

The

*Enforcer*TM

Spot weld Drill

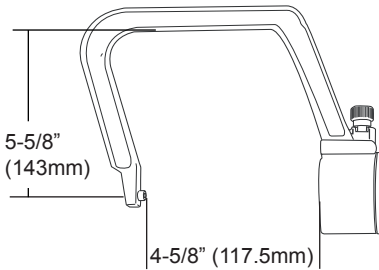
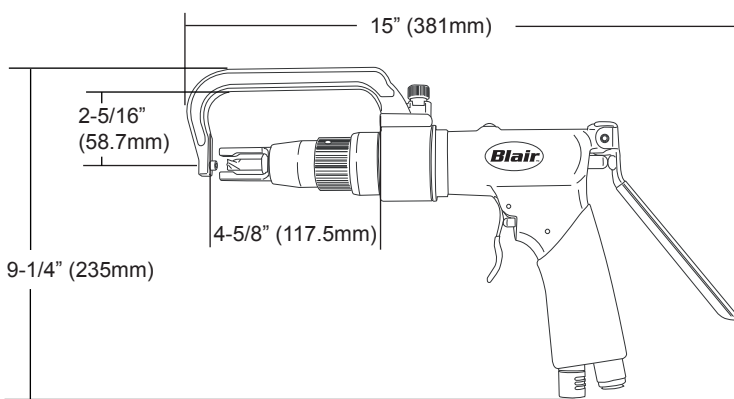
Operator's Manual



Part No. 11300

Blair Equipment Co. 3001 Hougén Dr. Swartz Creek, MI 48473
(810) 635-7111 www.blair-equipment.com

Specifications



Features

- *Low Speed 800 RPM / High Torque
- *360° Swivel on the clamp
- *Built-in Comfort Grip
- *Handle Exhaust
- *Low Operating Noise

Specifications

- Free Speed - 800 RPM
- Drill Bit Sizes - 6.5, 8, 10 & 12 mm Dia. X 47mm Long
- Air Inlet (NPT) - 1/4" (6.3mm)
- Hose Size - 3/8" (10mm)
- Air Pressure - 90psi. (6.2 Bar)
- Air Consumption - 4CFM (113 L/Min)
- Weight - 5.5 Lbs. (2.5 Kgs)

Important Safety Instructions



WARNING: Read and Understand all instructions. Failure to do so may cause personal injury or damage to the equipment.

Personal Safety

- Stay alert, watch what you are doing and use common sense when using a power tool. Do not use while tired or under the influence of drugs, alcohol or medication.
- Dress Properly. Do not wear loose clothing or jewelry. Keep long hair, loose clothing and gloves from moving parts.
- Avoid accidental starting. Disconnect any air supply before performing any maintenance or tool changes.
- Always use personal safety equipment. Wear Safety glasses to protect eyes from fling debris. Proper hearing protection must be used for appropriate conditions.

Work Area

- Keep your work area clean and well lit.
- Do not operate tools in an explosive atmosphere. Sparks may ignite fumes or dust.
- Keep bystanders away while operating power tools.
- Clean the work surface. Remove any adhesives, oil or foreign material from the work surface before removing the spot weld.

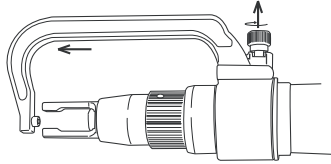
Tool Use and Care

- Do not start the cutter at an angle.
- Do not allow the cutter to slam in to the spot weld or work piece.
- Do not operate the machine at more than 800 RPM.
- Do not supply more than 90 psi to the machine.

Operating Instructions

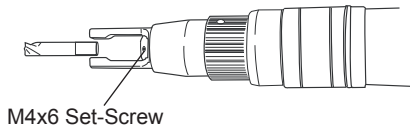
Removing the C-Clamp

Removing the C-clamp Assembly from the Blair Enforcer allows the user to switch between the different clamp assemblies and also allows access to the cutter. Pull UP on the thumb screw, turn 90° and pull the Clamp Assembly to the front of the *Blair Enforcer Spotweld Drill*. Follow these steps in the opposite order to re-install the C-clamp.



