

**MODELS CSU 30 – CSU 32AC – CSU 32RL
CSU 50AC – CSU 50RL – MDM 40
ELECTRIC MAGNETIC DRILLS**



OPERATING MANUAL



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1. Safety

All safety procedures must be observed at all times when using portable magnetic drills. Improper use and carelessness increase the risk of accidents and or injury! Read carefully and follow these instructions in order to protect your own safety.

1. During any work on non-horizontal components, the machine must be securely anchored by means of the safety chain supplied.
2. The machine may only be used on a flat and clean surface.
3. If the machine or the power cable show signs of damage, the machine must be switched off immediately.
4. Wearing safety glasses, hearing protection and protective clothing is necessary.
5. Do not wear any loose clothing, jewelry or other adornments that may get entangled in the moving parts of the machine.
6. Use only accessories or parts that are recommended by CS Unitec.
7. During drilling operations, the hole cutter must be cooled and lubricated with good quality cutting or lubrication oil, which is available from CS Unitec.
8. The motor must be switched off when tightening the electric drill.
9. When changing a hole cutter in the machine, the machine must be disconnected from the power supply.
10. Clean the area around the machine regularly. Pay extra attention to the bottom of the magnet and keep it clean and dry.
11. Regularly inspect whether all screws, nuts and bolts are tight.
12. Remove the steel shavings (chips, burrs) from the drill every time after drilling a hole, and use a glove to do so! The shavings are very hot and sharp.
13. When using the drill upside down, you must use special CS Unitec drill paste to lubricate the cutter. In contrast with oil, this product prevents grease from seeping into the motor.

IMPORTANT!

Read these directions and safety instructions completely and attentively. Before using this apparatus, make sure that it is connected to the correct voltage and that all grips and parts are tightly attached. This is in the interest of your own safety. Should you have any doubt about the use of this apparatus, please contact your supplier.



2. Technical specification

	CSU 30	CSU 32AC	CSU 32RL	CSU 50AC	CSU 50RL	MDM 40
Hole Cutters	7/16 - 1-1/8" 12-30 mm	7/16 - 1-1/4" 12-32 mm	7/16 - 1-1/4" 12-32 mm	7/16 - 2" 12-50 mm	7/16 - 2" 12-50 mm	7/16 - 1-1/2" 112-40 mm
Tapping	not applicable	not applicable	3/16-3/4" M5-M16	not applicable	3/16-15/16" M5-M20	not applicable
Twist Drill	Not applicable	1/16 - 1/2"	1/16 - 1/2"	1/16 - 7/8"	1/16 - 7/8"	Not applicable
Arbor Size	3/4" Weldon	3/4" Weldon	3/4" Weldon	3/4" Weldon	3/4" Weldon	3/4" Weldon
	1"x20 UNF	1/2"x20 UNF	1/2"x20 UNF	MK 2	MK 2	not applicable
Speed range (min-1)	450 RPM	450 RPM	100-450 RPM	I 250 RPM II 450 RPM	I 100-250 RPM II 180-580 RPM	440 RPM
Voltage	110-120V or 220-240V	110-120V or 220-240V	110-120V or 220-240V	110-120V or 220-240V	110-120V or 220-240V	110-120V or 220-240V
Magnet Size	160x80 mm	160x80 mm	160x80 mm	165x85 mm	165x85 mm	160x80 mm
Magnet Force	1500 kg	1400 kg	1400 kg	1700 kg -10%	1700 kg -10%	900 kg
Drill Size H x W x L	310x160x 240 mm	240x170x 350 mm	240x170x 350 mm	420x170x 230 mm	420x160x 230 mm	310x160x 240 mm
Stroke/ cutter	2-3/4" (70mm)	6" (150mm)	6" (150mm)	6" (150mm)	6" (150mm)	2-3/4" (70mm)
Weight	22 lb. (9,9 kg)	24 lb. (11 kg)	24 lb (11 kg)	29 lb. (13 kg)	29 lb. (13kg)	23 lb. (10,2 kg)

