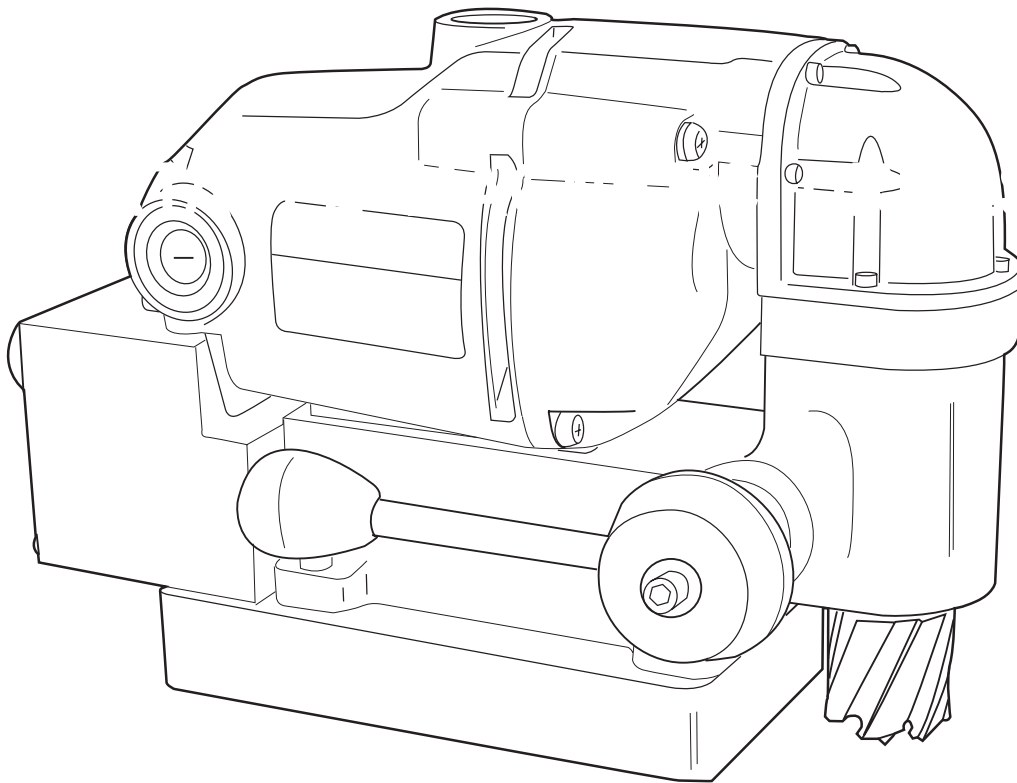


KIMBALL MIDWEST

Specializing in Materials Management

OPERATOR'S MANUAL



Part No. 82-4627

ROTO-KUT FRAME & FABRICATION DRILL

**For Use with ROTO-KUT Auto-Lok Frame
& Fabrication Drill Cutters**

ROTO-KUT FRAME DRILL

Part No. 82-4627

Welcome to Kimball Midwest

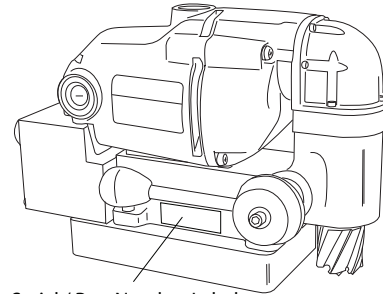
Congratulations on your purchase of a Roto-Kut Frame & Fabrication Drill. Your frame drill is designed to produce superior holes quickly and efficiently. Kimball Midwest is committed to provide you with tools and products to help you be more productive.

Before attempting to operate your new Roto-Kut Frame & Fabrication Drill, please read all instructions first. These include the Operator's Manual and Warning Label on the unit itself. With proper use, care, and maintenance, your model will provide you with years of effective hole drilling performance.

The Roto-Kut Frame Drill now uses a Serial/Part Number Label located on the side of the housing. Refer to this label to identify the serial number of your machine.

