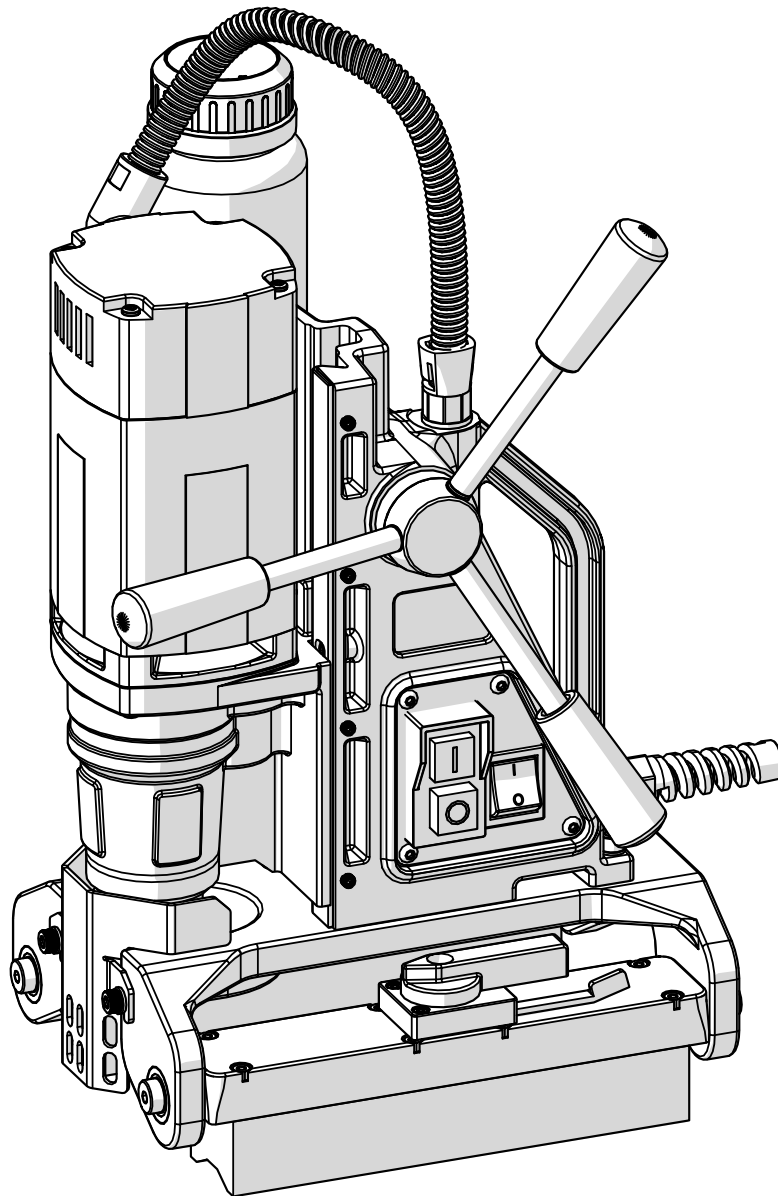


VERSADRIVE®

PATENT PROTECTED

Magnetic Drilling Machine

V35 PIPE



(Original Instructions)

Congratulations on your purchase of the Holemaker Technology *VERSADRIVE V35 PIPE* Transportable 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 metal cutting tools and products to help you be more productive.

Before operating your new magnetic drilling machine, please read all instructions first. These include the Operators Manual and Warning Labels 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:

Holemaker Technology LTD,
Bridge House,
Pattenden Lane,
Marden,
Kent,
UK,
TN12 9QJ

sales@holemaker-technology.com
www.holemaker-technology.com

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2 Safety

2.1 General power tool safety instructions



WARNING: Read all safety warnings, instructions, illustrations, and specifications provided with this power tool.



WARNING Read all safety warnings designated by the symbol  and all instructions.

Save all warnings and instructions for future reference.



2.1.1 General Power Tool Safety Warnings - Work Area Safety

- a) Keep work area clean and well lit.
- b) Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust.
- c) Keep children and bystanders away while operating a power tool. *Distractions can cause you to lose control.*



2.1.2 General Power Tool Safety Warnings - Electrical Safety

- a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.
- b) Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges, and refrigerators.
- c) Do not expose power tools to rain or wet conditions.
- d) Do not abuse the cord. Never use the cord for carrying, pulling, or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.
- e) When operating a power tool outdoors, use an extension cord suitable for outdoor use.
- f) If operating a power tool in a damp location is unavoidable, use a residual current device (RCD/GFI) protected supply.



2.1.3 General Power Tool Safety Warnings - Personal Safety

- a) Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.
- b) Use personal protective equipment. Always wear eye protection.
- c) Prevent unintentional starting. Ensure the switch is in the off position before connecting to power source and/or battery pack, picking up or carrying the tool.
- d) Remove any adjusting key or wrench before turning the power tool on
- e) Do not overreach. Keep proper footing and balance at all times.
- f) Dress properly. Do not wear loose clothing or jewellery. Keep your hair and clothing away from moving parts.
- g) Loose clothes, jewellery or long hair can be caught in moving parts.
- h) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.
- i) Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.



2.1.4 General Power Tool Safety Warnings - Power Tool Use and Care

- a) Do not force the power tool. Use the correct power tool for your application.
- b) Do not use the power tool if the switch does not turn it on and off.
- c) Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.
- d) Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tools.
- e) Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.
- f) Keep cutting tools sharp and clean.
- g) Use the power tool, accessories, and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.
- h) Keep handles and grasping surfaces dry, clean, and free from oil and grease.

2.1.5 Service

- a) Have your power tool serviced by a qualified repair person using only identical replacement parts.



2.2 Magnetic Drill - Specific Safety Warnings

- Keep your fingers well out of the drill/cutter 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 switching 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 minimum thickness of 4mm, 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 magnets clean and free of debris and swarf.
- Do not switch on the machine until it has been securely mounted and installed according to these instructions.
- Do not switch on the machine before having checked that the magnetic stand has been tightened firmly and securely 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 switched on.
- Before switching on the machine, make sure all accessories have 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 adjustable cutter guard is fitted correctly and operates properly.
- 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.



RESIDUAL RISKS

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

These are:

- Impairment of hearing
- 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.

Always try to reduce these risks further by the use safe working practices and the use of appropriate PPE as much as possible.

3 Description

3.1 Intended use

This magnetic drilling machine is intended for commercial/industrial use as a magnetic base drilling machine for drilling materials with a magnetizable surface using annular cutters and twist drills.

The magnetic drilling machine can be used horizontally, vertically, or overhead using the safety strap provided, taking the precautions identified in this manual.

This magnetic drilling machine is IP20 and is intended to be used in a weather-protected environment. Ambient operating temperatures of <-10 and >45°C should be avoided.

Use only HMT approved tools and accessories with this machine.

The machine should not be used beyond its stated capacities.

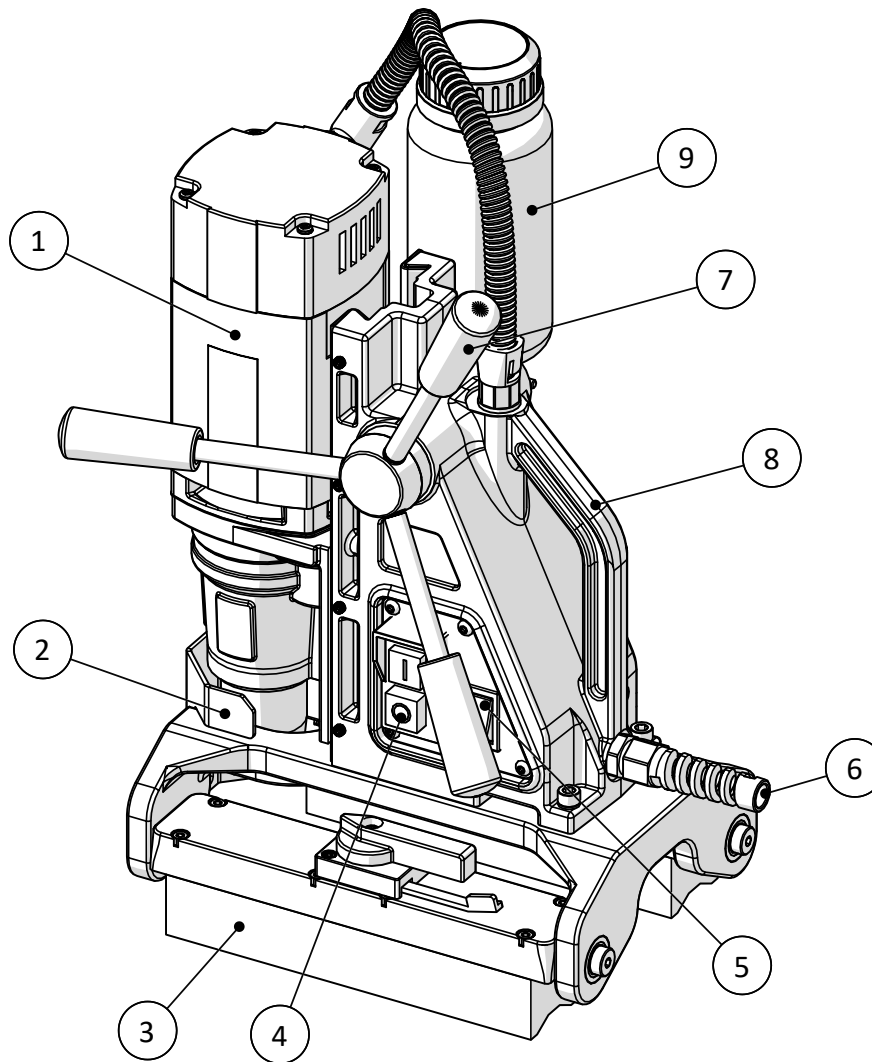
The machine should not be used for any purpose other than stated.

The machine should NEVER be used without a protective earth or ground connection.

The machine SHOULD NOT be used in a potentially explosive environment.

The machine should not be used as a lifting device, the magnetic base is for clamping only.

3.2 Description and features



[image 1]

- 1 Motor Unit
- 2 Safety Guard
- 3 Magnet Base
- 4 Motor Switch
- 5 Power Switch
- 6 Power Cable Outlet
- 7 Capstan Handle (Rise / Fall)
- 8 Stand Carrying Handle
- 9 Coolant Bottle

3.3 Packing List

Standard Machine

- 1 x Magnetic Drilling Machine
- 1 x Instruction Manual
- 1 x *VERSADRIVE* RAPID LOCK Weldon Adaptor
- 1 x Drill Guard & 2x fixing screws and washers.
- 1 x Hex Key (3)
- 1 x Safety Strap
- 1 x Basic Carrying Case
- 1x Coolant Bottle, Tap and Tube

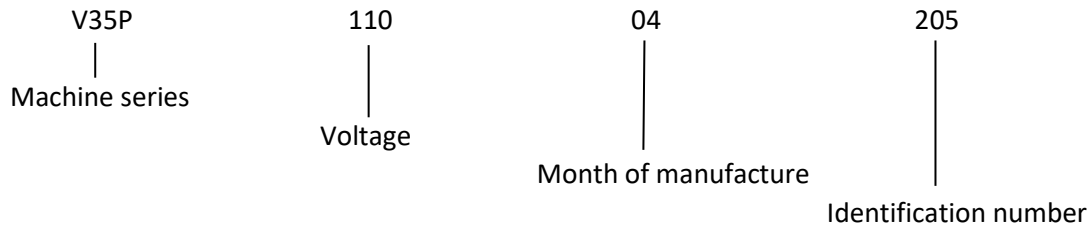
3.4 Serial number

The serial number is displayed on the machine on the motor housing.

The serial number will help you and your sales point validate and identify the machine.

As example: V35P11004205

This breaks down to:












The month and year of manufacture are shown on the bottom of the serial number label.

