

Slugger 2x2

Slugger Portable Magnetic Drilling Machine

OPERATOR'S MANUAL

WARNING!

BEFORE USE, BE SURE EVERYONE USING THIS MACHINE READS AND UNDERSTANDS ALL SAFETY AND OPERATING INSTRUCTIONS IN THIS MANUAL.



EYE PROTECTION
REQUIRED



HEARING PROTECTION
REQUIRED



NEVER PLACE
FINGERS NEAR
CUTTING AREA OR
MACHINE ARBOR



LINE VOLTAGE
PRESENT



BEWARE OF
ROTATING
MACHINE PARTS

CONTENT CHECKLIST

Please contact factory if your package is missing any of these supplemental items:

DESCRIPTION	PART #	QTY
OPERATOR'S MANUAL	UT102B	1
SHUNT INSTRUCTIONS	06958	1
WARRANTY CARD	0070342	1
2.5 MM HEX KEY	0151255	1
4MM HEX KEY	70587	1
6MM HEX KEY	058112	1
8MM COMBINATION WRENCH	0151219	1
KNOB AND SPOKE HANDLE	07018	3
SAFETY STRAP	06798	1
KNOCK-OUT WEDGE	07517	1
SAFETY AND MAINTENANCE CD	06814	1
#2MT ARBOR ASSEMBLY	07504	1
COOLANT BOTTLE ASSEMBLY	0151511	1



Slugger



MODEL #17980 (120V) OR #17982 (240V)

Serial # _____

Date of Purchase _____

Slugger Portable Magnetic Drilling Machine

Congratulations on your purchase of a Slugger portable magnetic drilling machine. Slugger drilling machines are designed to deliver fast, efficient hole drilling performance in portable applications. Please take a moment to complete and mail your product warranty registration card. Doing so will validate your machine's warranty period and ensure prompt service if needed. Thank you for selecting a Slugger product from Jancy Engineering Company.

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LIMITED WARRANTY

Jancy Engineering Company will, within one (1) year from the original date of purchase, repair or replace any goods found to be defective in materials or workmanship, provided the product warranty registration card has been returned to Jancy Engineering Company within thirty (30) days of purchase date. This warranty is void if the item has been damaged by accident, neglect, improper service or other causes not arising out of defects in materials or workmanship. This warranty does not apply to machines and/or components which have been altered, changed, or modified in any way, or subjected to use beyond recommended capacities and specifications. Electrical components are subject to respective manufacturers' warranties. All goods returned defective shall be returned prepaid freight to Jancy, which shall be the buyer's sole and exclusive remedy for defective goods. In no event shall Jancy Engineering be liable for loss or damage resulting directly or indirectly from the use of merchandise or from any other cause. Jancy Engineering is not liable for any costs incurred on such goods or consequential damages. No officer, employee or agent of Jancy is authorized to make oral representations of fitness or to waive any of the foregoing terms of sale and none shall be binding on Jancy.

**JANCY ENGINEERING RESERVES THE RIGHT TO MAKE
IMPROVEMENTS AND MODIFICATIONS TO DESIGN WITHOUT PRIOR NOTICE.**

IMPORTANT SAFETY INSTRUCTIONS



WHEN USING ELECTRIC TOOLS, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED TO REDUCE RISK OF FIRE, ELECTRIC SHOCK AND PERSONAL INJURY.

READ AND SAVE ALL INSTRUCTIONS FOR FUTURE REFERENCE.

1. **Keep Work Area Clean**
 - Cluttered areas and benches invite injuries.
2. **Consider Work Area Environment**
 - Do not expose power tools to rain.
 - Do not use power tools in damp or wet locations.
 - Keep work area well lit.
 - Do not use tool in presence of flammable liquids or gases.
3. **Guard Against Electric Shock**
 - Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges and refrigerator enclosures.
4. **Keep Children Away**
 - Do not let visitors contact tool or extension cord.
 - All visitors should be kept away from work area.
5. **Store Idle Tools**
 - When not in use, tools should be stored in a dry, high and locked-up place, out of reach of children.
6. **Do Not Force Tool**
 - It will do the job better and safer at the rate for which it was intended.
7. **Use Right Tool**
 - Do not force a small tool or attachment to do the job of a heavy-duty tool.
 - Do not use tool for unintended purpose. For example: Do not use a circular saw for cutting tree limbs or logs.
8. **Dress Properly**
 - Do not wear loose clothing or jewelry. They can be caught in moving parts.
 - Non-skid footwear is recommended when working outdoors.
 - Wear protective hair covering to contain long hair.
9. **Use Safety Glasses**
 - Also use face or dust mask if cutting operation is dusty.
10. **Do Not Abuse Electrical Cord**
 - Never carry tool by cord or yank it to disconnect from receptacle.
 - Keep cord from heat, oil and sharp edges.
11. **Secure Work**
 - Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
12. **Do Not Overreach**
 - Keep proper footing and balance at all times.

IMPORTANT SAFETY INSTRUCTIONS

13. **Maintain Tools With Care**
 - Keep tools sharp and clean for better and safer performance.
 - Follow instructions for lubricating and changing accessories.
 - Inspect tool cords periodically and if damaged, have repaired by authorized service facility.
 - Inspect extension cords periodically and replace if damaged.
 - Keep handles dry, clean, and free from oil and grease.
14. **Disconnect Tools**
 - Unplug when not in use, before servicing, and when changing accessories, such as bits and cutters.
15. **Remove Adjusting Keys And Wrenches**
 - Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
16. **Avoid Unintentional Starting**
 - Do not carry a plugged-in tool. Always disconnect from power source before moving.
 - Be sure switches are off before connecting to a power source.
17. **Outdoor Use Extension Cords**
 - When tool is used outdoors, use only extension cords intended for use outdoors and so marked.
18. **Stay Alert**
 - Watch what you are doing. Use common sense. Do not operate tool when you are tired.
 - Do not use when taking medications that may cause drowsiness.
19. **Check Damaged Parts**
 - Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.
 - Check alignment of moving parts, binding of parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center.
 - Do not use this tool if switches do not turn it on and off. Have defective switches replaced by authorized service center.

