

Please read and save these instructions. Read through this owner's manual carefully before using product. Protect yourself and others by observing all safety information, warnings, and cautions. Failure to comply with instructions could result in personal injury and/or damage to product or property. Please retain instructions for future reference.



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

FOR CUSTOMER SERVICE

Technical Question?

CALL 1-866-458-2472
customerservice@oem-tools.com

UNPACKING

After unpacking the unit, inspect carefully for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. If any damage is observed, a shipping damage claim must be filed with the carrier. DO NOT use the OEMTOOLS™ 24992 15" 16-Speed Heavy Duty Floor Drill Press if broken, bent, cracked or damaged parts (including labels) are noted. Any Drill Press that appears damaged in any way, operates abnormally or is missing parts should be removed from service immediately. If you suspect that the Drill Press was subjected to shock load (a load that was dropped suddenly, unexpectedly, etc.), immediately discontinue use until it has been checked by a factory authorized service center.



⚠ WARNING

The following safety information is provided as a guideline to help you operate your 15" 16-Speed Heavy Duty Floor Drill Press under the safest possible conditions. Any tool or piece of equipment can be potentially dangerous to use when safety or safe handling instructions are not known or not followed. The following safety instructions are to provide the user with the information necessary for safe use and operation. Please read and retain these instructions for the continued safe use of your 15" 16-Speed Heavy Duty Floor Drill Press. Failure to follow instructions listed below may result in serious injury. In addition, make sure that anyone who uses the equipment understands and follows these safety instructions as well.

Explanation of Safety Signal Words

⚠ WARNING: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION: Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTES: Provide clarity and helpful information.

Thank you very much for choosing an OEMTOOLS™ Product!

For future reference, please register your new tool at www.oem-tools.com and complete the owner's record below:

Model: _____ Purchase Date: _____

Save the receipt, warranty and these instructions. It is important that you read the entire manual to become familiar with this product before you begin using it. This product is designed for certain applications only. OEMTOOLS™ cannot be responsible for issues arising from modification. We strongly recommend that this product is not modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the product until you have first contacted customer service to determine if it can or should be performed on the product.



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

! IMPORTANT INSTRUCTIONS AND SAFETY RULES

1. Know your product. Read this manual carefully. Learn the product's applications and limitations, as well as potential hazards specific to it.
2. Keep work area clean and well lit. Cluttered or dark work areas invite accidents.
3. Keep children away. All children should be kept away from the work area. Never let a child handle this product without strict adult supervision.
4. DO NOT operate this product if under the influence of alcohol or drugs. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, DO NOT attempt to operate.
5. Use safety equipment. Eye protection should be worn at all times when operating this product. Use ANSI approved safety glasses. Everyday eyeglasses are NOT safety glasses. Dust mask, non-skid safety shoes, hard hat or hearing protection should be used in appropriate conditions.
6. Wear proper apparel. Loose clothing, gloves, neck-ties, rings, bracelets or other jewelry may present a potential hazard when operating this product. Keep all apparel clear of the product.
7. DO NOT overreach. Keep proper footing and balance at all times when operating this product.
8. Check for damage. Check your product regularly. If part of the product is damaged, it should be carefully inspected to make sure that it can perform its intended function correctly. If in doubt, the part should be repaired. Refer all servicing to a qualified technician. Consult your dealer for advice.
9. Keep away from flammables. DO NOT attempt to operate this product near flammable materials or combustibles. Failure to comply may cause serious injury or death.
10. Store idle product out of the reach of children and untrained persons. This product may be dangerous in the hands of untrained users.
11. Maintain product with care.
12. Keep product dry and clean.
13. DO NOT use a damaged product. Tag damaged products "DO NOT USE" until repaired.
14. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the product's operation.
15. Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one product may become hazardous when used on another product.
16. If damaged, have the product serviced before using. Many accidents are caused by poorly maintained products.
17. Product service must be performed only by qualified repair personnel. Service or maintenance performed by unqualified personnel could result in a risk of injury.
18. When servicing a product, use only identical replacement parts. Use of unauthorized parts or failure to follow maintenance instructions may create a risk of injury.
19. Maintain a safe working environment. Keep the work area well lit. Make sure there is adequate surrounding workspace. Keep the work area free of obstructions, grease, oil, trash, and other debris. DO NOT use this product in a damp or wet location.
20. Maintain labels and nameplates on this product. These carry important information. If unreadable or missing, contact OEMTOOLS™ for a replacement.
21. Avoid accidental fire and/or explosion. DO NOT smoke near engine fuel and battery components.
22. We believe the information contained herein to be reliable. However, general technical information is given by us without charge and the user shall employ such information at their own discretion and risk. We assume no responsibility for results or damages incurred from the use of such information in whole or in part. Always refer to specific instructions and technical information supplied by the vehicle manufacturer.

SPECIFIC SAFETY INSTRUCTIONS AND WARNINGS

⚠ WARNING: Read and understand all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

⚠ WARNING: For your own safety, DO NOT attempt to operate your drill press until it is completely assembled and installed according to the manual.

1. DO NOT use your tool where there is a risk of causing a fire or an explosion; e.g. in the presence of flammable liquids, gases, or dust. Power tools create sparks, which may ignite the dust or fumes.
2. Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control, so visitors should remain at a safe distance from the work area.
3. Be aware of all power lines, electrical circuits, water pipes and other mechanical hazards in your work area, particularly those hazards below the work surface hidden from the operator's view that may be unintentionally contacted and may cause personal harm or property damage.
4. Be alert of your surroundings. Using power tools in confined work areas may put you dangerously close to cutting tools and rotating parts.

⚠ WARNING: Always check to ensure the power supply corresponds to the voltage on the rating plate.

5. DO NOT abuse the power cord. Never carry a portable tool by its power cord, or yank tool or extension cords from the receptacle. Keep power and extension cords away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords may cause a fire and increase the risk of electric shock.
6. Grounded tools must be plugged into an outlet properly installed and grounded in accordance with all codes and ordinances. Never remove the grounding prong or modify the plug in any way. DO NOT use any adapter plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded.
7. Double insulated tools are equipped with a polarized plug (one blade is wider than the other). This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still doesn't fit, contact a qualified electrician to install a polarized outlet. DO NOT change the plug in any way.
8. Avoid body contact with grounded surfaces such as pipes, radiators, ranges, and refrigerators. There is an increased risk of electric shock if your body is grounded.
9. When operating a power tool outside, use an outdoor extension cord marked "W-A" or "W." These cords are rated for outdoor use and reduce the risk of electric shock.
10. DO NOT expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
11. DO NOT let your fingers touch the terminals of plug when inserting into or removing from the outlet.
12. Ground fault circuit interrupters. If work area is not equipped with a permanently installed Ground Fault Circuit Interrupter outlet (GFCI), use a plug-in GFCI between power tool or extension cord and power receptacle.
13. Stay alert, watch what you are doing and use common sense when operating a power tool. DO NOT use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
14. Dress properly. DO NOT wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts. Air vents often cover moving parts and should be avoided.
15. Use safety apparel and equipment. Use safety goggles or safety glasses with side shields which comply with current national



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

standards or, when needed, a face shield. Use a dust mask in dusty work conditions. This applies to all persons in the work area. Also use non-skid safety shoes, hard hat, gloves, dust collection systems, and hearing protection when appropriate.

