

Operator's Manual

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General safety instructions for Power Tools

1.KNOW YOUR POWER TOOL

Read and understand the owner's manual and labels affixed to the tool.Learn its application and limitations as well as the specific potential hazards peculiar to this tool.

2.GROUND ALL TOOLS

This tool is equipped with an approved 3 conductor and a 3 prong grounding type plug to fit the proper grounding type receptacle.

3.KEEP GUARDS IN PLACE

In working order and in proper adjustment and alignment.

4.WEAR PROPER APPAREL

Do not wear loose clothing,gloves,neckties,or jewelry (rings,wrist,watches) to get caught in moving parts.Wear protective hair covering to contain long hair.Roll long sleeves above the elbow.

5.USE SAFETY GOGGLES

6.KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents.Floor must not be slippery due to wax or sawdust.

7.KEEP CHILDREN AWAY

Main Specification

	Bench	Floor
Chuck Capacity	16mm	16mm
Distance,Spindle to column	190mm	190mm
Max.Spindle travel	80mm	80mm
Max.distance chuck to table	350mm	350mm
Max.distance chuck to base	600mm	600mm

Range of spindle speeds

12 speeds

Motor Speed		Spindle Speeds (min ⁻¹)											
50Hz	1400 min ⁻¹	180	250	300	400	480	580	970	1280	1410	1540	2270	2740
60Hz	1700 min ⁻¹	250	340	390	510	600	650	990	1550	1620	1900	2620	3100

16 speeds

Motor Speed		Spindle Speeds (min ⁻¹)															
50Hz	1400 min ⁻¹	190	250	360	400	490	540	600	720	750	780	1300	1600	1700	2070	2380	3000
60Hz	1700 min ⁻¹	220	300	430	480	590	650	720	850	900	950	1600	1900	2000	2500	2900	3600

Overall dimensions(LXMXH) 1065x650x305 mm³

1635x610x365 mm³

Net Weight

61KGS

67 KGS

Unpacking and checking contents

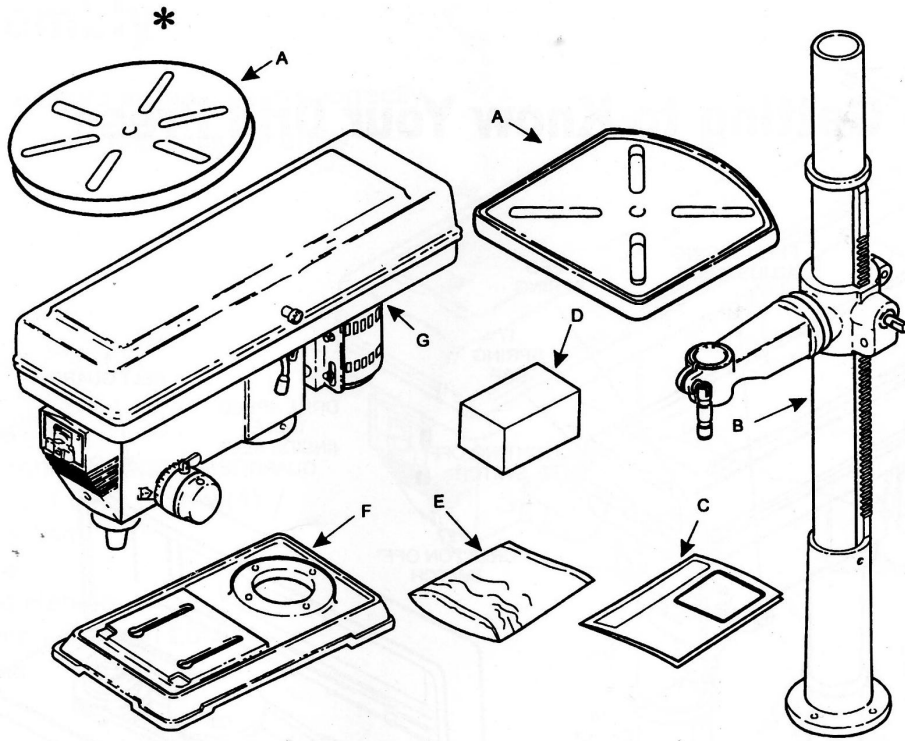
1.Unpacking and checking contents

Separate all the parts from packaging materials and check each item make sure all items are accounted for before discarding any packing material.














