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# FLOOR DRILL PRESS PPSC30TE

IN GOOD HANDS

TRANSLATION OF ORIGINAL INSTRUCTION MANUAL





## WHO ARE WE?

**Peugeot Professional Tools** was born out of several obvious considerations.

The first was to combine the know-how of **Peugeot**, which has mastered the art of cutting since 1810, with the expertise of **Tivoly**, a metalworker since 1917, in order to create a wide range of machines and tools for construction and maintenance professionals.

It was also a natural step to want to serve craftsmen and small businesses driven by strong family and heritage values.

For these professionals, **Peugeot Outils Professionnels** offers machines and tools designed specifically for their needs. **These tools are reliable, durable, and can be repaired in France** and in countries under distribution agreements by local industrial and family partners.

Trustworthy equipment with a longer warranty, logistics, and

**French after-sales service.** The assurance of dealing with the people who assembled these tools and know every part that goes into them inside out.

From exceptional projects to everyday work, these tools are designed to withstand the most demanding conditions and stand the test of time.

**Peugeot Professional Tools** was born out of one obvious fact: that our tools are in good hands. The hands of those who work behind the scenes and give their all to satisfy their customers.

**Since 1810**, many things have changed, but the hands have remained the same. The hands of enthusiasts, craftsmen, dedicated technicians and installers, workers who are proud of themselves and their achievements.

**Peugeot Professional Tools: tools in good hands.**

## THANK YOU FOR YOUR PURCHASE.

We are delighted that you have chosen Peugeot Professional Tools. Every detail has been designed to offer you an exceptional experience, and we hope you enjoy using it as much as we enjoyed creating it for you.

Your trust is essential to us, and we are delighted to accompany you every step of the way in your experience with the Peugeot Professional Tools brand.

**Your purchase comes with a 2-year warranty, extendable to an additional 2 years.**

























To benefit from this, register at [www.peugeot-outils-pro.com](http://www.peugeot-outils-pro.com)

If you have any questions or need assistance, our team is available to provide you with the best possible service.

To contact our after-sales service, visit [www.peugeot-outils-pro.com](https://www.peugeot-outils-pro.com), call [+33\(0\)4.79.89.59.00](tel:+330479895900), or email [service@peugeot-outils-pro.com](mailto:service@peugeot-outils-pro.com).

Thank you for choosing Peugeot Professional Tools. Your satisfaction is our priority.

## CONTENTS

<b>1</b>	<b>INTRODUCTION</b> .....	<b>4</b>
<b>2</b>	<b>PICTOGRAMS</b> .....	<b>4</b>
2.1	MACHINE SAFETY PICTOGRAMS .....	4
2.2	PICTOGRAMS USED IN THIS INSTRUCTION MANUAL .....	4
<b>3</b>	<b>SAFETY</b> .....	<b>5</b>
3.1	GENERAL SAFETY REQUIREMENTS.....	5
3.2	SPECIFIC SAFETY REQUIREMENTS.....	6
3.3	OPERATOR PROTECTION .....	7
<b>4</b>	<b>DESCRIPTION AND OPERATION</b> .....	<b>7</b>
4.1	INTENDED USE OF THE MACHINE.....	7
4.2	CHARACTERISTICS .....	7
4.3	DESCRIPTION OF THE MACHINE.....	8
<b>5</b>	<b>INSTALLATION</b> .....	<b>9</b>
5.1	 PACKAGING .....	9
5.2	 ASSEMBLY .....	9
5.3	 HANDLING AND TRANSPORT.....	12
5.4	 SETTING UP THE MACHINE.....	12
5.5	 ELECTRICAL CONNECTION .....	13
5.6	 INITIAL TEST AND INSPECTION BEFORE FIRST USE .....	13
<b>6</b>	<b>TOOLS</b> .....	<b>14</b>
6.1	 TOOL ASSEMBLY .....	14
6.2	 TOOL DISASSEMBLY .....	14
<b>7</b>	<b>ADJUSTMENTS</b> .....	<b>15</b>
7.1	 CONTROL DEVICES .....	15
7.2	DIGITAL DISPLAY .....	15
7.3	 DEPTH STOP .....	15
7.4	 SPINDLE RETURN SPRING.....	16
7.5	 CHUCK PROTECTION SCREEN.....	16
7.6	 TABLE.....	17
7.7	 SPINDLE ROTATION SPEED SELECTION.....	19
7.8	LED LIGHTING .....	20
7.9	 LASER GUIDE.....	21
<b>8</b>	<b>USE</b> .....	<b>22</b>
8.1	 DRILLING PROCEDURE.....	22
8.2	 OPERATING INCIDENTS .....	23
8.3	 TROUBLESHOOTING TABLE .....	24
8.4	 TAKING THE MACHINE OUT OF SERVICE .....	24
<b>9</b>	<b>MAINTENANCE</b> .....	<b>25</b>
9.1	 DAILY MAINTENANCE .....	25
9.2	 WEEKLY MAINTENANCE.....	25
9.3	 MONTHLY MAINTENANCE .....	25
9.4	 SEMI-ANNUAL MAINTENANCE.....	25
9.5	 BELTS .....	26
<b>10</b>	<b>EXPLODED VIEW</b> .....	<b>27</b>
<b>11</b>	<b>ELECTRICAL DIAGRAM</b> .....	<b>30</b>
<b>12</b>	<b>NOISE LEVEL</b> .....	<b>31</b>
<b>13</b>	<b>VIBRATION LEVEL</b> .....	<b>31</b>
<b>14</b>	<b>ENVIRONMENTAL PROTECTION</b> .....	<b>31</b>
<b>15</b>	<b>WARRANTY</b> .....	<b>31</b>
<b>16</b>	<b>DECLARATION OF CONFORMITY</b> .....	<b>32</b>

## 1 INTRODUCTION



**For safety reasons, read these instructions carefully before using this machine.  
Failure to follow the instructions will result in damage to persons and/or the machine.**

This instruction manual is intended for the operator, adjuster, and maintenance technician.

This instruction manual is an important part of your equipment. It provides rules and guidelines that will help you use this machine safely and efficiently. You must familiarize yourself with the functions and operation by carefully reading this instruction manual. For your safety, it is particularly important that you read and observe all recommendations on the machine and in this instruction manual.

These recommendations must be strictly followed at all times when using and maintaining the machine. Failure to follow the safety guidelines and warnings in the instruction manual and on the machine and/or use other than that recommended in the instruction manual may result in machine failure and/or injury.

Please keep this instruction manual with the machine or in a place that is easily accessible at all times for future reference. Ensure that all personnel involved in the use of this machine can consult it periodically.

If the instruction manual is lost or damaged, please contact us or your dealer to obtain a new copy.

Always use PEUGEOT OUTILS PROFESSIONNELS components and parts. Replacing components or parts other than PEUGEOT OUTILS PROFESSIONNELS may cause damage to the machine and endanger the operator.

This manual describes the safety instructions to be followed by the user. It is the responsibility of the employer or user, in accordance with Article L.4122-1 of the Labor Code, to take care of their health and safety and that of other persons affected by their actions or omissions, in accordance, in particular, with the instructions given to them.

The employer must carry out an assessment of the specific risks associated with their activity, must train workers in the use of the machine and in the prevention of these risks, and must appropriately inform workers responsible for the use or maintenance of work equipment of the instructions or guidelines that apply to them.

## 2 PICTOGRAMS

### 2.1 MACHINE SAFETY PICTOGRAMS

Meaning of the safety pictograms affixed to the machine (keep them clean and replace them when they are illegible or detached):



Safety footwear must be worn.



Safety glasses must be worn.



Do not wear protective gloves during machining.



Do not stop the tool by hand.  
Do not touch the tool while it is moving.  
Keep hands away from machining areas when the machine is in operation.



Do not open until the pulleys have stopped.



Electrical presence.



Hearing protection must be worn.



Read the instruction manual carefully.



**ROTATION BROCHE** Spindle rotation direction.



Do not wear loose clothing, wide sleeves, bracelets, watches, wedding rings, jewelry, ties, scarves, or any other items that could get caught in the moving parts of the machine.  
Wear hair nets for long hair.



Wait until the spindle has come to a complete stop before opening the pulley cover.



Ground connection for metal parts.

### 2.2 PICTOGRAMS USED IN THIS INSTRUCTION MANUAL



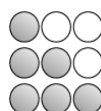
Direct danger to persons and damage to the machine



Possible damage to the machine or its surroundings



Wear protective gloves when changing tools and cleaning



Technical skill level: operator, user

Technical skill level: adjuster, maintenance

Technical skill level: maintenance technician



Note



**Electrical operations must be performed by personnel who are qualified and authorized to perform low-voltage electrical work.**

## 3 SAFETY

## 3.1 GENERAL SAFETY REQUIREMENTS



**To reduce the risk of fire, electric shock, mechanical shock, and personal injury when using power tools, follow basic safety precautions.**

This instruction manual only takes into account reasonably foreseeable behavior.

Our machines are designed and manufactured with the operator's safety in mind.

We accept no liability for damage caused by inexperience, incorrect use of the machine and/or damage to it and/or failure to comply with the instructions and safety rules contained in this instruction manual.

As a general rule, accidents always occur as a result of misuse or failure to read the instruction manual.

We remind you that any modification to the machine will result in our disengagement.

Check the presence, condition, and operation of all guards before starting work.

Ensure that moving parts are working properly, that there are no damaged components, and that the machine is operating perfectly during start-up.

Only competent and authorized personnel are permitted to repair or replace damaged parts.

Keep the work area clean and tidy.

Ensure that the entire work area is visible from the work position. Cluttered work areas and workbenches are a potential source of injury.

Do not use the machine outdoors, in very humid conditions, or in the presence of flammable liquids or gases.

Position the machine in a sufficiently lit work area.

The machine must not be used by young workers under the age of 18.

Do not allow unauthorized persons, especially children or animals, to enter the work area, touch the tools or electrical cables, and keep them away from the work area.

Never leave the machine unattended while it is in operation. Always disconnect the power supply. Only leave the machine when it has come to a complete stop.



Do not force the tool; it will perform better and be safer at the speed for which it is designed.

Do not force small tools to do the work of larger tools.

Do not use tools for jobs for which they are not intended.



Do not damage the power cord.

Never pull on the power cord to remove it from the electrical outlet.

Keep the power cord away from heat sources, greasy areas, and/or sharp edges.

Protect the power cord from moisture and any potential damage. Periodically check the power cord and, if damaged, have it repaired by an authorized repairer.

A faulty switch must be replaced by an authorized service center. Do not use the machine if the switch does not control the stop or start functions.



Do not overestimate your strength.

Always maintain a stable position and good balance.

Pay attention to what you are doing, use common sense, and do not use the machine when tired.

Always use both hands to operate this machine.

The use of any accessories other than those described in the instruction manual may present a risk of injury to persons.

The user is responsible for their machine and must ensure that: The reel is used by persons who have read the instructions and are authorized to do so.

Safety rules are followed.

Users have been informed of the safety rules.

Users have read and understood the instruction manual.

Responsibilities for maintenance and any repairs have been assigned and observed.

Defects or malfunctions have been immediately reported to an authorized repairer or your dealer.

The reel must be used in the areas of application described in this manual.

Any use other than that specified in these instructions may constitute a hazard.

Mechanical and/or electrical guards must not be removed or bypassed.

No modifications and/or conversions must be made.

PEUGEOT OUTILS PROFESSIONNELS declines all responsibility for damage caused to persons, animals, or objects as a result of failure to comply with the instructions and safety rules contained in this instruction manual.

## 3.2 SPECIAL SAFETY REQUIREMENTS



### Special safety requirements for the bench drill.

Before use, the machine must be correctly assembled.

Secure the machine to a base or workbench that is sufficiently flat, level, smooth, and non-slip, so that the machine is as stable as possible.

Secure the base or workbench to a sufficiently flat and non-slip floor so that the base or workbench is as stable as possible.

Use a base or workbench with sufficient capacity.

Do not use if the unit is not placed on a flat, stable surface that is free of obstacles and well lit.

Do not operate the machine when the safety guards are removed.

Do not use the machine without the pulley cover.

Adjust the chuck guard to prevent access to the non-working part of the tool.

Fit a tool that complies with the machine's recommendations.

Ensure that the tool is firmly locked in the chuck or spindle.

Do not use damaged or deformed tools.

Ensure that the choice and rotation speed of the tool are appropriate for the material to be drilled.

Use appropriate machining speeds. The speed must be selected when the drill is not running.

Check that the pulleys are correctly aligned.

Check that the belts are correctly positioned.

Check that the belts are correctly tensioned.

Use original belts to ensure correct tension.

Do not touch the tool while it is moving.

Do not stop the tool by hand.

Always keep the tool clean.

Do not clean the tool while it is moving.

The tool can become very hot during machine operation. Wait for the tool to cool down before replacing it.

Always keep the work table clean and uncluttered.

Do not add additional accessories for operations for which they are not designed.

