

VEVOR[®]

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate www.vevor.com/support

ANNULAR CUTTER

USER MANUAL

**MODEL: 10190010215/10190010216/10190010146
10190010213/10190010214**

We continue to be committed to provide you tools with competitive price.

"Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

VEVOR[®]

TOUGH TOOLS, HALF PRICE

ANNULAR CUTTER

MODEL: 10190010215/10190010216/10190010146
10190010213/10190010214



NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

Technical Support and E-Warranty Certificate
www.vevor.com/support

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

SAFETY INSTRUCTION AND PRECAUTIONS

⚠WARNING:

Read this material before using this product. Failure to do so can result in serious injury.

Safety Caution

For your safety please wear goggles and helmet. Do not wear loose clothes or yarn gloves.

1. Please use hook to remove the chip to prevent injuries of hand.
2. Before using, make sure the cutter is sound and securely. Do not use the cutter with damage.
3. Turn off the machine immediately if the cutter gets stuck.
4. Turn off the power before replace and disassemble cutter.
5. Do not touch the cutter when it is working.
6. Cutter's tip is hard but also fragile. Please protect the cutter to prevent it tipping.

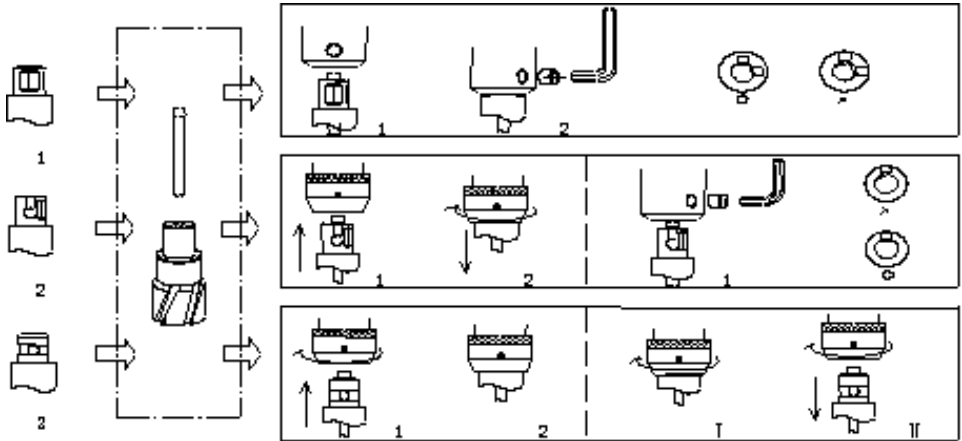
[The usage of annular cutter]

Annular cutter (Core drill) .It can cutting all kinds of steel, steel pipe, cast iron, stainless steel, aluminum, copper and various non-metallic materials.

[The type]

Shank	Suitable types of magnetic drill
Weldon shank	Applicable to all kinds of Magnetic core drill machine. Like: CHTOOLS、ALFRA、RUKO、HOUGEN、Rotabroach、BDS etc.
Universal shank (Nitto shank)	Applicable to all kinds of Magnetic core drill machine, unless Fein machine .Like: CHTOOLS、ALFRA、RUKO、HOUGEN、Rotabroach、BDS etc.
Fein shank	Applicable to Fein machine from Germany

[Method of application]



1. Installation method:

- Weldon shank (1) : The handle of two planes aim at the two screw holes on the drill spindle, With a hex wrench to tighten and leaving a gap of 0.2-0.3mm, Back and forth with your hand to confirm socket head screw perpendicular to the two planes, then screw down the screws.

- Universal shank (2) : The handle of two planes aim at steel ball within the drill chuck, then loaded into chuck.

Universal shank can also be used socket head screws, As long as socket head screw perpendicular to the two planes.

- Fein shank (3) : Turn on insurance ring of the main shaft clockwise to the right way, let the handle end insert into directly, rotate in small range until steel ball enter into the hole.

