

Hougen 17128HOU

Hougen 17128 RotaLoc Annular Cutter Instruction Manual

Model: 17128HOU

INTRODUCTION

This manual provides essential information for the safe and effective use of the Hougen 17128 RotaLoc Annular Cutter. This cutter is specifically designed for use with the Hougen HMD115 Ultra-Low Profile Truck Frame Drill. Adhering to these instructions will ensure optimal performance and longevity of your tool.

PRODUCT OVERVIEW

The Hougen 17128 RotaLoc Annular Cutter is a precision tool engineered for efficient hole cutting in various materials, particularly steel. Its robust construction and specialized design contribute to its high performance.

Key Features:

- **7/8-Inch Cutter Diameter:** Provides a precise cutting diameter for specific applications.
- **RotaLoc Annular Cutter for HMD115 Drill:** Specifically designed for seamless integration and optimal performance with the Hougen HMD115 Ultra-Low Profile Truck Frame Drill.
- **Made of M42 High Speed Steel:** Ensures durability, heat resistance, and extended tool life.
- **Feature Stack Cut Geometry:** Allows for efficient penetration through multiple plates in a single pass, up to 3/4-inch depth of cut.
- **5/8-Inch Bayonet-Style Shank Mounting:** Facilitates fast and tool-free change out, enhancing operational efficiency.



Image: The Hougén 17128 RotaLoc Annular Cutter, showcasing its bayonet-style shank and cutting teeth. This image illustrates the design of the cutter, highlighting its M42 high-speed steel construction and stack cut geometry.

SETUP

1. **Safety First:** Always wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and hearing protection, before handling tools or operating machinery.
2. **Inspect the Cutter:** Before each use, inspect the annular cutter for any signs of damage, wear, or dullness. Do not use a damaged or excessively worn cutter.
3. **Prepare the Drill:** Ensure your Hougén HMD115 Ultra-Low Profile Truck Frame Drill is clean and in good working order. Disconnect power before attaching or detaching accessories.
4. **Install Pilot Pin:** Insert the correct pilot pin (Hougén 17100 or 17101) into the center of the annular cutter. The pilot pin helps center the cutter and eject the slug.
5. **Attach Cutter to Drill:** Align the 5/8-inch bayonet-style shank of the RotaLoc cutter with the spindle of the HMD115 drill. Push and twist to secure the cutter firmly in place. Ensure it is fully seated and locked.
6. **Secure Workpiece:** Firmly clamp the material to be drilled to prevent movement during operation.

OPERATING INSTRUCTIONS

- Lubrication:** Apply a suitable cutting lubricant, such as Hougen Slick-Stik Lubricant, to the cutting area and the cutter itself. Proper lubrication is crucial for extending cutter life and achieving clean cuts.
- Positioning:** Position the drill over the marked center of the hole. The pilot pin should engage the workpiece first.
- Start Drilling:** Turn on the drill. Once the cutter reaches full speed, slowly engage the feed mechanism to bring the cutter into contact with the workpiece.
- Maintain Consistent Feed:** Apply steady, even pressure throughout the cutting process. Avoid excessive force, which can lead to premature wear or breakage. Allow the cutter to do the work.
- Monitor Cutting:** Observe the cutting action. If the cutter binds or the motor strains, reduce the feed rate. Continue to apply lubricant as needed.
- Complete the Cut:** Once the cutter has passed through the material, retract the drill. The slug should be ejected by the pilot pin.
- Power Off:** Turn off the drill and wait for the cutter to come to a complete stop before handling the workpiece or the cutter.

MAINTENANCE

- Cleaning:** After each use, clean the cutter to remove chips, debris, and lubricant residue. Use a brush or compressed air. Ensure the cutter is dry before storage.
- Lubrication:** Always use appropriate cutting lubricant during operation to minimize friction and heat, which prolongs cutter life.
- Inspection:** Regularly inspect the cutting edges for signs of wear, chipping, or dullness. A dull cutter will require more force, generate more heat, and produce poor quality holes.
- Storage:** Store the annular cutter in a dry, protected environment to prevent rust and damage to the cutting edges. Keep it in its original packaging or a dedicated tool case.
- Pilot Pin Care:** Ensure the pilot pin is clean and free of bends or damage. A damaged pilot pin can affect cutting accuracy and slug ejection.

TROUBLESHOOTING

Problem	Possible Cause	Solution
Poor cut quality / Rough holes	Dull or damaged cutter; Insufficient lubrication; Incorrect feed rate; Workpiece not secure.	Replace cutter; Apply more lubricant; Adjust feed rate; Secure workpiece firmly.
Excessive cutter wear / Short tool life	Lack of lubrication; Overheating; Excessive feed pressure; Incorrect material application.	Ensure continuous lubrication; Reduce feed pressure; Allow cutter to cool; Verify cutter is suitable for material.
Cutter binding / Drill stalling	Chips not clearing; Excessive feed pressure; Dull cutter.	Clear chips regularly; Reduce feed pressure; Replace dull cutter.

Problem	Possible Cause	Solution
Slug not ejecting	Damaged or incorrect pilot pin; Chips obstructing.	Check/replace pilot pin; Ensure pilot pin is clean and free to move; Clear chips.

SPECIFICATIONS

Attribute	Detail
Model Number	17128HOU
Cutting Diameter	0.88 Inches (7/8-Inch)
Depth of Cut (D.O.C.)	Up to 3/4-Inch (with Stack Cut geometry)
Material	M42 High Speed Steel (Alloy Steel)
Shank Type	Bayonet (5/8-inch)
Compatible Drill	Hougen HMD115 Ultra-Low Profile Truck Frame Drill
Compatible Pilot Pins	Hougen 17100 or 17101
Item Weight	1.92 ounces
Package Dimensions	9 x 3.6 x 0.6 inches
UPC	662850171288

WARRANTY AND SUPPORT

This Hougen product comes with a **90-day warranty**. For warranty claims, technical support, or further assistance, please contact Hougen customer service or visit the official Hougen brand store.

Official Brand Store: [Visit the Hougen Store on Amazon](#)