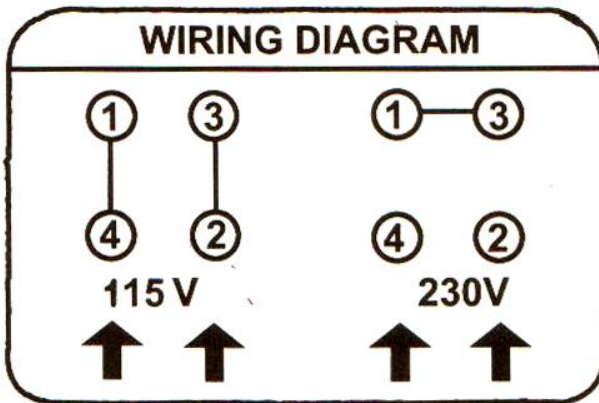


DRILL PRESS

INSTRUCTIONS

MANUAL



The initial voltage of the machine is 230V

MADE IN CHINA

SAFETY PRECAUTIONS FOR DRILL PRESS

Environment:

- a. Keep work area uncluttered and well- lit, all visitors(children especially) should be kept out of the area.
- b. Power tools should be used in dry area only. When using tools outdoors, please use proper extension cord.

Attention:

- a. Do not wear loose clothing or jewelry, they can get caught in moving parts.
- b. Safely glasses should be worn when operating power tools
- c. If cutting operation is dusty, mask should be worn.
- d. In changing the speed you have to turn off the switch and wait until the machine stop completely.
- e. Take off the chuck key before starting the motor. Never use your hand to hold on the object while drilling.
- f. Always screw the object tightly on the working table or use the drill press vise to prevent accident injury.
- g. Keep off your hand from the drill bit while drilling.
- h. Wear protect eye goggles when operating.

Operation of tools:

- a. Be sure the switch is off when plug in.
- b. Use the right tool for the job, don't force the tool. It will harm the machine or hurt you.
- c. Keep proper feeding and balance at all times.
- d. Keep hands away from cutting area.
- e. Guards should be in place and in working order. Remove adjusting keys, wrenches before turning on.

General Guidelines:

- a. Disconnect the tools when not in use. Take care of the power tools and be sure in safe performance.
- b. Do not carry tools by card or pull cord to disconnect the power.
- c. Use clamp or vise to hold work - it keeps both of your hands free.
- d. Store the tools in a dry place - well out of the reach of children.

Voltage Warning:

- a. Before connecting the tool to a power source, please be sure the supplied voltage is same as the rated voltage on the tools
- b. A power source with voltage greater than that specified for the tool can result in injury to the user and the machine.
- c. If you are not sure of the voltage rating, please don't use it. a lower voltage less than rated voltage will harm the motor also.

Grounding Instructions:

- a. Tools should be grounded to protect user from electric shock.
- b. If the tools equipped with approved three - conductor cord and three - prong grounding plug, it fits a grounding receptacle when using an adapter to connect a three - prong plug to two prong receptacle. The adapter plug must be attached to a permanent ground.

Additional Safety Rules For Drill Presses:

- a. Be sure drill bit or cutting tool is securely locked in the chuck.
- b. Be sure chuck key is removed from the chuck before turning on power.
- c. Adjust the table or depth stop to avoid drilling into the table.

d. Shut off the power, remove the drill bit and clean the table before leaving the machine.

Caution when practical. Use clamps or a vise to secure work piece to keep the work piece from rotating with the drill bit or culling tool.

Warning: Do not Wear Gloves While Operating Drill Presses:

General Assembly Instructions

Screw column to base, assemble the press head to column and tighten set screw with hex key, assembly the handleless chuck etc. upon the completion of assembly. Drill press can be washed with kerosene to remove the anti - rust oil applied at factory, then lubricating oil can be applied.

Round - out Tolerance

For drilling operations require close tolerances. Place drill blank or standard bar in the chuck and check the round out with a dial indicator. If the round - out is not within desired tolerance, tap the chuck bottom with a rubber or leather mallet until you got the desired tolerance.

Operation Directions

The following directions will give the operator who is not familiar with the drill press operation a start. Use scrap material for practice to get the feel of the machine before attempting the regular work.

A Correct Drilling Speeds:

Parameters which determine the best speed to use in any drill press operation are based on the material being worked, size of hole, type of drill or any others cutter and the quality of the hole desired. The smaller the drill the greater the required RPM. In soft material, the speed should be higher than in hard metals.

B Drilling in Metal:

Use clamps to hold the work when drilling in metal. The work should never be held by the bare hand. The lips of the drill may seize the work at any time, especially when breaking through the stock. If the piece is whirled out of the operator's hand, he may be injured in any case. The drill will be broken when the work strikes the column.

The work piece must be clamped firmly while drilling any tilting, twisting or shifting results not only in a rough hole, but also increase the drill breakage. For flat work, lay the piece on a wooden base and clamp it firmly down against the table to prevent it from turning. If the work piece is of irregular shape and can't be laid flat on the table, it should be securely blocked and clamped.

