

ASSEMBLY, OPERATING INSTRUCTIONS AND PARTS LIST FOR CRAFTSMAN DRILL PRESS

MODEL NUMBER 113.24630

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 — 113.24630
4. THE NAME OF ITEM — DRILL PRESS

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



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.

**SEARS, ROEBUCK AND CO.-U. S. A.
IN CANADA, SIMPSONS - SEARS LIMITED**



SAFETY RULES FOR POWER TOOLS

1. KNOW YOUR POWER TOOL

Read owner's manual carefully. Learn its applications and limitations as well as the specific potential hazards peculiar to this tool.

2. GROUND ALL TOOLS—UNLESS DOUBLE-INSULATED

If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If adapter is used to accommodate two-prong receptacle, the adapter wire must be attached to a *known ground*. Never remove third prong.

3. KEEP GUARDS IN PLACE

and in working order.

4. KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents.

5. AVOID DANGEROUS ENVIRONMENT

Don't use power tool in damp or wet locations, and keep work area well lit.

6. KEEP CHILDREN AWAY

All visitors should be kept safe distance from work area.

7. STORE IDLE TOOLS

When not in use, tools should be stored in dry, high or locked-up place — out of reach of children.

8. DON'T FORCE TOOL

It will do the job better and safer at the rate for which it was designed.

9. USE RIGHT TOOL

Don't force small tool or attachment to do the job of a heavy duty tool.

10. WEAR PROPER APPAREL

No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.

11. USE SAFETY GLASSES

with most tools. Also face or dust mask if cutting operation is dusty.

12. DON'T ABUSE CORD

Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.

13. SECURE WORK

Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.

14. DON'T OVERREACH

Keep proper footing and balance at all times.

15. MAINTAIN TOOLS WITH CARE

Keep tools sharp at all times, and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. DISCONNECT TOOLS

When not in use, before servicing; when changing accessories such as blades, bits, cutters, etc.

17. REMOVE ADJUSTING KEYS AND WRENCHES

Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

18. AVOID ACCIDENTAL STARTING

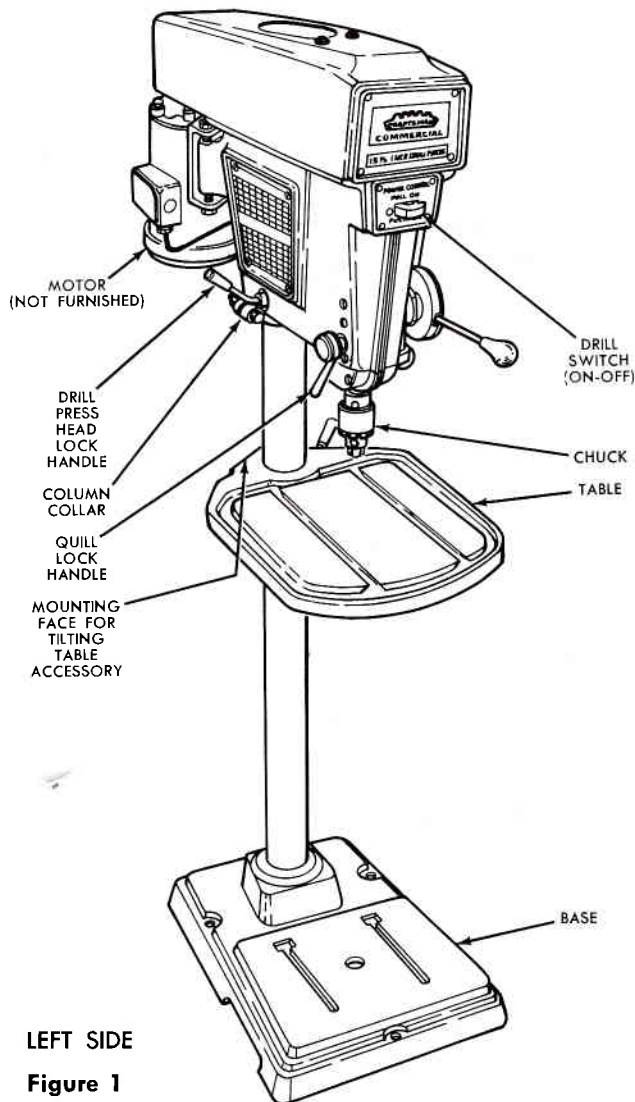
Don't carry plugged-in tool with finger on switch.



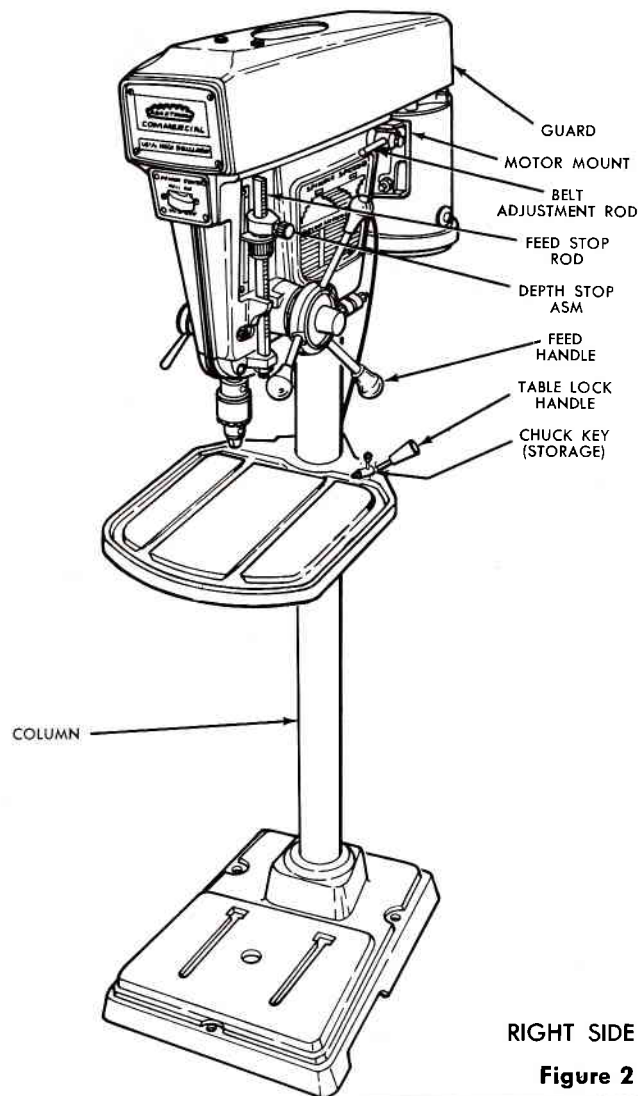
Copyright, 1969, by Power Tool Institute, Inc. All Rights Reserved.

