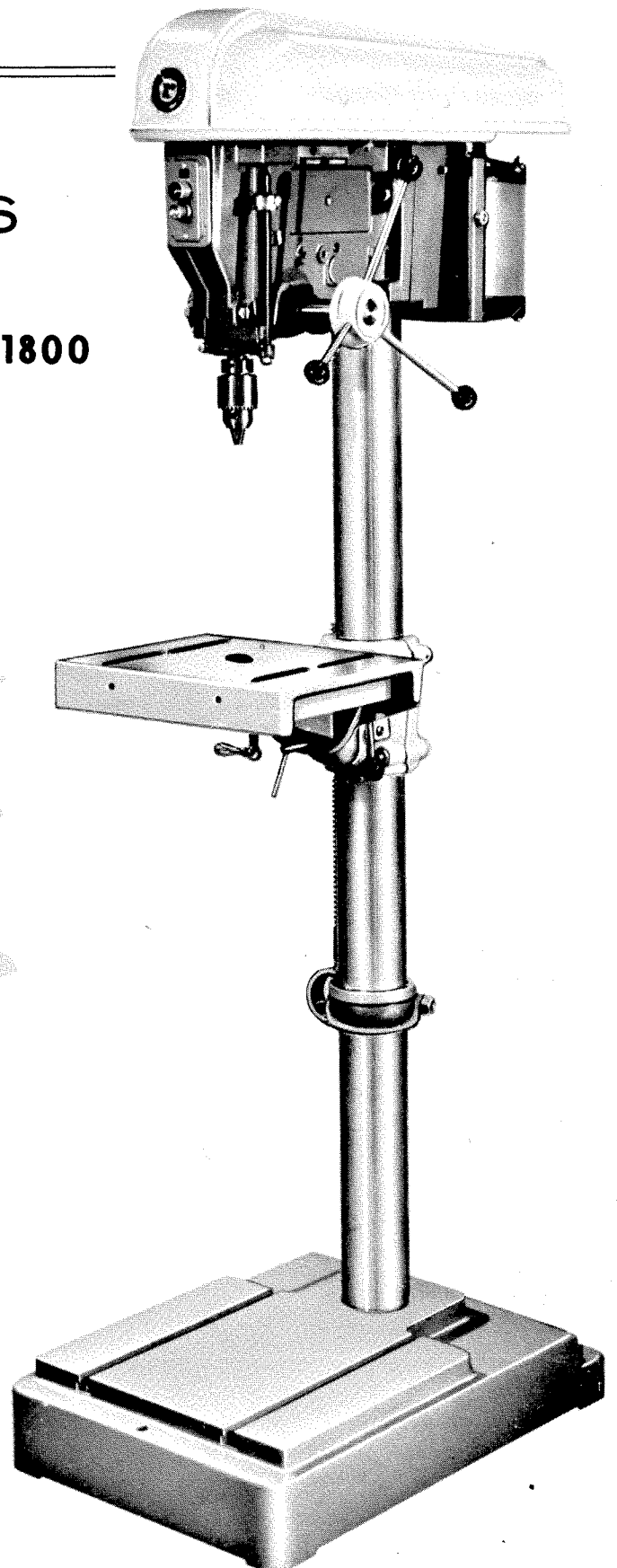


ROCKWELL-DELTA

17" DRILL PRESS

BEGINNING WITH SERIAL No. 141-1800



Rockwell
MANUFACTURING COMPANY

PM - 402-07-651-5010

DATED IM-7-15-67

SETTING UP

Your 17" Drill Press was completely assembled and tested at the factory. The head and table of your drill press have been lowered on the column for convenience in packaging. To raise the head proceed as follows:

1. Place a block of wood, about 7" long, between the drill press head and the table, as close to the column as possible.
2. Make sure the collar at the bottom of the raising mechanism rack is tight on the column and unlock the table clamp. Then loosen the two bolts, located on the right hand side of the head, that lock the head to the column.
3. Turn the raising mechanism hand crank clockwise to raise the table and head simultaneously.
4. When the table approaches the top of the raising mechanism, lock the table and head to the column. Then loosen the raising mechanism collar and turn the raising mechanism hand crank counterclockwise. This will slide the rack of the raising mechanism further up the column.
5. Repeat Steps 2, 3, and 4, until the top of head casting is level with the top of the column.
6. With the head and table still loose, visually line up the spindle with the center of the base and lock the head to the column.
7. Position the table and raising mechanism to the desired position on the column and lock them in place.

The table and all other machined or unpainted surfaces of the drill press are protected with a coating of rust preventive. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasolene or laquer thinner for this purpose.) After cleaning, cover all unpainted surfaces with a light film of good machine oil.

MOTORS AND SPEEDS

Rockwell $\frac{3}{4}$ hp or 1 hp $8\frac{1}{2}$ " frame motors may be used on 17" Drill Presses. However, $\frac{3}{4}$ hp motors should not be used for any power feed machines when they are intended for full capacities.

With a 1725 rpm motor the spindle speeds are:

High Speed Models – 700, 1150, 1750, 2750, and 4250 rpm.

Slo Speed Models – 385, 600, 935, 1450, and 2240 rpm.)

With a 1140 rpm motor the spindle speeds will be two thirds of those with the 1725 rpm motor.

When selecting a motor of any other make, be certain that it has the above specifications and is a NEMA 182 frame motor. Also be sure it is protected against loss of lubricant when operated in a vertical position.

When assembled to the drill press, the motor should turn in a clockwise direction as viewed from the top.