Specifications

Cutter Type.....Roto-Kut Auto - Loc Frame &
Fabrication Drill Cutters
Hole Capacity.....1/2" to 1-3/8"
Depth of Cut.....1"
Motor.....450 RPM, 8A 120V
Net Weight.....22.7 Lb



Serial / Part Number Label

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WARNING



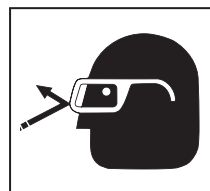
Cutters are sharp. Wear gloves when installing or removing cutter from arbor. Do not grab a rotating cutter.



To prevent electric shock, do not use power tools near wet areas, or where power tool may become wet.



Do not stare at operating light.



Always wear eye protection while using cutting tools, or in the vicinity of cutting.



The slug is ejected at the end of the cut. Do not aim cutter or arbor so that ejected slug may hit someone around, or below you.

IMPORTANT SAFETY INSTRUCTIONS



WARNING:

Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

1. Work Area Safety

- Keep your work area clean and well lit. Cluttered or dark areas invite accidents.
- Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
- Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.

2. Electrical Safety

- 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. Unmodified plugs and matching outlets will reduce risk of electrical shock.
- Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
- Don't expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
- Do not abuse the cord. Never use the cord for carrying or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
- When operating a power tool outdoors, use an outdoor extension cord suitable for outdoor use. Use of cord suitable for outdoor use reduces the risk of electric shock.
- If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply. Use of an RCD reduces the risk of electric shock.

3. Personal Safety

- 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. A moment of inattention while operating power tools may result in serious personal injury.
- Use personal protective equipment. Always wear eye protection. Protective equipment such as dust mask, non-skid shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.

- 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. Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.
- Remove any adjusting keys or wrench before turning the power tool on. A wrench or a key that is left attached to a rotating part of the power tool may result in personal injury.
- Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- Dress properly. Do not wear loose clothing or jewelry. Keep your hair and clothing away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts.
- If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used. Use of dust collection can reduce dust-related hazards.
- Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles. A careless action can cause severe injury within a fraction of a second.
- Always use safety chain. Mounting can release.

4. Power Tool Use and Care

- Do not force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it is designed.
- Do not use the power tool if the switch does not turn it on or off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- 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. Such preventative safety measures reduce the risk of starting the tool accidentally.

(Continued on page 4)

Save all warnings and instructions for future reference.

IMPORTANT SAFETY INSTRUCTIONS

- d) Store idle power tools out of reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. *Power tools are dangerous in the hands of untrained users.*
- 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. *Many accidents are caused by poorly maintained power tools.*
- f) Keep cutting tools sharp and clean. *Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.*
- g) Use the power tool, accessories and tool bits etc. in accordance with the instructions, taking into account the working conditions and the work to be performed. *Use of the power tool for operations different from those intended could result in a hazardous situation.*
- h) Keep handles and grasping surfaces, clean and free from oil and grease. *Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.*

5. Service

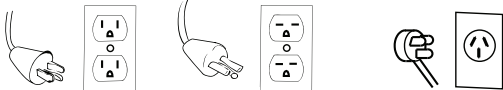
- a) Have your power tool serviced by a qualified repair person using only identical replacement parts. *This will ensure that the safety of the power tool is maintained.*

ADDITIONAL SAFETY INSTRUCTIONS

Safe Electrical Connection

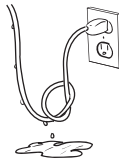
Your Drill is rated for use on 115VAC or 230V at 50-60Hz. Do not attempt to use drill on power sources rated other than this.

Plugs and Receptacles



Typical USA 115V Typical USA 230V 230V Type I Plug

Wet electrical connections are shock hazards. To prevent the cutting fluid from traveling along the cord and contacting the plug or power outlet, tie a drip loop as shown. Also elevate extension cords or gang box connections.



Extension Cords

Use only 3-wire extension cords that have a 3-prong grounding type plug and 3-pole receptacles that accept the tool's plug. Replace or repair damaged cords. Make sure the conductor size is large enough to prevent excessive voltage drop which will cause loss of power and possible motor damage.

