

# Slugger™ Holemaker

Holemaker 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 110V-#19040  
MODEL 220V-#19044

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

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

# Holemaker 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 twelve (12) months 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 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. Keep Work Area Clean**
  - Cluttered areas and benches invite injuries.
- 2. Consider Work Area Environment**
  - Do not expose power tools to rain.
  - Do not use power tools in damp or wet locations.
  - Keep work area well lit.
  - Do not use tool in presence of flammable liquids or gases.
- 3. Guard Against Electric Shock**
  - Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges and refrigerator enclosures.
- 4. Keep Children Away**
  - Do not let visitors contact tool or extension cord.
  - All visitors should be kept away from work area.
- 5. Store Idle Tools**
  - When not in use, tools should be stored in a dry, high and locked-up place, out of reach of children.
- 6. Do Not Force Tool**
  - It will do the job better and safer at the rate for which it was intended.
- 7. Use Right Tool**
  - Do not force a small tool or attachment to do the job of a heavy-duty tool.
  - Do not use tool for unintended purpose.
- 8. Dress Properly**
  - Do not wear loose clothing or jewelry. They can be caught in moving parts.
  - Rubber gloves and non-skid footwear are recommended when working outdoors.
  - Wear protective hair covering to contain long hair.
- 9. Use Safety Glasses**
  - Also use face or dust mask if cutting operation is dusty.
- 10. Do Not Abuse Electrical Cord**
  - Never carry tool by cord or yank it to disconnect from receptacle.
  - Keep cord from heat, oil and sharp edges.
- 11. 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.
- 12. Do Not Overreach**
  - Keep proper footing and balance at all times.

## IMPORTANT SAFETY INSTRUCTIONS

### **13. Maintain Tools With Care**

- Keep tools sharp and clean for better and safer performance.
- Follow instructions for lubricating and changing accessories.
- Inspect tool cords periodically and if damaged, have repaired by authorized service facility.
- Inspect extension cords periodically and replace if damaged.
- Keep handles dry, clean, and free from oil and grease.

### **14. Disconnect Tools**

- Unplug when not in use, before servicing, and when changing accessories, such as blades, bits and cutters.

### **15. Remove Adjusting Keys And Wrenches**

- Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

### **16. Avoid Unintentional Starting**

- Do not carry a plugged-in tool. Always disconnect from power source before moving.
- Be sure switches are off before connecting to a power source.

### **17. Outdoor Use Extension Cords**

- When tool is used outdoors, use only extension cords intended for use outdoors and so marked.

### **18. Stay Alert**

- Watch what you are doing. Use common sense. Do not operate tool when you are tired.
- Do not use when taking medications that may cause drowsiness.

### **19. Check Damaged Parts**

- Before further use of the tool, a guard or other part that is damaged should be repaired and performance verified prior to operation.
- 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.
- Do not use this tool if switches do not turn it on and off. Have defective switches replaced by authorized service center.

## 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 Holesetter 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. If in doubt of proper grounding, call a qualified electrician.

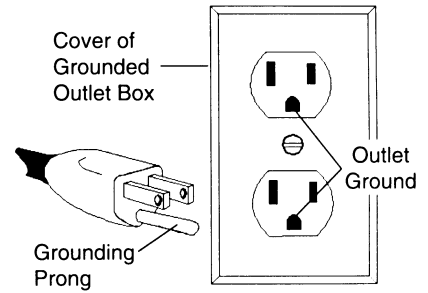


Fig. A

### **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. See table for the correct size to use depending on cord length and nameplate amperage rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

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

**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 C.

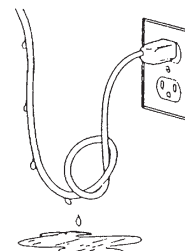


Fig. C

## SPECIAL INSTRUCTIONS

1. Read and follow operator's manual thoroughly. If you cannot locate your operator's manual, contact Jancy Engineering for an additional FREE copy.
2. DO NOT touch rotating cutter or parts.
3. Always stop machine completely and unplug from power source before changing cutters, cleaning clips, refilling lubrication or performing adjustments.
4. Never wear loose clothing or gloves when working near cutting area or machine arbor.
5. Always wear eye protection. Any tool can shatter.
6. Always use safety chain or strap provided with machine.
7. Always use proper tooling. Keep cutters securely fastened.
8. DO NOT use dull or broken cutters.
9. Beware of ejected slugs at end of cut. They become HOT during the cut.
10. Keep all safety features functioning and working properly.
11. Keep bottom of magnet burr free and clear of chips and debris.
12. To reduce the risk of electrical shock, DO NOT remove or alter electrical panels or use machine in damp areas.
13. Use only authorized service centers for repairs.

