113-24560

ASSEMBLY, OPERATING INSTRUCTIONS AND PARTS LIST FOR CRAFTSMAN DRILL PRESS

MODEL NUMBERS 113.24540 AND 113.24560

The Model Number will be found on a plate attached to your Drill Press. Always mention the Model Number in all correspondence regarding the CRAFTSMAN DRILL PRESS or when ordering repair parts.

Carefully read the instructions provided, observe the simple safety precautions and you will have many hours of satisfactory use from your new Craftsman tool.

HOW TO ORDER REPAIR PARTS

All parts listed herein may be ordered through SEARS, ROEBUCK AND CO. or SIMPSONS-SEARS LIMITED. When ordering parts by mail from the catalog order house which serves the territory in which you live, selling prices will be furnished on request or parts will be shipped at prevailing prices and you will be billed accordingly.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST:

1. The PART NUMBER
2. The PART NAME
3. The MODEL NUMBER 113.24540 or 113.24560
4. The NAME of item — DRILL PRESS

COAST TO COAST NATION-WIDE SERVICE FROM SEARS FOR YOUR CRAFTSMAN DRILL PRESS

PROTECTIVE Sears Care MAINTENANCE

SEARS, ROEBUCK AND CO. and SIMPSONS-SEARS LIMITED in Canada back up your investment with quick, expert mechanical service and genuine CRAFTSMAN replacement parts.

If and when you need repairs or service, call on us to protect your investment in this fine piece of equipment.

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Part No. 71031

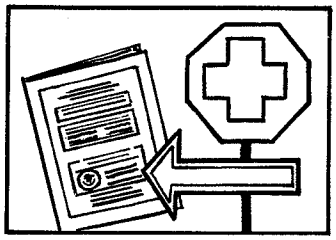
CRAFTSMAN

POWER TOOL SAFETY...AND YOU

3 MINUTES of required reading for the home Craftsman . . . whether this is your first purchase or you're an old hand at power tools.

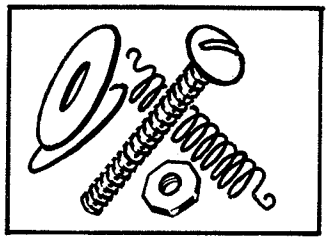
YOU'VE JUST BOUGHT A QUALITY SEARS TOOL, designed to give you many years of top performance and trouble-free operation. **It's also designed with safety in mind,** permitting you to use the tool without concern so long as certain basic rules are observed.

We'd like to call particular attention to some of the more **important rules** to follow for maximum enjoyment of your Sears power tools.



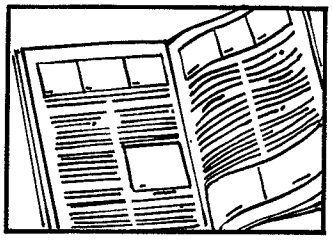
1. READ THE INSTRUCTION MANUAL . . .

completely • accurately.
Pay special attention to safety precautions and use of safety features.



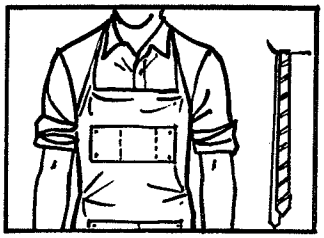
2. INSPECT THE POWER TOOL THOROUGHLY

Set up the machine according to instructions. Make certain all parts are included.



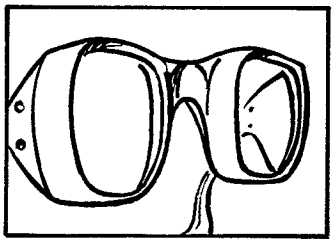
3. FOLLOW OPERATING INSTRUCTIONS CAREFULLY

They have been developed to insure correct procedure and prevent accidents.



4. DRESS PROPERLY FOR THE WORKSHOP

Get rid of loose clothing, roll up sleeves (or fasten securely), remove your tie, wear a snug-fitting shop apron.



5. WEAR SAFETY GLASSES

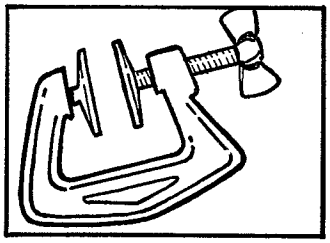
Safety glasses or eye shields are recommended for all power tool operations.

6. USE PROPER ELECTRICAL CONNECTIONS

Make certain proper voltage (110 or 220) is used. USE A GROUND WIRE; AND A SUITABLE PLUG, IF REQUIRED.

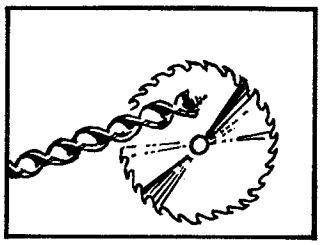
Check fusing requirements of the tool as outlined in the instruction manual.

Get in the habit of turning off the tool when not in use.



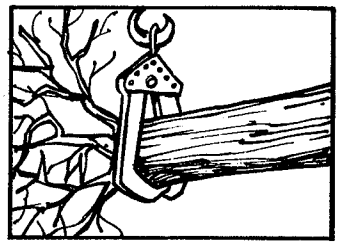
7. DOUBLE-CHECK HOLDING FIXTURES

Lock all clamps tightly.
Spin parts by hand to check against misalignment or looseness before turning on tool.



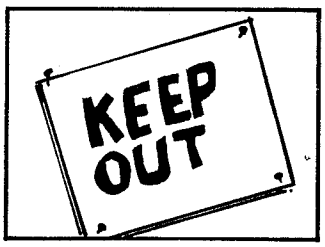
8. KEEP CUTTING TOOLS SHARP

Make certain blades, drills, cutters, etc., are in top shape. Dull tools can cause rough cuts, excessive chipping . . . and accidents.



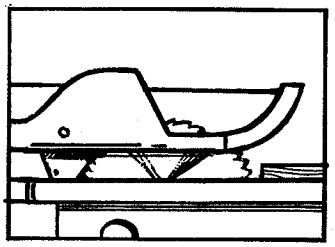
9. DON'T EXCEED THE LIMITS OF THE POWER TOOL

Abusing the power tool by doing work beyond its capacity reduces its life and increases the chance of injury to the operator. Watch especially the sizes of the work and feed rate.



10. KEEP SPECTATORS AWAY

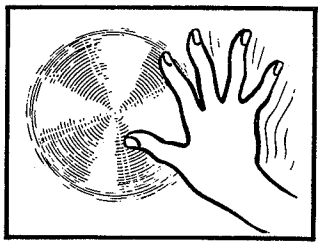
Curiosity and interest on the part of the family is fine, but avoid inspections when the power tool is running.



11. SAFETY GUARDS

Accessory safety guards are available for most tools. Use of these guards is highly recommended.

Keep protective caps on ends of exposed, rotating shafts.

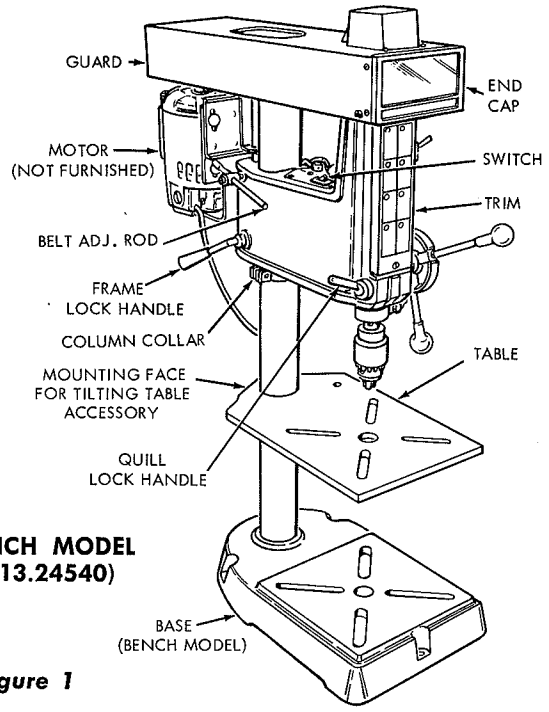


12. AVOID AWKWARD HAND POSITIONS

Do not place hands in a position where a sudden slip could cause them to move into a cutting tool. Do not force work abnormally into any cutting tool.

