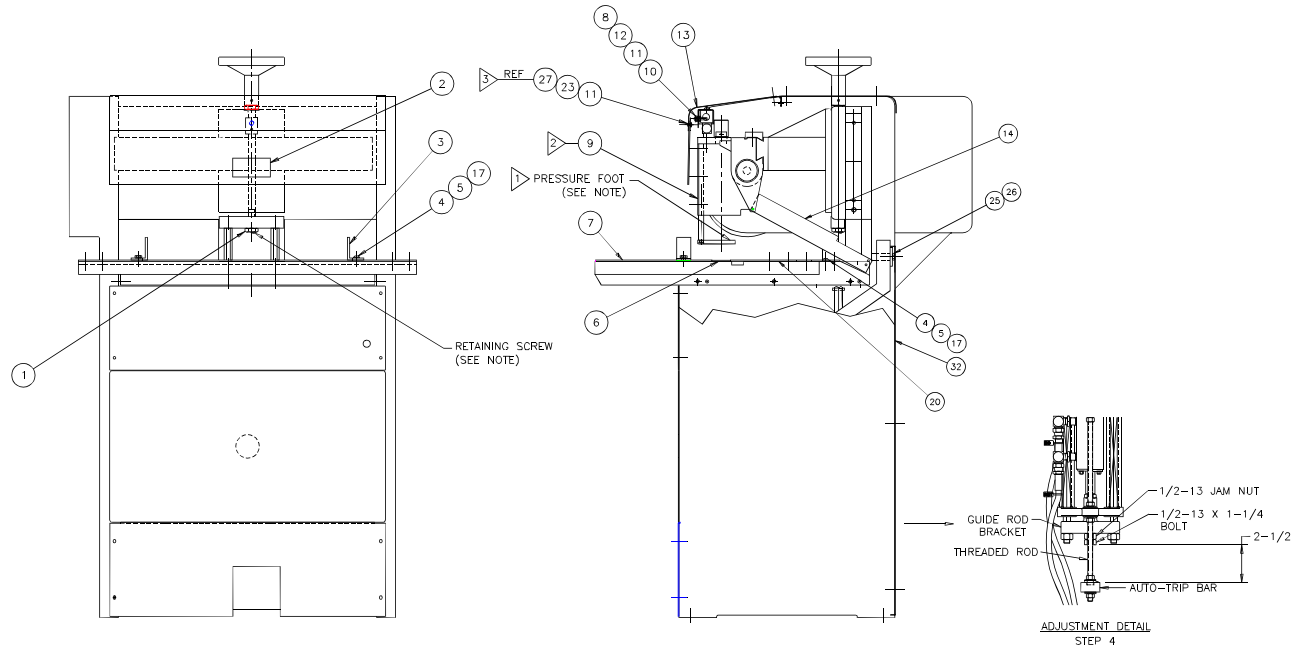


# 5.5 Main Assembly – Large Diameter Drill Head Field Conversion

A-6500-7 Rev. B



### INSTRUCTIONS FOR LARGE DIA DRILL FIELD CONVERSION:

- |                                 |              |                            |                  |
|---------------------------------|--------------|----------------------------|------------------|
| 1. REMOVE THE FOLLOWING PARTS:  | PART NO.     | STEP 3 CONT'D:             | PART NO.         |
| A. COVER                        | 6639         | D. (6) PLASTIC CUT STRIPS  | 6669             |
| B. SCALE                        | 6545         | E. FRONT TABLE ADAPTOR     | 6667             |
| C. HEADS                        | A-6594-6     | (ATTACH W/ 6672 OR A-6565) | (SEE NOTE BELOW) |
| D. CHIP CHUTE                   | A-6538       | F. STOPS FOR DRILL BLOCKS  | 6590             |
| E. SIDE GUIDE                   | A-6565       | G. CHIP CHUTE              | A-6538           |
| F. BACKGAGE                     | A-6561-2     | H. HAND KNOBS              | S-1770-1         |
| G. B.G. KNOBS                   | S-1770-1     | J. DRILL HEAD              | A-6594-7         |
| H. STOPS FOR DRILL BLOCKS       | 6590         | K. COVER                   | 6639-1           |
| I. TABLE LIGHT ASSY             | EE-1489-2    | P. (2) SCREWS (ITEM 26)    | H-6913-624       |
| J. RETAINING SCREW              | (SEE DWG)    | O. (2) NIPPLES (ITEM 25)   | H-6405-1-616     |
| M. (2) CHIP CHUTE BRKT MTG SCRS | H-6918-620   |                            |                  |
| N. (2) NIPPLES - 3/8 X 1-1/2    | H-6405-1-612 |                            |                  |
2. CLEAN TABLE – BE SURE WOOD CUTTING BLOCKS ARE FLUSH WITH TABLE.
3. INSTALL THE FOLLOWING PARTS:
- |   |           |
|---|-----------|
| A. TABLE LIGHT ASSY (MOUNTS OUTSIDE OF FRAME)   | EE-1489-2 |
| B. REAR TABLE ADAPTER   | 6668      |
| M. 3/4-16 THIN FLEX LOCK NUT (TURN HANDWHEEL CW TO EXPOSE ROD & INSTALL NUT FLUSH WITH END OF ROD.) | H-5239-12 |
| N. RETAINING SCREW (SEE DWG) (TURN HANDWHEEL CCW UNTIL NUT HITS BRKT)                               | (SEE DWG) |
4. ADJUSTMENT  
ON THE REAR ON THE MACHINE – LOCATE THE BOLT AND JAM NUT ON THE BOTTOM OF THE GUIDE ROD BRACKET. TURN THE BOLT OUT SO THAT IT IS 2-1/2 INCHES FROM THE TOP SURFACE OF THE TRIP BAR – TIGHTEN THE JAM NUT TO LOCK THE BOLT IN PLACE. (SEE DETAIL ABOVE)
5. ADJUST DRILLING DEPTH:  
FOLLOW NORMAL PROCEDURE FOR NEW DRILL ADJUSTMENT.
- NOTE: WHEN USING TWO DRILL HEADS, DO NOT USE (6672) PAPER GUIDES. USE THE STANDARD SIDE GUIDE (P/N A-6565).

