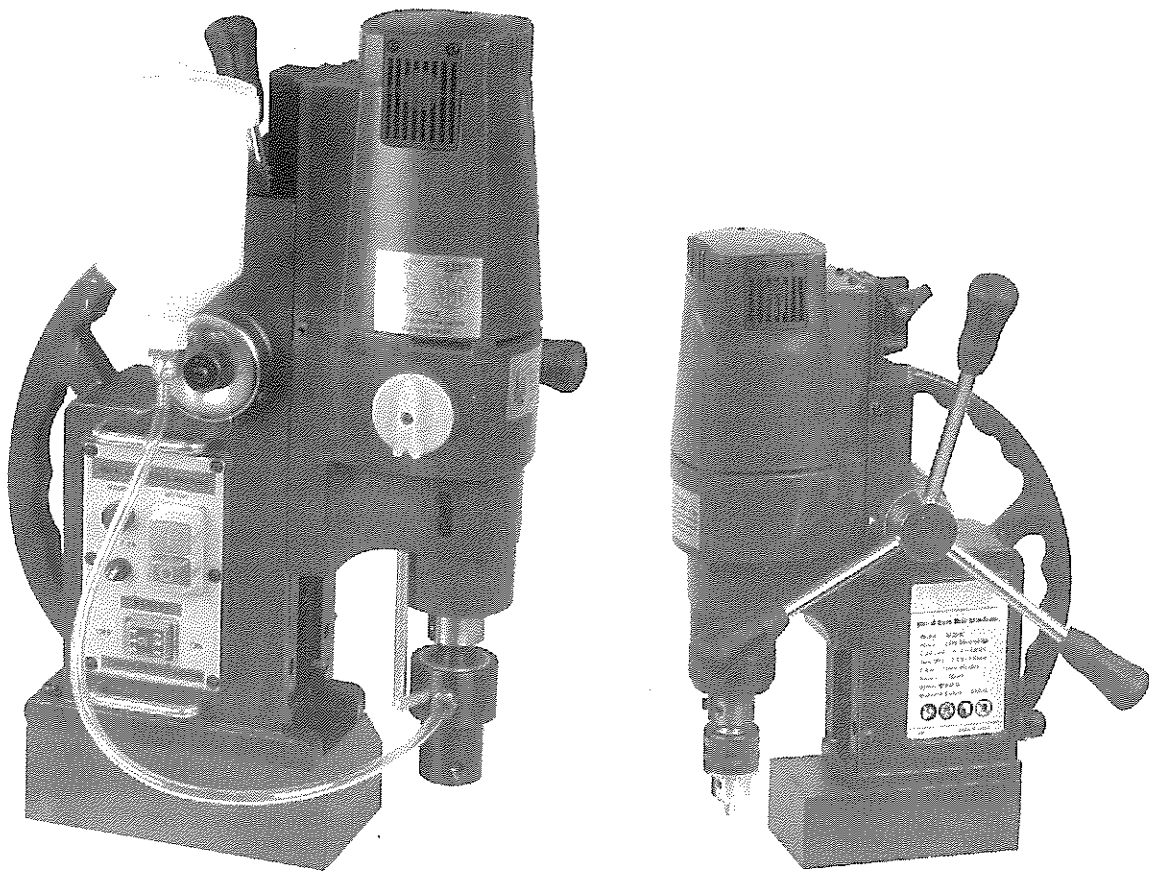


Operator's Manual

Magnetic Drill Machine

MODEL: MCD50 / MCD30 / MCD20



CAUTION: Read and follow all Safety Rules and Operating Instructions before First Use of this Product. Keep this manual with tools.

TABLE OF CONTENTS

Product Specifications	3
Safety	3-5
Accessories and Attachments	6
Carton Contents	6
Operation	7
Maintenance.....	7
Assembly Diagram.....	8

PRODUCT SPECIFICATIONS

Attention: Please choose proper power source, voltage and frequency that are shown in the label for your magnetic drill machine.