GUIDELINE FOR 2X2 SHIFT LEVER POSITION

Cutter Diameter Based on A-36 Steel	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2
HI (420 rpm)													
Low (210 rpm)													


SPECIAL INSTRUCTIONS


1. If you require an additional manual, please contact Jancy Engineering at (563) 391-1300 for a **FREE** copy.
2. Never place hands, fingers, gloves or clothing near cutting area or rotating machine parts.
3. Always disconnect machine from power source before changing cutters, clearing chips, refilling lubricant or performing adjustments.
4. Keep all safety features functioning and working properly.
5. Never wear loose clothing, gloves or jewelry when working near cutting area or rotating machine parts.
6. Always use eye and hearing protection.
7. Always use safety strap and chip guard provided with machine.
8. Always use proper tooling. Keep cutters securely fastened.
9. Do not use dull or broken cutters.
10. Do not use Slugger drilling machines on surfaces or materials being welded. Doing so can damage the machine's electrical components.
11. Beware of slugs ejected at end of cut. They become HOT during the cut.
12. Magnet will not hold properly on thin materials or rough and dirty surfaces.
13. Keep bottom of magnet burr free and clear of chips and debris.
14. To reduce the risk of electrical shock, do not use machine in wet or damp areas.
15. Do not remove or alter electrical panels. Use only authorized service centers for repairs.
16. Motor will not start on non-ferrous materials.


WARNING!

DO NOT OPERATE MACHINE IF WARNING AND/OR INSTRUCTION LABELS ARE MISSING OR DAMAGED.
CONTACT JANCY ENGINEERING FOR REPLACEMENT LABELS.


	⚠ WARNING!
	<p>ALWAYS USE EYE PROTECTION. ANY TOOL CAN SHATTER.</p> <p>LIVE VOLTAGE PRESENT. TO REDUCE RISK OF ELECTRICAL SHOCK, THE USER MUST READ AND UNDERSTAND OPERATOR'S MANUAL.</p>
 	⚠ CAUTION!
	<p>ALWAYS WEAR HEARING PROTECTION.</p> <p>BWARE OF EJECTED SLUG AT END OF CUT.</p>
SAFETY INSTRUCTIONS	
<ul style="list-style-type: none"> •Read and follow operator's manual thoroughly. If you can not locate your operator's manual, call Jancy Engineering Company at 563.391.1300 for a free copy. •Always stop machine completely and disconnect from power source before changing cutters, performing adjustments or servicing. •Do not use altered, dull or broken cutters. •Never wear loose clothing or gloves when working near cutting area or machine arbor. •Always use provided safety strap and chip guard. •Use proper tooling. Keep cutters securely fastened. •Magnet will not hold properly on thin materials and rough or dirty surfaces. Keep magnet free of chips and debris. •Keep all safety features functioning and working properly. •Use only authorized service centers for repairs. 	







MOTOR



MAGNET

JANCY ENGINEERING CO.

2735 Hickory Grove Road
Davenport, Iowa 53604
Tel : 563.391.1300 or Fax : 563.391.2323

120V AC

⚠ DANGER!




NEVER PLACE HANDS, FINGERS, GLOVES OR CLOTHING NEAR CUTTING AREA OR ROTATING MACHINE PARTS.

GROUNDING INSTRUCTIONS

⚠ WARNING!

Improperly connecting the grounding wire can result in the risk of electrical shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with tool. Never remove the grounding prong from the plug. If the cord or plug is damaged, have it repaired before using. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician. The 2x2 must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look like those in Figure A.

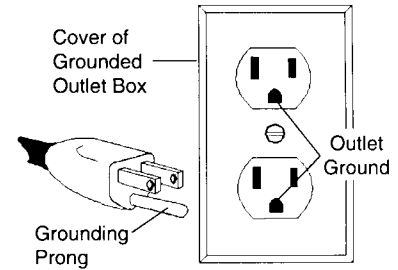


Fig. A

⚠ WARNING!

DO NOT USE SLUGGER DRILLING MACHINES ON SURFACES OR MATERIALS BEING WELDED. DOING SO CAN RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER DRILLING MACHINE.

EXTENSION CORDS

Use only 3-wire extension cords that have 3-prong grounding-type plugs and 3-pole receptacles that accept the tool's plug. Replace or repair damaged cords. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Jancy recommends using a minimum 12 gauge extension cord not to exceed 100 feet. The table below is supplied only as a guide to minimum gauge for extension cords, where the smaller the gauge number, the heavier the cord.

MINIMUM GAUGE FOR EXTENSION CORDS				
VOLTS	TOTAL LENGTH OF CORD IN FEET			
	120V	0-25	26-50	51-100
240V	0-50	51-100	101-200	201-300
AMPERAGE				
0-6	18	16	16	14
6-10	18	16	14	12
10-12	16	16	14	12
12-16	14	12	NOT RECOMMENDED	
RECOMMENDED WIRE GAUGE				

*JANCY RECOMMENDS USING A MINIMUM 12 GAUGE EXTENSION CORD NOT TO EXCEED 100 FEET.

DRIP LOOP: To help prevent cutting fluids from traveling along power cord and contacting power source, tie a drip loop in power cord as shown in Figure B.

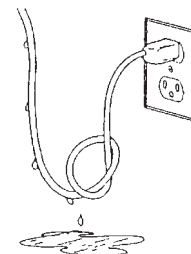


Fig. B

OPERATING INSTRUCTIONS (BEFORE YOU BEGIN)

Remove all contents from packaging and inspect to ensure no damage was incurred during shipping. Your 2x2 package should also include the following:

DESCRIPTION	PART #	QTY
OPERATOR'S MANUAL	LIT102B	1
SHUNT INSTRUCTIONS	06958	1
WARRANTY CARD	0070342	1
2.5 MM HEX KEY	0151255	1
4MM HEX KEY	70587	1
6MM HEX KEY	058112	1
8MM COMBINATION WRENCH	0151219	1
KNOB AND SPOKE HANDLE	07018	3
SAFETY STRAP	06798	1
KNOCK-OUT WEDGE	07517	1
SAFETY AND MAINTENANCE CD	06814	1
#2MT ARBOR ASSEMBLY	07504	1
COOLANT BOTTLE ASSEMBLY	0151511	1

GETTING STARTED



ALWAYS DISCONNECT 2X2 FROM POWER SOURCE BEFORE MAKING ADJUSTMENTS.

Assemble three spoke handles (item #405) to feed hub. **NOTE:** Feed hub assembly is mounted on right side of machine frame—if necessary, it can be reversed for lefthand operation by simply removing the fastener (item #402) and hub (item #401) from frame. Remove hub pinion shaft from right side of frame and insert it into left side of frame. Replace hub and fastener into frame and tighten securely.

Install the arbor into the drill motor by inserting the arbor body into the spindle. By turning the arbor while inserting, the arbor tang will properly line up in the spindle. The stop rod (item #911) should be between the inducer pin (item #904.3) and the hose connection (item #904.2) when properly installed. Turn the arbor until it bottoms out in the spindle and then tap lightly with a plastic hammer to secure.

To install coolant bottle, use bracket (item #611) to slide the coolant bottle onto the two retaining screws (item #614), located on the right side of drill. Install the free end of hose onto hose connection (item #904.2) on the arbor.

