

SETUP & OPERATION MANUAL

FEATURES

Forced opening line interrupter switch, requires machine restart in case of power failure or circuit interruption.

Adjustable spindle tension return spring.

Built-in laser pointer.

Sturdy design with cast-iron head, base, and table.

High-quality bearings for smooth, vibration-free operation.

Simple hand lever controlled mechanical variable speed from 500 to 3000 rpm.

Digital spindle speed display.

1/3 HP industrial-quality, 120 V motor.

Equipped with easy to adjust dual depth stop for complete control of both down stroke depth and upstroke travel.

5/8" chuck with key & convenient onboard chuck key holder.

Easy to use see-through flip-up chuck guard included.

Crank-operated rack and pinion table height adjustment.

SPECIFICATIONS

- Swing
12" (305 mm)
- Drilling capacity
5/8" (16 mm)
- Chuck size
5/8" (16 mm)
- Spindle travel
3 1/8" (80 mm)
- Spindle distance to table
15" (380 mm)
- Spindle distance to base
21 7/8" (556 mm)
- Table size
9 1/2" x 9 1/2" (240 x 240 mm)
- Column diameter
2 1/2" (65 mm)
- Spindle speeds
(Variable) - 500 to 3000 rpm
- Spindle taper
MT 2
- Overall height
34 1/8" (868 mm)
- Base size
15" x 9 5/8" (380 x 245 mm)
- Motor
1/3 HP, 120 V, 3.2 A
- Weight
75 lbs (34 kg)

12" VARIABLE SPEED DRILL PRESS - BENCH TOP



MODEL #75-010





GENERAL® INTERNATIONAL

8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3
Telephone (514) 326-1161 • Fax (514) 326-5555 • www.general.ca

THANK YOU for choosing this General® International model 75-010 drill press. This drill press has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this drill press as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking/metalworking instruction, nor to offer the user instruction in the craft of woodworking/metalworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

DISCLAIMER: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the

unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of drill press and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your unit exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® INTERNATIONAL WARRANTY

All component parts of General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® International agrees to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from the improper use of its equipment.

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- | | |
|---|---|
| 1. Do not operate the drill press when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness. | able work piece support if the work piece does not have a flat surface. |
| 2. The work area should be well lit, clean and free of debris. | 12. Do not push or force the bit into the stock. The drill will perform better and more safely when working at the feed rate for which it was designed. |
| 3. Keep children and visitors at a safe distance when the drill press is in operation; do not permit them to operate the drill press. | 13. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor. |
| 4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use. | 14. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning be sure it is properly re-attached before using the tool again. |
| 5. Stay alert! Give your work your undivided attention. Even a momentary distraction can lead to serious injury. | 15. Never leave the machine unattended while it is running or with the power on. |
| 6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices. | 16. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury. |
| 7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the drill press is in operation. | 17. Never stand on machinery. Serious injury could result if the tool is tipped over or if the drill bit is unintentionally contacted. |
| 8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating. | 18. Always disconnect the tool from the power source before servicing or changing accessories such as bits, or before performing any maintenance, cleaning, or if the machine will be left unattended. |
| 9. Keep hands well away from the drill bit and all moving parts. Use a hold-down or clamp to secure the stock, and use a brush, not hands, to clear away chips and dust. | 19. Make sure that the switch is in the "OFF" position before plugging in the power cord. |
| 10. Be sure that the drill bit is securely installed in the chuck before operation. | 20. Make sure the tool is properly grounded. If equipped with a 3-prong plug, it should be used with a three-pole receptacle. Never remove the third prong. |
| 11. Be sure the drill bit has gained full operating speed before beginning to drill. Always use a clean, properly sharpened bit. Dirty or dull bits are unsafe and can lead to accidents. Use suit- | 21. Do not use this drill press for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use. |
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ELECTRICAL REQUIREMENTS



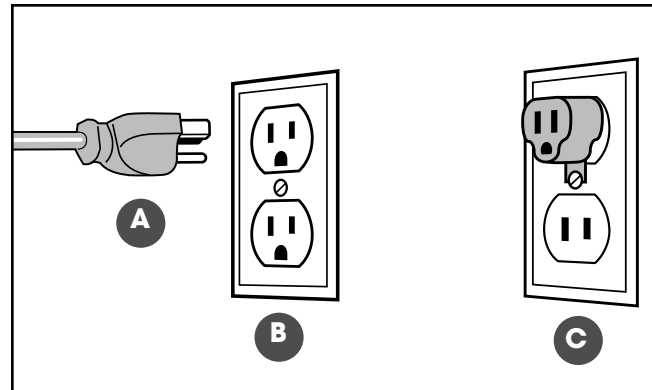
BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.

GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 120 V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug **A** to fit a grounded type receptacle **B**. Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used **C**, it must be attached to the metal screw of the receptacle.

Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.



CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

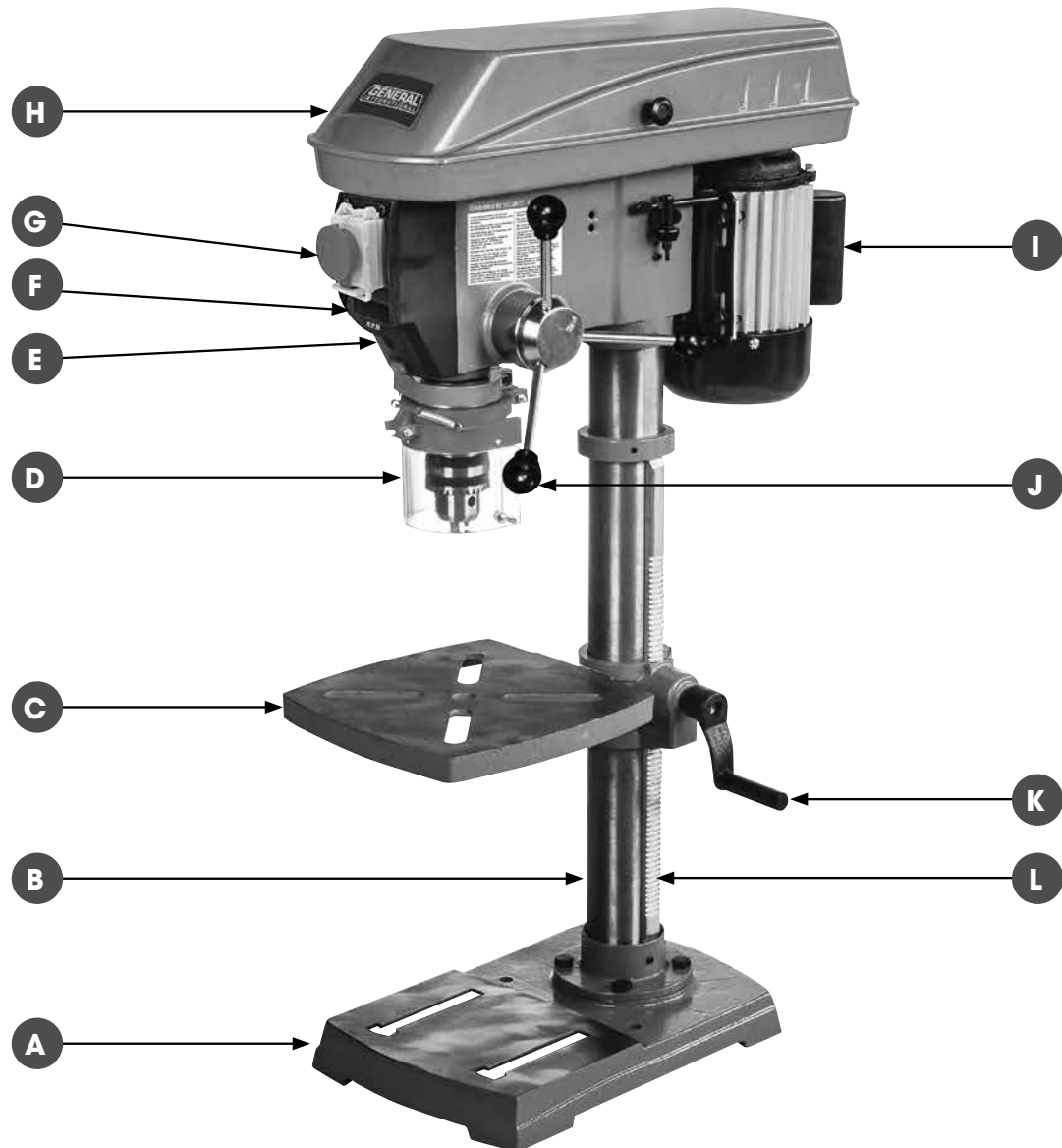
TABLE - MINIMUM GAUGE FOR CORD

EXTENSION CORD LENGTH

AMPERES	50 feet	100 feet	200 feet	300 feet
< 5	18	16	16	14
6 to 10	18	16	14	12
10 to 12	16	16	14	12
12 to 16	14	12	*NR	*NR

*NR = Not Recommended

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- A. BASE
- B. COLUMN
- C. TABLE
- D. FLIP-UP CHUCK GUARD
- E. LASER POINTER SWITCH
- F. DIGITAL SPEED DISPLAY

- G. SWITCH
- H. PULLEY COVER
- I. MOTOR
- J. FEED HANDLE
- K. TABLE CRANK HANDLE
- L. RACK

UNPACKING

Carefully unpack and remove the unit and its components from the box and check for missing or damaged items as per the list of contents below.

NOTE: PLEASE REPORT ANY DAMAGED OR MISSING ITEMS TO YOUR GENERAL® INTERNATIONAL DISTRIBUTOR IMMEDIATELY.