C Boring in Wood Twist Drills:

Although intending for metal drilling, the machine may also be used for drilling **holes in wood, machine star bits are generally preferred for working in wood They cut a square bottom hole** and are designed for removal of wood chips. Do not use hand bits, which have a screw lip, At drill press speeds they turn into the wood so rapidly as to lift the work piece off the table and whirl it.

ASSEMBLY

Bench Drill Press

a. Open the box and take out the base (No. 1), working table (No. 2) and column (No. 4) place them on a flat surface, screw the column extension or the column to the base.

b. Take out the head frame (No. 25) and assemble to the column (No. 4)

c. Then use the key for tightening the set screw (No. 3)

d. Assemble the handle (No. 43) and handle knob (No. 44) then screw it in the round head (No. 37) (Please see diagram)

Floor Type Drill Press

a. Open the box and take out the base (No. 1) and place it on a flat floor

- b. Take out the column (No. 4) with table bracket (No. 6) and screw it on the base (No. 1)
- c. Take out the head frame (No. 25) and assemble to the column (No. 4)
- d. Then use the key for tightening the set screw (No. 3)
- e. Bring out the handle (No. 43) and handle head (No. 44) then screw it in the round head (No. 37)
(Please see diagram)

INSTALLATION

- a. After installing the drill press, use the kerosene to wash out the antirust oil then wipe it with lubricant oil.
- b. Install your drill press in flat, sturdy floor or surface.
- c. Check if the drill press is shaking when the motor is switch "ON".
- d. Check the table bracket if it is moving smoothly up and down.
- e. Check if the spindle shaft moves smoothly.

LUBRICATION

- a. The ball bearing in the quill and the V - belt pulley are grease - sealed for life • Pull quill down to maximum depth and oil moderately once every 3 months.
- b. Slide bars, Remove motor belt and push cam handle towards the motor. Oil right and left slide bars lightly every 2 months.
- c. Grease the table bracket if cranking becomes difficult.

OPERATING TEST

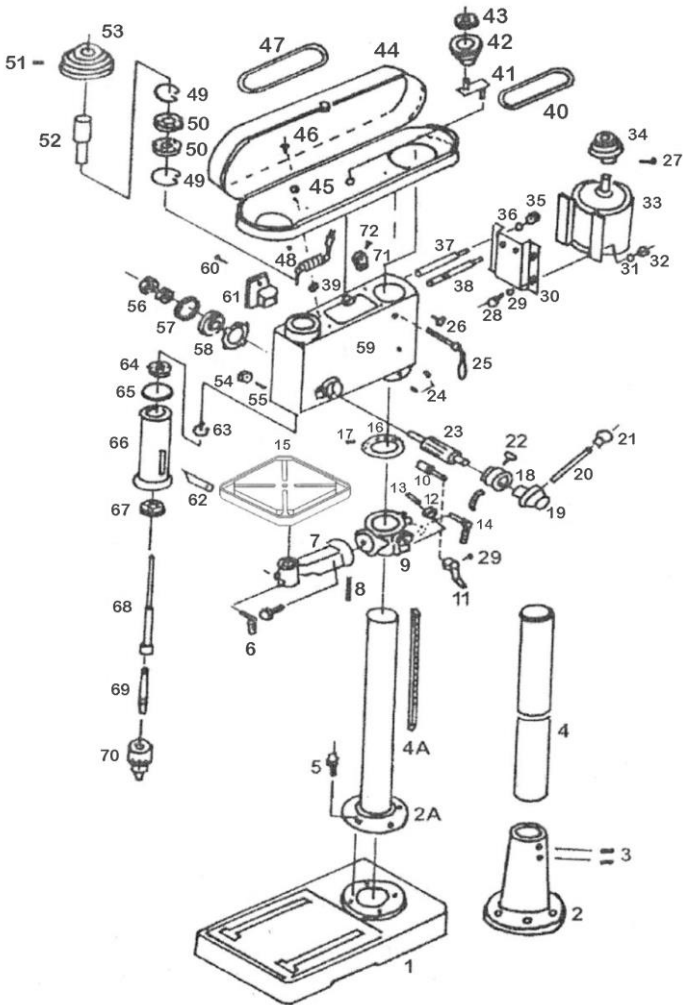
- a. Open the belt cover and release the left & right side cam shaft set handle then move the belt handle backward until the belt has its right tension.
- b. The rotation speed of spindle shaft can be changed by refer to the chart list which is attached inside the belt cover, then you can push the belt handle to adjust the V - belt to its right tension and set back the two side cam shaft set handle.
- c. Plug the electric socket to the outlet and press "ON" the switch then the spindle shaft will rotate clockwise.
- d. If the spindle shaft rotate counter - clockwise, it means the wiring connection are wrong, so turn off the switch and change the connection.
- e. Screw tight the object on the working table while drilling, so as to prevent injuries and to have a precision workmanship.
- f. Please use the right size of drill bit in the chuck which is in below the spindle shaft.
- g. Connect to the rated voltage and press "ON" the switch, the spindle shaft will rotate freely.
- h. When drilling, please hold on the handle at the right side of the head frame and press downward.

