

# REVO

## REVO R322 - US DRILL OWNERS MANUAL



### WARNING !

When using electric power tools basic safety precautions should always be used to reduce the risk of fire, electric shock and personal injury.

Read all of these instructions before attempting to operate this product and save these instructions



Machine shown  
R322-US without the  
safety guard for clarity.



G & J Hall Inc, 830 Hanley Industrial Court, Brentwood,  
MO 63144, USA Phone: (314) 968-5040  
Email: sales@gjhalltools.com Fax : (314) 968-5543

[www.revo-tools.com](http://www.revo-tools.com)

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## MACHINE SPECIFICATION









### REVO R322-US

Machine Height	12" (slide in down position)	
Machine Width	4 <sup>3</sup> / <sub>4</sub> " (without handles)	
Machine Depth	10 <sup>13</sup> / <sub>16</sub> "	
Stroke	6 <sup>1</sup> / <sub>8</sub> "	
Machine Weight	26lb (tool and detachable parts)	
Rated Motor Power	850W	
Voltage	110V / 230V AC	
Rated Current	7.8A / 3.7A	
IP Rating	IP20	
Spindle Speed - load	390 rpm (depends on cutter size and feed rate)	
Spindle Speed - n <sub>0</sub>	690 rpm	
No. of speeds	Single Speed	
FWD/REV	No	
Power Cord Length	8' 2"	
Insulation Class	CLASS I	
Annular Cutter Capacity	Ø1 <sup>3</sup> / <sub>8</sub> "	
Standard Cutting Depth	1" (2" with optional long Arbor)	
Twist Drill Capacity	Ø1 <sup>1</sup> / <sub>2</sub> "	
Tapping Capacity	N/A	
Countersink	Yes	
Chuck Type	<sup>3</sup> / <sub>4</sub> " Weldon Shank Arbor or <sup>1</sup> / <sub>2</sub> " Chuck	
Spindle Fitting	<sup>1</sup> / <sub>2</sub> " x 20 UN	
Magnet Dimensions	6 <sup>5</sup> / <sub>16</sub> " x 3 <sup>3</sup> / <sub>8</sub> "	
Magnet Power	60W	
Magnetic Adhesion	2,200lb (measured on 1" thick plate)	
Minimum Plate Thickness	<sup>3</sup> / <sub>8</sub> " (minimum recommended)	
Sound Pressure Level	88 dBA	Uncertainty 3 dBA
Sound Power Level	101 dBA	Uncertainty 3 dBA
SPL at Operators Head	92 dBA (1.55m high x 1m distance)	Uncertainty 3 dBA
Hand-arm Vibration	Less than 2.5 m/s <sup>2</sup>	Uncertainty 1.5m/s <sup>2</sup> .

The vibration measurement was made under standard conditions in accordance with the requirements of BS EN 60129-1:2009.

The actual vibration level during use will depend on the workpiece stability/rigidity and the condition of the cutter used. These factors may increase the vibration experienced by the operator, each individual application of the tool should be assessed for the effect of these application variable factors, before exposure.

## EXPLANATION OF SYMBOLS USED

Symbol	Meaning
	Eye protection should be worn at all times when using this tool.
	Hard Hat—Head protection should be worn at all times whilst using this tool, to protect from overhead hazards
	Ear protection / Ear defenders should be worn at all times whilst using this tool, this tool exceed 85dB(A)
	Electrical enclosure - risk of electric shock.
	Read and understand the instruction manual - before operating this tool.
	Caution ! / Attention !
	Instruction Manual
	WEEE - Waste of Electrical and Electronic Equipment This tool should be disposed of as Electrical & Electronic Waste.

## INTENDED OF USE OF POWER TOOL

This power tool is intended to be used for drilling holes with annular cutters, twist drills, counterbores, countersinks and step drills in an industrial environment.

The machine is meant to be held onto a magnetisable surface using its electro-magnetic base.

The power tool should be used in a weather protected environment and be used with the accessories provided or Revo - Tools recommended accessories only.

The power tool can be used vertically, horizontally and upside down, provided the magnetic adhesion and work environment allow.

Cutting paste should be used rather than cutting fluid when using the machine in the upside down position to prevent ingress of fluids into the electrical system.

## PROHIBITED USE OF POWER TOOL

This power tool should never be used without a ground or protective earth connection.

This power tool should not be used in a potentially explosive environment.

This power tool should not be use in a wet or humid environment where water could be drawn into the power tools cooling and ventilation system.

If the power tool is used in the upside down position, cutting fluids should not be used to prevent ingress of fluids into the electrical system, cutting paste should be used instead.

This power tool should never be positioned on a workpiece between the electrode and ground of an arc type welder. Damage to the machine will result as the welder will ground through the power tools ground or earth cable.

This power tool should not be used where the voltage is abnormally lower than the rated voltage, subject to voltage tolerances. Check the power tool rating plate, check the voltage available.

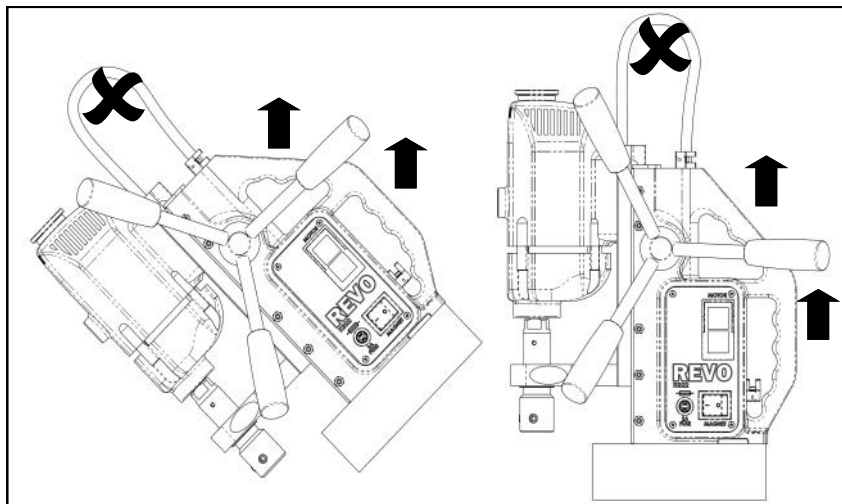
Operating on a lower than rated voltage will result in the electro magnet being at reduced power and the machine may become insecure whilst drilling.

## LIFTING HANDLES - TRANSPORTATION

When lifting the tool the lifting handles shown in the diagram on the right should be used.

The drill unit should be lowered to its lowest position for improved stability.

Under no circumstances should the motor cable be used for lifting the power tool.



## **PERSONAL SAFETY AND USE OF PPE**

### **Attention**

Always watch what you are doing and use common sense at all times when operating power tools.

Do not use the power tool whilst tired, or under the influence of drugs, alcohol or medication.

A moment of inattention when using a power tool may result in personal injury.

### **Clothing**

Always dress appropriately, do not wear loose clothing or jewellery.

Contain long hair, keep your hair, clothing and gloves away from any moving parts.

Loose clothes, jewellery or long hair can be caught in moving parts.

### **Accidental Start-up**

Be sure all switches are in their OFF positions before plugging in the machine.

When carrying or moving tools always keep your fingers away from the switches

Plugging in a power tool with the switches in the ON position could invite accidents.

### **Intentional Start-up**

Before starting up the power tool always remove any adjusting keys or tools.

A wrench key left in a rotating part of the power tool may result in injury.

### **Over Reaching**

Never over reach when using a power tool. Always ensure you have a proper stable footing and balance at all times before operating the tool.

Proper footing and balance enables better control of the tool in case of unexpected situations.

### **Personal Protective Equipment**

Always wear eye protection.

Always wear ear protection.

Always wear head protection.

Always wear non-skid safety shoes.

Where appropriate wear a dust mask and gloves depending on the working environment.

**WORK IN A SAFE MANNER AT ALL TIMES**

## **SPECIAL SAFETY PRECAUTIONS - MAGNETIC DRILLS**

### **Safety Strap**

The electro-magnet base on this power tool can release if there is a interruption in power supply or electrical malfunction.

The safety strap provided should be used at all times to prevent the power tool from falling in the event of power failure or electrical malfunction, possibly causing injury.

The safety cam buckle strap should be attached to the fixing points provided and checked for security before commencing any drilling operation.

### **Magnetic Adhesion**

The magnets strength depends on the thickness and condition of the work piece material. Always ensure that the work piece has a minimum thickness of 1/2" to ensure there is adequate magnetic adhesion.

If the work piece is less than 1/2" then a piece of steel plate 1/2" in thickness and larger than the magnet footprint must be inserted between the magnet and work piece to supplement the magnetic adhesion.

The surface on which the magnet is placed should be clean, flat and clear from debris or rust. The base of the magnet should be inspected to ensure it is also clean flat and clear of debris.

Always check the magnet is securely adhered to the work piece before commencing any drill operations.

Do not use other appliances on the same power receptacle, any variation in voltage cause by other appliances could result in the magnet releasing. Always us the tool on its own power receptacle.

This power tool can be used on a vertical surface or upside down provided there is sufficient magnetic adhesion, extra care should be taken when drilling vertically or upside down . When using the machine vertically or upside down it is possible hot and sharp swarf or chips may fall. Always wear appropriate personal protective equipment

### **When Cutting**

When using coolant or lubricants, ensure coolants and lubricants do not enter the drill units ventilation/cooling openings.