LIST OF CONTENTS	QTY
A. HEAD STOCK.....	1
B. BASE	1
C. TABLE	1
D. CHUCK GUARD	1
E. COLUMN.....	1
F. CHUCK.....	1
G. ARBOR.....	1
H. DOWNFEED HANDLE	3
I. SPEED CONTROL LEVER	1
J. 3, 4 & 5 MM ALLEN KEYS	3
K. DRIFT KEY	1
L. CHUCK KEY.....	1
M. BASE BOLT	4
N. TABLE ARM BOLT	1

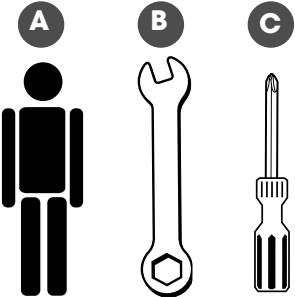
ADDITIONAL REQUIREMENTS FOR SET UP

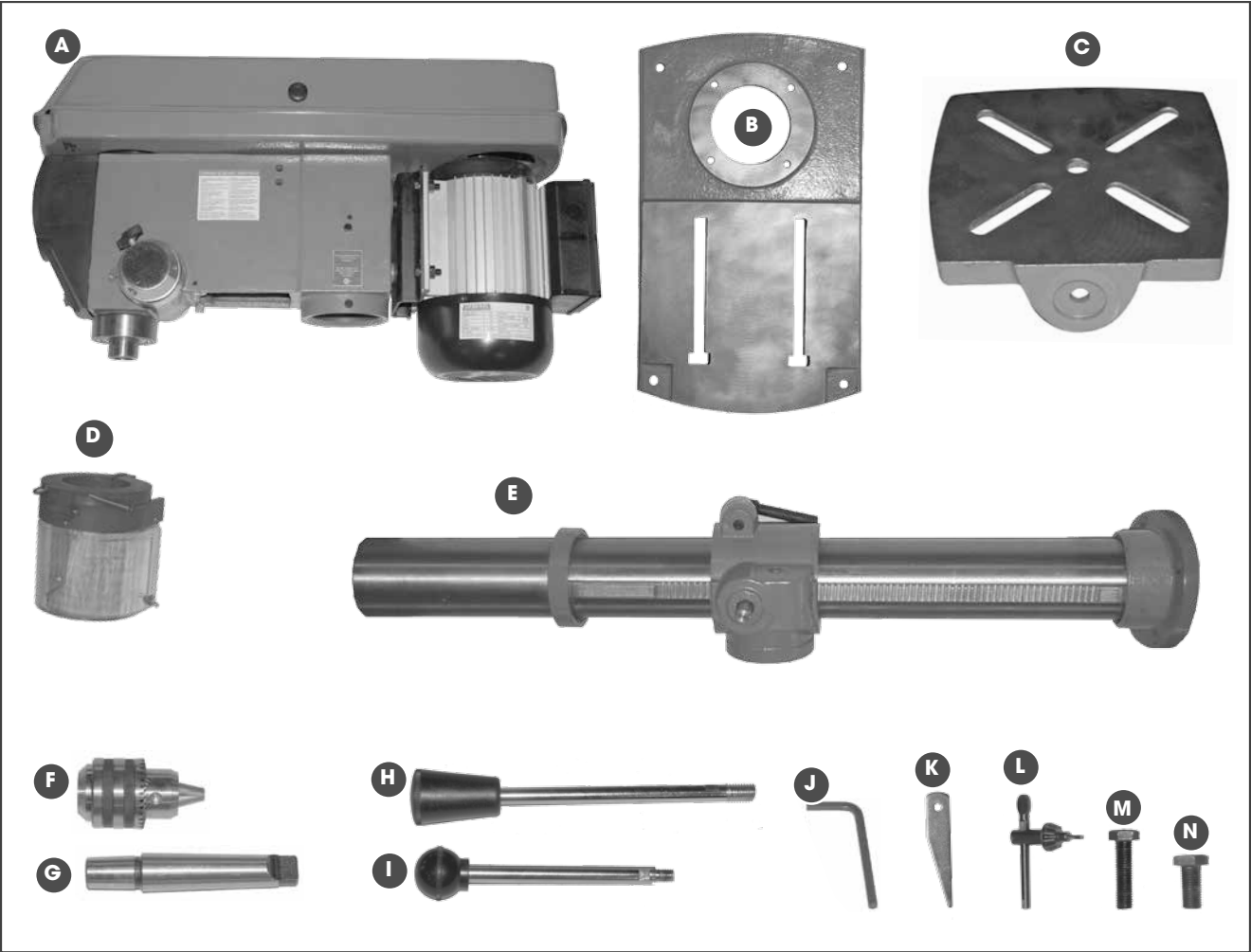
A. EXTRA PERSON FOR HELP WITH LIFTING
B. 9, 16 & 24 MM OPEN WRENCHES
C. PHILLIPS SCREWDRIVER

A

B

C





CLEANING

The protective coating on the machine prevents rust from forming during shipping and storage. Remove it by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations).

A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the machine's painted surfaces, as many solvent-based products will remove paint.

To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.



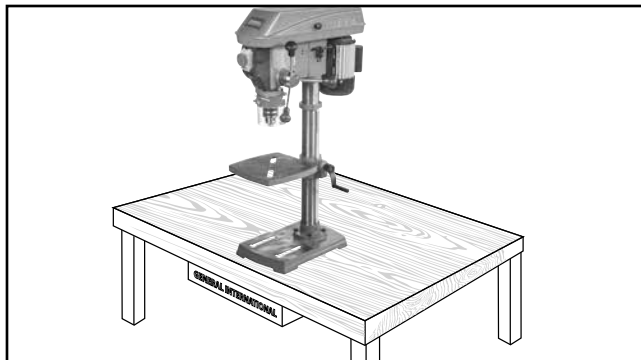
ASSEMBLY INSTRUCTIONS



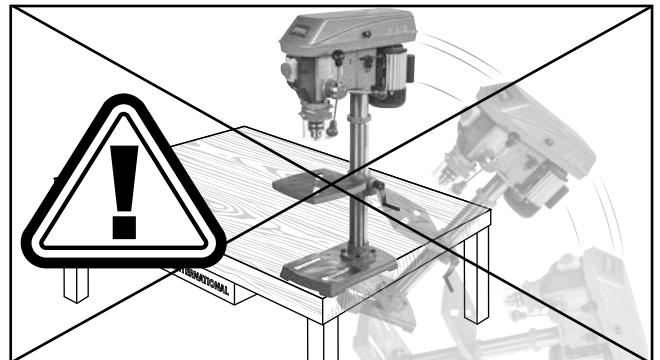
BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.

INSTALLING THE DRILL PRESS ON A STABLE SURFACE

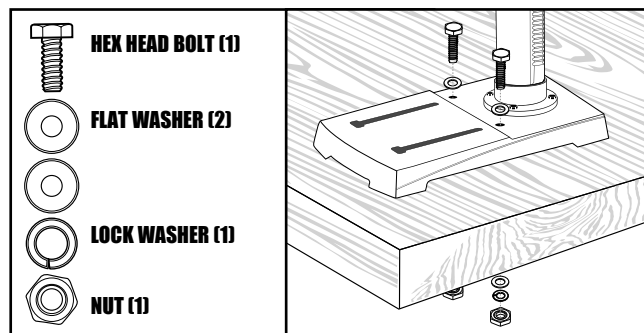
For your convenience this drill press is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.



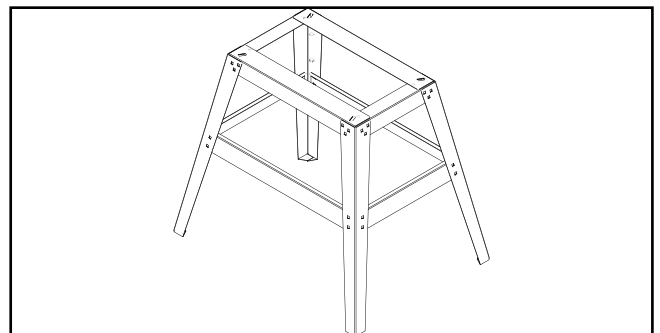
The unit should be immobilized on a flat, level, sturdy and stable surface, able to support the weight of the machine and the workpiece with ease.



Note: Never install or operate the unit over the edge of a table, workbench or other mounting surface.



If a permanent shop placement or installation is practical, consider using the mounting holes and drilling matching through holes in your workbench or mounting surface to bolt the drill press in place (hardware not included) on your workbench.

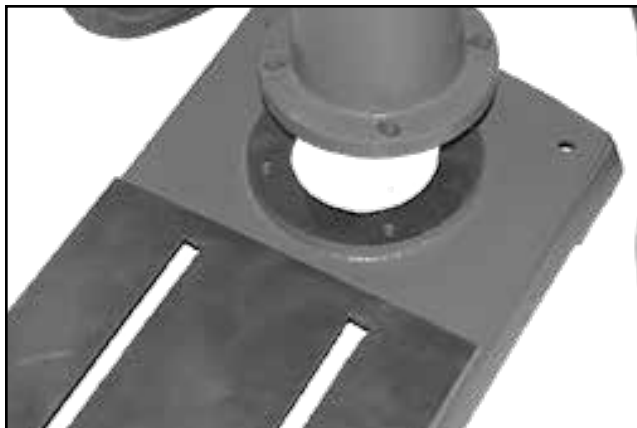


If you prefer, an optional universal steel stand (item #99-700) is available from your local General International dealer.