Specification	MCD50	MCD30	MCD20
Motor Power	1500 W	1100 W	900W
Magnetic Adhesion	15000 N	11000 N	8500W
Core drill	Φ12-50 mm	Φ12-30 mm	Φ12-20 mm
Core drill tool holder	19mm Weldon shank	19mm Weldon shank	19mm Weldon shank
Twist drill	Φ 32mm	Φ 16mm	Φ 13mm
Stroke	145 mm	125 mm	110mm
Spindle Taper	MT3		
Speed	400/600RPM	450RPM	650RPM
Weight (GW/NW)	41/33 KG	26/19 KG	20/17 KG

SAFETY

WARNING: To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection.

Use a separate electrical circuit for your tools. To avoid shock or fire, replace power cord immediately if it is worn, cut or damaged in any way.

GENERAL SAFETY INSTRUCTIONS

WARNING: To avoid mistakes that could cause serious injury, do not plug the Magnetic core drill machine in until you have read and understood the following:

1. **READ** and become familiar with the entire Operator's Manual. **LEARN** the tool's application, limitations and possible hazards.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from the tool before turning ON.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILDPROOF** with padlocks.
7. **DON'T FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE THE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.
9. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will result in a drop in line voltage and in loss of power that will cause the tool to overheat.
10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry that may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
11. **ALWAYS WEAR EYE PROTECTION.** Any Drill machine can throw foreign objects into the eyes that could cause permanent eye damage. ALWAYS wear Safety Goggles (not glasses). Everyday eyeglasses have only impact-resistance

lenses. They ARE NOT safety glasses.

12. **DISCONNECT TOOLS** before servicing; when changing accessories such as bits, cutters, and the like.
13. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in OFF position before plugging in.
14. **USE RECOMMENDED ACCESSORIES.** Consult the Operator's Manual for recommended accessories. The use of improper accessories may cause serious injury.
15. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
16. **CHECK FOR DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER "OFF".** Don't leave tool until it comes to a complete stop.
18. **DON'T OVERREACH.** Keep proper footing and balance at all times.
19. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
20. **DO NOT** use power tools in the presence of flammable liquids or gases.

SPECIFIC SAFETY INSTRUCTIONS FOR THE MAGNETIC DRILL MACHINE

1. **SECURE** the magnetic drill machine with the tension chain before starting work.
2. **MAKE SURE** the magnet has caught up the workpiece before drilling.
3. **USE** cooling medium when necessary.
4. **ALWAYS** keep hands out of the path of a drill bit. Avoid awkward hand positions where a sudden slip could cause your hand to move into the drill bit.
5. **USE THE RECOMMENDED SPEED** for any drill press accessory and for different work piece material.
6. **TO AVOID INJURY:** Use only accessories recommended for this machine..

ELECTRICAL REQUIREMENTS

POWER SUPPLY AND MOTOR SPECIFICATIONS

WARNING: To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tools. To avoid shock or fire, if power cord is worn or cut, or damaged in any way, have it replaced immediately.

GROUNDING INSTRUCTIONS

WARNING: This tool must be grounded while in use to protect the operator from electrical shock.

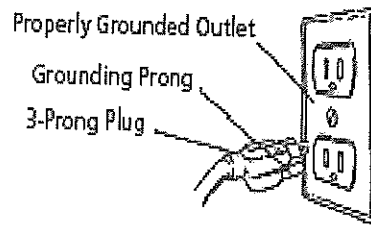
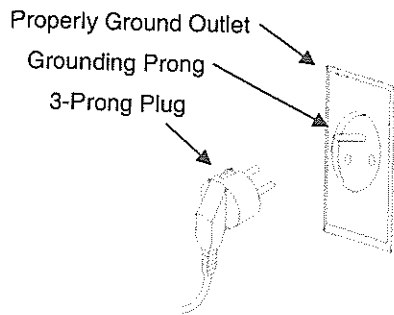
IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides a path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching receptacle that is properly installed and grounded in accordance with ALL local codes and ordinances.

DO NOT MODIFY THE PLUG PROVIDED. If it will not fit the receptacle, have the proper receptacle installed by a qualified electrician.