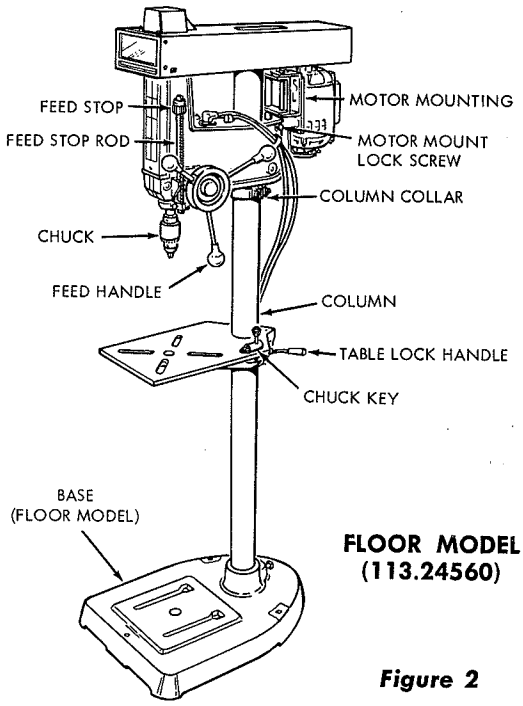
THINK SAFETY *Carefully plan each operation before turning on tool*

ASSEMBLY AND OPERATING INSTRUCTIONS FOR CRAFTSMAN DRILL PRESS MODEL NUMBERS 113.24540 AND 113.24560



BENCH MODEL (113.24540)

Figure 1



FLOOR MODEL (113.24560)

Figure 2

UNPACKING AND CHECKING CONTENTS

This Craftsman Drill Press is available as a bench model and as a floor model, as shown in figures 1 and 2. The bench model (No. 113.24540) is the same as the floor model (No. 113.24560) except for the longer column and larger base. Both models are shipped in the same style carton; however, the floor model has the long tubular column extending out of the carton.

In order to facilitate packaging, certain items are not attached at the factory, and must be assembled when received by the purchaser. These loose parts are packed in the carton with the drill press; therefore, before discarding any packaging materials, examine them carefully to make sure all "loose" parts have been removed. The following parts are not assembled to the drill press:

1. V-belt
2. Motor pulley (with set-screw)
3. Chuck key
4. Chuck
5. Feed handle rod and knob assemblies (three)
6. Motor attaching bolts (four)
7. Motor bolt nuts (four)
8. Motor bolt washers (four)
9. Guard
10. Guard attaching rod and two wing nuts
11. Hex wrench (3/32")
12. Hex wrench (5/32")
13. Feed stop assembly

MOTOR REQUIREMENTS

The drill press is designed to perform its best work when driven with a 1/2-horsepower, 1725 rpm, ball-bearing motor.

ASSEMBLY

1. Hold the frame securely, loosen the frame lock handle (figure 1) and slide the frame upward on column to a convenient working position. Tighten the frame lock handle.
2. Move the column collar upward as far as possible and re-tighten.
3. Loosen the table lock handle (figure 2) and raise the table to a position approximately eight inches below the frame. Tighten the table lock handle.
4. Screw the three feed handles into the tapped holes in feed hub.
5. Tighten feed handles hand tight by gripping the knobs.
6. To install motor, loosen the motor mount lock screw, at right rear of frame, (figures 2 and 4) and remove the motor mount assembly. (See figure 3.) Fasten the motor to the motor mount assembly with the hardware supplied, but DO NOT TIGHTEN HARDWARE. (Motor bolt nuts to be on motor side, as shown.)

   NOTE: Direction of rotation of the spindle must be clockwise when viewed from pulley end of spindle.

