



# Operating Instructions and Parts Manual 20-inch Gear Head Drill with Powerfeed

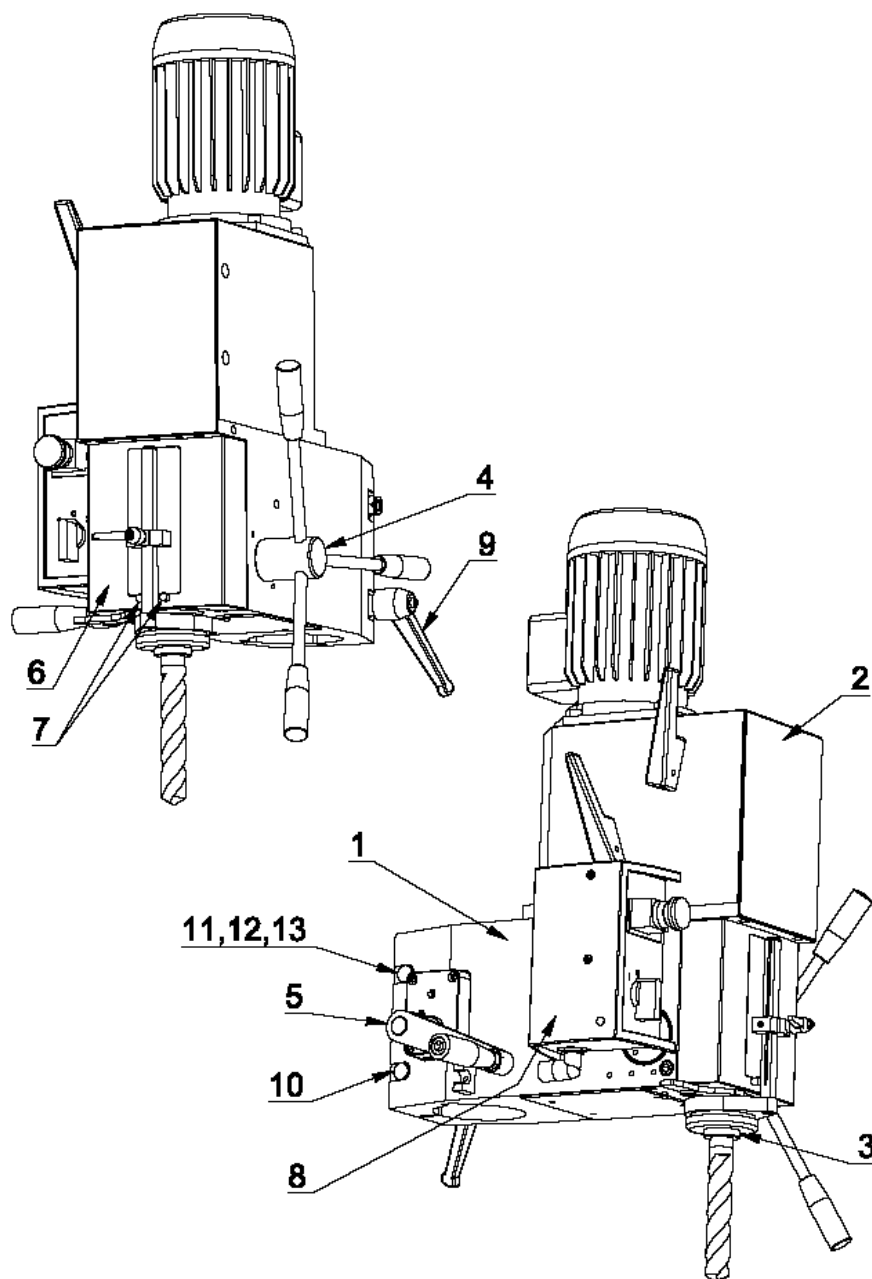
Modes J-A2608M-PF2, J-A2608M-PF4



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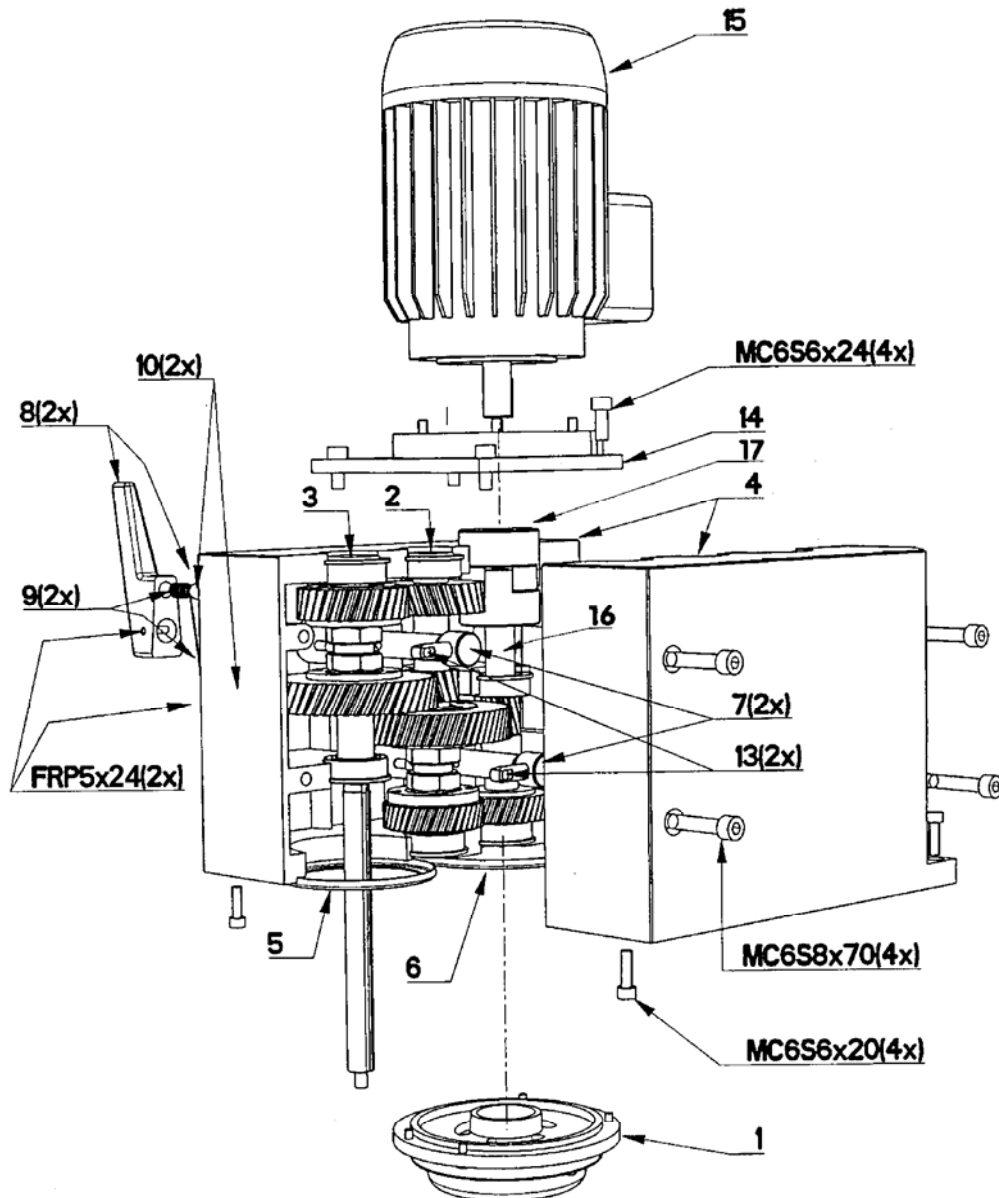
**Part No. M-354030**  
Revision G 07/2015  
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## Spindelhuvud – Drill head – Bohrkopf



