

OPERATING INSTRUCTION -20

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Operation Manual

WARNING

To prevent electric shock or fire, please strictly abide by the procedures in the operation manual.

The machine only for the authorized persons, please do not let other people to operate. If any violation of the instructions operation and cause personal injury or machine damage, our company disclaim all responsibility.

The machine can be only maintained by the people who has the certification.

THANKS TO THE BUYER

Thanks for buying the series of magnetic drill machine of . Please read the operation manual and pay attention to the safety precaution.

The right operation, will make you fully feel our products superior performance.

Please put this manual in a safe place for future reference.

ABOUT THIS MANUAL

The machine model of the description in this manual:

KCY: 28DM 38DM 55DM Mini models of horizontal magnetic drill

Confirm the machine model according to the nameplate.



DESCRIPTIONS OF PRODUCTS

Magnetic drill is a kind of electric tool for adhering and drilling on the horizontal level, side face and top face, and widely used in the building, bridge building, and ship building industries and so on. You can use the magnetic drill when you can not use drill press and electric hand drill to drill huge steel workpieces or in field operation. It's very convenient to use, flexible, can reduce labor intensity, improve the machining precision and work efficiency.

CAUTIONS





1. Please read the manual carefully before use, to understand the magnetic base drill structure; electromagnetic sucker, electric drill and transmission functions.
2. Before installing or remove the drill must confirm the motor switch is closed and unplug.
3. Four hours of uninterrupted operation of the machine will cause the machine to fire, four hours of uninterrupted operation of the disk will lead to high temperature. High temperature may cause fire. Do not touch the disk when the disk is hot, touch the disk will cause serious burns. No stop using disk for more than four hours. When you do not use the machine, you should turn off the switch and unplug the power switch.
4. And its operation must be put in the fuselage behind the cable, away from the drill bit
5. In the switching power supply, electric and magnetic switch must be in the off position
6. Drilling machine must be used when using engine coolant. The use of cooling liquid (soap) according to the ratio of watered, absolutely can not direct use water cooling. Otherwise very easy to damage, and the main internal rust on the drill bit can't get it out. No internal machine water, otherwise it will burn the circuit board.
7. Always keep the disk surface clean. Always keep the surface of the processed parts clean. If there is any foreign body in the middle of the disk and the processed parts, which will weaken the magnetic force, will result in the operation of the machine in the process of shaking. Will lead to accidents, keep all the surface clean and free of rust, small wood or other things.
8. The use of magnetic base drill, must wear a seat belt buckle.
9. No rough operation personnel, feed can not handle in order to work fast and pressed down the machine feed, so lossy bit and machine
10. Non-magnetic materials can not drill with magnetic base, if the non-magnetic material punching need to choose the magnetic base drill with sucker.
11. Cannot use at the same time, electric welding machine and magnetic base drill on the same piece of steel plate, so that the operating from electric shock danger.

ELECTRICAL SAFETY

Tool before connecting power, using the socket must be able to fit the plug machine. The 380V model to determine the fire and. Line the correct docking, power supply socket with the need of professionals to complete. Do not arbitrarily change the plug, adapter plugs can't pick. The electric tool wire used together.

SAFETY INSTRUCTIONS

Warning labels and/or other labels on the machine must be replaced when they were removed.

	<p>Do not operate the machine at insufficient lighting conditions. Do not operate the machine outdoors. Do not operate the machine when you are tired, when your concentration is impaired, and/ or under the influence of drugs, medication or alcohol.</p>
	<p>Climbing onto the machine is forbidden! Heavy injuries by falling down or by tilting of the machine are possible.</p>
	<p>The machine shall be used only by trained persons. Non authorized persons, especially children, shall be kept away from the work area.</p>
	<p>Do not wear loose clothing, long hair openly or loose jewellery like neck-laces etc. when operating the machine They might be caught by rotating parts and cause serious injuries.</p>



Use proper safety clothing and devices when operating the machine (, safety goggles, ear protectors, safety shoes ...)! Do not wear safety gloves for oper-ating because they decrease the working accuracy and they might be pulled into the saw blade.



