SERVICE PARTS LIST

BULLETIN NO.
54-30-0175

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

MAG STAND CONTROL PANEL

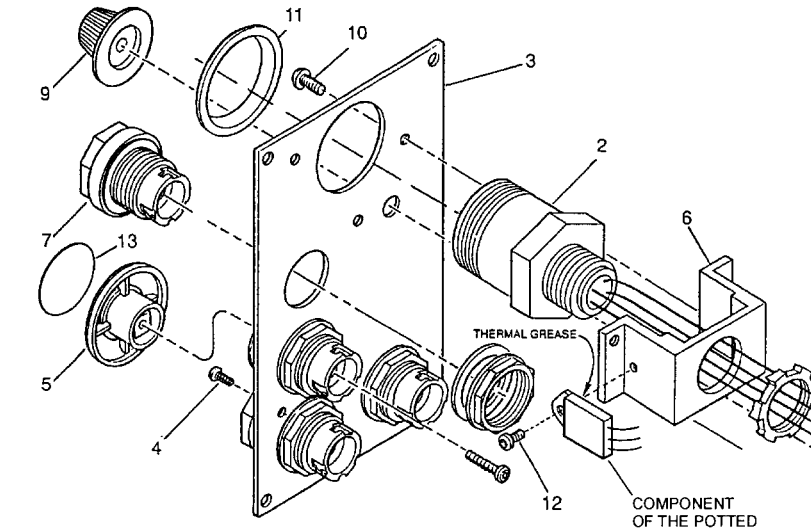
REVISED BULLETIN	DATE
	Mar. '99

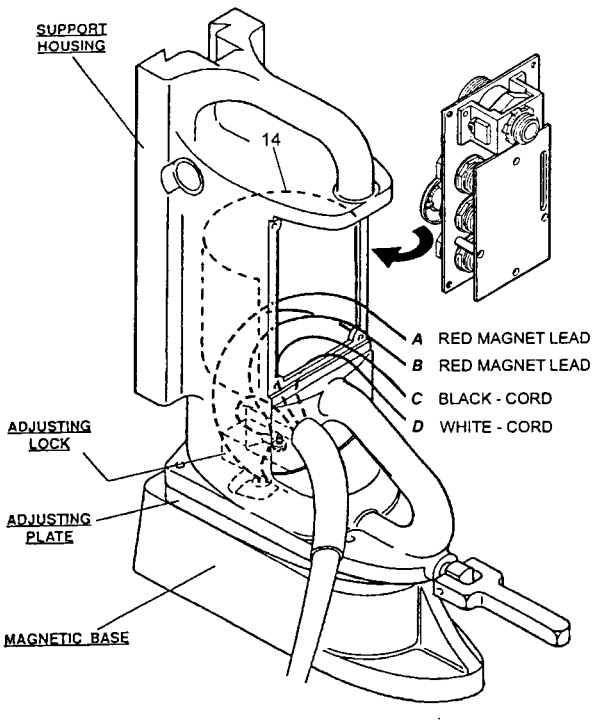
CATALOG NO. 23-35-0321 | SERIAL NUMBER

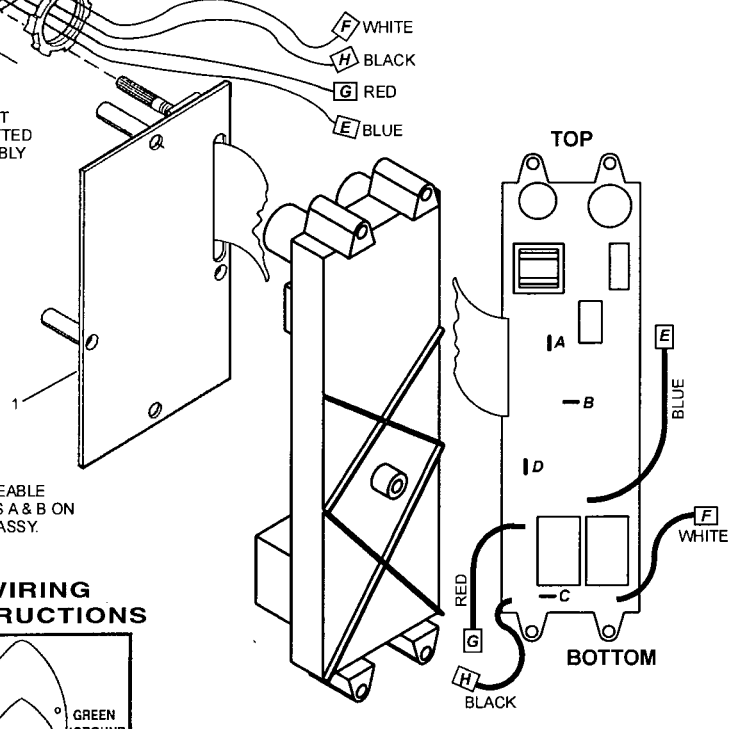
WIRING INSTRUCTION
SEE BELOW

EXAMPLE: 00 / 0
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

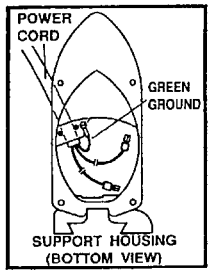
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	----------	Circuit Board Assembly	(1)
2	23-33-0495	Receptacle Assembly	(1)
3	44-66-0810	Panel Plate Assembly	(1)
4	06-82-5268	4-40 x 3/8" Pan Hd. Taptite T-9	(4)
5	42-42-0385	Drill "OFF" Button	(1)
6	42-36-1770	Receptacle Bracket	(1)
7	----------	Switch Button	(1)
	42-42-0405	Push Button - Green (Solid)	(1)
	42-42-0400	Push Button - Yellow (Solid)	(1)
	42-42-0440	Push Button - White (Clear)	(1)
	42-42-0450	Push Button - Push Button Blank	(1)
9	23-18-0080	Speed Dial	(1)
10	06-82-7252	8-32 x 3/8" Pan Hd. Slt. Tapt. T-20	(2)
11	45-06-0650	Receptacle Seal	(1)
12	06-81-8650	6-32 x 1/4" Rd. Hd. Sems	(1)
13	10-98-0225	"Drill-OFF" Label	(1)
14	23-16-1580	Panel Insulator	(1)







WIRING INSTRUCTIONS



SEE REVERSE SIDE *BEFORE WIRING* FOR IMPORTANT NOTES AND OPERATIONAL CHECK PROCEDURE

1. ROUTE TWO MAGNETIC BASE LEADS (RED WIRES WITH YELLOW SLEEVING) THROUGH ADJUSTING PLATE AND PAST ADJUSTING LOCK MECHANISM, ONE ON EACH SIDE. MAKE SURE SLEEVING IS NOT ABRADED DURING ROUTING.
2. SECURE LINE CORD IN SUPPORT HOUSING.
3. ATTACH GROUND TERMINAL TO SUPPORT HOUSING WITH GROUND SCREW. POSITION GROUND WIRE TERMINAL AS SHOWN, SO IT CAN SET FLAT AGAINST HOUSING BEFORE SECURING.
