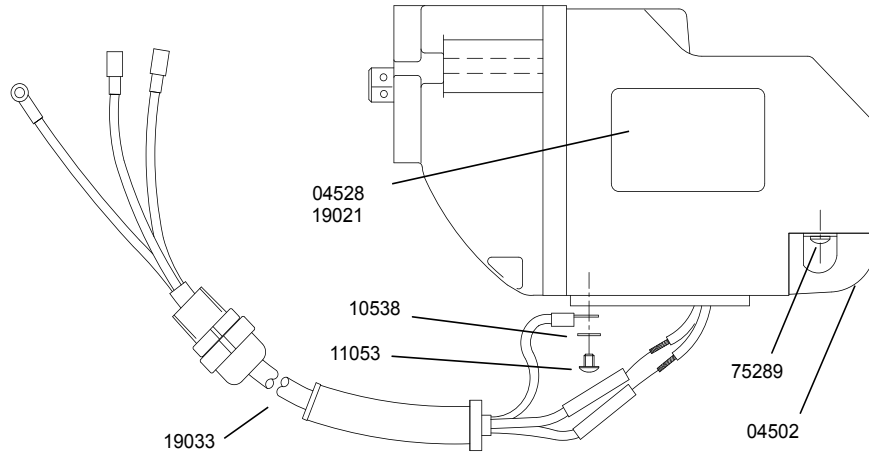
Item	Part #	Description	Qty
1	07184	Motor Assembly 240v	1
a	19021	Motor Label	1
b	04042	Motor Specs Label	1
c	19033	Motor Cord	1
d	11053	Screw BHC #8-32 X 3/16	1
e	10538	#8 Washer	1
f	04502	Inspection Cover	1
g	75289	Screw M5 X 8mm	2
2	04500	Dove Tail Slide (07219 Assy.)	1
	05824	Dove Tail Slide (07220 Assy.)	1
3	02428	Rack Gear (07182 Assy.)	1
	05825	Rack Gear (07183 Assy.)	1
4	02422	Motor Cord Bracket	1
5	41044	Screw BHC #10-32 X 3/8	2
6	75156	Screw SHC M6 X 1 X 15mm	4
7	40038	Screw SHC #10-32 X 5/8	1
8	90077	Screw BHC #10-32 X 1/2	1
9	10560	#10 Lock Washer	2
10	90028	1/4 Lock Washer	4
11	05057	Bottle Bracket	1
12	05988	Screw FHC #10-32 X 1/2	2
13	05185	1/4 X 3/8 lg.	1