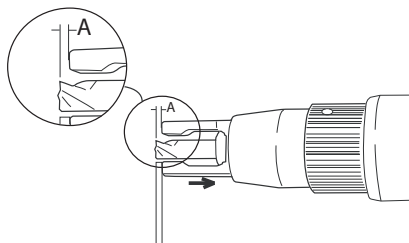
Installing the Spot weld Cutter

With the C-clamp removed, install the appropriate size Spot weld Cutter into the head of the Spot weld Gun, verifying that the flat on the cutter is in-line with the M4x6 Set-Screw. Also verify the cutter has been installed to its complete depth. Tighten the set-screw with a 2.5mm Hex Wrench and re-install the C-clamp as described above .



Setting the Depth of Cut

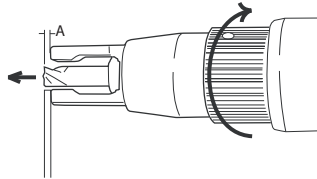
The depth of cut is determined by the distance from the end of the Spot weld Cutter to the end of the Support Jaws, when the Jaws are retracted (A). With the C-clamp removed, place the Support Jaws against a secure piece of steel and apply enough pressure to retract the jaws.



Operating Instructions

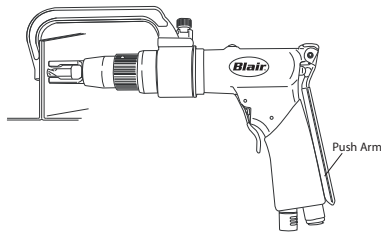
Setting the Depth of Cut *cont.*

Adjust the depth of the cutter to pass through the spot weld and the thickness of material. This distance may be increased or decreased by rotating the Adjusting Collar.

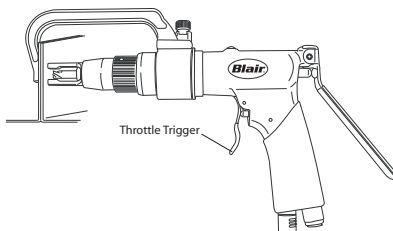


Making the Cut.

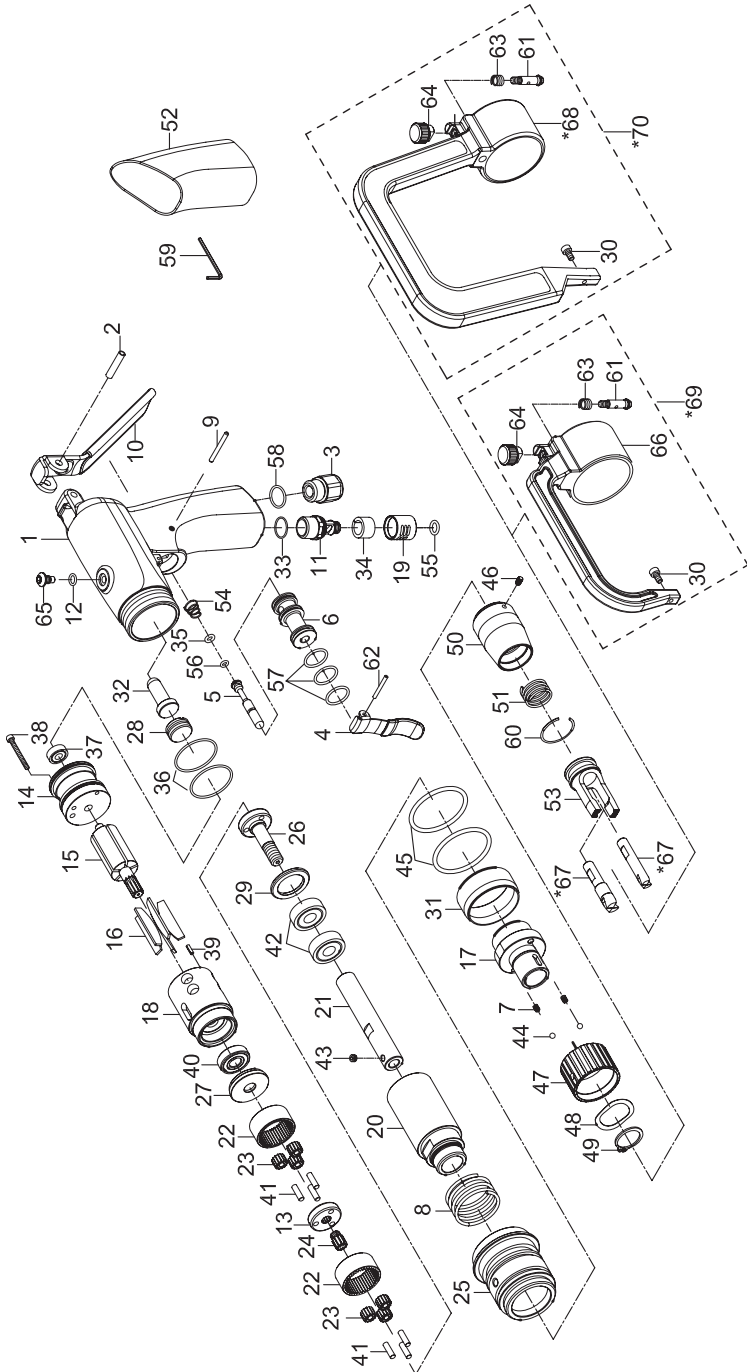
With the C-clamp re-installed, Position the **Blair Enforcer Spot-Weld Drill** so the center of the Spot weld Cutter is centered on the material to be removed. Verify the C-clamp, Throttle Trigger and Push Arm operations are not restricted.



