

USER MANUAL

HMT MAX40

Magnetic Drilling Machine

PLACE MACHINE MOTOR STICKER HERE

SERIAL NO. _____

DATE OF PURCHASE _____

Congratulations on your purchase of the HMT MAX40 Portable Magnetic Drilling Machine. Your model is designed to produce superior holes quickly and efficiently. Through years of experience, constant innovation and development, HMT is committed to provide you with cutting tool innovation to speed up metalworking.

Before operating your new magnetic drilling machine, please read all instructions first. These include the Operator's Manual and Warning Label on the unit itself. With proper use, care and maintenance, your model will provide you with years of effective hole drilling performance.

TO REDUCE THE RISK OF INJURY USER MUST READ AND UNDERSTAND ALL INSTRUCTIONS

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- 1. Removable Safety Guard
- 2. Removable Feed Handles x 3
- 3. Removable Cooling System
- 4. Magnetic Base
- 5. Magnet Switch
- 6. Motor Switch



Fig. 1

Explanation of terms used and Pictograms marked on tool

Symbol	Term, meaning	Explanation
	Read documentation	Be absolutely sure to read the enclosed documentation such as the Instruction Manual and the General Safety Instructions.
	Wear ear protection	Use ear protection during operation.
	Wear eye protection	Use eye-protection during operation.
	Hand Protection	Use hand protection when handling sharp tooling or swarf. Keep well clear of rotating parts
	European conformity symbol	Confirms the conformity of the power tool with the directives of the European Community
	Risk of Electric Shock	Single Phase electric current. Conform to local regulations. Maintenance or repair to be carried out by authorised and trained persons only
	Danger/warning/caution	Observe the information in the adjacent text!
	Class of protection I	Product with basic insulation and exposed (touchable), conductive parts additionally connected to the protective earth conductor.
mm	Millimeter	Unit of measure for length, width, height or depth
kg	Kilogram	Unit of measure for the mass
V	Volt	Unit of measure for the electric voltage
A	Ampere	Unit of measure for the electric current intensity
W	Watt	Unit of measure for the output
N	Newton	Unit of measure for the force
min	Minutes	Unit of measure for the time
no	No-load speed	Revolution speed at no-load
1/min	per minute	Unit of measure for number of revolutions, strokes, impacts or oscillations per min

GENERAL POWER TOOL SAFETY WARNINGS

Do not use this power tool before you have thoroughly read and completely understood this Instruction Manual and the “General Safety Instructions”, including the figures, specifications, safety regulations and the signs indicating DANGER, WARNING and CAUTION.



WARNING: When using electrical tools basic safety precautions should always be followed to reduce the risk of fire, electrical shock and personal injury including following.

Please also observe the relevant national industrial safety regulations. Non-observance of the safety instructions in the said documentation can lead to an electric shock, burns and/or severe injuries.

This Operator’s Manual and the “General Safety Instructions” should be kept for later use and enclosed with the power tool, should it be passed on or sold.

WORK AREA

1. Keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.
2. Do not operate magnetic drilling machine in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Magnetic drilling machine may create sparks which may ignite the dust or fumes.
3. Keep bystanders, children, and visitors away while operating a magnetic drilling machine. Distractions can cause you to lose control.

ELECTRICAL SAFETY

1. Magnetic drilling machine plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs.
2. Avoid body contact with grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is grounded.
3. Do not expose magnetic drilling machines to rain or wet conditions. Water entering a machine will increase the risk of electric shock.
4. Do not abuse the cord. Never use the cord to carry the magnetic drilling machine or pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock.
5. When operating a magnetic drilling machine, use an extension cord suitable for outdoor use. Use of a cord suitable for outdoor use reduces the risk of electric shock.
6. If operating a magnetic drilling machine in a damp location is unavoidable, use a residual current device (RCD) protected supply. Use of an RCD reduces the risk of electric shock. Conform to local or site specific regulations.

PERSONAL SAFETY

1. Stay alert, watch what you are doing and use common sense when using a magnetic drilling machine. Do not use machine while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating magnetic drilling machines may result in serious personal injury.

2. Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts.
3. Avoid accidental starting. Be sure switches are off before plugging in.
4. Never place hands, fingers, gloves or clothing near cutting area or rotating machine parts.
5. Remove adjusting keys or switches before turning the machine on. A wrench or a key that is left attached to a rotating part of the machine may result in personal injury.
6. Do not overreach. Keep proper footing and balance at all times. Proper footing and balance enables better control of the magnetic drilling machine in unexpected situations.
7. Use safety equipment. Always wear eye protection. Dust mask, non-skid safety shoes, hard hat, or hearing protection must be used for appropriate conditions.
8. Always use supplied safety chain during any work on non-horizontal components. Mounting can release.

