

# JEI DRILLING AND CUTTING SOLUTIONS

## SAFETY INSTRUCTIONS AND OPERATORS MANUAL FOR DRILLING MACHINE

# MAGBEAST®

MODEL HM50



MODEL HM50T



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# PLEASE READ THESE INSTRUCTIONS CAREFULLY BEFORE USING THE EQUIPMENT

MANUFACTURED BY:  
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## PLEASE READ BEFORE OPERATING THE MACHINE

Remove the unit from its case along with the accessories included:

The box should contain, where appropriate: -

- HM50 / HM50T Drilling Machine
- Oil Bottle
- Operating Instructions

Accessory pack containing: -

- Chain and Carabiner hook
- Allen key and jib strip adjustment
- Allen key for arbor
- Drill drift
- Chuck & Key (Optional extra JEI PART # JEICA-2MT)



### **ELECTRICAL CONNECTION**

Before starting the machine, please check the correspondence between voltage and frequency against the data mentioned on the identification plate. Voltage differences of + 6% and – 10% are allowed. The portable magnetic drilling machine HM50 is made in protection class II. Only use extension cables with a sufficient cross section. A cross section which is too small could cause a considerable drop in performance and an overheating of machine and cable.

### **Recommended minimum cross sections and maximum cable lengths**

Mains voltage	Cross Section in sq. mm	
	1.5	2.5
110v	20 m	40 m
220v	50 m	80 m

## **WARNING – THIS MACHINE MUST BE EARTHED**

## **SAFETY INSTRUCTIONS**

Please follow these simple instructions for your own protection:

1. Check the cable and plug for any damage
2. Never use blunt cutters (send your cutters back to JEI for re-sharpening)
3. Always wear safety goggles and gloves
4. Secure the unit with the safety chain when working overhead or vertical.
5. Always disconnect from the power source before changing cutters or working on machines itself.
6. Remove rings, watches, ties etc. that could tangle in the moving machine parts
7. Keep the unit and the workplace as clear of dirt and swarf as possible – check out JEI Magbrushes for quick and effective collection of swarf.
8. Do not attempt to change speed or reverse while the drill is operating and running.
9. Regular maintenance is essential, checking nuts, screws and bolts for tightness.
10. Always use the safety guard where appropriate

**IMPORTANT: THESE INSTRUCTIONS ARE FOR YOUR OWN SAFETY.**

### **IMPORTANT SAFETY INFORMATION: SAFETY RULES FOR POWER TOOLS**

#### **WARNING:**

When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.

#### **READ ALL THE INSTRUCTIONS**

1. **KEEP WORK AREA CLEAN:** Cluttered areas and benches invite injuries
2. **CONSIDER WORK AREA ENVIRONMENT:**
  - Don't expose power tools to rain
  - Don't use power tools in damp or wet locations
  - Keep work area well lit
  - Don't use tools in the presence of flammable liquids or gases
  - Power tools produce sparks during operation. They also spark when switching ON/OFF.
  - Never use power tools in dangerous sites containing lacquer, paint, benzene, thinner, gasoline, and gases, adhesive materials which are combustible or explosive.
3. **GUARD AGAINST ELECTRIC SHOCK.** Prevent body contact with grounded surfaces.  
For example: pipes, radiators, ranges, refrigerator encloses.
4. **KEEP CHILDREN AWAY:** Do not let visitors contact tool or extension cord. All visitors should be kept away from work area.
5. **STORE IDLE TOOLS:** When not in use, tools should be stored in dry and high or locked up place out of reach of children.
6. **DONT FORCE TOOL:** It will do the job better and safer at the rate for which it was intended.
7. **USE RIGHT TOOL:** Don't force small tools or attachments to do the job of a heavy-duty tool.  
Don't use tools for purposes not intended

