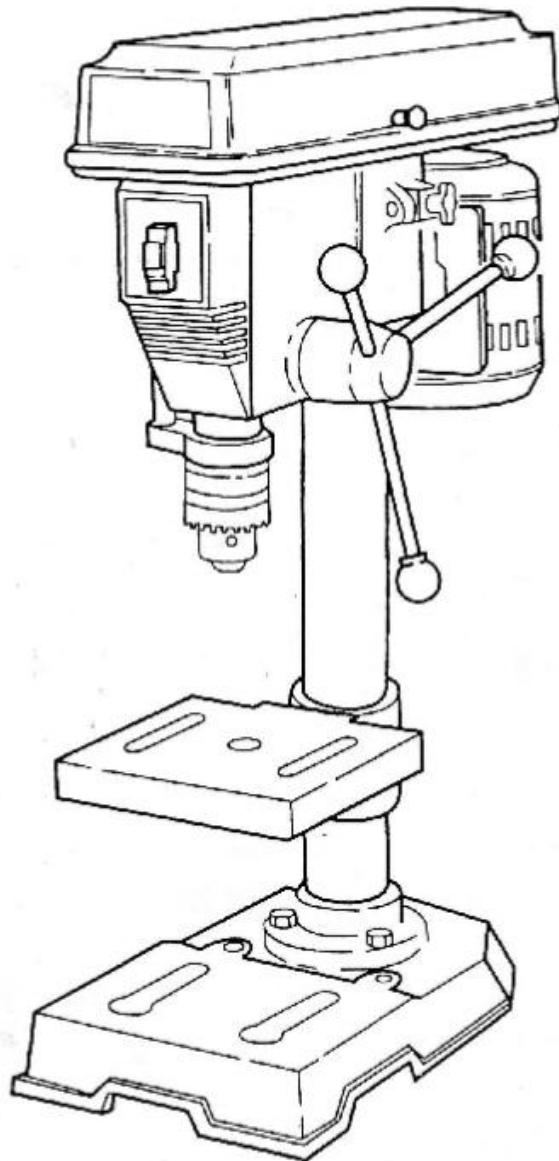


MODEL DP25016B



**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	250 mm / 10 in.
Spindle Taper	MT2
Spindle Travel	60 mm / 2-23/64 in.
Column Diameter	59.5 mm / 2-11/32 in.
Motor	120V/1ph/400W
Rack & Pinion	Yes
Base Size	320*215 mm / 13-25/32 × 8-15/32 in.
Table Size	195*196 mm / 7-43/64 × 7-23/32 in.
Max. Distance Chuck to Table	300 mm / 11-13/16 in.
Max. Distance Chuck to Base	375 mm / 14-49/64 in.
Overall Height	850 mm / 33-15/32 in.

Range of spindle speeds
5 speeds

Motor Speed	Spindle Speeds (min ⁻¹)				
1700 min ⁻¹	620	1100	1720	2340	3100

Overall dimensions (L*M*H)	690 × 430 × 260mm / 27-11/64 × 16-59/64 × 10-15/6
Net Weight	30kgs / 66 lbs