If the drill is used in the upside down position, use cutting paste instead of cutting fluid to prevent the possibility of fluids entering the electrical system.

When using annular cutters ensure that the slug ejected at the end of the cut will not endanger anyone in the vicinity, if working at height some form of collection device for the ejected slug may be necessary.

Care should be taken with the ejected slug, this will be both hot and sharp, gloves should be worn when handling the slug.

## **ELECTRICAL SAFETY**

### **Earthing / Grounding.**

This power tool requires a ground or earth connection.

The power tool must be plugged into an outlet properly installed and grounded or earthed in accordance with all local codes and regulations.

Never remove or tamper with the ground or earth prong in any way.

Do not use adaptor plugs.

If the tool should electrically malfunction or breakdown, grounding or earthing will provide a low resistance path to carry harmful electricity away from the user.

### **Power Cord**

Never carry the power tool by its power cord or electrical hose.

Keep power cords away from heat, oil and sharp edges.

Never pull the power cord to disconnect it from the receptacle.

Always carry the power tool properly with the carrying handles provided.

Periodically inspect the power cord for damage,

If any damage is found the power tool should not be used until the damage has been repaired by a qualified electrician.

A damaged power cord will increase the risk of electric shock.

### **Using the Power Tool Outside**

Do not expose the power tool to rain or wet conditions, water entering the power tool will increase the risk of electric shock.

When operating the power tools outside, if required, an extension cord rated for outdoor use should be used.

These extension cords are rated for outdoor use and reduce the risk of electric shock.

### **Electrical Enclosure**

The electrical components on this power tool are housed within the main body casting, this and the side panels of the main body create an electrical enclosure.

The panels should not be removed except by a suitable trained or qualified electrician.

## **DUST EXTRACTION**

This tool is intended for drill holes in ferrous metals, if using on materials such as cast iron where dust might be created, suitable dust extraction should be used.

This is both to protect the operator and to protect the motor inlet from ingress of harmful dust particles.

Operators should wear suitable dust masks if dust is created whilst working.

## GENERAL SAFETY

- 1 - Keep work area clear  
Cluttered areas and benches invite injuries.
- 2 - Consider work area environment  
Do not expose tools to rain.  
Do not use tools in damp or wet locations.  
Keep work area well lit.  
Do not use tools in the presence of flammable liquids or gases.
- 3 - Guard against electric shock  
Avoid body contact with earthed or grounded surfaces  
(e.g. pipes, radiators, ranges, refrigerators).
- 4 - Keep other persons away  
Do not let persons, especially children, not involved in the work touch the tool or the extension cord and keep them away from the work area.
- 5 - Store idle tools  
When not in use, tools should be stored in a dry locked-up place, out of reach of children.
- 6 - Do not force the tool  
It will do the job better and safer at the rate for which it was intended.
- 7 - Use the right tool  
Do not force small tools to do the job of a heavy duty tool.  
Do not use tools for purposes not intended; for example do not use circular saws to cut tree limbs or logs.
- 8 - Dress properly  
Do not wear loose clothing or jewellery, 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 protective equipment  
Use safety glasses.  
Use face or dust mask if working operations create dust.
- 10 - Connect dust extraction equipment  
If the tool is provided for the connection of dust extraction and collecting equipment, ensure these are connected and properly used.
- 11 - Do not abuse the cord  
Never yank the cord to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.
- 12 - Secure work  
Where possible use clamps or a vice to hold the work. It is safer than using your hand.
- 13 - Do not overreach  
Keep proper footing and balance at all times.

## GENERAL SAFETY - CONT.

- 14 - Maintain tools with care
  - Keep cutting tools sharp and clean for better and safer performance.
  - Follow instruction for lubricating and changing accessories.
  - Inspect tool cords periodically and if damaged have them repaired by an authorized service facility.
  - Inspect extension cords periodically and replace if damaged. Keep handles dry, clean and free from oil and grease
- 15 - Disconnect tools
  - When not in use, before servicing and when changing accessories such as blades, bits and cutters, disconnect tools from the power supply.
- 16 - Remove adjusting keys and wrenches
  - Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- 17 - Avoid unintentional starting
  - Ensure switch is in "off" position when plugging in.
- 18 - Use outdoor extension leads
  - When the tool is used outdoors, use only extension cords intended for outdoor use and so marked.
- 19 - Stay alert
  - Watch what you are doing, use common sense and do not operate the tool when you are tired.
- 20 - Check damaged parts
  - Before further use of tool, it should be carefully checked to determine that it will operate properly and perform its intended function.
  - Check for alignment of moving parts, binding of moving 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 centre unless otherwise indicated in this instruction manual.
  - Have defective switches replaced by an authorized service centre.
  - Do not use the tool if the switch does not turn it on and off.
- 21 - Warning
  - The use of any accessory or attachment other than one recommended in this instruction manual may present a risk of personal injury.
- 22 - Have your tool repaired by a qualified person
  - This electric tool complies with the relevant safety rules. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user.

## UNPACKING AND ASSEMBLY

The REVO R322-US comes in a rugged blow moulded carrying case before first use:-

1. Remove the machine from the carrying case. (Note:- 26lb weight)
2. Fit the three screw in handles to the pinion shaft.
3. Fit the safety guard as shown in the instructions, see “Using the safety guard”
4. Fit the arbor, as detailed in the instructions under “Fitting the Drill Chuck / Arbor”

## SETTING UP THE TOOL

Before using the tool please ensure you have read the sections on the intended and prohibited of use of the machine.

The machine should only be used for hole drilling whilst attached to the work piece by the electro-magnetic base.

This machine is intended for use at any angle, but only if the electro-magnet is in full working order and has sufficient hold on the work piece material.

The safety strap should be attached in case of power failure or machine malfunction.

The safety strap should NOT be used as an alternative to the magnet for clamping purposes.

Always ensure the strap is correctly fitted and the machine is secure BEFORE starting the

## CONNECTION TO THE POWER SUPPLY

Connection to the power supply is by 8' 2" long cable and 3 pin plug.

This tool is CLASS I insulation and MUST be earthed, any power socket the tool is connected to must have an earth.

Before the power cord is connected the magnet switch should be in the OFF position.