MACHINE USE AND CARE

1. When using the machine on non-horizontal surfaces, cutting paste or spray paste is recommended. Do not use oil type liquids where oil can drip into the motor unit.
2. During machine operations, the annular cutter must be cooled and lubricated with good quality cutting or lubrication oil. Remove the slug from the annular cutter after each hole. Caution, the slug may be hot!
3. Use clamps or other practical way to secure and support the work piece to a stable platform. Holding the work by hand or against your body is unstable and may lead to loss of control.
4. Do not use machine if switch does not turn it on or off. Any tool that cannot be controlled with the switch is dangerous and must be repaired.
5. Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool. Such preventive safety measures reduce the risk of starting the tool accidentally.
6. When not in use, store Magnetic drilling machines out of reach of children and other untrained persons. Tools are dangerous in the hands of untrained users.
7. Maintain machines with care. Keep cutting tools sharp and clean. Properly maintained tools, with sharp cutting edges are less likely to bind and are easier to control.
8. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the machine operation. If damaged, have the tool serviced before using. Many accidents are caused by poorly maintained tools.
9. Use only accessories that are recommended by HMT for your model. Accessories that may be suitable for one machine, may become hazardous when used on another machine.

SERVICE

1. Tool service must be performed only by qualified repair personnel. Service or maintenance performed by unqualified personnel could result in a risk of injury.
2. When servicing a tool, use only identical replacement parts. Follow instructions in the Maintenance section of this manual. Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of electric shock or injury.
3. When using this machine, you **MUST** wear ear and eye protection.

ADDITIONAL SPECIFIC SAFETY RULES FOR MAGNETIC DRILLING MACHINES

- Keep your fingers well out of the drill area;
- Avoid touching the drilled core that is automatically ejected by the centering pin when the working procedure is finished. Contact with the core when it is hot, or if it falls, can cause personal injuries;
- Always use the drill guard. Before turning on machine ensure the guard is closed securely;
- Always use the safety strap;
- The magnetic drilling machine is suitable for use on steel with a thickness starting from 10 mm, with zero air gap between the magnet core surface and the mounting surface. Curvature, coats of paint and surface irregularities will create an air gap. Keep the air gap to a minimum;
- Always place the machine on a flat surface;
- Do not clamp the magnetic drilling machine on small or irregularly shaped objects;
- Always place the machine on a surface that is clear of shavings, chips, swarf and surface dirt;
- Keep the magnet clean and free of debris and swarf;
- Do not turn on the machine until it has been mounted and installed according to these instructions;
- Do not turn on the machine before having checked that the magnetic stand has been tightened firmly to the mounting surface;
- Adjust the table so cutter does not extend into the work piece before drilling. Do not perform any design, assembly or construction activities on the work piece while the machine is turned on;
- Before turning on the machine, make sure the accessory has been mounted correctly;
- Always use the recommended speed for the accessories and the material;
- Do not use the machine on the same work piece on which electric welders are being used;
- Use only an appropriate cutting fluid. We offer a range of premium cutting oils and lubricants which are specially developed and selected for optimum performance and maximum tool life;
- Do not use liquid cutting fluids while drilling vertically or overhead. Dip the cutter in cutting paste or apply an appropriate spray for these applications;
- Do not pour cutting fluid into the reservoir while it is mounted in the bracket. Do not allow cutting fluid to enter the drill motor;
- Before use, ensure movable chuck guard operates properly; Use Guard to protect user from flying chips and debris, and to protect from entry to moving spindle and tool. Switch off motor to clear swarf build up during the cut.
- Ensure that metal chips or resinous residue cannot lead to blockage of the function;
- In case of jammed cutter disconnect the machine from the power supply, remove the reason for the jam before turning on the machine again.
- Magnetic drills, pillar drills, and similar drill press equipment should have clear and unambiguous emergency stop features in accordance with current CE Markings and Directives
- Do not touch rotating tools, spindles, arbors or adaptors
- Do not place loose fitting gloves (especially Rigger Gloves), items of clothing, or jewellery near rotating tools or machine spindles.

