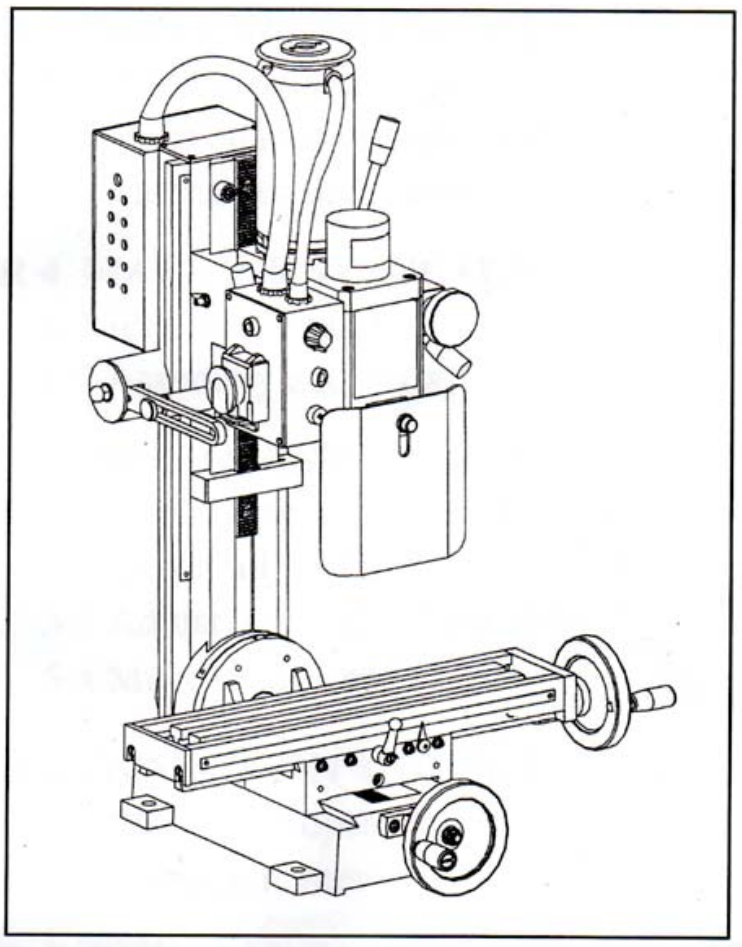
Mini Milling/Drilling Machine

Instruction Manual

WILLOUGHBY
COMMUNITY
MEN'S SHED
296C Sailors Bay Road,
NORTHBRIDGE N.S.W 2063



Read all instructions and warning before using this tool

XJ9510A

13. Do not overreach.
-Keep proper footing and balance at all times.
14. Maintain tools with care.
-Keep cutting tool sharp and clean for better and safer performance.Follow instructions for lubrication and changing accessories.Inspect tool cord periodically and if damaged have it repaired by an authorized serviced facility.Inspect extension cords periodically and replace, if damaged Keep handle dry,clean and free from oil and grease.
15. Disconnect tools.
-When not in use, before servicing and when changing accessories such as blade,bits and cutters.
16. Remove adjusting keys and wrenches.
-Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
17. Avoid unintentional starting.
-Do not carry a plugged-in tool with a finger on the switch.Ensure switch.Ensure switch is off when plugging in.
18. Use outdoor extension leads.
-When tool is used outdoors,use only extension cords intended for outdoor use.
19. Stay alert.
-Watch what you are doing .Use common sense.Do not operate tool when you are tired.
20. Check 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,free running 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 by an authorized service center unless otherwise indicated in this instruction manual. Have defective switches replaced by an authorized service facility.Do not use the tool if the switch does not turn it on and off.
21. Warning.
-The use of any accessory or attachment,other thăn those recommended in this instruction manual,may present a risk of personal injury.
22. Have your tool repaired by a qualified person.
-This electric tool is in accordance with the relevant safety requirements.Repairs should only be carried out by qualified persons using original spare parts,otherwise this may result in considerable danger to the user.

CHAPTER 7 GENERAL SAFETY INSTRUCTION

Warning!When using electric tools,basic safety precautions should always be followed to reduce the risk of fire,electric shock and personal injury,including the following.Read all these instructions before operating this product and save these instructions.