The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear safety glasses or eye shields before commencing power tool operation. We recommend **Wide Vision Safety Mask** for use over spectacles, or standard safety glasses . . . available at Sears retail or catalog stores.

ASSEMBLY AND OPERATING INSTRUCTIONS FOR CRAFTSMAN DRILL PRESS MODEL NUMBER 113.24630



LEFT SIDE
Figure 1



RIGHT SIDE
Figure 2

UNPACKING AND CHECKING CONTENTS

In order to facilitate packaging, certain items are not attached at the factory and must be assembled 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 (listed below) have been removed. The following parts are not assembled to the drill press.

QUANTITY	ITEM
1	Belt, V
3	Rod (Feed Handle)
3	Knob (Feed Handle)
1	Pulley, Motor (w/Set Screw)
1	Chuck, Drill
1	Mount, Motor
1	Bag of Miscellaneous Small Parts Consisting of the Following:
1	Key, Drill Chuck
1	Hex-L Wrench (5/32)
1	Hex-L Wrench (3/32)
1	Hex-L Wrench (1/4)
2	Screw, Set (Cone Pt. 5/16-18 x 1-1/4)
4	Bolt (5/16-18 x 1)
4	Washer (11/32 x 11/16 x 1/16)
6	Nut, Hex (5/16-18 x 1/2 x 3/16)

MOTOR REQUIREMENTS

The drill press is designed to perform its best work when driven with a 3/4 horsepower, 1725 RPM, ball bearing motor (rotation clockwise pulley end). The drill press is assembled at the factory for use with a 115 volt electric supply. Check power source to confirm line voltage, cycles and phase are the same as stated on motor name plate.

ASSEMBLY

CAUTION

Make sure the unit is not plugged in during assembly.

1. Hold the drill press head securely, loosen the drill press head lock handle (figure 1) and slide the head upward on column to a convenient working position. Tighten the drill press lock handle. Remove all Packaging material.
2. Move column collar up and tighten nuts.
3. Hold the table securely, loosen the table lock handle (figure 2) and raise the table to a position approximately eight inches below the drill press head. Tighten the table lock handle.
4. Assemble feed handles (screw 3 knobs and rods together). Screw the three feed handles (figure 2) into the tapped holes in the hub assembly. Hand tighten feed handle rods.

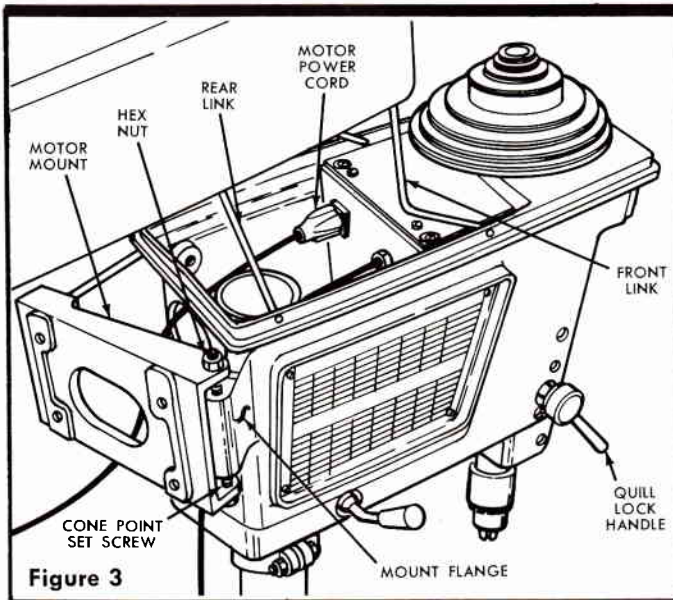


Figure 3

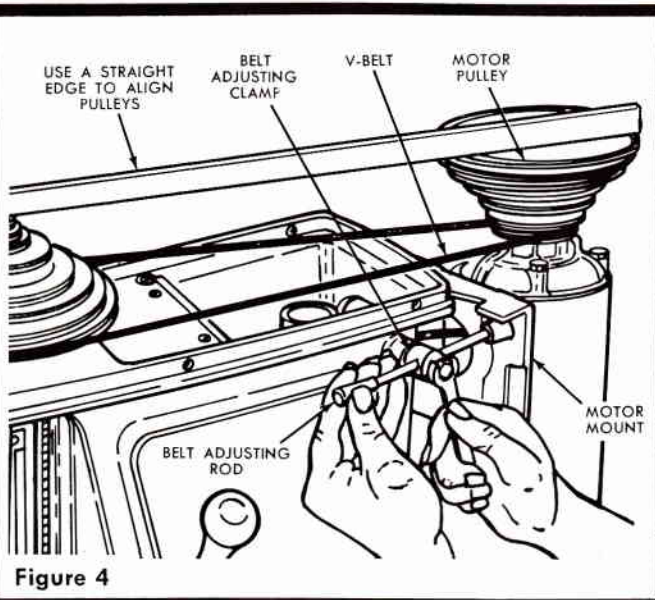


Figure 4

5. The depth scale is factory mounted and may need adjustment.
 - a. Move quill down until depth stop bottoms.
 - b. While holding firm downward pressure on feed handle, lock the quill with quill lock handle (see figure 3).
 - c. If the top surface of the depth pointer is not aligned with the zero graduation, loosen depth scale mounting screws and re-position scale.
 - d. Unlock quill lock handle.

MOTOR INSTALLATION

1. Remove guard assembly by depressing forward and rear links till they clear the holes in the drill press head (see figure 3).
2. To install motor, screw cone point set screws part way into holes on the motor mount assembly (see figure 3).
3. Align cone point set screws with holes on the mount flange at rear of drill press head (see figure 3). Using 5/32 hex wrench, tighten cone point set screws one at a time until motor mount is centered on mount flange.
4. Start hex nuts on both set screws. Tighten only the upper one.
5. Loosen bottom cone point set screw only and remove the motor mount from the drill press head.
6. Fasten the motor to the motor mount assembly with the 5/16-18 x 7/8 bolts, 11/32 x 11/16 x 1/16 washers and 5/16-18 x 1/2 x 3/16 nuts supplied. Make sure that the motor rotation (pulley end) is clockwise.
7. Install the assembly of the motor and motor mount to the drill press head by inserting the top cone point set screw on motor mount into the top hole on the mount flange. Tighten the lower cone point set screw until all vertical movement of motor mount assembly is removed, but motor will swing in horizontal plane. Tighten hex nut on lower cone point set screw.
8. Mount motor pulley on motor shaft so that small diameter is at the bottom (see figure 4), align the motor pulley vertically with the spindle pulley and tighten the pulley set screw. If motor shaft has a "flat", position the pulley so that pulley set screw tightens against the "flat".