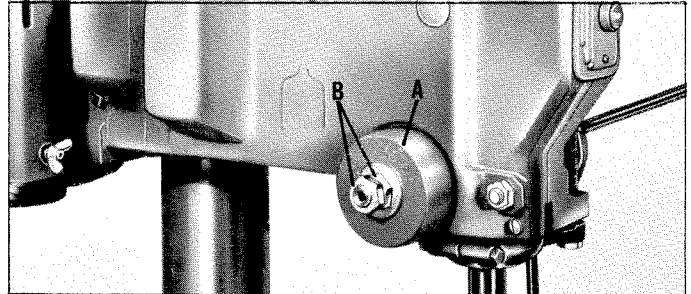


Fig. 1.

ADJUSTING SPINDLE RETURN SPRING

For the purpose of automatically returning the spindle upward after a hole has been drilled, a spring is provided enclosed in the case (A) Fig.1, and is located on the left side of the drill press head. This spring has been properly adjusted at the factory and this adjustment should not be disturbed unless absolutely necessary. If it should become necessary to adjust it, proceed as follows:

1. Back off the two nuts (B) Fig. 1. NOTE: Do not remove the inside nut from the shaft. The nuts(B) should be backed off just far enough so that the spring housing (A) can be disengaged from the roll pin in the head casting.
2. With a firm hold on the spring housing (A) Fig. 1, disengage it from the pin in the drill press head, by pulling the housing straight out, and turn the housing counterclockwise to increase or clockwise to decrease tension. CAUTION: BE CAREFUL NOT TO BOTTOM THE RETURN SPRING WHILE TURNING THE HOUSING COUNTERCLOCKWISE. THERE SHOULD BE ENOUGH SLACK LEFT IN THE SPRING TO PERMIT LOWERING THE SPINDLE THE FULL AMOUNT OF TRAVEL. Be sure the pin in the drill press head is engaged with the spring housing before releasing grip.
3. Retighten the two nuts (B) Fig. 1. NOTE: Do not over-tighten the inside nut against the spring housing (A) as this may cause binding of the pinion shaft.
4. The tension of the spring can be tested by turning pilot wheel counterclockwise. Be sure quill is not locked while testing.

NOTE:

The spindle return spring will lift approximately 40 pounds. When tapping heads, multiple spindles, or other heavy tooling is mounted on the quill or spindle of your machine, the use of our Cat. No. 17-836 Booster Spindle Return Spring Kit, along with the return spring supplied with your drill press, will enable the spindle to lift approximately 80 pounds.

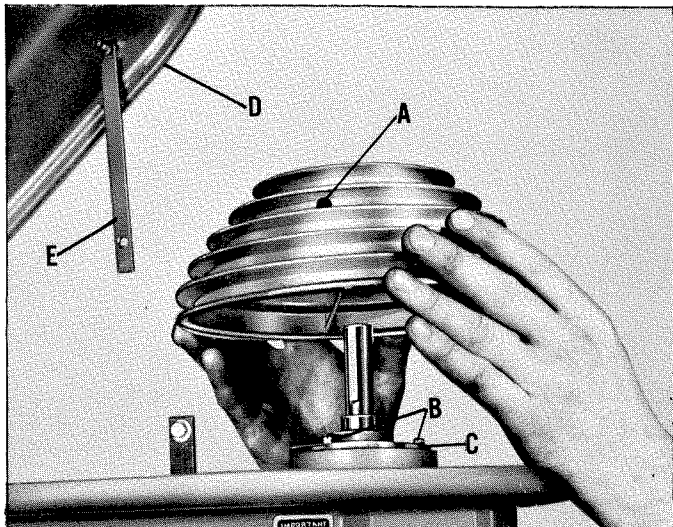


Fig. 2.

REPLACING BELT, SPINDLE PULLEY, AND UPPER SPINDLE ASSEMBLY

1. Raise belt guard, remove nut from bracket (E) and tilt guard back as shown in Fig. 2.

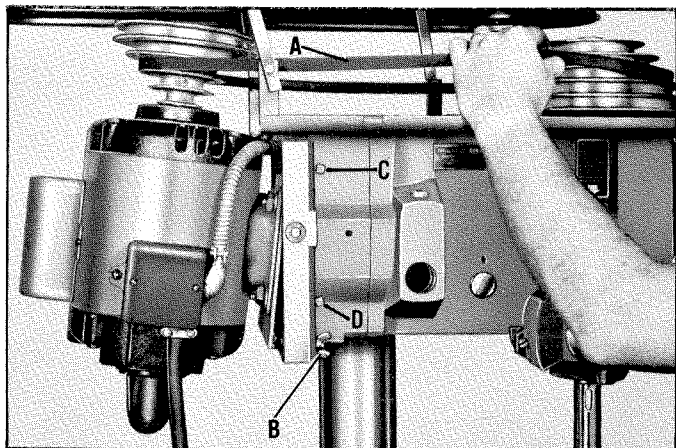


Fig. 3.

2. Release belt tension by loosening wing nut (B) Fig. 3, on left side of motor bracket.

3. Remove belt (A) Fig. 3.

4. Loosen set screw (A) Fig. 2, in spindle pulley, and slip the pulley off of the shaft.

5. Remove the three screws (B) and bearing retainer plate (C) Fig. 2.

6. Pull upper spindle assembly up and out of the head casting. For additional leverage it may be desirable to re-install the spindle pulley in an inverted position to aid in removing the upper spindle assembly.

