

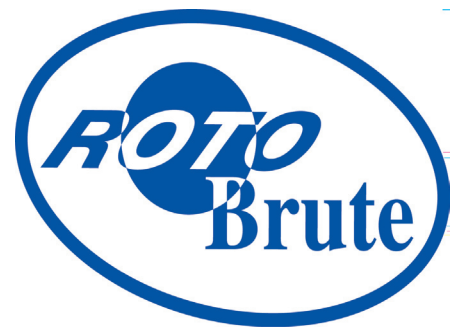


For over a hundred years, Champion Cutting Tool Corp. has pioneered the development of innovative products for the professional contractor, machinist, steel fabricator and builder.

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Portable Magnetic Drill Press

Model AC35

User Guide



- 1-3/8" Cutter Capacity
 - 1200 Watt Motor
 - 110 / 115v



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Operating Instructions

IMPORTANT

Please read these operating and safety instructions carefully and completely. For your own safety, before using this equipment check that the voltage is correct and that all handles and parts are firmly secured. If you are uncertain about any aspect of using this equipment, contact your distributor.

PLEASE KEEP THESE INSTRUCTIONS

Model AC35 Specifications

Motor (115v 50/60 Hz) (Watts):	1200
Amp	8
Maximum Cutter Diameter (inch):	1-3/8"
Maximum Cutting Depth (inch):	2"
No Load Speed (RPM):	600
Sound Power Level (Under Load) (dB (A)):	90
Net Weight (lb):	23
Magnet Dimensions (in):	H 1-7/8" x W 3-5/32" D 6-5/16"
Magnetic Adhesion (lbs):	2200
Arbor Internal Diameter:	3/4" weldon style

Contents: 1 Coolant Tank, 1 Coolant Tube, 1 Safety Guard, 1 Hex key 4mm, 1 Hex key 2.5mm, 1 Wrench 8mm, 3 Handles, 2 Butterfly Screws, 2 Spring Washers, 1 Safety Chain, Plastic Carrying Case.



Ear and eye protection MUST be worn during operating of this equipment. Do NOT touch the cutter while it is in motion. Always follow the Personal Protection Equipment (PPE) recommendations while operating this tool.

This machine is designed specifically for drilling holes in steel using annular cutters or with twist drills when using the optional drill chuck. We recommend Champion® Rotobrutus™ annular cutters. Please consult your Champion authorized distributor for a complete range of sizes. DO NOT modify and / or use your Rotobrutus™ Magnetic Drill Press for any application other than, for which it is intended.

Always ensure that the total work area can be viewed from the operating position. Do not operate the drill press in explosive environments – power tools create sparks that may ignite flammable materials or gases. Do not operate the drill press in damp or wet conditions, as electric shocks may result. Always use both hands to operate the drill press. Be careful to ensure that the material you are working on is securely clamped.

- This drill press is equipped with an approved grounded cord and plug for its use.
- Unplug the drill press from the electrical connection before replacement of the cutter, making adjustments or other maintenance work.
- We recommend the use of genuine RotoBrute™ annular cutters
- Inspect the machine and cutter before each use and do not use worn or damaged cutters.
- Ensure the cutter is correctly mounted and do not stop by hand.
- Always keep the power cord away from moving parts of the drill press and cutter.
- Never use the tool without the safety guard in place.

Mounting Annular Cutters Using The Quick-Release Arbor:

All AC35 machines come equipped with a quick-change arbor. The quick-change arbor allows users to install cutters and twist drills in seconds. First, insert the pilot pin into the cutter. Then, rotate the knurled collar to the left (clockwise when viewed from above) and insert the cutter. Ensure that the cutter is engaged on its flat in the tool holder. Then rotate the knurled collar to the right by hand to fully tighten. No tools are needed.

Magnetic Drill Safety

The drill's magnetic adhesion depends on the thickness of the work-piece. 1/2" (13mm) is the minimum thickness for safe operation. Keep the magnet clean of metal chips and other dirt and debris. These will seriously reduce the magnetic adhesion. Ensure that the magnet has adhered to the work-piece firmly before switching on the drill. The drill must be operated on its own electrical outlet. Always use the supplied safety strap or chain. An electrical overload can result in loss of adhesion. Check that the coolant level to be is sufficient for use. Never operate without cutting fluid.

Adjusting Dovetail Slides

Slowly adjust the hex screws while moving the handle up and down. Adjust so there is no free play or no binding anywhere through its range of travel. Periodically check, lubricate, and adjust as necessary.

Recommended Operating Procedures

1. Position the machine using the pilot pin as an aid in locating the center of the cut.
2. Switch on the magnet and check that the cutter is in the correct position and the machine is securely held to the work-piece.
3. With the motor head in the raised position, switch on the motor.
4. Turn the traverse handles to begin cutting. Use light pressure at first to keep cutter from wandering, and then continue with normal pressure. Do not force the tool. Let the speed of the cutter do the work. Cutting performance will not improve by applying more pressure on the tool, as cutter and motor life will be reduced.
5. Adjusting the coolant feed tap regulates the flow of cutting oil (#43).
6. Use less pressure as the cutter exits through the material. Always provide a method of catching the slug, as the ejected slug may cause injury.

CAUTION: The slug ejects at end of cut and is **very hot**.

- *Note: Always lock the slide lock (on the side of the machine) in the fully raised position when at rest to prevent the slide from accidentally falling down; remember to unlock it again before commencing drilling.*

WARNING: Do **not** attempt to drill a work-piece, which is thicker than the maximum cutting depth of the cutter being used. **Never** exceed 1-3/8" (35mm) cutter diameter.

Maintenance and Troubleshooting

Keep the drill press and the cord clean. In case of electrical or mechanical malfunction, immediately switch off the tool and disconnect the plug. Excessive sparking generally indicates the presence of dirt in the motor or worn out carbon brushes. Periodically check brushes for wear and replace when they reach 1/4" (6mm). Also check that the machine is well lubricated. For all other service and maintenance, please contact a Champion® authorized service center.