- 8. DRESS PROPERLY:** Do not wear loose clothing. They can be caught in moving parts.  
Rubber gloves and non-skid footwear are recommended when working outdoors.  
Wear protective hair covering to contain long hair.
- 9. USE SAFETY GLASES:** All persons in the area where power tools are being operated should also wear safety eye protectors and face or dust masks.
- 10. DONT ABUSE CORD:** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.
- 11. SECURE WORK:** Use clamps or a vice to hold work. It's safer that using your hand and it frees both hands to operate tool.
- 12. DON'T OVEREACH:** Keep proper footing and balance at all times
- 13. MAINTAIN TOOLS WITH CARE:** Keep tools sharp and clean for better and safer performance.  
Follow instructions for lubricating and changing accessories  
Inspect tool cords periodically and if damaged, have repaired by authorized service facility.  
Keep handles dry, clean, and free from oil and grease.
- 14. DISCONNECT TOOLS:** When not in use, before servicing and when changing accessories, such as blades, bits and cutters.
- 15. REMOVE ADJUSTING KEYS AND WRENCHES:** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
- 16. AVOID UNINTENTIONAL STARTING:** Don't carry plugged in hand tool with finger on switch.  
Be sure the switch is off when plugging in.
- 17. OUTDOOR USE EXTENSION CORDS:** When tool is used outdoors, use only extension cords intended for outdoors and so marked.
- 18. STAY ALERT:** Watch what you are doing, use common sense. Do not operate tool when you are tired.
- 19. CHECK DAMAGED PARTS:** Before further use of tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breaking of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in this instruction manual.  
Have defective switches replaced by an authorized service center. Do not use tool if switch does not turn it on and off.
- 20. AVOID USING A POWERTOOL FOR APPLICATIONS OTHER THAN THOSE SPECIFIED.**  
Never use a power tool for applications other than those specified in the instruction manual.
- 21. ENSURE SAFE OPERATION THROUGH CORRECT HANDLING.** Secure safe operation through correct handling by observing the instruction herein.  
Do not employ accessories other than those specified herein; otherwise, a hazardous condition may be created.  
Never allow a power tool to be used by people not familiar with correct handling (such as

children) or those who cannot handle the tool correctly.

- 22. CONFIRM THAT NO ITEMS SUCH AS AN ELECTRIC CABLE OR CONDUIT ARE BURIED INSIDE:** In places where live wiring may be hidden behind a wall, floor, ceiling, etc. Do not hold or contact any metal parts of the tool. In such cases metal parts could become electrically live and present a serious shock hazard.
- 23. KEEP THE RIGHT PARTS IN THE RIGHT POSITIONS:** Do not remove covers and screws which have been factory mounted. They perform important retrospective roles. Keep them in the right positions.
- 24. SHOULD THE PLASTIC HOUSING OR HANDLE OF A POWER TOOL BE CRACKED OR DEFORMED. DO NOT USE IT:** Since cracked or deformed parts may lead to an operator receiving an electric shock, do not use such a power tool. Immediately have it repaired.
- 25. SECURELY MOUNT ACCESSORIES AND BLADES TO THE TOOL MAIN BODY:** Extra care must be taken when using tools on elevated locations (such as a roof, ladder, scaffold or such like) to prevent injury to someone on a lower level in the event of the tool and or accessory should drop.
- 26. ALWAYS KEEP THE MOTOR AIR VENT FULLY OPENED:** A constantly open motor vent is necessary to allow air to come in and out for cooling the motor. Do not allow it to become clogged up, even if the dust is blown through it.
- 27. OPERATE POWERTOOLS AT THE RATED VOLTAGE:** Operate power tools at voltages specified on their nameplates.
- 28. NEVER TOUCH THE MOVING PARTS:** Never touch the moving parts such as blades, bits, cutters and others.
- 29. STOP OPERATION IMMEDIATELY IF ANY ABNORMALITY IS DETECTED:** Should a power tool be detected as out of order or should other abnormalities be observed during operation , stop using the tool immediately.
- 30. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF:** Don't leave tool until it comes to a complete stop.
- 31. CAREFULLY HANDLE POWERTOOLS:** Should a power tool be dropped or struck hard against hard materials inadvertently it may be deformed, cracked or damaged.
- 32. DO NOT WIPE PLASTIC PARTS WITH SOLVENT:** Solvents such as gasoline, thinner, benzene, carbon tetrachloride, and alcohol may damage and crack plastic parts. Do not wipe them with solvents. Wipe plastic parts with a soft cloth lightly dampened with soapy water.
- 33. WHEN REPLACING A COMPONENT PART, ADOPT THE SAME TYPE:** When replacing a Component part with a new one, adopt the same type of new part. Also, never attempt to repair a power tool yourself.

## ENVIROMENTAL PROTECTION



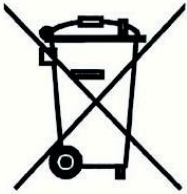
Raw material recycling instead of waste disposal

In order to avoid damages on transportation, the power tool has to be delivered in sturdy packaging. The packaging as well as the tool and its accessories are made of recyclable materials

and can be disposed of accordingly.

The tools plastic components are marked accordingly to their material, which makes it possible to remove environmentally friendly and differentiated because of available collection facilities.