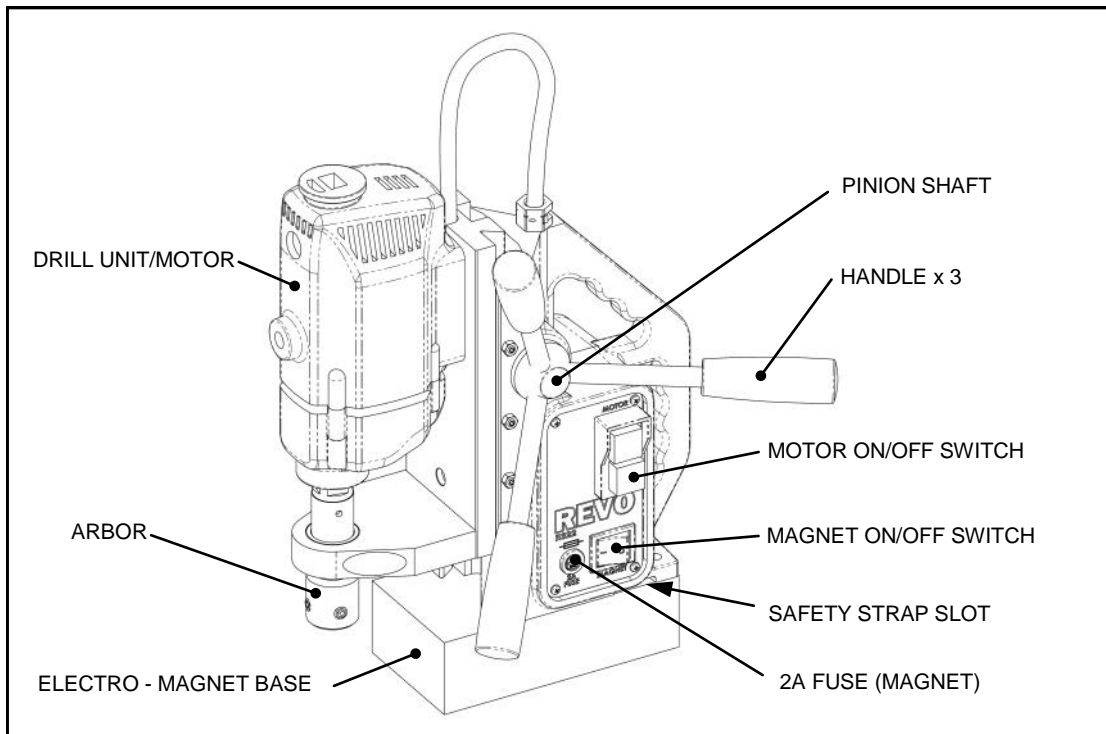
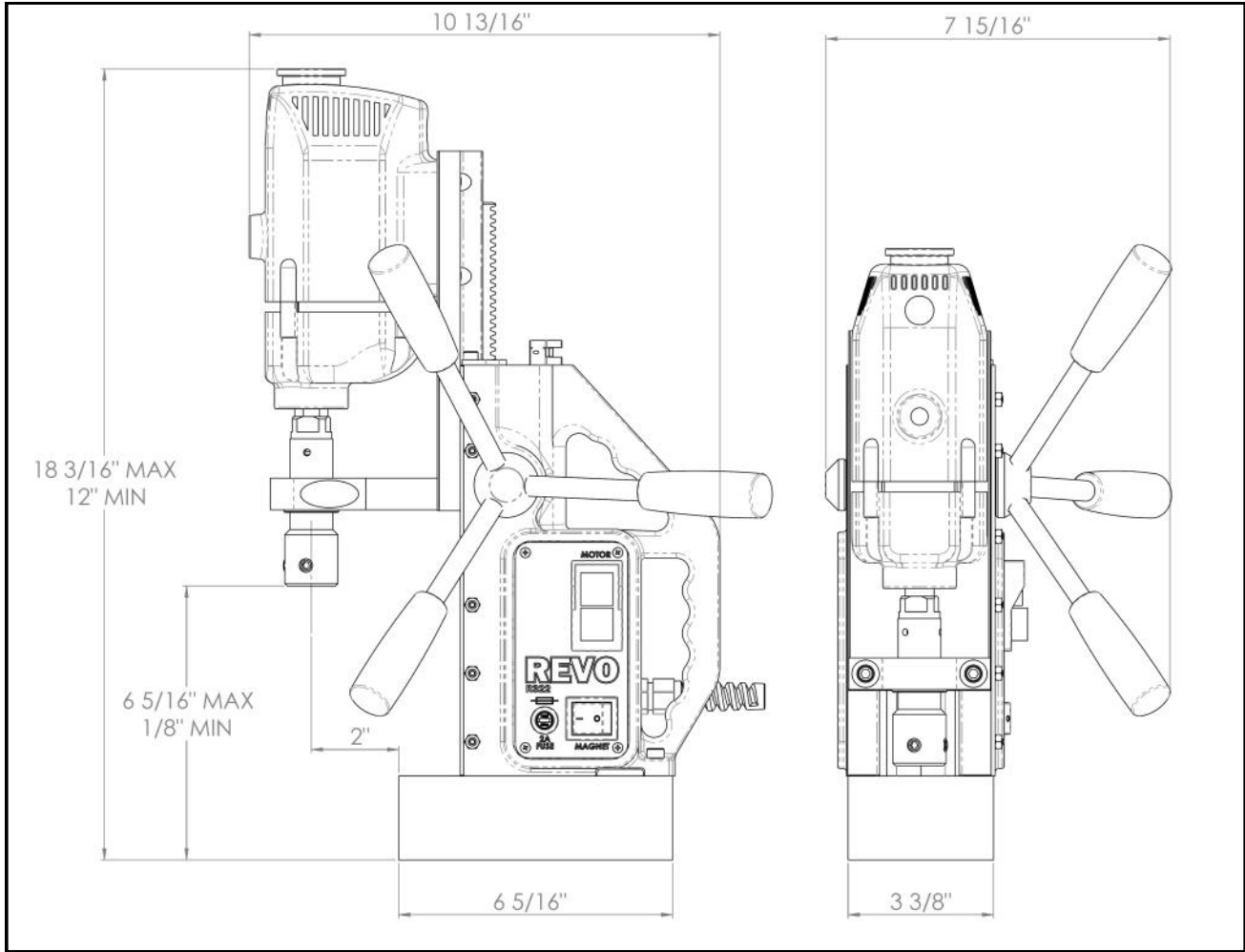
The power cord assembly is a custom terminated one, replacement should only be carried out by a qualified electrician. Only use the replacement parts listed below.

Power cord part number:-

18X503/A

For connection information, should the power cord need to be replaced, please refer to the wiring diagram in this manual or the connection label inside the rear panel of the power tool.

# ILLUSTRATED DESCRIPTION OF FUNCTIONS



## LIMITATIONS ON AMBIENT CONDITIONS

This power tool is has an ingress protection rating of IP20, it should not be used in dusty or damp environments.

The power tool should be used in a weather protected environment.

Precautions should be taken to ensure dust does not enter the ventilation system of the power tool causing clogging and overheating.

Power tools produce sparks that may ignite flammable substances such as gases, flammable liquids or dust.

Do not operate this power tool in a potentially explosive environment.

Ambient temperatures of >113°F should be avoided.

## STANDARD ACCESSORIES

The REVO R322-US is supplied in a rugged carrying case with the following as standard :-

- 3/4" Weldon Shank Arbor (1" cut depth)
- Safety Cam Buckle Strap
- Safety Guard
- 250ml Bottle of Cutting Oil
- Allen Key Set

## DISASSEMBLY & TRANSPORTATION

When the machine is not in use it should be stored in the carrying case provided.

Any cutters should be removed after use.

The drill unit should be wound down into a low position.

The three pinion handles need to be removed before placing the tool in the case.

Any additional tools or accessories should be stored in the case.

Make sure the case is securely closed and latches are secure before lifting the carrying case.

## SPECIAL TOOLS

All tools required for the safe operation and maintenance of this power tools are provided within the standard accessories, no additional tools should be required.

## SETTING AND TESTING - USING THE SAFETY STRAP

A cam buckle type safety strap is provided.

The power tool has a strap slot to allow the safety strap to be attached securely.

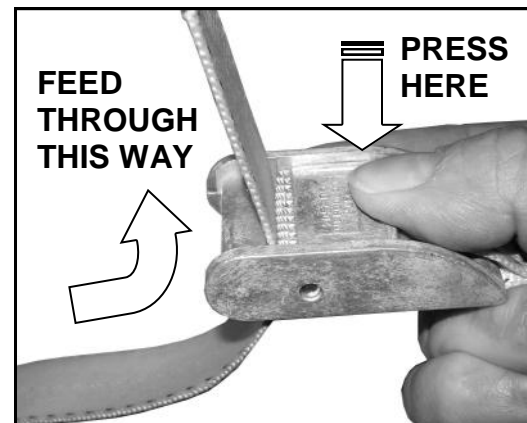
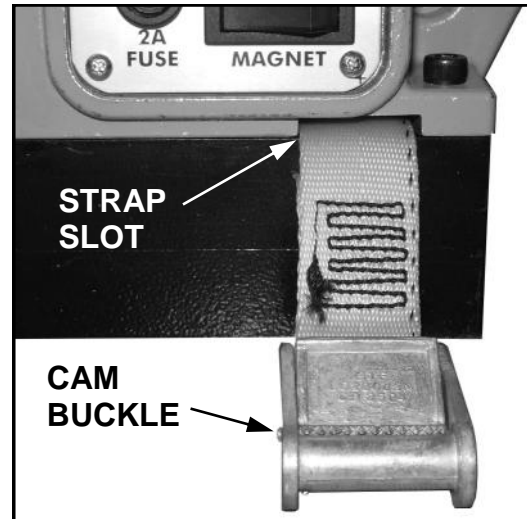
Always ensure the strap is correctly fitted and the machine is secure **BEFORE** starting the motor unit.

The safety strap is used to reduce the risk of injury in the case of a power supply or electrical malfunction.

A correctly fitted safety strap will hold the power tool if the electro-magnet loses its magnetic adhesion.

If the strap becomes damaged or lost, it must be replaced **BEFORE** using the power tool.

**DO NOT** use the safety strap as an alternative clamping method, the electro-magnet should have good magnetic adhesion at all times whilst using this power tool.



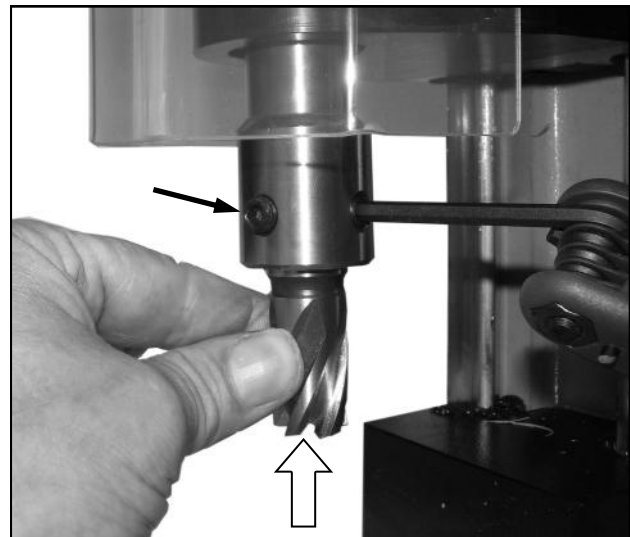
## MOUNTING CUTTERS INTO THE ARBOR

The holder for the cutting tool is known as the arbor. The arbor is designed to accept Powerbor 3/4" Weldon shank annular cutters.

The Powerbor annular cutters normally have two flats disposed at 90° to each other.

To mount the cutter.

First ensure the ejector pin is in place. Align the flats with the two fixing screws. Push the cutter up into the arbor until it stops. Tighten the two fixing screws onto the cutter flats with the hex keys supplied.



## FITTING THE DRILL CHUCK SUPPLIED

To replace the arbor (A) with the drill chuck supplied first remove the arbor.

To do this, using the spanners supplied, place one spanner on the flats of the drill output shaft.

Turn clockwise (as viewed from above) until the spanner meets the dovetail slide.

Place the the second spanner on the flats of the arbor, apply pressure, again clockwise as viewed from above.

If possible the magnet can be used to hold the machine whilst removing the arbor.

If the arbor is tight the spanner on the arbor flats can be tapped with a soft mallet.

Once the arbor is unscrewed the arbor support bracket (B) needs to be removed. This is accomplished by removing the two hexagon socket head cap screws.

