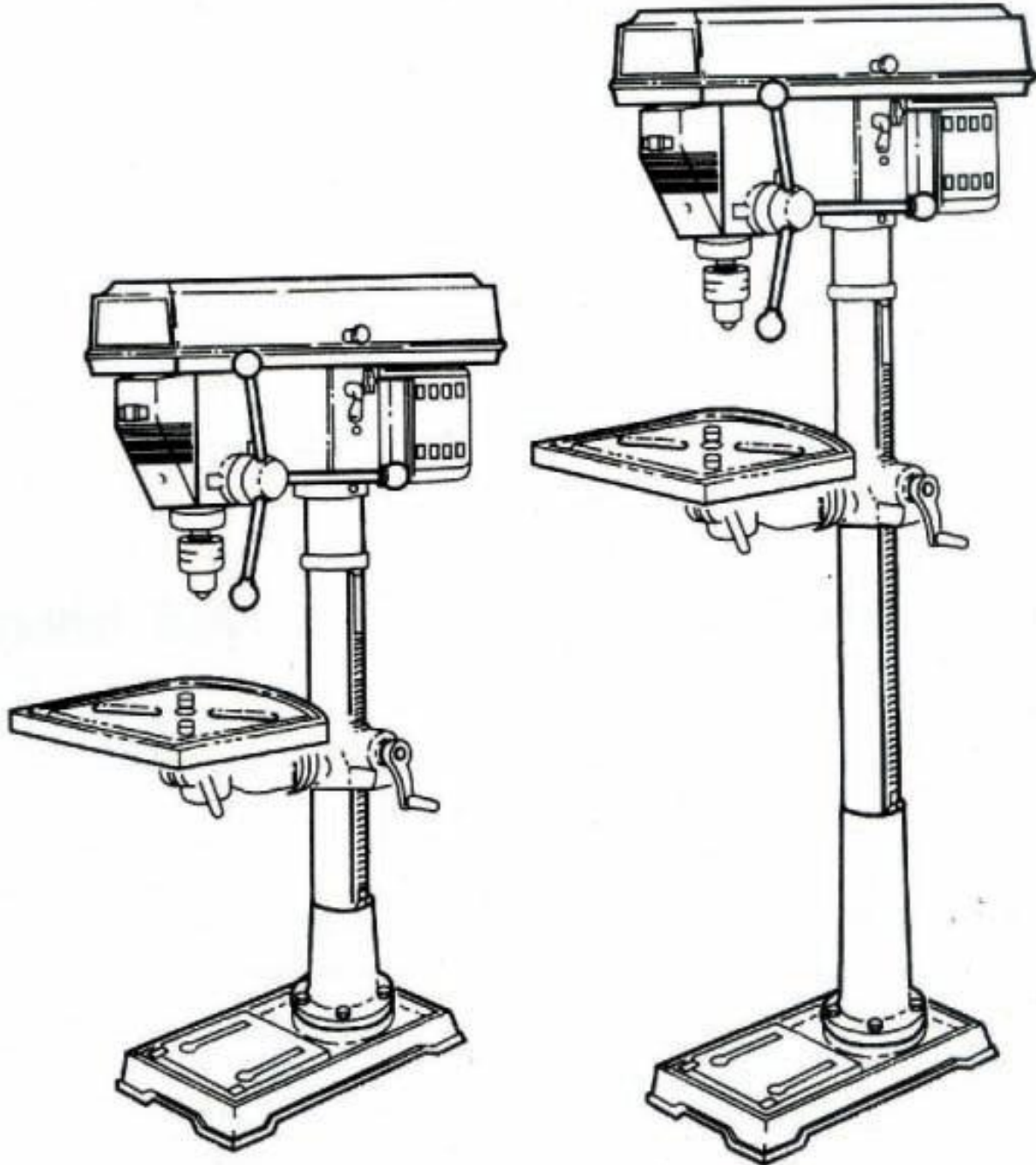


MODEL 1316B/1316F



**FOR YOUR SAFETY:
READ ALL INSTRUCTIONS CAREFULLY**

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General safety instructions for Power Tools

1.KNOW YOUR POWER TOOL

Read and understand the owner's manual and labels affixed to the tool.Learn its application and limitations as well as the specific potential hazards peculiar to this tool.

2.GROUND ALL TOOLS

This tool is equipped with an approved 3 conductor and a 3 prong grounding type plug to fit the proper grounding type receptacle.

3.KEEP GUARDS IN PLACE

In working order and in proper adjustment and alignment.

4.WEAR PROPER APPAREL

Do not wear loose clothing,gloves,neckties,or jewelry (rings,wrist,watches) to get caught in moving parts.Wear protective hair covering to contain long hair.Roll long sleeves above the elbow.

5.USE SAFETY GOGGLES

6.KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents.Floor must not be slippery due to wax or sawdust.