16. Avoid accidental starting. DO NOT carry the power tool with your finger on the switch. Ensure the switch is in the Off position before plugging tool into power outlet. In the event of a power failure, while a tool is being used, turn the switch Off to prevent surprise starting when power is restored.
17. DO NOT overreach. Keep proper footing and balance at all times.
18. Remove adjusting keys or wrenches before connecting to the power supply or turning on the tool. A wrench or key that is left attached to a rotating part of the tool may result in personal injury.
19. Never place your fingers in a position where they could contact the drill or other cutting tool if the workpiece should unexpectedly shift or if your hand should slip.
20. Whenever possible, position the workpiece to contact the left side of the column if it is too short or the table is tilted; clamp solidly to the table. Use table slots or clamping ledge around the outside edge of the table.
21. When using a drill press vise, always fasten it to a table.
22. Never climb on or allow others to climb on the drill press table; it could break or pull the entire drill press down.
23. Turn the motor switch Off and put away the Switch Key when leaving the drill press.
24. To avoid injury from thrown work or tool contact, DO NOT perform layout, assembly, or set up work on the table while the cutting tool is rotating.
25. DO NOT force the tool. Tools do a better and safer job when used in the manner for which they are designed. Plan your work, and use the correct tool for the job.
26. Never use a tool with a malfunctioning switch. Any power tool that cannot be controlled with the switch is dangerous and must be repaired by an authorized service representative before using.
27. Disconnect power from tool and place the switch in the locked or Off position before servicing, adjusting, installing accessories or attachments, or storing. Such preventive safety measures reduce the risk of starting the power tool accidentally.
28. Secure work with clamps or a vise instead of your hand to hold work when practical. This safety precaution allows for proper tool operation using both hands.
29. Store idle tools. When tools are not in use, store them in a dry, secure place out of the reach of children. Inspect tools for good working condition prior to storage and before re-use.
30. Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one tool may create a risk of injury when used on another tool.
31. Keep guards in place and in working order.
32. Your drill press must be bolted securely to a workbench. If there is any tendency for your drill press to move during certain operations, bolt the workbench to the floor.
33. This drill press is intended for use in dry conditions, indoor use only.
34. Always keep hands out of the path of a drill bit. Avoid awkward hand positions where a sudden slip could cause your hand to move into the drill bit.
35. DO NOT install or use any drill bit that exceeds 175 mm (7") in length or extends 150 mm (6") below the chuck jaws. They can suddenly bend outward or break.
36. DO NOT use wire wheels, router bits, shaper cutters, circle (fly) cutters, or rotary planers on this drill press.
37. When cutting a large piece of material, make sure it is fully supported at the table height.
38. DO NOT perform any operation freehand. Always hold the workpiece firmly against the table so it will not rock or twist. Use clamps or a vise for unstable workpieces.
39. Make sure there are no nails or foreign objects in the part of the workpiece to be drilled.
40. DO NOT touch the bit or chips. Drill bits and cuttings are hot immediately after drilling.
41. Never reach around or under the working head, or grab the chuck key to stop the drill press.
42. Make sure the drill press speed is appropriate for both the type of material and bit size you are using.
43. Clamp workpiece or brace against the left side of the column to prevent rotation. If it is too short or the table is tilted, clamp solidly to the table and use the fence provided.
44. If the workpiece overhangs the table such that it will fall or tip if not held, clamp it to the table. Provide auxiliary support.
45. Make sure all clamps and locks are firmly tightened before drilling.
46. Securely lock the head and table support to the column, and the table to the table support before operating the drill press.
47. Never turn your drill press on before clearing the table of all objects (tools, scraps of wood, etc.).
48. Before starting the operation, jog the motor switch to make sure the drill bit does not wobble or vibrate.
49. Let the spindle reach full speed before starting to drill. If your drill press makes an unfamiliar noise or if it vibrates excessively, stop immediately, turn the drill press off and unplug. DO NOT restart until the problem is corrected.
50. DO NOT perform layout assembly or set up work on the table while the drill press is in operation.
51. Make sure the spindle has come to a complete stop before touching the workpiece.
52. To avoid injury from accidental starting, always turn the switch Off and unplug the drill press before installing or removing any accessory or attachment or making any adjustment.
53. Keep guards in place and in working order.
54. Only use the self-ejecting type chuck key as provided with the drill press.
55. DO NOT try to drill material that is too small to be securely held.
56. Use the drill press in a well-lit area and on a level surface clean and smooth enough to reduce the risk of trips, slips, or falls. Use it where neither the operator nor a casual observer is forced to stand in line with a potential kickback.
57. Never leave tool running unattended.

NOTE: The manufacturer declines any and all responsibility for damage to vehicles or components if said damage is the result of unskillful handling by the operator or of failure to observe the basic safety rules set forth in the instruction manual.

⚠WARNING: Carefully read Rules for Safe Operation and Instructions.

IMPORTANT SAFETY INSTRUCTIONS

The warnings, precautions, and instructions discussed in this manual cannot cover all possible conditions and situations that may occur. The operator must understand that common sense and caution are factors which cannot be built into this product but must be supplied by the operator.

PRODUCT DESCRIPTION

This OEMTOOLS™ 16-Speed Drill Press is great for working in a wide range of materials. The floor drill press is constructed of cast iron to reduce vibration and features smooth rack-and-pinion movement, an adjustable depth stop with gauge and a solid cast iron table. The table also rotates 360 degrees and can be tilted 45 degrees left or right.



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

PRODUCT SPECIFICATIONS

16 SPEED	120V, 7.5 AMP, 220 - 3600 RPM Motor
DRILLING DEPTH	3-1/8"
CHUCK SIZE	7/64" - 5/8"
SPINDLE TO TABLE DISTANCE	28"
SPINDLE TO BASE DISTANCE	47"
SWING	15"
DIMENSIONS	56-1/2" (L) x 20" (W) x 10" (H)
WEIGHT	148 Lbs.

RANGE OF SPINDLE SPEEDS

Motor Speed		Spindle Speeds (min ⁻¹)																
50 Hz	1400 min ⁻¹	190	250	360	400	490	540	600	720	750	780	1300	1600	1700	2070	2380	3000	
60 Hz	1700 min ⁻¹	220	300	430	480	590	650	720	850	900	950	1600	1900	2000	2500	2900	3600	

UNPACKING

1. Separate all parts from packaging materials and check each of the following items to make sure all items are accounted for before discarding any packing material.
2. Remove the protective oil that is applied to the table and column. Use any ordinary household type grease and spot remover.
3. Apply a coat of paste wax to the table and column to prevent rust. Wipe all parts thoroughly with a clean dry cloth.

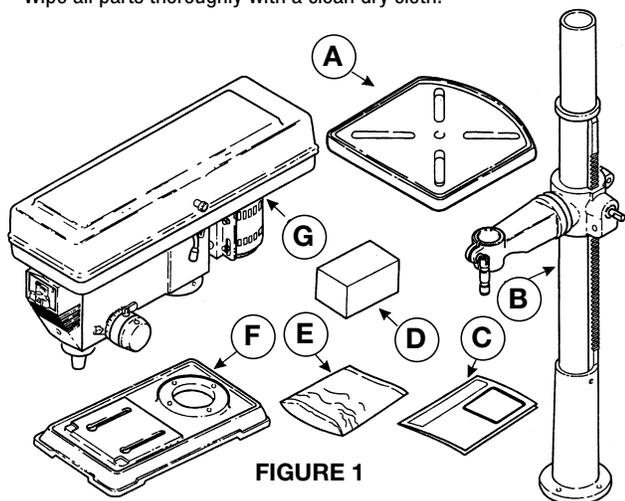


FIGURE 1

Figure	Description	Quantity
A	Table	1
B	Column Support Arm	1
C	Owner's Manual	1
D	Box of Loose Parts	1
E	Bag of Loose Parts	1
F	Base	1
G	Head Arm	1

LIST OF LOOSE PARTS IN THE BOX AND BAGS

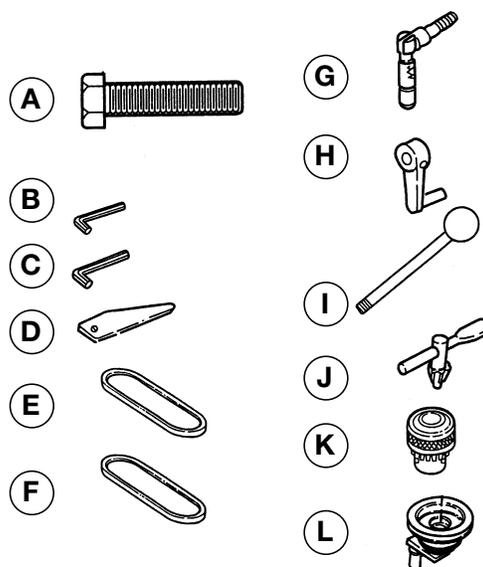


Figure	Description	Quantity
A	Long Hex-Screw M10 X 1.5 - 40	4
B	M3 Hex "L" Wrench	1
C	M5 Hex "L" Wrench	1
D	Drift Key	1
E	V-Belt M24	1
F	V-Belt M26	1
G	Clamp Column Lock	1
H	Crank (Set screw included)	1
I	Feed Handle	3
J	Chuck Key	1
K	Chuck	1
L	Idler Pulley Assembly	1