Using an inappropriate accessory increases the risk of accidents.

Keep hands away from machining areas when the machine is in operation.

**It is not advisable to wear gloves during machining.**

Reserve them for cleaning operations, when the machine is stopped, and for any operations involving a risk of cuts, burns, or pinching.

Never hold materials to be drilled by hand; clamp them securely using appropriate tools such as vices and clamping systems.

Secure a vise or the material to the table using a set of clamps.

Thin sheets are the most dangerous:

- Their thinness makes them sharp.
- The tool tends to plunge when breaking through.
- Offset holes increase the risk because the material describes a circle as it rotates. Fingers, wrists, forearms, and even the chest are particularly exposed.

Use mountings and clamps:

- Support for uneven and flexible material.
- Guide for drilling small holes in a thin sleeve.

Do not start machining against the material.

Do not strike the tool against the material to be drilled, but apply gradual pressure.

Adjust the table or machining depth setting so as not to drill through the table.

Manually apply cutting fluid to cool the tool. The service life of the tool and the efficiency of the machining depend on this.

An optional lubrication system can be installed.

It is very important to prevent cutting fluid from spilling onto the surrounding area, as this creates a slipping hazard.

Always work in a stable position and maintain your balance.

Always wear safety glasses.

Ensure that no one is in the path of debris caused by machining.

Always keep the work area clean and uncluttered.

In all cases, stay focused on the task at hand.

For all operations involving a risk of cutting, burning, pinching, snagging, entanglement, or crushing, including loading and unloading materials to be drilled, changing tools, and handling the table, vise, clamps, and material to be drilled, stop the machine and wear protective gloves.

Rushing rarely saves time: the tool heats up, becomes blunt, and needs to be resharpened. The work is poorly done. The risk of accidents is increased.

Wear hearing protection.

If necessary, wear respiratory protection to reduce the risk of inhaling hazardous dust.

Keep the motor fan cover clean and uncovered to ensure the machine operates correctly.

Before changing the material to be drilled, a tool, or before performing any operation to position or remove material waste, stop the machine.

Disconnect the power supply for any major operations (maintenance, servicing).

Replace the table when it is worn.

Keep the machine clean and in good condition.

Remove chips regularly.

When cleaning, remove chips that may be sharp and hot while wearing protective goggles and gloves, with the machine turned off, and collect them in bins. Avoid using a blow gun; instead, use a clean, dry cloth, brush, long-handled brush, hook, magnetic collector, or vacuum cleaner.

Do not immerse the machine in water or wash it with a pressure washer, as this may cause water to penetrate the electrical components.

Do not use solvents or aggressive detergents for cleaning.

Disconnect the machine and check that the moving parts are locked when transporting the drill.

Store the machine in a dry place out of the reach of children.



Accidents are generally the result of:

- Lack of accessories to hold the material securely in place.
- Disorder: accessories, if available, are not stored away and the operator cannot find them and therefore does not use them.
- Inappropriate or dangerous operating procedures.
- Insufficient training, learning, and/or experience of operators in the use of the machine.
- Absence of protective covers during machine use.
- Ill-fitting clothing, lack of safety glasses for certain tasks.

### 3.3 OPERATOR PROTECTION



**For operator safety, ensure that non-working parts are always covered by a protective guard.**

This machine is designed for a single operator. The operator must wear appropriate personal protective equipment:

- During use:
  - Safety shoes.
  - Safety glasses.
  - Hearing protection.
  - Respiratory protection.
- When cleaning the machine or changing tools:
  - Safety shoes.
  - Safety glasses.
  - Protective gloves.



The operator must wear close-fitting clothing and, if necessary, hair coverings for long hair.

The operator must not wear, for example:

- Loose-fitting clothing with wide sleeves.
- Bracelets, watches, wedding rings, jewelry, ties, scarves.
- Any other objects that could get caught in the moving parts of the machine.



## 4 DESCRIPTION AND OPERATION

### 4.1 INTENDED USE OF THE MACHINE

The PPSC30TE bench drill is a machine designed and manufactured solely for regular use (3-5 hours/day) for dry drilling operations, with vertical movement, in ferrous metals (steel, iron, cast iron) and non-ferrous metals (stainless steel, aluminum, copper, lead, zinc, tin, brass, etc.), plastics, and wood (optional lubrication system).

The manufacturer declines all responsibility in the event of misuse or machining of materials not recommended for the machine. Under proper conditions of use and maintenance, safe operation and performance are guaranteed for several years. To do this, explore the machine's various functions.

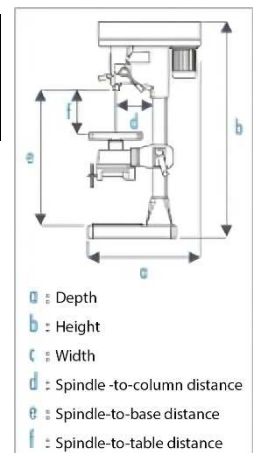
### 4.2 FEATURES

- Cast steel column.
- Transmission via toothed belts and steel pulleys.
- Spindle mounted on ball bearings.
- On/off switch equipped with a low voltage coil.
- Locking punch stop.
- Removable polycarbonate mandrel protection screen.
- Reversible table-vice up to 45°, with cutting fluid collector.
- Vise table movement via rack and pinion.
- Digital display for drilling depth.
- Digital display for spindle speed.
- Laser guide for drilling position.
- LED lighting.
- Pulley cover equipped with an electric safety lock.
- Spindle return adjustable by return spring.
- Supplied as standard with:
  - 1 to 16 mm self-tightening chuck – B18;
  - CM3 – B18 chuck tail;
  - cone puller;
  - service keys.

Capacity of Maximum max (mm)	Chuck chuck	∅ column (mm)	Stroke of Spindle (mm)	Number of speeds	Speeds of (rpm) (rpm)	Dimensions (a x b x c) (mm)	Power engine (kW)	Power	Weight (kg)
30	CM3	92	120	12	180 – 2510	775 x 1720 x 470	11	400 V three-phase	140

d (mm)	e (mm)	f (mm)	Dimensions table (mm)	Grooving table (mm)	Center distance grooving table (mm)	Dimensions base (L x W x H) (mm)
250	1215	755	470 x 420	14	2 x 120	575 x 425 x 95

Features Vise table (TE)	Width of jaws (mm)	Height of jaws (mm)	Opening (mm)
	200	50	165



## 4.3 DESCRIPTION OF THE MACHINE

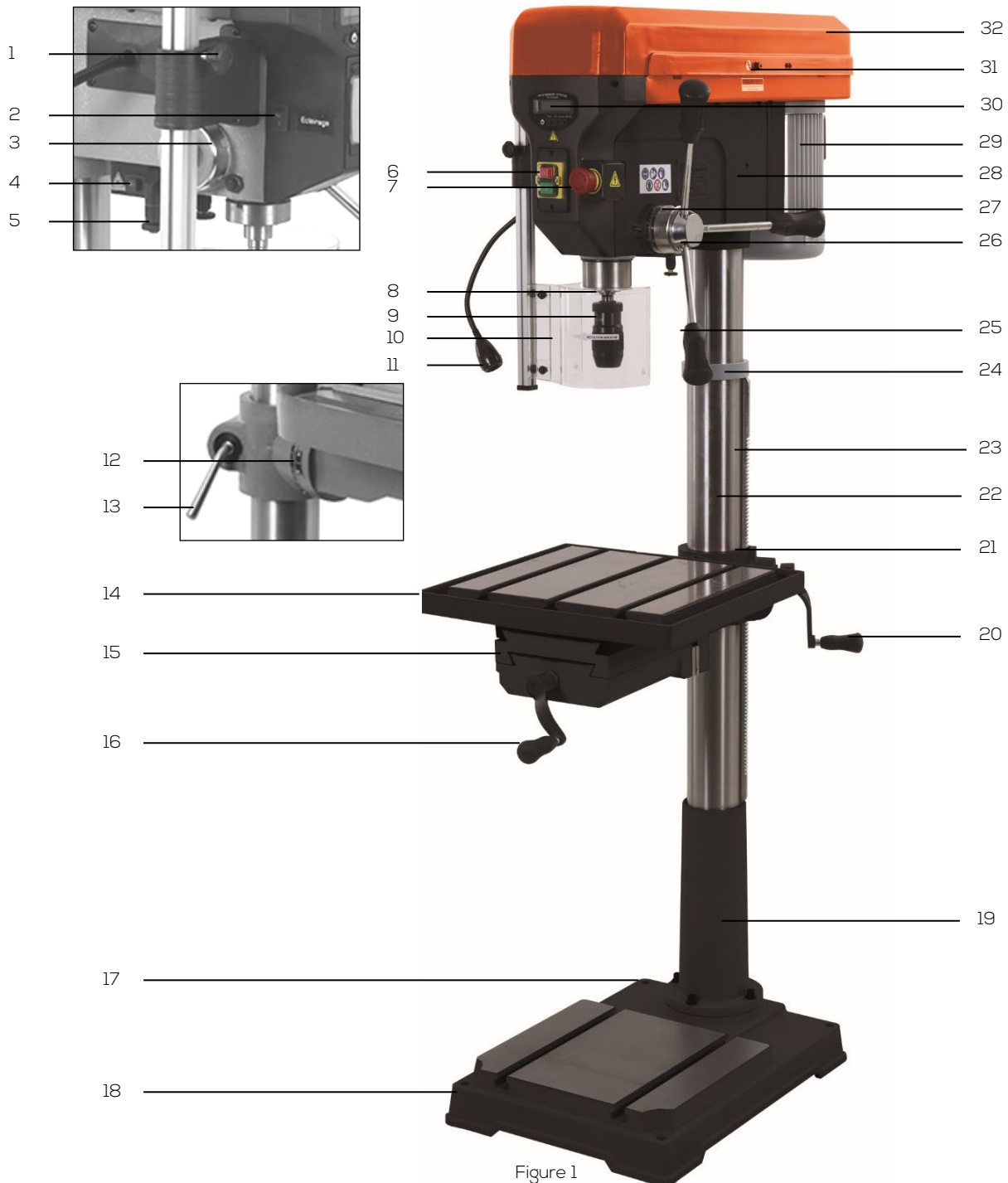


Figure 1

- |  |                                       |
|--|---------------------------------------|
| 1. Protective screen adjustment handle         | 17. Base sealing attachment point     |
| 2. LED light switch                            | 18. Base                              |
| 3. Return spring                               | 19. Column support                    |
| 4. Laser guide switch                          | 20. Table vise "UP/DOWN" crank handle |
| 5. Laser guide                                 | 21. Table vise support collar         |
| 6. ON/OFF switch                               | 22. Column                            |
| 7. Latching punch stop                         | 23. Rack                              |
| 8. Spindle                                     | 24. Rack ring                         |
| 9. Chuck                                       | 25. Capstan arm                       |
| 10. Removable chuck guard                      | 26. Capstan                           |
| 11. LED lighting                               | 27. Depth stop tightening knob        |
| 12. Graduation on table vise support collar    | 28. Drill head                        |
| 13. Clamp handle for table vise support collar | 29. Motor                             |
| 14. Reversible table                           | 30. Digital display                   |
| 15. Reversible vise                            | 31. Pulley cover screws               |
| 16. Vise handle                                | 32. Pulley cover                      |

## 5 INSTALLATION



The procedures described below must be performed by qualified and authorized personnel.

## 5.1 PACKAGING

The drill is packaged in a cardboard box on a pallet, facilitating handling, transport, and storage.

Use a pallet truck or forklift to move the drill. Several people are required to set it up.

When unpacking, remove each part of the machine, check its general condition, and then proceed with assembly.

Check that the machine is clean. The machine is delivered with the ground parts coated with a protective anti-rust oil.

If the product does not appear to be in good condition or if any parts are broken or missing, contact your dealer.

Keep the instruction manual for future reference.



A small moisture-proof bag may be included in the packaging. Keep it out of the reach of children and throw it away.