Item	Description	Qty
A	Table (square or Round).....	1
B	Column Support Asm.....	1
C	Owner's Manual.....	1
D	Box of Loose Parts.....	1
E	Bag of Loose Parts.....	*
F	Base.....	1
G	Head Asm.....	1

2.Remove the protective oil that is applied to the table and column.Use any ordinary household type grease and spot remover

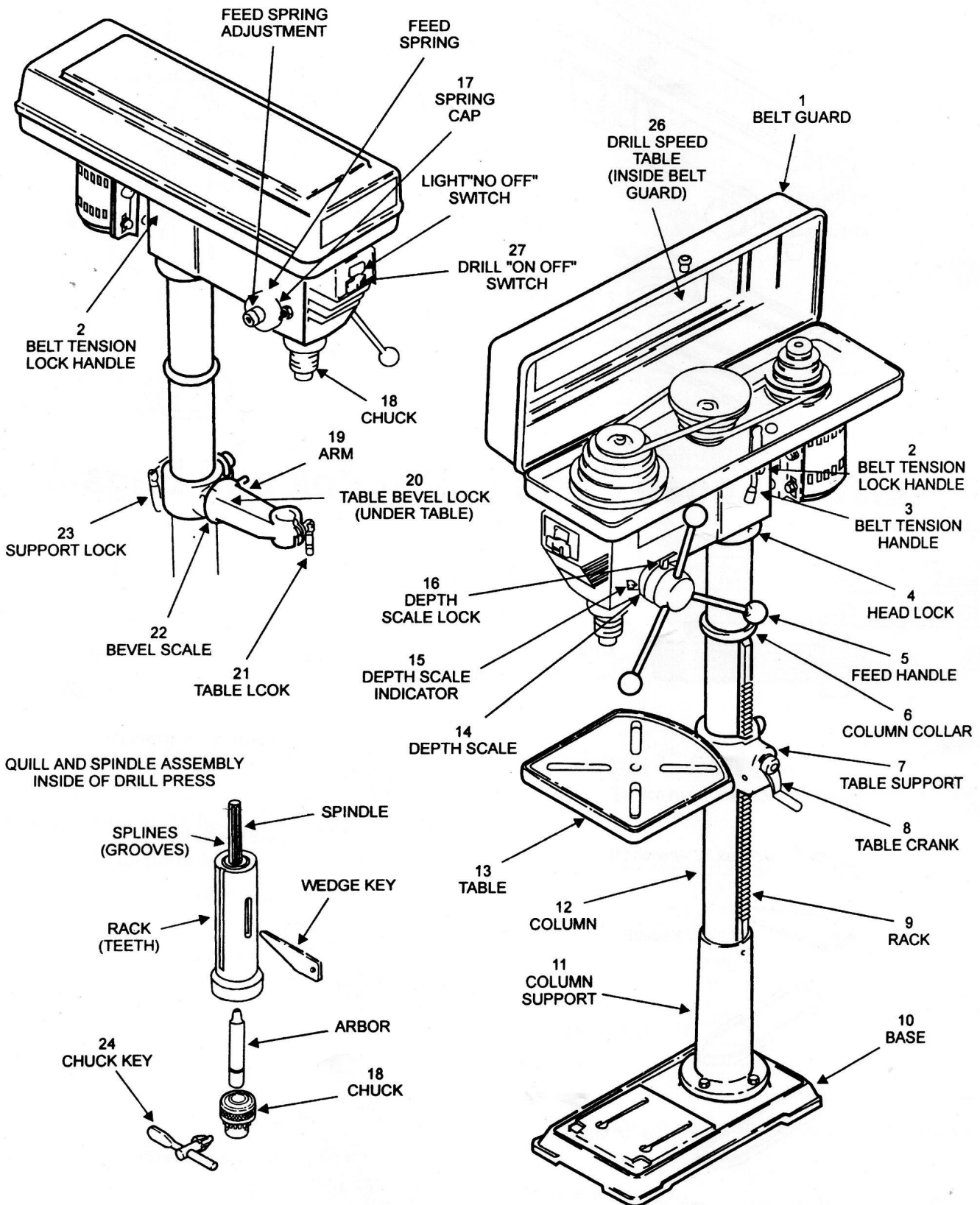
3.Apply a coat of paste wax to the table and column to prevent rust.Wipe all parts thoroughly with clean dry cloth.