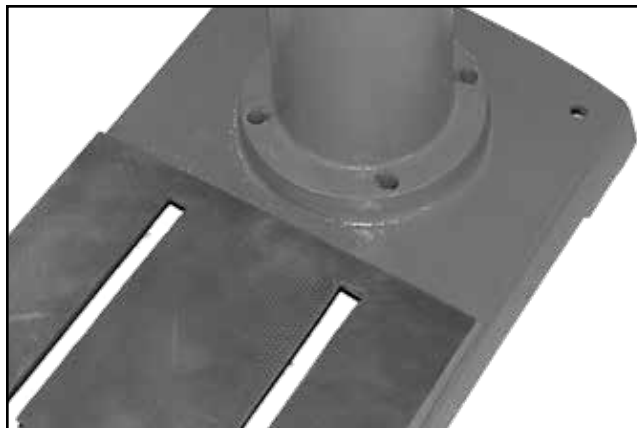


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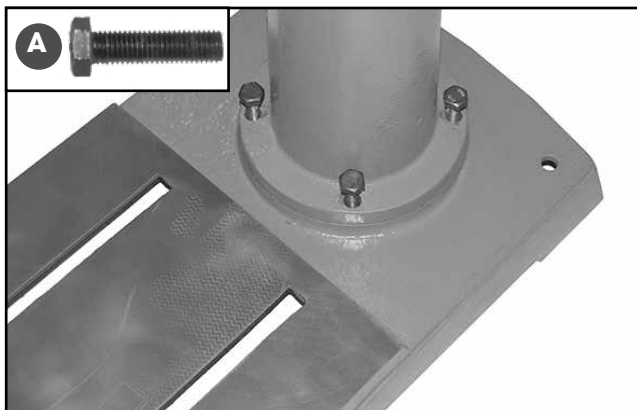
INSTALLING THE COLUMN ON THE BASE



1. Set the base on a flat and stable surface, and then install the column on the base.



2. Align the mounting holes in the column with the corresponding holes in the base.



3. Tighten the four bolts by hand **A** few turns.

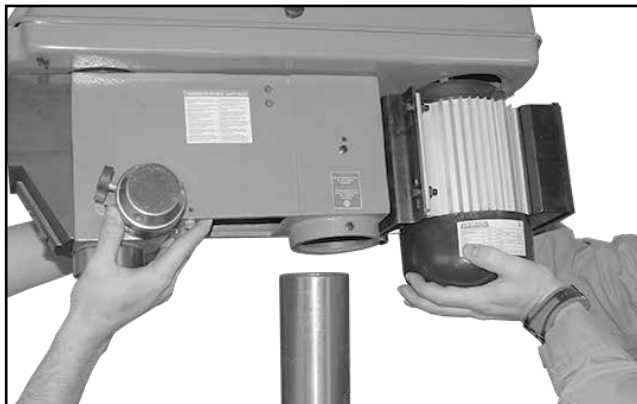


4. Then secure the bolts using a 16 mm wrench.

INSTALLING THE HEAD STOCK ON THE COLUMN



THE HEAD STOCK IS HEAVY. DO NOT OVER-EXERT. THE HELP OF AN ASSISTANT WILL BE NEEDED FOR THE FOLLOWING STEP. DO NOT GRIP THE HEAD STOCK BY THE PULLEY COVER WHEN LIFTING.



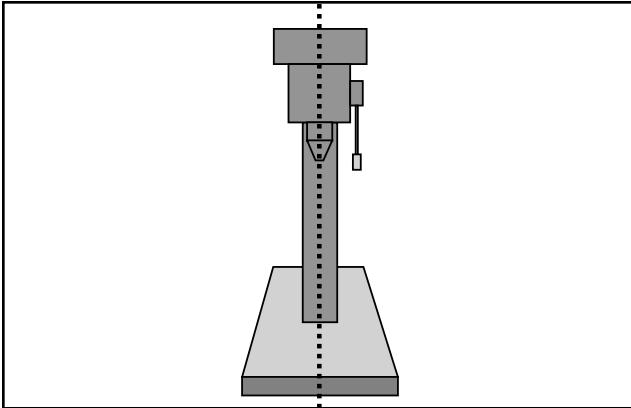
1. Lift the head stock and place its opening above the column.



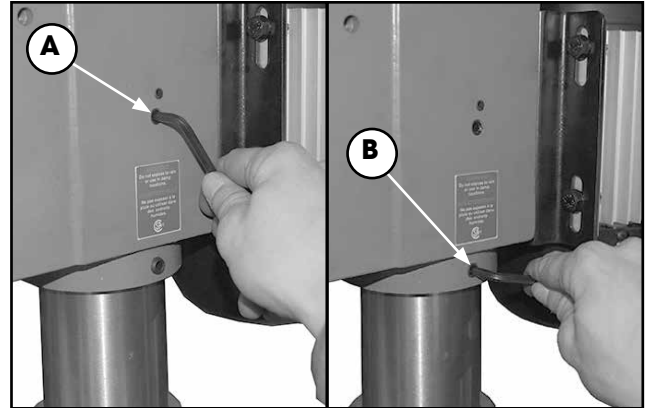
2. Slide the head stock opening onto the column.



BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE “OFF” POSITION AND THAT THE POWER CORD IS UN-PLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.

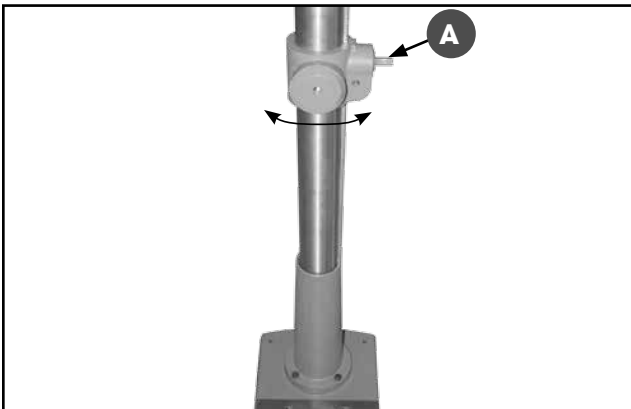


3. Center the head stock with the column and the table.

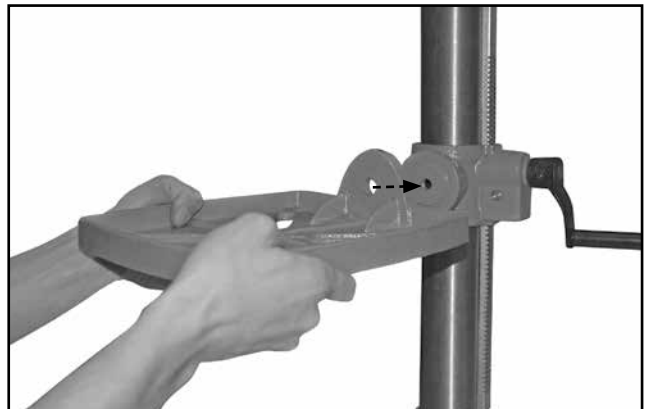


4. Secure the head stock to the column by tightening screws **A** & **B** using a 5 mm Allen key.

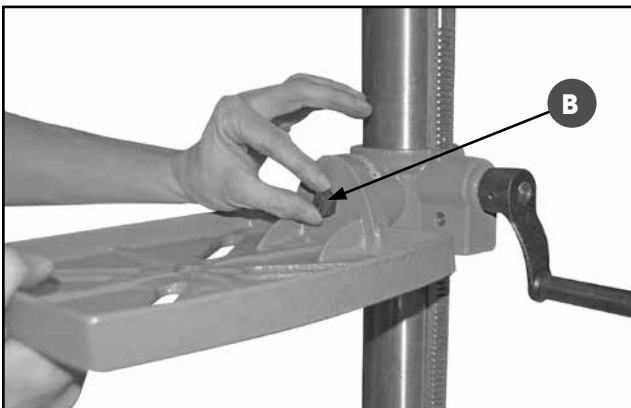
INSTALLING THE TABLE



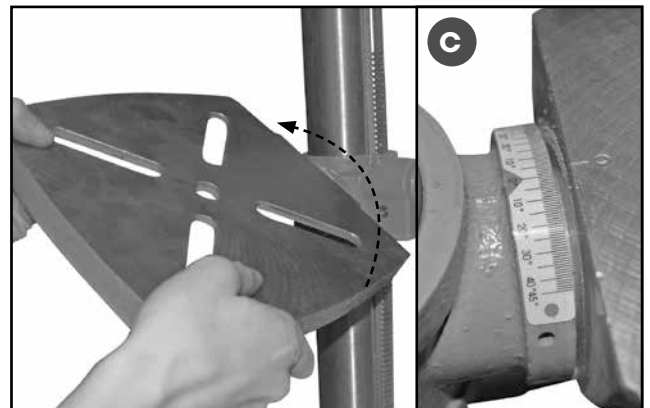
1. Make sure that arbor **A** is to the right and the table bracket is centered on the column. Turn the bracket if needed as shown.



2. Hold the table against the bracket aligning the mounting holes as shown.



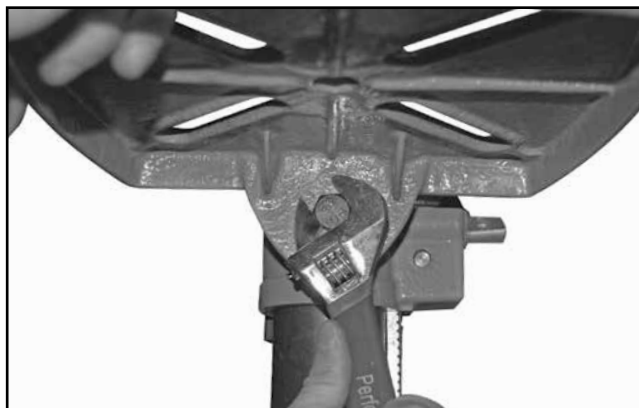
3. Tighten bolt **B** hand tight for now.



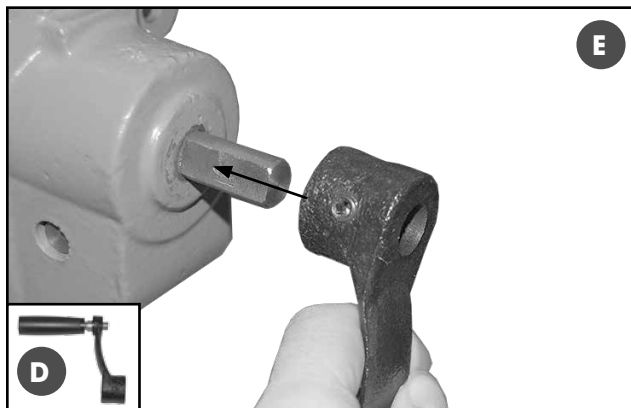
4. Turn the table until the zero point of the table bracket and the table are aligned as shown **C**.