MAINTENANCE

After using the machine you have to clean it completely and lubricate all sliding and moving parts.

ASSEMBLY DIAGRAM

ZJ4120 & ZJ5120
414-2137 & 414-2134



ZJ4120 Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
412001	1	Base		1	412037	37	Shaft		1
412002	2	flange plate		1	412038	38	Adjusting shaft		1
412003	3	Hex.Soc.set screw	M8*10	2	412039	39	Rubber ring		4
412004	4	Column		1	412040	40	V-Belt	640	1
412005	5	Hex.screw	M10*30	1	412041	41	pulley spindle		1
412006	6	Locking handle		1	412042	42	centre belt pulley		1
412007	7	Table bracket		1	412043	43	Bearing	6202	2
412008	8	Angle scale		1	412044	44	Pulley cover		1
412009	9	working table holder		1	412045	45	Flat washer		4
412010	10	Worm		1	412046	46	Bolt	M6*10	4
412011	11	Handle		1	412047	47	V-Belt	640	1
412012	12	Helical gear		1	412048	48	Electric plug		1
412013	13	Pin		1	412049	49	C-spring		2
412014	14	Locking handle	M12*45	1	412050	50	Bearing	6105	2
412015	15	working table		1	412051	51	Nut	M8*10	1
412016	16	fixing ring		1	412052	52	Splined sleeve		1
412017	17	Hex.Soc.set screw	M8*10	1	412053	53	Spindle pulley		1
412018	18	Depth indicator		1	412054	54	Nut	M8	1
412019	19	Handle seat		1	412055	55	Fixing screw	M8*20	1
412020	20	Handle bar		3	412056	56	Nut	M12	2
412021	21	Handle knob		3	412057	57	Spring cover		1
412022	22	Fixing screw	M8*16	1	412058	58	Spring		1
412023	23	feeding shaft		1	412059	59	Cast iron box		1
412024	24	Hex.Soc.set screw	M8*10	2	412060	60	Fixing screw		2
412025	25	Adjusting handle		1	412061	61	Switch		1
412026	26	Fixing bolt	M8*30	2	412062	62	Wedge		1
412027	27	Hex.Soc.screw	M8*10	1	412063	63	C-spring		1
412028	28	Hex screw	M8*25	4	412064	64	Bearing	6205	1

412029	29	Flat washer		4	412065	65	Rubber ring		1
412030	30	Motor fixing plate		1	412066	66	Spindle holder		1
412031	31	flat washer		4	412067	67	Bearing	6205	3
412032	32	Nut	M8	4	412068	68	Spindle		1
412033	33	Motor	3/4HP	1	412069	69	Joint lever		1
412034	34	Motor pulley		1	412070	70	Chuck		1
412035	35	Nut	M12	2	412071	71	Adjusting fork		1
412036	36	Flat washer		2	412072	72	Hex.Soc.screw	M8*10	1

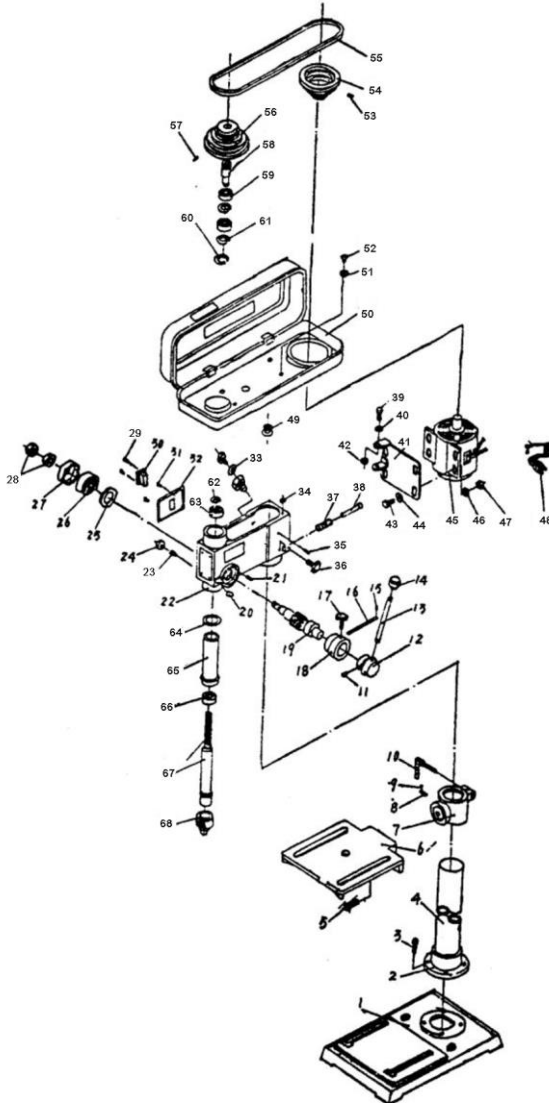
ZJ5120 Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
512001	1	Base		1	512037	37	Shaft		1
512002	2	flange plate		1	512038	38	Adjusting shaft		1
512003	3	Hex.Soc.set screw	M8*10	2	512039	39	Rubber ring		4
512004	4	Column		1	512040	40	V-Belt	640	1
512005	5	Hex.screw	M10*30	1	512041	41	pulley spindle		1
512006	6	Locking handle		1	512042	42	centre belt pulley		1
512007	7	Table bracket		1	512043	43	Bearing	6202	2
512008	8	Angle scale		1	512044	44	Pulley cover		1
512009	9	working table holder		1	512045	45	Flat washer		4
512010	10	Worm		1	512046	46	Bolt	M6*10	4
512011	11	Handle		1	512047	47	V-Belt	640	1
512012	12	Helical gear		1	512048	48	Electric plug		1
512013	13	Pin		1	512049	49	C-spring		2
512014	14	Locking handle	M12*45	1	512050	50	Bearing	6105	2
512015	15	working table		1	512051	51	Nut	M8*10	1
512016	16	fixing ring		1	512052	52	Splined sleeve		1
512017	17	Hex.Soc.set screw	M8*10	1	512053	53	Spindle pulley		1
512018	18	Depth indicator		1	512054	54	Nut	M8	1
512019	19	Handle seat		1	512055	55	Fixing screw	M8*20	1
512020	20	Handle bar		3	512056	56	Nut	M12	2
512021	21	Handle knob		3	512057	57	Spring cover		1
512022	22	Fixing screw	M8*16	1	512058	58	Spring		1
512023	23	feeding shaft		1	512059	59	Cast iron box		1
512024	24	Hex.Soc.set screw	M8*10	2	512060	60	Fixing screw		2
512025	25	Adjusting handle		1	512061	61	Switch		1
512026	26	Fixing bolt	M8*30	2	512062	62	Wedge		1
512027	27	Hex.Soc.screw	M8*10	1	512063	63	C-spring		1
512028	28	Hex screw	M8*25	4	512064	64	Bearing	6205	1

