

# IMPORTANT INSTRUCTIONS

## For Foredom® Handpiece H.25

**Before attaching this handpiece please read these instructions. They should always be followed to reduce the risk of personal injury or damage to the handpiece.**

**Always use a proper dust collection system or wear a respirator to prevent the inhalation of dust particles, or other debris into the lungs.**

### Repair Service

Factory repairs are done promptly and at reasonable cost. If you wish, you can send your equipment directly to the factory marked "Attention: Repair Department". Be sure include a brief note describing the problem and to give your phone number, email and street address. Estimates will be made upon request.

**Never wear open shoes or sandals. Use footwear that is tough enough to protect your feet from falling tools.**

**Keep both hands and fingers away from the cutting edge at all times.**

**Do not wear loose fitting clothing or jewelry. Loose clothing or jewelry can become entangled in the tool. Do not wear items such as neckties or jewelry when operating power tools. Secure or tie back long hair.**

**Always wear proper eye protection while using this handpiece. Wear safety glasses or a face shield whenever you operate a Foredom Flexible Shaft machine or any power tool to prevent serious eye injury.**

**See your power tool owner's manual for complete instructions on use and maintenance.**

**Use both hands whenever possible to hold and guide the tool.**

**Never use a damaged, bent, vibrating, or out of balance accessory.**

**Avoid knots, imperfections in the wood or metal objects like nails, which could catch or damage the tool bit. Let the speed of the tool do the work.**

**For more information on this handpiece** and other Foredom tools, contact your local dealer. When no local dealer is available, write: **Foredom Electric Co.** 16 Stony Hill Rd, Bethel, CT 06801, call (203) 792-8622, fax (203) 796-7861, or email: customerservice@blackstoneind.com

Form 1226 n 1/16

Printed in U.S.A.

**14,000 RPM is the recommended maximum speed for the H.35 handpiece.**

**The bearings in the H.35 will overheat and may cause damage if you operate your motor at full speed (generally 18,000RPM).**

### Maintenance and Lubrication

**Handpieces:** no lubrication is required. Putting oil or grease into the front or back of these handpieces will damage their pre-lubricated ball bearings. The collet seat and threads of the handpiece should be kept free of dirt, chips, dust or debris. **Flexible Shaft:** Every 50 hours of use the flexible shaft should be checked, wiped clean and relubricated. Unscrew outer sheath connector nut (left hand thread) and remove inner drive shaft. The shaft is threaded through both a silencer spring and the outer sheath. Slide both the outer sheath and the silencer spring off of the flexible shaft. Usually the silencer spring remains inside the sheath when you remove it.

**Every 200 hours** the flexible shaft should be thoroughly cleaned with a solvent. Apply a **light film** of Foredom grease (MS10006) to entire length of inner shaft.

**Reattach outer sheath** and run motor for ten minutes before reconnecting handpiece. Turn off motor, wipe off excess grease from tip of drive shaft and reconnect to handpiece per instructions on reverse. Instructions on reverse.

### To Change an Accessory

**Be sure the shank size of the accessory is paired with the same size collet. Inserting an accessory which is too small or too large may damage the collet.**

Insert the pin provided into the pilot hole and through the spindle hole (turn spindle to align holes). Apply wrench and loosen chuck nut slightly by turning counterclockwise. Insert shank of accessory into collet. Tighten chuck nut with wrench, keeping pin in pilot hole. Test for a secure hold by pulling on accessory. Remove pin.

**Never screw the chuck nut back on too tightly. If you tighten an empty collet or insert an accessory which is too small or too large you may damage the collet.**

### Changing Collets

Foredom offers additional collets for holding burs and other accessories with different shank sizes.

**To Change a Collet** insert pin provided into the pilot hole and through the spindle hole (turn spindle to align holes). Apply wrench and unscrew chuck nut by turning counterclockwise. Remove chuck nut to expose collet and pull collet out of handpiece spindle. Slip new collet in place and screw on chuck nut with pin and wrench.



chuck nut and collet

### Adjust the Shaft and Sheath

It is important to check the sheath and shaft tip and properly adjust them before attaching this handpiece to your Foredom flex shaft tool. The tip of the flexible shaft should extend 3/4" beyond the end of the sheath. This adjustment is made by loosening the set screw in the motor connector and moving the sheath in or out while the motor and shaft/sheath are hanging fully extended or laying on a flat surface. When the shaft is adjusted correctly, tighten the set screw in the motor connector.