Before any maintenance you have to disconnect the panel saw from the power source. Never use the plugged cable for transporting or manipulating the machine.

INSTRUCTIONS

1. Plug the power plug, the drill bit aim at processing position, make the magnetic switch is opened, so that the magnetic is adsorbed on the surface of steel plate magnetic materials. No impurities on the surface, and check whether the attractive force is normal or not. (general plate thickness should be more than 10mm)
2. Please placed the magnetic base drill required from the drilling near site and select the appropriate adsorption material. And will handle hole safety rope penetrates into the frame, the other one is in fastening frame after the penetration of the buckle, and then close the safety rope buckle. Hand and pull off, should not loose and mobile.
3. For a support screw, regulating the support screw that the bottom touches the workpiece surface.
4. For the magnetic base is provided with the angle of the drill, the use of angle wrench movement angle disk in the annex to the belt rack makes bit central alignment processing position, tighten the angle wrench.
5. Open the electric drill switch, check whether the drill bit beat, sound is normal, if everything is normal can turn the handle to feed.
6. Start feeding should be slow, gives the quantity of about 0.05mm/r in general, not too much force, to prevent overload.
7. If the drill suddenly stopped, you must turn off the power switch immediately, (Must close the magnetic control switch)
8. Please shut down for a period of time machine in continuous use for 2-3 hours, in case magnetic base is overheated and leakage or burned.
9. Should be filled with cooling water or cooling liquid using hollow drill, turn on the tap, and let it flow out slowly.

10. The company factory hollow drill are equipped with cooling kettle, please put the kettle arranged on the corresponding position before operating the machine, and tighten the two round head screw. The kettle is connected after please figure two (035), fittings is screwed on the hydrosphere, tighten the end can be on the frame by.

GROUNDING DEVICE

This tool should be properly grounded, in order to avoid the shock. Grounding device should have the lead standard, and a grounding plug with earthing special line. Do not be ground false joint in the line of fire or three-phase line. Grounded power receptacle should be connected with the earthing device is connected to the eternal, so that it can work with yellow green wire connected to the plug hole and connection piece at the same time and ground connection.

QUALITY ASSURANCE

Consumers buy our machines produced within twelve months, enjoy free maintenance and warranty service. During normal use of the whole or parts of any manufacturing process or product failures caused by components, please present the original invoice, the dealer stamped and filled properly warranty certificate to the Company or the Company's designated repair station to receive free services. machine consumable normal wear and tear, overload, do not operate according to operating specifications, disassemble, damage caused as a result of use of parts other than the Company and damage, are not covered by warranty. warranty expires, provided by the designated repair station maintenance service. maintenance records must be sealed or signed by the repair station to take effect.

FAULT HANDING

FAULTS	CAUSES	ELIMINATION METHODS
Magnetic base without suction	Switch contact undesirable	Repair the switch
	Power supply is broken	Repair the power supply
	The fuse burn out	Replace the Fuses
	Electromagnet short circuit or burn out	Repair or replace the magnetic bridge
	Adsorption not on the steel frame	Change the adsorption surface
Machine did not run after the jump	Switch contact undesirable	Repair and change switch
	Joint loose	Check the electric drill part connector
	Brush and commutator poor contact	Repair or replace the electric brush
	Drill the armature or stator coil burn out	Changing the armature or stator
Magnetic little suction	Adsorption artifacts thin	Replace the adsorption surface or thickening adsorption surface (> 10mm steel sheet)
	Adsorption on the surface is small	Replace the adsorption surface or temporary welding thick surface adsorption
	Support bar between the adsorption surface	Support bar top tight
	Diode may be virtual welding	Re Welding
Turn the handle guide does not work	Shaft key cut	Replace the shaft key
	Wheel and rack misplace	Unscrew the rack bottom screw, remove guide to repair
Drill out the elliptical hole	For a drill and a fastener is loose	Correction of verticality tighten the fasteners
	Bit unilateral cutting	Grind anew
	Adsorption surface have sundry	Eliminate clutter
Spindle shake	Frame adjusting screw loose	Tighten adjusting screws
Electric ignition	The spark turns orange.	Slow down.
	Sparks flying out.	Change the brush, please.
	Sparks into a ring of fire	Please check if the motor is burned.