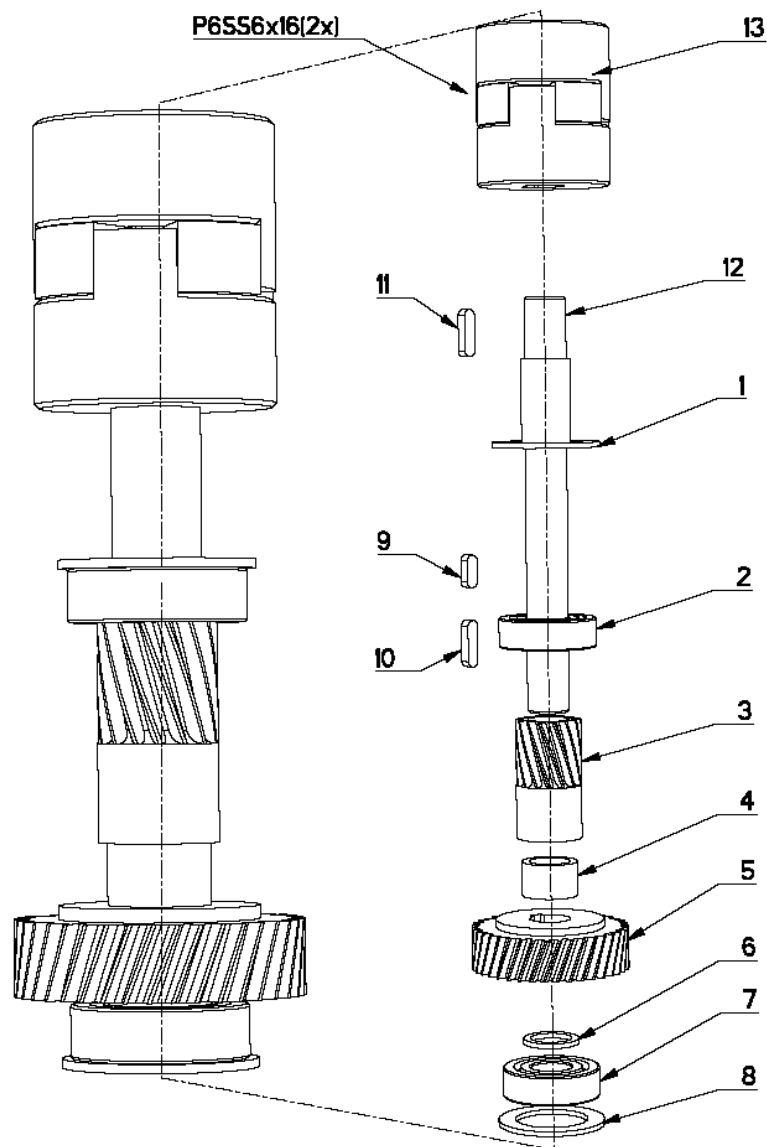
| Pos | Art. No.   | Benämning          | Description        | Benennung            | Not     |
|-----|------------|--------------------|--------------------|----------------------|---------|
| 1.  | 2X08770    | Spindelhus         | Spindle housing    | Spindelgehäuse       |         |
| 2.  | 2X08774    | Växellåda          | Gear box           | Getriebekasten       |         |
| 3.  | 2X08710    | Spindelhylsa       | Spindle sleeve     | Spindelhülse         |         |
| 4.  | 2X08752R   | Matningsaxel komp. | Feed shaft compl.  | Vorschubwelle kompl. |         |
| 5.  | 2X08720-1R | Snäckväxel         | Worm gear unit     | Schneckenwechsel     |         |
| 6.  | 2X08702    | Frontkåpa          | Front cover        | Frontdeckel          |         |
| 7.  | 3P01407    | Pinne              | Pin                | Stift                | CP 8x36 |
| 8.  | 4U08775    | Elboxkåpa          | Electric box cover | Elektrokastengehäuse |         |
| 9.  | 3R00014    | Ställbar låsspak   | Locking lever      | Sperrarm             |         |
| 10. | 3S02556    | Skruv M6S          | Screw              | Schraube             | 12x120  |
| 11. | 3S02558    | Skruv M6S          | Screw              | Schraube             | 12x130  |
| 12. | 3M09122    | Låsmutter          | Locking nut        | Sicherungsmutter     | M12     |
| 13. | 3B04178    | Bricka TRB         | Washer             | Scheibe              | 13x24x4 |

# Växellåda – Gear box – Getriebegehäuse



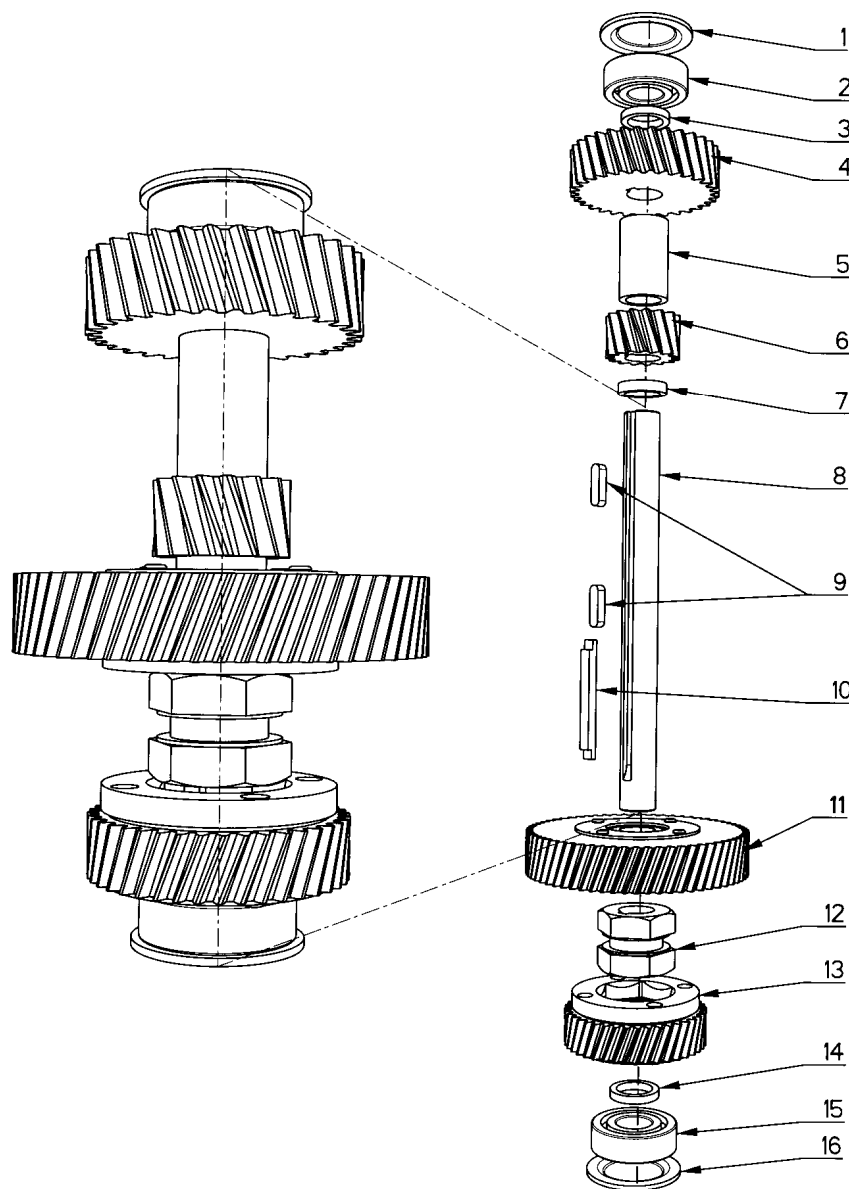
| Pos | Art. No.  | Benämning         | Description         | Benennung        | Not  |
|-----|-----------|-------------------|---------------------|------------------|------|
| 1.  | 4L02502-2 | Täckplåt          | Cover plate         | Abdeckplatte     |      |
| 2.  | 2X08404-2 | 2:a axel kompl.   | 2:nd shaft complete | 2:e Welle kompl. |      |
| 3.  | 2X08404-3 | 3:e axel kompl.   | 3:rd shaft complete | 3:e Welle kompl. |      |
| 4.  | 2X08772   | Växellådshus kpl. | Gear box complete   | Getriebekasten   |      |
| 5.  | 4B00174   | Styrring          | Ring                | Ring             |      |
| 6.  | 4B00173   | Styrring          | Ring                | Ring             |      |
| 7.  | 2X08536   | Skiftarm          | Gear selector arm   | Schaltarm        |      |
| 8.  | 4RS0653-1 | Växelspak         | Gear lever          | Schalthebel      |      |
| 9.  | 4C02921   | Fjäder            | Gear                | Feder            |      |
| 10. | 3T04028   | Stålkula          | Steel ball          | Schaltgriff      |      |
| 13. | 4T04168   | Skiftstift        | Shift pin           | Stift            |      |
| 14. | 2N08624   | Motorfläns        | Motor flange        | Motorflansch     |      |
| 15. | 3E03005   | Motor             | Motor               | Motor            | 230V |
| 17. | 2X08727   | 1:a axel kompl.   | 1:st shaft complete | 1:e Welle kompl. |      |