## OPERATING INSTRUCTIONS (BEFORE YOU BEGIN)

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

DESCRIPTION	PART #	QTY
METAL TOOL BOX	080801	1
SAFETY STRAP WITH CLIP	06798	1
SSS M8 X 8	0070541	1
HEX WRENCH 4MM	0070587	1
HEX WRENCH 3MM	0070586	1
HEX WRENCH 2.5MM	080806	1
PILOT, 1" SMALL	16001	1
PILOT, 2" SMALL	16002	1
PILOT, 1" (1/4")	16003	1
PILOT, 2"	16004	1
WRENCH, 8MM COMBINATION	0151219	1
OPERATORS MANUAL	LIT111	1
SPOKE HANDLE WITH KNOBS	080407	3

## CAUTION!

**BE SURE YOUR HOLEMAKER IS DISCONNECTED FROM THE POWER SOURCE BEFORE MAKING ADJUSTMENTS.**

1. Assemble (3) spoke handles #080407 to the Holemaker pinion shaft #080401. NOTE: Pinion assembly is mounted on the right side of the machine frame. If necessary, it can be reversed to operate from the left side of the frame. Simply remove the screw #080404 from the left edge of the pinion. Remove pinion #080401 from the right side of the frame and insert it in to the left side of the frame. Replace flat washer #080405 and screw #080404 (tighten securely).
2. To install coolant bottle assembly, slide bracket (on coolant bottle assembly) onto the two retaining screws #08073 located on the left side of the drill. Install the hose connector in to the hose fitting on the side of the coolant ring.

## 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 Jancy cutting tools.
2. Remove any excessive mill scale or rust from surface to be drilled.
3. When drilling thin materials, Jancy recommends placing a steel plate under the work piece and Holemaker magnet area to increase magnetic holding force.
4. Material that has been flame cut may become heat treated and therefore difficult to drill. Avoid drilling near such areas whenever possible.
5. Special cutter lubricant are available for using the Holemaker and annular cutters in the horizontal position. Consult your distributor for more information.



**Caution:** Do not drill on material where welding is also simultaneously being performed. Drilling machine will be damaged.



**Caution:** Powering drilling machine from generator without proper surge protection device between generator and drilling machine may cause damage to Printed Circuit Board in machine.

## READY TO MAKE THE CUT

1. Insert the annular cutter in to the machine arbor, lining up the flats on the cutter shank drive with the set screws on the arbor. Secure the set screws making sure the screws are recessed in arbor body. The surface you are working on should be clean and level, free from rust, scale, dirt and chips.
2. Fill coolant reservoir with a water-soluble coolant.
3. Position the Holemaker on the work piece.
4. Lower cutter/drill to surface of material. When using cutter tool holder, coolant flow starts when pilot pin is depressed. Lifting pilot pin off work surface will stop coolant flow.
5. Place the drilling machine on the work piece, with pilot pin over the center of the hole to be cut.
6. Move the rocker switch located on the panel to the ON position. The switch will illuminate to indicate DC power is going to the magnet.
7. Depress motor ON switch to start drill.
8. To start a cut, apply pressure until the cutter has established an external groove. Then apply steady pressure through the remainder of the cut (Note: Do not peck drill when using annular cutters). The tools are designed to evacuate chips when drilling.
9. Position chip guard toward work area before drilling.

## AFTER THE CUT

1. After the cut has finished, the slug should be expelled on the down stroke. If the slug is not expelled after the cut, disconnect the machine from the power source and remove the cutter from the arbor body, then expel the slug. (Caution: The pilot should not be used to do this).
2. After the cut is finished, return motor to the full upright position, depress motor OFF button and wait until motor fully stops. Move magnet switch to the OFF position to release the magnetic base from the material.

## REGULAR MAINTENANCE

1. The motor slide may become loose and require adjustment after the machine has been in use for the first few weeks. Wrenches are provided in the tool kit for this adjustment. Loosen the (4) locking nuts #080102; bring the motor slide into the full down position. Using hex key, equally tighten (4) adjustment screws #080103, working from the center frame position to top and bottom. Proper adjustment would mean the 3-spoke handle controlling the motor slide should stay in whatever position you bring it in to (no drifting down off the slide). When all (4) screws have been adjusted, tighten (4)-locking nuts to maintain adjustment. This adjustment should be required very infrequently because of the precision of the machine.
2. The motor slides #080107N & #080108N are made of brass; they should be protected from contamination and periodically lubricated with good multi-purpose grease.
3. The motor slides and slide plate #080109N should be inspected and replaced if they have become worn, or damaged in any way.
4. Keep the magnet clean and free of chips, oil or other contaminants.
5. Inspect arbor, sleeve and support bracket for visible wear.
6. The cutting speed should be kept in such a way as not to cause any substantial decrease in motor speed.
7. Non-coolant cutting is not recommended, but if such a case occurs the co-acting parts of arbor #080507A should be lubricated from time to time with good multi-purpose grease.
8. Inspect motor brushes and replace after extended periods of machine usage.
9. Replace any worn parts and tighten fasteners that become loose during daily usage.