9. Loosen screw on belt adjusting clamp (see figure 4). Place the V-Belt around the lower pulley grooves (see figure 4) and take up the slack by pivoting the motor mount away from the drill press head. Hold the motor mount in this position, slide the belt adjusting rod until its tip contacts the motor mount and tighten screw on belt adjusting clamp.
10. Adjust V-Belt tension. Refer to "BELT TENSION" under ADJUSTMENTS" (see figure 13).

CAUTION: For proper operation the improved V-Belt "MUST" be properly adjusted.
11. Replace guard after properly adjusting belt tension (see figure 3).
12. Connect the motor power cord to the outlet on the electric support assembly (see figure 3).

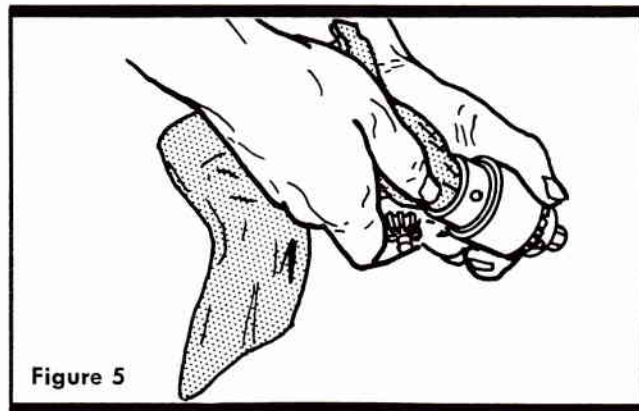


Figure 5

CHUCK INSTALLATION

1. Clean the spindle taper and tapered socket in chuck body with a clean cloth (see figure 5). Make sure no foreign particles are left on these tapered surfaces which would prevent proper seating of the parts.
2. Apply a light film of oil on spindle taper and place chuck on end of spindle (see figure 6). Screw the chuck collar onto the threaded portion on end of spindle. Hold spindle pulley with one hand to prevent spindle from rotating and tighten chuck collar with drill chuck key (see figure 7).

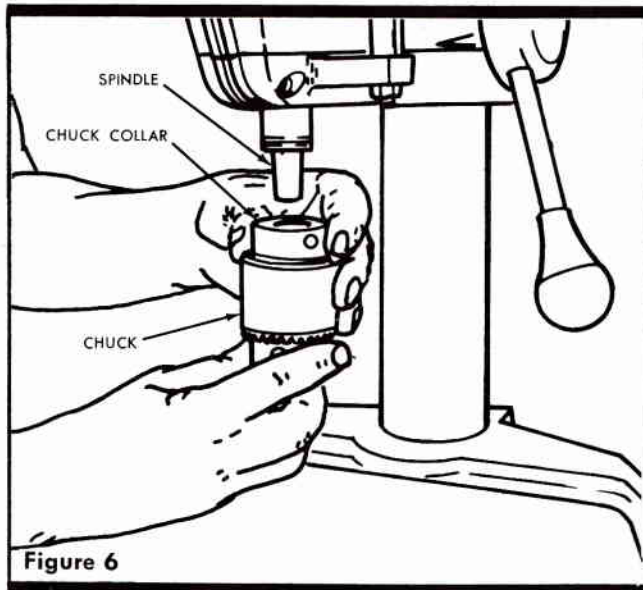


Figure 6

CHUCK REMOVAL

When removal of the chuck is required, make sure the power cord is disconnected. Prevent rotation of spindle by holding the spindle pulley, and loosen chuck locking collar with the end of the chuck key (see figure 7). 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 bearing or both.

DRILL PRESS INSTALLATION

Three 13/32-inch diameter holes have been provided in the base of the unit, through which bolts or screws may be inserted to secure the drill press to the floor. If the drill press rocks due to an uneven floor, shim the base with steel washers at the mounting holes before bolting down to the floor. Connect the drill press power cord to a grounded 115 volt receptacle only.

OPERATION

CONTROLS

- 1. Chuck.** The key-type chuck has a maximum capacity of a 1/2-inch diameter. For holes larger than 1/2-inch reduced shank drills must be used. The chuck is equipped with a lock collar to retain it on the spindle when using tools that develop side thrust while in operation, such as routers, molding cutters, etc.
- 2. Switch.** The motor is controlled by a safety switch (pull on; push off), located on the front of the drill press head (see figure 9).

NOTE: If the motor is equipped with an "ON-OFF" switch it can be left "ON" and the drill press operated by the "ON-OFF" safety switch on the drill press.

- 3. Spindle Speeds.** Eight spindle speeds are available by moving the V-Belt from one pulley groove to another (see figure 10). These eight spindle speeds have been found adequate for all normal operations using common materials. To change the spindle speed refer to step 3 "BELT ADJUSTING ROD". Refer to the R.H. trim panel for the recommended spindle speed step for drill diameter and material. This chart is based on using the recommended 1725 RPM motor.

NOTE: To determine spindle speeds for other motor speeds multiply the diameter of the motor pulley by the motor speed and divide by the diameter of the spindle pulley.

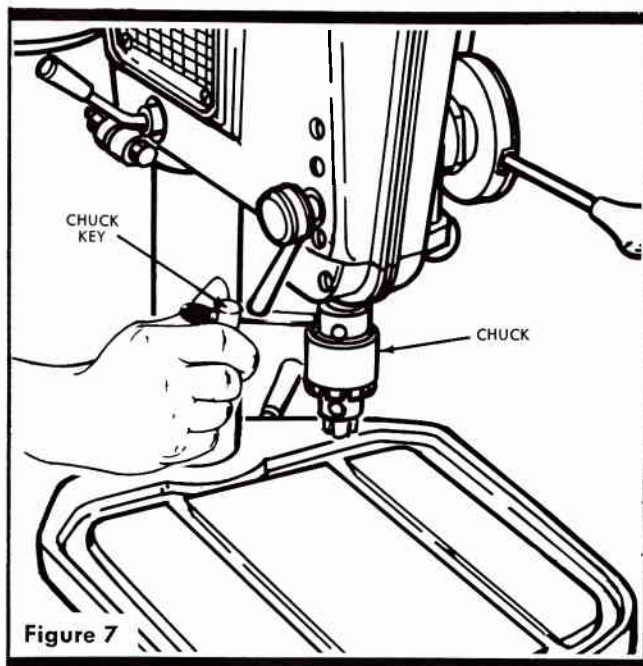


Figure 7

CAUTION: The motor speed should never exceed 1800 RPM with any motor. If a variable speed motor or other similar device is used make certain that at no time is the motor speed allowed to exceed 1800 RPM.

4. Belt Adjusting Rod: The belt adjusting rod will allow quick and easy change of spindle speeds.

- Push motor mount (A figure 10) back.
- Lift up on belt adjusting rod (B figure 10) release motor mount.
- Slide belt to desired groove.
- Push motor mount (A) back and re-position belt adjusting rod.

5. Feed Handle. The feed handle is used to raise and lower the quill a total distance of four inches (see Figure 9). If the feed return fails to return quill to the top of the stroke, refer to "Adjustments", "Automatic Feed Return" on page 8.