512029	29	Flat washer		4	512065	65	Rubber ring		1
512030	30	Motor fixing plate		1	512066	66	Spindle holder		1
512031	31	flat washer		4	512067	67	Bearing	6205	3
512032	32	Nut	M8	4	512068	68	Spindle		1
512033	33	Motor	3/4HP	1	512069	69	Joint lever		1
512034	34	Motor pulley		1	512070	70	Chuck		1
512035	35	Nut	M12	2	512071	71	Adjusting fork		1
512036	36	Flat washer		2	512072	72	Hex.Soc.screw	M8*10	1

ASSEMBLY DIAGRAM

ZJ4113H
414-2136



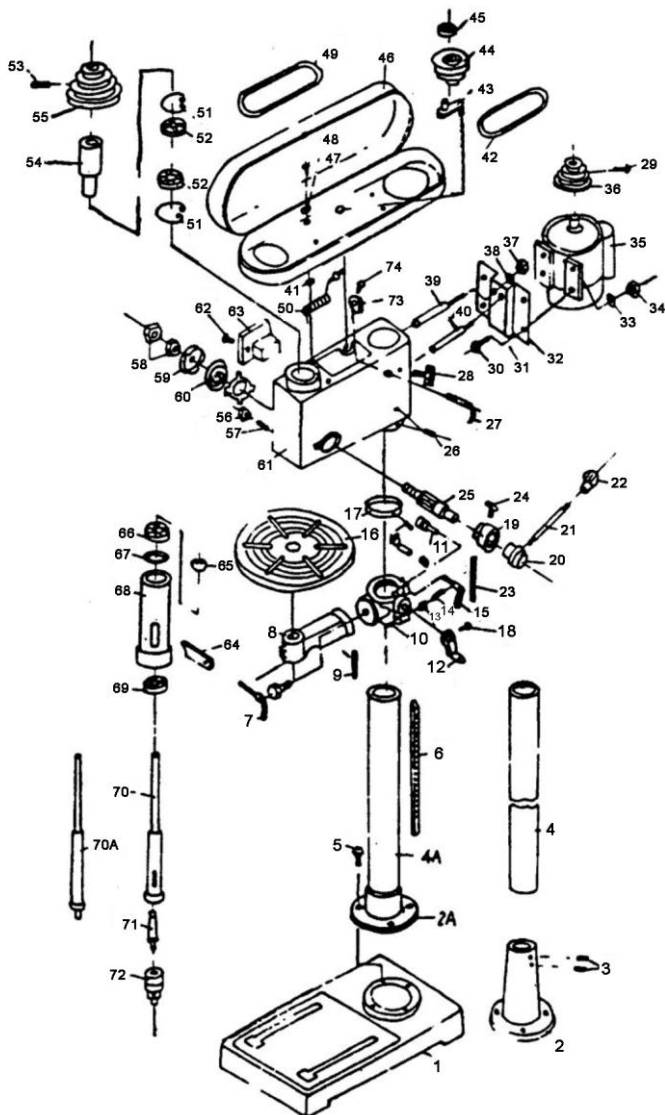
ZJ4113H Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
4113H01	1	Base		1	4113H35	35	Roll pin	φ6*24	2
4113H02	2	Columu holder		1	4113H36	36	Lock screw		1
4113H03	3	Hex Hd.Bolt	H8*25	4	4113H37	37	Spring		1
4113H04	4	Columu		1	4113H38	38	Slide kod		1
4113H05	5	Hex Hd.Bolt	H8*25	1	4113H39	39	Hex hd.screw	H8*30	2
4113H06	6	Table		1	4113H40	40	Flat washer		2
4113H07	7	Table bracket		1	4113H41	41	Motor plate		1
4113H08	8	Scale		1	4113H42	42	Hex nut	H8	2
4113H09	9	Rivet		1	4113H43	43	Hex hd.screw	H8*25	4
4113H10	10	Columu lock handle		1	4113H44	44	Flat washer		4
4113H11	11	Pin		1	4113H45	45	Motor	1/2HP	1
4113H12	12	Pinien assembly		1	4113H46	46	Flat washer		4
4113H13	13	Handle		3	4113H47	47	Hex nut	H12	4
4113H14	14	Ball		3	4113H48	48	Power cord		1
4113H15	15	Rivet		1	4113H49	49	Cord insulater	H22	1
4113H16	16	Scale		1	4113H50	50	Pully cover		1
4113H17	17	Lock screw		1	4113H51	51	Flat washer	φ6	4
4113H18	18	Depth stop play		1	4113H52	52	Cheese hd.screw	H6*12	4
4113H19	19	Feed shaft		1	4113H53	53	Hex soc.set.screw	H6*10	1
4113H20	20	Pointer		1	4113H54	54	Moter pulley		1
4113H21	21	Stop pin		1	4113H55	55	V-Belt		1
4113H22	22	Head		1	4113H56	56	Spindle Pulley		1
4113H23	23	Hex soc set screw	H8*25	1	4113H57	57	Hex soc.set.screw	H6*10	1