3. Items included in delivery

	CSU 30	CSU 32AC	CSU 32RL	CSU 50AC	CSU 50RL	MDM 40
Carring Cases	Yes	Yes	Yes	Yes	Yes	Yes
Chuck 1/2"	No	No	No	No	No	No
Tap collets	No	No	Yes	No	Yes	No
Hearing protectors	Yes	Yes	Yes	Yes	Yes	Yes
Safety glases	Yes	Yes	Yes	Yes	Yes	Yes
Safety gloves	Yes	Yes	Yes	Yes	Yes	Yes
Safety chain	Yes	Yes	Yes	Yes	Yes	Yes
Allen key 2,5	Yes	Yes	Yes	Yes	Yes	No
Allen key 3	No	Yes	Yes	No	No	No
Allen key 4	Yes	Yes	Yes	Yes	Yes	Yes
Allen key 5	Yes	Yes	Yes	Yes	Yes	No
Wrench 8	Yes	Yes	Yes	Yes	Yes	No
Ejector pin MK2	No	No	No	Yes	Yes	No
Centering pin	Yes	Yes	Yes	Yes	Yes	No
Manual	Yes	Yes	Yes	Yes	Yes	Yes
Safety instructions	Yes	Yes	Yes	Yes	Yes	Yes
Drilling oil	Yes	Yes	Yes	Yes	Yes	Yes

When using this apparatus, you MUST wear ear and eye protection. CS Unitec has included these articles as standard accessories for your own safety. Do NOT touch the drill when it is running. Always follow the recommendations for personal protection apparatuses (PPD) when using this tool.

4-1 Instructions

CS Unitec machines are specifically designed for drilling holes in steel, possibly expanded by the possibility of tapping/reaming/countersinking (depending on the model). CS Unitec machines may not be adapted and/or used for applications other than those they were designed for, including driving other apparatuses.

Make sure that you can oversee the entire work area from where you are operating this apparatus. Use barriers to keep others away. Do not use the machine in places subject to hazard of explosion – electrical tools produce sparks which may ignite flammable materials or gases. To prevent electrical shocks, do not use the tool in moist or wet conditions or environments. Always operate this tool using both hands. Make sure the work piece is always clamped down safely.

This tool is equipped with a cable and plug approved for the country it is to be used in. The yellow-green wire in the cable is the earth wire: never connect this to a pole under voltage.

4-2 Tool assembly

4-2-1 Core drill assembly

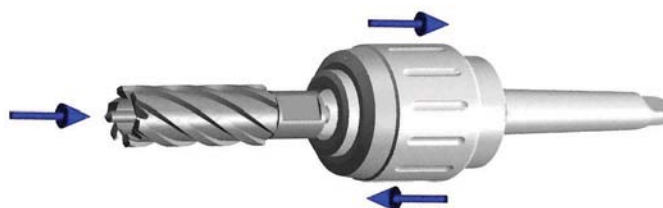
1. Pilot Pin (Centering pin)
2. Pilot hole in the hole cutter

Clean the inner wall and the arbor of the drill to ensure proper oil supply. First insert the pilot pin in the pilot hole located in the back of the of the cutter shank. Only then insert the cutter with its pilot (centering pin) in the drill arbor.

3. Hole cutter shank: the part you slide into the drill arbor
4. Oil groove or flattened surface allowing the oil to pass for lubrication from the inside out
5. Flat surface:



Option Keyless:



After sliding the hole cutter into the drill arbor, make sure the 2 flat surfaces are located exactly in front of the screw holes (number 3 in the picture) and subsequently tighten the screws securely by

means of the Allen keys included (Allen key 4).

4-2-2 Chuck assembly

The option of using our machines with spiral twist drills and other tools that have a cylindrical shank is an important characteristic of CS Unitec magnetic drills (see 3-1 for technical data related to maximum capacity).

4-2-2-1 Installation of IBC 18 (1/2“ geared chuck with a 3/4” Weldon Shank)

IBC18 includes the adaptor IBC 14 (1/2”x20 UNF to 3/4” Weldon) and a 1/2” geared chuck (with internal 1/2”x20 UNF thread). Slide the 3/4” Weldon Shank into the drill arbor and tighten set screws on the 2 flats.