List of Loose Parts in the box and bags

- | | | | |
|---|--------------------------------------|--|----------------------------|
|  | M10X1.5-40Long
Hex head screw (4) |  | Clamp-column lock (1) |
|  | M3 Hex "L"wrench (1) |  | Crank (with set screw) (1) |
|  | M4 Hex "L"wrench (1) |  | Feed handle (3) |
|  | M5 Hex "L" wrench (1) |  | Key-chuck (1) |
|  | Key-drift (1) |  | Chuck (1) |
|  | Belt "V" M24(1) |  | Idler pulley assembly (1) |
|  | Belt "V" M26(1) | | |

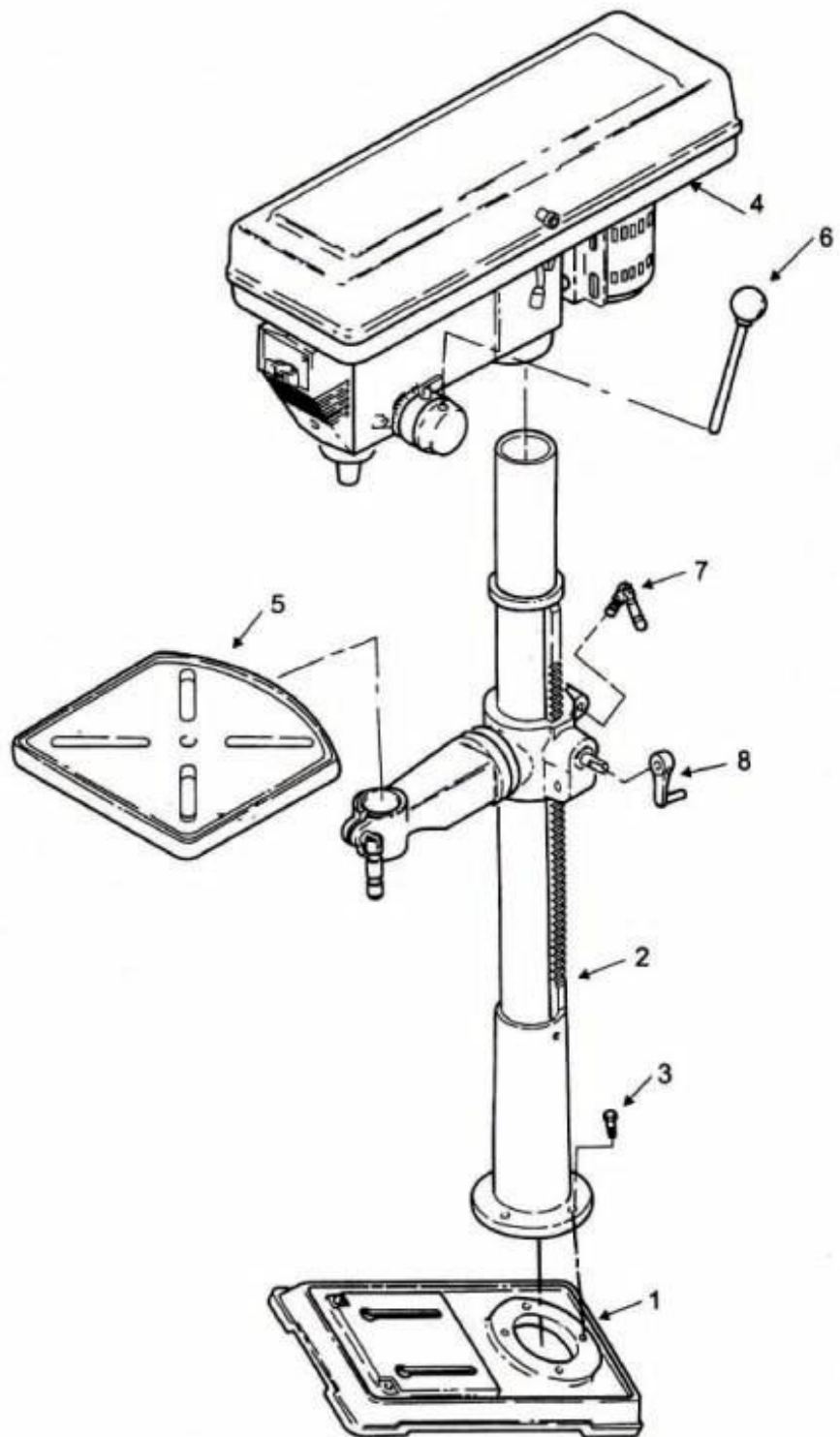
Getting to Know Your Drill Press



Assembly

Refer to the figure install all parts correctly,
tighten the screw and bolts securely.