7.KEEP CHILDREN AWAY

Main Specification

Drill Capacity	16 mm / 5/8 in.
Chuck Capacity	16 mm / 5/8 in.
Swing	330 mm / 13 in.
Spindle Taper	MT2
Spindle Travel	80 mm / 3-5/32 in.
Column Diameter	73 mm / 2-7/8 in.
Motor	120V/1ph/600W
Rack & Pinion	Yes
Base Size	450 × 270mm / 17-23/32 × 10-5/8 in.
Table Size	dia 300mm / 11-13/16 in.
Overall Height	DP33016B: 990 mm / 38-31/32 in. DP33016F: 1630mm / 64-11/64 in.

Range of spindle speeds

16 speeds

Motor Speed	Spindle Speeds (min-1)												
1700 min ⁻¹	220	300	430	480	590	650	720	850	900	950	1600	1900	2000
	2500	2900	3600										

Unpacking and checking contents

1. Unpacking and checking contents

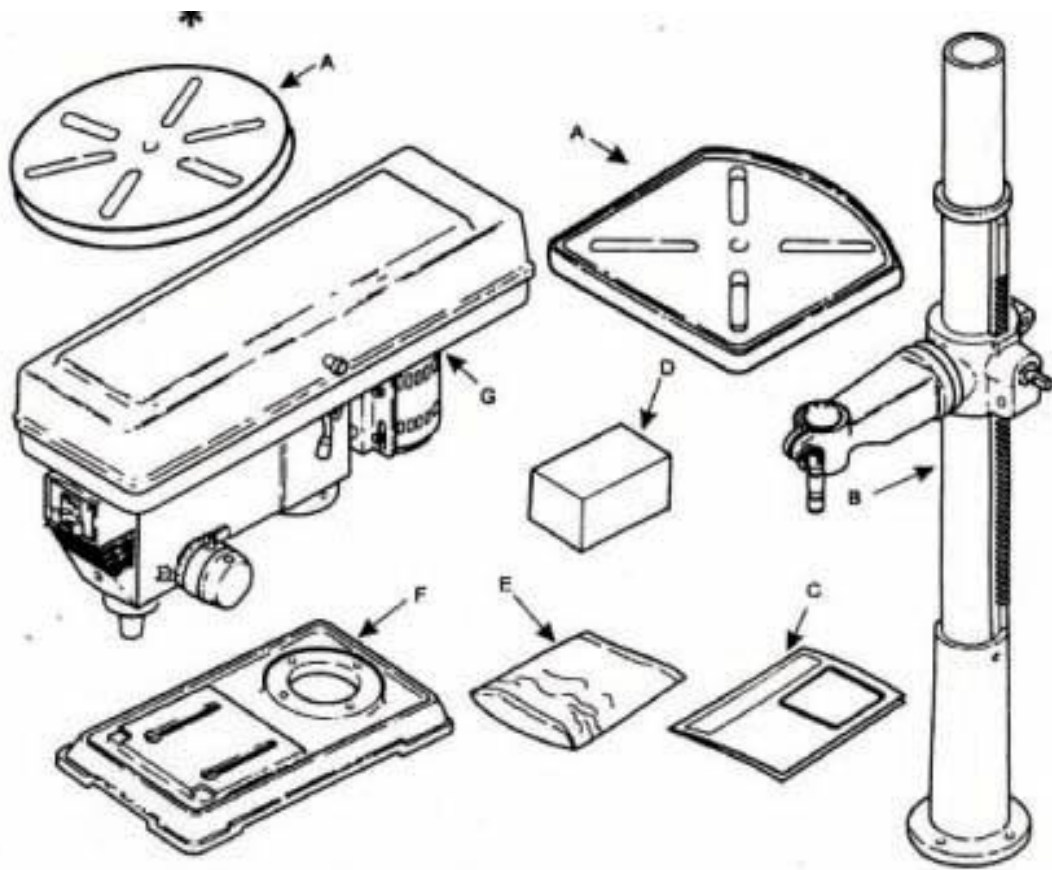
Separate all the parts from packaging materials and check each item make sure all items are accounted for before discarding any packing material.

Item	Description	Qty
A	Table (square or Round).....	1
B	Column Support Asm.....	1
C	Owner's Manual.....	1
D	Box of Loose Parts.....	1
E	Bag of Loose Parts.....	*
F	Base.....	1
G	Head Asm.....	1