## ONLY FOR EU COUNTRIES



Do not dispose of household tools together with household waste material, In observance of European directive 2012/19/EU on waste electrical and electronic equipment and its implementation in accordance with national law, electric tools that have reached the end of their life must be collected separately and returned to an environmentally compatible recycling facility.

## NOISE EMISSION / VIBRATION

The indication of noise emission is measured according to DIN 45 635, part 21. The level of acoustic pressure on the work place could exceed 85 dB (A) in this case protection measures must be taken.



### WEAR EAR PROTECTORS!

The typical hand arm vibration is now below  $2.5\text{m/s}^2$   
Measured values determined according to EN 60 745

The declared vibration emission level represents the main applications of the tool. However if the tool is used for different applications with different accessories or poorly maintained the vibration emission may differ. This may significantly increase the exposure level over the total working period.

An estimation of the level of exposure to vibration should also take into account the times when the tool is switched off or when it is running but not actually doing the job. This may significantly reduce the exposure level over the total working period. Identify additional safety measures to protect the operator from the effects of vibration such as: maintain the tool and the accessories, keep the hands warm, organization of work patterns.

## DUST PROTECTION

Dust from material such as paint containing lead, some wood species, minerals and metal may be harmful. Contact or inhalation of the dust may cause allergic reactions and/or respiratory diseases to the operator or bystanders.

Certain kinds of dust are classified as carcinogenic such as oak and beech dust especially in

conjunction with additives for wood conditioning (chromate, wood preservative). Material containing asbestos must only be treated by specialists.

## **OPERATING THE MACHINE**

- a) Fitting the cutter or drills, always unplug the power source to the machine before fitting or removing cutters or drills into the arbor. To fit cutters loosen both screws to permit the cutter shank to fit fully into the arbor ensuring the flats of the cutter are in line with set screws, then tighten the set screws until the cutter is safely locked in to the arbor.

With a gloved hand or a brush clean any dirt or swarf from the base of the magnet and the work piece and place unit in correct place for drilling.

Attach safety chain by looping it through the handle of the machine and around the work piece or other suitable anchor point. Take up any slack on the chain and clip the hook through a convenient link in the chain.

Plug the power cable into a suitable power supply (using extension lead of the correct rating if necessary) The use of an RCD is also highly recommended.

- b) Drilling – Broaching, Energize the magnet by switching on the magnet switch  
Check the magnet is holding to the work piece. Using the oil bottle add oil to the work piece. If cutting in inverted position it is recommended a aerosol foam coolant or cutting paste is used.

Select the required speed.

## **SPEED SELECTION**

The machine is equipped with a mechanical two-speed gearbox. Select the required speed by pressing in, shifting and engaging. The position of the lower speed is in direction of the working spindle. Change the speed only when the machine is not running and support the speed changing by slightly rotating the work spindle.

Start Motor

Please note that the motor will not run unless the magnet is energized.

If for any reason the power is interrupted the relay makes it necessary to restart the motor again before cutting it can continue.

Advance the cutter to the work piece using light and controlled pressure until the cutter has broken the surface, then increase pressure until the motor is loaded. Maintain even pressure right through the cut.

Too much pressure will NOT speed up the cut, it will reduce the life of the cutter and may cause damage to the motor.

If the turnings become blue add more oil. At the end of the cut the slug will be ejected, check before commencing next hole.

Stop the motor, switch off the magnet.

**WARNING:** Under no circumstances try to remove turnings or swarf from the cutter when machine is in operation. **NEVER** introduce any body parts to moving parts of the machine when it is switched on. This document is issued for general information and instruction and as such does not constitute a specification of the equipment.

Only use faultless and sharp drilling tools and avoid that the machine stops due to overload.

## MOUNTING THE TOOL



**DISCONNECT THE PLUG FROM THE MAINS BEFORE EVERY TOOL CHANGE!**

### Twist Drills:

Drills with MT2 connection can be directly fitted in the drill spindle.

For twist drills with MT1 connection use a reducing sleeve MT2 – MT1

For twist drills with parallel shank use a drill chuck B18 with appropriate taper mandrel MT2 – B18

### Annular Cutter:

For working with annular cutters you need a mount MT2 – 0 19 Weldon

Fit the ejector pin of suitable length in the cutter.

Place the core drill in the Weldon mount so that the two Allen screws hit the two surfaces of the shaft. Tighten the Allen screws equally.

