

# INSTRUCTIONS FOR REPLACING HUB AND PAWL ASSEMBLY

## TOOLS REQUIRED

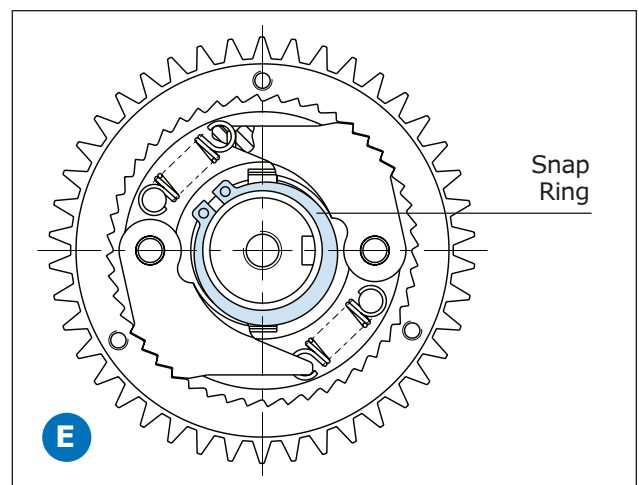
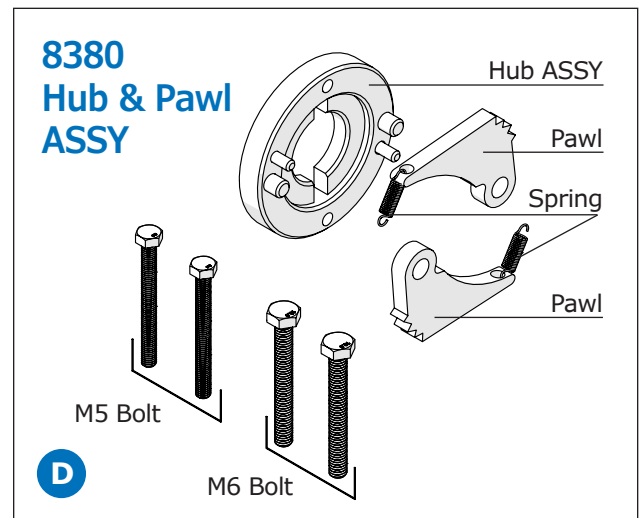
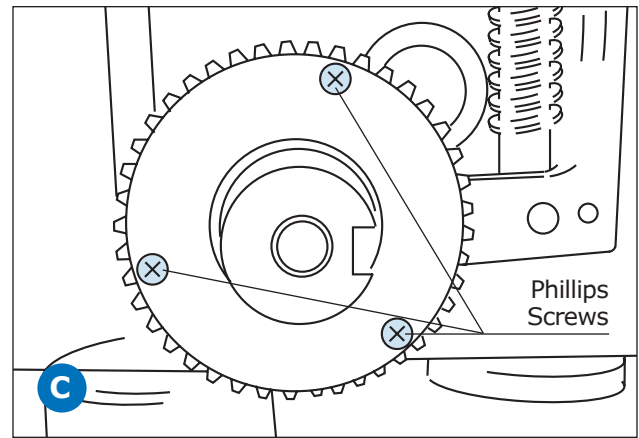
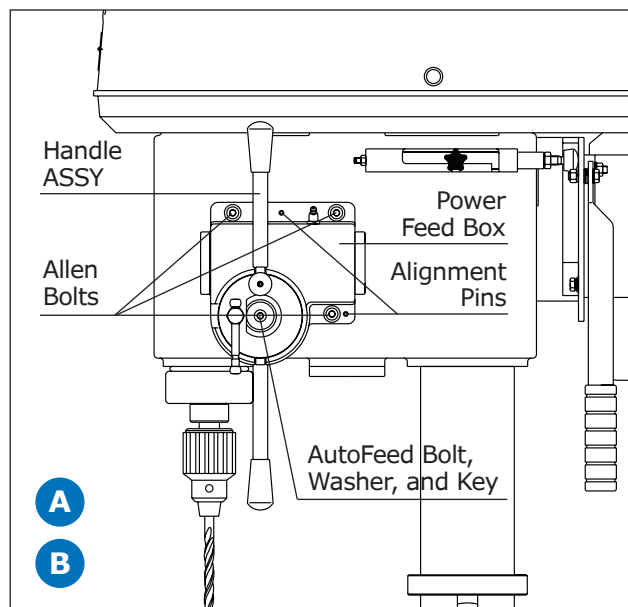
- Snap Ring Pliers (external)
- 8380 Hub & Pawl ASSY (only sold as ASSY)
- 6mm Allen Wrench
- Phillips Head Screwdriver
- Pry Bar
- Needle Nose Pliers
- Clean Shop Rags and Clean Work Area for Disassembled Components
- Small Hammer
- Brass Drift