WHAT YOU SHOULD KNOW BEFORE YOU DRILL

1. Type of material to be drilled, Brinnell or Rockwell hardness, material thickness and position should all be determined to ensure proper selection of Slugger cutting tools, RPM, coolant and drilling time.
2. Remove any excessive mill scale or rust from surface to be drilled.
3. Material that has been flame cut may have become heat-treated and therefore difficult to drill. Avoid drilling near such areas whenever possible.
4. Drilling with the 2x2 in horizontal positions requires a special lubrication for Slugger cutters. Consult Jancy Engineering for details.

BEFORE THE CUT

1. Select correct pilot pin and place in cutter shank from the rear, align flats on cutter shank with arbor body set screws, insert cutter in arbor body.
2. Tighten set screws securely on cutter shank flats. **NOTE:** Set screws should be recessed in arbor body when tight.
3. The surface you are working on should be clean and flat, and free from rust, scale, dirt and chips.
4. Fill coolant reservoir with a water-soluble coolant.
5. Place Slugger machine on workpiece with pilot pin over the center of hole to be drilled.
6. Connect machine to power source.
7. Lower Slugger cutter to surface of material to be cut. Coolant will be released down the pilot into center of Slugger cutter. Coolant flow can be stopped by lifting pilot pin off work surface. **NOTE:** Be sure coolant valve is open. Regulate coolant flow by adjusting coolant valve.

CAUTION!

ALWAYS USE SAFETY STRAP. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER DRILLING MACHINE.

8. The safety strap must be securely fastened to machine and around work being drilled. Loop strap around work piece and connect strap ends by attaching to D-rings on drill. **NOTE:** Safety strap is intended only to restrain the drill to the work piece in the event of a power failure to the magnetic base.
9. Position chip guard toward work area before drilling.

READY TO MAKE THE CUT

CAUTION!

POSITION CHIP GUARD TOWARD WORK AREA BEFORE DRILLING.

1. Move magnet switch to "ON" position. Switch will illuminate to indicate power is present – magnetic base should be firmly secured to workpiece at this time. Thin materials may require an additional steel plate to achieve proper magnet adhesion.
2. Start drill motor by depressing green motor "ON" button.
3. Using the feed handles advance cutter into material until Slugger cutter has established an external groove in the material, During the remainder of cut apply smooth constant pressure without overloading motor. **NOTE:** Slugger cutters are designed for uninterrupted cutting. Chips are evacuated during the cut. Do not peck drill when using Slugger cutters.

CAUTION!

IF DRILL MOTOR SHOULD STALL OR STOP BEFORE A COMPLETE CUT IS MADE, ALWAYS REMOVE CUTTER FROM HOLE BEFORE ATTEMPTING TO RESTART MOTOR. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY AND/OR DAMAGE TO THE SLUGGER DRILLING MACHINE. **NOTE:** THIS MACHINE'S CIRCUITRY WILL AUTOMATICALLY SHUT THE DRILL MOTOR OFF IF MAGNETIC BASE IS SEPARATED FROM ITS WORK SURFACE. IF YOUR MACHINE REQUIRES ADJUSTMENT, CONTACT JANCY'S SERVICE DEPARTMENT.

AFTER THE CUT

1. After Slugger cutter has finished the cut, the "slug", or uncut center portion of material, will be expelled when motor is returned to the full up position.
2. Return machine into full upright position and depress red motor "OFF" button, wait until motor completely stops.
3. Move magnet switch to "OFF" position when ready to release magnetic base from work surface.

BASIC TROUBLESHOOTING

1. **Magnetic base not holding securely**
 - Material is too thin to engage magnet.
 - Surface of material being drilled must be free of chips, debris, rust and mill scale.
 - Does size of cutter exceed machine's rated capacity?
 - Check magnet face for unevenness, nicks and burrs.
 - Is welding equipment connected to material being drilled?
2. **Drill motor running, arbor and spindle not turning**
 - Possible sheared spindle key.
3. **Motor slows when drilling**
 - Is an extension cord being used? If so, see page 6 for recommended wire gages and cord lengths.
 - Excessive downfeed pressure during drilling cycle will cause motor to slow and overheat.
 - Does cutting tool need to be resharpened?
4. **Coolant system not working**
 - Coolant system is gravity dependent, machine must be in a upright position to operate properly.
 - Check operation of coolant valve. Valve must turn freely.
 - Check coolant lines for blockage.
 - Dirt or debris in coolant tank.
 - Consistency of coolant mixture too thick.
 - Is correct pilot pin being used?
 - Vent hole in coolant tank lid blocked.
5. **Slugs not ejecting from cutter**
 - Lack of coolant causing slugs to expand in cutter bore.
 - Is correct pilot pin being used?
 - Possible broken internal arbor parts.
6. **Breaking cutters**
 - How is coolant being applied? Coolant must be supplied to interior of cutter.
 - Excessive feed pressure being applied when cutter initially contacts work surface.
 - Confirm material hardness.
 - Drilling stacked materials with incorrect cutter.
 - Dull cutters; dull or chipped cutting edges require excessive feed pressure, resulting in breakage.
 - Excessive arbor runout – see regular maintenance on page 10.
 - Improperly adjusted motor slide – see page 10.
7. **Oversized or rough holes**
 - Insufficient coolant.
 - Excessive feed pressure.
 - Dull cutter.
 - Excessive arbor runout – see regular maintenance on page 10.
 - Motor slide improperly adjusted.