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

GETTING TO KNOW YOUR FLOOR DRILL PRESS

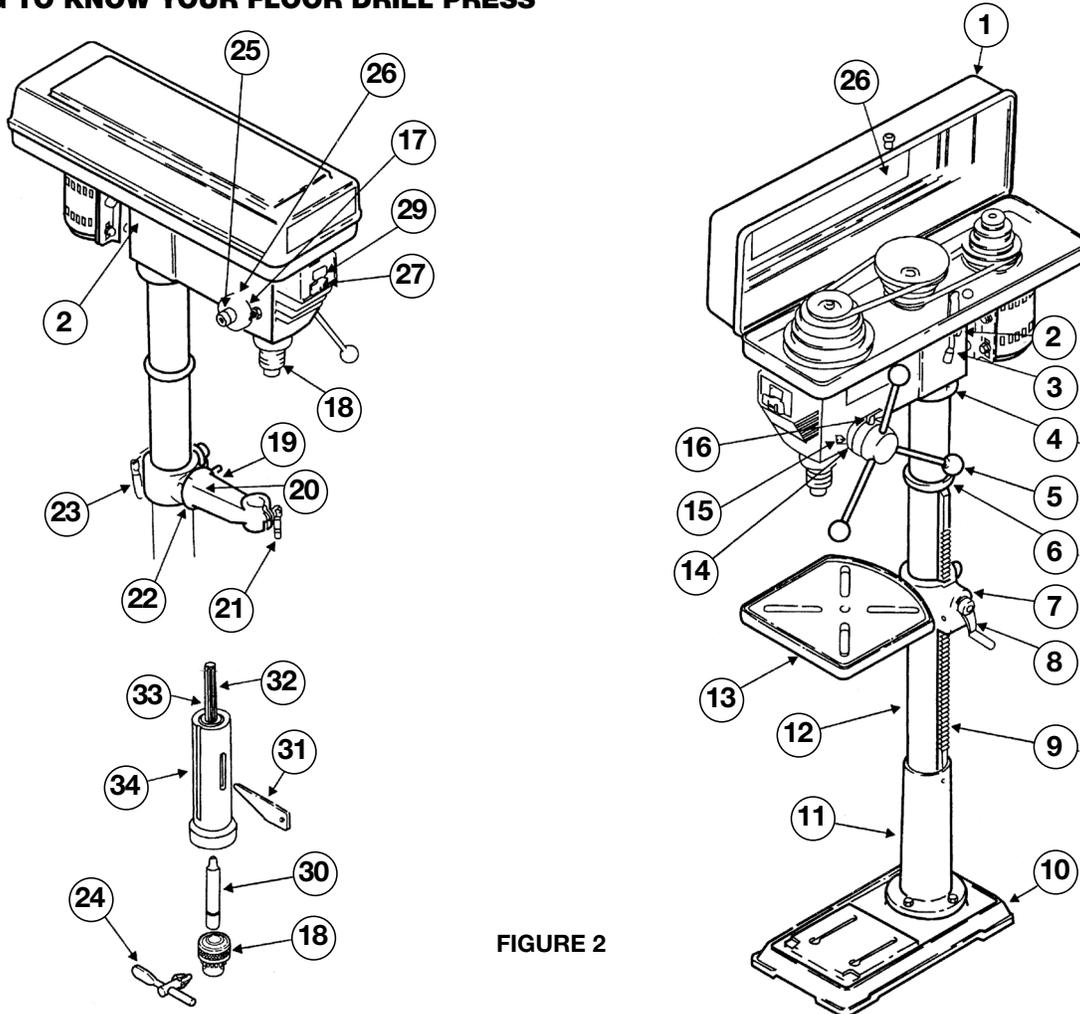


FIGURE 2

Figure	Description
1	Belt Guard
2	Belt Tension Lock Handle
3	Belt Tension Handle
4	Head Lock
5	Feed Handle
6	Column Collar
7	Table Support
8	Table Crank
9	Rack
10	Base
11	Column Support
12	Column
13	Table
14	Depth Scale
15	Depth Scale Indicator
16	Depth Scale Lock
17	Spring Cap

Figure	Description
18	Chuck
19	Arm
20	Table Bevel Lock (Under Table)
21	Table Lock
22	Bevel Scale
23	Support Lock
24	Chuck Key
25	Feed Spring Adjustment
26	Feed Spring
27	Drill ON/OFF Switch
28	Drill Speed Table (Inside Belt Guard)
29	Light ON/OFF Switch
30	Arbor
31	Wedge Key
32	Spindle
33	Splines (Grooves)
34	Rack (Teeth)



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

ASSEMBLY

⚠ WARNING: For your own safety, never connect plug to power outlet until all assembly steps are completed.

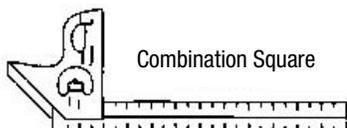
Medium Screwdriver



8" Adjustable Wrench

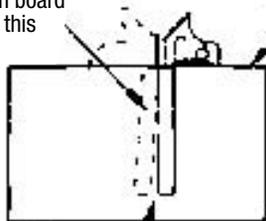


Combination Square



COMBINATION SQUARE MUST BE TRUE.
Check its accuracy as illustrated below.

Draw light line on board along this edge



Straight edge of board is 3/4" thick. This edge must be perfectly straight.

There should be no gap or overlap when square is flipped over in dotted area.

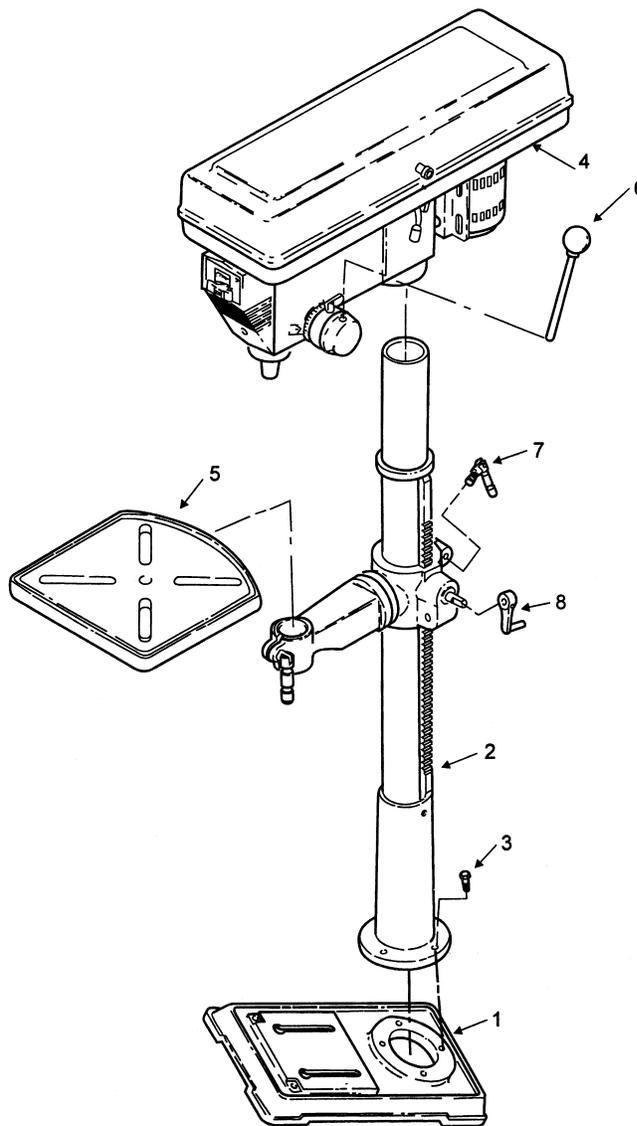


FIGURE 3

Refer to the figure to install all parts correctly; tighten screws and bolts securely.