- Safety chains or similar restraints should be used to prevent a magnet drill falling in the event of a power cut to the electromagnetic base. Use extra caution with generator power supply for this reason
- Wear approved Eye / Face guard, ear protection and hand protection at all times.
- Inspect cutting tools before use: Do not use the tool if cracks or damage is observed on any part of the tool.
- Use cutting tools within the torque and RPM recommendations
- Inspect the cutting tool regularly for any signs of damage. Immediately replace the tool if any damage is found.
- Before use, ensure the cutting tool is inserted securely into designated arbor, adapter or socket.
- Be sure to disconnect power when handling cutting tools.
- Use Impact type cutting tools only with Impact rated sockets, extensions, adapters & accessories.
- Risk assessment and method statements should be produced and followed by the user at all times
- Metal swarf and chips produced should be assessed for potential cut hazards
- Excessive lubrication use should be assessed for potential slipping hazards, especially on smooth or painted surfaces
- Position appropriate guarding to protect users and passers by from chips, debris and entanglement hazards
- Slugs produced by annular cutters can become a hazard if they are allowed to fall from height.
- Material, slugs, and swarf in recent contact with cutting tools can become very hot

RESIDUAL RISKS

In spite of the application of the relevant safety regulations and the implementation of safety devices, certain residual risks cannot be avoided.

These are:

Impairment of hearing; Wear ear protection in areas with noise emissions > 80 db(A).

- Risk of personal injury from flying particles;
- Risk of burns due to accessories becoming hot during operation;
- Risk of personal injury due to prolonged use.

POSITION Serial number

The Serial Number, which also includes the type of machine, the year and month of manufacturing and identification number, is engraved on the frame, magnet and the motor unit.

Example:

30 14 09 001

Model type

Year of Manufacture

Month of manufacture

Identification number

Package Contents

- 1 Magnetic drilling machine
- 1 Carrying case
- 1 Removable guard
- 3 Handles
- 1 Hex key set
- 1 Removable Lubrication system
- 1 Safety Strap
- 1 Operators manual

TECHNICAL DATA HMT MAX40

Technical Specifications

CUTTER SIZE RANGE	12-40mm
TWIST DRILL RANGE	4.2-18mm
COUNTERSINKING	N/A
LENGTH	270mm
WIDTH INC HANDLES	165mm
HEIGHT	330-430mm
STROKE	100mm
WEIGHT	11.5 Kg
MAGNET SIZE (L x W)	80x160mm
MAGNETIC FORCE	800 Kg
MOTOR POWER	1050 W
SPEED/s (RPM)	430 RPM
ARBOR	19.05mm (3/4") Weldon
TAKES CHUCK	No
COOLANT SYSTEM	Removable

Sound & Vibration Data

Motor Unit	MAX40 Motor Uni2
Sound Pressure Level	84 dB(A)
Sound Power Level	97 dB (A)
Noise K Factor	3 dB (A)
Vibration	1,95 ms/2
Vibration K Factor	1.5 m/s ²

REMARK: The sum of the measured emission value and respective measuring inaccuracy represents the upper limit of the values that can occur during measuring.



Wear ear protection!

For measurement values obtained according to the respective product standard, see the last page of this Instruction Manual.

DESCRIPTION (fig. 1)



WARNING: Never modify the power tool or any part of it. Damage or personal injury could result.

1. Safety Guard
2. Feed handle
3. Cooling system tank
4. Magnetic stand
5. Magnet switch
6. Motor switch

INTENDED USE

This magnetic drilling machine is intended for commercial use as a drilling machine for drilling materials with a magnetizable surface using annular cutters and twist drill. Some magnetic drills are also suitable for tapping, countersinking and reaming in a weather-protected environment using the application tools and accessories recommended by HMT. The magnetic drilling machine can be used horizontally, vertically or overhead.

INSTRUCTIONS FOR PUTTING INTO OPERATION

Please make sure that the contacting surface for the magnet is level, clean and rust-free. Remove any varnish or primer. When working on materials that are not magnetizable, suitable fixation devices, obtainable as accessories from HMT e. g. suction plate, vacuum plate or pipe-drilling device must be used.

When working on steel materials with a material thickness of less than 12 mm, the workpiece must be reinforced with an additional steel plate in order to guarantee the magnetic holding power.

Check the machine for possible damage; Before using the machine, you must carefully check protective devices or slightly damaged components to ensure they are operating perfectly and as intended.

Check that moving parts are in perfect working order and do not jam and check whether parts are damaged. All parts must be correctly installed and fulfill all conditions necessary to ensure perfect operation of the machine.

Damaged protective devices and parts must be repaired or replaced according to specifications by HMT or any authorized HMT dealer.

DO NOT use under wet conditions or in presence of flammable liquids or gases. This magnetic drilling machine is a professional power tool.

DO NOT let children come into contact with the machine. Supervision is required when inexperienced operators use this machine.

ELECTRICAL SAFETY

The electric motor has been designed for one voltage only. Always check that the power supply corresponds to the voltage on the rating plate.

Your HMT MAGNETIC DRILLING MACHINE is designed in class I (grounded) according to EN 61029-1. Earth wire is required.

If the supply cord is damaged, it must be replaced by a specially prepared cord available through the HMT service organization.