4-2-2-2 Installation of IBC 17 (1/2“ geared chuck on the spindle extending from the motor)

For some of our magnetic drills it is possible to install a 1/2” drill chuck directly to the threaded spindle shaft extending from the motor unit. This is in reference to the models CSU 32AC and CSU 32RL.

Remove the Allen screws below the triangular guide by using the Allen key 5 included. For model CSU 32RL you must remove the 2 Allen screws that lock the drill spindle to the shaft extending from the motor with the use of Allen screw 3. Remove the spindle by using wrenches 18 and 20. You can now install a chuck with internal thread of 1/2”x20 UNF to the shaft extending from the motor unit.

When reinstalling the spindle and triangular guide, you must ensure that the triangular guide does not cause any resistance to the drill spindle as it turns.

4-2-2-3 Installing the IBC 22 (3/4” geared chuck with MT No. 2 adaptor)

For some of our magnetic drills it is possible to install a chuck with a MT 2 adapter connection. This is in reference to the models CSU 50AC and CSU 50RL.

Use the no. 2 Drift Key included to remove the 3/4” Weldon MT 2 cutter arbor. Next install the chuck with a MT2 adaptor connection into the female of the MT2 spindle of the drill.

4-2-3 Installation of threading tools

The CSU 32RL and CSU 50RL models enable you to thread the hole you drilled.

With delivery of your CSU 32RL or CSU 50RL you received 4 tap holder collets specifically 1/4”, 1/2”, 5/8”, and 3/4”. These tap arbors are geared to the use of DIN376 machine taps. Slide the tap into the tap arbor and secure it by using the Allen screw inserted in the tap arbor (Allen key 3). Attach the tap arbor in the drill arbor and secure it with one of the Allen screws inserted in the drill arbor (Allen key 4).

Tap Holder Collets (shaft size) Inch sizes available: 1/4“ to 15/16“, conforming to ASA standard

M8	p 6 mm	M14	p 11 mm	M20	p 16 mm
M10	p 7 mm	M16	p 12 mm	M22	p 18 mm
M12	p 9 mm	M18	p 14 mm	M24	p 18 mm

4-3 The magnetic drill

4-3-1 The magnet

The attachment force generated by the magnet depends on various factors.

- thickness of the material to be drilled
- coating of the material to be drilled
- dirt under the magnet or the material to be drilled

Material: a minimum of 3/8" (10 mm) thickness is required for the magnet to work the best.

If the indicator light on the control panel (chapter 4-3-2) lights up green, the magnet is generating sufficient attachment force. If the indicator light lights up red, the magnet is not generating sufficient attachment force. Do not drill if the light is red.

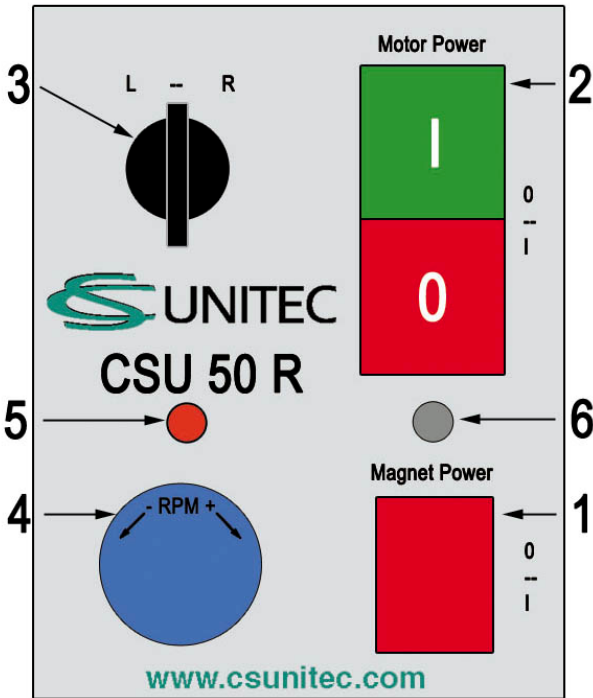
We would like to point out that this only refers to an indicator and not a certainty that the magnet will not release the material. CS Unitec accepts no liability ensuing from the magnet indicator not functioning or functioning properly.