To fit the drill chuck simply screw it into place on the spindle nose.

A special left handed screw is provided to hold the chuck.

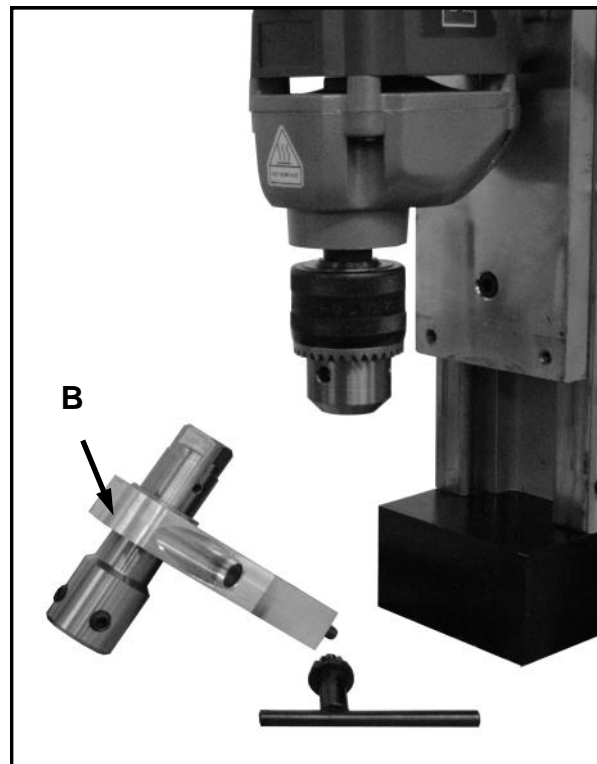
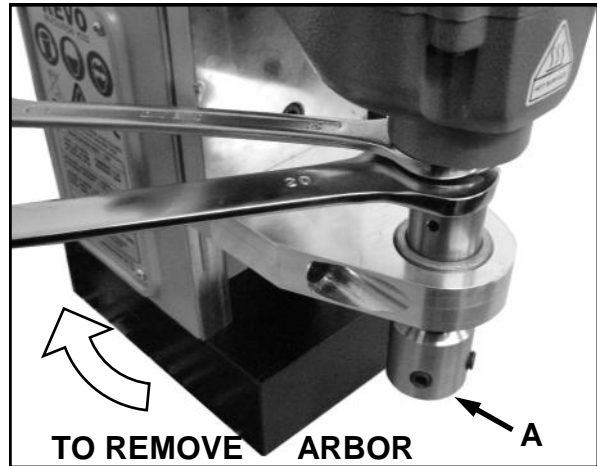
Replacement of the arbor is a reversal of the procedure above.

## USING TWIST DRILLS

Twist drills can be used with the R322-US.

To accommodate twist drills, or any plain shank cutting tool, the R322-US is supplied as standard with a 1/2" drill chuck and key.

The drill chuck takes standard parallel shank twist drills of up to 1/16" - 1/2".



## SAFETY GUARD

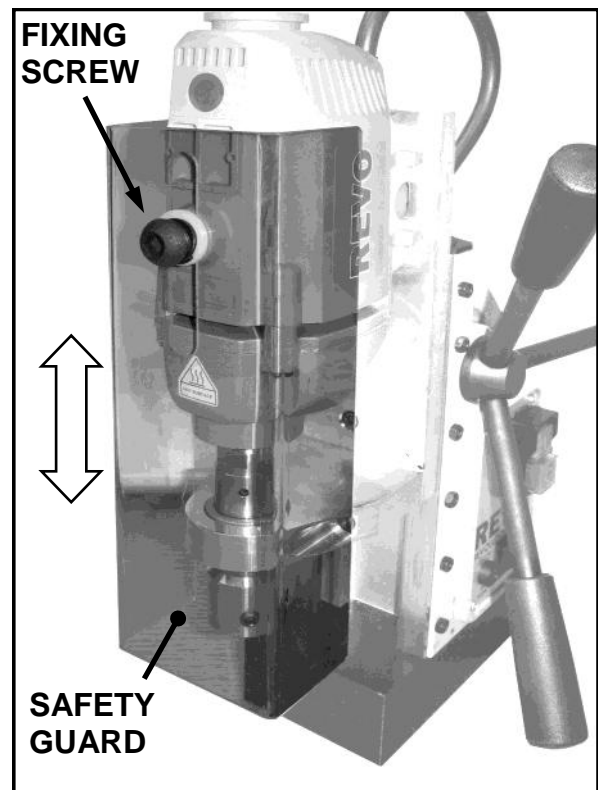
A safety guard is supplied with this power tool, it should be attached **BEFORE** using the power tool.

The guard is attached at 1 point, by a button head screw to the motor. The nylon washer should be closest to the guard with the spring washer between the nylon washer and the screw head.

The screw should be tightened just enough to allow the spring washers to hold the guard up.

The guard has approximately 2" of travel which is adequate standard length cutters.

The guard should be adjusted so it is able to slide with light pressure.



## CLAMPING - MAGNET CONTROL

An electro-magnet is used for clamping the tool onto the workpiece.

The magnet is controlled by the magnet switch (F) located at the bottom of the control panel.

'O' indicates magnet OFF 'I' indicates magnet ON.

Ensure the magnet switch is OFF before connecting the power supply.

Ensure the magnet is clean and free from debris and that the machine is on a flat clean ferrous surface of the required minimum thickness (3/8").

To switch the magnet ON, press the switch to the 'I' position, the switch will illuminate to indicate there is a power supply to the machine.

The security of the magnet should always be physically checked **BEFORE** starting the drill unit.

The magnet is protected by a 20mm 2A fast acting fuse (G).



## CUTTING SPEEDS/MATERIALS—HSS CUTTERS

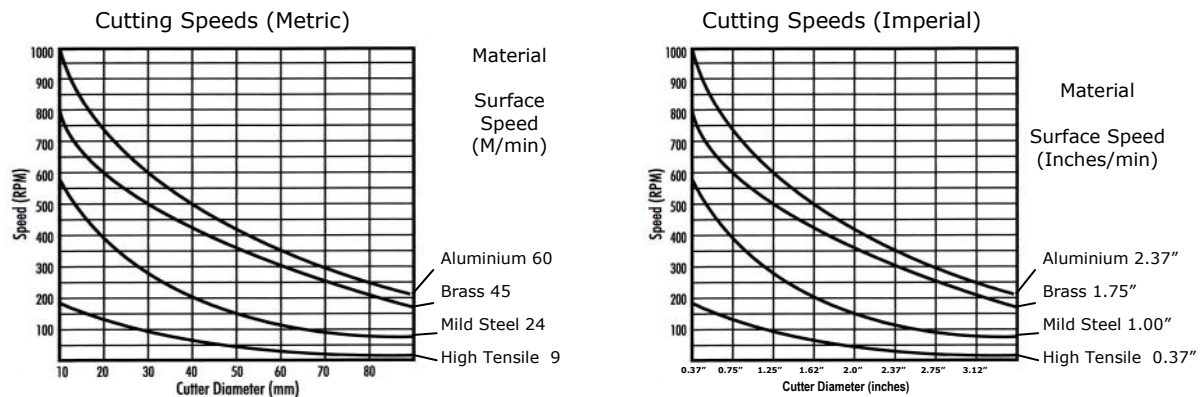
The REVO R322 is a single speed drill unit with a no load speed of 690 rpm and full load speed of 390 rpm, under load the R322 will regulate its speed depending on the load applied.

ie: a small cutter will run faster than a larger cutter (if the same feed rate is applied)

The R322 has the optimum power / torque / spindle speed for HSS annular and TCT cutters in the range  $\text{Ø}1/2''$  to  $\text{Ø}1\ 3/8''$ , cutting EN10025 S235J steel or its equivalent.

The R322 can also be used on other materials such as high tensile steel and stainless steel if the appropriate speed for the material to be cut is selected.

Cutting Speeds—suggested speed rates for varying cutter diameters / materials



## WORKPIECE MATERIAL AND SIZE LIMITATIONS - MAGNET

The electro - magnet clamping force is measured as the pull off load when clamped on a steel plate (EN10025 S235J or its equivalent) of 1" thickness, flat with a good surface and free from rust and debris.

For any other workpiece material the clamping force will be different, any difference in workpiece thickness and the clamping force will deviate.

The minimum recommended plate thickness for the electro-magnet is 1/2" thick.

If the workpiece is thinner than recommended then an additional plate, made of suitable material should be added by clamping to the workpiece, this will help the electro-magnet become more secure.

BEFORE using the drill always ensure the magnet is held onto the work piece securely.

## OPERATION - SPINDLE - START / STOP

The drill unit or “motor” is controlled by a twin push button switch (H) at the top of the control panel.

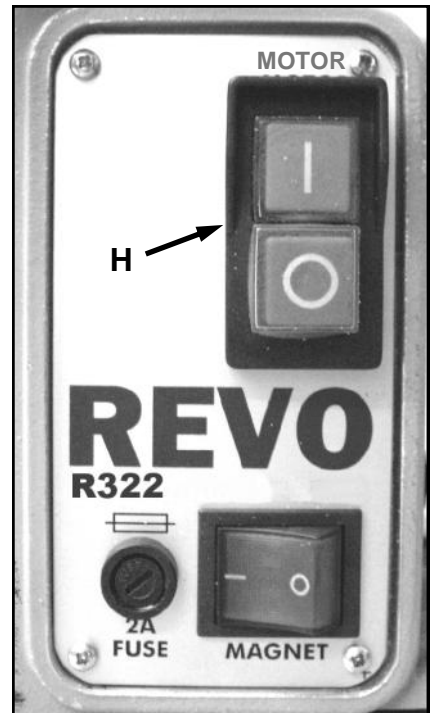
The green button is ON the red button is OFF.