7. Reassemble by reversing the above instructions.

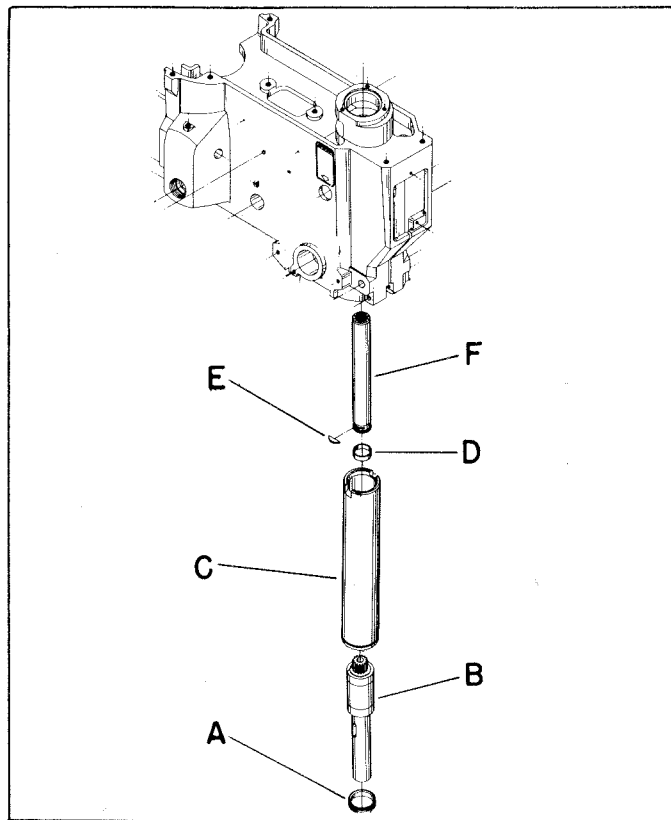


Fig. 4.

CHANGING LOWER SPINDLE ASSEMBLY

To replace the lower spindle assembly or to change drill presses fitted with #2 Morse Taper Spindle to 1/2" capacity key chuck spindle assembly, proceed as follows:

1. Lower the table to allow sufficient space between the table and head to remove the spindle.

2. Lower quill approximately 2" to 4" and lock quill securely with quill locking nut.

3. Using a spanner wrench remove bearing closure nut (A), and pull lower spindle (B) out of quill (C) Fig. 4.

4. Remove garter spring (D), and key (E), Fig. 4. Disengage sleeve (F) from spindle.

5. Reassemble in reverse order.

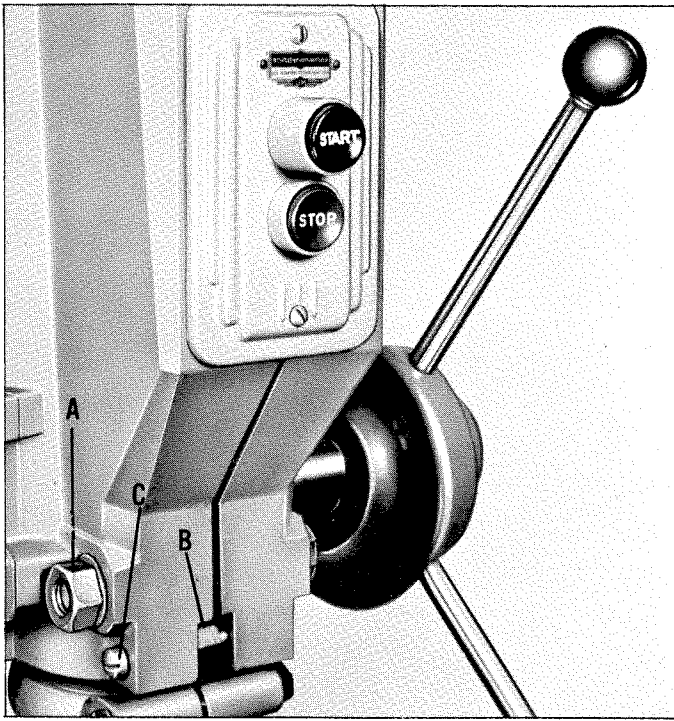


Fig. 5.

QUILL ADJUSTMENTS

The quill can be locked at any desired point in its travel by tightening the quill locking nut (A) Fig. 5. This is an especially desirable feature for set-up of tooling for production type operations.

After considerable use, play might develop between the quill and the head casting. This play can be eliminated by loosening quill locking nut (A) and lock nut (B) Fig. 5. The screw (C) can then be turned clockwise which will draw the split halves of the head casting together to compensate for wear. When the final adjustment is accomplished tighten lock nut (B), Fig. 5.

DRILLING HOLES TO DEPTH WITH HAND FEED DRILL PRESS

When drilling one or two holes to a predetermined depth, the calibrations on the face of the depth stop rod (A) Fig. 6, can be used.

When drilling a number of holes to a predetermined depth, or if a more exact setting is required, proceed as follows:

1. Raise the locking sleeve (B) Fig. 6, and turn the micro-nut (C) to the desired position on the stop rod (A).
2. Lower the locking sleeve (B) so it will engage micro-nut (C) Fig. 6. Lock sleeve (B) in place with thumb screw if drill press head is mounted in other than vertical position. When the drill press is mounted with the chuck pointing "up", the locking sleeve (B) and micro-nut (C) Fig. 6, should be reversed on the stop rod (A).

