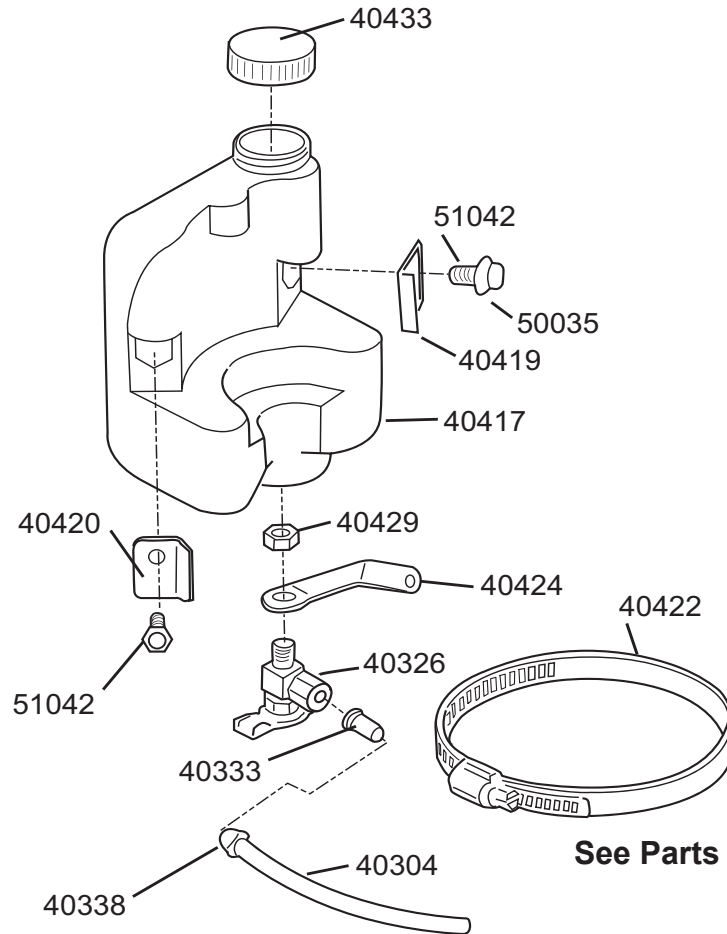


# COOLANT BOTTLE ASSEMBLY - P/N: 40442



See Parts List on Page 15

## Checking Operation of Automatic Cutting Fluid Inducer

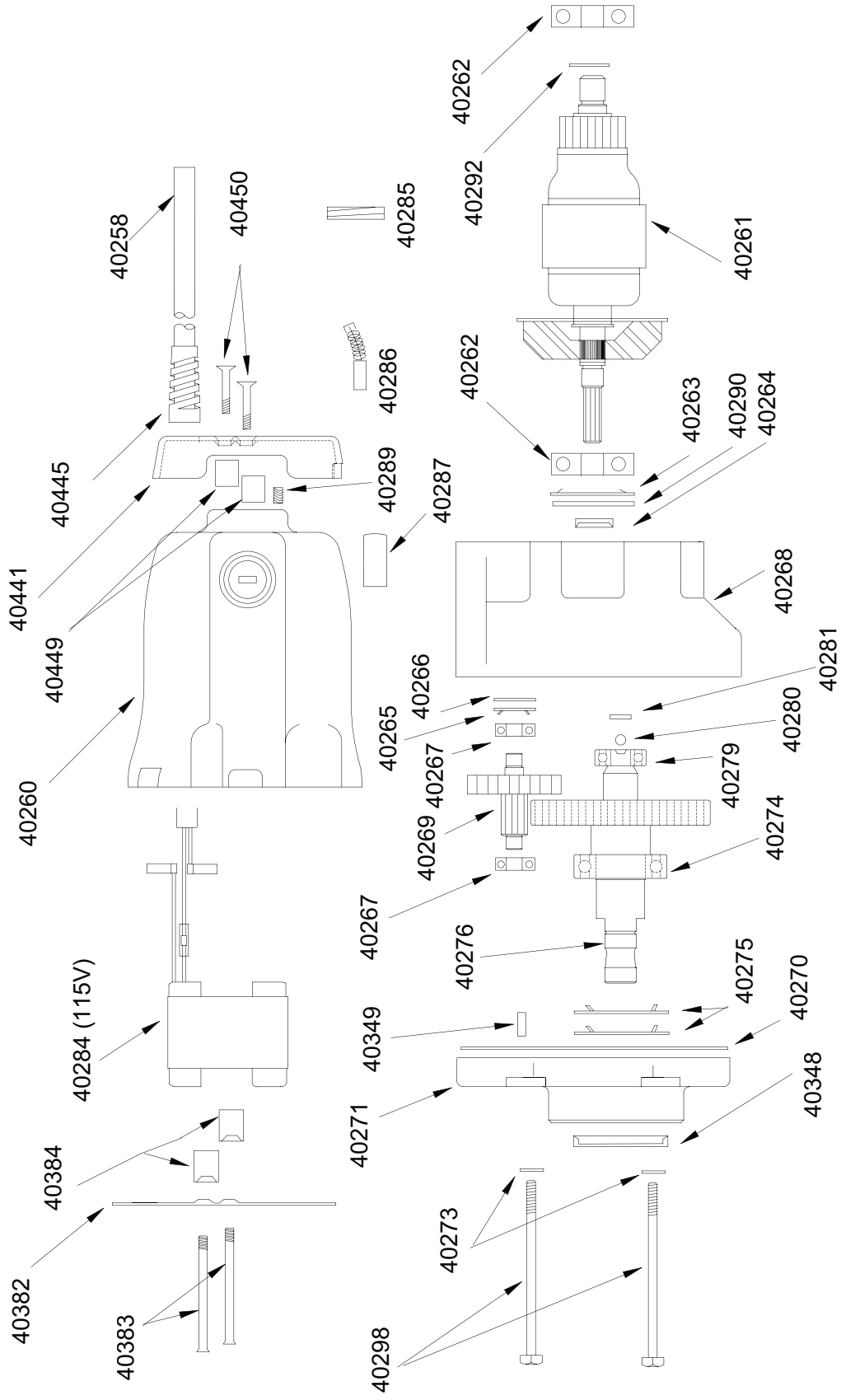
*Note: The automatic cutting fluid inducer system works on a gravity flow basis. Therefore, it is only effective when the drill is mounted on a horizontal or slightly inclined work surface.*