## 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.
- Does size of cutter exceed machine's rated capacity?
- Check magnet face for unevenness, nicks and burrs.
- Is welding equipment connected to material being drilled?

### 2. Drill motor running, arbor and spindle not turning

- Possible sheared drive train component.

### 3. Motor slows when drilling

- Is an extension cord being used? If so, see page 5 for recommended wire gages and cord lengths.
- Excessive downfeed pressure during drilling cycle will cause motor to slow and overheat.
- Does cutting tool need to be resharpened?

### 4. Coolant system not working

- Coolant system is gravity dependent, machine must be in a upright position to operate properly.
- Dirt or debris in coolant tank.
- Consistency of coolant mixture too thick.
- Is correct pilot pin being used?
- Vent hole in coolant tank lid blocked.

### 5. Slugs not ejecting from cutter

- Lack of coolant causing slugs to expand in cutter bore.
- Is correct pilot pin being used?
- Possible broken internal arbor parts.

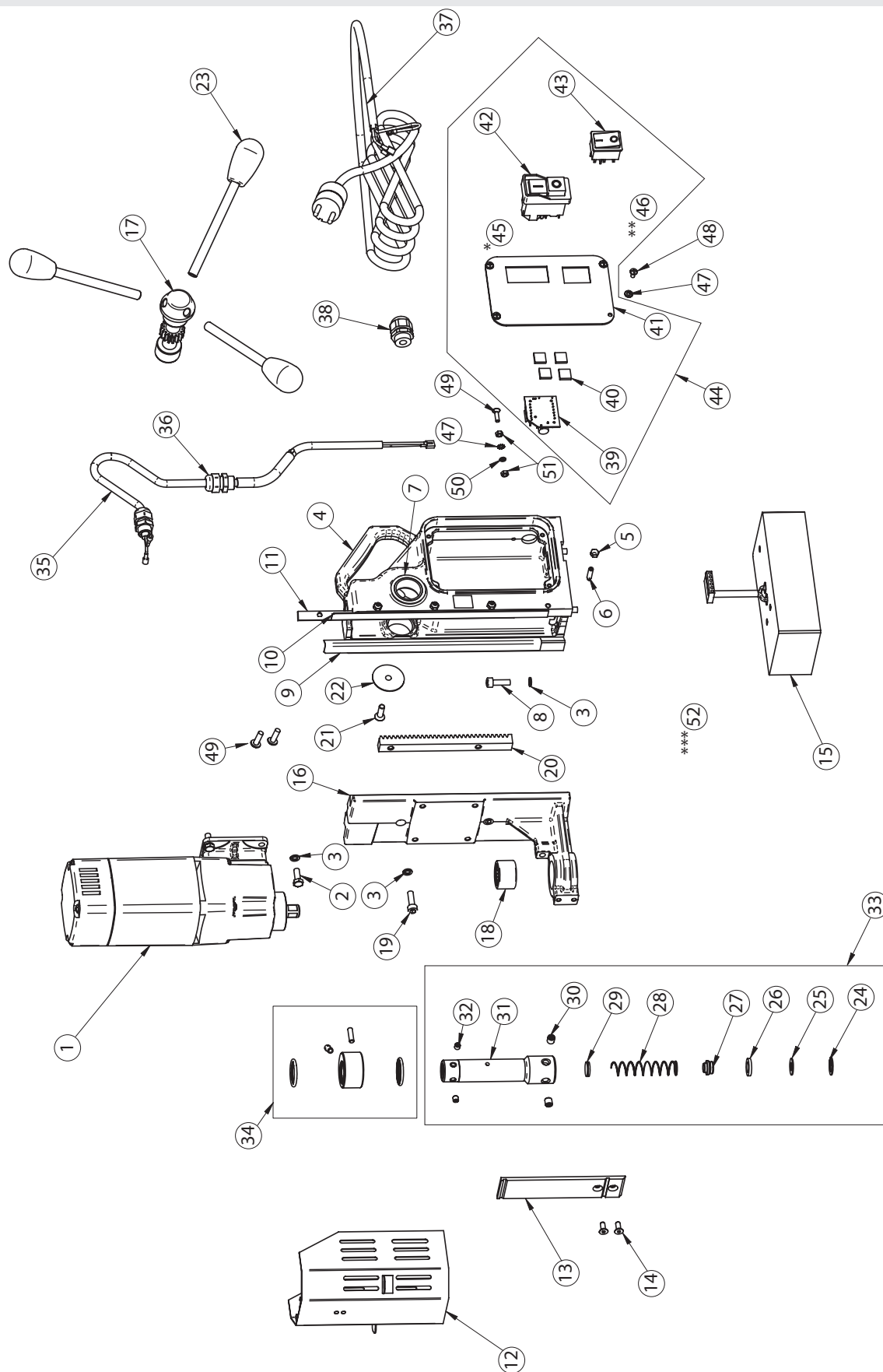
### 6. Breaking cutters

- How is coolant being applied? 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 8.

### 7. Oversized or rough holes

- Insufficient coolant.
- Excessive feed pressure.
- Dull cutter.

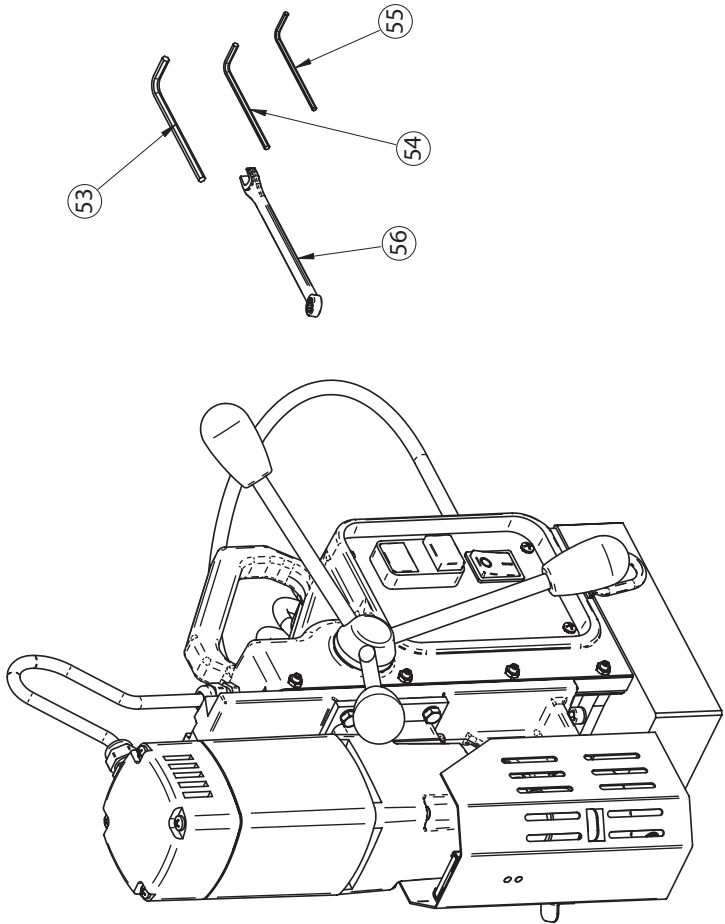
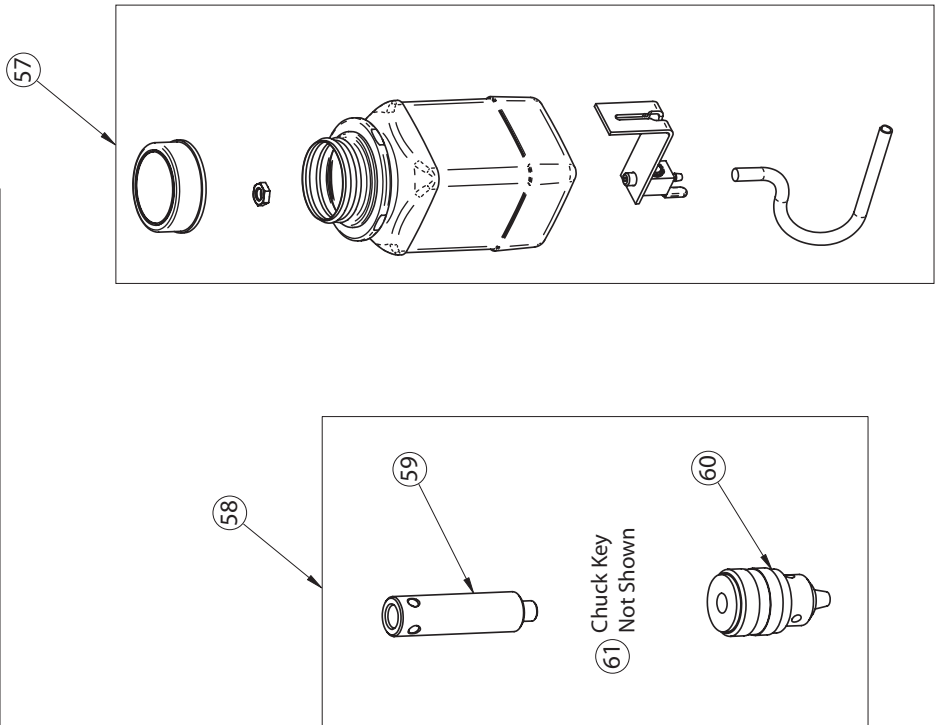
## PARTS BREAKDOWN