Figure	Description
1	Base
2	Columns with Support Arm
3	M10 x1.5 - 40 Screw (4)
4	Head Arm
5	Table
6	Feed Handle
7	Clamp Column Lock
8	Crank



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

ASSEMBLY OF COLUMN AND TABLE HARDWARE

1. Position base on floor. Remove protective covering and discard.
2. Remove protective sleeve from column tube and discard. Place column assembly on base and align holes in column support with holes in base.
3. Locate (4) four 3/8" Dia. x 9/16" long bolts.
4. Install a bolt in each hole through column support and base; tighten with adjustable wrench. See figure 4.

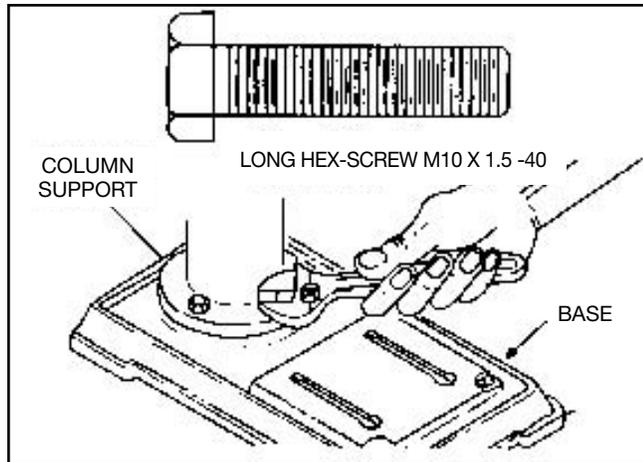


FIGURE 4

5. Locate table crank and support lock in loose parts box.
6. Install support lock from left side into table support and tighten by hand.
7. Install table crank assembly and tighten set screw with a 7/64" Hex "L" wrench. Do not overtighten. Set screw should be tightened against the flat section of the shaft. See figure 5.

NOTE: To minimize crank backlash, tighten support lock and rotate elevation worm shaft clockwise; then, assemble crank tight against table support and tighten set screw.

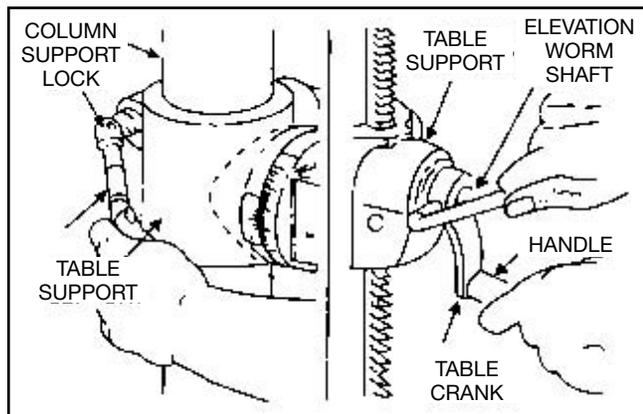


FIGURE 5

8. Check column collar for proper adjustment. Collar should not be angled on the column, and it should not be positioned so rack will slide freely in collar when table is rotated 360° around column table. If re-adjusted, only tighten set screw enough to keep collar in place. See figure 6.

NOTE: To avoid column or collar damage, do not overtighten set screw.

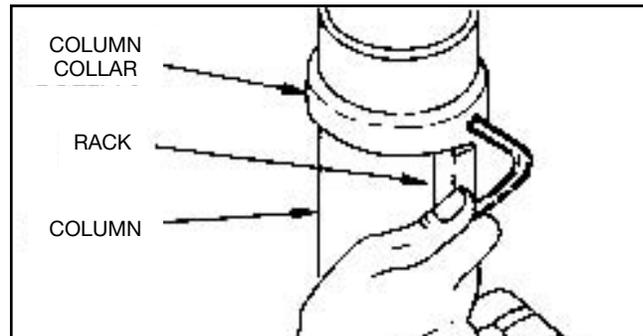


FIGURE 6

INSTALLING THE TABLE

1. Loosen support lock and raise table support by turning table crank clockwise until support is at a working height level. Tighten support lock. See figure 7 & 8.

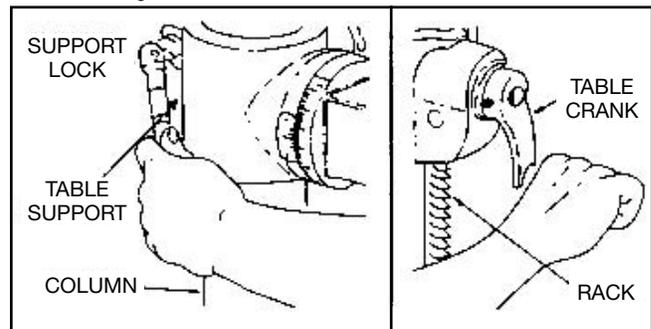


FIGURE 7

FIGURE 8

2. Remove protective covering from table and discard. Place table in table support and tighten table lock (located under table) by hand. See figure 9.

NOTE: If table won't fit into table support easily, try opening table support with a flat blade screwdriver.

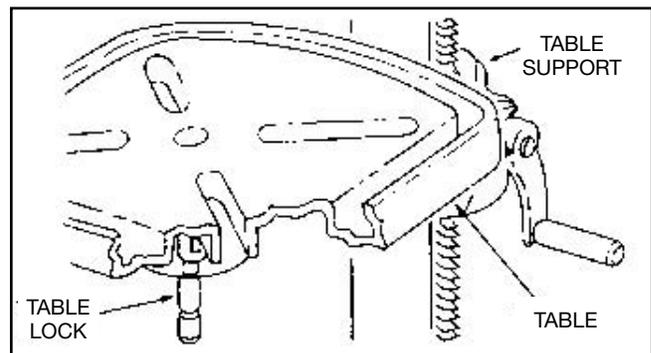


FIGURE 9



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

INSTALLING THE HEAD

CAUTION: The head assembly weighs about 55 Lbs. Carefully lift head.

1. Remove protective bag from head assembly and discard. Carefully lift head above column tube and slide it onto column making sure head slides down over column as far as possible. Align head with table and base. See figure 10.

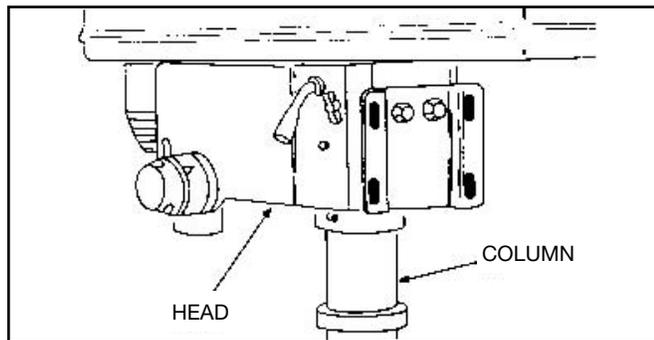


FIGURE 10

2. Locate (2) two 3/8" Dia. x 1/2" long set screws in loose parts bag.
3. Install a set screw in each hole (as indicated) on the right side of the Head. Using a 5 mm Hex "L" wrench, tighten the two head lockset screws. See figure 11.