3.5 Technical data

VERSADRIVE V35 PIPE-110 / V35 PIPE-230 (Check machine markings)				
Description	Metric		Imperial	
Capacity Annular Cutters	Up to Ø35 mm (TCT cutters)		Up to Ø1-3/8" (TCT cutters)	
Capacity Twist Drills	Ø 1 – Ø12 mm		Ø 1/16" – Ø 1/2"	
Capacity Threading	N/A – not reversing		N/A – not reversing	
Capacity Countersinking	25mm		Ø 1"	
Overall Length	245mm (with guard)		9-5/8"	
Overall Width	215mm (incl. handles & Coolant)		8-1/2"	
Overall Height	340mm Min - 480mm Max		13-3/8" Min – 18-7/8" Max	
Slide Stroke	140mm		5-1/2"	
Weight – (Machine only)	11.7 kg		25 lb	
Magnet dimensions	186 x 41 x 50mm (L x W x H) 2 off		7-3/8" x 1-5/8" x 2" - 2 off	
Magnetic Adhesion Force	532 Kg (25mm Thick Material)		1170 lb (1.0" Thick Material)	
Rated Voltage	110V AC / 230V AC		115V AC / 230V AC	
Rated Current	8.2A / 4.0A		8.2A / 4.0A	
Rated Motor Power	850 W		1.125 hp	
Magnet Power	50 W		50W	
Total Power	900 W		900W	
IP Rating	IP20		IP20	
Insulation Class	Class 1		Class 1	
Speeds No Load	750 ^{min-1}		750 Rev/Min	
Spindle type	19,05mm Weldon		3/4" Weldon	
Sound Pressure Level - 110V	84 dB(A)	Uncertainty 3 dB(A)	84 dB(A)	Uncertainty 3 dB(A)
Sound Pressure Level - 230V	87 dB(A)	Uncertainty 3 dB(A)	87 dB(A)	Uncertainty 3 dB(A)
Sound Power Level - 110V	97 dB(A)	Uncertainty 3 dB(A)	97 dB(A)	Uncertainty 3 dB(A)
Sound Power Level - 230V	100 dB(A)	Uncertainty 3 dB(A)	100 dB(A)	Uncertainty 3 dB(A)
SPL at Operators Head Level	89 dBA	Uncertainty 3 dBA	89 dBA	Uncertainty 3 dBA

Since this tool is not a hand-held power tool, hand arm vibration figures are not applicable. However, the hand arm vibration figure, if required is less than 2.5m/s²

Symbols

Symbol	Term, meaning	Explanation
	Read Documentation	You MUST 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.
	Wear Gloves	
	Danger/warning/caution	Observe the information in the adjacent text!
	Warning Electrical Enclosure	Danger - High voltage present inside enclosure.
	European conformity symbol	Confirms the conformity of the power tool with the directives of the European Community.
	United Kingdom conformity symbol	Confirms the conformity of the power tool with the directives of the United Kingdom.
	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 min ⁻¹	per minute	Unit of measure for number of revolutions, strokes, impacts or oscillations per minute.

3.6 Environmental



Separate collection. This product must **NOT** be disposed of with normal household waste.



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.

4 Preparation & adjustment

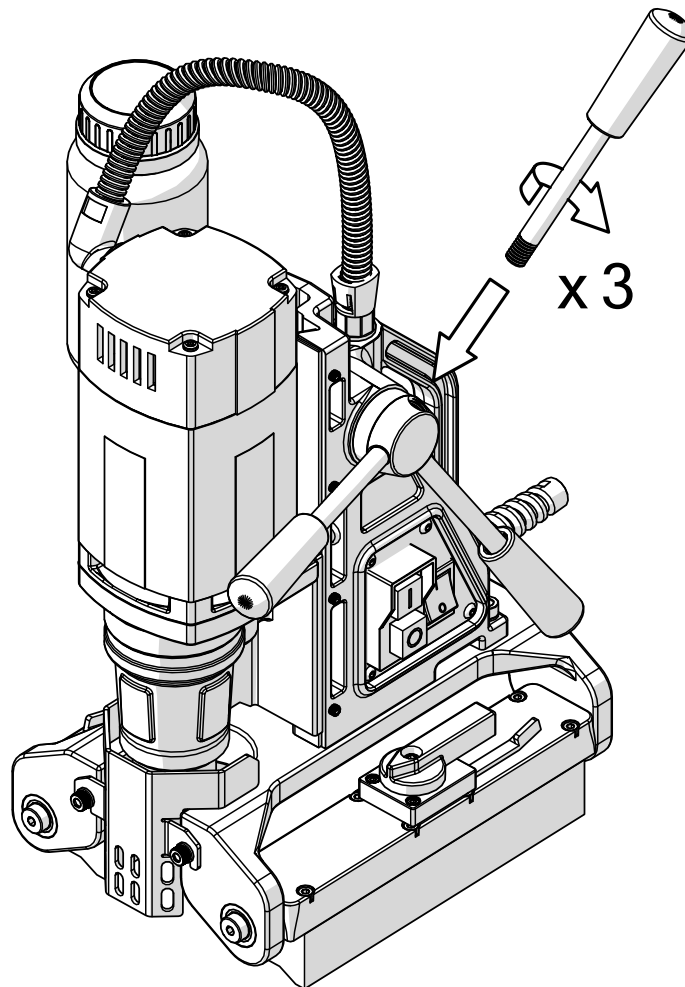
4.1 Assembly



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 all switches are in the OFF position. An accidental start-up can cause injury.

4.1.1 Fitting the feed handles

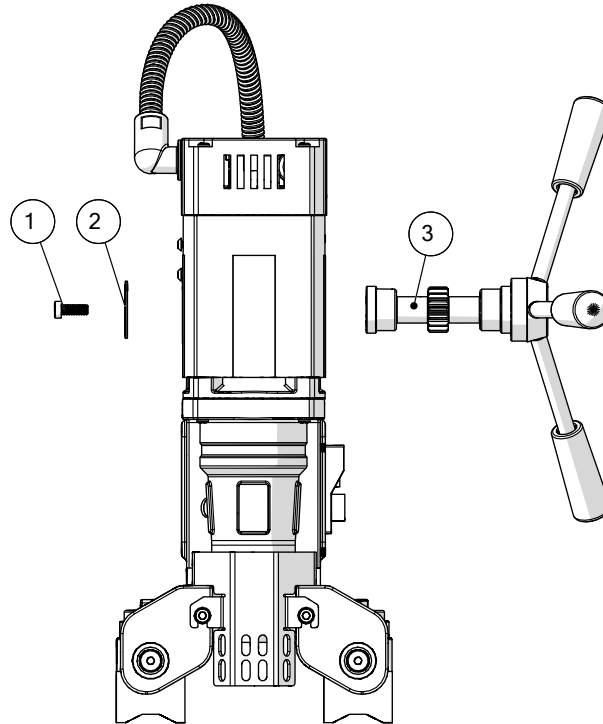
Take the feed handle (x 3) and screw each one in turn into the pinion shaft.
Ensure the handles are fully secure before use.



[image 2]

To remove the feed handle from the machine, first lower the slide until it is at its lower most position.

Unscrew the M5 CSK screw (item 1) and remove the pinion shaft retainer (item 2). The pinion shaft and feed handle assembly (item 3) can now be withdrawn.

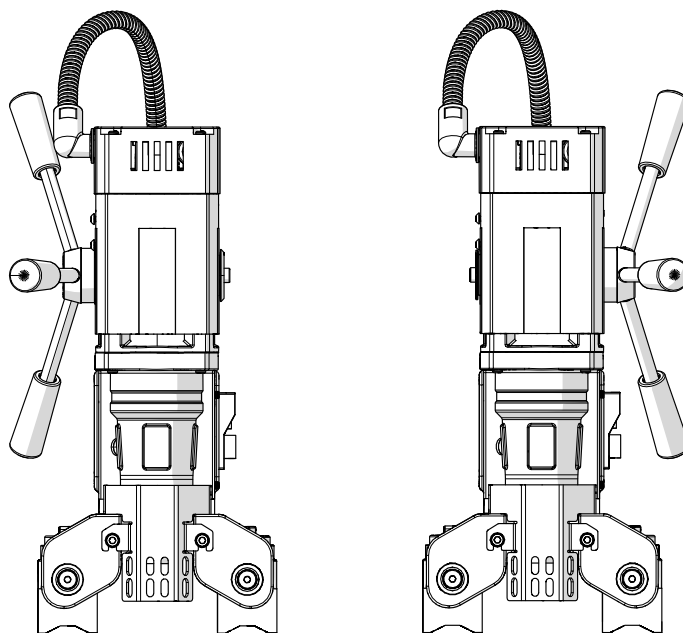


[image 3]

It is possible to position the feed handle on either side of the machine (image 4).

Method of removal and refitting is as in 3.1.1 and 3.1.2 above.

IMPORTANT: If the feed handle is repositioned, the operator must have good access to the controls at ALL times.



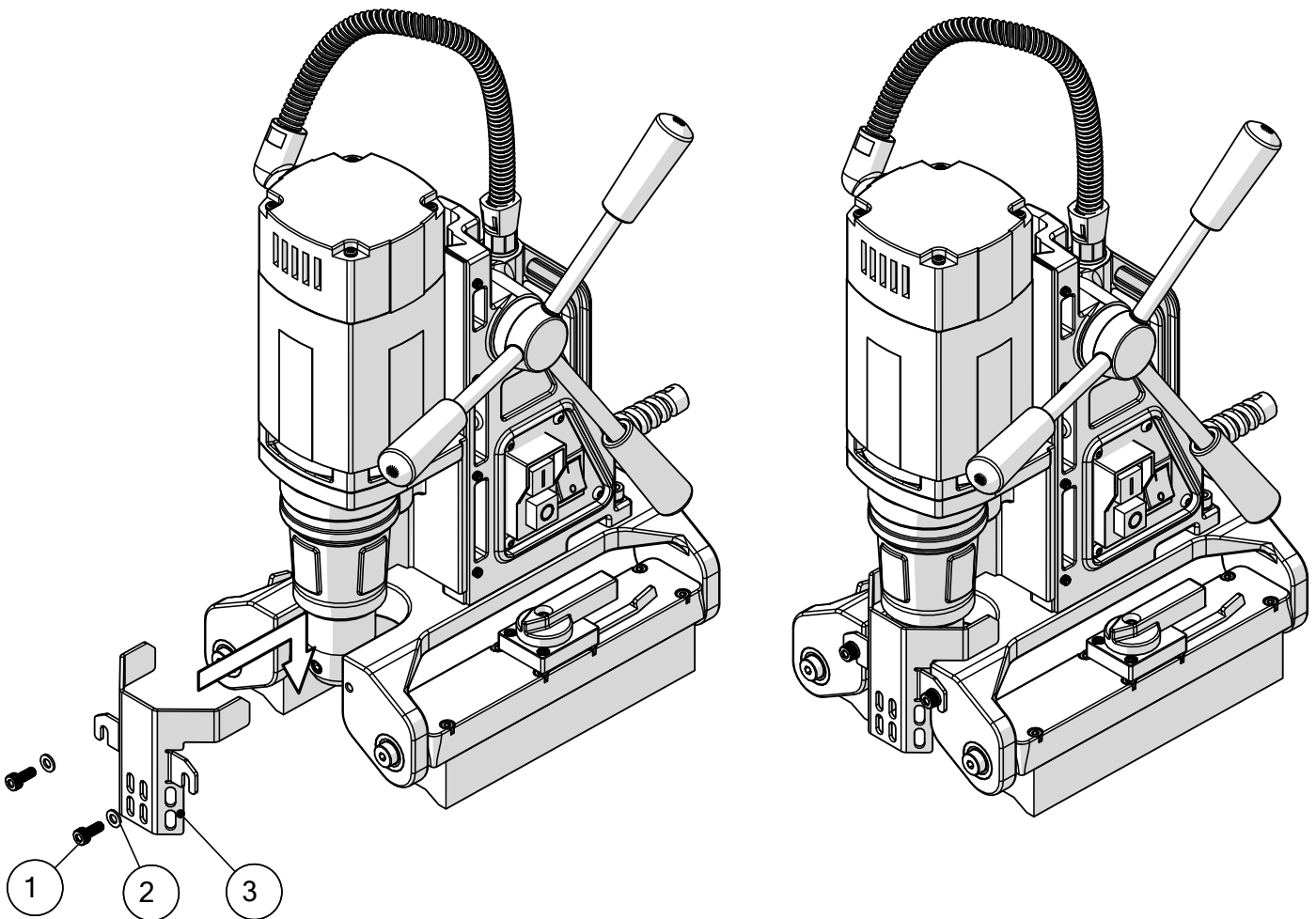
[image 4]

4.1.2 Mounting the drill guard

The drill guard protects against ejection of sharp and/or hot chippings, it also protects against accidental contact with rotating parts and must always ALWAYS be mounted during operation.

This guard is FIXED guard.