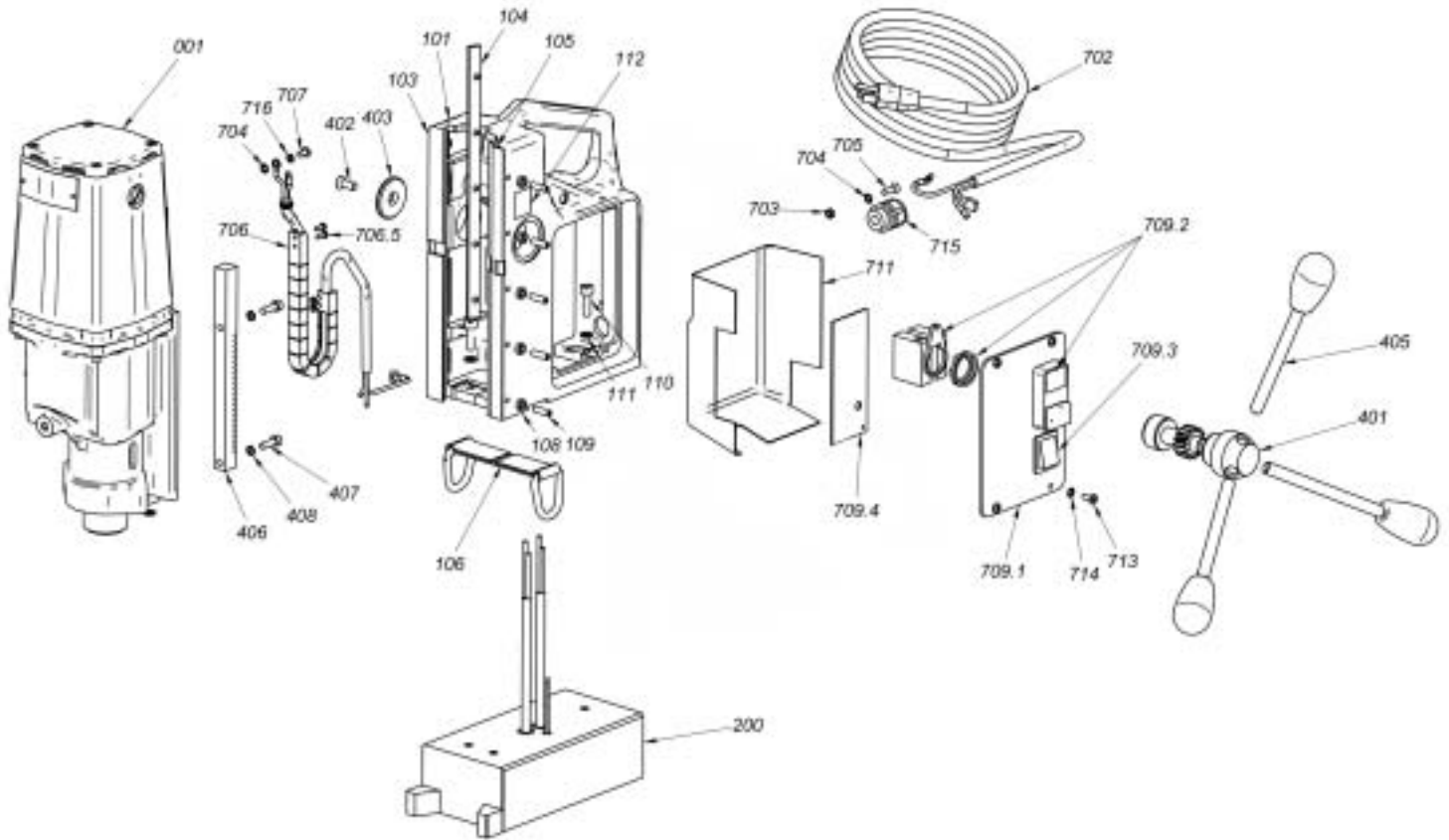
REGULAR MAINTENANCE

1. The motor slide may require adjustment after machine has been in service. Loosen jam nuts using provided wrench. Using feed handles, position motor/slide assembly in the full up position. Using supplied hex key, equally turn adjustment screws clockwise to increase slide tension or counterclockwise to decrease slide tension. Do not over tighten adjustment screws. Excessive slide tension can damage the machine. Properly adjusted, the motor/slide assembly should have no side to side movement and remain positioned without drifting down.
2. Keep bottom of magnet clean, free of chips, burrs, nicks, oil and other contaminants. Inspect magnet face to ensure surface is flat and square. A worn magnet surface dramatically reduces magnetic holding force.
3. Periodically lubricate motor slide ways with lithium base grease.
5. Arbor runout should not exceed .0035 inches per revolution. This is most accurately measured by placing a dial indicator needle inside of arbor bore and rotating arbor while observing indicator.
6. Inspect motor brushes and replace as needed during extended periods of heavy machine usage.
7. Replace any worn parts and regularly tighten fasteners that have become loose during usage.
8. Regularly test machine by placing machine on non-ferrous material. Engage magnet switch. Motor should not continue running when motor on button is released.

DIMENSIONS AND SPECIFICATIONS	
Height	21"
Width	8"
Length	12"
Weight	36-1/4 lbs.
Motor	1.6 HP 1200W (single phase) 120V / 10.2A ~ 240V / 5.1A 210 / 420 RPM (no load)
Spindle Bore	#2 morse taper
Arbor Bore	3/4"
Drill Point Breakaway	1111 lbs. on 1" plate
Magnet Base Dimensions	3-1/2" x 8"
Magnet Dead Lift	2657 lbs. on 1" plate
Slugger Cutter Diameter (Maximum)	2"
Slugger Depth of Cut (Maximum)	2"