EXTENSION CABLE

If an extension cable is required, use an approved 3-core extension cable suitable for the power input of this tool (see technical data). The minimum conductor size is 1.5 mm²; the maximum length is 30 meter. When using a cable reel, always unwind the cable completely.

ASSEMBLY AND ADJUSTMENTS



WARNING: *To reduce the risk of injury, turn unit off and disconnect machine from power source before installing and removing accessories, before adjusting or changing set-ups or when making repairs. Be sure the switch is in the OFF position. An accidental start-up can cause injury.*

PREPARATION OF THE MACHINE (FIG. 1)

1. Assemble the feed handle.
2. Mount the drill guard.
3. Fit the lubrication system as necessary.
4. Place the machine on a clean, level and solid surface. Remove any particles that will obstruct full contact between the magnetic stand and the mounting surface.
5. Fit the safety chain or strap (in vertical or overhead drilling applications).

MOUNTING THE DRILL GUARD (FIG. 1)

The guard protecting against chippings and accidental contact must always be mounted during operation.

1. Hold the guard in front of the magnet, aligning the slots in the guard with the holes in the magnet.
2. Fit the screws into the hole located in the side of the magnet.



WARNING: *Always use the safety guard.*

FITTING THE LUBRICATION SYSTEM (FIG. 1)

The lubrication system can be used for horizontal drilling applications (the drill being used vertically).

- position the cooling tank by locating bracket point to the frame hole. This is found on the opposite side of the unit to the handles.
- Connect the hose to the nipple on the spindle drive shaft.

In order to use the lubrication system, it must be filled with a sufficient amount of cutting fluid.

1. Make sure the flow regulator is closed;
2. Unscrew the cap;
3. Fill the container with cutting fluid;
4. Screw the cap back on.



WARNING: *Do not use the lubrication system in vertical or overhead drilling applications where a liquid oil can run down over the motor*

FITTING THE SAFETY CHAIN/STRAP



1. Pass the safety chain/strap through the opening as marked
2. Wrap the chain/strap around the workpiece
3. If the workpiece is not suitable for the chain/strap, an alternative safety strap/chain arrangement should be made in accordance with the contractor/operatives local risk assessment and method statement
4. Tool tethering requirements for safety at height should be assessed separately to this safety chain/strap requirement



WARNING: Always use the safety chain/strap when using machine vertically and/or upside-down..

INSERTING AND REMOVING AN ACCESSORY

The tool holder accepts annular cutters with a 19,05 mm Weldon shank with one or more flats.



WARNING: The teeth of a cutter are very sharp and can be dangerous.

1. In order to fit an annual cutter it is necessary to remove the guard (1);
2. Slide the pilot pin through the hole in the center of the cutter shank.
3. Insert the shank of the accessory as far into the tool holder as possible.
4. Tighten the two Allen screws with Allen key;
5. To remove the accessory, loosen the Allen screws and take out the cutter.

PRIOR TO OPERATION

Try a few simple projects using scrap material until you develop a “feel” for the machine.

OPERATION

Instructions for use



WARNING: Always observe the safety instructions and applicable regulations.



WARNING: To reduce the risk of serious personal injury, turn tool off and disconnect tool from power source before making any adjustments or removing/installing attachments or accessories.

MAGNETIC BASE

Material of minimum 10 mm thickness is required for the magnet to work the best.

The attachment force generated by the magnet depends on various factors.

- Thickness of the material the magnet is placed on;
- Paint or coating of the material the magnet is placed on;
- Metal chips, oil or other dirt under the magnet.

Make sure that the magnet attaches tightly to the work piece before turning on the motor unit of the magnetic drilling machine. HMT magnets have 2 coils; make sure that both coils are in contact with the material. Do not connect any other machines to the electrical outlet the magnetic drilling machine is plugged into, as it may result in the loss of magnetic force.

Always use the safety chain included. Drilling above your head can be dangerous and is not recommended. The use of magnetic drilling machines on pipes, not-flat or non-magnetic materials is not recommended without specialist attachments

TURNING MACHINE ON AND OFF

THE CONTROL PANEL

The control panel on your magnetic drilling machine is designed for maximum operating facility and safety.

Fig.2



In order to operate properly, the machine has to be turned on following the procedure as described below.

ACTIVATING THE MAGNET

Connect the machine to the mains/work piece. To activate the magnet, press the red button (Fig. 2 -2). The switch will be lit (red). To deactivate the magnet, press the same button (Fig. 2 -2) again.

TURNING THE MOTOR ON AND OFF

The motor unit can only be switched ON when the magnet is activated. To turn the motor ON, by pressing the green button with marking "I"(Fig. 2 - 1). To switch the motor OFF, press the red button with marking "O"(Fig. 2 - 1).