IMPROPER CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with green insulation (with or without yellow stripes) is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment-grounding conductor to a live terminal.

CHECK with a qualified electrician or service person if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

Refer to nether picture:



WARNING: Improper connection of equipment grounding conductor can result in the risk of electrical shock. equipment should be grounded while in use to protect operator from electrical shock.

-Check with a qualified electrician if you do not understand grounding instructions or if you are in doubt as to whether the tool is properly grounded.

-This tool is equipped with an approved cord and a 3-prong grounding type plug for you protection against shock hazards.

-Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown.

-Do not remove or alter grounding prong in any manner. in the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

WARNING: This machine is for indoor use only. Do not expose to rain or use in damp locations.

GUIDELINES FOR EXTENSION CORDS

USE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and cause overheating.

Be sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

ACCESSORIES AND ATTACHMENTS

RECOMMENDED ACCESSORIES

WARNING: To avoid injury:

- Use only accessories recommended for this magnetic drill machine.
- Follow instructions that accompany accessories. Use of improper accessories may cause hazards.
- Use only accessories designed for this magnetic drill machine to avoid injury from thrown broken parts or work pieces.
- Do not use any accessory unless you have completely read the instruction or operator's manual for that accessory.

CARTON CONTENTS

UNPACKING AND CHECKING CONTENTS

Carefully unpack the magnetic drill machine and all its parts, and compare against the illustration following.

WARNING:

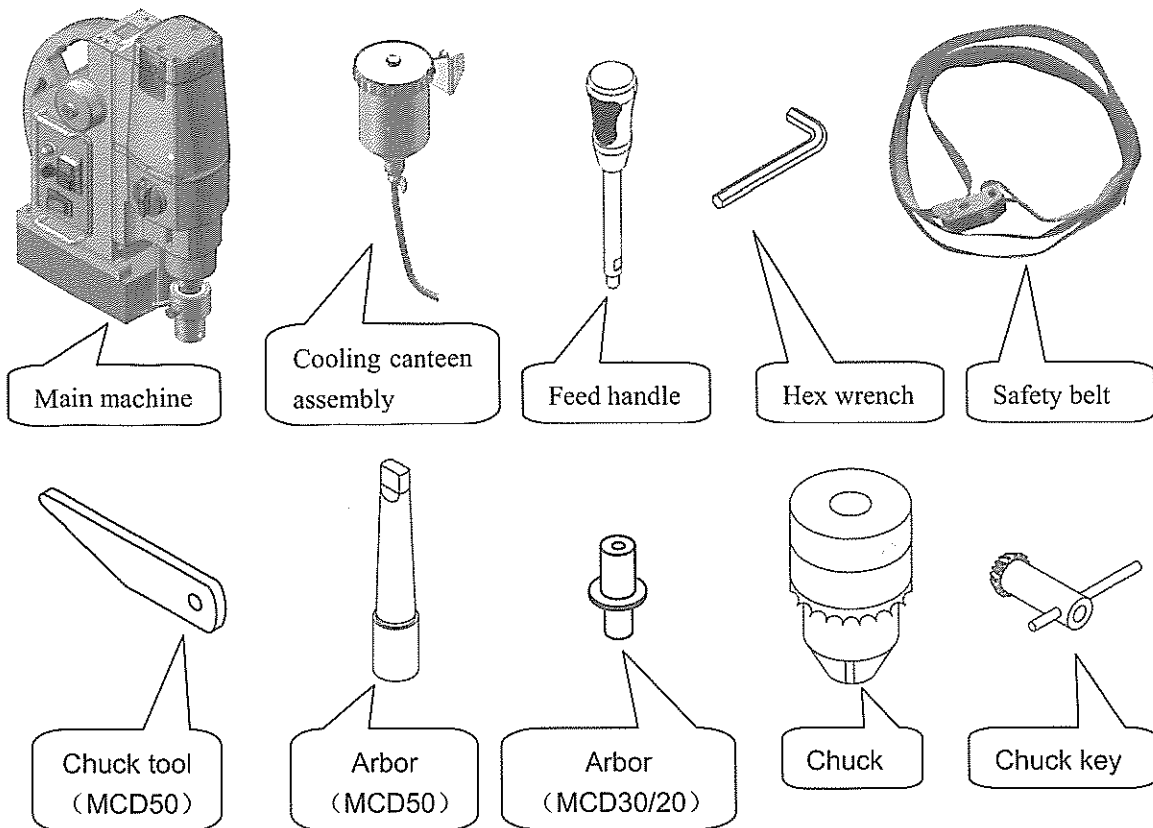
- To avoid injury from unexpected starting, do not plug the power cord into a power source receptacle during unpacking and assembly. This cord must remain unplugged whenever you are assembling or adjusting the magnetic drill machine.
- If any part is missing or damaged, do not plug the magnetic core drilling machine in until the missing or damaged part is replaced, and assembly is complete.