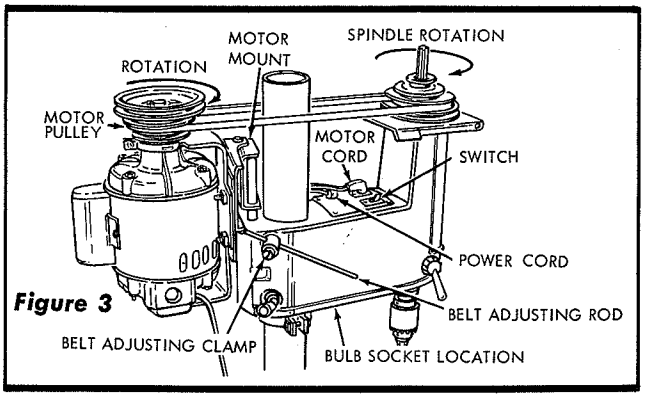


Figure 3

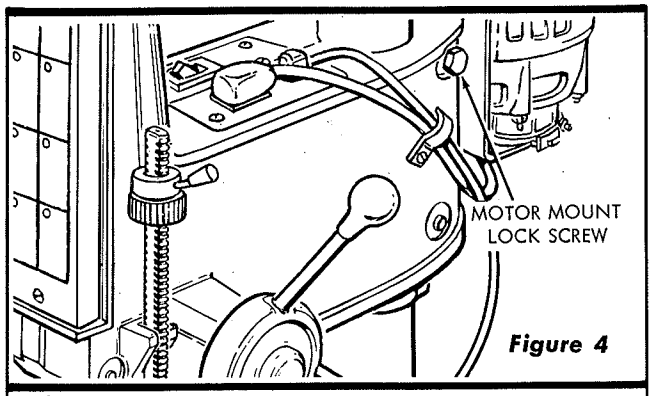


Figure 4

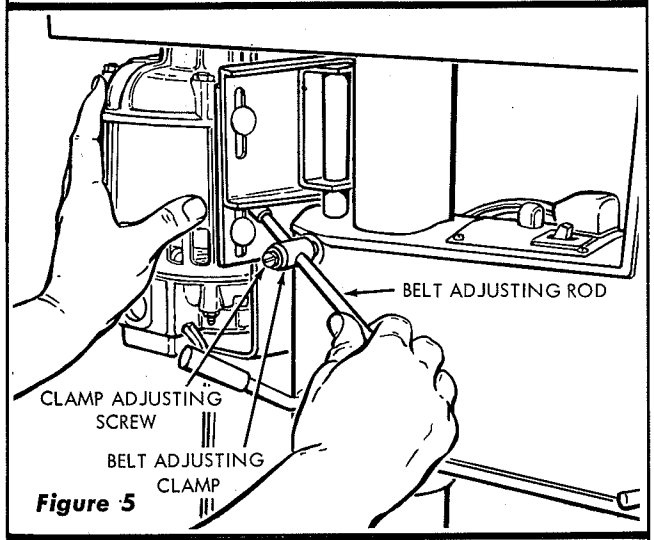


Figure 5

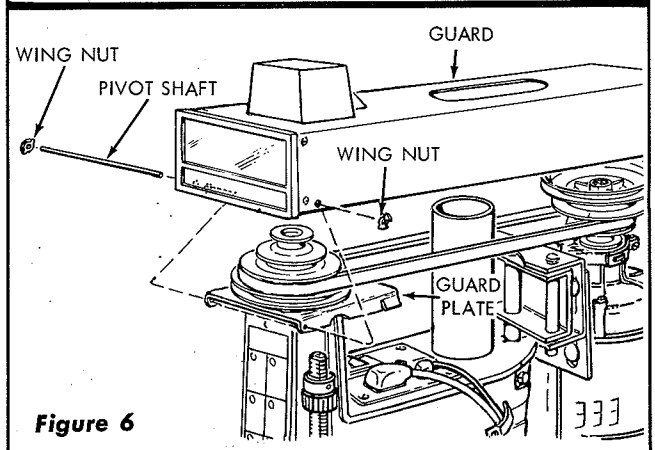


Figure 6

7. Mount the motor pulley on motor shaft so the small diameter is at the bottom. Tighten the pulley set screw with pulley mounted as far on the shaft as possible (near the motor bearing). If your motor shaft has a "flat", position the pulley so the set screw will tighten against the "flat". Install motor and motor mount assembly in the drill press frame.
8. Slide motor vertically until pulleys are in alignment. For normal speeds the largest groove on the motor pulley must be in line with the smallest groove on the spindle pulley. Tighten all motor mounting bolts.
9. Place the V-belt around pulleys and take up belt slack by pivoting the motor mount away from the frame. While maintaining proper belt tension, position motor mount assembly so the belt straddles the column equally. Tighten the motor lock screw (See figure 4).
10. Install the belt adjusting clamp (figure 3) into the tapped hole provided in the left side of the frame. Push the belt adjusting rod tip on one end of the belt adjusting rod and slide rod into the belt adjusting clamp. With belt properly tensioned (3/8-inch to 1/2-inch movement inward when pushing on outside of belt with average finger pressure) slide the adjusting rod to contact motor mounting assembly, and tighten clamp adjusting screw. (See figure 5.) Refer to "BELT TENSION" under "ADJUSTMENTS."

    NOTE: Excessive belt tension will produce bearing noise, rapid bearing wear, and sluggish automatic feed return.
11. Install a 60-watt incandescent bulb in the socket provided and plug the motor cord into the outlet on the frame. (See figure 3.)

    NOTE: If drill press is operated at 230 v., 115 v. light bulb must be removed.
12. Attach the guard to the guard plate at spindle end of frame with the pivot shaft and two wing nuts. (See figure 6.) This is accomplished as follows:
    Screw one of the wing nuts on the pivot shaft, lower the guard into operating position until the pivot shaft holes in the guard are aligned with corresponding holes in the guard plate. Then slide the pivot shaft through the holes and install the wing nut at other end of shaft. The guard should raise and lower without interference. (See figure 6.)
13. Clean the spindle taper and tapered socket in chuck body with a clean cloth. (See figure 7.) Make sure no foreign particles are left on these tapered surfaces that would prevent proper seating of the parts. Apply a light film of oil on spindle taper and place chuck on end of

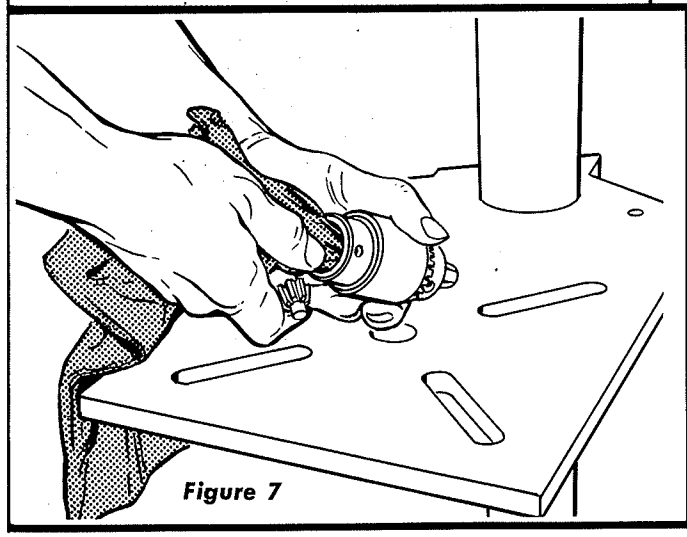


Figure 7

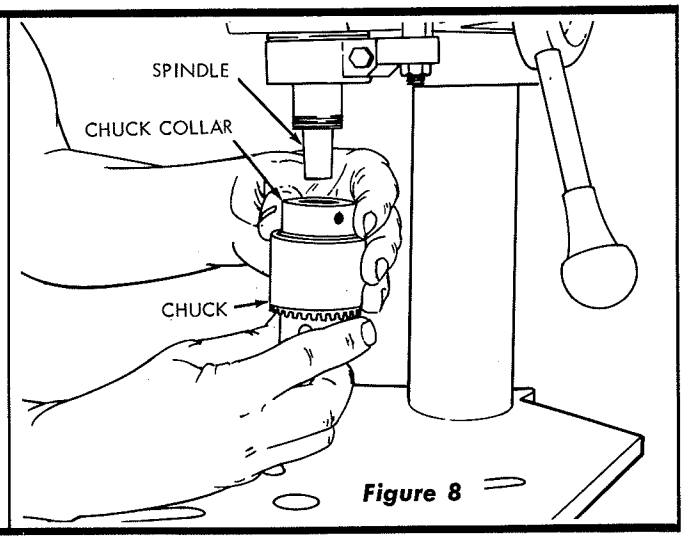


Figure 8

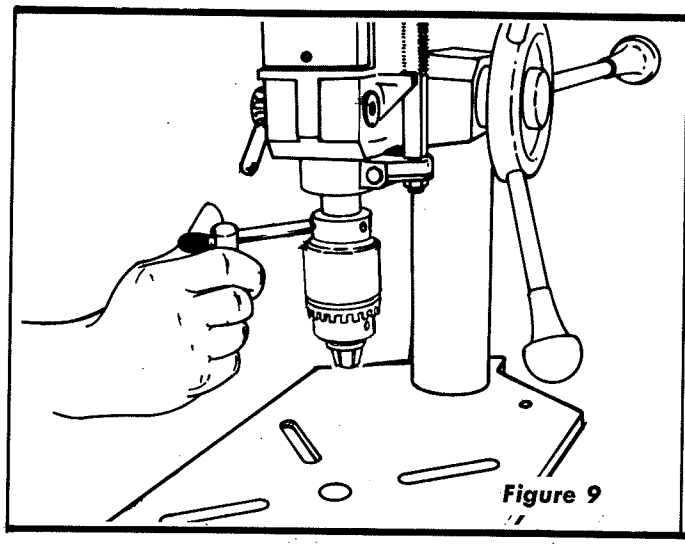


Figure 9

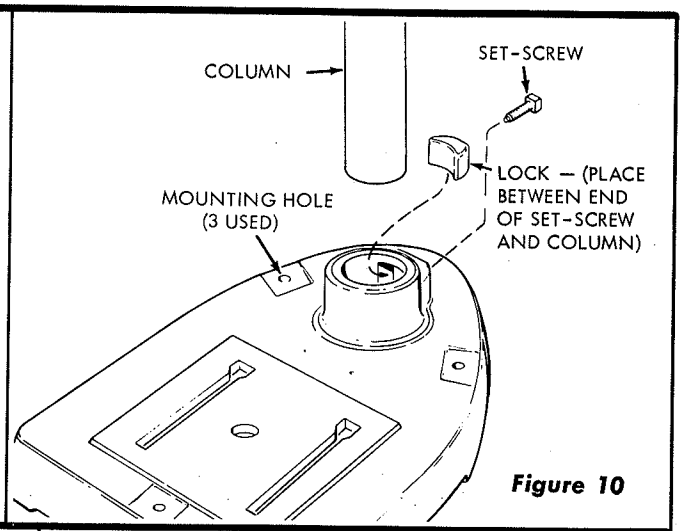


Figure 10

spindle. (See figure 8.) Screw the chuck collar onto the threaded portion on end of spindle. Make sure switch controlling the motor is "OFF," then squeeze belt around spindle pulley with left hand to keep spindle from rotating and tighten collar with handle of chuck key. (See figure 9.) The collar should not be excessively tight, as it has a tendency to become tighter during operation.

14. Connect the drill-press power cord to a 115 volt, house power source.

INSTALLATION

Three 13/32-inch diameter holes have been provided in the base of the bench model unit, through which bolts or screws may be inserted to secure the drill press to a well constructed bench or tool stand. Similar holes are provided in the base of the floor-model unit for securing it to the floor, if required. (See figure 10.) When attaching the column to base, make sure the lock is properly inserted in base cavity so that curved portion of lock fits against column and flat portion of lock is against end of set-screw, as shown in figure 10.