Warning: magnetic drill equipped with a safety rope, when operating, make sure the magnetic drill and the object is fastened by the rope. In case of power failure suddenly, causing the machine fall off or thrown objects and cause accidents.

MACHINE MODEL PARAMETER LIST

Specifications		KCY-28DM	KCY-38DM	KCY-55DM
Core Cutter	mm	28	38	55
Voltage	v	110/220~	110/220~	110/220~
Magnetic Adhesion	N	13500	14500	15500
Input	w	1400	1650	1900
No-load speed	rpm	690	670	640

Attention: Our company does not assume any responsibility because the machine is not solid or fixed safety facilities are not in appropriate place cause accident.



NO.	Parts name	QTY	NO.	Parts name	QTY
1	Neka 19	1	54	Marketing 12 * 8 * 7	1
2	PU gasket B	1	55	Spindle WS-28	1
3	Top WS	1	56	Bearing 6005	1
4	Stainless steel gasket 2 #	1	57	Reverse Silk WS-28	1
5	Spring WS	1	58	Round head cross self-propelled screw	2
6	Hegonal top silk M10 * 10	2	59	Stator KCY-38DM	1
7	Spindle WS-28	1	60	Bearing 608	1
8	Cross level screw M3 * 8	4	61	Bearing sleeve WS-28	1
9	O-ring φ 6 * 2	1	62	Parameter WS(60.3 * 29.5)	1
10	Bearing gear WS-28	1	63	Brand 40-80	1
11	Bearing 6805	1	64	Stator shell 40	1
12	Wild card 26	1	65	Brush frame 40 copper	2
13	Hegonal screw M5 * 16	2	66	Bypass 19/40	2
14	Clamp WS-28	1	67	Carbon Brush 40	2
15	Elevator WS-28	2	68	Round Head Cross Screw	2
16	Hegonal screw M5 * 16	2	69	Round Head Cross Screw	4
17	Copper joint WS-28	1	70	Round head cross self-propelled screw	2
18	Water injection rod WS-28	1	71	Lock connector M12 * 1.5	1
19	O-ring φ 6 * 2	1	72	Round head cross self-propelled screw	2
20	Water connection WS-28	1	73	Top 40	1
21	Horizontal 15 * 6	1	74	Power cord 3 * 1.0 * 2.5 M	1
22	Hegonal screw M5 * 25	2	75	Card 8	1
23	Hand WS-28	1	76	PE tube AD10 * 80	1
24	Gear Box WS-28	1	77	Card 8	1
25	Moontooth pin 9 * 3 * 4	1	78	Card 8	1
26	I tooth shaft WS-35-3	1	79	Card 8	1
27	Bearing 6001	1	80	Hose AD10 * 80	1
28	Triangle Iron WS-28	1	81	Round head cross self-propelled screw	4
29	Cross level screw M4 * 8	3	82	Switch KCD5	1
30	Card 12	1	83	Switch KCD1	1
31	Class I gear WS-1(8)	1	84	Button panel WS(70.6 * 40.6)	1
32	Card 8	1	85	Rectifier Bridge KBJ4109	1
33	Roller bearings 9 * 13 * 10	1	86	Hegonal screw M5 * 10	2
34	Round head self-propelled screw	4	87	Switch Box WS-28	1
35	Cylinder pin 5 * 15	2	88	Magnetic disk WS-156 * 80 * 40	1
36	Middle cover WS-28	1			
37	O-ring φ 28 * 1.8	1			
38	Bearing 6001	1			
39	Hegonal screw M6 * 25	4			
40	Rotor KCY-38DM	1			
41	Windscreen 40	1			
42	Hegonal screw M4 * 12	4			
43	Sleeve cover WS-28	2			
44	Set WS-28	2			
45	Volume 5 * 22	2			
46	Card 12	2			
47	Lift gear WS-28	2			
48	Marketing 4 * 10	2			
49	Composite Bearing WS-28	2			
50	Horizontal WS-28	1			
51	Powder Metallurgy Suite WS-28	2			
52	Bearing 6905	1			
53	Spindle gear WS-35-2	1			

