



Operation Manual **Magnetic Drill Model FE 45**



OPERATION GUIDELINES

Attention: Make sure the magnetic drill is turned off and unplugged from power supply before parts assembly and set-up.

- 1- Place the magnetic drill in desired position. Install the adequate drill.
- 2- Plug machine into power supply, turn on electromagnetic switch, making it adhered to the steel surface.
- 3- Unfasten the magnet base handle and set the exact drilling position. Turn and fasten handle securely.
- 4- Switch machine on. Set the desired rotation.

TIPS

- Use the automatic lubrication system only when Magnetic Drill is in the horizontal position. In other positions, use spray or paste lubricants.
- The drilling capacity showed in table "Features" above refers to annular cutters, which provide significant savings in time and power, once they cut a single ring around the hole, producing solid chips as waste. Since they are hollow, annular cutters require special care by the operator or else they may break down. Annular cutters are not recommended for cutting "Sandwich" plates.
- When using annular cutters to cut holes in pipes, the use of the pilot is not recommended. Thus, the chip will be held inside the annular cutter and not inside the pipe.

Standard equipment includes:

- 01 Magnet base
- 01 Electric drill
- 01 Safety belt
- 02 Fuses 1 A
- 01 Hex wrench
- 01 Oil tank
- 01 Carbon brush
- 01 # 2-1 morse taper reduction sleeve
- 01 morse taper ejector tool
- 01 annular cutter chuck

Optional accessories

- Pipe adapter
- Rail adapter
- Morse cone adapter for B16 chuck
- B16 chuck
- Pilot pin for annular cutters

WARRANTY

MERAX Magnet Base Drilling Machines have a 6-month guarantee after the date of issue of invoice or delivery of the product to the final consumer.

This warranty applies to manufacturing, materials, parts and workmanship defects, when adequately proven.

This warranty does not apply to damages provoked by inadequate transportation, accidents of any type, misuse, electrical installation oscillations, use of wrong voltage, bad quality of compressed air, the removal or alteration of the series number of the machine, and the non-compliance with the instructions herein contained

This warranty does not apply to any component that deteriorates under normal use.

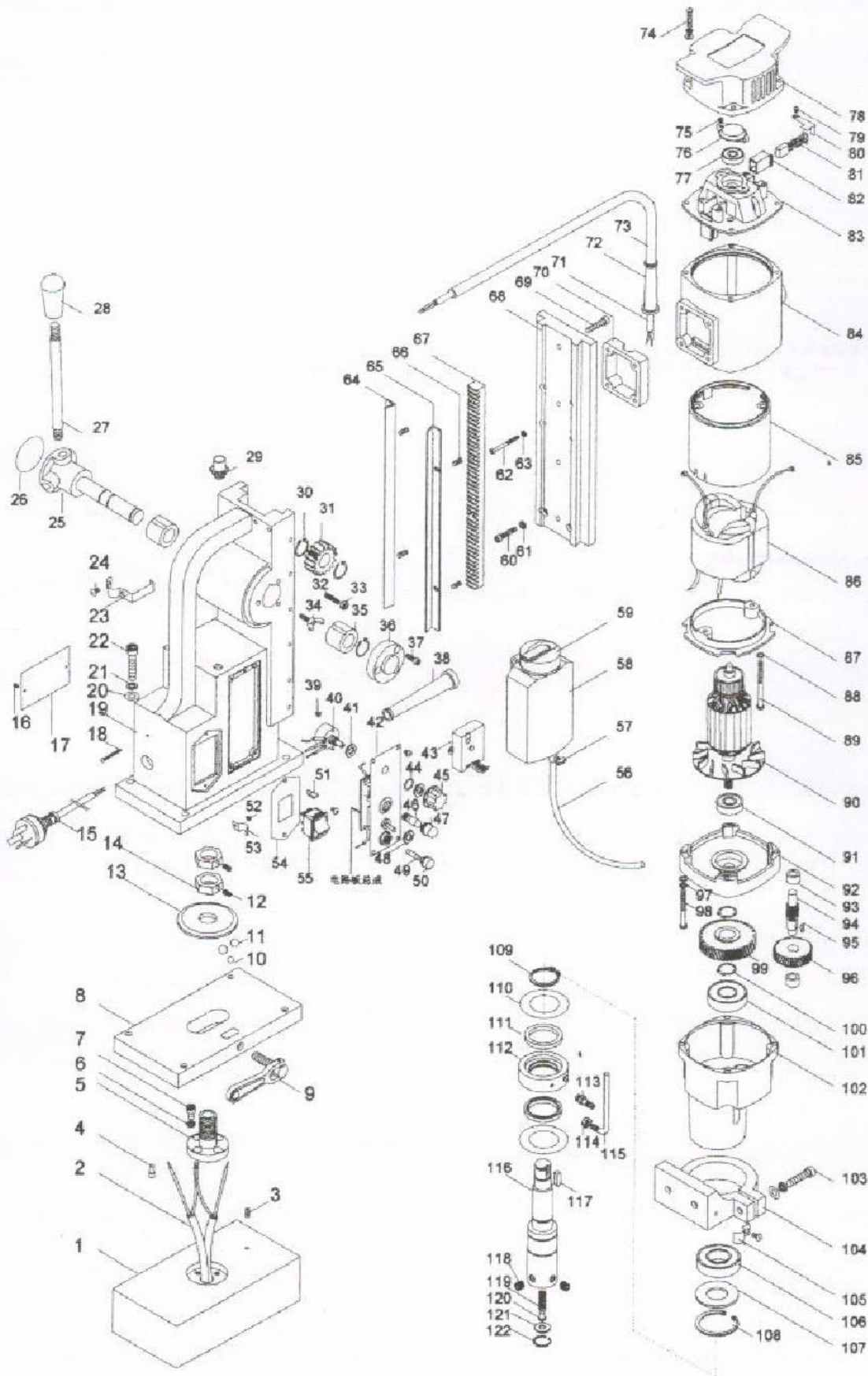
Use only original spare parts and always contact a Merax Authorized Assistance. Check list in our website: www.merax.com.br