Make sure that the magnet attaches tightly to the work piece before turning on the motor of the electric drill. CS Unitec magnets have 2 coils: make sure that both coils are in contact with the material. Do not connect any other machines to the electrical outlet the drill is plugged into, as it may result in the loss of magnetic force. Always use the safety chain included. Drilling above your head is extremely dangerous and is not recommended.

For the use of magnetic drills on non-magnetic (non-ferrous) materials, refer to our brochure or our website www.csunitec.com where several vacuum plate drilling systems are mentioned.

4-3-2 The control panel

The control panel on your electric drill is designed for maximum operating facility and safety.



1. The magnet switch. This switch is used to switch the magnet on and off, and is included on every CS Unitec magnetic drill.
2. The on/off switch. This switch is used to turn the motor of electric drill on and off, and is included on every CS Unitec magnetic drill.
3. The left/right switch. This rotating switch is used to determine the direction of rotation of the electric drill, and is included on models CSU 32RL and CSU 50RL.
4. The speed control. This rotating button is used to continuously adjust the rpm of the machine and is included on models CSU 32RL and CSU 50RL.
5. The magnet indicator. This indicator shows whether the magnetic force is being used to the full extent. For a more detailed description, see chapter 4-3-1. This indicator is included on models CSU 32AC, CSU 50AC, CSU 50RL.
6. The fuse cartridge with fuse. This fuse cartridge is included on every CS Unitec magnetic drill. Type of fuse: glass fuse 5x20. For fuse values, see the table below.

4-3-3 Fuse values

CSU 30	110-120 V 220-240 V	F2A F2A	CSU 50AC	110-120 V 220-240 V	F2A F2A
CSU 32AC	110-120 V 220-240 V	F2A F2A	CSU 50RL	110-120 V 220-240 V	F2A F2A
CSU 32RL	110-120 V 220-240 V	MT10A F6,3	MDM 40	110-120 V 220-240 V	F2A F2A

4-4 Hole Cutter

4-4-1 Hole cutter selection

There are many different types of steel. It is not possible to drill all these types of steel with 1 type of cutter. We recommend the following:

- CS Unitec HSS (6-Series) – Use these cutters for drilling holes in 37/52 carbon steel and aluminum
- CS Unitec Cobalt (7-Series) - Use these cutters for drilling holes in stainless steel and other high-quality steel alloy types
- CS Unitec HSS TiAlN – Use these cutters for drilling holes in 37/52 carbon steel and aluminum. Due to special titanium aluminum nitride coating on the cutter, these have a lifespan of 3-5x longer than standard HSS bits

Check power supply

Make sure the used current and voltage correspond with the machine specifications. When using a power cord cable extension, make sure it can do the job. Use the correct wire gauge for the length. See the Extension Cord Selection Chart.

The hole cutters listed above are available in the following Ø and drilling depths:

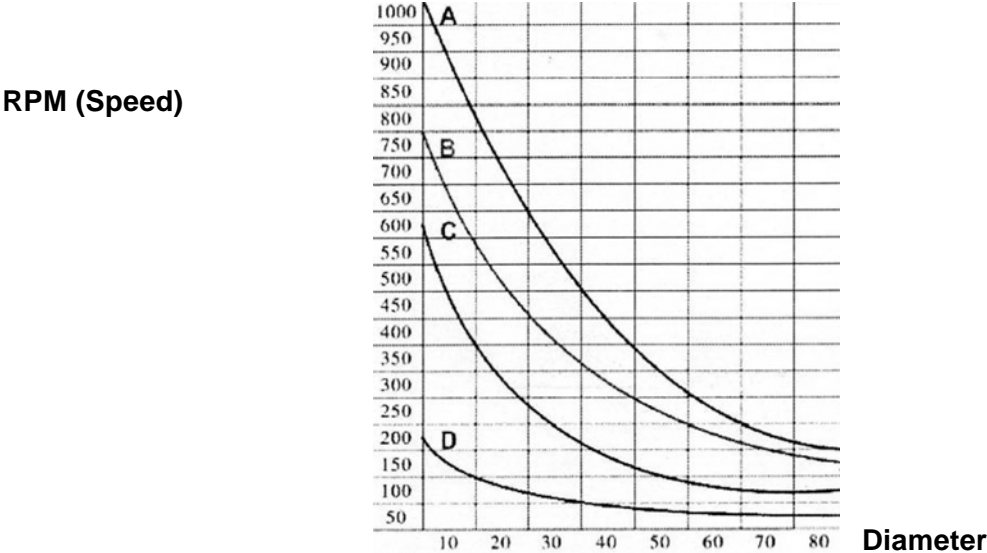
Type	Drilling depth	Diameter (1 mm or 1/16" increasing)
CS Unitec HSS	30 mm (1-1/8")	12 through 100 mm
		7/16" through 4"
	55 mm (2-1/8")	12 through 100 mm
		7/16" through 4"
	75 mm (3")	20 through 100 mm
		3/4" through 4"
110 mm (4-1/4")	20 through 100 mm (3/4" – 4")	
CS Unitec Cobalt	25 mm (1")	12 through 100 mm (7/16" through 4")
	50 mm (2")	13 through 100 mm (1/2" – 4")
	100 mm (4")	20 through 100mm (3/4" – 4")
CS Unitec TiAlN	30 mm (1-1/8")	12 through 50 mm
		7/16" through 2-1/16"
	55 mm (2-1/8")	12 through 50 mm
		7/16" through 2-1/16"
75 mm (3")	3/4" through 2-1/16"	

- Special Size Hole Cutters are available upon request

4-4-2 Rpm selection / rpm diagram

The selection of the rpm to operate at depends on the material to be drilled and the diameter of the hole cutter your are going to use. The diagram below indicates the cutter rpm to be operating at.

- Curve A – Aluminum
- Curve B – Copper
- Curve C – Steel 37/52
- Curve D – Stainless steel and other high-quality steel alloys



4-4-3 Rpm adjustment

CS Unitec magnetic drills can run at the following motor speeds:

- CSU 30 - 1 mechanical setting of 450 rpm while free idling
- CSU 32AC - 1 mechanical setting of 450 rpm while free idling
- CSU 32RL- 1 mechanical continuous adjustment settings of 0-450 rpm while free idling
- CSU 50AC - 2 mechanical settings of 250 and 450 rpm while free idling
- CSU 50RL - 2 mechanical continuous adjustment settings of 100-250 and 180-580 rpm while free idling

Changing mechanical speed rpm settings for the CSU 50AC and CSU 50RL models is done by means of sliding the black gear selection button up or down on the side of the gear box.

Attention!!!

Do not change mechanical rpm settings until the machine has come to a complete stop!



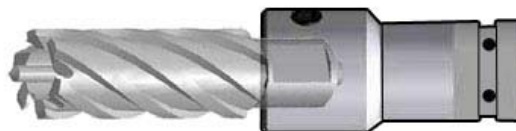
Adjusting the variable speed rpm settings is done by turning the speed control dial on the control panel (see chapter 4-3-2).

4-4-4 Cooling / lubrication

CS Unitec recommends the use of cooling and lubricating agents. Not only do these assist in drilling, but they will also lengthen the lifespan of your tools. With the use of annular cutters, cooling and lubricating agents can be supplied through the cutter to the workpiece.

All magnetic drills in the CS Unitec program can be equipped with an automatic cooling system, which provides a guaranteed supply of the cooling and lubricating agents from the inside. If your machine is not to be equipped with an automatic cooling system, it will still be possible to cool and lubricate from the inside.

Use the holes in the drill arbor for this purpose by squirting cooling and lubricating agents into one of the holes found on the side of the arbor.



For horizontal drilling, CS Unitec recommends the use of a drilling compound.

After you have read the explanatory information and safety recommendations above, you are ready to actually start drilling.

Use the centering pilot pin, when positioning the machine in order to determine the center of the hole to be drilled. Turn the magnet on and verify that the drill is still in the correct position and that

the machine is pushed tight against the work piece. Turn the motor on at the highest setting and allow it to run at full speed. Turn the arms to start drilling. Apply slight pressure to make sure the drill remains in place and continue with regular pressure. Do not put too much pressure on the machine – allow the speed of the drill do the work. Drilling performance does not improve by putting more pressure on the tool: on the contrary, the hole cutter and the motor will wear out sooner. Adjust the drilling supply oil where necessary via the oil cock or, if your drill does not have automatic cooling, squirt oil on the drill. Apply less pressure after the drill has cut through the material. Always find a way to remove the burr without causing injuries.