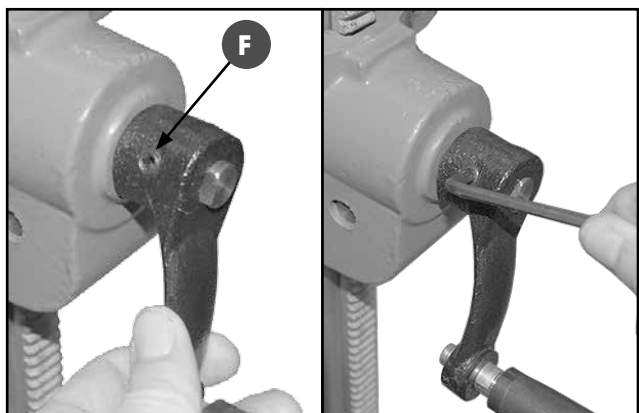
MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.



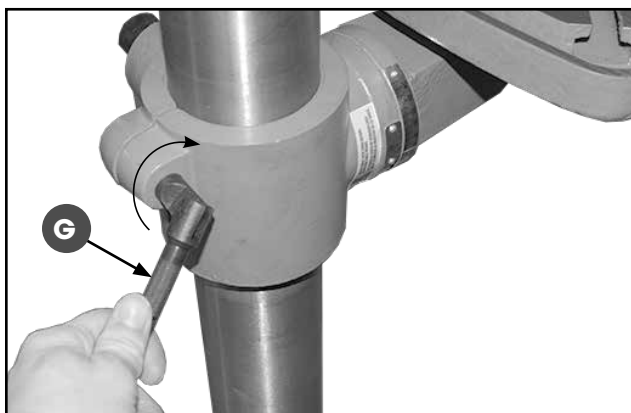
5. Tighten the arm's mounting bolt using a wrench.



6. Slide handle **D** onto the arbor as shown **E**.

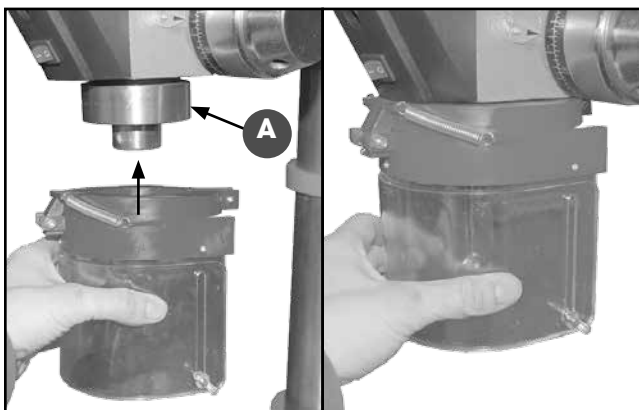


7. Tighten the set screw **F** using a 4 mm Allen key.

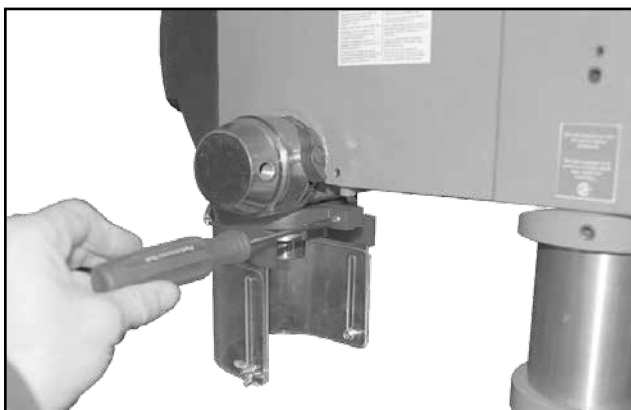


8. Lock the table in position by tightening the lever **G** as shown.

INSTALLING THE CHUCK GUARD



1. Slide the chuck guard onto its support as shown **A**.

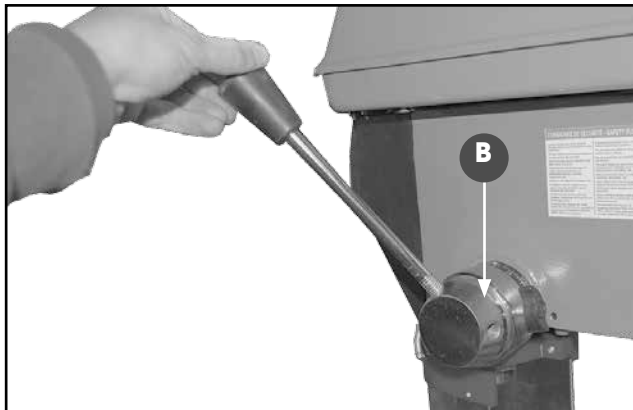


2. Tighten the chuck guard using a Phillips screwdriver.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

INSTALLING THE DOWNFEED HANDLES

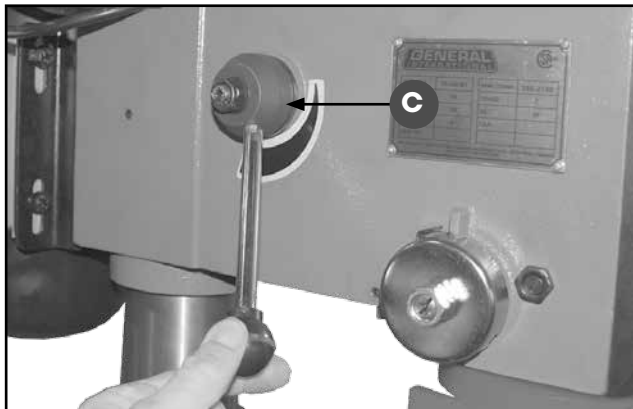


1. Thread the three downfeed handles into their mounting holes located in the support **B**.



2. Tighten each handle using a 9 mm wrench.

INSTALLING THE SPEED CONTROL LEVER

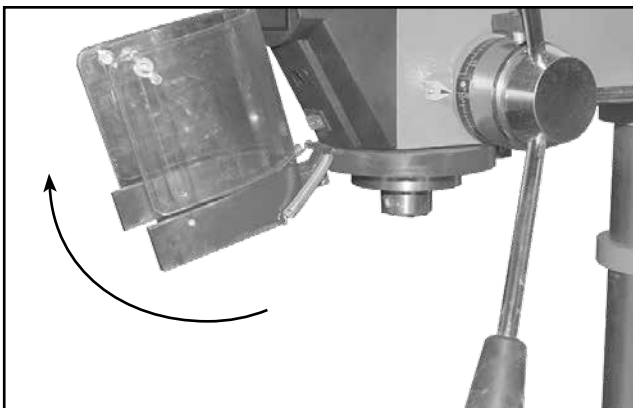


1. Thread the handle into its mounting hole located in the bracket **C**.



2. Tighten the handle using a 9 mm wrench.

INSTALLING THE CHUCK



1. Lift the chuck guard as shown.



2. Clean inside the chuck with a dry cloth until all grease or lubricant is removed.



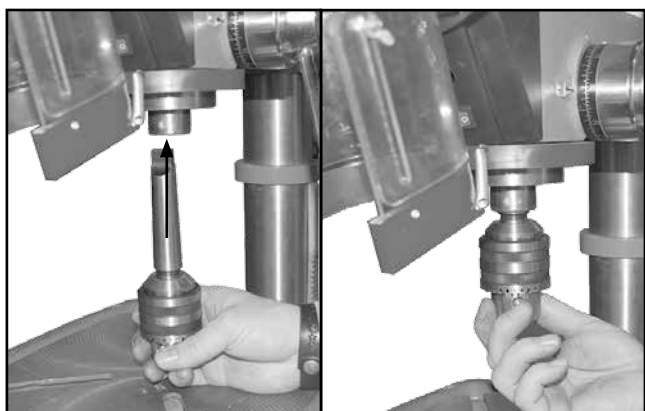
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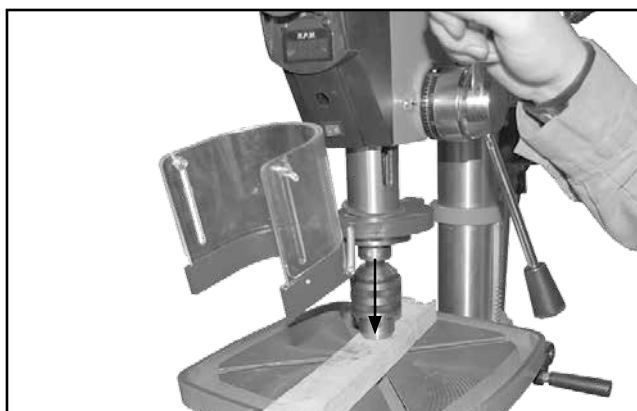
3. Fit the arbor into the chuck as shown.