## 5.2 ASSEMBLY



Before using the drill, it must be assembled by several people:

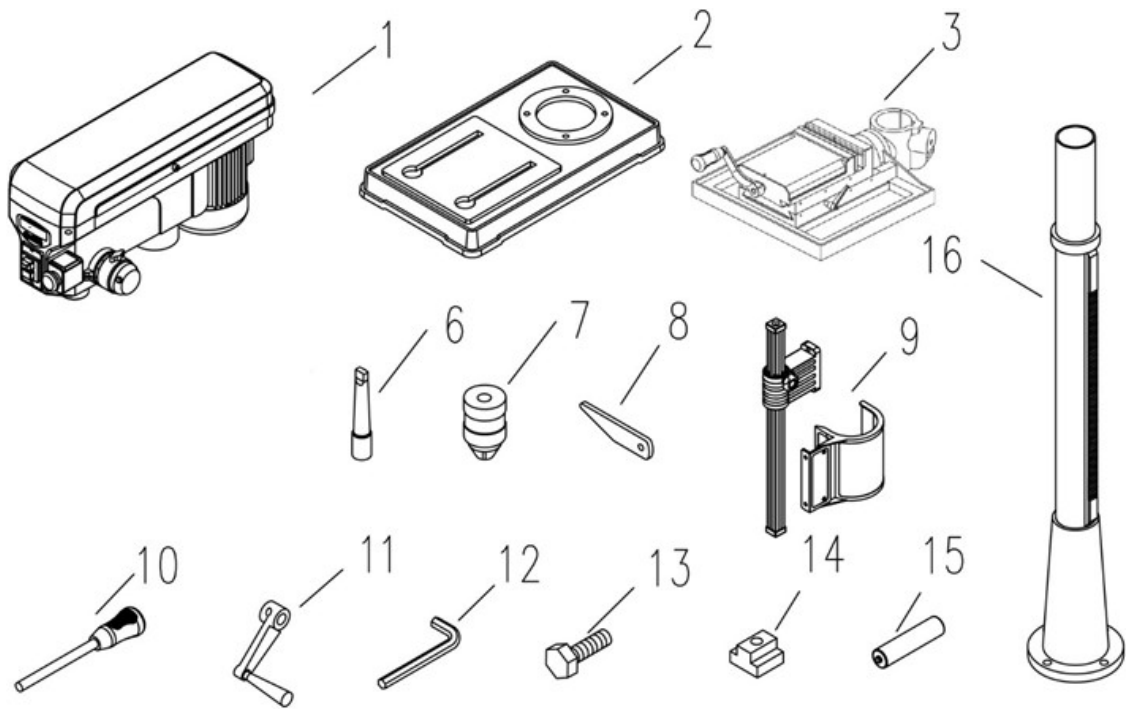
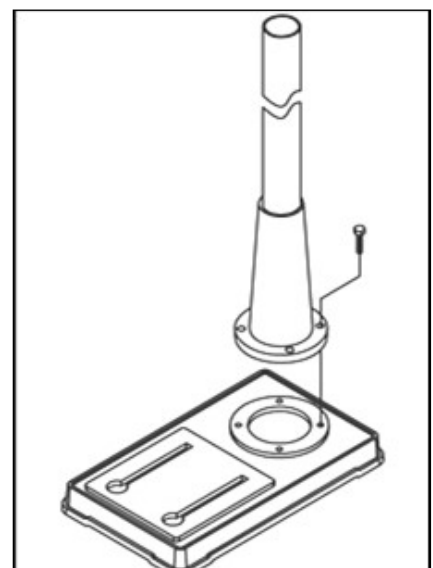
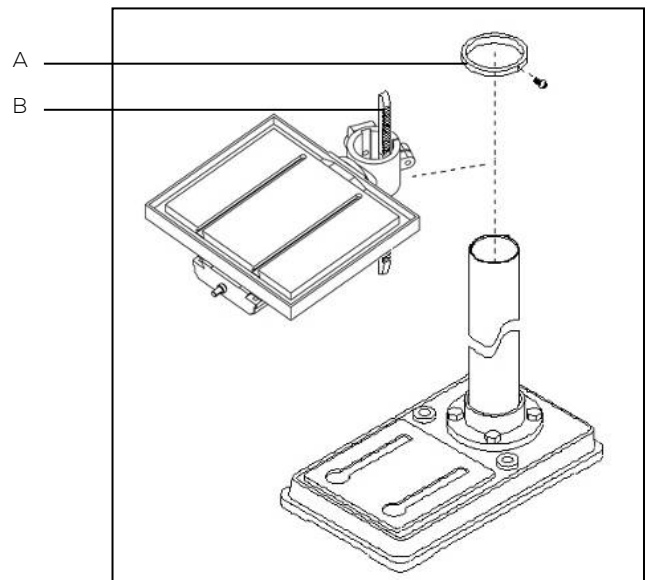



Figure 2

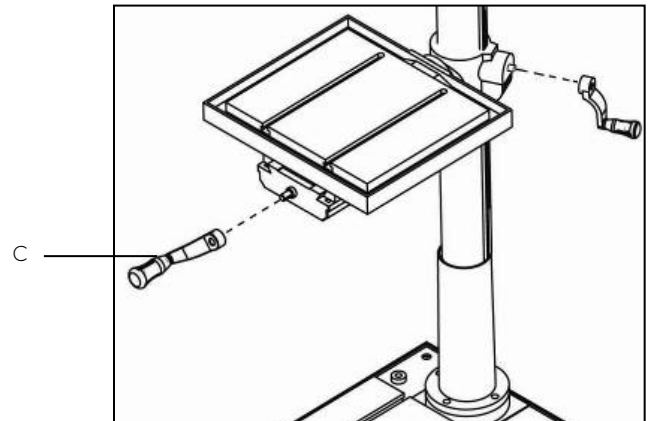
- The column (16 fig. 2) must be correctly secured to the base (2 fig. 2):
  1. Place the column on the base and align the mounting holes.
  2. Secure the column to the base with the four screws and washers (13 fig. 2).



- The reversible vise table (3 fig. 2) must be correctly installed on the column (16 fig. 2):
  3. Remove the rack ring (A) by loosening the screw using the wrench provided (12 fig.2).
  4. Remove the rack (B) from the column.
  5. Insert the locking handle for the table-vice support collar (13 fig.1).
  6. Check that the pinion of the table-vice support collar is properly inserted to connect to the worm screw.
  7. Insert the rack in the correct direction (largest flat part facing up) into the table-vice support collar.

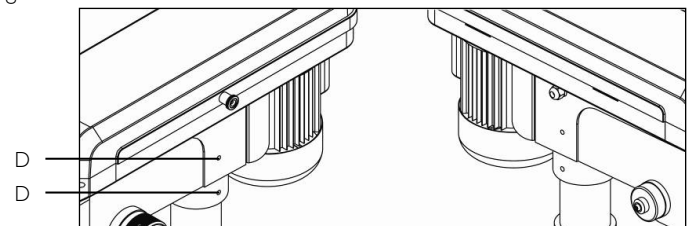



8.  With the help of at least two people, hold the rack (teeth against the inner right side of the table-vice support collar) and slide the table-vice assembly onto the column.
9. Slide the rack ring onto the column with the chamfer facing downwards to ensure that the upper end of the rack is locked in place (leave 1 mm of play with the rack).
10. Tighten the rack ring screw using the wrench provided.
11. Check that the table-vice support collar rotates properly.
12. Tighten the locking handle on the vise table support collar (13 fig.1).

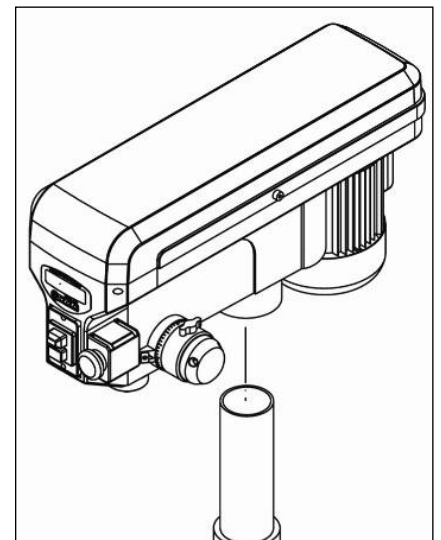


- ✓ The ideal height of the table from the floor is approximately 110 cm.

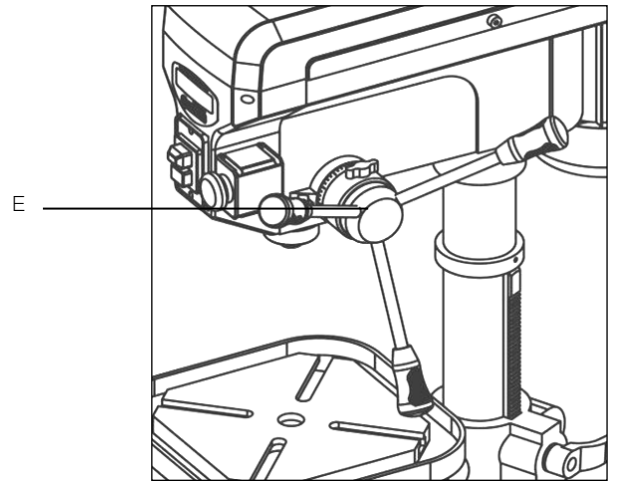
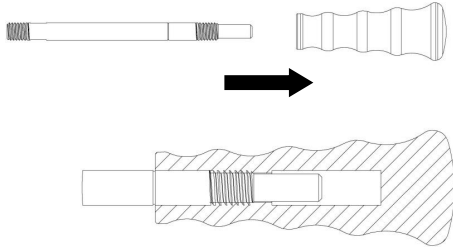
- The drill head (1 fig. 2) must be correctly installed on the column (16 fig. 2):
  16. Loosen the head clamping screws (D) located on the left or right side of the drill head using the wrench provided (12 fig.2).



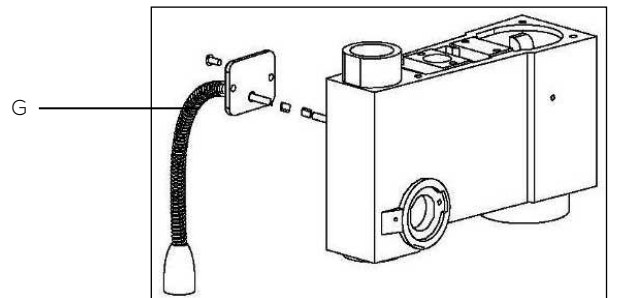
17.  With the help of at least two people, carefully lift the drill head and slide it onto the column.
18. Ensure that the head slides as far as possible along the column.
19. Check that the drill head is correctly positioned on the column.
20. Align the drill head with the base axis (2 fig.2) to ensure the unit is properly balanced.
21. Tighten the head clamping screws on the left or right side of the drill head using the wrench provided to hold the drill head in place.



- The capstan arms (10 fig. 2) must be correctly installed for spindle descent:  
22. Screw the capstan arms onto the capstan (E) and tighten.
- ✓ Screw the handles onto the arms as shown in the figure below.

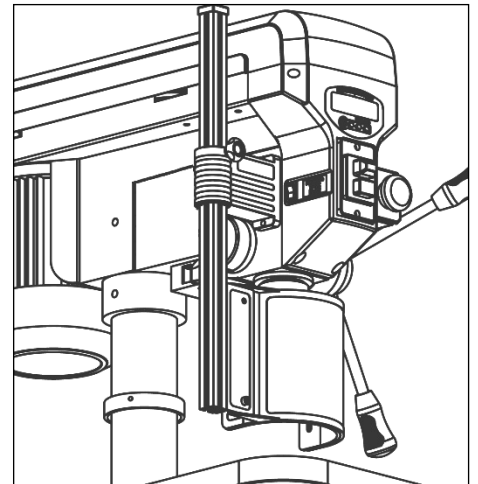


23. Connect the LED light (G) to the power terminals located in the drill.  
24. Secure it to the left side of the drill head using the appropriate screws.



- The removable servo-controlled chuck guard (9 fig.2) must be correctly installed for the machine to function properly:  
25. Assemble the complete chuck guard assembly correctly.  
26. Install the complete chuck guard assembly in its holder located on the left side of the drill head.

- ✓ See § 7.5 "CHUCK PROTECTIVE SCREEN."



## 5.3 HANDLING AND TRANSPORT

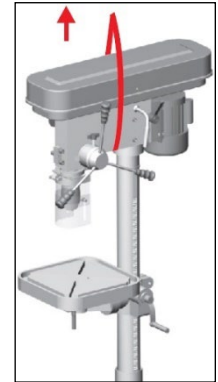


**This machine has a very high center of gravity, so be careful of the risk of tipping. Check that the screws securing the head to the column are tightened properly.**



Given the weight (130 kg) and dimensions of the machine, handling and installation must be carried out using appropriate means and with the assistance of several people.

To lift the drill, use a slinging system (e.g., polyester cables of adequate capacity with hooks) and position it as shown in the attached figure. Check that the moving parts are locked. Ensure that the head is securely locked. Lift the drill with the utmost care; keep people who are not involved in the lifting away.



## 5.4 INSTALLATION OF THE MACHINE



**Installation environment:**

- Power supply voltage in accordance with the machine specifications.
- Ambient temperature between +5°C and +35°C.
- Relative humidity not exceeding 90%.
- Sufficient ventilation at the installation site.
- Work area sufficiently lit for safe working: lighting must be 500 LUX.

Take into account the location of the machine in the room; it must allow for easy movement and maneuvering. Maintain a minimum distance of 800 mm between the rear of the machine and the wall.

The machine must be fully assembled.