# ADDITIONAL PARTS

OPTIONAL EQUIPMENT

ITEM #	DESCRIPTION	PART #	QTY
58	CHUCK ADAPTER & KEY	08300	1
59	ADAPTER ONLY	08300-A	1
60	CHUCK ONLY	08300-C	1
61	CHUCK KEY ONLY	08300-K	1



## PARTS LIST

ITEM #	DESCRIPTION	PART #	QTY
1	MOTOR, 120V	081001	1
	MOTOR, 240V	081001-2	1
2	SCR, HHCS M6 X 16	081003	4
3	WASHER, M6 LOCK	080004	9
4	BODY	081101	1
5	NUT, M5 HEX	080102	4
6	SCR, SSS M5 X20	080103	4
7	SLEEVE	080104	2
8	SCR, HHCS M6 X 20	080106	3
9	SLIDE INSERT, LEFT	080107N	1
10	SLIDE INSERT, RIGHT	080108N	1
11	SLIDE PLATE	080109N	1
12	GUARD ASSEMBLY	081110	1
13	GUARD SLIDE	081112	1
14	SCR, FHSCS M5 X 10	081113	2
15	MAGNET, 110V / 240V	080200	1
16	SLIDER	081301	1
17	PINION SHAFT	080401	1
18	NEEDLE BEARING	081302	1
19	SCR, SHCS M6 X 20	080402	2
20	GEAR RACK	081403	1
21	SCR, FHSCS M6 X 20	080404	1
22	HUB WASHER	080405	1
23	HANDLE WITH KNOB	080407	3
24	INTERNAL RETAINING RING	080501	1
25	WASHER	080502	1
26	SEAL	080503	1
27	PLUNGER	080504	1
28	SPRING	080506	1
29	SEAL WASHER	080508	1
30	SCR, SSS M8 X 10 FLAT POINT	080505	2
31	ARBOR BODY	080507	1
32	SCR, SSS M6 X 6 FLAT POINT	080509	2
33	ARBOR ASSEMBLY	080507A	1
34	COOLANT RING ASSEMBLY	080614	1
35	MOTOR CORD	080717	1
36	STRAIN RELIEF	080716	2
37	POWER CORD - 120V	080705	1
	POWER CORD - 220V	080705-2	1
38	STRAIN RELIEF - PG11	080704	1
39	ELEC. CONTR. - SW-20 -120V	080712	1
	ELEC. CONTR. - SW-20 -220V	080712-2	1
40	LOCKING PILLAR	080718	4
41	PANEL PLATE	081711	1
42	SWITCH, MOTOR ON/OFF	080706	1
43	SWITCH, MAGNET	080708	1
44	PANEL ASSEMBLY	080120N	1
45	*NOTE-MAG./CONTR.-WIRES	0817077	1
46	**NOTE-MAG./MOTOR-WIRES	0817078	1
47	WASHER, M4 SERR. LOCK	06773	5
48	SCR, CRPHMS M4 X 10	080710	4
49	SCR, CRPHMS M4 X 12	080703	3
50	WASHER, M4 LOCK	080720	1
51	NUT, M4 HEX	080701	2
52	***NOTE - SAFETY STRAP	06798	1
53	WRENCH, HEX 4MM	0070587	1
54	WRENCH, HEX 3MM	0070586	1
55	WRENCH, HEX 2.5MM	080806	1
56	WRENCH, 8MM COMBINATION	0151219	1
57	COOLANT CONTAINER ASSEMBLY	081611A	1

\*NOTE:  
MAGNET SWITCH AND ELECTRONIC CONTROLLER WIRE GROUP ARE NOT SHOWN.

