



AC50

MAGNETIC DRILL PRESS USER GUIDE



SAFETY / USAGE GUIDELINES



PARTS & SCHEMATICS



CHAMPION
CUTTING TOOL CORP



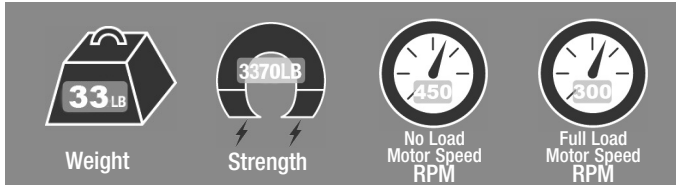
AC50

COMPONENTS & SAFETY

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



INCLUDED WITH EVERY AC50

1 Coolant Tank Kit, 1 Chip Guard Kit, 1 Hex key 4mm, 1 Hex key 2.5mm, 1 Wrench 8mm, 3 Handles, 1 Safety Chain & 1 Plastic Carrying Case

Ear and eye protection MUST be worn during operation 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® Rotobrute annular cutters. Please consult your Champion authorized distributor for a complete range of sizes.

Do not modify or use your RotoBrute magnetic drill press for any application other than drilling, reaming, or cutting holes. Always use safety strap or chain when operating your AC50 magnetic drill.

SAFETY

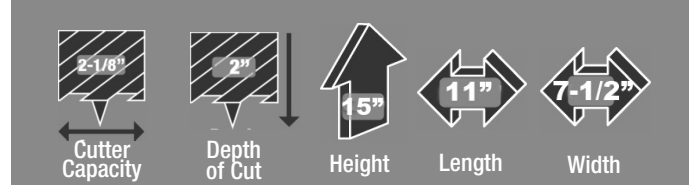
Be sure to read and follow these important safety instructions:

When using your AC50 drill press, be sure to follow these important safety precautions:

1. Before operating the machine, check supply voltage and general conditions, i.e. cable/cord damage. A machine with a damaged cable must be repaired prior to use.
2. Always use safety strap or chain in all drilling applications.
4. Since cutting tools can shatter, eye and head protection should be worn at all times.
5. After use, clean machine and cutters and keep in the case provided.
6. Store when not in use, in a dry environment.
7. Always provide a method of catching slug, where the ejected slug may cause injury (slug ejects at end of cut).
8. Should the cutter jam in the work-piece, stop the machine immediately. Isolate the machine at the main supply. Loosen the cutter by rotating the arbor. Do not attempt to free cutter by starting and stopping the motor.
9. Always use the safety guard provided.

Electrical Safety

1. Grounded tools must be plugged into an outlet properly installed and grounded in accordance with all codes and ordinances. Never remove the grounding prong or modify the plug in any way.
2. Do not use any adapter plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. If the tools should electrically malfunction or break-down, grounding provides a low resistance path to carry electricity away from the user.
3. Never use the cord to carry the tools or pull the plug from an outlet. Replace damaged cords immediately.
4. When operating a power tool outside, use an outdoor extension cord marked "W-A" or "W". These cords are rated for outdoor use and reduce the risk of electric shock. Minimal gauge external cord should be 12/3.
5. Use the AC50 with 110 A/C voltage only. Not for use with generators, welders or any DC power source. Do not use on any surface where welding is taking place.



Personal Safety

Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol, or medication.

Do not wear loose clothing or jewelry. Avoid accidental starting. Be sure switch is off before plugging in. Carrying tools with your finger on the switch or plugging in tools that have the switch on invites accidents.

Remove adjusting keys before turning the tool on.

Do not overreach. Keep proper footing and balance at all times.

Safety equipment (eye protection, dust mask, nonskid safety shoes, hard hat, hearing protection) should be used for appropriate conditions.

Tool Use and Care

Use clamps or other practical ways to secure and support the work-piece to a stable platform.

Do not force tool. Use the correct tool for the application.

Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool.

Store idle tools out of reach of children and other untrained persons.

Maintain tools with care. Keep cutting tools sharp and clean.

Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the tool's operation. If damaged, have the tool serviced before using.

Service

Tool service must be performed only by qualified personnel.

When servicing a tool, use only original replacement parts.

Use of unauthorized parts will void the warranty.

Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electric shock or injury.

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. 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.

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

WARNING: Do not attempt to drill a work-piece, which is thicker than the maximum cutting depth of the cutter being used. Never exceed 2-1/8" 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.