Unpacking and checking contents

1.Unpacking and checking contents

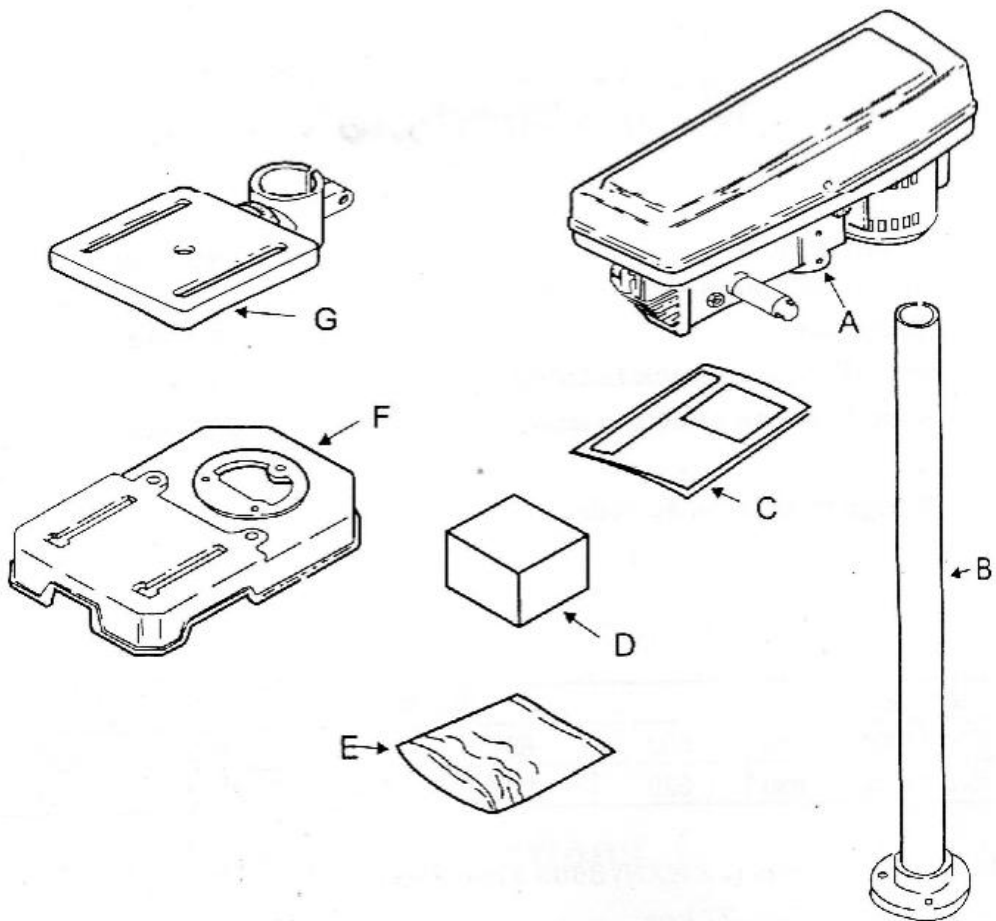
Separate all the parts from packaging materials and check each item make sure all items are accounted for before discarding any packing material.

Item	Description	Qty
A	Head Asm.....	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	Table/Support Arm.....	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.

4 in.



List of Loose Parts in the box and bags



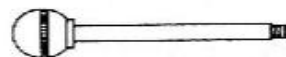
M8 x 1.25-20
HEX HEAD SCREW(3)



SUPPORT LOCK HANDLE(1)



M4 HEX "L" WRENCH(1)



FEED HANDLE(3)



M3 HEX "L" WRENCH(1)