Use one hand to support the bottom of the Spot weld Drill, the grip of the Drill is then placed in the palm of the second hand. Apply pressure to the Push Arm and bring the spot weld cutter to the material, just to make contact. The Throttle Trigger is then pulled to start the cutter rotation. Continue to apply pressure to the Push Arm until the cutter has completed the cut. Once through, release pressure from the Push Arm and allow the spot weld cutter to retract, then release the Throttle Trigger to stop the rotation.



Breakdown



Parts List

#	Part #	Description	Qty.	#	Part #	Description	Qty.
1	711001	Motor Housing	1	37	711037	Ball Bearing	1
2	711002	Spring Pin	1	38	711038	Screw	1
3	711003	Air Inlet	1	39	711039	Spring Pin	1
4	711004	Throttle Lever	1	40	711040	Ball Bearing	1
5	711005	Valve Stem	1	41	711041	Pin	6
6	711006	Valve	1	42	711042	Ball Bearing	2
7	711007	Spring	2	43	711043	Set Screw	1
8	711008	Spring	1	44	711044	Steel Ball	2
9	711009	Pin	1	45	711045	O-Ring	2
10	711010	Push Arm	1	46	711046	Set Screw	1
11	711011	Exhaust Shaft	1	47	711047	Adjusting Nut	1
12	711012	O-Ring	1	48	711048	Wave Washer	1
13	711013	Gear Plate	1	49	711049	Retaining Ring	1
14	711014	Rear End Plate	1	50	711050	Adjust Attach.	1
15	711015	Rotor	1	51	711051	Spring	1
16	711016	Rotor Blade	5	52	711052	Grip	1
17	711017	Adjusting Seat	1	53	711053	Support	1
18	711018	Cylinder	1	54	711054	Spring	1
19	711019	Exhaust Sleeve	1	55	711055	O-Ring	1
20	711020	Gear Housing	1	56	711056	O-Ring	1
21	711021	Bit Holder	1	57	711057	O-Ring	3
22	711022	Internal Gear	2	58	711058	O-Ring	1
23	711023	Planet Gear	6	59	711059	Spanner	1
24	711024	Idler Gear	1	60	711060	Retainer Ring	1
25	711025	Clamp Cage	1	61	711061	Lock Bar	1
26	711026	Work Spindle	1	62	711062	Spring Pin	1
27	711027	Bearing Cap	1	63	711063	Spring	1
28	711028	Screw	1	64	711064	Knob	1
29	711029	Washer	1	65	711065	Screw	1
30	711030	Screw	1	67	11306	6.5mm Cutter	
31	711031	Clamp Nut	1		11308	8mm Cutter	
32	711032	Steel Bar	1		11310	10mm Cutter	
33	711033	O-Ring	1		11312	12mm Cutter	
34	711034	Muffler	1	69	711066	C-Frame - 2"	1
35	711035	O-Ring	1	70	711068	C-Frame - 5"	1
36	711036	O-Ring	1				

Commercial / Industrial Limited Warranty

Blair Equipment Company warrants its Tornado II Paint Shaker for a period of 1 year and other products for ninety (90) days from 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 or workmanship. No other expressed warranty is given or authorized. Blair Equipment Company 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. Some states do not allow exclusions of incidental or consequential damages or limitation on how long an implied warranty lasts and, if the law of such a state governs your purchase, the above exclusion and limitation may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service, return the item(s), transportation prepaid, to
Blair Equipment Co.
3001 Hougen Drive, Swartz Creek,
Michigan 48473.

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OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR
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