When using your magnetic drill vertically or upside-down, we must point out that metal burrs can easily get into the motor during drilling. We will not repair any damage done to your machine by such action under coverage of the warranty.

CAUTION: The metal piece drilled out is pushed out and is **very hot**. Wear gloves!

4-5 Tapping

Models CSU 32RL and CSU 50RL give you the opportunity to cut threads in the hole you drilled. However, both models require a different approach to do so.

4-5-1 Tapping with CSU 32RL

Leave the magnet of your drill machine on to retain the correct position. Exchange the drill for the tap, using the tap collet. If necessary, center the tap above the hole you drilled. Make the machine rotate clockwise by using the clockwise / counter-clockwise switch. Allow the motor to run at full speed and gently lower the drill until it touches the material. The CSU 32RL is a 'throttled' machine, in other words, the rpm is controlled by supplying the motor with more or less capacity. At low rpm, this machine does not have sufficient force to run the tap through the material.

After the first impulse, the rpm will be drastically reduced by the load. After tapping the hole, allow the tap to slowly run in reverse to remove the tap from the hole.

Due to the absence of moment of force control, it is impossible to tap 'blind' holes with this machine.

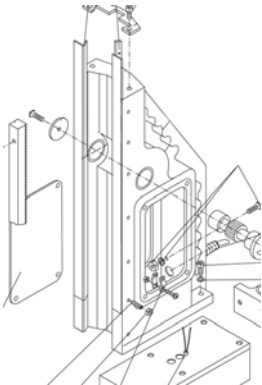
4-5-2 Tapping with CSU 50RL

Leave the magnet of your drill machine on in order to retain correct position. Exchange the drill for the tap using the tap arbor. Center the tap above the hole you drilled. Set the machine to rotate clockwise by means of the clockwise / counter-clockwise switch. Switch your machine to gear box 1 by using the gear box switch. Adjust the speed by means of the speed control, if necessary; gently lower the drill until it touches the material. After tapping the hole, allow the tap to slowly run in reverse to remove the tap from the hole.

Due to the absence of moment of force control, it is impossible to tap 'blind' holes with this machine.

5-1 Maintenance

Just as with every apparatus with moving parts, your magnetic drill also needs regular maintenance service.



A few recommendations

- Clean all dust and burrs off your magnetic drill
- Regularly check the carbon brushes for wear
- Replace any defective parts immediately: this prevents properly functioning parts from being damaged
- Adjust your guide regularly and make sure it is clean and greased. This prevents any play from being created and the spindle, triangular guide and guide rails from excessive wear. The guide is adjusted by tightening or loosening the set screws (1d + 1e on the drawing) on the side of the magnetic drill

Check the grease in the gear box regularly and replace it if necessary. We recommend you store your machine on its side regularly so that the gear box grease can run back to where the gears are.

6. Trouble shooting

Magnet and motor do not function	<ul style="list-style-type: none"> - The magnet switch is not connected to the supply - Damaged or defective wiring - Defective fuse - Defective magnet switch - Defective control unit
Magnet does function, the motor does not	<ul style="list-style-type: none"> - Damaged or defective wiring - Carbon brushes are stuck or worn out - Defective magnet switch - Defective on/off switch - Defective control unit - Defective amature and/or field
Magnet does not function, motor does	<ul style="list-style-type: none"> - Defective magnet - Defective control unit
Hole cutters break quickly, holes are bigger than the hole cutter	<ul style="list-style-type: none"> - Play in the guide - Bent spindle - Shaft extending from the motor is bent

