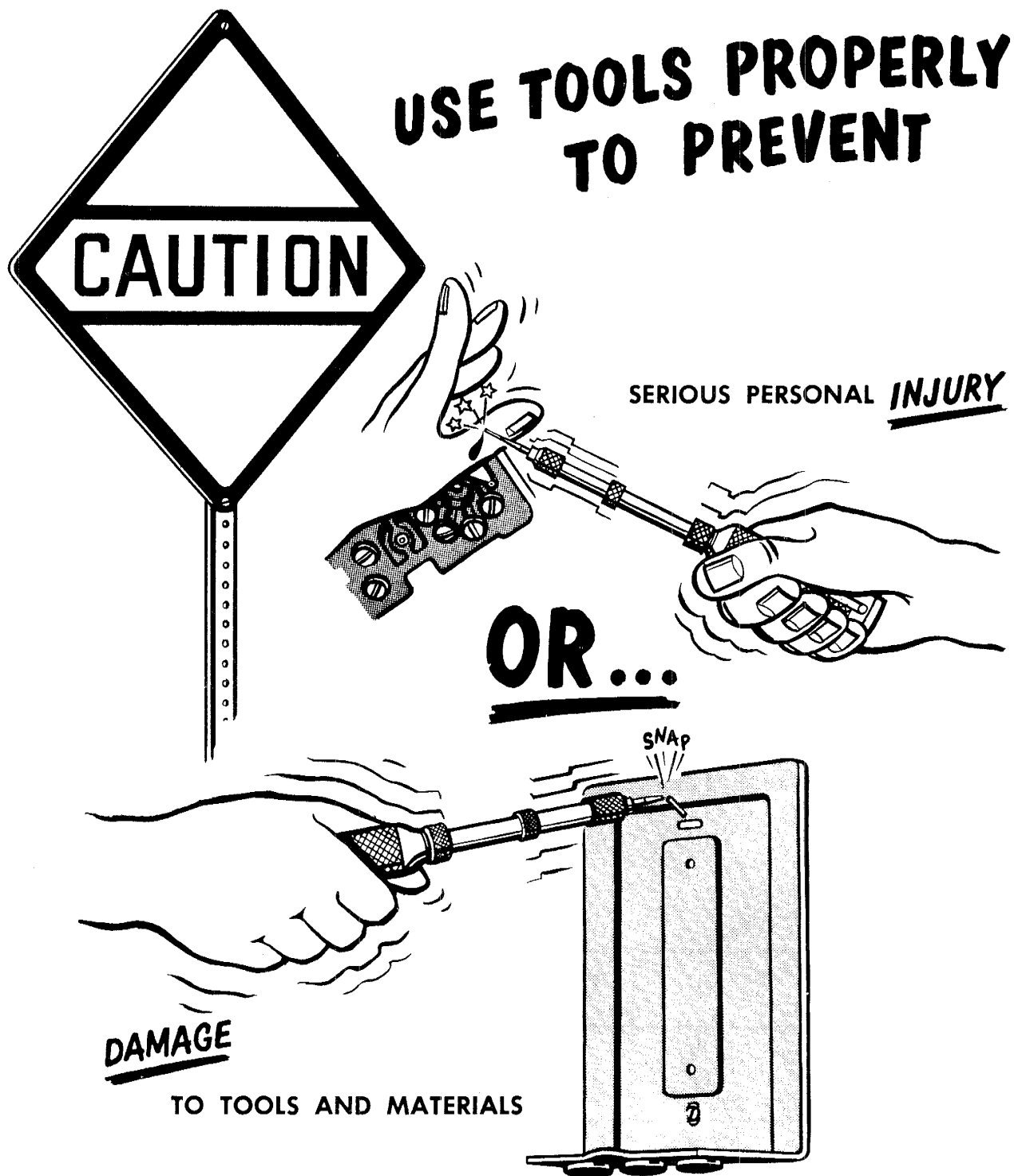
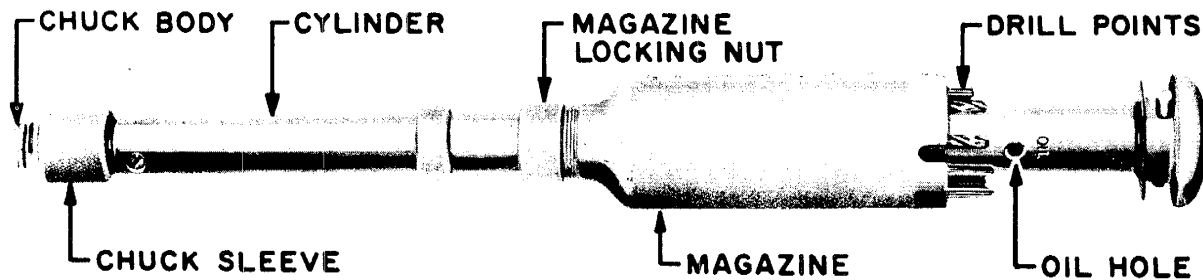




B AUTOMATIC DRILL**Fig. 1 — B Automatic Drill****1.00 INTRODUCTION**

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



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.