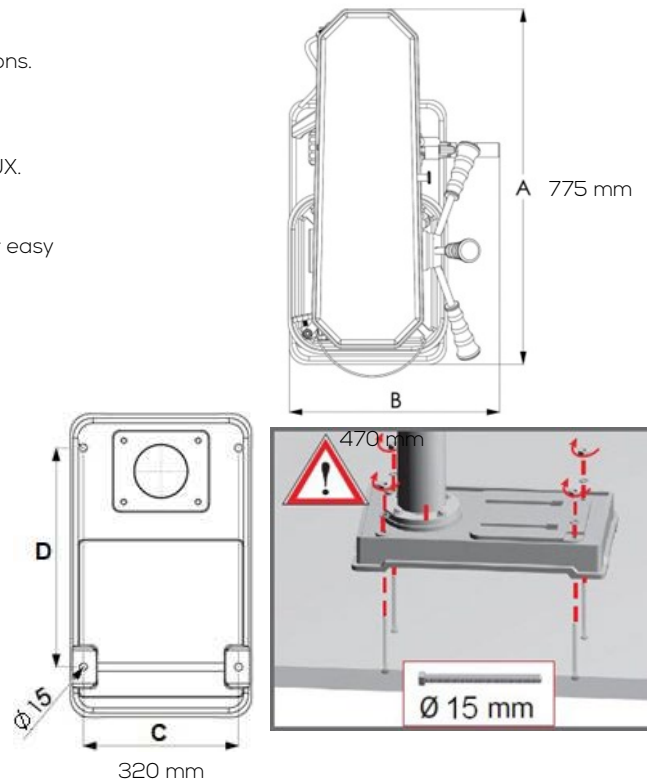


With the help of several people, position the machine on a base or workbench that is sufficiently flat, level, smooth, and non-slip, so that the machine is as stable as possible. Secure the base or workbench to a sufficiently flat and non-slip floor, so that the base or workbench is as stable as possible. Use a base or workbench with sufficient capacity.

Drill fixing holes in line with the base fixing points (17 fig.1) and proceed with fixing.

Secure the machine using appropriate washers, nuts, and bolts.

Before tightening the bolts, check that the drill is level. To correct, wedge sheets of metal of suitable thickness (gauge blocks) between the base or workbench and the base of the machine. To perform machining operations in accordance with ergonomic criteria, the ideal height for positioning the work table is approximately 110 cm from the floor.



**Cleaning the new machine:**

- All machines are delivered with the ground parts covered with a protective anti-rust grease. Before using the machine, remove this grease with a thinner. This operation is very important and must be carried out with the utmost care: failure to remove the grease could cause seizing.
- Check that the surfaces of the drill are free of dust and chips.
- After cleaning, all exposed parts must be coated with a protective oil film using a medium viscosity oil.

## 5.5 ELECTRICAL CONNECTION



**Electrical work must be carried out by qualified personnel authorized to perform low-voltage electrical work.**



**Before mounting a tool, check that the drill spindle rotates clockwise (a pictogram is present on the machine).  
The warranty does not cover damage caused by incorrect connection.**



### **ELECTRICAL PRESENCE**

Ensure that the supply voltage of the electrical installation corresponds to that of the machine.

Connect the machine to the power supply using the machine's power cable.

Check that the electrical outlet is compatible with the machine's plug (3P+T).

For the electrical connection, the socket used must comply with the "EN 60309-1" standards.

Check that the electrical installation to which the machine will be connected is properly earthed in accordance with current safety standards.

Do not use a welding machine or any other device that could overload the same electrical installation line as the machine.

We remind the user that there must always be a magnetothermal protection device upstream of the electrical installation to protect all conductors against short circuits and overloads.

This protection must always be selected based on the electrical characteristics of the machine, as specified on the nameplate:

- Voltage: 400 V single-phase
- Frequency: 50 Hz
- Motor power: 1.1 kW
- Current: 2.7 A
- Protection rating: IP 54



**Do not use a welding machine or any other device that could overload the same electrical line as the machine.**



**Use of the machine with a damaged power cable is strictly prohibited.  
Regularly check the condition of the power cord, switches, and cable gland.**



**Use an extension cord or cable reel with a cross-section and length that are compatible with the machine's power rating, and unroll them completely.  
Electrical connections and extension cords must be protected from splashes and kept on dry surfaces.**



**Do not remove the plug from the electrical outlet by pulling on the cord; pull only on the plug.**

## 5.6 INITIAL TEST AND INSPECTION BEFORE FIRST USE

- Check that the drill head is securely attached to the column, the column is attached to the base, the base is attached to a pedestal or workbench, and the pedestal or workbench is attached to a sufficiently flat and non-slip floor, so that the pedestal or workbench is as stable as possible.
- Ensure that the table is correctly positioned on its support and that the support is securely attached to the column.
- Check that the moving parts are working properly and that there are no damaged components.
- Check that the guards are in place, intact, and in good working order.
- Check the condition of the tool.
- Check that the spindle descent, chuck guard adjustment, and table "UP/DOWN" functions are working correctly.
- Check that the pulleys are correctly aligned.
- Check that the belts are correctly positioned.
- Check that the belts are correctly tensioned.
- Check that the machine runs perfectly when idle.

## 6 TOOLS



**Disconnect the machine from the power supply before changing any tools.**



**Never install a damaged tool.  
Replace the tool when it is worn or broken to avoid additional vibrations and inaccurate machining.**



**Check that the tool is clean.  
Install a tool that complies with the machine's recommendations for use.**



**The tool can become very hot during machine operation. Wait for the tool to cool before replacing it.**



**Remove all objects from the table before any operation.**



**Risk of puncture, pricking, pinching, or crushing.**

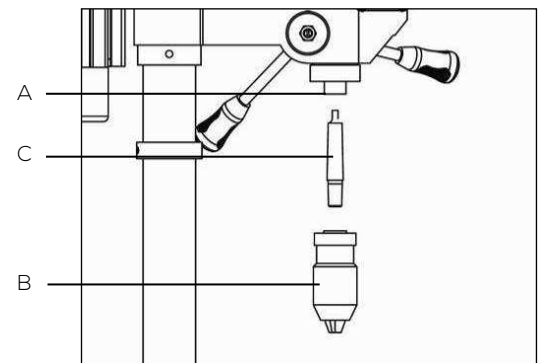


**Protective gloves must be worn.**

## 6.1 TOOL ASSEMBLY

**Procedure:**
**A. CM2 - B18 chuck shank with 1 to 16 mm self-tightening chuck - B18**

1. Degrease the inside of the spindle (A), the chuck (B), and the tapered part of the chuck tail (C) using a dry cloth.
2. Firmly push the chuck tail (C) into the chuck (B) by hand.
3. Firmly push the chuck (B) and chuck tail (C) assembly into the spindle (A) by hand.
4. Mount the  $\varnothing 1$  mm to  $\varnothing 16$  mm cylindrical shank tool in the chuck (B).


**B. Tool with tapered shank**

1. Degrease the inside of the spindle (A) and the tapered part of the tool using a dry cloth.
2. Mount the tool with a tapered shank directly into the spindle (A) (if necessary, adjust the size of the Morse taper using a suitable reducer or augments).

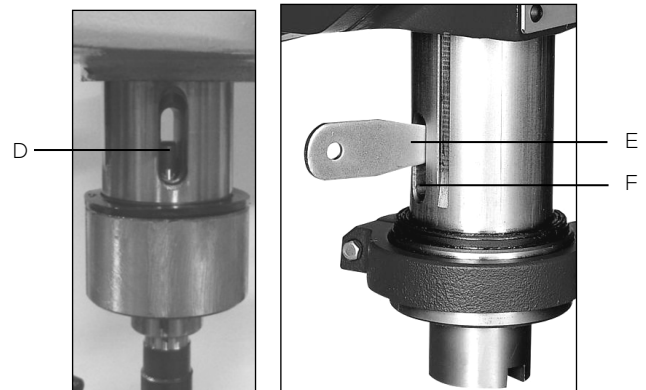


**Before assembling the chuck shank + chuck in the drill spindle, clean all contact surfaces with a thinner.  
Any oil or grease used in the packaging of these parts must be removed, otherwise the chuck may come loose during operation.**

## 6.2 TOOL DISASSEMBLY

**Procedure:**

1. Position the table approximately 250 mm below the tool.
2. Lower the spindle using the capstan arms by approximately 100 mm.
3. Lock the spindle in place using the depth stop.
4. Turn the spindle by hand so that you can see the tapered tool (D) (the spindle bore must be correctly aligned with the sleeve bore).
5. Insert a cone puller (E) into the spindle bore (F).
6. Hold the tool in your hand and tap the end of the cone puller lightly with a mallet to extract the tool.



## 7 ADJUSTMENTS



Follow the specific safety instructions for the drill (see § 3.2).



Before starting operation, familiarize yourself with the controls.



Wearing appropriate personal protective equipment is mandatory.

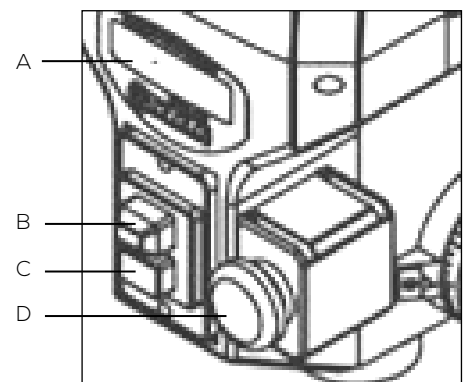


Before any maintenance or servicing operation, disconnect the machine.

## 7.1 CONTROL DEVICES

## Control panel

- A. DIGITAL DISPLAY:
  - Indicates the drilling depth.
  - Indicates the spindle rotation speed.
- B. RED SWITCH "0" OFF:
  - Stops the spindle.
- C. GREEN SWITCH "I" MACHINE OPERATION:
  - The machine spindle is activated.
- D. STOP PUNCH WITH LOCK:
  - General machine shutdown

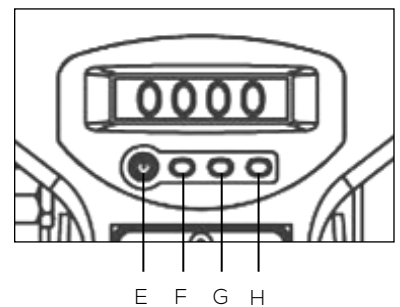


## 7.2 DIGITAL DISPLAY

The drill has a digital display that shows the drilling depth (with a tolerance of +/- 5 mm) and the drilling speed.

The display has four function keys:

- E. "Power": Activates/deactivates the digital display.
- F. "Depth/Speed": Displays the drilling depth/drilling speed.
- G. "in/mm": Selects the distance between "inch" and "mm" (millimeter).
- H. "ZERO": Resets the spindle stroke to zero.



## 7.3 DEPTH STOP

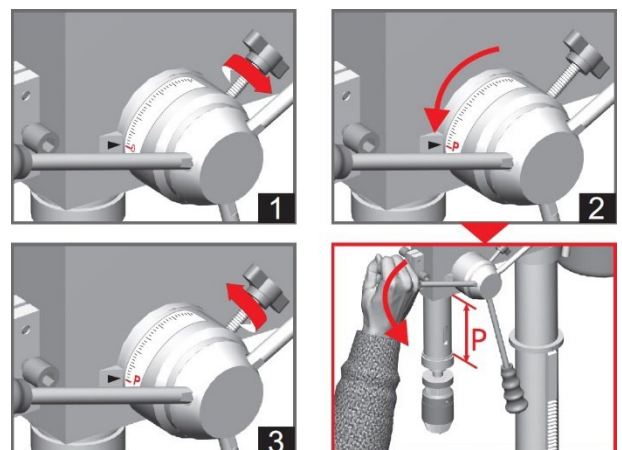


Disconnect the machine from the power supply before performing this operation.

To avoid lowering the spindle to its maximum position or to prevent drilling a through hole, the spindle descent limit can be adjusted using the depth stop located to the right of the drill head. To stop drilling at the desired depth:

1. Check that the spindle is in the upper position and that the depth stop knob is loose.
2. Rotate the scale to the desired drilling depth.
3. Lock the scale by tightening the depth stop knob.
4. Lower the spindle using the capstan arms to check the drilling depth.
5. The drilling depth is also shown on the digital display.

P = Drilling depth.



## 7.4 SPINDLE RETURN SPRING



**Disconnect the machine from the power supply before performing this operation.**

The drill is supplied with the spindle counterbalanced by a coil spring (factory-set). However, the spindle return spring may need to be adjusted if the spring tension causes the spindle to return too quickly or if the spindle no longer returns to the upper position:

1. Carefully loosen the screw (I) by a few turns.



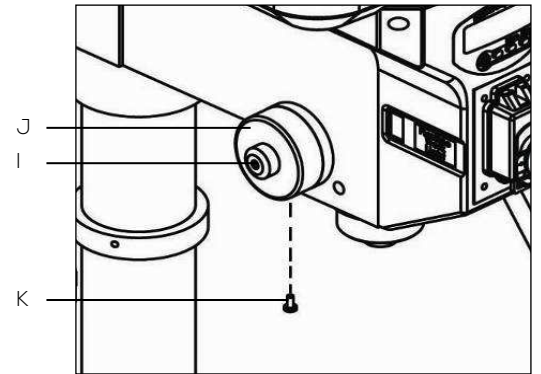
If screw (I) is completely removed, there is a risk of the spring housing (J) popping out suddenly.