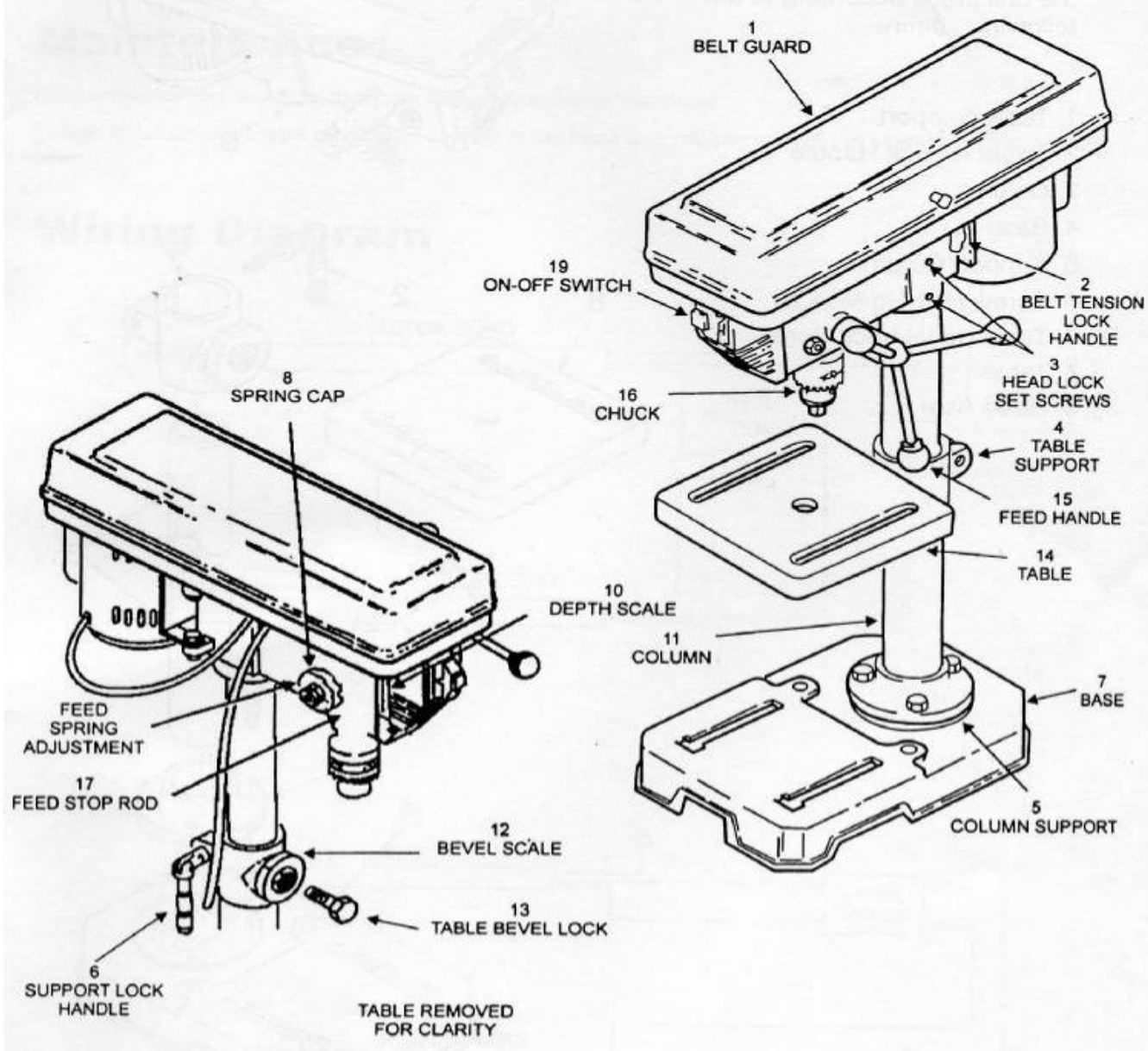


CHUCK(1)



CHUCK KEY(1)