\*\*NOTE:  
MAGNET SWITCH AND MOTOR SWITCH WIRE GROUP ARE NOT SHOWN.

\*\*\*NOTE:  
SAFETY "D" RING STRAP AND CLIP ARE NOT SHOWN.

## DRILL SPECIFICATIONS

DIMENSIONS AND SPECIFICATIONS	
Height	15" minimum (381mm)
Width	7" (181mm)
Length (including handle)	12" (305mm)
Weight	30 lbs. (13.7 kg)
Motor	1.4 HP 1050W (single phase) 120V / 10.2~240V / 5.1A 350 RPM (load)
Arbor bore	3/4" (19.05mm)
Drill point breakaway	1095 lbs. on 1" plate
Magnet base dimensions	3-1/3" x 6-2/3" (84mm x 168mm)
Magnet dead lift	2350 lbs. on 1" plate
Cutter diameter (maximum)	1-3/8" (35mm)
Cutter depth of cut (maximum)	2" (50mm)
C/L spindle to motor face	1.3" (33mm)
C/L spindle to magnet face	1.9" (48.5mm)

## INSTRUCTIONS TO CONVERT HOLEMAKER TO ACCEPT TWIST DRILLS

Remove arbor assembly (part no. 080507A), by removing 2 hex screws (part no. 080509), which connect the arbor to the motor.

Disconnect the arbor from the motor, and pull down through the support casting. Also remove the coolant ring assembly (part no. 080614).

Push the 12mm chuck and adapter, up through the support casting, and tighten 2 hex screws onto the flats of the motor spindle.

## AVAILABLE SLUGGER CUTTERS AND ACCESSORIES

CUTTER DIAMETER	DECIMAL EQUIVALENT	1" DEPTH OF CUT PART #	2" DEPTH OF CUT PART #	3" DEPTH OF CUT PART #
7/16	.4375	S4375	SL437	NA
1/2	.5000	S5000	SL500	NA
13MM	.5118	S5118	SL511	NA
14MM	.5512	S5512	SL551	NA
9/16	.5625	S5625	SL562	NA
15MM	.5906	S5906	SL590	NA
5/8	.6250	S6250	SL625	NA
16MM	.6299	S6299	SL629	NA
17MM	.6693	S6693	SL669	NA
11/16	.6875	S6875	SL687	NA
18MM	.7087	S7087	SL708	NA
19MM	.7480	S7480	SL748	NA
3/4	.7500	S7500	SL750	7500S
20MM	.7874	S7874	SL787	*7874S
13/16	.8125	S8125	SL812	8125S
21MM	.8268	S8268	SL826	*8268S
22MM	.8661	S8661	SL866	*8661S
7/8	.8750	S8750	SL875	8750S
23MM	.9055	S9055	SL905	*9055S
15/16	.9375	S9375	SL937	9375S
24MM	.9449	S9449	SL944	*9449S
25MM	.9843	S9843	SL984	*9843S
1	1.000	S1000	SL100	1000S
26MM	1.023	S1023	SL102	*1023S
1-1/16	1.062	S1062	SL106	1062S
27MM	1.063	S1063	SL107	*1063S
28MM	1.102	S1102	SL110	*1102S
1-1/8	1.125	S1125	SL112	1125S
29MM	1.141	S1141	SL114	*1141S
30MM	1.181	S1181	SL118	*1181S
1-3/16	1.187	S1187	SL119	1187S
31MM	1.220	S1220	SL122	*1220S
1-1/4	1.250	S1250	SL125	1250S
32MM	1.259	S1259	SL126	*1259S
33MM	1.299	S1299	SL129	*1299S
1-5/16	1.312	S1312	SL131	1312S
34MM	1.338	S1338	SL133	*1338S