- 1) Slide the drill guard (3) up to the magnet and align the fixing holes with the slots.
- 2) Fit the 5mm socket cap screw (1) and nylon washer (2) each side.
- 3) Tighten the 5mm socket cap screws until the guard is secure.
- 4) Removal is a reverse of the above.



[image 5]

4.1.3 Fitting the cooling system

Description of the cooling system.

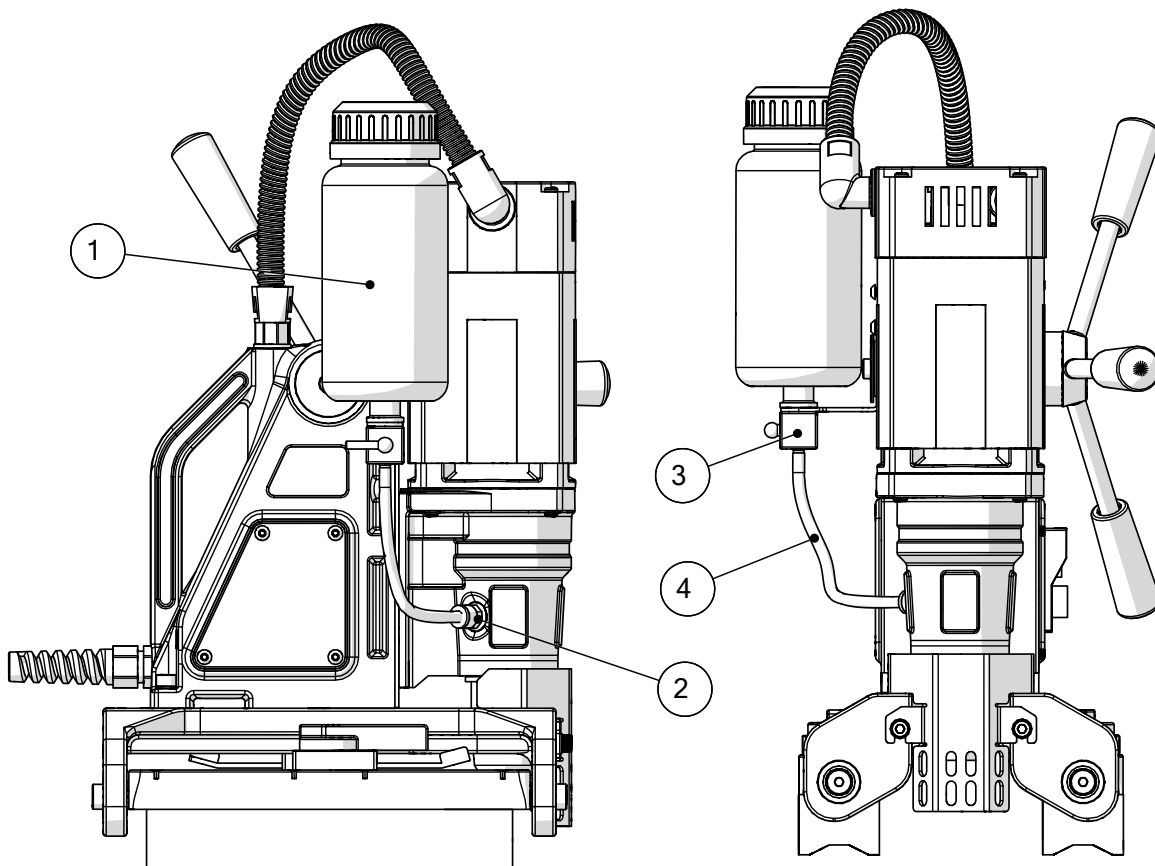
The coolant system consists of the following items: -

1. Coolant bottle and bracket
2. Coolant inlet (gearbox)
3. Coolant flow rate adjustment tap.
4. Coolant Tube

The coolant system has a through spindle inlet (2) which allows coolant to be fed down through the centre of the cutter whilst rotating.

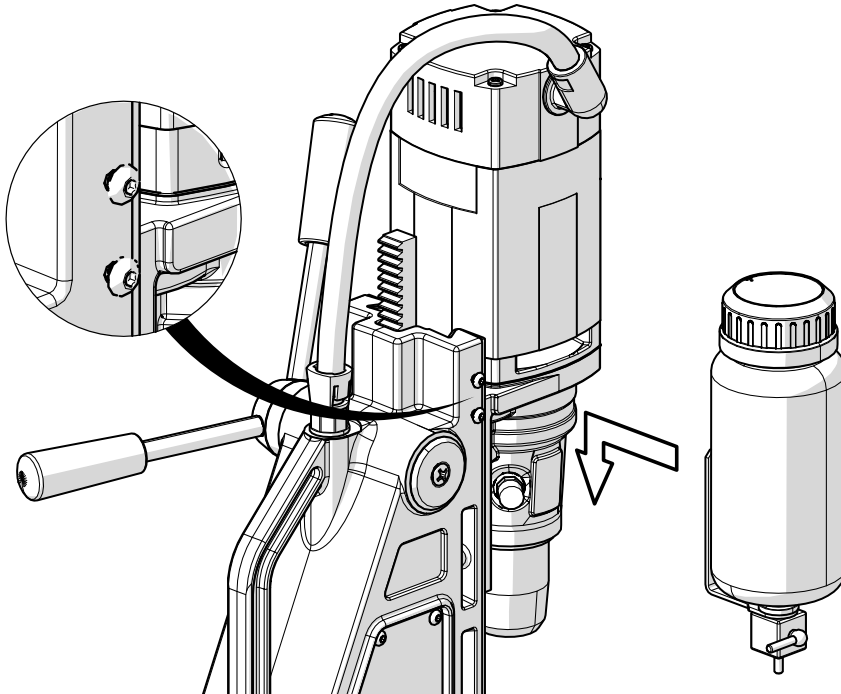
Coolant is stored in the coolant bottle (1), the flow is regulated by the tap (3) and fed to the cutter holder collar by means of a flexible tube (4).

The coolant bottle is attached to the main stand by means of a bracket.

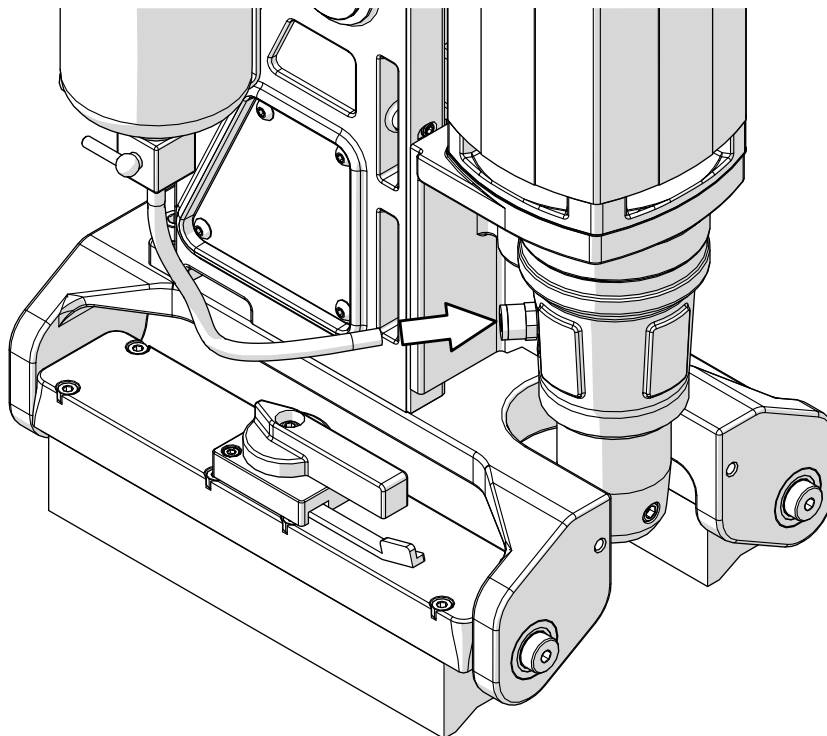


[image 6] – Guard not shown.

The coolant bottle and tap assembly has a mounting bracket which is slotted to allow easy removal. To fit the bottle, place the bracket over the 2x button head socket screws then slid down to lock in place. See image 7 below.



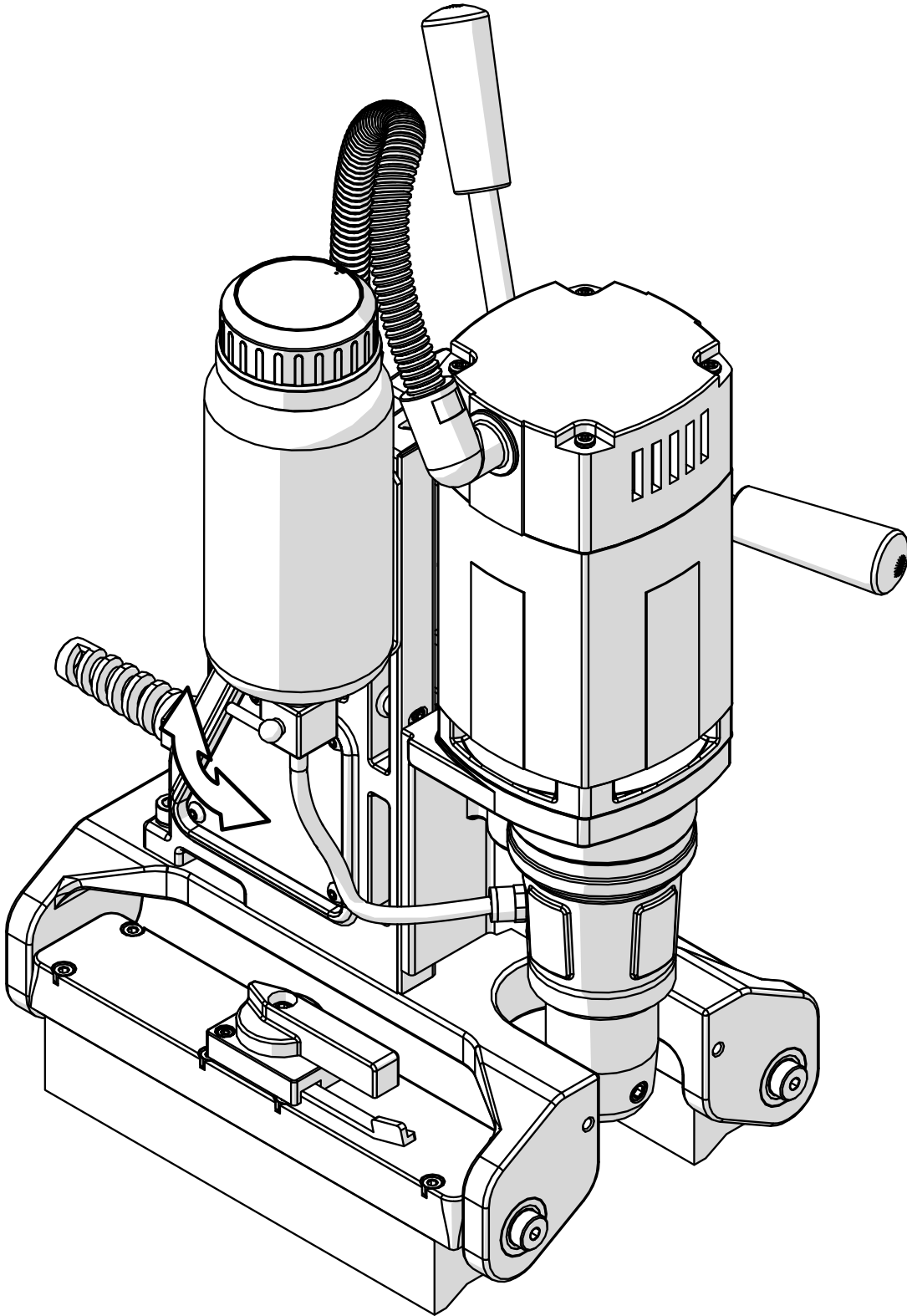
[image 7]



[image 8]

Fit the coolant tube to both the coolant bottle and the cutter holder.

To regulate the flow of coolant, rotate the tap at the bottom of the coolant bottle.