The green button is below with the surrounding bezel. The red button is raised above the surrounding bezel. This is to prevent inadvertent operation of the drill unit.

The motor will not operate unless the magnet is switched ON first.

BEFORE starting the motor, the security of the magnet should be physically checked, if any movement is possible this should be rectified BEFORE using the drill.

The motor control has an under-voltage relay, if the power is interrupted the motor will stop and will not restart when the power is resumed until the motor control is operated again.



## OPERATION - REVERSING OF THE HANDLES

The three handles (C) which raise and lower the drill unit are attached to the pinion shaft (D).

These handles and the pinion shaft itself can be turned around so the handles can be used on each side of the machine. This is useful if access is limited on one side of the machine because of the machines location.

The handles are normally mounted on the same side as the controls, if they need to be reversed the following procedure should be used.

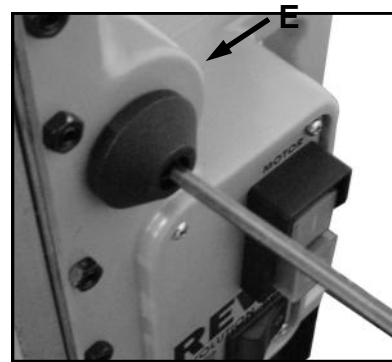
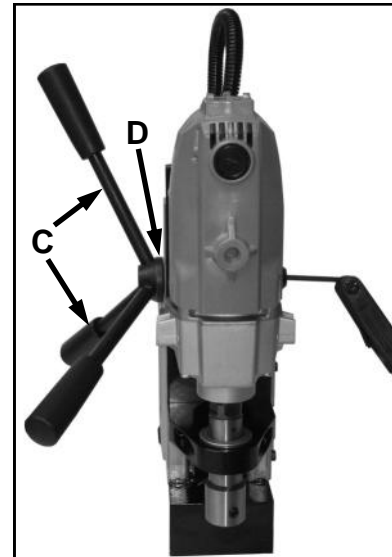
First, the drill unit and its slide should either be supported or put into its lowest position to prevent the risk of it falling when the pinion is disengaged.

The hexagon head cap screw in the end of the pinion shaft end cap (E) should be unscrewed.

The pinion shaft end cap can then be removed, the pinion shaft and handle assembly can be withdrawn.

The pinion shaft and handle assembly can then be mounted on the opposite side of the machine, taking care to ensure the pinion gear teeth engage with the rack teeth.

The pinion shaft end cap and its hexagon head cap screw should then be replaced and re-tightened.

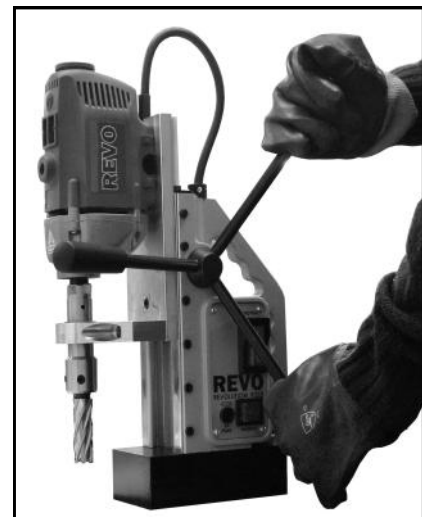


## OPERATION - NORMAL OPERATOR POSITION

The normal operator position is as shown in the image on the right, in general it is best to use the machine from in front of the control panel so that all the operator controls are visible and easily accessed.

There are occasions with this type of machine that it is used horizontally or even upside down. Extra care should be taken in these circumstances and access to the machine controls should be maintained.

The pinion shaft can be reversed on this type of machine to allow the drill better access in confined spaces. When the handles are reversed, again the operator should still have full access to the control panel before using the machine.



## **OPERATION - USING THE DRILL WITH ANNULAR CUTTERS**

Insert the correct pilot pin into the pilot pin hole through the shank of the cutter.

Mount the cutter in the tool holder (arbor) of the machine as described in previous chapters, ensuring the cutter is secure and correctly fitted.

Position the machine on the work piece ensuring the magnet is on a flat clean ferrous surface and the work piece is not below the minimum recommended thickness.

Use the pilot pin to align the centre of the cutter to the desired hole position.

Switch on the magnet and physically check the machine is securely adhered to the work piece.

Once in position, attach the safety strap, if the magnetic adhesion fails for some reason the safety strap will reduce movement of the machine.

Apply cutting fluid through the small holes in the arbor, the arbor has a small reservoir for coolant which is fed down through the central pin hole to the cutter. The use of cutting fluid will enhance the quality of the cut and prolong the life of the cutter.

Lower the safety guard provided.

Switch on the drill motor, feed the cutter down by using the three handles provided. Proceed with caution, apply pressure gradually until the cutter has formed a groove of approx 1/8". Once a groove is established the pressure can be increased.

DO NOT apply excessive pressure, if excessive pressure is required it is a sign the cutter may be worn, continuing to use a worn cutter will result in damage to the drill motor.

If the drill motor slows significantly under load ease off the downward pressure.

On deep holes it may be necessary to withdraw the cutter to remove swarf and to apply more cutting fluid.

A cutter in good condition will need only moderate feed pressure and will produce continuous chips or swarf. Broken chips or swarf indicate a cutter or material problem, so care should be taken.

## **OPERATION - BLOCKAGES OF CHIPS AND WORKPIECE FRAGMENTS**

If excessive swarf builds up during the cut it may be necessary to withdraw the cutter to remove the swarf, care should be taken as the swarf will be both hot and sharp.

As the cutter begins to break through, the feed pressure should be reduced slightly.

When the cutter breaks through, a slug of material at the centre of the cut will be ejected. This will be both hot and sharp. Care should be taken when handling the slug.

Care should be taken that the ejection slug is safe and can not injure anyone in the vicinity, the slug should be prevented from falling where possible.

## MAINTENANCE - GENERAL

To keep this machine in a safe working condition regular certain maintenance is required.

1. The gib strip on the dovetail slide must be adjusted to eliminate any free play.
2. The dovetail slides will need to be lubricated with oil periodically.
3. The magnetic base should be inspected for damage on its magnetic surface or for any damage to the resin, any damage should be repaired before using the drill.
4. A monthly inspection of the carbon brushes is recommended, excessive wear could lead to motor damage or malfunction.

## MAINTENANCE - REPLACING BRUSHES

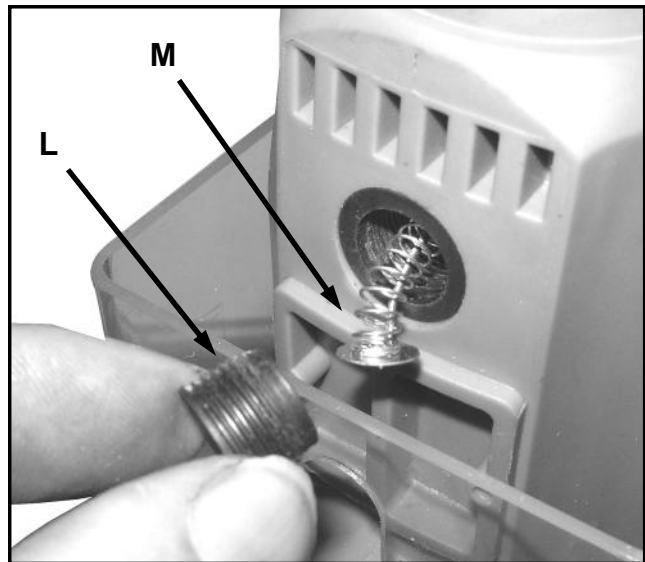
The carbon brushes (M) can be removed by simply unscrewing the brush cap (L).

The brush has a spring and metal cap attached, simply withdraw the brush to inspect or replace it.

When replacing the brush, slide it into the brush holder, make sure the metal cap of the brush seats in the recess on the brush cap, then screw the brush cap home.

Always use genuine replacement parts.

The brushes on this drill unit have an auto stop feature, when the brush reaches its wear limit the motor will stop until the brushes are replaced

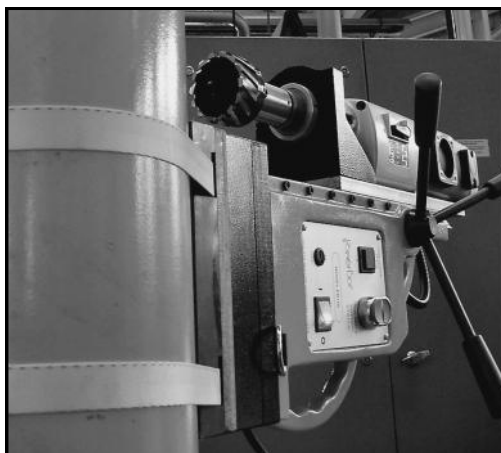


## ACCESSORIES



18Y170  
CHUCK ADAPTOR

This allows a drill chuck to be quickly placed into the arbor of the machine.