1. Keep work area clean.
   -Cluttered areas and benches invite injuries.
2. Consider work area environment.
   -Do not expose power to rain.Do not use power tools in damp or wet locations.
   Keep work area well lit. Do not use power tools where there is risk to cause fire or explosion.
3. Guard against electric shock.
   -Avoid boby contact with earthed or grounded surfaces(e.g.pipes,radiators,ranges, refrigerators.)
4. Keep children away.
   - Do not let visitors touch the tool or extension code.All visitor should be kept away from work area.
5. Store idle tools.
   -When not in use,tools should be stored in a dry,high or loched up place,out of reach of children.
6. Do not force the tools.
   -It will do the job better and safer at the rate for which it was intended.
7. Use the right tools.
   -Do not force small tools or ottachments to do the job of a heavy duty tool.Do not use tools for purposes not intended;for example,do not use circular saws to cut three limbs or logs.
8. Dress properly.
   -Do not wear loose clothing or jewelry,they can be caught in moving parts.Rubber gloves and non-skid footwear are recommended when working outdoors. Wear protecting hair covering to contain long hair.
9. Uses safety glasses.
   -Also use face or dust mask if the cutting operation is dusty.
10. Connect dust extraction equipment.
    -If devices are provided for the connection of extraction and collection facilities,ensure these are connected and properly used.
11. Do not abuse the cord.
    -Never carry the tool by cord or yand it to disconnect it from the socket,keep the cord away from heat,oil and sharp edges.
12. Secure work
    -Use clamp or a voice to hold the work.It is start than using your hand and it frees both hands to operate the tool.

6-2 Attend for Operation

Please attend the following items as you operate in order to ensure the operation safety and maintain the capacity of machine.

☐ **Inspection before turn on**

1.Before turn on power,you must check the tool chuck and cutter tighten it certainly.
2.Inspect whether each machine part has loosen.
3.Check the rod of speed adjustment at correct position certainly.
4.Workpiece is fixed with press cake or fixture certainly.
5.Clean and remove the obstacles around the machine.

☐ **During Operation**

1.Drinking alcohol or being worse spirited is absolutely forbidden to operate the machine.
2.Wearing gloves or necktie is absolutely forbidden to operate the machine.
3.Select and install appropriate cutter,no loosen.
4.The machine will shaking as follows condition:
a.The depth of cut is too deep.
b.The feeding speed is too fast.
c.The rotation speed is too fast.
d.The machine and stock plane is not fixed firmly.
e.The vice and workpiece is not fixed firmly.

☐ **Protection and Maintenance**

1.Please perform the maintenance on each level and make a record.
2.Please turn off the power perform maintenance or projection.
3.Please inform our dealer to assign professional person to deal with the action beyond extent of individual maintenance and protection.

CHAPTER 6 OPERATION AND NOTICE FOR USE

6-1 Method of Operation

☐ Drilling or Deep Milling

1. According to Chp5, replacement of chuck and tool. Install appropriate adjustment and tighten it certainly.
2. Select appropriate speed level .**[ATTENTION: When spindle is running, don't change the HIGH/LOW speed !]**
3. Use press cake or fixture set the workpiece on the working table.
4. Adjust working table (Longitudinal Axis(Y)) and Saddle seat (Cross Axis (X))in position.
5. Loosen the limit block handle, adjust the blocks in position. Note don't let tool meet the workpiece.
6. Put Adjusting tools in order and remove all obstacles which are around the machine.
7. Turn on the main power. Adjust appropriate spindle speed and drilling or deep milling.
8. Refer the ruler on fuselage can know drilling or milling depth.
9. Finish working , turn off power and take the spindle to upper position.
10. Clean the machine.

☐ Face Milling

1. According to Chp5, replacement of chuck and tool. Install appropriate adjustment and tighten it certainly.
2. Select appropriate speed level. **[ATTENTION: When spindle is running, don't change the HIGH/LOW speed !]**
3. Use press cake or fixture set the workpiece on the working table.
4. Adjust working table (Longitudinal Axis (Y)) and Saddle seat (Cross Axis (X)) in position.
5. Release limit block on fuselage, adjust the depth of cut, then fixed.
6. Arrange all tools in proper place.
7. Turn hand wheel of working table (Y-axis) and saddle seat(X-axis) to do face milling.
8. Finishing all steps, turn off power and make spindle return to upper position, release workpiece.
9. Clean the machine.

☐ Drilling or Milling Speed

Before any operation, set the spindle to a correct speed of running.
The operating speed range for working is 0 to 2500 rpm. For most part, the correct speed may consider the size of working face and the material. Generally, you can use higher speed for softer material or small holes. Use lower speed for harder material or bigger holes.
A good rule of thumb is : Smaller hole and the softer material, use higher speed.
But don't drill too fast (above 2300 rpm) if your workpiece is wood, you may burn it . For metal, the speed can from 0 to 2500 rpm.