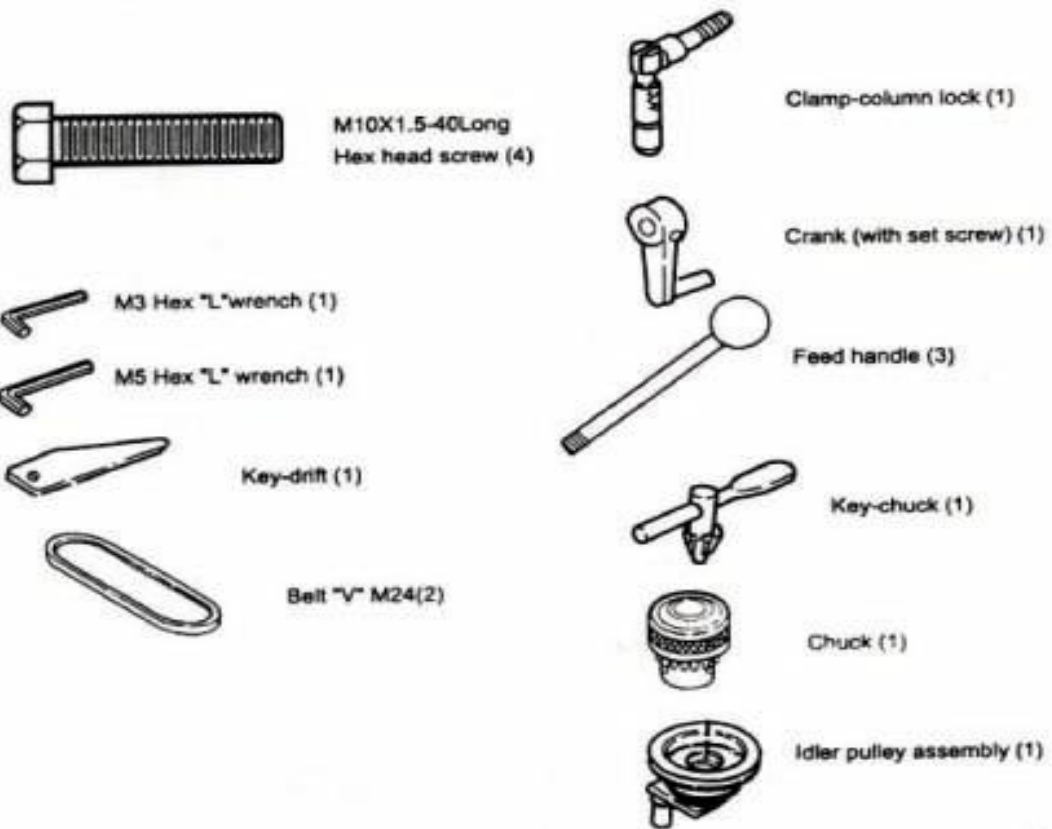
2. Remove the protective oil that is applied to the table and column. Use any ordinary household type grease and spot remover

3. Apply a coat of paste wax to the table and column to prevent rust. Wipe all parts thoroughly with clean dry cloth.

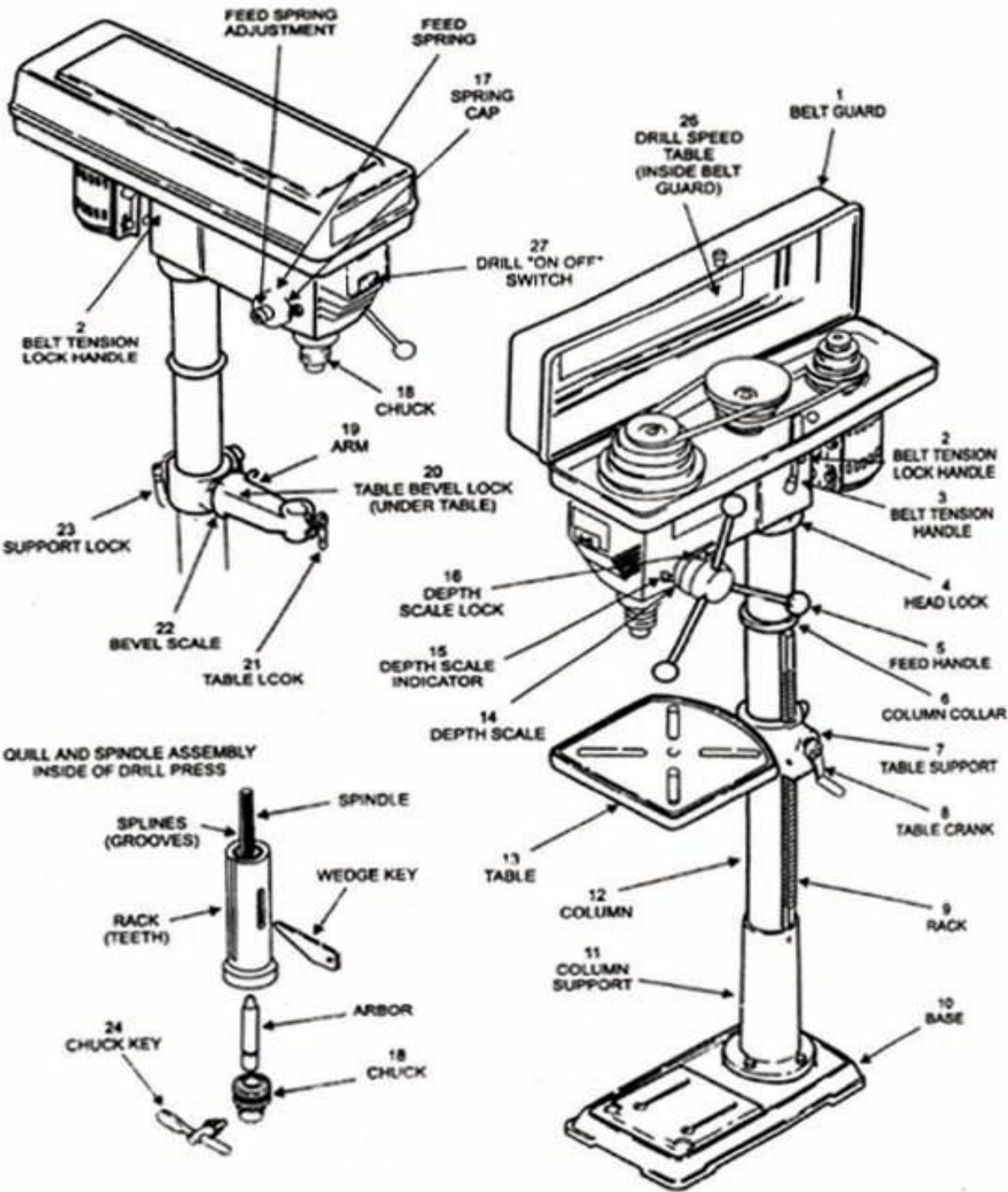
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List of Loose Parts in the box and bags



