



**D-50A
AUTOMATIC DRILL**



OPERATING MANUAL

1. Specification

1. Drilling material: paper
2. Drilling capacity: 1-57/64" (48mm) for Φ 13/64" (5mm) – Φ 5/16" (8mm)
 1-1/2" (38mm) for Φ 5/32" (4mm)
 1-7/64" (28mm) for Φ 1/8" (3mm)
- 3, Drilling bit: Φ 1/8" - Φ 5/16" (Φ 3mm - Φ 8mm)
4. Table moving: vertically 55/64" (22mm), horizontally 1-1/16" (270mm)
5. Standard drilling hole:

3 holes	\odot 3.15" (80mm) \odot 3.15" (80mm) \odot
3 holes	\odot 4.25" (108mm) \odot 4.25" (108mm) \odot
4 holes	\odot 3.15" (80mm) \odot 3.15" (80mm) \odot 3.15" (80mm) \odot
4 holes	\odot 1.77" (45mm) \odot 2.56" (65mm) \odot 1.77" (45mm) \odot
6 holes	\odot 0.75" (19mm) \odot 0.75" (19mm) \odot 1.97" (50mm) \odot 0.75" (19mm) \odot 0.75" (19mm) \odot

6. Table max working width: 13.58" (345mm)
7. Consumption: 300W
8. Power supply: 230V/110V 50/60Hz
9. Fuse capacity: 2A (Φ 5X20)
10. Net weight: 36Kg

2. Illustration



Fig 1

- A: Console panel
- B: Drilling base
- C: Drilling bit
- D: Locking bracket
- E: Locking button
- F: Handle
- G: Platform
- H: Conductive rubber pad
- I: Side gauge
- J: Hexagonal bar
- K: Clamping bar
- L: Transparent plastic cover

3. Installation

1. Unpack the machine from the carton by holding the two square steel bars at the bottom of the machine.
 - ◆ **Caution: Don't pull the shell of the machine.**
2. Assemble the table to the machine and fix it using two screws on both sides.
3. Plug the machine into to the mains. Switch the machine on. Make sure the machine is good grounded connection.

4. Operation

1. Check for any staples or clips in the sheets before drilling to avoid any damage to the machine.
2. Set the rear and front position of the table and tighten its two fixing screws on both sides of the machine.
3. Select a drilling bit with desired diameter. Open the transparent plastic cover. Push the drill bit upward into the base to the top position then tighten the two grub screws. Close the transparent plastic cover.
4. Load the sheets onto the table. Press the clamping bar downward at the center of the bar to clamp the sheets tightly (shown in Fig 2).
5. Select the desired drilling distance by turning the hexagonal bar and moving the table in place.
6. Drill the sheets by pressing down the "start" key on the console panel. The bit will drill downward and return to the original position after finishing its work. Move the front table for subsequent drilling.
7. Take the drilled sheets away by releasing the clamping bar (shown in Fig 3).

5. Console panel (shown in Fig 4)

1. Buttons

RESET: Have the drilling bit return to the original position.

UP: Have the drilling bit go upward.

DOWN: Have the drilling bit go downward..

START: Have the machine drill automatically.

Drilling: Have the drilling bit rotate.

2. Lamps

COVER: transparent plastic cover is open.

BIT: The machine is buzzing due to an overload. Press the "RESET" key to reset the machine and check for any paper jam in the drilling bit or a blunt drilling bit.

3. Power Switch

Switch on/off the machine.