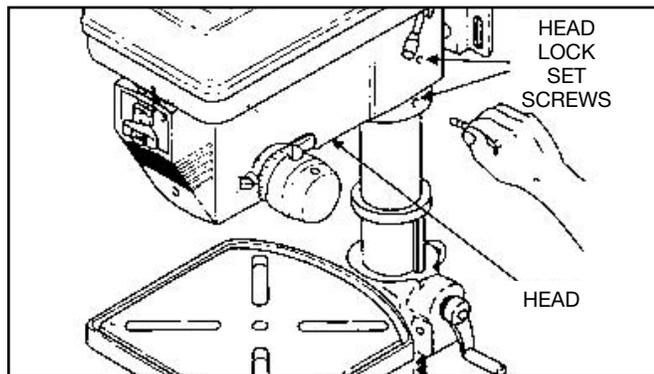


FIGURE 11

INSTALLING THE PULLEY-CENTER

1. Locate center pulley assembly in loose parts bag and place in proper hole. See figure 12.

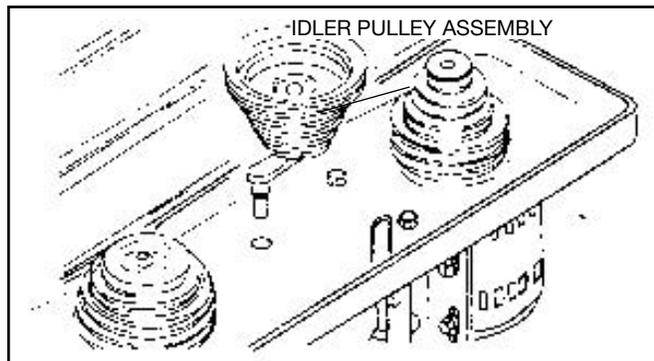


FIGURE 12

INSTALLING THE BELT

1. Locate two (2) V-belts in the loose parts bag.
2. Use speed chart inside belt guard to choose speed for drilling operation. Install belts in correct position for desired speed. The longer of the two belts is always positioned between the spindle pulley and idler pulley. See figure 13.

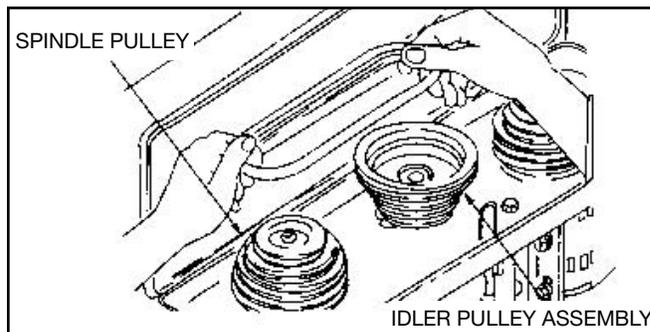


FIGURE 13

- NOTE:** Refer to inside belt guard for Recommended Drilling Speeds.
3. Apply tension to belt by turning Belt Tension Handle counter-clockwise until belt deflects approximately 1/2" by thumb pressure at its center.
 4. Tighten Belt Tension Lock Handles.

- NOTE:** Over-tensioning belt may cause motor not to start or damage bearings.
5. If belt slips while drilling, re-adjust belt tension. See figure 14.

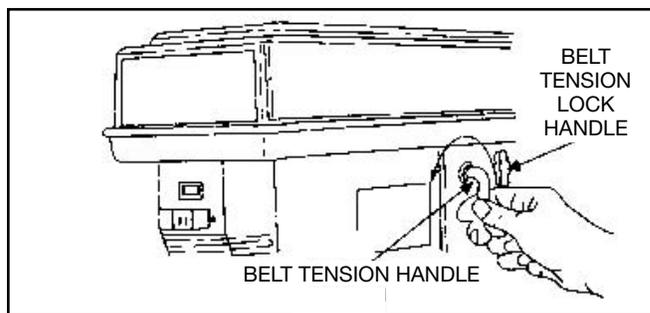


FIGURE 14



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

INSTALLING THE BELT GUARD KNOB

1. To attach belt guard knob, locate knob and 5 mm Dia. x 12 mm long pan screw in loose parts bag. Install screw in hole located on guard and attach knob turning until tight. See figure 15.

WARNING: To avoid possible injury, keep guard in place and in proper working order while operating.

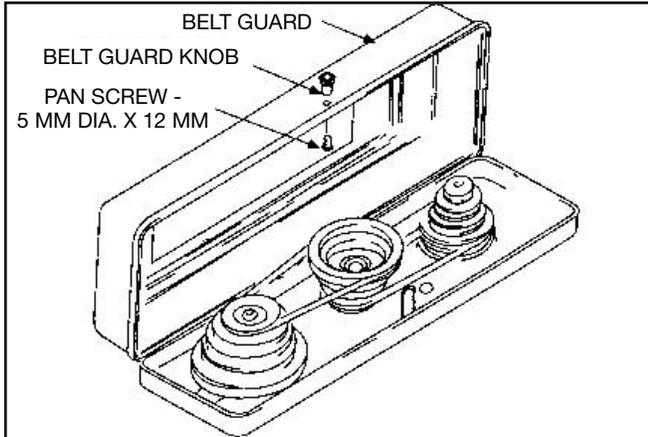


FIGURE 15

INSTALLING THE FEED HANDLES

1. Locate three (3) feed handles among loose parts.
2. Screw the feed handles into the threaded holes in the hub and tighten. See figure 16.

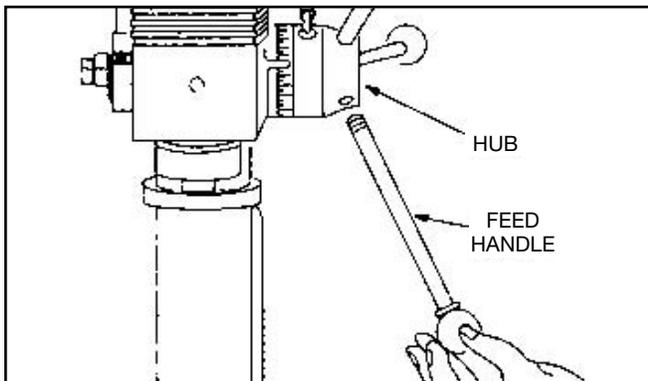


FIGURE 16

INSTALLING THE CHUCK

1. Clean out the Tapered Hole in the chuck. Clean the tapered surface on the arbor with a clean cloth. Make sure there are no foreign particles sticking to the surfaces. The slightest piece of dirt on any of these surfaces will prevent the chuck from seating properly. This will cause the drill to "wobble". See figure 17 & 18.

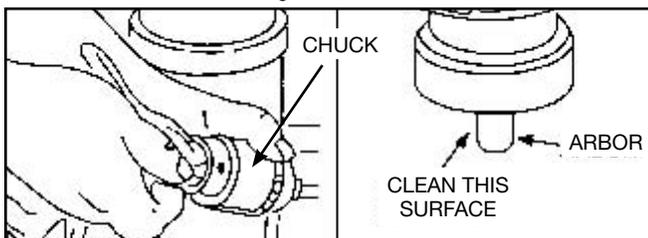


FIGURE 17

FIGURE 18

2. Slide the chuck up over the arbor as illustrated.
3. Unlock support lock and raise table so it is about two (2) inches below tip of chuck.
4. Turn chuck sleeve clockwise and open jaws in chuck completely.
5. Turn feed handles counter-clockwise and force chuck against table until chuck is secure. See figure 19.

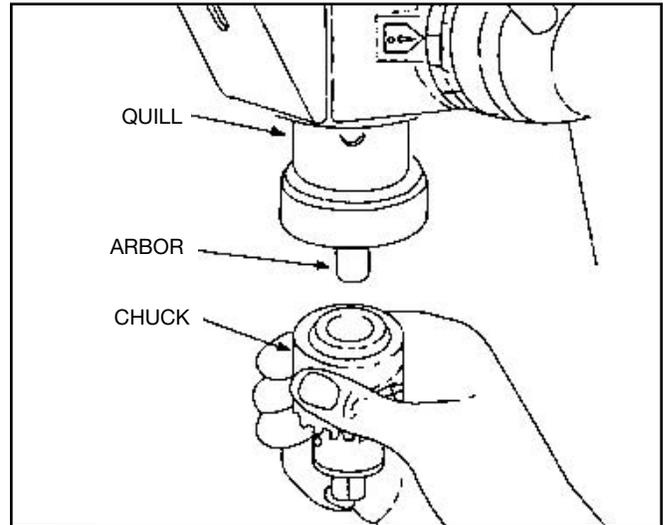


FIGURE 19

INSTALLING THE LIGHT BULB

1. Install a light bulb (no larger than 60 watt) into the socket inside the head. See figure 20.

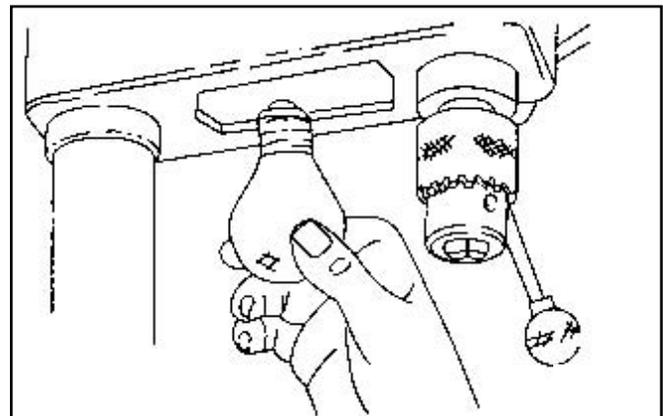


FIGURE 20



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

ADJUSTING THE TABLE SQUARE TO HEAD

NOTE: The combination square must be "true". See "Unpacking" section for method.