NOTE: MAGNETIC BASE REQUIRES 1" MINIMUM MATERIAL THICKNESS WHEN DRILLING 1-3/8" AND LARGER DIAMETER HOLES

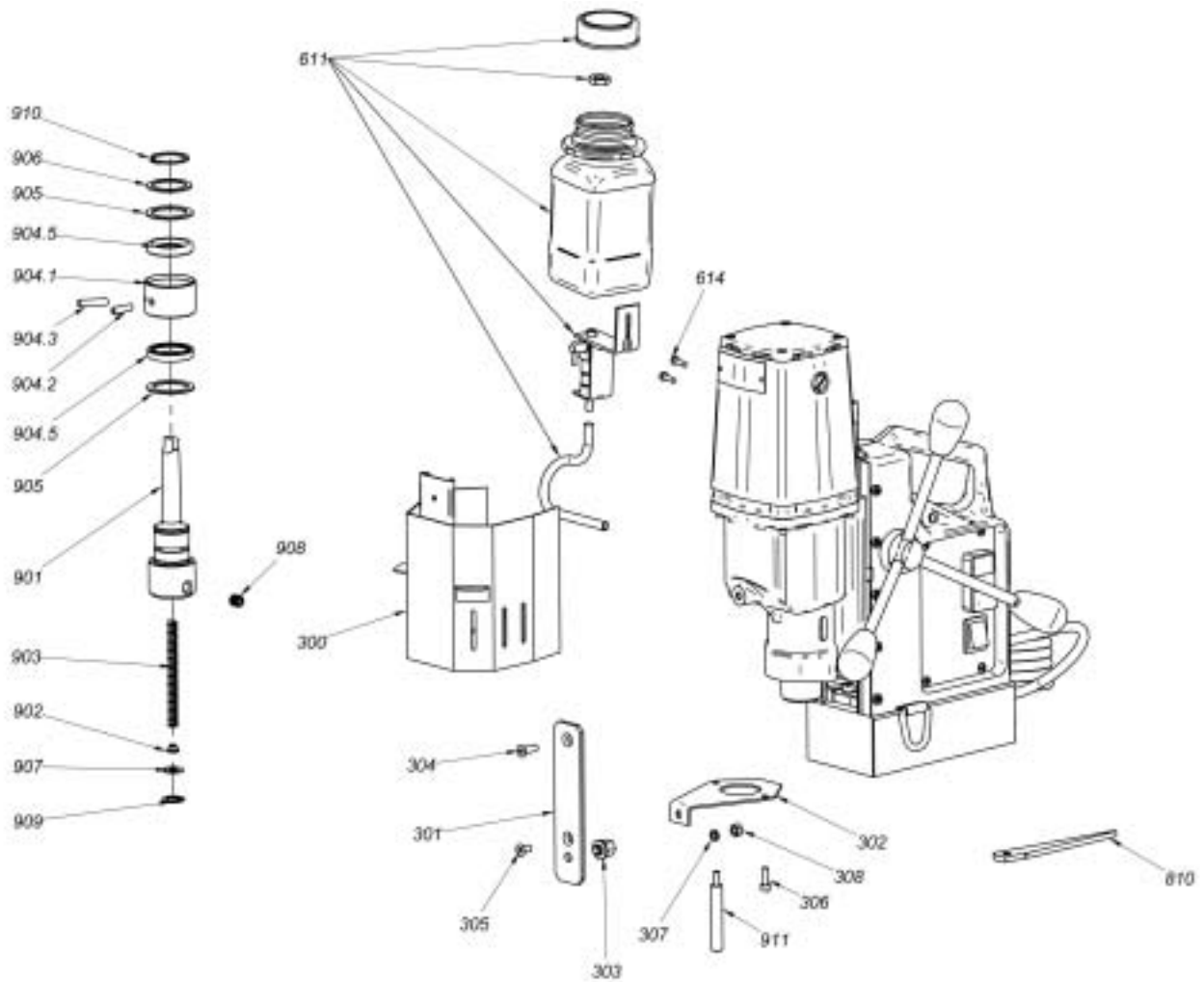
MACHINE PARTS LIST



ITEM	DESCRIPTION	PART #	QTY
001	MOTOR ASSEMBLY 120V	07001MT2	1
	MOTOR ASSEMBLY 240V	07003MT2	1
101	FRAME	07005	1
103	SLIDE INSERT (LEFT)	07501	1
104	PRESSURE PLATE	07004	1
105	SLIDE INSERT (RIGHT)	07502	1
106	D-RING STRAP	06796	1
108	NUT, M5	0151181	5
109	SSS, M5 X 25	07020	5
110	SHCS, M6 X 20	0014102	3
111	WASHER, SPLIT M6	07016	3
112	LABEL, GIB ADJUST	07503	1
200	MAGNET	07017	1
401	HUB SHAFT	07019	1
402	SFHMS, M6 X 20	06774	2
403	HUB WASHER	07006	1
405	SPOKE HANDLE	07018	3
406	GEAR RACK	07024MT2	1

ITEM	DESCRIPTION	PART #	QTY
407	SHCS, M5 X 20	06774	2
408	WASHER, SPLIT M5	07023	2
702	POWER CORD 120V	06564	1
	POWER CORD 240V	CALL	1
703	NUT, M4	0070133	2
704	WASHER, INTERNAL M4	04576	2
705	SFHMS, M4 X 16	07116	1
706	MOTOR CORD ASSEMBLY	07139MT2	1
706.5	PHMS, 2.9 X 10 THREAD CUTTING	045793	4
707	CRPHMS, M4 X 10	04820	1
709.1	PANEL PLATE WITH LABEL	07091	1
709.2	MOTOR SWITCH ASSEMBLY	BM510	1
709.3	MAGNET SWITCH	BM507	1
709.4	CIRCUIT BOARD 120V	07094	1
	CIRCUIT BOARD 240V	07095	1
713	PHMS, M4 X 16	07011	4
714	WASHER, SPLIT M4	04576	4
715	STRAIN RELIEF	0151064	1