### Attention!!

**Never press the tool into the tool connection with might and main!**

**Morse taper and – cone have to be free of grease and dirt.**

## REMOVING THE TOOL

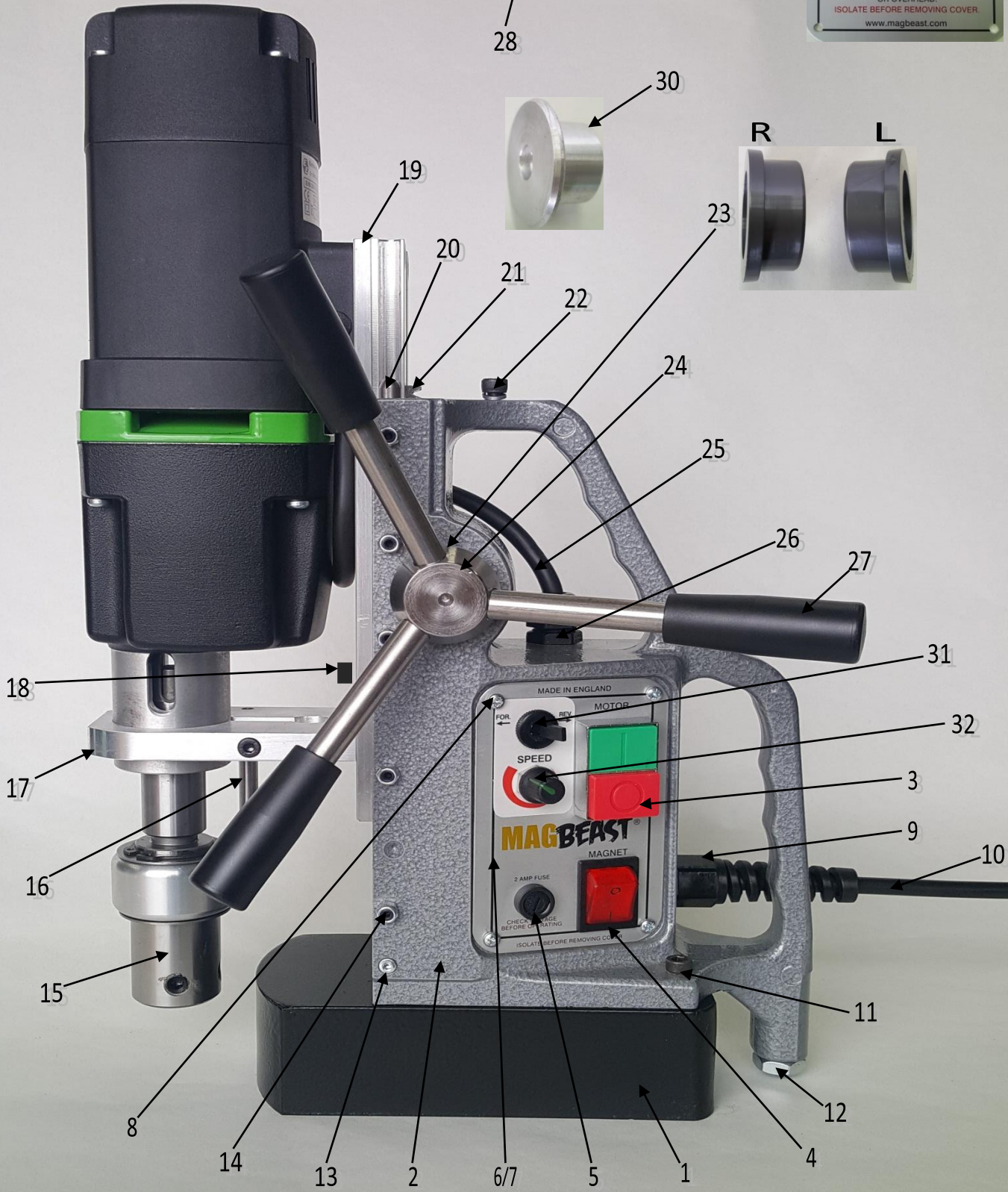
Put the drill drift in the opening of the gearbox collar.

If you cannot insert the drill drift through the work spindle, turn the work spindle slightly.

Remove the tool from the work spindle with a slight impact on the drill drift.