1. Insert a straight ground steel rod or a straight drill bit (not included) approximately 3" long into chuck and tighten.
2. With table raised to working height and locked on column, place combination square flat on table beside rod.
3. If an adjustment is necessary, loosen the set screw under bevel lock with 3 mm Hex "L" wrench. Loosen the table bevel lock with the 24 mm flat wrench (included). (These adjustments are located under the table.)
4. Align the table square to the bit by rotating the table until the square and bit are in line.
5. Retighten table bevel lock.
6. Retighten set screw. See figure 21 and 22.

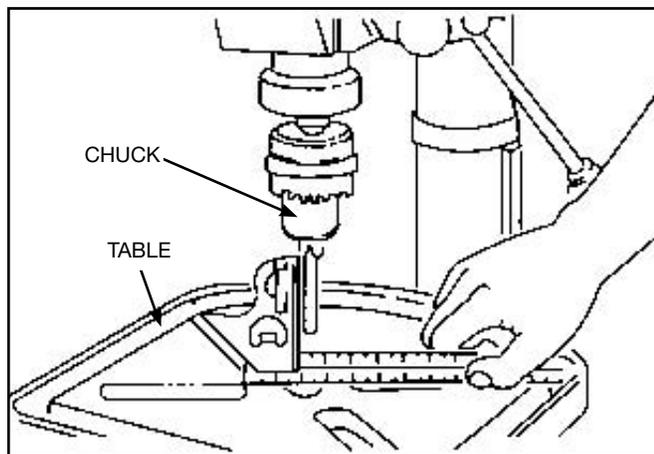


FIGURE 21

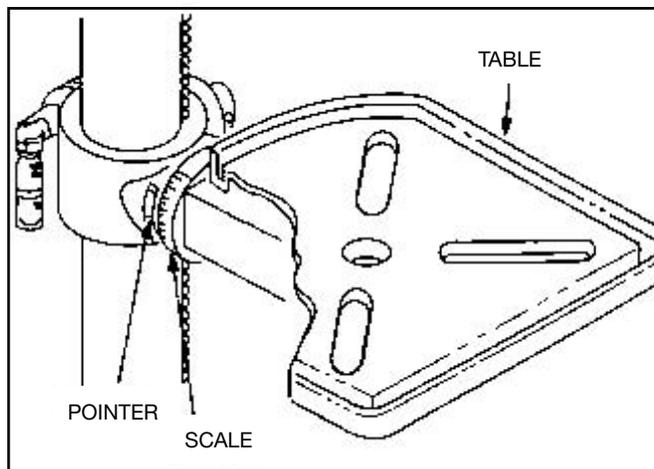


FIGURE 22

BEVEL SCALE

NOTE: The bevel scale is included to provide a quick method for beveling the table to approximate angles. If precise accuracy is necessary, a square or other precise measuring tool should be used to position the table.

1. To use the bevel scale, perform the following:
 - a. Loosen set screw and table bevel lock (see step 3 above).
 - b. Move table so desired angle or bevel scale is straight across from zero line on table support.
 - c. Retighten table bevel lock and set screw. See figure 23.

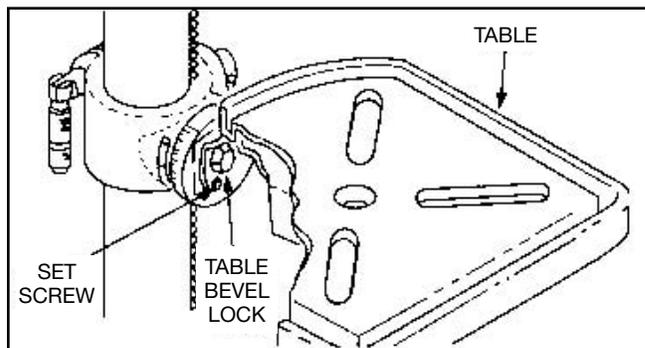


FIGURE 23

OPERATION

1. Before using this machine, the operator should carefully read over this operation manual to acquaint himself/herself with the construction, controls and driving system of the machine.
2. All of the Ball Bearings are packed with grease at the factory. They require no further lubrication. Periodically lubricate the grooves in the spindle and the rack (teeth of the quill).
3. Install drill into chuck far enough to obtain maximum gripping of the chuck jaws. Make sure that the drill is centered in the chuck. Tighten the drill sufficiently, so that it does not slip while drilling. Turn the chuck key clockwise to tighten, counter-clockwise to loosen the drill bit.
4. The drilling depth may be controlled by the pointer and depth scale or by the two stop nuts on the feed stop rod.
5. To position the table, loosen the support lock handle; move the table to the desired position and retighten the support lock. To tilt table, loosen the bevel lock, tilt the table to desired position on the bevel scale and retighten bevel lock.
6. After drilling a hole, release the feed handle to have the spindle sleeve return to its original position.
7. In case of any trouble or abnormal noise arising during operation, stop the motor at once and identify the cause.
8. After operation, remove chips and dirt on the machine and cover all the unpainted surfaces with oil to prevent them from rusting. Turn off the power supply for safety.

EXTENSION CORD USE

1. Use only 'Listed' extension cords. If used outdoors, they must be marked "For Outdoor Use." Those cords having 3-prong grounding type plugs and mating receptacles are to be used with grounded tools.
2. Replace damaged or worn cords immediately.
3. Check the name plate rating of your tool. Use of improper size or gauge of extension cord may cause unsafe or inefficient operation of your tool. Be sure your extension cord is rated to allow sufficient current flow to the motor. For the proper wire gauge for your tool, see chart.



15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

CHART FOR MINIMUM WIRE SIZE OF EXTENSION CORDS

Nameplate AMPS	Cord Length			
	25'	50'	100'	150'
0-6	18 AWG	16 AWG	16 AWG	14 AWG
6-10	18 AWG	16 AWG	14 AWG	12 AWG
10-12	16 AWG	16 AWG	14 AWG	12 AWG
12-16	14 AWG	12 AWG	(Not Recommended)	

If in doubt, use larger cord. Be sure to check voltage requirements of the tool to your incoming power source.

MAINTENANCE

▲WARNING: For your own safety, turn switch Off and remove plug from power source outlet before maintaining or lubricating your drill press.

▲WARNING: To avoid shock or fire hazard, if the power cord is worn, cut, or damaged in any way, have it replaced.

▲WARNING: Make sure this tool is disconnected from its power source before attempting any maintenance, cleaning, or inspection.

1. Maintain your tools. It is recommended that the general condition of any tool be examined before it is used. Keep your tools in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. If any abnormal vibrations or noise occurs, turn the tool off immediately and have the problem corrected before further use. Have necessary repairs made by qualified service personnel.
2. All of the ball bearings are packed with grease. They require no further lubrication. Periodically lubricate the table elevation mechanism and the grooves in the spindle. See "Getting to know your drill press" section of this manual.
3. Frequently blow out any dust that may accumulate inside the motor. A coat of automotive type paste wax applied to the table and column will help keep the surfaces clean.
4. Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control. Keep handles dry, clean, and free from oil and grease.
5. Use only soap and a damp cloth to clean your tools. Many household cleaners are harmful to plastics and other insulation. Never let liquid get inside a tool.