## Motoraxel – Engine shaft – Motorwelle



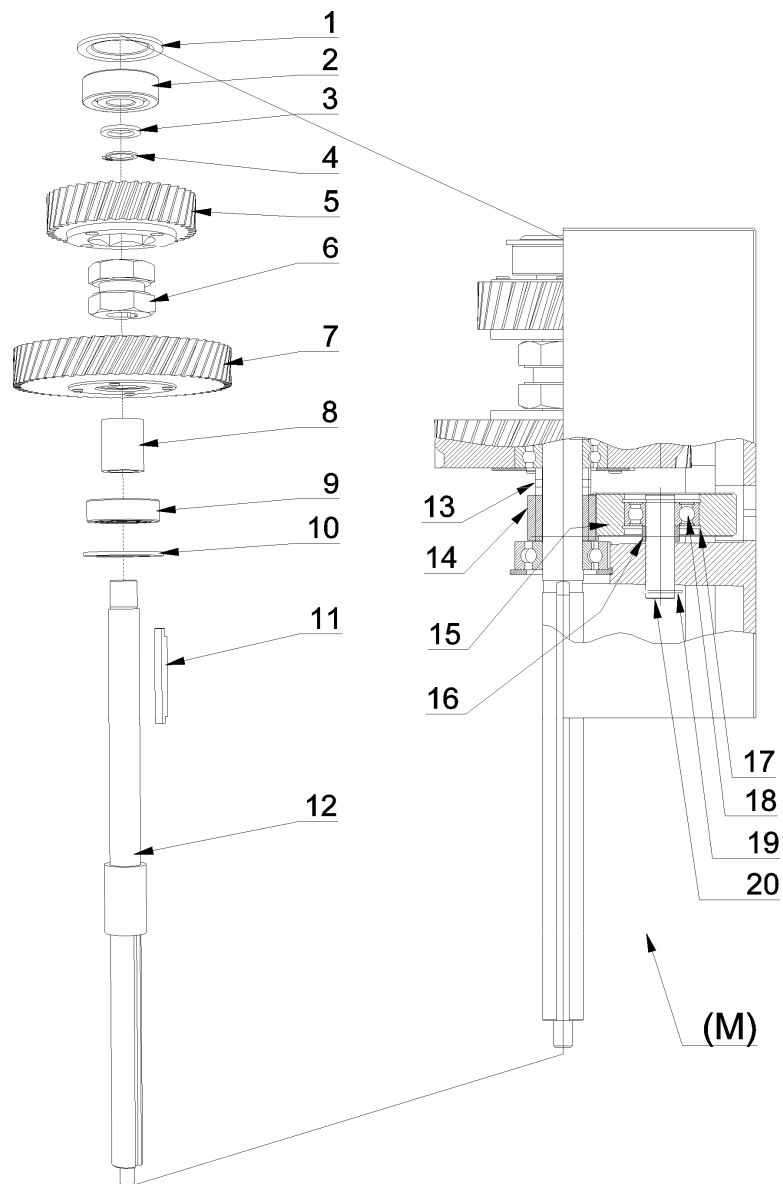
| Pos | Art. No. | Benämning          | Description    | Benennung      | Not    |
|-----|----------|--------------------|----------------|----------------|--------|
| 1.  | 4B00137  | Lock               | Washer         | Scheibe        |        |
| 2.  | 3L11003  | Enrad spårkullager | Ball bearing   | Kugellager     | 6203   |
| 3.  | 2H07969  | Kugghjul           | Gear           | Zahnrad        | 15-1,5 |
| 4.  | 2D17014  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x14  |
| 5.  | 2H07972  | Kugghjul           | Gear           | Zahnrad        | 39-1,5 |
| 6.  | 2D17002  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x2   |
| 7.  | 3L11003  | Enrad spårkullager | Ball bearing   | Kugellager     | 6203   |
| 8.  | 4B00137  | Lock               | Washer         | Scheibe        |        |
| 9.  | 3K00184  | Kil                | Key            | Keil           | 5x5x14 |
| 10. | 3K00187  | Kil                | Key            | Keil           | 5x5x20 |
| 11. | 3K00230  | Kil                | Key            | Keil           | 6x6x20 |
| 12. | 2A08727  | Axel               | Shaft          | Welle          |        |
| 13. | 3XS0659  | Axelkoppling       | Shaft coupling | Wellenkupplung |        |