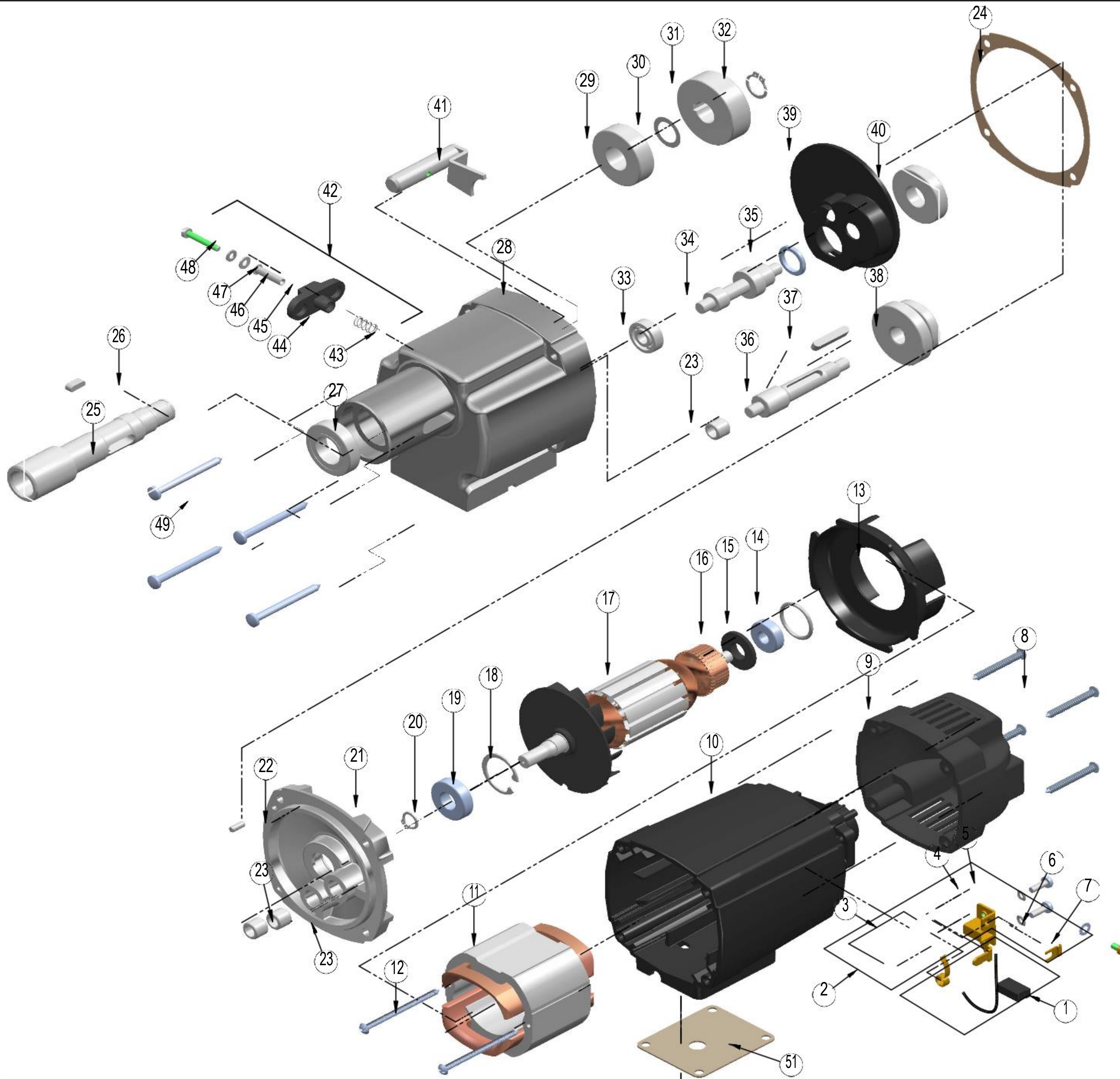
# HM50/HM50T



## HM50/HM50T PARTS LIST

1	MAGNET BASE	HM50-01
2	MAIN BODY CASTING	HM50-03
3	MOTOR STOP/START SWITCH	HM100-34
4	MAGNET/POWER SWITCH	35708
5	FUSE HOLDER	HM50-07
6	BARE SWITCH PANEL	HM50-SP
7	HM50 COMPLETE SWITCH PANEL	HM50-PNL
7	HM50T COMPLETE SWITCH PANEL	HM50T-PNL110
8	SWITCH PLATE FIXING SCREWS (4)	HM50-12
9	CABLE GLAND FOR MAINS CABLE	0151064
10	MAINS CABLE	0012180
11	M6 CASTING/MAGNET FIXING BOLT	HM50-04
12	STABILIZER BOLT	HM50-02
13	M4 RAIL FIXING BOLT	HM50-03A
14	M5 RAIL ADJUSTMENT SCREW/LOCK NUTS	HM50-11
15	ARBOR COMPLETE WITH COOLANT RING	HM50-16
16	COOLANT RING STOP	HM100-16CRS
17	GEARBOX SUPPORT/FIXING BRACKET	HM50-14
18	M5 SLIDE STOP BOLT	HM50-13
19	SLIDE	HM50-05
20	8MM DIA SLIDE RAIL	HM50-22
21	RACK	HM50-23
22	M6 COOLANT FIXING BOLT	HM50-21
23	PINION BUSHES	HM50-20
24	PINION GEAR	HM50-18
25	MOTOR CABLE/WIRING HARNESS	HM50-25 / HM100T-27
26	CABLE GLAND FOR MOTOR CABLE	HM50-26
27	HANDLE COMPLETE WITH KNOB	HM50-17
28	PCB CONTROL	HM50/100-PCB
29	BACK PLATE/WARNING	HM50-BP
30	PINION END CAP	HM100/50-PC
31	HM50T FORWARD/REVERSE SWITCH	HM100-07T
32	HM50T SPEED CONTROL WITH KNOB	HM100-10
**	DIRECTION RELAY	HM100T-RELAY1 / HM100T-RELAY2
**	SAFTEY GUARD	HM50-GUARD
**	COOLANT INLET (ARBOR)	HM100-16A

# EIB14 \_ TWO SPEED DRIVE UNIT \_ 230V



Sr. No.	PART NAME	PART No.	QTY.
1	Auto Cutoff Carbon Brush Pair	32099MB42	1
2	Brush Holder SA total	33199MB35	2
3	Brush Holder SA (32099MB02)		2
4	Wave washer M4 TYPE B (34217MB04)		4
5	CH screw M4x12 (31617101MB00)		4
6	Star Washer M4 (32117MB30)		2