NOTES:

MAX. BACK MARGIN = 2-5/8" (67mm)

- 1. WHEN CHANGING DRILLS, REMOVE PRESSURE FOOT.
- 2. TWO DRILL HEADS ARE NOT RECOMMENDED FOR SINGLE PHASE MACHINES.
- 3. REQUIRED OF MACHINES PRIOR TO 10-1-89.

Main Assembly – Large Diameter Drill Head Field Conversion – Parts List  
A-6500-7 Rev. B

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
28	A-6500-7 SHT 5	BLUEPRINT OF ASSEMBLY	1
1	H-5239-12	3/4-16 LT TH FLEX LOCK NUT	1
2	6670	LABEL	1
3	6672	PAPER GUIDE	2
4	H-6910-606	3/8-16 X 3/4 BUTT HD SCR	4
5	H-7324-12	3/8 SHAKEPROOF LOCKWASHER	4
6	6669	CUTTING BLOCK - PLASTIC	6
7	6667	TABLE ADAPTOR - FRONT	1
8	H-7322-#10	WASHER - #10 POLISHED FL	4
9	A-6594-7	LARGE DIA DRILL HD ASSY	1
10	H-6923- 102420	#10-24 X 1-1/4 LG RD HD SCR	2
11	H-6423-#10	#10-24 HEX NUT	6
12	H-7324-#10	#10 INT TOOTH LOCK WASHER	6
13	6639-1	COVER - FRONT	1
14	A-6538	CHUTE - CHIP	REF
15	S-887	3/8 X 90%%D CONN (NOT SHOWN)	1
16	S-1122-1	3/8 INS. SLEEVE AS -1 (NOT SHOWN)	2
17	H-7322-6	WASHER - 3/8 POLISHED FL	4
18	B-180	3 X 5 MAIL BAG (NOT SHOWN)	1
19	E-2196-11	KNOCK-OUT PLUG (NOT SHOWN)	1
20	6668	TABLE ADAPTER - REAR	1
21	W-134	WRENCH - 7/32 (NOT SHOWN)	1
22	4687	DRIFT (NOT SHOWN)	2
23	6642	SUPPORT - SHIELD (SEE NOTE #3)	REF
24	E-807	3/8" EX. FLEX CONDUIT (NOT SHOWN)	0.5
25	H-6405-1-616	3/8 X 2" NIPPLE, BLK EX HVY	2
26	H-6913-624	3/8-16 X 3" HEX HD SCR	2
27	H-6910- 102403	#10-24 X 3/8 BUTT HD SCR (QTY 3)	REF

## Main Assembly – Large Diameter Drill Head Field Conversion – Installation Instructions

A-6500-7 Rev. A



### CAUTION

**Always Disconnect the main power when cleaning, servicing or lubricating your drill. See Power Lock-Out Procedure, page 5.**

The MS-10B Paper Drill can be easily altered to handle drilling of one or two holes up to 1-1/2" diameter, as well as handling standard drill work. Seven standard size hollow drills (listed below) are available for use with these large hole drilling heads.

The adjustment for hole spacing is done in the same manner as for a standard drill head. The maximum center-to-center distance of heads is 17-3/4", while the minimum distance is 5". The maximum back margin is 9". The machine can handle either one or two heads with a maximum drilling capacity of a 2" lift.



### CAUTION

**WARNING: drills are very sharp (even after use), handle with care to avoid severe lacerations. Even dull drills are sharp enough to cause severe lacerations.**

It is important to keep the hollow drills sharp. They are sharpened to a 35 degree bevel and if there isn't a machine shop in your area that can handle the job, a factory resharpening service is provided for large hole drills. Two drills are provided with each head so one can be sent in for sharpening while the other is being used. More drills, however, maybe desired to allow for continuous drilling work.

The large hole drilling conversion kit (#A-6500-7) includes one large hole drilling head (#A-6594-7) which is supplied with two hollow drills, 1-3/8" diameter, unless otherwise specified.

### Standard Large Hole Hollow Drill Sizes

9/16" dia.

5/8" dia.

3/4" dia.

1" dia.

1-1/4" dia.

1-3/8" dia.

1-1/2" dia.

### Installation Instructions:

- 1) Remove the following parts:
 

A. cover assembly	A-6638
B. scale	6545
C. heads	A-6594-1 or -6
D. chip chute	A-6538
E. side guide	A-6565
F. backgauge knobs	6587
G. backgauge	6561-2
H. drill block stops	6590
I. table light assembly	EE-1489-2
- 2) Clean table – be sure present wood drilling blocks are flush with the table
- 3) Install the following parts:
 

A. mount the table light assembly outside the frame with (2) 1-1/4" round head machine screws and (4) hex nuts.
B. Rear table adapter 6668
C. Chip chute

Note: If chip chute extensions are ordered, install them before mounting the chip chute. See instructions for mounting instructions.

- D. (6) plastic drilling blocks 6669
- E. Front table adapter 6667  
Attach with paper guides 6672 or A-6565 if desired
- F. stops for drilling blocks 6590
- G. backgauge 6561-2
- H. backgauge knobs 6587
- I. drill head A-6594-7
- J. cover assembly 6638-1

4) Adjust drilling depth – follow normal procedure for new drill adjustment.

5) When using two drill heads do not use paper guides 6672, use standard side guide A-6565