18YPIPE PIPE CLAMP

This allows the drill to be mounted on a pipe or cylindrical object, the magnet attaches to the "saddle" so the material of the workpiece does not need to be magnetic.

## MAINTENANCE - TOOL USE AND CARE

Always ensure the work piece is secure and stable before attempting to work on it.

Do not force the tool, always use the correct type of cutting tool for your application and use it at the rate it was designed to work at.

Do not use the power tool if the power switch does not turn it on or off, any tool which can not be turned on or off with the switch is dangerous and must be repaired before use.

Always disconnect the plug from the power supply before making any adjustments, changing accessories or storing the tool. This will prevent the risk of the starting the tool accidentally.

Always store tools not in use out of reach of children and untrained persons. Tools are dangerous in the hands of an untrained user.

Maintain all cutting tools with care, keep them sharp and clean, properly maintained tools with sharp edges are less likely to bind and will be easier to control.

Do not operate the power tool with dull or damaged cutting tools, this may overload the motor.

Check the power tools periodically for misalignment or binding of moving parts, also broken parts or any other condition that may affect the tools operation. If damaged have the tool serviced before using, Poorly maintained tools can cause accidents.

Use only Revo - Tools recommended accessories, accessories made for other power tools may not be suitable and could become hazardous when used.

## SERVICE

Only trained repair personnel should perform tool service. Service or maintenance performed by untrained personnel could result in a risk of injury.

When servicing the power tool, only use identical replacement parts, pay attention to the power tools voltage rating and model number to ensure the correct replacement parts are specified.

## WARRANTY

### REVO - TOOLS WARRANTY STATEMENT

Revo -Tools warrants its magnetic drills for one (1) year from the 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 workmanship. No other expressed warranty is given or authorised. Revo - Tools 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. To obtain warranty service, return the item(s) to your nearest factory authorised repair centre.

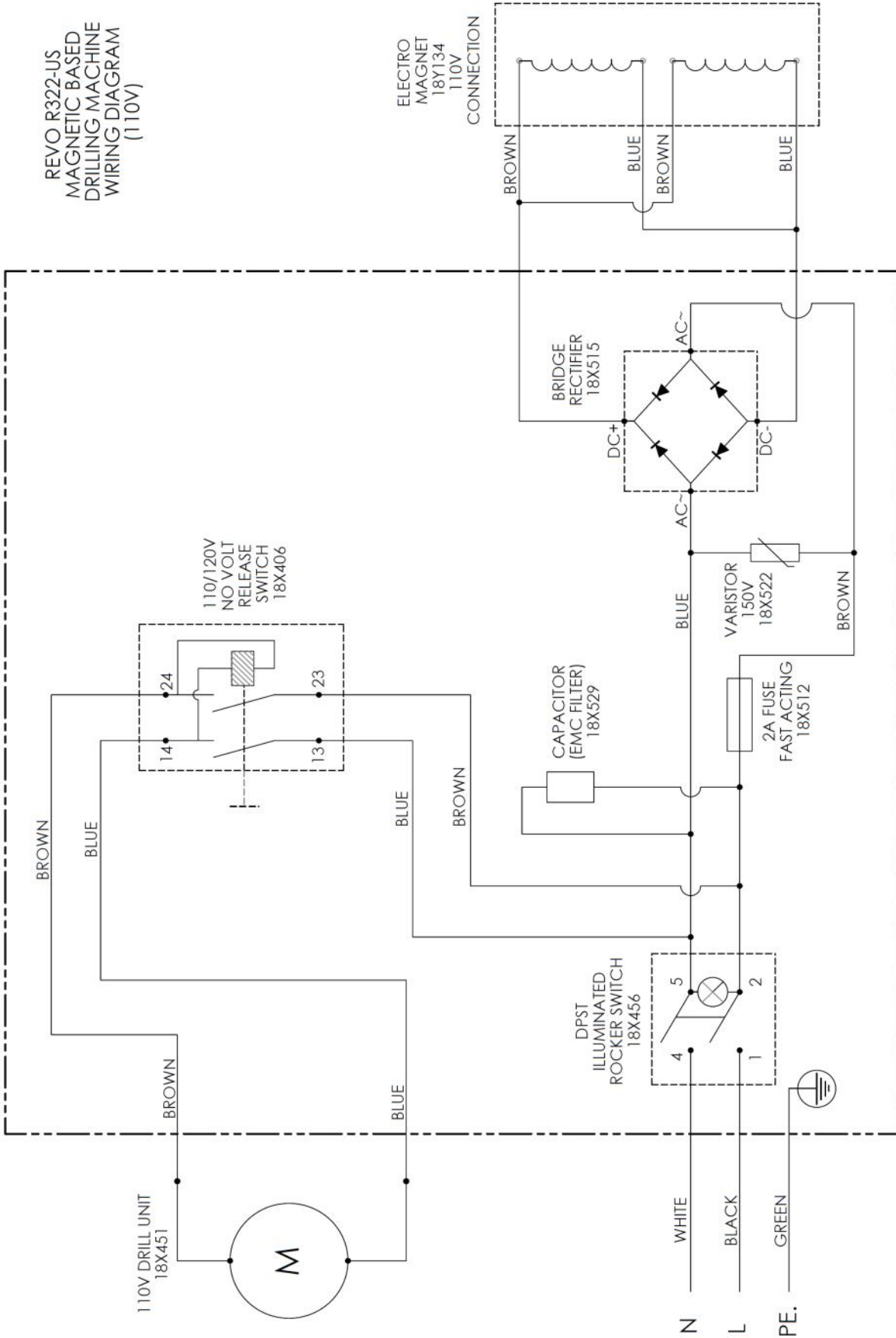
**This warranty is on lieu of any other warranty, expressed or implied, including any warranty of merchantability or fitness for a particular purpose.**

# R322 - US WIRING DIAGRAM

## REVO R322

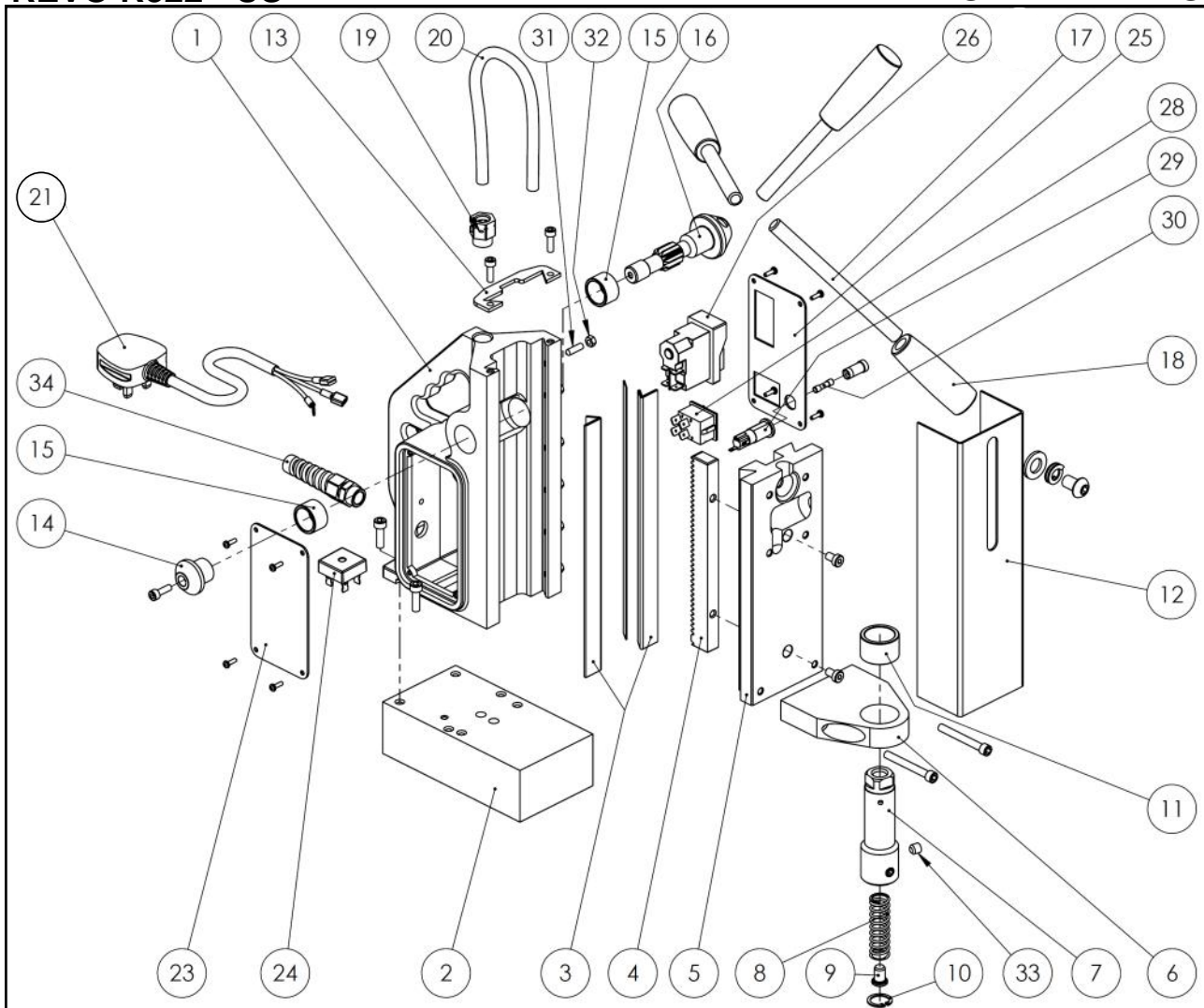
## WIRING 110V US

REVO R322-US  
MAGNETIC BASED  
DRILLING MACHINE  
WIRING DIAGRAM  
(110V)