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TROUBLE SHOOTING

TROUBLE	PROBABLE CAUSE	REMEDY
Noisy operation.	<ol style="list-style-type: none"> 1. Incorrect belt tension. 2. Dry spindle. 3. Loose spindle pulley. 4. Loose motor pulley. 	<ol style="list-style-type: none"> 1. Adjust tension. 2. Lubricate spindle. 3. Check tightness of retaining nut on pulley and tighten if necessary. 4. Tighten setscrews in pulleys.
Drill bit burns.	<ol style="list-style-type: none"> 1. Incorrect speed. 2. Chips not coming out of hole. 3. Dull drill bit. 4. Feeding too slow. 5. Not lubricated. 	<ol style="list-style-type: none"> 1. Change speed. 2. Retract drill bit frequently to clear chips. 3. Resharpen drill bit. 4. Increase the speed. 5. Lubricate drill bit.
Drill bit leads off – hole not round.	<ol style="list-style-type: none"> 1. Hard grain in wood or lengths of cutting lips and/or angles are not equal. 2. Bent drill bit. 	<ol style="list-style-type: none"> 1. Resharpen drill bit correctly. 2. Replace drill bit.
Wood splinters on underside.	<ol style="list-style-type: none"> 1. No "back up material" under workpiece. 	<ol style="list-style-type: none"> 1. Use "back-up material".
Workpiece turns loose from hand.	<ol style="list-style-type: none"> 1. Not supported or clamped properly. 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it.
Drill bit binds in workpiece.	<ol style="list-style-type: none"> 1. Workpiece pinching drill bit or excessive feed pressure. 2. Improper belt tension. 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it. 2. Adjust tension.
Excessive drill bit runout or wobble.	<ol style="list-style-type: none"> 1. Bent drill bit. 2. Worn spindle bearings. 3. Drill bit not properly installed in chuck. 4. Chuck not properly installed. 	<ol style="list-style-type: none"> 1. Use a straight drill bit. 2. Replace bearings. 3. Install drill bit properly. 4. Install chuck properly.
Quill returns too slow or too fast.	<ol style="list-style-type: none"> 1. Spring has improper tension. 	<ol style="list-style-type: none"> 1. Adjust spring tension.
Chuck will not stay attached to spindle or falls off when attempting to install.	<ol style="list-style-type: none"> 1. Dirt, grease or oil on the tapered inside surface of chuck or on the spindle's tapered surface. 	<ol style="list-style-type: none"> 1. Using a household detergent, clean the tapered surface of the chuck and spindle to remove all dirt, grease and oil.



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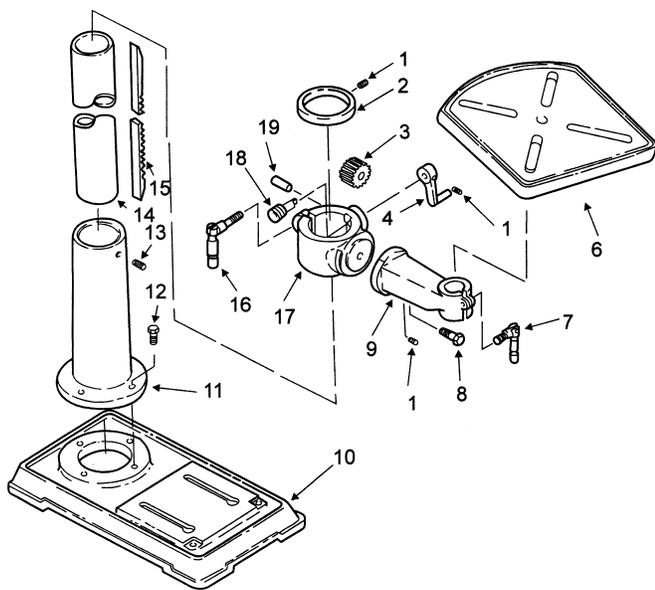


FIGURE 24

Key No.	Description
1	Screw-Hex Socket Set M6 x 1.0 - 10
2	Collar Rack
3	Gear Helical
4	Crank
5	Table
6	Clamp Table
7	Screw-Hex HD M16 x 20 - 35
8	Arm Table with Scale
9	Arm
10	Base
11	Support Column
12	Screw-Hex HD M10 x 1.5 - 40
13	Screw-Hex Socket Set M10 x 1.5 - 12
14	Tube Column
15	Rack
16	Clamp Column
17	Support Table with Indicator
18	Worm Elevation
19	Pin Gear

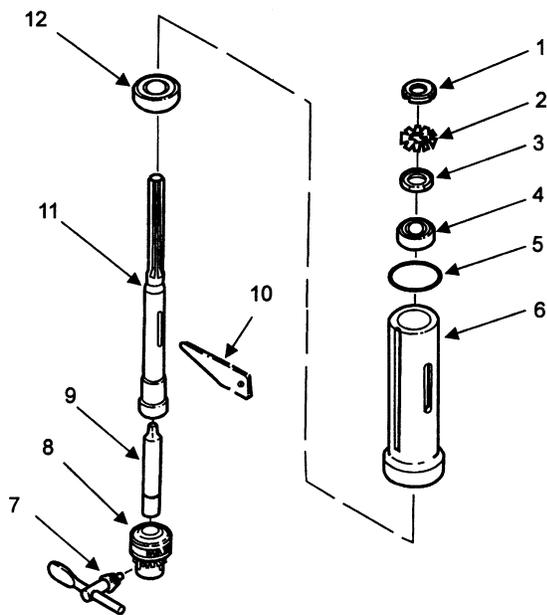


FIGURE 25

Key No.	Description
1	Nut Lock
2	Ring Lock
3	Washer
4	Ball Bearing (17 mm)
5	Rubber Washer
6	Quill Tube
7	Chuck Key
8	Chuck
9	Arbor
10	Drift Key
11	Spindle
12	Ball Bearing



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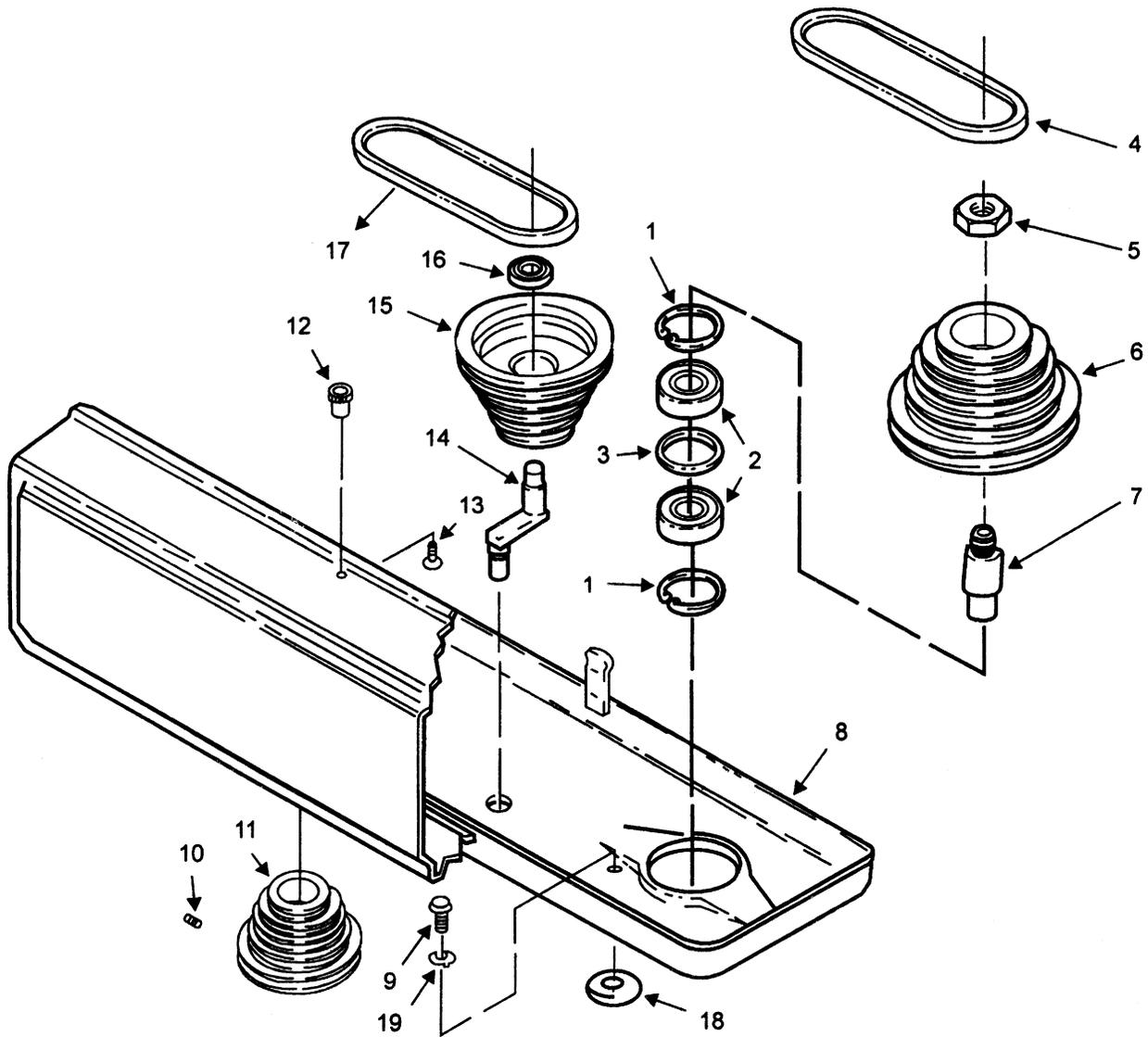