1 - The Motor Switch:

This switch is used to switch the motor unit On and Off;

2 - The Magnet Switch:

This switch is used to switch the magnet On and Off.

DRILLING A HOLE

Now that you have read the explanatory information and safety recommendations above, you are ready to actually start drilling. Follow these 10 steps for best drilling result:

- 1 Use the tip of the pilot pin to determine the center of the hole to be drilled.
- 2 Turn the magnet on and verify that the drill is in the right position and that the machine is pushed tight against the work piece.
- 3 If your machine is equipped with a auto coolant system, put open the valve to release the oil. If your machine does not have a auto coolant system, fill the holes of the spindle with oil.
- 4 Turn the motor on at the highest setting and allow it to run at full speed.
- 5 Turn the arms to start drilling. Apply only a slight pressure when the Annular Cutter touch the metal. Do not push the Annular Cutter with force into the metal.
- 6 Apply a regular pressure while drilling. The drilling performance does not improve by putting more pressure on the tool. Too much pressure will overload the motor and your Annular Cutter will be worn sooner. ***Let the cutter do the job and give it time to cut the metal!!!***
- 7 Adjust the oil supply when necessary, if your drill does not have a auto coolant system, stop drilling regularly, refill the holes of the spindle and continue drilling.
- 8 Apply less pressure when the drill cuts through the material.
- 9 Turn the arms to put the motor in highest position and turn off the motor unit.
- 10 Remove the burr, metal chips and clean the cutter and surface without getting injuries.
Caution : The metal piece drilled out can be sharp and very hot!!

DRILLING WITH ANNULAR CUTTERS

Annular cutters only cut material at the periphery of the hole, rather than converting the entire hole to shavings. As a result, the energy required to make a hole is lower than for a twist drill. When drilling with an annular cutter, it is not necessary to drill a pilot hole.



WARNING: Do not touch the cutter or the parts close to the cutter immediately after operation, as they may be extremely hot and cause burns to the skin. Ensure nobody is in the work area where the metal core is ejected.

DRILLING CONDITIONS

The ease with which material can be drilled depends on several factors including tensile strength and abrasion resistance. Whilst hardness and/or strength is the usual criterion, wide variations in machineability can exist among material showing similar physical properties.

The drilling conditions are dependent on requirements for tool life and surface finish. These conditions are further restricted by the rigidity of the tool and the work piece, lubrication and machine power available. The harder the material, the lower the cutting speed.

Some materials of low hardness contain abrasive substances leading to rapid cutting edge wear at high speeds. Feed rates are governed by rigidity of set-up, volume of material to be removed, surface finish and available machine power.

LUBRICATION IN HORIZONTAL APPLICATIONS

- Adjust the fluid flow as required using the flow regulator;
- Add more cutting fluid if the shavings (metal chips) become blue.

VERTICAL AND OVERHEAD APPLICATIONS

Dip the cutter in cutting paste or apply an appropriate spray.

LUBRICATING THE FEED TRAVEL

The feed travel should be lubricated periodically with grease to ensure smooth operation.

- Raise the motor unit to the highest position possible;
- Lubricate the dove-tail guide way at both sides;
- Lubricate the gear rack.

After repeated use, the gear rack may become loose. If necessary, adjust the 5 self-locking set screws at the left side. Tighten screws in series until the gear rack moves freely in the dove-tail guide but does not allow the motor to wobble.

Cleaning



WARNING: Blow dirt and dust out of the main housing with dry air as often as dirt is seen collecting in and around the air vents. Wear approved eye protection and approved dust mask when performing this procedure.



WARNING: Never use solvents or other harsh chemicals for cleaning the non-metallic parts of the tool. These chemicals may weaken the materials used in these parts. Use a cloth dampened only with water and mild soap. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

Optional Accessories



WARNING: Since accessories, other than those offered by HMT, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only HMT recommended accessories should be used with this product.

Consult your dealer for further information on the appropriate accessories.

MAINTENANCE

Your HMT power tool has been designed to operate over a long period of time with a minimum of maintenance. Continuous satisfactory operation depends upon proper tool care and regular cleaning.



CAUTION: To reduce the risk of injury, turn unit off and disconnect machine from power source before installing and removing accessories, before adjusting or changing set-ups or when making repairs. Be sure the switch is in the OFF position. An accidental start-up can cause injury.

Just as every magnetic drilling machine with moving parts, your HMT magnetic drilling machine also needs regular maintenance service. A few recommendations follow :

VISUALLY CHECK THE MACHINE FOR DAMAGE

Machine must be checked before operation for any signs of damage that will affect the operation of the machine. Particular notice must be taken of the mains cable, if the machine appears to be damaged it should not be used failure to do so may cause injury or death.