OPERATION

SET-UP GUIDE

Two operating instruction panels are located directly in front of the operator, when facing the drill press. (See figure 11.) The end cap, located on forward end of the guard contains information regarding suggested speeds for performing various operations. The trim contains a "Set-Up Guide", which is a combined numbered color-code system. It indicates the location of controls required for a particular set-up operation. The operator should become familiar with the "Set-Up Guide" before operating the drill press.

CONTROLS

1. **Chuck.** The key-type chuck has a maximum capacity of a 1/2-inch diameter drill. It is equipped with a lock collar to retain it on the spindle, which eliminates the necessity of having collet chucks for such tools that develop side thrust while in operation, such as routers, molding cutters, etc.
2. **Feed Stop.** The feed stop unit provides a means of presetting hole depths before drilling or for drilling several holes to the same depth. (See figure 12.) The feed stop handle (when tightened) holds the feed stop collar in place. The two pieces, as an assembly, can be moved on the stop rod for fast positioning by turning the unit a quarter turn and sliding it up or down to the approximate desired position. (See figure 12.) With the quill extended for maximum drill depth desired, the feed stop collar is

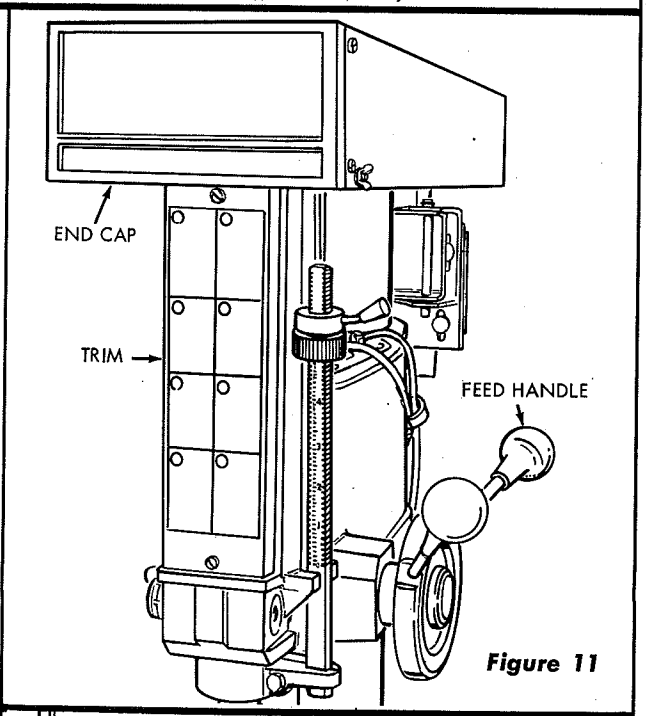


Figure 11

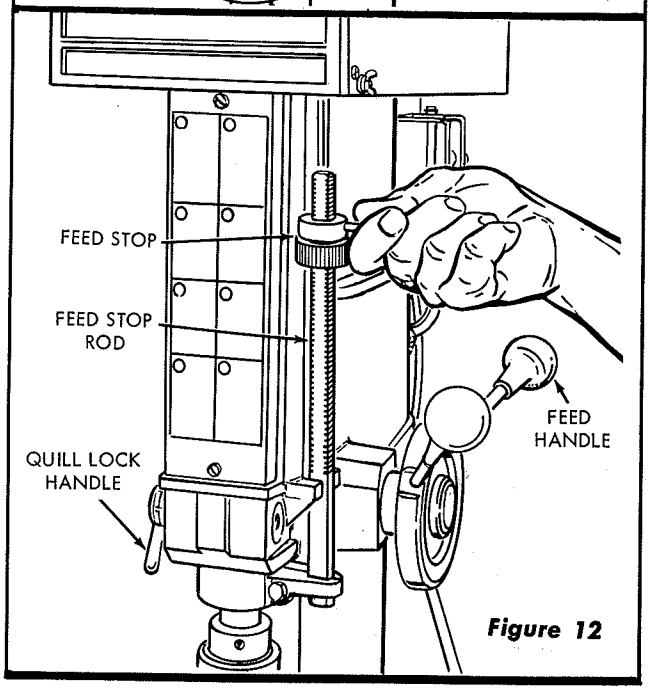


Figure 12

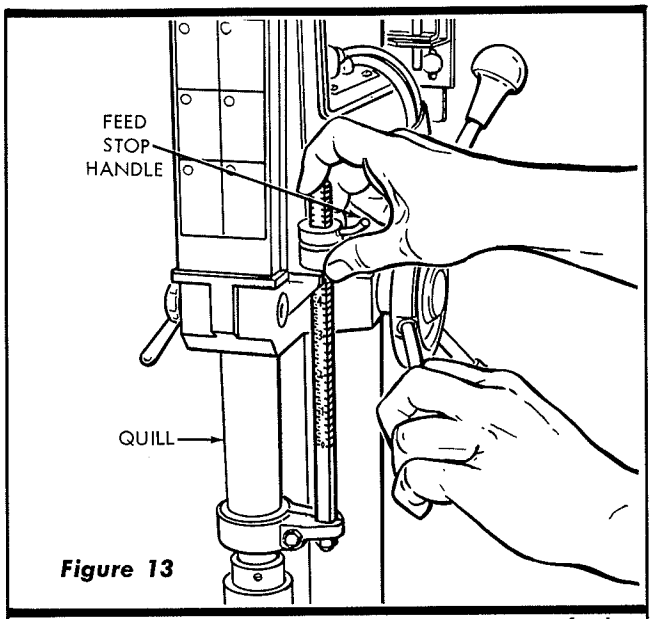


Figure 13

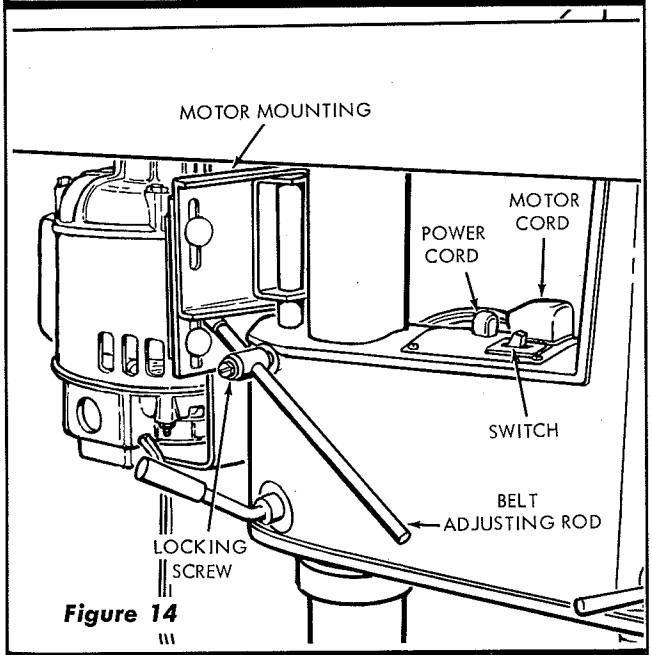


Figure 14

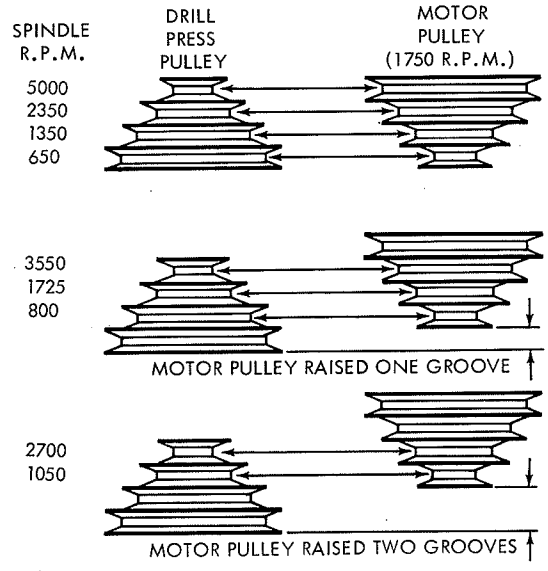


Figure 15

rotated on the feed stop rod and clamped with the feed stop handle.