4. ATTACH THE BLACK AND WHITE LEADS FROM LINE CORD, AS SHOWN.
5. ATTACH THE LEADS FROM THE MAGNETIC BASE , AS SHOWN. **NOTE:** THE LEADS FROM THE MAGNETIC BASE CAN BE ATTACHED TO THE PANEL IN EITHER LOCATION.
6. ATTACH THE POTTED PCB ASSEMBLY TO THE SUPPORT HOUSING.
7. GENTLY PUSH THE BUNDLE OF WIRES DOWNWARD AND INSTALL THE CONTROL PANEL INTO THE HOUSING. AVOID PINCHING WIRES OR THE RIBBON CABLE AS THE CONTROL PANEL IS BEING INSTALLED.

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005

THIS PANEL ASSEMBLY IS DESIGNED FOR USE WITH HALF-WAVE MAGNETIC BASES ONLY (4201, 4221, 4231 Mag Stands)

TO DETERMINE IF THE MAGNETIC BASE IS FULL-WAVE OR HALF-WAVE, DISCONNECT THE TWO (2) RED MAGNETIC LEADS (A & B) FROM THE STAND'S CONTROL PANEL AND MEASURE THE RESISTANCE ACROSS THE LEADS. THE RESISTANCE OF A PROPER OPERATING HALF-WAVE MAGNETIC BASE WILL BE BETWEEN 37 AND 45 OHMS; A FULL-WAVE WILL BE BETWEEN 97 AND119 OHMS.

FOR FULL-WAVE BASES (4202, 4203 Mag Stands) USE PANEL ASSEMBLY NO. 23-35-0312.

PANEL ASSEMBLY IS ATTACHED TO THE SUPPORT HOUSING IN ONE OF TWO WAYS.

- THREE (3) #8-32 MACHINE SCREWS ARE USED THROUGH THE TOP AND MIDDLE HOLES IN THE POTTED ASSEMBLY, USING THE TAPPED HOLES IN THE BACK OF THE SUPPORT HOUSING **(CURRENT PRODUCTION).**
- FOR **NON-TAPPED** SUPPORT HOUSING ***(PREVIOUS PRODUCTION),*** USE THE FOUR SETS OF (VELCRO®) LOCKING TAB CONNECTORS INCLUDED. THE SUPPORT HOUSING'S SURFACE FOR ATTACHING THE TABS OF THE KIT MUST BE CLEAN AND DRY. SURFACE SHOULD BE CLEANED WITH MINERAL SPIRITS AND ALLOWED TO DRY.