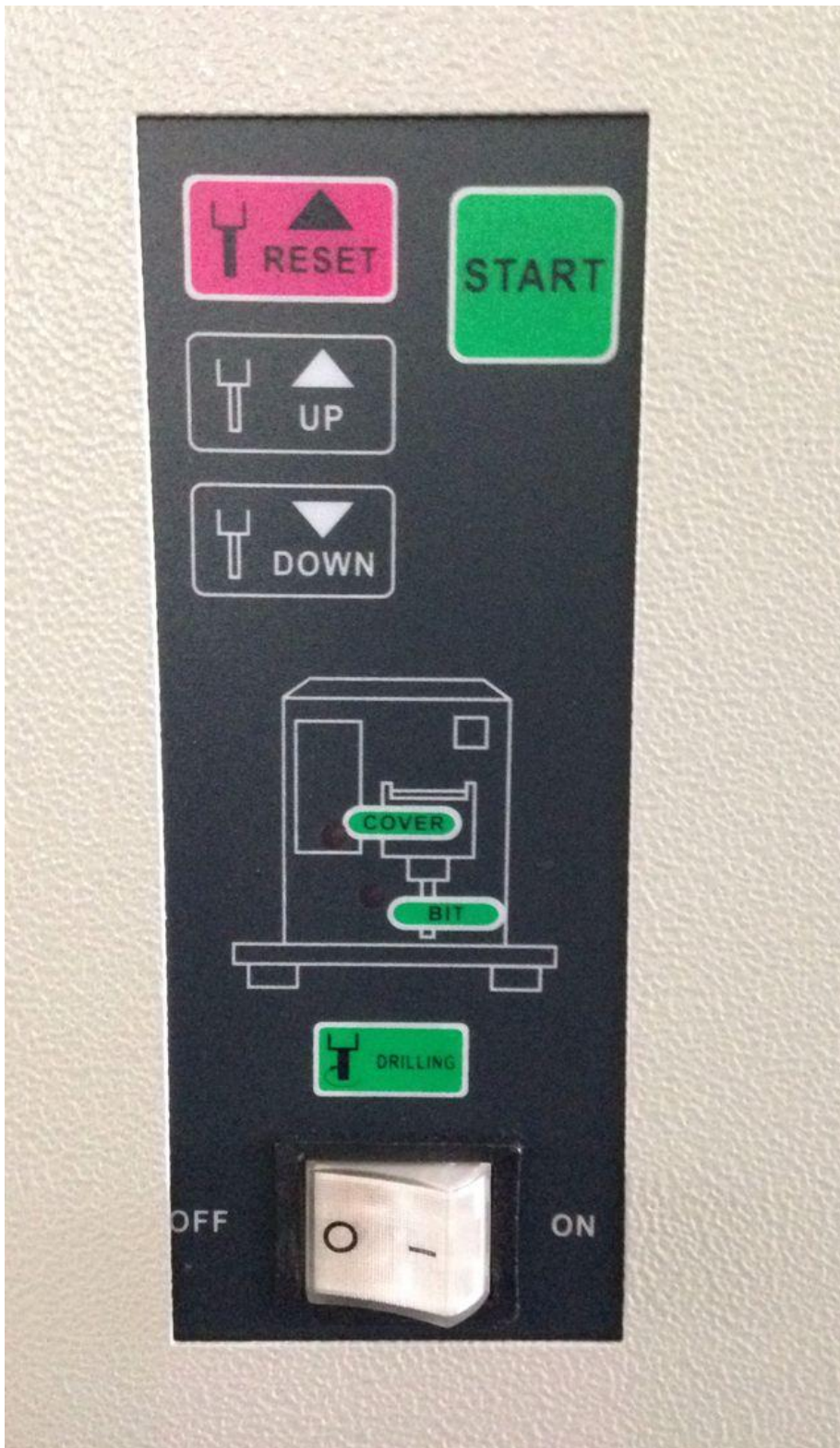


Fig 4

6. Maintenance

1. **Replacing drilling bit:** Open the transparent plastic cover and loosen the two grub screws in the base. Remove the worn bit and replace it with a new one.
2. **Replacing conductive rubber pad:** Replace the worn conductive rubber pad with a new one. Never use pads of other type.
3. **Cleaning paper jam & Sharpening drilling bit:** The alarm is given when the drill bit fails to work properly caused by scraps paper jam or drilling bit is blunt.
Cleaning paper jam: Insert the drill bit into one end of the fixing rod and tighten the wing screw at the groove of the drilling bit and insert the awl into the other end of the rod.
Sharpening drilling bit: Take the awl out of the fixing rod after removing scraps, insert the sharpener into the rod and turn the sharpener clockwise until the drilling bit is sharpened adequately (shown in Fig 6). Attention: After sharpening several times, the drilling bit will be shorter, and a timely replacement is needed.).
4. **Lubrication:** Subject to the guidance of specialists.
5. **Components Supply:** Use our special components for the replacement of the consumable parts such as the conductive rubber pad and drilling bit in order to secure longer use of the machine.
6. **Attention:**
 - The machine is only designed for paper drilling other than plastic or metal media.
 - The conductive rubber pad should be revolved when used for over 100 times at the one same position.