LENGTH OF CORD, FEET	RECOMMENDED WIRE GAUGE	RECOMMENDED WIRE GAUGE
	115V MOTOR 10 - 12 AMPS	230V MOTOR 5 - 6 AMPS
Up to 25	16	18
26 - 50	14	18
51 - 100	10	16
101 - 200	8	14
201 - 300	6	12
301 - 500	4	10

Outdoor Extension Cord Use

When tool is used outdoors, use only extension cords intended for use outdoors and so marked.

Additional Safety Precautions

Arbor and cutter should never be used as a handhold or handle. Keep hands and clothing away from all moving parts. Do not use Hough Cutters where ejected slug might cause injury (slug ejected at end of cut). Also, adhere to all operating instructions. Do not drill through any surface that may contain live electrical wiring. Drilling into a live wire could cause exposed metal parts of the drill to be made live. Remove chips wrapped around cutter and arbor after each hole. With motor off and power disconnected, grasp chips with leather gloved hand or pliers and pull while rotating counterclockwise. Should the cutter become jammed in the work, stop the unit immediately to prevent personal injury. Disconnect the drill from the power supply and loosen jammed cutter by turning the arbor counterclockwise. Never attempt to free the jammed cutter by starting the motor. Service at authorized repair center only.

Operating Near Welding Equipment

DO NOT operate this unit on the same work surface that welding is being performed on. Severe damage to the unit, particularly the power cord, could occur. This could also result in personal injury to the operator.

Circuit Breaker (If Applicable)

Changing of the circuit breaker to a higher amp rated breaker, or bypassing the circuit breaker is not recommended and will void product warranty.

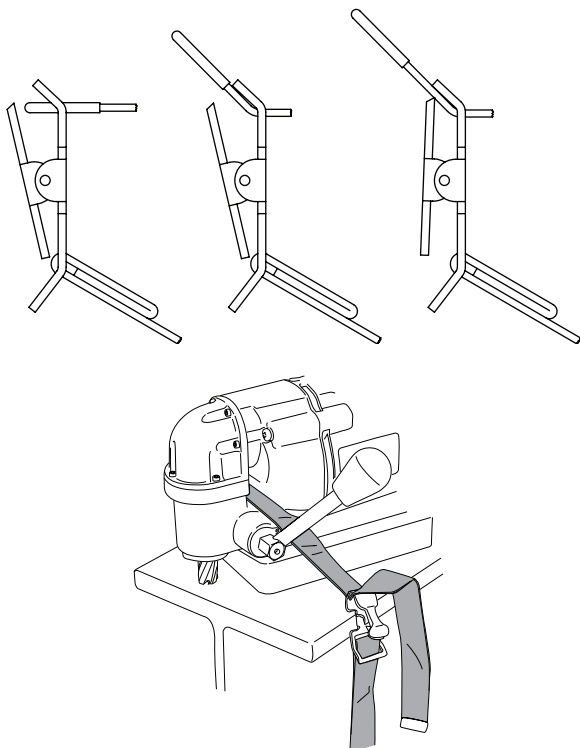
Circuit Breaker Operation (If Applicable)

The circuit breaker is a thermal breaker. When it reaches the higher temperature rating it will trip and cause the unit to shut down. This is a protective device and can be reset after 5 to 10 minutes. To reset the breaker, press the breaker button back in. If it does not reset, let the unit cool a little longer until you can push the button in and it stays in position.

Save all warnings and instructions for future reference.

OPERATING INSTRUCTIONS

1. Place drill on material (at least 3/8" thick) and locate for drilling hole.
2. Press magnet switch to "ON"
3. Thread safety strap through opening between motor and drill housing. Ensure that strap does not interfere with operation of feed handles. Insert tab of strap into buckle. Cinch strap tight to material and drill housing. Check for slack and adjust as needed.



CAUTION:

- Keep strap clear of cutting area, chips, and rough edges on material.
 - Inspect strap periodically for fraying and damage. Do not use a damaged safety strap.
4. Apply liberal amount of cutting fluid or stick lubricant to cutter. Additional lubrication may be required to finish cut.
 5. Make certain that cutter is clear of workpiece and turn motor ON by pressing the motor START button.