7	CH screw M4 x 8 (31017301MB00)		2
8	CH Self Tap Screw 4.8X38	32017MB05	4
9	Cap	3809001MB58	1
10	Field Case	31204MB17	1
11	Field SA - 230V	37132A1MB50	1
12	Phillips head self tap screw 3.9x60	32017MB03	2
13	Baffle	37732Y1MB40	1
14	O ring	32003MB03	1
15	Ball Bearing (8-22-7) 608 2Z	31109021MB01	1
16	Dust Washer	32004MB04	1
17	Armature SA - 230V	37132A1MB00	1
18	Circlip 28mm x 1.2 B TYPE	32017MB04	1
19	Ball Bearing (12-28-8)6001 2Z	31909MB01	1
20	Circlip 11 A	31217711MB00	1
21	GC Cover (Silver)	31201931MB00	1
22	Dowel 4 x 12	32117MB23	1
23	NRB 8-12-10 HK810	32509MB01	3
24	Gasket	31203071MB00	1
25	Spindle sleeve	3713234MB20	1
26	Key 5-5-12	3802006MB01	1
27	Ball Bearing 20-37-9 (6904-2RS)	32009MB03	1
28	Gear case (Silver)	31201921MB00	1
29	Ball Bearing 17-40-12 (6203-2RS)	31909MB03	1
30	Washer	33117MB04	1
31	Spindle Gear	3713234MB30	1
32	Circlip 15 x 1 A TYPE	31217651MB00	1
33	Ball Bearing 8-22-7 (608 2Z)	31109021MB01	1
34	Inter Pinion	3713235MB00	1
35	Spacer	31202471MB00	1
36	Inter shaft for gear cluster	3712234MB60	1
37	Key 5-5-28	3802006MB02	1
38	Gear Cluster	3713234MB40	1
39	Grease Barrier	31204031MB00	1
40	Intermediate Gear	37132A4MB70	1
41	Coupling Bolt SA	31299451MB00	1
42	Gear Changer SA Black EE	312991041MB00	1
43	Comp.Spring (31202501MB00)		1
44	Gear Shifting Knob EE Black (31204MB14)		1
45	Screw Sleeve (31217681MB00)		1
46	Plain Washer M4 (31017341MB00)		1
47	Star Washer M4 (32117MB30)		1
48	CH Screw M4 x 25 (31217671MB00)		1
49	Phillip head Self Tap Screw 4.8x45	32017MB16	4
50	1MM SQ. X 2CORE CABLE (IES 60227) CE*	32013MB24	0.57
51	Field Case Gaket	31203091MB00	1