4113H24	24	Hex nut	H8	1	4113H58	58	Spindle sleeue		1
4113H25	25	Spring rotainor		0	4113H59	59	Bearing	6203	2
4113H26	26	Coll spring		1	4113H60	60	Retaining ring		2
4113H27	27	Spring cover		1	4113H61	61	Retaining ring		1
4113H28	28	Hex jas nut		2	4113H62	62	Retaining ring		1
4113H29	29	Cheese hd screw		2	4113H63	63	Bearing		1
4113H30	30	Switch		1	4113H64	64	Rubber washer		1
4113H31	31	Cheese hd screw		2	4113H65	65	Quill		1
4113H32	32	Switch cover		1	4113H66	66	Bearing	6201	1
4113H33	33	Wire insulater		2	4113H67	67	Spindle		1
4113H34	34	Rubber washer		4	4113H68	68	13MM chuck		1

ASSEMBLY DIAGRAM

ZJ4116
414-2135



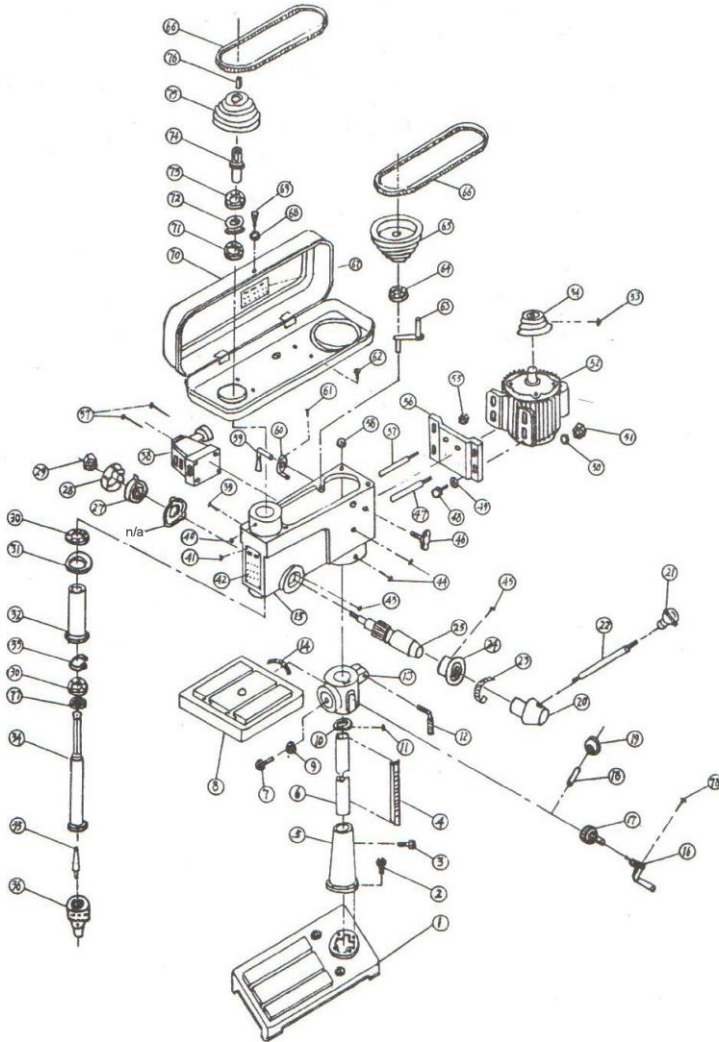
ZJ4116 Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
411601	1	Base		1	411638	38	Flat washer		2
411602	2	fianged column base		1	411639	39	Shaft		1
411603	3	Hex.Soc.set screw	M8*10	3	411640	40	Adjusting shaft		1
411604	4	Column		1	411641	41	Rubber ring		4
411605	5	Hex.screw	M10*30	4	411642	42	V-Belt	550	1
411606	6	teeth		1	411643	43	pulley spindle		1
411607	7	Table Locking handle		1	411644	44	pulley		1
411608	8	Table bracket		1	411645	45	Bearing	6201	2
411609	9	Angle scale		1	411646	46	Pulley cover		1
411610	10	working table holder		1	411647	47	Flat washer		4
411611	11	Worm		1	411648	48	Bolt	M6*10	4
411612	12	Handle		1	411649	49	V-Belt	550	1
411613	13	gear		1	411650	50	Electric plug		1
411614	14	Pin		1	411651	51	C-spring		2
411615	15	Locking handle	M12*45	1	411652	52	Bearing	6203	2
411616	16	working table		1	411653	53	Nut	M8*10	1
411617	17	fixing ring		1	411654	54	Splined sleeve		1
411618	18	Hex.Soc.set screw	M8*10	1	411655	55	Spindle pulley		1
411619	19	Depth indicator		1	411656	56	Nut	M8	1
411620	20	Handle seat		1	411657	57	Fixing screw	M8*16	1
411621	21	Handle bar		3	411658	58	Nut	M12	2
411622	22	Handle knob		3	411659	59	Spring cover		1
411623	23	Depth scale		1	411660	60	Spring		1