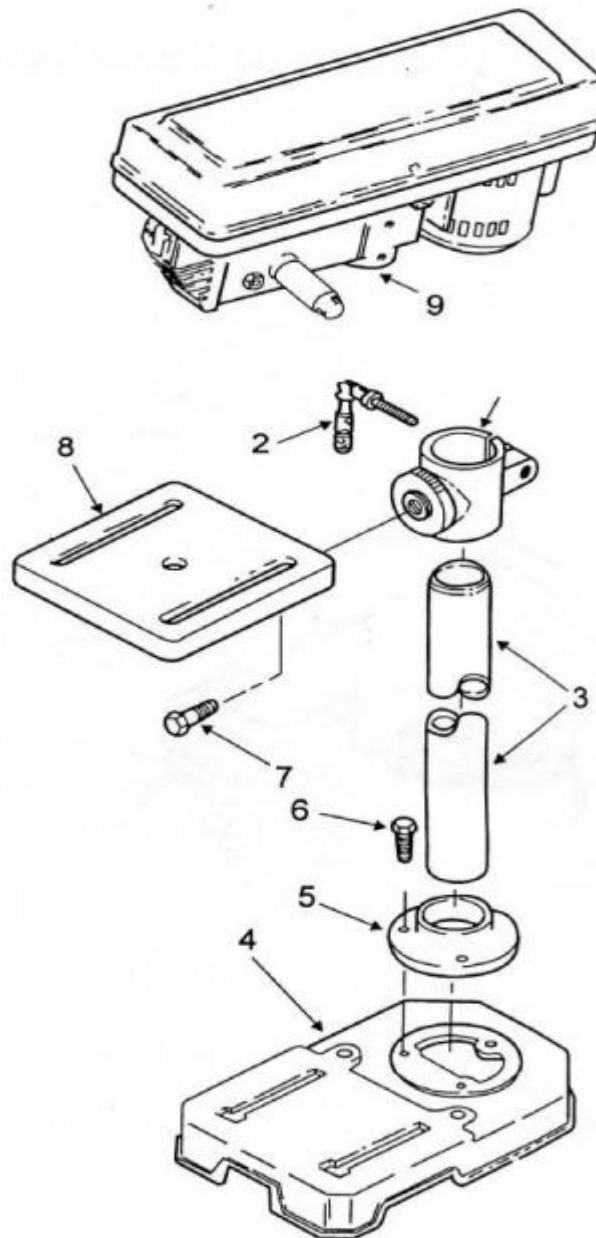
Getting to know your drill press



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

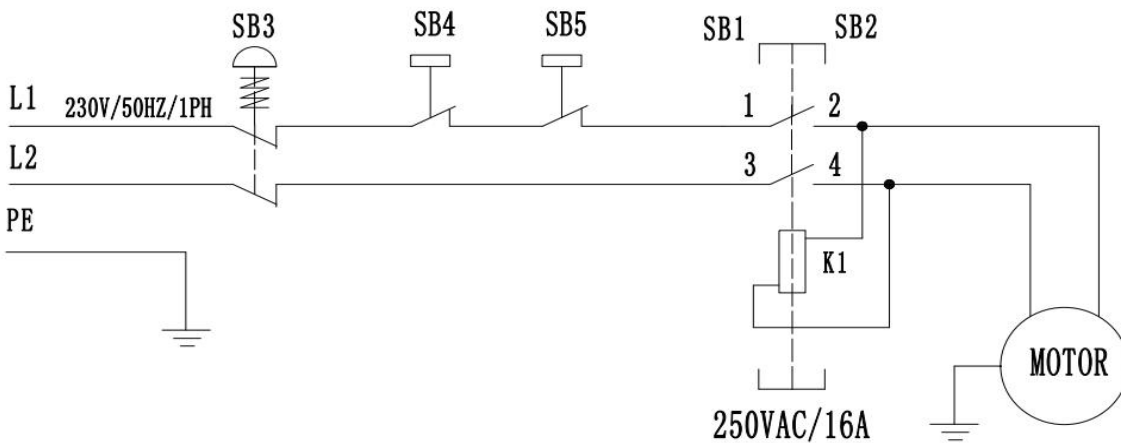
All of the BALL BEARING are packed with grease at the factory.They require no further lubrication. Periodically lubricate the table elevation mechanism,the SPLINES (grooves) in the spindle,and the RACK (teeth of the quill),see "Getting to know your drill press."

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	PROBABABLE 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 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 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

