**OPERATION MANUAL**

**DRILLING UNIT FD56-100**

1. Confirm and check motor specifications, voltage, rotation direction, wiring, and proximity switch before normal application.
2. Spindle (09) and piston (15) moved to retract end.
3. Dog (50-1) touches proximity switch (68-1).
4. Adjusting rapid travel: adjusting the distance between nut (51) and hydro-checker (72).
5. Adjusting feed stroke:
6. Remove protection cover (08).
7. Loose left turn nuts.
8. Adjusting and move nuts (37) to required depth, tighten these nuts.
9. Pneumatic power connected to A and B holes, A hole is forward, B hole is for retract. There are A. B. holes on both side of unit.
10. After piston travel distance has been set up (No. 5 described), adjust dog (50) to touch proximity switch (68).
11. To adjust forward and retract speed, use flow control valves of A and B holes.
12. To adjust feed rate, we have to use open wrench and screw driver to adjust the knob of hydro-checker.
13. Adjusting tightness of belt:
14. Remove knob (73), cover (20B).
15. Loosen screw (74) 4 pcs.
16. Move adjusting block to acquire necessary tightness of belt.
17. Tighten screw (74).