CAUTION: The top of the adjusting collar should never be more than 1/8-inch away from the shoulder of the feed stop collar after an adjustment has been made. If the desired adjustment can not be made within the 1/8-inch allowance, reposition the unit and adjust the feed stop adjusting collar. (See figure 13.)

3. **Feed Stop Rod.** This rod is a gauge, with six inches of 1/16-inch graduations, carrying the feed stop and lock nut. (See figure 12.)
4. **Feed Handle.** The feed handle is used to raise and lower the chuck a total distance of six inches. (See figure 12.) It has an automatic spring loaded return action.
5. **Quill Lock Handle.** The quill lock handle (when tight) holds the quill at any depth of cut for such operations as shaping, routing, surface grinding, etc. (See figure 12.) Always release the quill lock before attempting to raise or lower the quill.
6. **Table Lock Handle and Frame Lock Handle.** The table lock handle and frame lock handle control the barrel locks which grip the column.

   CAUTION: When releasing either of these handles do so with care. Support the item being repositioned, so that it will not drop too rapidly causing damage to the parts.
7. **Column Collar.** This is a two-piece collar for clamping to the column. It should be located under the frame to keep it from sliding down accidentally when the frame lock handle is loosened. (Refer to Figure 1.)
8. **Motor Mounting.** The motor mount is designed with a double hinge arrangement in order to make changing of spindle speeds easy and rapid. In addition, a quick-type belt adjusting rod has been provided, which will, in effect, provide a solid motor mount and maintain proper belt tension when the drill press is operating. (See figure 5.) To move the belt from one pulley groove to another, disengage the rod, pivot motor forward and slip belt into desired groove. Engage the rod with the rubber tip under the rib welded to motor mount.
9. **Switch.** A switch plate on top of the frame, between the quill and motor, contains the "ON-OFF" switch and a receptacle for "plugging-in" the motor power cord. (See figure 14.) The drill press power cord also emerges from this switch plate. If the motor is equipped with a switch, it can be left "ON" and the drill press operated with the drill-press switch. For set-up purposes it may be desirable to keep the light on. This can be accomplished by leaving the drill-press switch "ON", and operating the unit with the motor switch.

SPINDLE SPEEDS

Nine spindle speeds are available by shifting the belt and pulleys as shown diagramatically in figure 15. The four spindle speeds (650, 1350, 2350, and 5000 rpm) shown on the guard end cap may be obtained by shifting the belt to different pulley grooves. These speeds have been found adequate for all normal operations using common materials.

However, five additional intermediate speeds can be obtained by operating with the guard cover in the open position and shifting the motor pulley upward one or two grooves.

NOTE: Use extra caution whenever the drill press is operated with the guard in the open position.

If speeds slower than 650 rpm or faster than 5000 rpm are required, a Multi-Speed Attachment (Catalog No. 2338) is available at the nearest Sears Retail Store or Mail Order House. If this attachment, a variable speed motor, or other similar device is used, *make certain that at no time the spindle speed is allowed to exceed 8500 rpm.* To determine spindle speed, multiply motor speed by the diameter of motor pulley and divide by the diameter of spindle pulley. If an intermediate pulley is used (like Catalog No. 2338), multiply the motor speed by the diameter of motor pulley and divide by the diameter of the in-line intermediate pulley to obtain the speed of the intermediate pulley. Then, multiply this speed by the diameter of the intermediate pulley (that drives the spindle) and divide by the diameter of the spindle pulley.

OPERATING HINTS

1. **Removing the Chuck.** When removal of the chuck is required, make sure the switch controlling motor is "OFF." Prevent rotation of spindle by squeezing the belt around spindle pulley, and loosen chuck locking collar with the end of the chuck key. Continued rotation of the collar will force the chuck off the tapered spindle. Do not attempt to drive or wedge the chuck off, as this could damage the spindle, spindle bearings, or both.

2. **Types of Drill Bits.** (See figure 16.)
   A variety of bits are available for use in the drill press. For metal drilling, the standard type twist drill will satisfy the requirements of the average home work shop. If extensive commercial operations are to be performed, high-speed steel drills (although more expensive) will prove to be the better tool as higher operating speeds are possible, plus longer life of cutting edges.

   The flat boring bit makes an excellent all purpose wood bit.

   For larger holes, a hole saw is available for either metal or wood. This bit has a center drill for piloting, and teeth around the outer rim similar to a saw blade.

   Also, for large holes in wood an expansion bit may be used. When the expansion bit or any hand wood bit is used in the drill press, **the screw point must have the threads removed to prevent too rapid entry into the wood.** These threads may be filed off with an ordinary file.

   Countersinking in wood may best be accomplished by using the multifluted type countersink. It will produce the cleanest cut and will not gum up under continuous operation.

   The combination pilot, shank, and countersink drills are becoming popular for wood screw applications.

3. **Drill Sharpening.** (See figure 17.) When grinding twist drills, extreme care should be exercised, in order to maintain the efficiency of the drill. **The dead center of the point must be maintained,** that is, **both cutting lips must be the same length. Also, the angle of cutting lips in relation to the center-line of the drill must be equal.** The angle should be approximately 59 degrees (118 degrees included) for metal, and 30 degrees (60 degrees included) for wood. The cutting lip should be relieved gradually behind the cutting edge so that the clearance at the heel is approximately 12 degrees.

4. **Protecting Workpiece on Drill Breakthrough.** When drilling through wood, a piece of scrap material under the workpiece will eliminate splintering and mutilation of the workpiece as the drill point breaks through.

