



B AUTOMATIC DRILL

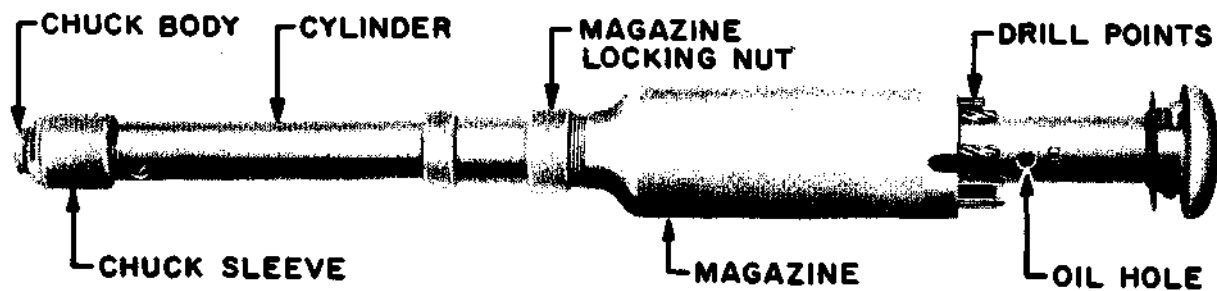


Fig. 1 — B Automatic Drill

1.00 INTRODUCTION

This section tells how to use and take care of B Automatic Drill, Specification AT-7137 (Fig. 1).

2.00 GENERAL

- 2.01 The B Automatic Drill is a push-type drill. It is used with drill points suitable for drilling small holes in light metal or wood. The handle serves as a magazine for ten drill points.
- 2.02 Drill points furnished with the B Automatic Drill are listed in Table A.
- 2.03 Drill points of other sizes may be ordered separately.

3.00 OPERATION

- 3.01 To remove a drill point from magazine:
 - 1. Loosen magazine locking nut, allowing magazines to slide down cylinder.
 - 2. Remove desired drill point.
 - 3. Slide magazine to its original position and tighten locking nut.
- 3.02 To insert drill point:
 - 1. Grasp cylinder of the drill in palm of hand with thumb against back of chuck sleeve.
 - 2. Slide chuck sleeve forward past end of chuck body.

TABLE A
DRILL POINTS

Quantity	Size	Intended Use	Remarks
2	1/16"	Wood	Straight-fluted carbon steel drills, suitable for drilling wood.
2	3/32"	Wood	
2	11/64"	Wood	
2	No. 33	Metal	Carbon or alloy steel twist drills suitable for light metal drilling.
2	No. 30	Metal	

3. Insert drill point in chuck and release chuck body.

- 3.03 Rotary action of the drill is created by the forward stroke, or push, of the handle.

4.00 PRECAUTIONARY MEASURES

NOTE *Observe the following precautions to prevent accidents, and damage to tools or materials.*

- Keep both hands behind the drill point during operation.
- Use suitable eye protection when drill is used above eye level.
- Remove drill point from the chuck when not in use.
- Do not use drill points that are bent.

- Mark the location to be drilled and remove apparatus before drilling holes.
- Start guide holes with a center punch when metal is being drilled.
- Use only enough pressure to operate the drill. (This is particularly important when using the small 1/16-inch drill point.)
- Hold drill at right angle to surface being drilled.

5.00 MAINTENANCE

- 5.01 Keep the automatic drill well lubricated with light-weight lubricating oil, applied through the cylinder oil hole.
- 5.02 The automatic drill should operate freely without bind or excessive play in parts.