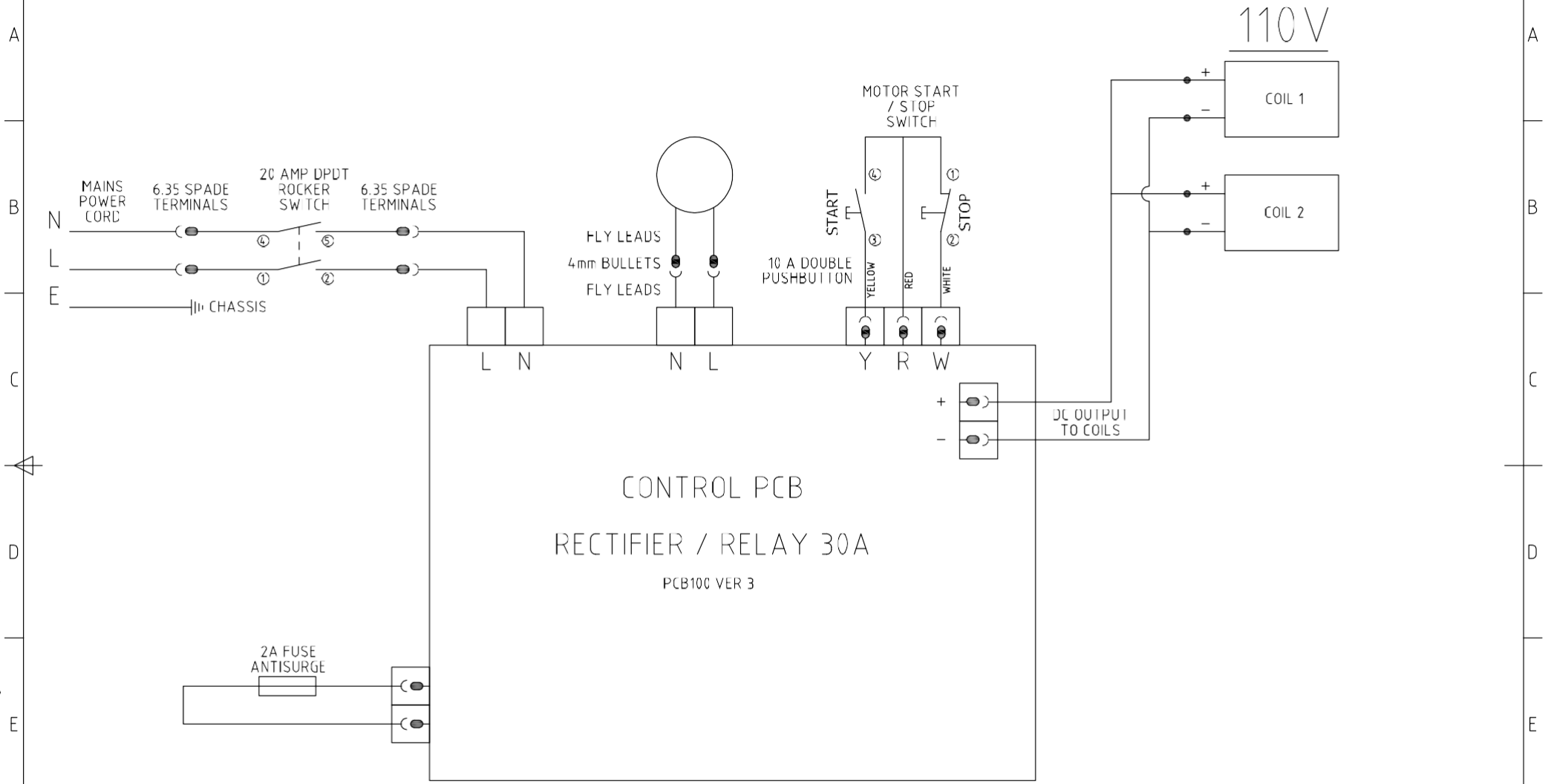
\* Parts are Not Shown

PART NO.	REV:
312141581MB00	1

## HM50 MOTOR PARTS

No.	Description	Part No	No.	Description	Part No
1	Cap	HM51	35	Locking Ring 15/1	HM535
2	Self tapping screw HC 4.8x45	HM52	36	Shaft for Gear Box 13Z	HM536
3	Armature 220v	HM53/2	37	Grooved Ball Bearing 608	HM537
4	Grooved Ball bearing 608 2Z	HM54	38	Gear Block 34/40Z	HM538
5	Locking ring 28/1.2	HM55	39	Locking Ring A5x5x28	HM539
6	Brush holder complete	HM56	40	Needle Sleeve HK0810	HM540
7	Carbon brush	HM57	41	Self Tapping Screw HC 4.8 x22	HM541
8	Corrugated spring washer B4	HM58	42	Air Guiding Ring	HM542
9	Self tapping screw ZM4x12	HM59	43	Self Tapping Screw HC 3.9x60	HM543
10	Locking Ring 11/1	HM510	44	Field 220v	HM544/2
11	Notched Pin Plug 4x12	HM511	45	Motor Housing	HM545
12	O-Ring 22x2.5	HM512	46	Anti Parasit Condenser	HM546
13	PT Screw 50x50	HM513	47	Spacer	HM547
14	Grooved Ball Bearing 6001 2Z	HM514	48	Side Handle Complete	HM548
15	End of shield gearing	HM515	49	Gearbox Seal	HM549
16	Gearbox Housing	HM516	50	Grease Compartment Barrier	HM540
17	Intermediate Wheel 34Z	HM517			
18	Two Pinion Shaft 11/17 Z	HM518			
19	Gear Changer Complete	HM519	3	Armature 110v	HM53
20	Coupling Bolt Complete	HM520	28	Connecting Cable 4h Plug 16A	HM528/1
21	Grooved Ball Bearing 6203 2RS	HM521	29	Switch	HM529
22	Self Tapping Screw HC 4.2x16	HM522	44	Field 110v	HM544
23	Work Spindle	HM523			
24	Pair of Handle Halves	HM524			
25	Cable Grommet	HM525			
26	Wire Locking Flange	HM526			
27	Self Tapping Screw HC 4.2x13	HM527			
28	Connecting Cable 2x1mm"	HM528			
29	Flush Mounting Switch	HM529/2			
30	Soft start switch "S"	HM530			
31	Grooved Ball Bearing 6904 2RS	HM531			
32	Spindle Wheel 45Z	HM532			
33	Locking Spring A5x5x12	HM533			
34	Locking Washer 15/22x0.2	HM534			

RevNo	Revision note	Date	Signature	Checked



FILE NAME	1640-1	FSCM NO	SHEET	SCALE
SIZE	A3		1	N/A
DRAWN	JHP			
CHECK				
APPR.				
ISSUED	19/03/2018			
REV	0		DWG NO	
CONTRACT NO			MAG1	

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## ***EC Declaration of Conformity***