4. Make sure the arbor is inserted all the way into the chuck.

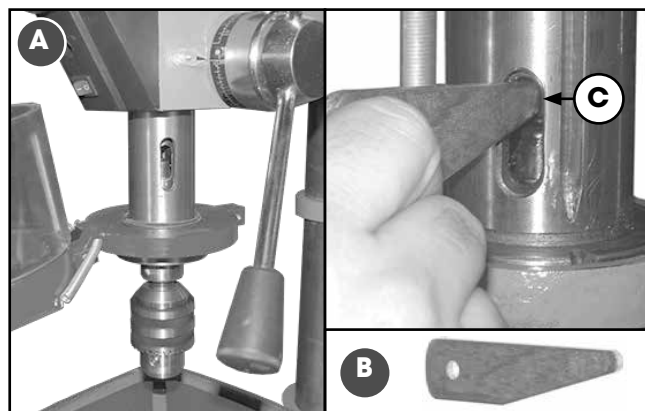


5. Slide the arbor into the quill assembly as shown.

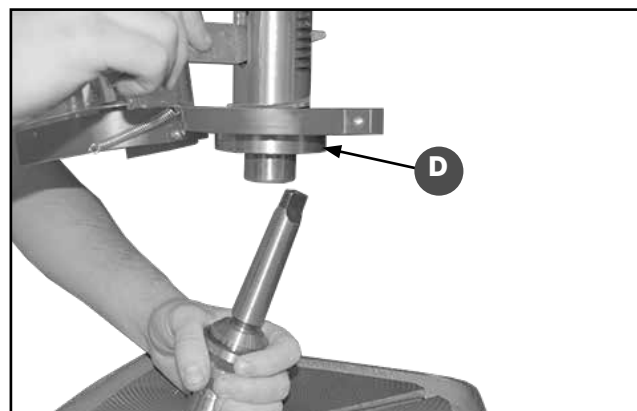


6. Using the feed handles, lower the chuck against a piece of wood on the table to pressfit it into the quill.

REMOVING THE CHUCK



1. Using feed handle, lower the quill assembly **A**. Insert the drift key **B** all the way into the quill assembly **C**.



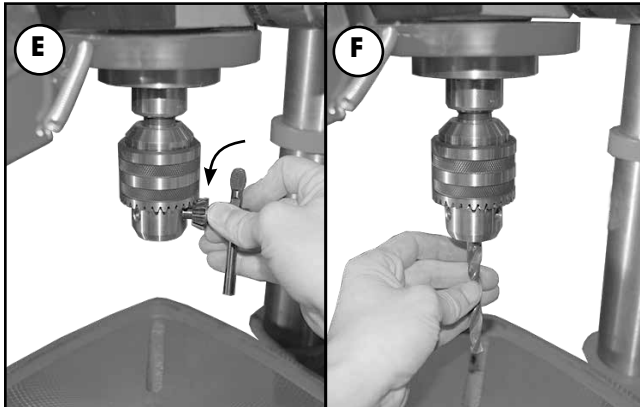
2. While holding onto the chuck, tap gently on the key with a hammer or rubber mallet to loosen and remove the arbor and chuck.

Note: It may be necessary to rotate the quill in order to be able to get the tool all the way through **D**.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

INSTALLING A DRILL BIT



1. Open the chuck by turning the key **E** counter-clockwise until you can insert a drill bit **F**.



2. Secure the drill bit in the chuck by turning the key clockwise.

BASIC ADJUSTMENTS & CONTROLS



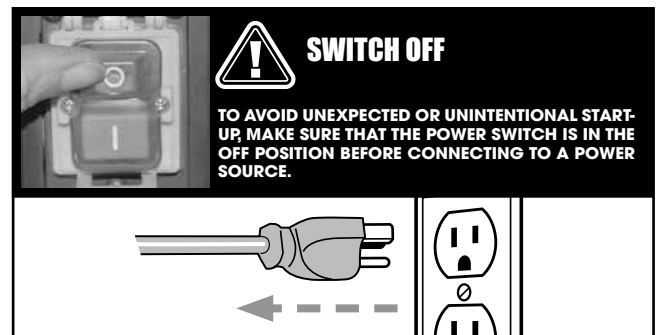
TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY. TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

CONNECTING TO A POWER SOURCE

Once the assembly steps have been completed, plug the power cord into an appropriate outlet.

Refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed.

When operations have been completed unplug the machine from the power source.



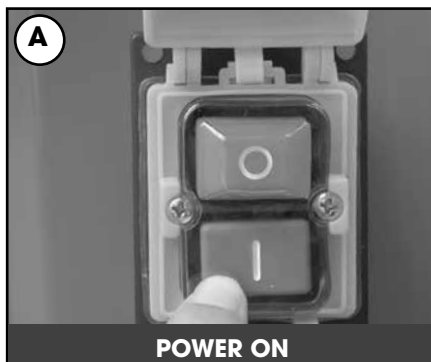
ON/OFF POWER SWITCH

This drill is equipped with a forced opening line interrupter switch located on the front which requires machine restart in case of power failure or circuit interruption.

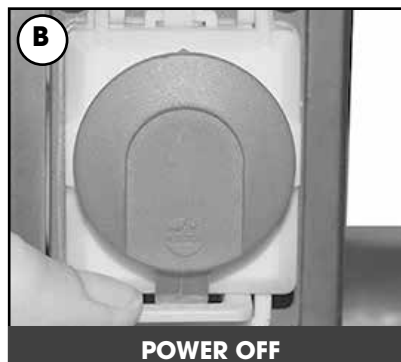
To start the machine, pull up the switch cover and press the start button "I", **A**.

To stop the machine, press directly on the switch cover **B**.

To turn on the laser pointer, set the switch **C** in the "I" position. To turn off the laser pointer, set the switch in the "O" position.



POWER ON



POWER OFF

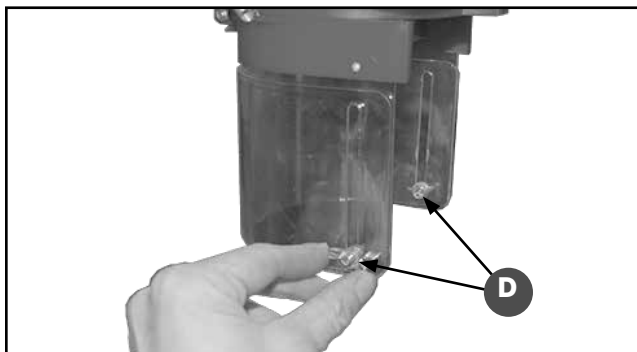


LASER POINTER SWITCH

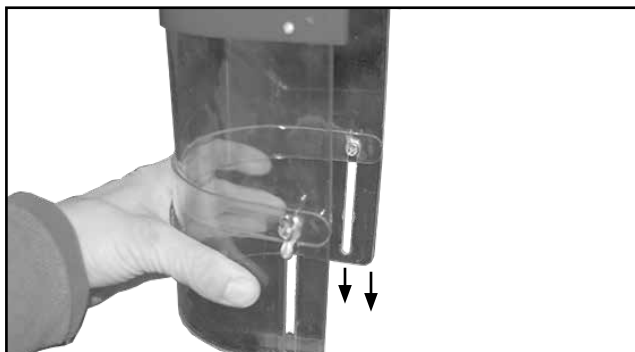


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

ADJUSTING THE CHUCK GUARD HEIGHT



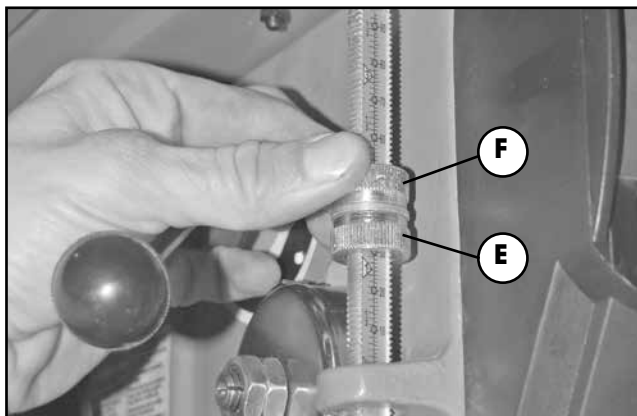
1. Loosen the wing nuts **D**.



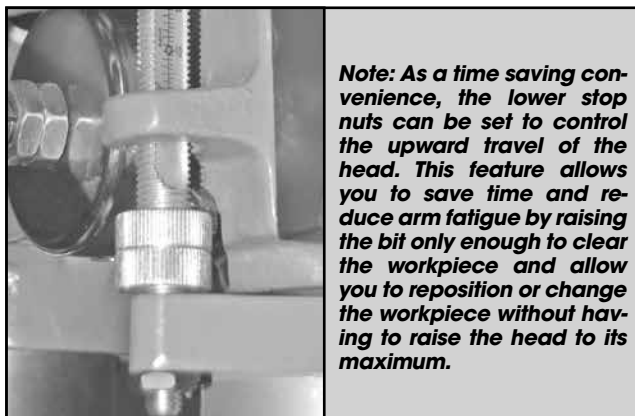
2. Position the shield at the desired height, then re-tighten the wing nuts.

ADJUSTING THE DEPTH STOP

This drill is equipped with an adjustable depth stop to allow repetitive drilling to a set depth. To set the depth stop:

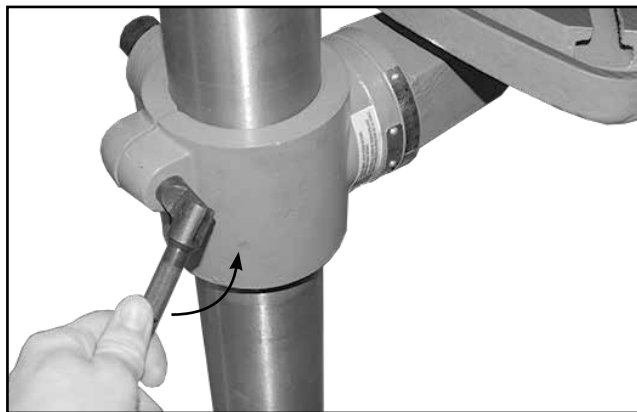


1. Set the lower stop nut **E** to the desired drilling depth and adjust the jam nut **F** against it to lock it in place.