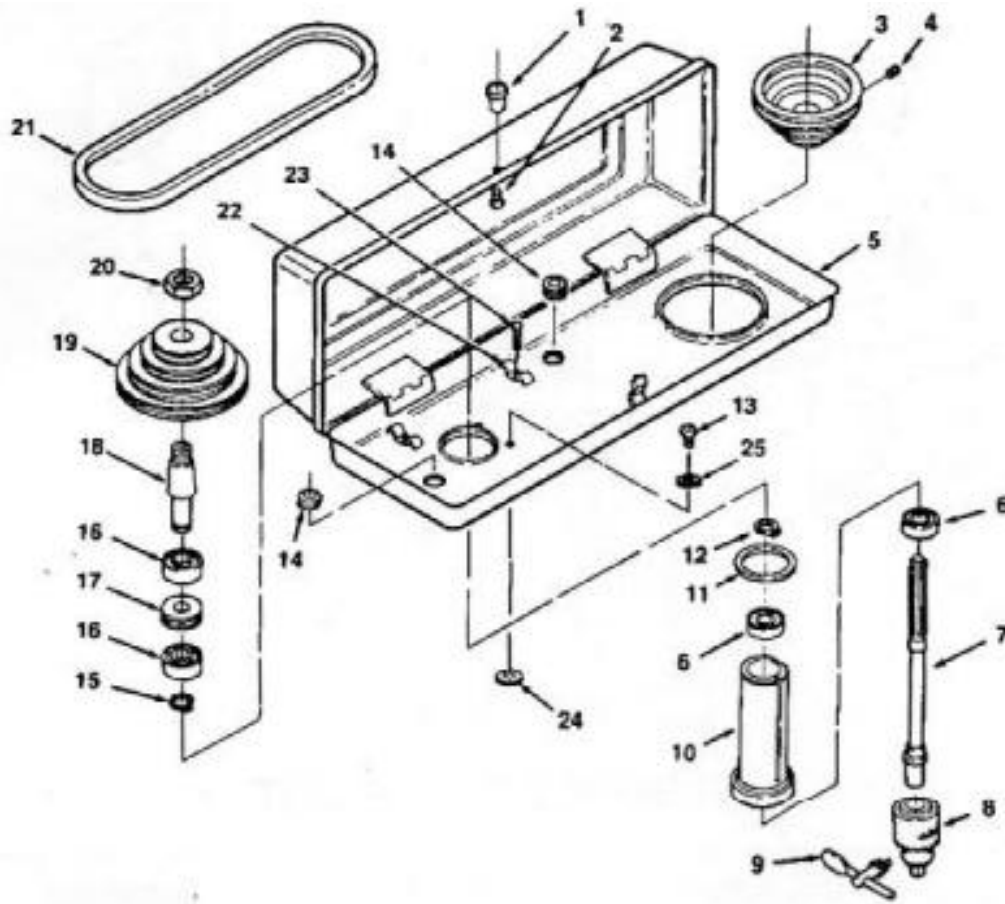


FIGURE1

FIGURE1 PARTS LIST

Key No.	Description	Key No.	Description
1	Knob	14	Bushing-Rubber
2	Screw-Pan Hd.M5*0.8-12	15	Ring-Retaining
3	Pulley-Motor	16	*Bearing-Ball 17mm
4	Screw-Hex Soc.Set M6*1.0-10	17	Spacer
5	Guard Pulley w/Lables	18	Insert Pulley (includes Key #15&20)
6	*Bearing-Ball 12mm	19	Pulley-Spindle
7	Shaft-Spindle	20	Nut-Pulley
8	Chuck	21	Belt-"V"5/16*31
9	Key-Chuck	22	Clamp Cord
10	Tube-Quill	23	Screw-Pan Hd.M5*0.8-10
11	Gasket-Quill	24	Washer Foam
12	Ring-Retaining	25	*Lockwasher M6
13	Screw-Wash.Hd.M6*1.0-12		