Motor running roughly and/or seizing up	<ul style="list-style-type: none"> - Bent spindle - Shaft extending from the motor is bent - Triangular guide not mounted straight - Dirt between spindle and triangular guide
Motor making a rattling sound	<ul style="list-style-type: none"> - Gear ring (bottom of the armature) worn out - Gear(s) worn out - No grease in gear box
Motor humming, big sparks and motor has no force	<ul style="list-style-type: none"> - Armature burned - Field burned - Carbon brushes worn out
Motor does not start or fails (CSU 50AC)	<ul style="list-style-type: none"> - Damaged or defective wiring - Dirt in sensor speed control unit - Defective speed control unit - Defective speed control or its wiring - Defective or loose magnet on top of anchor
Guiding takes a great deal of effort	<ul style="list-style-type: none"> - Guide is set too tight - Guide is dry - Guide/gear-rack/rotation system dirty or damaged
Insufficient magnetic force	<ul style="list-style-type: none"> - Damaged or defective wiring - Bottom of magnet not clean and dry - Bottom of magnet not flat - Work piece is not bare metal - Defective control unit - Defective magnet
Motor only runs at maximum rpm (CSU 32RL)	<ul style="list-style-type: none"> - Defective speed switch - Damaged / defective wiring - Defective control unit
Frame under voltage	<ul style="list-style-type: none"> - Damaged / defective wiring - Defective magnet - Motor seriously dirty
Fuse blows when magnet switch is turned on	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Defective magnet switch - Defective control unit - Defective magnet
Fuse blows when motor is started up	<ul style="list-style-type: none"> - Damaged or defective wiring - Wrong value fuse - Motor running roughly - Defective anchor and/or field - Carbon brushes worn out - Defective control unit
Rotation system free, stroke too long	<ul style="list-style-type: none"> - Loose or defective gear-rack - Defective rotation system

CAUTION: Do not operate your tool on a current on which the voltage is not within correct limits. Do not operate tools rated A.C. only on D.C. current. To do so may seriously damage the tool.

EXTENSION CORD SELECTION

If an extension cord is used, make sure the conductor size is large enough to prevent excessive voltage drop which will cause loss of power and possible motor damage. A table of recommended extension cord sizes will be found in this section. This table is based on limiting line voltage drop to 5 volts (10 volts for 230 volts) at 150% of rated amperes.

If an extension cord is to be used outdoors it must be marked with the suffix W-A following the cord type designation. For example – SJTW-A to indicate it is acceptable for outdoor use.

RECOMMENDED EXTENSION CORD SIZES FOR USE WITH PORTABLE ELECTRIC TOOLS

		Length of Cord in Feet									
		115V	25 Ft.	50 Ft.	100 Ft.	150 Ft.	200 Ft.	250 Ft.	300 Ft.	400 Ft.	500 Ft.
		230V	50 Ft.	100 Ft.	200 Ft.	300 Ft.	400 Ft.	500 Ft.	600 Ft.	800 Ft.	1000 Ft.
Nameplate Ampere Rating	0-2	18	18	18	16	16	14	14	12	12	
	2-3	18	18	16	14	14	12	12	10	10	
	3-4	18	18	16	14	12	12	10	10	8	
	4-5	18	18	14	12	12	10	10	8	8	
	5-6	18	16	14	12	10	10	8	8	6	
	6-8	18	16	12	10	10	8	6	6	6	
	8-10	18	14	12	10	8	8	6	6	4	
	10-12	16	14	10	8	8	6	6	4	4	
	12-14	16	12	10	8	6	6	6	4	2	
	14-16	16	12	10	8	6	6	4	4	2	
	16-18	14	12	8	8	6	4	4	2	2	
	18-20	14	12	8	6	6	4	4	2	2	

Terms of warranty

CS Unitec guarantees its standard machine program, CSU models, for a period of 6 months, and the CS Unitec+ machine line, MAB models) for 12 months, starting on the date of purchase by the end user, covering material defects and/or manufacturing errors. If you experience any problems, you should return the machine postage paid to your dealer or to CS Unitec, including a copy of the bill and a copy of the warranty registration card. This warranty does not of course cover any damage or failure caused by incorrect use, overload or wear. Defective machines and/or parts covered by the warranty terms are repaired and/or replaced of CS Unitec without charge. The warranty is limited to the repair or replacement of the drilling machines only.

For further information contact CS Unitec, Inc.

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