## 2:a axel – 2:nd shaft – 2:e Welle



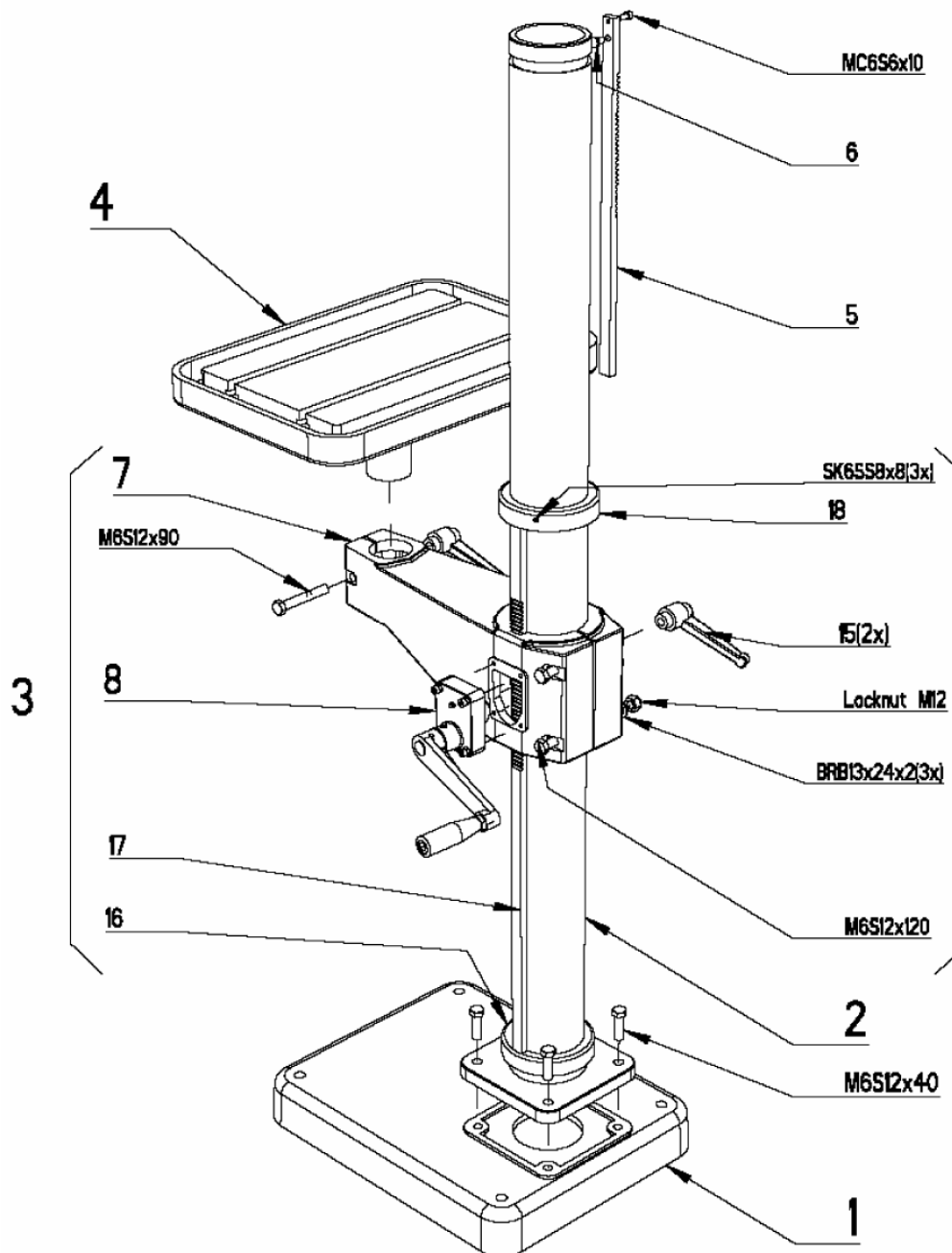
| Pos | Art. No. | Benämning          | Description    | Benennung      | Not    |
|-----|----------|--------------------|----------------|----------------|--------|
| 1.  | 4B00138  | Lock               | Washer         | Scheibe        | C-138  |
| 2.  | 3L11003  | Enrad spårkullager | Ball bearing   | Kugellager     | 6203   |
| 3.  | 2D00009  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x3,5 |
| 4.  | 2H07971  | Kuggjul            | Gear           | Zahnrad        | 32-2   |
| 5.  | 2D17038  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x38  |
| 6.  | 2H07970  | Kuggjul            | Gear           | Zahnrad        | 15-2   |
| 7.  | 2D00013  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x5   |
| 8.  | 2A04871  | 2:a axel           | 2:nd shaft     | 2:e Welle      | C-4871 |
| 9.  | 3K01187  | Kil                | Key            | Keil           | 5x5x20 |
| 10. | 2T06615  | Övre kil           | Key            | Keil           | C-6615 |
| 11. | 2X08408R | Kuggjul kompl.     | Gear complete  | Zahnrad kompl. | 64-1,5 |
| 12. | 2T04254  | Kopplingsklo       | Clutch         | Kupplung       | C-4254 |
| 13. | 2X08406R | Kuggjul kompl.     | Gear complete  | Zahnrad kompl. | 40-1,5 |
| 14. | 2D00009  | Distanshylsa       | Spacing sleeve | Distanzhülse   | 17x3,5 |
| 15. | 3L11003  | Enrad spårkullager | Ball bearing   | Kugellager     | 6203   |
| 16. | 4B00138  | Lock               | Cover          | Deckel         | C-138  |

### 3:e axel – 3:rd shaft – 3:e Welle



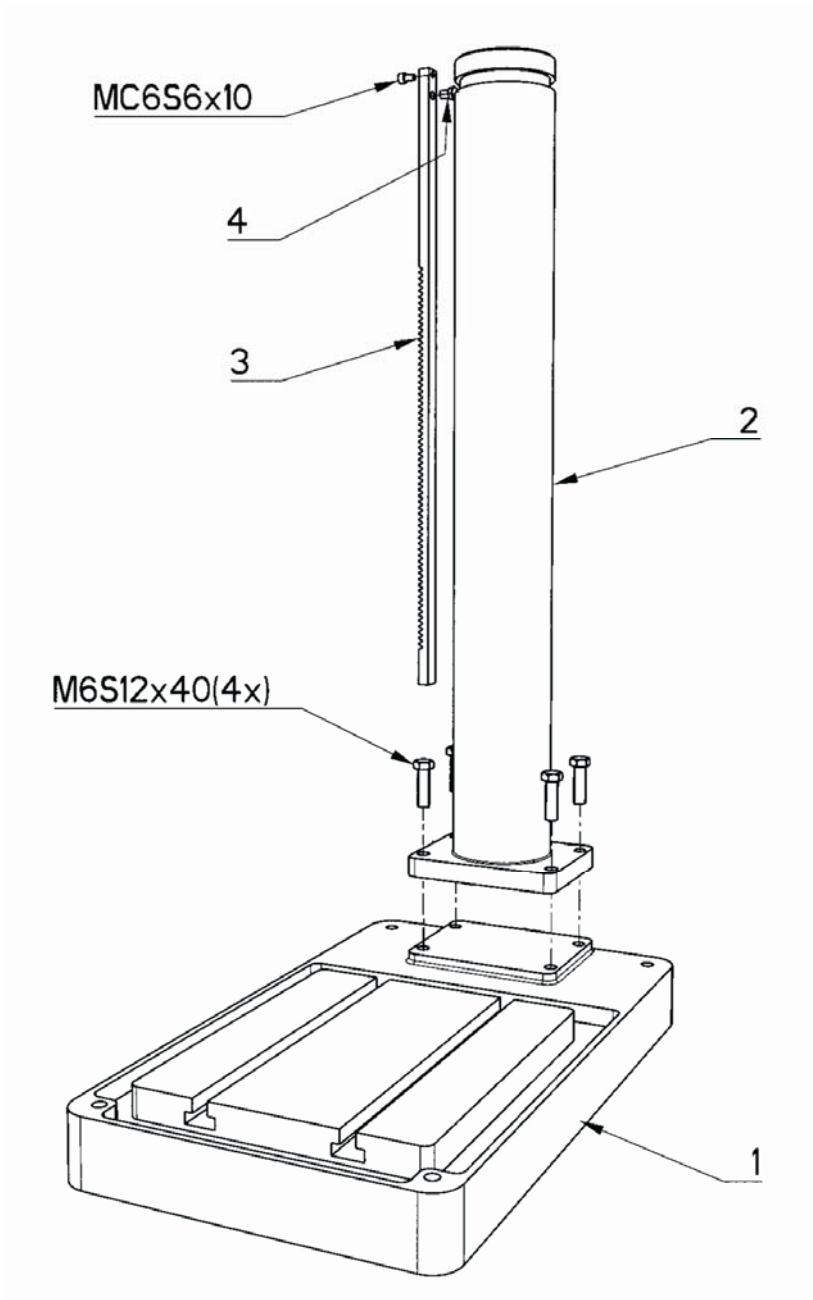
| Pos  | Art. No.   | Benämning            | Description        | Benennung              | Not      |
|------|------------|----------------------|--------------------|------------------------|----------|
| 1.   | 4B08584    | Lock                 | Cover              | Deckel                 | C-138    |
| 2.   | 3L16002    | Enrad spårkullager   | Ball bearing       | Kugellager             | 6302     |
| 3.   | 3D15002    | Distanshylsa         | Spacing sleeve     | Distanzhülse           | 15x2     |
| 4.   | 3C01117    | Spårring             | Circlip            | Führungsring           | SgA 15   |
| 5.   | 2X08413R   | Kuggghjul kompl.     | Gear complete      | Zahnrad kompl.         | 32-2     |
| 6.   | 2T04254    | Kopplingsklo         | Clutch             | Kupplung               | C 4254   |
| 7.   | 2X08411R   | Kuggghjul kompl.     | Gear complete      | Zahnrad kompl.         | 49-2     |
| 8.   | 2D00006    | Distanshylsa         | Spacing sleeve     | Distanzhülse           | 17x31,5  |
| 9.   | 3L11003    | Enrad spårkullager   | Ball bearing       | Kugellager             | 6203     |
| 10.  | 4B00137    | Lock                 | Cover              | Deckel                 | C-137    |
| 11.  | 2T06615    | Övre kil             | Key                | Keil                   | C-6615   |
| 12.  | 2A08410    | 3:e axel             | 3:rd shaft         | 3:e Welle              | B-8410   |
| 13a. | 2D00011    | Distanshylsa 17x4,5  | Spacer 17x4,5      | Distanzhülse 17x4,5    | 2 st/pcs |
| 13b. | 2D00009    | Distanshylsa 17x3,5  | Spacer 17x3,5      | Distanzhülse 17x3,5    | 1 st/pc  |
| 14.  | 2HSB7501-1 | Kuggghjul            | Gear wheel         | Zahnrad                | 18-1,5   |
| 15.  | 2X08558    | Mellanhjul kompl.    | Gear feed complete | Vorschubzahnrad kompl. |          |
| 16.  | 4D12006    | Distanshylsa         | Spacer             | Distanzhülse           | 12x6,5   |
| 17.  | 3C02131    | Spårring SGH 32      | Circlip SGH 32     | Sicherungsring SGH 32  | 2st/pcs  |
| 18.  | 3L13001    | Kullager             | Bearing            | Kugellager             | 6201 2Z  |
| 19.  | 3C01114    | Spårring             | Circlip            | Sicherungsring         | SGA 12   |
| 20.  | 2A08441    | Axel till mellanhjul | Feed gear shaft    | Welle Vorschubzahnrad  |          |