- 1 Base
- 2. Column/w Support Asr
- 3 M10*1.5-40Screw (4)
- 4 Head Asm
- 5 Table
- 6 Feed Handle
- 7 Clamp-Column Lock
- 8 Crank



Lubrication

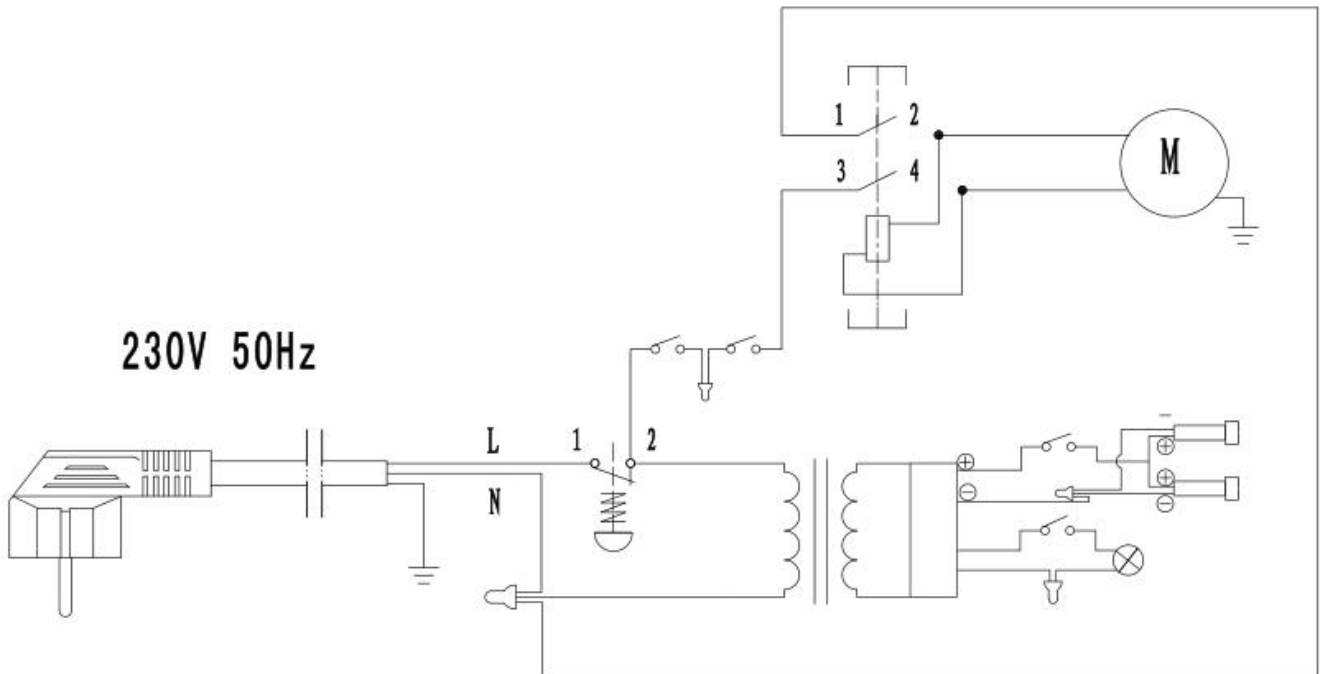
All of the BALL BEARING are packed with grease at the factory.They require no further lubrication. Periodically lubricate the table elevation machanism,the SPLINES (grooves) in the spindle,and the RACK (teeth of the quill),see "Getting to know your drill press."

Maintenance

Frequently blow out any dust that may accumulate inside the motor.

A coat of automotive type paste was applied to the table and column will help to keep the surfaces clear

Wire diagram



n.

Trouble Shooting

TROUBLE	PROBABABLE CAUSE	REMEDY
Noisy Operation	<ol style="list-style-type: none"> 1.Incorrect belt tension. 2.Dry Spindle. 3.Loose spindle pulley 4.Loose motor pulley 	<ol style="list-style-type: none"> 1.Adjust tension. 2.Lubricate spindle. 3.Checking tightness of retaining nut on pulley and tighten if necessary. 4.Tighten setscrews in pulleys.
Drill bit burns	<ol style="list-style-type: none"> 1.Incorrect speed. 2.Chips not coming out of hole. 3.Dull drill bit 4.Feeding too slow 5.Not lubricated 	<ol style="list-style-type: none"> 1.Change speed. 2.Retract drill bit frequently to clear chips. 3.Resharpener drill bit. 4.Faster the speed. 5.Lubricate drill bit.
Drill bit leads off... hole not round	<ol style="list-style-type: none"> 1.Hard grain in wood or lengths of cutting lips and/or angles not equal 2.Bent drill bit 	<ol style="list-style-type: none"> 1.Resharpener drill bit correctly. 2.Replace drill bit.
Wood splinters on underside	<ol style="list-style-type: none"> 1.No "back up material" under workpiece. 	<ol style="list-style-type: none"> 1.Use "back-up material"
Workpiece turn loose from hand	<ol style="list-style-type: none"> 1.Not supported or clamped properly. 	<ol style="list-style-type: none"> 1.Support working or clamp it.
Drill bit binds in workpiece	<ol style="list-style-type: none"> 1.Workpiece pinching drill bit or excessive feed pressure. 2.Improper belt tension. 	<ol style="list-style-type: none"> 1.Support working or clamp it. 2.Adjust tension.
Excessive drill bit runout or wobble	<ol style="list-style-type: none"> 1.Bent drill bit 2.Worn spindle bearings. 3.Drill bit not properly installed in chuck 4.chuck not properly installed. 	<ol style="list-style-type: none"> 1.Use a straight drill bit. 2.Replace bearings. 3.Install drill bit properly. 4.Install chuck properly.
Quill Returns too slow or too fast	<ol style="list-style-type: none"> 1.Spring has improper tension. 	<ol style="list-style-type: none"> 1.Adjust spring tension.
Chuck will not stay attached to spindle if falls off when trying to install it.	<ol style="list-style-type: none"> 1.Dirty,grease,or oil on the tapered inside surface of chuck or on the spindles tapered surface. 	<ol style="list-style-type: none"> 1.Using a household detergent clean the tapered surface of the chuck and spindle to remove all dirt,grease and oil.