CAUTION: Clean all dirt, dust, metal chips and burrs of your magnetic drilling machine

OPERATION OF THE MACHINE

The machines operation must be checked to ensure that all components are working correctly. Replace any defective parts immediately. This prevents properly function parts from being damaged.

CARBON BRUSHES

Brushes should be checked to make sure there is no abnormal wear present. This should be checked at least once a week if used frequently. If the carbon brush has worn more than 2/3 the original length the brushes should be changed. Failure to do so may cause damage to the machine.

CHECK MAGNETIC BASE

Before every operation the magnetic base should be checked to make sure that the base is flat and there is no damage present. An uneven magnet base will cause the magnet not to hold as efficiently and may cause injury to the operator.

CHECK MACHINES GREASE

The gearbox grease should be checked once a month to ensure all moving components are covered to prevent wear. The grease should be changed at least once a year to ensure you gain the best from the machine.

CHECK ARMATURE

This should be checked at least 1 per month to check that there are visual signs of damage to the body or to the commutator. Some signs of wear will be seen on the commutator over a period of time this is normal as this is the part that comes in contact with the brushes but any signs of abnormal damage and the part should be replaced.

ADJUSTMENT OF SLIDE

An essential requirement of the machine is that the slide can move in a smooth and controlled manner, free of lateral movement and vibration.

This situation can be maintained by periodic adjustment of the slide and is accomplished in the following manner:

1. Place the machine in an upright position and, by means of the capstan, raise the slide to its highest position. Clean the brass rail strips and apply a small amount of light machine oil to the wear surfaces.
2. Commencing with the top screw, loosen both setting nut (#4 on spare part drawing) with included wrench 8 and the setting screw (#5 on spare part drawing) with included Allen key 2.5. Then gently feed in setting screw until slight resistance is encountered. Follow your way down adjusting all setting nuts and screws.
3. Operate the slide up and down a few times to test the movement and make any further necessary adjustments. Try to ensure that all the screws are exerting a uniform pressure on the slide from top to bottom. A perfectly adjusted slide will operate freely up and down without any sideways movement.

REPAIR, MODIFICATION AND INSPECTION

Repair, modification and inspection of HMT Magnetic drilling machines must be done by HMT or an HMT authorized dealer. The spare parts list will be helpful if presented with the machine to the HMT dealer for service when requesting repair or other maintenance.

HMT machines are constantly being improved and modified to incorporate the latest technological advancements. Accordingly, some parts (i.e. part numbers and/or design) may be changed without prior notice. Also, due to HMT's continuing program of research and development, the specifications of machines are subject to change without prior notice.

TROUBLE SHOOTING

Magnet and motor do not function	<ul style="list-style-type: none"> - The magnet switch is not connected to the power supply - Damaged or defective wiring - Defective fuse - Defective magnet switch - Defective Control Unit - Defective power supply
Magnet does function, the motor does not work	<ul style="list-style-type: none"> - Damaged or defective wiring - Carbon brushes are stuck or worn out - Defective magnet switch - Defective On / Off switch - Defective Control Unit - Defective armature and/or field
Magnet does not function, the motor does	<ul style="list-style-type: none"> - Defective magnet - Defective wiring of magnet - Defective Control Unit
Annular cutters break quickly, holes are bigger than the hole cutter	<ul style="list-style-type: none"> - Clearance in the guide - Bent spindle - Shaft extending from the motor is bent - Bent pilot pin
Motor running roughly and/or seizing up	<ul style="list-style-type: none"> - Bent spindle - Shaft extending from the motor is bent - Triangular guide not mounted straight - Dirt between spindle and triangular guide
Motor starts running when magnet switch is turned on	<ul style="list-style-type: none"> - Damage or defective relays in control unit
Motor making a rattling sound	<ul style="list-style-type: none"> - Gear ring (bottom of the armature) worn out - Gear(s) worn out - No grease in gear box
Motor humming, sparking, and motor has no force	<ul style="list-style-type: none"> - Armature damaged (burned) - Field burned - Carbon brushes worn out
Motor does not start or fails.	<ul style="list-style-type: none"> - Damaged or defective wiring - Dirt in sensor Speed Control Unit - Defective or loose magnet on top of armature - Damaged or defective (sensor) Speed Control Unit - Damage to Armature or field coil - Damaged or defective carbon brushes
Guiding takes a great deal of effort	<ul style="list-style-type: none"> - Guide is set too tight - Guide is dry, needs to be greased - Guide/gear- rack/rotation system dirty or damaged
Insufficient magnetic force	<ul style="list-style-type: none"> - Damaged or defective wiring - Bottom of magnet not clean and dry - Bottom of magnet not flat - Work piece is not bare metal - Work piece is not clean or flat - Work piece is less than 10 mm (too thin) - Defective Control Unit - Defective magnet

Frame under voltage	<ul style="list-style-type: none"> - Damaged / defective wiring - Defective magnet - Motor seriously dirty
Fuse blows when magnet switch is turned on	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Defective magnet switch - Defective Control Unit - Defective magnet
Fuse blows when motor is started	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Motor running roughly - Defective Armature and / or Field - Carbon brushes worn out - Defective Control Unit
Rotation system free stroke too long	<ul style="list-style-type: none"> - Loose or defective gear-rack - Defective rotation system

NOTE: Please contact HMT if there is machine failure and the problem cannot be saved with one of the above solutions!!