6. Feed Cutter slowly into workpiece. Only after cutting path is established to a depth of about 1/16" can additional force be applied to feed handles. Ease up on feed pressure as cutter starts breaking through

CAUTION: Do not over-feed cutter. Excessive feed pressure may cause the magnet to break free from material.

DRILLING MULTIPLE LAYER MATERIALS:

****Special Cutter Geometry Required!**
Second layer penetration may be difficult. Slight additional feed pressure may be required (avoid over-feed as noted above).

If unable to penetrate second layer, withdraw cutter from material ejecting slug and clean away any remaining chips. Feed cutter in hole and continue cut.

- Turn motor off when cut is finished.
- Fully retract cutter from material, ejecting the slug.
- Remove safety strap.

7. Turn magnet switch to "OFF" position.

CAUTION: Retain firm hold on drill to prevent dropping.

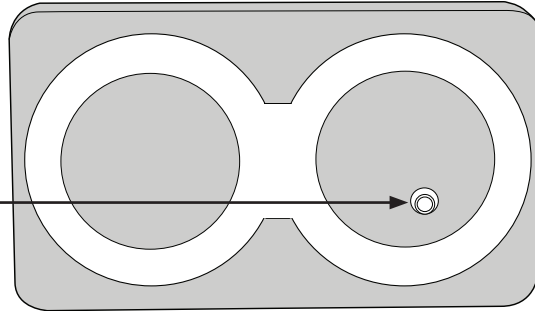
Cutter Inside Diameter may collect chips, restricting depth of cut. Cutter should be frequently inspected and any chips or debris removed.

OPTIONAL FEED METHODS:

- 5/8" Box Wrench
- Ratchet with 5/8" Socket
- NO PLIERS OR OPEN END WRENCH (They will damage threaded feed handle mounting holes)

SAFETY SWITCH

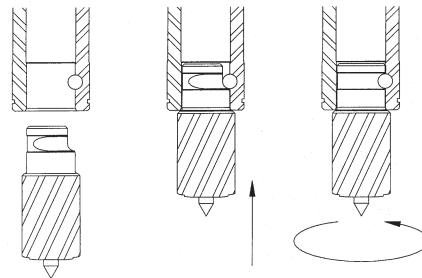
NOTE: The Safety Switch located in the base of the unit shuts off the motor when the unit lifts. The magnet will stay engaged until you turn off the magnet. It is important to keep this area clean and free from chips. Periodically check this switch for proper function and if for some reason it is not working properly, send the unit to an authorized repair center for service.



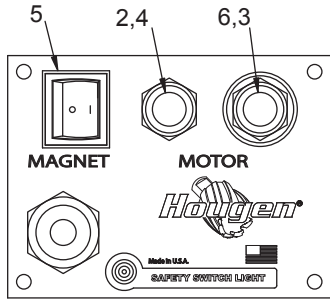
KIMBALL MIDWEST RECOMMENDS THAT CONDITIONS ARE CORRECTED SO THE LIGHT TURNS GREEN. THIS ALLOWS FOR THE UNIT TO BE OPERATED IN A SAFE MANNER.

ROTO-KUT AUTO-LOK FRAME & FABRICATION DRILL CUTTER INSTALLATION

1. Disconnect machine from power source.
2. Insert pilot into cutter.
3. Align flat on shank with pin in spindle.
4. Insert cutter into spindle.
5. Give cutter 1/4 turn in opposite direction of flutes.