6. Depth Stop Assembly. The depth stop assembly provides a means of pre-setting hole depths before drilling and for drilling several holes to the same depth (see figure 9). The depth stop has both a quick coarse adjustment and a fine adjustment. It can be moved on the feed stop rod for fast positioning by loosening the depth stop screw and sliding it up or down to the approximate desired position (see figure 9). Fine adjustment can be made by rotating the adjustment collar (see figure 9). The following steps should be followed for adjusting depth stop assembly.

- Position depth stop assembly near top of feed stop rod.
- Install drill in chuck and position work on table.
- Lower quill until tip of drill contracts top surface of work piece and tighten quill lock handle (see figure 9).
- Loosen depth stop screw, move the depth stop so the pointer is approximately at the desired depth reading on depth scale and retighten depth stop screw.
- Final fine adjustment can be made by rotating adjustment collar (see figure 9). Each quarter turn is equal to 1/64-inch, each full turn is equal to 1/16-inch.
- Loosen quill lock handle.

7. Quill Lock Handle: The quill lock handle (when tightened) holds the quill at any depth of cut for such operations as shaping, routing, surface grinding, etc. (see figure 9). Always release the quill lock before attempting to raise or lower the quill.

8. Table Lock Handle and Drill Press Head Lock Handle. The table lock handle and drill press head lock handle control the barrel locks which grip the column. When they are loose you can both swivel and raise or lower the head or the table. Both the head and table will swivel 360°. Do not swivel head and table unless drill press is securely bolted to floor.

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.

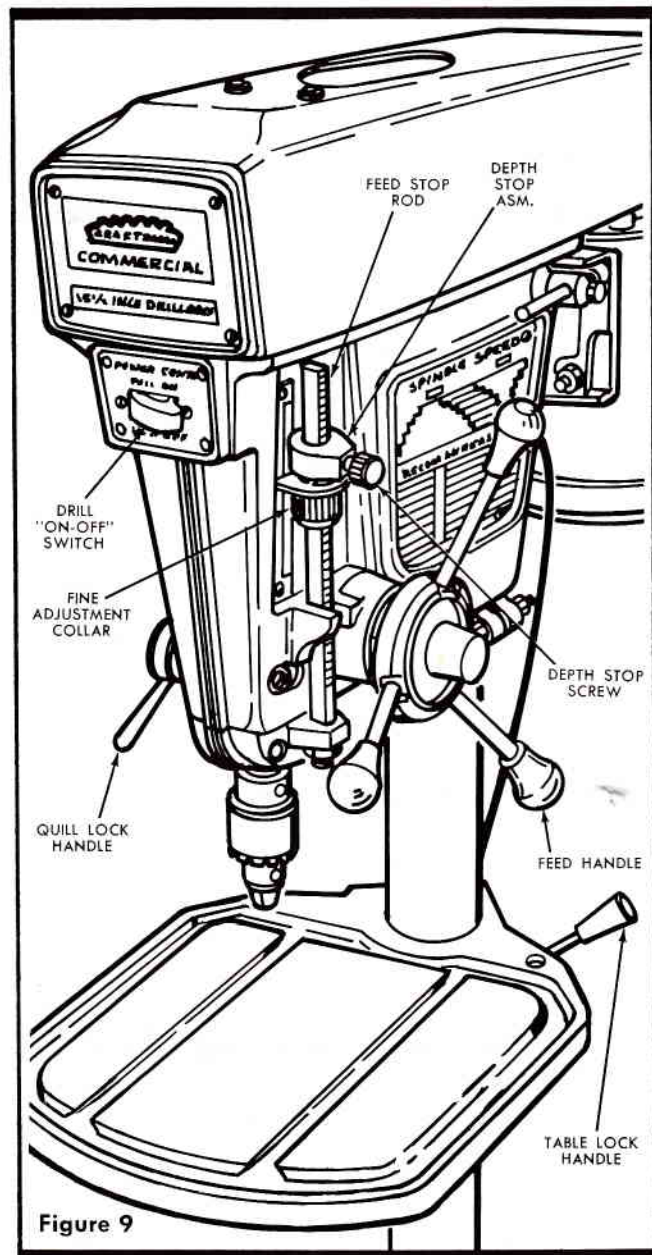


Figure 9

9. Column Collar. This is a two-piece collar for clamping to the column. It should be located under the drill press head to keep it from sliding down accidentally when the drill press head lock handle is loosened (see figure 1).