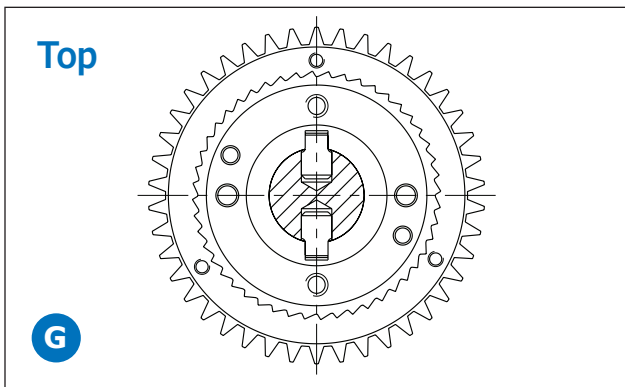
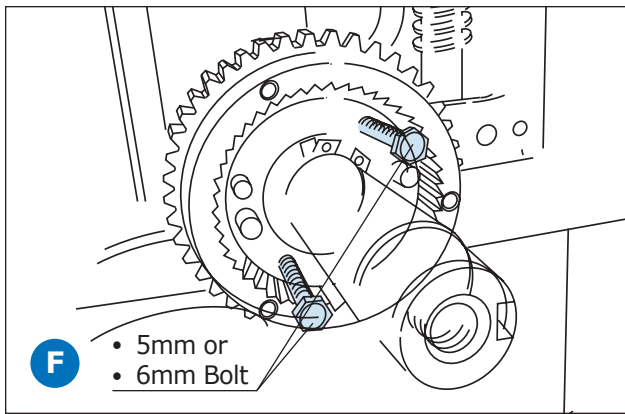
## Removing Power Feed Handle Assembly

Use a 6mm Allen Wrench to remove center bolt of auto feed handle assembly.

**NOTE 1:** Important—All removed components and assemblies must be kept in a clean area to avoid contamination with dirt and residue, etc. Otherwise, damage to drill unit could occur during operation.

**NOTE 2:** Keep auto-feed handles in vertical position during disassembly and installation of 8380 repair kit.





## STEPS FOR REMOVAL OF HUB AND PAWL ASSEMBLY

**NOTE: Keep handles in vertical position at 12 o'clock and 6 o'clock)**

### Step 1: (Drawings A and B)

- Remove bolt and washer from center hub using a 6mm Allen wrench. Set aside.
- Pull the handle ASSY out 1 inch towards you; push ASSY in; remove key from the shaft. Set aside.
- Remove the handle ASSY. Set aside.

**Step 2:** Remove three Allen screw bolts from the box of the power unit (two on top, one on right side). Set aside.

**Step 3:** Gently pry power unit box off side of drill press while being careful of the two alignment pins. Set aside.

**Step 4:** Remove three screws from the face plate mounted on the exposed gear with a Phillips screwdriver and set them aside. Remove the plate and set aside (Drawing C).

**Step 5:** Remove 2 pawls and 2 small springs (Drawing D). Set aside.

**Step 6:** This uncovers the external snap ring (Drawing E). Using snap ring pliers, remove the snap ring. Set aside.

**Step 7:** Insert two bolts (6mm or 5mm x 80) into the threaded holes, which are 180 degrees apart. (Drawing F). Tighten evenly (this pulls the back plate out and off the shaft).

**Step 8:** Inspect external and internal teeth on gear housings. If any are missing or rounded (or rolled over) the gear must be replaced. Also, check the two pins in the shaft.

**Step 9:** Take the 8380 Hub & Pawl ASSY and remove pawls and springs from the new back plate. Place the back plate over the shaft with the pins pointing out toward you. The slots in the back plate should be at 12 o'clock and 6 o'clock going over the pins in the shaft (Drawing G). Using a small hammer and brass drift, tap the backing plate into place. If you do not have a brass drift, a one inch diameter pipe will work.

**Step 10:** Replace the snap ring back on the shaft with snap ring pliers. If the snap ring is bent during this process it needs to be replaced.

**Step 11:** Place new pawls and springs back on the backing plate.

**Step 12:** Quick check to see if the problem is fixed:

- Slide handle body on shaft
- Slide key into slot
- Tighten bolt and washer
- Turn exposed gear by hand
- Pull out on handles to feed position
- If it stops the gear you are turning, then you set it correctly
- Remove screw, washer, key, and handle body

**Step 13:** Replace the face plate with three Phillips screws and then tighten.

**Step 14:** Roll the alignment pins, which should be in the power unit box. If the pins are still in the drill press head then remove and place in the holes in power unit box, flush with the machine surface.

**Step 15:** Place the power unit box back over the shaft and exposed gear: push up to the drill press head. Place the three 6mm bolts back into their housings and start the bolts into the drill press head. Do not tighten.

**Step 16:** Use a punch and hammer. Drive the alignment pins back into the drill press head (this aligns the parts). Then tighten the three screws "securely."

**Step 17:** Place the handle body back on the shaft and push it in. Then insert the round end of the key into the slot and handle body. Finally, insert the bolt and washer back on the end of the shaft and tighten with a 6mm wrench.