

Operation Manual

Adjustable Hole Cutter

63255, 63256, 63257



Illustration similar, may vary depending on model

Read and follow the operating instructions and safety information before using for the first time.

Technical changes reserved!

Due to further developments, illustrations, functioning steps, and technical data can differ insignificantly.

Updating the documentation

If you have suggestions for improvement or have found any irregularities, please contact us.



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Introduction

Thank you for purchasing this quality product. **To minimise the risk of injury we urge that our clients take some basic safety precautions when using this device. Please read the operation instructions carefully and make sure you have understood its content.**

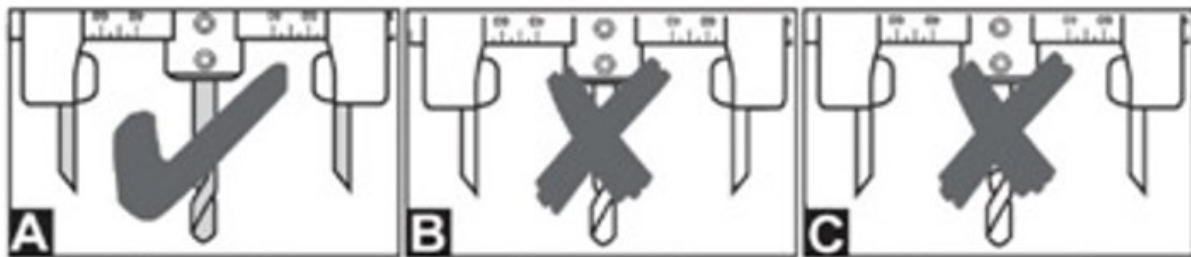
Keep these operation instructions safe.

Safety instructions

- If possible, only use the hole cutter in stationary machines, e.g., on upright drilling machines.
- Keep your work area tidy and well lit. Untidy and poorly lit work areas increase the risk of accidents.
- Only operate with a suitable drill bit.
- Wear appropriate protective equipment, especially safety goggles, during use.
- Keep your hands away from the moving parts and the blades! **Risk of injury!**
- Make sure that the workpiece is firmly clamped. Loosening of the workpiece by the hole cutter can cause damage to property and personal injury.
- Before each use, check the blades of the hole cutter for damage, wear, and correct attachment. Do not use the cutter if any parts are damaged or loose.
- Only use the hole cutter for its intended purpose. Improper use can result in damage to property and personal injury.
- Do not use the hole cutter without a protection cowl.
- Always operate the hole cutter with an appropriate pressure. Excessive cutting pressure can damage the cutter bar.

Attaching the knives to the hole cutter

Adjust the cutting knife holders with the supplied hexagonal wrench so that the cutting knives have the desired dimension. The inside edge of the holders should match the corresponding scale on the arm. It is important that the alignment of the cutting knives is correct.



Right

Wrong

Wrong

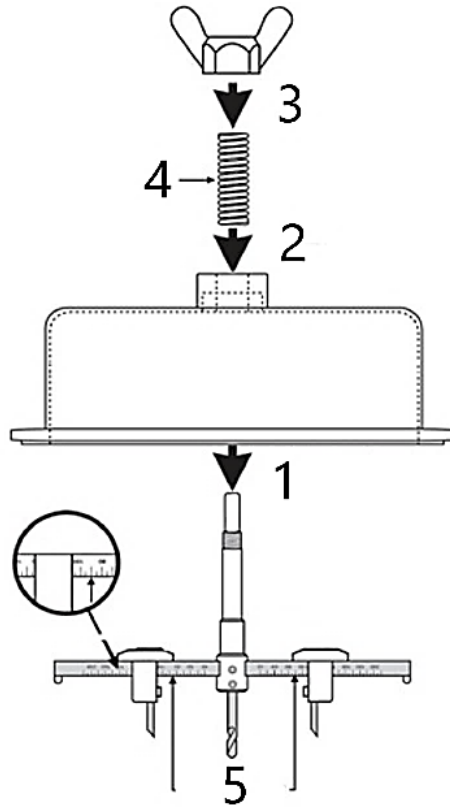
Operation

1. When the knives are correctly adjusted and the holders perfectly secured, push the spindle through the hole in the protection cowl.
2. Slide the pressure spring onto the protruding spindle.
3. Screw the wing nut onto the threaded end of the spindle as shown so that the assembly has a tight fit.
4. Attach the assembly to a suitable variable speed hand drill and ensure that the spindle is properly secured. Select a speed according to the "Cutting speed" table.
5. Approach the complete assembly very carefully to the workpiece, switch on, and let the pilot drill start working.

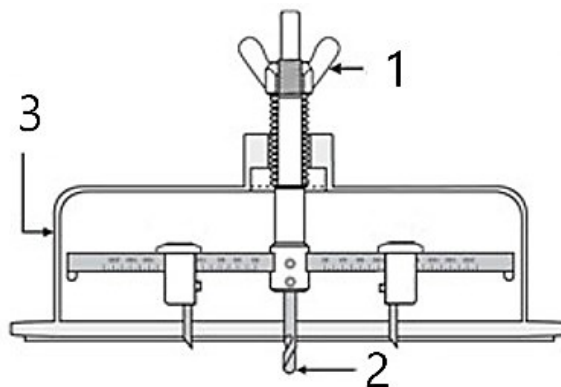
6. The protection cowl comes into contact with the workpiece quickly, so make sure that it is square. Push the spindle in further, but do not force it. Let the cutters come into contact with the workpiece very gently.

Caution! If the cutters get caught, the tool could be torn out of your grip.

Note! The cutting depth can be adjusted via the function on the hand drill.



No	Name	No	Name
1	Step 1	4	Compression spring
2	Step 2	5	Size graduations
3	Step 3		

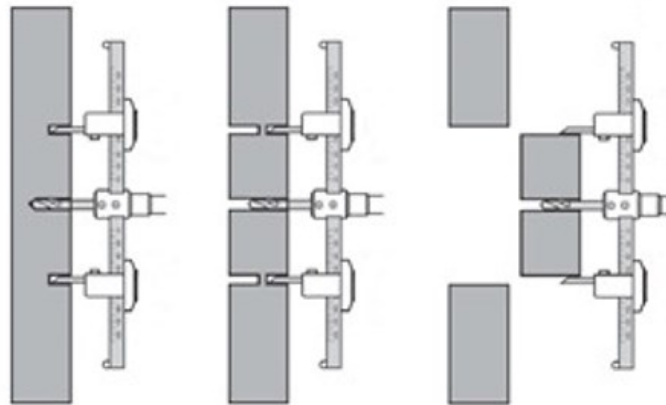


No	Explanation	No	Explanation
1	Adjust cutting thickness (left hand thread)	3	Protection cowl prevents chips from flying and collects dust
2	Pilot drill		

Information on the cutting process

Please note that it is possible to cut material up to a thickness of 34 mm. However, this could cause damage to the edge of the hole in the material to be cut, as the holders of the cutting blade would create score marks on the surface. It is therefore preferable to limit the cutting thickness to 30 mm.

If it is possible to cut from both sides of the workpiece, the maximum thickness that can be cut is 68 mm (or 60 mm if scoring of the workpiece is not a problem). To do this, first cut from one side as described and then use an 8 mm drill. Drill the pilot hole through the remaining thickness and then very carefully cut out from the back of the workpiece. Make sure that the pilot drill of the cutter almost enters the previously drilled pilot hole.



Cutting speed

Hole diameter (mm)	Drill speed ($\frac{1}{\text{min}}$)
40–49	800
50–69	600
70–89	400
90–119	200
120–180	100

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