[image 9]

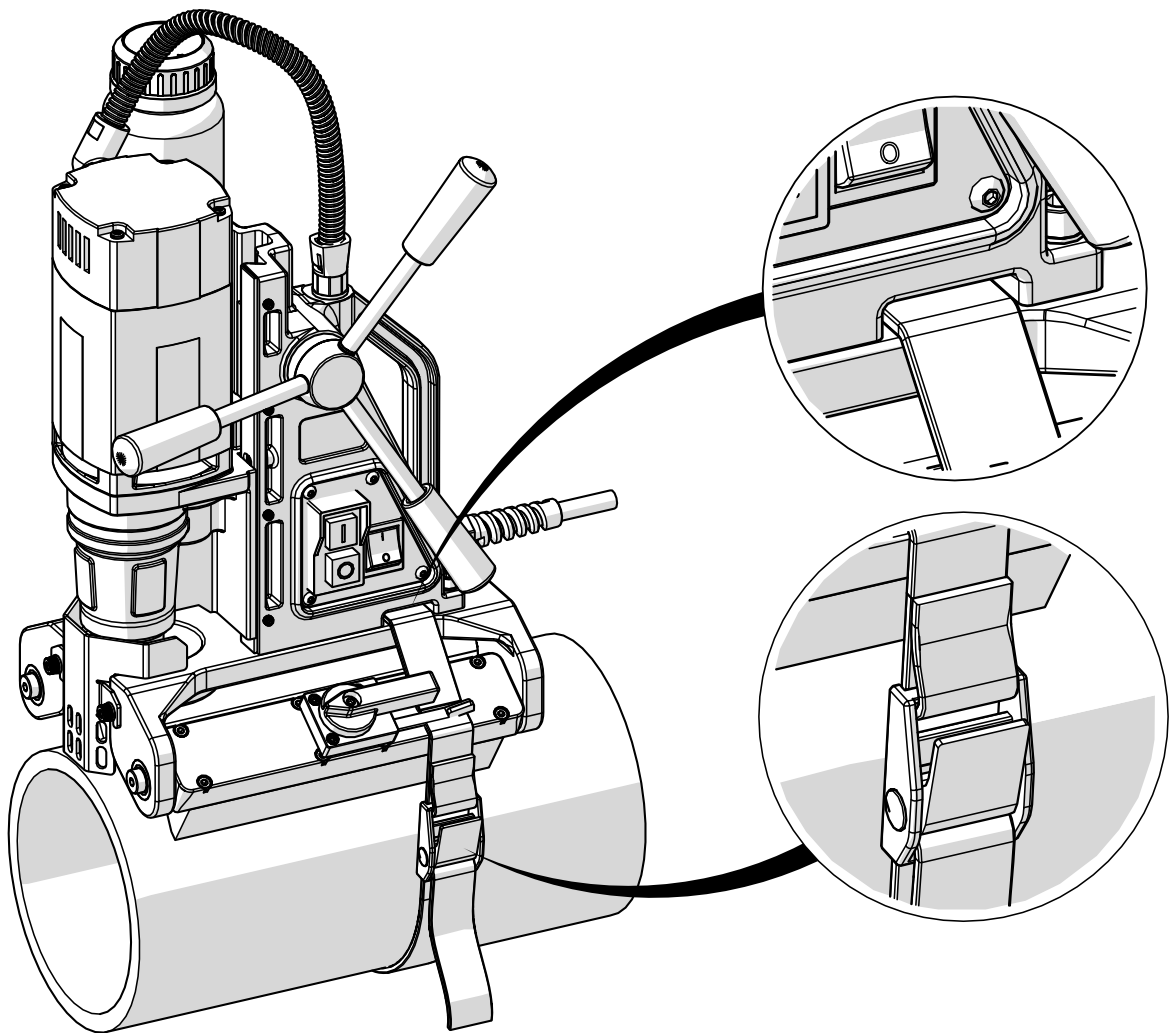
4.1.4 Fitting the safety strap

The safety strap should always be used during operation.

Use of the safety strap reduces the risk of personal injury if for some reason there is a loss of magnetic adhesion, and the magnet comes loose from the workpiece.

The purpose of the safety strap is to prevent the machine from falling or spinning should there be a loss of magnetic adhesion.

The safety strap should NOT be used as an alternative method of clamping to the magnet.



[image 10] - Upper inset shows strap slot - Lower inset shows cam buckle.

Position the machine on the item to be drilled and switch on the both magnets.

Feed the free end of the strap through the strap slot on the machine and around the workpiece.

Fit the free end through the cam buckle.

Pull on the free end to tighten the strap.

MAKE SURE the safety strap is securely fitted **BEFORE** using the drill.

4.2 Prior to use

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

When working on steel materials with a material thickness of less than 4 mm, the work piece 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 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 of 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 near 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 BS EN 62841-1. Earthing connection 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 earthed extension cable suitable for the power input of this tool (see technical data). Minimum conductor size is 1.5 mm²; the maximum length is 30 metre. When using a cable reel, always unwind the cable completely.

TRY A FEW SIMPLE PROJECTS USING SCRAP MATERIAL UNTIL YOU DEVELOP A "FEEL" FOR THE MACHINE

LET THE MACHINE RUN IN FOR A PERIOD OF 8-10 HOURS BEFORE STARTING WITH BIG OPERATIONS.

DO NOT LOAD THE MACHINE TOO MUCH DURING RUN-IN PERIOD

NEVER USE THE MACHINE IN SERIOUS OVERLOAD

KEEP THE MACHINE CLEAR FROM MOISTURE AT ALL TIMES TO PROTECT THE MACHINE, YOURSELF AND OTHERS.

5 Using the machine



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.

5.1 Carrying handle

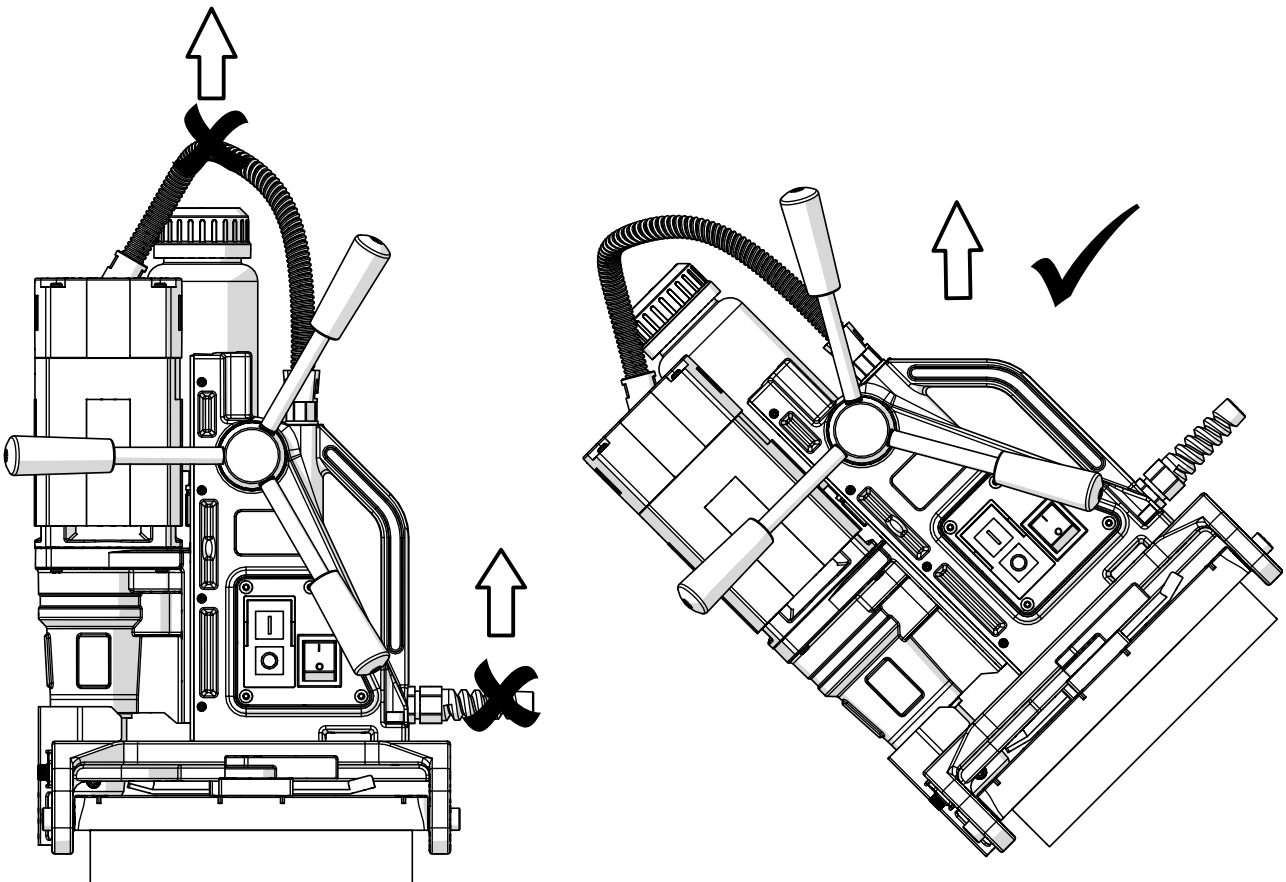
This machine has an integral carrying handle built into the stand housing. The machine is intended to be carried by one person by hand, the weight is <12Kg.

The machine should be lifted with the designated handle only.

DO NOT lift the machine with the electrical conduit cable to the motor.

DO NOT lift the machine with the power cable.

Before lifting the machine, lower the motor unit and slide to its lowest position.

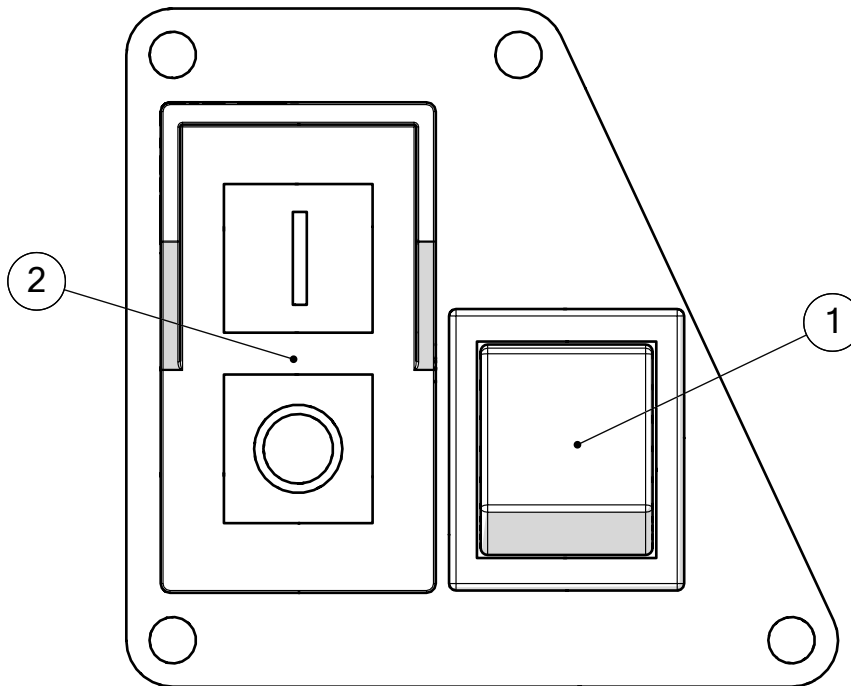


[image 11]

5.2 Control panel

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

1. Power Switch (Illuminated)
2. Motor NVR Switch



[image 12]

5.2.1 Power Switch

The power switch (Image 12 - item 1) is an illuminated rocker switch.

When in the on position the switch will illuminate red.

This switch provides power to the drill.

The power switch must be turned on only after the machine is in position, and before any attempt to use the drill is made.

The power switch also supplies power for the motor to operate if it is off the motor will not start.

5.2.2 Motor NVR Switch

The Motor NVR Switch (image 12 – item 2) operates the motor spindle.

NVR = No Volt Release – The motor switch has an undervoltage release mechanism to switch off the motor if the supply voltage reduces. The switch must be manually reset when the power is returned, this is a safety feature.

There are two buttons.

1. GREEN marked with the symbol 'I' this will START the motor unit.
2. RED marked with the symbol 'O' this will STOP the motor unit.

The GREEN-START button is lower and is shrouded to prevent unintentional operation or start up. The RED-STOP button is raised and unshrouded so it can be quickly accessed in case of emergency.