## Pelare – Column – Säule



| Pos | Art. No.   | Benämning         | Description        | Benennung                | Not    |
|-----|------------|-------------------|--------------------|--------------------------|--------|
| 1.  | 1B03013    | Fotplatta         | Base plate         | Fussplatte               |        |
| 2.  | 4X08300    | Pelare            | Column             | Säule                    | L=1500 |
| 3.  | 2X08723    | Bordarm kompl.    | Table arm complete | Tischarm kompl.          |        |
| 4.  | 2WS1231    | Fyrkantsbord      | Table              | Tisch                    |        |
| 5.  | 2X08445    | Kuggstång         | Rack               | Zahnstange               |        |
| 6.  | 2T07146    | Tapp              | Pin                | Zapf                     |        |
| 7.  | 2Y08723    | Bordarm           | Table arm          | Tischarm                 |        |
| 8.  | 2X08720-1R | Snäckväxel kompl. | Worm gear complete | Schneckengetriebe kompl. |        |
| 16. | 2N00186R   | Nedre ring        | Lower ring         | Unterer Ring             |        |
| 17. | 2I03598    | Kuggstång         | Rack               | Zahnstange               |        |
| 18. | 2N03668R   | Övre ring         | Upper ring         | Oberer Ring              |        |

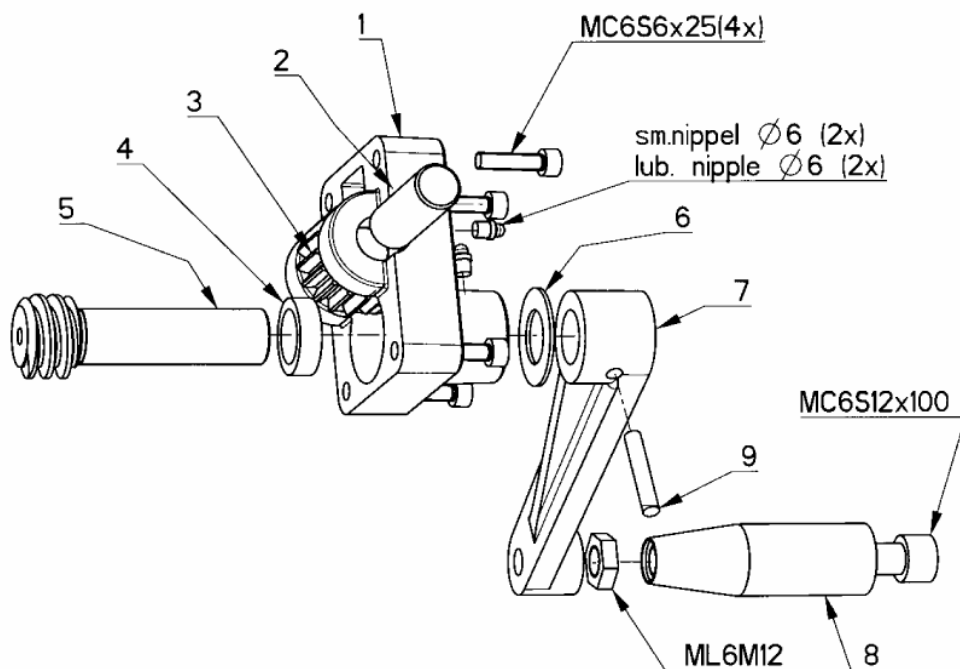
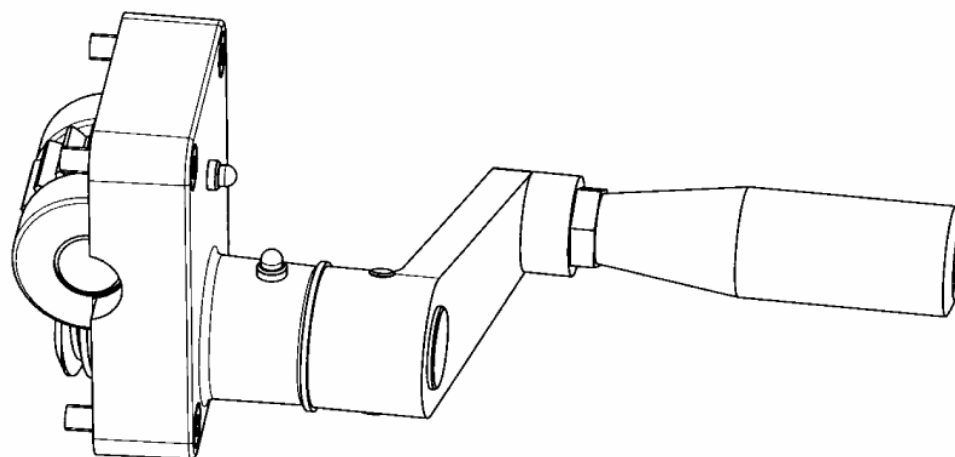
## Pelare bänk – Column bench type drill – Säule Tischbohrmaschine



| Pos | Art. No. | Benämning        | Description | Benennung  | Not |
|-----|----------|------------------|-------------|------------|-----|
| 1.  | 1B03016  | Bänkplatta       | Base plate  | Fussplatte |     |
| 2.  | 4ZS1232  | Bänkelare        | Column      | Säule      |     |
| 3.  | 2X08545  | Kuggstång kompl. | Rack        | Zahnstange |     |
| 4.  | 2T07146  | Tapp             | Pin         | Zapfen     |     |

