



SERVICE PARTS LIST

BULLETIN NO.
55-30-0450

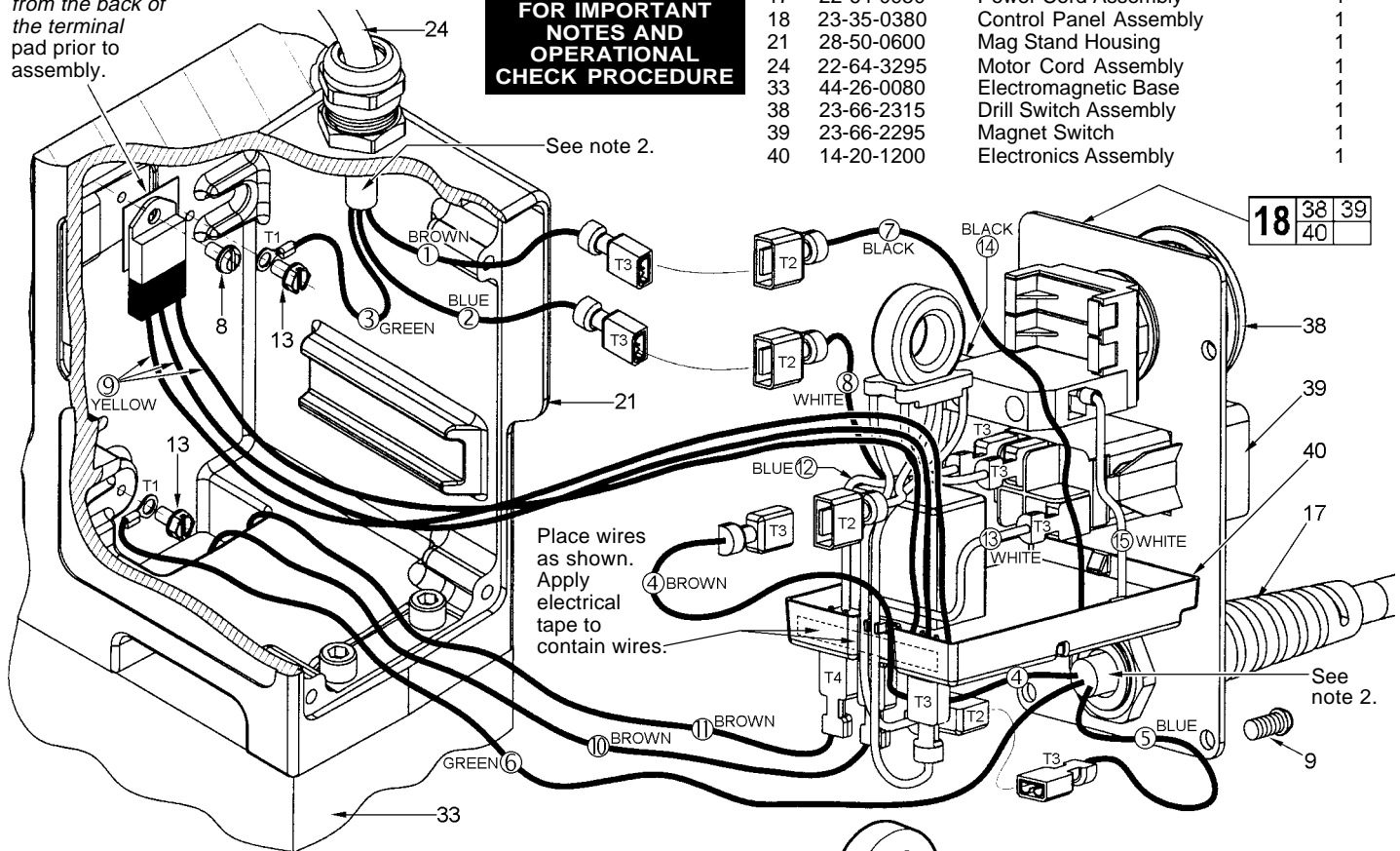
SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
MAG STAND CONTROL PANEL			Nov. 2002
CATALOG NO. 23-35-0380	SERIAL NUMBER	WIRING INSTRUCTION SEE BELOW	

EXAMPLE:
00 0 Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

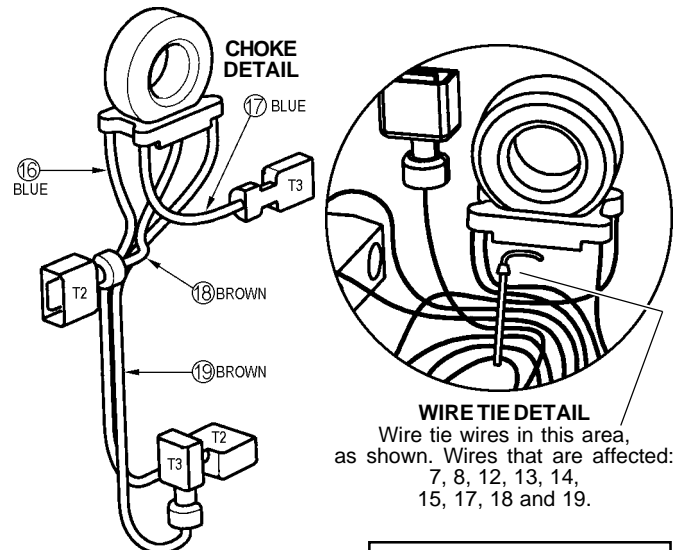
IMPORTANT!
Remove the film from the back of the terminal pad prior to assembly.