# REVO R322 - US

# STAND PARTS

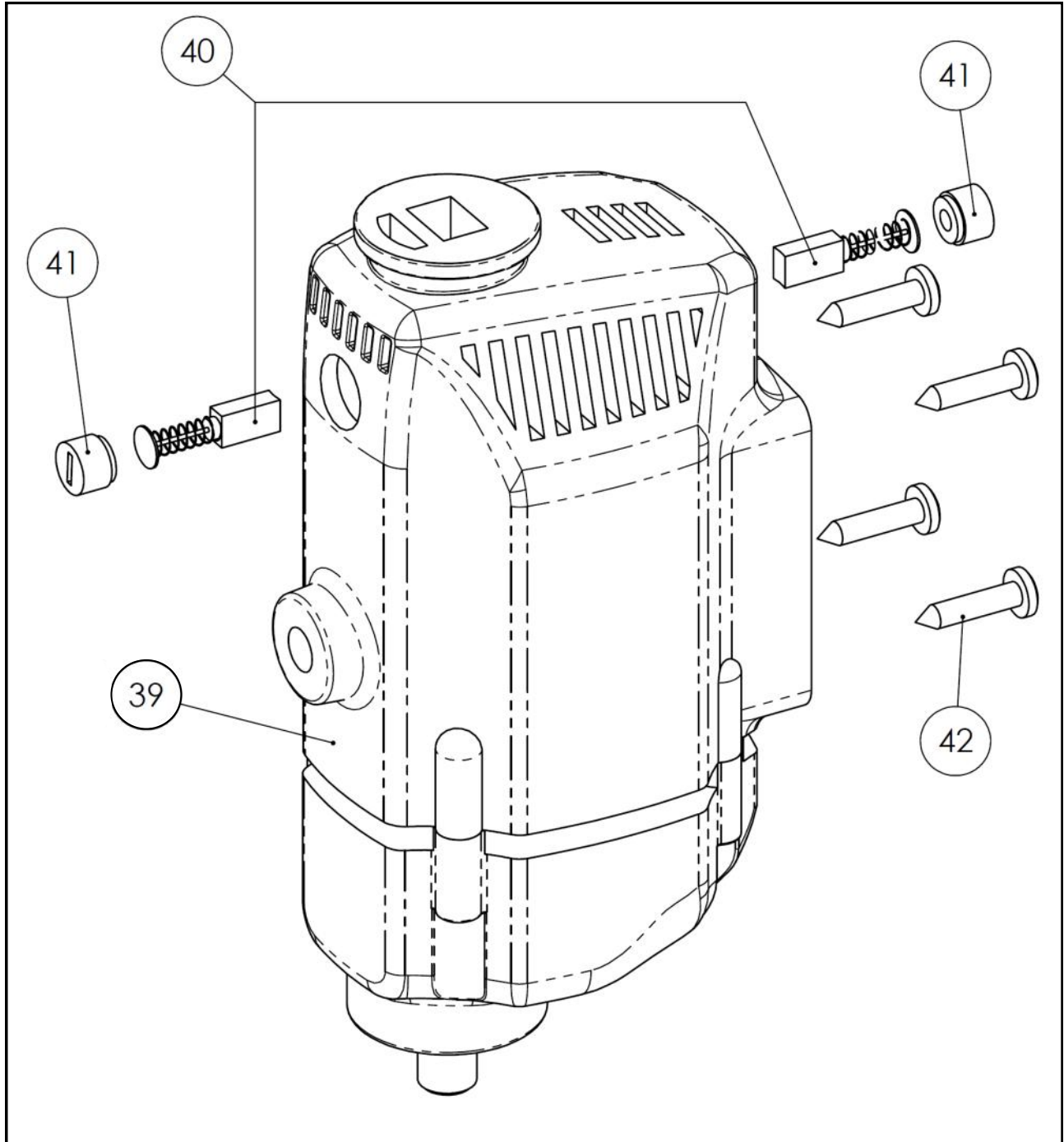


ITEM	Part No.	Description
1	18Y138/G	MAIN BODY CASTING (GREY)
2	18Y134	ELECTRO-MAGNET BASE
3	18X312	BRASS GUIDES (PAIR)
4	18Y140	MACHINE RACK - INC. SCREWS
5	18X411	DOVETAIL SLIDE
6	18Y201	ARBOR SUPPORT BRACKET - INC BUSH
7	18Y130	ARBOR ASSEMBLY (1/2" X 20 UN)
8	18X321	ARBOR SPRING
9	18X323	ARBOR PISTON
10	18X206	INTERNAL CIRCLIP
11	18X417	SPINDLE BUSH ONLY
12	18X310	REVO SAFETY GUARD
13	18X311	RETAINING BRACKET
14	18X524	PINION END CAP
15	18X502	PINION BUSH
16	18Y144	PINION SHAFT - INC CAP & SCREW
17	18X718	HANDLE
18	18X520	KNOB
17+18	18Y145	HANDLE/KNOB COMPLETE
19	18X519	CORD GRIP (CABLE GLAND)

ITEM	Part No.	Description
20	18X503/2	REVO CABLE FLEX TO MOTOR
21	18X503/A	MAINS CABLE 110V US
23	18X454	R322 REAR PANEL
24	18X515	RECTIFIER UNIT
25	18X455	R322 CONTROL PANEL (PLATE)
26	18X406	MOTOR START/STOP SWITCH - 110V
28	18X456	MAGNET SWITCH - 0 & I MARKINGS
29	18X457	R322 FUSE HOLDER
30	18X512	2A FUSE
31	18X224	M5 x 18 CONE POINT SCREW
32	18X219	M5 NUT
33	18X205	M8 X 8 SKT SCREW
34	18X430	POWER CABLE STRAIN RELIEF BUSH

### NOT SHOWN

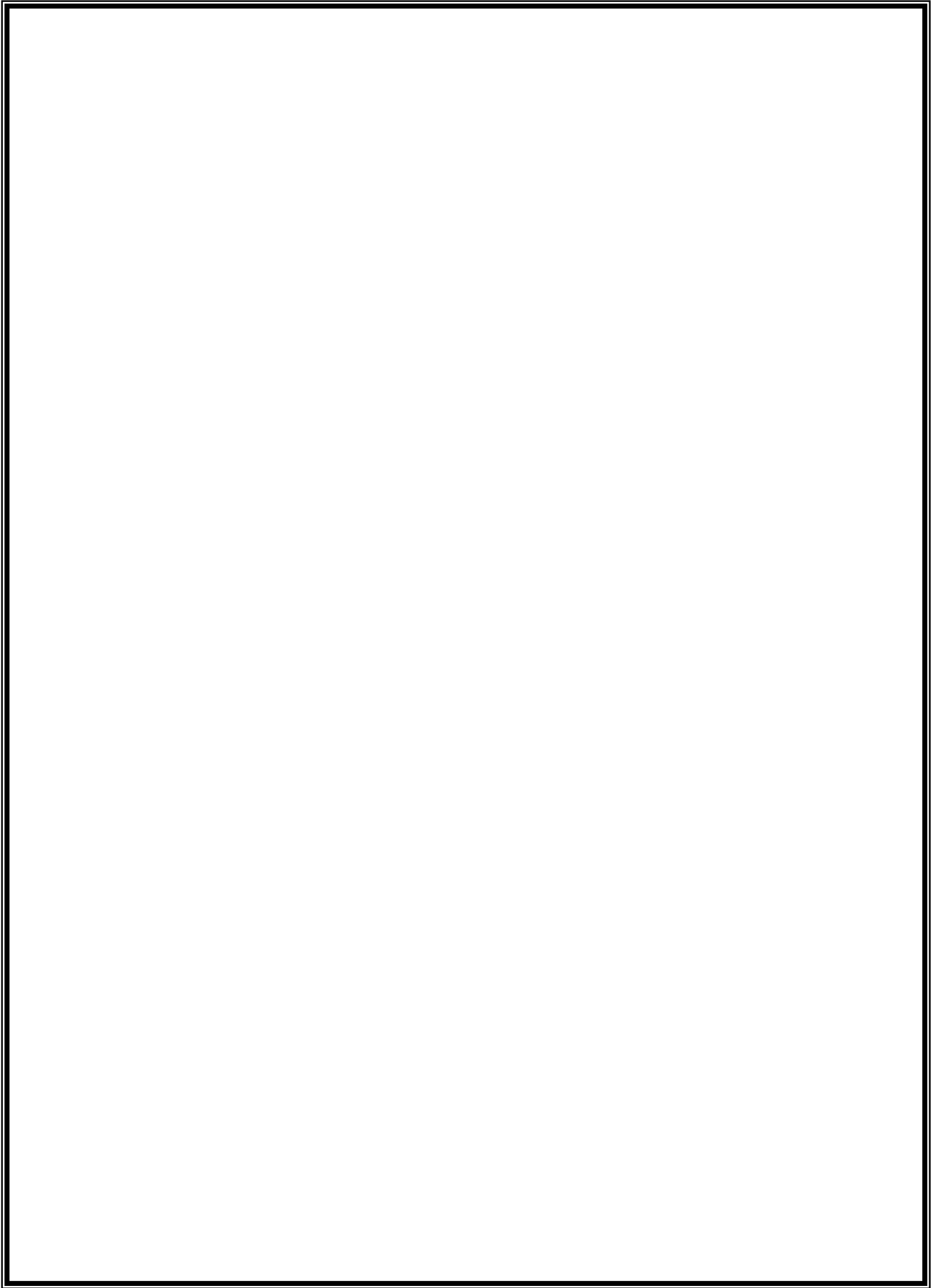
35	18X470	PLASTIC CASE
36	18ZA02B	1/2" DRILL CHUCK & KEY
36	18Y170	CHUCK ADAPTOR - ACCESORY
37	18X419	SAFETY STRAP - CAM BUCKLE