**Always make sure your power tool is unplugged during any maintenance procedure.**

### To Attach Handpiece to Flexible Shaft:

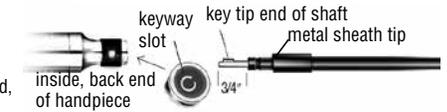
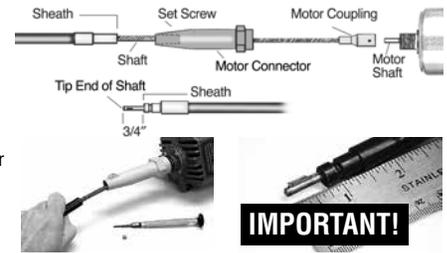
**Before attaching the handpiece, connect the motor to the speed control and plug into power source.**

While holding the black colored metal outer sheath tip facing upward, turn on the control so that the motor is running at about half speed and then turn it off. While the inner key tip is still rotating, grip the handpiece and push it onto the sheath tip with one firm motion until it snaps into place (shown below). This procedure will align the key tip into the keyway slot. To verify this, insert and tighten an accessory into collet, turn on control to a low speed and observe that the accessory rotates smoothly.

For how-to videos go to [www.foredom.net](http://www.foredom.net)

### Handpiece Locking Screw on H.25

The locking screw on the bottom of your handpiece prevents unintended release from the shaft and sheath and keeps the handpiece from rotating on the sheath. Some users prefer to use this handpiece with locking screw removed since it is easier to switch out handpieces.



### To Remove Handpiece from Flexible Shaft:

**First make sure your power tool is unplugged** and then, simply pull the handpiece off the shaft and sheath with a firm grip.



### Handpiece Accessories and Spare Parts

Pins and wrenches that are lost or damaged can be ordered from your dealer or the factory.

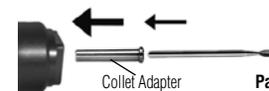
**P/N HP103117**– Pin and Wrench for handpiece H.25

### Collets for H.25

P/N	Nominal Capacity
HP103116	1/16"
HP103115	3/32"
HP103114	1/8" (comes with H.25H)
HP103113	3/16"
HP103112	1/4" (comes with H.25H)
HP103124	3mm
HP103126	4mm
HP103119	6mm

### HP103000 5 Collet Set

includes: 1/16", 3/32", 1/8", 3/16", and 1/4" collets.



### Collet Adapters

(listed at right) let you 'step down' to a smaller shank size accessory.

Part No.	Collet Size	Accessory Shank Size
HPL4-3233	3/32" →	1/16"
HPL4-3234	1/8" →	1/16"
HPL4-3235	3mm →	3/32"
HPL4-3236	1/8" →	3/32"
HPL4-3237	3mm →	1.6mm

### LIMITED WARRANTY

Warranty period is 90 days for handpieces.

Blackstone Industries, LLC d/b/a The Foredom Electric Company warrants, to the original purchaser only, that its products will be free from defects in material or workmanship for the applicable period of time indicated above following the purchase date. During the warranty period, the defective product will be repaired or replaced without charge or, at our sole option, the purchase price will be refunded. This warranty does not cover damage caused in transit or by accident, misuse or ordinary wear.

ALL IMPLIED WARRANTIES INCLUDING, WITHOUT LIMITATION, IMPLIED WARRANTIES OF FITNESS FOR A PARTICULAR PURPOSE AND MERCHANTABILITY, ARE LIMITED IN DURATION TO THE APPLICABLE WARRANTY PERIOD. IN NO EVENT WILL WE BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES. Some states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusion may not apply to you.

At our sole option, repair, replacement or refund will be made if the product is returned postage prepaid to:

**The Foredom Electric Company** 16 Stony Hill Road, Bethel, Connecticut 06801

All warranty repairs must be done at our factory at the above address. We will not pay any shipping or transportation charges. Shafts, sheaths and duplex springs are not covered by this warranty.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.