2. While holding the spring housing (J) firmly, loosen and remove the screw (K).



Be careful as the spring case may pop out suddenly.

3. While holding the spring case (J) firmly, carefully turn it in the appropriate direction to increase or decrease the spring tension (counterclockwise to increase spring tension or clockwise to decrease spring tension) until a notch on the spring case aligns with the screw (K).
4. Once the adjustment has been made, tighten the screw (K).
5. Tighten the screw (I).
6. Test the spindle return.



**Avoid returning the spindle too abruptly to avoid risks and not compromise the life of the return spring.**

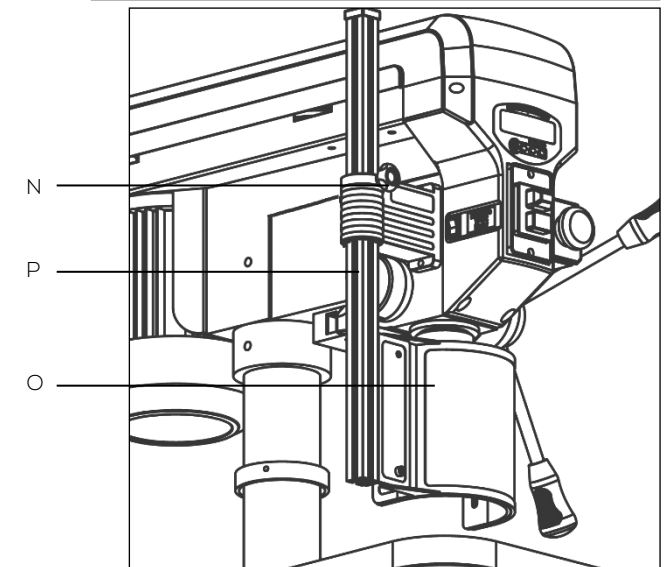
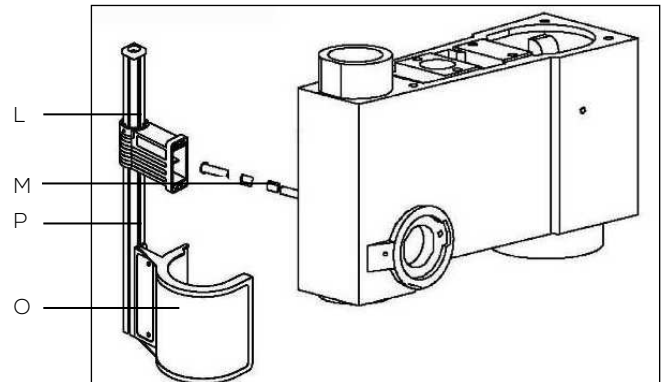
## 7.5 CHUCK PROTECTIVE SCREEN

Before operating the drill, fit and adjust the removable servo-controlled chuck guard correctly:

1. Check that the electrical connections on the protective screen support block (L) and on the electrical connections coming out of the drill head (M) are tight.
2. Connect the protective screen support block (L) to the electrical connections (M) located on the drill head.



3. Position the adjustment handle (N) located on the protective screen support block (L) upwards.
4. Mount the protective screen (O) on the screen shaft (P) using two screws.
5. Mount the assembly in the protective screen support block (L).
6. Position the screen shaft (P) and tighten the handle (N).
7. To ensure the drill operates correctly, adjust the chuck guard correctly with the shaft in the closed position (an electric safety lock ensures closure) and tighten the handle (N).



**Raising/lowering the chuck guard shaft:**

1. Loosen the handle (N).
2. Set the chuck guard (O) to the desired height using the shaft (P).
3. Tighten the handle (N).

Close the chuck guard properly before starting the machine (an electric safety lock ensures closure).

7.6  TABLE


**Stop the machine before moving the table and the material to be drilled.**



**Never hold the material to be drilled with your hands; secure it firmly using a vice or clamps.**



**Remove all objects from the table and the tool from the chuck before any operation.**



**Risk of pinching and crushing.**

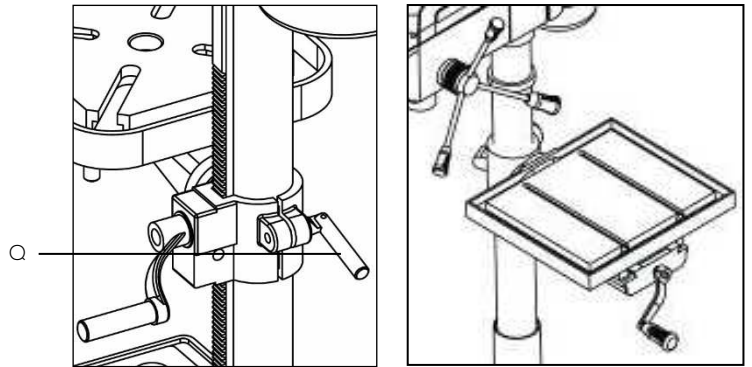


**Secure the vise (optional) or the material to the table using a set of clamps.**

✓ The maximum weight that the drill table can support is 70 kg.

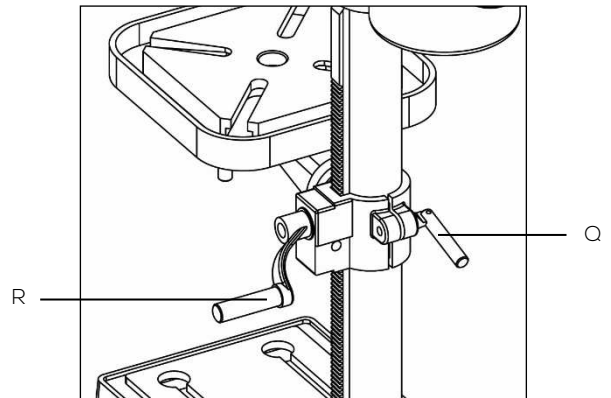
**A. Adjusting the axial position of the table:**

1. Loosen the table support collar locking handle (Q).
2. Rotate the table to the appropriate position (360° rotation of the table support collar).
3. Tighten the table support collar locking knob (Q).



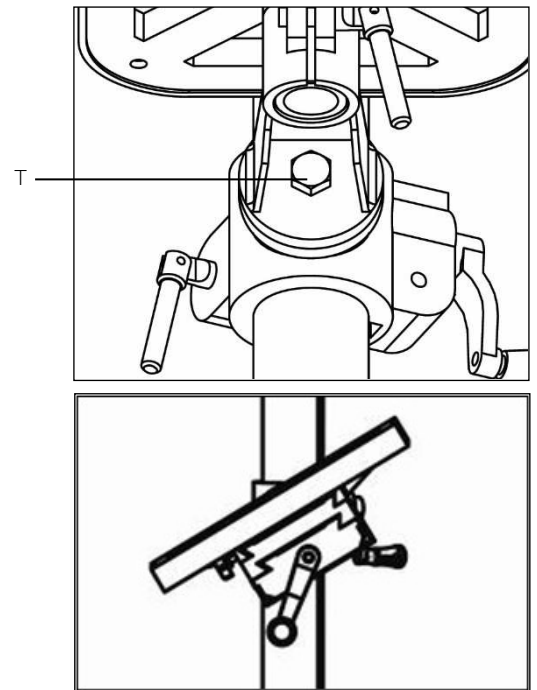
**B. Adjusting the height of the vise table:**

1. Loosen the locking handle on the vise table support collar (Q).
2. Adjust the vise table to the desired position by turning the vise table "UP/DOWN" crank handle (R).
3. Tighten the locking handle on the vise table support collar (Q).



### C. Adjusting the angle of the vise table:

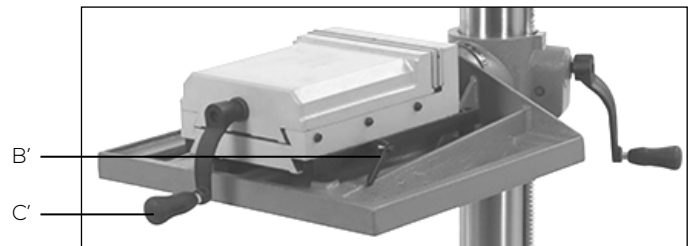
1. Adjust the height of the vise table so that there is no risk of pinching or crushing with other parts.
2. Loosen the hexagonal screw (T) located under the vise table.
3. Tilt the vise table to the desired angle to the left or right using the angle mark.
4. Tighten the hexagonal screw (T) to secure the tilt of the vise table.



**Avoid overtightening the screw to prevent breaking the pivot on the table support collar.**

### D. Adjusting the vise:

1. To slide the vise into its seat, loosen the handle (B').
2. Move the vise forward or backward depending on the part to be drilled.
3. Tighten the handle (B').
4. Hold the workpiece in place by tightening the jaws using the vise handle (C').



### E. Table:

- The table allows a vise to be attached via the grooves.
- The vise and a set of clamps are available as optional extras.



**To work safely, the material must always be securely clamped using a suitable clamping tool on the T-slot table or in the vise.**

### F. Lubrication system (optional):

- An optional lubrication system can be installed.
- The lubrication system is connected to a fitting in the table provided for this purpose.



7.7  SPINDLE ROTATION SPEED SELECTION


**The speed must be selected when the drill is stopped.**



**Risk of entanglement or winding.**

The spindle speed is adjusted by changing the position of the belts on the drive pulleys located in the pulley cover (32 fig.1).

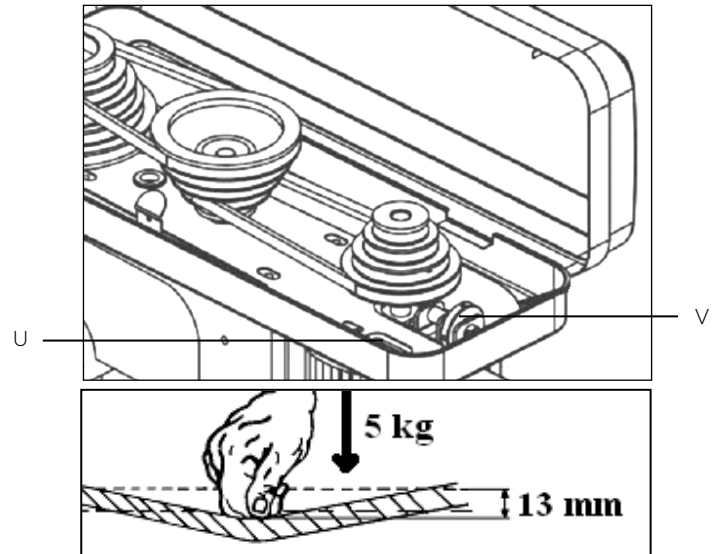
Refer to the speed table located in the pulley cover (32 fig.1).

The speed is controlled by a transmission system using toothed belts and steel pulleys.

The speed range is from 210 rpm to 2880 rpm.

To select the spindle rotation speed:

1. Stop the machine.
2. Unscrew the pulley cover screw (31 fig.1) to open the pulley cover (32 fig.1).
3. Unlock the motor by loosening the three motor tension nuts (U).
4. Turn the belt tension knob (V) counterclockwise (to the left) to move the motor forward and loosen the belts.
5. Change the position of the belts according to the table (see next page) to obtain the desired speed.
6. Turn the belt tension knob (V) clockwise (to the right) to move the motor backward and thus tighten the belts.
7. Lock the motor in place using the three motor tension nuts (U).
8. To ensure that the belts are correctly tensioned, they should have a deflection of approximately 13 mm per 5 kg of pressure.
9. Close the pulley cover (32 fig.1) and tighten the screw (31 fig.1).



The spindle speed is shown on the digital display (30 fig.1).



Only change the speed when the machine is stopped.



Close the pulley cover properly before starting the machine (an electric safety lock ensures that it is closed).