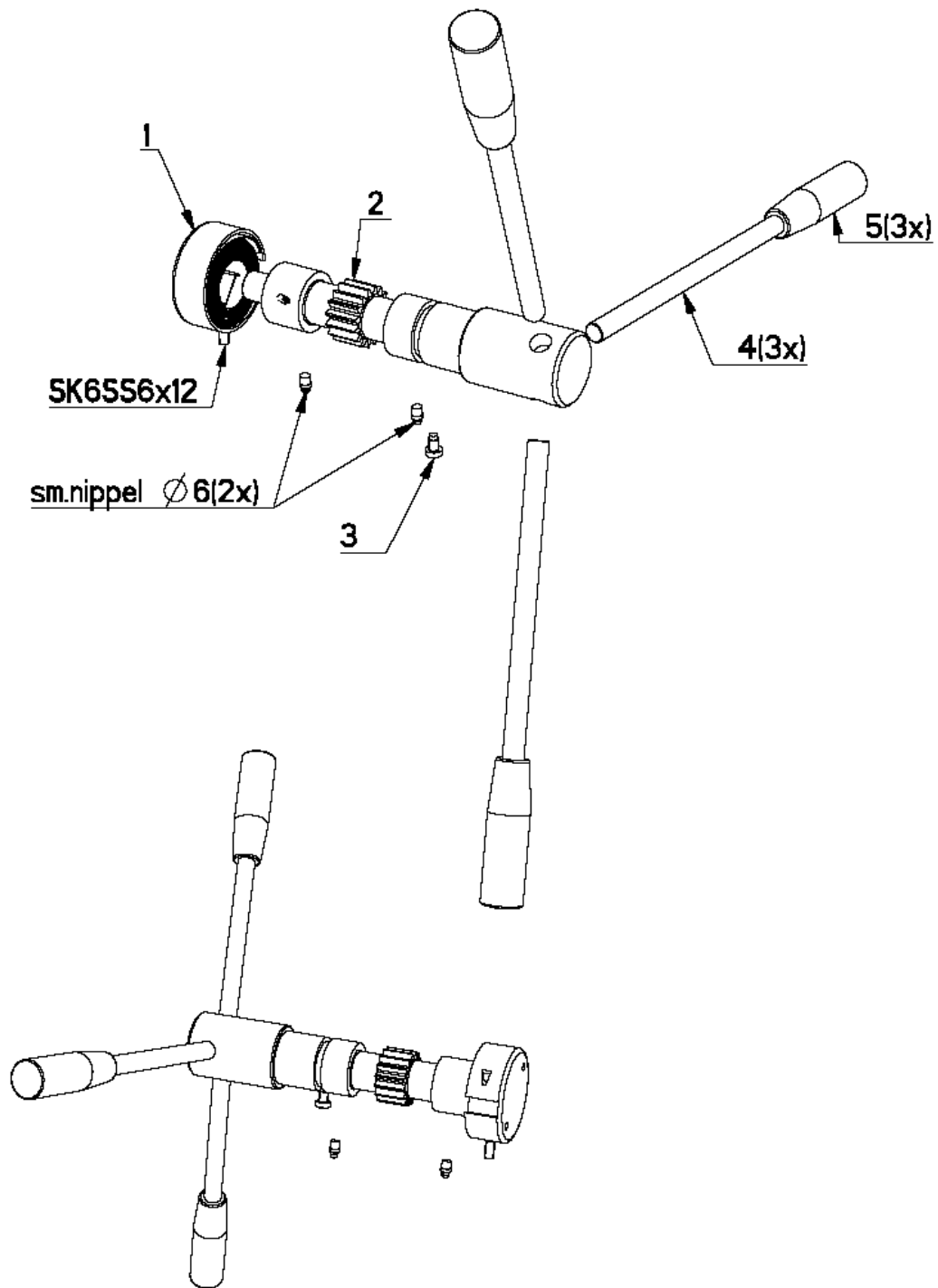


2X08720 – Snäckväxelhus kompl. – Worm gear box compl. – Schneckengetriebegehäuse kompl.



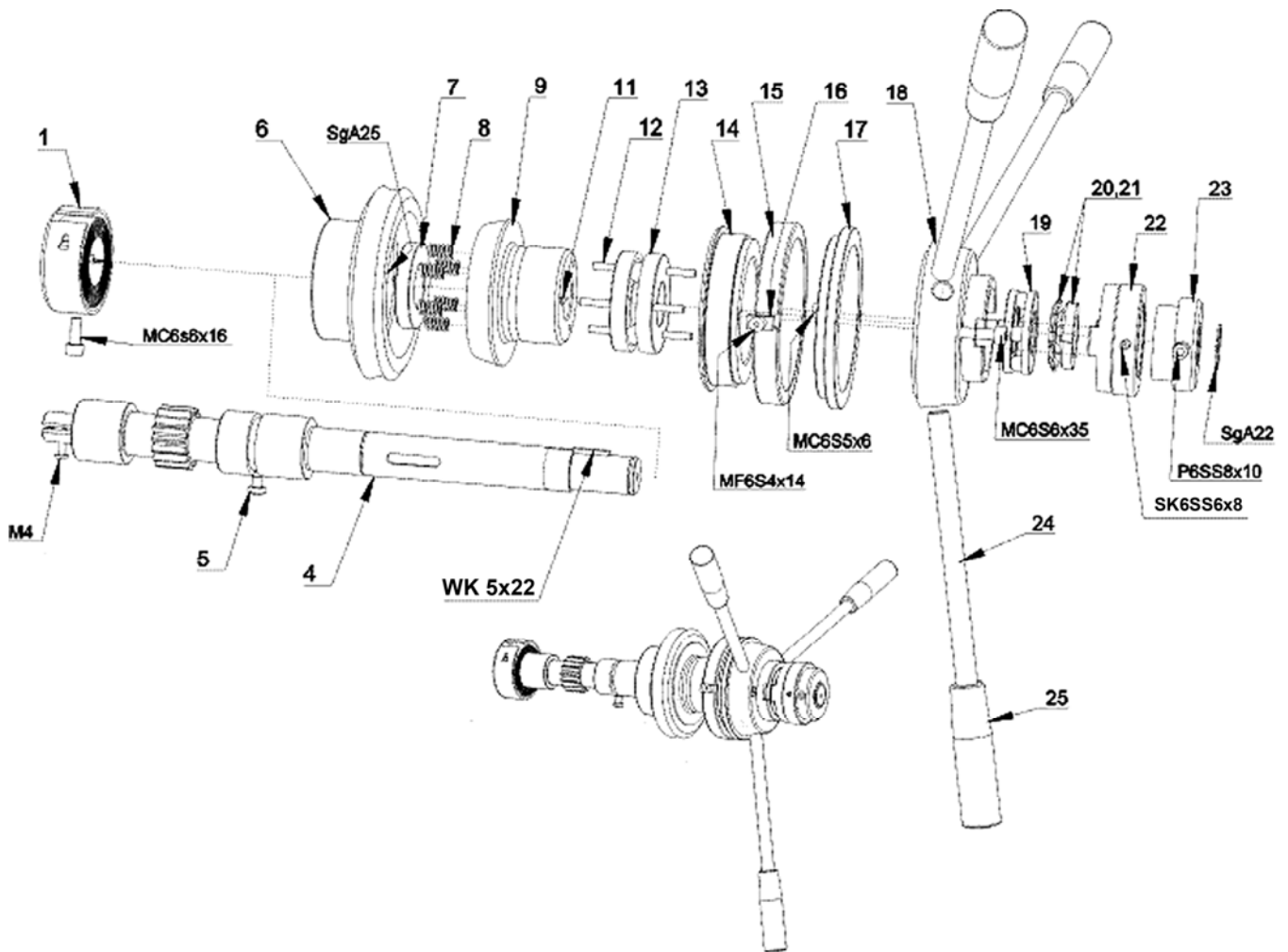
| Pos | Art. No. | Benämning     | Description   | Benennung                | Not       |
|-----|----------|---------------|---------------|--------------------------|-----------|
| 1.  | 2N08720  | Snäckväxelhus | Worm gear box | Schneckengetriebegehäuse |           |
| 2.  | 2A08725  | Axel          | Shaft         | Welle                    |           |
| 3.  | 2HS1201  | Kuggjul       | Gear          | Zahnrad                  |           |
| 4.  | 2D20008  | Distansring   | Spacer        | Distanzring              | 20x8      |
| 5.  | 2IS1203  | Snäckskruv    | Worm shaft    | Schneckenwelle           |           |
| 6.  | 3L00021  | Glidbricka    | Washer        | Scheibe                  |           |
| 7.  | 2RS1182  | Vev           | Crank         | Kurbel                   |           |
| 8.  | 3R01106  | Handtag       | Handle        | Ballengriff              |           |
| 9.  | 3S04444  | Skruv         | Screw         | Schraube                 | SK6SS 8x8 |

