NOTE:
All lead lengths are before stripping.
All leads must be held to ± .125”
unless specified elsewhere.
Strip wire per ES 13-11.
Crimp terminals per ES 13-15.

TERMINAL DESCRIPTION

<table>
<thead>
<tr>
<th>Code</th>
<th>Part No.</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>T1</td>
<td>23-74-0605</td>
<td>1</td>
</tr>
<tr>
<td>T2</td>
<td>23-74-0410</td>
<td>2</td>
</tr>
<tr>
<td>T3</td>
<td>23-74-1060</td>
<td>4</td>
</tr>
</tbody>
</table>

AS AN AID TO REASSEMBLY,
TAKE NOTE OF WIRE ROUTING
AND POSITION IN WIRE GUIDES
AND TRAPS WHILE
DISMANTLING TOOL.

INSERT BLACK LEADWIRE #1
AND RED LEADWIRE #4
INTO TRAPS ON BRUSH
TUBE HOLDER.

INSERT GREEN GROUND WIRE #3 INTO
WIRE TRAP GROOVE ON MOTOR
HOUSING.

CORD JACKET TO EXTEND
.25 MINIMUM PAST FITTINGS.

USING A 20MM
CROWS FOOT WRENCH, APPLY 120 IN/LBS
OF TORQUE TO FITTING NUT AND 55 IN/
LBS
OF TORQUE TO LOCKING NUT WHEN
ASSEMBLING THE MOTOR CORD ASSEMBLY
TO THE MOTOR COVERS.

IN ASSEMBLY, CORD WIRES MUST BE
ROUTED AROUND THIS PROTRUSION.

As an aid to reassembly,
take note of wire routing
and position in wire guides
and traps while
dismantling tool.
SERVICE PARTS LIST

MAG STAND CONTROL PANEL

CATALOG NO. 23-35-0360

<table>
<thead>
<tr>
<th>FIG.</th>
<th>PART NO.</th>
<th>DESCRIPTION OF PART</th>
<th>NO. REQ.</th>
</tr>
</thead>
<tbody>
<tr>
<td>8</td>
<td>06-81-8650</td>
<td>6-32 x 1/4&quot; Rd. Hd. Sems</td>
<td>1</td>
</tr>
<tr>
<td>9</td>
<td>06-82-7252</td>
<td>8-32 x 3/8&quot; Pan Hd. Slit. Tapt. T-20</td>
<td>4</td>
</tr>
<tr>
<td>13</td>
<td>06-95-5150</td>
<td>Sems Machine Ground Screw</td>
<td>2</td>
</tr>
<tr>
<td>17</td>
<td>22-64-3285</td>
<td>Power Cord Assembly</td>
<td>1</td>
</tr>
<tr>
<td>18</td>
<td>23-35-0360</td>
<td>Control Panel Assembly</td>
<td>1</td>
</tr>
<tr>
<td>21</td>
<td>28-50-0600</td>
<td>Mag Stand Housing</td>
<td>1</td>
</tr>
<tr>
<td>24</td>
<td>22-64-3290</td>
<td>Motor Cord Assembly</td>
<td>1</td>
</tr>
<tr>
<td>33</td>
<td>44-26-0070</td>
<td>Electromagnetic Base</td>
<td>1</td>
</tr>
<tr>
<td>38</td>
<td>23-66-2265</td>
<td>Drill Switch Assembly</td>
<td>1</td>
</tr>
<tr>
<td>39</td>
<td>23-66-2260</td>
<td>Magnet Switch</td>
<td>1</td>
</tr>
<tr>
<td>40</td>
<td>14-46-2040</td>
<td>Potted PCB Kit</td>
<td>1</td>
</tr>
</tbody>
</table>

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

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

---

1. Route two magnetic base leads (brown wires #10 and 11) through the opening in the bottom of the mag stand housing #21.
2. Secure the cord #24 from drill in the top opening of the mag stand housing. The cord jacket is to extend .25 minimum beyond the fittings.
3. Secure the power cord assembly #17 to the control panel kit #18. The cord jacket is to extend .25 minimum beyond the fittings.
4. Attach ground terminals from green wires #3 and #6 to mag stand housing with ground screws #13. Orient the terminals as shown.
5. 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.
6. 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.
7. Route black wire #4 from the power cord assembly into the wire trap on the potted pcb kit, as shown.
8. Connect all wires, as shown. In assembly, wires #5, #6, #10 and #11 must be contained beneath the electronics boat.
9. 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.

ATTENTION
Observe precautions for handling electrostatic sensitive devices.

---

REVISED BULLETIN: SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

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

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

BACK VIEW OF PANEL
Route wire #14 inbetween wire #12 and route wire #15 inbetween wire #13, as shown.
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 120 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 120 V AC receptacle.

---

<table>
<thead>
<tr>
<th>ACTION</th>
<th>RESPONSE</th>
<th>POSSIBLE CAUSE</th>
<th>SOLUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Magnet is &quot;on&quot;. Drill switch is &quot;on&quot;.</td>
<td>Tool does not operate. Magnet switch lamp is &quot;on&quot;.</td>
<td>1. Drill switch was &quot;on&quot; when magnet was turned &quot;on&quot;.</td>
<td>1. Turn drill switch &quot;off&quot;, then back &quot;on&quot;.</td>
</tr>
<tr>
<td>Magnet switch is turned &quot;on&quot;.</td>
<td>Magnet switch lamp turns &quot;on&quot;, then &quot;off&quot;.</td>
<td>1. Magnet is damaged.</td>
<td>1. Check magnet resistance, 335 to 355 ohms.</td>
</tr>
<tr>
<td>Magnet switch is turned &quot;on&quot;. Drill switch is turned &quot;on&quot;.</td>
<td>Magnet switch lamp is on, turns off when drill switch is turned &quot;on&quot;.</td>
<td>1. Motor brushes are worn.</td>
<td>1. Replace brushes.</td>
</tr>
</tbody>
</table>

23-35-0360 TROUBLE SHOOTING