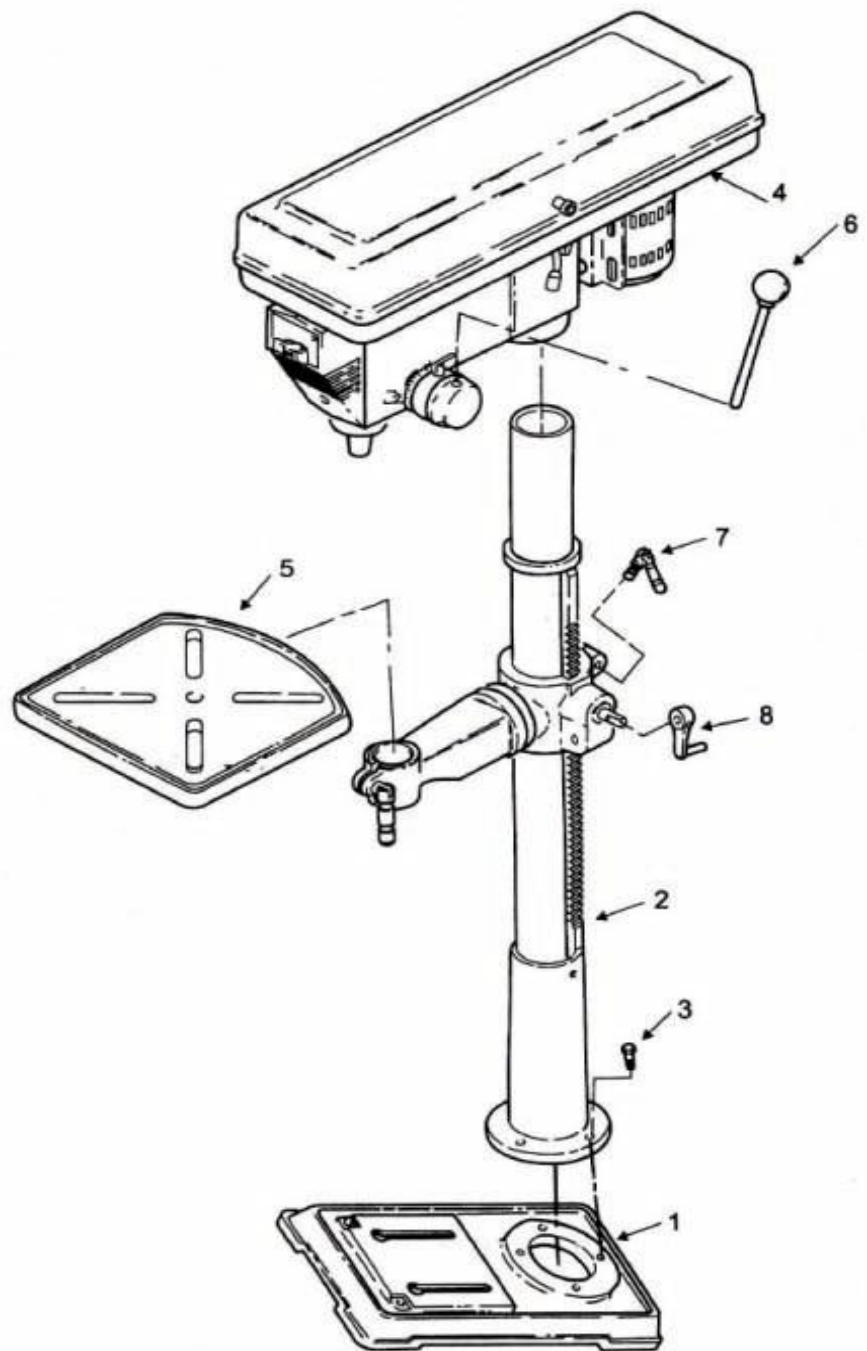
Getting to know your drill press



Assembly

Refer to the figure install all parts correctly,
tighten the screw and bolts securely.