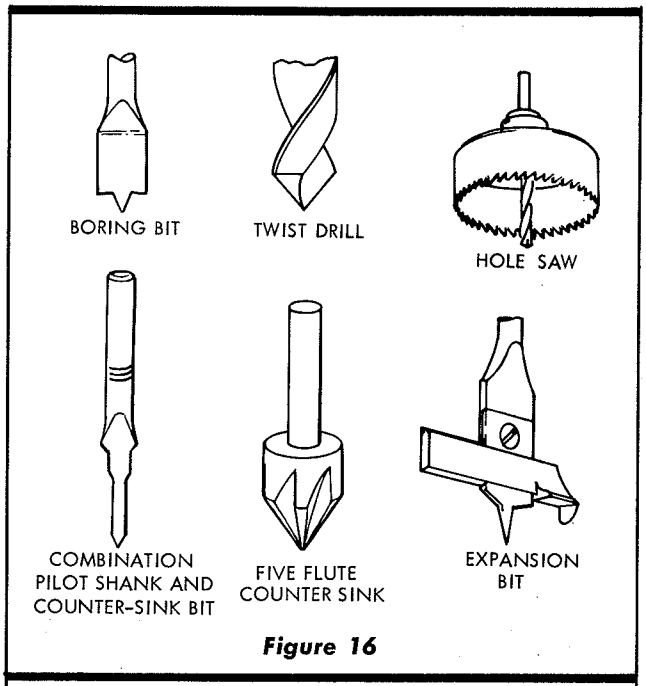


Figure 16

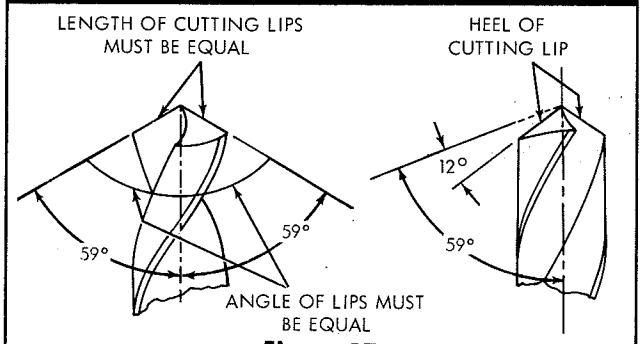


Figure 17

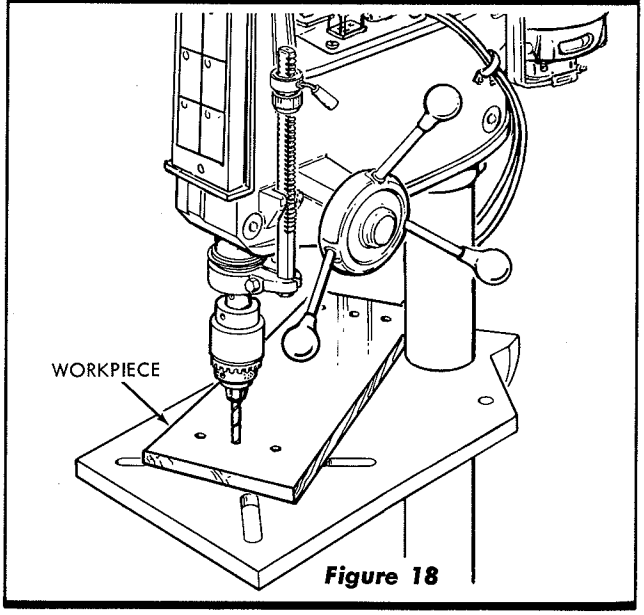


Figure 18

5. **Another method to prevent splintering** is to reverse the workpiece when the point of drill just breaks through and finish the hole from the opposite side.

6. **Preventing Movement of Workpiece When Drilling.** To prevent work from being torn from operator's hands, position wood or metal items against the left side of the column. (See figure 18.) If a metal workpiece is too short

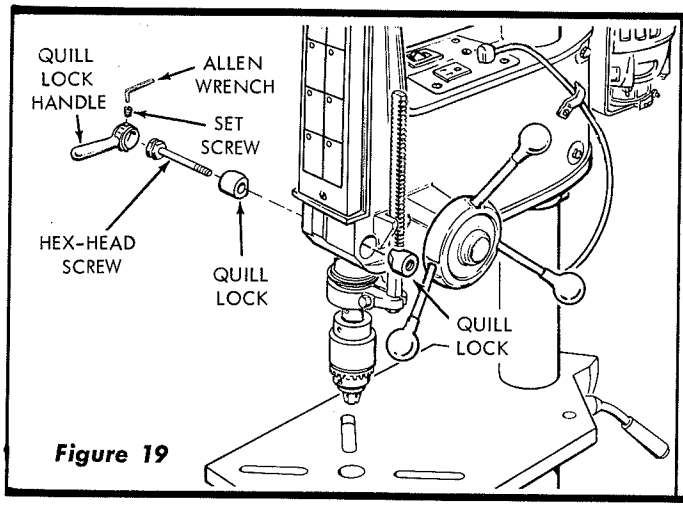


Figure 19

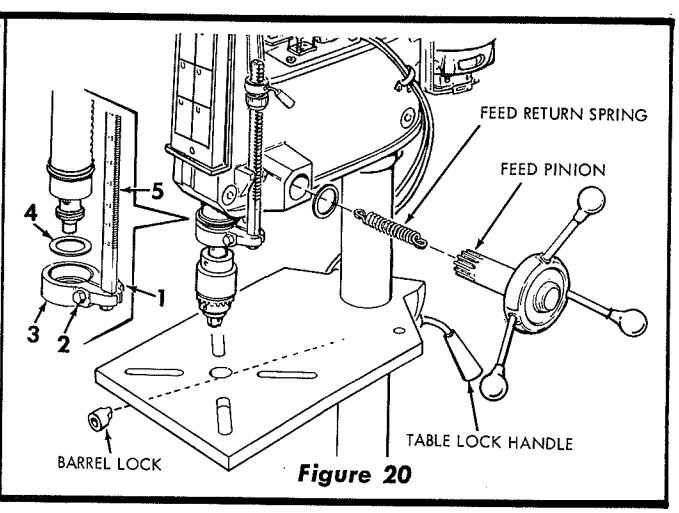


Figure 20

to reach the column, clamp it to the table or use a drill vise. Reduce rate of feed when drill starts to break through metal workpieces to prevent "grabbing" by the drill.

CAUTION: When removing (raising) drill from workpiece — wood or metal — make sure that work does not raise off table. A sure method of preventing this is to clamp the work to the table before drilling.

7. **Marking Depth of Hole.** When drilling to a definite depth, such as blind holes, the feed stop may be set to the desired depth by lowering the drill to a mark on the edge of the workpiece corresponding to the depth of the hole desired.

NOTE: A complete operating manual is included with this drill press, which illustrates and describes more than 100 useful and interesting operations.

ADJUSTMENTS

QUILL LOCK HANDLE

For greatest ease of operation the quill lock handle should point forward when locked. To change the position of the handle, loosen the set-screw, remove handle from hex-head screw and rotate to correct position. (See figure 19.) Replace the handle and tighten the set-screw.

SPINDLE PLAY

If axial play (vertical movement) exists in the spindle, it can be removed by the following procedure:

1. Clamp the quill with quill lock handle; loosen the 1/4-20 feed stop collar clamping nut (1, figure 20), reposition feed stop collar (3) upward as far as it will go, then tighten the feed stop collar clamping nut (1).
2. Make sure the feed stop rod (5) is positioned properly in the guide slot of the frame.

When the feed stop collar is removed in order to install the mortising attachment (Catalog No. 9-2460), use the washer (4, figure 20) in the mortising attachment clamping collar and eliminate spindle play as described in preceding paragraphs.

BELT TENSION

This adjustment is made by loosening the lock screw on the belt adjusting rod and sliding the rod rearward. (See figures 5 and 14.) Excessive tension shortens bearing life, causes excessive belt wear and robs the motor of power. Tension should be just enough to prevent slippage at normal operating speeds and feeds. (Refer to paragraph 10 under "ASSEMBLY.")

PULLEY SET-SCREWS

Tighten motor pulley set-screw after a few hours operation and after adjusting the pulley on motor shaft for a spindle speed change.

CAUTION: Frame or table assembly should be securely supported when changing locked position of handles.

TABLE AND FRAME LOCK HANDLES (See figures 1 and 2.) To change the locked position of table lock handle or frame lock handle, unscrew the handle from barrel lock and rotate barrel lock 180°. Re-insert the lock and tighten lock handle (See figure 20.)

AUTOMATIC FEED RETURN

If the automatic feed return fails to return the chuck to the top of the stroke, or if the return action becomes sluggish, check belt tension for over-tightness. If belt tension is correct, the feed return tension may be adjusted as follows: (See figure 20.)

1. Lock the quill at the top of its stroke with quill lock handle.
2. Holding the feed handles, pull pinion assembly straight out until pinion gear teeth are dis-engaged from the rack and the feed assembly is free to turn. Then turn handles counterclockwise approximately one-half turn and re-engage the pinion.
3. Release quill lock handle and check tension. If return tension is still not sufficient, repeat the above adjustment until the desired return action is obtained.

LUBRICATION

1. Spindle and pulley bearings have been packed with lubricant at the factory and require no further attention for the life of the bearings.
2. To maintain smoothness of operation and prevent rust, apply a small amount of light cup grease to the quill occasionally while in a down position.
3. Wipe the column and table occasionally with an oil-soaked cloth, or spray with a silicon base rust inhibitor to prevent rust and maintain smooth sliding action.