1. With Magnetic Drill in operation position, turn feed handle so that the cutter and pilot are above the work surface.
2. Fill cutting fluid bottle with cutting fluid.
3. To test automatic cutting fluid inducer (with the magnet ON and motor OFF), feed the arbor gently toward the work surface until the pilot is pushed up into the cutter. Open the needle valve until fluid is visible filling the plastic tube. Fluid should filter down onto the work surface through the groove in the pilot.
4. To insure proper cutter lubrication, always make sure that the slot in the pilot is kept clean from residual buildup.

## Checking Operation of Cutting Fluid Arbor Reservoir (HMD914S)

1. With magnetic drill in operating position, turn feed handle so that cutter and pilot are above the work surface.
2. With magnet turned ON and Motor OFF, fill reservoir by introducing cutting fluid through slots in Arbor. Cutting fluid should not leak out.
3. Test metering capabilities of Arbor/Cutter/ Pilot assembly (magnet ON-motor OFF) by feeding the Arbor gently toward work surface until pilot is pushed up into Cutter, thus allowing fluid to filter down onto work surface through groove in pilot.
4. For proper lubrication, all cutting fluid in reservoir should empty onto work surface in no less than 15 seconds and no more than 30 seconds.

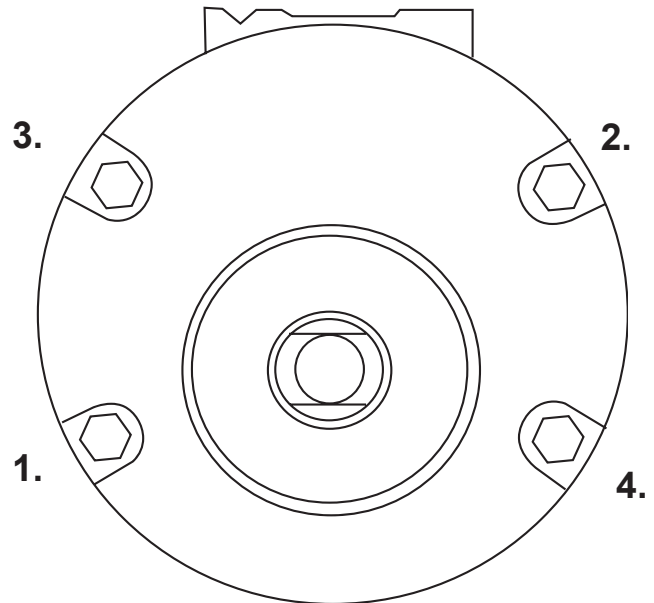
# Motor Exploded View and Parts List



**40287** Torque to 4 - 6 in/lb  
**40383** Torque to 15 - 25 in/lb (Use Loctite® #242)  
**40287** Loctite® #271 to outside of Brush Holder