- 1 Base
- 2. Column/w Support Asm
- 3 M10*1.5-40Screw (4)
- 4 Head Asm
- 5 Table
- 6 Feed Handle
- 7 Clamp-Column Lock
- 8 Crank



Lubrication

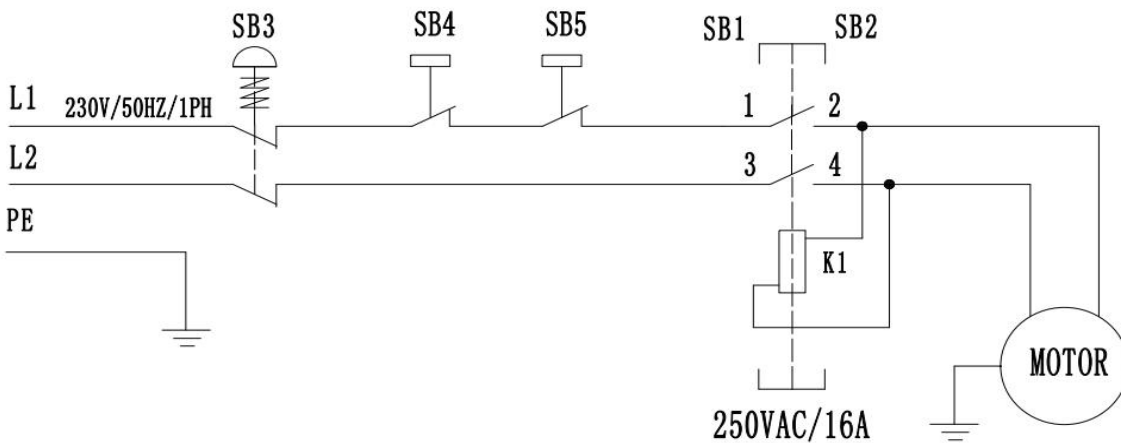
All of the BALL BEARING are packed with grease at the factory.They require no further lubrication. Periodically lubricate the table elevation mechanism,the SPLINES (grooves) in the spindle,and the RACK (teeth of the quill),see "Getting to know your drill press."

Maintenance

Frequently blow out any dust that may accumulate inside the motor.

A coat of automotive type paste was applied to the table and column will help to keep the surfaces clean.

Wire diagram



Part No.	Component/Object	Manufacturer	PCS	
Motor	Motor	AC250V/1PH/400W	1	
SB1	Magnetic Switch	250VAC/16A	1	KJD12
SB2				
SB3	Push Button-Emergency Stop	250VAC/12A	1	HY57B
SB4	Micro Switch	250VAC/16A	1	KW-7-3B
SB5	Micro Switch	250VAC/16A	1	KW7

Trouble Shooting

TROUBLE	PROBABALE 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.Checking 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.Faster 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 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 turn loose from hand	<ol style="list-style-type: none"> 1.Not supported or clamped properly. 	<ol style="list-style-type: none"> 1.Support working 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 working or clamp it. 2.Adjust temsion.
Excessive drill bit runout or wobble	<ol style="list-style-type: none"> 1.Bent drill bit 2.Worn spindle bearings. 3.Drill but 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 if falls off when trying to install it.	<ol style="list-style-type: none"> 1.Dirty,grease,or oil on the tapered inside surface of chuck or on the spindles 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.