411624	24	Fixing screw	M8*16	1	411661	61	Cast iron box		1
411625	25	feeding shaft		1	411662	62	Fixing screw		2
411626	26	Fixing screw	M8*10	2	411663	63	Switch		1
411627	27	Adjusting handle		1	411664	64	Wedge		1
411628	28	Fixing bolt	M8*30	2	411665	65	C-spring		1

411629	29	Fixing screw	M8*10	1	411666	66	Bearing	6203	1
411630	30	Bolt	M8*25	4	411667	67	Rubber ring		1
411631	31	Flat washer		4	411668	68	Spindle holder		1
411632	32	Motor fixing plate		1	411669	69	Bearing	6203	3
411633	33	flat washer		4	411670	70	Spindle		1
411634	34	Nut	M8	4	411671	71	Joint lever		1
411635	35	Motor	3/4HP	1	411672	72	Chuck		1
411636	36	Motor pulley		1	411673	73	Adjusting fork		1
411637	37	Nut	M12	2	411674	74	Hex.Soc.screw	M8*10	1

ASSEMBLY DIAGRAM

ZJ5125A&ZJ5132A
414-2133 & 414-2138



ZJ5125A Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
5125A01	1	Base		1	5125A40	40	Soc. Hex. Screw	M8*16	2
5125A02	2	Hex head bolts	M10*35	4	5125A41	41	Fixing Rivet		4
5125A03	3	Soc. Hex. Screw	M10*10	2	5125A42	42	Name Plate		1
5125A04	4	Teeth		1	5125A43	43	Bolt	5*20	1
5125A05	5	Column Base		1	5125A44	44	Soc. Hex. Screw	M8*10	2
5125A06	6	Coloumn		1	5125A45	45	Screw	M8*10	1
5125A07	7	Hex head bolts	M20*45	1	5125A46	46	Fixing bolt		2
5125A08	8	Working table		1	5125A47	47	Adjusting shaft		1
5125A09	9	Washer	∅ 20	1	5125A48	48	Hex head bolts	M8*25	4
5125A10	10	Retaining Ring		1	5125A49	49	Flat washer	∅ 8	4
5125A11	11	Soc. Hex. Screw	M8*10	1	5125A50	50	elastic washer	∅ 8	4
5125A12	12	Locking Handle	M12*45	1	5125A51	51	nut	M8	4
5125A13	13	Working table holder		1	5125A52	52	motor	1-1/2HP	1
5125A14	14	Angle scale		1	5125A53	53	Soc. Hex. Screw	M8*10	1
5125A15	15	cast iron box		1	5125A54	54	motor pulley		1
5125A16	16	height adjusting handle		1	5125A55	55	nut	M12	2
5125A17	17	Worm		1	5125A56	56	Motor Plate		1
5125A18	18	Core shaft		1	5125A57	57	shaft		1