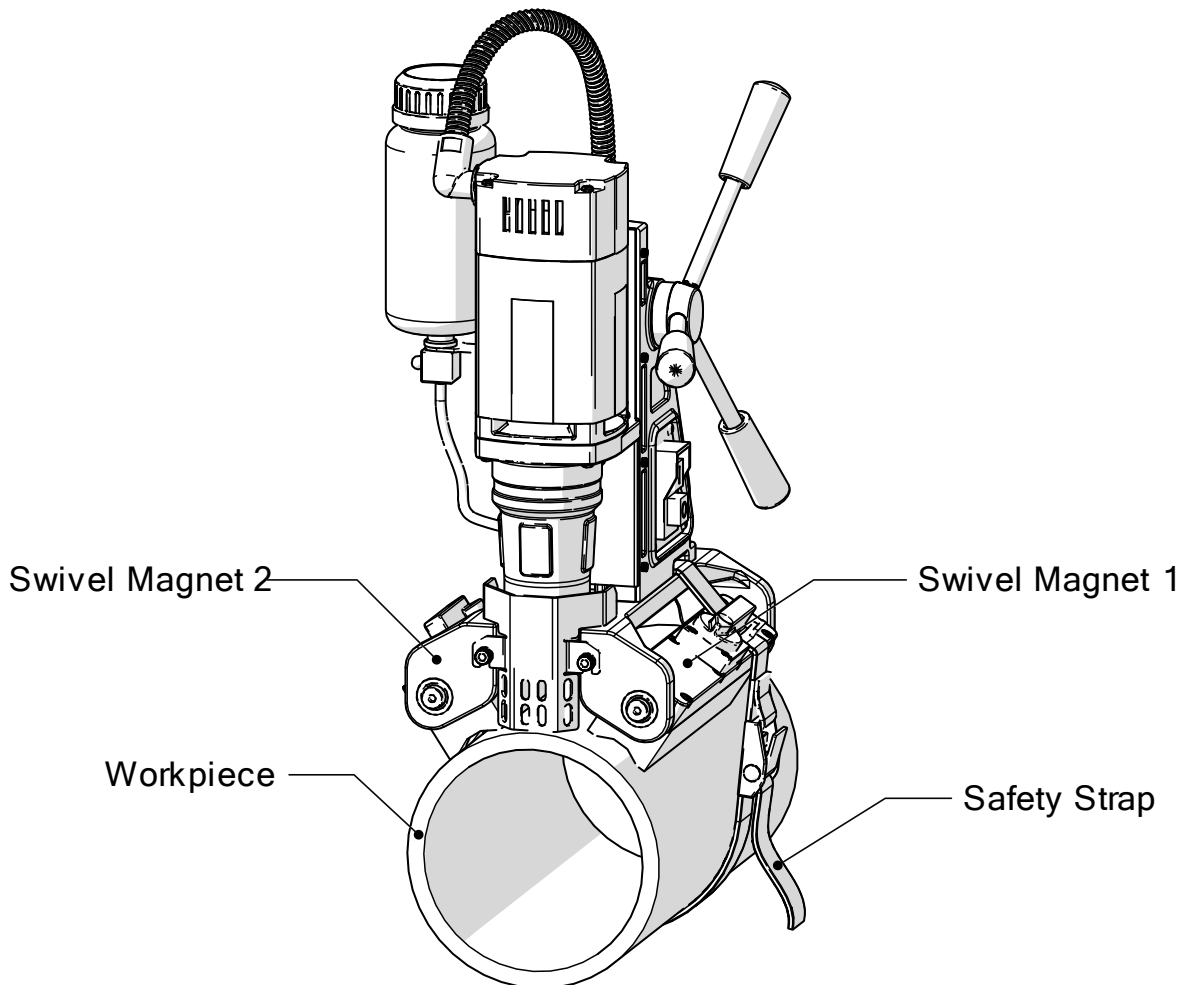
The motor switch will not switch on if the power switch is in the OFF position.
The motor switch will not latch on if the protection fuse has blown.

5.3 Switchable Magnet – Pipe Base

Make sure the magnetic drilling machine is placed on a smooth, clean, level, and solid surface without any objects or debris in between to guarantee maximum adhesion.

The thicker the workpiece material the better the magnetic adhesion will be when operating the machine. The switchable permanent magnets of the V35 PIPE Base are suited to cutting relatively thin material, down to 4mm, but care must be taken on thinner materials.

The operator **MUST** confirm the magnetic adhesion is sufficient before operating the drill unit.



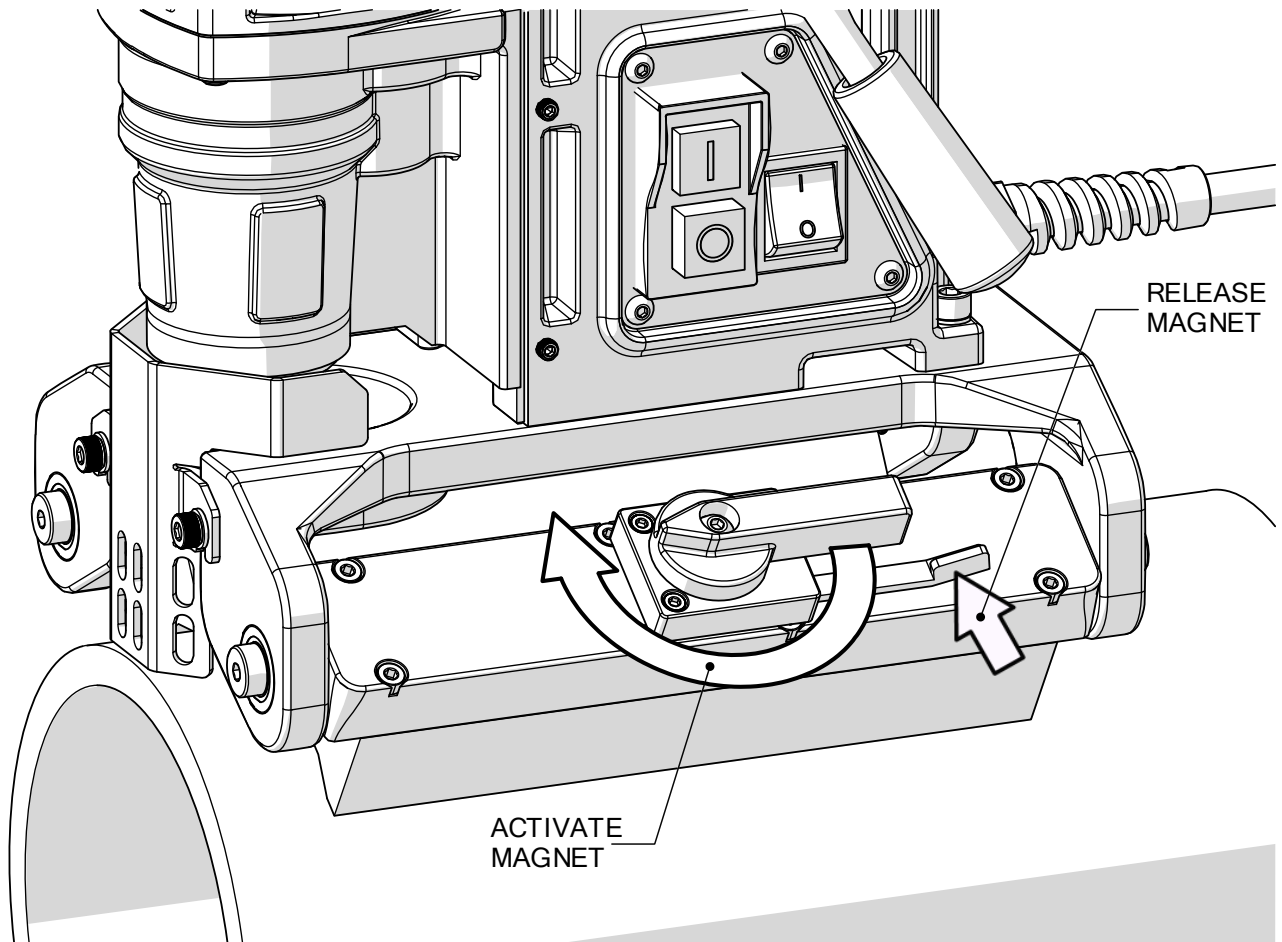
[image 13]

The switchable swivel magnets will work best on surface of > 10 mm thickness.

If the switchable swivel magnets are not able to create a good enough magnetic field.

Causes may be:

- Surface not flat
- Workpiece not magnetisable (e.g. Aluminium/Stainless Steel)
- Workpiece coated or painted
- Workpiece not thick enough



It is the responsibility of the operator to make sure the workpiece offers the best basis for the magnetic drilling machine to adhere and that the machine is secure before use.

- 1) Place the machine on the workpiece.
- 2) Ensure both magnets are pivoted and fully in contact.
- 3) Slide the machine to the desired drilling position, align the tool to any centre mark.
- 4) Turn BOTH magnet levers to the ON position to activate the magnets.
- 5) **IMPORTANT** – check that the machine is secure on the workpiece **BEFORE** operating the drill.
- 6) To deactivate the magnets, push the levers shown in the diagram above.

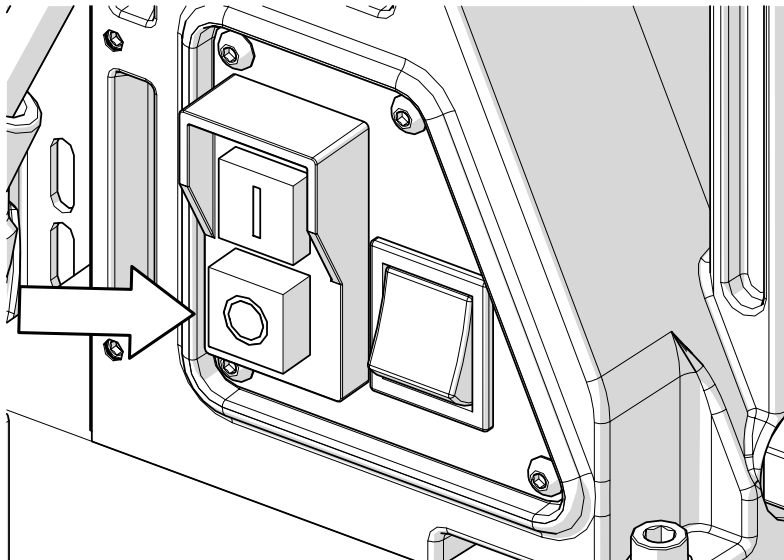
ALWAYS use the safety strap included.

Drilling above your head is extremely dangerous and is not recommended. For the use of magnetic drilling machines on pipes, curved or non-magnetic materials, we refer you to our website www.holemaker-technology.com where several pipe clamping & drilling systems can be found.

5.4 Emergency Stop

In case of emergency, to quickly stop the motor spindle rotating, hit the RED STOP button on the motor switch. This switch is both raised and unshrouded to enable it to be accessed quickly in an emergency. See [Image 14] below.

By hitting the motor stop this will stop the motor but leave the magnet energized for safety.



[image 14]

5.5 Tool lubrication

MACHINE IN UPRIGHT DRILLING POSITION

In order to use the lubrication system, the tank must be filled with a cutting fluid or oil

- 1) Make sure the flow regulator is closed.
- 2) Unscrew the fluid reservoir cap.
- 3) Fill the fluid reservoir with cutting fluid or oil.
- 4) Replace and secure the cap.
- 5) Adjust the fluid flow as required using the flow regulator
- 6) Add more cutting fluid if the shavings (metal chips) become blue.

VERTICAL AND OVERHEAD DRILLING POSITION

Apply cutting paste or an appropriate lubrication spray.