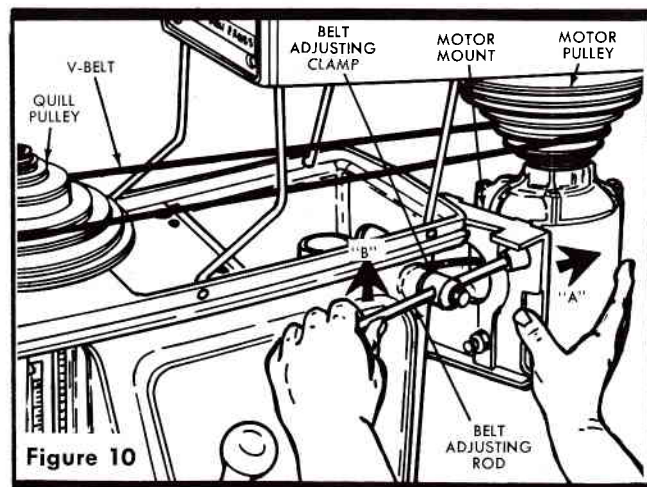


Figure 10

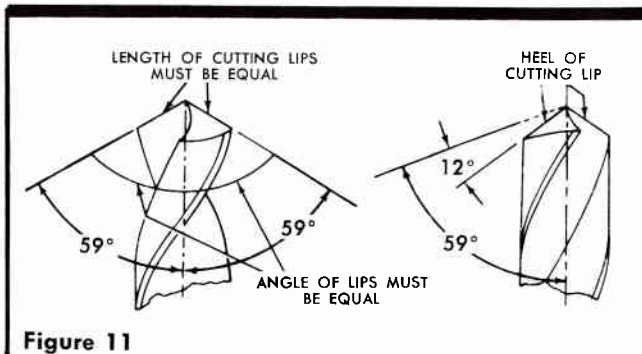


Figure 11

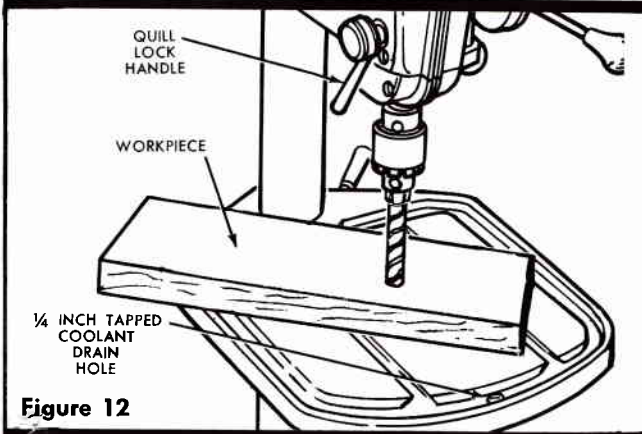


Figure 12

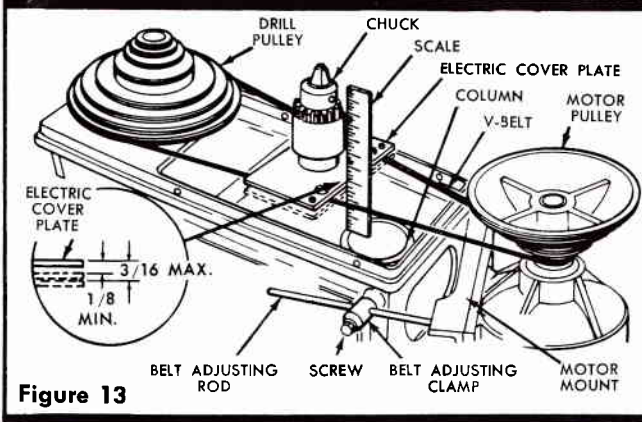


Figure 13

OPERATING HINTS

1. Drill Sharpening. (See figure 11). 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.

2. TABLE

A. Provision has been made in front of the table for a 1/4-inch pipe fitting for a coolant drain (see figure 12). Coolant supply system is not furnished.

B. If coolant is not to be used a center clearance hole can be drilled in the table. If later operation with coolant is required the center hole can be drilled and tapped for a 3/4" pipe plug to reseal the hole.

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

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

5. 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 12). If a workpiece is too short to reach the column, clamp it to the table or use a drill vise which should be clamped or bolted to table. Reduce rate of feed when drill starts to break through metal workpiece to prevent "grabbing" by the drill.

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

ADJUSTMENTS

BELT TENSION

Loosen screw on belt adjusting clamp (See figure 13). Position motor mount until V-belt is taut. Hold motor mount at this position, slide belt adjusting rod against mount and tighten screw on belt adjusting clamp.

CAUTION: This belt is an improvement over the traditional V-belt but it requires much greater tension. To get the best performance the following steps must be used for correct tensioning:

1. Remove chuck, guard and electrical cover plate.
NOTE: Set the belt for the slowest speed.
2. Place cover plate across belt as shown.
3. Measure the distance between the top of the column tube and edge of the cover plate as shown.
4. Put the chuck on the cover plate and re-measure the distance between top of the column tube and edge of the cover plate.
5. Adjust Tension rod until the difference between the two measurements is approximately 1/8 to 3/16. The belt will then have the correct tension.

NOTE: Excessive belt tension will produce bearing noise and rapid bearing wear.

PULLEY SET-SCREW

Tighten motor pulley set-screw after a few hours of drill press operation.

TABLE AND DRILL PRESS HEAD LOCK HANDLES

(See figures 1 and 2.)

To change the locked position of table lock handle or drill press head lock handle, unscrew the handle from barrel lock and rotate barrel lock 180°. Re-insert the lock and tighten lock handle (See figure 14).

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

QUILL LOCK HANDLE

This handle can be adjusted by loosening the set screw with a 3/32 hex-L wrench and rotating to any desired position (see figure 14).

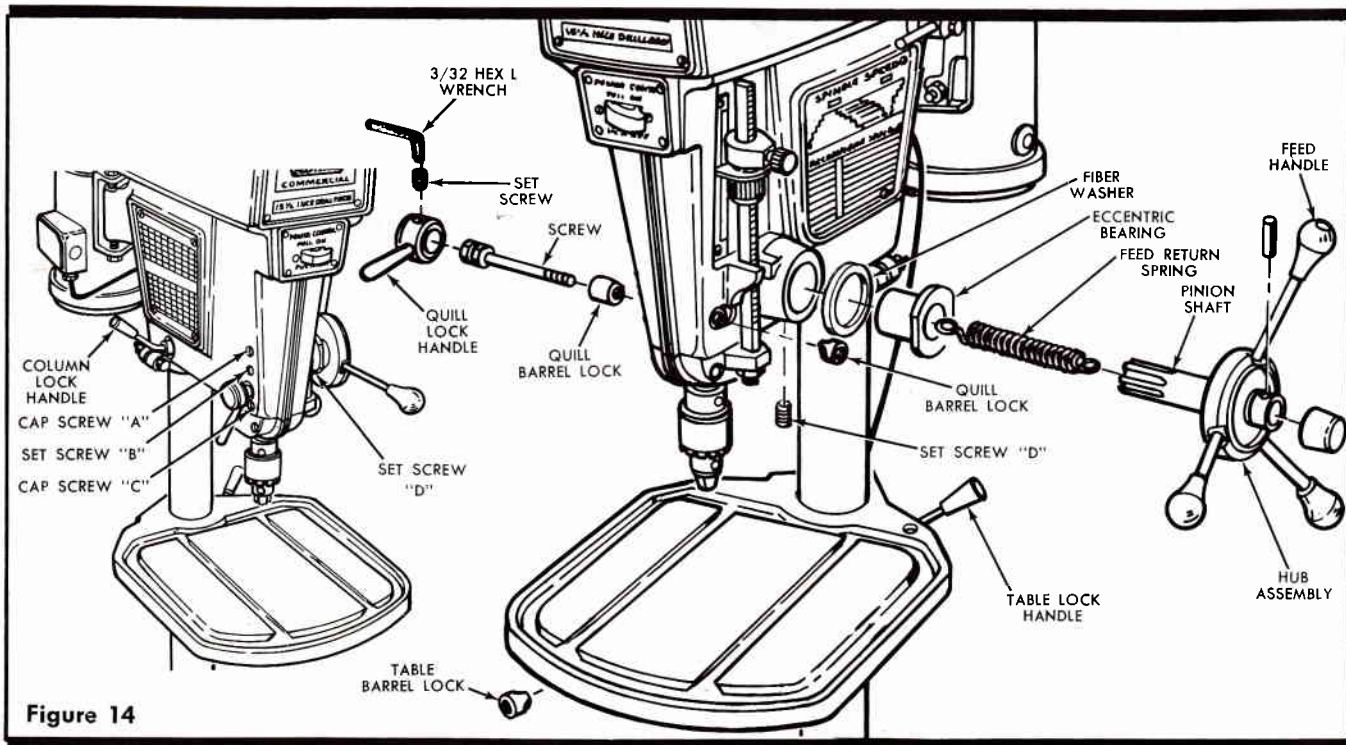


Figure 14

NOTE: The quill bearing, pinion backlash and feed return have been adjusted at the factory. The following adjustment should only be required to take up wear after long usage.