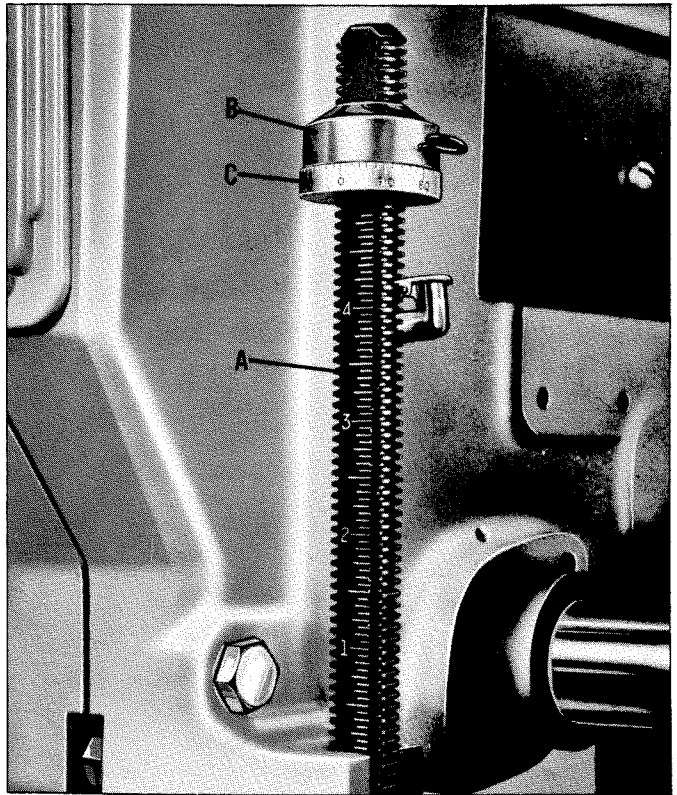


Fig. 6.

3. When locking sleeve (B) is in place on the micro-nut (C) Fig. 6, the micro-nut can not be turned. When a change in depth is required, the locking sleeve (B) must be raised, and while it is raised, turn the micro-nut (C) the necessary calibration marks. Each mark represents $.002''$. Then lower the locking sleeve (B).

4. The use of the micro-set stop nut will maintain the same hole depth, no matter how many holes are to be drilled. However, we recommend that the hole depth be checked whenever a drill has to be sharpened or changed.

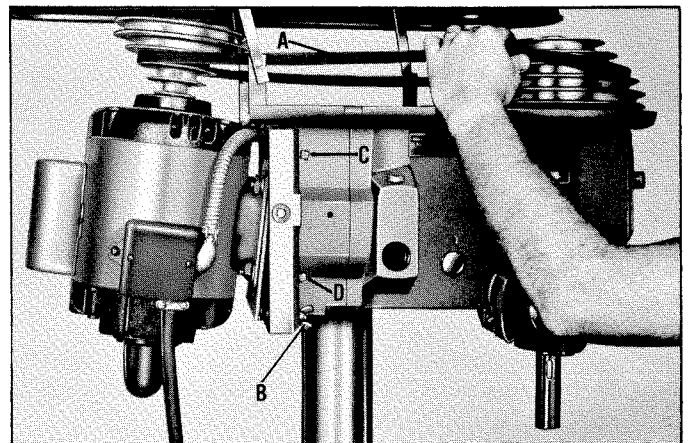


Fig. 7.

ADJUSTING BELT TENSION

To adjust belt tension, proceed as follows:

1. Raise the belt guard and tighten wing nut (B) Fig. 7.

- Loosen the two screws (C and D) Fig. 7, and also loosen the screw on the right hand side of the head, which is directly opposite screw (C).
- Pull the motor away from the head to increase or push the motor toward the head to decrease the belt tension. NOTE: CARE MUST BE TAKEN TO KEEP THE MOTOR SHAFT IN PARALLEL ALIGNMENT WITH THE SPINDLE.

- When the desired tension is obtained, tighten the three screws loosened in Step 2.

CHANGING SPEEDS

- Raise the belt guard.
- Loosen wing nut (B) Fig. 7. The motor will then tilt forward, as shown in Fig. 7, releasing the belt tension.
- Move the belt (A) Fig. 7, to the desired step on the motor pulley and retighten wing nut (B).
- Lower the belt guard.

SLO AND HIGH SPEED MODELS

To change drill press from slo-speed to high-speed or vice-versa is an easy operation. Two kits are available for this purpose.

The Cat. No. 1391 Kit is used for converting drill presses from slo-speed to high-speed.

Included in the kits are the correct spindle and motor pulleys and V-belt. When removing pulleys always remember to loosen the set screws that hold the pulleys on the shaft or spindle. Be careful not to lose the keys.

The Cat. No. 17-862 is used for converting drill presses from high-speed to slo-speed.

HOW TO CHANGE SPINDLE ADAPTERS

One of the unique features of 17" Key Chuck Drill Presses is that they come equipped with a lower spindle assembly having a $1 \frac{1}{16}$ " - 20 thread (A) Fig. 8, and the Cat. No. 15-830 Drill chuck which has a threaded mounting collar (B) Fig. 8.

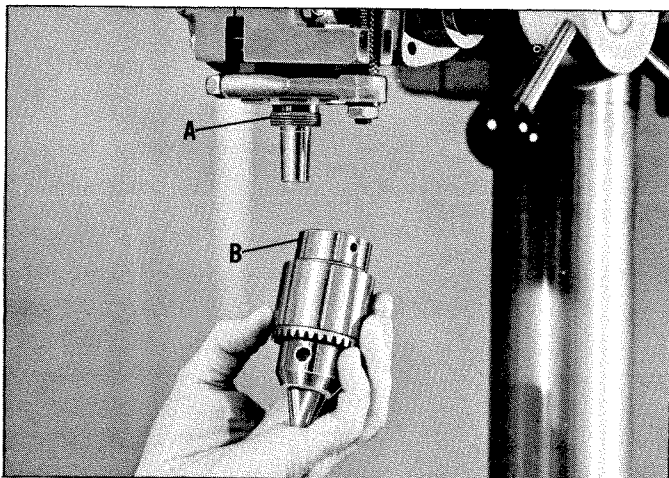


Fig. 8.

Various spindle adapters, shown in Fig. 9, can also be adapted to the threaded spindle of your 17" key chuck Drill Press. These adapters are available as an accessory.