TABLE OF LOOSE PARTS

Unpack carton; check you machine to see parts listed below:

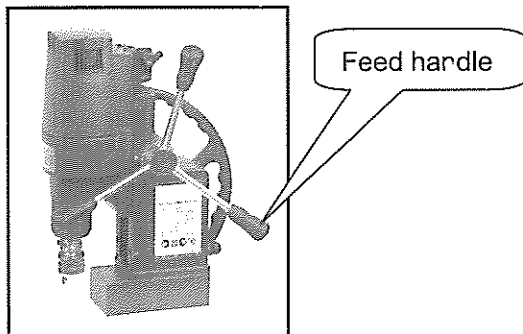
MCD50		MCD30		MCD20	
Main machine	1	Main machine	1	Main machine	1
Cooling canteen	1	Cooling canteen	1	Cooling canteen	1
Feed handle	3	Feed handle	3	Feed handle	3
Hex wrench	3	Hex wrench	3	Hex wrench	3
Chuck tool	1				
Arbor (*)	1	Arbor	1	Arbor	1
Chuck (*)	1	Chuck	1	Chuck	1
Chuck key (*)	1	Chuck key	1	Chuck key	1
Safety belt	1	Safety belt	1	Safety belt	1
Manual	1	Manual	1	Manual	1

(*) Alternative parts. Your machine possibly has not these pars.



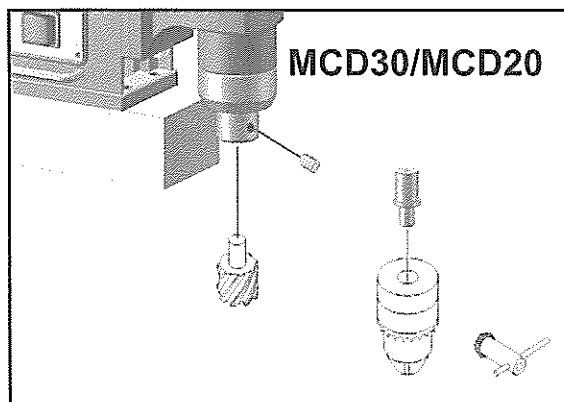
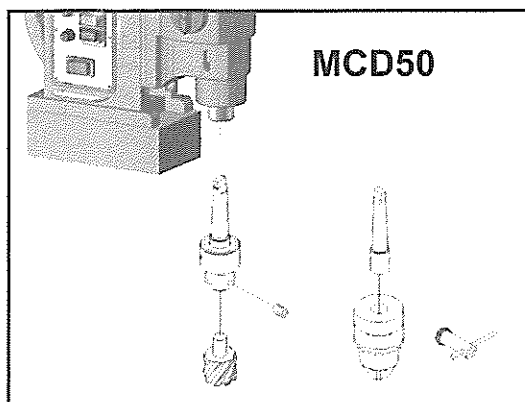
OPERATIONS

1. Assemble the feed handle to main machine



2. Installing tool

With the switch "OFF", Install a core drill bit or a twist drill bit just like following fig



Warning: To avoid injury or accident by the chuck key or Hex Wrench ejecting forcibly from the chuck when the power is turned ON, always recheck and remove the chuck key before turning the power ON.

