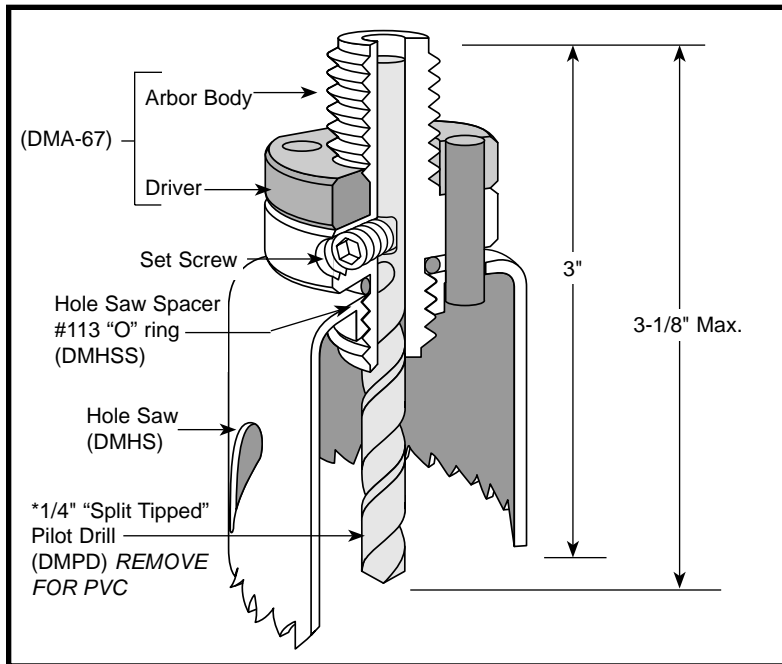


Assembly Instructions for 2" Hole Saw

DMHS-7 FOR DRILLING CAST IRON, DUCTILE IRON, PVC AND A/C PIPE

ARBOR ASSEMBLY WITH HOLE SAW



The 1/4" "Split Tipped" Pilot Drill* (DMPD) provides coupon retention when drilling Cast Iron, Ductile Iron or A/C pipe, with the water main dry. When installing the drill (DMPD) make sure the flat on the drill is lined up with the Arbor Set Screw and does not protrude over 1/8" beyond the Hole Saw. This Hole Saw is designed to provide for OCCASIONAL 2" taps. The Ford Drilling Machine is not intended to be used for *routine* taps larger than 1".

***NOTE:** Do NOT use Pilot Drill for PVC pipe.



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ASSEMBLY AND OPERATING INSTRUCTIONS

1. Insert the Boring Bar (DMBB-67) into the Drilling Machine (Fig. 1).
2. Select the Adapter (DMA) that matches the outlet threads of the corporation stop and attach it to the bottom of the Drilling Machine (Fig. 2).
3. Remove the Driver from the Arbor Body and screw the Hole Saw (DMHS) onto the shorter of the two threaded ends of the Arbor Body. Make sure that a Hole Saw Spacer #113 "O" ring (DMHSS) is installed on the Arbor between it and the Hole Saw.
4. Tighten the Hole Saw on the Arbor until resistance is felt. Replace Driver onto the Arbor Body and continue to tighten the saw until Driver pins line up with the holes in the top.
5. Attach the hole saw to the end of the Boring Bar (DMBB-67) by screwing the balance of the top threaded end of the Arbor Body into the tapped end of the Boring Bar (DMBB-67) (Fig. 3).
6. Refer to the instructions on page 8 of catalog section AB for general machine operation. **When operating a Hole Saw, lower the cutter gently onto the pipe. NEVER reverse the direction of rotation or the small carbide teeth on the edge of the Hole Saw will be destroyed. ALWAYS TURN CLOCKWISE. ALWAYS CUT WITH A SLOW FEEDSCREW RATE, ALLOWING CUTTER ENGAGEMENT WITH LIGHT PRESSURE.** The Hole Saw is for use on A/C, Ductile Iron, Cast Iron and PVC pipe. When drilling PVC pipe use a steady continuous drilling action and do not stop until the pipe has been drilled completely through. If you stop, relieve the feedscrew pressure and disengage the cutter from the pipe immediately. **DO NOT USE THE PILOT DRILL WHEN DRILLING PVC.**
7. When making dry taps the 1/4" "Split Tipped" Pilot Drill should be used for coupon retention when drilling Cast Iron, Ductile Iron or A/C pipe. **DO NOT USE THE PILOT DRILL WHEN DRILLING PVC.**



Fig. 1 Insert the Boring Bar into the Drilling Machine.



Fig. 2 Select the proper Drilling Machine Adapter and attach it to the Drilling Machine.



Fig. 3 Attach the Arbor-Driver-Hole Saw assembly to the end of the Boring Bar.