SEE REVERSE SIDE BEFORE WIRING FOR IMPORTANT NOTES AND OPERATIONAL CHECK PROCEDURE

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
8	06-81-8650	6-32 x 1/4" Rd. Hd. Sems	1
9	06-82-7252	8-32 x 3/8" Pan Hd. Slit. Tapt. T-20	4
13	06-95-5150	Sems Machine Ground Screw	2
17	22-64-0950	Power Cord Assembly	1
18	23-35-0380	Control Panel Assembly	1
21	28-50-0600	Mag Stand Housing	1
24	22-64-3295	Motor Cord Assembly	1
33	44-26-0080	Electromagnetic Base	1
38	23-66-2315	Drill Switch Assembly	1
39	23-66-2295	Magnet Switch	1
40	14-20-1200	Electronics Assembly	1



- Route two magnetic base leads (brown wires #10 and 11) through the opening in the bottom of the mag stand housing #21.
- Secure the cord #24 from drill in the top opening of the mag stand housing. The cord jacket is to extend .13 to .25 minimum beyond the fittings.
- Secure the power cord assembly #17 to the control panel kit #18. The cord jacket is to extend .13 to .25 minimum beyond the fittings.
- Attach ground terminals from green wires #3 and #6 to mag stand housing with ground screws #13. Orient the terminals as shown.
- Orient terminal pad (component of the potted pcb kit), as shown. **Remove film from the back of the terminal pad** and secure to mag stand housing with screw #8.
- Attach the leads from the magnetic base, as shown. **Note:** the leads from the magnetic base are interchangeable and can be attached to the panel in either location.
- Route brown wire #4 from the power cord assembly next to the wire trap on the electronics assembly, as shown.
- Connect all wires, as shown. In assembly, wires #5, #6, #10 and #11 must be contained beneath the electronics boat.
- Apply electrical tape, as shown, to contain wires on the face of the electronics boat.
- Align the potted boat with the groove in the mag stand housing cavity. Gently push the bundle of wires and the control panel assembly into the housing. Avoid pinching wires as the control panel is being installed.



TERMINAL DESCRIPTION		
Code	Part No.	Qty.
T1	23-74-0895	2
T2	23-74-0440	4
T3	23-74-0430	8
T4	-----	2

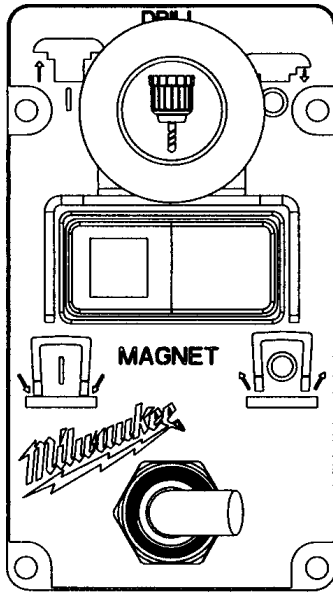
ATTENTION
Observe precautions for handling electrostatic sensitive devices



OPERATIONAL CHECK LIST

1. DIELECTRIC POTENTIAL TESTING

Dielectric potential testing should be conducted on a fully assembled tool that has successfully completed a ground continuity test. The dielectric potential voltage should be between 1200 and 1320 VAC.



2. SET UP

- A. Place the magnetic drill stand on a steel plate.
- B. Verify that the magnet switch is "OFF".
- C. Verify that the drill switch is "OFF".
- D. Plug magnetic drill stand into a 230 V AC receptacle.
*Response: Motor does not operate.
 Red lamp on the magnet switch is off.*

3. MAGNET SWITCH TEST

- A. Push the magnet switch "ON".
*Response: Red lamp on magnet switch is lit.
 The motor does not operate.*
- B. Verify that the magnetic drill stand cannot be easily moved on the steel surface.

4. NORMAL DRILLING

- A. Pull the drill switch "ON".
*Response: Magnet is on, "MAGNET" button is lit,
 drill motor is on (operating).*

5. LINE LOCKOUT

- A. Push the drill switch "OFF".
Response: The motor stops operating.
- B. Push the magnet switch "OFF".
Response: The magnet and red lamp are off.
- C. Pull drill switch "ON".
Response: The motor will not operate.
- D. Turn magnet switch "ON".
*Response: The motor will not operate.
 Magnet is on, "MAGNET" button is lit.*

6. END OF TEST

- A. Turn both switches "OFF".
- B. Unplug magnetic drill stand from 230 V AC receptacle.

23-35-0380 TROUBLE SHOOTING			
ACTION	RESPONSE	POSSIBLE CAUSE	SOLUTION
Magnet is "on". Drill switch is "on".	Tool does not operate. Magnet switch lamp is "on".	1. Drill switch was "on" when magnet was turned "on".	1. Turn drill switch "off", then back "on".
		2. Control module is damaged.	2. Replace control module.
Magnet switch is turned "on".	Magnet switch lamp turns "on", then "off".	1. Magnet is damaged.	1. Check magnet resistance, 970 to 1000 ohms.
		2. Wiring from magnet to control module is damaged.	2. Repair or replace wiring.
		3. Control module is damaged.	3. Replace control module.
		4. Voltage is too low/ extension cord is too long or wrong gauge.	4. Check for 230 VAC at cord end. Check extension cord length and gauge.
Magnet switch is turned "on". Drill switch is turned "on".	Magnet switch lamp is on, turns off when drill switch is turned "on".	1. Motor brushes are worn.	1. Replace brushes.
		2. Control module is damaged.	2. Replace control module.