Repair Parts

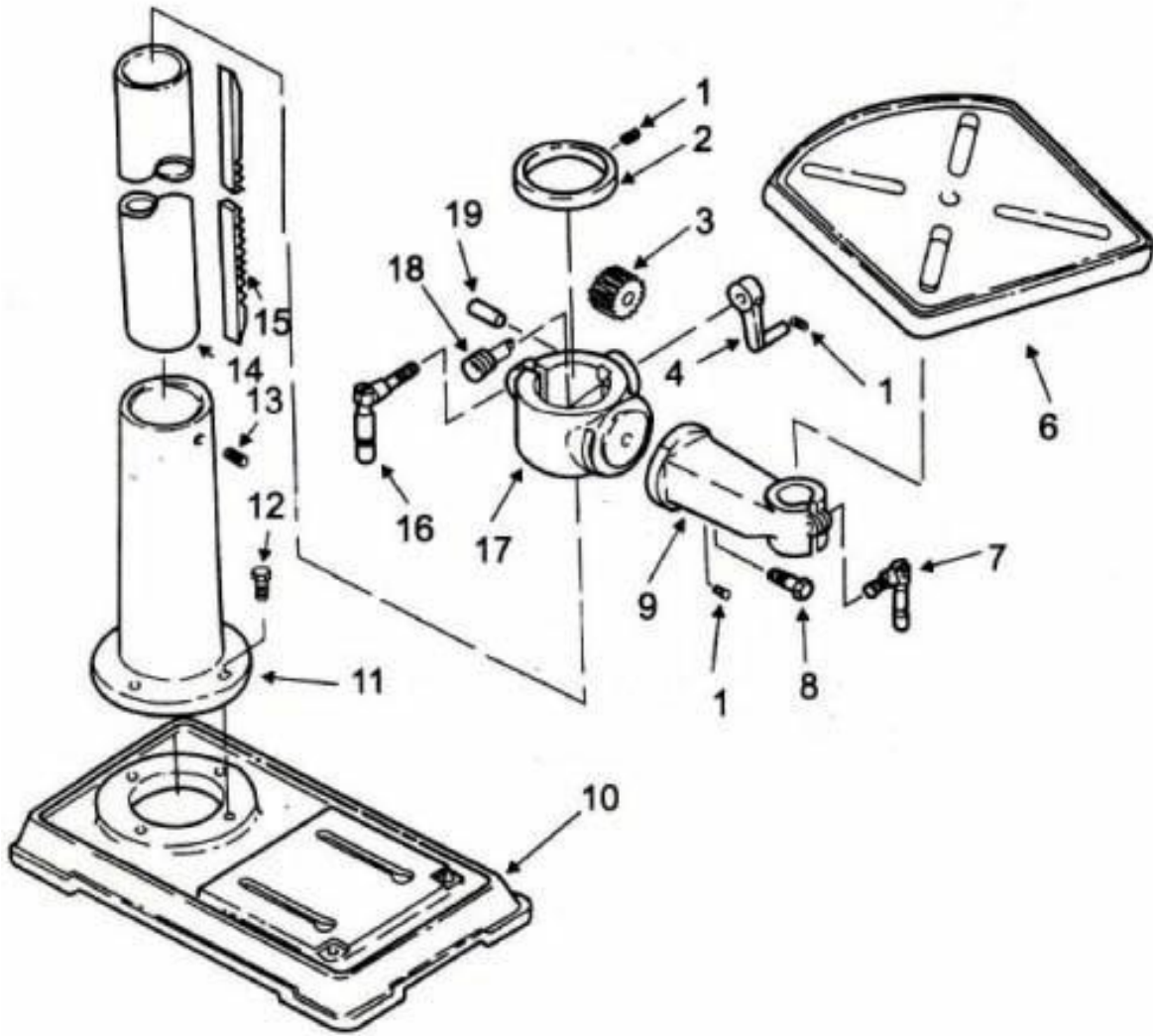


FIGURE1

FIGURE1 PARTS LIST

Key No.	Description
1	Screw-Hex Soc.Set M6*1.0-10
2	Collar-Rack
3	Gear-Helical
4	Crank
6	Table
7	Clamp-Table
8	Screw-Hex HD M16*20-35
9	Arm-Table w/Scale
10	Base

Key No.	Description
11	Support Column
12	Screw-Hex HD M10*1.5-40
13	Screw-Hex Soc.Set M10*1.5-12
14	Tube Column
15	Rack
16	Clamp-Column
17	Support Table w/Indicator
18	Worm-Elevation
19	Pin-Gear