3. Positioning the magnetic drill machine

Put the magnetic drill machine on the work piece and make the drill bit to the working center position.

If your machine is provided rotor plate, You can easily set the drill center position by adjusting the rotor plate and retightening the handle.

Fasten the safety belt to connect the machine and work piece.

4. Speed adjusting

Choose the proper speed by the drill bit diameter and material of Work piece.

Caution: This function is only provided by MCD50.

5. Operate the machine

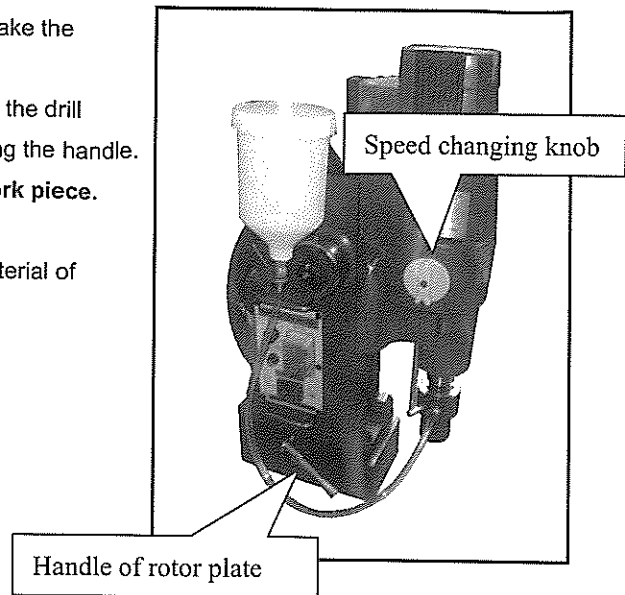
Insert the plug in a socket of power supply.

Set the magnet switch on

Turn on the motor switch

Hold the feed handle and drill hole slowly.

USE cooling medium when necessary.



MAINTENANCE

Warning! Before inspection and maintenance disconnect the plug from the power supply.

● FREQUENT INSPECTION

The magnetic drill should be inspected frequently. Whether the cord, in-lead, plug or switch is in good condition. Whether there is any damage on the drive part.

● LUBRICATION

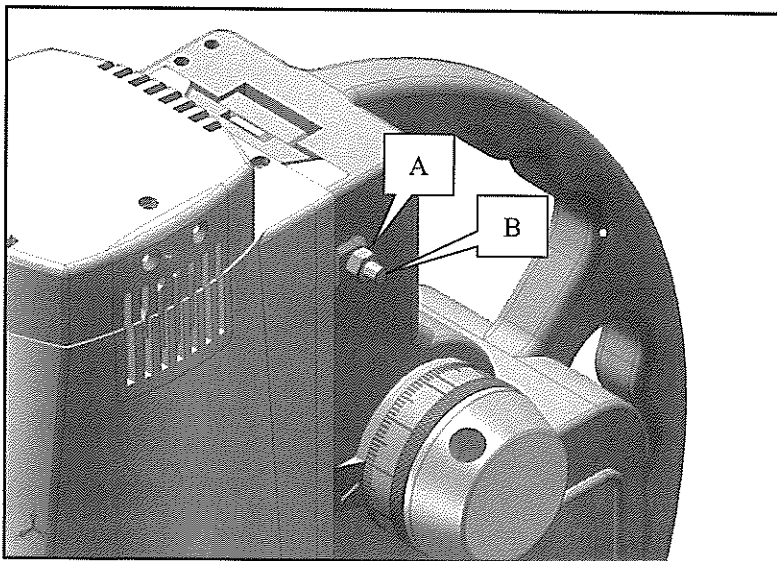
For lubricating the body and pinion that moves the slid plate up and down, a few drops of oil should be applied occasionally to the rack, and keep them clean.

● KEEP IN STORAGE

The magnetic drill should be kept at dry clean and non-corrosive environment.