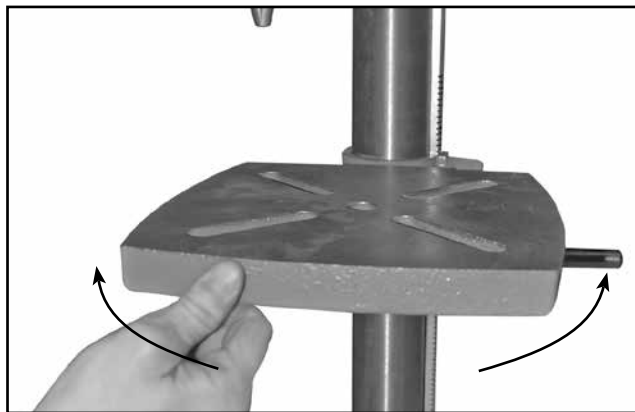


Note: As a time saving convenience, the lower stop nuts can be set to control the upward travel of the head. This feature allows you to save time and reduce arm fatigue by raising the bit only enough to clear the workpiece and allow you to reposition or change the workpiece without having to raise the head to its maximum.

TABLE SWING ADJUSTMENT



1. Loosen the column lock handle as shown.



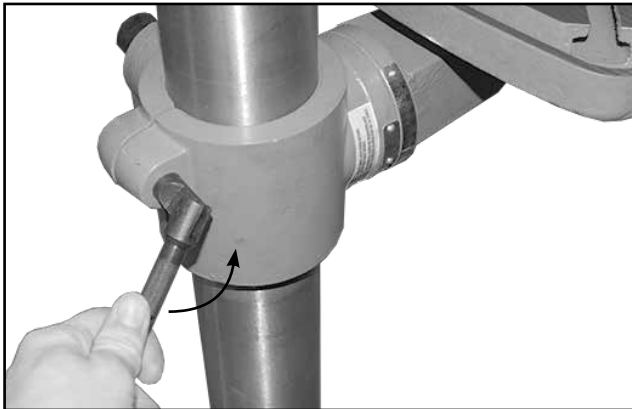
2. Swing the table to the desired position, then re-tighten the column lock handle.

Note: When working with taller work pieces swing the table 180° out of the way and use the base as a table.

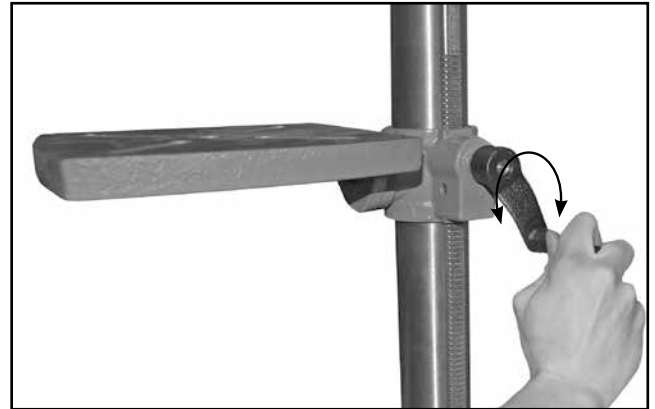


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

ADJUSTING TABLE HEIGHT

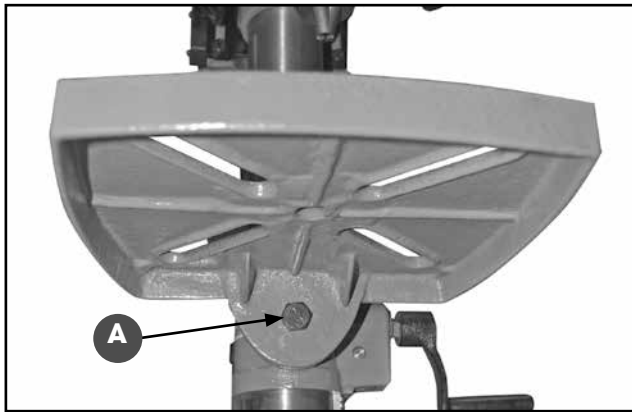


1. Loosen the column lock handle as shown.

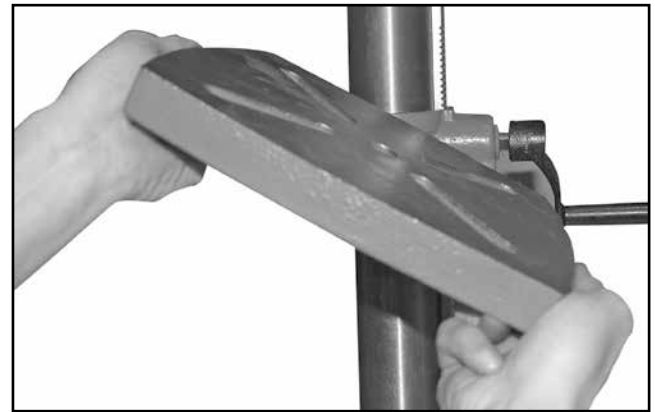


2. Turn the crank handle as shown until the table is at the desired height, then retighten the column lock handle.

TABLE TILT ADJUSTMENT



1. Loosen nut A



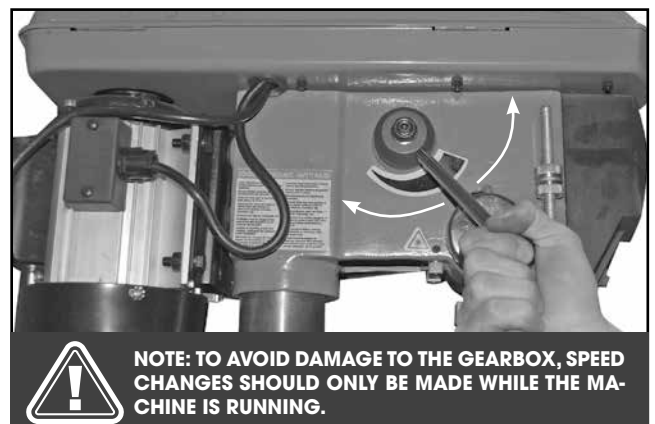
2. Tilt the table to the desired angle, and then retighten the nut A.

DRILL SPEED ADJUSTMENT

This machine is equipped with a mechanical variable speed drive pulley system that allows the user to change the spindle speed while the machine is in operation.

This system is considered more efficient and convenient than models that require a complete shut-down and then a more complicated change of belts on a multi-pulley system.

To change speeds the user simply turns on the machine and then turns the speed control lever in the appropriate direction until the desired speed appears on the digital speed display.



NOTE: TO AVOID DAMAGE TO THE GEARBOX, SPEED CHANGES SHOULD ONLY BE MADE WHILE THE MACHINE IS RUNNING.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

GUIDELINES FOR SELECTING SPEEDS BASED ON BIT SIZE AND BIT MATERIAL

	BIT MATERIAL				
	CAST STEEL	TOOL STEEL	CAST IRON	MILD STEEL	ALUMINUM COPPER
DOWNFEED SPEED	40 fpm	60 fpm	80 fpm	100 fpm	200 fpm
DRILL BIT DIAMETER	SPEED (rpm)				
1/16" (2 mm)	1910 - 2445	2865 - 3665	3820 - 4890	4775 - 6110	9550 - 12 225
1/8" (3 mm)	1220 - 1275	1835 - 1910	2445 - 2545	3055 - 3185	6110 - 6365
3/16" (5 mm)	765 - 815	1145 - 1220	1530 - 1630	1910 - 2035	3820 - 4075
1/4" (6 mm)	610	915 - 955	1220 - 1275	1530 - 1590	3055 - 3180
5/16" (8 mm)	480 - 490	715 - 735	955 - 980	1195 - 1220	2390 - 2445
3/8" (10 mm)	380 - 405	570 - 610	765 - 815	955 - 1020	1910 - 2035
7/16" (11 mm)	350	520 - 525	700	870	1740 - 1745
1/2" (13 mm)	300 - 305	440 - 460	590 - 610	735 - 765	1470 - 1530
5/8" (16 mm)	240 - 245	360 - 365	480 - 490	600 - 610	1200 - 1220
3/4" (19 mm)	190 - 205	285 - 305	380 - 405	480 - 510	955 - 1200

OPERATING INSTRUCTIONS

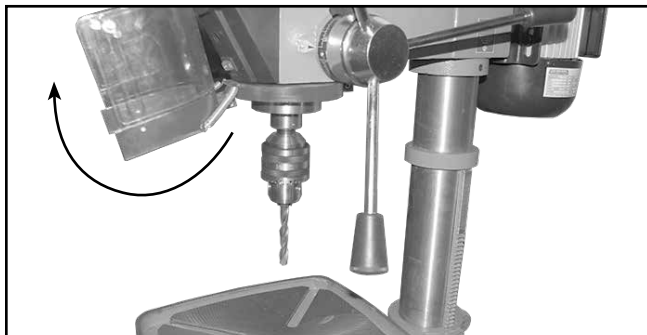
CHECKLIST BEFORE STARTING



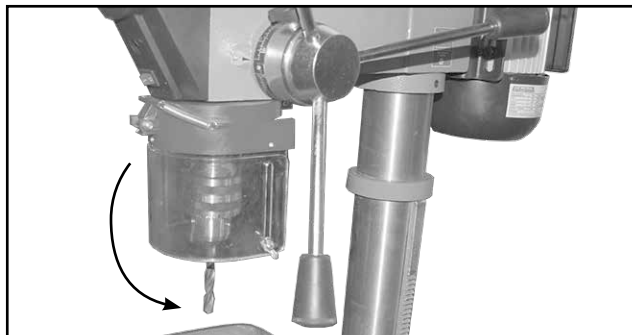
VERIFY ALL CHECK POINTS BEFORE STARTING. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

- Make sure the pulley cover is closed.
- Check that the chuck is installed properly.
- Make sure the chuck guard is securely installed and closed properly.
- When turning the machine "ON" be aware that the shaft will rotate freely.
- When the drill press is running check to see if it runs without vibration or shaking.
- Make sure the table bracket moves up and down smoothly.
- Make sure the spindle shaft turns smoothly.