## Matningsaxel (manuell) – Feed shaft (manual) – Vorschubwelle (manuell)



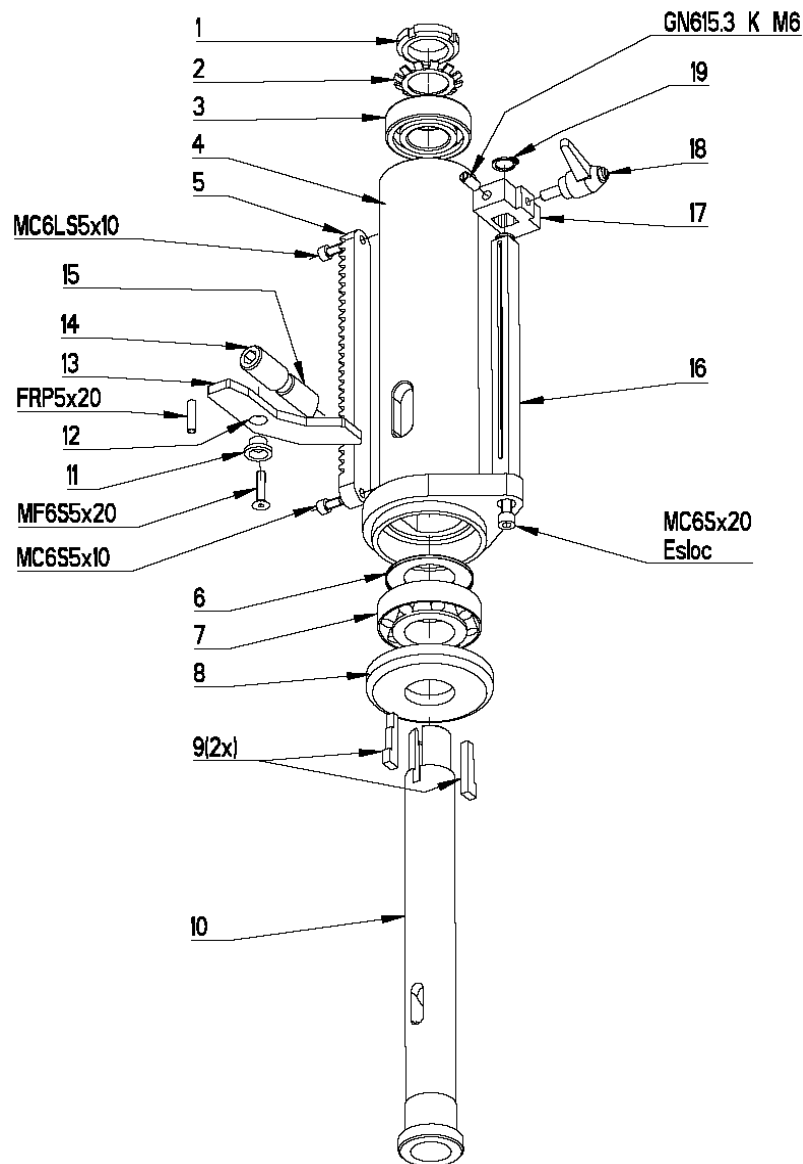
| Pos | Art. No. | Benämning        | Description         | Benennung           | Not      |
|-----|----------|------------------|---------------------|---------------------|----------|
| 1.  | 4XS2150  | Fjäderhus kompl. | Spring housing cpl. | Federgehäuse kompl. |          |
| 2.  | 2I08752  | Matningsaxel     | Feed shaft          | Vorschubwelle       |          |
| 3.  | 4S04211  | Tappskruv        | Pin screw           | Zapfschraube        |          |
| 4.  | 2E08758  | Matningsspak     | Feed lever          | Vorschubhebel       | 3 st/pcs |
| 5.  | 3R04004  | Handtag          | Handle              | Ballengriff         | 3 st/pcs |