QUILL BEARING ADJUSTMENT (see figure 14).

1. Lock quill lock handle.
2. Loosen eccentric bearing set screw (D figure 14) using a 5/32 hex L wrench.
3. Turn eccentric bearing (with channel lock type wrench), until pinion has considerable backlash.
4. Loosen quill lock handle.
5. Loosen the two cap screws (A&C figure 14), using a 1/4 hex L wrench.
6. Loosen the set screw (B figure 14) using a 5/32 hex L wrench. Adjust by using either sequence "A" if quill is tight or "B" if quill is loose.
 - A. If quill is tight:
 1. Turn set screw (B) clockwise until quill is free to move up and down.
 2. Tighten cap screw (A) until quill is locked, back-off until quill is free.
 3. Tighten cap screw (C) until quill is locked, back-off until quill is free.
 4. Re-adjust pinion backlash.
 - B. If quill is loose.
 1. Turn cap screw (A) until quill is tight and back-off until quill is free.
 2. Turn setscrew (B) until it has seated (not too tight).
 3. Turn cap screw (C) until quill is tight and back-off until quill is free.
 4. Retighten cap screw (A) until quill is tight and back-off until quill is free.
 5. Retighten cap screw (C) until quill is tight and back-off until quill is free.
 6. Re-adjust pinion backlash.

PINION BACKLASH ADJUSTMENT

Lock spindle with quill lock handle and loosen set screw (D figure 14). Using a channel lock type wrench turn eccentric bearing one way or the other until it binds then back-off until it is free and has minimum backlash throughout the full length of the quill travel (or stroke). Retighten set screw (D). Do not overtighten. Overtightening may lock pinion shaft.

AUTOMATIC FEED RETURN

After proper adjustment of quill bearing and pinion backlash if the automatic feed return fails to return the quill to the top of the stroke, or if the action is sluggish, the feed return may be adjusted as follows: (See Figure 14).

1. Lock the quill at the top of its stroke with quill lock handle.
2. Grasp hub assembly, pull straight out until the feed assembly is free to turn. Then turn handles counter-clockwise approximately one-half turn and re-engage the pinion shaft.
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. Also grease splined portion of spindle.
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.
4. In order to maintain smooth operation of pinion, pull pinion shaft (Figure 14) out and lubricate occasionally with cup grease.

POWER TOOL GUARANTEE

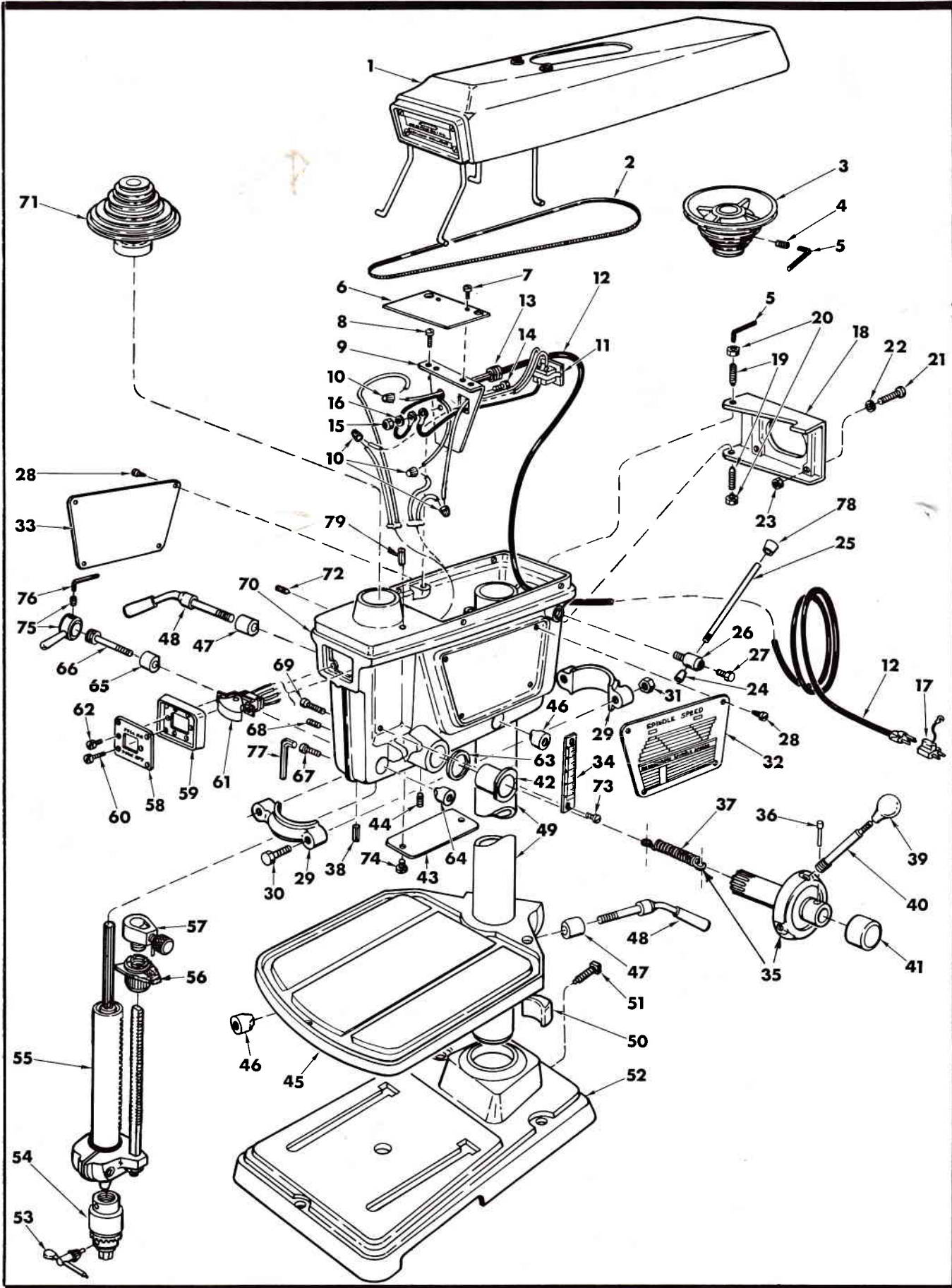
During the first year, we will repair your Craftsman Drill Press free of charge, if defective in material or workmanship.

This guarantee service is available by simply returning the Drill Press to any Sears Store throughout the United States.

