

**TQC DOLLY DRILL**  
LD9250

MANUAL

**1 SAFETY PRECAUTIONS**

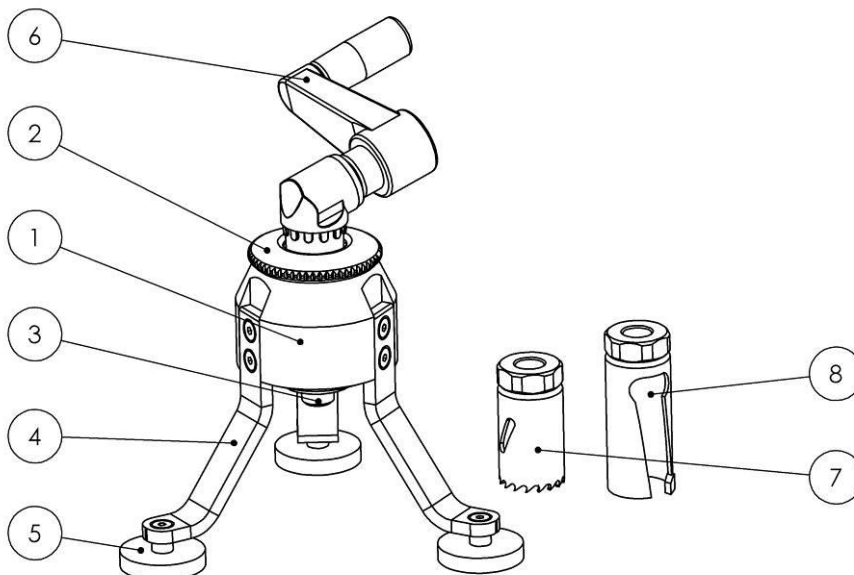
- A dolly drill is a sharp object. Be careful when using it.

**2 PRODUCT DESCRIPTION**

The TQC Dolly Drill is a special by TQC designed instrument to remove residues of glue around the dolly and to cut the coating free by adhesion tests. Disposal by hand of too much glue and cut the coating free from the substrate is a heavy and difficult job especially when inspectors need to perform multi test per day. This can cause painful wrists and arms. The TQC Dolly Drill makes the job significantly easier.

**2.1 Specifications**

Height	15 cm
Feet diameter	aprox. 16 cm Ø with magnets
Drill diameter	20 mm inner (Drill with inner diameters of 10, 14 en 50 mm on request).

**2.2 Details**

1. house
2. adjustment ring
3. chuck
4. base foot
5. tilt able magnetic foot Ø 30mm
6. grip
7. drill Ø 20mm for regular coatings
8. hardmetal drill Ø 20mm for fibre glass coatings

**3 STANDARDS**

ASTM D4541

#### 4 WHAT'S IN THE BOX?

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LDTQC Dolly Drill with 20mm bore hole

#### 5 PERFORM A MEASUREMENT

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1. Be sure before making a test the dolly is well glued and hardened sufficiently.
2. Check if the test surface is stiff and flat enough to make the test.
3. Place the hollow dolly drill over the dolly, the magnets provide a tight adhesion to the metal surface. If necessary the height of the 3 feet can be adjusted. Loosen the double screws of each foot and tighten them on the requested height. When heightened the feet can only be tightened with one screw per foot.
4. A spring loaded mechanism offers enough pressure on the drill.
5. Adjust by rotating the red ring the force needed onto the drill to cut and remove glue and coating around the dolly under test.
6. Lift the dolly drill gently without touching the dolly.
7. Perform the adhesion test with a suitable tester.

**TIP:** For optimum and reproducible results we advise the Adhesion tester PosiTest AT(manual) or AT-A(automatic) with hydraulic and self-aligning, quick-coupling actuator. Both models have a digital display to read where model AT-A has preprogrammed settings to build pressure until breakage point.

#### 6 MAINTENANCE

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- Though robust in design, this instrument is precision-machined. Never drop it or knock it over
- Always clean the instrument after use.
- Clean the instrument using a soft dry cloth. Never clean the instrument by any mechanical means such as a wire brush or abrasive paper. This may cause, just like the use of aggressive cleaning agents, permanent damage.

#### 7 DISCLAIMER

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The right of technical modifications is reserved.

The information given in this manual is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this manual without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Whilst we endeavour to ensure that all advice we give about the product (whether in this manual or otherwise) is correct we have no control over either the quality or condition of the product or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this manual is liable to modification from time to time in the light of experience and our policy of continuous product development.