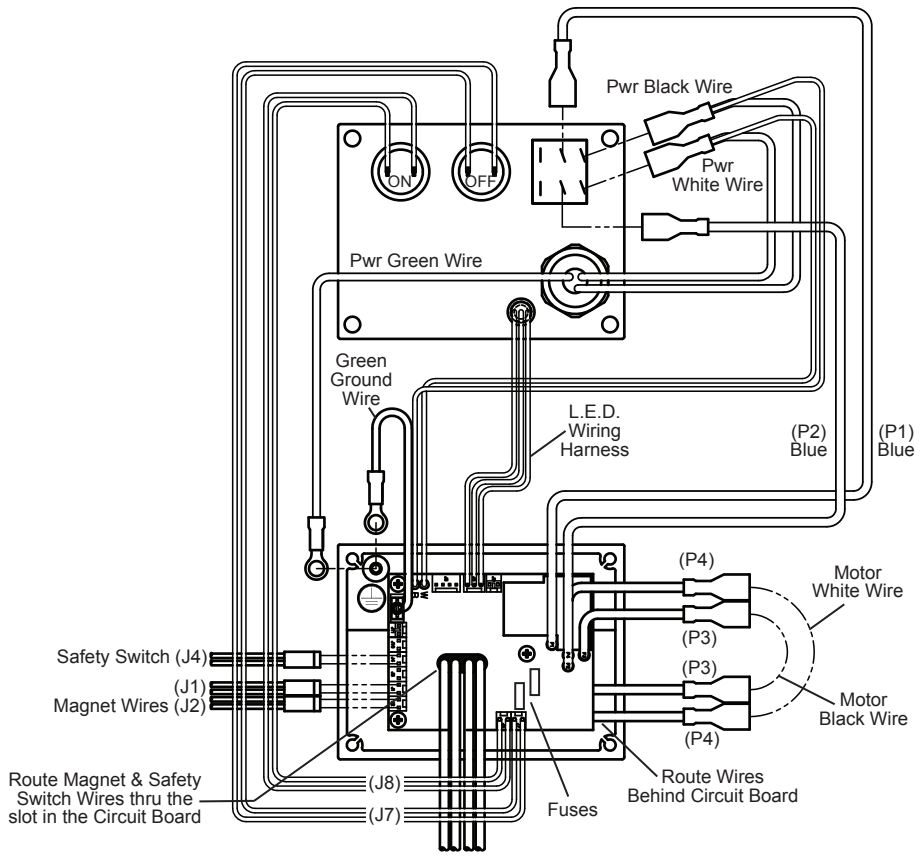
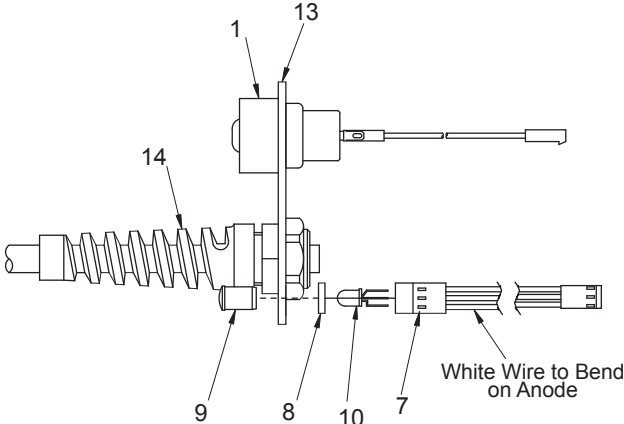