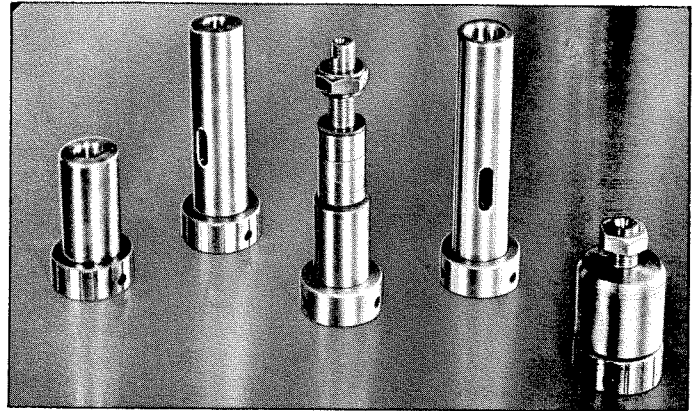


Fig. 9.

The spindle adapters, shown in Fig. 9, along with the Cat. No. 15-830 Drill Chuck, shown in Fig. 8, can be used on 17" Morse Taper Drill Presses when the lower spindle cartridge (Part No. 402-07-301-5001) is installed in the drill press instead of the standard #2 Morse Taper Spindle Cartridge.

When removing either the chuck or the spindle adapters, we recommend the use of the Cat. No. 15-838 spanner wrench which is supplied with Key Chuck Drill Presses. Turn the locking collar of the adapter or chuck with the spanner wrench while keeping the spindle from turning by either holding belt or holding the chuck with the chuck key in one of the pilot holes in the nose of the chuck, as shown in Fig. 10.

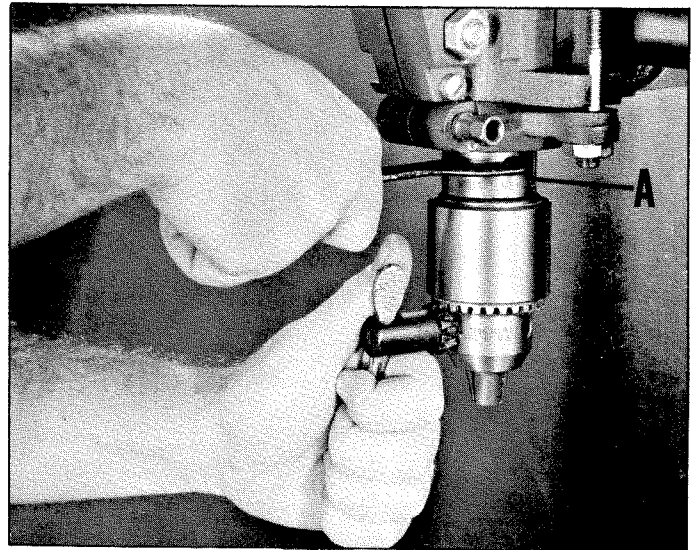
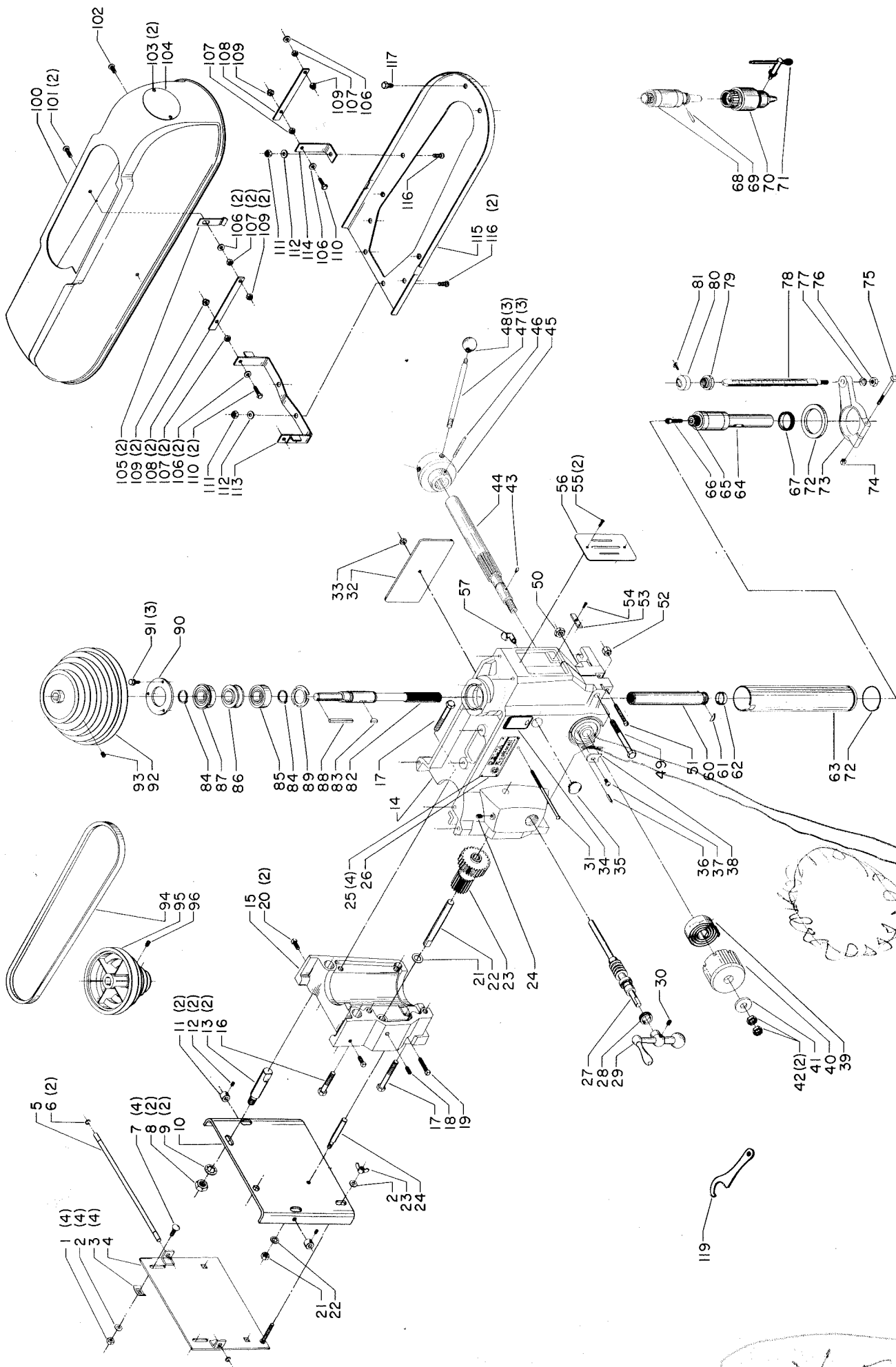