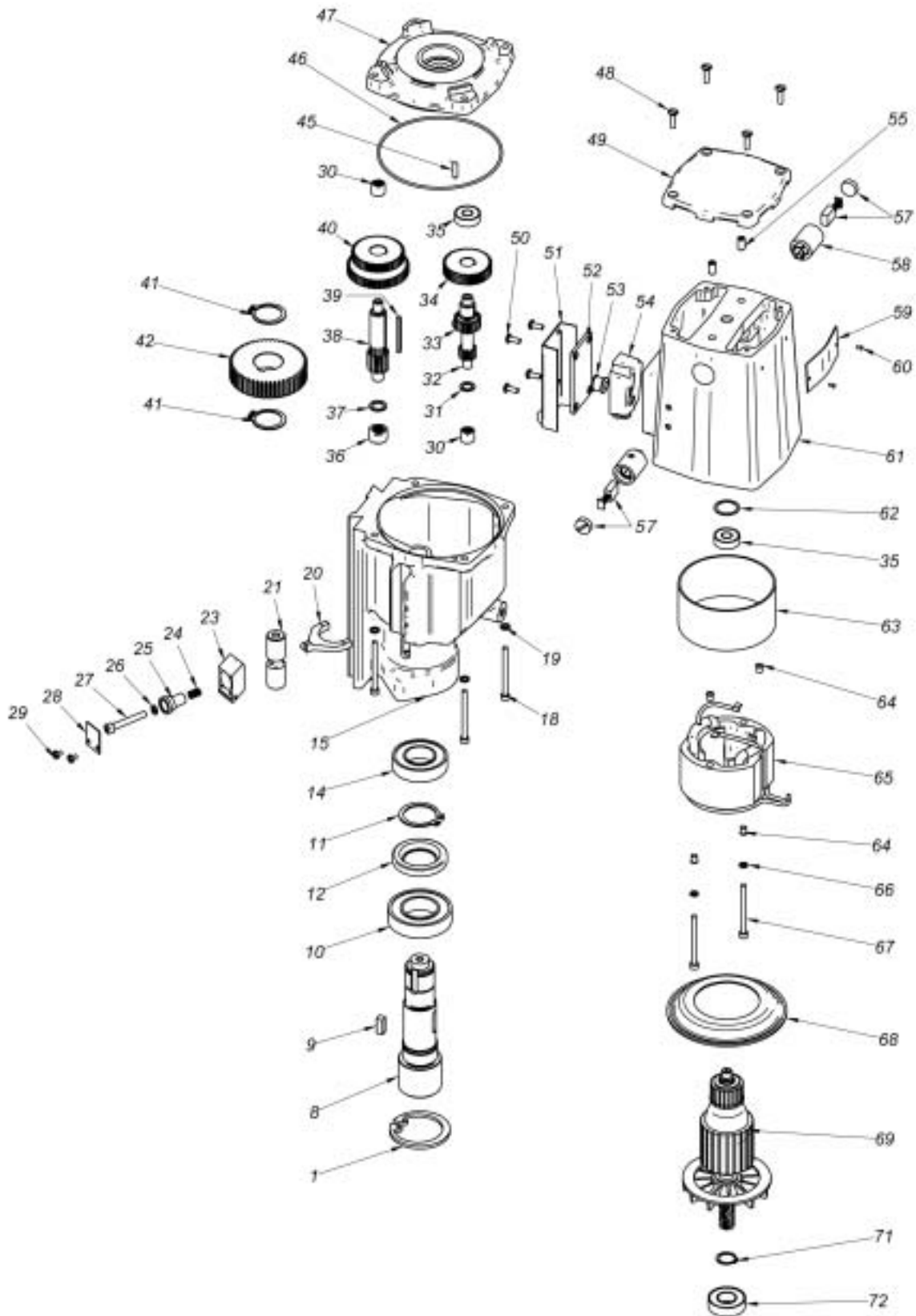
MACHINE PARTS LIST



ITEM	DESCRIPTION	PART #	QTY
300	CHIP GUARD	07026	1
301	GUIDE PLATE	070301	1
302	FLANGE PLATE	070302	1
303	BALL DETENT	070303	1
304	SFHMS, M6 X 20	05MT404	1
305	SFHMS, M6 X 12	054140	1
306	SHCS, M5 X 16	0151239	1
307	WASHER, SPLIT M6	070307	1
308	NUT, M6	070308	1
611	BOTTLE ASSEMBLY	0151511	1
614	PHMS, M4 X 12	06770	2
810	KNOCK-OUT WEDGE	07517	1
900	ARBOR ASSEMBLY	07504	1
901	ARBOR BODY	07505	1

ITEM	DESCRIPTION	PART #	QTY
902	PLUNGER	07506	1
903	SPRING	07507	1
904.1	COOLANT INDUCER	07508	1
904.2	HOSE CONNECTION	07509	1
904.3	INDUCER PIN	07510	1
904.5	SEAL	07511	2
905	WASHER	07512	2
906	SPACER	07513	1
907	WASHER	07514	1
908	SSS, M10 X 10	07336	2
909	RETAINING RING, INTERNAL 19W	0215067	1
910	RETAINING RING, EXTERNAL 15Z	07515	1
911	STOP ROD	07516	1

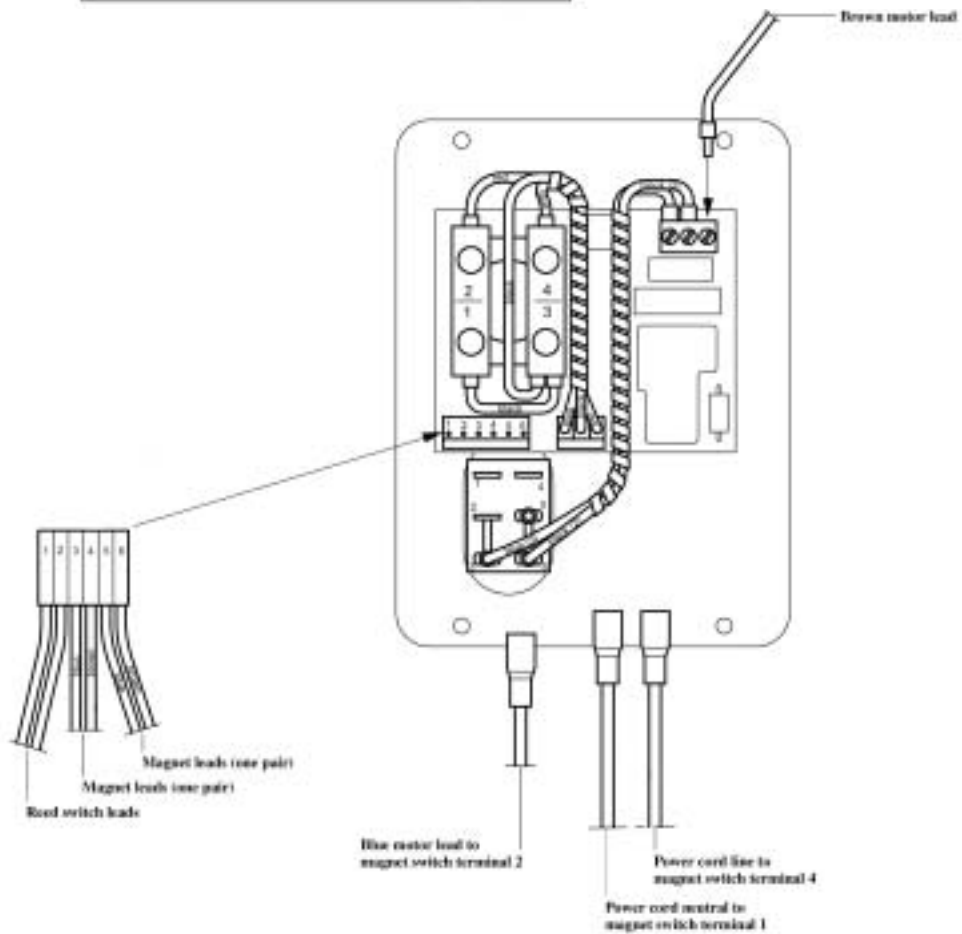
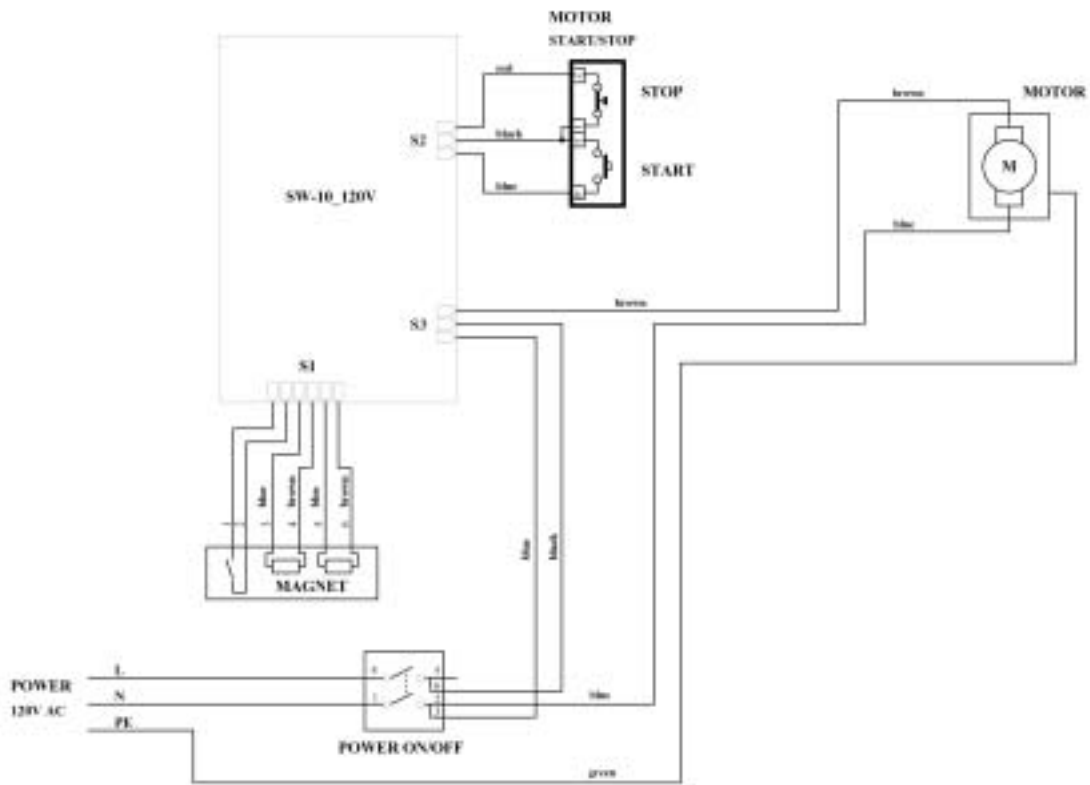
MOTOR PARTS