Repair Parts

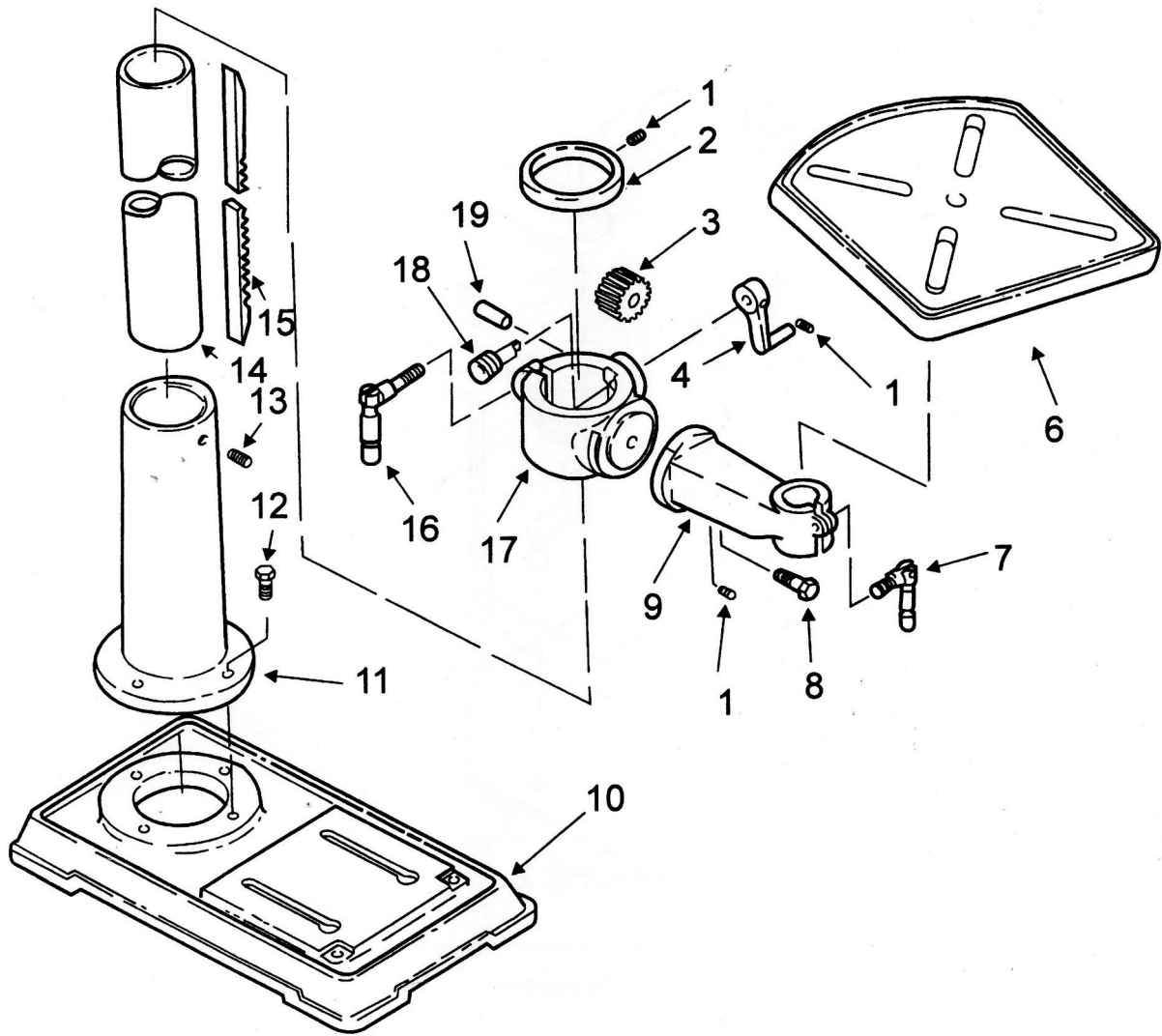


FIGURE1

FIGURE1 PARTS LIST

Key No.	Description
1	Screw-Hex Soc.Set M6*1.0-10
2	Collar-Rack
3	Gear-Helical
4	Crank
6	Table
7	Clamp-Table
8	Screw-Hex HD M16*20-35
9	Arm-Table w/Scale
10	Base

Key No.	Description
11	Support Column
12	Screw-Hex HD M10*1.5-40
13	Screw-Hex Soc.Set M10*1.5-12