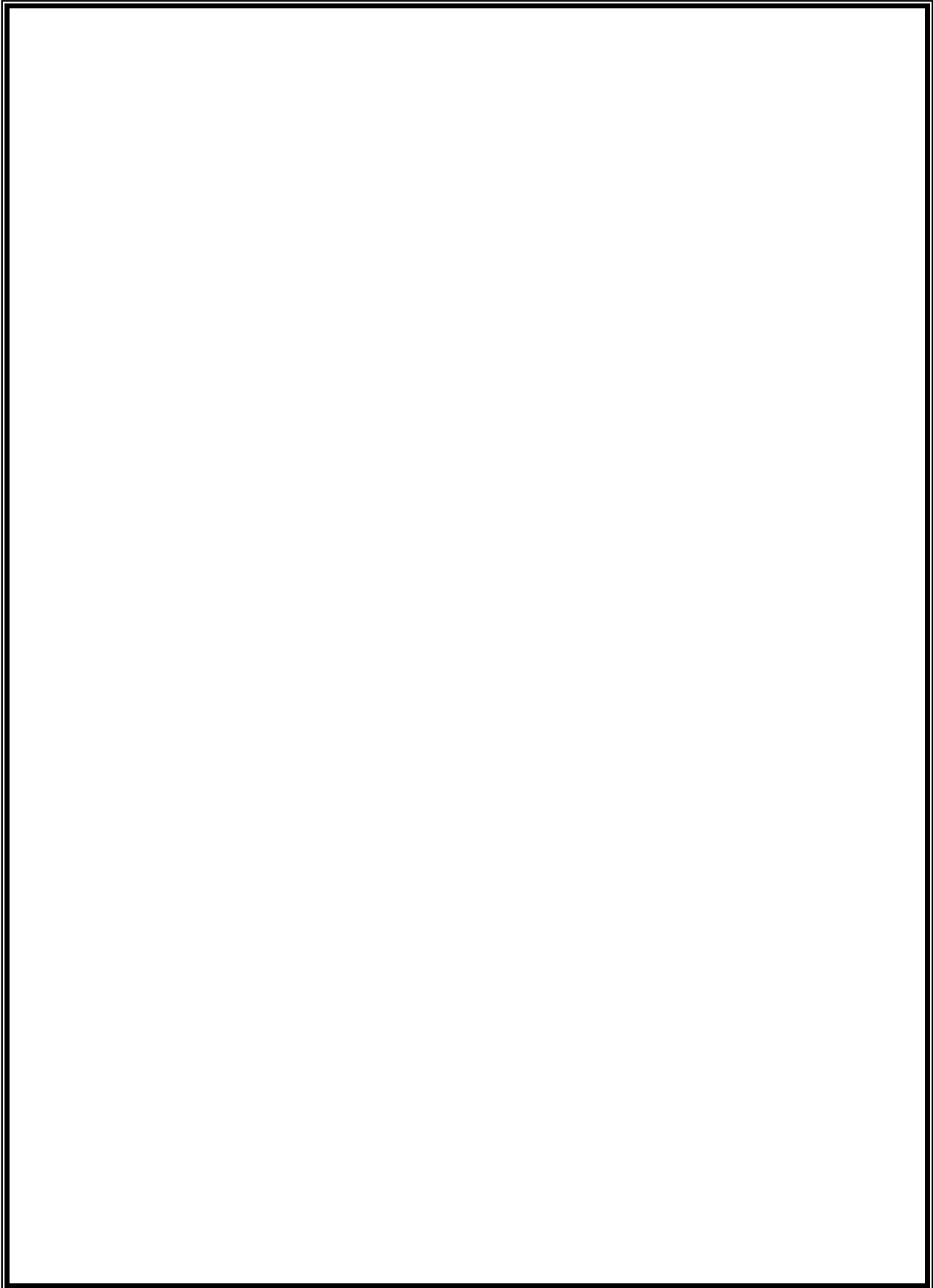


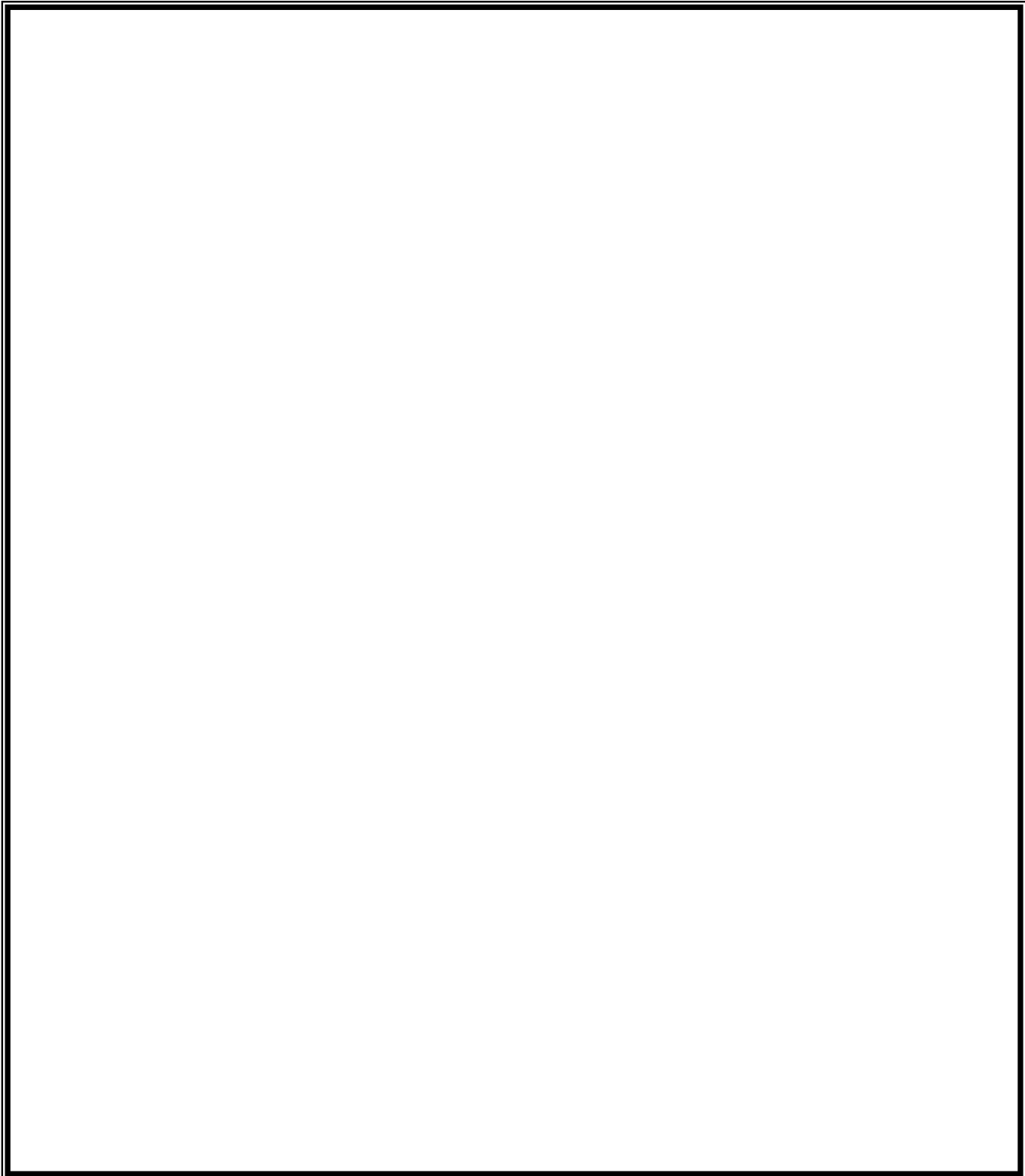
ITEM	Part No.	Description
39	18X451	COMPLETE DRILL UNIT - 110V
40	18X432	SET OF CARBON BRUSHES
41	18X433	BRUSH CAP
42	18X5620	5.5mm x 25mm SCREW

NOTE: The replaceable parts for the drill unit are limited to carbon brushes, brush caps and fixing screws only.

If the drill unit becomes unserviceable due to wear, it is normally more cost effective to replace the entire drill unit.







**WARRANTY REGISTRATION**

**Thank you for purchasing your REVO-Tools magnetic based drilling machine. To ensure any warranty claim can be processed promptly, please register your machine, now, on-line at :-**

**<http://www.revo-tools.com>**

**Click on the button on the left “REVO WARRANTY REGISTRATION”**