PROTECTING THE ENVIRONMENT



Separate collection. This product must not be disposed of with normal household

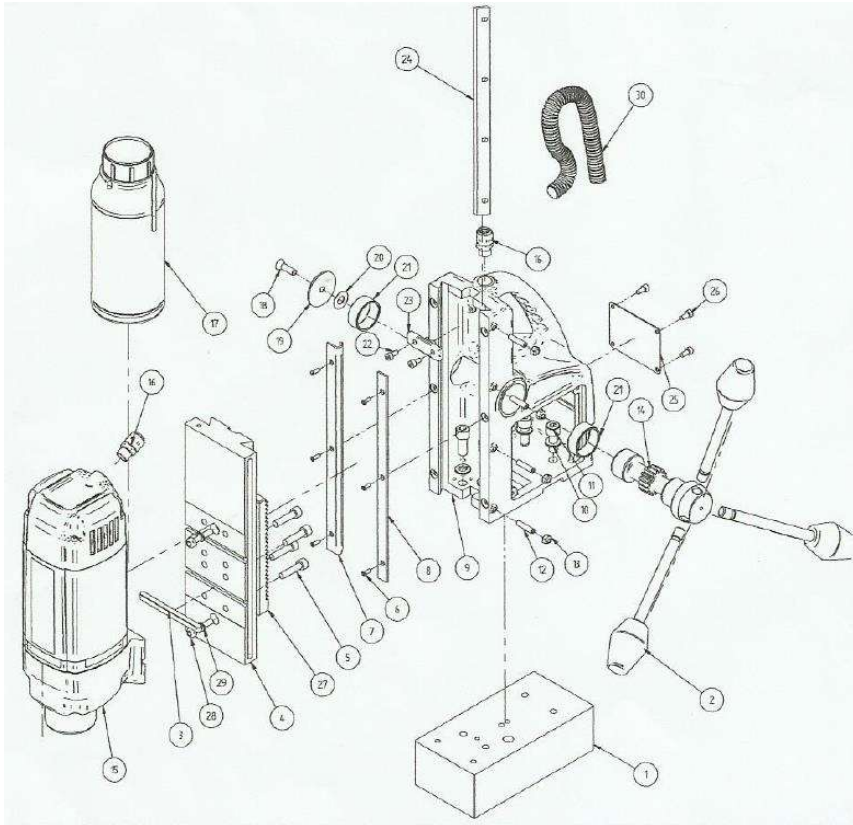
Should you find one day that your HMT product needs replacement, or if it is of no further use to you, do not dispose of it with household waste. Make this product available for separate collection.



Separate collection of used products and packaging allows materials to be recycled and used again. Re-use of recycled materials helps prevent environmental pollution and reduces the demand for raw materials.

Local regulations may provide for separate collection of electrical products from the household, at municipal waste sites or by the retailer when you purchase a new product.