5125A19	19	Gear		1	5125A58	58	rubber washer		4
5125A20	20	Handle seat		1	5125A59	59	adjusting handle		1
5125A21	21	Handle knob		3	5125A60	60	adjusting pin		1
5125A22	22	Handle bar		3	5125A61	61	Soc. Hex. Screw	M8*10	1
5125A23	23	Depth scale		1	5125A62	62	screw	M8*12	4
5125A24	24	Depth indicator		1	5125A63	63	Crankshaft		1
5125A25	25	Gear Shaft		1	5125A64	64	bearing (6202)		1
5125A26	26	n/a		1	5125A65	65	middle pulley		1
5125A27	27	Spring		1	5125A66	66	V-belt		2
5125A28	28	Spring seat		1	5125A67	67	Speed changing lable		1
5125A29	29	Nut		1	5125A68	68	Flat washer	∅ 6	1
5125A30	30	Bearing (6203)		1	5125A69	69	lifting button		1
5125A31	31	Rubber ring		1	5125A70	70	pulley cover		1
5125A32	32	Spindle quill		1	5125A71	71	bearing (6205)		1
5125A33	33	G-ring	∅ 17	1	5125A72	72	ring		1
5125A34	34	Spindle		1	5125A73	73	bearing (6205)		1
5125A35	35	Tapped spindle tip		1	5125A74	74	Splined sleeve		1
5125A36	36	chuck		1	5125A75	75	spindle pulley		1
5125A37	37	Screw	M5*10	2	5125A76	76	key		1
5125A38	38	switch		1	5125A77	77	Bearing(6205)		1
5125A39	39	Adjusting handle		1	5125A78	78	Soc. Hex. Screw	M8*10	1

ZJ5132A Parts List

Item No	No.	Part Description	Size	qty	Item No	No.	Part Description	Size	qty
5132A01	1	Base		1	5132A40	40	Soc. Hex. Screw	M8*16	2
5132A02	2	Hex head bolts	M10*35	4	5132A41	41	Fixing Rivet		4
5132A03	3	Soc. Hex. Screw	M10*10	2	5132A42	42	Name Plate		1
5132A04	4	Teeth		1	5132A43	43	Bolt	5*20	1
5132A05	5	Coloumn Base		1	5132A44	44	Soc. Hex. Screw	M8*10	2
5132A06	6	Coloumn		1	5132A45	45	Screw	M8*16	1
5132A07	7	Hex head bolts	M20*45	1	5132A46	46	Fixing bolt	M10*32	2
5132A08	8	Working table		1	5132A47	47	Adjusting shaft		1
5132A09	9	Washer	φ 20	1	5132A48	48	Hex head bolts	M8*25	4
5132A10	10	Retaining Ring		1	5132A49	49	Flat washer	φ 8	4
5132A11	11	Soc. Hex. Screw	M8*10	1	5132A50	50	elastic washer	φ 8	4
5132A12	12	Locking Handle		1	5132A51	51	nut	M8	4
5132A13	13	Working table holder		1	5132A52	52	motor	1-1/2HP	1
5132A14	14	Angle scale		1	5132A53	53	Soc. Hex. Screw	M8*10	1
5132A15	15	cast iron box		1	5132A54	54	motor pulley		1
5132A16	16	height adjusting handle		1	5132A55	55	nut	M12	2
5132A17	17	Worm		1	5132A56	56	Motor Plate		1
5132A18	18	Core shaft		1	5132A57	57	shaft		1
5132A19	19	Gear		1	5132A58	58	rubber washer		4
5132A20	20	Handle seat		1	5132A59	59	adjusting handle		1

5132A21	21	Handle knob		3	5132A60	60	adjusting pin		1
5132A22	22	Handle bar		3	5132A61	61	Soc. Hex. Screw	M8*10	1
5132A23	23	Depth scale		1	5132A62	62	screw	M8*12	4
5132A24	24	Depth indicator		1	5132A63	63	Crankshaft		1
5132A25	25	Gear Shaft		1	5132A64	64	bearing (6202)		1
5132A26	26	n/a		1	5132A65	65	middle pulley		1
5132A27	27	Spring		1	5132A66	66	V-belt		2
5132A28	28	Spring seat		1	5132A67	67	Speed changing lable		1
5132A29	29	Nut		1	5132A68	68	Flat washer	∅ 6	1
5132A30	30	Bearing (6205)		1	5132A69	69	lifting button		1
5132A31	31	Rubber ring		1	5132A70	70	pulley cover		1
5132A32	32	Spindle quill		1	5132A71	71	bearing (6107)		1
5132A33	33	G-ring	∅ 25	1	5132A72	72	ring		1
5132A34	34	Spindle		1	5132A73	73	bearing (6107)		1
5132A35	35	Tappered spindle tip		1	5132A74	74	Splined sleeve		1
5132A36	36	chuck		1	5132A75	75	spindle pulley		1
5132A37	37	Screw	M5*10	2	5132A76	76	key		1
5132A38	38	switch		1	5132A77	77	Bearing(6107)		1
5132A39	39	Adjusting handle		1	5132A78	78	Soc. Hex. Screw	M8*10	1

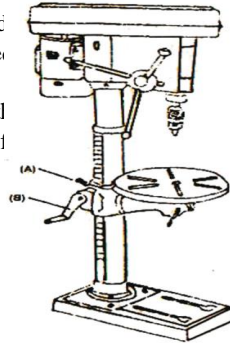
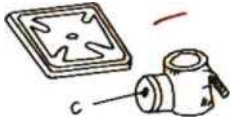
Table Adjustments:

- a. To adjust table up or down, loosen clamp bolt (A), turn crank handle (B) to the desired height then retighten the clamp bolt(A).
- b. To swing table 360° , loosen clamp bolt(A) then swing the table to appropriate position, retighten clamp bolt.
- c. To tilt the table, loosen work table nuts (c), tilt to desired angle and retighten the nuts.