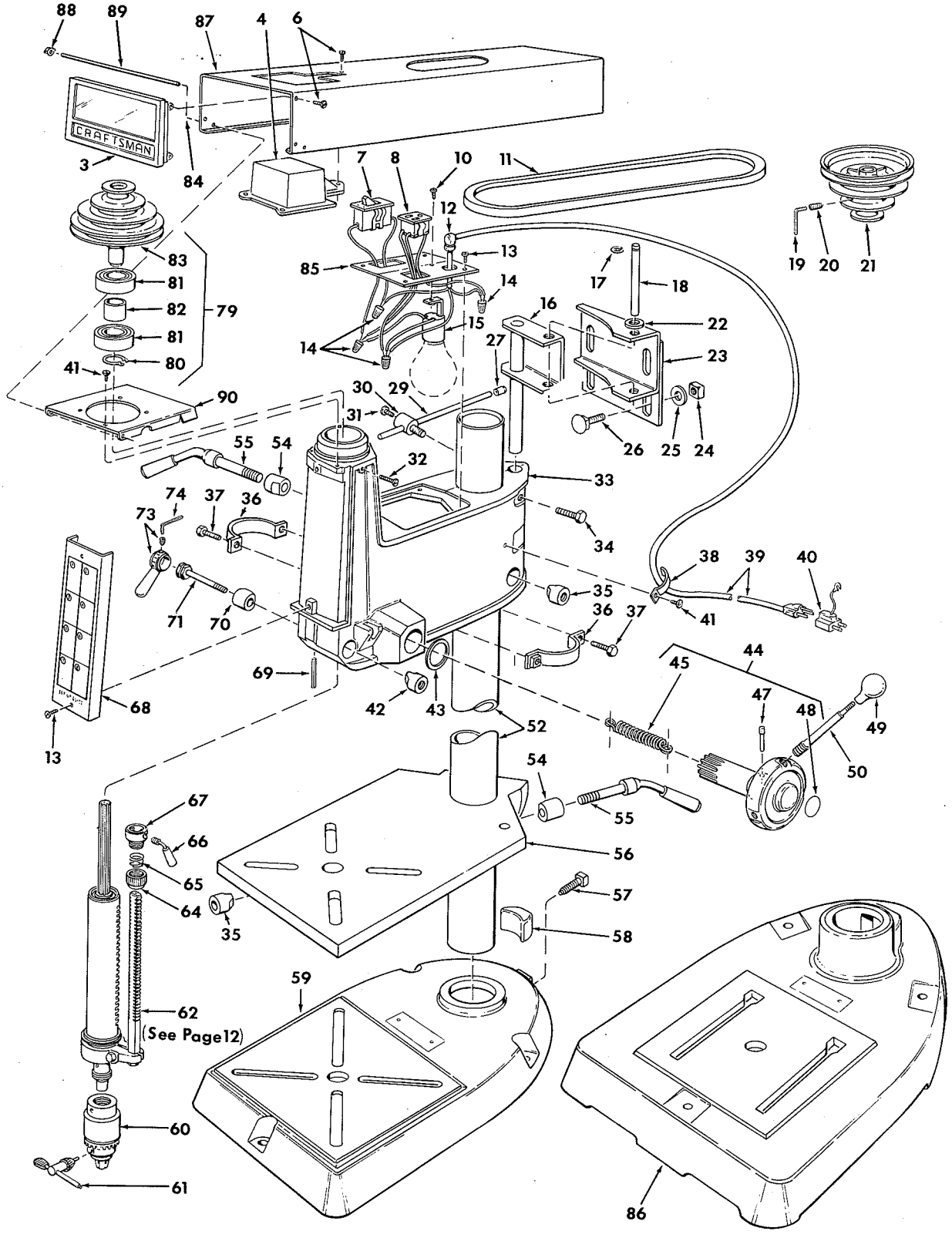
BENCH POWER TOOL GUARANTEE

We guarantee all Craftsman Drill Presses to be free from defects in material and workmanship. When properly used, cared for and maintained, we will replace or repair at our option and install without cost to you, for a period of one (1) year from date of sale, any part which proves, upon our examination, to be defective under normal use. This guarantee doesn't apply to Drill Presses used in rental service.

TYPICAL COMPLAINTS ON DRILL PRESS OPERATION

COMPLAINT	PROBABLE CAUSE	REMEDY
Noisy operation when idling.	1. Improper belt tension.	1. Reposition belt adjusting rod to provide 3/8 to 1/2 inch movement inward when pushing on outside of belt with average finger pressure.
Noisy operation when idling at high speeds.	1. Splines in drill press pulley assembly not in optimum alignment with spindle splines.	1. Loosen the slotted, pan-head screw (located immediately under guard plate assembly on right-hand side of frame), remove pulley assembly and rotate one tooth at a time (re-install belt and operate) until position of quietest operation is determined. Tighten the screw.
Drill or cutting tool used heats up or work burns.	1. Excessive speed. 2. Chips not clearing. 3. Drill or cutting tool is dull. 4. Too slow a feed.	1. Change to slower speed. 2. Retract drill frequently to clean chips from hole. 3. Sharpen drill or other tool. 4. Feed fast enough to keep tool cutting chips.
Drill leads off.	1. Hard grain in wood may cause drill to veer. 2. Cutting lip lengths and/or angles not equal.	1. Grind drill point to 60° included angle. 2. Grind to proper length and angle.
Wood splinters on large break through.	1. Lack of support.	1. Use scrap block under work piece.
Work torn from hands.	1. Failure to follow proper procedure.	1. Clamp work to table or use drill vise for metal items. 2. Support wood or metal against left side of column whenever possible.
Drill binds in work.	1. Work piece pinching drill. 2. Excessive feed pressure.	1. Support work piece directly under, or as close to cutting area as possible; maintain proper alignment. 2. Feed with uniform pressure and avoid jamming drill into work piece.
Drill overheats when mortising.	1. Improper set-up. 2. Improper drill speed. 3. Dull chisel and/or bit.	1. Provide proper amount of chip clearance — must be at least 1/16-inch between chisel and back side of end of bit. 2. Adjust belt steps to attain proper operating speed. 3. Sharpen.
Chatter and rough cutting action when routing.	1. Spindle speed too slow. 2. Vibration. 3. A cut which has excessive depth.	1. Higher spindle speeds produce smoother cuts. 2. Work must be held firmly throughout pass; use the column as back-up (figure 18) or hold-downs when possible. 3. Full depth of cut should be produced by making successive passes.
Drill overheats when drilling iron or steel.	1. Failure to use cutting oil. 2. Too slow a feed. 3. Too slow or too fast a spindle speed.	1. Use cutting oil. 2. Feed fast enough to keep tool cutting chips. 3. Small diameter drills — increase spindle speed; large diameter drills — decrease spindle speed.
Excessive drill runout or wobble.	1. Bent drill. 2. Worn spindle bearings. 3. Drill not installed in chuck properly. 4. Excessive belt tension.	1. Discard drill. 2. Replace bearings. 3. Loosen, re-position, and tighten drill. 4. Readjust belt tension.
Axial play in spindle (vertical movement)	1. Feed stop collar out of adjustment.	1. Readjust feed stop collar (Refer to "SPINDLE PLAY," under "ADJUSTMENTS.")
Cannot remove the chuck.	1. Rust between tapered socket in chuck body and spindle taper.	1. Apply a generous quantity of penetrating oil at top of chuck collar, on threads of spindle chuck collar and allow oil to soak in. Repeat application of penetrating oil and soaking until chuck can be backed off with chuck key. (Refer to figures 8 and 9.) After removal, polish tapered contact surfaces with crocus cloth and oil.

PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL Nos. 113.24540 (Bench Model) and 113.24560 (Floor Model)



PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL Nos. 113.24540 (Bench Model) and 113.24560 (Floor Model)

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN ON THIS LIST:

1. THE PART NUMBER
2. THE PART NAME
3. THE MODEL NUMBER — 113.24540 (Bench Model) — 113.24560 (Floor Model)
4. THE NAME OF ITEM — DRILL PRESS

Always order by Part Number — not by Key Number

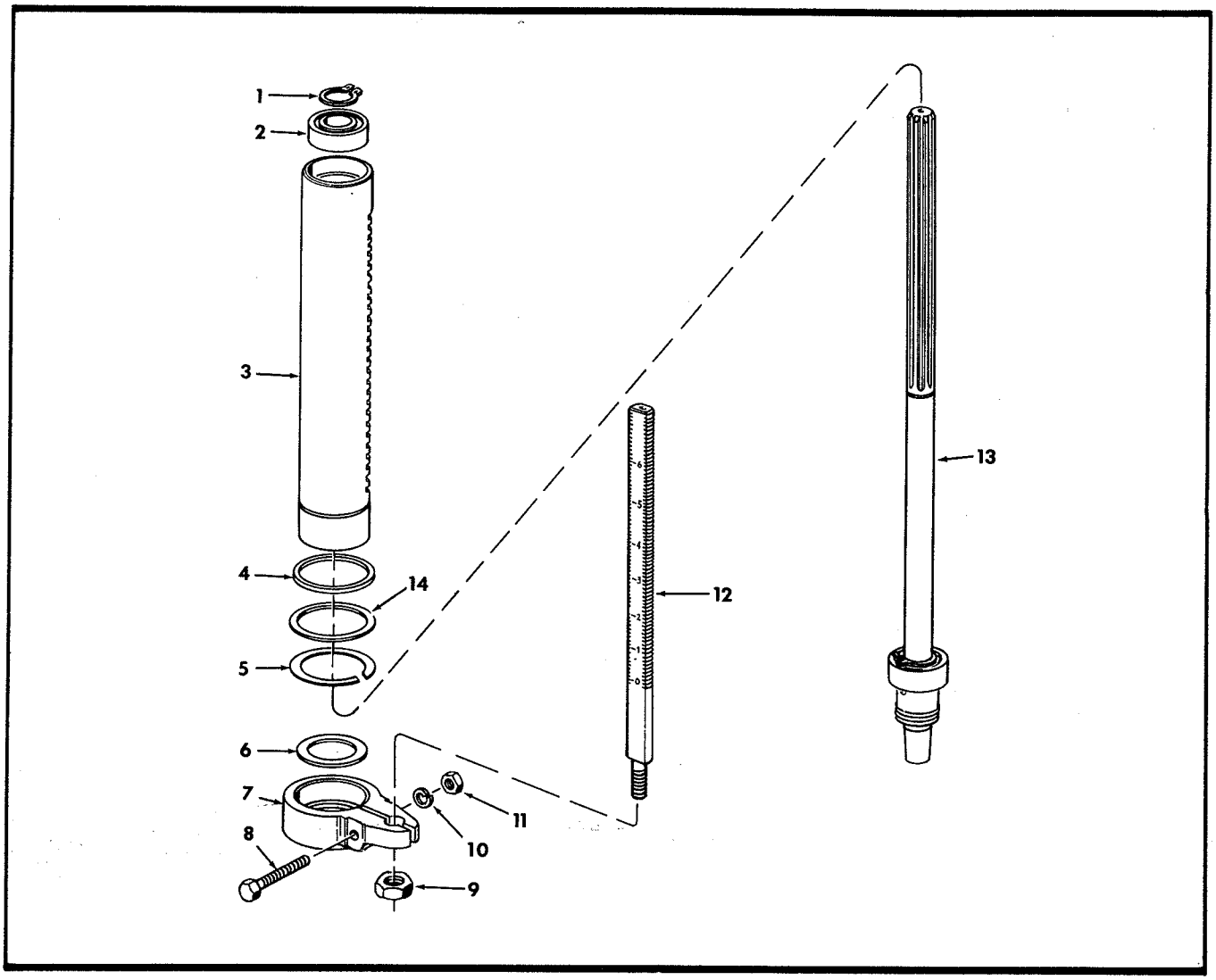
Key No.	Part No.	Description
3	71021	Cap, End
4	71022	Cap, Spindle
6	9413184	Screw, No. 4 x 3/8, Type 25, Pan Hd. Slotted
7	71034	Switch
8	71035	Outlet
10	436691	*Screw, Mach., No. 8-32 x 1/4, Pan Hd. Slotted
11	60172	Belt, "V" Type 1/2 x 45
12	37875	Relief, Strain
13	9404351	Screw, No. 6-32 x 5/16, Type 23, Pan Hd. Slotted
14	71046	Connector, Wire
15	71017	Socket, Bulb
16	71005	Hinge Assembly, Motor Support
17	60044	Ring, Retaining
18	71007	Pin, Motor Mount Hinge
19	37837	†Wrench, Allen 5/32
20	9411963	*Screw, Set, 5/16-18 x 1/2, Soc. Hd. Set
21	38390	Pulley Assembly (w/Set Screw)
22	71033	Washer, Rubber
23	71006	Mounting Assembly, Motor
24	105616	*Nut, Sq. 5/16-18
25	118774	*Washer, Plain 5/16
26	126218	*Bolt, Carriage, 5/16-18 x 3/4, Rd. Hd., Sq. Neck
27	71011	Tip, Belt Adjustment Rod
29	71012	Rod, Belt Adjusting
30	71010	Clamp, Belt Adjusting
31	188030	*Screw, No. 1/4-20 x 1/2 Pan Hd., Slotted
32	436918	*Screw, No. 10-32 x 3/4, Pan Hd., Slotted
33	71004	Frame, Drill Press
34	60163	*Bolt, Hex. Hd., 3/8-16 x 1-1/2
35	38626	Barrel, Lock
36	71050	Collar
37	60164	*Bolt, Hex. Hd., 5/16-18 x 1-1/4
	9-2438	†Collar Assy. (w/Bolts) (Includes key Nos. 36 & 37)
38	30700	Clamp, Capacitor
39	37848	Cord and Plug, Power
40	37568	Adapter, Power Cord and Plug
41	9404387	Screw, No. 10-32 x 5/16, Type 23, Pan Hd., Slotted

Key No.	Part No.	Descripton
42	38631	Lock, Barrel
43	38452	Washer, Fibre
44	27360	Hub Assembly
45	38989	Spring
47	27617	Pin
48	27815	Label
49	18916	Knob
50	27626	Rod
52	27621	Tube, Column (Bench Model)
	27622	Tube, Column (Floor Model)
54	38627	Lock, Barrel
55	38633	Handle, Lock
56	71002	Table
57	110452	*Screw, Set, 1/2-32 x 1-1/2, Square Head
58	38211	Lock
59	71042	Base Assembly (Bench Model)
60	38682	†Chuck (w/Key)
61	38683	†Key, Drill Chuck
62	71047	Spindle Assy., Stop (See Page 12)
64	27631	Collar, Adjustment
65	38881	Spring, Compression
66	27628	Handle, Feed Stop
67	27629	Collar, Feed Stop
68	71008	Trim
69	58712	Pin, Roll
70	38632	Lock, Barrel
71	18512	Screw
73	18120	Handle (w/Set Screw)
74	37836	†Wrench, Allen 3/32
79	27104	Spindle Assembly, Pulley
80	18414	Ring, Retaining
81	18212	Bearing, Ball
82	18413	Sleeve
83	27415	Pulley
85	71016	Plate, Mounting
86	71043	Base Assembly (Floor Model)
87	71053	Guard
88	60174	Nut, Wing
89	71052	Shaft, Pivot
90	71054	Plate, Guard
Not Shown	71031	Assembly and Operating Instructions and Parts List

* Standard Hardware Item — May be Purchased Locally.

† Stock Item — May be secured through the hardware departments of most Sears or Simpsons-Sears Retail Stores or Mail Order Houses.

PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL Nos. 113.24540 (Bench Model) and 113.24560 (Floor Model)



Key No.	Part No.	Descripton
1	30783	Ring, Retaining
2	3509	Bearing, Ball
3	71013	Tube, Quill
4	27813	Gasket, Quill
5	27812	Ring, Retaining
6	71051	Washer
7	38422	Collar, Feed Stop

Key No.	Part No.	Descripton
8	9415802	*Screw, 1/4-20 x 1-1/2, Hex. Hd.
9	118645	*Nut, Hex. Jam, 3/8-16
10	115109	*Washer, Lock, 1/4
11	115120	*Nut, Hex., 1/4-20
12	71014	Rod, Feed Stop
13	71015	Spindle Assembly
14	60176	Washer

* Standard Hardware Item — May be Purchased Locally.