14	Tube Column
15	Rack
16	Clamp-Column
17	Support Table w/Indicator
18	Worm-Elevation
19	Pin-Gear

Repair Parts

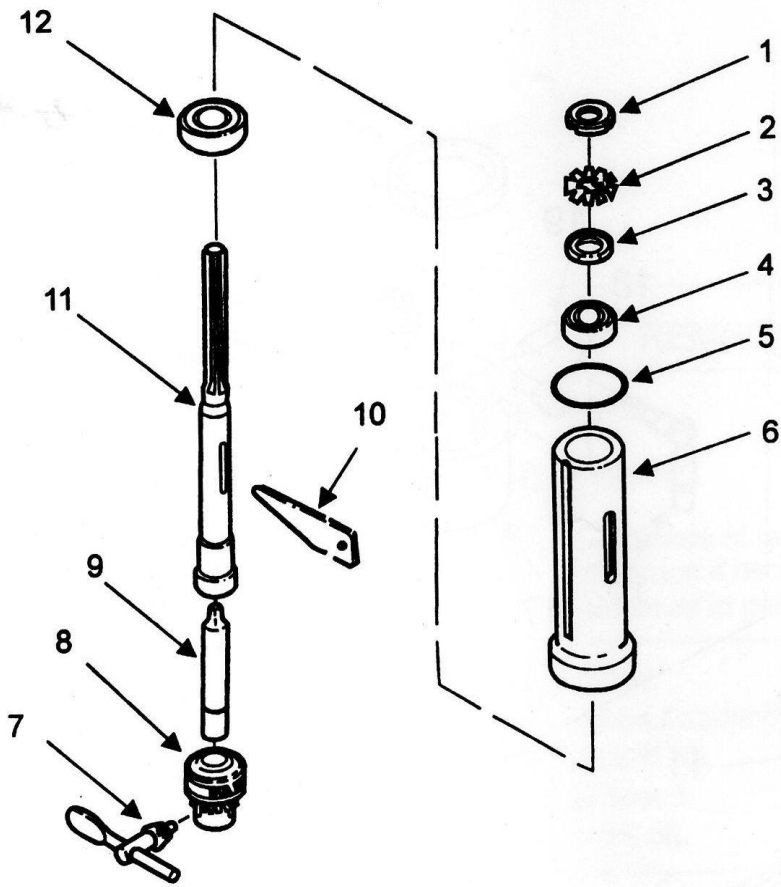


FIGURE2

FIGURE2 PARTS LIST

Key No.	Description
1	Nut-Lock
2	Ring-Locking
3	Washer
4	Bearing-Ball 17mm
5	Washer-Rubber
6	Tube-Quill
7	Key-Chuck
8	Chuck
9	Arbor
10	Key-Drift
11	Spindle
12	Bearing-Ball