2. Recommended cutting speed for high speed steel annular cutter:

Dia / Material	12-18	19-25	26-32	33-39	40-46	47-53	54-60	61-65
carbon steel	447-318	301-229	220-179	173-146	143-124	121-108	106-95	93-88
alloy steel	371-247	234-178	171-139	135-114	111-96	94-84	82-74	73-68
stainless steel	345-230	217-165	159-129	125-106	103-90	88-78	76-69	67-63
Aluminum	1857-1238	1173-891	857-696	675-571	557-484	474-420	412-371	365-342
cast iron	796-530	502-382	367-298	289-244	238-207	203-180	176-159	156-146
cast copper	1194-796	754-573	551-447	434-367	358-311	304-270	265-238	234-220

3. Feed speed: The recommended feed speed is 0.08-0.12mm/R or 0.6-1.0mm/sec. Different feed speed will cause different chip and affect the performance of removal of chips.

4. Positioning: Chisel a positioning point in the center of the position to be drilled or mark a "cross" line with an alloy needle to ensure the accuracy of the drilled position. Note that when using the center chisel to hit the positioning point, please make sure that the center chisel is perpendicular to the surface of the workpiece to avoid affecting the smooth discharge of the cutting core

5. Start to drill: Make sure the button of magnetic drill machine is clean before power on. Turn on the switch of coolant liquid when start to drill. First feed slowly and feed in the normal speed after drill 1-2mm.

6. Finish drill: Turn off the power and use hook to remove the chips on the cutter after it stops.

[Notice]

The following actions will help to reduce or slow wearing and fracturing of cutter.

1. When drilling steel parts, please make sure enough amount of cooling and use metal cutting fluid.
2. Good rigidity of drill pipe and the guide rail gap can improve the precision of drilling and the life of the bit.
3. Please make sure flat and clean between the magnetic holder and artifacts.
4. Before cutting, make sure all parts to be locked surely.

5. Drilling in the start and at the end, the drilling feed should reduce 1/3.
6. For a large amount of fine powder material which occurs in the drilling, such as cast iron, cast copper, etc., can use compressed air instead of coolant liquid to help chip removal.
7. Please remove the chips on the cutter, to ensure smooth chip removal.

[The solutions of common problem]

The solutions of chip core stuck:

Use nonmetallic material lightly slaping drill, or lightly pressure core material repeatedly,in order to make it loose to pop up, also can remove the bit, tap the thimble, so that it is out.

The wearing of tools:

Under the normal cooling, when chip appear blue-black color, it need to check the drill bit blade, when the most big wear width is 0.5 mm, it needs grinding.

	Items	Description
1	Name	Annular Cutter
2	Model	10190010215
3	Parameter	Shank: Weldon shank D.O.C: 2" Cutter Dia.: 1", 1-1/8", 1-1/4", 1-1/2", 1-3/4", 2"

	Items	Description
1	Name	Annular Cutter
2	Model	10190010216
3	Parameter	Shank: Universal shank D.O.C: 2" Cutter Dia.: 1", 1-1/8", 1-1/4", 1-1/2", 1-3/4", 2"

	Items	Description
1	Name	Annular Cutter
2	Model	10190010146
3	Parameter	Shank: Weldon shank D.O.C: 1" Cutter Dia.: 1/2"、9/16"、11/16"、13/16"、15/16"、1-1/16"

	Items	Description
1	Name	Annular Cutter
2	Model	10190010213
3	Parameter	Shank: Weldon shank D.O.C: 1" Cutter Dia.: 7/16"、1/2"、9/16"、11/16"、5/8"、3/4"、13/16"、7/8"、15/16"、1"、1-1/16"

	Items	Description
1	Name	Annular Cutter
2	Model	10190010214
3	Parameter	Shank: Weldon shank D.O.C: 2" Cutter Dia.: 7/16"、1/2"、9/16"、11/16"、5/8"、3/4"、13/16"、7/8"、15/16"、1"、1-1/16"

MADE IN CHINA

VEVOR[®]

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate

www.vevor.com/support