115v MOTOR PARTS DIAGRAM



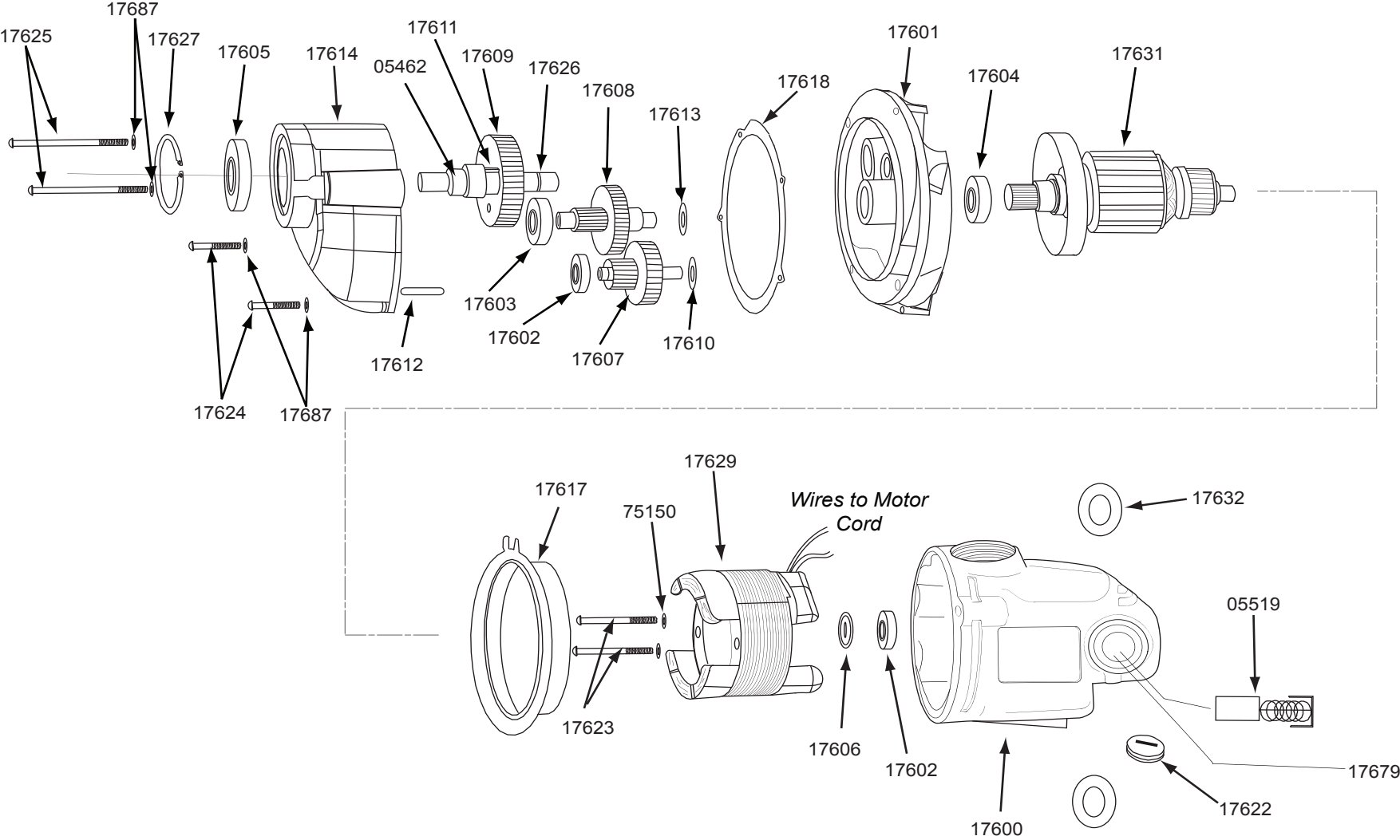
05479 115v MOTOR ASSEMBLY



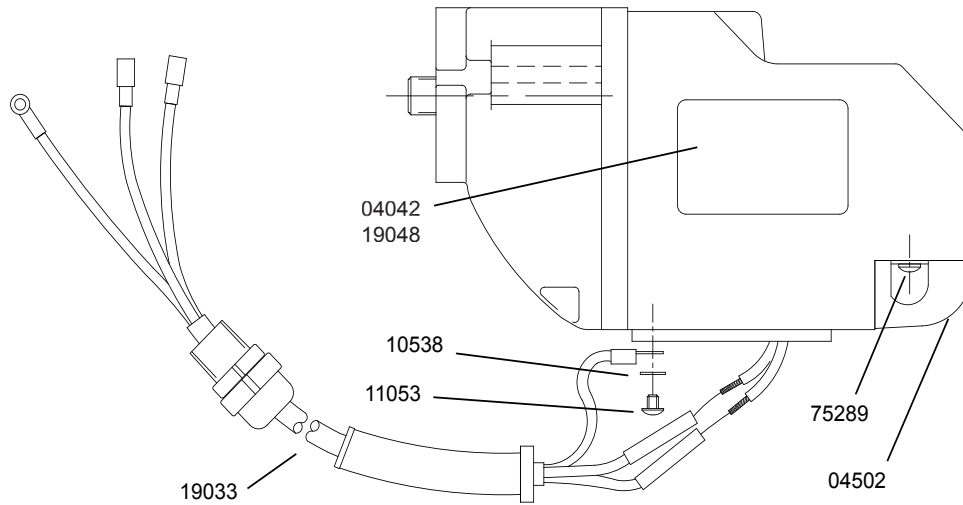
MOTOR PARTS LIST

Part #	Description	Qty	Part #	Description	Qty
04502	Brush Cover	1	17613	Flat Washer	1
04528	Label, Motor Safety	1	17614	Gear Housing	1
05462	Spindle	1	17617	Fan Guide	1
05474	Motor 115v	1	17618	Gasket	1
10538	Washer #8	1	17630	Armature	1
11053	Scew BHS #8-32	1	17628	Field	1
17600	Field Case	1	17621	Carbon Brush (Pack of 2)	1
17601	Gear Housing	1	17622	Brush Cap	2
17602	Ball Bearing	2	17623	Pan Head Screw	2
17603	Ball Bearing	1	17624	Pan Head Screw Short	2
17604	Ball Bearing	1	17625	Pan Head Screw Long	2
17605	Ball Bearing	1	17626	Retaining Ring	1
17606	Dust Seal	1	17627	Retaining Ring	1
17607	1st Inter. Gear Assy	1	17632	Paper Washer	2
17608	2nd Inter. Gear Assy	1	17679	Brush Holder	2
17609	Spur Gear	1	19021	Label, Motor	1
17610	Flat Washer	1	19033	Motor Cord	1
17611	Key	1	75289	Pan Head Screw	2
17612	Dowel Pin	1			

230v MOTOR PARTS DIAGRAM



07184 230v MOTOR ASSEMBLY



MOTOR PARTS LIST

Part #	Description	Qty	Part #	Description	Qty
04042	Label, Motor Safety	1	17612	Dowel Pin	1
04502	Brush Cover	1	17613	Flat Washer	1
05462	Hex Spindle	1	17614	Gear Housing	1
05475	240v Motor	1	17616	Spindle	1
05519	Carbon Brush 240v	2	17617	Fan Guide	1
10538	Washer #8	1	17618	Gasket	1
11053	Screw BHS #8-32	1	17622	Brush Cap	2
17600	Field Case	1	17623	Pan Head Screw	2
17601	Gear Housing	1	17624	Pan Head Screw Short	2
17602	Ball Bearing	2	17625	Pan Head Screw Long	2
17603	Ball Bearing	1	17626	Retaining Ring	1
17604	Ball Bearing	1	17627	Retaining Ring	1
17605	Ball Bearing	1	17629	Field	1
17606	Dust Seal	1	17631	Armature	1
17607	1st Inter. Gear Assy	1	17632	Paper Washer	2
17608	2nd Inter. Gear Assy	1	17679	Brush Holder	2
17609	Spur Gear	1	19033	Motor Cord	1
17610	Flat Washer	1	19048	Label, Motor	1
17611	Key	1	75289	Pan Head Screw	2