## Motor Bolt Sequence

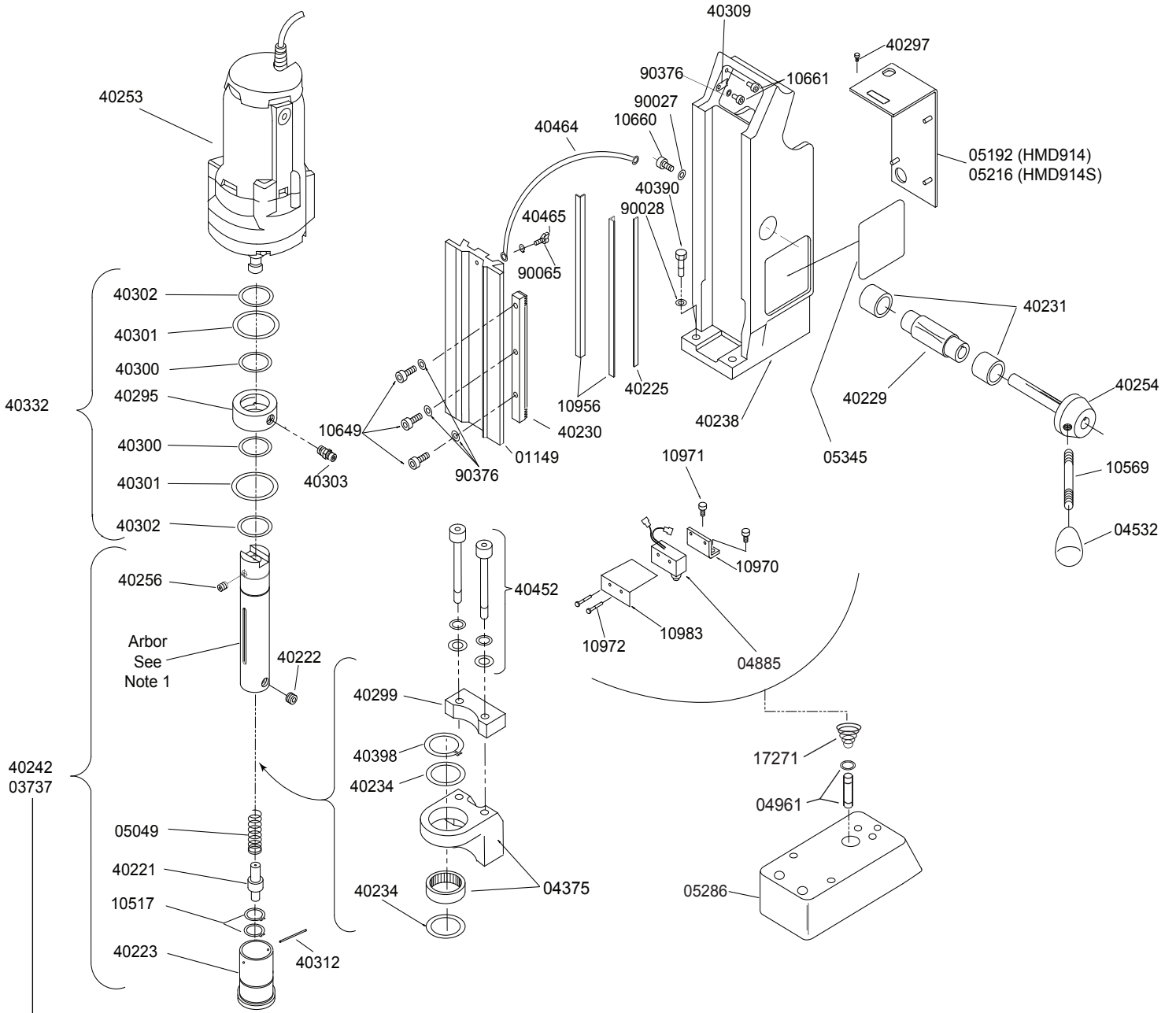
1. Tighten bolts in the sequence shown to 5 - 10 in/lb.
2. Retighten bolts in the same sequence to 35 - 40 in/lb.