*Standard Hardware Item --- May Be Purchased Locally

Repair Parts

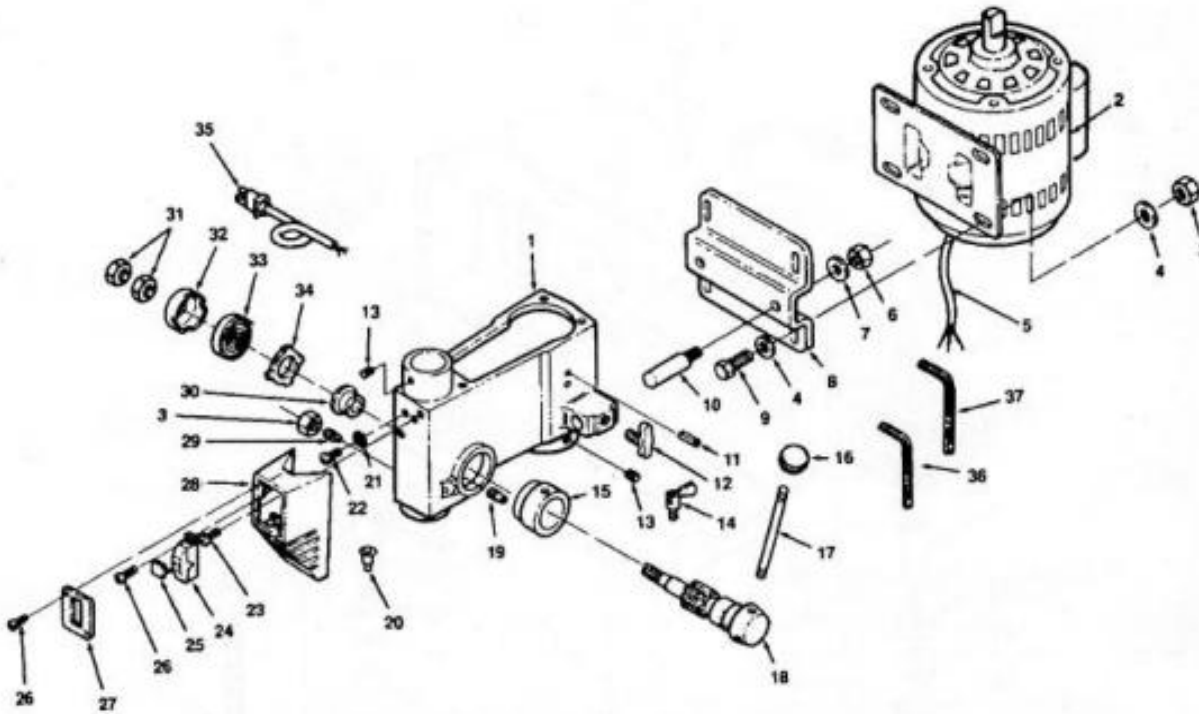


FIGURE2
FIGURE2 PARTS LIST

Key No.	Description	Key No.	Description
1	Head w/Pointer&Trim	21	*Lockwasher-Ext.5mm
2	Motor	22	Screw-Pan Hd.M5*0.8-8
3	*Nut-Hex M8	23	Screw-Pan Hd.M5*0.8-12
4	*Washer M8*16*1.6	24	Switch Locking
5	Cord-Motor	25	Key-Switch
6	*Nut-Hex M10	26	Screw-Self Tap.Pan Hd M4.2*1.4-9.5
7	*Lockwasher M10	27	Cover-Switch Plate
8	Bracket-Motor	28	Box-Switch
9	Screw-Hex Hd.M8*1.25-20	29	Screw-Special Set M8*1.25*18
10	Support-Motor Bracket	30	Seat-Spring
11	Pin-Roll 6*16	31	*Nut-Hex M12*1.5-8
12	knob-Motor Adjusting	32	Cap-Spring
13	Screw-Hex Soc.Set M8*1.25-8	33	Spring-Torsion
14	Lock-Depth Screw	34	Retainer-Spring
15	Ring-Depth Stop W/Scale	35	Cord-Power
16	knob	36	Hex"L"-Wrench 3mm
17	Rod	37	Hex"L"-Wrench 4mm
18	Hub-Pinion		Owners Manual (Not Illustrated)
19	Pin-Stop		
20	*Connector-Wire		

*Standard Hardware Item --- May Be Purchased Locally

Repair Parts

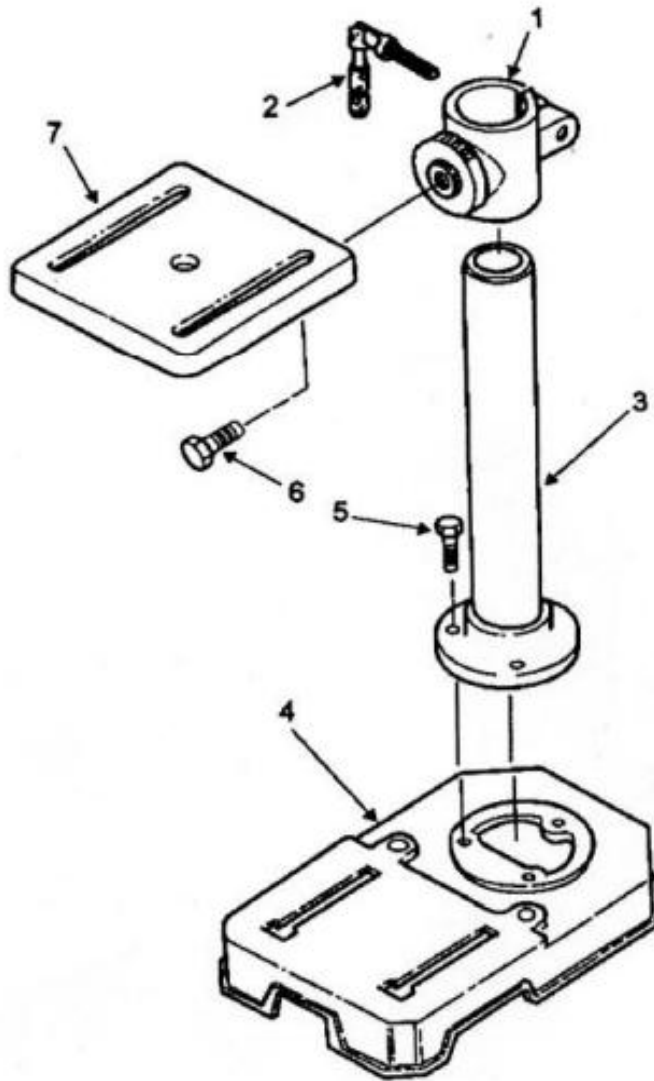


FIGURE3

FIGURE3 PARTS LIST

Key No.	Description
1	Support-Table w/Scale
2	Support-Lock Handle
3	Tube/Support
4	Base
5	Screw-Hex Hd.M8*1.25-20
6	Screw-Hex Hd.1/2-12*7/8
7	Table