DRILLING STEP-BY-STEP



1. Lift the chuck guard as shown and install a drill bit suitable for the type of material to drill.



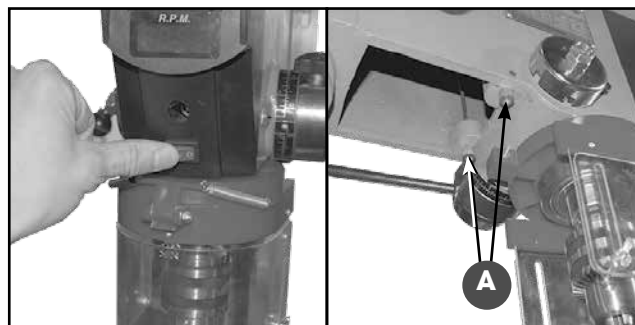
2. Flip the chuck guard down in place as shown.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.



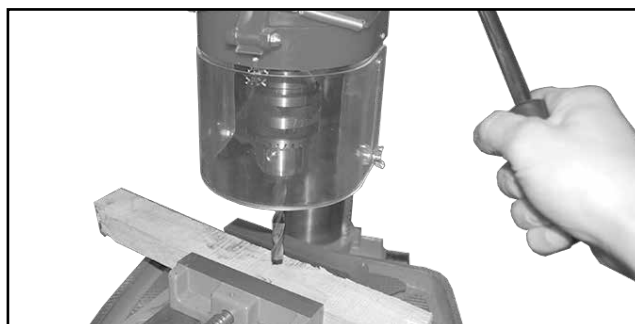
3. Secure the workpiece in a vise (optional).



4. For precision drilling use the laser pointer to locate the drilling point on the workpiece.



5. Turn ON the machine and adjust the speed.

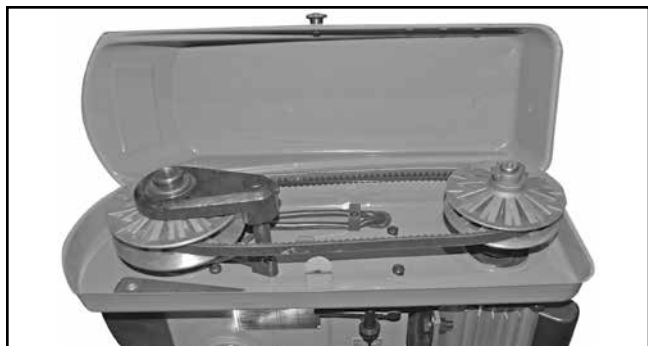


6. Use the downfeed handles to lower the bit into the workpiece.

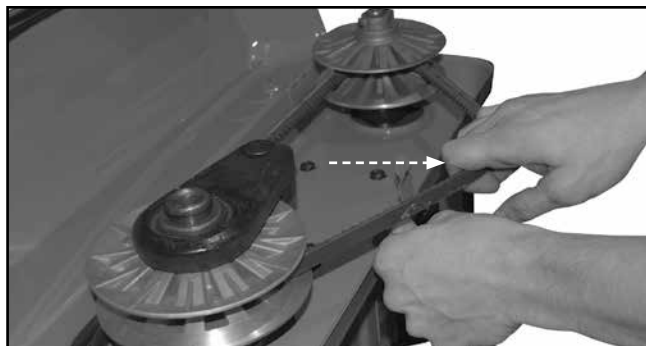
MAINTENANCE

BELT REPLACEMENT

Inspect the belts after every 100 hours of use. Belts that show visible signs of wear such as cracks or fraying at the edges should be replaced immediately.



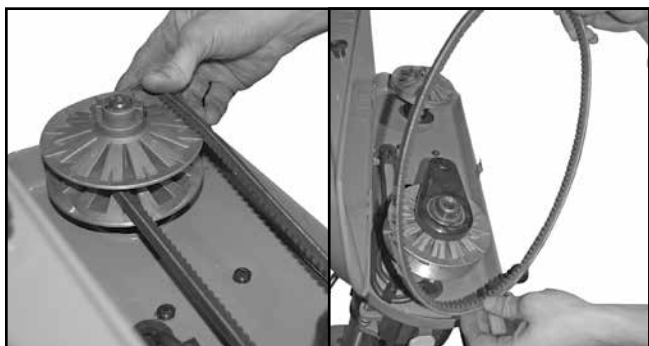
1. Unplug the machine, and open the pulley cover as shown.



2. Pull on the belt as shown to spread the spring-mounted pulley flanges.

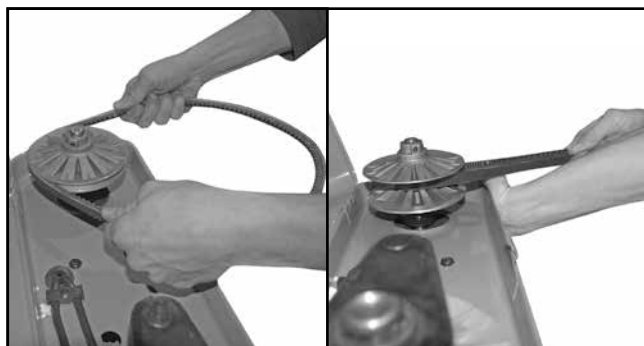


MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.



- 3.** Slip a portion of the belt off and turn the pulley by hand until the belt comes off the pulley completely.

Note: *Be careful to avoid pinching your fingers between the belt and pulley.*

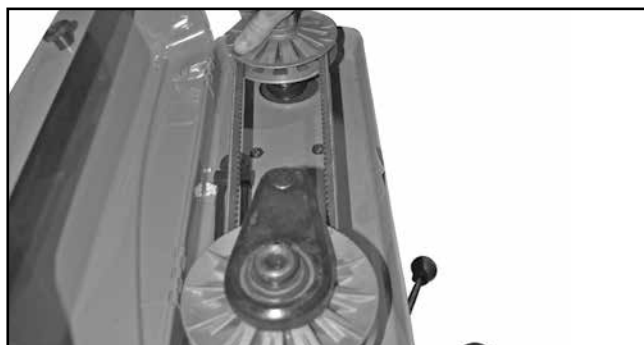


- 4.** To install a new belt, put it between the flanges of the drive pulley. Pull back on the belt to make sure it is seated properly on the pulley.



- 5.** Hold the tension on the belt and slide the opposite end onto the other pulley.

Note: *Be careful to avoid pinching your fingers between the belt and pulley.*

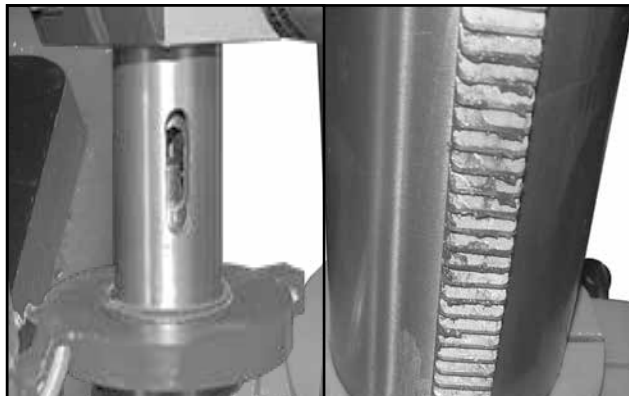


- 6.** Turn the pulley by hand until the belt tensions and snaps into place.

LUBRICATION

Periodically lubricate all sliding or moving parts including the column, rack and the quill shown (use any all purpose grease, available at any hardware store).

Note: *Bearings in the quill and the V-belt pulleys are sealed, permanently lubricated and should require no further maintenance.*



RECOMMENDED OPTIONAL ACCESSORIES



item #70-025

25 PIECE DRUM SANDING KIT

Turn your drill press into a mini drum sander. 5 different sized drums: 1/2", 3/4", 1", 1-1/2" & 2" plus 2 sets of 80 grit and 2 sets of 120 grit, sanding sleeves for each.



item #70-030

ABRASIVE SLEEVES

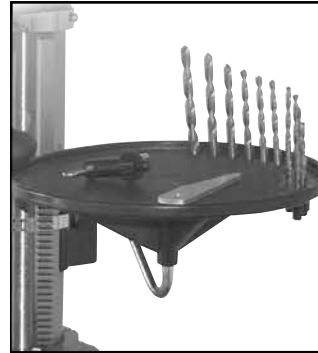
10 piece replacement abrasive sleeve set for 70-025. Includes 5 (one of each size) 80 & 120 grit sanding sleeves.



Item #70-105

9" AUGER DRILL BIT SET

Heavy duty carbon steel. Heat-treated and precision sharpened for quick, accurate and effortless cuts. Includes 6 bits - sizes: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4" with 3/8" shank, in a convenient carrying case.



Item #70-125

DRILL PRESS TOOL TRAY

Can be installed on most drill press columns. Made with a metal swivel rod.



Item #70-130

9" VISE-CLAMP

Adjustable lock-in clamping pressure and 360 degree rotation; a must for all safety conscious woodworkers. Includes two 1/2" t-bolts to mount to any drill table with 9/16" (or wider) mounting holes.