## Matningsaxel (M) – Feed shaft (M) – Vorschubwelle (M)



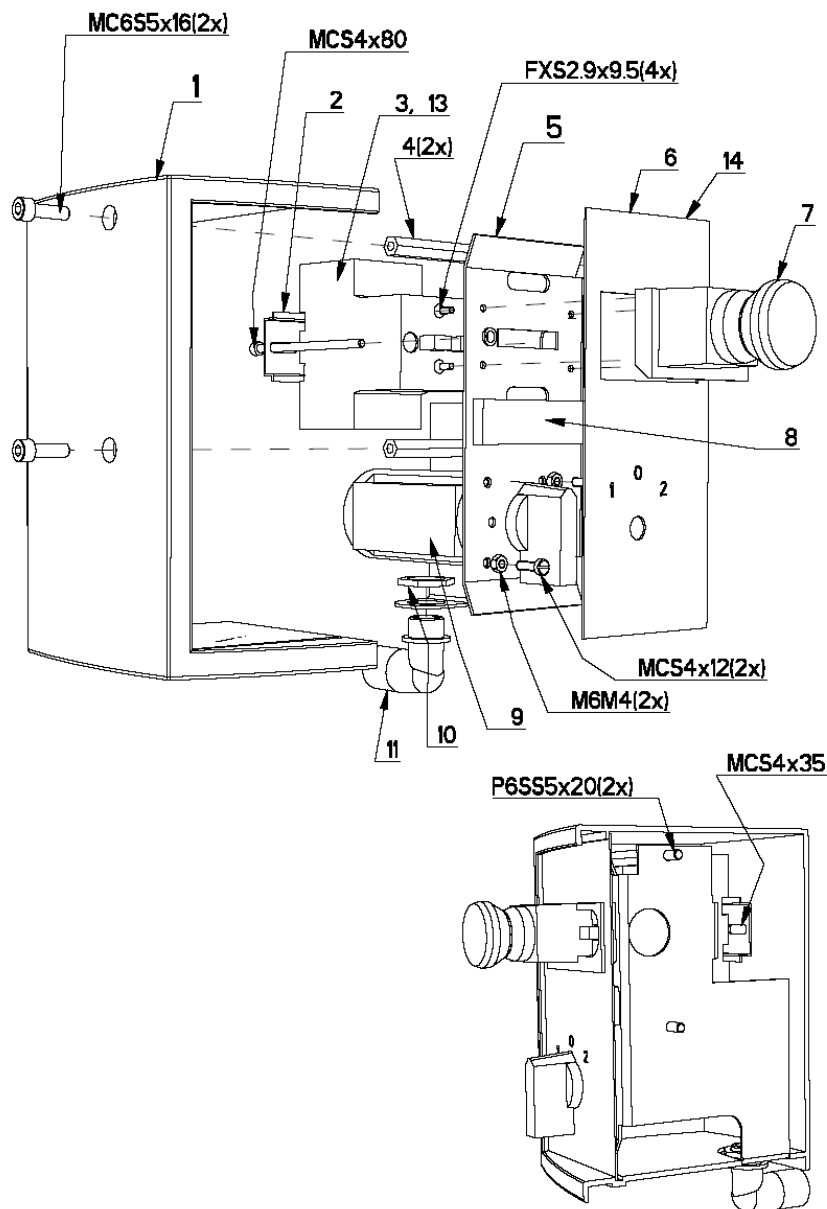
| Pos | Art. No.     | Benämning           | Description        | Benennung        | Note  |
|-----|--------------|---------------------|--------------------|------------------|-------|
| 1   | 4XS2150      | Returfjäder         | Return spring      | Rückholfeder     |       |
| 4   | 2I08456      | Matningsaxel        | Feed shaft         | Vorschubwelle    |       |
| 5   | 4S04211      | Styrskruv           | Guide screw        | Führungsschraube |       |
| 6   | 2ISB7523-2   | Snäckhjul           | Worm wheel         | Schneckenrad     |       |
| 7   | 2TSB142081   | Tryckplatta         | Pressure plate     | Druckscheibe     |       |
| 8   | 4CSB548090-2 | Tryckfjäder         | Clutch head spring | Druckfeder       | 6 st. |
| 9   | 2NSB142080   | Kopplingshuvud      | Clutch head        | Kupplungskopf    |       |
| 11  | 3K01235      | Kil                 | Key                | Keil             |       |
| 12  | 3P07257      | Stift               | Pin                | Stift            | 6 st. |
| 13  | 2TSB548091   | Kopplingsskiva      | Clutch half        | Kupplungsscheibe |       |
| 14  | 2TSB548092   | Låsring             | Lock ring          | Schliessring     |       |
| 15  | 2TSB548093-1 | Anslagsring         | Stop ring          | Stoppring        |       |
| 16  | 2TSB548093-3 | Anslagsklack        | Trip dog lip       | Anschlag         |       |
| 17  | 2TSB548093-2 | Ställring           | Adjusting ring     | Einstellung      |       |
| 18  | 2TSB548094   | Handspaksfäste      | Handle holder      | Griffhalter      |       |
| 19  | 3L61005      | Axialkullager       | Bearing            | Lager            |       |
| 20  | 3B07005      | Låsbricka           | Locking washer     | Blechsicherung   |       |
| 21  | 3M06005      | Mutter              | Nut                | Mutter           |       |
| 22  | 2TSB548096-1 | Klokoppling         | Coupling clutch    | Klauenkupplung   |       |
| 23  | 2TSB548096-2 | Nav för klokoppling | Coupling hub       | Kupplungsnav     |       |
| 24  | 2E02854      | Spak                | Feed lever         | Vorschubhebel    | 3 st. |
| 25  | 3R01005      | Handtag             | Handle             | Ballengriff      | 3 st. |

## Spindelhylsa – Spindle sleeve – Spindelhülse



| Pos | Art. No.   | Benämning          | Description          | Benennung         | Not        |
|-----|------------|--------------------|----------------------|-------------------|------------|
| 1.  | 3M06005    | Mutter             | Nut                  | Mutter            | MK 5       |
| 2.  | 4B00155    | Låsbricka          | Locking washer       | Sicherungsscheibe |            |
| 3.  | 3L15005    | Enrad.spårkullager | Ball bearing         | Kugellager        | 6205       |
| 4.  | 2G08710    | Spindelhylsa       | Spindle sleeve       | Spindelhülse      |            |
| 5.  | 2I08753    | Kuggstång          | Rack                 | Zahnstange        |            |
| 6.  | 4B03769    | Bricka             | Washer               | Scheibe           |            |
| 7.  | 3L51006    | Kon.rullager       | Taper roller bearing | Rollenlager       | 30206      |
| 8.  | 2TS1106    | Rullagerlock       | Roller bearing cover | Rollenlagerdeckel |            |
| 9.  | 2T08386    | Kil                | Key                  | Keil              |            |
| 10. | 2A08418-1R | Borrspindel        | Spindle              | Bohrspindel       |            |
| 11. | 2T08593    | Distanshylsa       | Spacing sleeve       | Distanzhülse      |            |
| 12. | 3B06003    | Bricka             | Washer               | Scheibe           |            |
| 13. | 2T08547    | Anslag             | Stop                 | Anschlag          |            |
| 14. | 3S08622    | Skruv              | Screw                | Schraube          | P6SS 16x25 |
| 15. | 2T08714    | Klämback           | Collet jaw           | Klemmbacke        |            |
| 16. | 2A08755    | Djupmåttstång      | Depth gauge rod      | Tiefenmassstange  |            |
| 17. | 2T08757    | Stopp för matning  | Stop                 | Anschlag          |            |
| 18. | 3R00002    | Handtag            | Locking lever        | Klemmhebel        | M6x16      |
| 19. | 3C01114    | Spårring           | Circlip              | Führungsring      | SgA12      |

## 2X08705 – Ellåda – Electric Box – Elektrokasten



| Pos | Art. Nr.  | Benämning                          | Description                           | Benennung                            | Not       |
|-----|-----------|------------------------------------|---------------------------------------|--------------------------------------|-----------|
| 1.  | 2U08705   | Elboxkåpa                          | Electric box cover                    | Elektrokastengehäuse                 |           |
| 2.  | 2L08712   | Ankarsken                          | Rail anchor                           | Schienenklemme                       |           |
| 3.  | 3E10606   | Motorskydd                         | Motor protector                       | Motorschutz                          | 230V 50Hz |
| 4.  | 2E08713   | Elboxdistanspinne                  | Electric box dist. tube               | Elektrokasten Abstandstift           |           |
| 5.  | 4L08706   | Fästplåt                           | Anchor plate                          | Halteblech                           |           |
| 6.  | 4L08711-X | Elboxpanel                         | Electric box plate                    | Elektrokastenschild                  |           |
| 7.  | 3E16227   | Nödstoppknapp                      | Emergency stop                        | Notstopp                             |           |
| 8.  | 3T18003   | Svampgummilist                     | Rubber moulding                       | Gummifassung                         | 15x8 L=50 |
| 9.  | 3E06023   | Handpolomkopl.                     | Pole reverser                         | Polumschalter                        |           |
| 10. | 3E19083   | Kontramutter                       | Nut                                   | Mutter                               |           |
| 11. | 3E19225   | Förskruvning                       | Nipple                                | Verschraubung                        |           |
| 13. | 3E10613   | Undersp.utlösare                   | Low volt release                      | Unterspannungsauslöser               | 230V 50Hz |
| 14. |           | Används ej                         | Not in use                            | Wird nicht verwendet                 |           |
| 15. | 3E12006   | Drift-Kondensator<br>(inte i bild) | Run-Condensator<br>(not in picture)   | Trieb-Kondensator<br>(nicht im Bild) |           |
| 16. | 3E12007   | Start-Kondensator<br>(inte i bild) | Start-Condensator<br>(not in picture) | Start-Kondensator<br>(nicht im Bild) |           |