**Check that the pulleys are correctly aligned.**  
**Check that the belts are correctly positioned.**  
**Check that the belts are correctly tensioned.**



**Change the spindle speed from its raised position to its original position.**

Speed values in rpm according to gear ratio			
<b>1</b> <b>210 rpm</b>  Belts : A-1 . 5-4	<b>2</b> <b>310 rpm</b>  Belts : A-1 . 4-3	<b>3</b> <b>350 rpm</b>  Belts : B-2 . 5-4	<b>4</b> <b>460 rpm</b>  Belts : A-1 . 3-2
<b>5</b> <b>470 rpm</b>  Belts : C-3 . 5-4	<b>6</b> <b>520 rpm</b>  Belts : B-2 . 4-3	<b>7</b> <b>630 rpm</b>  Belts : D-4 . 5-4	<b>8</b> <b>690 rpm</b>  Belts : A-1 . 2-1
<b>9</b> <b>700 rpm</b>  Belts : C-3 . 4-3	<b>10</b> <b>770 rpm</b>  Belts : B-2 . 3-2	<b>11</b> <b>1300 rpm</b>  Belts : E-5 . 4-3	<b>12</b> <b>1390 rpm</b>  Belts : D-4 . 3-2
<b>13</b> <b>1560 rpm</b>  Belts : C-3 . 2-1	<b>14</b> <b>1940 rpm</b>  Belts : E-5 . 3-2	<b>15</b> <b>2070 rpm</b>  Belts : D-4 . 2-1	<b>16</b> <b>2880 rpm</b>  Belts : E-5 . 2-1

TABLE OF RECOMMENDED ROTATION SPEEDS BASED ON MATERIALS AND TOOL DIAMETERS

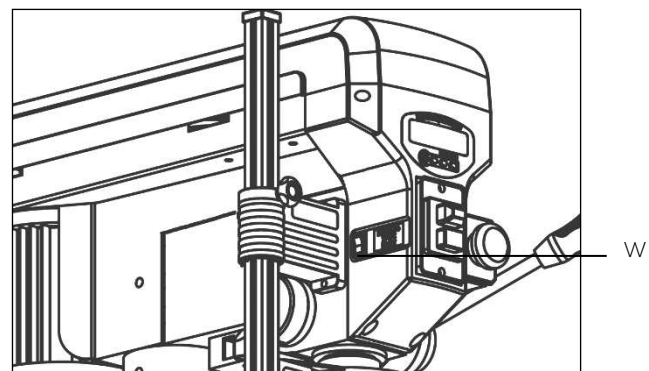
Speeds of Rotation (rpm)	Wood (mm)	Zinc (mm)	Aluminum Brass (mm)	Plastic (mm)	Cast iron Bronze (mm)	Steel Medium/hard (mm)	Steel Hard (mm)	Steel Stainless steel (mm)
2740	∅ 10	∅ 7	∅ 6	∅ 5	∅ 3.2	∅ 2.4	∅ 1.6	∅ 1.2
2270	∅ 16	∅ 10	∅ 9	∅ 8	∅ 6.5	∅ 4	∅ 3.5	∅ 2
1410 - 1540	∅ 22	∅ 12.5	∅ 12	∅ 11	∅ 9	∅ 6.5	∅ 5	∅ 3.5
970 - 1280	∅ 32	∅ 19	∅ 18	∅ 16	∅ 12.5	∅ 9.5	∅ 8	∅ 6.5
480 - 580	∅ 41	∅ 22	∅ 19	∅ 20	∅ 16	∅ 13	∅ 11	∅ 9.5
300 - 400	∅ 50	∅ 25	∅ 22	∅ 25	∅ 19	∅ 16	∅ 14	∅ 12
180 - 250	∅ 58	∅ 28	∅ 25	∅ 30	∅ 22	∅ 19	∅ 16	∅ 14

## 7.8 LED LIGHTING

The machine has LED lighting located on the left side of the drill head. The switch (W) for the LED lighting is located on the left side of the control panel.

For better visibility when drilling, the LED lighting can be turned on:

- "0": The LED lighting is off.
- "I": The LED light is on.



7.9  LASER GUIDE


**Turn off the machine before performing this operation.**



**Disconnect the machine from the power supply before opening the battery compartment.**



**Do not open the battery compartment while the drill is in operation.**

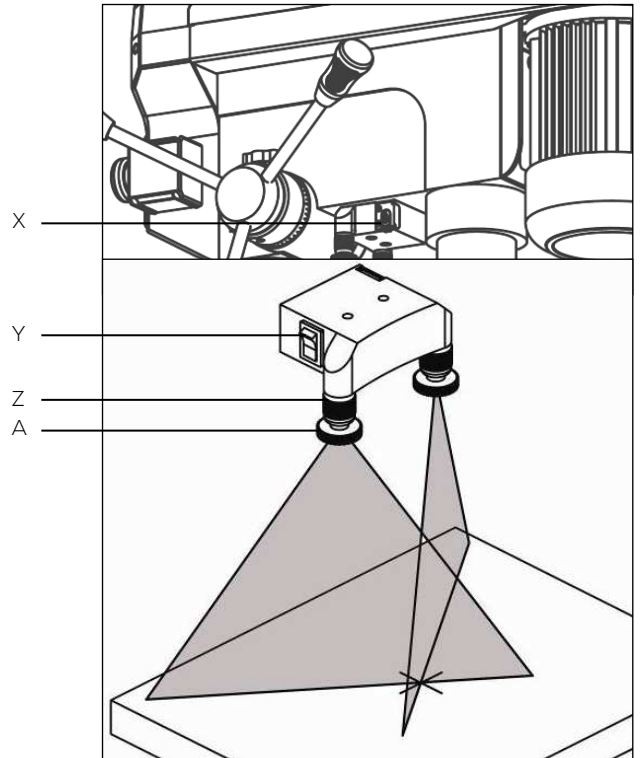
The machine has a Class 2 laser guide for drill positioning.

The laser guide must be adjusted before use. To adjust the laser guide:

1. Insert the two batteries (type AAA R03 1.5V) into the compartment (X) opposite the switch, observing the polarities.
2. Mark an "X" on the material to be drilled.
3. Insert a tool into the chuck or spindle and align its tip with the intersection of the lines of the "X" mark.
4. Press the laser switch (Y) to the "I" position to turn on the laser guide.
5. Check that the laser lines are aligned with the "X" markings on the material.
6. If the laser lines are not aligned, loosen the locking knobs (Z) on each side of the laser guide and turn the adjustment knobs (A) until the lines meet in the center of the "X" markings.
7. Tighten the locking knobs (Z) to secure them.



8. Do not move the table as this will disrupt the drilling position.



**When using the laser guide, do not point the laser beam at people or reflective surfaces. Even a low-intensity laser beam can cause eye damage. Therefore, do not look directly into the laser beam.**



**Use only AAA R03 1.5V batteries.**



**Do not attempt to recharge the batteries that were supplied.**



**Remove the batteries from the compartment if they are not going to be used for an extended period of time.**



**All batteries must be replaced at the same time.**



**In the event of damage and/or improper use of a battery, corrosive liquid may be ejected and vapors may escape: avoid contact with hands, skin, and eyes (may cause irritation or burns and may be toxic if swallowed) and ventilate the workplace (may cause respiratory tract irritation). In case of accidental contact, clean with water, and/or if you feel unwell, consult a doctor.**



**Do not throw batteries into fire (risk of explosion) or in the trash.**

**In accordance with European Directive 2006/66/EC, used or defective batteries must be isolated and recycled appropriately.**



**If the machine is stored for more than three months without being used, remove the batteries to prevent damage due to possible battery leakage.**

## 8 USE

 8.1  DRILLING PROCEDURE


Follow the specific safety instructions for the drill (see § 3.2).



Before starting operation, familiarize yourself with the controls.



Wearing appropriate personal protective equipment is mandatory.



All operations relating to the machining procedure must be carried out when the spindle is in the upper position and the tool is stopped.



Ensure that the tool is firmly locked in the chuck or spindle.



Keep hands away from machining areas when the machine is in operation.  
Before positioning the material or removing cutting waste, stop the machine.



Never hold materials to be drilled by hand; clamp them securely using appropriate tools such as vices and clamping systems.



During use, there is a risk of hot metal debris being projected.



Do not apply excessive pressure to the tool. Machining performance is not improved by applying high pressure to the tool, but the service life of the tool and machine will be reduced.



Before performing any maintenance or servicing, disconnect the machine.

**A. Instruction**

1. Ensure that the tool selected is suitable for the material to be drilled.
2. Check that the tool is sharp and securely clamped (see § 6.1).
3. Ensure that the spindle speed is appropriate for the work to be performed (see § 7.7).
4. Ensure that the material to be drilled is securely clamped to the table or in the vice to prevent it from moving during machining.
5. Adjust the height of the work table (see § 7.6).
6. Adjust the depth stop correctly (see § 7.3).
7. Adjust the chuck guard (see § 7.5).
8. Close the chuck guard (an electrical safety lock ensures closure).
9. Connect the machine's power supply.
10. Adjust the laser guide, if necessary (see § 7.9).
11. Turn on the LED light, if necessary (see § 7.8).
12. Unlock the emergency stop button and/or reconnect the safety devices.
13. Press the green "I" switch to start the machine.
14. Ensure that no one is in the path of debris caused by machining.
15. Do not start machining against the material or strike the tool against the material to be drilled, but work by applying moderate pressure to the capstan arms.
16. If necessary, use the optional lubrication system or manually apply cutting fluid to cool the tool.
17. Carefully raise the spindle once machining is complete.

**B. Shutdown**

1. Press the red "0" switch to turn off the spindle.
2. Turn off the laser guide.
3. Turn off the LED light.
4. Lock the push-button stop switch.
5. Open the chuck guard.



When machining is complete, return the spindle to its starting position (rest, upward).

## 8.2 OPERATING INCIDENTS

### A. Tool jamming in the material



**Protective gloves must be worn.**

1. Stop the machine by pressing the emergency stop button.
2. Open the chuck guard.
3. Carefully release the tool by turning the chuck counterclockwise while raising the spindle with the spindle lowering arms.
4. Carefully remove the material.
5. Check that the tool is not damaged.
6. When the tool is tightened, replace the chuck guard.
7. Unlock the punch stop.



**Replace the tool if it is damaged.**



**Work by applying more moderate pressure on the capstan arms.**

### B. Chip winding around the tool



**Do not remove the chip by hand.**

If the chip becomes twisted:

1. Reassemble the tool.
2. If this is not enough to eject the chip, stop the machine immediately by pressing the emergency stop button.
3. Remove the chip using a hook.

### C. Restarting a cycle after a safety stop

1. Unlock the emergency stop button.
2. Carefully raise the spindle.
3. Press the green "I" switch to start the machine.

### D. Power failure

1. Carefully raise the spindle.
2. Press the green "I" switch to start the machine.



**The machine is equipped with an electrical system with a low voltage device (preventing accidental restarting).**

8.3  TABLE OF FAULTS AND SOLUTIONS

FAULT	PROBABLE CAUSE	SOLUTION
The machine does not work:	<ul style="list-style-type: none"> <li>▪ No power supply.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Check the power supply.</li> <li>➤ Check the power outlet.</li> <li>➤ Check the power cable.</li> <li>➤ Call an authorized repair technician.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ A safety device has been activated.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Check that the pulley cover is properly closed.</li> <li>➤ Check that the chuck guard is properly closed.</li> <li>➤ Check that the punch stop is unlocked.</li> </ul>
Noisy operation:	<ul style="list-style-type: none"> <li>▪ Incorrect belt tension.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Adjust the belt tension correctly.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Spindle not lubricated or dirty.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Clean and lubricate the spindle.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Loose pulleys.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Tighten the pulleys.</li> </ul>
The tool is burned or smoking:	<ul style="list-style-type: none"> <li>▪ Incorrect spindle speed.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Change the spindle speed.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Chips not being removed from the drill hole.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Frequently remove the tool and clean the drill hole.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Difficult machining.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Sharpen or replace the tool.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ No lubrication.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Lubricate the tool.</li> </ul>
Excessive vibration:	<ul style="list-style-type: none"> <li>▪ Bent tool.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Use a straight tool.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Tool not properly secured in the chuck.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Secure the tool correctly.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Chuck incorrectly installed.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Reinstall the chuck correctly.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Spindle bearings defective.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Replace the spindle bearings.</li> </ul>
The tool remains attached to the material:	<ul style="list-style-type: none"> <li>▪ Material pinching the tool or excessive pressure applied.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Secure the material firmly or reduce the pressure.</li> </ul>
	<ul style="list-style-type: none"> <li>▪ Incorrect belt tension.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Adjust the belt tension correctly.</li> </ul>
The part is no longer secured:	<ul style="list-style-type: none"> <li>▪ No proper support or clamping.</li> </ul>	<ul style="list-style-type: none"> <li>➤ Support or clamp the part to be drilled correctly.</li> </ul>

 8.4  TAKING THE MACHINE OUT OF SERVICE

If the drill is not to be used for an extended period of time, it is recommended to proceed as follows: Unplug the power cord from the power supply.

1. Remove the batteries from the laser guide compartment.
2. Remove all objects from the table and the tool from the chuck.
3. Release the return spring.
4. Clean and lubricate the machine carefully.
5. Cover the machine if necessary.

## 9 MAINTENANCE



**Before performing any maintenance or servicing, disconnect the machine.**



**Wear gloves and protective eyewear, and use a clean, dry cloth, brush, long-handled brush, hook, magnetic collector, or vacuum cleaner for all cleaning operations (especially when removing chips, which may be sharp and hot).**



**Do not use a blow gun to remove machining chips.  
Do not use solvents or aggressive detergents for cleaning.  
Do not immerse the machine in water or wash it with a water jet.**



**Chips are often very sharp and hot. Do not touch them with your bare hands.**

To maintain the efficiency of the machine and its components, it is necessary to carry out maintenance.