**95-140 (4'') / 95-150
(5'') / 95-160 (6'')**

item #95-140 / 95-150 / 95160

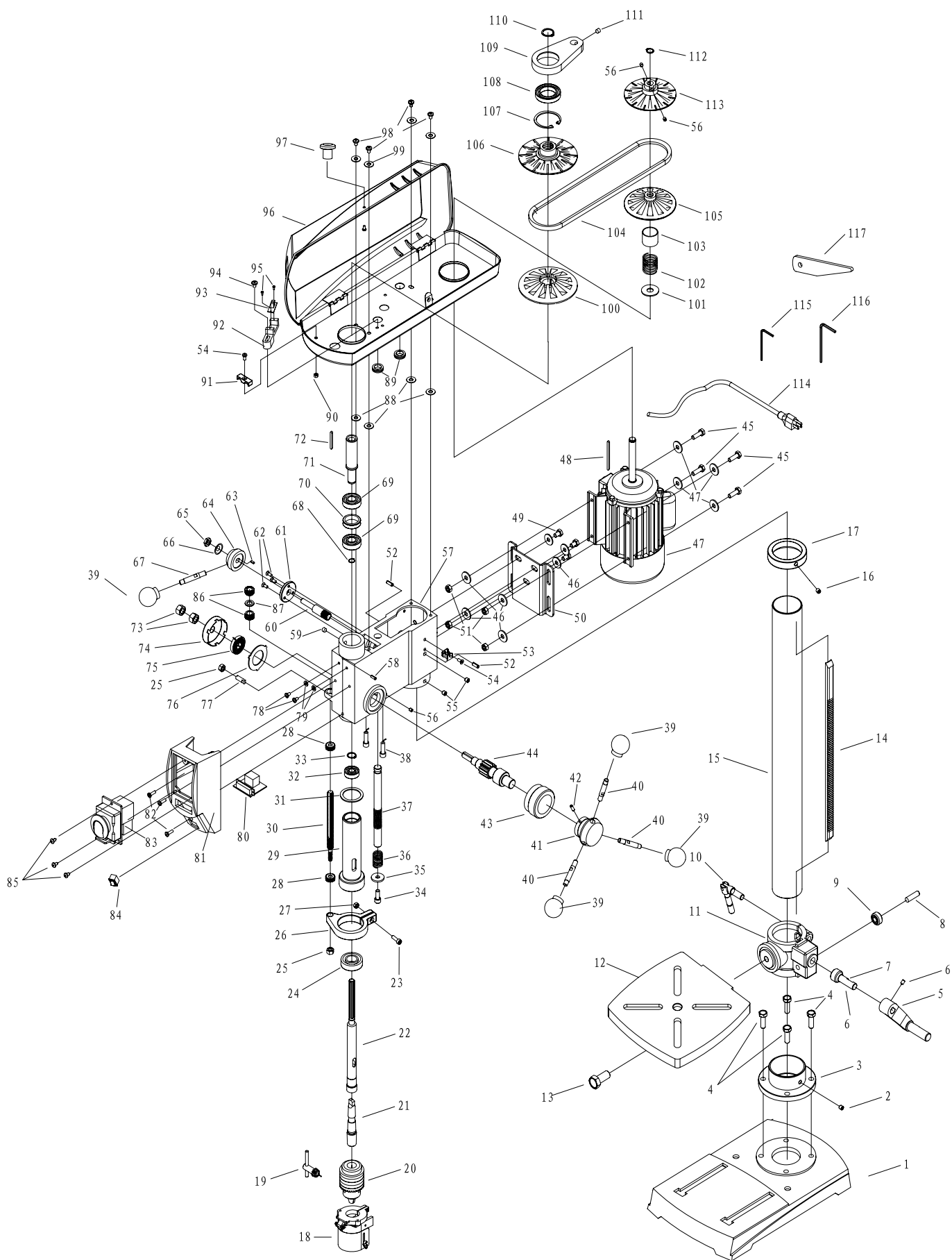
DRILL PRESS VISES

Hold down slots along both sides. High tensile iron casting construction for maximum durability. One-piece cast-iron axial sleeve and movable jaws. Fast action, "Acme" type screw threads.

NOTES

[illegible]

DIAGRAM 75-010



PARTS LIST

75-010

IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.

PART*	REFERENCE*	DESCRIPTION	QTY	PART*	REFERENCE*	DESCRIPTION	QTY
75010-01	13401001	BASE	1	75010-60	W13202027A	GEAR SHAFT	1
75010-02	GB/T78	HEX BOLT M8X8	1	75010-61	W13202028B	SHAFT PLATE	1
75010-03	13401002A	SUPPORT COLUMN	1	75010-62	GB/T819	SCREW M5X12	3
75010-04	GB/T5783	HEX BOLT M10X30	4	75010-63	GB/T1564	KEY 3X6	1
75010-05	13401009	LEVER	1	75010-64	W13202032	HANDLE SEAT	1
75010-06	GB/T80	HEX BOLT M6X10	1	75010-65	GB/T889.1	NYLOCK NUT	1
75010-07	13401008	WORM GEAR	1	75010-66	GB/T1972	LOCK WASHER	1
75010-08	13201007	PIN	1	75010-67	C13104005	ROD	1
75010-09	13201006	HELICAL GEAR	1	75010-68	GB/T894.1	RETAINING RING	1
75010-10	16101013	LOCK HANDLE	1	75010-69	GB/T276	BEARING	2
75010-11	13401004B	TABLE BRACKET	1	75010-70	13302023A	SPACER	1
75010-12	13401014	TABLE	1	75010-71	W13302022	PULLEY SHAFT	1
75010-13	GB/T5783	HEX BOLT M16X35	1	75010-72	GB/T1564	KEY	1
75010-14	13201010A	RACK	1	75010-73	GB/T6172	HEX NUT M12	2
75010-15	13401003A	COLUMN	1	75010-74	16104008	CAP SPRING	1
75010-16	GB/T80	HEX BOLT M6X10	1	75010-75	16104009	SPRING	1
75010-17	13401011F	RACK RETENTION RING	1	75010-76	16104007A	RETAINING SPRING	1
75010-18	16208002	CHUCK GUARD	1	75010-77	13302021	SET SCREW	1
75010-19	16103009G-1	CHUCK KEY	1	75010-78	GB/T818	PAN HEAD SCREW M5X6	2
75010-20	16103009G	CHUCK	1	75010-79	GB/T862.1	SPROC. WASHER	2
75010-21	16103007	ARBOR	1	75010-80	DQ010002200	DIGITAL SPEED DISPLAY	1
75010-22	13303001	SPINDLE	1	75010-81	W13302008C	SWITCH BOX	1
75010-23	GB/T79	SCREW M6X16	1	75010-82	GB/T818	PAN HEAD SCREW M5X14	3
75010-24	GB/T276	BEARING	1	75010-83	KJD12	SWITCH	1
75010-25	GB/T6172.1	HEX NUT M8	2	75010-84	KCD1-B3B	LASER SWITCH	1
75010-26	W134B08005-1A	LOCK COLLAR	1	75010-85	ST4.2X9.5	PAN HEAD SCREW GB/T8483	1
75010-27	GB/T6170	NUT M6	1	75010-86	W134B08005-6	ADJUSTMENT NUT	2
75010-28	W13408005-2	NYLOCK NUT	2	75010-87	W134B08005-4	WASHER	1
75010-29	13303002	QUILL ASSEMBLY	1	75010-88	13105009	FOAM WASHER	4
75010-30	W13408005-5	DEPTH STOP BOLT	1	75010-89	20105012	RUBBER BUSHING	3
75010-31	13303006	QUILL GASKET	1	75010-90	GB/T6170	NUT M5	3
75010-32	GB/T276	BEARING	1	75010-91	16102014A	CORD CLAMP	3
75010-33	GB/T894.1	RETAINING RING	1	75010-92	W134A05009	SENSOR BRACKET	1
75010-34	GB/T79	SCREW M8X20	1	75010-93	DQ014001100	SPEED SENSOR	1
75010-35	GB/T96.2	WASHER	1	75010-94	GB/T818	PAN HEAD SCREW M4X8	2
75010-36	W13402033	SPRING	1	75010-95	ST2.2X6.5-F	SELF-TAPPING SCREW	4
75010-37	W16302029	SHAFT	1	75010-96	W134B05000	PULLEY COVER	1
75010-38	13302026	LASER POINTER	2	75010-97	13205010	KNOB	1
75010-39	13204011	KNOB	4	75010-98	GB/T818	PAN HEAD SCREW M6X8	4
75010-40	13204005A	ROD	3	75010-99	GB/T97.2 6	WASHER	4
75010-41	13304001	HANDLE BRACKET	1	75010-100	W13305009-2	SPINDLE PULLEY	1
75010-42	GB/T879	PIN Ø5X16	1	75010-101	W16205005-4	SPRING SEAT	1
75010-43	13304003E	SCALE	1	75010-102	W16205005-3	MOTOR PULLEY SPRING	1
75010-44	13304002	PINION	1	75010-103	W16205005-5	SPRING COVER	1
75010-45	GB/T5783	HEX BOLT M8X25	4	75010-104	W13405007	V-BELT	1
75010-46	GB/T97.2	WASHER	11	75010-105	W13305005-1	MOTOR PULLEY	1
75010-47	YLL7114-W02	MOTOR	1	75010-106	W13305009-1	SPINDLE PULLEY	1
75010-48	C13106013	KEY	1	75010-107	GB/T894.1	RETAINING RING	1
75010-49	GB/T5783	HEX BOLT M8X12	3	75010-108	GB/T276	BEARING	1
75010-50	W13202007B	MOTOR PLATE	1	75010-109	W13202031	CAM	1
75010-51	GB/T6170	NUT M8	4	75010-110	GB/T894.1	RETAINING RING	1
75010-52	GB/T879	PIN Ø 6X16	2	75010-111	GB/T80	HEX BOLT M8X16	1
75010-53	16103011B	CHUCK KEY HOLDER	1	75010-112	GB/T894.1	RETAINING RING	1
75010-54	GB/T818	SCREW M5X10	4	75010-113	W13305005-2	MOTOR PULLEY	1
75010-55	GB/T80	HEX BOLT M8X8	2	75010-114	DLCKEE2S08	POWER CORD W/PLUG	1
75010-56	GB/T80	HEX BOLT M6X8	4	75010-115	GB5356-86 S3	ALLEN KEY 3MM	1
75010-57	W134B02001	HEAD	1	75010-116	GB5356-86 S4	ALLEN KEY 4MM	1
75010-58	GB/T879	PIN Ø2.5X12	1	75010-117	16103008	DRIFT KEY	1
75010-59	GB/T78	HEX BOLT M8X8	1				



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