TROUBLE SHOOTING CHART

TROUBLE	PROBABLE CAUSE	REMEDY
Noisy operation.	<ol style="list-style-type: none"> 1. Improper belt tension. 2. Improper quill adjustment. 3. Improper pinion backlash adjustment. 4. Dry spindle. 5. Noisy motor. 	<ol style="list-style-type: none"> 1. Adjust belt tension 2. Adjust quill. 3. Adjust backlash. 4. Lubricate spindle with STP motor oil crankcase additive or equivalent. 5. Check motor bearings.
Drill or cutting tool used heats up or work burns.	<ol style="list-style-type: none"> 1. Excessive speed. 2. Chips not clearing. 3. Drill or cutting tool is dull. 4. Too slow a feed. 5. Rotation of drill incorrect. 	<ol style="list-style-type: none"> 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. 5. Reverse motor rotation (correct motor rotation-clockwise when viewing from top of drill press).
Drill leads off.	<ol style="list-style-type: none"> 1. No drill spot. 2. Cutting lip lengths and/or angles not equal. 	<ol style="list-style-type: none"> 1. Center punch work piece. 2. Grind to proper length and angle.
Wood splinters on break through.	<ol style="list-style-type: none"> 1. Lack of support. 	<ol style="list-style-type: none"> 1. Use scrap block under work piece.
Work torn from hands.	<ol style="list-style-type: none"> 1. Failure to follow proper procedure. 	<ol style="list-style-type: none"> 1. Clamp work to table or use drill vise clamped or bolted to table for metal items. 2. Support wood or metal against left side of column whenever possible.
Drill binds in work.	<ol style="list-style-type: none"> 1. Work piece pinching drill. 2. Excessive feed pressure. 3. Improper belt tension 	<ol style="list-style-type: none"> 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. 3. Adjust belt tension
Drill overheats when mortising.	<ol style="list-style-type: none"> 1. Improper set-up. 2. Improper drill speed. 3. Dull chisel and/or bit. 	<ol style="list-style-type: none"> 1. Provide proper amount of chip clearance — must be at least 1/64-inch between chisel and back side of end of bit. 2. Position belt to attain proper operating speed. 3. Sharpen.
Chatter and rough cutting action when routing.	<ol style="list-style-type: none"> 1. Spindle speed too slow. 2. Vibration. 3. Excessive depth of cut. 	<ol style="list-style-type: none"> 1. Higher spindle speeds produce smoother cuts. 2. Work must be held firmly throughout pass; use the column as back-up or hold-downs when possible. 3. Full depth of cut should be produced by making successive passes.
Drill overheats when drilling iron or steel.	<ol style="list-style-type: none"> 1. Failure to use cutting oil. 2. Too slow a feed. 3. Too slow or too fast a spindle speed. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. Bent drill. 2. Worn spindle bearings. 3. Drill not installed in chuck properly. 4. Chuck not installed properly on spindle. 	<ol style="list-style-type: none"> 1. Discard drill. 2. Replace bearings. 3. Loosen, re-position, and tighten chuck. 4. Reinstall chuck (refer to Chuck Installation under "Assembly").
Cannot remove the chuck.	<ol style="list-style-type: none"> 1. Rust between tapered socket in chuck body and spindle taper. 	<ol style="list-style-type: none"> 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. After removal, polish tapered contact surfaces with crocus cloth and oil.

PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL No. 113.24630



**PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL No. 113.24630**

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN PARTS LIST: 1. THE PART NUMBER 3. THE MODEL NUMBER — 113.24630
2. THE PART NAME 4. THE NAME OF ITEM — DRILL PRESS

Always order by Part Number — not by Key Number

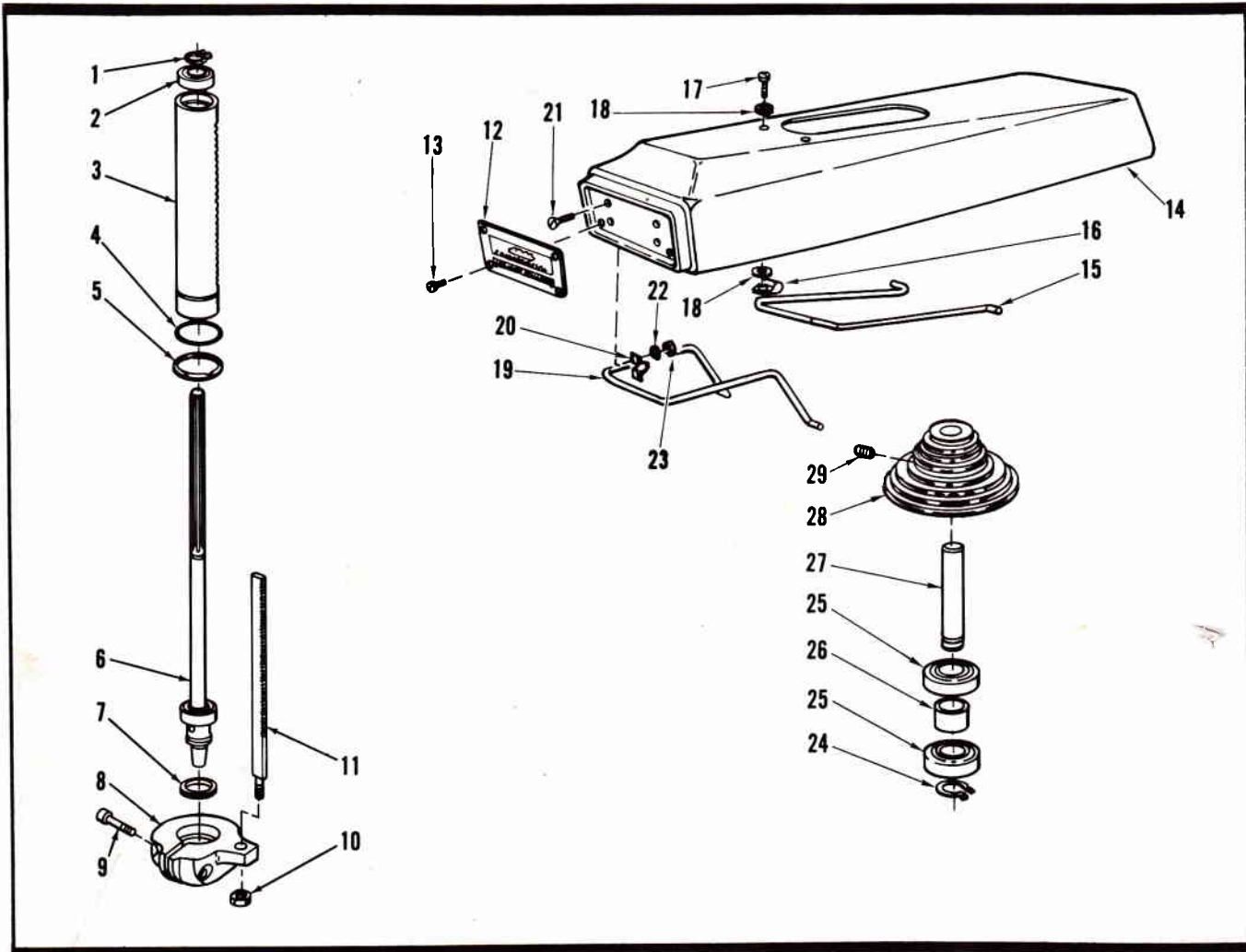
Key No.	Part No.	DESCRIPTION
1	None	Guard ASM (See Page 12)
2	71064	Belt, V
3	71065	Pulley, Motor
4	9411963	*Screw, Hex. Soc. 5/16-18 x 1/2 Cup Pt. Set
5	60096	†Wrench, Hex. "L" 5/32
6	71092	Plate, Rear Cover
7	457516	Screw, Type A, Pan No. 8 x 1/4
8	448003	*Screw, Ty. 23 Sl. 6-32 x 3/8
9	71087	Bracket
10	71046	*Connector, Wire
11	69027	Outlet Asm.
12	69026	Cord Asm.
13	37818	Relief Strain
14	443507	*Screw, M Pan Hd. 1/4-20 x 1/2
15	115120	*Nut, Hex. 1/4-20 x 7/16 x 3/16
16	138167	*Lockwasher 1/4 Int. Tooth
17	37568	Adapter, Power Cord and Plug
18	71067	Motor, Mount
19	139377	Screw, Set Cone Pt. 5/16-18 x 1-1/4
20	124824	*Nut, Hex., 5/16-18 x 1/2 x 3/16
21	60025	* *Bolt 5/16-18 x 1
22	118774	*Washer 11/32 x 11/16 x 1/16
23	124824	*Nut, Hex. 5/16-18 x 1/2 x 3/16
24	71103	Knob, Rod Belt Adj.
25	71104	Rod, Belt Adj.
26	71010	Clamp, Belt Adj.
27	443507	*Screw, Hex., Hd. 1/4-20 x 1/2
28	145372	*Screw, Ty. U Rd. Hd. 4 x 1/4
29	71105	Collar, Column
30	60196	*Screw, M Hex. Hd. 5/16-18 x 3
31	124824	*Nut, Hex. 5/16-18 x 1/2 x 3/16
32	71106	Panel, R.H. Trim
33	71107	Panel, L.H. Trim
34	71098	Scale, Depth
35	71108	Hub Assembly (Includes Key No. 37)
36	60197	Pin, Roll
37	71109	Spring
38	60193	Pin, Roll
39	18916	Knob
40	27626	Rod
41	71110	Cap, Spring Retaining