CONTROL PANEL / HOOKUP DIAGRAM

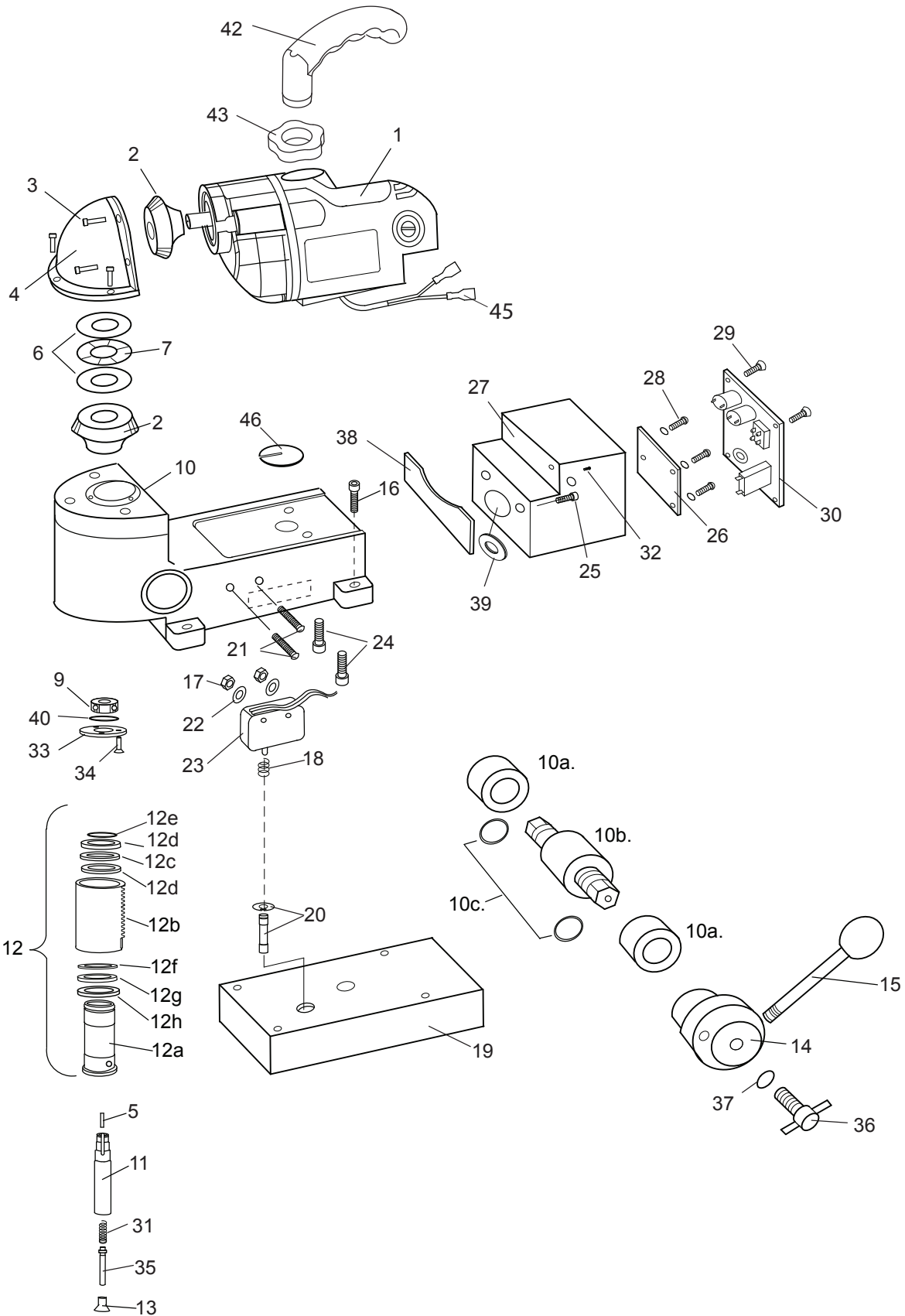


05911KM Faceplate Assembly - (includes 1-14)

Item	Part #	Description	Qty
1	01226	Switch Guard	1
2	01228	Red Switch Cover	1
3	01334	Motor ON Switch	1
4	01335	Motor OFF Switch	1
5	01833	Rocker Switch	1
6	02409	Green Switch Cover	1
7	04877	Wire Harness	1
8	04878	Spacer	1
9	04879	Clear Lens	1
10	04881	Bulb	1
11	05208	Green Ground Wire Assy.	1
13	17696	Faceplate	1
14	17490	Power Cord Assembly	1
15	07522	Fuse	2