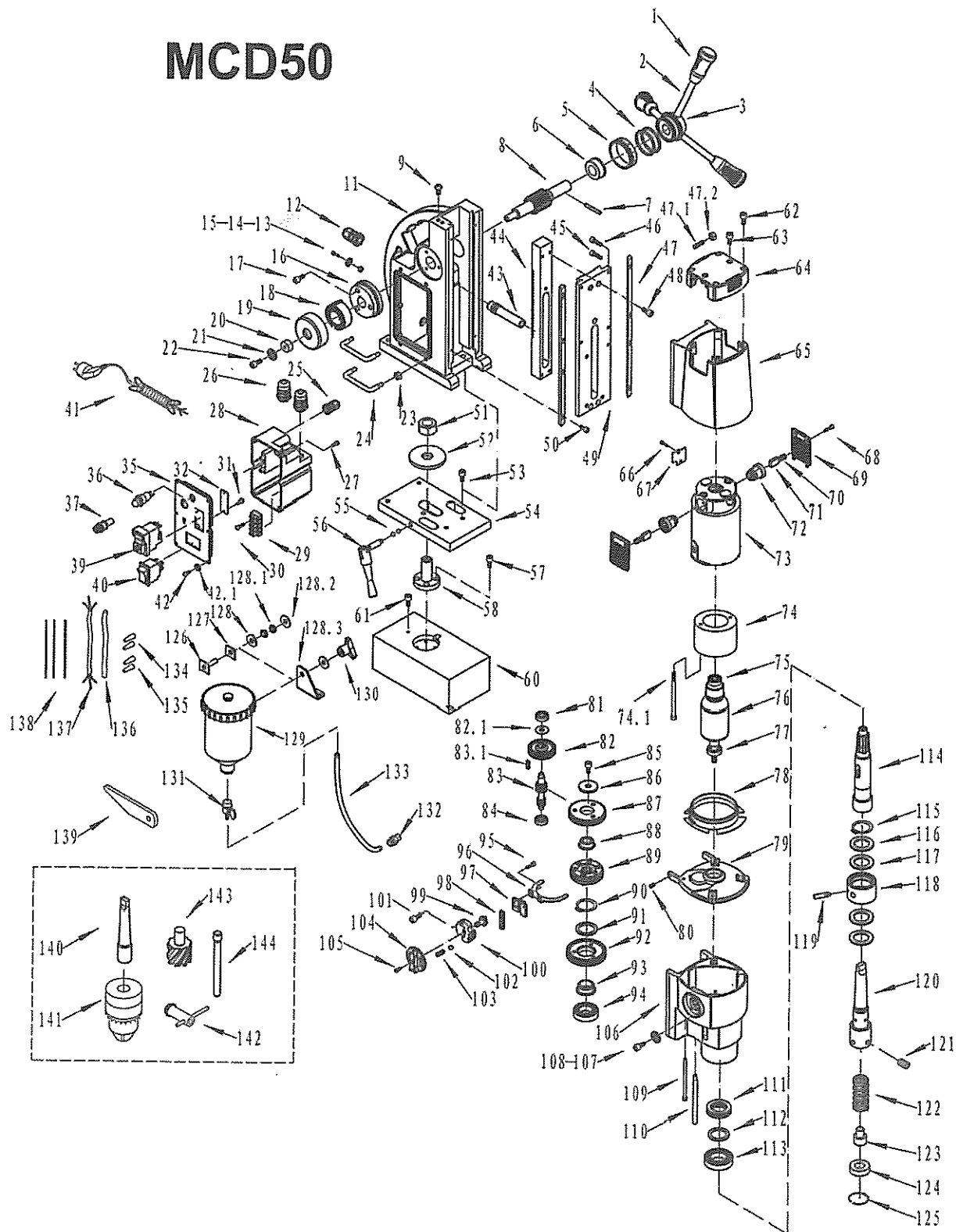
● Adjust the clearance of guide rail

Loosen the hex nuts (A), Adjust the set screws (B) to get the proper clearance of guide rail and retighten the hex nuts.