CUTTER DIAMETER	DECIMAL EQUIVALENT	1" DEPTH OF CUT PART #	2" DEPTH OF CUT PART #	3" DEPTH OF CUT PART #
1-3/8	1.375	S1375	SL137	1375S
35MM	1.377	S1377	SL138	*1377S
36MM	1.417	S1417	SL141	*1417S
1-7/16	1.437	S1437	SL143	1437S
37MM	1.456	S1456	SL145	*1456S
38MM	1.496	S1496	SL149	*1496S
1-1/2	1.500	S1500	SL150	1500S
39MM	1.535	S1535	SL153	*1535S
1-9/16	1.562	S1562	SL156	1562S
40MM	1.574	S1574	SL157	*1574S
41MM	1.614	S1614	SL161	*1614S
1-5/8	1.625	S1625	SL162	1625S
42MM	1.654	S1654	SL165	*1654S
1-11/16	1.687	S1687	SL168	1687S
43MM	1.692	S1692	SL169	*1692S
44MM	1.732	S1732	SL173	*1732S
1-3/4	1.750	S1750	SL175	1750S
45MM	1.771	S1771	SL177	*1771S
46MM	1.811	S1811	SL180	*1811S
1-13/16	1.812	S1812	SL181	1812S
47MM	1.850	S1850	SL185	*1850S
1-7/8	1.875	S1875	SL187	1875S
48MM	1.889	S1889	SL188	*1889S
49MM	1.929	S1929	SL192	*1929S
1-15/16	1.937	S1937	SL193	1937S
50MM	1.968	S1968	SL196	*1968S
2	2.000	S2000	SL200	2000S
51MM	2.007	S2007	SL201	*2007S
52MM	2.047	S2047	SL204	2047S
2-1/16	2.062	S2062	SL206	2062S
2-1/8	2.125	S2125-.75S	SL212-.75S	2125S-.75S
2-3/16	2.187	S2187-.75S	SL218-.75S	2187S-.75S
2-1/4	2.250	S2250-.75S	SL225-.75S	2250S-.75S
2-5/16	2.312	S2312-.75S	SL231-.75S	2312S-.75S
2-3/8	2.375	S2375-.75S	SL237-.75S	2375S-.75S

\*DENOTES NON-STOCK CUTTERS. CONSULT JANCY ENGINEERING FOR DELIVERY.  
NOTE: 3-INCH DEPTH-OF-CUT SLUGGER CUTTERS ARE NOT AVAILABLE BELOW 3/4" DIAMETER.

### COOLANT AND CUTTING PASTE

DESCRIPTION	PART #
PINT	10206VV
QUART	10207VV
GALLON	10208VV
5-GALLON	10209VV
55-GALLON	10210VV
CUTTING PASTE	10205

### SLUGGER CUTTER PILOT PINS (FOR CUTTERS LISTED ABOVE)

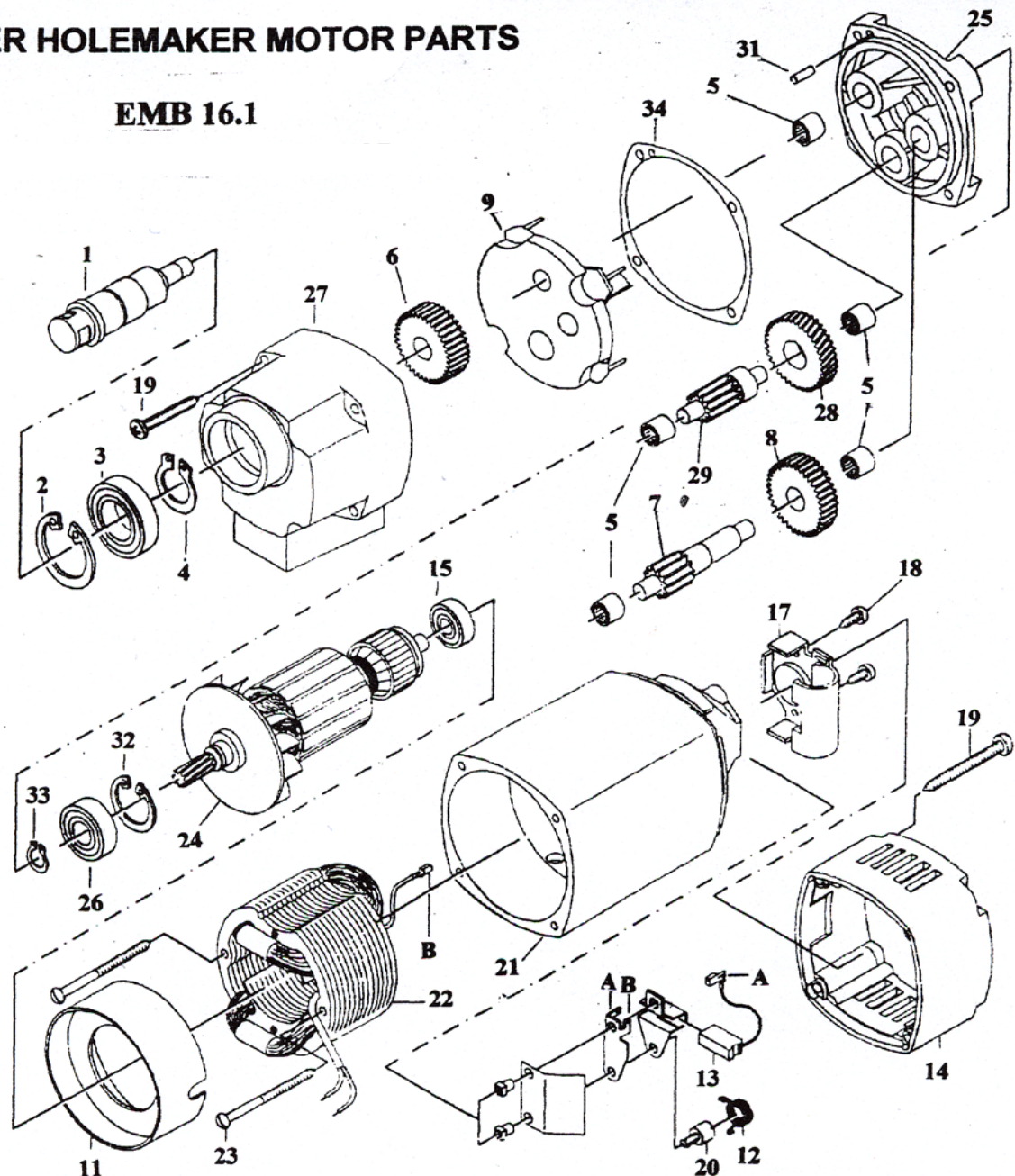
PILOT FITS CUTTER SIZES	PART #
1" DEPTH OF CUT / 1/2" DIAMETER AND SMALLER	16001
2" DEPTH OF CUT / 1/2" DIAMETER AND SMALLER	16002
1" DEPTH OF CUT / 9/16" DIAMETER AND LARGER	16003
2" DEPTH OF CUT / 9/16" DIAMETER AND LARGER	16004
ALL STANDARD 3" DEPTH OF CUT	16005