Repair Parts

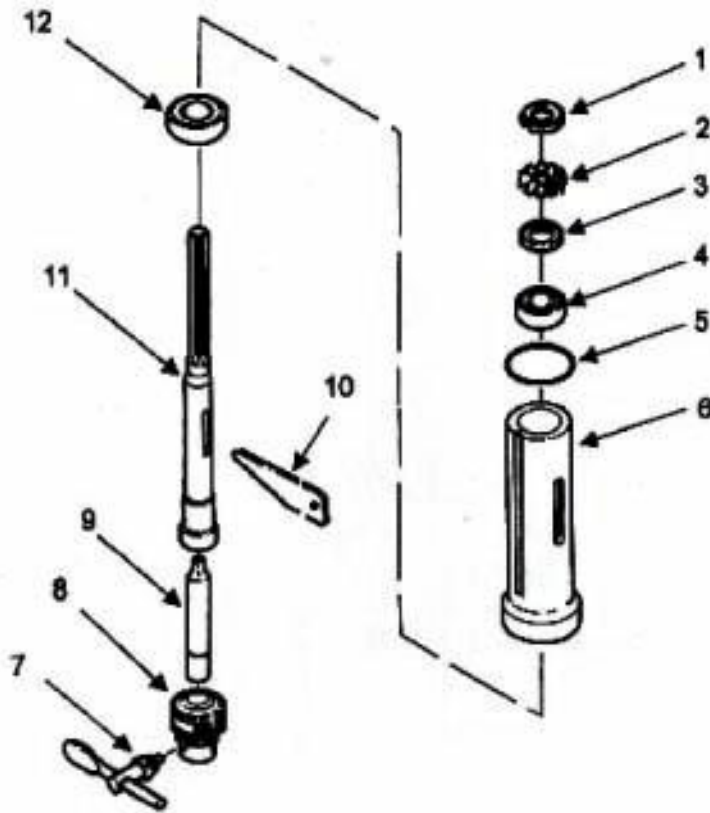


FIGURE2

FIGURE2 PARTS LIST

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

Repair Parts

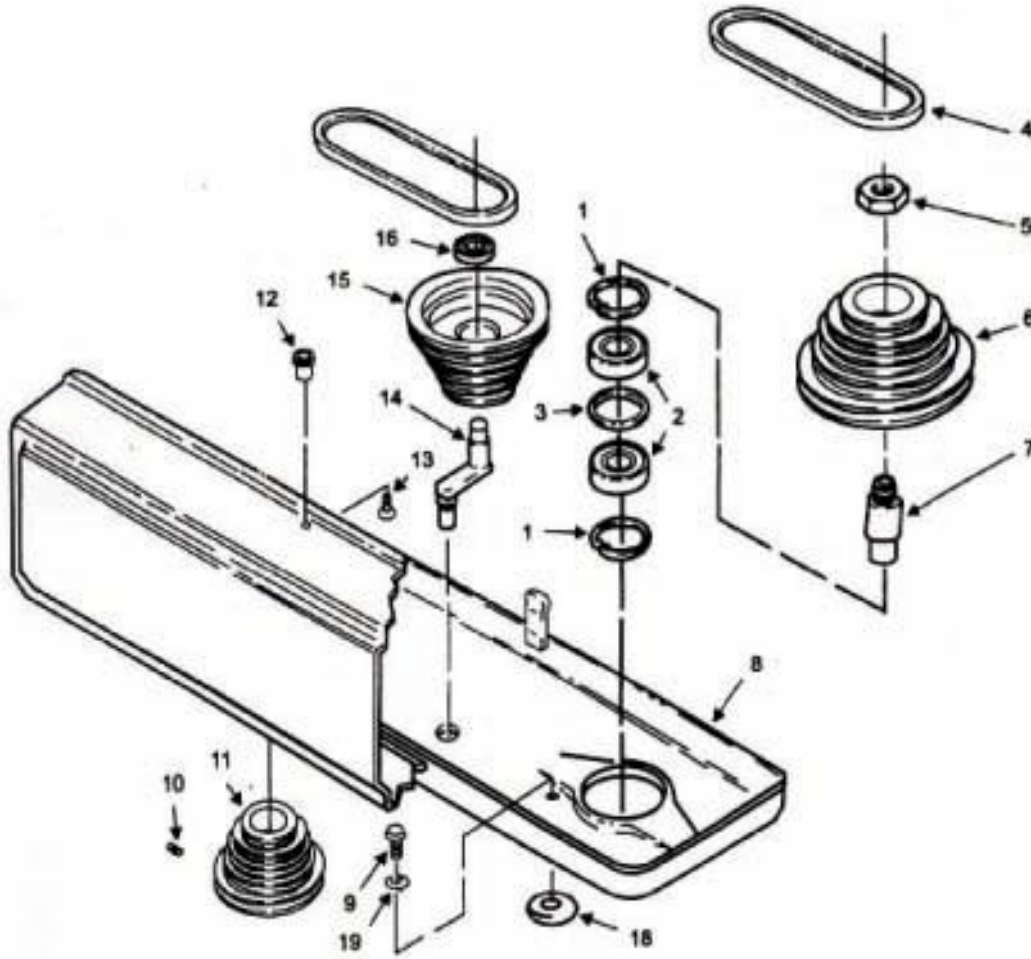


FIGURE3

FIGURE3 PARTS LIST

Key No.	Description
1	Ring-Retaining
2	Bearing-Ball 25mm
3	Spacer-Bearing
4	Belt-"V" M24
5	Nut-Pulley
6	Pulley-Spindle
7	Insert-Pulley
8	Guard-Pulley w/Labels
9	Screw-RD HD Washer M6*1.0-16

Key No.	Description
10	Screw-Set M10*1.5-12
11	Pulley-Motor
12	Knob
13	Screw-Pan HD M5*0.8-12
14	Pivot-Ldler
15	Pully-Center
16	Bearing-Ball 15mm
18	Washer Foam
19	Lock Washer Ext.M6