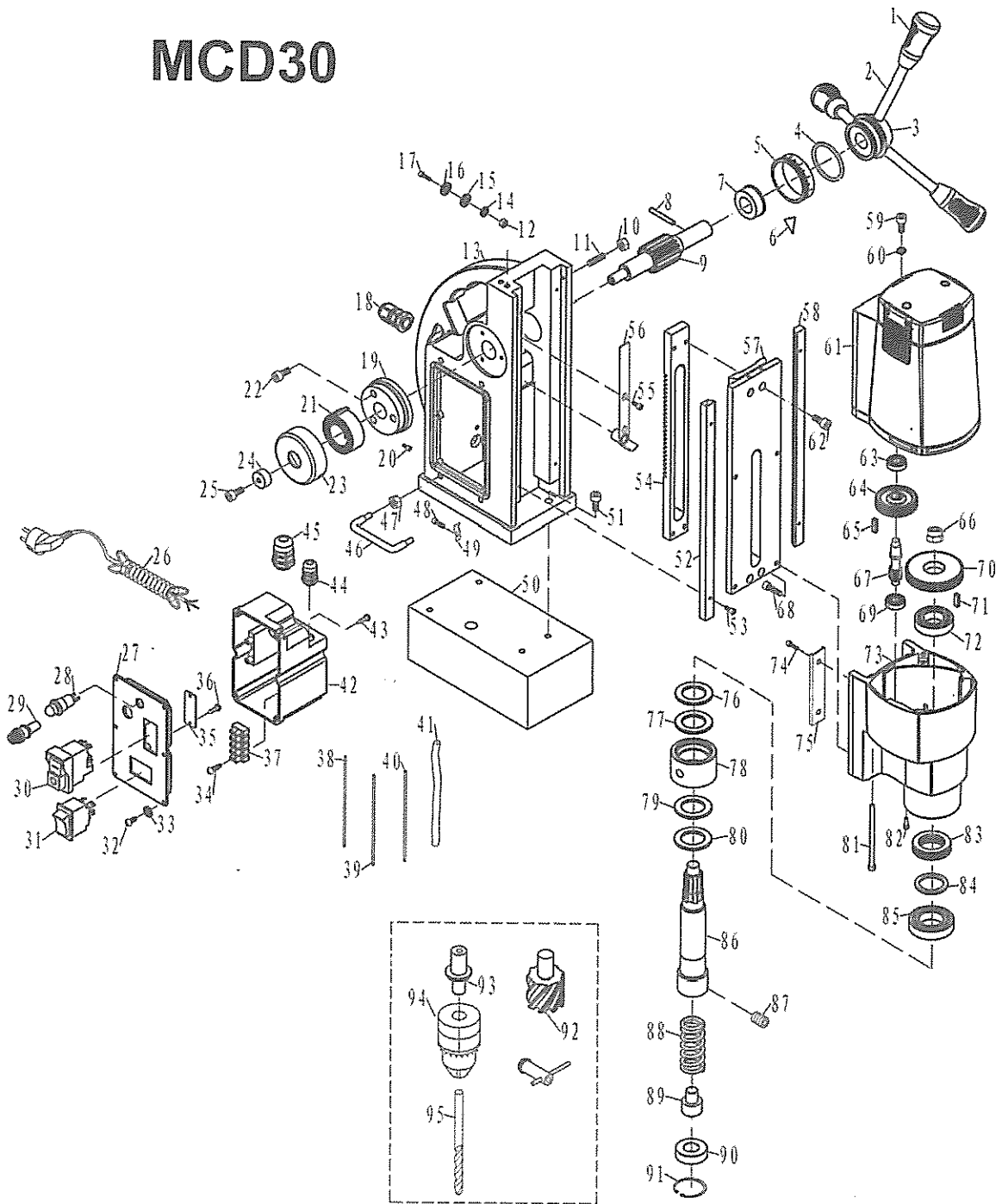


ASSEMBLY DIAGRAM

MCD50



MCD30



MCD20