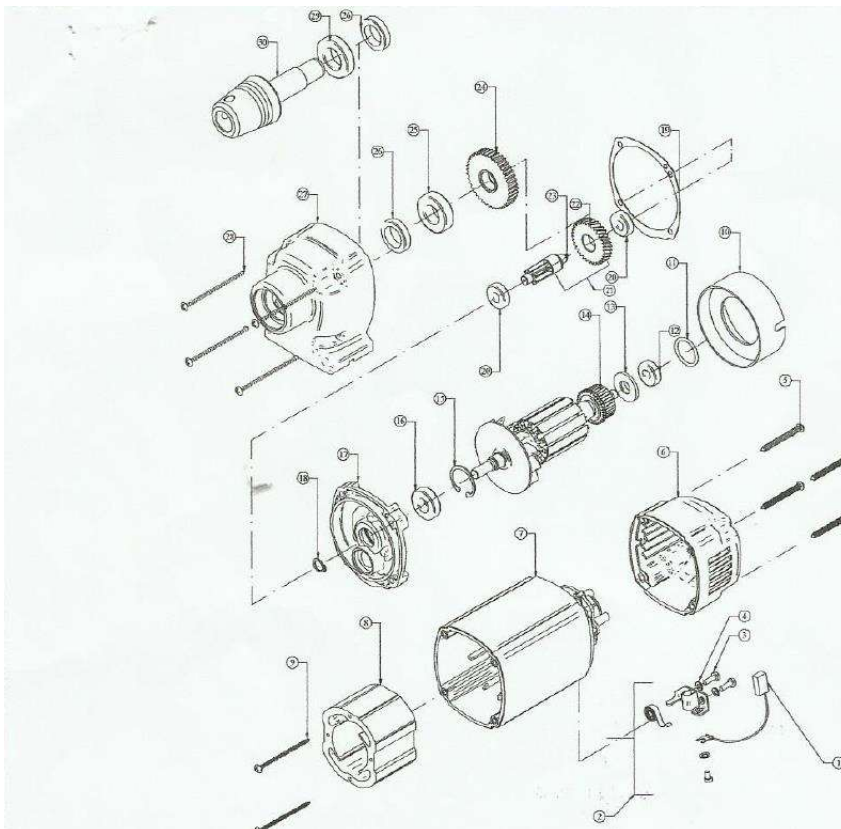
SPARE PART LIST HMT MAX40: FRAME



Sr.No	PART NAME	PART No.	QTY
1	Base SA	219945	1
2	Handle lever SA	219902	3
3	Key	210215	1
4	Guide plate	210117	1
5	SH screw M6 x 25	131765100	4
6	Countersunk screw M3x8	211721	6
7	Brass strip left	210103	1
8	Brass strip right	210104	1
9	Main body	210118	1
10	Spring washer M8	101710100	4
11	SH screw M8 x 20	101708100	4
12	SCH grub screw M5 x 20	211701	4
13	Lock nut M5	101760100	4
14	Spindle	210202	1
15	Drill unit	219916	1
16	Gland PGR	211309	2
17	Coolant bottle SA	219912	1
18	Countersunk screw M6 x 16	211705	1
19	Spindle cap	210217	1
20	Lock foil	210301	1
21	Spindle bush	210203	2
22	SH screw M4x8	121761100	2
23	Cord clamp	210406	1
24	Gib	210501	1
25	Spec. plate	211417	1
26	SH screw M4x8	121761100	4
27	Rack	210201	1
28	SH screw M5 X 25	121763100	2
29	Int tooth lock washer (M5)	101739100	2
30	Cable conduit	101308100	1

PART NO. 211420 REV: D2

MAX 40 PARTS LIST: MOTOR



DRILL UNIT BHM 35

Sr.no.	PART NAME	PART no.	QTY
1	Carbon Brush SA	219903	2
2	Brush Holder SA	209902	2
3	CH Screw M4x12	161710100	4
4	Spring washer M8	101706100	4
5	Phillip head self tap screw 4.8x45	201716	4
6	Back cover	200403	1
7	Field Case	200401	1
8	Field SA	77117150	1
9	Phillip head self tap screw 3.9x60	201703	2
10	Baffle	200402	1
11	O ring	200303	1
12	Ball Bearing (8-22-7) 608 2Z	110902101	1
13	Dust washer	200404	1
14	Armature SA	77117100	1
15	Circlip 28mm x 1.2 B TYPE	201704	1
16	Ball Bearing (12-28-8)5001 2Z	190901	1
17	GC Cover	210120	1
18	Circlip 10mm x 1 A TYPE	111713100	1
19	Gasket	200301	1
20	Ball Bearing (8-22-7) 608	110902101	2
21	Inter shaft SA	209911	1
22	Inter Gear (200202)		1
23	Inter Shaft (200201)		1
24	Spindle Gear	200203	1
25	Ball Bearing (17-35-10) 6003 2RS	190905	1
26	Oil Seal	210302	2
27	Gear case	210119	1
28	Phillip head Self Tap Screw 4.8 x 60	201718	4
29	Ball Bearing (20-37-9) 6904 2RS	200903	1
30	Spindle SA	219915	1

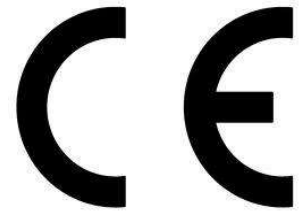
PART NO. 211419 REV: D1

CE/EMC DECLARATION OF CONFORMITY

DECLARING:

Holemaker Technology Ltd (HMT)

OSC, The Forge
Wheelers Lane, Linton
Kent, ME17 4BN
United Kingdom



The above company declares that we are in possession of and satisfied with the CE certification provided by the manufacturing company; with details as follows

That the following Appliance complies with the appropriate basic safety and health requirements of the EC Directives based on its design and type, as brought into circulation by company of manufacture