## Motor Parts List

Part #	Description	Qty	Part #	Description	Qty
40258	Motor Cord	1	40281	Motor Slug	1
40260	Housing, Brush End	1	40284	Field Assy 115V	1
40261	Armature Assy 115V	1	40285	Brush Plug	2
40262	Bearing	2	40286	Brush (Package of 2)	1
40263	Flat Spring	1	40287	Brush Holder	2
40264	Seal	1	40289	Screw #10-32 x 1/4"	2
40265	Flat Spring	1	40290	Washer	1
40266	Washer	1	40292	Retaining Ring	1
40267	Bearing	2	40298	Screw 1/4-20 x 3-1/2"	4
40268	Gear Housing	1	40348	Seal	1
40269	Gear Cluster	1	40349	Plug	1
40270	Gasket	1	40350	Syntech grease	8 oz.
40271	Cap. Gear Housing	1	40382	Baffle	1
40273	Lock Washer 1/4"	4	40383	Screw #10-32	2
40274	Bearing	1	40384	Baffle Spacer	2
40275	Flat Spring	2	40441	End Cap	1
40276	Gear Output	1	40445	Strain Relief	1
40279	Bearing	1	40449	Spacer	2
40280	Ball	1	40450	Screw #10-32 x 1"	2
			90424	Brush Holer Clip	2

# EXPLODED VIEW



COOLANT BOTTLE SHOWN ON PAGE 9

10725 - Carrying Case

Note 1:

40242 - HMD914  Includes: 05049, 10517, 40222, 40223, 40256, 40312  
 03737 - HMD914S

40242 for Coolant arbors only

# PARTS LIST

Part #	Description	Qty	Part #	Description	Qty
03737	Arbor HMD914S	1	40294	Motor Slide	1
04375	Arbor Sup. Bracket Assy	1	40295	Inducer	1
04532	Feed Handle Knob	3	40297	Screw-Slotted Hex	4
04885	Safety Switch	1	40299	Arbor Support Brkt	1
04909	Safety Switch Bracket	1	40300	O-Ring	2
04961	Plunger Assy	1	40301	Thrust Washer	2
05049	Arbor Spring	1	40302	Retaining Ring	2
05192	Control Panel (HMD914)	1	40303	Coolant Fitting	1
05116	Control Panel (HMD914S)	1	40304	Tubing 1/4" OD	1
05286	Magnet	1	40309	Cord Clamp	1
05345	Warning Label	2	40312	Roll Pin-Modified	1
10517	Retaining Ring	1	40326	Cutting Fluid Valve	1
10569	Feed Handle	3	40332	Inducer Assy	1
10649	Screw SHC #10-32	3	40333	Brass Insert	1
10660	Screw SHC 1/4-20 x 5/8	1	40338	Nylon Ferrule, 1/4" Tube	1
10661	Screw BHC #10-24	2	40377	Shrink Tube	1
10725	Carrying Case	1	40390	Bolt-HH 1/4-20	3
10956	Brass Gibbs-Pair	1	40398	Ejector Collar Re. Ring	1
10971	Screw SHC 1/4-20	2	40417	Coolant Bottle	1
10972	Screw BHC #6-32	2	40419	Retaining Bracket-Right	1
10977	Screw BHC 1/4-20	1	40420	Retaining Bracket-Left	1
10983	Safety Switch Ins. Shield	1	40422	Coolant Bottle Clamp	1
17271	Taper Spring	1	40424	Anti-Rotational Finger	1
40221	Spring Seat	1	40429	Nut-Locking	1
40222	Set Screw - Arbor	2	40433	Coolant Bottle Cap	1
40223	Ejector Collar	1	40442	Cutting Fluid Bottle Assy	1
40225	Steel Gib	1	40452	Arbor Bolt Kit	1
40229	Feed Gear	1	40464	Ground Strap	1
40230	Gear Rack	1	40465	Screw HH 1/4-20	1
40231	Bushing Bronze	2	50035	Washer 1/4" Int. Tooth	6
40234	Thrust Washer	2	51042	Screw SHC 1/4-20	2
40237	Set Screw 1/4-28	5	90027	Washer Flat	1
40238	Housing	1	90028	Washer 1/4" Helical	3
40242	Arbor Assy HMD914	1	90052	Washer Ground Screw	1
40253	Motor 115V	1	90065	Washer 1/4" Star	2
40254	Hub Assy	1	90352	Screw SHC 1/4-28	4
40256	Set Screw 5/16-18	1	90376	Washer #10 Internal	3