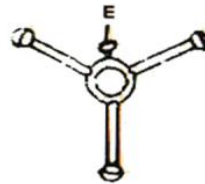
Spindle Adjustments

To stop drill at desired depth, loosen half wing bolt (E) located on feed pinion assembly, rotate fractional increments to desired depth and tighten half wing bolt. To hold a stationary depth, loosen half wing bolt (E) turn feed pinion to the lowest point then rotate fractional increments to desired depth and retighten, half wing bolt. This will hold the spindle assembly stationary at desired depth.



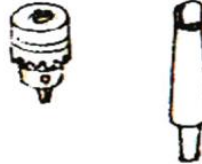
Drill Chuck And Arbor:

Put the small end of arbor into the chuck, place the long end into the spindle hold crank table 5 inches, from tip of spindle open chuck completely pull feed pinion down, pressing the chuck against the table till arbor secure.



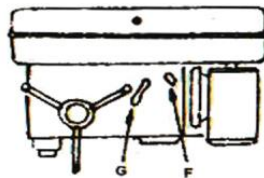
Morse Taper Drill Bits

To use Morse taper bits, remove chuck and taper, adjust stationary depth to 3 inches (see depth instruction) Turn spindle manually lining up spindle and quill key holes. Using key bar tap lightly until taper and chuck fall out. Loosen half wing bolt and allow spindle assembly to return to its original position. Place the taper bit into the spindle hole, twisting and pushing upward until bit is snug. Place a wood block on the table and crank up table until the tapered bit is firmly into the spindle.



Changing Speeds:

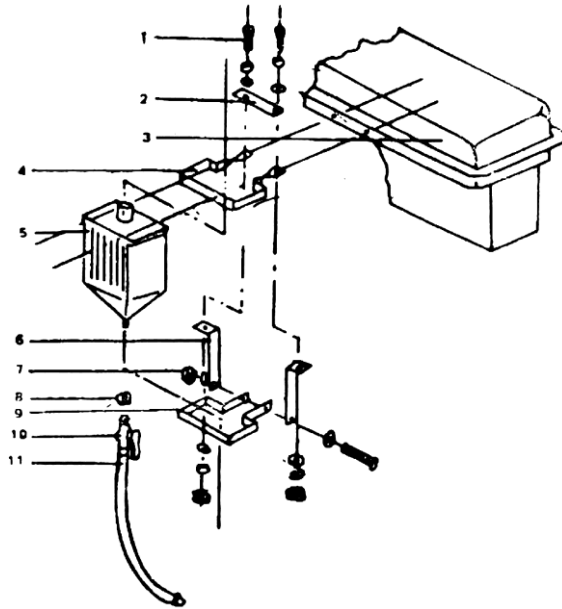
To change speeds, loosen slide bar lock screw (F) and pull cam handle (G) toward the front of the drill press, place pulley belt on appropriate pulley rungs (see chart inside the head cover). Push cam handle toward the motor & tighten slide bar lock screw, check pulley belt for proper tension- and make final adjustments.



Reference list of drill parameters:

Material	Cast iron	Steel	Iron	Aluminum	Gun metal
drill dia.(mm)	rpm	rpm	rpm	rpm	rpm
Φ3	2550	1600	2230	9500	8000
Φ4	1900	1200	1680	7200	6000
Φ5	1530	955	1340	5700	4800
Φ6	1270	800	1100	4800	4000
Φ7	1090	680	960	4100	3400
Φ8	960	600	840	3600	3000
Φ9	850	530	740	3200	2650
Φ10	765	480	670	2860	2400
Φ11	700	435	610	2600	2170
Φ12	640	400	560	2400	2000
Φ13	590	370	515	2200	1840
Φ14	545	340	480	2000	1700
Φ16	480	300	420	1800	1500
Φ18	425	265	370	1600	1300
Φ20	380	240	335	1400	1200
Φ22	350	220	305	1300	1100
Φ25	305	190	270	1150	950

ASSEMBLY MANUAL OF OILER



No.	PARTS NAME
1	Fixed Bolts & Nuts Set
2	Press Plate
3	Belt cover
4	Upper Brace
5	Oiler Tank
6	Connection Plate
7	Braced Bolt & Nut Set
8	Oil Resistant Packing
9	Lower Brace
10	On - Off Valve
11	Flexible Tube & Nozzle
12	Wet Table
13	Adaptor
14	Extension Tube