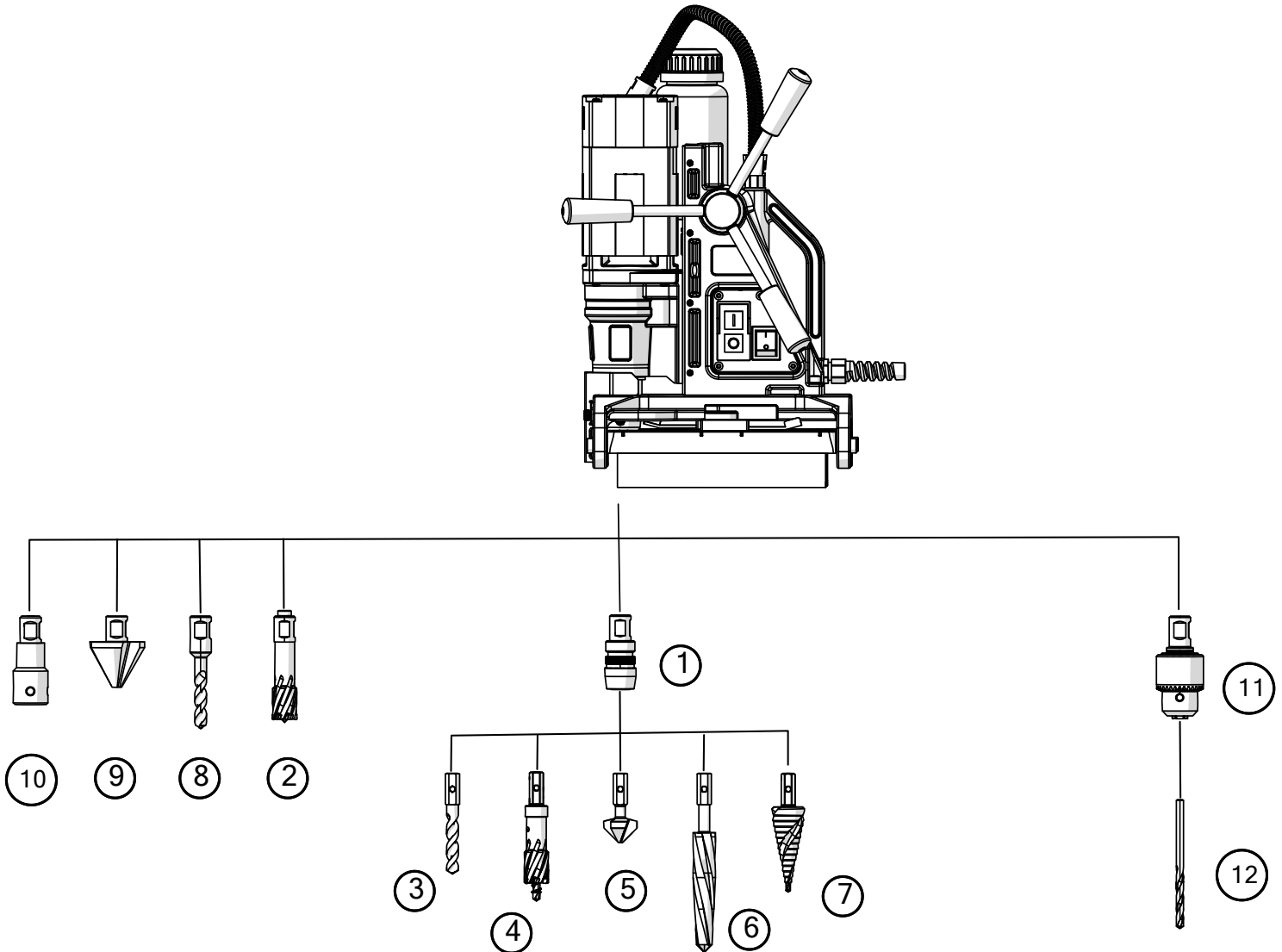
WARNING:

Do not use the lubrication system in vertical or overhead drilling applications.
Cutting fluid should not be allowed to enter the motor housing of the machine.
Instead use HMT Cutting Paste / HMT AeroPaste / SpeedLube Spray Lubricant.

Make sure to use only suitable cutting oil or fluid. HMT offers a wide range of cutting lubricants for all tool and material combinations. Proper cooling will help you create better results faster, whilst extending the lifetime of your tools.

6 Working with operating tools

6.1 VERSADRIVE Magnet Drill System



1. *VERSADRIVE* RAPID LOCK Weldon Shank Adaptor. (*Supplied*)
2. *CARBIDEMAX* TCT Broach Cutter.
3. *VERSADRIVE* Drill Bit.
4. *VERSADRIVE* Holecutter.
5. *VERSADRIVE* Countersink Bit.
6. *VERSADRIVE* Reamer.
7. *VERSADRIVE* Step Drill.
8. *HMT* Weldon Shank Drill Bit
9. *HMT* Weldon Shank Countersink Bit
10. *HMT* Weldon Extension (50mm, 75mm, 100mm)
11. *HMT* 13mm Keyed Chuck with Weldon to B16 Adaptor
12. Parallel Shank Drill Bit (Or other parallel shank tool)

6.2 VERSADRIVE RAPID LOCK ADAPTORS

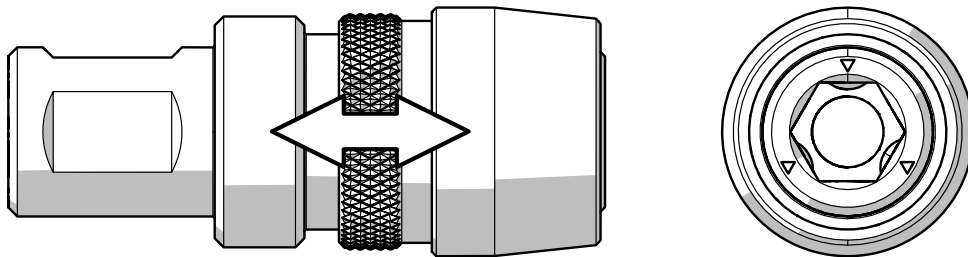
The *VERSADRIVE* V35 PIPE is supplied as standard with a *VERSADRIVE* RAPID LOCK Weldon adaptor.

The *VERSADRIVE* RAPID LOCK Weldon adaptor can also be used to adapt other magnetic drill.

This adaptor fits directly into the Weldon arbor of the machine to allow rapid loading of all *VERSADRIVE* tools/cutters.

VERSADRIVE RAPID LOCK offers the following advantages:

- Single handed tool change.
- RAPID and secure tool changing.
- Quick Release mechanism.
- Wide variety of *VERSADRIVE* cutting tools available, Drill, Tap, Countersink, Ream, etc.
- No tools required (Chuck wrench, Allen Key, etc).



6.3 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 use, 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 such as the tensile strength and hardness. Whilst hardness and/or strength is the usual criterion, wide variations in machinability 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.

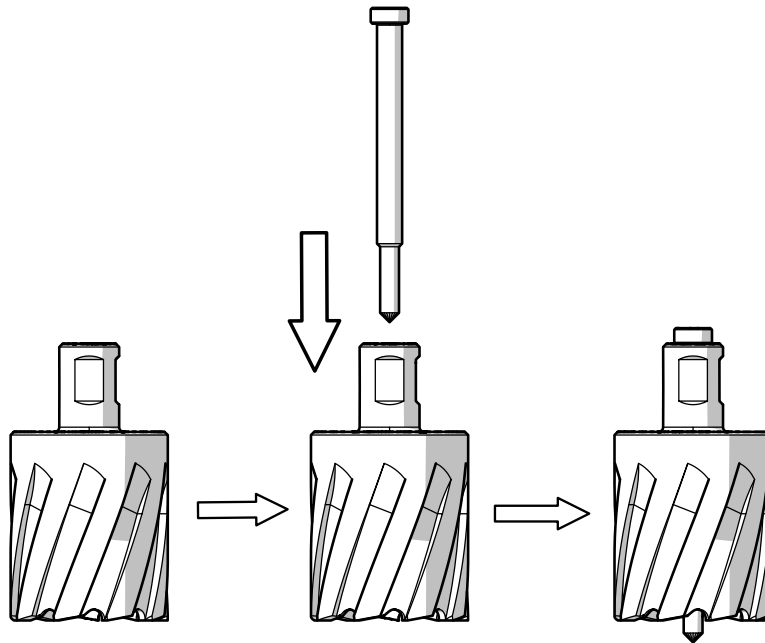
Some materials of low hardness contain abrasive substances leading to rapid cutter wear at high speeds. Feed rates are governed by rigidity of set-up, volume of material to be removed, surface finish and available machine power.

DRILLING A HOLE

Now that you have read the explanatory information and safety recommendations above, you are ready to start drilling. Follow these 13 steps below for best drilling results:

1. Install the annular cutter.

Place the pilot pin into the cutter, as shown in [Image 17]

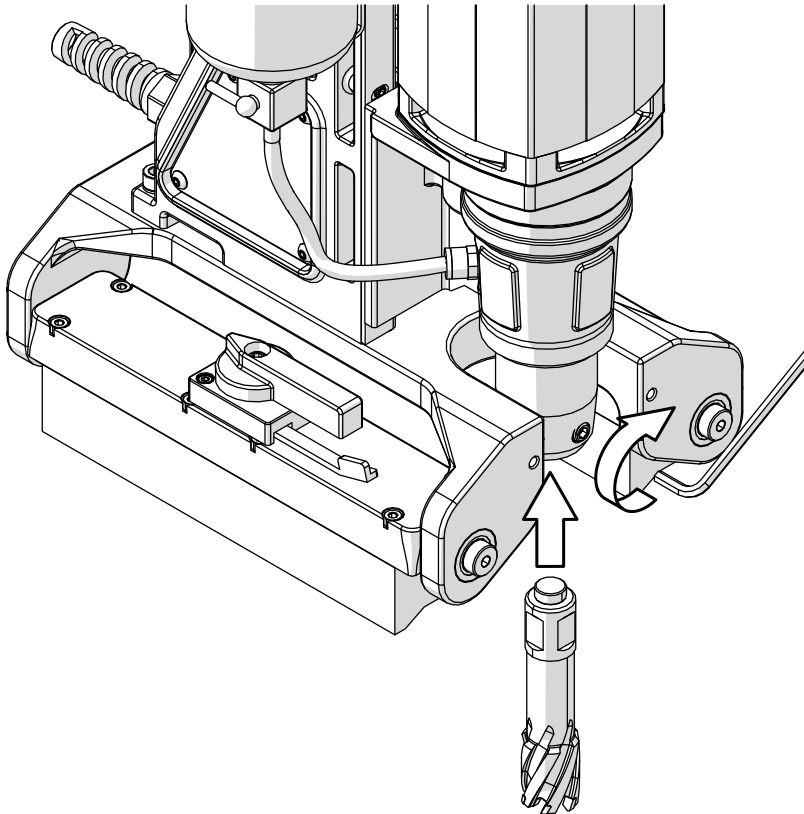


[image 17]

Insert the cutter and pin into the machine arbor, ensure both of the cutter shank flats align with the fixing screws on the machine arbor.

Once the cutter is aligned and pressed fully home tighten the two Allen screws with the key supplied.

ALWAYS MAKE SURE THE POWER PLUG IS DISCONNECTED!



[image 18] Guard not shown for clarity.

TAKE CARE WHEN HANDLING SHARP CUTTERS

2. Precisely mark the centre position of the of the hole on the workpiece.
3. Use the pilot pin to position the machine and in the correct position, with the tip of the pilot pin to meet the marked center of the hole.
4. Fix the machine by switching on the magnets and verify that the drill is in the right position and that the machine is fully secure on the work piece.
5. Open the valve/tap of the coolant system (if fitted) to allow the coolant oil to flow.
6. Switch on the motor and allow it to run up to the set speed.

7. Use the feed handle to lower the cutter to the workpiece, begin with relatively light pressure until a groove is formed.
8. Apply a regular pressure while drilling. The drilling performance does not improve by putting more pressure on the tool. Too much pressure will overload and slow the motor and as a result your annular cutter will become worn sooner.
A continuous, non-discoloured iron swarf is a sign of correct drilling speed and a well-cooled, sharp cutter. Let the cutter do the job and give it time to cut the metal!!!
9. Adjust the coolant/lubrication supply as necessary.
10. As the cutter approaches break through, apply less pressure.
The slug will be ejected out of the cutter by the pilot pin. Take care to ensure the ejected slug is contained and does not present a hazard
11. Once the slug is ejected, with the cutter still rotating, reverse the feed handle back until the output shaft is in its highest position and stop the motor unit.
12. Remove any burrs, metal chips and clean the cutter and surface wearing PPE, safely.
13. To remove the annular cutter, hold the cutter whilst releasing the two fixing screws, and pull down the cutter.

After drilling the cutter can be hot, resulting in a tighter fitment inside the output shaft. If this makes the cutter hard to remove, wait a few minutes for the cutter to cool down and try again.

PROTECT YOUR HANDS FROM THE SHARP CUTTER!

Caution: The ejected metal core piece drilled out can be sharp and very hot!!

6.4 Twist drills

This magnetic drilling machine can be used with twist drills of the following types.

- 1) HMT *VERSADRIVE* shank drills – using the *VERSADRIVE* Rapid Lock Weldon Adaptor.
- 2) HMT Weldon shank drills – fitted directly into the Weldon arbor.
- 3) Plain shank drills used in 3 jaw drill chuck – HMT drill chuck with Weldon shank adaptor.