Below are the most important maintenance tasks, which can be classified according to their frequency as daily, weekly, monthly, semi-annual, and special tasks.

Failure to perform the prescribed tasks will result in premature wear and tear and reduce the performance of the machine.


 9.1  DAILY MAINTENANCE

- Clean the machine as normal to remove any chips that have accumulated (collect them in bins).
- Clean the spindle cone.
- Check the tools for wear.
- Lubricate all sliding and ground parts before starting up the drill (pay particular attention to the sleeve and column).
- Lubricate the mechanism for raising and lowering the table located in the table support collar.
- Check the operation of the protective covers, safety devices, and stop devices.
- Check that the motor ventilation grilles are clear.
- Check and replace the power cable if necessary.

 9.2  WEEKLY MAINTENANCE

- Clean the machine thoroughly and carefully, removing any chips (collect them in bins).
- Clean and lubricate the spindle.
- Sharpen the tools.
- Check that the protective covers and control mechanisms are working properly, looking for any defects.
- Check that the screws are tight.

 9.3  MONTHLY MAINTENANCE

- Check that all screws are tight, especially those on the motor and protective covers.
- Check the integrity of the protective covers and devices.
- Check that the pulleys are tight.
- Clean and grease the spindle pulley section.
- Coat exposed parts with a protective oil film.

 9.4  SIX-MONTHLY MAINTENANCE

- Test the continuity of the equipotential protection circuit.

## 9.5 BELTS



**Use original belts to ensure correct tension.**



**Check that the pulleys are correctly aligned.  
Check that the belts are correctly positioned.  
Check that the belts are correctly tensioned.**

The drill has three pulleys in the pulley cover, driven by two toothed belts:

- XPZ480 motor side belt;
- Spindle side belt V10X590.

An electrical safety lock prevents the machine from operating when the pulley cover is open.

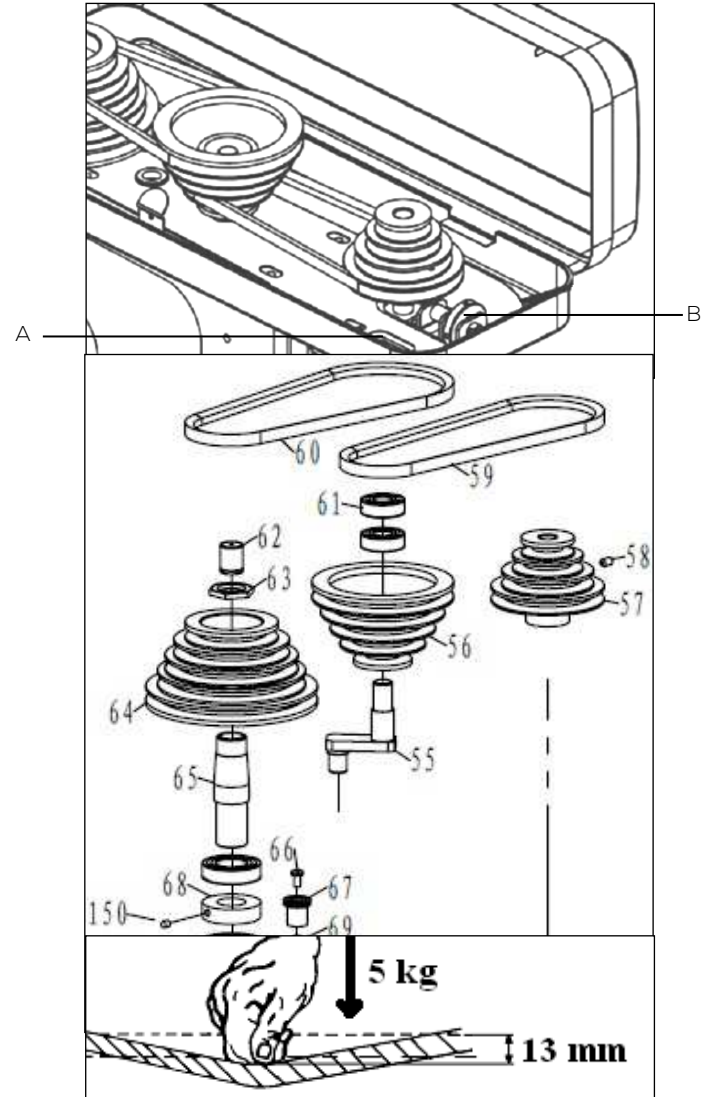
Check the belts regularly for wear.

#### A. Replacing the motor-side belt (item 59):

1. Stop the machine.
2. Unscrew the pulley cover screw (31 fig.1) to open the pulley cover (32 fig.1).
3. Unlock the motor by loosening the three motor tension nuts (A).
4. Turn the belt tension knob (B) counterclockwise (to the left) to move the motor forward and thus loosen the motor side belt (item 59) and the spindle side belt (item 60).
5. Remove the motor side belt (item 59).
6. Clean the inside of the pulley cover, the motor pulley (item 57), and the center pulley (item 56).
7. Correctly install the new motor-side toothed belt in the central pulley housing (item 56) and the motor pulley (item 57).
8. Turn the belt tension knob (B) clockwise (to the right) to move the motor backward and thus retighten the motor side belt (item 59) and the spindle side belt (item 60).
9. Lock the motor in place by tightening the three motor tension nuts (A).
10. To ensure that the motor side belt is correctly tensioned, it should have a deflection of approximately 13 mm per 5 kg of pressure.

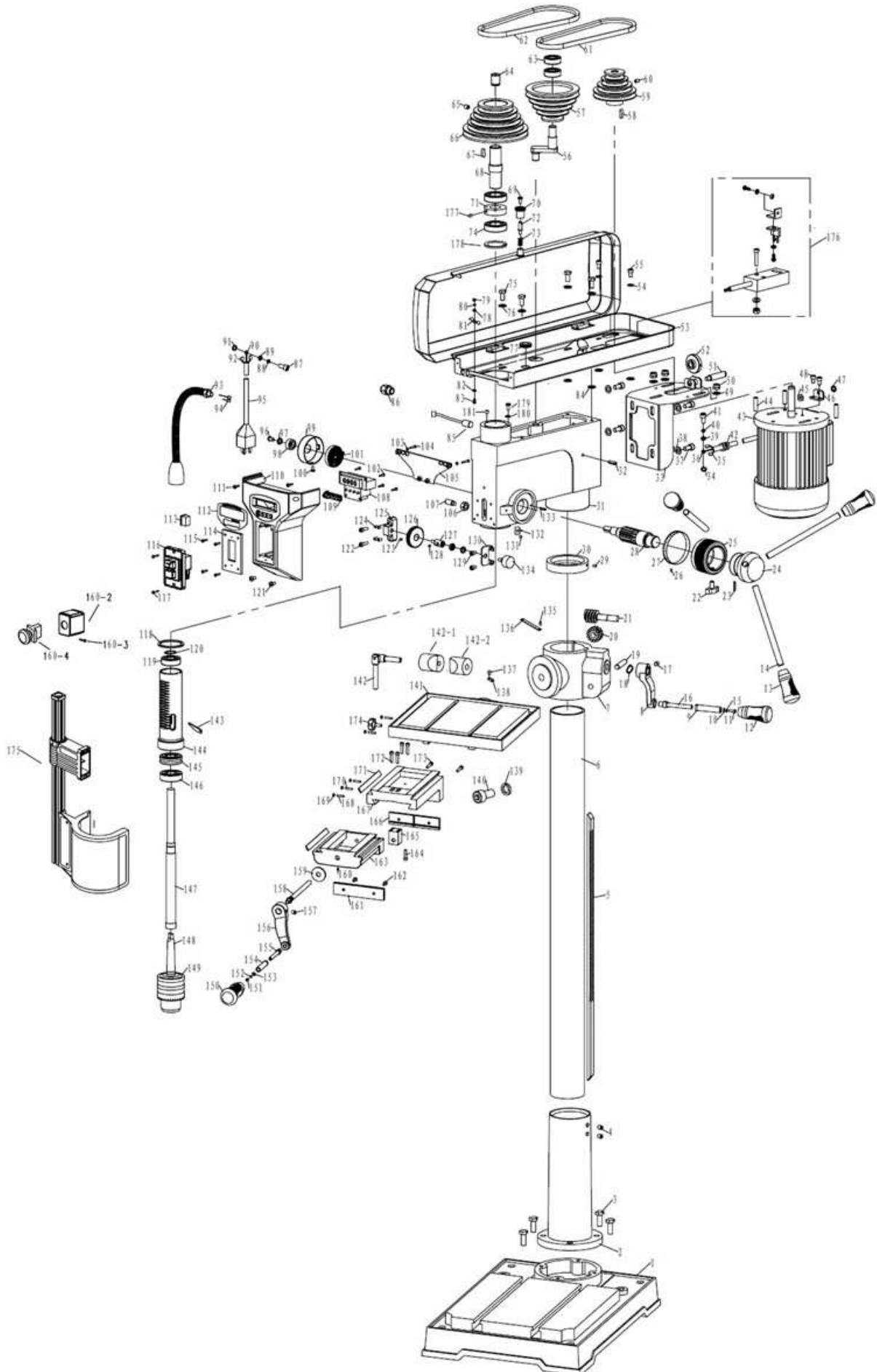
#### B. Replacing the belt on the spindle side (item 60):

1. Follow steps 1 to 4 above.
2. Remove the belt on the spindle side (item 60).
3. Clean the inside of the pulley cover, the spindle pulley (item 64), and the center pulley (item 56).
4. Correctly install the new toothed belt on the spindle side in the spindle pulley housing (item 64) and the center pulley (item 56).
5. Turn the belt tension knob (B) clockwise (to the right) to move the motor backward and thus retighten the motor side belt (item 59) and the spindle side belt (item 60).
6. Lock the motor in place by tightening the three motor tension nuts (A).
7. To ensure that the belt on the spindle side is correctly tensioned, it should have a deflection of approximately 13 mm per 5 kg of pressure.
8. Close the pulley cover and tighten the screw.



## 10 EXPLODED VIEW

## EXPLODED VIEW PPSC30TE (VIEW 01)



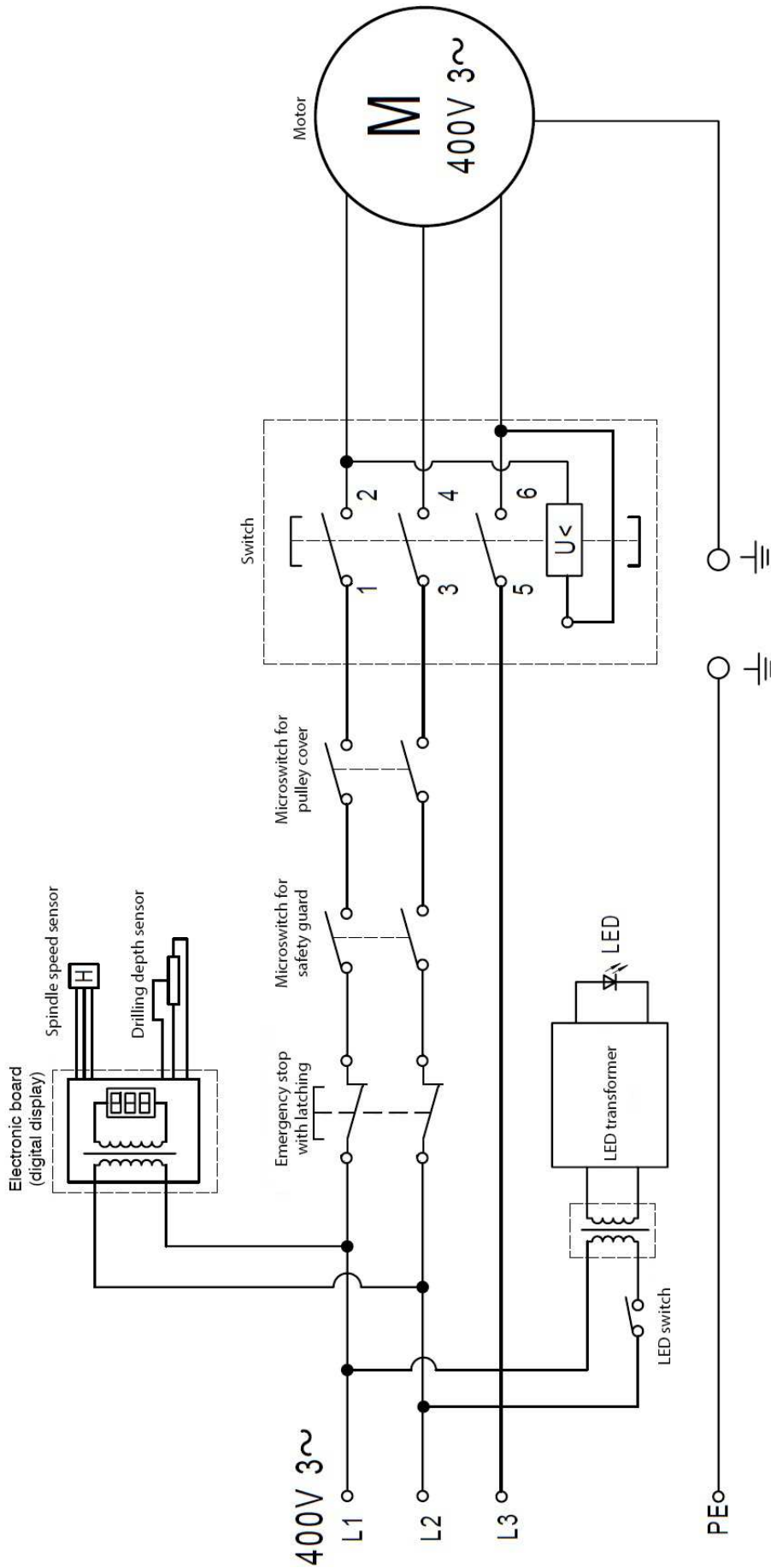
## PARTS LIST EXPLODED VIEW PPSC30TE (VIEW 01)