FIGURE 26

Key No.	Description
1	Retaining Ring
2	Ball Bearing (25 mm)
3	Bearing Spacer
4	V-Belt M24
5	Nut Pulley
6	Spindle Pulley
7	Pulley Insert
8	Pulley Guard with Labels
9	Screw-RD HD Washer M6 x 1.0 - 16
10	Screw Set M10 x 1.5 - 12

Key No.	Description
11	Motor Pulley
12	Knob
13	Screw Pan HD M5 x 0.8 - 12
14	Pivot Idler
15	Center Pulley
16	Ball Bearing (15 mm)
17	V-Belt M26
18	Foam Washer
19	Lock Washer Ext. M6



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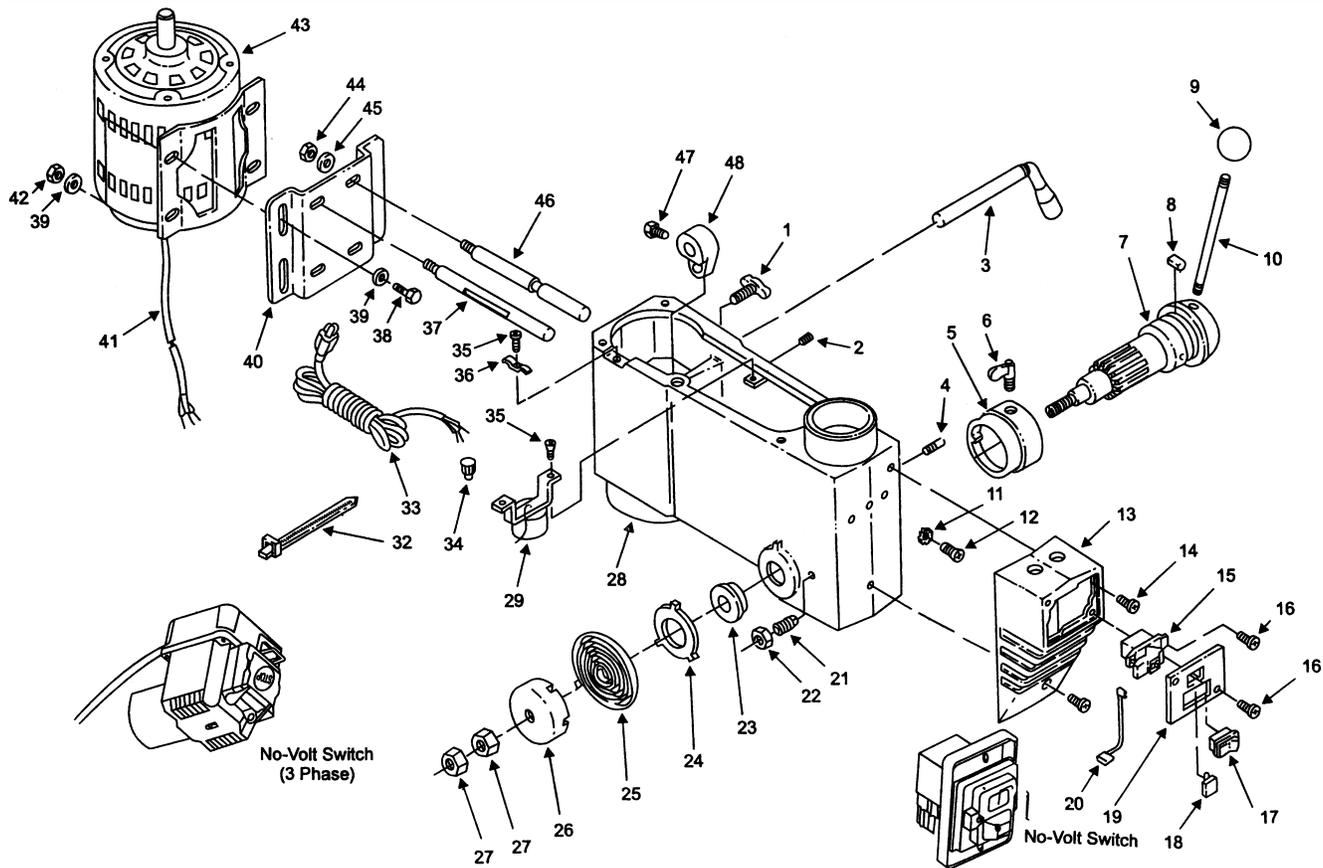


FIGURE 27

Key No.	Description
1	Adjusting Motor Knob
2	Screw-Socket Set M10 x 1.5 - 12
3	Belt Handle Tension
4	Pin Stop
5	Ring-Depth Stop with Scale
6	Lock-Depth Screw
7	Hub
8	Scale Guide
9	Knob
10	Rod
11	Lock Washer Ext. M5
12	Screw Pan HD M5 x 0.8 - 8
13	Box Switch
14	Screw Pan HD M5 x 0.8 - 16
15	Locking Switch

Key No.	Description
16	Screw Pan HD M4.2 x 1.4 - 8
17	Rocker Switch
18	Switch Key
19	Switch Cover Plate
20	Lead Arm 3
21	Special Screw Set 10 x 1.5 - 27
22	Nut-Hex M10 x 1.5
23	Seat Spring
24	Retainer Spring
25	Tension Spring
26	Cap Spring
27	Nut-Hex M12 x 1.5 - 8
28	Head with Pointer and Trim
29	Socket Bulb Asm.
32	Wire Tie
33	Power Cord

Key No.	Description
34	Wire Connector
35	Screw Pan HD M6 x 1.0 - 12
36	Cord Clamp
37	Motor Support Bracket
38	Screw-Hex HD M8 x 1.25 - 20
39	Washer 8 x 16 x 1.6
40	Motor Mount
41	Motor Cord
42	Nut-Hex M8 x 1.25
43	Motor
44	Nut-Hex M12 x 1.75
45	Lock Washer 1/2
46	Motor Support Bracket
47	Screw-Hex HD M5 x 0.8 - 8
48	Adjusting Lever

NOTE: The manufacturer declines any and all responsibility for damage to vehicles or components if said damage is the result of unskillful handling by the operator or of failure to observe the basic safety rules set forth in the instruction manual.

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15" 16-SPEED HEAVY DUTY FLOOR DRILL PRESS

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