7 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. Particularly the mains cable, if the machine appears to be damaged it should not be used failure to do so may cause injury or death.

CLEANING

- Clean all dirt, dust, metal chips and burrs of your magnetic drilling machine
- 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 an approved dust mask.
- 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.

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 BASES

Before every operation the magnetic bases 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.

When the machine is out of use for a longer period, apply a small amount of machine oil to the underside of the magnetic base for rust protection. Clean the magnetic base again with next use.

CHECK GEARBOX GREASE

The gearbox grease should be checked and replaced at least once a year to ensure maximum lubrication and cooling, and thus the best performance and durability of the machine.

CHECK ARMATURE

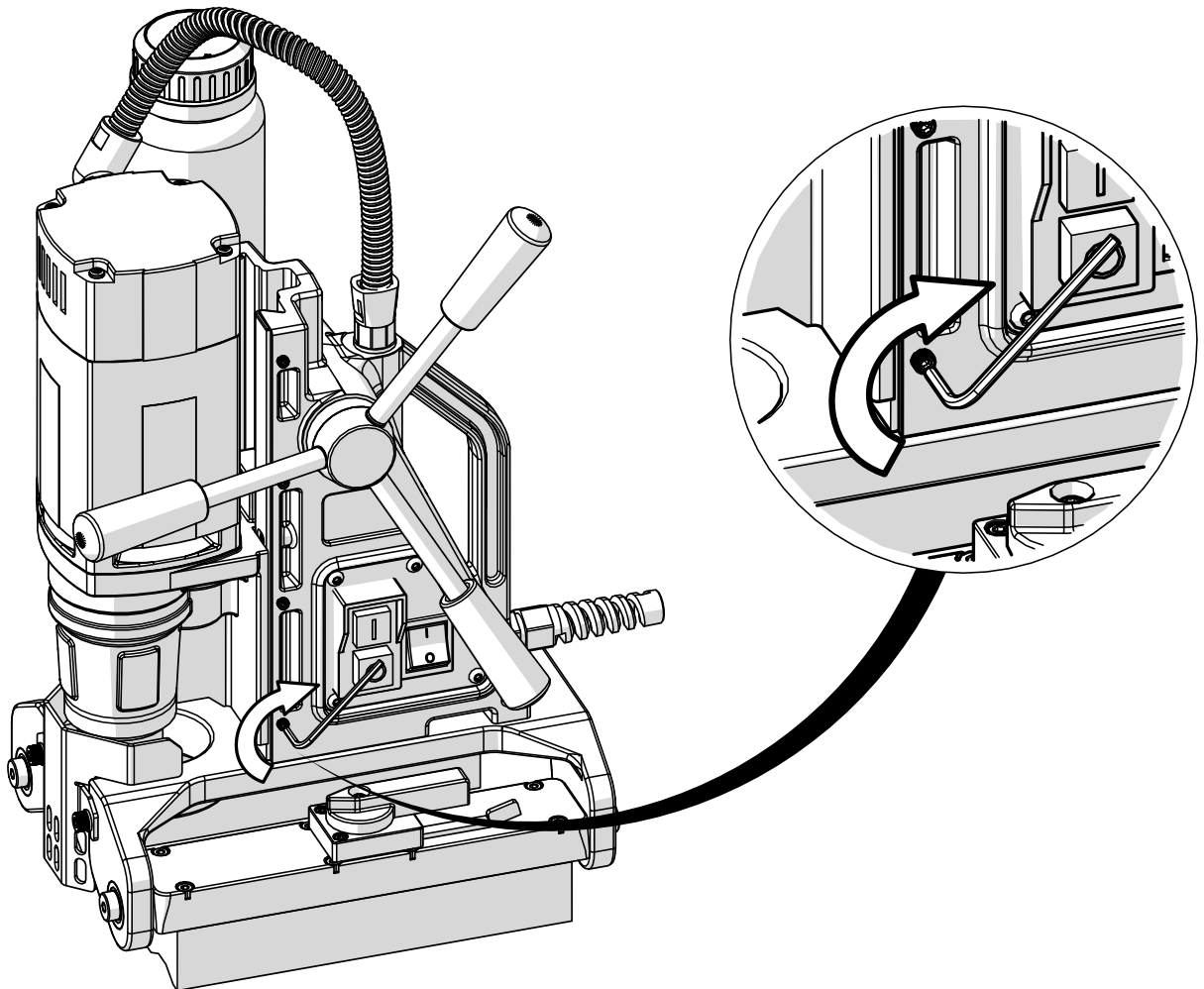
This should be checked at least once per month to check that there are no visual signs of damage to the body or to the commutator. Some signs of wear will be seen on the commutator over a period of time, as this part comes in contact with the carbon brushes, but any signs of abnormal damage and the part 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.

When supplied new, the output shaft has already been adjusted for ideal movement.
After time and use, the up and down movement may become a little loose, requiring adjustment.

Adjustment can be made via the 4x adjustment screws down the side of the main housing.



[image 20] Slide Adjustment - Adjust screws x4

To adjust the slide

- 1) Lower the slide to its lowest point
- 2) Adjust each of the 4x screws, in turn as below.
- 3) Adjust (tighten) the socket set screw with a 2.5mm Allen key.
- 4) Check the slide movement and keep readjusting until there is a slight resistance.

After adjustment the slide should be easy to move up and down, it should also stay at any height position. Do not overtighten the adjustment screws!

REPAIR, MODIFICATION AND INSPECTION

Repair, modification, and inspection of HMT Magnetic drilling machines must be done by HMT or 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.



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.

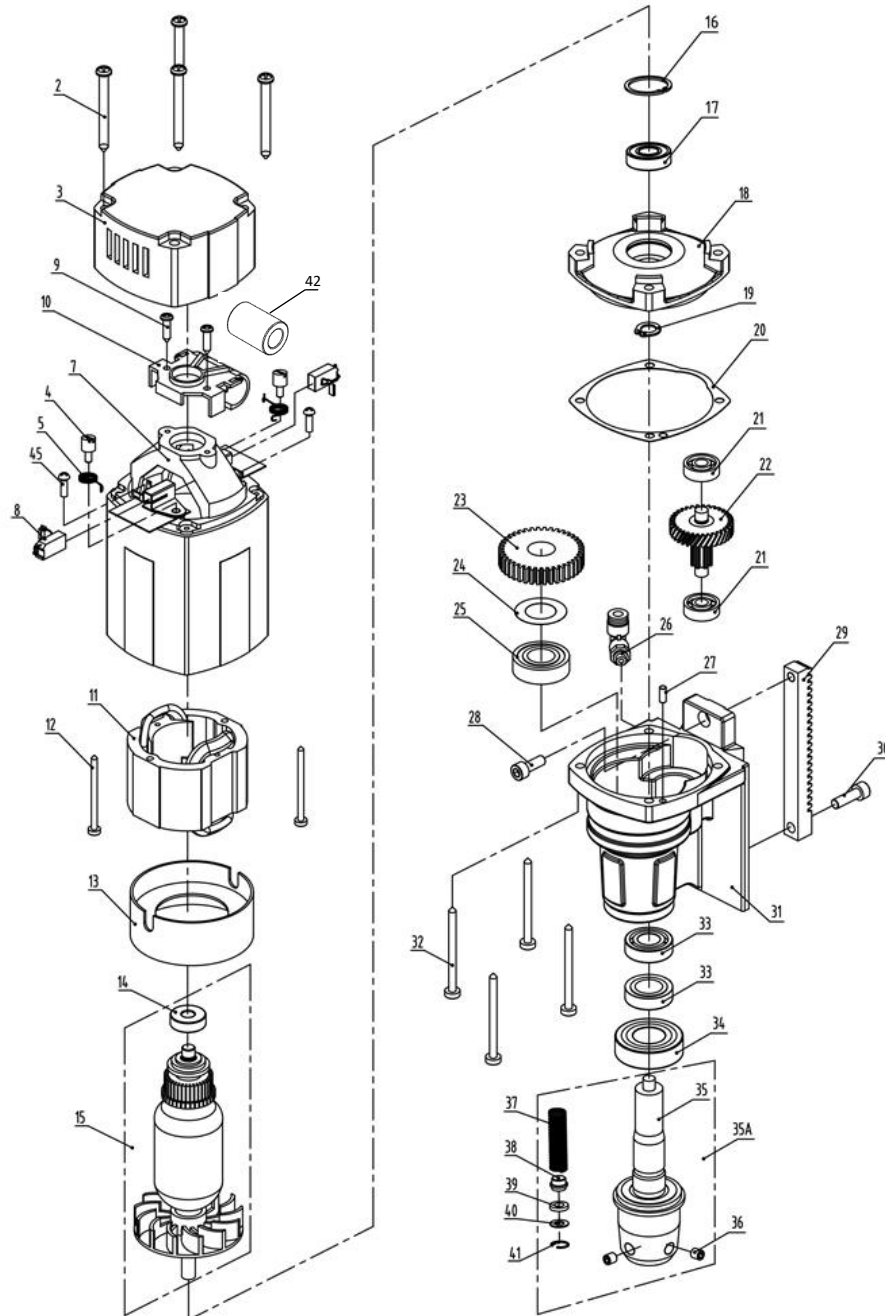
8 Trouble shooting

Magnet and motor do not function	<ul style="list-style-type: none"> - The machine is not connected to the power supply - Damaged or defective wiring - Defective fuse - Defective power switch - 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 power switch - Defective On / Off switch - Defective armature and/or field
Magnet does not function, the motor does	<ul style="list-style-type: none"> - Defective magnet - Defective wiring of magnet
Annular cutters break quickly, holes are bigger than the hole cutter	<ul style="list-style-type: none"> - Excessive clearance in the Slide - Bent spindle - Bent Arbor
Motor running roughly and/or seizing up	<ul style="list-style-type: none"> - Worn bearings - Worn transfer gear
Motor making a rattling sound	<ul style="list-style-type: none"> - Gear(s) worn out - No grease in gear box
Motor humming, big sparks and motor has no force	<ul style="list-style-type: none"> - Armature damaged (burned out) - Field coil damaged (burned out) - Carbon brushes worn out
Motor does not start or fails.	<ul style="list-style-type: none"> - Damaged or defective wiring - Defective or loose magnet on top of armature - Damage to Armature or field coil - Damaged or defective carbon brushes
Guiding takes a great deal of effort	<ul style="list-style-type: none"> - Slide Adjustment screws have been overtightened - Dirt in height adjustment gear/rack assembly - Insufficient lubrication to slide
Insufficient magnetic force	<ul style="list-style-type: none"> - Damaged magnet - 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 magnet
Fuse blows when magnet switch is turned on	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Defective power switch - Defective Control Unit
Fuse blows when motor is started	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Defective Armature and / or Field - Carbon brushes worn out

9 Exploded views & Spare part lists

9.1 Motor exploded view.

VERSADRIVE V35 PIPE – Drill unit parts diagram



Description	HMT Part	Qty
VERSADRIVE V35-110 Motor Unit - 110V	859203-110	1
VERSADRIVE V35-230 Motor Unit - 230V	859203-230	1