IMPORTANT

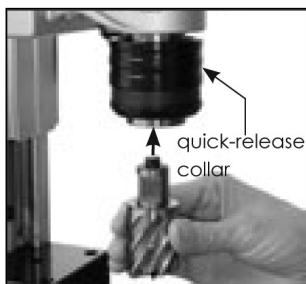
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Using Annular Cutters

No tools are needed to mount annular cutters to the AC50. Mounting annular cutters using the quick-change arbor:

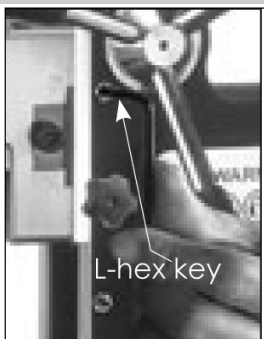
1. All AC50 machines come equipped with a quick-change arbor. The quick-change arbor allows users to install cutters and twist drills in seconds.
2. First, insert the pilot pin into the cutter.
3. Push up on the quick change collar.
4. Insert the annular cutter with pilot pin and turn until the flat meets the locking pin
5. When the flat meets the locking pin, the collar will snap down
6. Double check that the collar is down and the cutter is fully locked before operating the mag drill



Caution: Never use a cutting tool that is larger than the maximum rated capacity of the machine.

Adjusting the Gibs (Dovetail Slides)

1. Periodically check, lubricate, and adjust as needed.
2. The gibs require adjustment if too loose.
3. To adjust, loosen the lock nuts and adjust the adjuster screws evenly while moving the handle up and down.
4. Adjust so that there is no free play, without any binding anywhere in its range of travel.
5. Then retighten the lock nuts.



Repositioning of Handles

1. Elevate the slide upward to full height.
2. Remove the pinion cap screw and pinion cap from the shaft end (opposite side to handles).
3. Slide the pinion with the handles on outward, approximately 1/3rd distance.
4. Disengage the rack by means of raising the slide up by another 3/4".
5. Remove pinion, reposition through opposite side of body casting and reverse procedure as above.

Assembly of Traverse Handles

1. To assemble traverse handle, place each of the three (3) handles into the threaded holes on the pinion shaft, turning clockwise to tighten.
2. To remove handles, turn counter-clockwise.

Assembly of Safety Guard

1. Mount safety guard to magnet using two wing nuts provided.

Coolant Tank Assembly

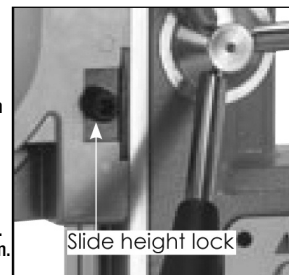
1. First attach clear tube to the bottom of the coolant tank. Loosen the nut and slide nut onto tube. Tighten the nut.
2. Slide tank hanger over the screw on the upper right hand side of slide and tighten.
3. Firmly insert the opposite end of tube into quick-release connector.
4. To remove, first firmly push the red collar of the connector and pull the tube out.
5. Cutting coolant fluid is always required when using annular cutters. Open tank cover and fill. Check coolant fluid level often. Keep coolant tap closed when not in use.

Adjusting the Slide Height

1. Adjustable slide height models allow the operator to quickly change the height position of the motor head on the slide.
2. This is useful when switching between twist drills and annular cutters.
3. For annular cutters, use the lowest position possible for best stability. For twist drills, raise the motor head to allow enough clearance for the twist drill to be mounted.

To adjust:

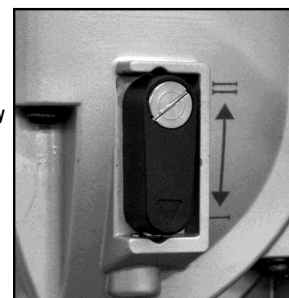
1. Using the T-handle hex wrench, loosen the socket cap screw on the Slide Height Lock.
2. Slide the motor head to the desired position.
3. Tighten the Slide Height Lock.



Gear Selection

1. Select the desired gear by swinging the gear selector tab out of the detent slot and into the correct speed
2. Then pop the selector tab back into the detent.
3. It may be necessary to turn the spindle by hand slightly to shift into gear.

GEAR	NO LOAD SPEED	FULL LOAD SPEED
1	300 rpm	180 rpm
2	450 rpm	270 rpm



NOTE: These speeds are general recommendations only. Actual speeds should be determined by the material and the cutting speed recommended by the cutting tool manufacturer.

CAUTION: Ensure that that gears engage fully.

CAUTION: ALWAYS ensure that the machine is fully stopped before attempting to change gears!

CAUTION: Never change gears on a running machine!

Assembly of Drill Chuck for use with Straight Shank Tools

1. An important feature of the AC50 is that it can quickly and easily be converted to operate standard twist drills and other straight shank cutting tools such as chassis reamers.
2. Optional equipment RB1234 chuck adaptor and AC35-1220 are needed to use the AC50 with twist drills.
3. Insert the RB1234 in the quick change arbor and make sure that the flats align with the locking mechanism of the arbor.
4. Screw the AC35-1220 on to the adaptor.
5. You are now ready to insert your cutting tool into the chuck.
6. Tighten down with the appropriate chuck key and you are ready to drill.