Fig. 10.

When attaching adapters to the spindle, it is very important to wipe clean both the spindle taper and taper hole in adapter. Then place the adapter on the spindle and tighten the locking collar (A) Fig. 10. If in checking the spindle for accuracy, there should be a run out, we suggest that the adapter be removed and turned perhaps one quarter or one-half turn and replaced. This may reduce or eliminate the run out, it may also increase it, in which case, remove the adapter and turn it some more on the spindle.



Spring 92-08001-411
 Screw 404-04-112-500

NOTE →

Replacement Parts

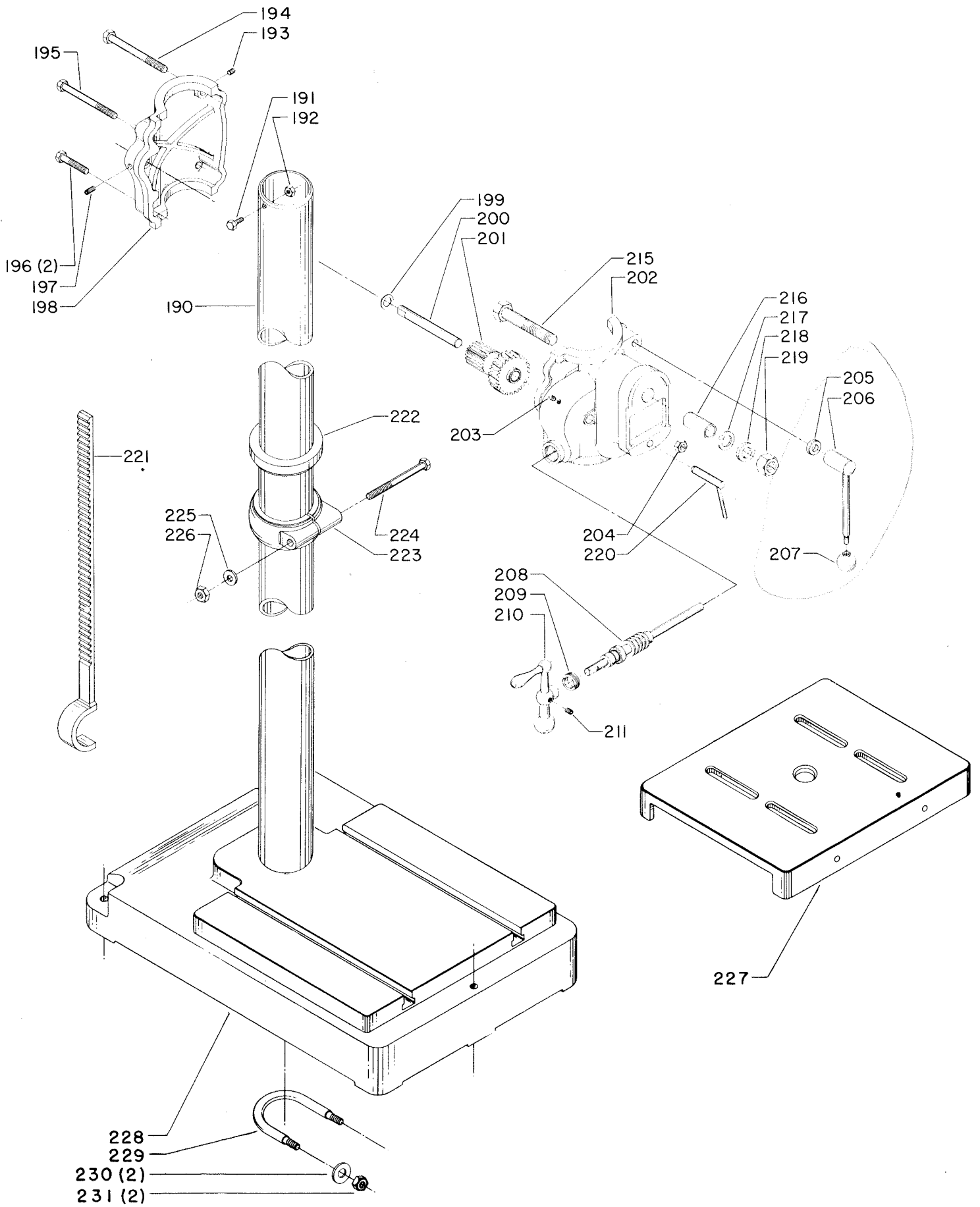
Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	SP-1300	5/16"-18 Hex. Nut	*	402-07-377-5009	Quill and Lower Spindle, 1/2" Chuck), Consisting of:
2	SP-1620	11/32x11/16x1/16" Washer			
3	SP-2951	Speed Nut	60	DP-615	Sleeve
4	402-07-372-5001	Motor Plate	61	DP-623	Key
5	402-07-106-5006	Shaft	62	DP-622	Garter Spring
6	904-15-011-7105	Retaining Ring	63	402-07-077-5002	Quill
7	SP-808	5/16-18 x 1" Carriage Bolt	67	BG-12	Bearing Closure Nut
8	SP-1226	5/8"-18 Hex. Jam Nut	68	402-07-301-5001	Lower Spindle, (1/2" Chuck), Including:
9	SP-1674	5/8" Internal Tooth Lockwasher			
10	402-07-072-5008	Plate	69	SP-2423	#2x7/8" Taper Pin
11	LBS-169	Collar	70	Cat. #15-830	Chuck, Including:
12	SP-208	1/4-20x1/4" Soc. Set Screw	71	DP-597	Key
13	402-07-071-5003	Pin	72	DP-704	Garter Spring
14	402-07-357-5022	Head, Including:	*	402-07-388-5002	Stop Assembly, Consisting of:
15	402-07-020-5005	Cap	73	402-07-014-5002	Bracket
16	SP-615	7/16-14x1-3/4" Hex. Hd. Scr.	74	SP-1034	1/4"-20 Hex. Nut
17	SP-3114	7/16-14x2-1/2" Hex. Hd. Scr.	75	901-11-011-1453	1/4-20x2-1/2" Sq. Hd. Scr.
18	SP-207	5/16-18x1/2" Soc. Set Scr.	76	SP-5433	3/8"-16 Hex. Jam Nut
19	SP-303	5/16-18x1-1/4" Sq. Hd. Set Scr.	77	SP-1704	3/8" Split Lockwasher
20	SP-308	5/16-18x3/4" Sq. Hd. Set Scr.	78	402-07-108-5004	Rod
21	NCS-43	Special Washer	79	402-04-088-5005	Stop
22	DP-642	Compound Gear Shaft	80	DP-561	Body
23	402-07-051-5002	Compound Gear	81	SP-1534	#6-32x1/4" Thumb Screw
24	SP-103	5/16-18x1/4" Headless Set Scr.	*	402-07-406-5002	Spindle Shaft, Consisting of:
25	SP-2250	#4x3/16" Drive Scr.	82	402-07-106-5005	Spindle
26	960-02-012-0038	Nameplate	83	SP-2600	Key
27	DP-636-S	Worm Shaft	84	SP-7025	Retaining Ring
28	DP-638	Bearing Closure Nut	85	SP-5360	Bearing
29	DDL-160-S	Ball Crank, Including:	86	926-01-051-6349	Pulley