### PILOT PIN FUNCTIONS

Pilot pins align Slugger cutters to desired drilling position, provide lubricant to center of cutter during drilling cycle and eject slug from center of cutter after the drilling cycle.

# SLUGGER HOLEMAKER MOTOR PARTS

## EMB 16.1



Detail#	Description	Part #	Detail#	Description	Part #
1	Work Spindle	E55601	21	Motor Casing	E55621
2	Internal Retaining Ring	E55602	22	Field - 110V	E55622
3	Bearing	E55603		Field - 220V	E55722
4	External Retaining Ring	E55604	23	Sheet Metal Screw	E55623
5	Needle Bearing	E55605	24	Armature, 110V, 5 Spline	E55624EX
6	Spindle Gear	E55606		Armature, 220V, 5 Spline	E55724EX
7	Intermediate Shaft 2	E55607	25	Gearbox Cover	E55625
8	Intermediate Gear 2	E55608	26	Bearing	E55626
9	Grease Plate	E55609	27	Gear Box	E55627
11	Fan Shroud	E55611	28	Intermediate Gear 1 - 8 Spline	E55628
12	Brush Spring	E55612		Intermediate Gear 1 - 5 Spline	E55628EX
13	Carbon Brush	E55613	29	Intermediate Shaft 1	E55629
14	Motor Cap	E55632	31	Dowel Pin	E55631
15	Bearing	E55615	32	Internal Retaining Ring	E55015
17	Capacitor Holder	E55617	33	External Retaining Ring	E55633
18	Sheet Metal Screw	E55618	34	Gasket, Gear Box Cover	E55634
19	Sheet Metal Screw	E55619			
20	Spring Screw	E55620			

## OTHER AVAILABLE SLUGGER DRILLS

DESCRIPTION	MODEL #	MAX DIAMETER	CAPACITY DEPTH
USA5 120V	18066	2-3/8"	3"
USA5 240V	18080	2-3/8"	3"
USA5 EC 120V	18066EC	2-3/8"	3"
USA5 EC 240V	18080EC	2-3/8"	3"
USA5 EX 120V	18066EX	2-3/8"	2"
USA5 EX 240V	18080EX	2-3/8"	2"
USA5 EXB 120V	18066EXB	2-3/8"	2"
USA5 EXB 240V	18080EXB	2-3/8"	2"
JM101 120V	19020	1-3/8"	2"
JM101 240V	19024	1-3/8"	2"
JM101 120V WITH 3/8" SLIDE BAR FEED HANDLE	19021	1-3/8"	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	1-3/8"	2"
MAGFORCE 240V	06921	1-3/8"	2"

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