We

***JEI Drilling & Cutting Solutions Ltd  
Unit 21, Empire Business Park,  
Enterprise Way,  
Burnley, Lancashire, UK, BB12 6LT***

Declare with full responsibility that product:

## **MAGBEAST HM50 / HM50T DRILLING MACHINE WITH ELECTROMAGNETIC BASE**

which the declaration applies to is in accordance with the following standards:

EN 62841-1:2015, EN 55014-1:2017, EN ISO 12100:2010,

and satisfies safety regulations of guidelines:

2014/30/EU, 2014/35/EU, 2006/42/EC, 2011/65/EU, 2012/19/EU

Burnley, 31/12/2022

A handwritten signature in black ink, appearing to read 'D. McFadden', is positioned above a horizontal line.

David McFadden  
Managing Director

### **JEI Twelve (12) month limited warranty**

JEI warrants the HM50 / HM50T Drilling machine to be free of defects in material and workmanship under normal use for a period of twelve months from date of purchase. **This warranty does not cover damage or wear which arise from misuse, accident, tampering or any other causes not related to defects in workmanship or materials.** This warranty is conditioned upon the prepaid return of the HM50 Machine to JEI Group Ltd, Unit 21, Empire Business Park, Empire Way, Burnley, Lancs. Or our International representative for our international customers for examination and verification of the claimed defects. If defect is verified, JEI Group Ltd will replace, free of charge, any defective parts. If inspection of the machine does not disclose any defect in workmanship or materials, the original purchaser will be notified by JEI Group Ltd, or its representative, of the costs of necessary repairs. If repairs are authorized, repairs will be made and the costs of repair and return transportation will be billed through the customer's distributor.

THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES (EXPRESSED OR IMPLIED) INCLUDING WARRANTY OF MERCHANT ABILITY OR FITNESS FOR A PARTICULAR PURPOSE, SPECIAL AND CONSEQUENTIAL ARE EXPRESSLY EXCLUDED AND DENIED.



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