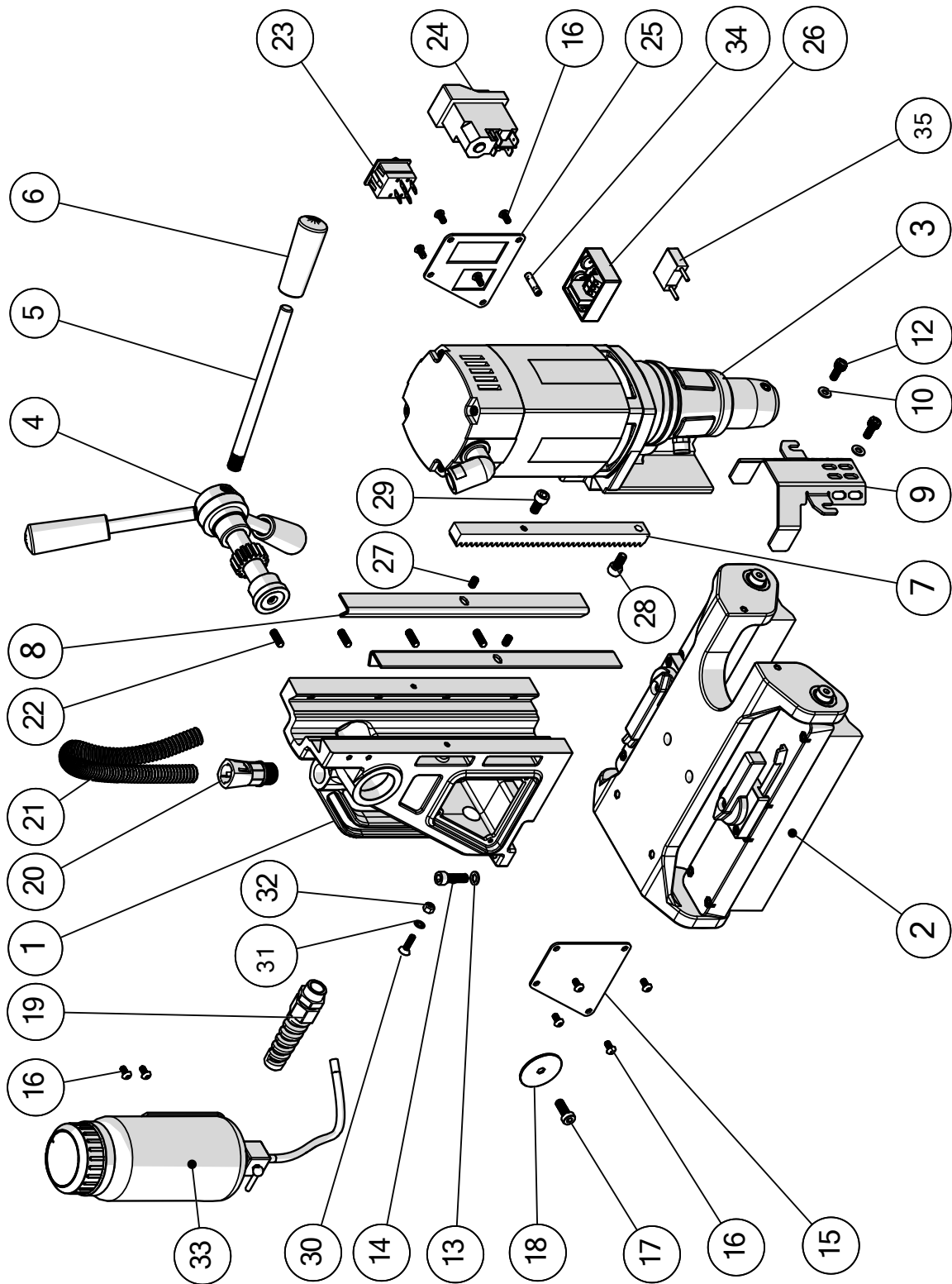
Motor spare part list

VERSADRIVE V35 PIPE – Motor / Gearbox Parts List

Item	Description	Part No.	Qty
2	Screw BK4,8 x 55	803050-0033	4
3	End cover	859203-01	1
4	Screw for spring		2
5	Spring		2
6	Screw		2
7	Housing incl. carbon brush holder	803019-0026	1
8	Carbon brush set 220V	859203-230-01	1
	Carbon brush set 110V	859203-110-01	
9	Screw M4 x 16		2
10	Adaptor ring cap		1
11	Field 220v	859203-230-03	1
	Field 110v	859203-110-03	
12	Screw BK4x55		2
13	Baffle		1
14	Bearing 8x22x7 608	803019-0015	1
15	Armature 220-240V	859203-230-02	1
	Armature 110-120V	859203-110-02	
16	Circlip 472/28/1.2		1
17	Bearing 6001	803019-0016	1
18	Inner Gear Plate	859203-04	1
19	Circlip 471/10/1		1
20	Gasket Small		1
21	Bearing 608 (8x22x7)	803019-0100	2
22	First Gear 34T	859203-02	1
23	Spindle Gear 40T	859203-03	1
24	Adaptor Ring		1
25	Bearing 6003	803019-0050	1
26	Coolant Connector	803019-0037	1
27	Casing Pin		1
28	Bolt M6 x 12		1
29	Rack (175mm)		1
30	Screw SS M6 x 20		3
31	Gear Casing		1
31/Set	Gear Casing Complete		-
32	Screw	803019-0039	4
33	Seal		2
34	Bearing	803019-0090	1
35	Spindle incl. Spring Set	803019-0091	1
36	Fixing Screw M8 x 8	803085-0024	2
37 - 41	Spring Set V35	803019-0047	1
42	Ferrite Bead (110V FCC only)		1

9.2 Stand exploded view

VERSADRIVE V35 PIPE – Magnetic stand parts diagram

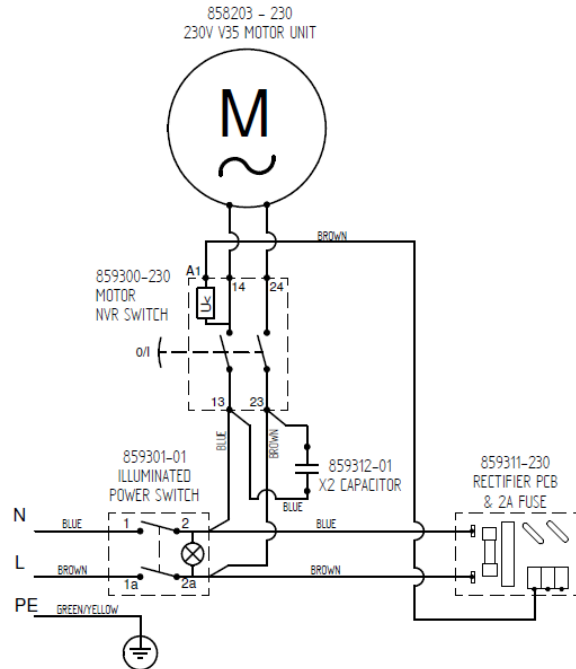


VERSADRIVE V35 PIPE – Magnetic Drill Stand - Parts List

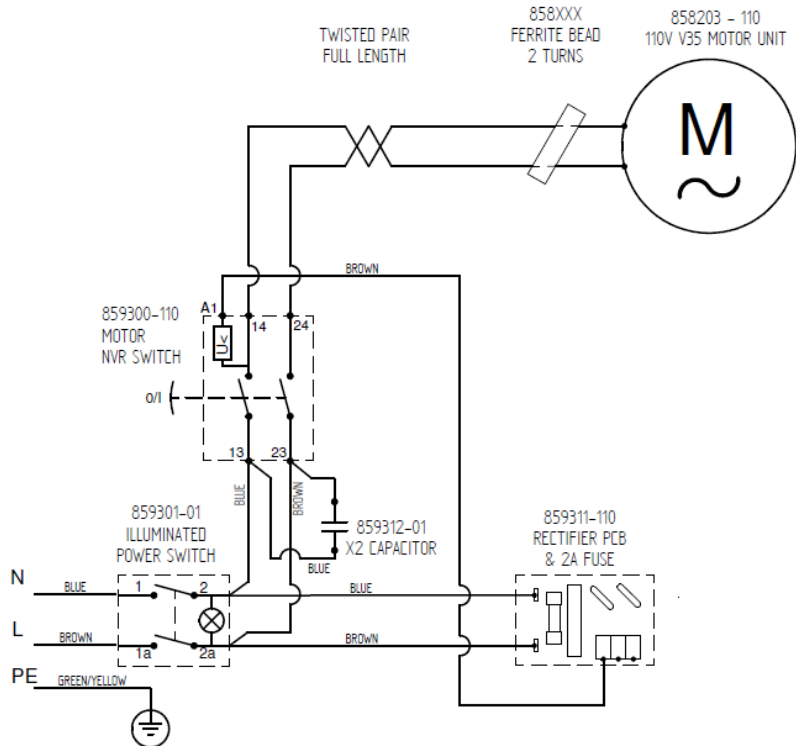
Item	Description	Part No.	Qty
1	Body Casting	859001-02	1
2	Switchable Magnet Base Assy.	811040-35	1
3	Drill/Gearbox Unit 230V	859203-230	1
	Drill/Gearbox Unit 110V	859203-110	
4	Pinion shaft	859006-02	1
5	Capstan Handle	859007-03	3
6	Capstan Plastic Knob	859007-04	3
7	Rack (175mm)	859011-02	1
8	Brass guide	859010-02	2
9	Guard	859016-04	1
10	M5 Form A Washer	859401-03	2
11	M5 Spring Washer		2
12	M5 x 12 Skt Hd Cap Screw	859400-09	2
13	M6 x 20 Skt Hd Cap Screw	859400-01	4
14	M6 Schnorr Washer	859401-02	2
15	Rear Panel - 230V	859013-02-230	1
	Rear Panel - 110V	859013-02-110	
16	M4 x 8 Button Hd Skt Screw	859402-01	10
17	Pinion End Cap	859008-02	1
18	M6 Pinion End Cap screw	859400-06	1
19	Cable Protection Gland	859308-01	1
20	Conduit Cable Gland	859019-01	1
21	Plastic Conduit	859014-02	1
22	M5 x16 Cone Point Skt Screw	859403-01	4
23	Power Switch	859301-01	1
24	Motor NVR Switch 230V	859300-230	1
	Motor NVR Switch 110V	859300-110	
25	Front Panel	859012-02	1
26	PCB - 230V	859311-230	1
	PCB - 110V	859311-110	
27	M5 x 8 Skt Screw	859403-02	2
28	M6 x 12 Skt Hd Cap Screw	859400-06	1
29	M6 x 12 Skt Hd Cap Screw	859400-06	1
30	M4 x 16 Torx CSK Head A2/SS	859404-01	1
31	M4 Int Serrated Washer A2/SS	859404-03	1
32	M4 Hex Nut A2/SS	859404-02	1
33	Coolant Bottle Assembly	859102-BR	1
34	2A Fuse	859304-01	1
35	EMC X2 Capacitor	859312-01	1

9.3 Wiring diagrams

VERSADRIVE V35 PIPE – 230V wiring diagram (below)



VERSADRIVE V35 PIPE -110V wiring diagram (below)



10 HMT Warranty Statement

Magnetic Drills & Electrical Equipment

Holemaker Technology warrants its Magnetic Drills for the period stated in the manual or on the product specification sheet which can be found on the website. The warranty period is valid from the date of purchase against defects due to faulty material or workmanship. At its discretion, once a warranty claim has been validated, HMT will either:

- A. Arrange for the transport and repair of the equipment by HMT in the United Kingdom
- B. Supply free of charge parts for repair by an authorized repair center.

Conditions of warranty validity:

The Customer must notify HMT of any defect in writing within ten (10) Business Days of the defect occurring or of becoming aware of the defect.

- 1. HMT is permitted to make a full examination of the alleged defect.
- 2. The defect did not materialize as a result of misuse, neglect, alteration, mishandling or unauthorized manipulation by any person other than the Company's authorized personnel.
- 3. The defect did not arise out of any information, design or any other assistance supplied or furnished by the Customer or on its behalf, and.
- 4. The defect is directly attributable to defective material, workmanship, or design.

Insofar as the Equipment comprises or contains equipment or components which were not manufactured or produced by the Company, the Customer shall be entitled only to such warranty or other benefit as the Company has received from the manufacturer.

The HMT warranty policy is in accordance with its Terms & Conditions of business. Warranties can be registered at holemaker-technology.com/pages/warranty



11 Certification

Declaration of conformity

Holemaker Technology Ltd
Bridge House
Pattenden Lane
Marden
Kent
TN12 9QJ



Declares that the following appliance complies with all relevant UKCA and CE marking Directive requirements:

Product	Magnetic Drilling Machine
Model	VERSADRIVE V35 PIPE
Ratings and principal characteristics	230V~, 110V~, 50/60Hz, 900W, n_o : 750/ min ⁻¹ Insulation Class 1

Relevant Standards

Machinery Directive	2006/42/EC	EN 12100-1:2010 EN 62841-1:2015
EMC Directive	2014/30/EU	EN 61000-3-2:2019 EN 61000-3-3:2013+A1:2019 EN 55014-1:2017+A11:2020 EN 55014-2:2015

RoHS3 Directive 2015/863/EU

Verification Issuing Office: SGS - CSTC
CB Scheme Approval Certificate BE-40172

CE & UKCA Certificate No: SHEM210500404601PTC, SHEM210700750101PTC
SHES210400817601TLC, SHEM210700750301PTC
SHEM210700750201PTC,
UKCA SHES210400817601TLC

FCC EMC Verification of Compliance No: SHEM210400394001PTC

Hugh Crane

Date: 16.03.2022

A handwritten signature in black ink, appearing to read 'Hugh Crane'.

Director

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