Parts Listing

No.	Description	Code	Amount
1	Magnet base	PF4520	1
2	Solenoid Coil Magnet Base	PF4538	2
3	Screw	PF4520	1
4	Pin	N	1
5	Screw	N	1
6	Springs	N	4
7	Hex screw	N	4
8	Plate	N	1
9	Fine tuning lever	PF4525	1
10	Ball	N	1
11	Ball	N	2
12	Pin	N	2
13	Washer	N	1
14	Nut	N	2
15	Plug	N	1
16	Rivet	N	2
17	Label	N	1
18	Screw	N	1
19	Machines block	N	1
20	Washer	N	4
21	Sets of springs	N	4
22	Hex screw	N	4
23	Oil reservoir support bracket	N	1
24	Screw	N	2
25	Metal strap	N	1
26	Label	N	1
27	Lever	PF4501	3
28	Lever cable	PF4501	3
29	Lever cable protector	N	1
30	Snap ring	N	3
31	Gear pinion	PF4534	1
32	Screw	N	5
33	Head screw	N	5
34	Thumb screw	N	1
35	Steel Bushing	N	2
36	Plastic cap	PF4518	1
37	Screw	N	3
38	Plastic cap	N	1
39	Screw	N	2
40	Rotation potentiometer	PF4519	1
41	Nut	N	1
42	Magnet control Panel	PF4503	1
43	Rotation potentiometer	PF4519	1
44	Washer	N	1
45	Switch	N	1
46	Lamp	PF4503	1
47	Acrylic	PF4503	1
48	Nut	PF4503	1
49	Fuse	PF4503	1
50	Fuse holder cap	PF4503	1
51	Thermoplastic pipe	N	1
52	Screw	N	1
53	Cord holder	N	1
54	Toggle cover	N	1
55	Switch	PF4504	1
56	Plastic hose	FE 45	1
57	Gauge	FE 45	1
58	Oil reservoir	FE 45	1
59	Oil reservoir cap	FE 45	1
60	Hex screw	N	4
61	Spring washer	N	2

No.	Description	Code	Amount
62	Screw	N	4
63	Spring washer	N	4
64	Copper Plate	PF4528	1
65	Copper Plate	PF4528	1
66	Plate screws	PF4530	4
67	Rack-and-pinion	PF4531	1
68	Mounting plate, Drill	PF4532	1
69	Screw	N	1
70	Intermediary Guide	PF4533	1
71	Cord	N	1
72	Cord protection	N	1
73	Spiral Conduit	PF4527	1
74	Hex screw	N	4
75	M5 - 10 Screw	N	2
76	Bearing Protection	PF4523	1
77	Bearing	DU6000	1
78	Upper cap	PF4526	1
79	Screw 4 x 10	N	2
80	Brush holder cap	PF4507	2
81	Carbon brush	PF4517	2
82	Brush holder	PF4506	2
83	Rear bearing of electric motor	PF4505	1
84	Motor body	PF4508	1
85	Insulator body	PF4509	1
86	Electric coil	PF4510	1
87	Coil	PF4511	1
88	Spring washer	N	2
89	Hex screw	N	2
90	Induction motor	PF4512	1
91	Bearing	DU6201	1
92	Intermediate Bearing Motor	PF4513	1
93	Bearing - Bushing Motor Bearing	PF4536	2
94	Gear pinion	PF4514	1
95	Woodruff key	N	1
96	Gear pinion	PF4521	1
97	Spring washer	N	1
98	Screw	N	1
99	Main gear	PF4522	1
100	Snap ring	N	2
101	Bearing	PU6204	1
102	Reducer body	PF4515	1
103	Screw	N	1
104	Mounting plate, Drill	PF4516	1
105	Hose mount	N	1
106	Bearing	PU6205	1
107	Spring washer	N	1
108	Snap ring	N	1
109	Snap ring	FE 45	1
110	Washer	FE 45	1
111	Stop ring	FE 45	1
112	Lubrication bearing	FE 45	1
113	Fitting	FE 45	1
114	Nut	FE 45	1
115	Bumper	FE 45	1
116	Morse cone shaft	PF4524	1
117	Woodruff key	FE 45	1
118	Screw	FE 45	1
119	Spring	FE 45	1
120	Pin	FE 45	1
121	Washer	FE 45	1
122	Snap ring	FE4504	1

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