ROTO-KUT FRAME & FABRICATION DRILL

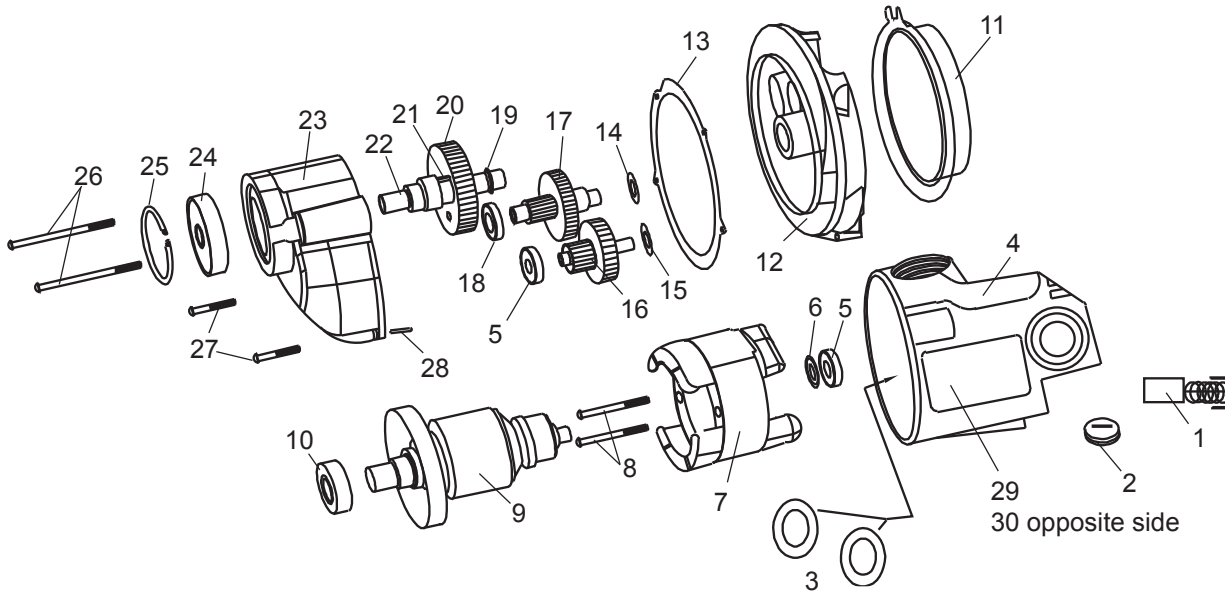


PARTS LIST

Item #	Part #	Description	Qty
1	17276KM	Motor Assy	1
2	17535	Miter Gear Set	2
3	17002	SHC #6-32 X 1/2	7
4	17510KM	Gear Cap Assembly	1
5	17277	Key 1/8 sq. X .53 lg.	1
6	17517	Thrust Washers .312 ID X .750 OD	2
7	17516	Thrust Bearing .312 ID X .750 OD	1
9	17270	Ball Bearing 32 X12 X 10mm	1
10	17279KM	Housing Assy	1
10a	17495	Bronze Bearing	2
10b	17298	Feed Gear	1
10c	40546	O-Ring	2
11	17280	Spline Shaft	1
12	17646	Quill / Arbor Assembly	1
12a	17649	Arbor Assembly	1
12b	17647	Quill Assembly	1
12c	17546	Bronze Thrust Washer	1
12d	17547	Steel Thrust Washer	2
12e	04720	Retaining Ring	1
12f	17644	Thrust Washer	1
12g	17645	Thrust Needle Bearing	1
12h	17643	Thrust Washer Seal	1
13	17493	SCR-FHC Modified 1/4-28 X 1/2 lg	1
14	17282	Hub Assembly	1
15	17283	Feed Handle Assembly	1
16	10553	SHC Screw 1/4-20 X 7/8	4
17	40374	Hex Nut #6-32	2
18	17271	Tapered Spring	1

Item#	Part #	Description	Qty
19	17651	Magnet Assembly	1
20	17285	Plunger Assembly	1
21	17476	BHC Torx Screw #6-32 X 1-1/4	2
22	90052	Lock Washer #6 ext. tooth	2
23	04885	Safety Switch Assembly	1
24	75096	SHC Screw M6 X 20	2
25	75094	SHC Screw M5 X 12	2
26	08646	Circuit Board	1
27	17691KM	Electrical Box	1
28	02547	SCR- #4-40 X 5/16 lg	3
29	24081	SCR #10 X 3/8 self tap.	4
30	05911KM	Faceplate Assy.	1
31	17492	Comp. Spring	1
32	04439	BHC Screw #10-32 X 3/16	1
33	17289	Bearing Retaining Washer	1
34	04718	Screw #4-40 X 3/8	3
35	17494	Plunger	1
36	17291	Thumb Screw	1
37	90027	1/4 Flat Washer	1
38	17293	Motor Seal	1
39	17274	Grommet	1
40	17475	Retaining Ring 12mm Shaft	1
41	05208	Green Ground Wire	1
42	05921	Handle	1
43	05920	Locking Nut	1
44	05372	Lubriplate Grease	.01 oz
45	90218	Wire Terminal	2
46	07294	1" Diam. Lexan Protector	1