Reference	Description	Quantity
01	DRILL BASE #RAL 9004	1
02	COLUMN SUPPORT	1
03	M10x30 BOLT	4
04	M10x10 SCREW	2
05	RACK	1
06	COLUMN	1
07	TABLE VISE SUPPORT COLLAR	1
08	CRANK	1
09	SOCKET	1
010	M4 WASHER	1
011	M4x8 SCREW	1
012	HANDLE	1
013	HANDLE	3
014	CAPSTANE ARM	3
015	M4 BRAKE WASHER	1
016	AXLE	1
017	M8x10 SCREW	1
018	CIRCLIP Ø14	1
019	PINION SHAFT	1
020	PINION	1
021	WORM SCREW	1
022	M8x18 BUTTERFLY SCREW	1
023	PIN	1
024	CAPESTAN	1
025	THRUST BEARING	1
026	RIVET 2.5x6	1
027	DRILLING DEPTH MARK	1
028	PINION SHAFT	1
029	M6x10 SCREW	1
030	RACK RING	1
031	HEAD	1
032	PIN 6x20	1
033	ENGINE MOUNT	1
034	M4 DENTAL FITTING	1
035	CONNECTION	2
036	EARTH CONNECTION	4
037	M8x16 BOLT	4
038	M9 WASHER	4
039	M4 WASHER	1
040	M4 LOCK WASHER	1
041	M4x10 SCREW	1
042	MOTOR POWER CABLE	1
043	400V THREE-PHASE 1100W MOTOR	1
044	M8x35 SCREW	3
045	M8 LOCK NUT	1
046	PLATE	1
047	M8 WASHINGMACHINE	1
048	M6x10 SCREW	2
049	M9 WASHER	3
050	M8 LOCK NUT	3
051	AXLE	1
052	TENSION WHEEL	1
053	PULLEY COVER #RAL 2008	1
054	M6 WASHER	2
055	M6x6 BOLT	2
056	CENTRAL PULLEY SUPPORT	1
057	CENTRAL PULLEY	1
058	KEY C6x40	1
059	PULLEY MOTOR SIDE	1
060	LOCKING SCREW M8x10	1
061	ENGINE SIDE BELT AV13X745	1
062	SPINDLE SIDE BELT AV13X770	1
063	BEARING 6202	2
064	GREASE NIPPLE	1
065	LOCKING SCREW M8x10	1
066	SPINDLE SIDE PULLEY	1
067	KEY C10x8x35	1
068	PULLEY SUPPORT SPINDLE SIDE	1
069	M4x10 SCREW	1
070	CORE	1
071	MAGNETIC SUPPORT	1
072	SCREW	1
073	SPRING	1
074	BEARING 6205	2
075	M8x12 BOLT	4
076	M8 WASHER	4
077	M22 RUBBER RING	2
078	M5 WASHER	2
079	M5 NUT	2
080	M5 LOCK WASHER	2
081	FLANGE	2
082	M5 WASHER	2
083	M5x20 SCREW	2
084	RUBBER WASHER 9x18x2.5	6
085	SENSOR	1
086	M16 CABLE GLAND	1
087	M4x10 SCREW	1
088	M4 LOCK WASHER	1
089	M4 WASHER	1
090	GROUND CONNECTION	1
091	M4 DENTAL FILLING	1
092	CONNECTION	2
093	LAMP	1
-	MOUNTING PLATE	1
-	M4x8 SCREW	4
094	CONNECTION	2

095	THREE-PHASE POWER CABLE	1
096	M6x12 SCREW	1
097	WASHER 18x6,5x2	1
098	NUT	1
099	RETURN SPRING HOUSING	1
100	M4x8 SCREW	1
101	RETURN SPRING	1
102	ST2,9x9,5 SCREW	4
103	M4 WASHER	4
104	ST2,9x13 SCREW	4
105	PLATE	1
106	M10 NUT	1
107	M10x27 SCREW	1
108	ELECTRONIC BOARD	1
109	BUTTON	1
110	PANEL	1
111	M4x16 SCREW	2
112	STICKER	1
113	LIGHT SWITCH	1
114	CONTROL BOX SUPPORT	1
115	ST2,9x9,5 SCREW	4
116	THREE-PHASE CONTROL BOX	1
117	ST4,2x12 SCREW	3
118	RUBBER RING	2
119	BEARING 6203	1
120	CIRCLIP Ø17	1
121	M4x12 SCREW	1
122	M4x16 BOLT	2
123	M4x6 SCREW	1
124	M4x6 SCREW	4
125	SENSOR SUPPORT	1
126	KNOB	1
127	AXLE	1
128	M4x6 SCREW	1
129	M4x6 BOLT	2
130	SENSOR PLATE	1
131	RIVET 2,5x6	1
132	POINTER	1
133	M6x5x28 SCREW	1
134	SENSOR	1
135	RIVET 2,5x6	2
136	TABLE INCLINE MARK	1
137	RIVET 2,5x6	2
138	POINTER	1
139	M20 LOCK WASHER	1
140	M20x55 BOLT	1
141	TABLE FOR DRILL #RAL 9004	1
142	TABLE LOCKING HANDLE	1
142-1	CLAMP FLANGE	1
142-2	CLAMP FLANGE	1
143	PUSH CONE	1
144	SPINDLE SHEATH	1
145	BEARING	1
146	BEARING 6206	1
147	SPINDLE	1
148	XPLR+QM CM3 - B18 CHUCK SHANK	1
149	XPLR+MAS SELF-CLAMPING CHUCK FROM 1 TO 16 MM B18	1
150	HANDLE	1
151	M4x8 SCREW	1
152	M4 LOCK WASHER	1
153	M4 WASHER	1
154	SLEEVE	1
155	AXLE	1
156	CRANK	1
157	M8x10 SCREW	1
158	THREADED ROD	1
159	WASHER Ø14xØ30x4	1
160	M8x12 SCREW	1
160-2	HANGING PUNCH STOP BOX	1
160-3	SELF-TAPPING SCREW	4
160-4	HANGING PUNCH STOP	1
161	UPPER VISE JAW	1
162	M8x12 SCREW	2
163	UPPER CLAMP	1
164	M8x40 BOLT	1
165	NUT	1
166	LOWER VISE JAW	1
167	LOWER VISE	1
168	M6x35 SCREW	2
169	M6 NUT	5
170	M6x30 SCREW	3
171	WEDGE	2
172	M8x25 BOLT	4
173	M8x20 BOLT	2
174	M10 INDEXABLE HANDLE	1
175	THREE-PHASE CHUCK PROTECTION KIT	1
176	OKS8 COVER-PULLEY MICROSWITCH (250V 10A / VS10N)	1
177	MAGNET	1
178	RESTRAINT RING	1
179	SCREW	3
180	WASHER	3
181	SCREW	1

## 11 WIRING DIAGRAM

## ELECTRICAL DIAGRAM PPSC30TE



## 12 NOISE LEVEL

The noise level emitted by this machine during operation will depend on the type of material being ground and the type of grinding wheel. For this reason, the measurement data is relative.

The risk of hearing damage to the operator depends on the length of exposure to noise.

The operator must wear ear defenders or other appropriate personal protective equipment when the sound power exceeds 85 dB(A) in the workplace.

- Average sound pressure level:  
**LpAm = 75.2 dB(A)**
- Sound power level:  
**LwA = 88.2 dB(A)**

The sound power calculation was performed taking into account factors such as: reverberation at the test site, ground noise absorption, and other factors that may interfere with

measurements. This estimate allows us to state that the degree of error in the values obtained would be around 3 dB(A).

The values given are emission levels and not necessarily levels that allow for safe working. Although there are correlations between emission levels and exposure levels, these cannot be used reliably to determine whether additional precautions are necessary. Parameters that influence actual exposure levels include workshop characteristics, other sources of noise, etc., i.e., the number of machines and neighboring manufacturing processes. In addition, permissible exposure levels may vary from country to country. However, this information allows the machine user to make a better risk assessment.



## 13 VIBRATION LEVEL

The data relating to the vibrations transmitted by this machine during the working process will depend on the type of material being ground and the type of grinding wheel. For this reason, the measurement data is relative.

Exposure to vibrations can have serious consequences for the health of workers. A person exposed daily to high-amplitude vibrations may develop neurological and joint disorders in the long term.

The exposure level assessment is based on the calculation of the daily exposure value A(8), normalized to a reference period of 8 hours.

Whenever an employee is exposed to A(8) vibrations exceeding the daily exposure level triggering action set at 2.5 m/s<sup>2</sup>, the

These values must be taken into account when assessing the level of exposure.

Regular and frequent exposure to a highly vibrating work tool exposes workers' hands and arms to chronic disorders known as "vibration syndrome."

- Average hand/arm vibration level:  
**A(8) < 2.5 m/s<sup>2</sup>**

employer must assess the risks of the task assigned to the employee and implement control measures.

Exposure values for vibrations transmitted to the hand-arm system:

- Daily exposure limit value A(8) = 5 m/s<sup>2</sup>
- Daily exposure value triggering action A(8) = 2.5 m/s<sup>2</sup>

## 14 ENVIRONMENTAL PROTECTION

Your machine contains many recyclable materials.

This logo indicates that used machines must not be mixed with other waste.

This will ensure that the machines are recycled under the best conditions, in accordance with European Directive WEEE 2012/19/EU on waste electrical and electronic equipment.

Contact your local council or dealer to find out where your nearest collection points for used machines are located.

Thank you for your  
protecting the



cooperation in  
environment.

## 15 WARRANTY

If the machine is covered by warranty, it must be serviced exclusively by an authorized after-sales service center.

The machine warranty is valid for 2 years from the date of purchase by the user.

This product benefits from an additional 2-year warranty extension, provided that the user registers the product on the PEUGEOT OUTILS PROFESSIONNELS website ([www.peugeot.outils-pro.com](http://www.peugeot.outils-pro.com)) within 30 days of the date of purchase. This warranty extension is subject to the same conditions as the initial warranty.

Accessories and consumables are not covered by the warranty.

It is important to keep the invoice, which serves as the warranty certificate.

The warranty is limited to the repair or replacement of defective parts free of charge, after evaluation by the manufacturer.

For any requests for information or spare parts relating to the machine, it is essential to provide the exact information shown on the nameplate. The warranty does not cover damage caused by the user or by a repairer not approved by Tivoly.

Link to the General Warranty Terms and Conditions:



# CEAL DECLARATION OF CONFORMITY "ORIGINAL"

The undersigned (Manufacturer/Importer):

**TIVOLY**

**266 ROUTE PORTES DE TARENTEISE 73790 TOURS-EN-SAVOIE**

Declares that the following new machine:

- Designation: FLOOR DRILL PRESS
- Brand: PEUGEOT PROFESSIONAL TOOLS
- Model: PPSC30TE
- Reference: PPM00400002
- Serial number:

Complies with applicable harmonized legislation:

- **Machinery Directive 2006/42/EC (until January 19, 2027)**
- **EU Regulation 2023/1230 (from January 20, 2027)**

Complies with the essential safety requirements applicable to it:

- **Low Voltage Directive 2014/35/EU**
- **Electromagnetic Compatibility Directive 2014/30/EU**
- **WEEE Directive 2012/19/EU**
- **RoHS-2 Directive 2011/65/EU**
- **REACH 1907/2006**
- **Noise Directive 2003/10/EC**
- **Vibration Directive 2002/44/EC**


Done at TOURS-EN-SAVOIE  
On

Stéphane Le Mounier  
Managing Director



Person authorized to compile the technical file:

- M. LE MOUNIER – TIVOLY – 266 ROUTE PORTES DE TARENTEISE 73790 TOURS-EN-SAVOIE

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	In its ongoing effort to improve the quality of its products, TIVOLY reserves the right to modify their characteristics. The information, photos, exploded views, and diagrams contained in this document are not contractual.	Published by april 2026 Instruction manual PPSC30TE