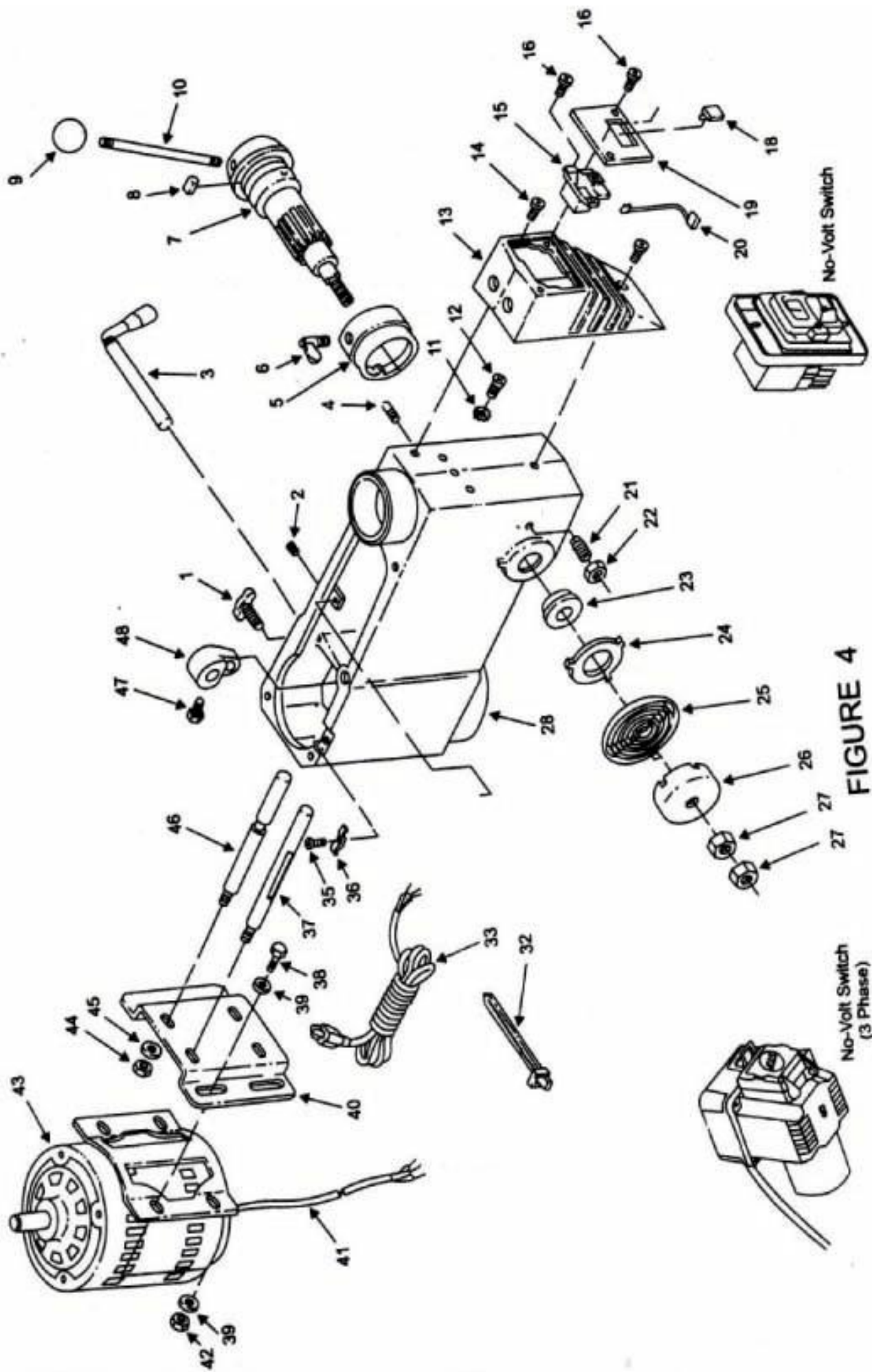


FIGURE 4

FIGURE4 PARTS LIST

Key No.	Description
1	knob-Motor Adjusting
2	Screw-Socket Set M10*1.5-12
3	Handle-Belt Tension
4	Pin-Stop
5	Ring-Depth Stop W/Scale
6	Lock-Depth Screw
7	Hub
8	Guide Scale
9	Knob
10	Rod
11	Lock-Washer-Ext M5
12	Screw-Pan HD M5*0.8-8
13	Box Switch
14	Screw-Pan HD M5*0.8-16
15	Switch-Locking
16	Screw-Pan HD M4.2*1.4-8
18	Key-Switch
19	Cover-Switch Plate
20	Lead-Asm 3
21	Screw-Set Special 10*1.5-27
22	Nut-Hex M10*1.5

Key No.	Description
23	Seat-Spring
24	Retainer-Spring
25	Spring-Torsion
26	Cap-Spring
27	Nut-Hex M12*1.5-8
28	Head w/Pointer and Trim
32	Tie-Wire
33	Cord-Power w/Plug
36	Clamp-Cord
37	Support-Motor Bracket
38	Screw-Hex HD M6*1.0*12
39	Washer 8*16*1.6
40	Mount-Motor
41	Cord-Motor
42	Nut-Hex M8*1.25
43	Motor
44	Nut-Hex M12*1.75
45	Lockwasher 1/2
46	Support-Motor Bracket
47	Screw-Hex HD M8*1.25-16
48	Lever-Adjusting