17276KM MOTOR DIAGRAM & PARTS LIST



Item	Part #	Description	Qty
1	17621	Carbon Brush	2
2	17622	Brush Cap	2
3	17632	Paper Washer	2
4	17600	Field Case	1
5	17602	Ball Bearing	2
6	17606	Dust Seal	1
7	17628	Field (120V)	1
8	17623	Pan Head Screw	2
9	17630	Armature (120V)	1
10	17604	Ball Bearing	1
11	17617	Fan Guide	1
12	17601	Gear Housing	1
13	17618	Gasket	1
14	17613	Flat Washer	1
15	17610	Flat Washer	1

Item	Part #	Description	Qty
16	17607	1st Inter. Gear Assy	1
17	17608	2nd Inter. Gear Assy	1
18	17603	Ball Bearing	1
19	17626	Retaining Ring	1
20	17609	Spur Gear	1
21	17611	Key	1
22	17616	Spindle	1
23	17615	Gear Housing (includes 24 & 25)	1
24	17605	Ball Bearing	1
25	17627	Retaining Ring	1
26	17625	Pan Head Screw Long	2
27	17624	Pan Head Screw Short	2
28	17612	Dowel Pin	1
29	05704	Label - Motor Safety (120V)	1
30	05956	Label - Motor Specs (120V)	1

ROTO-KUT AUTO-LOK CUTTERS

The ROTO-KUT Auto-Lok cutters are made specifically for the 82-4627 ROTO-KUT Frame & Fabrication Drill. They are equipped with 5/8" tool-less Bayonet-style twist and lock shank, available 1" depth of cut standard cutter. They are made of premium high speed steel and available in diameters from 1/2" to 1-3/8".

ROTO-KUT Auto-Lok Frame & Fabrication Drill Cutters 1" D.O.C.

PART#	DESCRIPTION
82-5632	1/2"
82-5636	9/16"
82-5640	5/8"
82-5644	11/16"
82-5648	3/4"
82-5652	13/16"
82-5656	7/8"
82-5660	15/16"
82-5664	1"
82-5668	1-1/16"
82-5672	1-1/8"
82-5676	1-3/16"
82-5680	1-1/4"
82-5684	1-5/16"
82-5688	1-3/8"
82-5628	PILOT

Standard Geometry Cutters

ROTO-KUT Auto-Lok Frame & Fabrication Drill Cutter Kits 1" D.O.C.

PART#	DESCRIPTION
82-4629	Kit contains (3) Cutters, 1" D.O.C. - 1/2", 5/8", 3/4" dia. plus (2) pilots in a sturdy plastic case

COMMERCIAL / INDUSTRIAL LIMITED WARRANTY

Kimball Midwest warrants its Roto-Kut Frame Drill, for one (1) year from date of purchase against defects due to faulty material or workmanship and will repair or replace (at its option) without charge any items returned. This warranty is void if the item has been damaged by accident or unreasonable use, neglect, improper service, or other causes not arising out of defects in material or workmanship. No other expressed warranty is given or authorized. Kimball Midwest. disclaims any implied warranty of MERCHANTABILITY or FITNESS for any period beyond the expressed warranty and shall not be liable for incidental or consequential damages. Some states do not allow exclusions of incidental or consequential damages or limitation on how long an implied warranty lasts and, if the law of such a state governs your purchase, the above exclusion and limitation may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service, return the item(s), transportation prepaid, to Kimball Midwest, 4800 Roberts Road, Columbus, OH 43228

Roto-Kut Frame Cutters are warranted against manufacturing defects only. Subject to Kimball Midwest inspection.

THIS WARRANTY IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

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D445808 6280123

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