Repair Parts

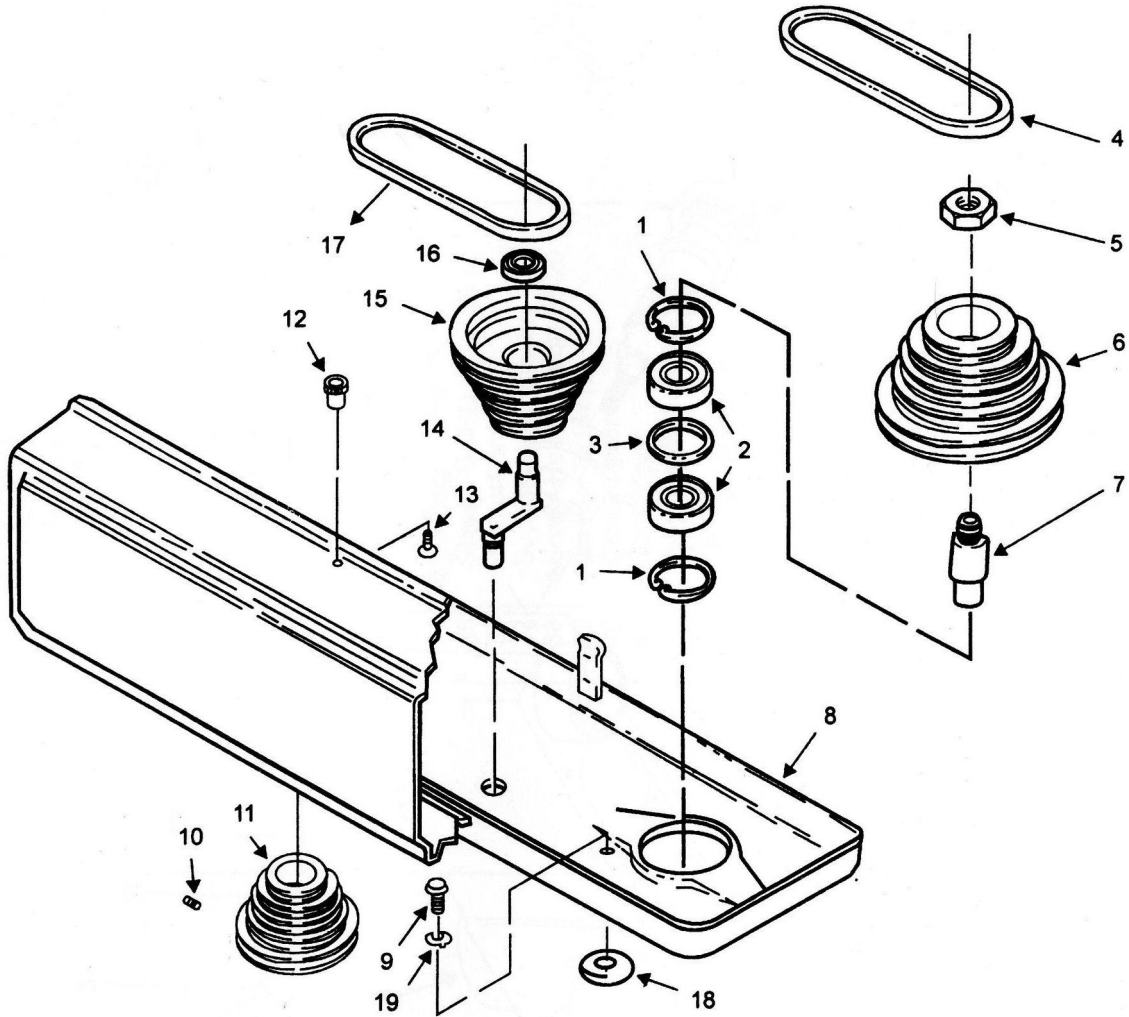


FIGURE3 PARTS LIST

Key No.	Description
1	Ring-Retaining
2	Bearing-Ball 25mm
3	Spacer-Bearing
4	Belt-"V" M24
5	Nut-Pulley
6	Pulley-Spindle
7	Insert-Pulley
8	Guard-Pulley w/Labels
9	Screw-RD HD Washer M6*1.0-16

Key No.	Description
10	Screw-Set M10*1.5-12
11	Pulley-Motor
12	Knob
13	Screw-Pan HD M5*0.8-12
14	Pivot-Ldler
15	Pully-Center
16	Bearing-Ball 15mm
18	Washer Foam
19	Lock Washer Ext.M6