Clamping sheets illustration

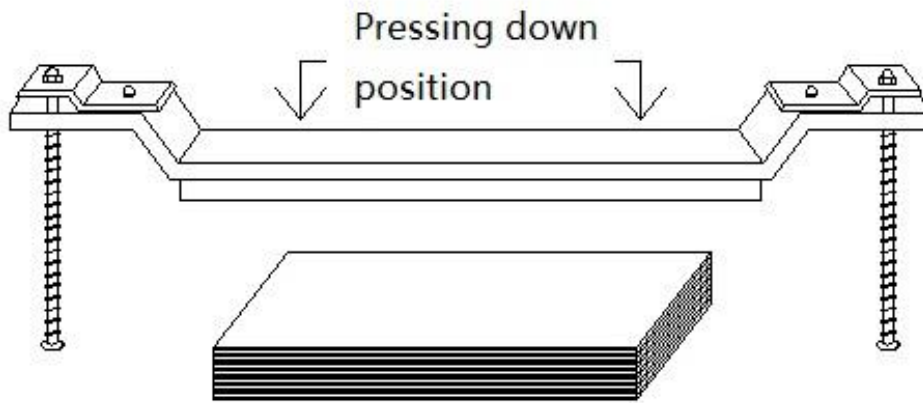


Fig 2

Releasing sheets illustration

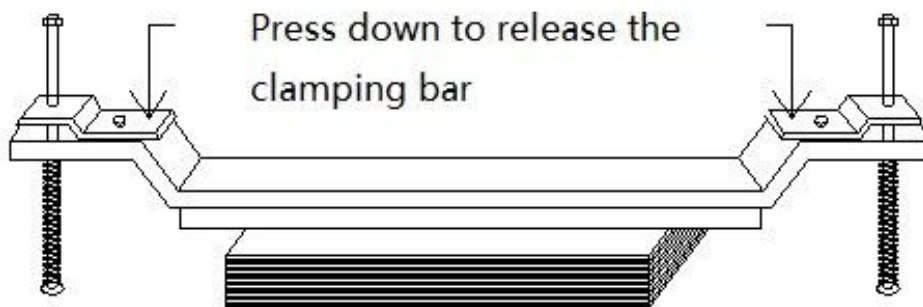


Fig 3

Cleaning paper jam illustration

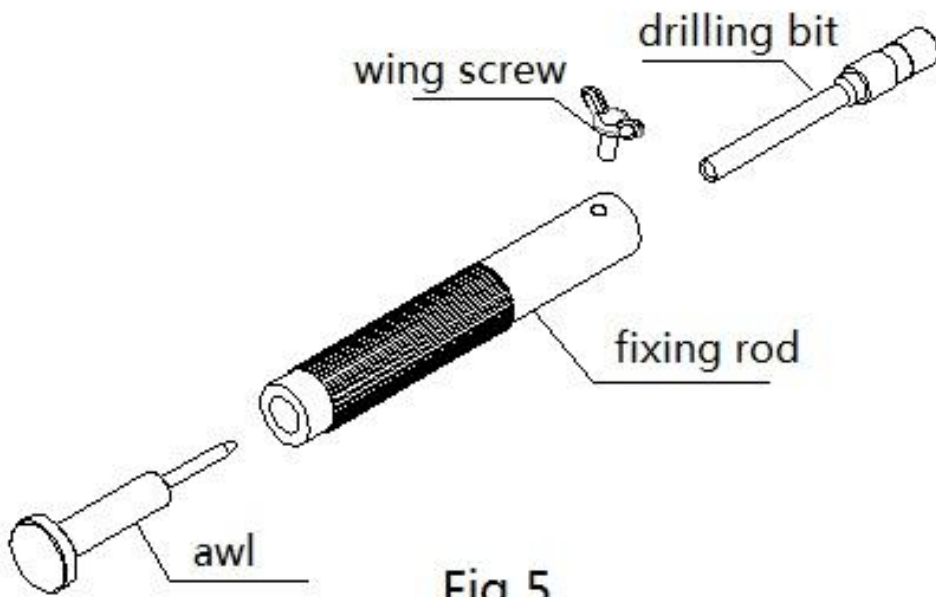


Fig 5

Sharpening drilling bit illustration

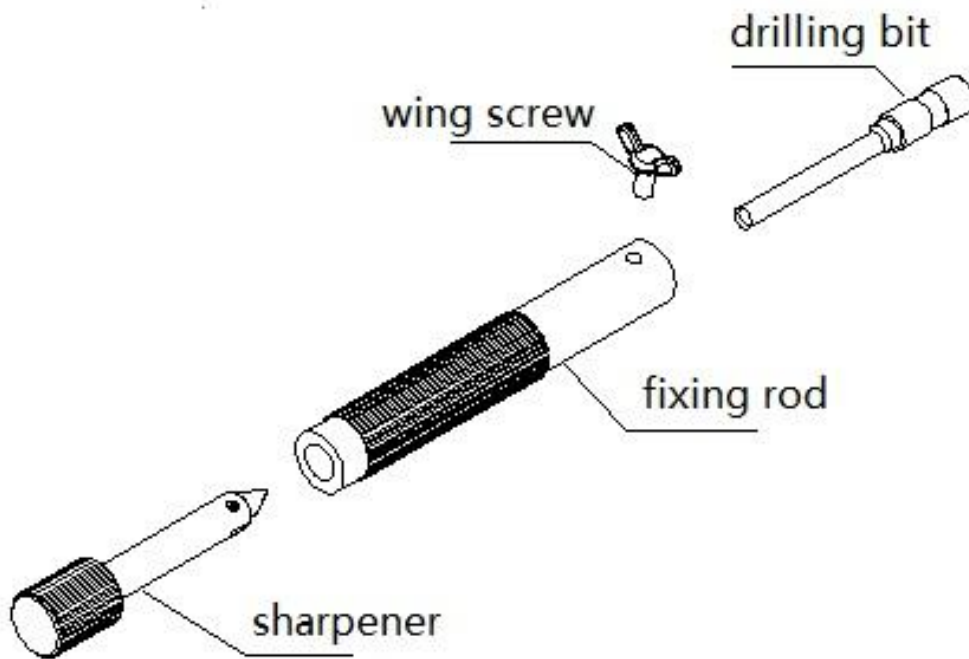


Fig 6