30	SP-206	5/16-18x5/16" Soc. Set Scr.	87	920-04-021-5116	Bearing
31	SP-912	1/4-20x4-1/2" Rd. Hd. Screw	88	SP-2661	3/16x3/16x2" Key
32	402-07-072-5001	Cover Plate	89	SP-7352	Spring Washer
33	SP-1034	1/4"-20 Hex. Jam Nut	90	402-07-072-5006	Plate
34	960-03-010-2413	Lubrication Plate	91	901-20-241-6107	#10-32x3/8" Hex. Hd. Washer
35	399-32	Plug	92	DP-825-R	Slo-Speed Pulley, Including:
36	SP-6715	3/16x5/8" Roll Pin	93	SP-201	5/16-18x5/16" Soc. Set Scr.
37	SP-8105	1/4-20x1/2" Hex. Soc. Button Head Screw	92	DP-826-R	Hi-Speed Pulley, Including:
			93	SP-201	5/16-18x5/16" Soc. Set Scr.
38	13-67	Retainer	94	Cat. #520	Slo-Speed V Belt
39	928-08-011-5876	Return Spring	94	Cat. #501	Hi-Speed V Belt
40	11-14	Spring Housing	95	Cat. #1311	Slo-Speed Motor Pulley, Incl.:
41	SP-1608	5/8x1-1/2x3/32" Washer	96	SP-201	5/16-18x5/16" Soc. Set Scr.
42	SP-1226	5/8"-18 Hex. Jam Nut	95	Cat. #1312	Hi-Speed Motor Pulley, Incl.:
43	212-4	Spring Pin	96	SP-201	5/16-18x5/16" Soc. Set Scr.
44	402-07-106-5026	Pinion Shaft	100	402-07-054-5002	Upper Guard
45	402-04-107-5002	Hub	101	SP-7510	1/4-20x3/4" Truss Hd. Scr.
46	905-01-010-6745	3/16x1-7/8" Roll Pin	102	SP-7504	1/4-20x5/8" Truss Hd. Scr.
47	952-01-021-3263	Rod	103	SP-2250	#4-3/16" Drive Screw
48	FJ-324	Knob	104	960-02-012-0028	Guard Nameplate
49	SP-633	7/16"-14x3-1/4" Hex. Hd. Scr.	105	PF-62	Spring Clip
50	SP-5437	7/16"-14 Hex. Nut	106	SP-1614	9/32x5/8x1/16" Washer
51	SP-703	1/4"-20x1-3/4" Fil. Hd. Scr.	107	SP-1034	1/4"-20 Hex. Jam Nut
52	SD-18	1/4"-20 Special Hex. Nut	108	402-07-059-5002	Hinge
53	438-01-021-0081	Plate	109	SP-1079	1/4"-20 Hex. Lock Nut
54	SP-3019	#6-32x1/2" Self-Tapping Scr.	110	SP-626	1/4-20x3/4" Hex. Hd. Scr.
55	SP-3019	#6-32x1/2" Self-Tapping Scr.	111	SP-1300	5/16"-18 Hex. Nut
56	DP-572	Switch Opening Cover	112	SP-1620	11/32x11/16x1/16" Washer
57	907-01-050-5239	Oiler	113	401-04-314-5010	Rear Bracket
*	402-07-377-5007	Quill Assembly, (#2 Morse Taper), Consisting of:	114	11-180	Front Bracket
60	DP-615	Sleeve	115	402-07-054-5001	Lower Guard
61	DP-623	Key	116	SP-506	5/16-18x5/8" Rd. Hd. Scr.
62	DP-622	Garter Spring	117	SP-629	5/16-18x3/8" Hex. Hd. Scr.
63	402-07-077-5002	Quill	119	Cat. #15-838	Spanner Wrench (Chuck Model Only)
64	DP-610-A	Lower Spindle, (#2M. T.), Including:			
65	402-07-051-5005	Pinion Gear	*	Not Shown Assembled	
66	SP-750	5/16-18x1" Soc. Hd. Screw			
67	BG-12	Bearing Closure Nut			