MOTOR PARTS LIST

ITEM	DESCRIPTION	PART #	QTY
1	RETAINING RING, INTERNAL 55W	07128	1
8	SPINDLE	07129MT2	1
9	KEY, SQUARE 6 X 6 X 15	07127	1
10	BEARING, 6006	07126	1
11	RETAINING RING, EXTERNAL 30Z	07125	1
12	SEAL, SPINDLE 28 X 47 X 7	07518	1
14	BEARING, 6005	07122	1
15	GEAR CASE	07159MT2	1
18	SHCS, M5 X 30	03097	4
19	WASHER, SPLIT M5	07023	4
20	SHIFT FORK	07146	1
21	SHIFT PIN	07145	1
23	SHIFT LEVER	045014	1
24	SPRING	04591	1
25	SHIFT COLLAR	04524	1
26	WASHER, INTERNAL M5	04563	1
27	SHCS, M5 X 35	04572	1
28	TAG, SHIFT	04514	1
29	CRPHMS, M3 X 5	045793	2
30	BEARING, NEEDLE RHINA 081210	07151	2
31	WASHER, THRUST 8, 1	07158	1
32	GEARSHAFT, 12T/20T	07157	1
33	KEY, WOODRUFF 3 X 3.7	07156	1
34	GEAR, HELICAL 46T	07155	1
35	BEARING, 608	04544	1
36	BEARING, NEEDLE RHINA 101610	07147	1
37	WASHER, THRUST 10, 1	07148	1
38	GEARSHAFT, 12T	07149	1
39	KEY, SQUARE 3 X 3 X 36	07161	1
40	GEAR, DUAL 52T/44T	07150	1
41	RETAINING RING, EXTERNAL 25Z	07152	2
42	GEAR, 52T	07162	1
45	PIN, DOWEL 4 X 16	07160	1
46	O-RING	07153	1
47	COVER, GEAR CASE	07154	1
48	SFHMS, M4X16	07116	4
49	COVER, FIELD CASE	07115	1
50	CRPHMS, M4 X 10	04820	4
51	COVER, CORD	07120	1
52	PLATE, CORD	07119	1
53	GROMMET	07117	1
54	LINER, COVER	07118	1
55	SSS, M6 X 12	0070526	2
57	BRUSH SET	04550	1
58	BRUSH HOLDER	04551	2
59	TAG, MOTOR 120V	07027	1
	TAG, MOTOR 240V	07028	1
60	DRIVE SCREW, #2 X 3/16	0070028	2
61	FIELD CASE	07113	1
62	WASHER, SPRING	04560	1
63	INSULATOR, FIELD	05010	1
64	INSULATOR, FIELD SCREVV	04557	4
65	FIELD 120V	06580	1
	FIELD 240V	06584	1
66	WASHER, INTERNAL M4	04576	2
67	SHCS, M4 X 50	07106	2
68	SHROUD	07105	1
69	ARMATURE 120V	04644	1
	ARMATURE 240V	04645	1
71	RETAINING RING, EXTERNAL 15Z	0070526	1
72	BEARING, 6002	07101	1

WIRING DIAGRAMS



OTHER AVAILABLE SLUGGER DRILLS

DESCRIPTION	MODEL #	MAX DIAMETER	CAPACITY DEPTH
USA5 120V	18066	2-3/8"	3"
USA5 240V	18080	2-3/8"	3"
USA5 EX 120V	18066EX	2-3/8"	2"
USA5 EX 240V	18080EX	2-3/8"	2"
USA5 EXB 120V	18066EXB	2-3/8"	2"
USA5 EXB 240V	18080EXB	2-3/8"	2"
JM101 120V	19020	1-3/8"	2"
JM101 240V	19024	1-3/8"	2"
JM101 120V WITH 3/8" SLIDE BAR FEED HANDLE	19021	1-3/8"	2"
2 X 2 120V	17980	2"	2"
2 X 2 240V	17982	2"	2"
4 X 4 120V	17985	4"	3"
4 X 4 240V	17987	4"	3"
MAGFORCE 120V	06920	1-3/8"	2"
MAGFORCE 240V	06921	1-3/8"	2"
AIRFORCE	20002	1-1/16"	3/4"

YOUR DISTRIBUTOR



JANCY ENGINEERING COMPANY

MANUFACTURER OF SLUGGER® CENTERFREE CUTTERS AND PORTABLE MAGNETIC DRILLING MACHINES

Tel · 563.391.1300 or Fax · 563.391.2323

2735 Hickory Grove Road · Davenport, Iowa 52804
email · jancy@jancy.com / web · jancy.com

SLUGGER SM 2 X 2-MT2PARTS LIST:

