

SPECIFICATIONS

ROLLER MODEL	22490-
TUBE OD SIZE	1.5" - 3"
VOLTAGE	110
FREQUENCY	50/60
AMPERAGE	16.3
DRIVE SPINDLE	#3 M.T.
PROTECTION CLASS	CLASS II
DEGREE PROTECTION	IP 20
WEIGHT	16 LBS (7.2kgs)
SPEED	30-75/90-230 RPM

Noise Emission

The indication of noise emission figures is basing on DIN 45 649, part 2, DIN 45 635, part 21, and DIN EN 27 574 (ISO 7574).

- noise level (L_{WA}) (94+3) dB re 1 pW
working place-related emission figure (L_{pA}) 84 dB
for idle run as per DIN 45635 - 21 - KL 2
- noise level (L_{WA}) 88 dB re 1 pW
working place-related emission figure (L_{pA} , cyc) 79 dB
for substitute run with load (without workpiece machining) as per DIN 45635

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MODEL
22490-0000

VARIABLE SPEED & POWER ELECTRIC TUBE ROLLER



OPERATING INSTRUCTIONS & SERVICE MANUAL

Rev: A, 5/15/2015

TO REDUCE THE RISK OF INJURY AND EQUIPMENT DAMAGE
USER MUST READ AND UNDERSTAND OPERATOR'S MANUAL.

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SAFETY INSTRUCTIONS



WARNING!

READ AND UNDERSTAND ALL INSTRUCTIONS

Failure to follow all instructions listed below, may result in accident, fire and/or personal injury.

SAVE THESE INSTRUCTIONS

1. **KNOW YOUR POWER TOOL.** Read this service manual carefully.
2. **GROUNDING INSTRUCTIONS.** This product is equipped with a cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.
3. **KEEP GUARDS IN PLACE** and in working order.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **AVOID DANGEROUS ENVIRONMENT.** Keep work areas well lit.
6. **STORE IDLE TOOLS.** When not in use, tools should be stored in dry, high or locked-up place – out of reach of children.
7. **DON'T FORCE TOOLS.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOLS.** Don't force small tool or attachment to do the job of a heavy-duty tool.
9. **WEAR PROPEL APPAREL.** No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.
10. **USE SAFETY GLASSES** with most tools. Also face or dust mask if cutting operation is dusty.
11. **DON'T ABUSE CORD.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.
12. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hands to operate tool.
13. **DON'T OVERREACH.** Keep proper footing and balance at all times.
14. **MAINTAIN TOOL WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **DISCONNECT TOOLS:** When not in use; before servicing; when changing accessories such as blades, bits, cutters, etc.
16. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking that keys and adjusting wrenches are removed from tool before turning it on.
17. **AVOID ACCIDENTAL STARTING.** Don't carry plugged-in tool with finger or switch.
18. Remove the plug from the socket before carrying out any adjustment, servicing or maintenance.
19. Do not use unit with combustible fluids or where combustible fluids or fumes may be present.

POS. NO.

45	22490-0045	Grooved Ball Bearing
46	22490-0046	Disk F. Grooved Ball Bearing
47	22490-0047	Locking Ring
48	22490-0048	Intermediate Shaft 1
49	22490-0049	Coupling Wheel
50	22490-0050	Gear Sleeve
51	22490-0051	Intermediate Wheel 1
52	22490-0052	Spring Washer
53	22490-0053	Washer
54	22490-0054	Washer
55	22490-0055	Clutch Washer
56	22490-0056	C-Clip
57	22490-0057	Coupling, Complete
58	22490-0058	Intermediate Shaft 2
59	22490-0059	Fitting Spring, hardened
60	22490-0060	Cluster Gears
61	22490-0061	Coupling Bolt
62	22490-0062	Gear Switch
63	22490-0063	Intermediate Shaft 3
64	22490-0064	Intermediate Wheel 2
65	22490-0065	Work Spindle
66	22490-0066	Spindle Wheel
67	22490-0067	Fitting Disk
68	22490-0068	Fitting Spring
69	22490-0069	Locking Ring
70	22490-0070	Tube Handle, Complete
71	22490-0071	Disk Spring
72	22490-0072	Grease Chamber
73	22490-0073	Nut, Hexagon 8m10 x 1

Keep the electric tool clean

After approx. 300 hours of operation, the carbon brushes have to be checked by a specialist. If they are shorter than 5 mm, they must be replaced by new, original brushes. They must be run in by a 20-min idle run of the tool. Also the condition of the commutator must be checked. In case of irregular coloring of the individual blades and sur-face crashes, send the tool to a service workshop.

Cleaning of gearbox and motor is needed after approx. 500 hours of operation. Since this is the time of a general check of all components, send the tool to a workshop.

PARTS LIST

POS. NO.

21a	80500020	Speed Dial 220 VOLT
21b	80500007	Torque Dial
42 + 74	71540517	Disk of Needle Bearing
1	22490-0001	Rotor, Complete
2	22490-0002	Stator, Complete
3	22490-0003	Motor Housing
4	22490-0004	Air Guiding Ring
5	22490-0005	Carbon Brush Holder
7	80700021	Carbon Brushes
8	73320999	Disk
9	80201385	Spring Disk 34
10	80201180	Screw CM4x12
11	80410021	Ball Bearing See 100 579
12	80701002	Magnet Ring
13	73320315	Bearing Seal
14	74329280	Circuit Board - ETE 32/2.3 110 Volt
15	80600110	Reverser
16	80201260	Self Tapping Screw
17	7742A240	Motor Cap
18	80201267	Screw Replaces 050.0112
19	7152B293	Spacer
20	71521230	Selector Wheel
22	80500010	Condensor-SEE #80500014
23	71527260	Side Handle
24	80600114	Switch
25	80600060	Connection Cable
26	71323255	Cable Sleeve
27	71540330	Locking Flange
28	80201271	Screw 4.2x16
29	80201291	Screw
30	80201294	Self Tapping Screw
31	7152B610	End Shield
32	80201333	Safety Ring 28/1.2 Replaces 050.0166 33 80410031 Bearing Replaces 032.0171
34	80201320	Safety Ring Replaces 050.0176
35	80201292	Screw 4.2x16
36	80420110	Needle Sleeve Replaces 050.0161 37 74429620 Paper Seal
38	80200580	Notched Pin 5x16
39	71521400	Gearbox Housing
40	80410020	Bearing
41	80420001	Needle Bearing
43	80410061	Ball Bearing See 223 158
44	80201336	Locking Ring

SPEED AND POWER SELECTION

In order to get highest torque, user must set unit to low gear, set power switch to maximum and speed switch to minimum. **Please becarefull during gear changing.**

Make sure the unit is not turning.

Push gear switch button down and change it to desired gear.

Support gear changing by slightly rotating the working spindle

Make sure the gear switch button push back itself. it means the gear is engaged.



OPERATION

Working Instructions

To protect the operator, the machine has a mechanical safety clutch.

This drilling machine include a MK III cone spindle. Take always care for cleanliness of the hollow spindle and use only drilling chucks with undamaged shank.