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Bully VOELL MACHINE

DP-633L

Old 17" Return Springs



Replacement Parts

Ref. No.	Part No.	Description
190	Cat. #1368	3 1/2 x 38 1/2" Column (Bench Model)
190	Cat. #1367	3 1/2 x 62" Column (Floor Model)
191	SP-612	1/4-20 x 5/8 Hex. Hd. Cap Scr.
192	SP-1034	1/4-20 Hex. Nut
*	402-07-314-5001	Table Bracket, Consisting of:
193	SP-201	5/16-18 x 5/16 Soc. Hd. Set Scr.
194	SP-643	1/2-13 x 4 Hex. Hd. Cap Scr.
195	SP-637	7/16-14 x 3 3/4 Hex. Hd. Cap Scr.
196	SP-615	7/16-14 x 1 3/4 Hex. Hd. Cap Scr.
197	SP-207	5/16-18 x 1/2 Soc. Hd. Set Scr.
198	402-07-020-5003	Cap
199	NCS-43	5/8 x 1 x 1/32 Washer
200	DP-642	Compound Gear Shaft
201	402-07-051-5002	Compound Gear
202	402-07-014-5006	Bracket
203	SP-103	5/16-18 x 1/4 Hdless. Set Scr.
204	SP-5438	7/16-14 Hex. Jam Nut
205	DP-6	33/64 x 1 x 3/16 Collar
206	DP-663-S	Clamp Handle, Including:
207	FJ-324	Handle Ball
208	DP-636-S	Worm Shaft
209	DP-638	Brg. Closure Spanner Nut
210	DDL-160-S	Ball Crank, Including:
211	SP-206	5/16-18 x 5/16 Soc. Hd. Set Scr.
215	SP-630	3/4-10 x 3 1/2 Hex. Hd. Cap Scr.
216	DP-665	Sleeve
217	DP-736	25/32 x 1 1/4 x 3/32 Washer
218	SP-1707	3/4 Lockwasher
219	SP-1245	3/4 -10 Hex. Nut
220	DP-666-S	Index Pin
221	402-07-351-5001	Gear Rack
222	DP-648-S	Rack Thrust Bearing
223	DP-678-S	Collar, Including:
224	SP-631	7/16-14 x 4 Hex. Hd. Cap Scr.
225	DDL-174	29/64 x 1 x 1/8 Washer
226	SP-1004	7/16-14 Hex. Nut
227	402-05-091-5001	Table
228	402-07-005-5002	Base
229	402-07-027-5001	"U" Bolt
230	SP-1618	9/16 x 1 3/8" x 12 ga. Stl. Washer
231	SP-1282	1/2" - 13 Hex. Nut

* Not Shown Assembled.

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Rockwell is proud of the quality of the power tools which it sells. The component parts of our tools are inspected at various stages of production, and each finished tool is subjected to a final inspection before it is placed in its specially designed carton to await shipment. Because of our confidence in our engineered quality, we agree to repair or replace any part or parts of Rockwell Power Tools or Rockwell Power Tool Accessories which examination proves to be defective in workmanship or material. In order to take advantage of this guarantee, the complete portable power tool or accessory, or in the case of machinery, the part must be returned prepaid to the appropriate factory, factory branch, or authorized service station for our examination. This guarantee, of course, does not include repair or replacement required because of misuse, abuse, or normal wear and tear. Repairs made by other than our factory, factory branch, or authorized service station, relieves Rockwell of further liability under this guarantee. This guarantee is made expressly in place of all other guarantees expressed or implied with respect to fitness, merchantability or quality.

MOTORS

Motors are built to Rockwell's specifications by only leading motor manufacturers. A service station list is supplied with your motor and all defective motors (both in and out of guarantee) should be taken to the local authorized repair station when service is desired.

THINGS TO REMEMBER WHEN OPERATING YOUR DRILL PRESS

1. ALWAYS WEAR SAFETY GLASSES OR A FACE SHIELD.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF POWER TOOLS, OBTAIN ADVICE FROM YOUR SUPERVISOR OR INSTRUCTOR.
3. REMOVE TIE, RINGS, WATCH AND OTHER JEWELRY, AND ROLL UP SLEEVES.
4. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
5. CHECK THE LOCATION OF THE CHUCK KEY BEFORE TURNING ON POWER.
6. HOLD THE MATERIAL SECURELY WITH A VISE OR CLAMPS.
7. ADJUST THE TABLE OR DEPTH STOP TO AVOID DRILLING INTO THE TABLE.
8. BE SURE DRILL BIT OR CUTTING TOOL IS SECURELY LOCKED IN THE CHUCK.
9. GUARDS SHOULD BE IN PLACE AND USED AT ALL TIMES.
10. SHUT OFF THE POWER AND CLEAN THE TABLE BEFORE YOU LEAVE THE MACHINE.



FOR

SERVICE,

QUALITY

and PERFORMANCE in
WOODWORKING and METALWORKING
MACHINES
and
POWER TOOLS