ITEM NO:	JANCY PART NO:	ITMS PART NO:	DESCRIPTION	QTY REQ
1	07128		INTERNAL RETAINING RING 55W	
8	07129-MT2		SPINDLE 2X2 MT2	
9	07127		SQUARE KEY 6X6X15	
10	07126		LOWER SPINDLE BEARING 6006	
11	07125		EXTERNAL RETAINING RING 30Z	
12	07124		SPINDLE SEAL 28 X 47 X 7	
14	07122		UPPER SPINDLE BEARING 6005	
15	07159-MT2		GEAR CASE 2 X 2 MT2	
18	04572		HEX SOCKET BOLT M5 X 30	
19	07023		SPRING WASHER M5	
20	07146		SHIFT FORK	
21	07145		SHIFT PIN	
22	04571		SPRING PIN 3 X 12	
23	04534		SHIFT LEVER	
24	04591		COMPRESSION SPRING	
25	04524		SHIFT DRIVE PIN	
26	04563		SPRING WASHER M5	
27	04572		HEX SOCKET BOLT M5X35	
28	04514		SHIFT LEVER LABEL	
29	45793		SCREW M3 X 5 PHCRMS	
30	07151		NEEDLE BEARING RHNA 081210	
31	07158		BEARING WASHER 8.1	
32	07157		GEAR SHAFT Z12;Z20,M-1MM	
33	07156		WOODRUFF KEY 3 X 3.7	
34	07155		HELICAL INPUT GEAR Z46,M=0.8MM	
35	04544	BE608Z	BEARING 608 2Z P6" S"	
36	07147		NEEDLE BEARING RHNA	
37	07148		BEARING WASHER 10.1	
38	07149		GEARSHAFT Z12,M=1.25MM	
39	07161		SQUARE KEY 3X3X36	
40	07150		CLUSTER GEAR Z52/Z44,M-1MM	
41	07152		EXTERNAL RETAINING RING 25Z	
42	07162		GEAR Z52,M=1.25MM	
45	07160		DOWELL PIN 4 X 16MM	
46	07153		SEAL "O" RING 102 X 2	
47	07154		GEARBOX COVER 2 X 2	
48	07116	SP5M48	SCREW M4 X 16 SFHMS	
49	07115	SP2249	FIELD CASE COVER 2 X 2	
50	06771	SP6771	CROSS RECESSED SCREW M4 X 10	
51	07120	SP2251	CONNECTION COVER	
52	07119	SP2252	INSULATION INSERT	
53	07117		SNAP BUSHING LA6	
54	07118		INSULATION CASE	
55	0070526	SP70526	HEX SET SCREW M6 X 12	
56	04552	SP4552	MOTOR BRUSH CAP	

57	04550	SP4550	MOTOR BRUSH SET	
58	04551	SP4551	MOTOR BRUSH HOLDER	
59	07027		MOTOR TAG 2 X 2 240V	
60	0070028		DRIVE SCREW 2 X 4MM	
61	07113	SP2261	FIELD CASE 2 X 2	
62	04560	SPMT4560	WASHER SPRING, UPPER ARMATURE	
63	05010	SP2263	FIELD INSULATOR SLEEVE 3.187" X 3.375"X2"	
64	04557		SCREW INSULATOR	
65	04647	SP4647	FIELD 2 X 2 240V	
66	35702	SPMT35702	SPRING WASHER 4.3	
67	07106		HEX SOCKET BOLT M4 X 50	
68	07105		ARMATURE FAN COVER	
69	04645	SP4645	ARMATURE 2 X 2 240V	
71	07102		EXT. RETAINING RING 15Z	
72	07101		BEARING 6002 LLU	
101	K22101	SP22101	BODY	
103	K22103		SLIDE INSERT (LEFT)	
104	K22104		PLATE SLIDE	
105	K22105		SLIDE INSERT (RIGHT)	
106	K22106		D-RING STRAP	
108	K0151181	SP151181	HEX NUT M5	
109	K22109		HEX INSERT SCREW M5 X 25	
110	K22110		HEX SOCKET BOLT M6 X 20	
111	K35106	SPMT106	SPRING WASHER 6.1	
112	K22112		LABEL CORRECT GIB ADJ	
200	K22200	SP22200	ELECTROMAGNETIC BASE	
300	K22300	SP22300	GUARD	
301	K22301	SP22301ASSY	GUARD' S SLIDE	
302	K22302	SP22302	BACK REST	
303	K22303		BALL LOCK	
304	K22304		SCREW M6 X 20	
305	K22305		SCREW M6 X 12	
306	K22306	SP22306	HEX SOCKET BOLT M5 X 16	
307	K35106	SPMT106	SPRING WASHER 6.1	
308	K22308		HEX NUT M6	
401	K22401	SP22401	PINION	
402	K35404		SCREW M6 X 20	
403	K35405	SPMT35405	FLAT WASHER	
404	K22404	SP22404	OVAL KNOB	
405	K22405	SP22405	HANDLE WITH KNOB	
406	K22406	SP22406	GEAR RACK	
407	K35303		HEX SOCKET BOLT M5 X 20	
408	K22408		SPRING WASHER 5.1	
601	K35603	SPMT35603	COOLANT VALVE	
610	K35609		HEX NUT SHORT - M12	
611	K35612	SPMT35612	COOLANT CONTAINER WITH CAP	
612	K35601		PLASTIC HOSE (FLEXIBLE)	
614	K35611		SCREW M4 X 12	
702	K0014200		POWER CORD 240V	
703	K35701	SPMT35701	HEX NUT M4	

704	K35702	SPMT35702	SPRING WASHER 4.3	
705	K22705		CROSS RECESSED SCREW M4 X 16	
706	K22706	SP22706	MOTOR WIRES SET	
706.5	K22706.5		SELF TAPPING SCREW 2.9 X 10	
706.6	K22706.6		SNAP BUSHINBG LA6	
707	K22707		CROSS RECESSED SCREW M4 X 8	
708	K22708		SNAP BUSHING LA10	
709.1	K22709.1		PANEL PLATE	
709.2	K35706	SPMT35706	MOTOR ON/OFF SWITCH	
709.3	K35708	SPMT35708	MAGNET SWITCH	
709.4	K22709.4-240		ELECTRONIC CONTROLLER MCM-04 240V	
710	K22710-230	SP22710	ELECTRONIC CONTROLLER TL01 240V	
710.13	K22710.13		GROUP OF WIRES WITH LED	
710.17	K22710.17		LED SOCKET	
711	K22711		CONTROLLER HOUSING	
712	K22712		HEX SOCKET BOLT M4 X 10	
713	K22713		CROSS RECESSED SCREW M4 X 10	
714	K35702	SP35702	SPRING WASHER 4.3	
715	K35704		STRAIN RELIEF PG11	
716	K22716		SPRING WASHER 4.1	
810	K22810		WEDGE MT2	
900	KIA2MT-HM	SA2MTHM	ARBOR SET - AMT3C-19/2	
901	K22901		ARBOR BODY	
902	K22902		PLUNGER	
903	K22903		SPRING	
904.1	K22904.1		COOLANT RING	
904.2	K04810	SPMT4810	HOSE TIP	
904.3	K22904.3		PIN L-32	
904.5	K22904.5		SEAL	
905	K22905		WASHER 1	
906	K22906		WASHER 11	
907	K22907		FLAT WASHER	
908	KMT802	SPMT802	HEX SET SCREW M10 X 10	
909	K35501		INTERNAL RETAINING RING 19W	
910	K22910		EXT. RETAINING RING 32W	
911	K22911		STOP PIN	