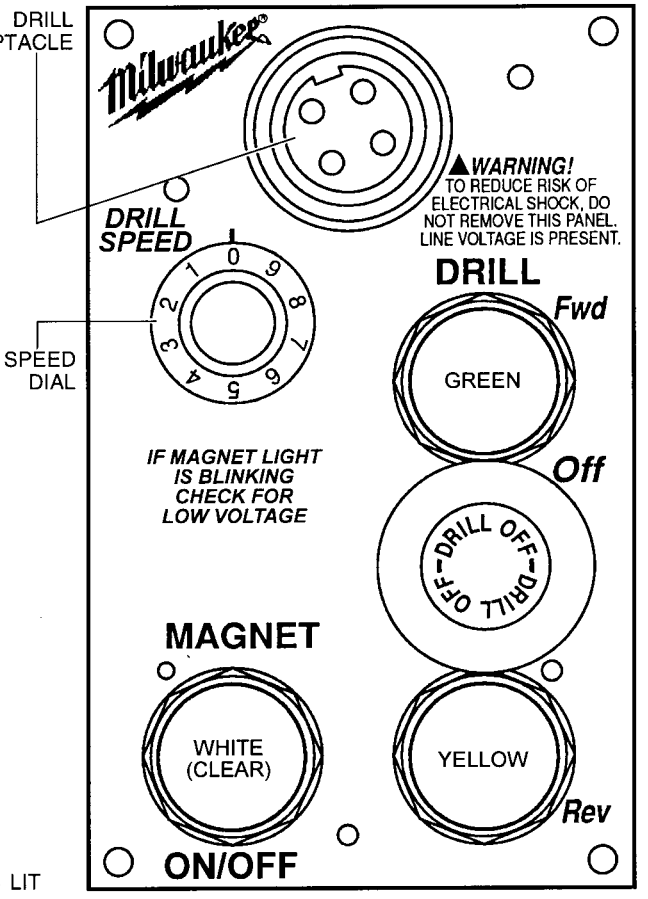
1.) PEEL OFF THE PLASTIC LINER FROM ONE SIDE OF A LOCKING TAB CONNECTOR AND STICK ONE TO EACH FOOT ON THE POTTED PCB ASSEMBLY.

2.) WITH A TAB CONNECTOR IN PLACE ON EACH FOOT, PEEL OFF THE REMAINING PLASTIC LINERS AND PRESS THE ENTIRE ASSEMBLY ONTO THE CLEAN INSIDE BACK SURFACE OF THE SUPPORT HOUSING.

3.) SEE WIRING INSTRUCTIONS, GENTLY PUSH WIRES DOWNWARD AND INSTALL CONTROL PANEL ASSEMBLY ONTO HOUSING.

PANEL OPERATIONAL CHECK LIST

1. SET UP
   A) PLACE THE STAND ON A STEEL SURFACE
   B) ATTACH A 120 V AC MOTOR
   C) SET SPEED DIAL TO THE FULL-ON POSITION (ROTATE CLOCKWISE UNTIL DIAL KNOB STOPS)
   D) APPLY 120 V AC
2. PRESS THE "FWD" BUTTON AND THEN PRESS THE "REV" BUTTON
   RESPONSE - DRILL DOES NOT OPERATE
3. PRESS THE "DRILL-OFF" BUTTON AND THEN THE "MAGNET" BUTTON
   RESPONSE - MAGNET TURNS ON, "MAGNET" BUTTON LIGHTS, DRILL DOES NOT OPERATE
4. TRY TO MOVE THE STAND
   RESPONSE - MAGNET DOES NOT ALLOW MOVEMENT
5. PRESS THE "FWD" BUTTON
   RESPONSE - DRILL ROTATES IN THE FORWARD DIRECTION
6. PRESS THE "DRILL-OFF" BUTTON
   RESPONSE - DRILL ROTATION STOPS
7. PRESS THE "REV" BUTTON
   RESPONSE - DRILL ROTATES IN THE REVERSE DIRECTION
8. PRESS THE "DRILL-OFF" BUTTON
   RESPONSE - DRILL ROTATION STOPS
9. PRESS THE "FWD" BUTTON
   RESPONSE - DRILL ROTATES IN FORWARD DIRECTION
10. PRESS THE "MAGNET" BUTTON
    RESPONSE - MAGNET STAYS ON AND "MAGNET" BUTTON STAYS LIT



11. ROTATE THE "SPEED DIAL" TO IT'S FULL OFF POSITION AND THEN BACK TO FULL-ON
    RESPONSE - MOTOR SPEED DECREASES AND INCREASES IN RESPONSE TO THE DIAL SETTING
12. PRESS THE "REV" BUTTON
    RESPONSE - DRILL SPEED DECREASES BEFORE REVERSING (SLIGHT FOR THE 4253 MOTOR), DRILL ROTATION CHANGES TO REVERSE, DRILL SPEED INCREASES TO FULL ON
13. PRESS THE "MAGNET" BUTTON
    RESPONSE - MAGNET STAYS ON AND "MAGNET" BUTTON STAYS LIT
14. PRESS THE "DRILL-OFF" BUTTON
    RESPONSE - DRILL ROTATION STOPS AND MAGNET STAYS ON, "MAGNET" BUTTON STAYS LIT
15. PRESS THE "MAGNET" BUTTON
    RESPONSE - MAGNET TURNS OFF, "MAGNET" BUTTON EXTINGUISHES