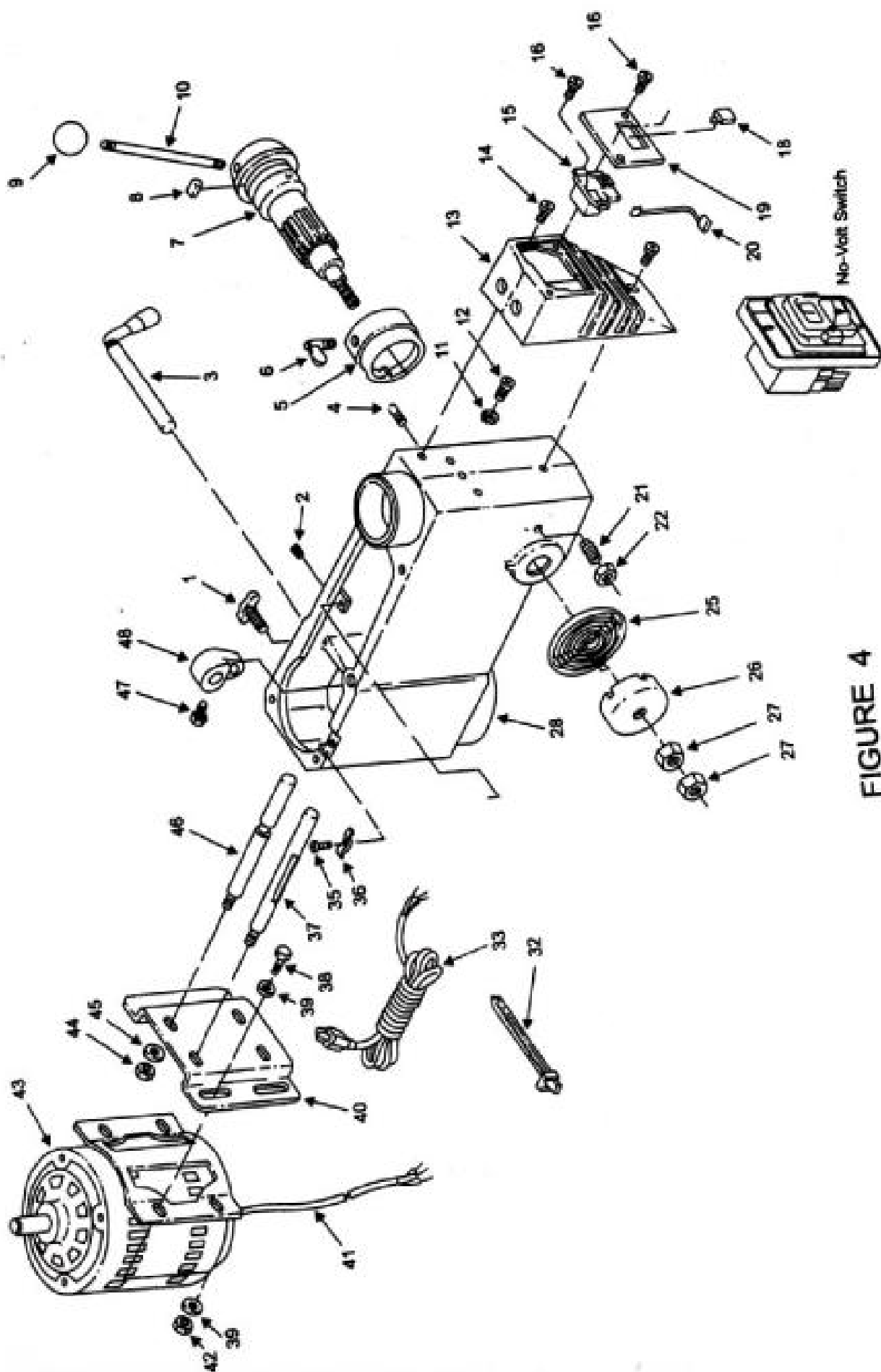


FIGURE 4

FIGURE4 PARTS LIST

Key No.	Description
1	knob-Motor Adjusting
2	Screw-Socket Set M10*1.5-12
3	Handle-Belt Tension
4	Pin-Stop
5	Ring-Depth Stop W/Scale
6	Lock-Depth Screw
7	Hub
8	Guide Scale
9	Knob
10	Rod
11	Lock-Washer-Ext M5
12	Screw-Pan HD M5*0.8-8
13	Box Switch
14	Screw-Pan HD M5*0.8-16
15	Switch-Locking
16	Screw-Pan HD M4.2*1.4-8
18	Key-Switch
19	Cover-Switch Plate
20	Lead-Asm 3
21	Screw-Set Special 10*1.5-27
22	Nut-Hex M10*1.5

Key No.	Description
25	Spring-Torsion
26	Cap-Spring
27	Nut-Hex M12*1.5-8
28	Head w/Pointer and Trim
32	Tie-Wire
33	Cord-Power w/Plug
36	Clamp-Cord
37	Support-Motor Bracket
38	Screw-Hex HD M6*1.0*12
39	Washer 8*16*1.6
40	Mount-Motor
41	Cord-Motor
42	Nut-Hex M8*1.25
43	Motor
44	Nut-Hex M12*1.75
45	Lockwasher 1/2
46	Support-Motor Bracket
47	Screw-Hex HD M8*1.25-16
48	Lever-Adjusting