Key No.	Part No.	DESCRIPTION
42	71111	Bearing, Eccentric
43	71112	Plate, Cover
44	138666	*Screw, Hex. Soc. 5/16-18 x 5/16
45	71113	Table
46	38626	Lock, Barrel
47	38627	Lock, Barrel
48	60059	Handle, Lock
49	27622	Tube, Column
50	38211	Lock, Tube
51	110452	*Screw, Sq. Hd. Set 1/2-13 x 1-1/2
52	71114	Base
53	38683	†Key, Drill Chuck
54	38623	†Chuck, Drill
55	71115	Spindle Asm. (See Page 12)
56	71116	Indicator Asm.
57	71117	Gage Asm., Depth
58	71118	Cover, Plate, Switch
59	71119	Plate, Switch Mtg.
60	448005	*Screw, Ty. 23 Fl. Sl. 6-32 x 1/2
61	71134	Switch
62	448003	*Screw, Ty. 23 Pan Slot 6-32 x 3/8
63	71130	Washer, Fiber
64	38631	Lock, Barrel
65	38632	Lock, Barrel
66	18512	Screw
67	60053	*Screw, Hex. Soc. Hd. Cap 5/16-18 x 1-1/2
68	139376	*Screw, Cone Pt. Set 5/16-18 x 1
69	138225	*Screw, Hex. Soc. Hd. Cap 5/16-18 x 1-3/4
70	71121	Head, Drill Press
71	71097	Pulley Assembly (See Page 12)
72	139376	Screw, Set Hex. Soc. Cone Pt. 5/16-18 x 1
73	448001	*Screw, Ty. 23 6-32 x 1/4
74	448033	*Screw, 10-32 x 3/8
75	18120	Handle (w/set Screw)
76	37836	†Hex-L Wrench (3/32 Inch)
77	30505	†Hex-L Wrench (1/4 Inch)
78	71063	Tip, Belt Adj. Rod
79	273336	Pin, Roll
Not Shown	71132	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 Catalog Order Houses.

**PARTS LIST FOR CRAFTSMAN DRILL PRESS
MODEL No. 113.24630**



Key No.	Part No.	DESCRIPTION
—	71115	Spindle Asm.
1	60198	Ring, Retaining
2	71127	Bearing, Ball
3	71123	Tube, Quill
4	60199	Gasket, Quill
5	60200	Ring, Retaining
6	71122	Spindle Asm.
7	71126	Nut, Spindle Bearing
8	71124	Collar, Stop
9	138222	Bolt, Cap 5/16-18 x 1
10	118645	Nut, Hex. Jam 3/8-16 9/16 x 7/32
11	71125	Rod, Depth Stop
12	71128	Panel, Guard Front
13	60049	*Screw, Type 23 Pan, 4-40 x 3/16
14	71129	Guard
15	71070	Link, Rear

Key No.	Part No.	DESCRIPTION
16	71071	Clamp
17	145205	*Screw, Pan Type B No. 8 x 3/4
18	60158	*Washer, St. L. 13/64 x 9/16 x 3/64
19	71072	Link, Front
20	71073	Clamp
21	119264	*Screw, M. Fl. Hd. 10-32 x 1/2
22	120217	*Washer, Lock 10 x .062 x .047
23	115999	*Nut, Hex. Hd., 10-32 x 3/8 x 1/8
24	18414	Ring, Retaining
25	30571	Bearing, Ball
26	71091	Spacer
27	71090	Insert, Pulley
28	71089	Pulley Spindle
29	60192	Screw Nylok Set 5/16-18 x 1/2

*Standard Hardware Item — May be Purchased Locally.

IMPORTANT

THIS BELT IS AN IMPROVEMENT OVER THE TRADITIONAL V-BELT BUT IT REQUIRES MUCH GREATER TENSION. TO GET THE BEST PERFORMANCE THE FOLLOWING STEPS MUST BE USED FOR CORRECT TENSIONING.

1. Remove chuck, guard and electrical cover plate.

NOTE: Set the belt for the slowest speed.

2. Place cover plate across belt as shown on back.

3. Measure the distance between the top of the column tube and edge of the cover plate as shown on back.

4. Put the chuck on the cover plate and re-measure the distance between top of the column tube and edge of the cover plate.

5. Adjust Tension rod until the difference between the two measurements is approximate $1/8$ to $3/16$. The belt will then have the correct tension.

NOTE: For additional details see BELT TENSION in manual

